

Part Oiler Station Control

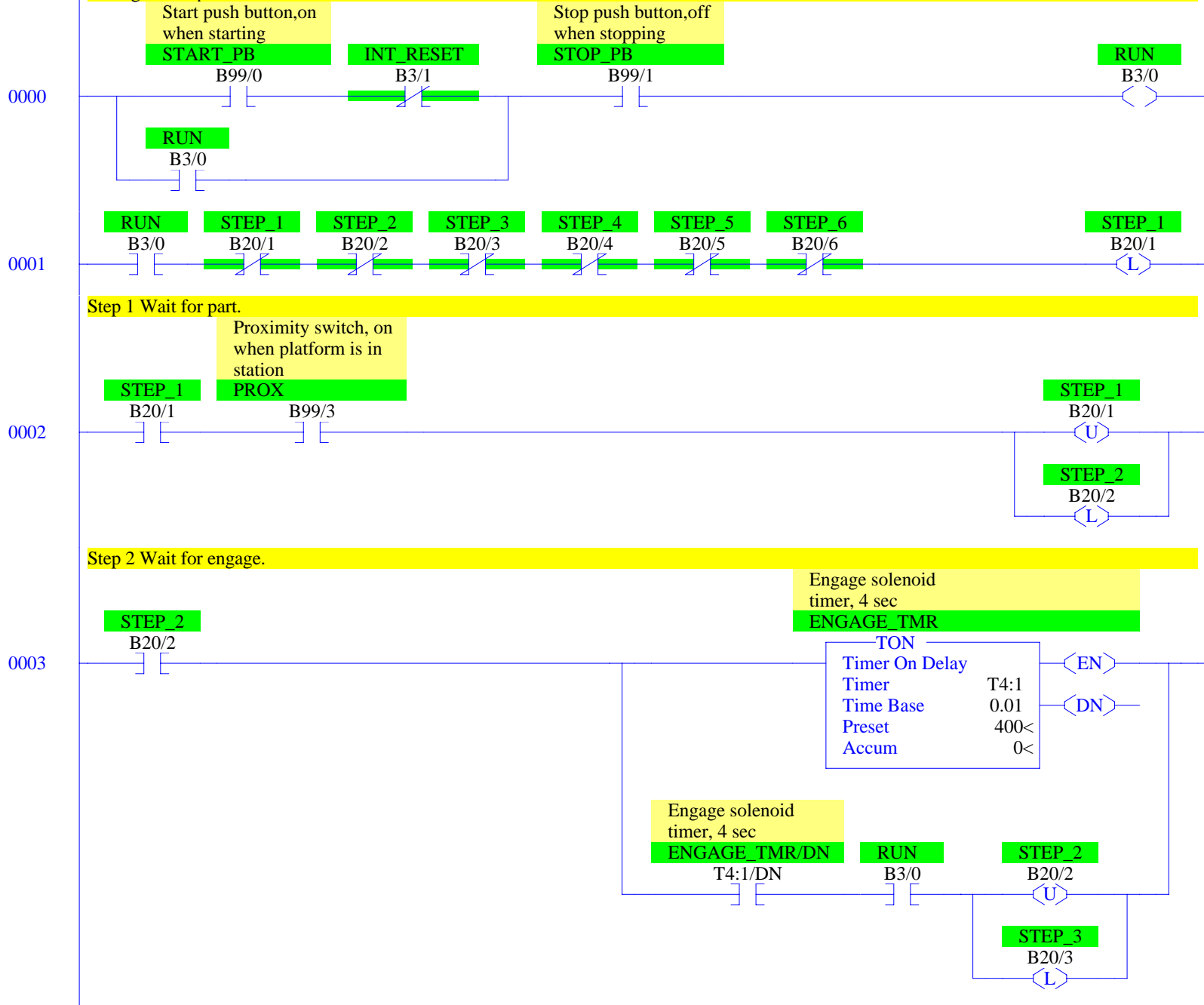
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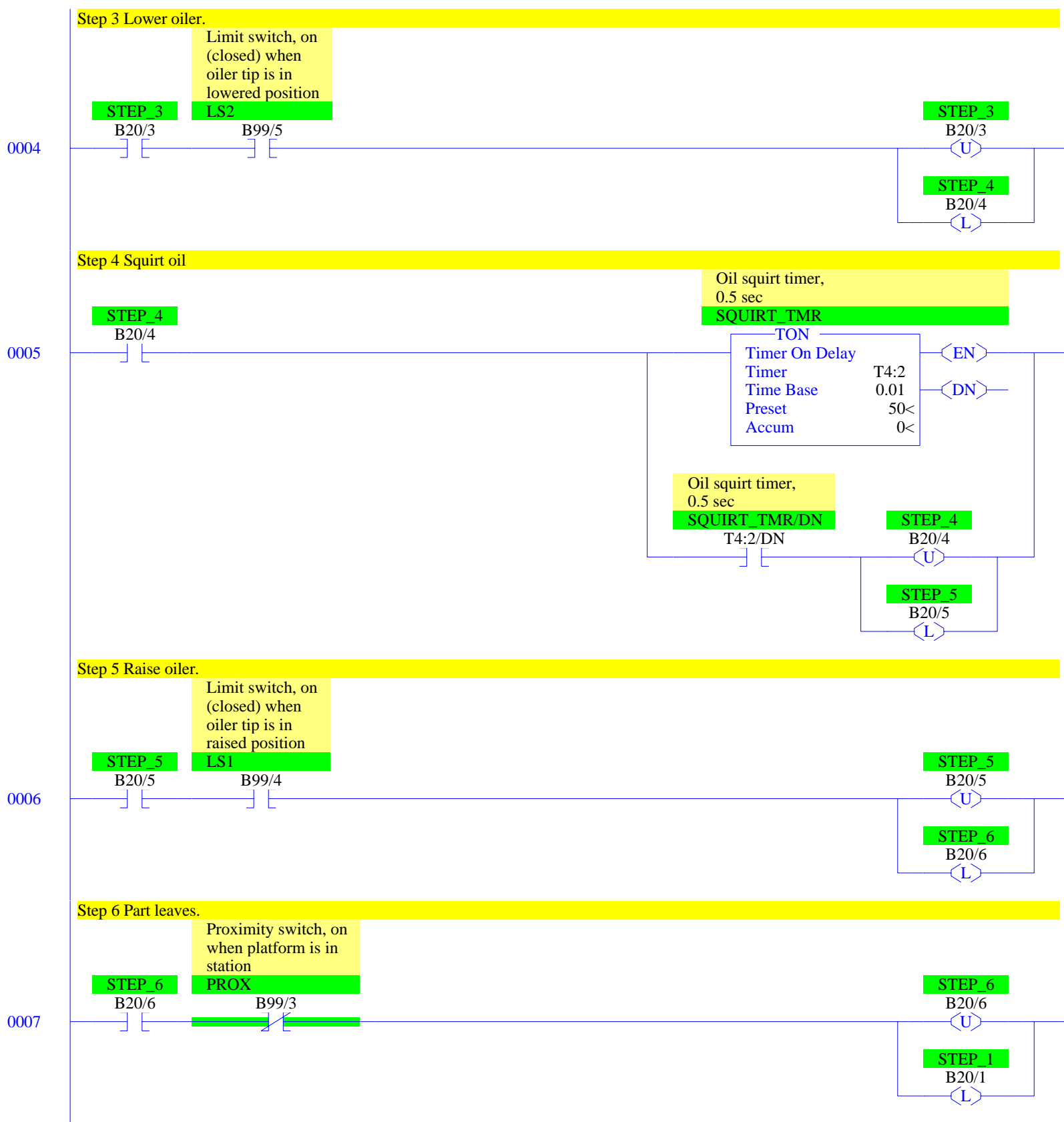
