

0021

Reset unlatches all normal operation step-in progress bits

Reset in progress

INT\_RESET

B20/40

Wait for pallet

STEP\_1

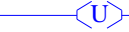
B20/1



Move to hook 2

STEP\_2

B20/2



Raise pallet

STEP\_3

B20/3



Lower rotator

STEP\_4

B20/4



Clamp engine

STEP\_5

B20/5



Raise rotator

STEP\_6

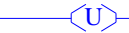
B20/6



Rotate clockwise

STEP\_7

B20/7



Lower rotator

STEP\_8

B20/8



Unclamp timer

STEP\_9

B20/9



Raise rotator

STEP\_10

B20/10



Rotate CCW

STEP\_11

B20/11



Drop engine

STEP\_12

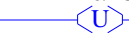
B20/12

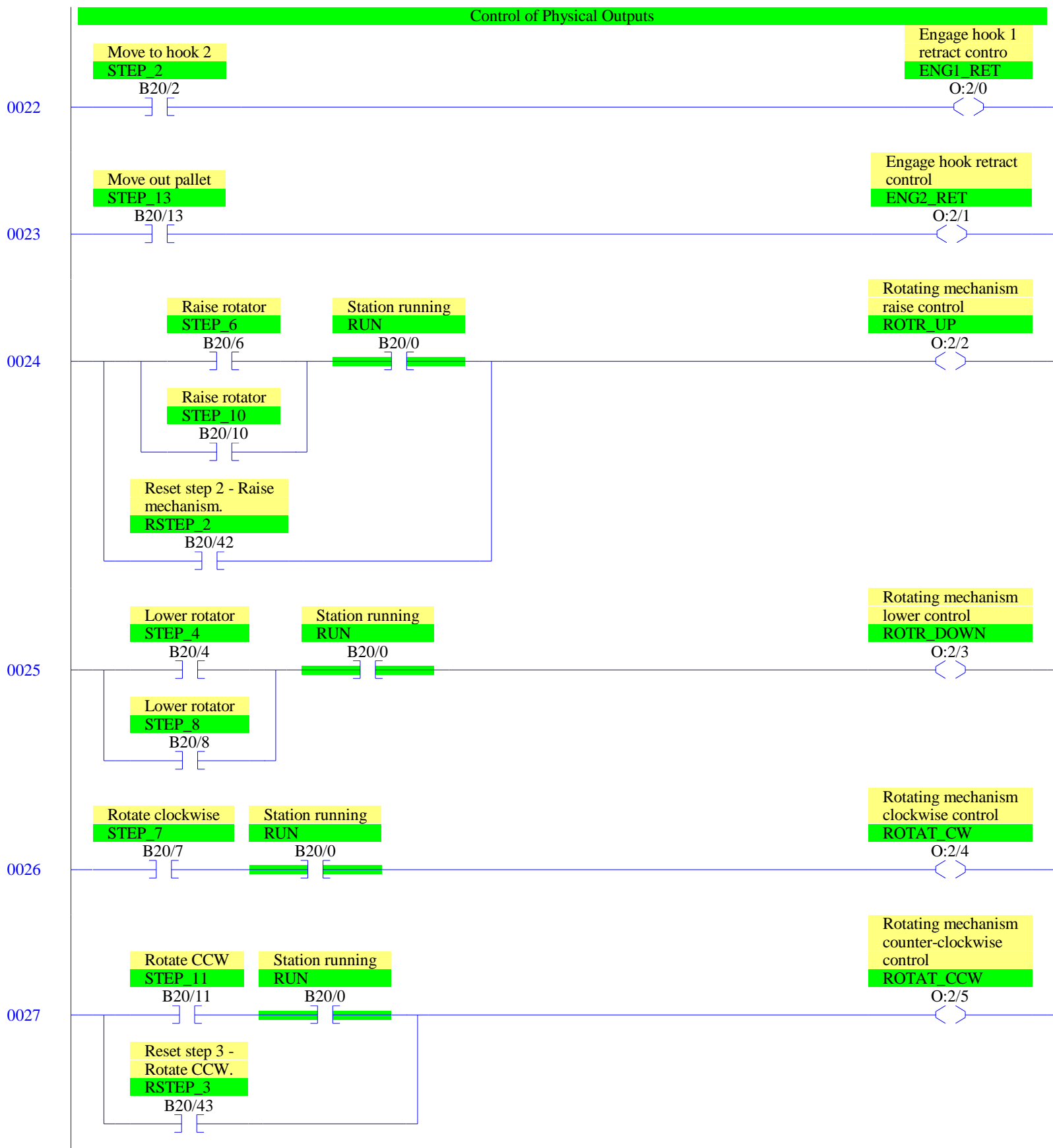


Move out pallet

STEP\_13

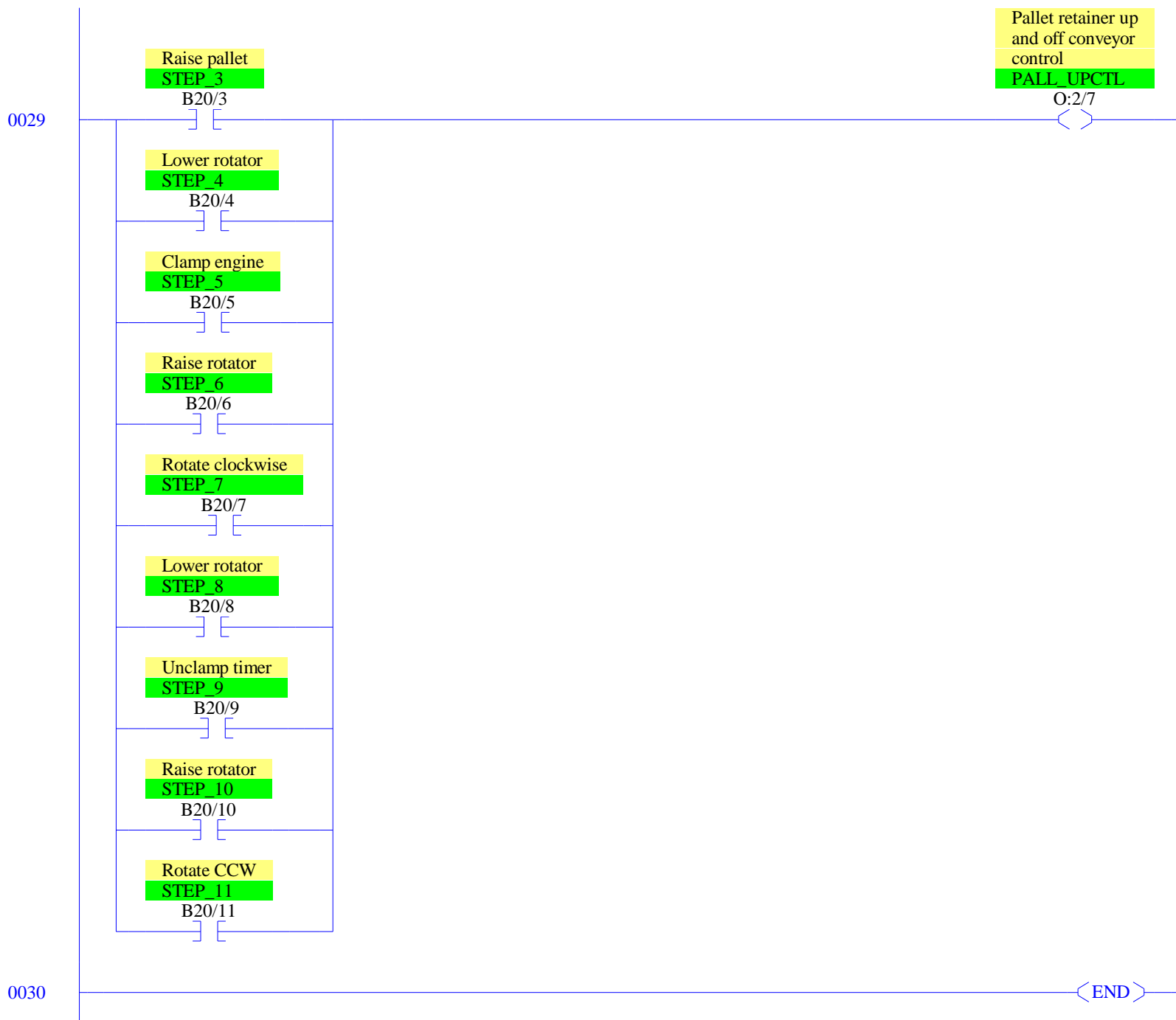
B20/13











## RSLogix 500 Cross Reference Report - Sorted by Address

|         |   |
|---------|---|
| O:2/0   | - {ENG1_RET} Engage hook 1 retract contro<br>OTE - File #2 - 22   |
| O:2/1   | - {ENG2_RET} Engage hook retract control<br>OTE - File #2 - 23  |
| O:2/2   | - {ROTR_UP} Rotating mechanism raise control<br>OTE - File #2 - 24  |
