

## Part Oiler Station Control

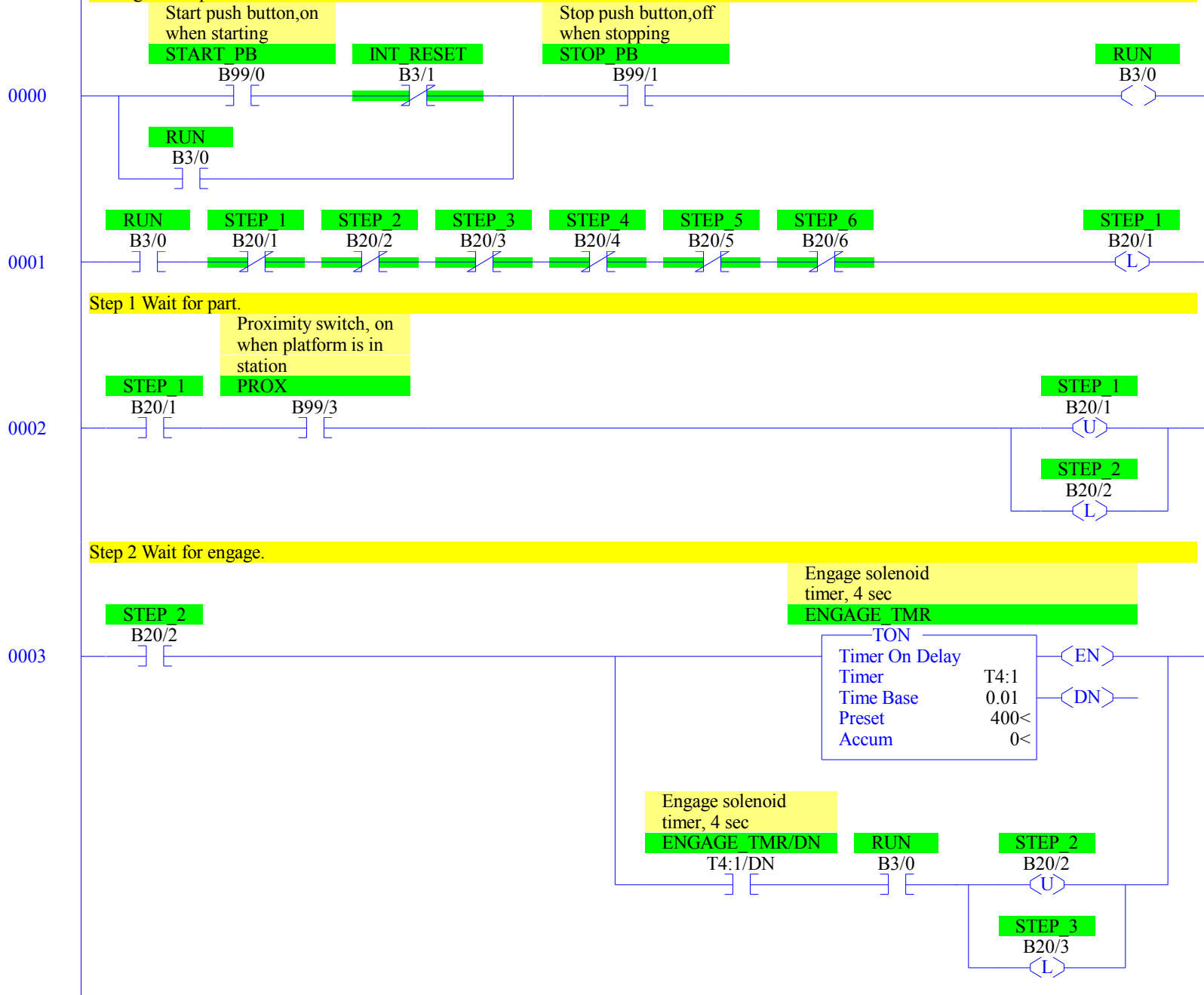
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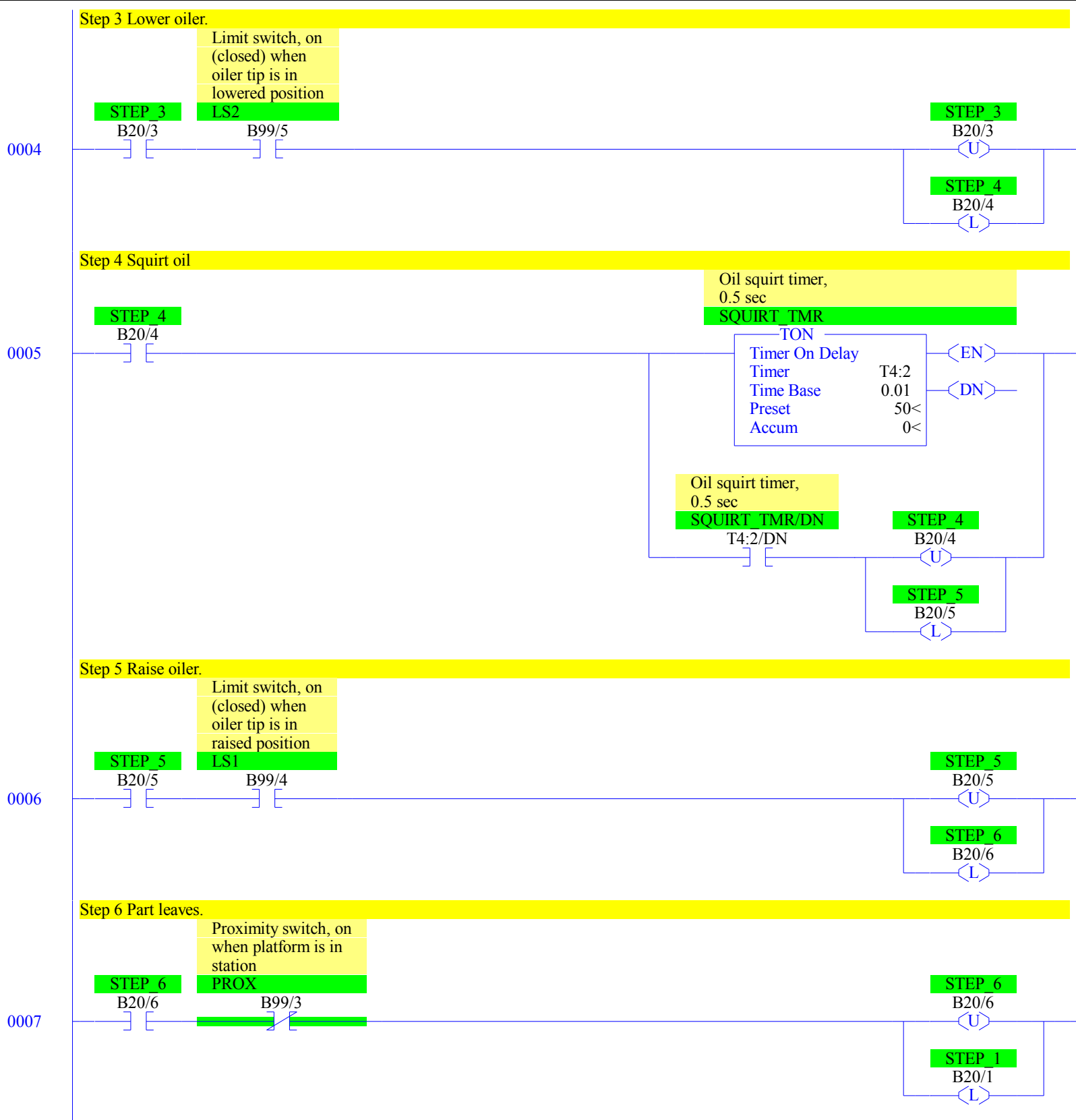
