

## Part Oiler Station Control - With Simulation

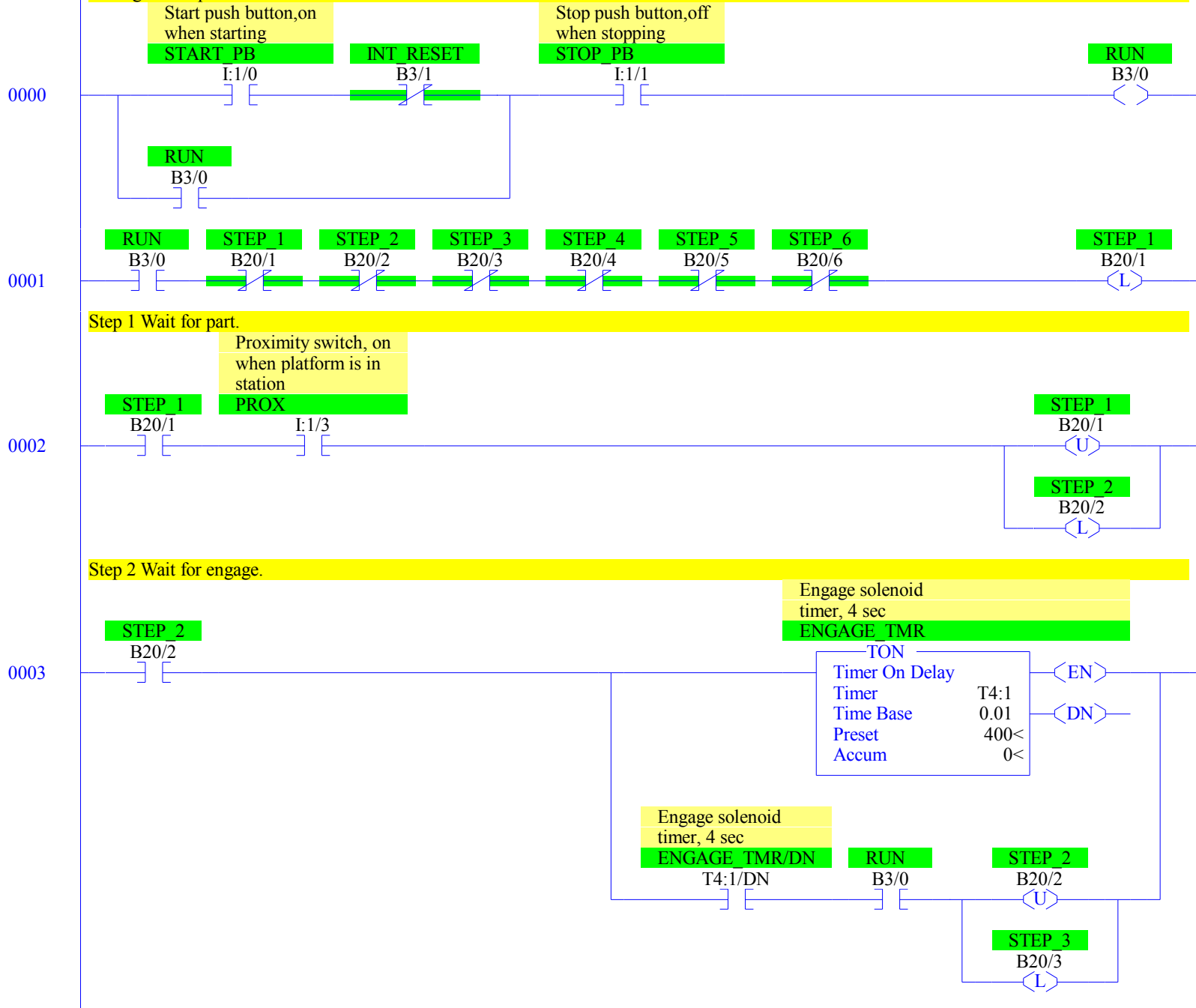
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