

Carton Sealer

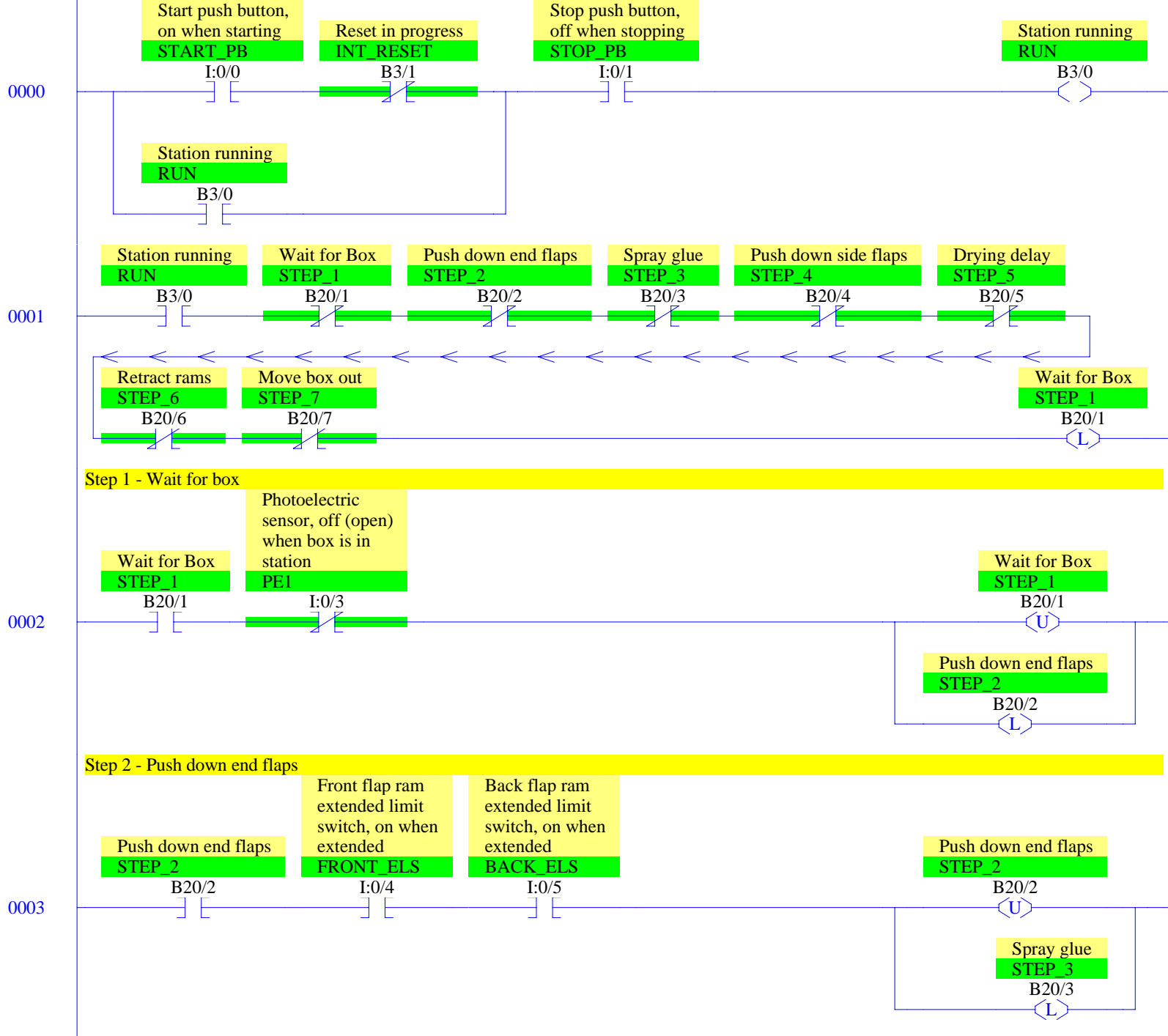
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