Additional internal memory:

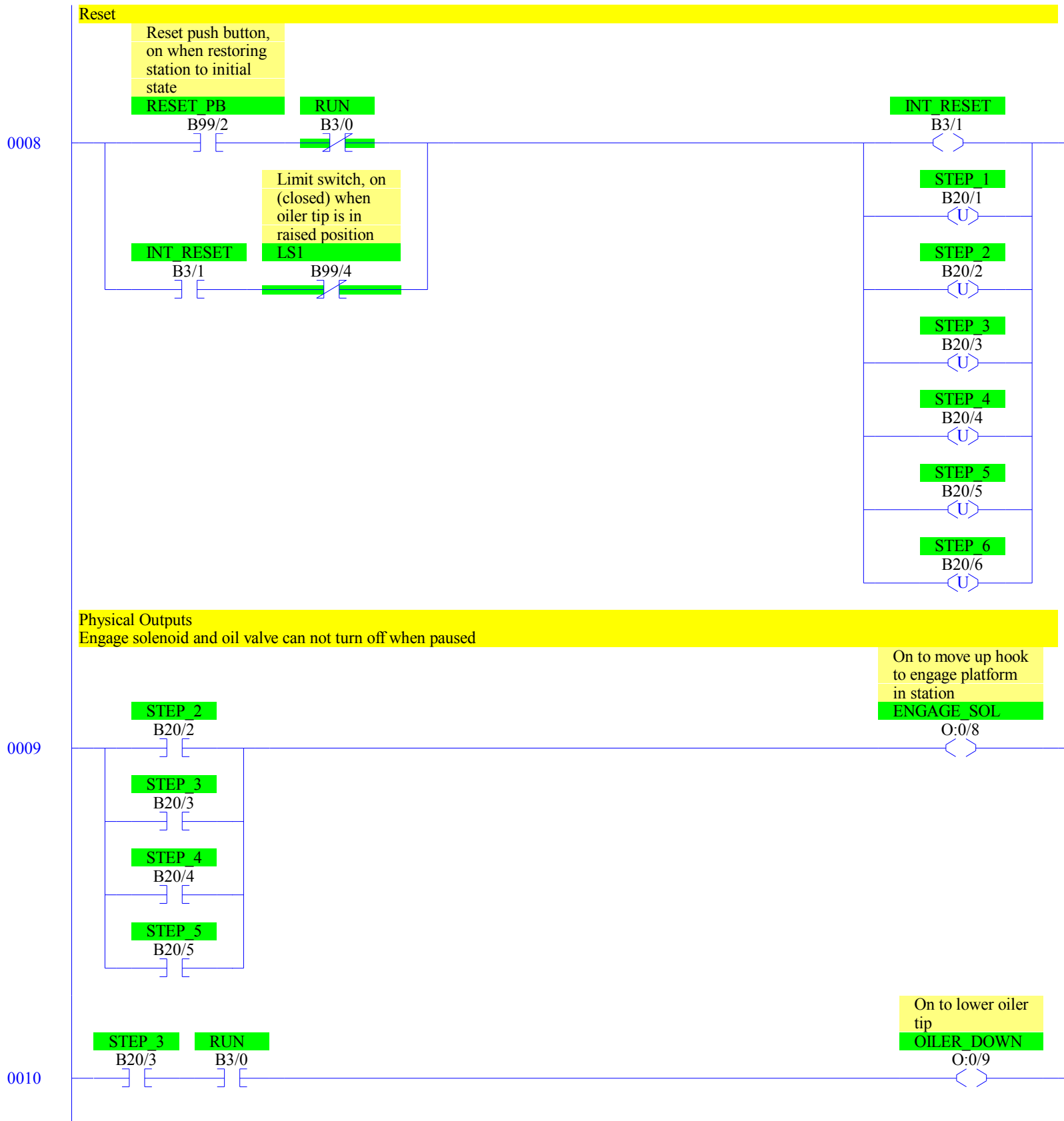
Symbol	Address	
RUN	B3/0	On while station running
