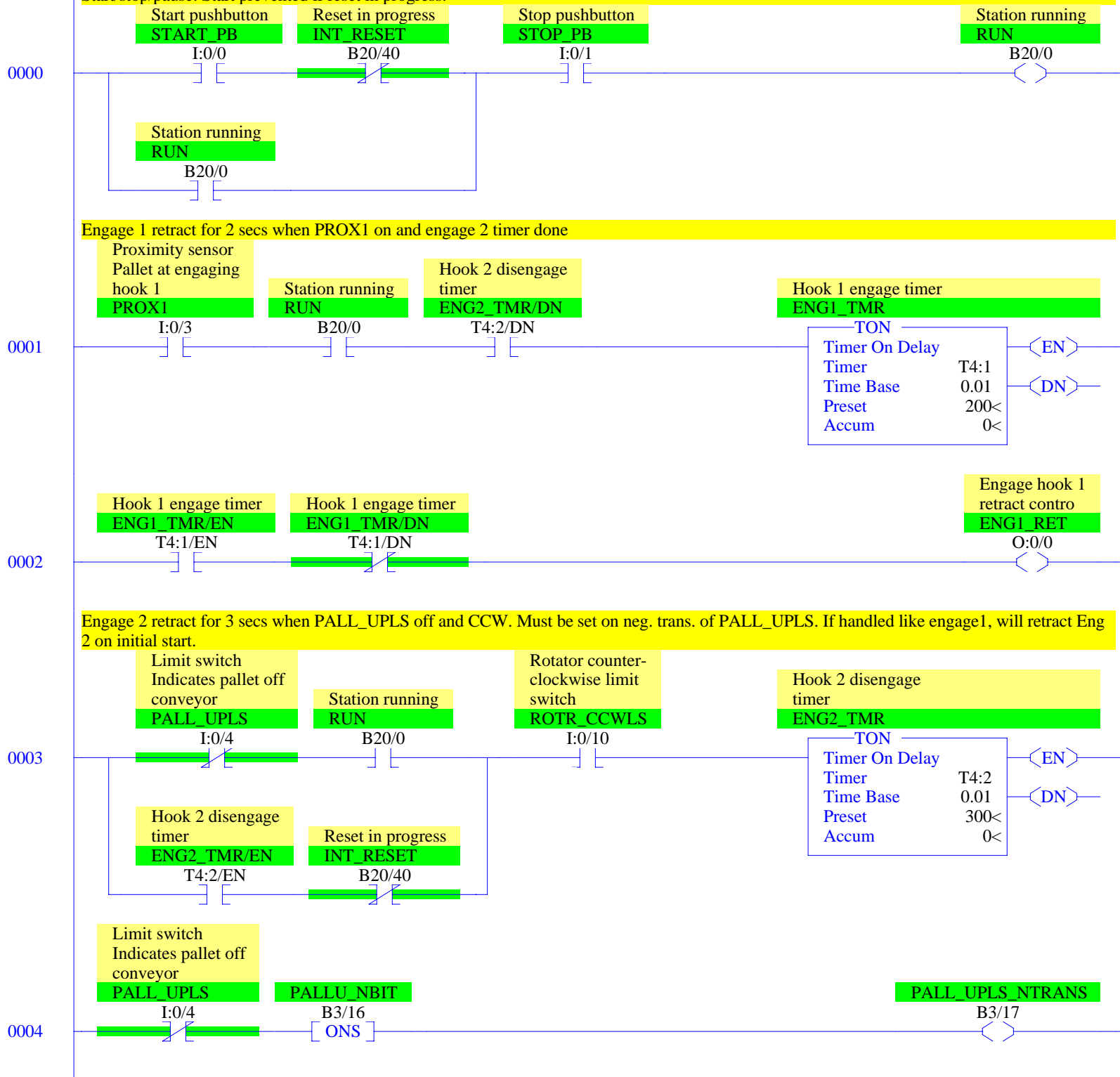
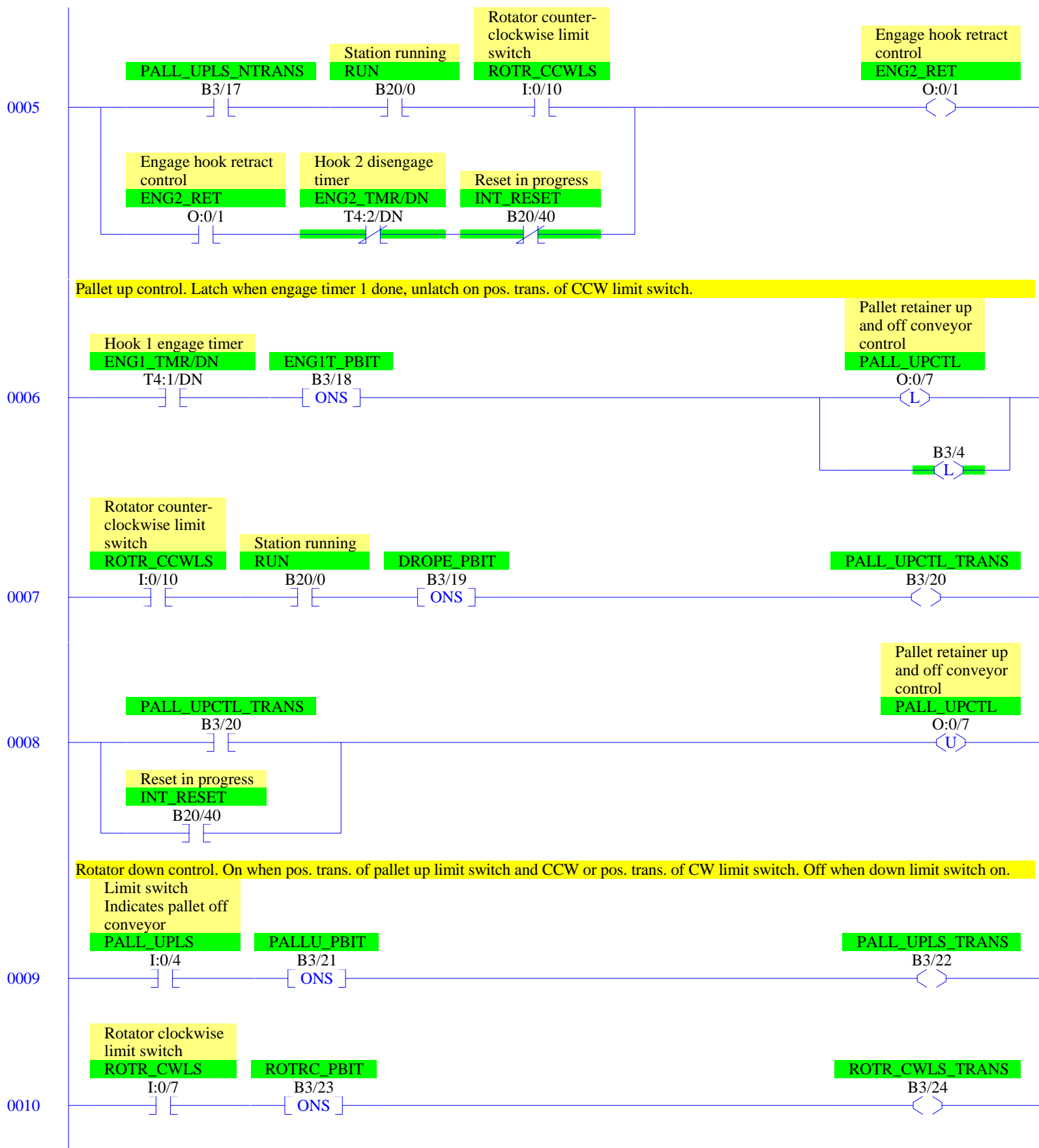


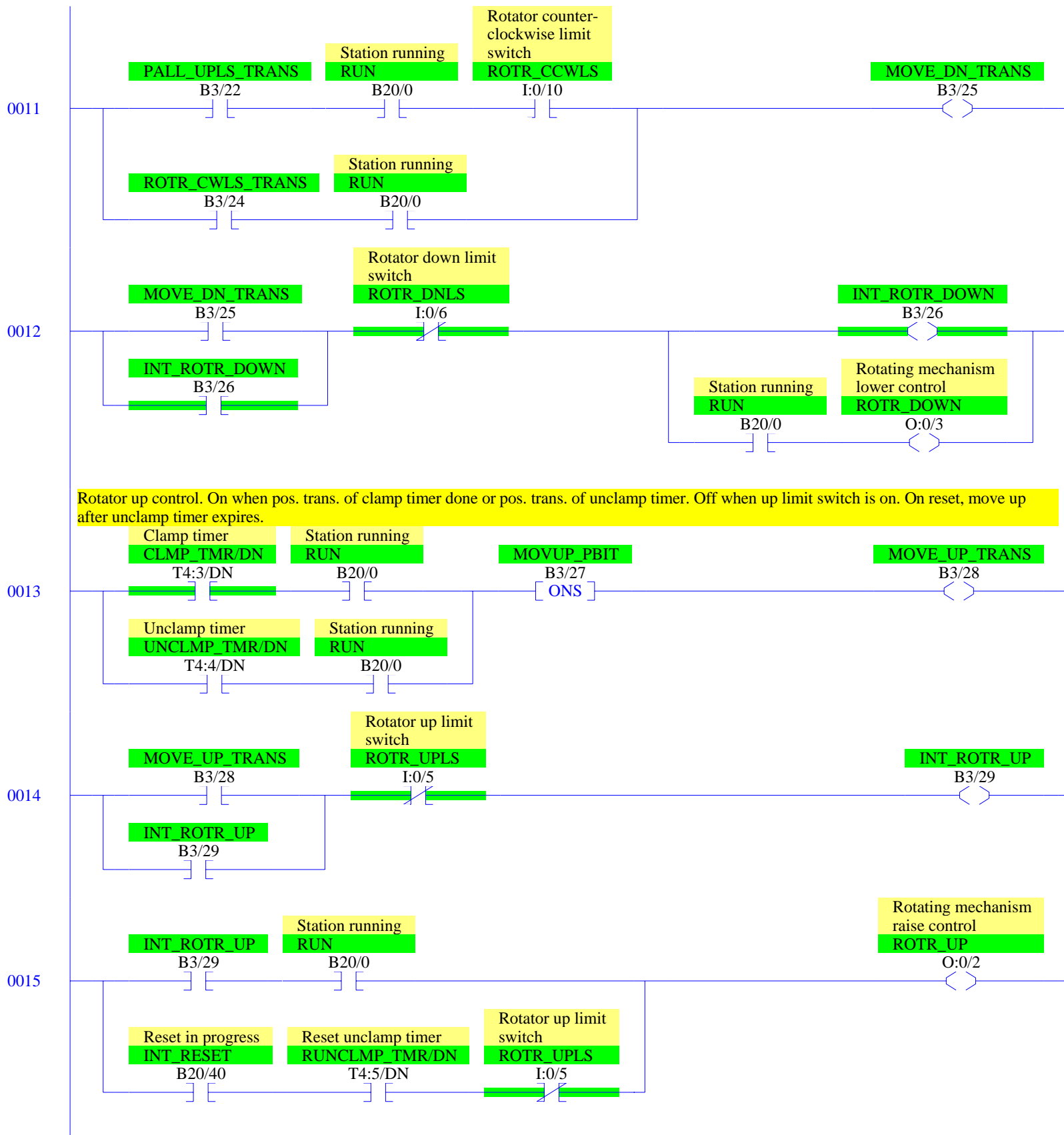
Example 6.7 - Engine Inverter Control - Unstructured Sequence with Simulation

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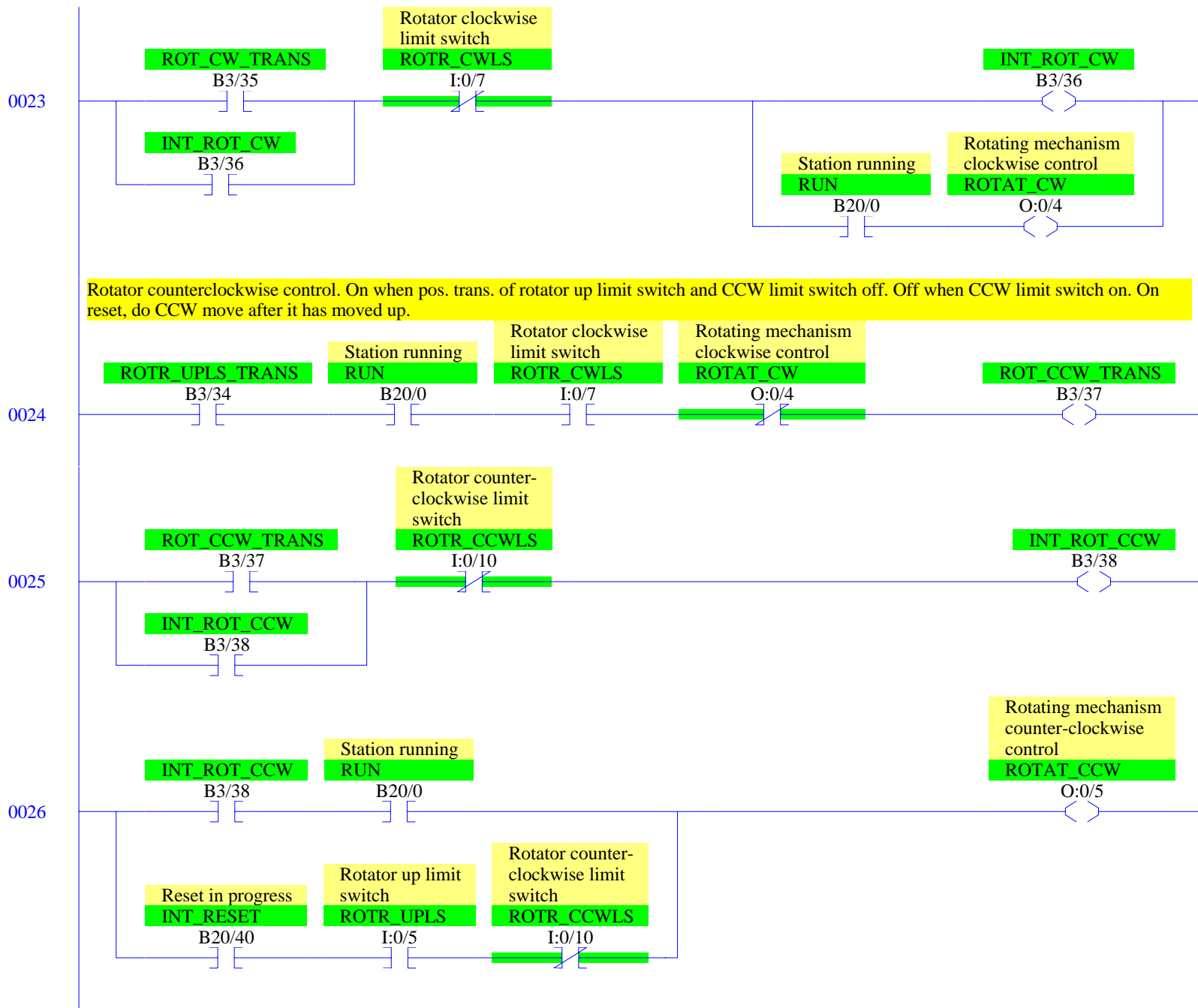
Start/stop/pause. Start prevented if reset in progress.

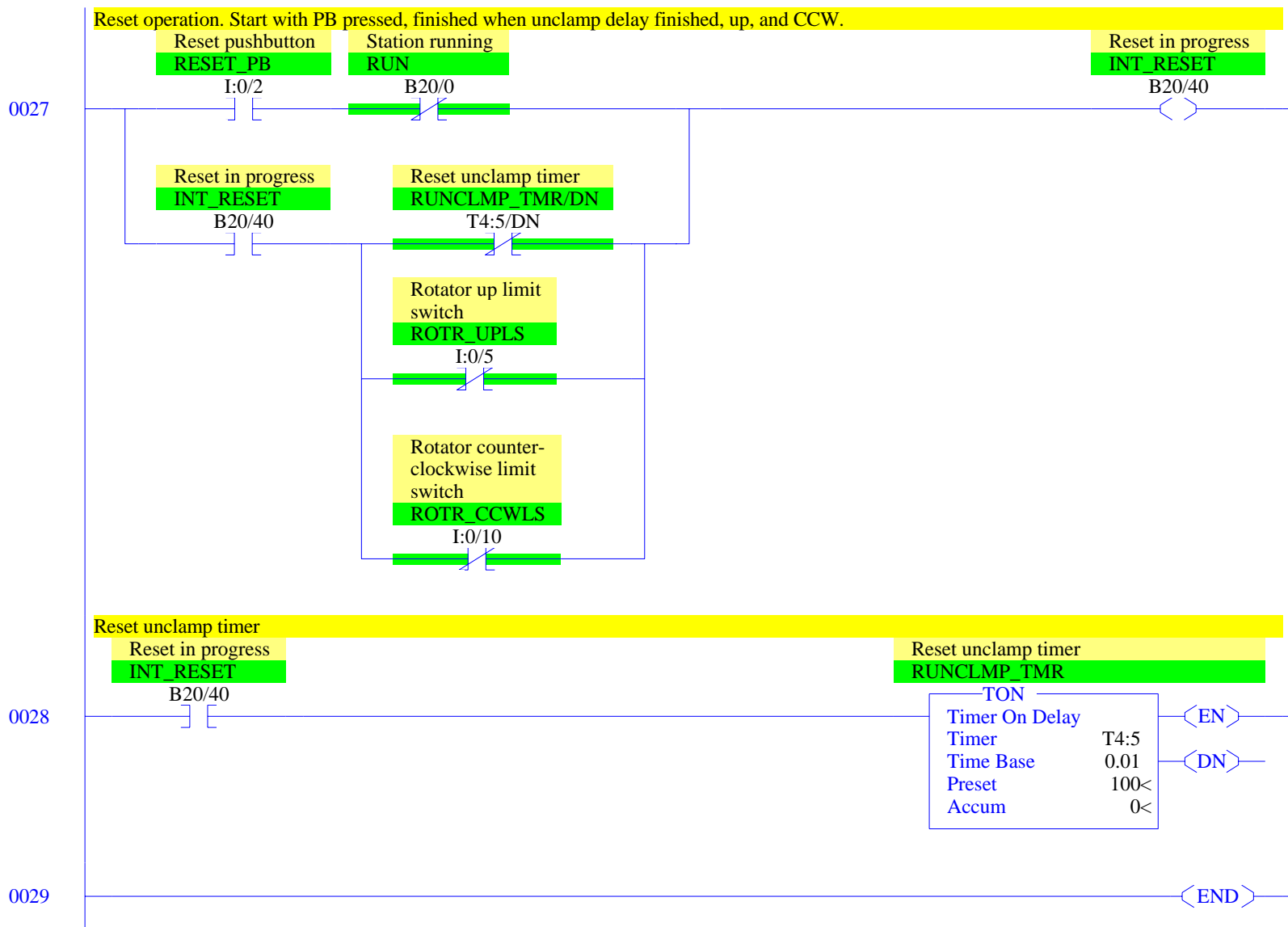












RSLogix 500 Cross Reference Report - Sorted by Address

O:0/0	- {ENG1_RET} Engage hook 1 retract contro
	OTE - File #2 - 2
O:0/1	- {ENG2_RET} Engage hook retract control
	XIC - File #2 - 5
	OTE - File #2 - 5
O:0/2	- {ROTR_UP} Rotating mechanism raise control
	OTE - File #2 - 15
