

Stamping Station Control

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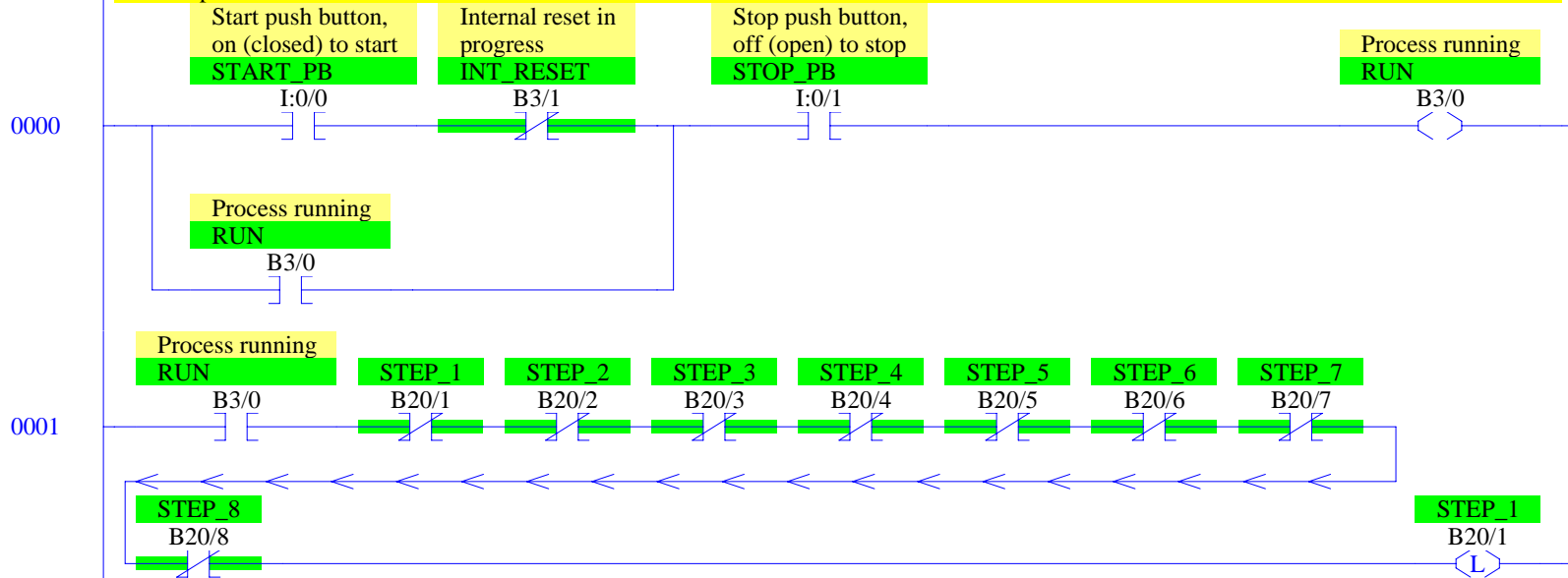
Additional internal memory:

Symbol	Address	
RUN	B3/0	On while station running
INT_RESET	B3/1	Internal reset
STEP_1 to STEP_8	B20/1 to B20/8	Step-in-progress bits
RAM_UP_TMR	T4:1	Times raising of stamp head
RETRACT_TMR	T4:2	Times retract of PCYL2
RST_TMR	T4:3	Times raising of stamp head when reset

