

## Conveyor Transfer 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_5	B20/1 to B20/5	Step-in-progress bits
DLY_TMR	T4:1	Box travel delay after gate up

Start/stop and initial start.

During restart prevent start.

Start push button, on  
when starting

START\_PB

I:0/0

Stop push button, off  
when stopping

STOP\_PB

I:0/1

RUN

B3/0

INT\_RESET

B3/1

RUN

B3/0

RUN

B3/0

STEP\_1

B20/1

STEP\_2

B20/2

STEP\_3

B20/3

STEP\_4

B20/4

STEP\_5

B20/5

STEP\_1

B20/1

Step 1 Wait for box.

Photoelectric  
sensor, on (closed)  
when box is present  
at gate

BOX\_PRESENT

I:0/4

STEP\_1

B20/1

STEP\_1

B20/1

STEP\_2

B20/2

Step 2 Move box on.

Photoelectric  
sensor, on (closed)  
when box is present  
at gate

BOX\_PRESENT

I:0/4

STEP\_2

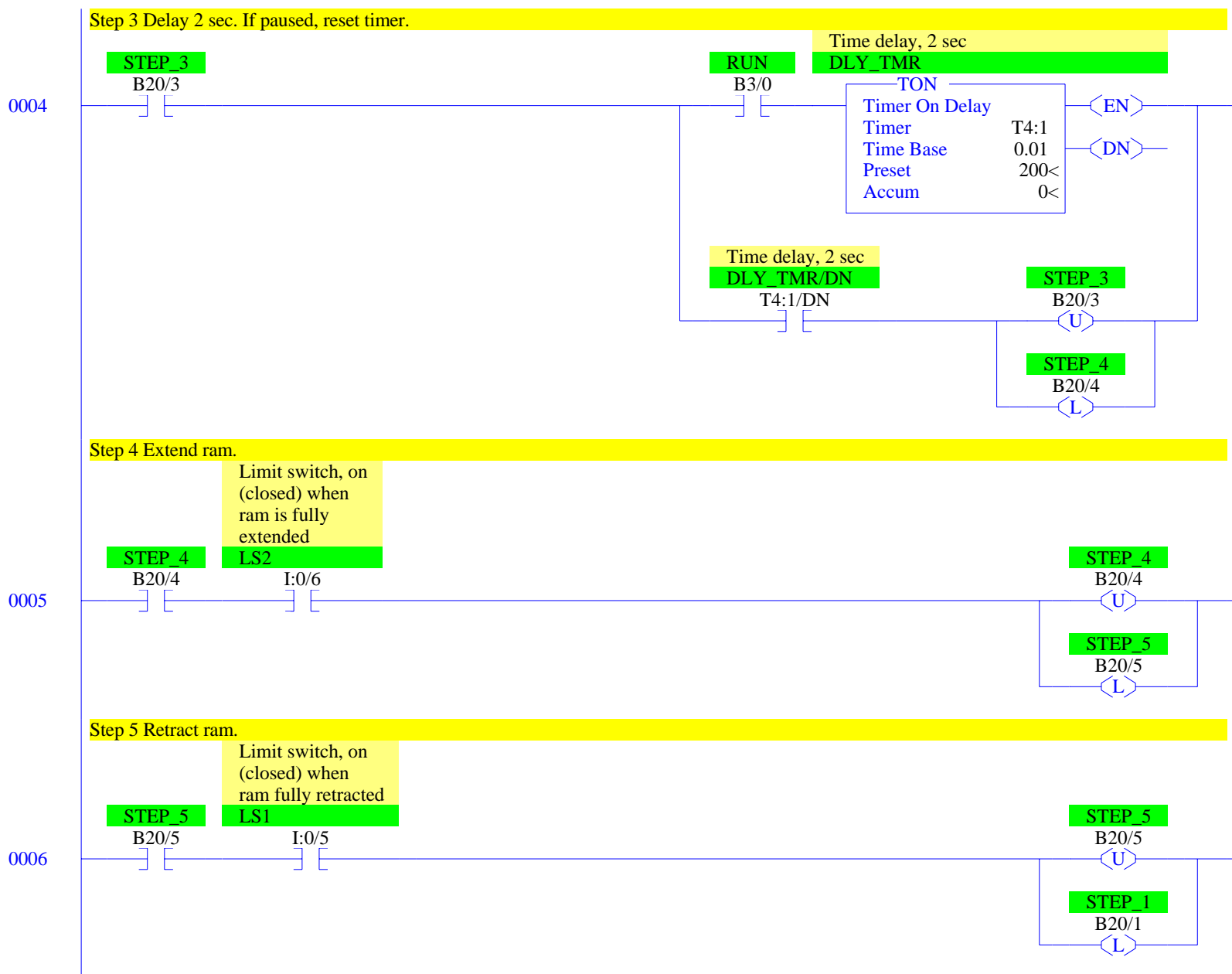
B20/2

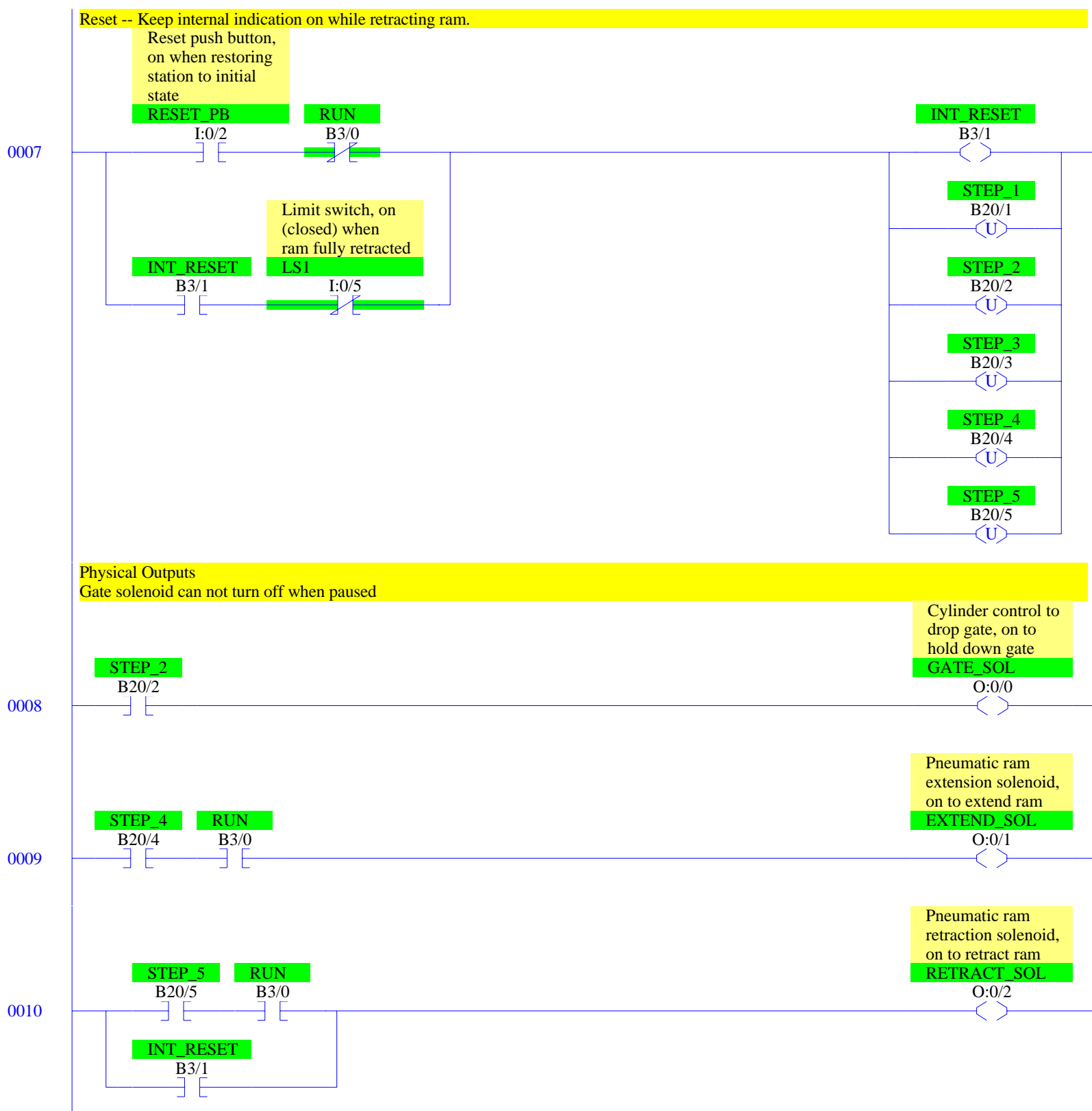