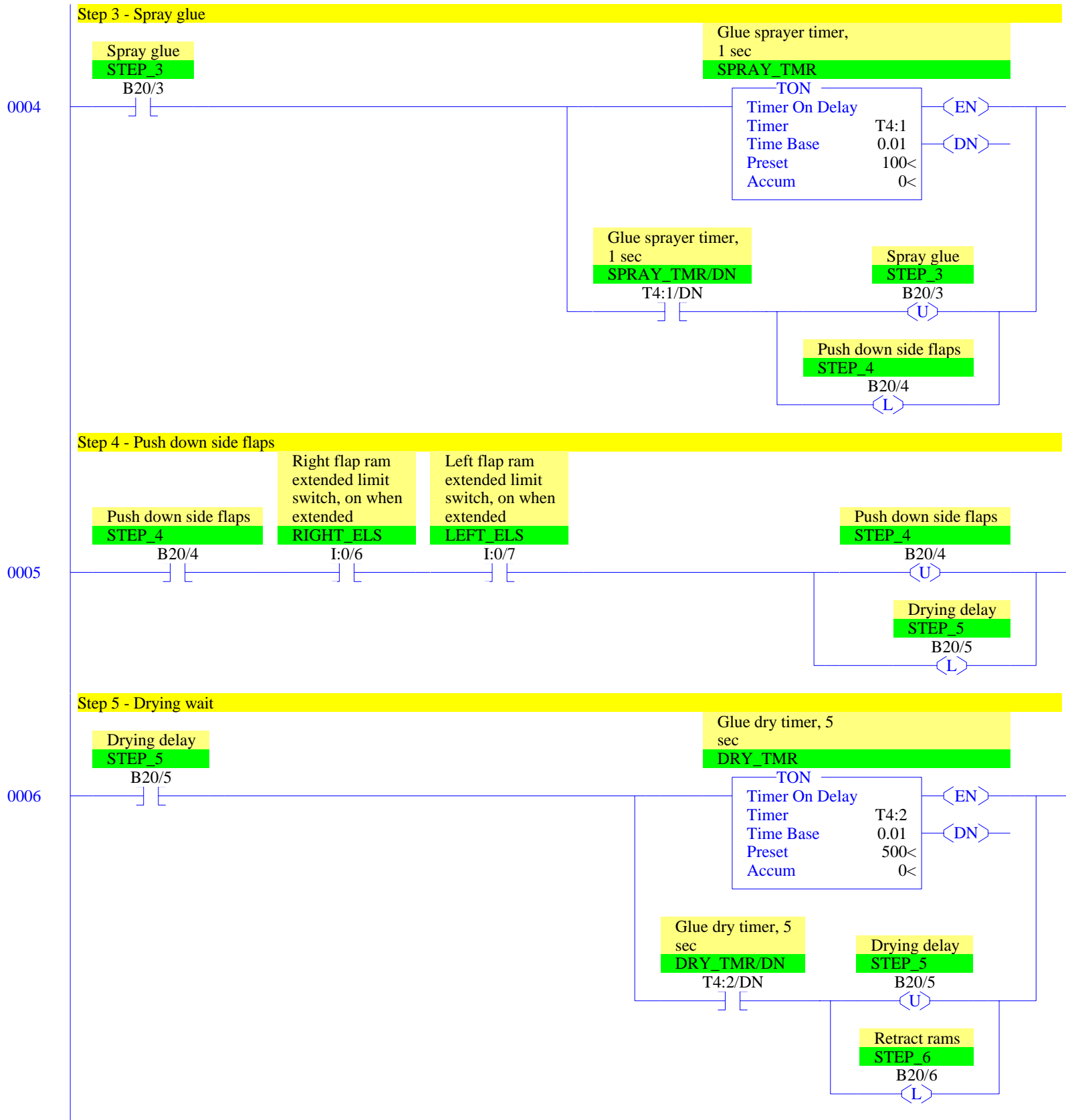
Additional internal memory:

