

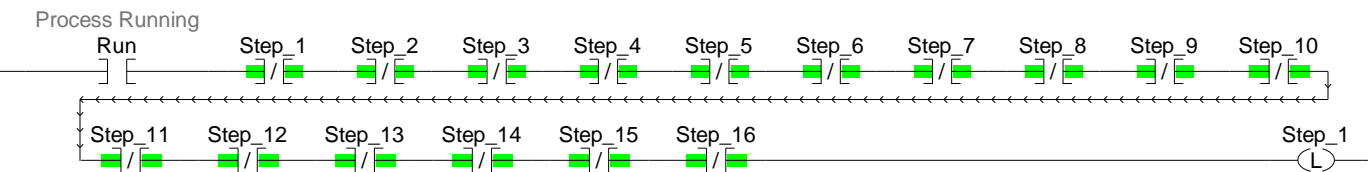
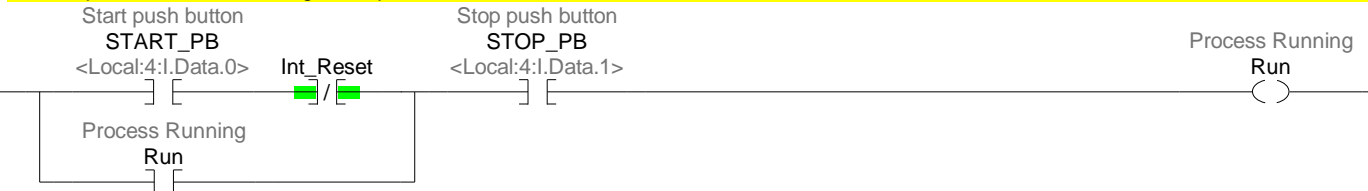
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Revised Drilling Station Control

Additional internal memory:

Tag	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Step_1 to Step_16	BOOL	Step-in-progress bits
Unclamp_Tmr	TIMER	Times unclamp of part carrier

