

## Main

---

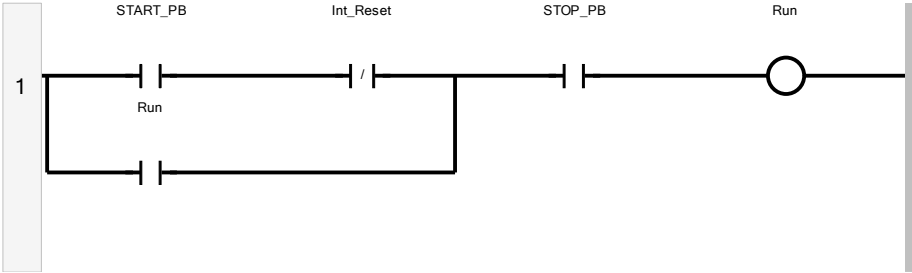
Table of Contents

Main ..... 3

Main

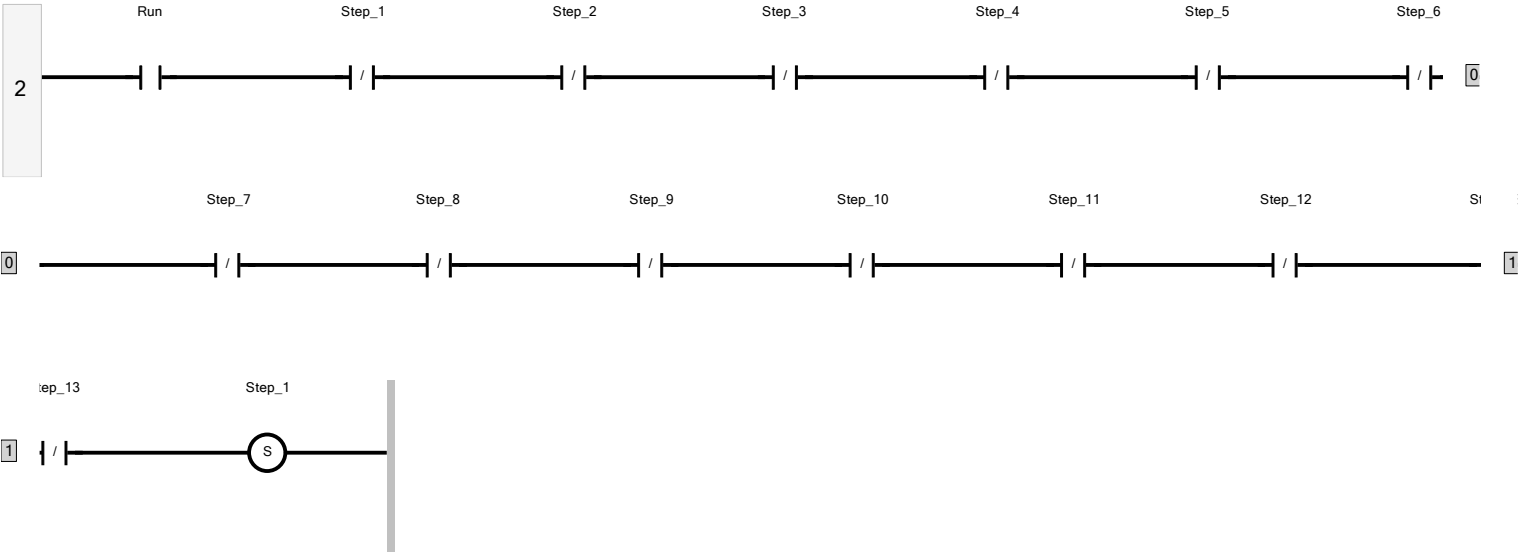
Rung1 Diagram

Example 6.4 Engine Inverter Station control  
Start/stop/pause. Start prevented if reset in progress.  
Copyright (c) 2023, Dogwood Valley Press, LLC