O:0/3	- {ROTR_DOWN} Rotating mechanism lower control
	OTE - File #2 - 12
O:0/4	- {ROTAT_CW} Rotating mechanism clockwise control
	XIO - File #2 - 24
	OTE - File #2 - 23
O:0/5	- {ROTAT_CCW} Rotating mechanism counter-clockwise control
	OTE - File #2 - 26
	XIO - File #2 - 22
O:0/6	- {GRIP_CLOS} Gripper close control
	OTU - File #2 - 18
	XIC - File #2 - 19
	XIO - File #2 - 20
	OTL - File #2 - 16
O:0/7	- {PALL_UPCTL} Pallet retainer up and off conveyor control
	OTU - File #2 - 8
	OTL - File #2 - 6
I:0/0	- {START_PB} Start pushbutton
	XIC - File #2 - 0
I:0/1	- {STOP_PB} Stop pushbutton
	XIC - File #2 - 0
I:0/2	- {RESET_PB} Reset pushbutton
	XIC - File #2 - 27
I:0/3	- {PROX1} Proximity sensor Pallet at engaging hook 1
	XIC - File #2 - 1
I:0/4	- {PALL_UPLS} Limit switch Indicates pallet off conveyor
	XIO - File #2 - 3, 4
	XIC - File #2 - 9
I:0/5	- {ROTR_UPLS} Rotator up limit switch
	XIC - File #2 - 26
	XIO - File #2 - 27, 14, 15
	XIC - File #2 - 21
I:0/6	- {ROTR_DNLS} Rotator down limit switch
	XIO - File #2 - 12
	XIC - File #2 - 16, 17
I:0/7	- {ROTR_CWLS} Rotator clockwise limit switch
	XIC - File #2 - 24
	XIO - File #2 - 23
	XIC - File #2 - 10, 17
I:0/10	- {ROTR_CCWLS} Rotator counter- clockwise limit switch
	XIO - File #2 - 25, 26, 27
	XIC - File #2 - 3, 5, 7, 11, 16, 22
B3/4	- OTL - File #2 - 6
B3/16	- {PALLU_NBIT}
	ONS - File #2 - 4
B3/17	- {PALL_UPLS_NTRANS}
	XIC - File #2 - 5