| O:2/3   | - {ROTR_DOWN} Rotating mechanism lower control<br>OTE - File #2 - 25  |
| O:2/4   | - {ROTAT_CW} Rotating mechanism clockwise control<br>OTE - File #2 - 26   |
| O:2/5   | - {ROTAT_CCW} Rotating mechanism counter-clockwise control<br>OTE - File #2 - 27  |
| O:2/6   | - {GRIP_CLOS} Gripper close control<br>OTE - File #2 - 28   |
| O:2/7   | - {PALL_UPCTL} Pallet retainer up and off conveyor control<br>OTE - File #2 - 29  |
| I:1/0   | - {START_PB} Start pushbutton<br>XIC - File #2 - 0  |
| I:1/1   | - {STOP_PB} Stop pushbutton<br>XIC - File #2 - 0  |
| I:1/2   | - {RESET_PB} Reset pushbutton<br>XIC - File #2 - 15   |
| I:1/3   | - {PROX1} Proximity sensor Pallet at engaging hook 1<br>XIC - File #2 - 2   |
| I:1/4   | - {PALL_UPLS} Limit switch Indicates pallet off conveyor<br>XIC - File #2 - 4<br>XIO - File #2 - 13   |
| I:1/5   | - {ROTR_UPLS} Rotator up limit switch<br>XIC - File #2 - 7, 11, 18  |
| I:1/6   | - {ROTR_DNLS} Rotator down limit switch<br>XIC - File #2 - 5, 9   |
| I:1/7   | - {ROTR_CWLS} Rotator clockwise limit switch<br>XIC - File #2 - 8   |
| I:1/10  | - {ROTR_CCWLS} Rotator counter- clockwise limit switch<br>XIC - File #2 - 12, 19  |