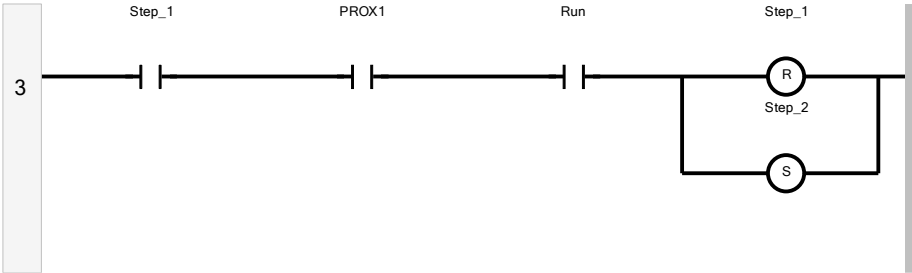
Rung2 Diagram

Transition out of initial step



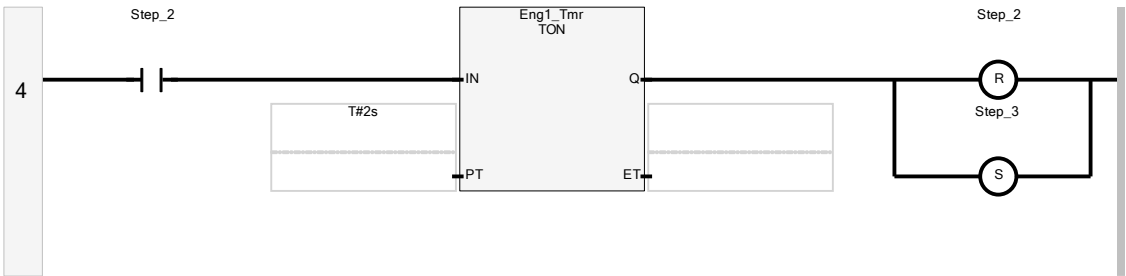
Rung3 Diagram

Step 1 - Wait for pallet. Trans. to step 2 when pallet present



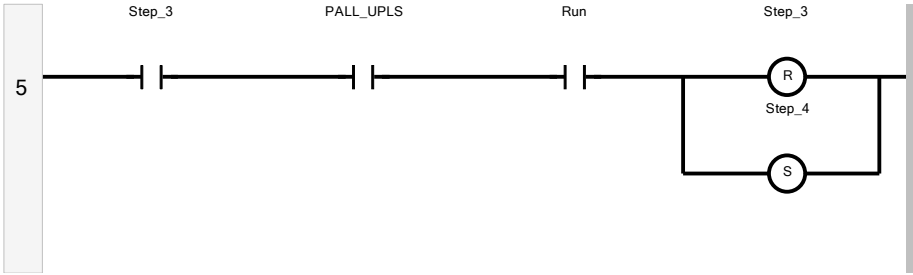
Rung4 Diagram

Step 2 - Move to hook 2. Trans. to step 3 when engaging 1 hook open 2 sec



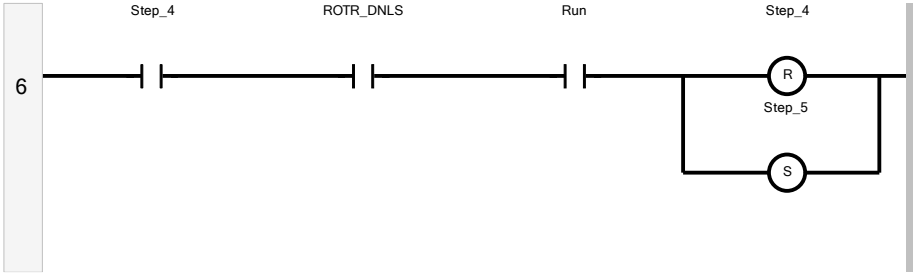
Rung5 Diagram

Step\_3 - Raise pallet. Trans. to step 4 when up



