

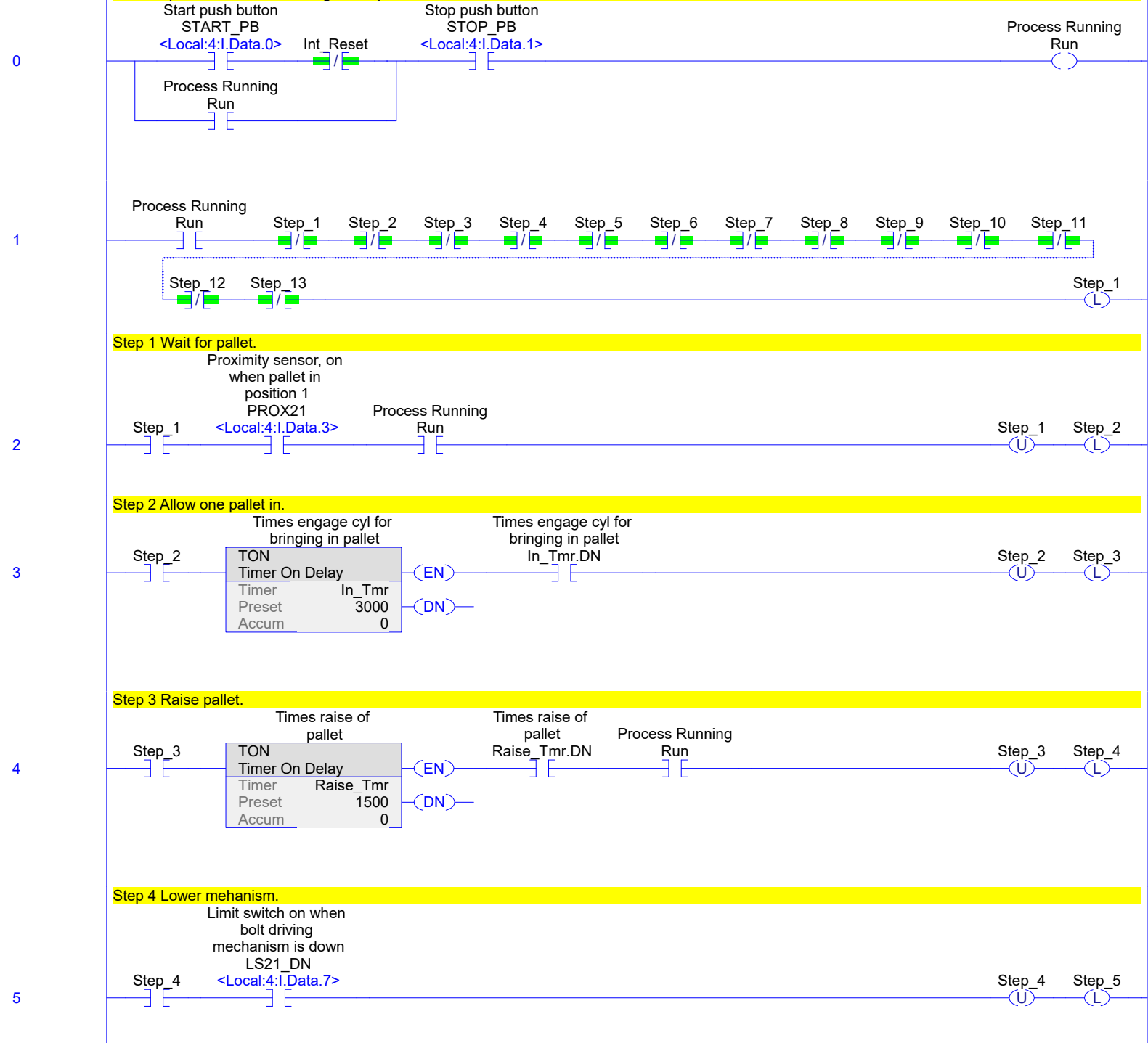
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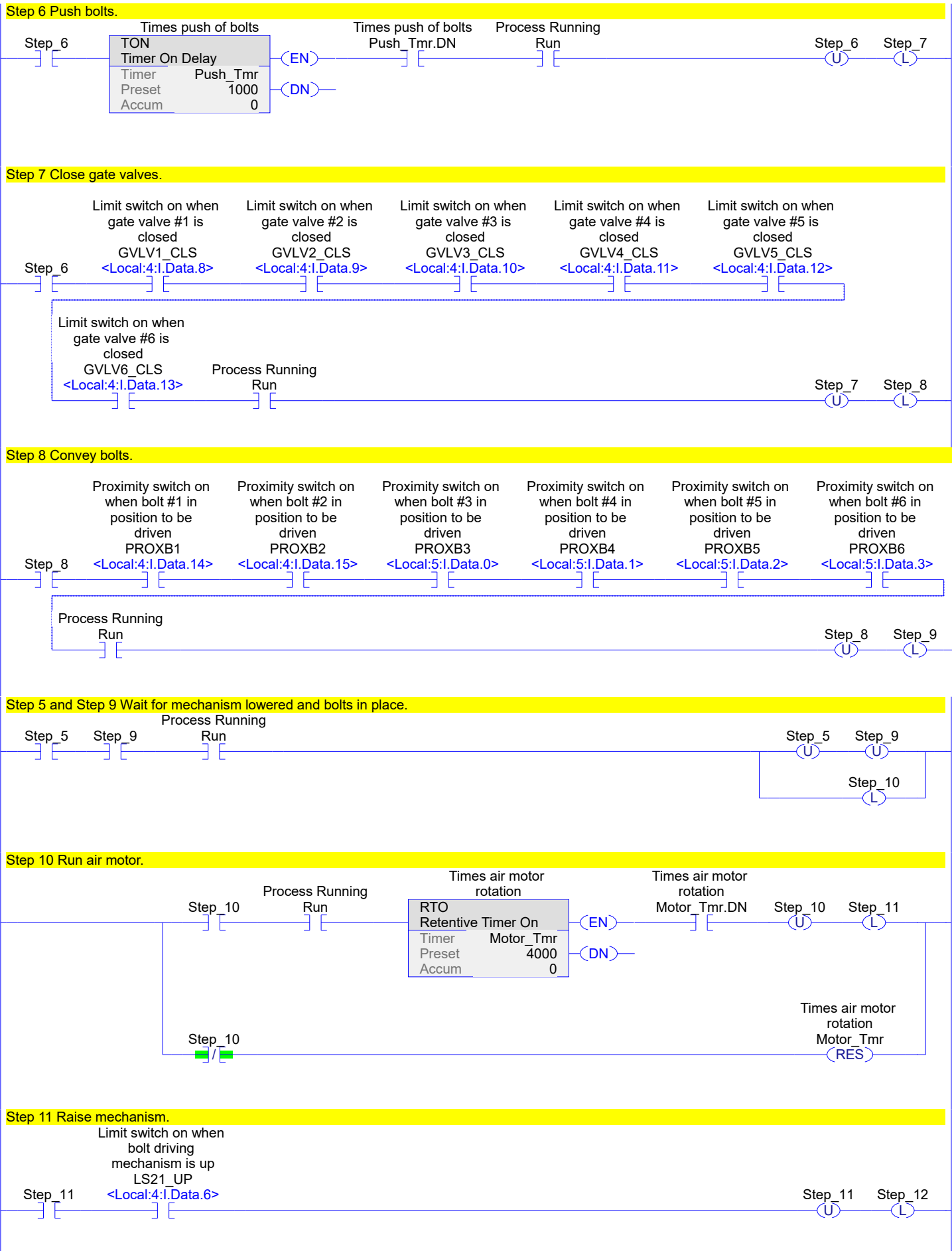
Revised Bolt Driving Station Control

