

Pressing Station Control

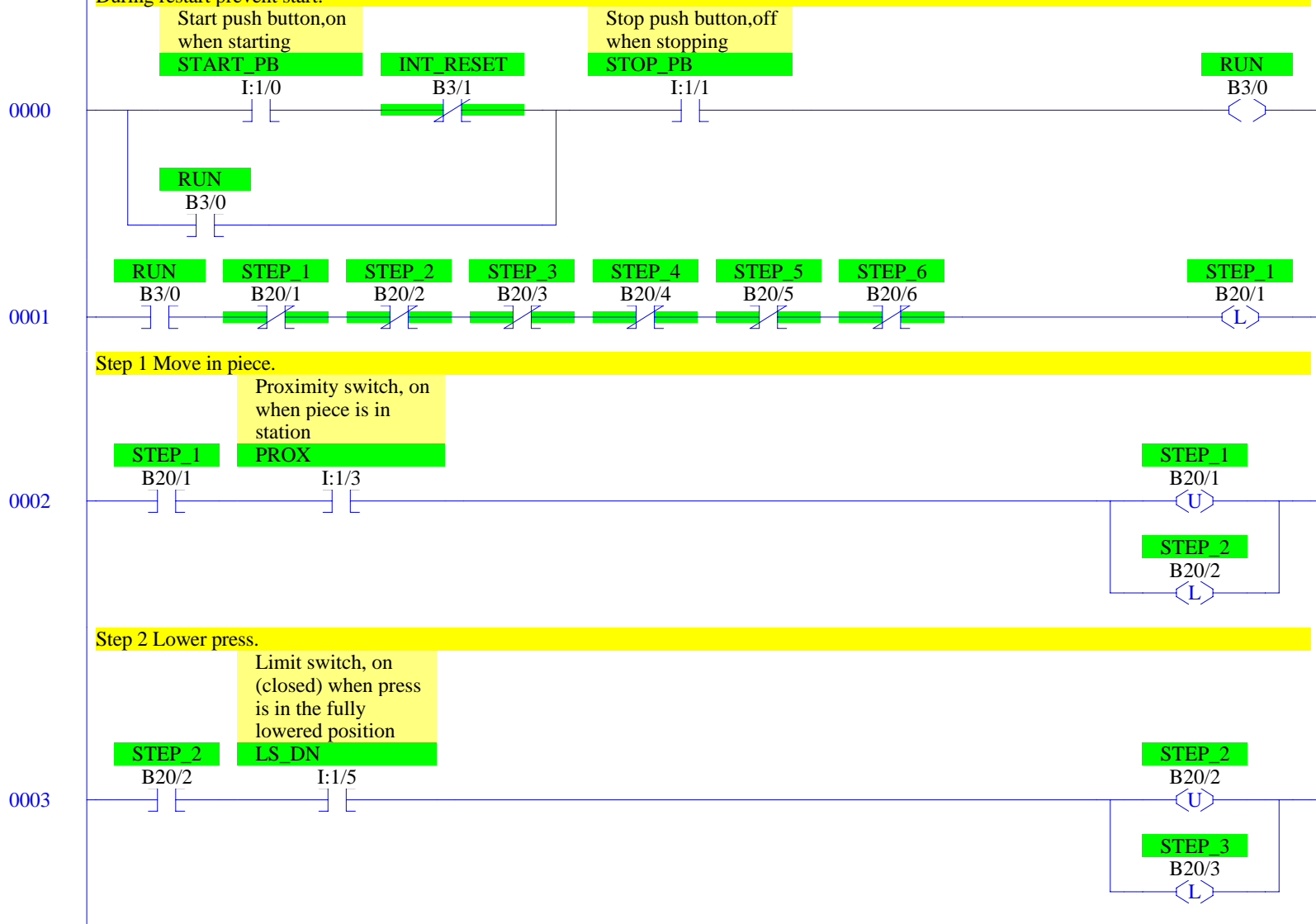
Copyright (c) 2013 Dogwood Valley Press, LLC