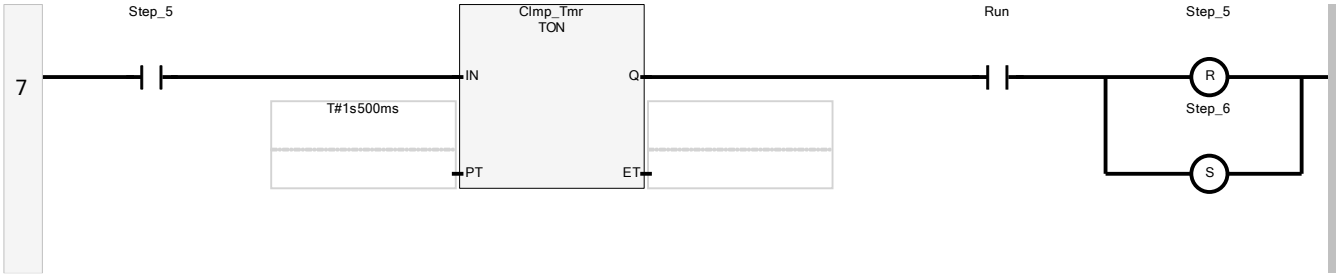
Rung6 Diagram

Step 4 - Lower rotator. Trans. to step 5 when up



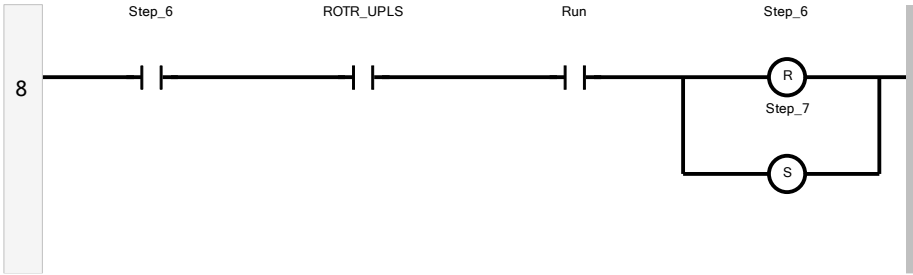
Rung7 Diagram

Step 5 - Clamp engine. Trans. to Step 6 when timer done and not paused



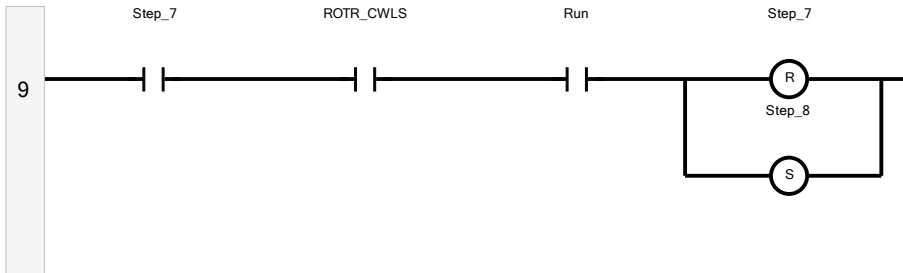
Rung8 Diagram

Step 6 - Raise rotator. Trans. to Step 7 when up.



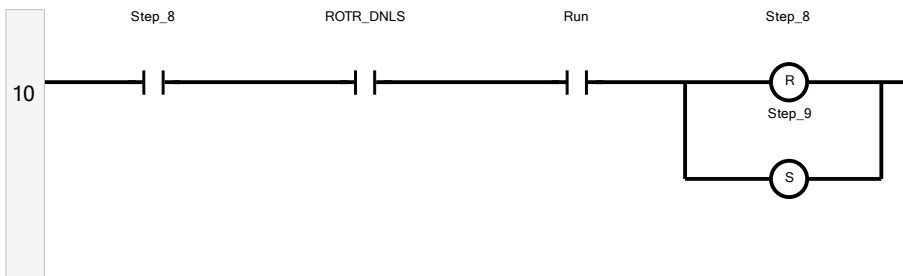
## Rung9 Diagram

Step 7 - Rotate clockwise. Trans. to Step 8 when clockwise.