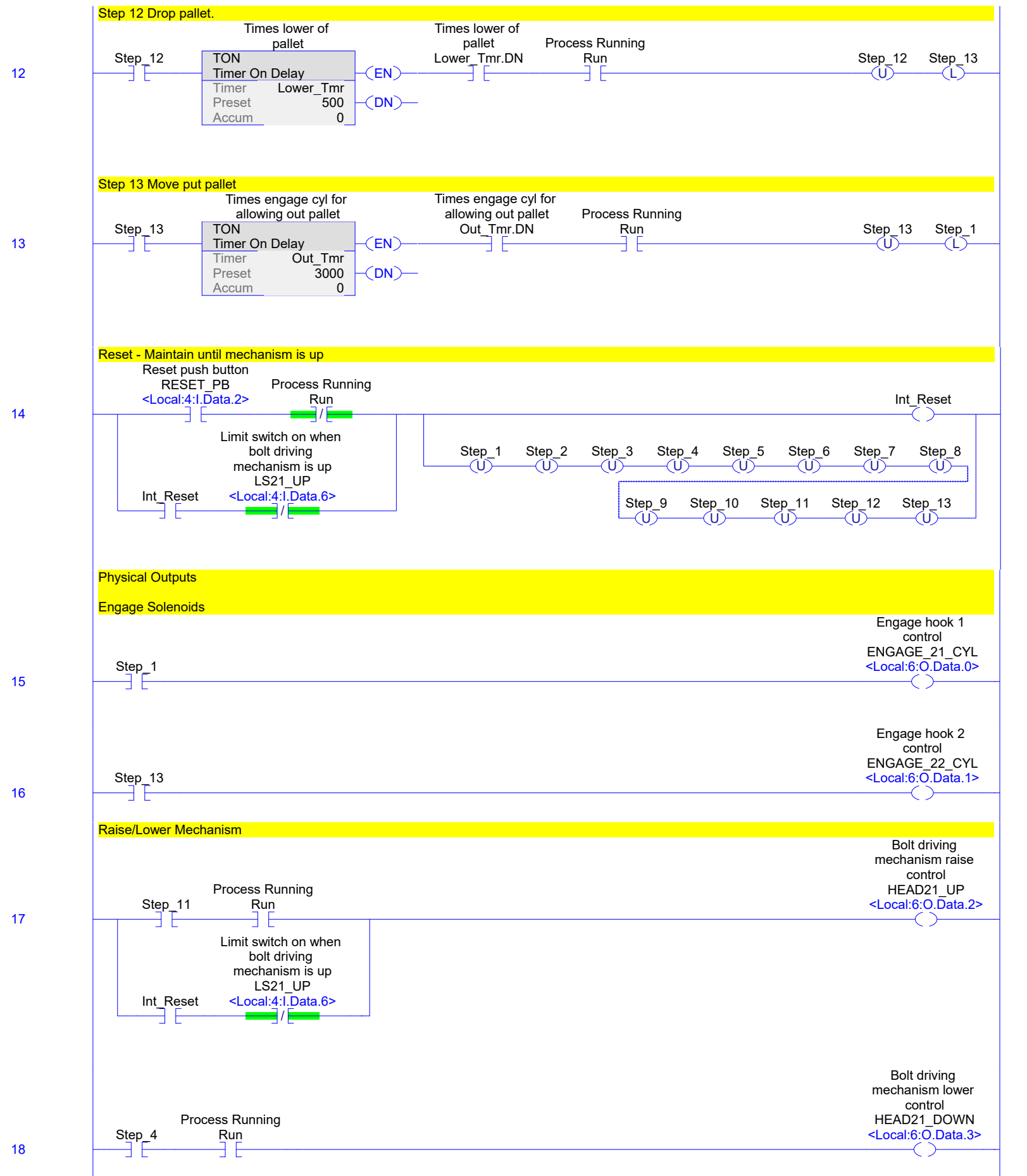
Additional internal memory:

Tag	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Step_1 to Step_13	BOOL	Step-in-progress bits
In_Tmr	TIMER	Times engage cyl for bringing in pallet
Raise_Tmr	TIMER	Times raise of pallet
Push_Tmr	TIMER	Times push of bolts
Motor_Tmr	TIMER	Times air motor rotation
Lower_Tmr	TIMER	Times lower of pallet
Out_Tmr	TIMER	Times engage cyl for allowing out pallet

Start/stop and initial start. During reset, prevent start







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Push Bolt Solenoids

Step_6

Push bolt #1 into
pneumatic tube
PBOLT1_CYL
<Local:6:O.Data.4>

Push bolt #2 into
pneumatic tube
PBOLT2_CYL
<Local:6:O.Data.5>

Push bolt #3 into
pneumatic tube
PBOLT3_CYL
<Local:6:O.Data.6>

Push bolt #4 into
pneumatic tube
PBOLT4_CYL
<Local:6:O.Data.7>

Push bolt #5 into
pneumatic tube
PBOLT5_CYL
<Local:6:O.Data.8>

Push bolt #6 into
pneumatic tube
PBOLT6_CYL
<Local:6:O.Data.9>

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Gate Valves

Step_7

Step_8

Close gate valve #1
to seal pneumatic
tube
GVLV1
<Local:6:O.Data.10>

Close gate valve #2
to seal pneumatic
tube
GVLV2
<Local:6:O.Data.11>

Close gate valve #3
to seal pneumatic
tube
GVLV3
<Local:6:O.Data.12>

Close gate valve #4
to seal pneumatic
tube
GVLV4
<Local:6:O.Data.13>

Close gate valve #5
to seal pneumatic
tube
GVLV5
<Local:6:O.Data.14>

Close gate valve #6
to seal pneumatic
tube
GVLV6
<Local:6:O.Data.15>

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