| T4:1    | - {ENG1_TMR} Hook 1 engage timer<br>TON - File #2 - 3   |
| T4:1/DN | - XIC - File #2 - 3   |
| T4:2    | - {ENG2_TMR} Hook 2 disengage timer<br>TON - File #2 - 14   |
| T4:2/DN | - XIC - File #2 - 14  |
| T4:3    | - {CLMP_TMR} Clamp timer<br>TON - File #2 - 6   |
| T4:3/DN | - XIC - File #2 - 6   |
| T4:4    | - {UNCLMP_TMR} Unclamp timer<br>TON - File #2 - 10  |
| T4:4/DN | - XIC - File #2 - 10  |
| T4:5    | - {RUNCLMP_TMR} Reset unclamp timer<br>TON - File #2 - 17   |
| T4:5/DN | - XIC - File #2 - 17  |
| B20/0   | - {RUN} Station running<br>OTE - File #2 - 0<br>XIC - File #2 - 0, 1, 2, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 24<br>25, 26, 27<br>XIO - File #2 - 15 |
| B20/1   | - {STEP_1} Wait for pallet<br>OTL - File #2 - 1, 14<br>OTU - File #2 - 2, 21<br>XIC - File #2 - 2<br>XIO - File #2 - 1                            |
| B20/2   | - {STEP_2} Move to hook 2<br>OTL - File #2 - 2<br>OTU - File #2 - 3, 21<br>XIC - File #2 - 3, 22<br>XIO - File #2 - 1                             |
| B20/3   | - {STEP_3} Raise pallet   |