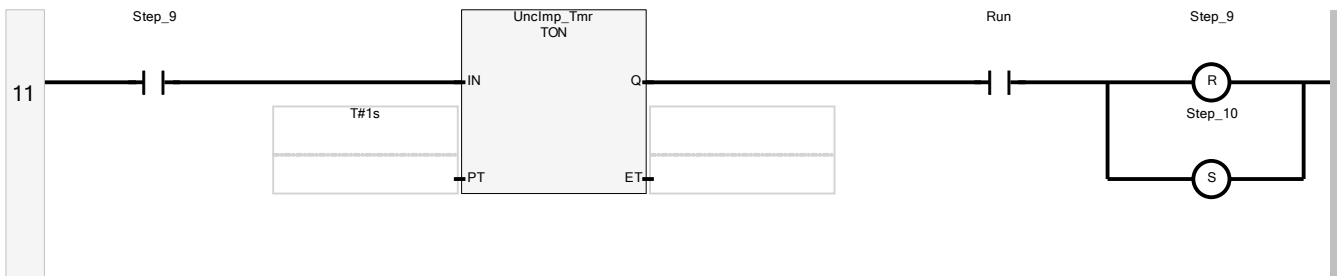
## Rung10 Diagram

Step 8 - Lower rotator. Trans. to Step 9 when down.



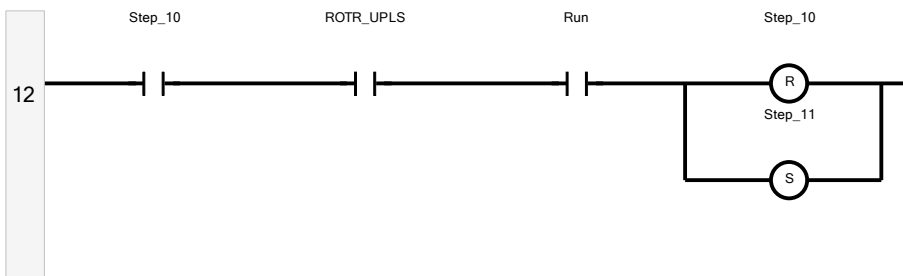
## Rung11 Diagram

Step 9 - Unclamp timer. Trans. to Step 10 after 1 sec.



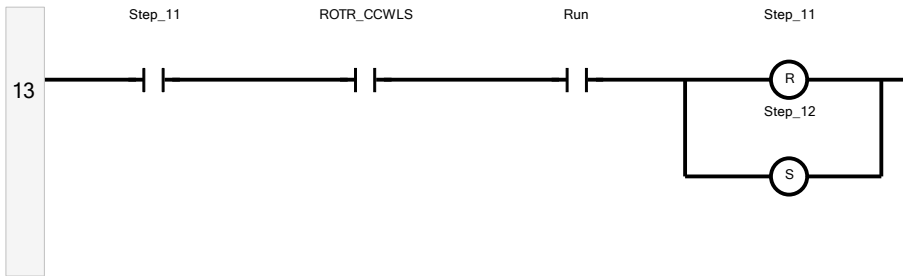
## Rung12 Diagram

Step 10 - Raise rotator. Trans. to Step 11 when up.



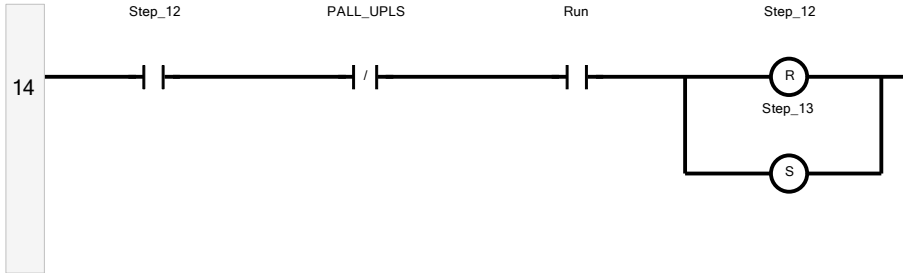
## Rung13 Diagram

Step 11 - Rotate CCW. Trans. to Step 12 when CCW.



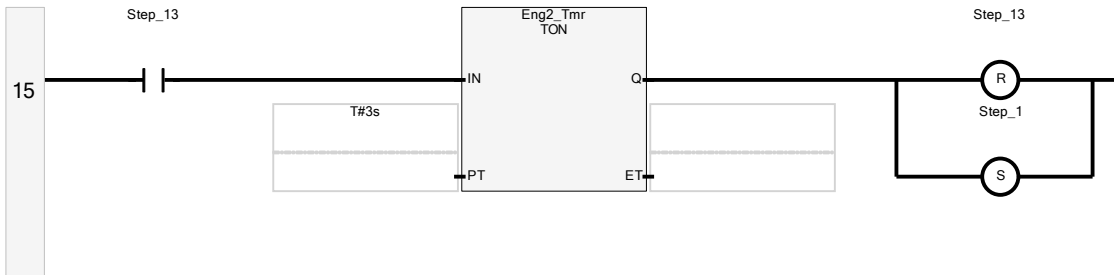
**Rung14 Diagram**

Step 12 - Drop engine. Trans. to Step 13 when not up.



