

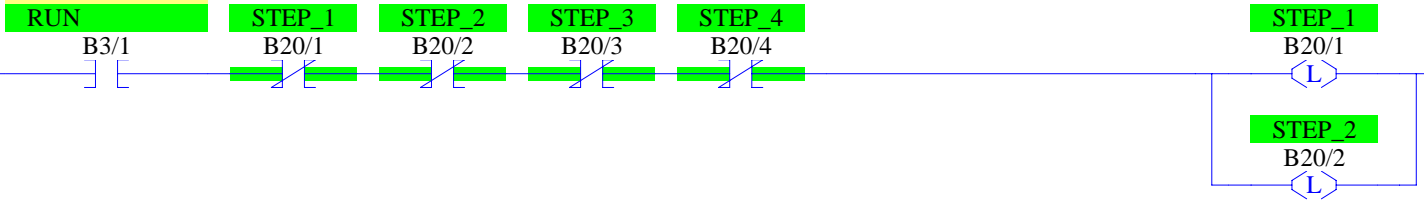
Revised Parts Transfer Station Control

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Additional internal memory:

Symbol	Address	
STEP_1 to STEP_4	B20/1 to B20/4	Step-in-progress bits
MOTOR1_TMR	T4:1	Sealing bag timer
PARTS_CTR	C5:1	Parts counter