	OTE - File #2 - 4
B3/18	- {ENG1T_PBIT}
	ONS - File #2 - 6
B3/19	- {DROPE_PBIT}
	ONS - File #2 - 7
B3/20	- {PALL_UPCTL_TRANS}
	XIC - File #2 - 8
	OTE - File #2 - 7
B3/21	- {PALLU_PBIT}
	ONS - File #2 - 9
B3/22	- {PALL_UPLS_TRANS}
	XIC - File #2 - 11
	OTE - File #2 - 9

RSLogix 500 Cross Reference Report - Sorted by Address

B3/23	- {ROTRC_PBIT}	
	ONS - File #2 - 10	
B3/24	- {ROTR_CWLS_TRANS}	
	XIC - File #2 - 11	
	OTE - File #2 - 10	
B3/25	- {MOVE_DN_TRANS}	
	OTE - File #2 - 11	
	XIC - File #2 - 12	
B3/26	- {INT_ROT_DOWN}	
	OTE - File #2 - 12	
	XIC - File #2 - 12	
B3/27	- {MOVUP_PBIT}	
	ONS - File #2 - 13	
B3/28	- {MOVE_UP_TRANS}	
	XIC - File #2 - 14	
	OTE - File #2 - 13	
B3/29	- {INT_ROT_UP}	