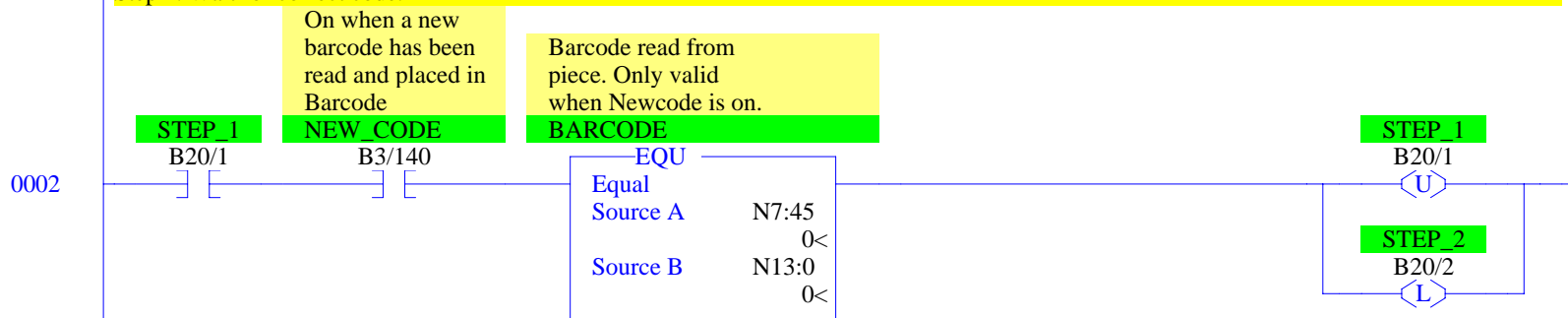
Conversion formula

$$PT214_VAL = ((PT214_MEAS - 6241) / 24965) * (3000) + 2000$$