INT_RESET	B3/1	Internal reset
STEP_1 to STEP_6	B20/1 to B20/6	Step-in-progress bits
ENGAGE_TMR	T4:1	Delay to capture engine
SQUIRT_TMR	T4:2	Times squirt of oil

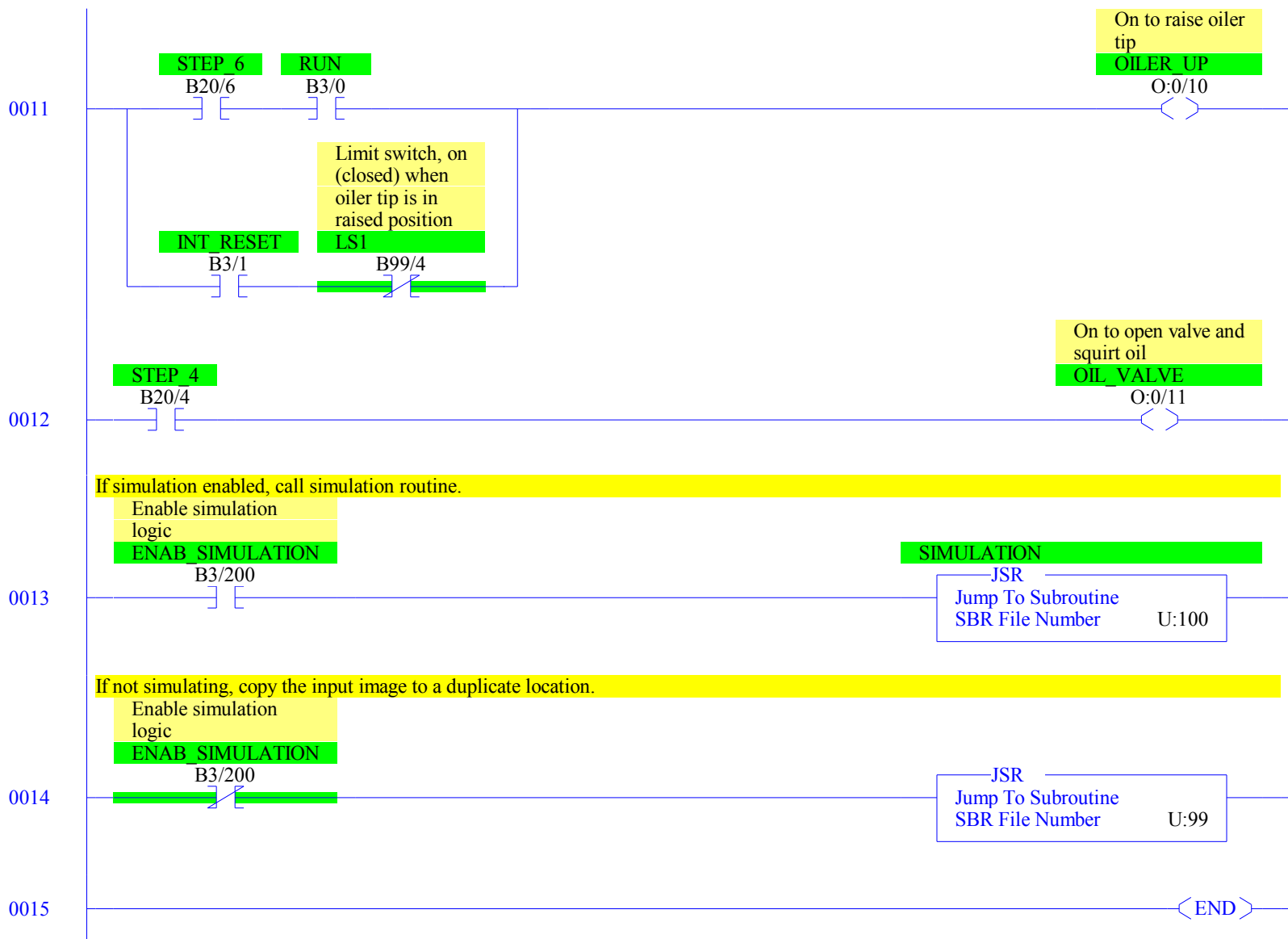
Start/stop and initial start.

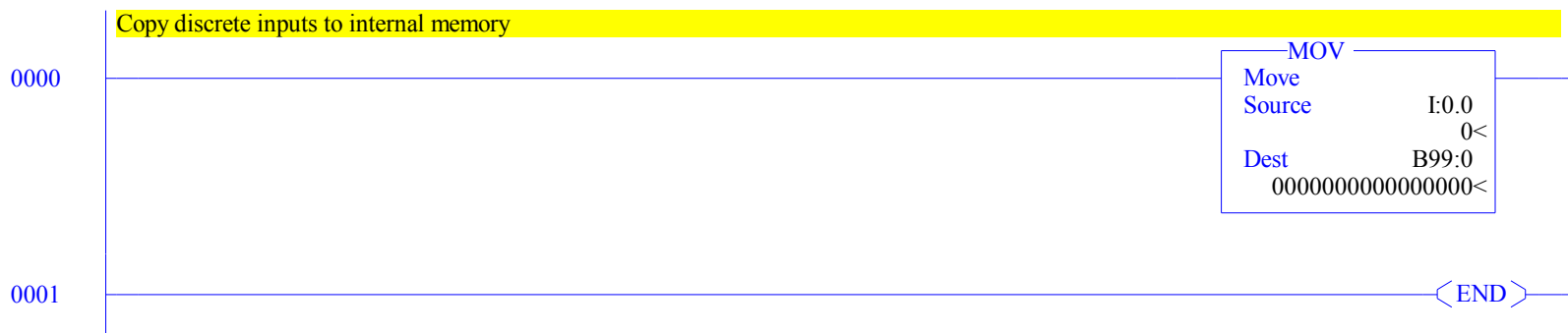
During restart prevent start.

