

Main

Table of Contents

Main 3

Main

Local Variables

Name	Alias	Data Type	Dimension	Initial Value	Project Value	Comment	Direction	String Size
Step_1		BOOL					Var	
Step_2		BOOL					Var	
Step_3		BOOL					Var	
Step_4		BOOL					Var	
Step_5		BOOL					Var	
Step_6		BOOL					Var	
Step_7		BOOL					Var	
Part_Ctr		CTU			Var	
Part_Ctr_Rst		BOOL					Var	
G1_Hold_Tmr_Rst		BOOL					Var	
G2_Hold_Tmr_Rst		BOOL					Var	
Motor1_Tmr		TON			Var	

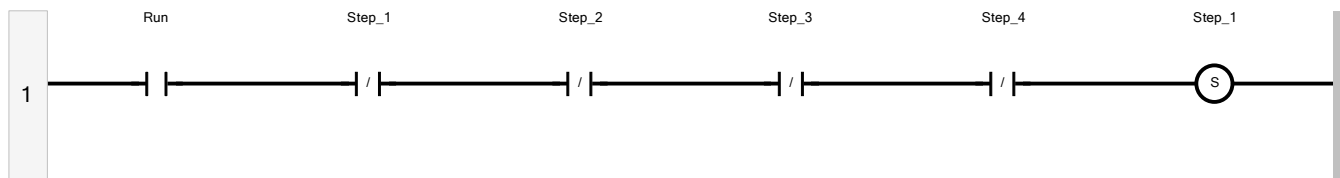
Rung1 Diagram

SP6-3 Parts Transfer Station

Copyright (c) 2023, Dogwood Valley Press, LLC

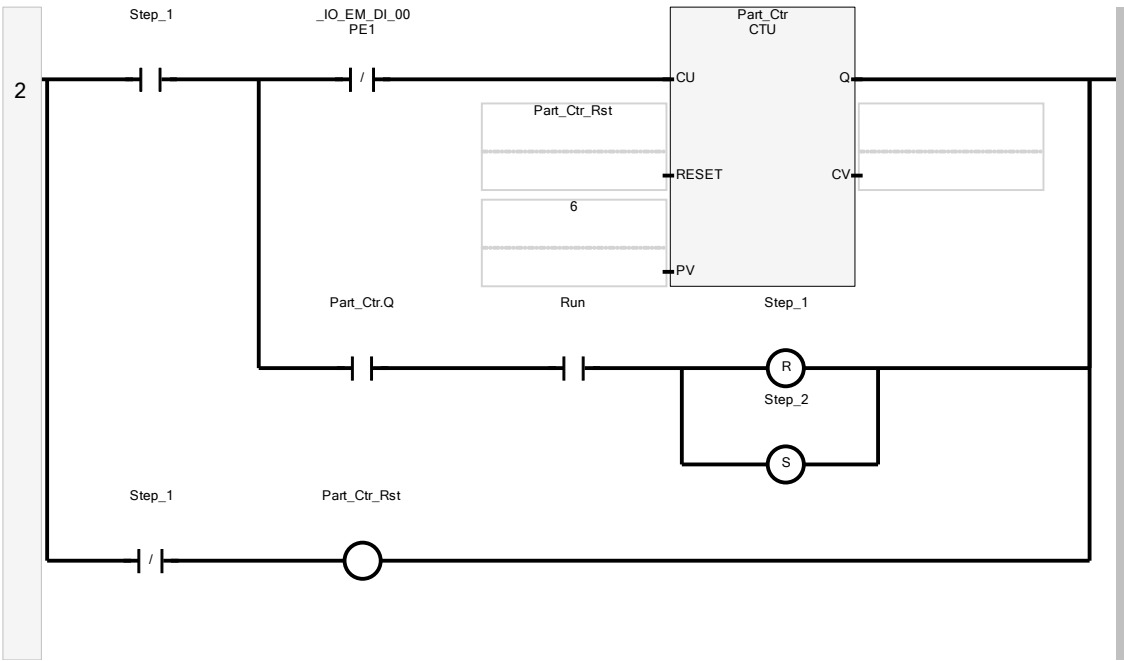
Additional internal memory:

Tag	Data Type	
Step_1 to Step_4	BOOL	Step-in-progress bits
Motor1_Tmr	TON	Turntable turn timer
Parts_Ctr	CTU	Parts counter

