

Pressing Station Control

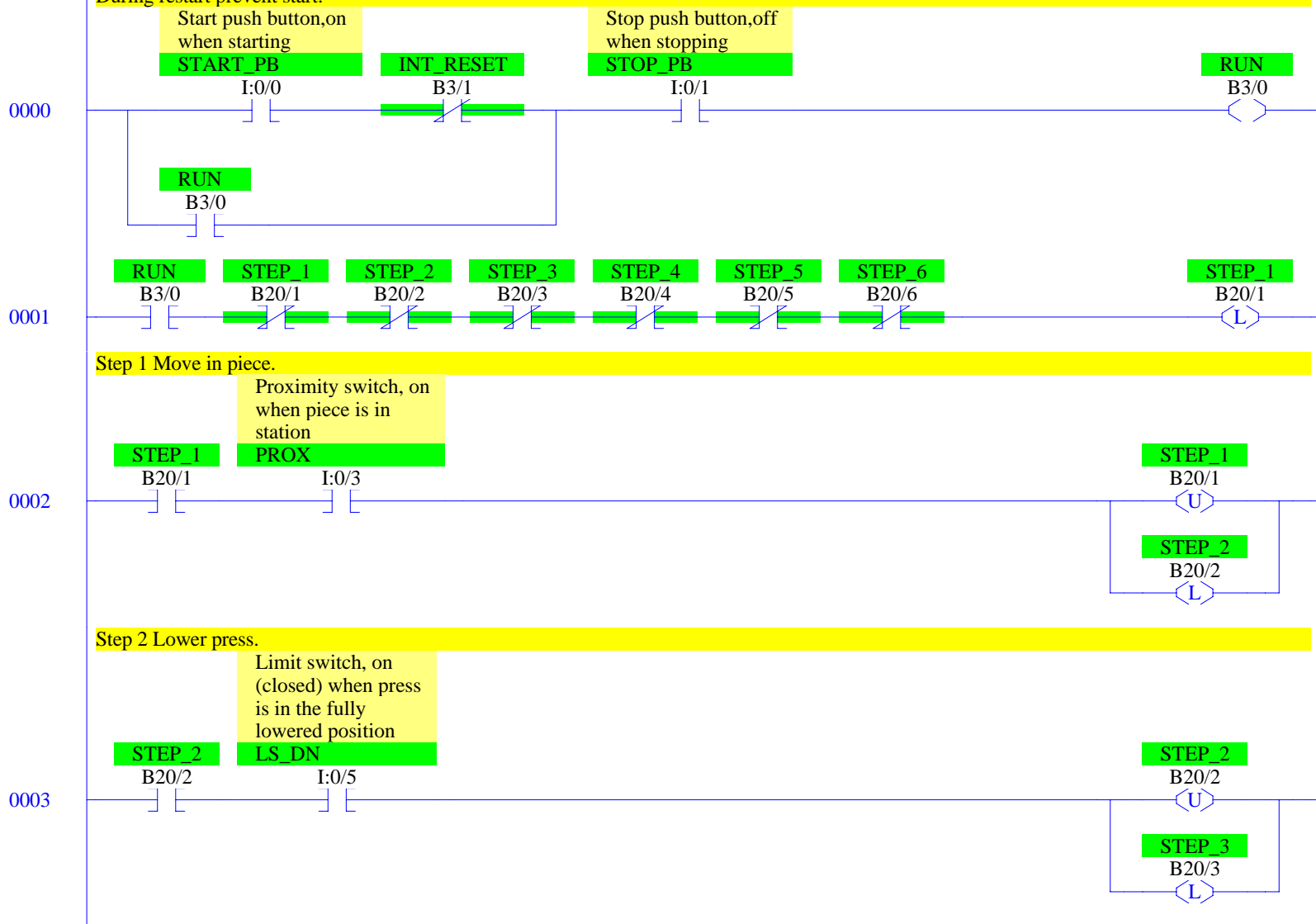
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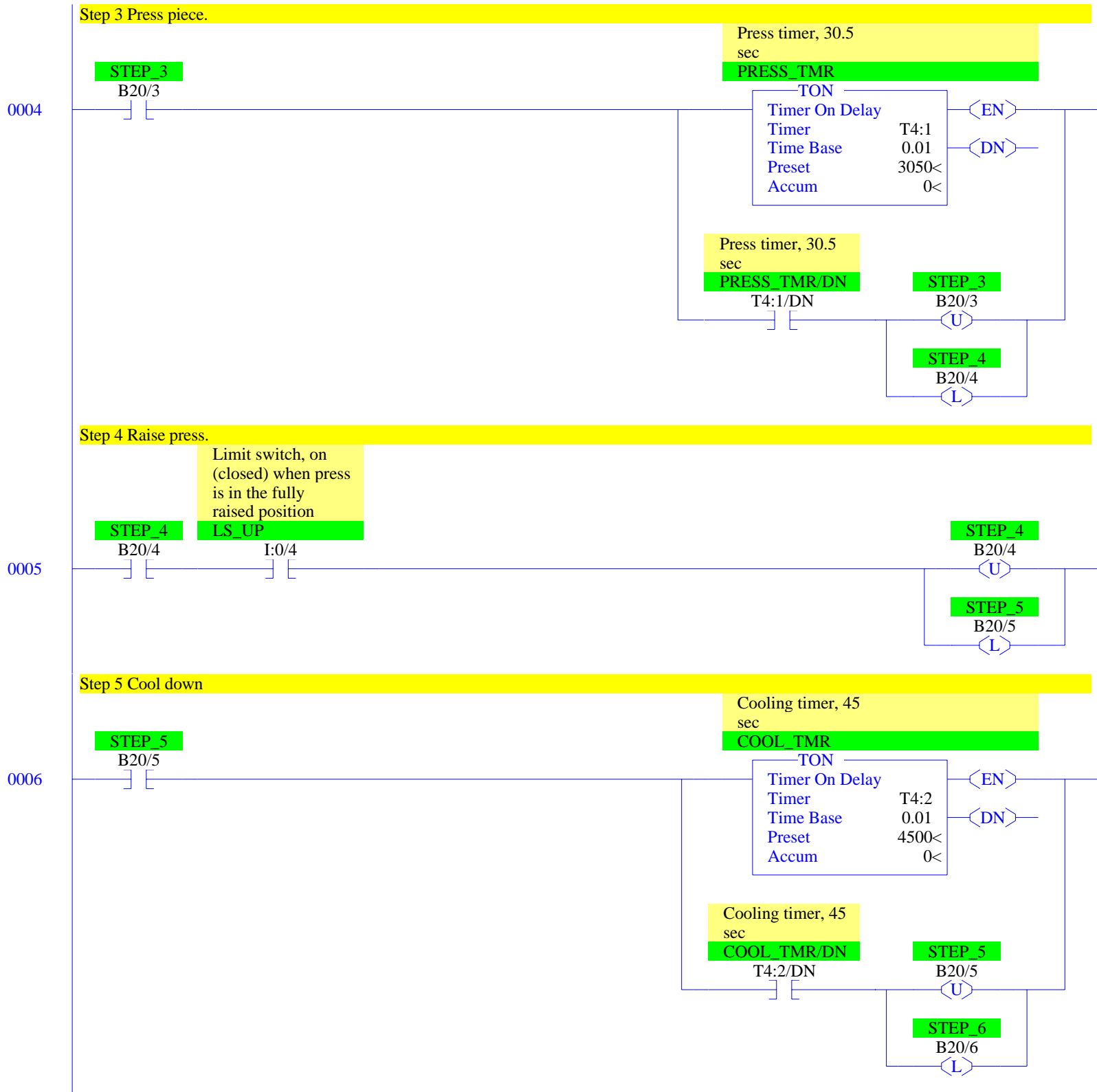
Additional internal memory:

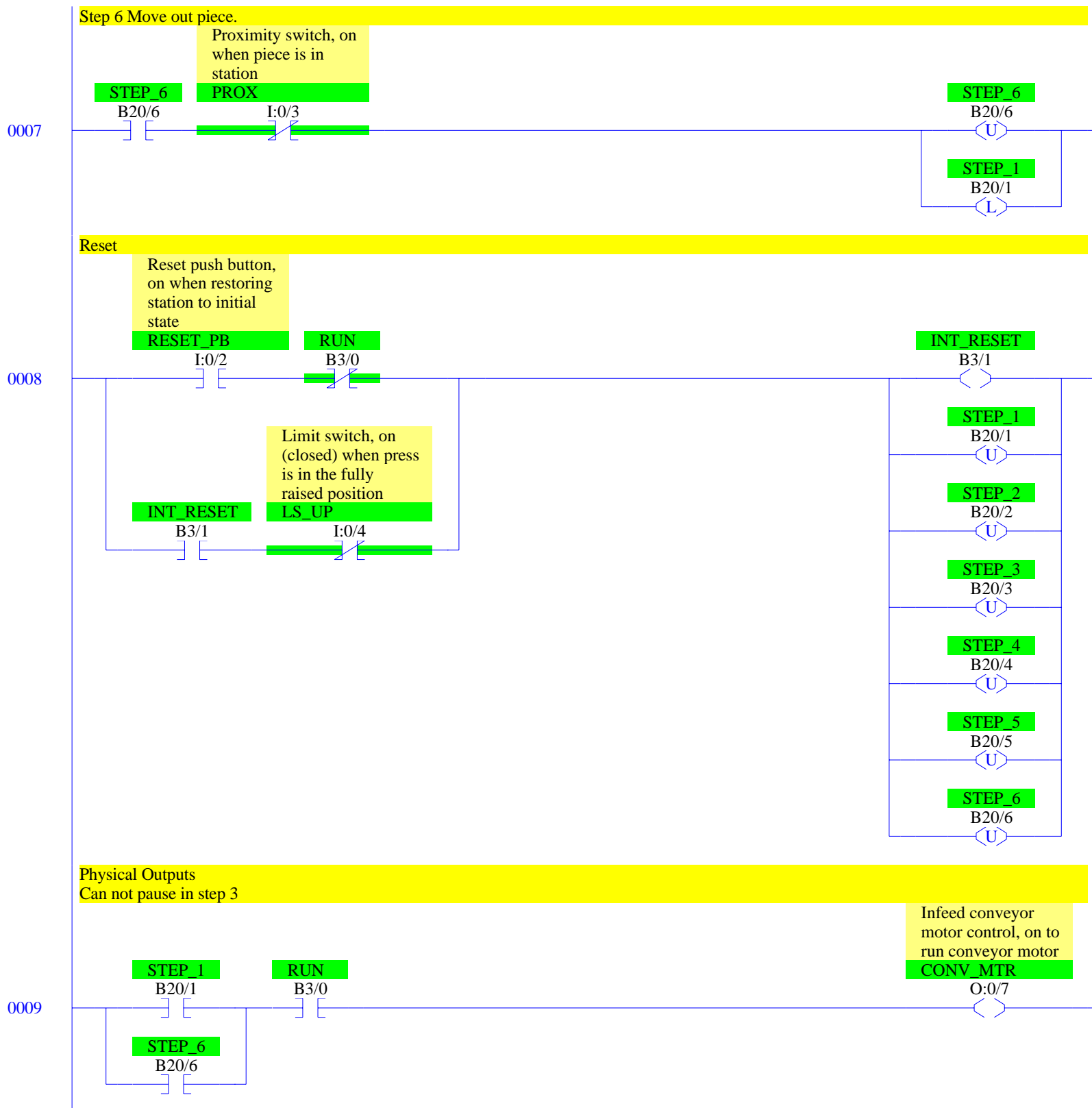
Symbol	Address	
RUN	B3/0	On while station running
INT_RESET	B3/1	Internal reset
STEP_1 to STEP_6	B20/1 to B20/6	Step-in-progress bits
PRESS_TMR	T4:1	Times press step
COOL_TMR	T4:2	Times cool-down of part