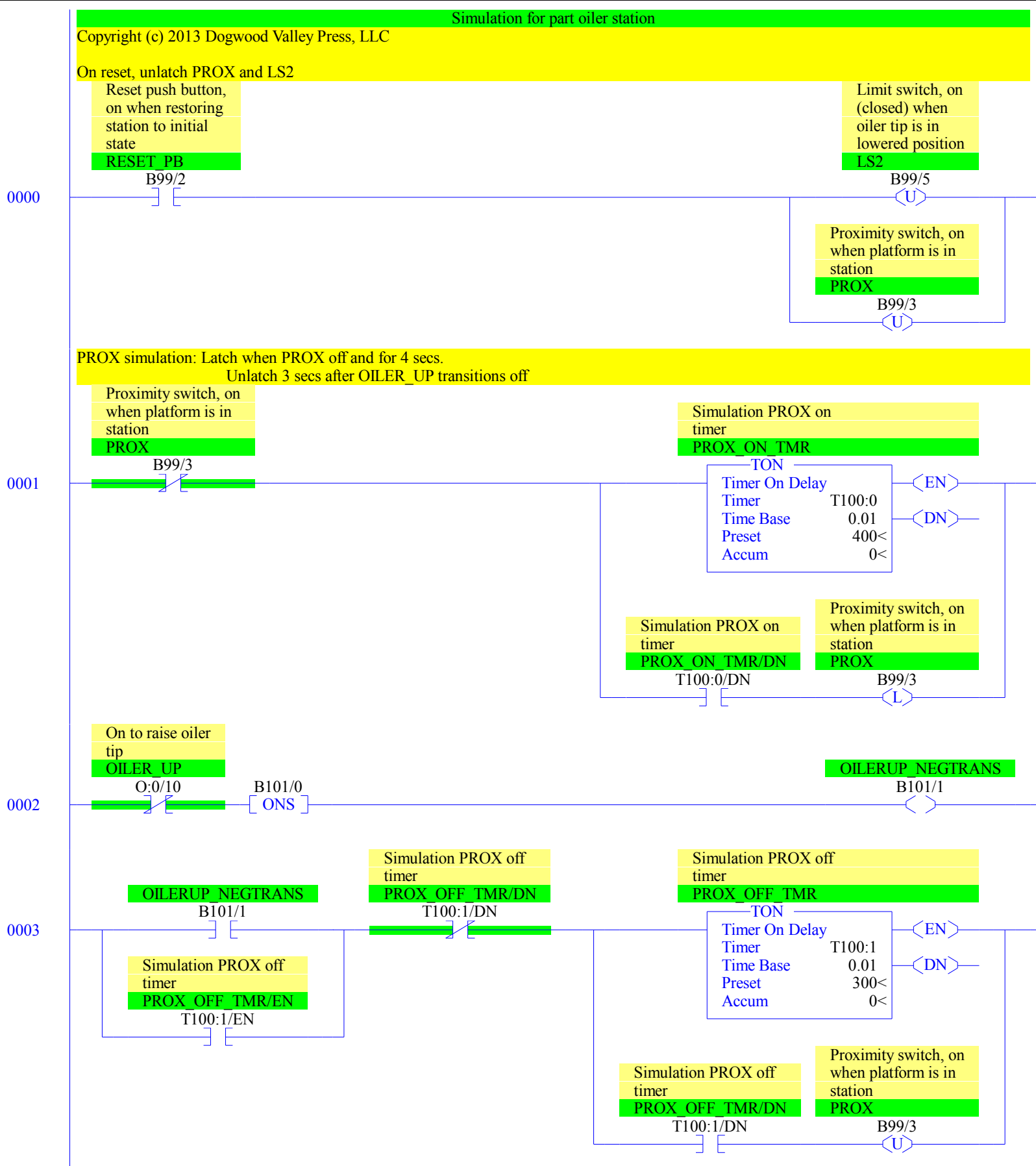


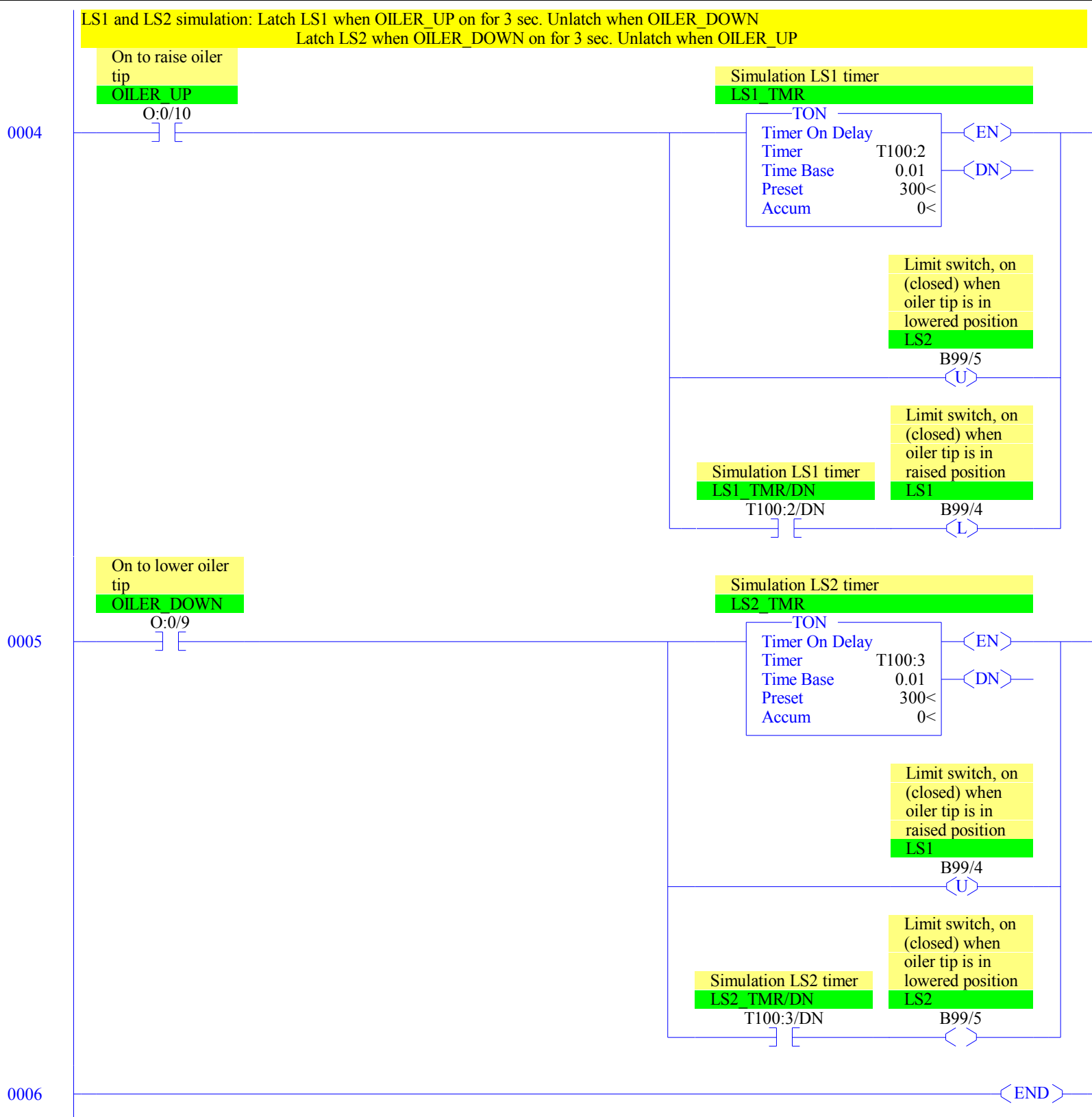












## RSLogix 500 Cross Reference Report - Sorted by Address

O:0/8	- {ENGAGE_SOL} On to move up hook to engage platform in station
	OTE - File #2 - 9
O:0/9	- {OILER_DOWN} On to lower oiler tip
	OTE - File #2 - 10
	XIC - File #100 SIMULATE - 5
O:0/10	- {OILER_UP} On to raise oiler tip
	OTE - File #2 - 11
	XIC - File #100 SIMULATE - 4
	XIO - File #100 SIMULATE - 2
O:0/11	- {OIL_VALVE} On to open valve and squirt oil
	OTE - File #2 - 12
I:0.0	- MOV - File #99 DUPLIC_INS - 0
B3/0	- {RUN}
	OTE - File #2 - 0
	XIC - File #2 - 0, 1, 3, 10, 11
	XIO - File #2 - 8
B3/1	- {INT_RESET}
	OTE - File #2 - 8
	XIC - File #2 - 8, 11
	XIO - File #2 - 0
B3/200	- {ENAB_SIMULATION} Enable simulation logic
	XIC - File #2 - 13
	XIO - File #2 - 14
T4:1	- {ENGAGE_TMR} Engage solenoid timer, 4 sec
	TON - File #2 - 3
T4:1/DN	- XIC - File #2 - 3
T4:2	- {SQUIRT_TMR} Oil squirt timer, 0.5 sec
	TON - File #2 - 5
T4:2/DN	- XIC - File #2 - 5
B20/1	- {STEP_1}
	OTL - File #2 - 1, 7
	OTU - File #2 - 2, 8
	XIC - File #2 - 2
	XIO - File #2 - 1
B20/2	- {STEP_2}
	OTL - File #2 - 2
	OTU - File #2 - 3, 8
