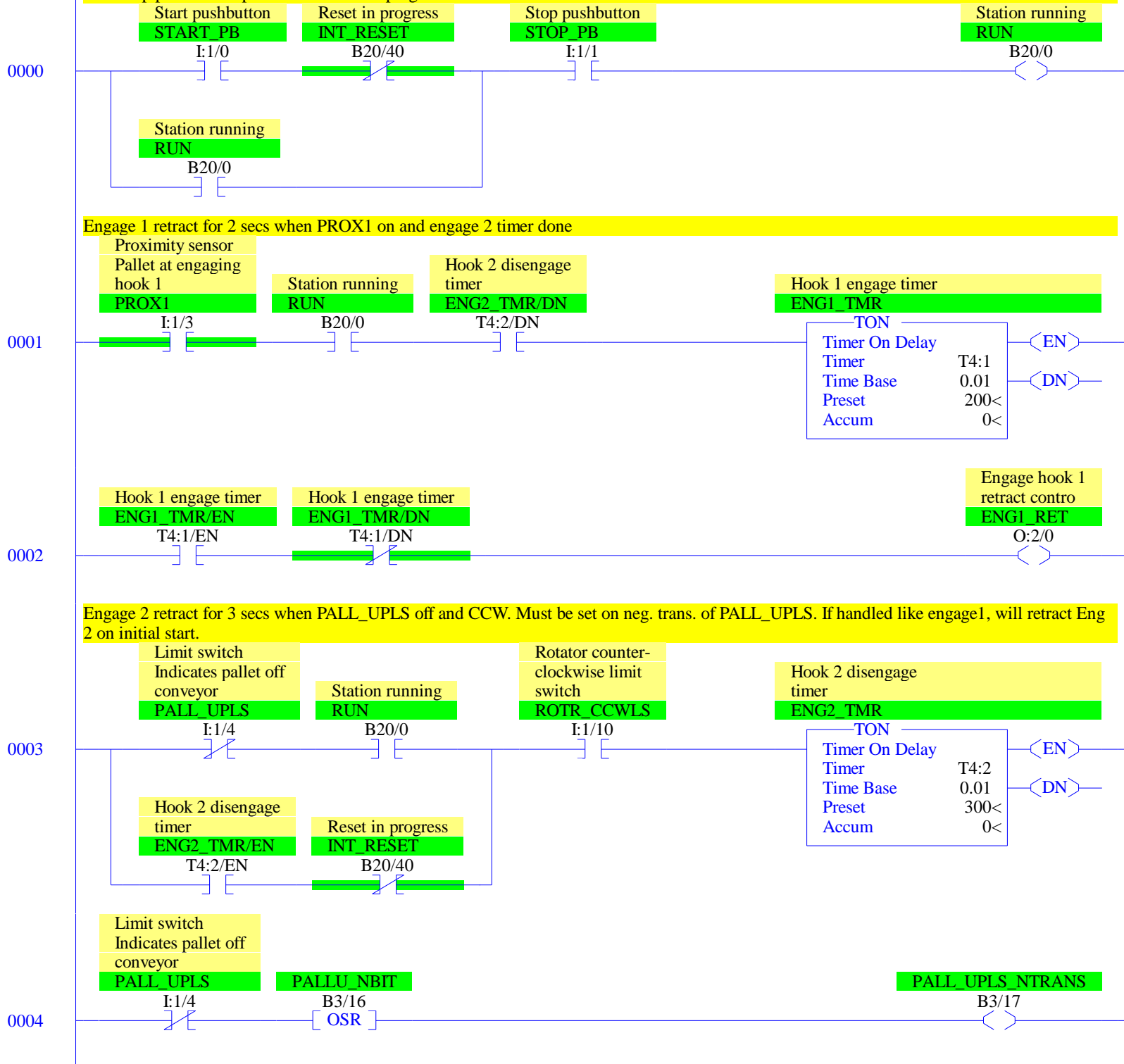
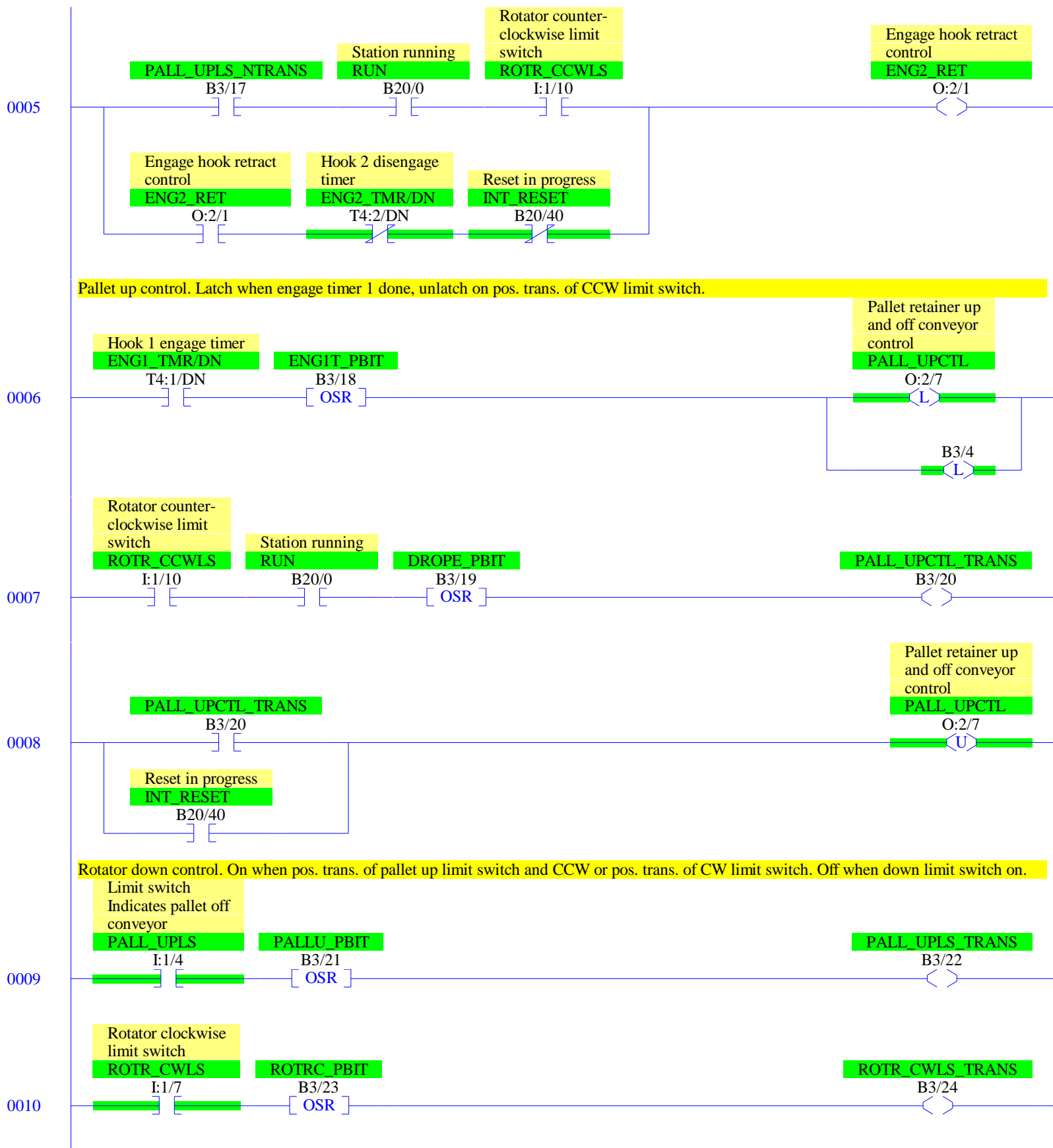


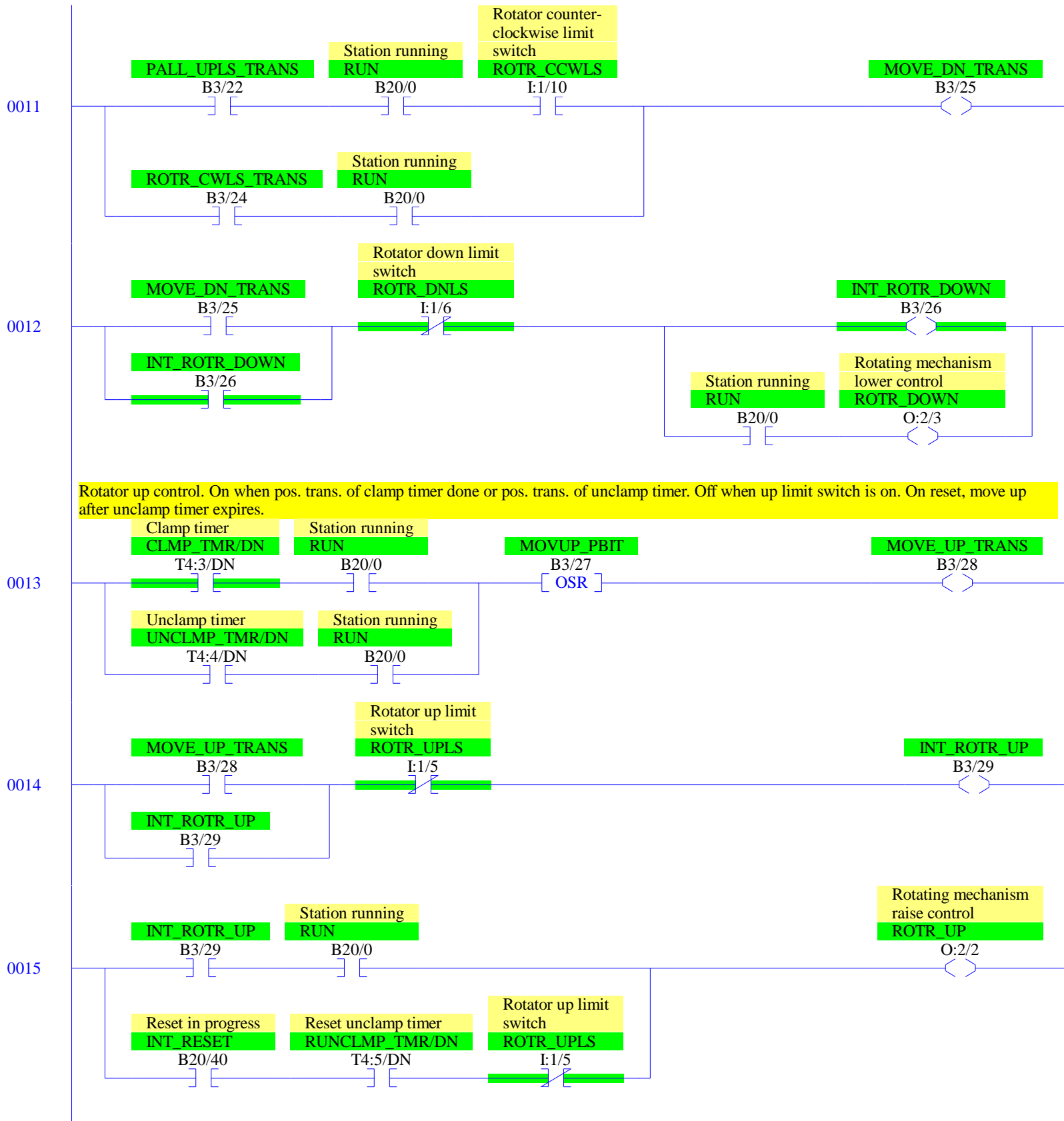
## Example 6.7 - Engine Inverter Control - Unstructured Sequence with Simulation

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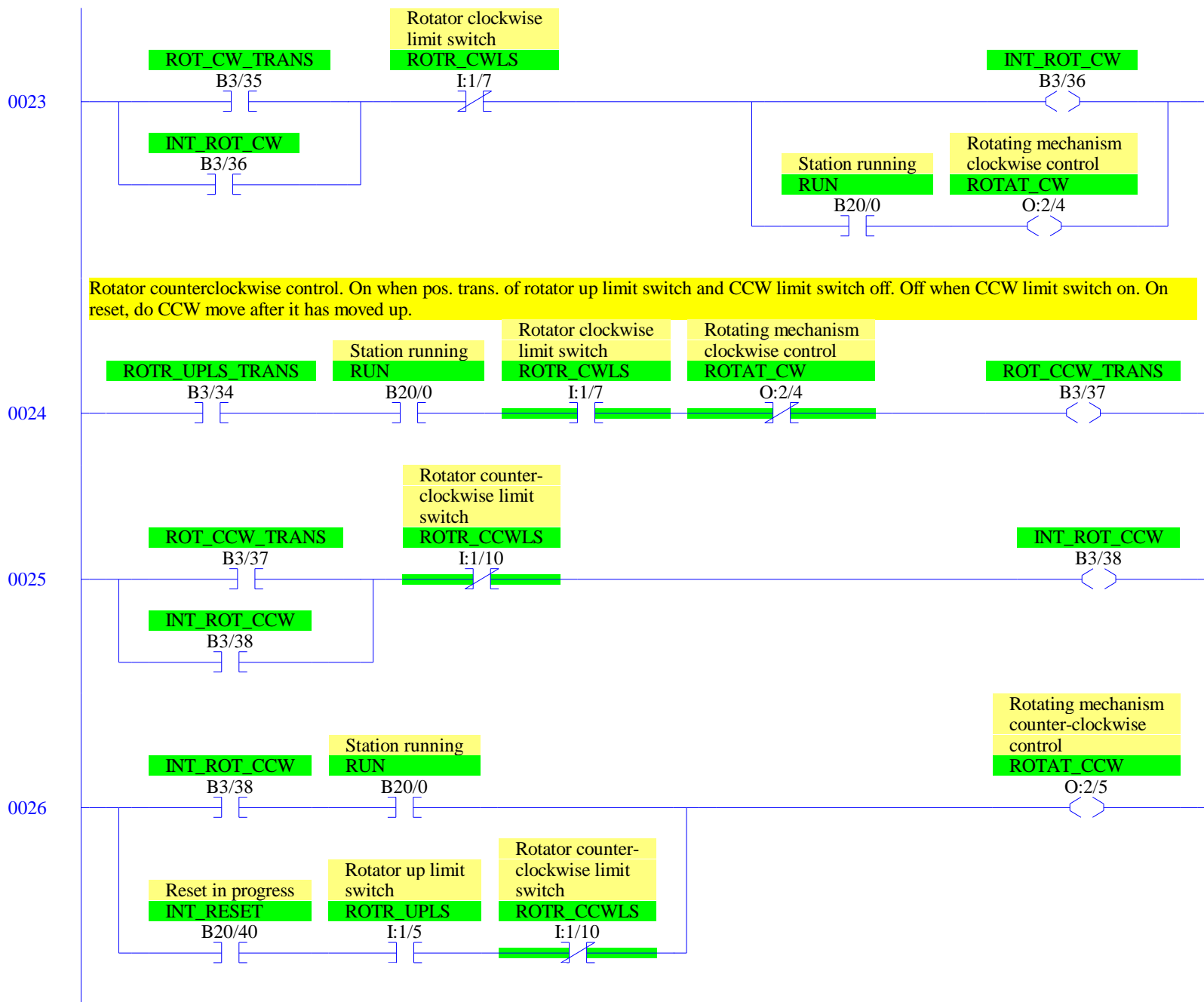
Start/stop/pause. Start prevented if reset in progress.

