

Transfer Station Control

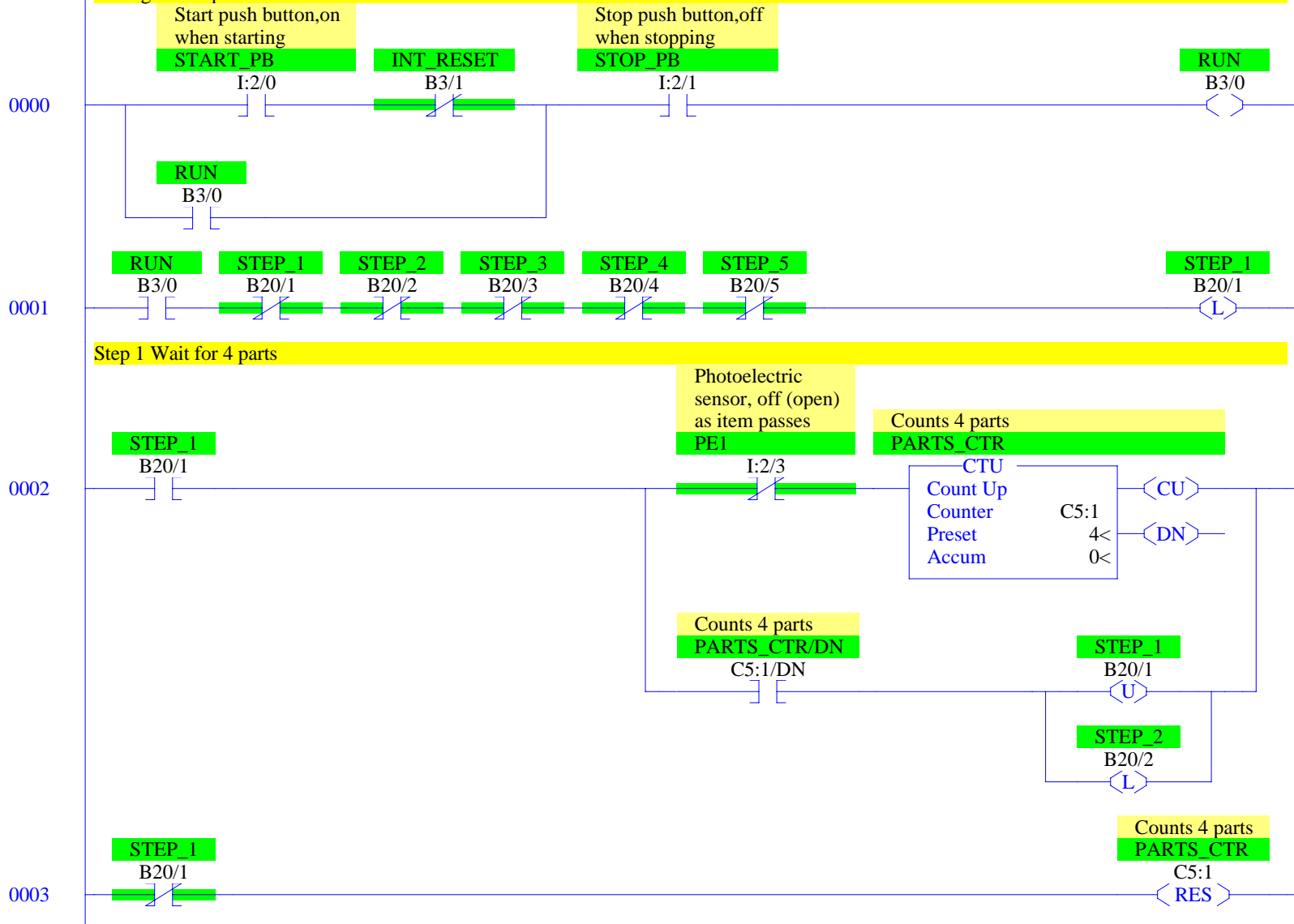
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