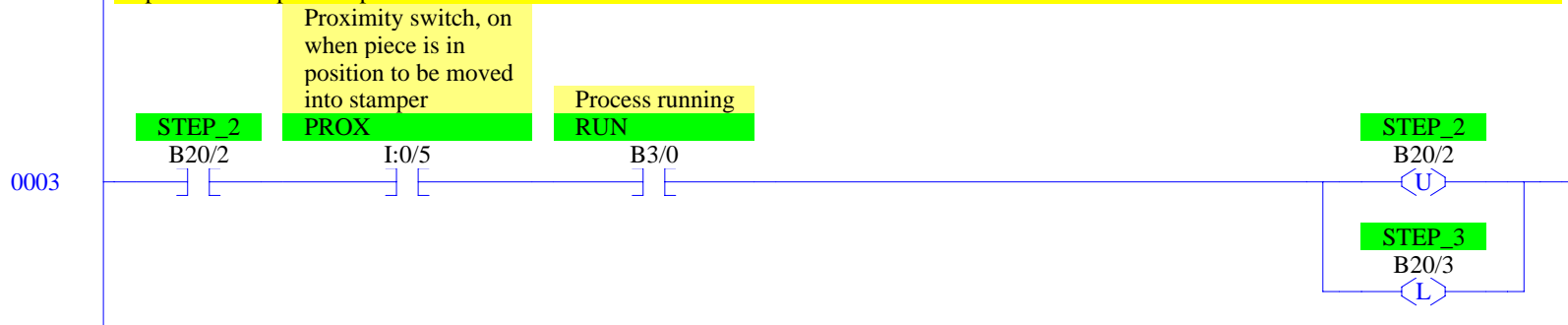
Start/Stop. Initial start

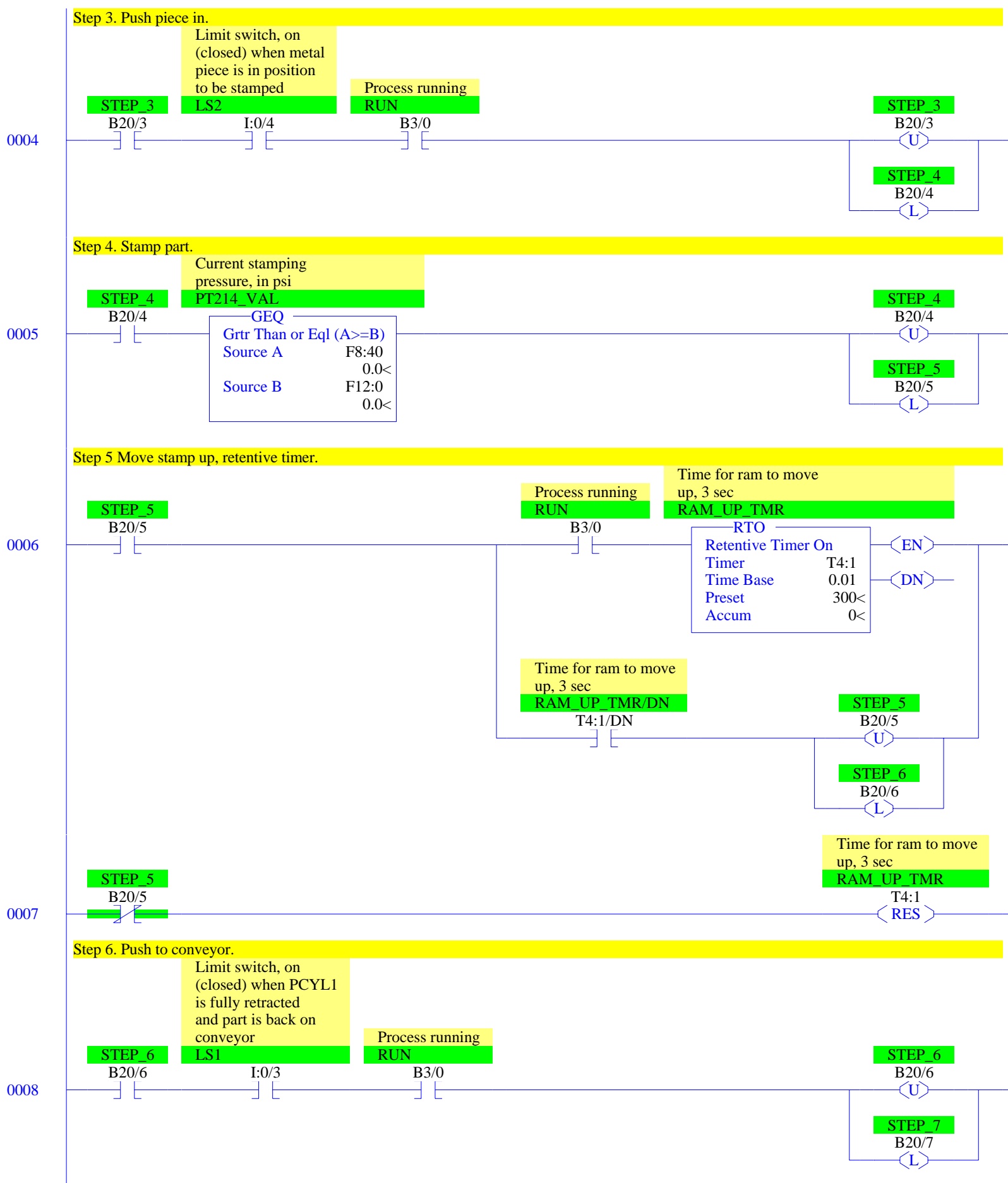


