

Hole Drilling Station 1 Control

Copyright (c) 2013 Dogwood Valley Press, LLC

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
GATE_TMR	T4:1	Delay to allow part to get to gate 2

Start/stop and initial start.

During restart prevent start.

Start push button, on
when startingSTART_PB
I:1/0INT_RESET
B3/1Stop push button, off
when stoppingSTOP_PB
I:1/1RUN
B3/0RUN
B3/0STEP_1
B20/1

(L)

Step 1 Wait for part.

Proximity switch, on
when part in
position 1STEP_1
B20/1

(L)

PROX1
I:1/4

(L)

RUN
B3/0

(L)

STEP_1
B20/1

(U)

STEP_2
B20/2

(L)

Step 2 Open Gate 1.

Gate 1 timer, 2 sec

GATE_TMR

(EN)

(DN)

TON
Timer On Delay
Timer T4:1
Time Base 0.01
Preset 200<
Accum 0<

(EN)

(DN)

(EN)

(DN)

(EN)

(DN)

(EN)

(DN)

(EN)

(DN)

(EN)

(DN)

(EN)

(DN)

(EN)

(DN)

(EN)

(DN)

(EN)

(DN)

(EN)

(DN)

(EN)

(DN)

Gate 1 timer, 2 sec

GATE_TMR/DN
T4:1/DN

(L)

RUN
B3/0

(L)