Start/stop and initial start. During reset, prevent start



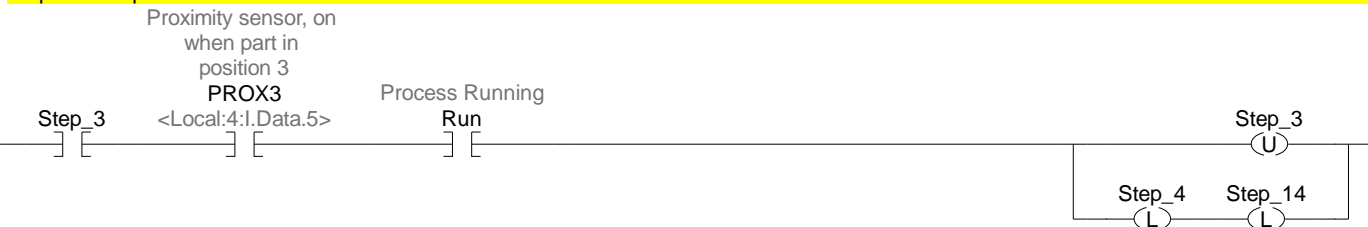
Step 1 Wait for first part

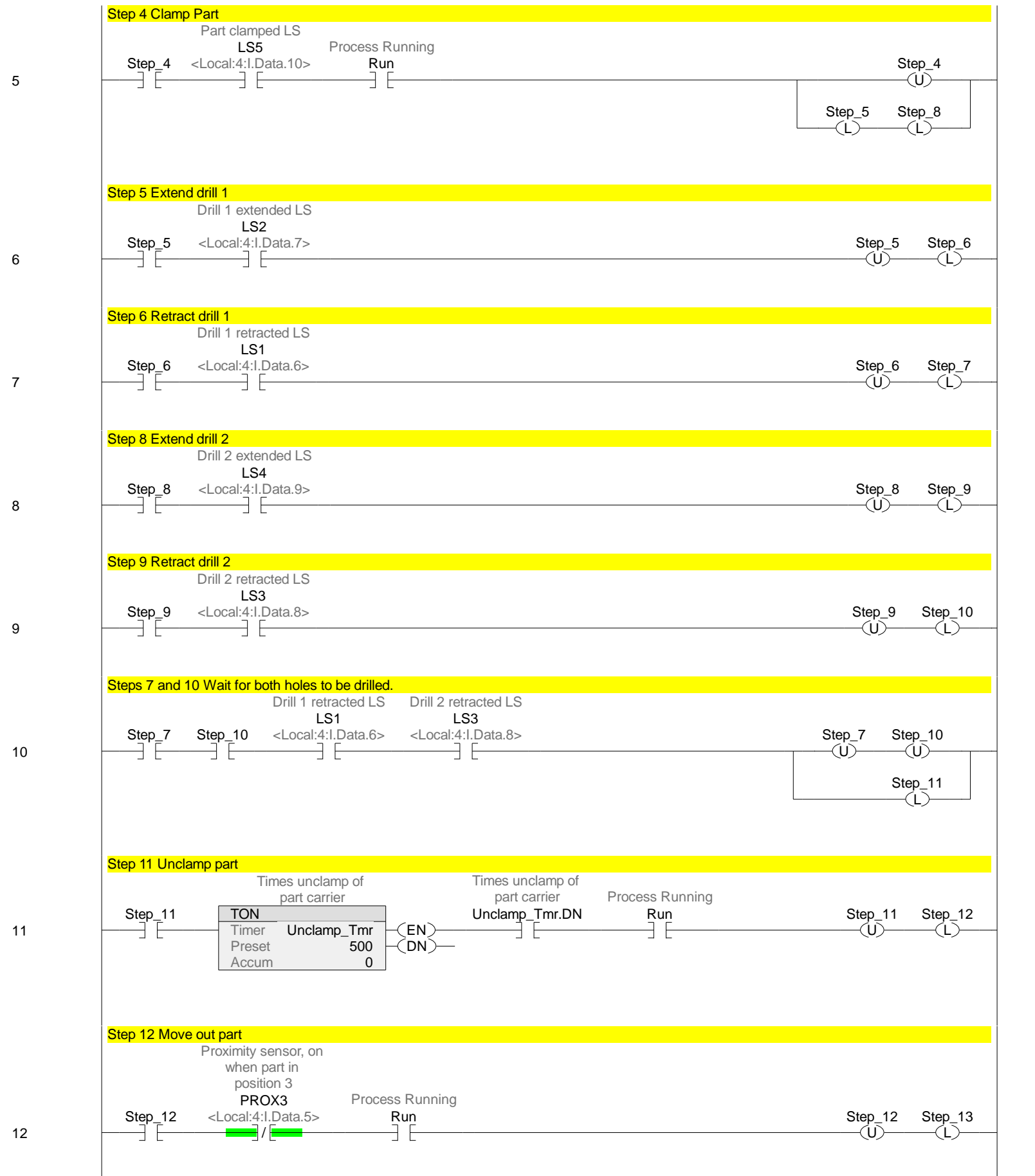