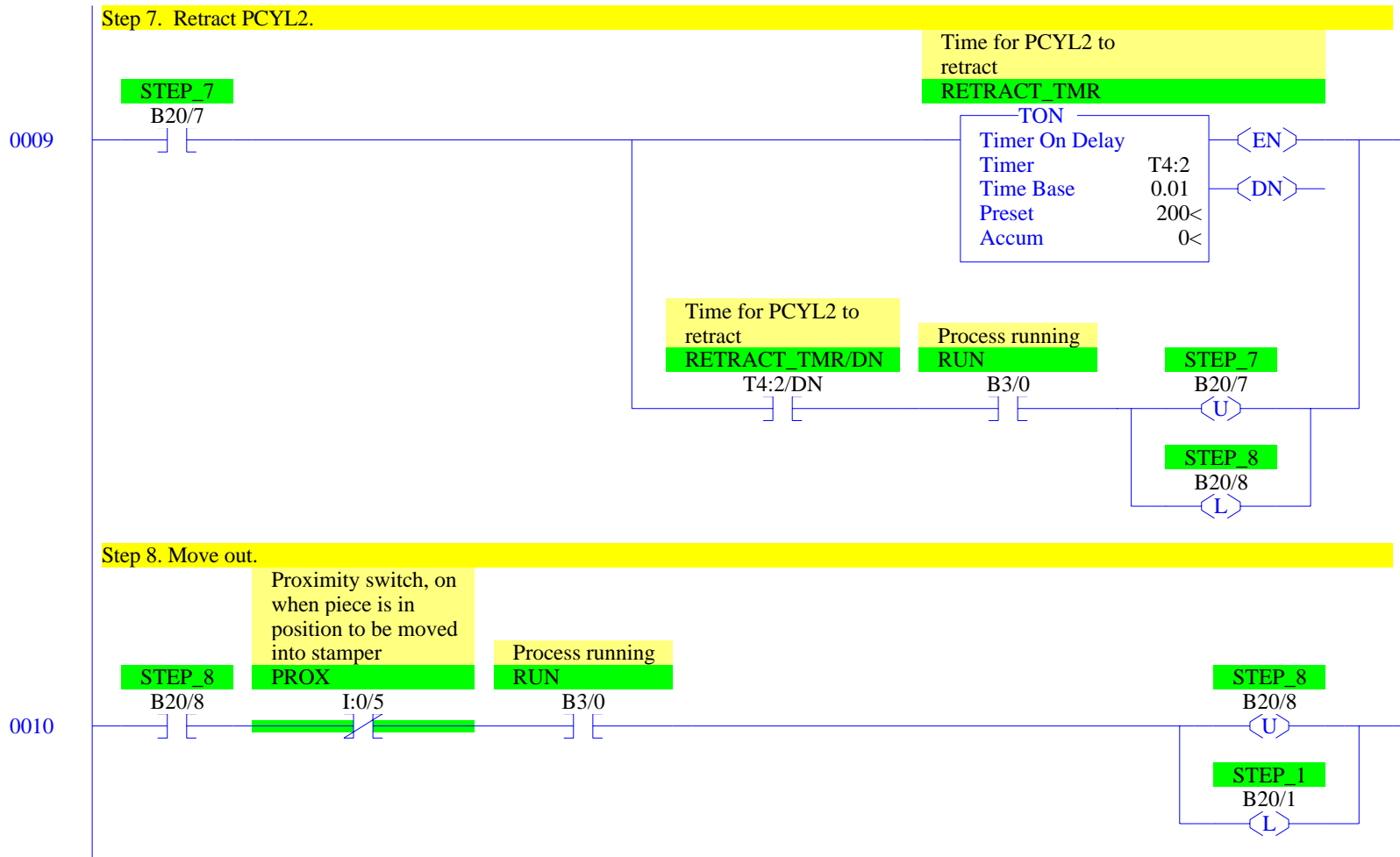
Step 1. Wait for correct code.



Step 2. Wait for piece in position.







