


For safety reasons, an operator is required to actuate 2 pushbuttons in order to close a stamping press. The intention is to ensure that both of the operator's hands are out of the press when it closes. The logic incorporates timing delays that prevent the operator from tapping 1 pushbutton down and making the press faster but unsafe to operate.

Additional internal memory:

Variable	Data Type	Address	
HP3TR1	BOOL	%M3	No delay for timing PB1
HP3TR2	BOOL	%M4	No delay for timing PB2
TR1	INT[3]	%R1	Timer for PB1 delay
TR2	INT[3]	%R2	Timer for PB2 delay

 **Operator interlock.**
Press does not operate unless operator presses both HPPB1 and HPPB2 within 1 second of each other.
Taping either button down disables press operation.

