

## Transfer Station Control

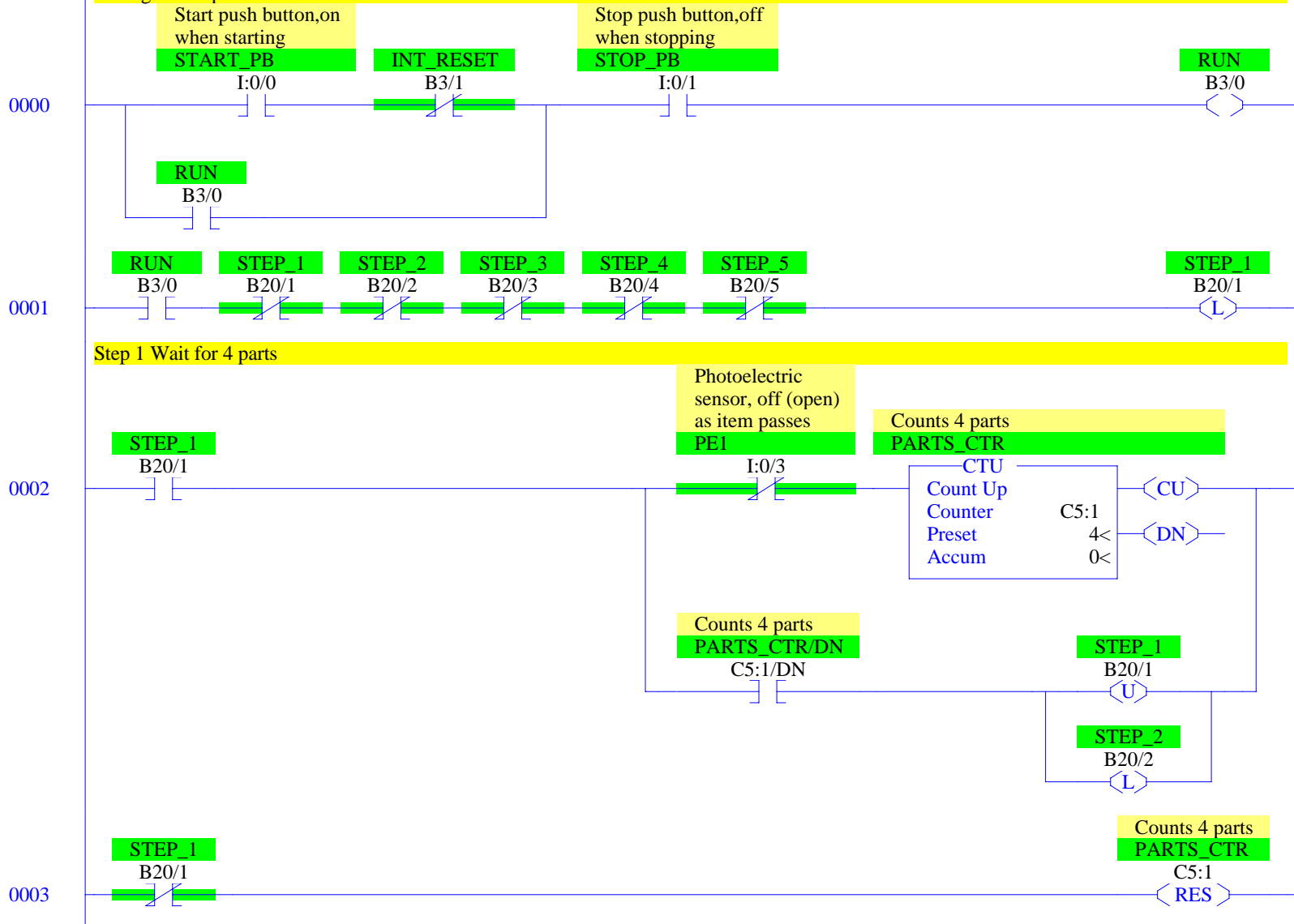
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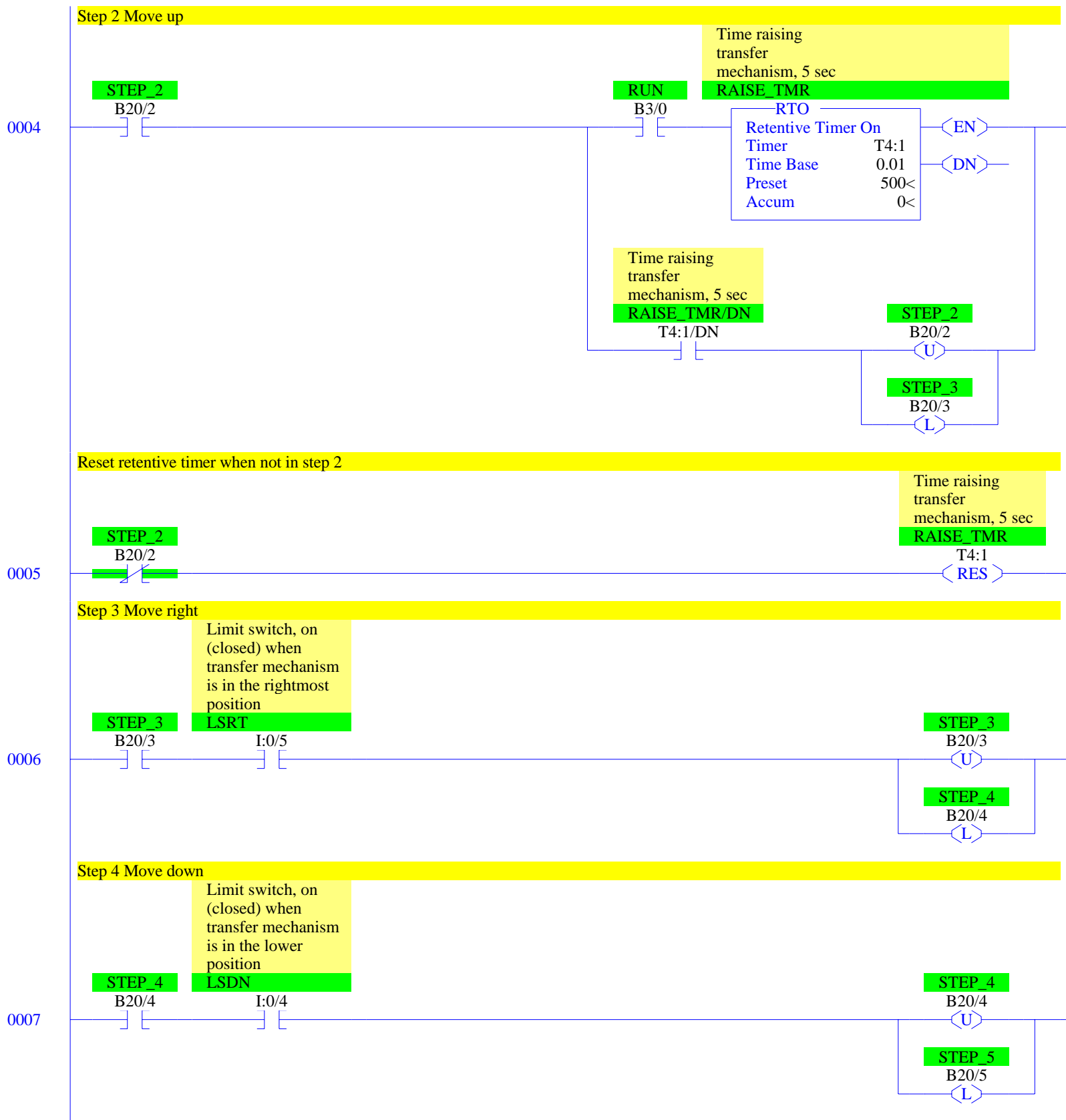
Additional internal memory:

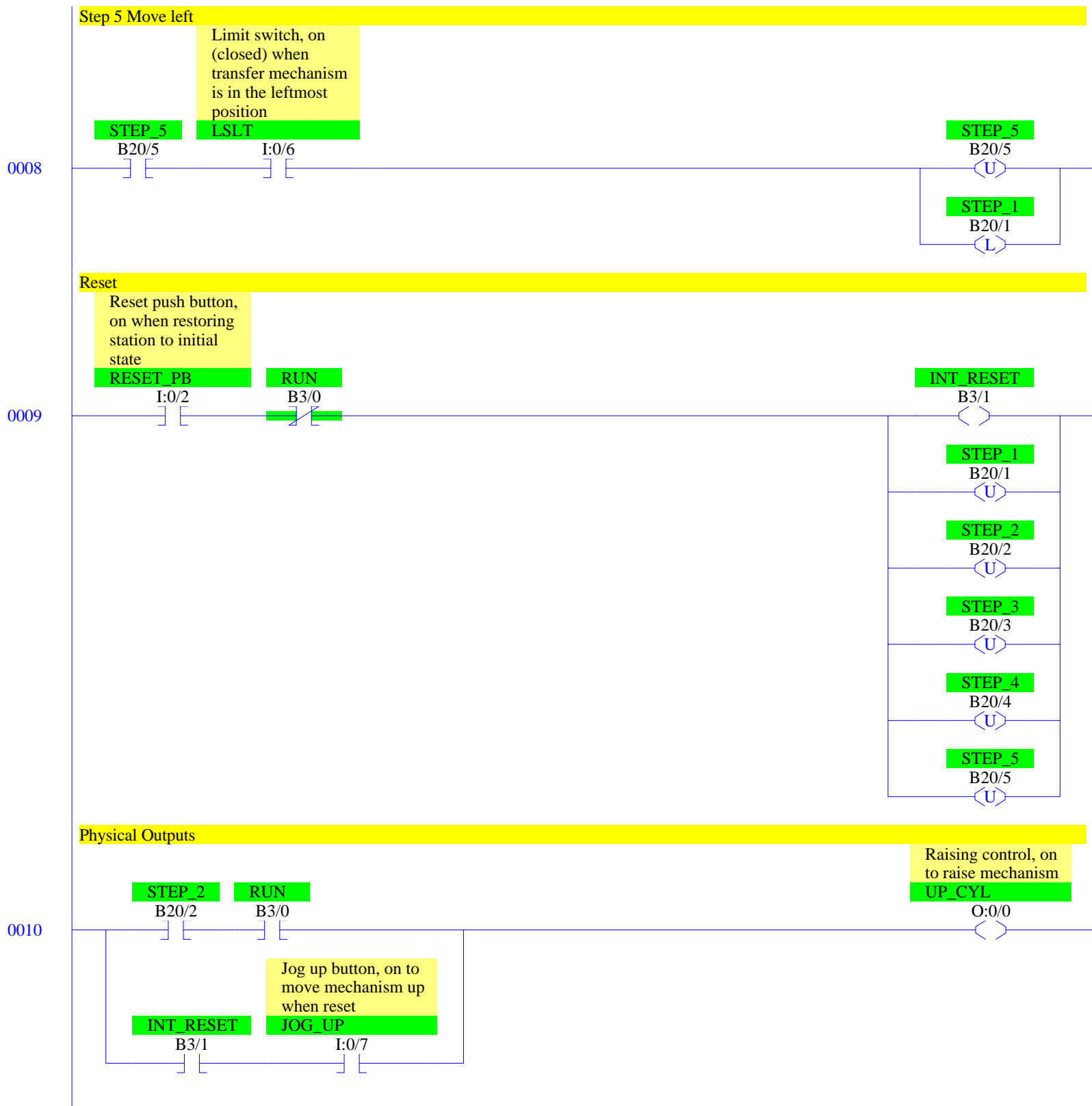
Symbol	Address	
RUN	B3/0	On while station running
INT_RESET	B3/1	Internal reset
STEP_1 to STEP_5	B20/1 to B20/5	Step-in-progress bits
RAISE_TMR	T4:1	Times moving up
PARTS_CTR	C5:1	Counts parts

