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2

3 Simulation

4 On reset, reset PROX

5 RESET — PROX (RM)

6 PROX simulation: Set when INFEED running for 3 secs.
Reset when PROX on and CHAIN_CONV runs for one sec

7 TON *Prox_O...* IN Q PT ET; INFEED_M... — PROX (SM); 3000 — PT

8 TON *Prox_O...* IN Q PT ET; PROX CHAIN_CO... — PROX (RM); 1000 — PT

9 LEFT_LS simulation: Turn on when LEFT_CYL on for 3 sec

10 TON *Left_Tmr* IN Q PT ET; LEFT_CYL — LEFT_LS (M); 3000 — PT

11 RIGHT_LS simulation: Turn on when RIGHT_CYL on for 3 sec

12 TON *Right_...* IN Q PT ET; RIGHT_CYL — RIGHT_LS (M); 3000 — PT

13 BOT_LS simulation: Turn on when BOT_CYL on for 3 sec

14 TON *Bot_Tmr* IN Q PT ET; BOT_CYL — BOT_LS (M); 3000 — PT

15 ENC_PULSE simulation: Generate one-scan pulse every 10 ms

16 TON *Enc_Tic* IN Q PT ET; CHAIN_CO... *Enc_Tic.Q* (NC) — ENC_PULSE (M); 10 — PT