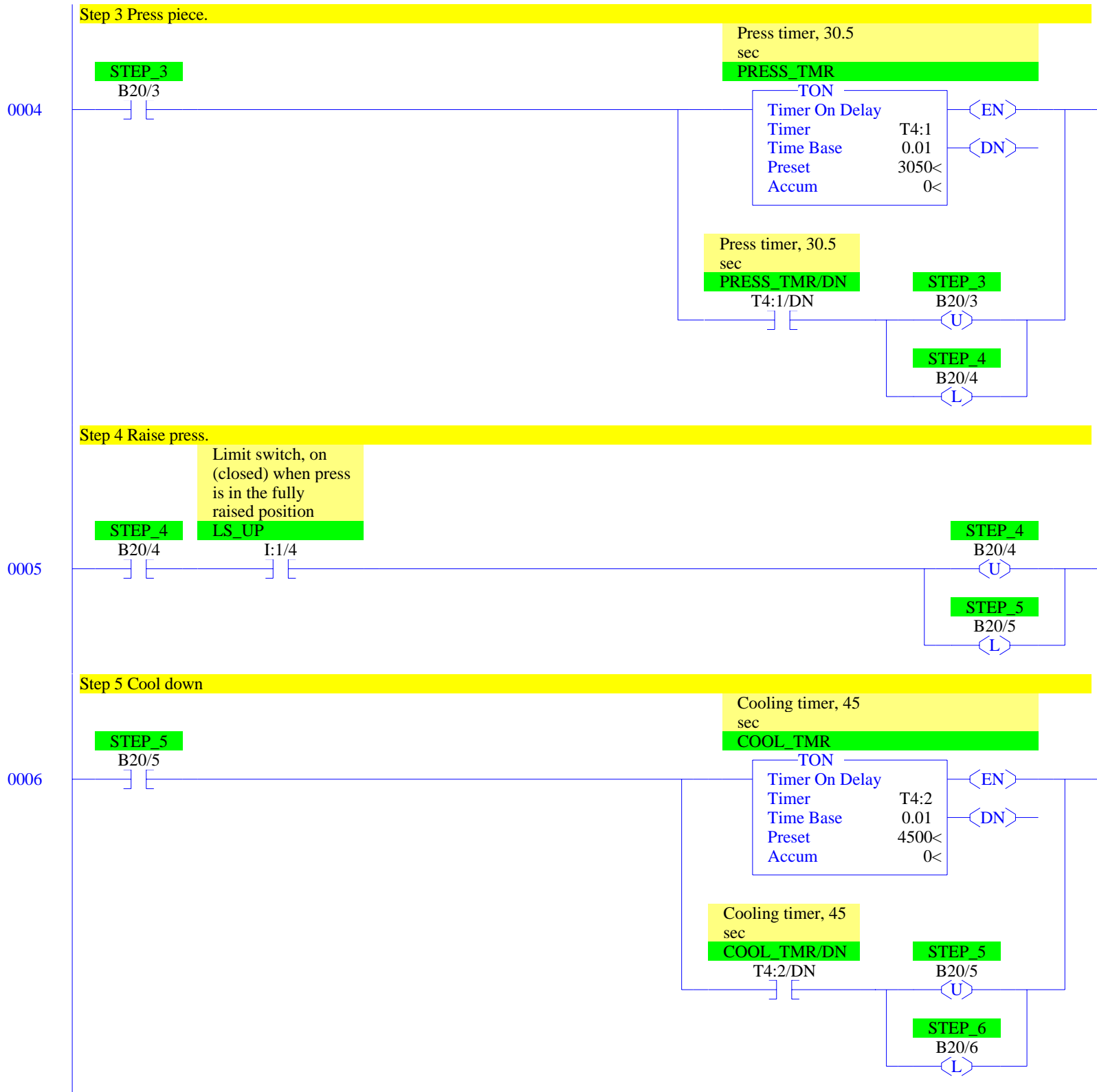
Additional internal memory:

