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### Parts Transfer Station Control

Additional internal memory:

Tag	Data Type	
Step_1 to Step_4	BOOL	Step-in-progress bits
Motor1_Tmr	TIMER	Turntable turn timer
Parts_Ctr	COUNTER	Parts counter

#### Initial Start

Internal coil, on when operation enabled



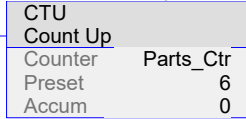
#### Step 1 Count parts

Reset counter when not in step 1

Photoelectric sensor, off (open) when part passes  
PE1

Counts 6 parts

<Local:1:I.Data.0>



Internal coil, on when operation enabled

Counts 6 parts  
Parts\_Ctr.DN

Run

Step\_1

Step\_2

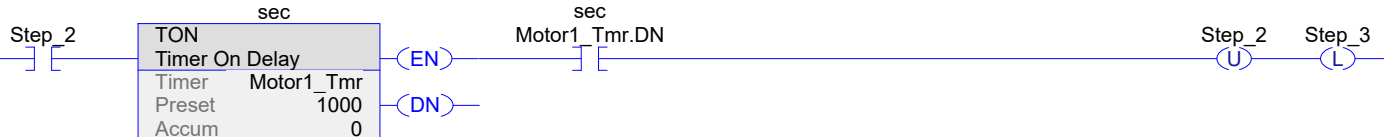
Counts 6 parts  
Parts\_Ctr

(RES)

#### Step 2 Rotate Table

Turntable on for 1 sec

Turntable on for 1 sec



#### Step 3 Extend Ram

Ram extended limit switch, on when ram is extended  
LS1

Internal coil, on when operation enabled



#### Step 4 Retract Ram

Ram retracted limit switch, on when ram is retracted  
LS2

Internal coil, on when operation enabled