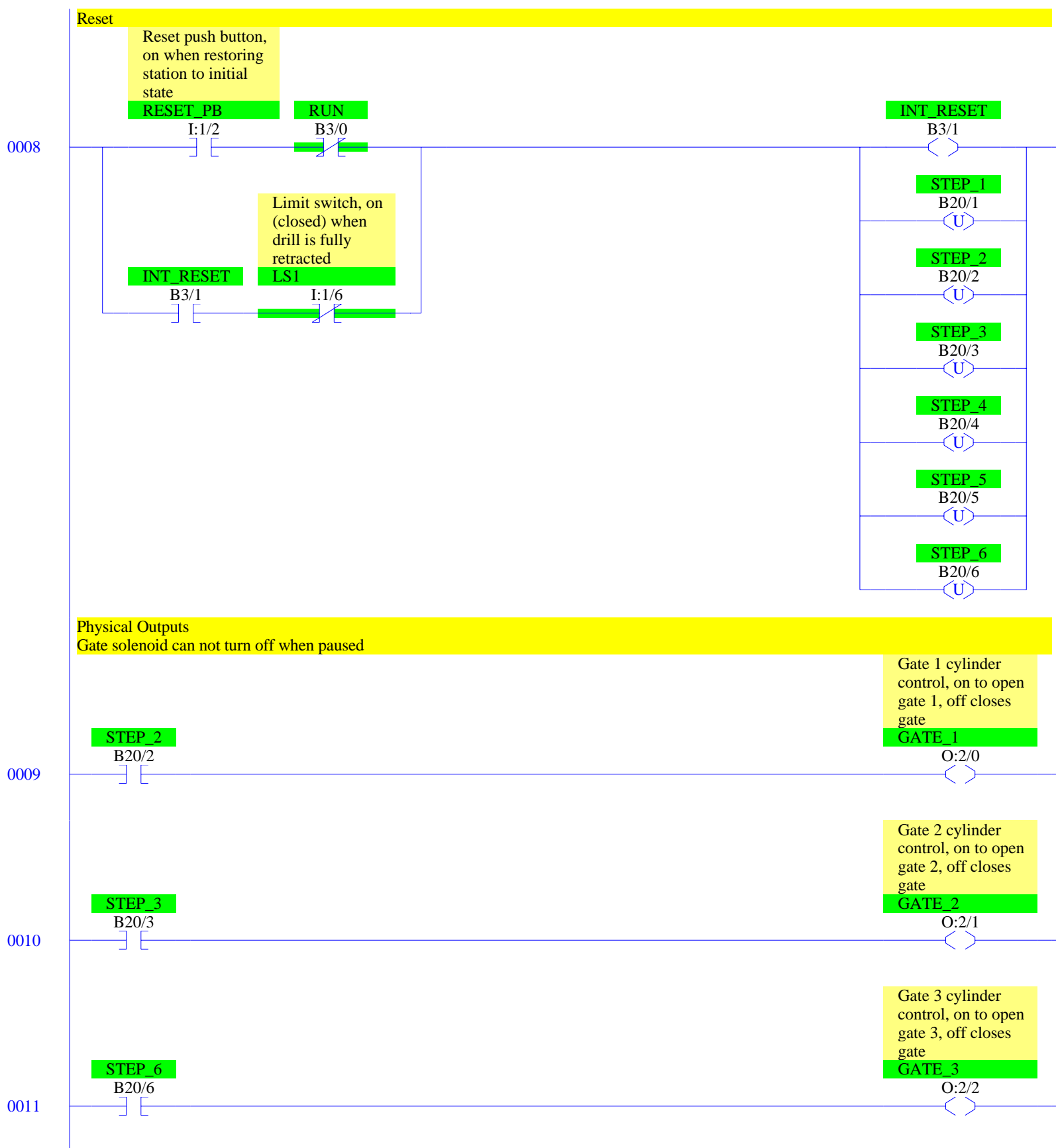
STEP_2
B20/2

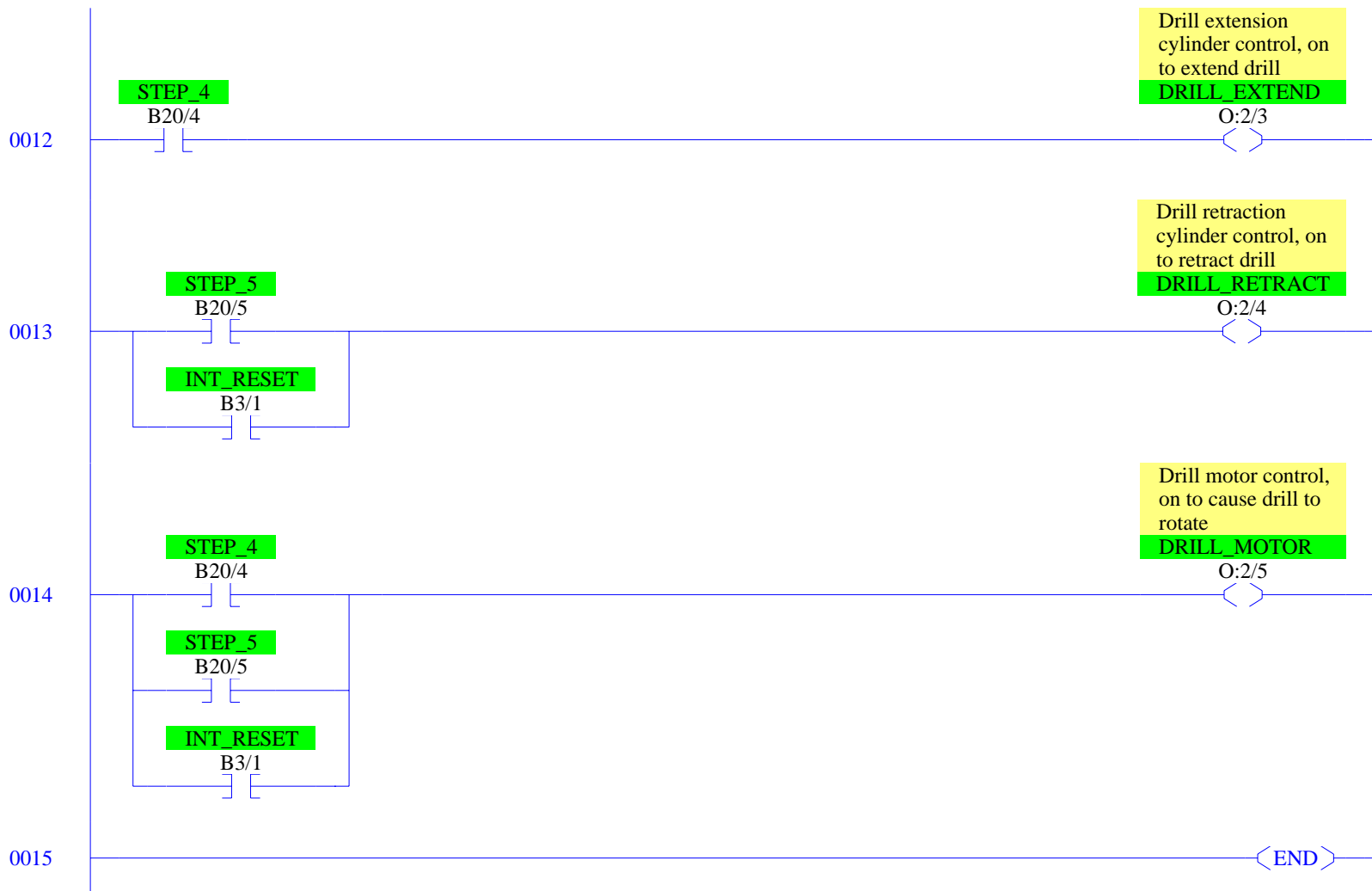
(U)