Additional internal memory:

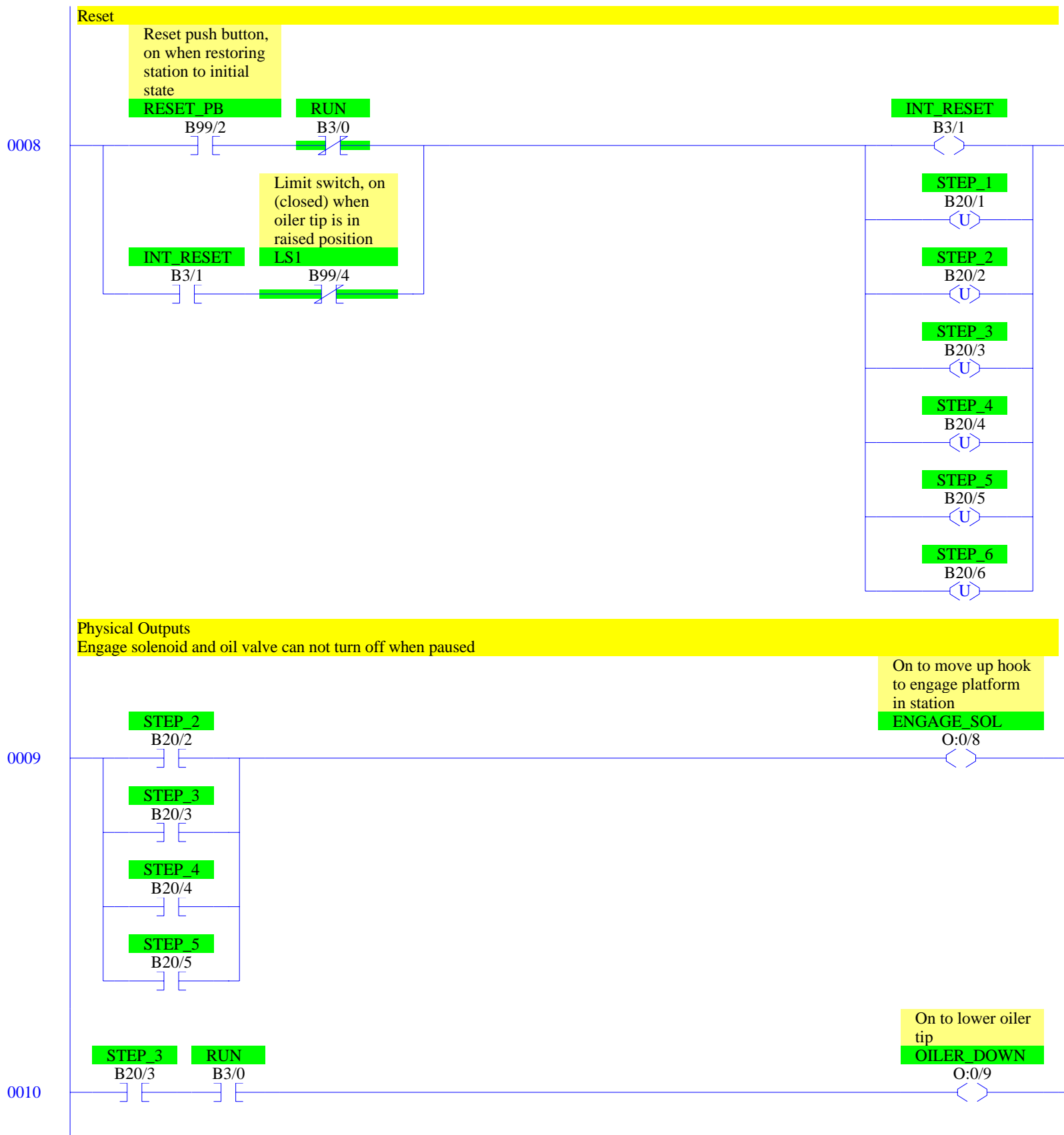
Symbol	Address	
RUN	B3/0	On while station running