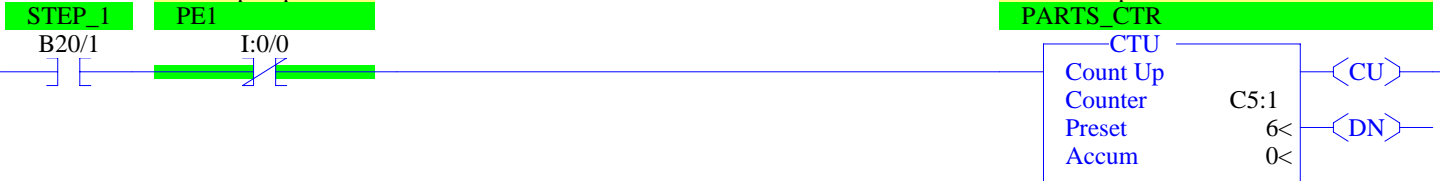
Initial start

Internal coil, on
when operation
enabled to run

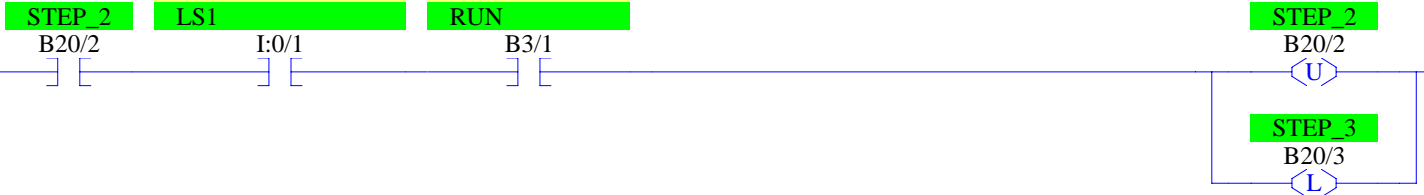
Step 1 Count Parts

Photoelectric
sensor, off (open)
when part passes

Counts 6 parts

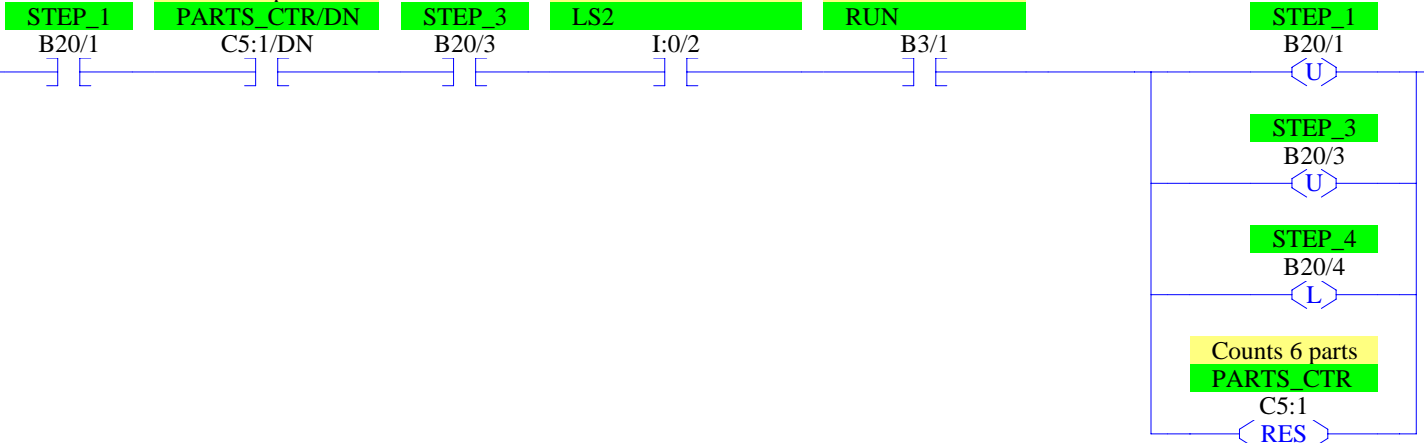


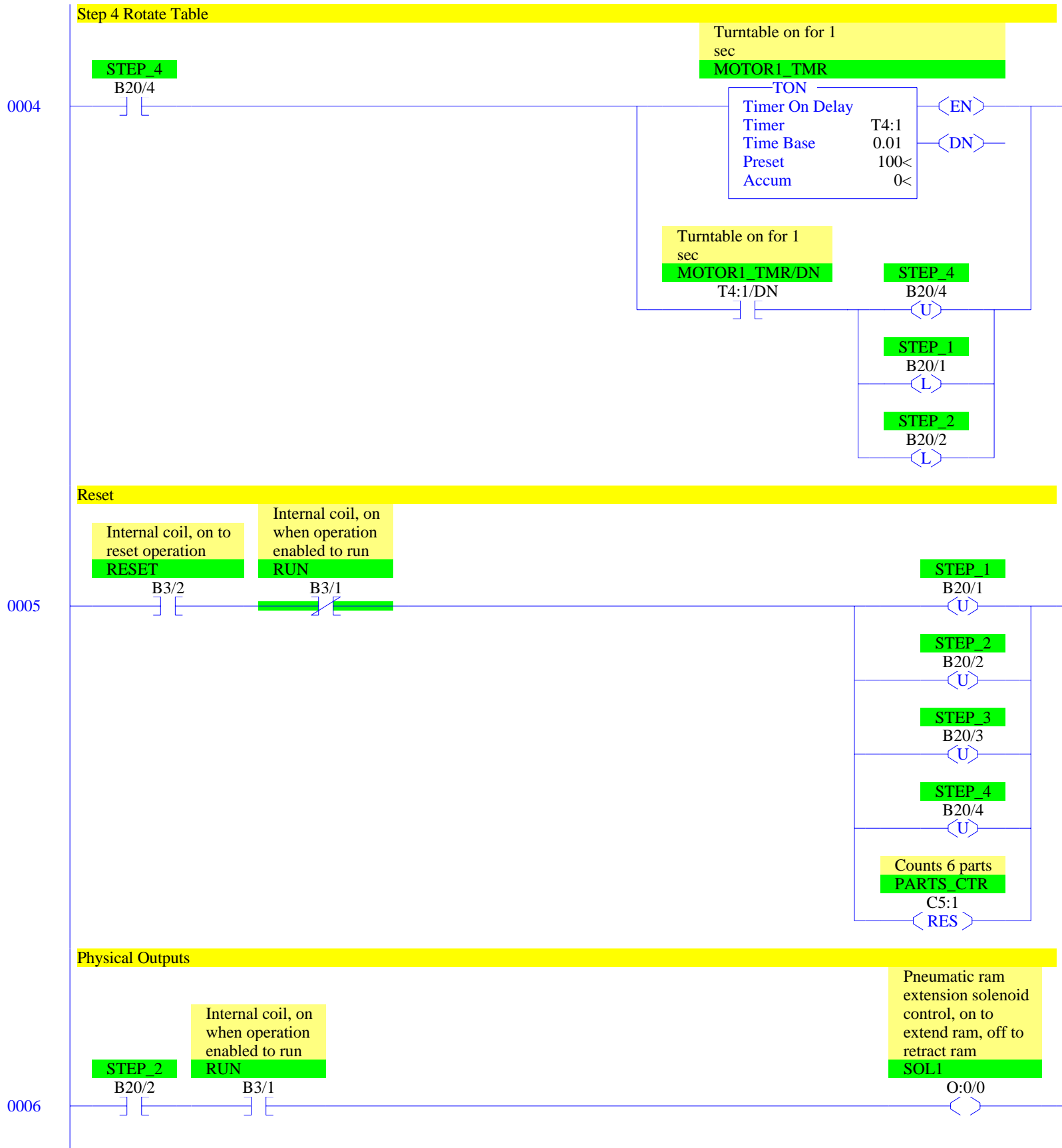
Step 2 Extend Ram

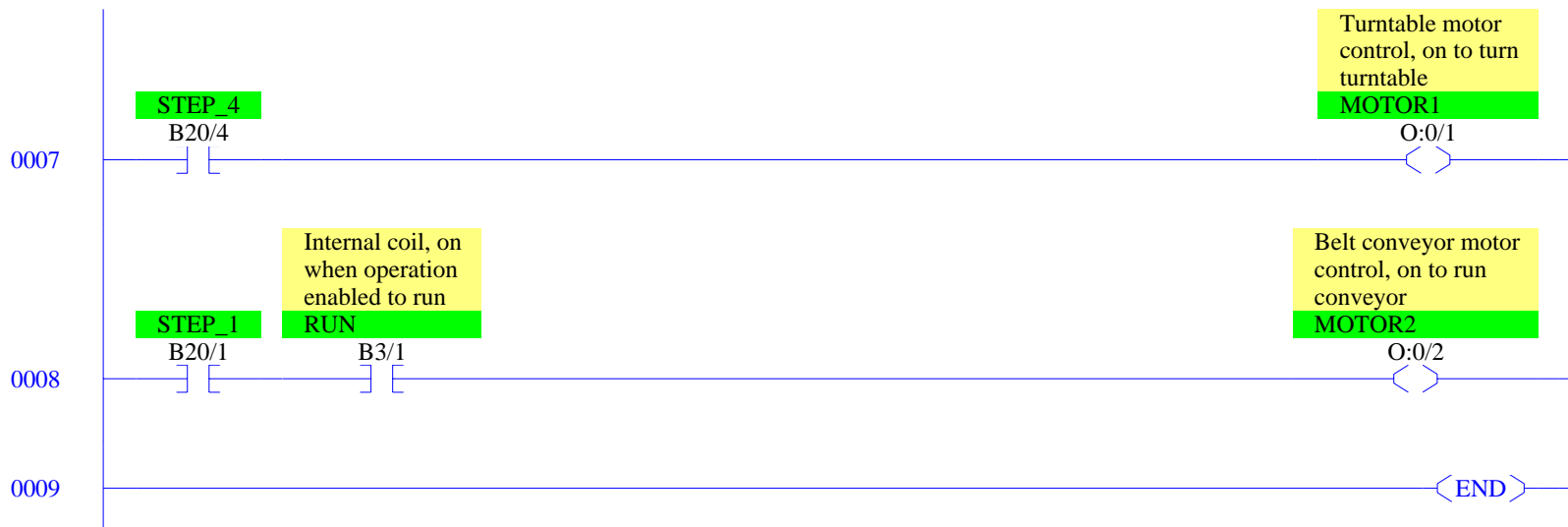
Ram extended limit
switch, on when ram
is extendedInternal coil, on
when operation
enabled to run

Transition out of Step 1, Count Parts and Step 3, Retract Ram

Counts 6 parts

Ram retracted limit
switch, on when ram
is retractedInternal coil, on
when operation
enabled to run





RSLogix 500 Cross Reference Report - Sorted by Address

O:0/0	- {SOL1} Pneumatic ram extension solenoid control, on to extend ram, off to retract ram OTE - File #2 - 6
O:0/1	- {MOTOR1} Turntable motor control, on to turn turntable OTE - File #2 - 7
O:0/2	- {MOTOR2} Belt conveyor motor control, on to run conveyor OTE - File #2 - 8