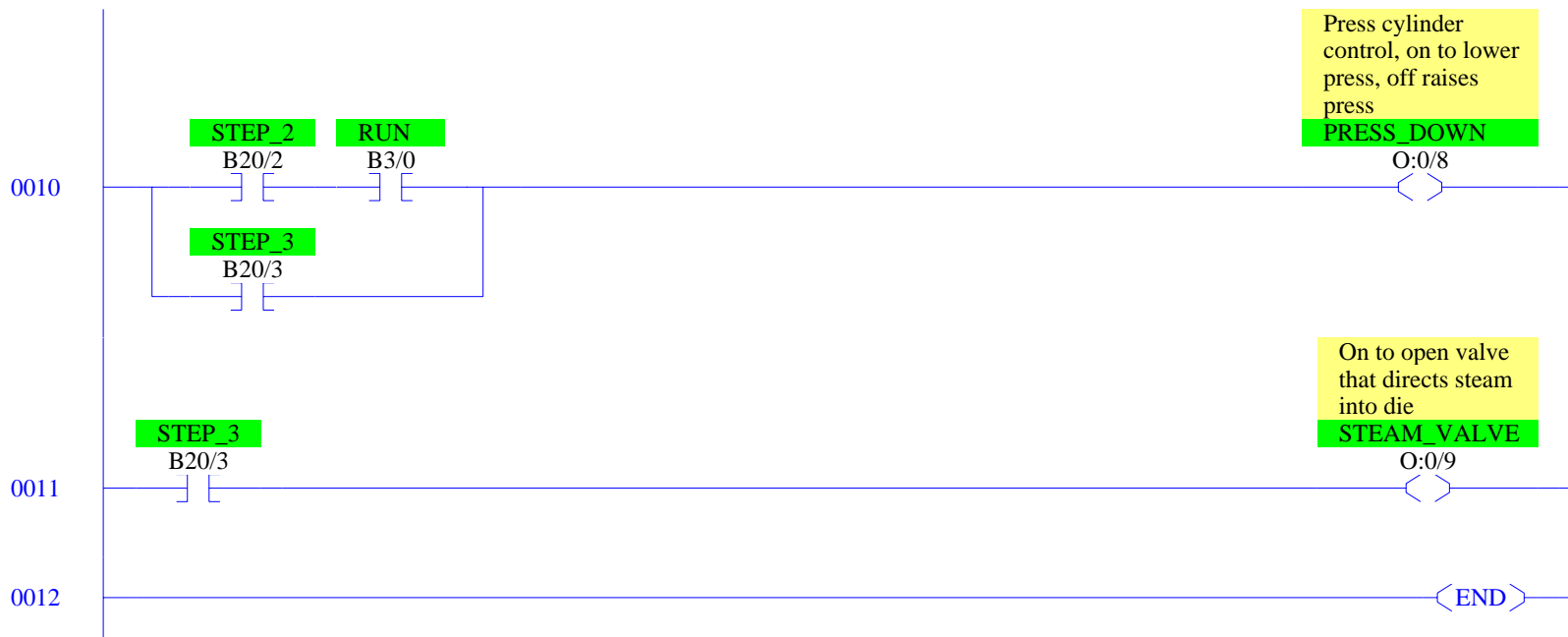
Start/stop and initial start.