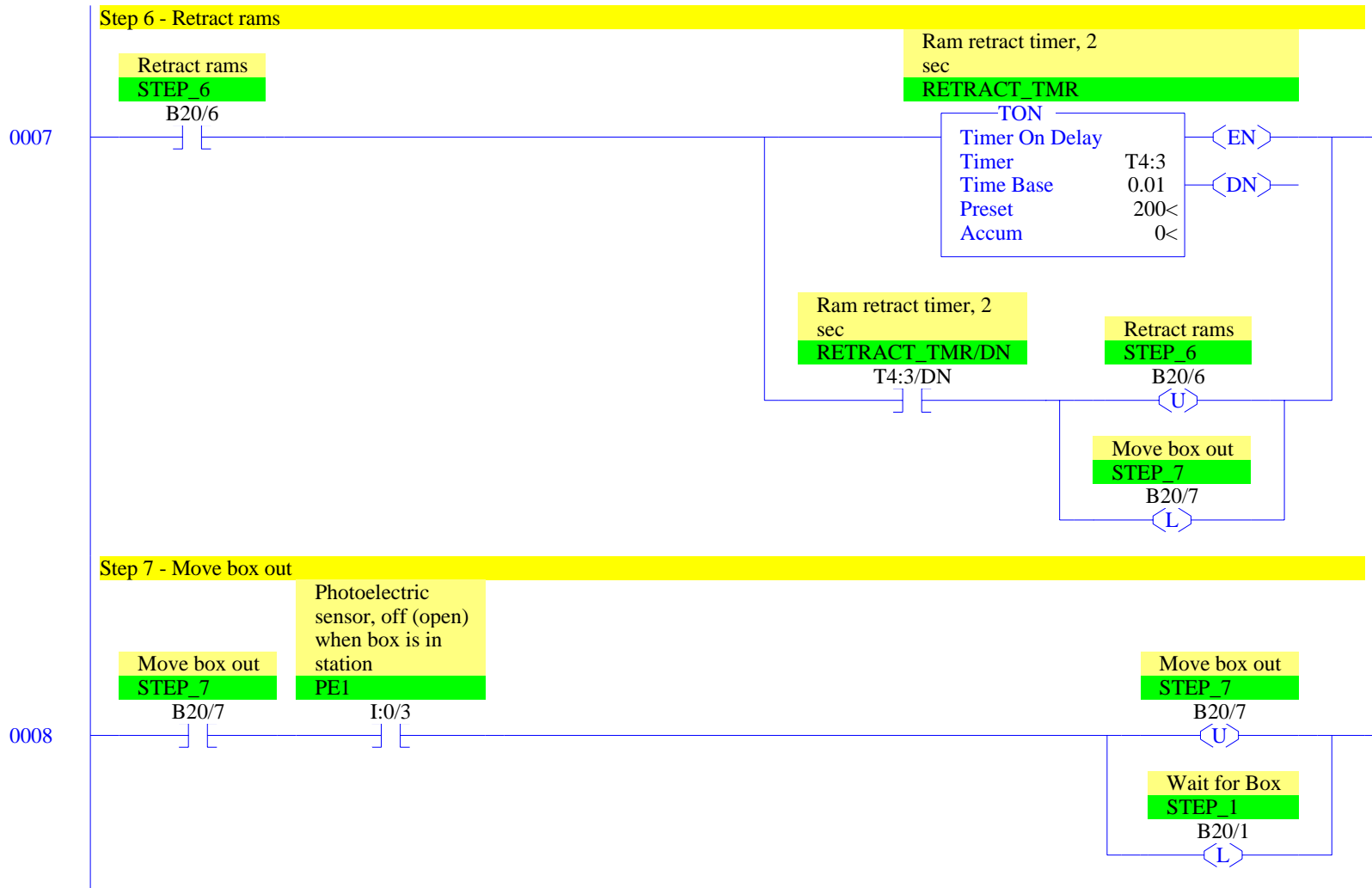
Symbol	Address	
RUN	B3/0	On while station running
INT_RESET	B3/1	Internal reset
STEP_1 to STEP_7	B20/1 to B20/7	Step-in-progress bits
SPRAY_TMR	T4:1	Times spray
DRY_TMR	T4:2	Times drying step
RETRACT_TMR	T4:3	Times retract of rams
RESET_TMR	T4:4	Times reset (retract of rams)

