

XL120 Pin	Pin Assignment	XL220 Pin	Notes
A1	24VDC CPU Supply	A1	
A2	24VDC Common Un-grounded	A2	
A3	Jog Forward	C2	
A4	Jog Reverse	C3	
A5	Run Input	C4	
A6	Shear Complete	C10	
A7	Setup Lockout	C6	
A8	Forward/Fast Output	E7	
A9	Slow Output	E3	
A10	Reverse	E4	
A11	Shear Down Output	E10	
A12	Run Output	E5	Use this for run latch only!
A13	End Notch Down Output	E12	
A14			
A15			
A16	Vee Notch Down Output	E11	
B1	Die Select Output	F3	
B2	Manual Shear	C7	
B3	Manual End Notch	D3	
B4	Sheet Detect	C9	
B5			
B6	Encoder Shield		
B7	Encoder 0VDC		
B8	Encoder +5VDC		
B9			
B10			
B11	Encoder B-		
B12	Encoder B+		
B13	Encoder A-		
B14	Encoder A+		
B15			
C1	24VDC I/O Power	B1	
C2	24VDC I/O Common	B2	
C3	Hole Punch	F2	
C4	Center Hole Gag	F4	
C5	Outer Hole Gag	F5	
C6	Hole Position Gag	F7	
C7	Shear Up/Boost	E14	
C8	Item Complete	E6	
C9			
C10			
C11	Manual Vee Notch	D2	
C12	Manual Hole	C8	
C13	End Complete	C12	
C14	Vee Complete	C11	
C15			
C16	Hole Complete		15

D1		
D2		
D3		
D4		
D5		
D6		
D7		
D8		
D9		
D10		
D11		
D12		
D13	Communication to SL343	B14
D14	Communication to SL343	B15
D15		
D16	Chassis Ground	Mounting Lug

Pin	Additional Connections Required
D1	24VDC Common
E1	24VDC Common
F1	24VDC Common

Note

If the controller is installed on an Engel machine, you must set parameter ID 318 "Slow Output While Halted" to YES.