Measurement Conversion

0011

SUB

Subtract	
Source A	I:1.0
	0<
Source B	6241.0
	6241.0<
Dest	F8:0
	0.0<

DIV

Divide	
Source A	F8:0
	0.0<
Source B	24965.0
	24965.0<
Dest	F8:0
	0.0<

MUL

Multiply	
Source A	F8:0
	0.0<
Source B	3000.0
	3000.0<
Dest	F8:0
	0.0<

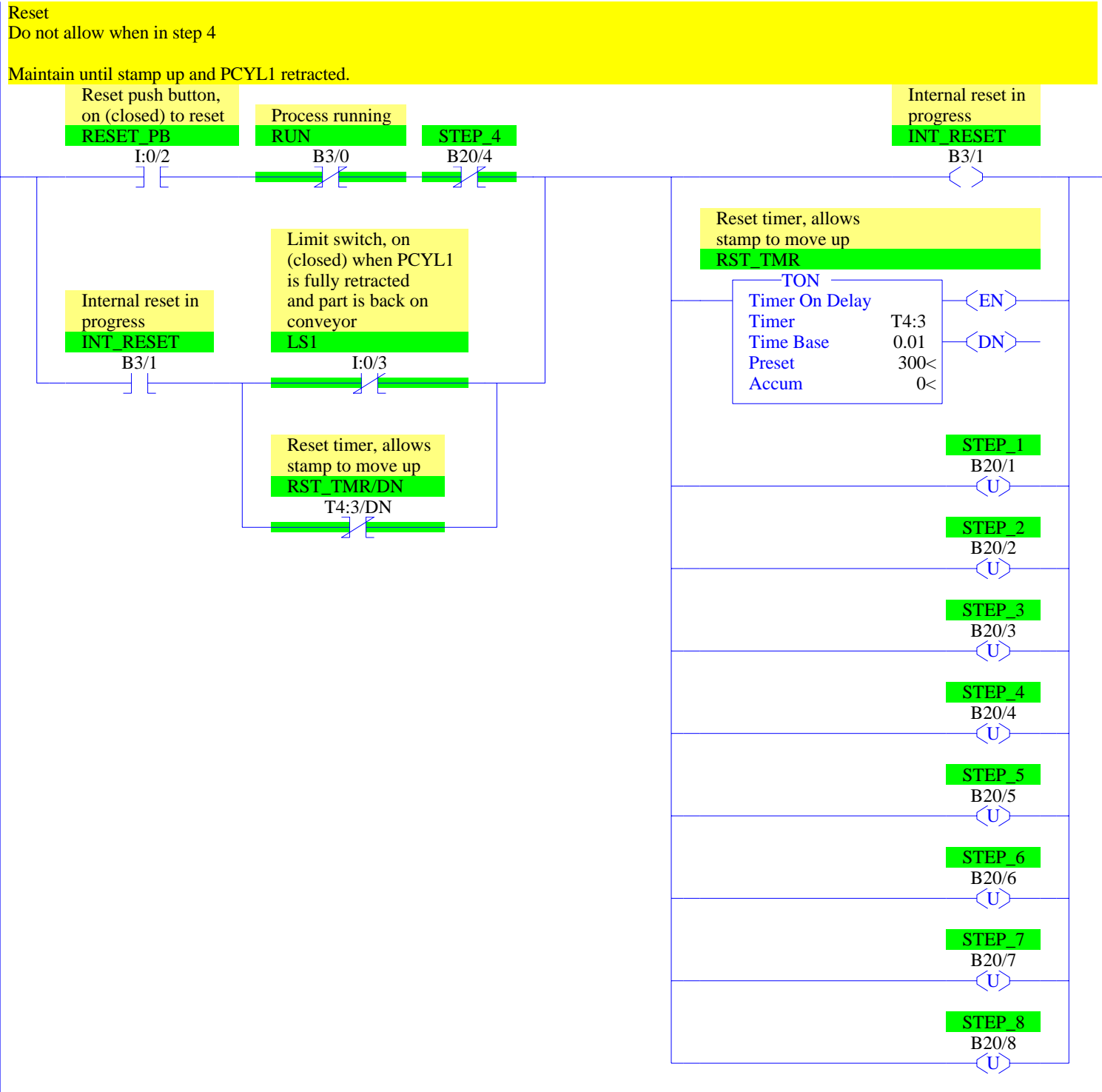
Current stamping
pressure, in psi

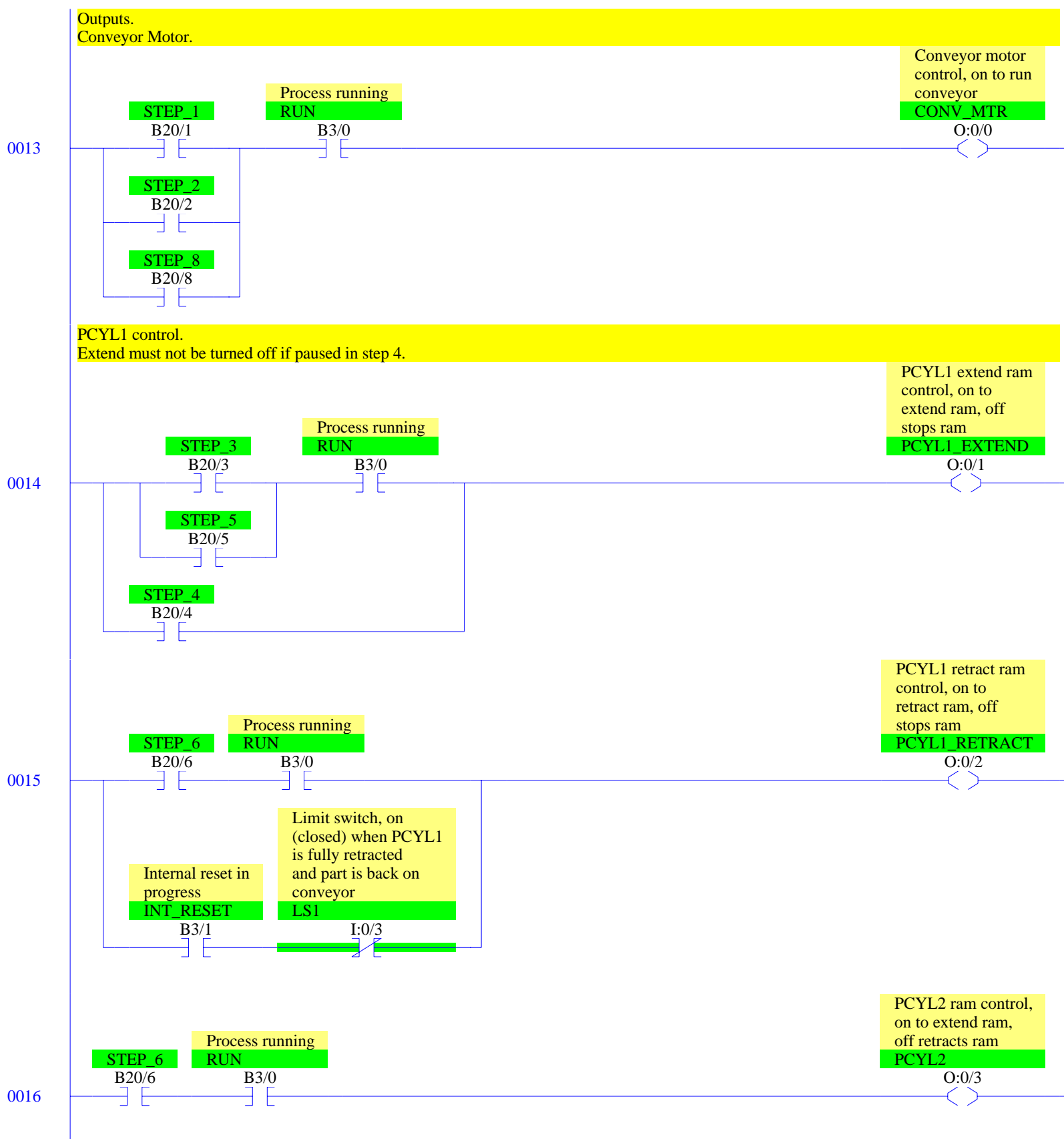
PT214_VAL

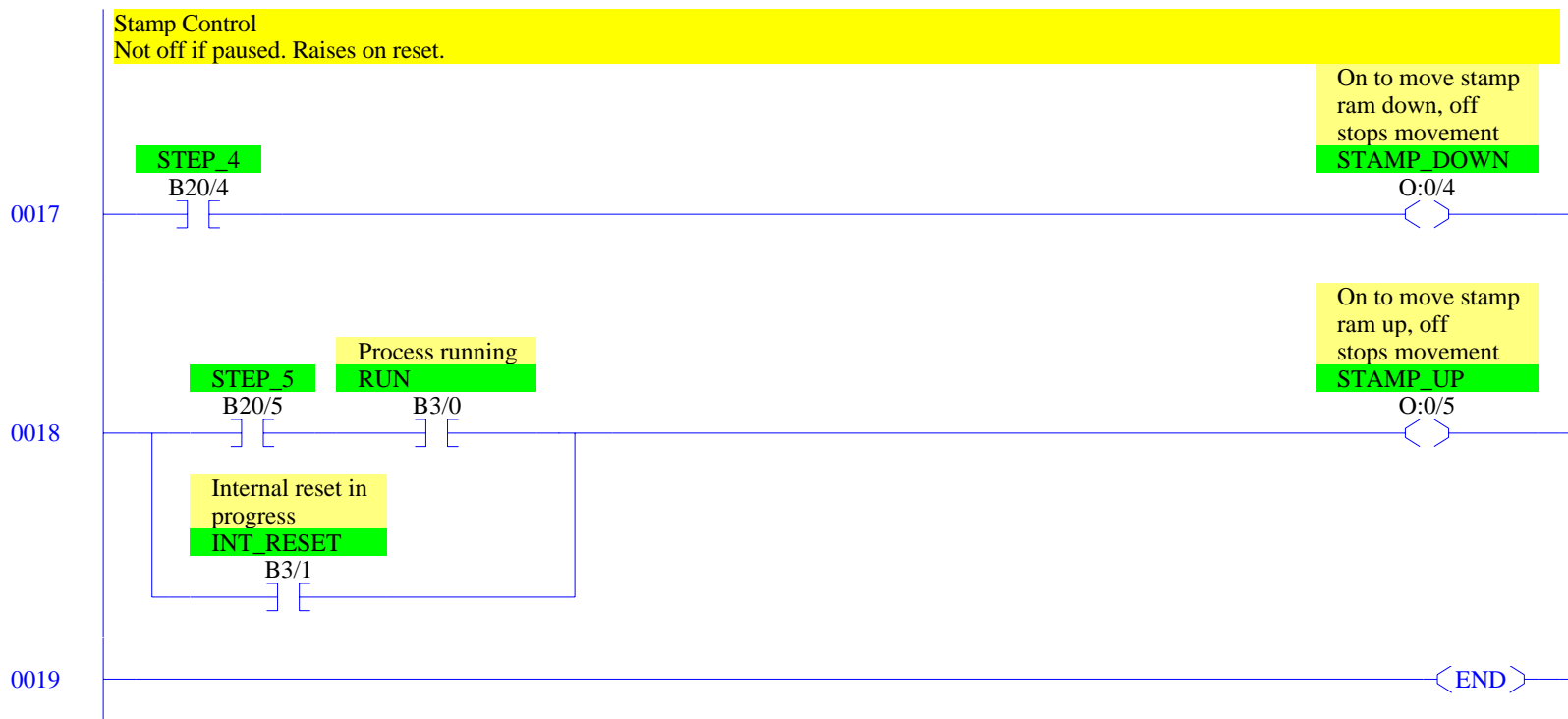
ADD

Add	
Source A	F8:0
	0.0<
Source B	2000.0
	2000.0<
Dest	F8:40
	0.0<

0012







RSLogix 500 Cross Reference Report - Sorted by Address

O:0/0	- {CONV_MTR} Conveyor motor control, on to run conveyor OTE - File #2 - 13
O:0/1	- {PCYL1_EXTEND} PCYL1 extend ram control, on to extend ram, off stops ram OTE - File #2 - 14
O:0/2	- {PCYL1_RETRACT} PCYL1 retract ram control, on to retract ram, off stops ram OTE - File #2 - 15
O:0/3	- {PCYL2} PCYL2 ram control, on to extend ram, off retracts ram OTE - File #2 - 16