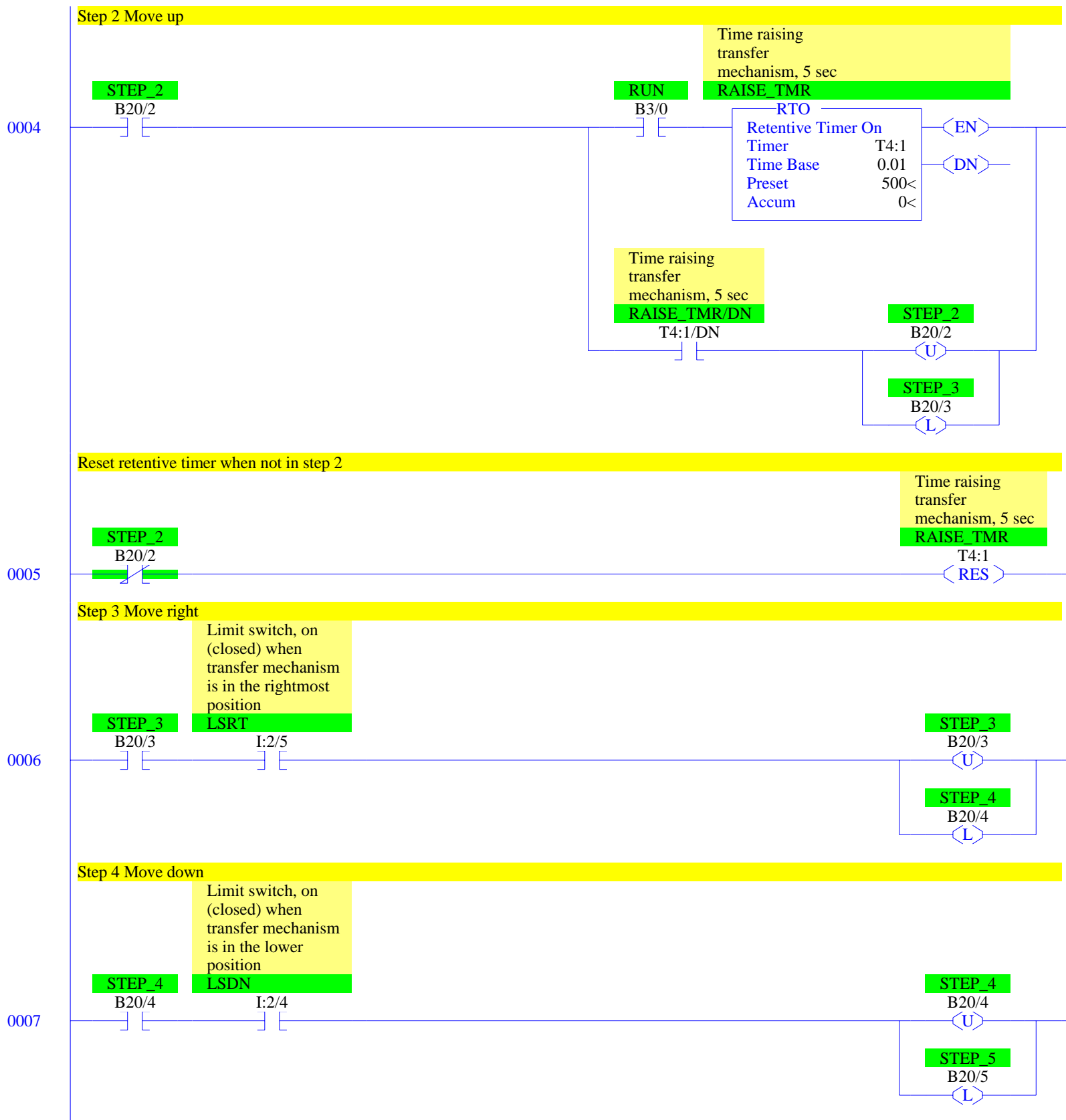
Additional internal memory:

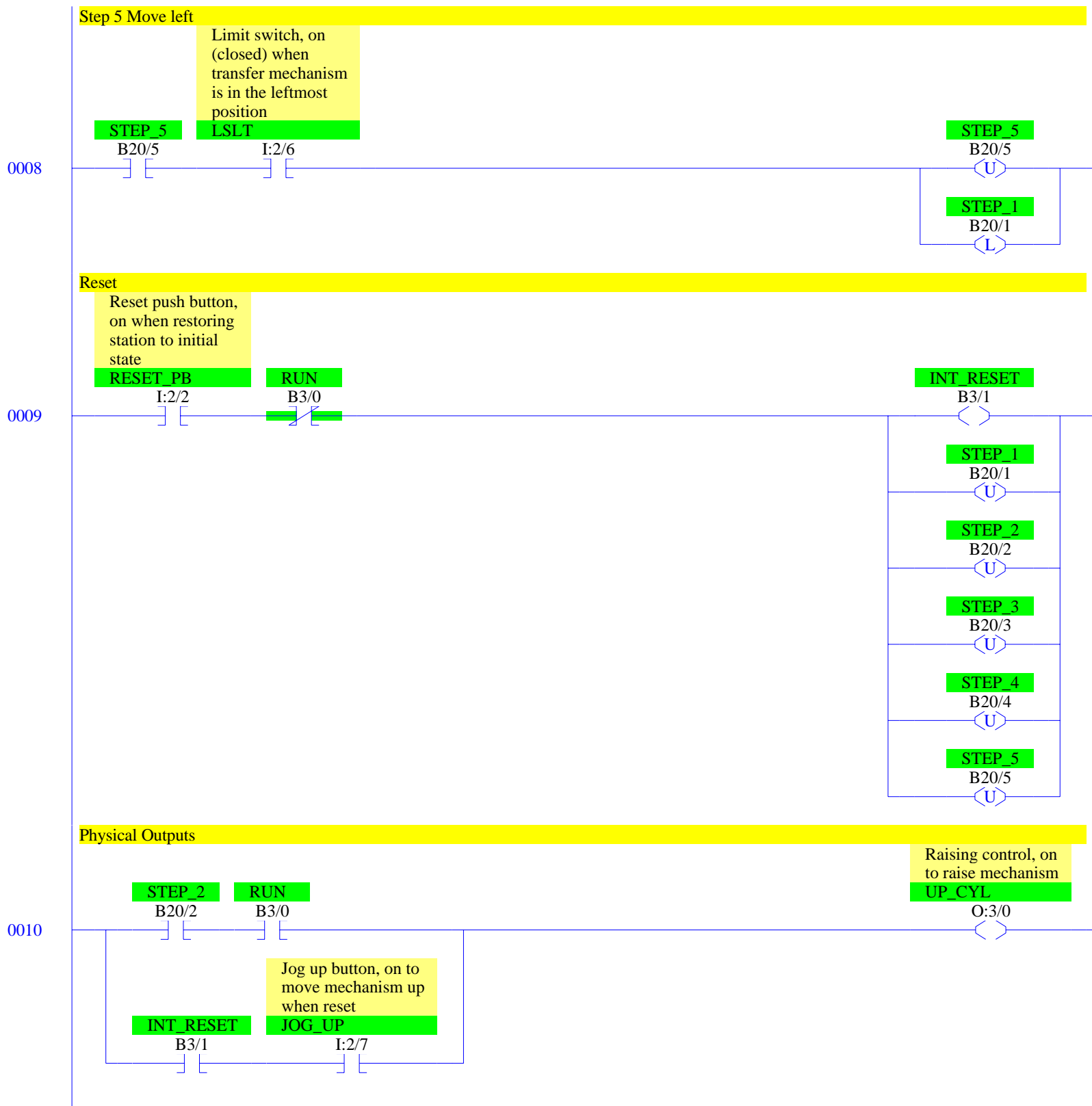
Symbol	Address	On while station running
RUN	B3/0	On while station running
INT_RESET	B3/1	Internal reset
STEP_1 to STEP_5	B20/1 to B20/5	Step-in-progress bits
RAISE_TMR	T4:1	Times moving up
PARTS_CTR	C5:1	Counts parts