	XIC - File #2 - 3, 9
	XIO - File #2 - 1
B20/3	- {STEP_3}
	OTL - File #2 - 3
	OTU - File #2 - 4, 8
	XIC - File #2 - 4, 9, 10
	XIO - File #2 - 1
B20/4	- {STEP_4}
	OTL - File #2 - 4
	OTU - File #2 - 5, 8
	XIC - File #2 - 5, 9, 12
	XIO - File #2 - 1
B20/5	- {STEP_5}
	OTL - File #2 - 5
	OTU - File #2 - 6, 8
	XIC - File #2 - 6, 9
	XIO - File #2 - 1
B20/6	- {STEP_6}
	OTL - File #2 - 6
	OTU - File #2 - 7, 8
	XIC - File #2 - 7, 11
	XIO - File #2 - 1
B99:0	- MOV - File #99 DUPLIC_INS - 0
B99/0	- {START_PB} Start push button, on when starting
	XIC - File #2 - 0
B99/1	- {STOP_PB} Stop push button, off when stopping
	XIC - File #2 - 0
B99/2	- {RESET_PB} Reset push button, on when restoring station to



## RSLogix 500 Cross Reference Report - Sorted by Address

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        initial state
        XIC - File #2 - 8
        File #100 SIMULATE - 0
B99/3    - {PROX} Proximity switch, on when platform is in station
        OTL - File #100 SIMULATE - 1
        OTU - File #100 SIMULATE - 0, 3
        XIC - File #2 - 2
        XIO - File #2 - 7
        File #100 SIMULATE - 1
B99/4    - {LS1} Limit switch, on (closed) when oiler tip is in raised