INT_RESET	B3/1	Internal reset
STEP_1 to STEP_6	B20/1 to B20/6	Step-in-progress bits
ENGAGE_TMR	T4:1	Delay to capture engine
SQUIRT_TMR	T4:2	Times squirt of oil

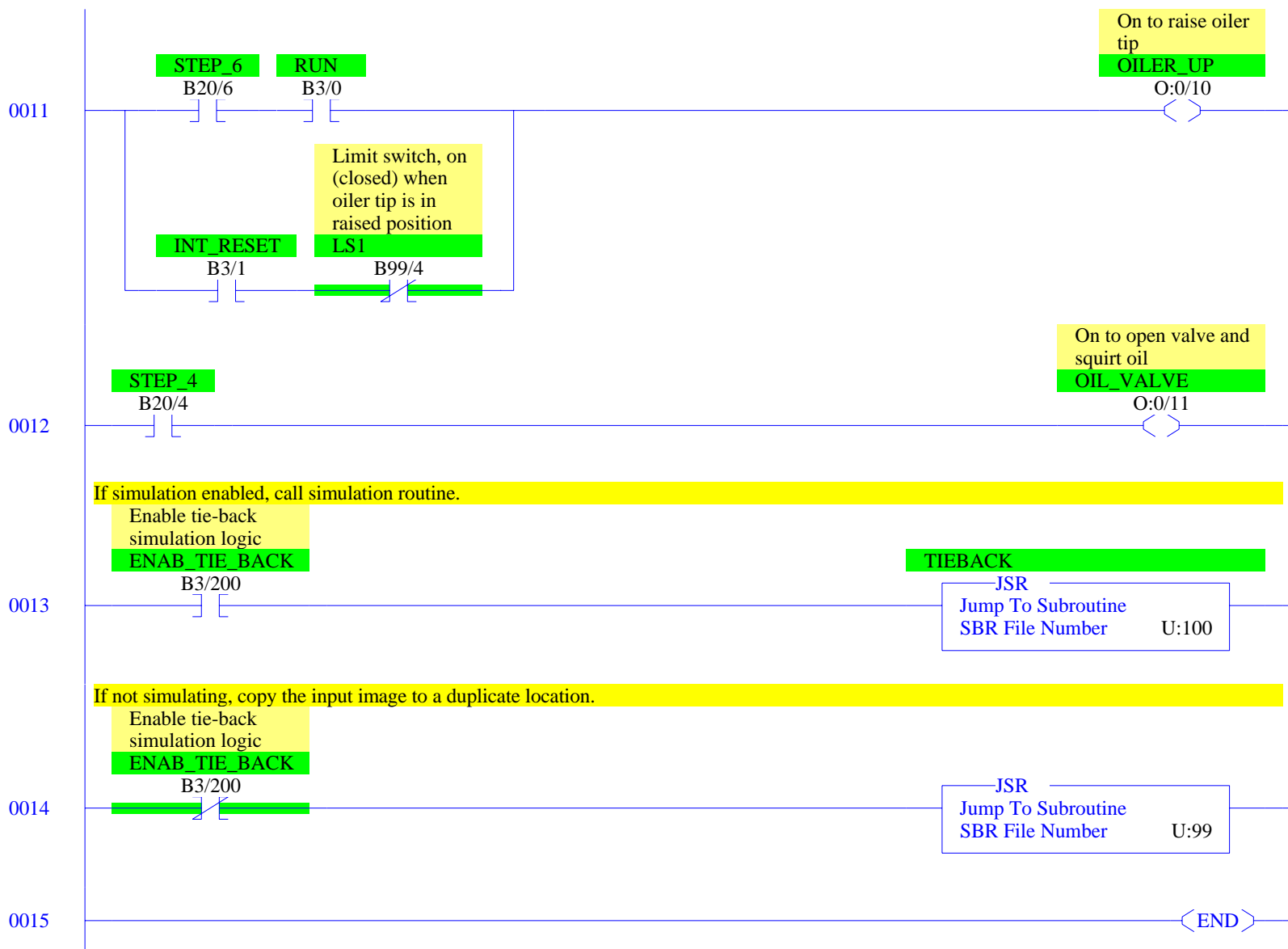
Start/stop and initial start.

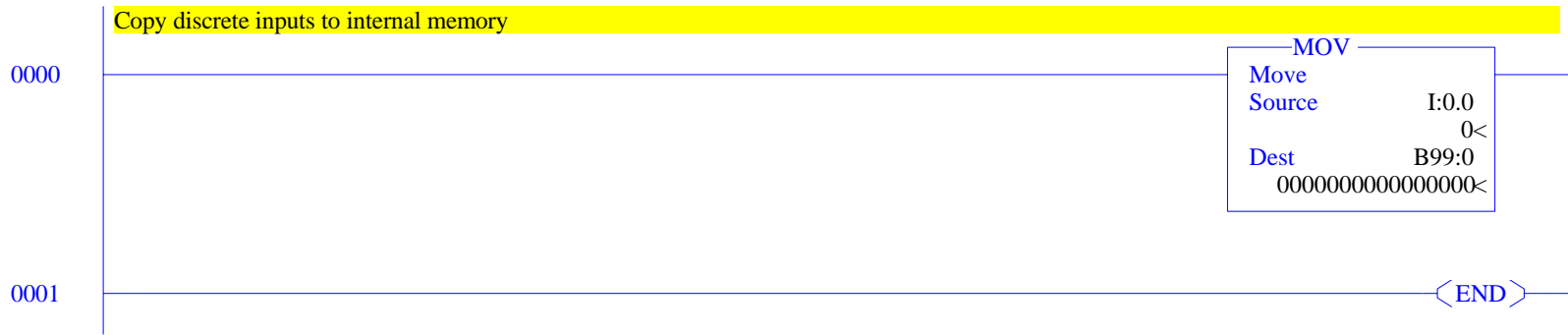
During restart prevent start.