Start/stop and initial start.

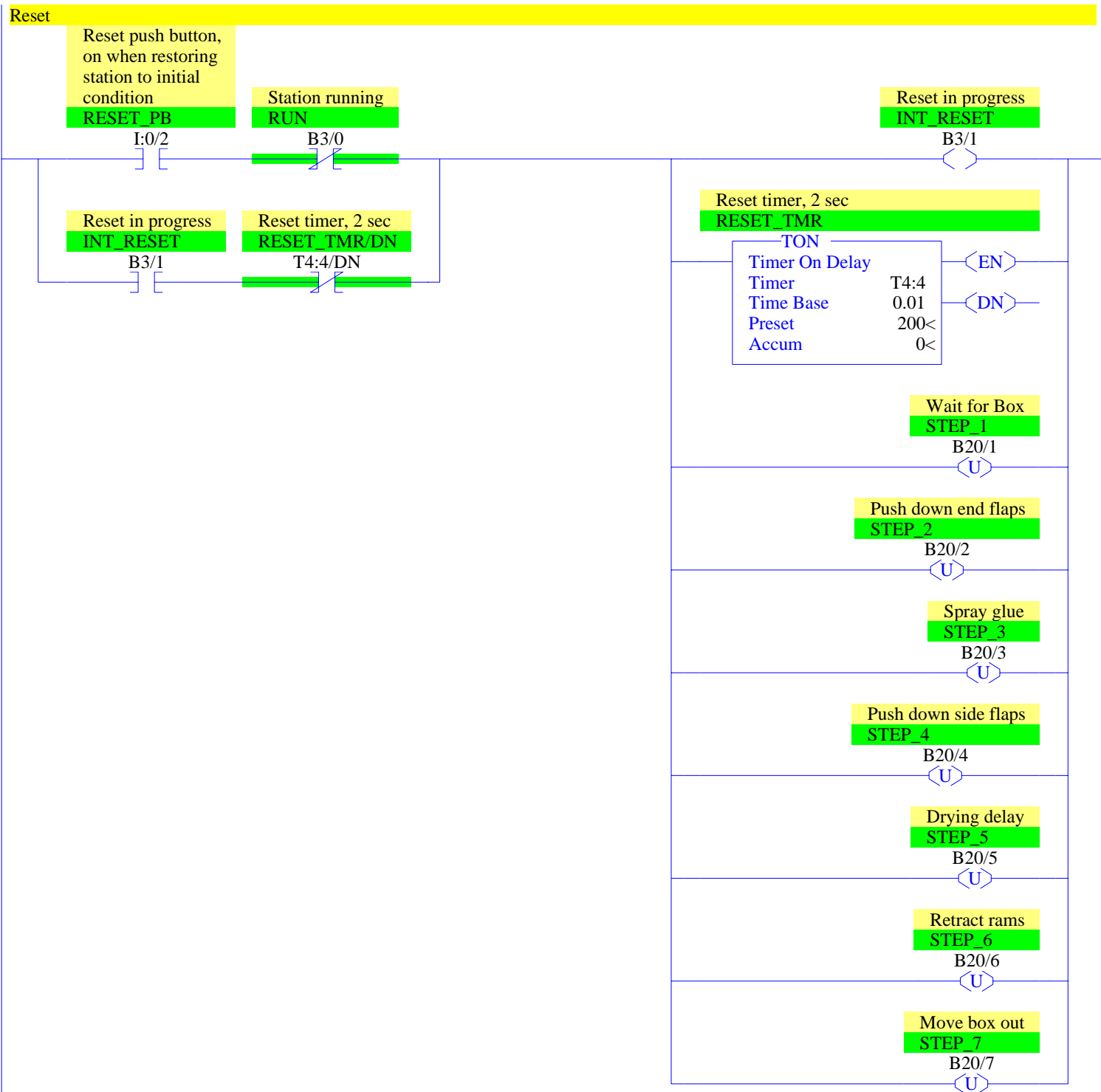
During reset, prevent start.



