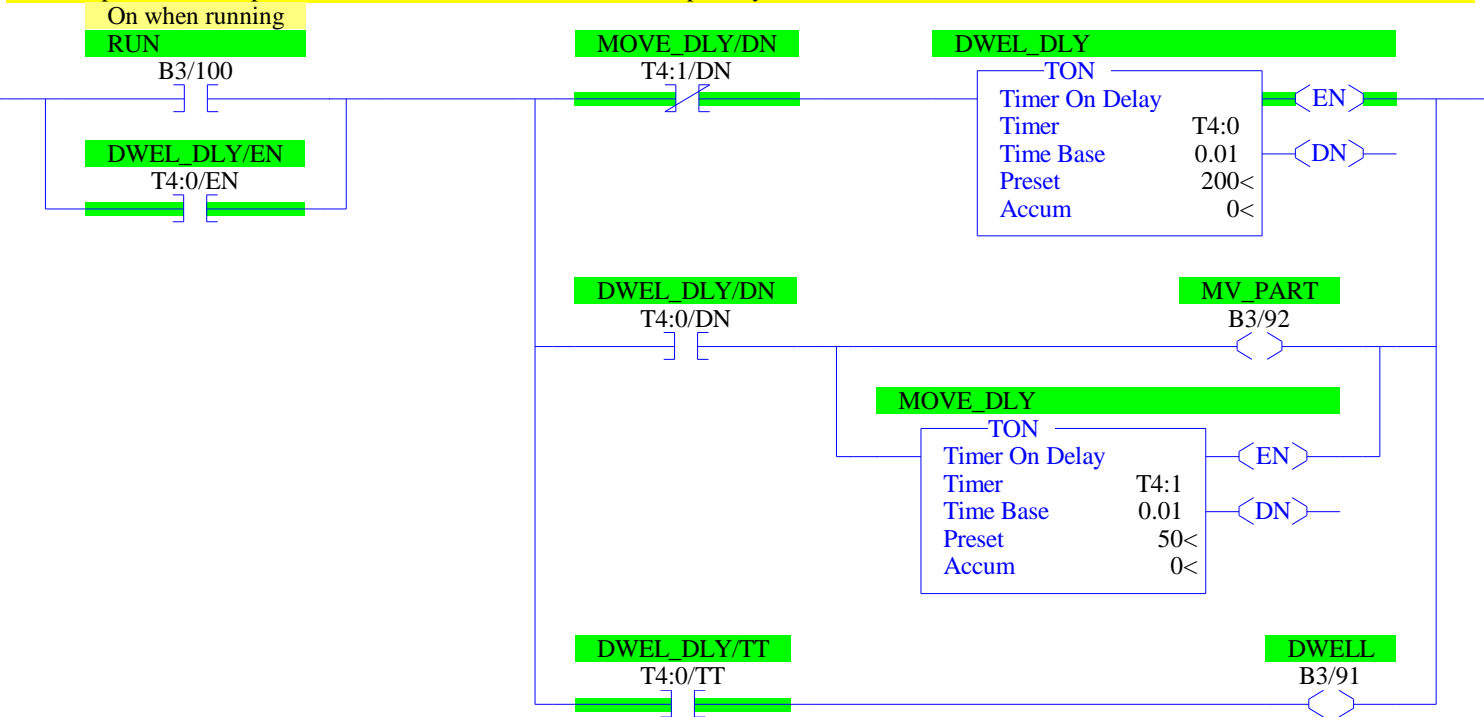


Example 8.1 Reject Tracking Using a Shift Register

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Generate part dwell and part move indications. If Run turns off, complete cycle.