## RSLogix 500 Cross Reference Report - Sorted by Address

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      OTL - File #2 - 3
      OTU - File #2 - 4, 21
      XIC - File #2 - 4, 29
      XIO - File #2 - 1
B20/4 - {STEP_4} Lower rotator
      OTL - File #2 - 4
      OTU - File #2 - 5, 21
      XIC - File #2 - 5, 25, 29
      XIO - File #2 - 1
B20/5 - {STEP_5} Clamp engine
      OTL - File #2 - 5
      OTU - File #2 - 6, 21
      XIC - File #2 - 6, 28, 29
      XIO - File #2 - 1
B20/6 - {STEP_6} Raise rotator
      OTL - File #2 - 6
      OTU - File #2 - 7, 21
      XIC - File #2 - 7, 24, 28, 29
      XIO - File #2 - 1
B20/7 - {STEP_7} Rotate clockwise
      OTL - File #2 - 7
      OTU - File #2 - 8, 21
      XIC - File #2 - 8, 26, 28, 29
      XIO - File #2 - 1
B20/8 - {STEP_8} Lower rotator
      OTL - File #2 - 8
      OTU - File #2 - 9, 21
      XIC - File #2 - 9, 25, 28, 29
      XIO - File #2 - 1
B20/9 - {STEP_9} Unclamp timer
      OTL - File #2 - 9
      OTU - File #2 - 10, 21
      XIC - File #2 - 10, 29
      XIO - File #2 - 1
B20/10 - {STEP_10} Raise rotator
      OTL - File #2 - 10
      OTU - File #2 - 11, 21
      XIC - File #2 - 11, 24, 29
      XIO - File #2 - 1
B20/11 - {STEP_11} Rotate CCW
      OTL - File #2 - 11
      OTU - File #2 - 12, 21
      XIC - File #2 - 12, 27, 29
      XIO - File #2 - 1
B20/12 - {STEP_12} Drop engine
      OTL - File #2 - 12
      OTU - File #2 - 13, 21
      XIC - File #2 - 13
      XIO - File #2 - 1
B20/13 - {STEP_13} Move out pallet
      OTL - File #2 - 13
      OTU - File #2 - 14, 21
      XIC - File #2 - 14, 23
      XIO - File #2 - 1
B20/40 - {INT_RESET} Reset in progress
      OTE - File #2 - 15
      XIC - File #2 - 15, 16, 21
      XIO - File #2 - 0, 20
B20/41 - {RSTEP_1} Reset step 1 - Delay to unclamp.
      OTL - File #2 - 16
      OTU - File #2 - 17
      XIC - File #2 - 17
      XIO - File #2 - 16
B20/42 - {RSTEP_2} Reset step 2 - Raise mechanism.
      OTL - File #2 - 17
      OTU - File #2 - 18

```

## RSLogix 500 Cross Reference Report - Sorted by Address

|        |  |
|--------|--|
|        | XIC - File #2 - 18, 24                             |
|        | XIO - File #2 - 16                                 |
| B20/43 | - {RSTEP_3} Reset step 3 - Rotate CCW.             |
|        | OTL - File #2 - 18                                 |
|        | OTU - File #2 - 19                                 |
|        | XIC - File #2 - 19, 27                             |
|        | XIO - File #2 - 16                                 |
| B20/44 | - {RSTEP_4} Reset step 4 - unlatch internal reset. |
|        | OTL - File #2 - 19                                 |
|        | OTU - File #2 - 20                                 |
|        | XIC - File #2 - 20                                 |
|        | XIO - File #2 - 15, 16                             |