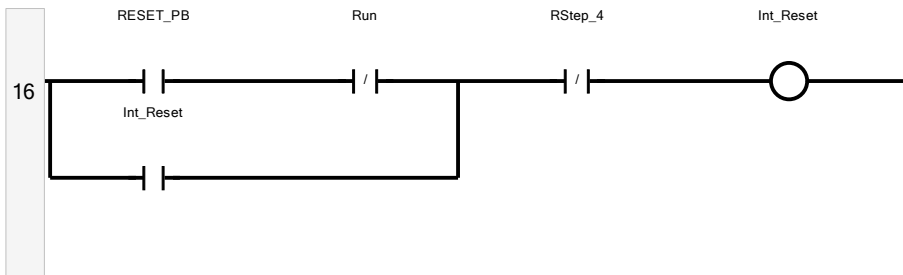
**Rung15 Diagram**

Step 13 - Move out pallet. Trans. to Step 1 when time done.



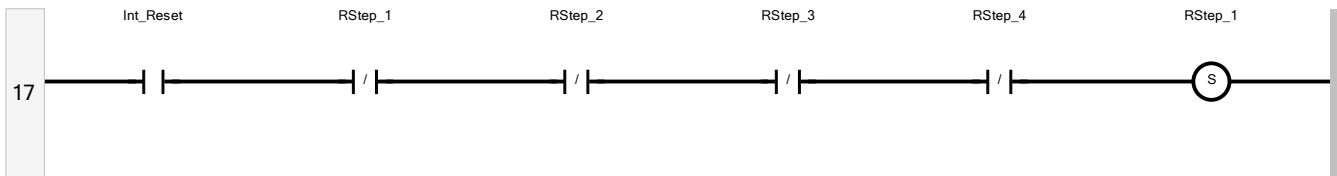
**Rung16 Diagram**

Start/stop for reset operation. Reset pb starts it, reset step 4 stops it.



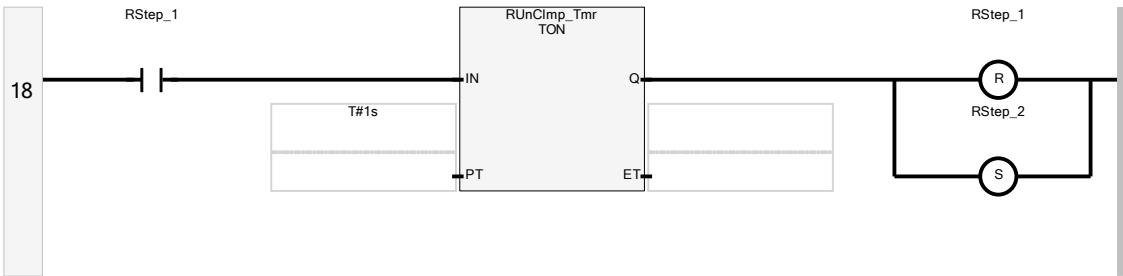
**Rung17 Diagram**

First press of reset pb starts reset



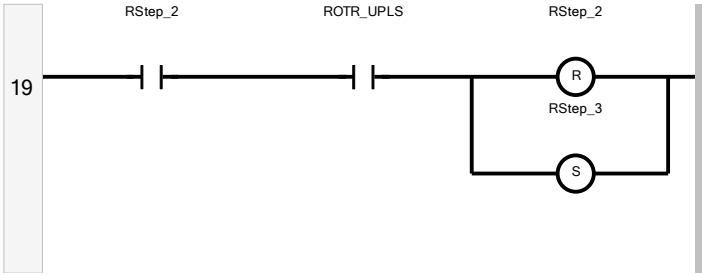
**Rung18 Diagram**

Reset Step 1 - Delay to unclamp. Trans. to Reset Step 2 when done.