	OTE - File #2 - 14	
	XIC - File #2 - 14, 15	
B3/30	- {GRIPC_PBIT}	
	ONS - File #2 - 16	
B3/31	- {GRIPO_PBIT}	
	ONS - File #2 - 17	
B3/32	- {OPEN_GRIP_TRANS}	
	XIC - File #2 - 18	
	OTE - File #2 - 17	
B3/33	- {ROTU_PBIT}	
	ONS - File #2 - 21	
B3/34	- {ROTR_UPLS_TRANS}	
	XIC - File #2 - 22, 24	
	OTE - File #2 - 21	
B3/35	- {ROT_CW_TRANS}	
	OTE - File #2 - 22	
	XIC - File #2 - 23	
B3/36	- {INT_ROT_CW}	
	OTE - File #2 - 23	
	XIC - File #2 - 23	
B3/37	- {ROT_CCW_TRANS}	
	OTE - File #2 - 24	
	XIC - File #2 - 25	
B3/38	- {INT_ROT_CCW}	
	OTE - File #2 - 25	
	XIC - File #2 - 25, 26	
T4:1	- {ENG1_TMR} Hook 1 engage timer	
	TON - File #2 - 1	
T4:1/DN	- XIO - File #2 - 2	
	XIC - File #2 - 6	
T4:1/EN	- XIC - File #2 - 2	
T4:2	- {ENG2_TMR} Hook 2 disengage timer	
	TON - File #2 - 3	
T4:2/DN	- XIC - File #2 - 1	
	XIO - File #2 - 5	
T4:2/EN	- XIC - File #2 - 3	
T4:3	- {CLMP_TMR} Clamp timer	
	TON - File #2 - 19	
T4:3/DN	- XIC - File #2 - 13	
T4:4	- {UNCLMP_TMR} Unclamp timer	
	TON - File #2 - 20	
T4:4/DN	- XIC - File #2 - 13	
T4:5	- {RUNCLMP_TMR} Reset unclamp timer	
	TON - File #2 - 28	
T4:5/DN	- XIC - File #2 - 15	
	XIO - File #2 - 27	
B20/0	- {RUN} Station running	
	OTE - File #2 - 0	
	XIC - File #2 - 0, 1, 3, 5, 7, 11, 12, 13, 15, 16, 17, 22, 23, 24	

26
XIO - File #2 - 27
B20/40 - {INT_RESET} Reset in progress
OTE - File #2 - 27
XIC - File #2 - 8, 15, 18, 26, 27, 28
XIO - File #2 - 0, 3, 5