

Notes: LEDs ON at initial turn-on & setup, no fixture, SMEMA I/O not connected

SMEMA signals

INPUT	
48	307 7 Board Entrance Sensor
47	306 6
46	305 5 Unloader Ready (low true, LED On)
45	304 4
	C2
44	303 3 Identical Error Signal
43	302 2 PASS Signal
42	301 1 FAIL Signal
41	300 0 Test in progress
	C1 KV-E8X

OUTPUT	
40	707 7
39	706 6
38	705 5
37	704 4 Buzzer
	C2
36	703 3 Driving Conveyor
35	702 2 Light Pole Red light-steady
34	701 1 Light Pole Green light-steady
33	700 0 Light Pole Yellow light-steady
	C1 KV-E8R

40	215 15 Conveyor Upper-limit Sensor
39	214 14 Press Lower-limit Sensor
38	213 13 Press Upper-limit Sensor for Retest
37	212 12 Press Upper-limit Sensor
	C4
36	211 11 Exit Board Passage Sensor
35	210 10 Conveyor Lower-limit Sensor
34	209 9 Reversed board sensor
33	208 8 Board Available (from Loader)
	C3
32	207 7 Board Stopper Sensor (outside)
31	206 6 Board Stopper Sensor (inside)
	C2
30	205 5 Change Arriving Sensor
29	204 4 Board Arriving Sensor
	C1 KV-E16X
28	203 3 Pneumatic Pressure-OK Signal
27	202 2 Installing the Fixture-OK Signal
26	201 1 BUZZER RESET button
25	200 0 Door SW

32	615 15 FAIL (to Unloader)
31	614 14
30	613 13 ILS Board Available (to Unloader)
29	612 12 PASS (to Unloader)
	C4
28	611 11
27	610 10
26	609 9 Board Stopper(OUT)
25	608 8
	C3
24	607 7 Failed UUT
23	606 6 Passed UUT
22	605 5 Conveyor in Driving
21	604 4 Test in progress
	C2
20	603 3 Conveyor Up Instruction
19	602 2 Conveyor Down Instruction
18	601 1 Press Up Instruction
17	600 0 Press Down Instruction
	C1 KV-E16R

24	107 107 Emergency Stop Push Button
23	106 106 Press Up Push Button
22	105 105 Press Down Push Button
21	104 104 Press Down Push Button
20	103 103 Through Mode
19	102 102 Board Stopper In/Out SW
18	101 101 Conveyor UP
17	100 100 Conveyor Down
16	015 15 Conveyor Drive Push Button
15	014 14 AUTO Button
14	013 13 Auto/Manual Changeover SW
13	012 12
12	011 11
11	010 10
10	009 9
9	008 8 Sample Freq LSB
8	007 7
7	006 6
6	005 5
5	004 4 ReTest Cycles LSB
4	003 3 Open (Use is impossible)
3	002 2
2	001 1
1	000 0 REPROBE Cycles LSB
	bit1
	bit2
	bit3
	bit4
	bit1
	bit2
	bit3
	bit4
	bit1
	bit2
	bit3
	bit4

16	15 515 Conveyor Down
15	14 514 Conveyor Up
14	13 513 Conveyor in Drive
13	12 512 Press Down End
	C8
	C7
12	11 511 Press Up End
11	10 510 In Emergency Stop
10	9 509 In Automatic Operation
9	8 508 In Manual Operation
8	7 507 ESC
7	6 506 F7 Print Test Results Report
6	5 505 F1 Start Test
5	4 504 Sample Test (low = test, hi = skip)
	C6
4	3 503 Light Pole Red light-blinking
	C5 Blinking Common Line
3	2 502 Light Pole Yellow light-blinking
	C4
2	1 501 ILS is Ready (low true to Loader)
	C3
1	0 500 F5 Failure-only ReTest
	No. OUTPUT
	0V
	24V