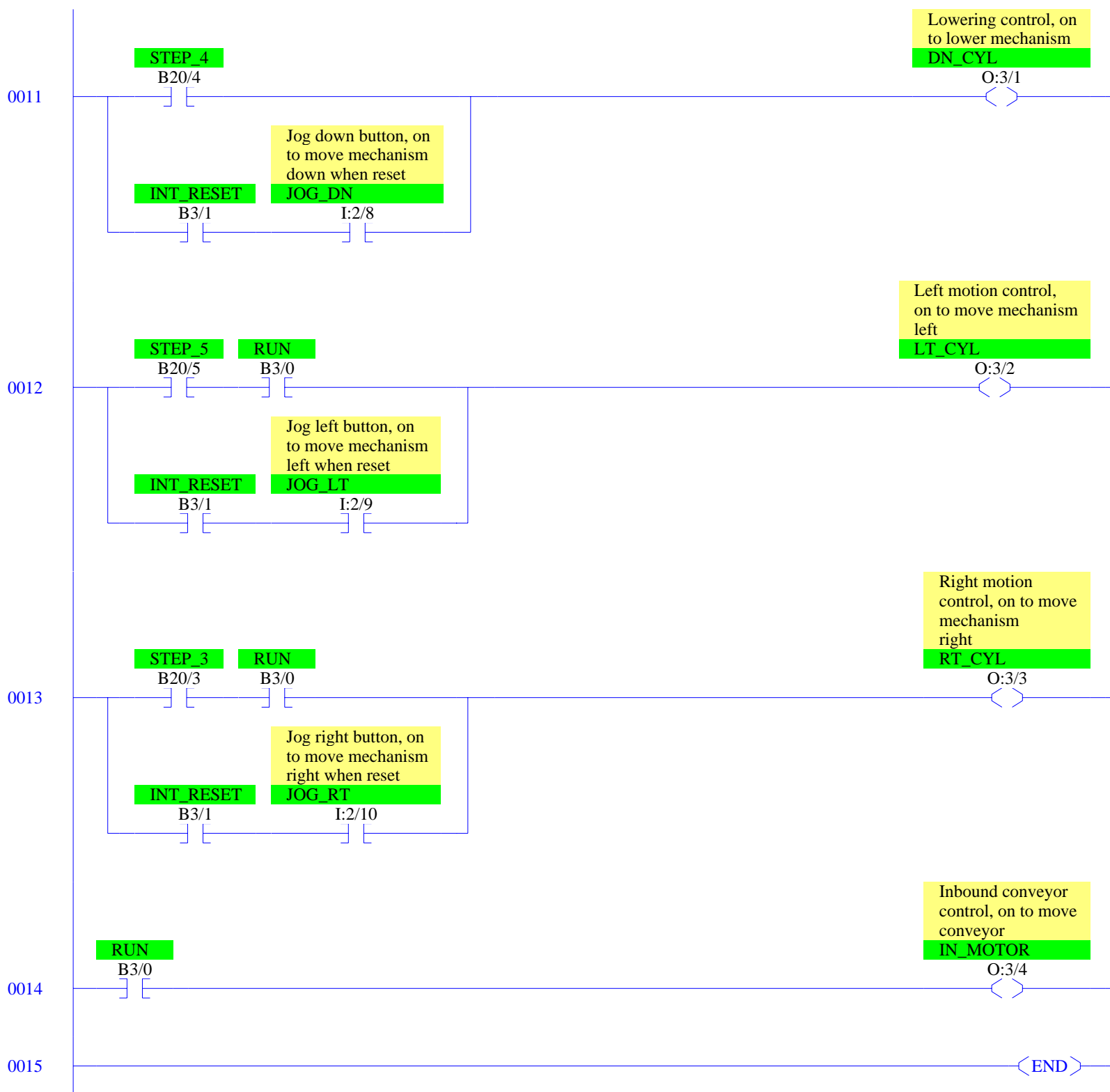
Start/stop and initial start.