I:0/0	- {PE1} Photoelectric sensor, off (open) when part passes XIO - File #2 - 1
I:0/1	- {LS1} Ram extended limit switch, on when ram is extended XIC - File #2 - 2
I:0/2	- {LS2} Ram retracted limit switch, on when ram is retracted XIC - File #2 - 3
B3/1	- {RUN} Internal coil, on when operation enabled to run XIC - File #2 - 0, 2, 3, 6, 8 XIO - File #2 - 5
B3/2	- {RESET} Internal coil, on to reset operation XIC - File #2 - 5
T4:1	- {MOTOR1_TMR} Turntable on for 1 sec TON - File #2 - 4
T4:1/DN	- XIC - File #2 - 4
C5:1	- {PARTS_CTR} Counts 6 parts CTU - File #2 - 1 RES - File #2 - 3, 5
C5:1/DN	- XIC - File #2 - 3
B20/1	- {STEP_1} OTL - File #2 - 0, 4 OTU - File #2 - 3, 5 XIC - File #2 - 1, 3, 8 XIO - File #2 - 0
B20/2	- {STEP_2} OTL - File #2 - 0, 4 OTU - File #2 - 2, 5 XIC - File #2 - 2, 6 XIO - File #2 - 0
B20/3	- {STEP_3} OTL - File #2 - 2 OTU - File #2 - 3, 5 XIC - File #2 - 3 XIO - File #2 - 0
B20/4	- {STEP_4} OTL - File #2 - 3 OTU - File #2 - 4, 5 XIC - File #2 - 4, 7 XIO - File #2 - 0