STEP_3
B20/3

(L)







RSLogix 500 Cross Reference Report - Sorted by Address

O:2/0	- {GATE_1} Gate 1 cylinder control, on to open gate 1, off closes gate OTE - File #2 - 9
O:2/1	- {GATE_2} Gate 2 cylinder control, on to open gate 2, off closes gate OTE - File #2 - 10
O:2/2	- {GATE_3} Gate 3 cylinder control, on to open gate 3, off closes gate OTE - File #2 - 11
O:2/3	- {DRILL_EXTEND} Drill extension cylinder control, on to extend drill OTE - File #2 - 12
O:2/4	- {DRILL_RETRACT} Drill retraction cylinder control, on to retract drill OTE - File #2 - 13
O:2/5	- {DRILL_MOTOR} Drill motor control, on to cause drill to rotate OTE - File #2 - 14
I:1/0	- {START_PB} Start push button, on when starting XIC - File #2 - 0
I:1/1	- {STOP_PB} Stop push button, off when stopping XIC - File #2 - 0
I:1/2	- {RESET_PB} Reset push button, on when restoring station to initial state XIC - File #2 - 8
I:1/4	- {PROX1} Proximity switch, on when part in position 1 XIC - File #2 - 2
I:1/5	- {PROX3} Proximity switch, on when part in position 3 XIC - File #2 - 4 XIO - File #2 - 7
I:1/6	- {LS1} Limit switch, on (closed) when drill is fully retracted XIC - File #2 - 6 XIO - File #2 - 8
I:1/7	- {LS2} Limit switch, on (closed) when drill is extended to proper hole depth XIC - File #2 - 5
B3/0	- {RUN} OTE - File #2 - 0 XIC - File #2 - 0, 1, 2, 3, 4, 6, 7 XIO - File #2 - 8
B3/1	- {INT_RESET} OTE - File #2 - 8 XIC - File #2 - 8, 13, 14 XIO - File #2 - 0
T4:1	- {GATE_TMR} Gate 1 timer, 2 sec TON - File #2 - 3
T4:1/DN	- XIC - File #2 - 3
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, 10 XIO - File #2 - 1
B20/4	- {STEP_4} OTL - File #2 - 4 OTU - File #2 - 5, 8 XIC - File #2 - 5, 12, 14 XIO - File #2 - 1
B20/5	- {STEP_5} OTL - File #2 - 5 OTU - File #2 - 6, 8 XIC - File #2 - 6, 13, 14 XIO - File #2 - 1
B20/6	- {STEP_6} OTL - File #2 - 6

RSLogix 500 Cross Reference Report - Sorted by Address

OTU - File #2 - 7, 8
XIC - File #2 - 7, 11
XIO - File #2 - 1