0000

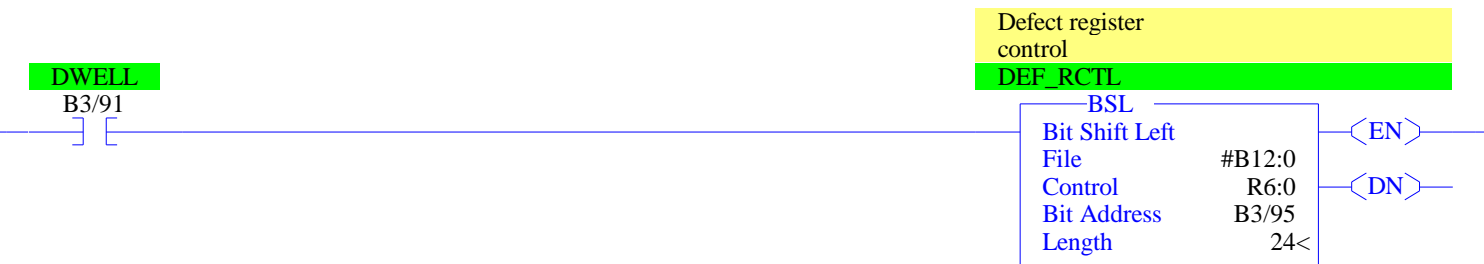


Shift defect indications left one position. Always shift in a zero.