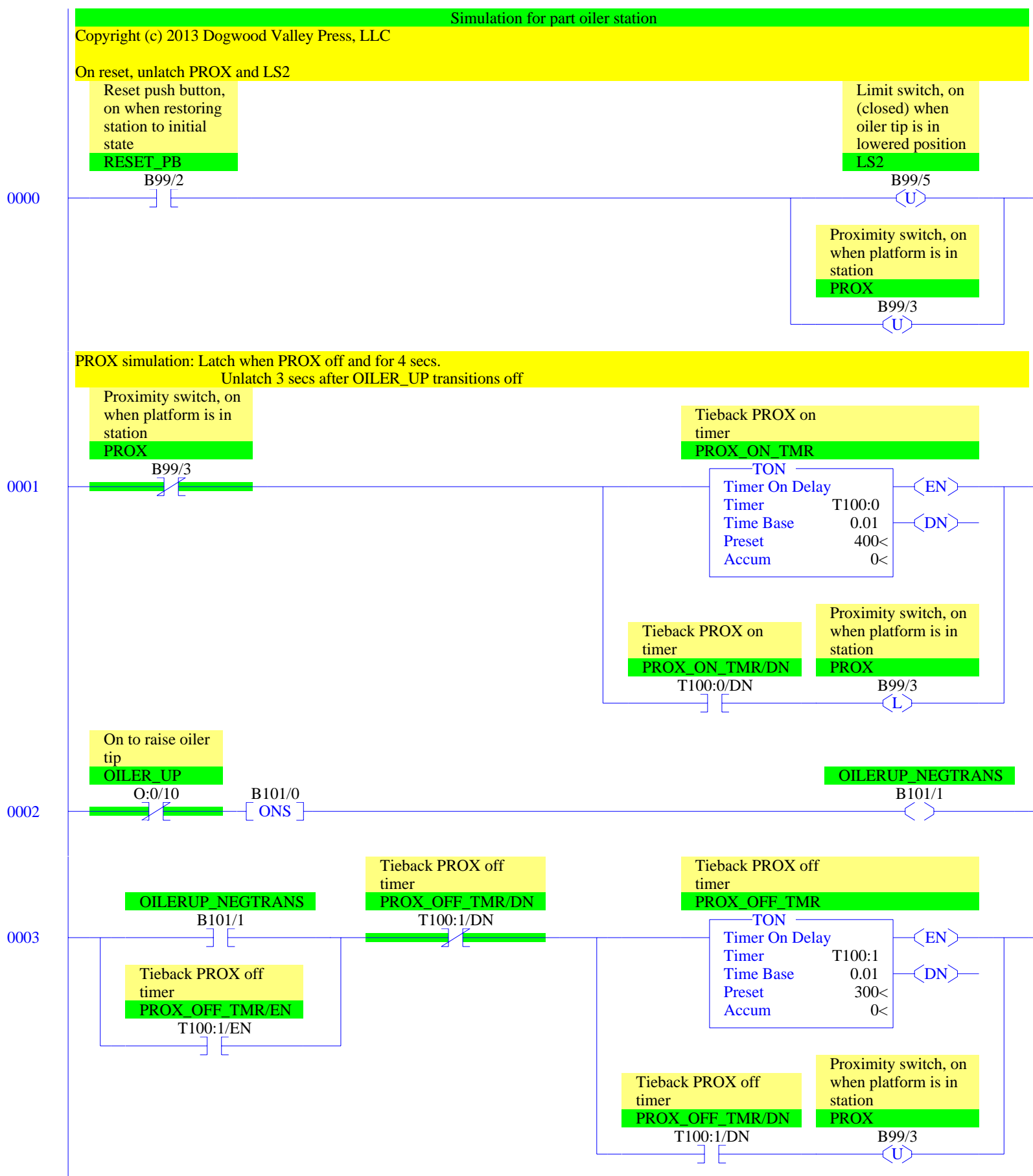


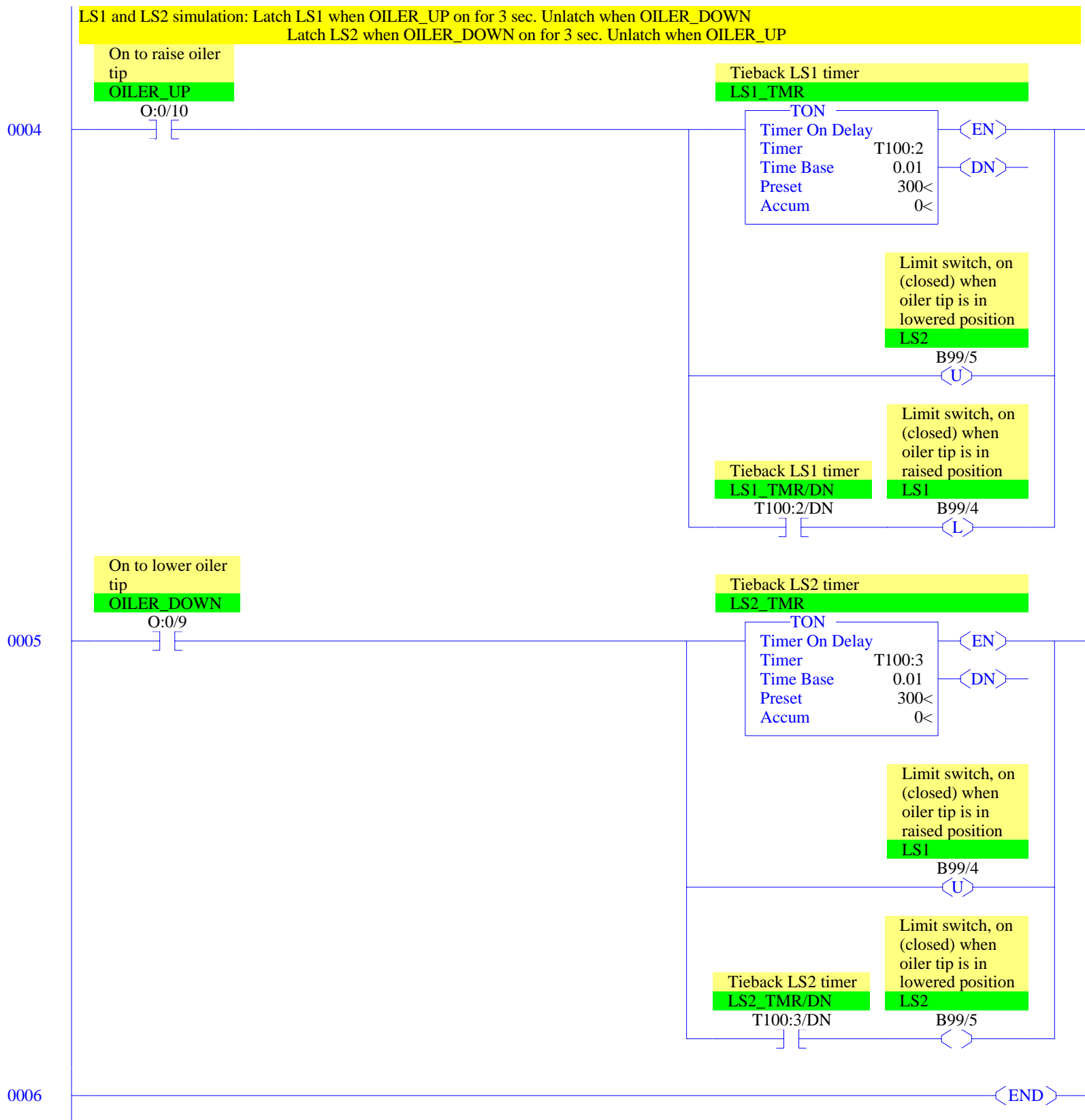












RSLogix 500 Cross Reference Report - Sorted by Address

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O:0/8      - {ENGAGE_SOL} On to move up hook to engage platform in station
            OTE - File #2 - 9
O:0/9      - {OILER_DOWN} On to lower oiler tip
            OTE - File #2 - 10
            XIC - File #100 TIEBACK - 5
O:0/10     - {OILER_UP} On to raise oiler tip
            OTE - File #2 - 11
            XIC - File #100 TIEBACK - 4
            XIO - File #100 TIEBACK - 2
O:0/11     - {OIL_VALVE} On to open valve and squirt oil
            OTE - File #2 - 12
I:0.0      - MOV - File #99 DUPLIC_INS - 0
B3/0       - {RUN}
            OTE - File #2 - 0
            XIC - File #2 - 0, 1, 3, 10, 11
            XIO - File #2 - 8
B3/1       - {INT_RESET}
            OTE - File #2 - 8
            XIC - File #2 - 8, 11
            XIO - File #2 - 0
B3/200     - {ENAB_TIE_BACK} Enable tie-back simulation logic
            XIC - File #2 - 13
            XIO - File #2 - 14
T4:1       - {ENGAGE_TMR} Engage solenoid timer, 4 sec
            TON - File #2 - 3
T4:1/DN    - XIC - File #2 - 3
T4:2       - {SQUIRT_TMR} Oil squirt timer, 0.5 sec
            TON - File #2 - 5
T4:2/DN    - XIC - File #2 - 5
B20/1      - {STEP_1}
            OTL - File #2 - 1, 7