During restart prevent start.









RSLogix 500 Cross Reference Report - Sorted by Address

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O:3/0      - {UP_CYL} Raising control, on to raise mechanism
             OTE - File #2 - 10
O:3/1      - {DN_CYL} Lowering control, on to lower mechanism
             OTE - File #2 - 11
O:3/2      - {LT_CYL} Left motion control, on to move mechanism left
             OTE - File #2 - 12
O:3/3      - {RT_CYL} Right motion control, on to move mechanism right
             OTE - File #2 - 13
O:3/4      - {IN_MOTOR} Inbound conveyor control, on to move conveyor
             OTE - File #2 - 14
I:2/0      - {START_PB} Start push button, on when starting
             XIC - File #2 - 0
I:2/1      - {STOP_PB} Stop push button, off when stopping
             XIC - File #2 - 0
I:2/2      - {RESET_PB} Reset push button, on when restoring station to initial state
             XIC - File #2 - 9
I:2/3      - {PE1} Photoelectric sensor, off (open) as item passes
             XIO - File #2 - 2
I:2/4      - {LSDN} Limit switch, on (closed) when transfer mechanism is in the lower position
             XIC - File #2 - 7
I:2/5      - {LSRT} Limit switch, on (closed) when transfer mechanism is in the rightmost position
             XIC - File #2 - 6
I:2/6      - {LSLT} Limit switch, on (closed) when transfer mechanism is in the leftmost position
             XIC - File #2 - 8
I:2/7      - {JOG_UP} Jog up button, on to move mechanism up when reset
             XIC - File #2 - 10
I:2/8      - {JOG_DN} Jog down button, on to move mechanism down when reset
             XIC - File #2 - 11
I:2/9      - {JOG_LT} Jog left button, on to move mechanism left when reset
             XIC - File #2 - 12
I:2/10     - {JOG_RT} Jog right button, on to move mechanism right when reset
             XIC - File #2 - 13
B3/0       - {RUN}
             OTE - File #2 - 0
             XIC - File #2 - 0, 1, 4, 10, 12, 13, 14
             XIO - File #2 - 9
B3/1       - {INT_RESET}
             OTE - File #2 - 9
             XIC - File #2 - 10, 11, 12, 13
             XIO - File #2 - 0
T4:1       - {RAISE_TMR} Time raising transfer mechanism, 5 sec
             RTO - File #2 - 4
             RES - File #2 - 5
T4:1/DN    - XIC - File #2 - 4
C5:1       - {PARTS_CTR} Counts 4 parts
             CTU - File #2 - 2
             RES - File #2 - 3
C5:1/DN    - XIC - File #2 - 2
B20/1      - {STEP_1}
             OTL - File #2 - 1, 8
             OTU - File #2 - 2, 9
             XIC - File #2 - 2
             XIO - File #2 - 1, 3
B20/2      - {STEP_2}
             OTL - File #2 - 2
             OTU - File #2 - 4, 9
             XIC - File #2 - 4, 10
             XIO - File #2 - 1, 5
B20/3      - {STEP_3}
             OTL - File #2 - 4
             OTU - File #2 - 6, 9
             XIC - File #2 - 6, 13
             XIO - File #2 - 1
B20/4      - {STEP_4}
             OTL - File #2 - 6
             OTU - File #2 - 7, 9

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RSLogix 500 Cross Reference Report - Sorted by Address

B20/5 XIC - File #2 - 7, 11
 XIO - File #2 - 1
- {STEP_5}
 OTL - File #2 - 7
 OTU - File #2 - 8, 9
 XIC - File #2 - 8, 12
 XIO - File #2 - 1