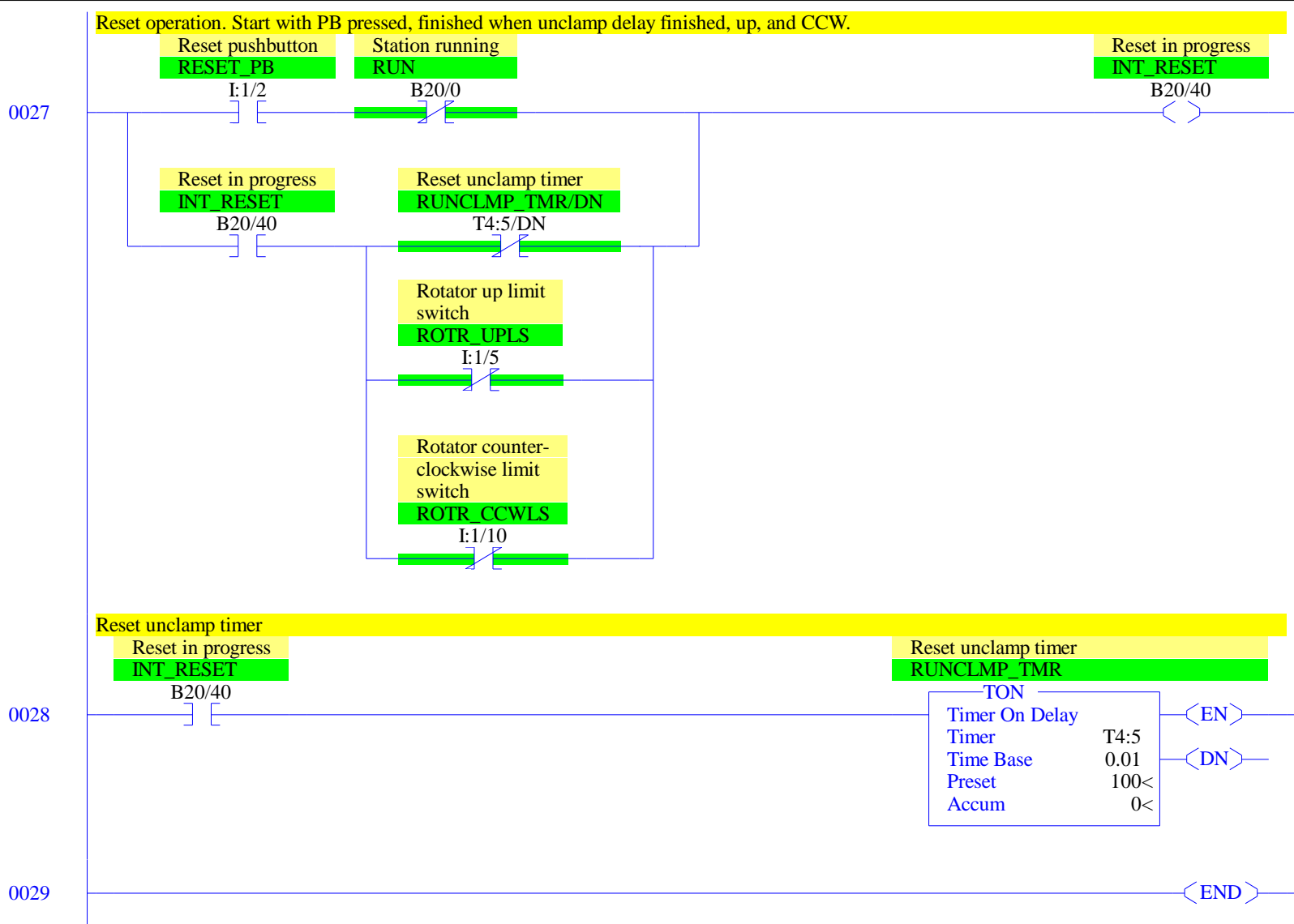












## RSLogix 500 Cross Reference Report - Sorted by Address

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

## RSLogix 500 Cross Reference Report - Sorted by Address

B3:1/8	- {ROTR_CWLS_TRANS}
	OTE - File #2 - 10
	XIC - File #2 - 11
B3:1/9	- {MOVE_DN_TRANS}