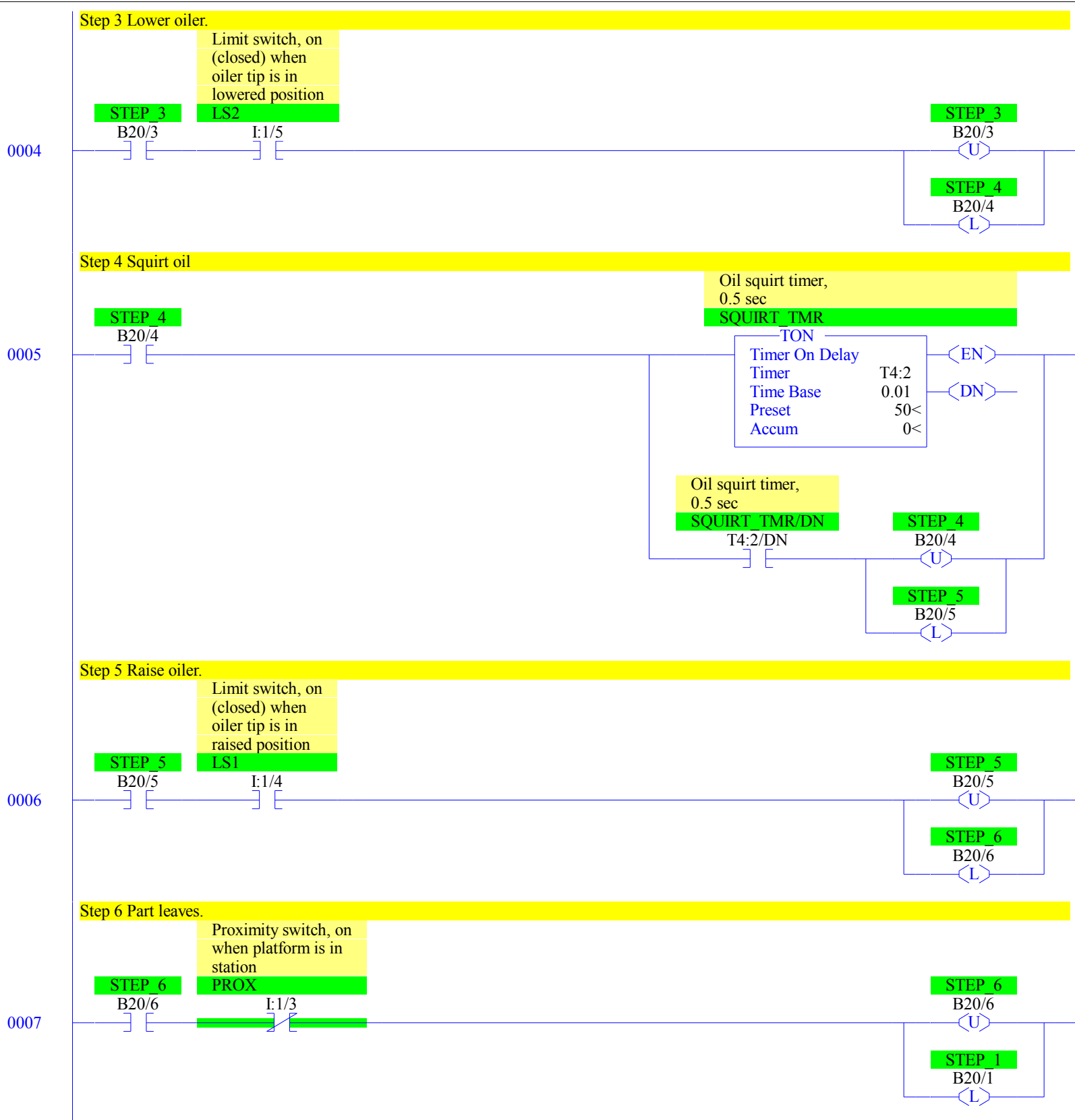
Additional internal memory:

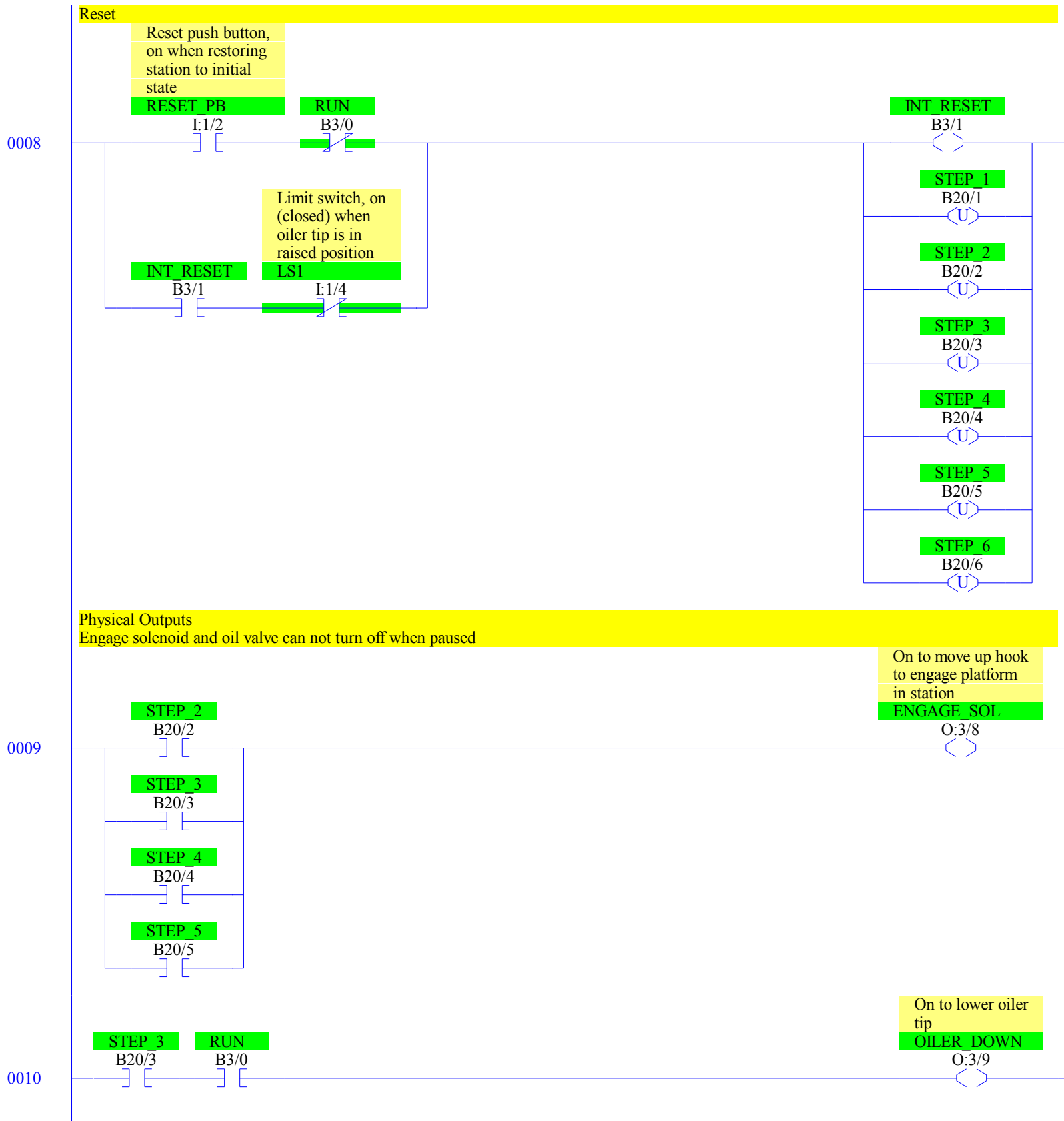
Symbol	Address	