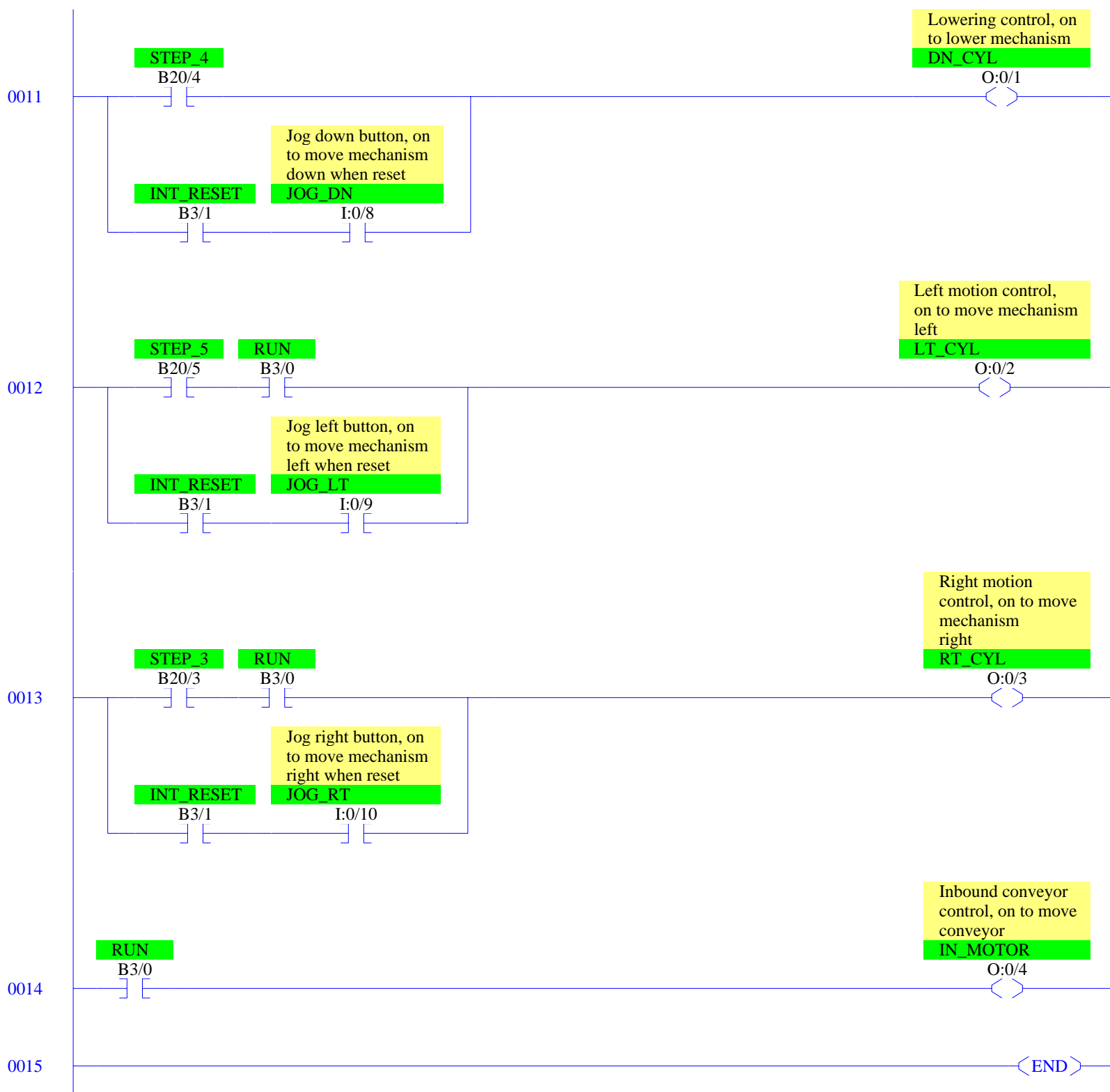
Start/stop and initial start.

