

Revised Parts Transfer Station Control

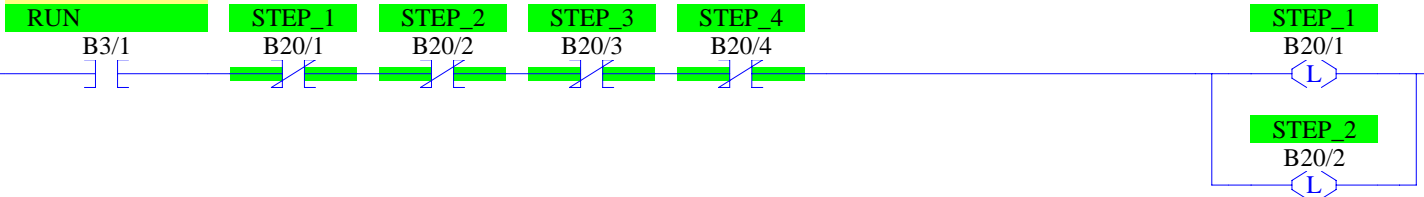
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Additional internal memory:

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

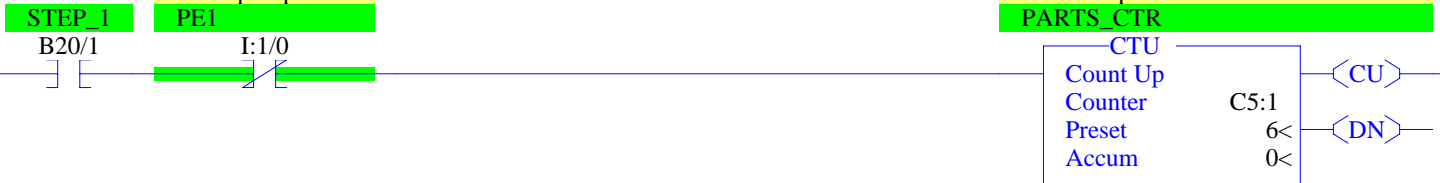
Initial start

Internal coil, on when operation enabled to run



Step 1 Count Parts

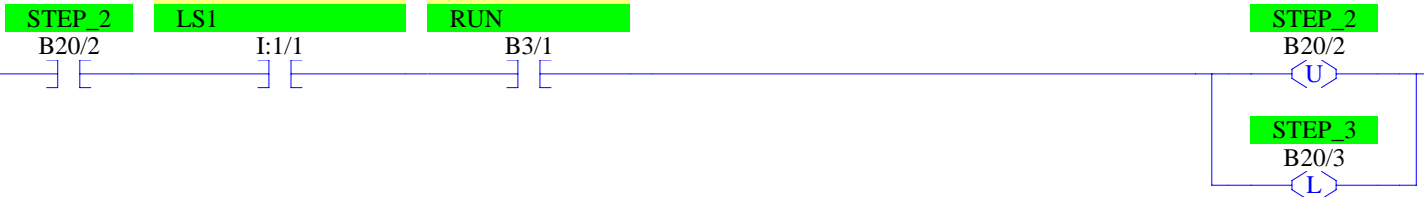
Photoelectric sensor, off (open) when part passes



Step 2 Extend Ram

Ram extended limit switch, on when ram is extended

Internal 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 retracted

Internal coil, on when operation enabled to run