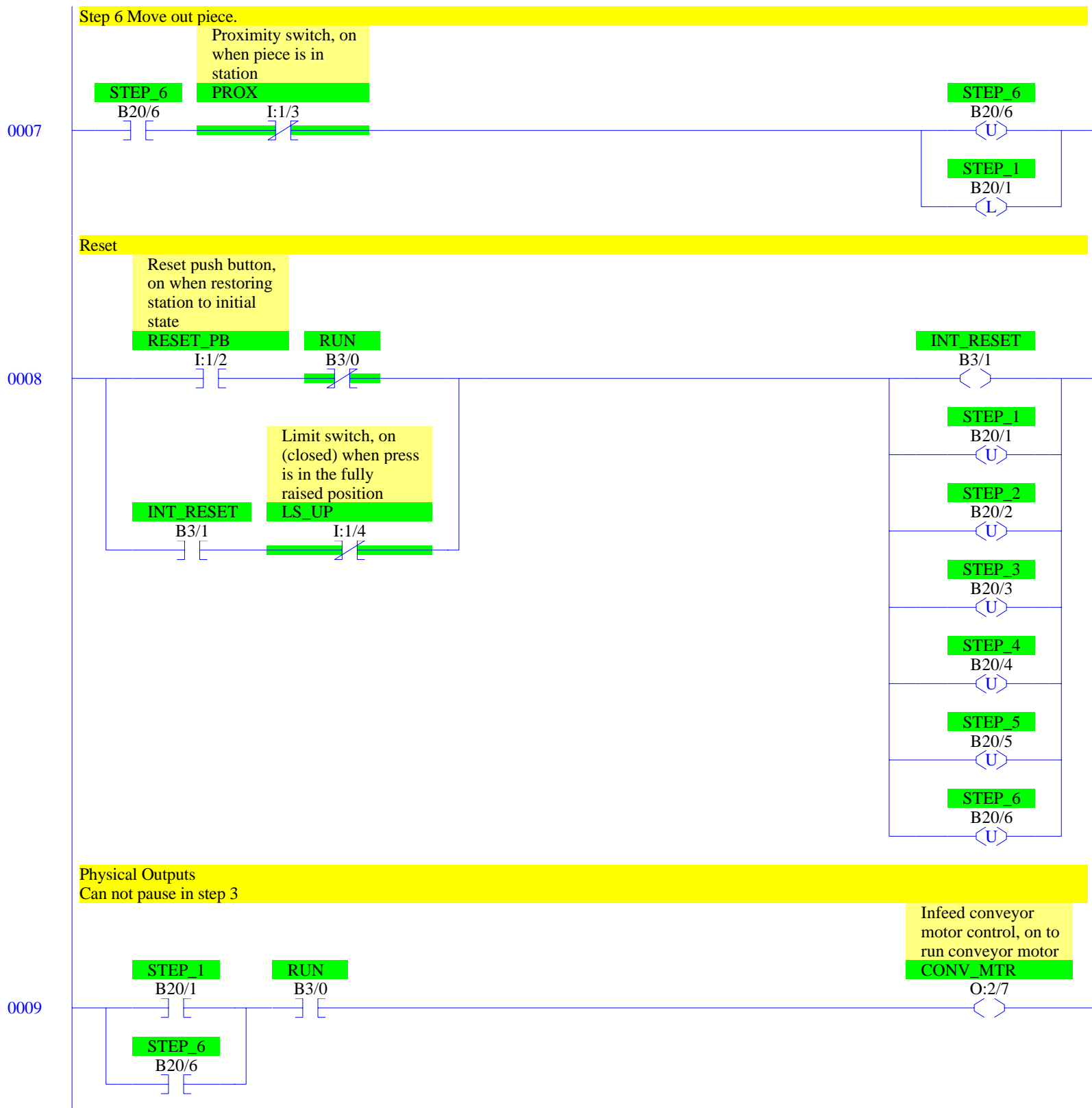
Symbol	Address	
RUN	B3/0	On while station running
INT_RESET	B3/1	Internal reset
STEP_1 to STEP_6	B20/1 to B20/6	Step-in-progress bits
PRESS_TMR	T4:1	Times press step
COOL_TMR	T4:2	Times cool-down of part