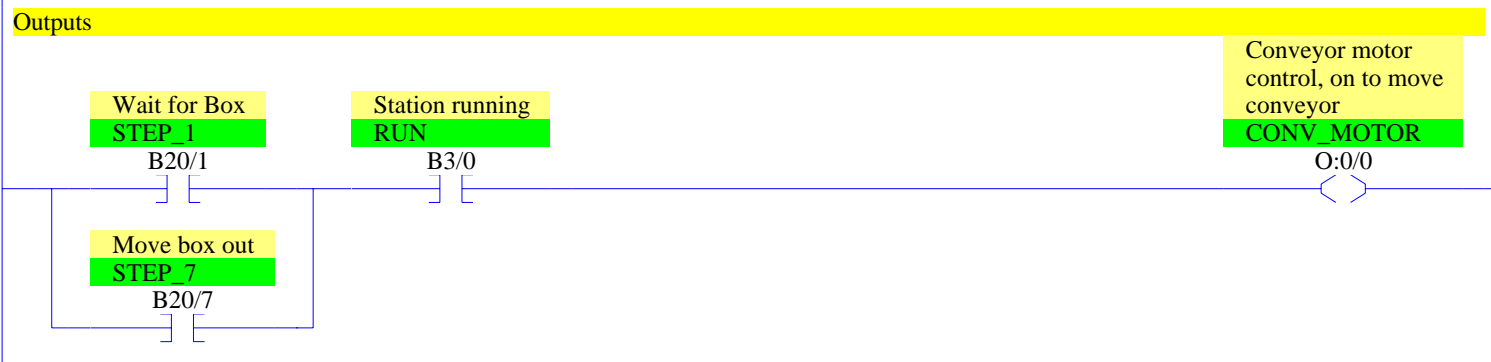


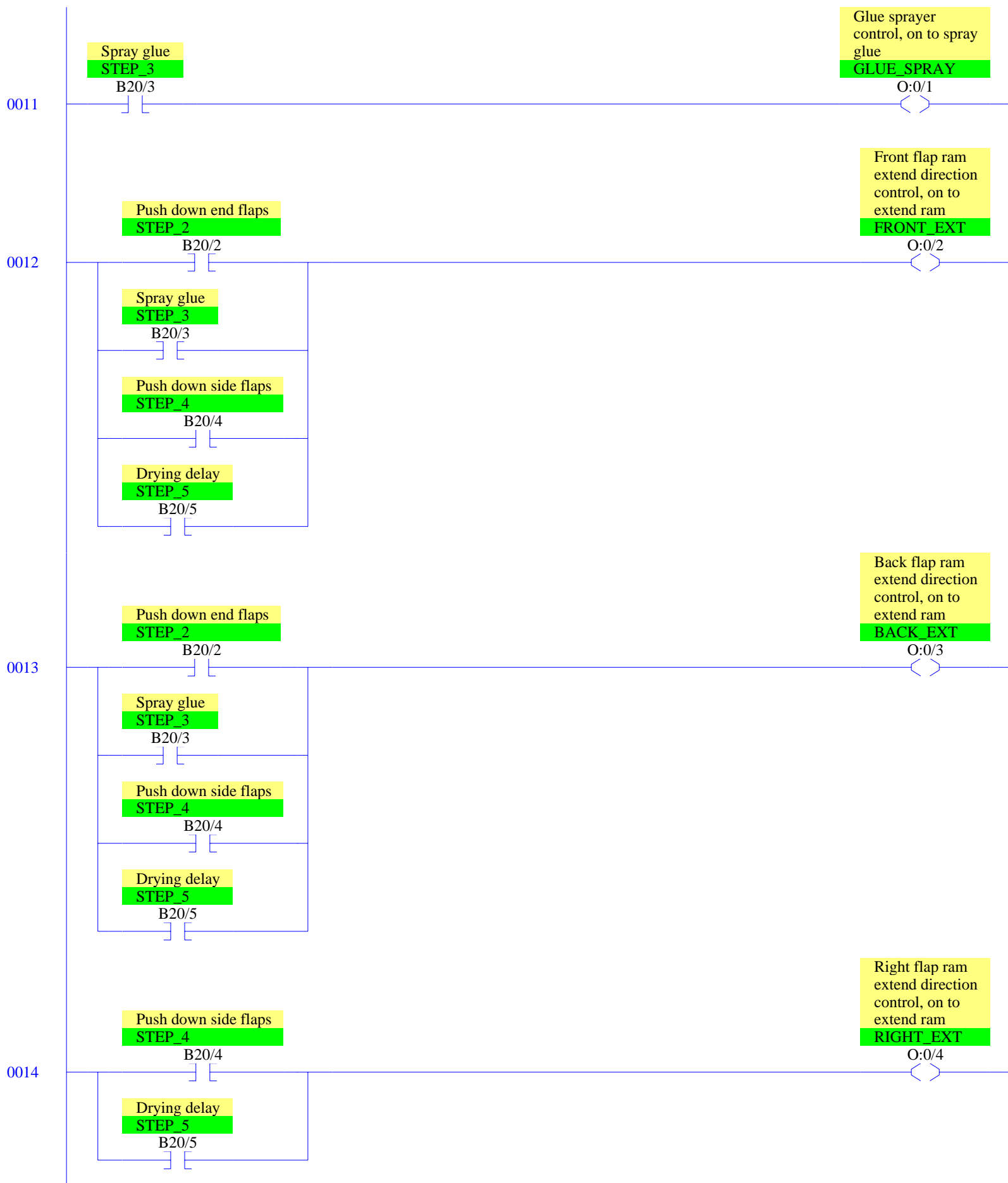


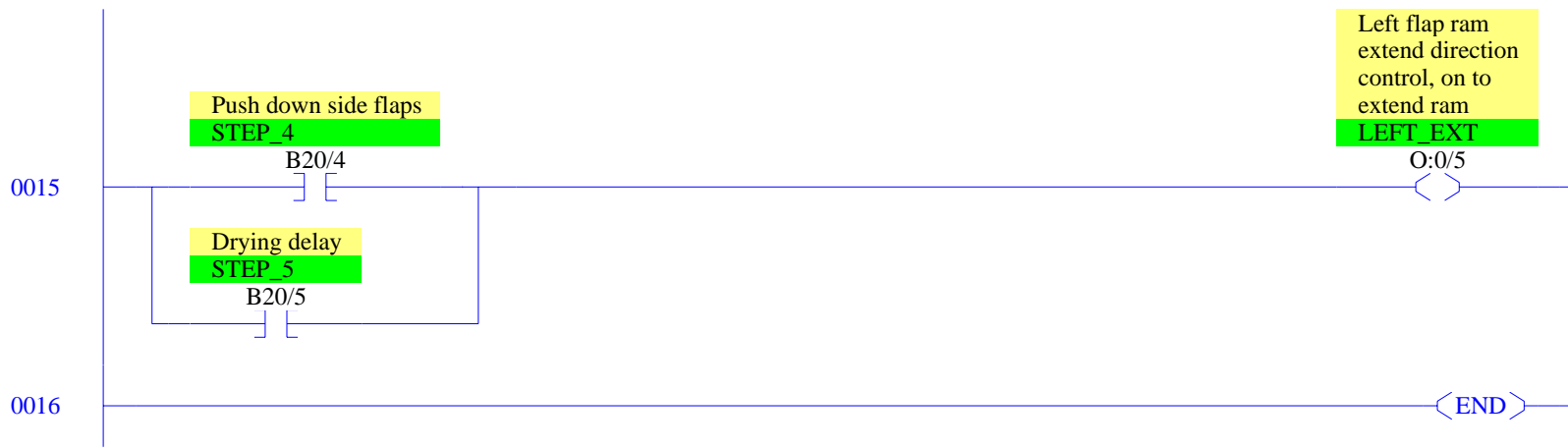
0009



0010







RSLogix 500 Cross Reference Report - Sorted by Address

O:0/0	- {CONV_MOTOR} Conveyor motor control, on to move conveyor OTE - File #2 - 10
O:0/1	- {GLUE_SPRAY} Glue sprayer control, on to spray glue OTE - File #2 - 11
O:0/2	- {FRONT_EXT} Front flap ram extend direction control, on to extend ram OTE - File #2 - 12
O:0/3	- {BACK_EXT} Back flap ram extend direction control, on to extend ram OTE - File #2 - 13
O:0/4	- {RIGHT_EXT} Right flap ram extend direction control, on to extend ram OTE - File #2 - 14
O:0/5	- {LEFT_EXT} Left flap ram extend direction control, on to extend ram OTE - File #2 - 15
I:0/0	- {START_PB} Start push button, on when starting XIC - File #2 - 0
I:0/1	- {STOP_PB} Stop push button, off when stopping XIC - File #2 - 0
I:0/2	- {RESET_PB} Reset push button, on when restoring station to initial condition XIC - File #2 - 9