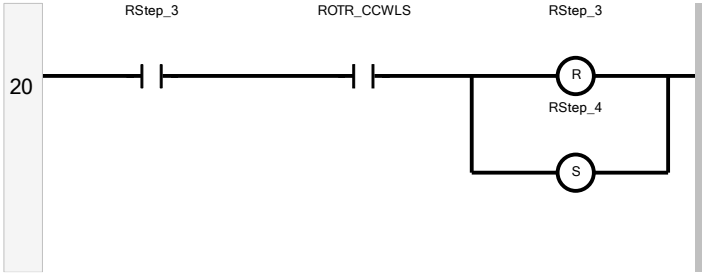
Rung19 Diagram

Reset Step 2 - Raise mechanism. Trans. to Reset Step 3 when up.



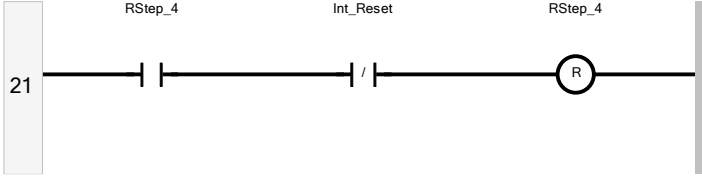
Rung20 Diagram

Reset Step 3 - Rotate CCW. Trans. to Reset Step 3 when CCW.



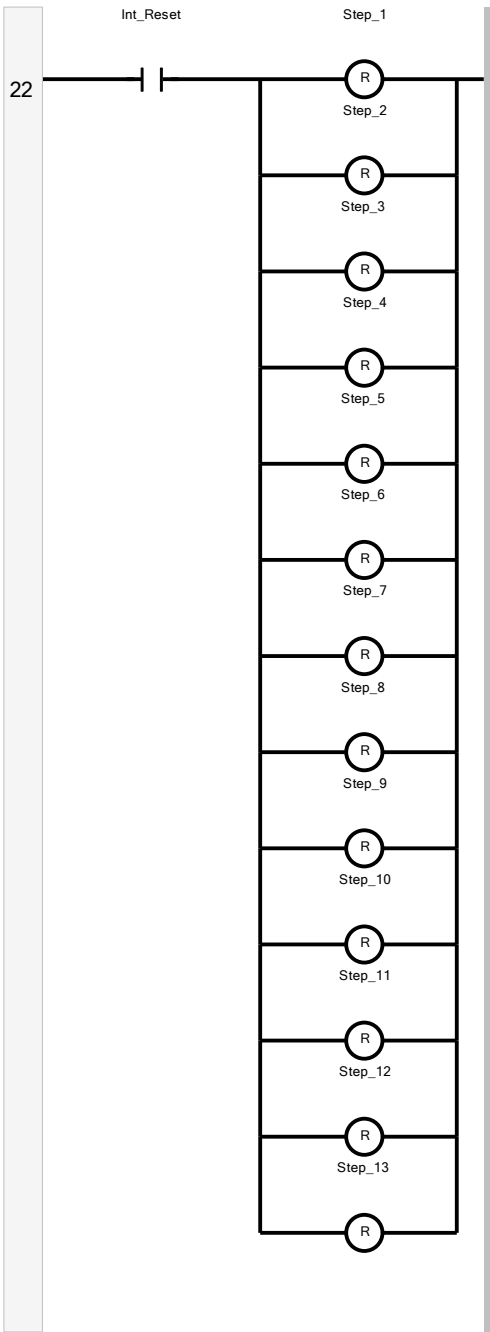
Rung21 Diagram

Transition out of Reset Step 4 when internal reset unlatched.

