

XL208CL Switch Settings Version 1.00

Models: XL208CL

Switch 1	Switch 2	Description
OFF	OFF	INVALID
ON	OFF	INVALID
OFF	ON	Single-Speed Flying-Cut (Bradbury "BOSS" Shear)
ON	ON	INVALID
Switch #	OFF	ON
3	NOT USED – MUST BE OFF	NOT USED – MUST BE OFF
4	CW Encoder 1 Direction	CCW Encoder 1 Direction
5	CW Encoder 2 Direction	CCW Encoder 2 Direction
6	Normal Analog Voltage Polarity	Inverted Analog Voltage Polarity
7	NOT USED – MUST BE OFF	NOT USED – MUST BE OFF
8	NOT USED – MUST BE OFF	NOT USED – MUST BE OFF
9	CRT Disabled	CRT Enabled
10	NOT USED – MUST BE OFF	NOT USED – MUST BE OFF

Notes:

1. Encoder 1 and Encoder 2 are used as follows:

Model	Encoder 1	Encoder 2
XL208CL – Flying-Cut.	Line Encoder	Motor Encoder (Flying-Cutoff)

XL208CL Inputs & Outputs Version 2.00

IO#	Inputs	Outputs
1	Jog Forward	Fast Forward
2	Jog Reverse	Slow
3	Run	Reverse
4	Emergency Stop (E-Stop)	Run
5	Setup Lockout	Item Complete
6	Manual Shear	Drive Enable
7	Not Used	Print Flush/Encoder
8	Tail Out (Inverted Sheet Detect)	Print Trigger
9	Press 0 Complete (Shear)	Not Used
10	Not Used	Not Used
11	Not Used	Not Used
12	Not Used	Not Used
13	Not Used	Not Used
14	Not Used	Not Used
15	Not Used	Not Used
16	Not Used	Not Used
17	Not Used	Not Used
18	Not Used	Not Used
19	Not Used	Not Used
20	Not Used	Not Used
21	Asynchronous Print Detect	Not Used
22	Die Home	Not Used
23	Not Used	Not Used
24	Not Used	Not Used

Notes:

1. The Asynchronous Print Detect input is only available on models with a Print on Part printer configured in an Asynchronous mode.