I:0/3	- {PE1} Photoelectric sensor, off (open) when box is in station XIC - File #2 - 8 XIO - File #2 - 2
I:0/4	- {FRONT_ELS} Front flap ram extended limit switch, on when extended XIC - File #2 - 3
I:0/5	- {BACK_ELS} Back flap ram extended limit switch, on when extended XIC - File #2 - 3
I:0/6	- {RIGHT_ELS} Right flap ram extended limit switch, on when extended XIC - File #2 - 5
I:0/7	- {LEFT_ELS} Left flap ram extended limit switch, on when extended XIC - File #2 - 5
B3/0	- {RUN} Station running OTE - File #2 - 0 XIC - File #2 - 0, 1, 10 XIO - File #2 - 9
B3/1	- {INT_RESET} Reset in progress OTE - File #2 - 9 XIC - File #2 - 9 XIO - File #2 - 0
T4:1	- {SPRAY_TMR} Glue sprayer timer, 1 sec TON - File #2 - 4
T4:1/DN	- XIC - File #2 - 4
T4:2	- {DRY_TMR} Glue dry timer, 5 sec TON - File #2 - 6
T4:2/DN	- XIC - File #2 - 6
T4:3	- {RETRACT_TMR} Ram retract timer, 2 sec TON - File #2 - 7
T4:3/DN	- XIC - File #2 - 7