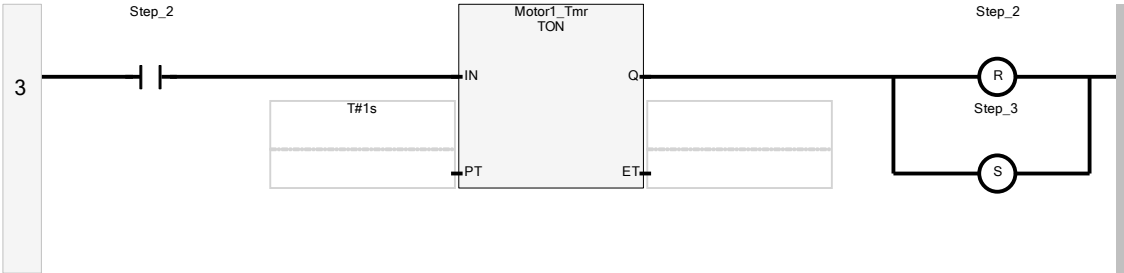


Rung2 Diagram

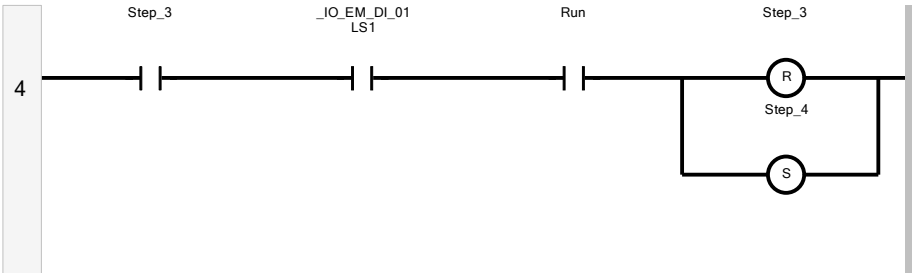
Step 1 - Count parts. Reset counter when not in step 1



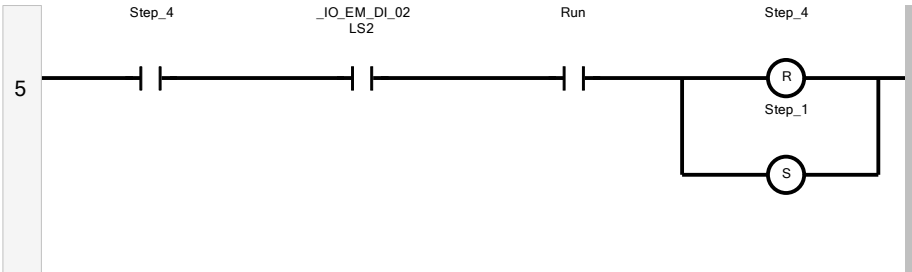
Rung3 Diagram
Step 2 - Rotate table



Rung4 Diagram
Step 3 - Extend Ram

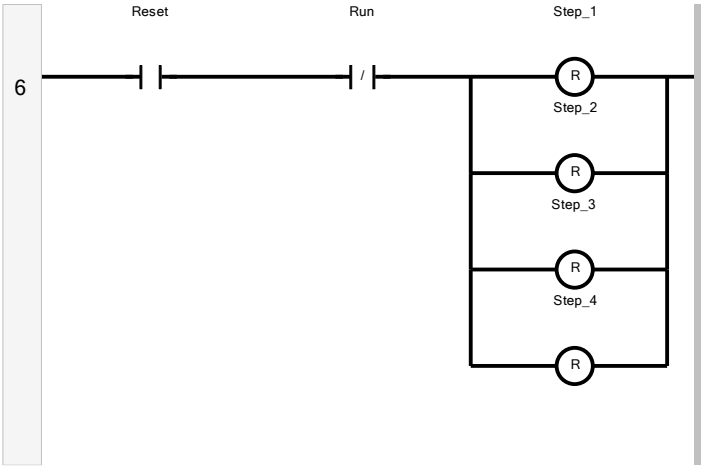


Rung5 Diagram
Step 4 - Retract Ram



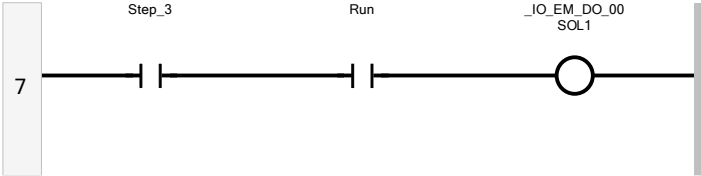
Rung6 Diagram

Reset steps



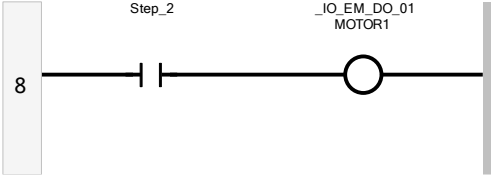
Rung7 Diagram

Physical Outputs



Rung8 Diagram

Roll conveyor control



Rung9 Diagram

Gate 1 cylinder control