0001

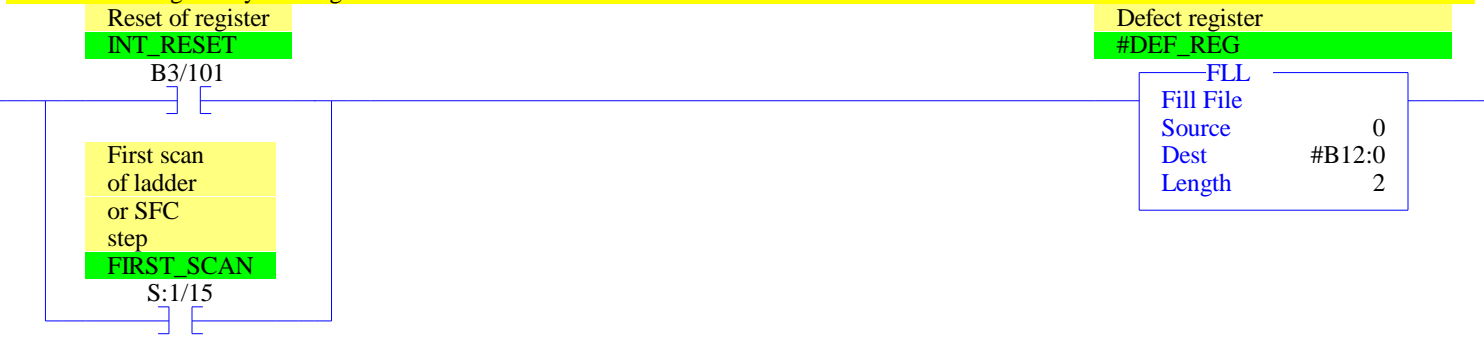


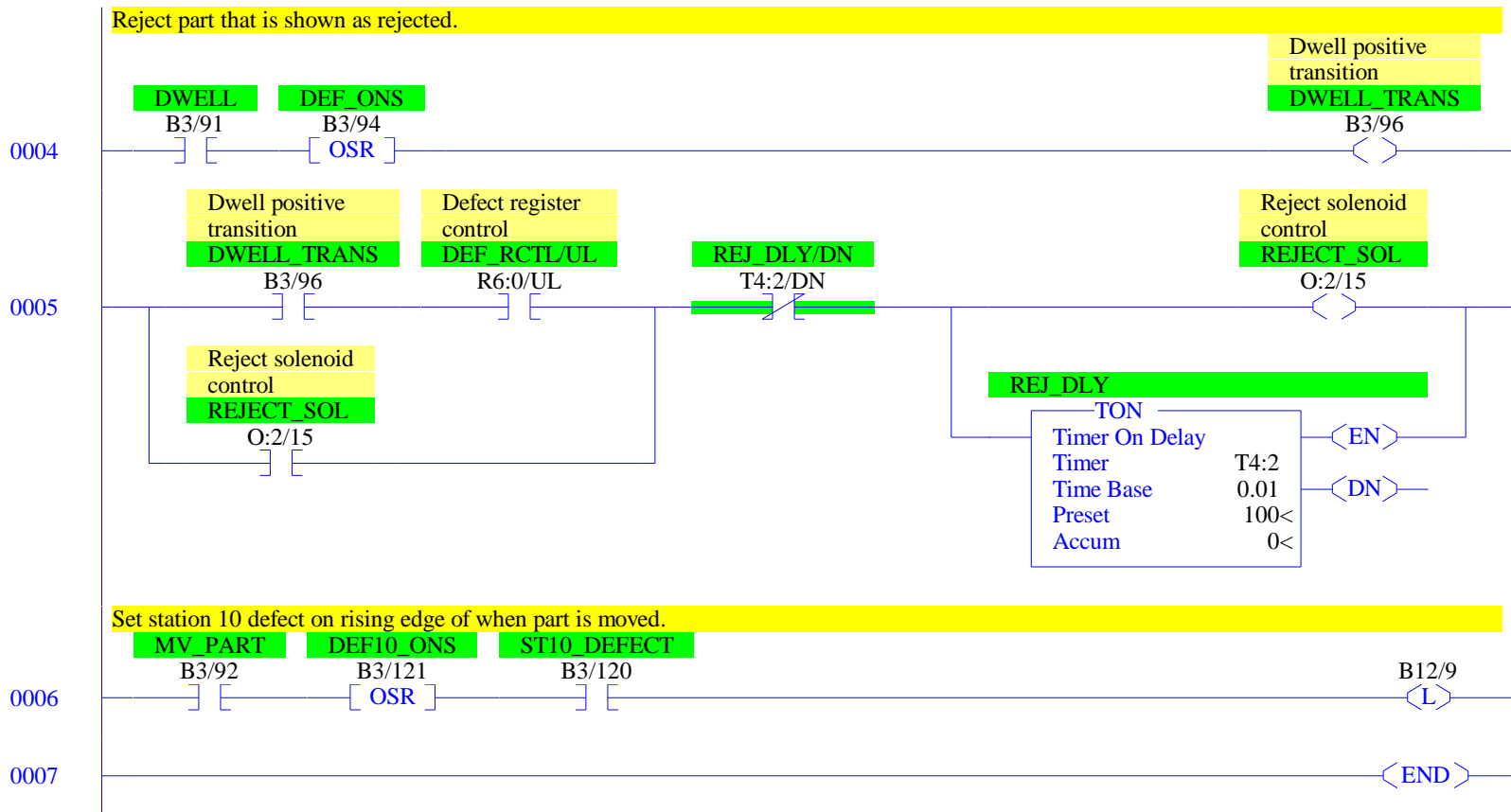
0002



Initialize shift register by clearing both words.

0003





RSLogix 500 Cross Reference Report - Sorted by Address

```

O:2/15      - {REJECT_SOL} Reject solenoid control
              OTE - File #2 - 5
              XIC - File #2 - 5
S:1/15      - {FIRST_SCAN} First scan of ladder or SFC step
              XIC - File #2 - 3
B3/91       - {DWELL}
              OTE - File #2 - 0
              XIC - File #2 - 2, 4
B3/92       - {MV_PART}
              OTE - File #2 - 0
              XIC - File #2 - 6
B3/94       - {DEF_ONS}
              OSR - File #2 - 4
B3/95       - {FIRST_BIT}
              BSL - File #2 - 2
              OTE - File #2 - 1
              XIC - File #2 - 1
              XIO - File #2 - 1
B3/96       - {DWELL_TRANS} Dwell positive transition
              OTE - File #2 - 4
              XIC - File #2 - 5
B3/100      - {RUN} On when running
              XIC - File #2 - 0
B3/101      - {INT_RESET} Reset of register
              XIC - File #2 - 3
B3/120      - {ST10_DEFECT}
              XIC - File #2 - 6
B3/121      - {DEF10_ONS}
              OSR - File #2 - 6
T4:0        - {DWEL_DLY}
              TON - File #2 - 0
T4:0/DN     - XIC - File #2 - 0
T4:0/TT     - XIC - File #2 - 0
T4:0/EN     - XIC - File #2 - 0
T4:1        - {MOVE_DLY}
              TON - File #2 - 0
T4:1/DN     - XIO - File #2 - 0
T4:2        - {REJ_DLY}
              TON - File #2 - 5
T4:2/DN     - XIO - File #2 - 5
R6:0        - {DEF_RCTL} Defect register control
              BSL - File #2 - 2
R6:0/UL     - XIC - File #2 - 5
B12:0       - {DEF_REG} Defect register
              FLL - File #2 - 3
              BSL - File #2 - 2
FILE B12:0 LEN:2 - FLL - File #2 - 3
              BSL - File #2 - 2
B12/9       - OTL - File #2 - 6
FILE B12/9 LEN:2 - FLL - File #2 - 3
              BSL - File #2 - 2

```