STEP\_2

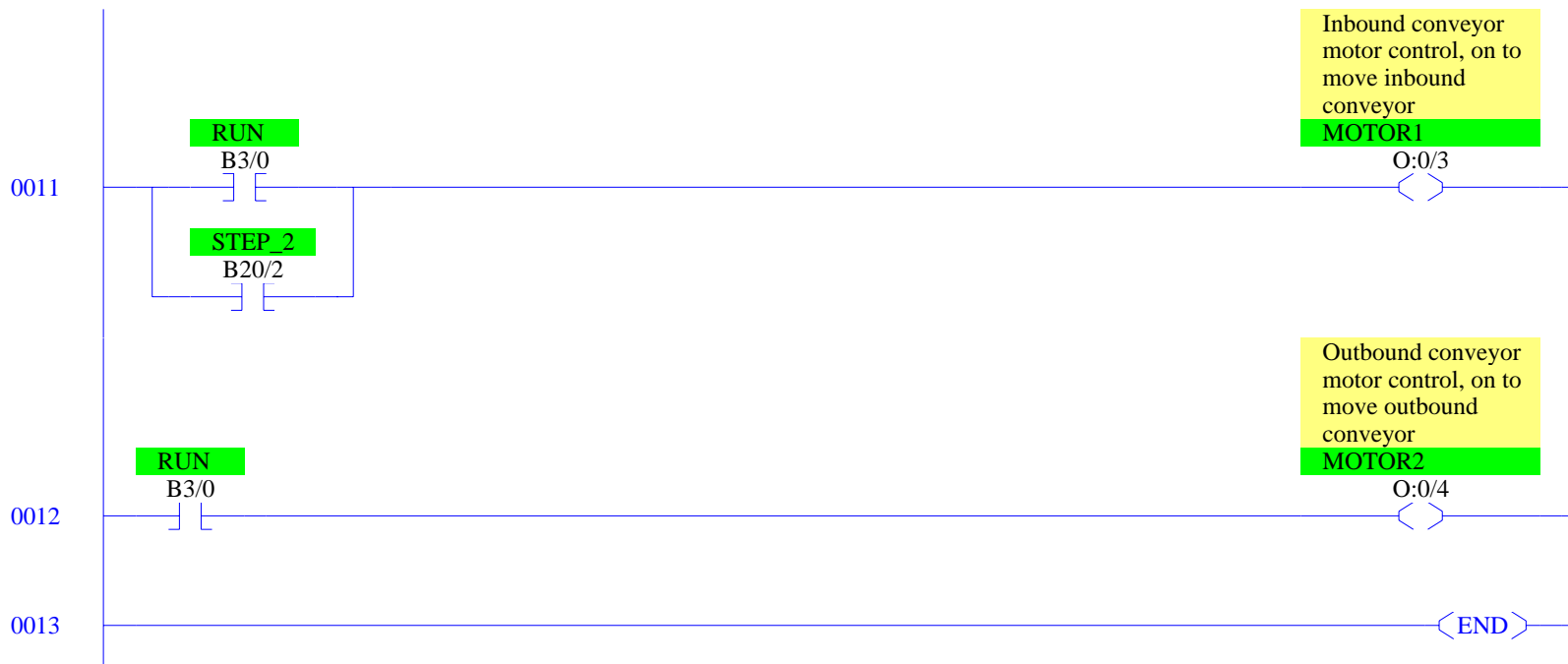
B20/2

STEP\_3

B20/3







## RSLogix 500 Cross Reference Report - Sorted by Address

O:0/0	- {GATE_SOL} Cylinder control to drop gate, on to hold down gate OTE - File #2 - 8
O:0/1	- {EXTEND_SOL} Pneumatic ram extension solenoid, on to extend ram OTE - File #2 - 9
O:0/2	- {RETRACT_SOL} Pneumatic ram retraction solenoid, on to retract ram OTE - File #2 - 10
O:0/3	- {MOTOR1} Inbound conveyor motor control, on to move inbound conveyor OTE - File #2 - 11
O:0/4	- {MOTOR2} Outbound conveyor motor control, on to move outbound conveyor OTE - File #2 - 12
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 - 7
I:0/4	- {BOX_PRESENT} Photoelectric sensor, on (closed) when box is present at gate XIC - File #2 - 2 XIO - File #2 - 3
I:0/5	- {LS1} Limit switch, on (closed) when ram fully retracted XIC - File #2 - 6 XIO - File #2 - 7