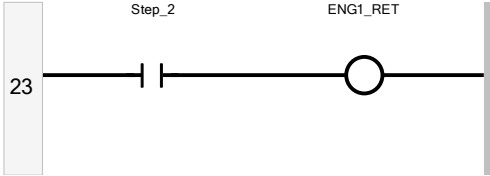


Rung22 Diagram

Reset steps

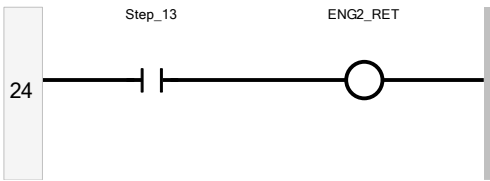


**Rung23 Diagram**  
**Engaging hooks control**



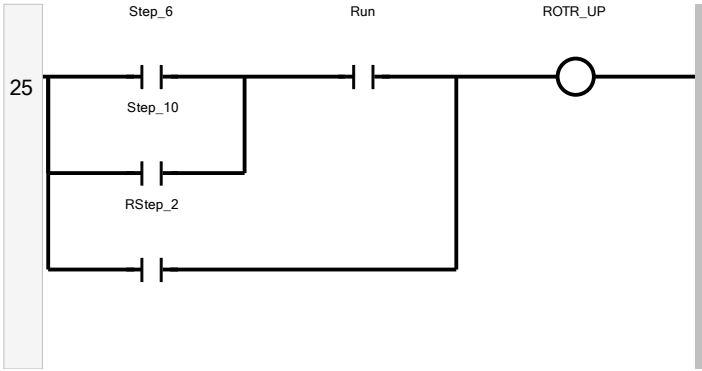
**Rung24 Diagram**



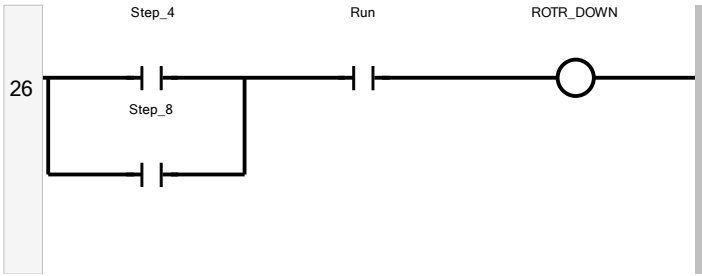


Rung25 Diagram

Rotating mechanism up/dpwn control

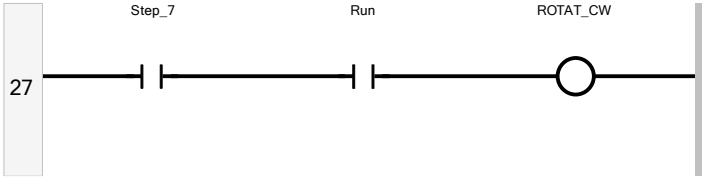


Rung26 Diagram

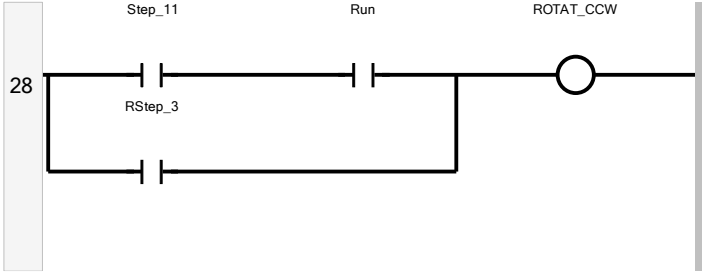


Rung27 Diagram

Rotation control

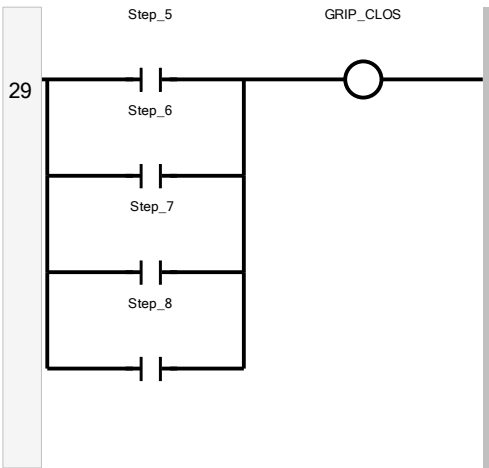


Rung28 Diagram



Rung29 Diagram

Gripper control



Rung30 Diagram

Pallet up control