During restart prevent start.









## RSLogix 500 Cross Reference Report - Sorted by Address

O:0/0	- {UP_CYL} Raising control, on to raise mechanism OTE - File #2 - 10
O:0/1	- {DN_CYL} Lowering control, on to lower mechanism OTE - File #2 - 11
O:0/2	- {LT_CYL} Left motion control, on to move mechanism left OTE - File #2 - 12
O:0/3	- {RT_CYL} Right motion control, on to move mechanism right OTE - File #2 - 13
O:0/4	- {IN_MOTOR} Inbound conveyor control, on to move conveyor OTE - File #2 - 14
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 state XIC - File #2 - 9
I:0/3	- {PE1} Photoelectric sensor, off (open) as item passes XIO - File #2 - 2
I:0/4	- {LSDN} Limit switch, on (closed) when transfer mechanism is in the lower position XIC - File #2 - 7
I:0/5	- {LSRT} Limit switch, on (closed) when transfer mechanism is in the rightmost position XIC - File #2 - 6
I:0/6	- {LSLT} Limit switch, on (closed) when transfer mechanism is in the leftmost position XIC - File #2 - 8
I:0/7	- {JOG_UP} Jog up button, on to move mechanism up when reset XIC - File #2 - 10
I:0/8	- {JOG_DN} Jog down button, on to move mechanism down when reset XIC - File #2 - 11
I:0/9	- {JOG_LT} Jog left button, on to move mechanism left when reset XIC - File #2 - 12
I:0/10	- {JOG_RT} Jog right button, on to move mechanism right when reset XIC - File #2 - 13
B3/0	- {RUN} OTE - File #2 - 0 XIC - File #2 - 0, 1, 4, 10, 12, 13, 14 XIO - File #2 - 9
B3/1	- {INT_RESET} OTE - File #2 - 9 XIC - File #2 - 10, 11, 12, 13 XIO - File #2 - 0
T4:1	- {RAISE_TMR} Time raising transfer mechanism, 5 sec RTO - File #2 - 4 RES - File #2 - 5
T4:1/DN	- XIC - File #2 - 4
C5:1	- {PARTS_CTR} Counts 4 parts CTU - File #2 - 2 RES - File #2 - 3
C5:1/DN	- XIC - File #2 - 2
B20/1	- {STEP_1} OTL - File #2 - 1, 8 OTU - File #2 - 2, 9 XIC - File #2 - 2 XIO - File #2 - 1, 3
B20/2	- {STEP_2} OTL - File #2 - 2 OTU - File #2 - 4, 9 XIC - File #2 - 4, 10 XIO - File #2 - 1, 5
B20/3	- {STEP_3} OTL - File #2 - 4 OTU - File #2 - 6, 9 XIC - File #2 - 6, 13 XIO - File #2 - 1
B20/4	- {STEP_4} OTL - File #2 - 6 OTU - File #2 - 7, 9

RSLogix 500 Cross Reference Report - Sorted by Address

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B20/5	XIC - File #2 - 7, 11
	XIO - File #2 - 1
	- {STEP_5}
	OTL - File #2 - 7
	OTU - File #2 - 8, 9
	XIC - File #2 - 8, 12
	XIO - File #2 - 1