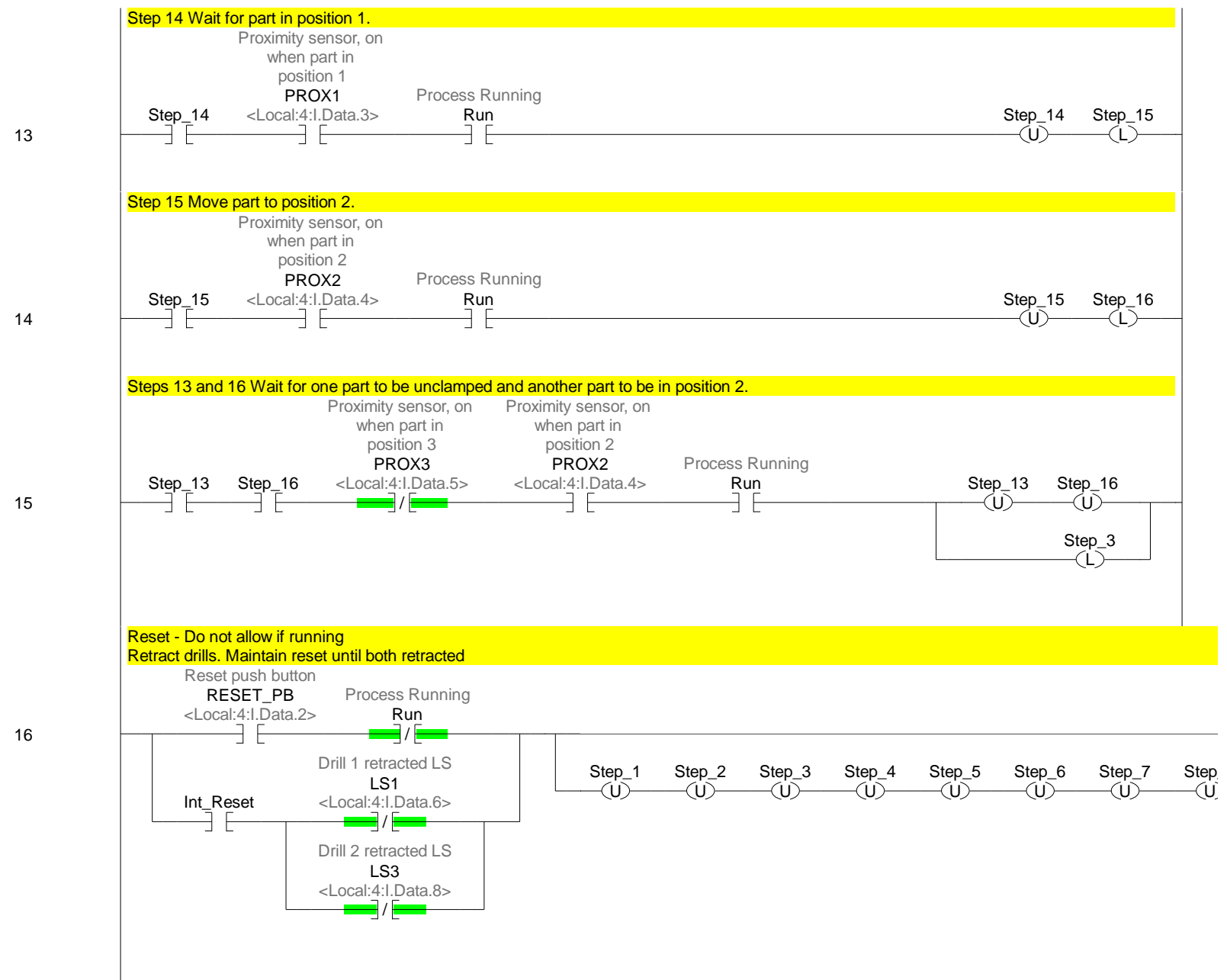
Step 2 Move part to Position 2.

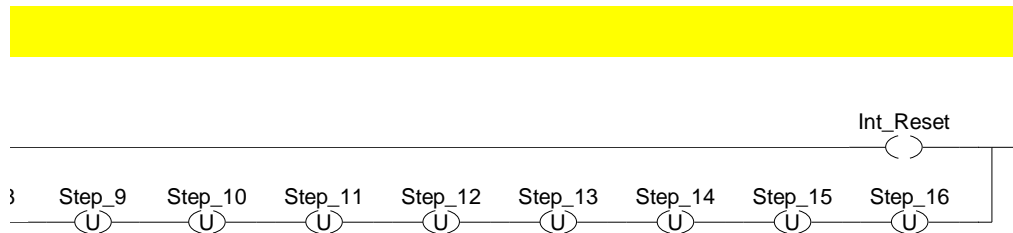


Step 3 Move part to Position 3.