During restart prevent start.









RSLogix 500 Cross Reference Report - Sorted by Address

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O:0/7      - {CONV_MTR} Infeed conveyor motor control, on to run conveyor motor
             OTE - File #2 - 9
O:0/8      - {PRESS_DOWN} Press cylinder control, on to lower press, off raises press
             OTE - File #2 - 10
O:0/9      - {STEAM_VALVE} On to open valve that directs steam into die
             OTE - File #2 - 11
I:0/0      - {START_PB} Start push button, on when starting
             XIC - File #2 - 0
I:0/1      - {STOP_PB} Stop push button, off when stopping
             XIC - File #2 - 0
I:0/2      - {RESET_PB} Reset push button, on when restoring station to initial state
             XIC - File #2 - 8
I:0/3      - {PROX} Proximity switch, on when piece is in station
             XIC - File #2 - 2
             XIO - File #2 - 7
I:0/4      - {LS_UP} Limit switch, on (closed) when press is in the fully raised position
             XIC - File #2 - 5
             XIO - File #2 - 8
I:0/5      - {LS_DN} Limit switch, on (closed) when press is in the fully lowered position
             XIC - File #2 - 3
B3/0       - {RUN}
             OTE - File #2 - 0
             XIC - File #2 - 0, 1, 9, 10
             XIO - File #2 - 8
B3/1       - {INT_RESET}
             OTE - File #2 - 8
             XIC - File #2 - 8
             XIO - File #2 - 0
T4:1       - {PRESS_TMR} Press timer, 30.5 sec
             TON - File #2 - 4
T4:1/DN    - XIC - File #2 - 4
T4:2       - {COOL_TMR} Cooling timer, 45 sec
             TON - File #2 - 6
T4:2/DN    - XIC - File #2 - 6
B20/1      - {STEP_1}
             OTL - File #2 - 1, 7
             OTU - File #2 - 2, 8
             XIC - File #2 - 2, 9
             XIO - File #2 - 1
B20/2      - {STEP_2}
             OTL - File #2 - 2
             OTU - File #2 - 3, 8
             XIC - File #2 - 3, 10
             XIO - File #2 - 1
B20/3      - {STEP_3}
             OTL - File #2 - 3
             OTU - File #2 - 4, 8
             XIC - File #2 - 4, 10, 11
             XIO - File #2 - 1
B20/4      - {STEP_4}
             OTL - File #2 - 4
             OTU - File #2 - 5, 8
             XIC - File #2 - 5
             XIO - File #2 - 1
B20/5      - {STEP_5}
             OTL - File #2 - 5
             OTU - File #2 - 6, 8
             XIC - File #2 - 6
             XIO - File #2 - 1
B20/6      - {STEP_6}
             OTL - File #2 - 6
             OTU - File #2 - 7, 8
             XIC - File #2 - 7, 9
             XIO - File #2 - 1

```