            OTU - File #2 - 2, 8
            XIC - File #2 - 2
            XIO - File #2 - 1
B20/2      - {STEP_2}
            OTL - File #2 - 2
            OTU - File #2 - 3, 8
            XIC - File #2 - 3, 9
            XIO - File #2 - 1
B20/3      - {STEP_3}
            OTL - File #2 - 3
            OTU - File #2 - 4, 8
            XIC - File #2 - 4, 9, 10
            XIO - File #2 - 1
B20/4      - {STEP_4}
            OTL - File #2 - 4
            OTU - File #2 - 5, 8
            XIC - File #2 - 5, 9, 12
            XIO - File #2 - 1
B20/5      - {STEP_5}
            OTL - File #2 - 5
            OTU - File #2 - 6, 8
            XIC - File #2 - 6, 9
            XIO - File #2 - 1
B20/6      - {STEP_6}
            OTL - File #2 - 6
            OTU - File #2 - 7, 8
            XIC - File #2 - 7, 11
            XIO - File #2 - 1
B99:0      - MOV - File #99 DUPLIC_INS - 0
B99/0      - {START_PB} Start push button,on when starting
            XIC - File #2 - 0
B99/1      - {STOP_PB} Stop push button,off when stopping
            XIC - File #2 - 0
B99/2      - {RESET_PB} Reset push button, on when restoring station to initial state
            XIC - File #2 - 8

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RSLogix 500 Cross Reference Report - Sorted by Address

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      File #100 TIEBACK - 0