I:0/6	- {LS2} Limit switch, on (closed) when ram is fully extended XIC - File #2 - 5
B3/0	- {RUN} OTE - File #2 - 0 XIC - File #2 - 0, 1, 4, 9, 10, 11, 12 XIO - File #2 - 7
B3/1	- {INT_RESET} OTE - File #2 - 7 XIC - File #2 - 7, 10 XIO - File #2 - 0
T4:1	- {DLY_TMR} Time delay, 2 sec TON - File #2 - 4
T4:1/DN	- XIC - File #2 - 4
B20/1	- {STEP_1} OTL - File #2 - 1, 6 OTU - File #2 - 2, 7 XIC - File #2 - 2 XIO - File #2 - 1
B20/2	- {STEP_2} OTL - File #2 - 2 OTU - File #2 - 3, 7 XIC - File #2 - 3, 8, 11 XIO - File #2 - 1
B20/3	- {STEP_3} OTL - File #2 - 3 OTU - File #2 - 4, 7 XIC - File #2 - 4 XIO - File #2 - 1
B20/4	- {STEP_4} OTL - File #2 - 4 OTU - File #2 - 5, 7 XIC - File #2 - 5, 9 XIO - File #2 - 1
B20/5	- {STEP_5} OTL - File #2 - 5 OTU - File #2 - 6, 7 XIC - File #2 - 6, 10 XIO - File #2 - 1