	OTE - File #2 - 11
	XIC - File #2 - 12
B3:1/10	- {INT_ROT_DOWN}
	OTE - File #2 - 12
	XIC - File #2 - 12
B3:1/11	- {MOVUP_PBIT}
	OSR - File #2 - 13
B3:1/12	- {MOVE_UP_TRANS}
	OTE - File #2 - 13
	XIC - File #2 - 14
B3:1/13	- {INT_ROT_UP}
	OTE - File #2 - 14
	XIC - File #2 - 14, 15
B3:1/14	- {GRIPC_PBIT}
	OSR - File #2 - 16
B3:1/15	- {GRIP_O_PBIT}
	OSR - File #2 - 17
B3:2/0	- {OPEN_GRIP_TRANS}
	OTE - File #2 - 17
	XIC - File #2 - 18
B3:2/1	- {ROT_PBIT}
	OSR - File #2 - 21
B3:2/2	- {ROTR_UPLS_TRANS}
	OTE - File #2 - 21
	XIC - File #2 - 22, 24
B3:2/3	- {ROT_CW_TRANS}
	OTE - File #2 - 22
	XIC - File #2 - 23
B3:2/4	- {INT_ROT_CW}
	OTE - File #2 - 23
	XIC - File #2 - 23
B3:2/5	- {ROT_CCW_TRANS}
	OTE - File #2 - 24
	XIC - File #2 - 25
B3:2/6	- {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	- XIC - File #2 - 6
	XIO - File #2 - 2
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
B20:0/0	- {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



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