B99/3  - {PROX} Proximity switch, on when platform is in station
      OTL - File #100 TIEBACK - 1
      OTU - File #100 TIEBACK - 0, 3
      XIC - File #2 - 2
      XIO - File #2 - 7
      File #100 TIEBACK - 1
B99/4  - {LS1} Limit switch, on (closed) when oiler tip is in raised position
      OTL - File #100 TIEBACK - 4
      OTU - File #100 TIEBACK - 5
      XIC - File #2 - 6
      XIO - File #2 - 8, 11
B99/5  - {LS2} Limit switch, on (closed) when oiler tip is in lowered position
      OTE - File #100 TIEBACK - 5
      OTU - File #100 TIEBACK - 0, 4
      XIC - File #2 - 4
T100:0 - {PROX_ON_TMR} Tieback PROX on timer
      TON - File #100 TIEBACK - 1
T100:0/DN - XIC - File #100 TIEBACK - 1
T100:1 - {PROX_OFF_TMR} Tieback PROX off timer
      TON - File #100 TIEBACK - 3
T100:1/DN - XIC - File #100 TIEBACK - 3
      XIO - File #100 TIEBACK - 3
T100:1/EN - XIC - File #100 TIEBACK - 3
T100:2 - {LS1_TMR} Tieback LS1 timer
      TON - File #100 TIEBACK - 4
T100:2/DN - XIC - File #100 TIEBACK - 4
T100:3 - {LS2_TMR} Tieback LS2 timer
      TON - File #100 TIEBACK - 5
T100:3/DN - XIC - File #100 TIEBACK - 5
B101/0 - ONS - File #100 TIEBACK - 2
B101/1 - {OILERUP_NEGTRANS}
      OTE - File #100 TIEBACK - 2
      XIC - File #100 TIEBACK - 3
U:99   - JSR - File #2 - 14
U:100  - {TIEBACK}
      JSR - File #2 - 13

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