O:0/4	- {STAMP_DOWN} On to move stamp ram down, off stops movement OTE - File #2 - 17
O:0/5	- {STAMP_UP} On to move stamp ram up, off stops movement OTE - File #2 - 18
I:0/0	- {START_PB} Start push button, on (closed) to start XIC - File #2 - 0
I:0/1	- {STOP_PB} Stop push button, off (open) to stop XIC - File #2 - 0
I:0/2	- {RESET_PB} Reset push button, on (closed) to reset XIC - File #2 - 12
I:0/3	- {LS1} Limit switch, on (closed) when PCYL1 is fully retracted and part is back on conveyor XIC - File #2 - 8 XIO - File #2 - 12, 15
I:0/4	- {LS2} Limit switch, on (closed) when metal piece is in position to be stamped XIC - File #2 - 4
I:0/5	- {PROX} Proximity switch, on when piece is in position to be moved into stamper XIC - File #2 - 3 XIO - File #2 - 10
I:1.0	- SUB - File #2 - 11
B3/0	- {RUN} Process running OTE - File #2 - 0 XIC - File #2 - 0, 1, 3, 4, 6, 8, 9, 10, 13, 14, 15, 16, 18 XIO - File #2 - 12
B3/1	- {INT_RESET} Internal reset in progress OTE - File #2 - 12 XIC - File #2 - 12, 15, 18 XIO - File #2 - 0
B3/140	- {NEW_CODE} On when a new barcode has been read and placed in Barcode XIC - File #2 - 2
T4:1	- {RAM_UP_TMR} Time for ram to move up, 3 sec RTO - File #2 - 6 RES - File #2 - 7
T4:1/DN	- XIC - File #2 - 6
T4:2	- {RETRACT_TMR} Time for PCYL2 to retract TON - File #2 - 9
T4:2/DN	- XIC - File #2 - 9
T4:3	- {RST_TMR} Reset timer, allows stamp to move up TON - File #2 - 12
T4:3/DN	- XIO - File #2 - 12
N7:45	- {BARCODE} Barcode read from piece. Only valid when Newcode is on. EQU - File #2 - 2
F8:0	- ADD - File #2 - 11 SUB - File #2 - 11 MUL - File #2 - 11 DIV - File #2 - 11
F8:40	- {PT214_VAL} Current stamping pressure, in psi ADD - File #2 - 11 GEQ - File #2 - 5
F12:0	- {DES_PRESS} Desired stamping ram pressure, in psi GEQ - File #2 - 5
N13:0	- {DES_BARCODE} Barcode of those parts that are to be stamped EQU - File #2 - 2
