

Copyright (c) 2011-2023 Dogwood Valley Press, LLC

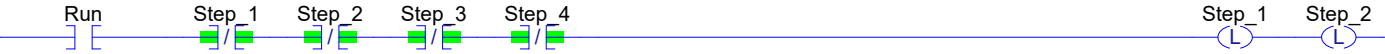
### Parts Transfer Station Control

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

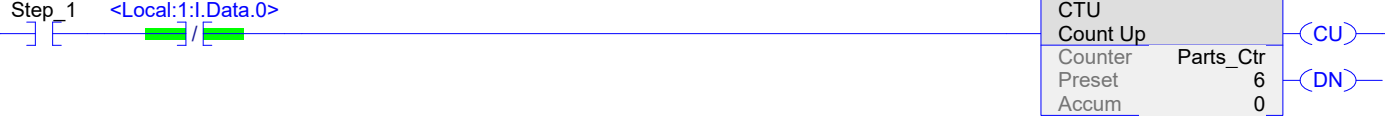
#### Initial Start

Internal coil, on when operation enabled



#### Step 1 Count parts

Photoelectric sensor, off (open) when part passes PE1



#### Step 2 Extend Ram

Ram extended limit switch, on when ram is extended LS1

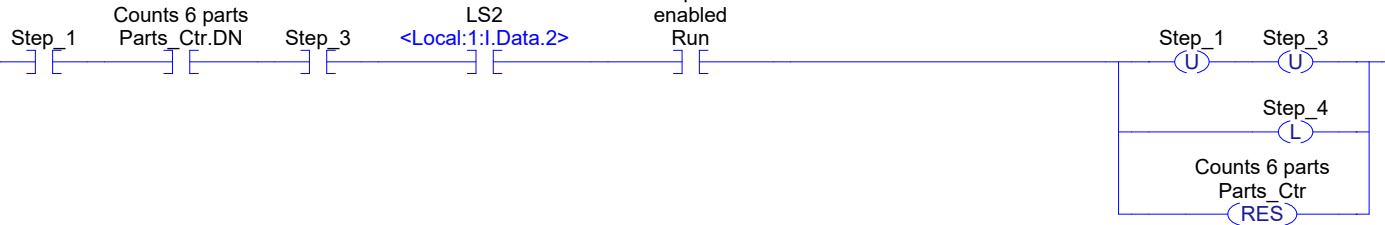
Internal coil, on when operation enabled



#### Transition out of Step 1, Count Parts and Step 3, Retract Ram

Ram retracted limit switch, on when ram is retracted LS2

Internal coil, on when operation enabled



#### Step 4 Rotate Table

Turntable on for 1 sec

Turntable on for 1 sec