        position
        OTL - File #100 SIMULATE - 4
        OTU - File #100 SIMULATE - 5
        XIC - File #2 - 6
        XIO - File #2 - 8, 11
B99/5    - {LS2} Limit switch, on (closed) when oiler tip is in lowered
        position
        OTE - File #100 SIMULATE - 5
        OTU - File #100 SIMULATE - 0, 4
        XIC - File #2 - 4
T100:0   - {PROX_ON_TMR} Simulation PROX on timer
        TON - File #100 SIMULATE - 1
T100:0/DN - XIC - File #100 SIMULATE - 1
T100:1   - {PROX_OFF_TMR} Simulation PROX off timer
        TON - File #100 SIMULATE - 3
T100:1/DN - XIC - File #100 SIMULATE - 3
        XIO - File #100 SIMULATE - 3
T100:1/EN - XIC - File #100 SIMULATE - 3
T100:2   - {LS1_TMR} Simulation LS1 timer
        TON - File #100 SIMULATE - 4
T100:2/DN - XIC - File #100 SIMULATE - 4
T100:3   - {LS2_TMR} Simulation LS2 timer
        TON - File #100 SIMULATE - 5
T100:3/DN - XIC - File #100 SIMULATE - 5
B101/0   - ONS - File #100 SIMULATE - 2
B101/1   - {OILERUP_NEGTRANS}
        OTE - File #100 SIMULATE - 2
        XIC - File #100 SIMULATE - 3
U:99     - JSR - File #2 - 14
U:100    - {SIMULATION}
        JSR - File #2 - 13

```