

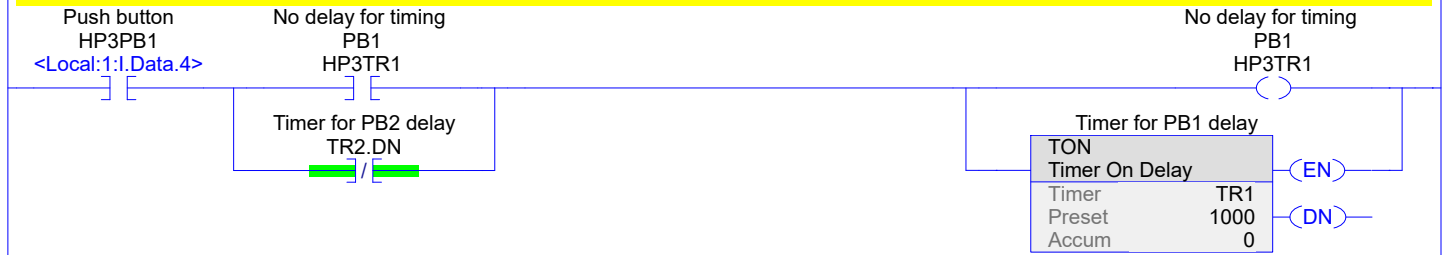
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For safety reasons, an operator is required to actuate 2 pushbuttons in order to close a stamping press. The intention is to ensure that both of the operator's hands are out of the press when it closes. The logic incorporates timing delays that prevent the operator from taping 1 pushbutton down and making the press faster but unsafe to operate.

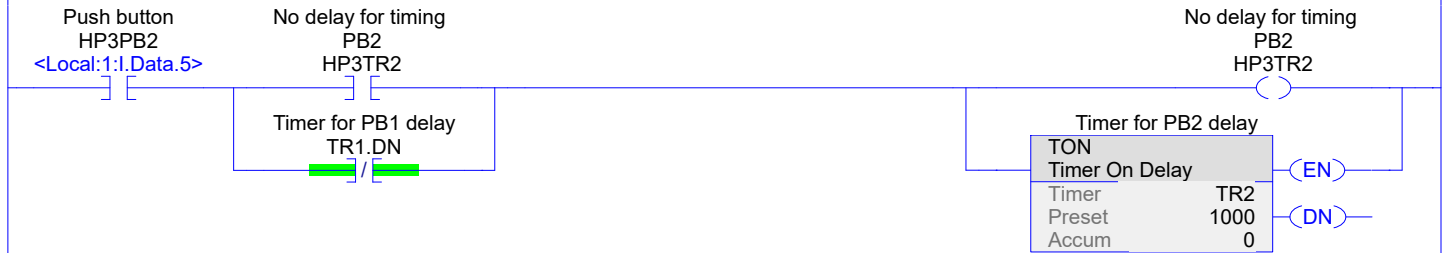
Additional internal memory:

Tag	Data Type	
HP3TR1	BOOL	No delay for timing PB1
HP3TR2	BOOL	No delay for timing PB2
TR1	TIMER	Timer for PB1 delay
TR2	TIMER	Timer for PB2 delay

0



1

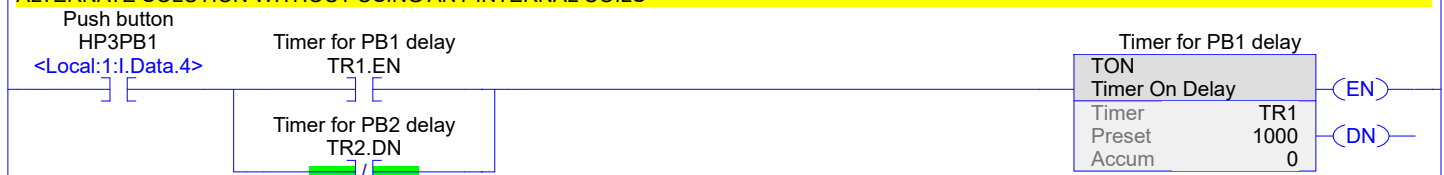


2

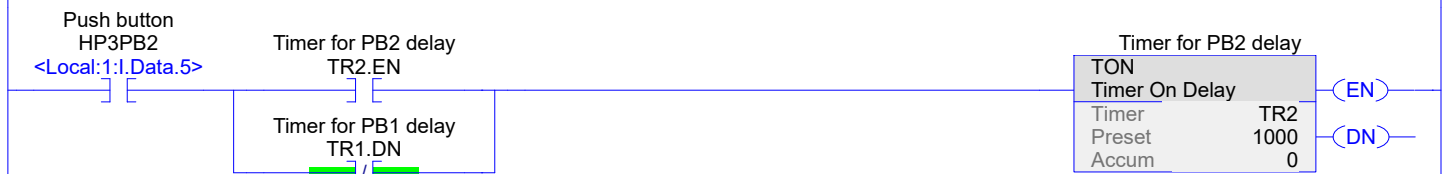


3

ALTERNATE SOLUTION WITHOUT USING ANY INTERNAL COILS



4



5



(End)