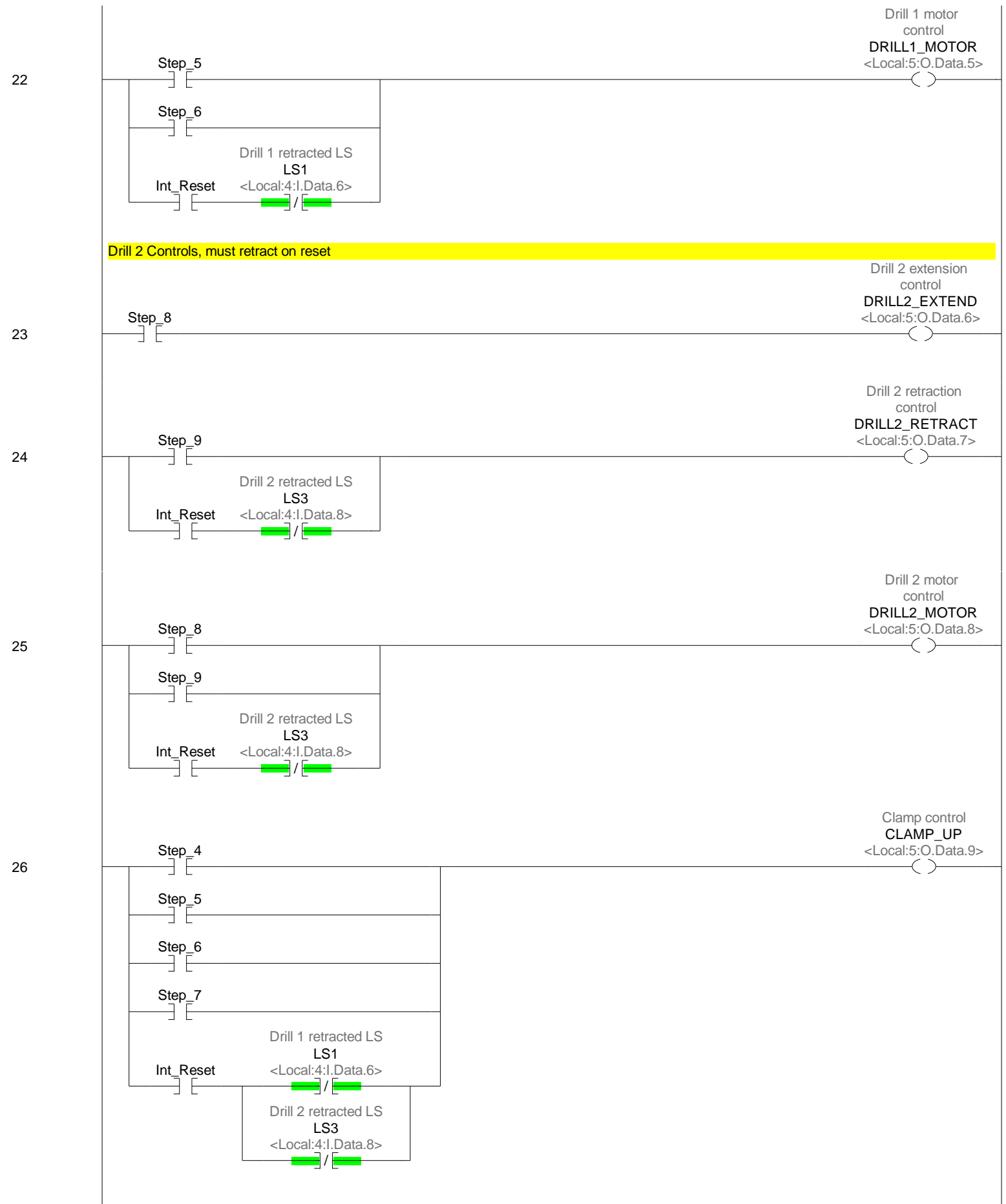




Physical Outputs

Gate Controls





(End)