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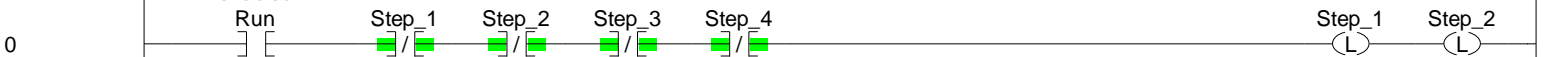
Parts Transfer Station Control

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

Photoelectric sensor, off (open) when part passes

PE1

<Local:1:I.Data.0>

Counts 6 parts



Step 2 Extend Ram

Ram extended limit switch, on when ram is extended

LS1

<Local:1:I.Data.1>

Internal coil, on when operation enabled

Run



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

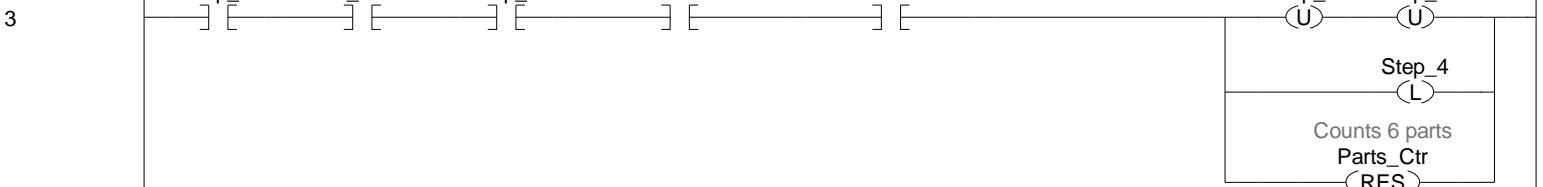
Ram retracted limit switch, on when ram is retracted

LS2

<Local:1:I.Data.2>

Internal coil, on when operation enabled

Run



Step 4 Rotate Table

Turntable on for 1 sec

Turntable on for 1 sec