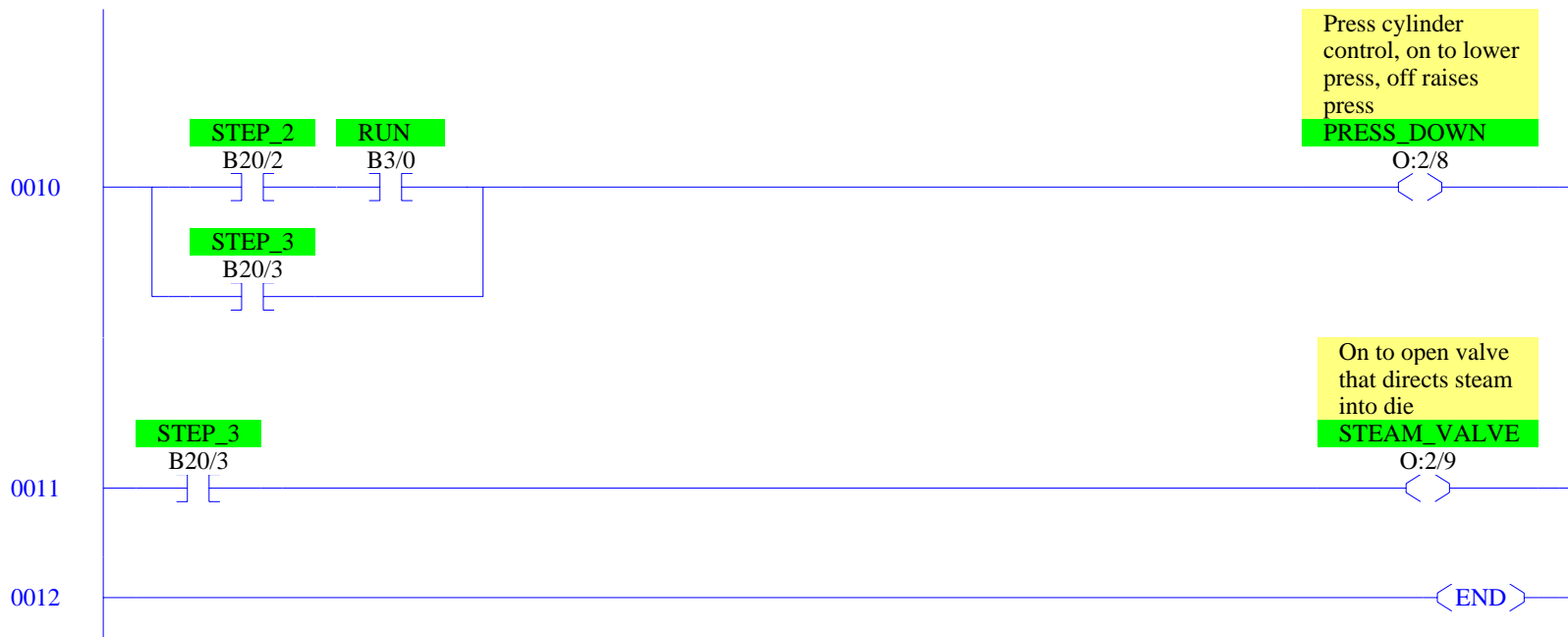
Start/stop and initial start.

During restart prevent start.









RSLogix 500 Cross Reference Report - Sorted by Address

O:2/7	- {CONV_MTR} Infeed conveyor motor control, on to run conveyor motor OTE - File #2 - 9
O:2/8	- {PRESS_DOWN} Press cylinder control, on to lower press, off raises press OTE - File #2 - 10
O:2/9	- {STEAM_VALVE} On to open valve that directs steam into die OTE - File #2 - 11
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:1/3	- {PROX} Proximity switch, on when piece is in station XIC - File #2 - 2 XIO - File #2 - 7
I:1/4	- {LS_UP} Limit switch, on (closed) when press is in the fully raised position XIC - File #2 - 5 XIO - File #2 - 8
I:1/5	- {LS_DN} Limit switch, on (closed) when press is in the fully lowered position XIC - File #2 - 3
B3/0	- {RUN} OTE - File #2 - 0 XIC - File #2 - 0, 1, 9, 10 XIO - File #2 - 8
B3/1	- {INT_RESET} OTE - File #2 - 8 XIC - File #2 - 8 XIO - File #2 - 0
T4:1	- {PRESS_TMR} Press timer, 30.5 sec TON - File #2 - 4
T4:1/DN	- XIC - File #2 - 4
T4:2	- {COOL_TMR} Cooling timer, 45 sec TON - File #2 - 6
T4:2/DN	- XIC - File #2 - 6
B20/1	- {STEP_1} OTL - File #2 - 1, 7 OTU - File #2 - 2, 8 XIC - File #2 - 2, 9 XIO - File #2 - 1
B20/2	- {STEP_2} OTL - File #2 - 2 OTU - File #2 - 3, 8 XIC - File #2 - 3, 10 XIO - File #2 - 1
B20/3	- {STEP_3} OTL - File #2 - 3 OTU - File #2 - 4, 8 XIC - File #2 - 4, 10, 11 XIO - File #2 - 1
B20/4	- {STEP_4} OTL - File #2 - 4 OTU - File #2 - 5, 8 XIC - File #2 - 5 XIO - File #2 - 1
B20/5	- {STEP_5} OTL - File #2 - 5 OTU - File #2 - 6, 8 XIC - File #2 - 6 XIO - File #2 - 1
B20/6	- {STEP_6} OTL - File #2 - 6 OTU - File #2 - 7, 8 XIC - File #2 - 7, 9 XIO - File #2 - 1