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SP6-3 Parts Transfer Station Control

Additional internal variable declarations:

Variables	Address	Data Type	
Run	%M1	BOOL	On while station running
Step_1 to Step_4	%T1 to %T4 BOOL	Step-in-progress bits	
Motor1_Tmr %R1	INT[3]	Times motor rotation	
Parts_Ctr	%R4	INT[3]	Counts parts
Parts_Ctr_Dn	%M3	BOOL	Needed parts counted

Initial start.

Run %M00039 — Step_1 %T00001 — Step_2 %T00002 — Step_3 %T00003 — Step_4 %T00004 → S Step_1 %T00001

Step 1
Count Parts

Step_1 %T00001 — PE1 %I00081 — UPCTR Parts_Ctr %R00004, R, 6 PV → M Parts_Ctr_Dn %M00003

Step_1 %T00001 → R

Parts_Ctr_Dn %M00003 — Run %M00039 → R Step_1 %T00001; S Step_2 %T00002

Step 2 Rotate Table

Step_2 %T00002 — TMR HUNDS Motor1_Tmr %R00001, 100 PV → R Step_2 %T00002; S Step_3 %T00003

Step 3 Extend Ram

Step_3 %T00003 — LS1 %I00082 — Run %M00039 → R Step_3 %T00003; S Step_4 %T00004

Step 4 Retract Ram

Step_4 %T00004 — LS2 %I00083 — Run %M00039 → R Step_4 %T00004; S Step_1 %T00001

Physical Outputs

Step_3 %T00003 — Run %M00039 → M SOL1 %Q00001

Step_2 %T00002 → M MOTOR1 %Q00002

Step_1 %T00001 — Run %M00039 → M MOTOR2 %Q00003

Reset

Reset %M00040 — Run %M00039 → R Step_1 %T00001; R Step_2 %T00002; R Step_3 %T00003; R Step_4 %T00004

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