B20/1	- {STEP_1} OTL - File #2 - 1, 10 OTU - File #2 - 2, 12 XIC - File #2 - 2, 13 XIO - File #2 - 1
B20/2	- {STEP_2}

RSLogix 500 Cross Reference Report - Sorted by Address

	OTL - File #2 - 2
	OTU - File #2 - 3, 12
	XIC - File #2 - 3, 13
	XIO - File #2 - 1
B20/3	- {STEP_3}
	OTL - File #2 - 3
	OTU - File #2 - 4, 12
	XIC - File #2 - 4, 14
	XIO - File #2 - 1
B20/4	- {STEP_4}
	OTL - File #2 - 4
	OTU - File #2 - 5, 12
	XIC - File #2 - 5, 14, 17
	XIO - File #2 - 1, 12
B20/5	- {STEP_5}
	OTL - File #2 - 5
	OTU - File #2 - 6, 12
	XIC - File #2 - 6, 14, 18
	XIO - File #2 - 1, 7
B20/6	- {STEP_6}
	OTL - File #2 - 6
	OTU - File #2 - 8, 12
	XIC - File #2 - 8, 15, 16
	XIO - File #2 - 1
B20/7	- {STEP_7}
	OTL - File #2 - 8
	OTU - File #2 - 9, 12
	XIC - File #2 - 9
	XIO - File #2 - 1
B20/8	- {STEP_8}
	OTL - File #2 - 9
	OTU - File #2 - 10, 12
	XIC - File #2 - 10, 13
	XIO - File #2 - 1