T4:4	- {RESET_TMR} Reset timer, 2 sec TON - File #2 - 9
T4:4/DN	- XIO - File #2 - 9
B20/1	- {STEP_1} Wait for Box OTL - File #2 - 1, 8 OTU - File #2 - 2, 9 XIC - File #2 - 2, 10 XIO - File #2 - 1
B20/2	- {STEP_2} Push down end flaps OTL - File #2 - 2 OTU - File #2 - 3, 9 XIC - File #2 - 3, 12, 13 XIO - File #2 - 1
B20/3	- {STEP_3} Spray glue OTL - File #2 - 3 OTU - File #2 - 4, 9 XIC - File #2 - 4, 11, 12, 13 XIO - File #2 - 1
B20/4	- {STEP_4} Push down side flaps OTL - File #2 - 4

RSLogix 500 Cross Reference Report - Sorted by Address

	OTU - File #2 - 5, 9
	XIC - File #2 - 5, 12, 13, 14, 15
	XIO - File #2 - 1
B20/5	- {STEP_5} Drying delay
	OTL - File #2 - 5
	OTU - File #2 - 6, 9
	XIC - File #2 - 6, 12, 13, 14, 15
	XIO - File #2 - 1
B20/6	- {STEP_6} Retract rams
	OTL - File #2 - 6
	OTU - File #2 - 7, 9
	XIC - File #2 - 7
	XIO - File #2 - 1
B20/7	- {STEP_7} Move box out
	OTL - File #2 - 7
	OTU - File #2 - 8, 9
	XIC - File #2 - 8, 10
	XIO - File #2 - 1