RUN	B3:0	On while station running
INT_RESET	B3:1	Internal reset
STEP_1 to STEP_6	B20:1 to B20:6	Step-in-progress bits
ENGAGE_TMR	T4:1	Delay to capture engine
SQUIRT_TMR	T4:2	Times squirt of oil

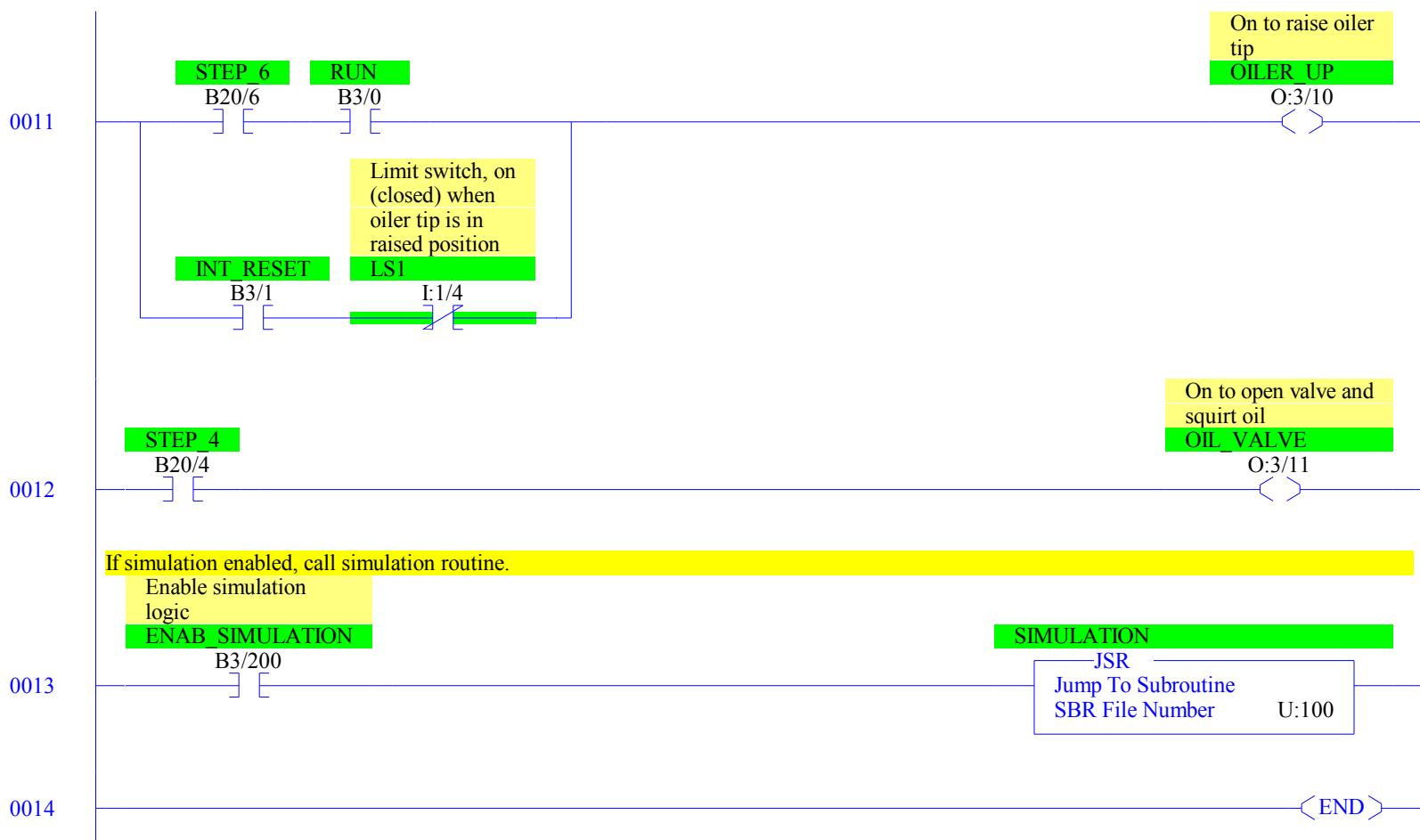
Start/stop and initial start.

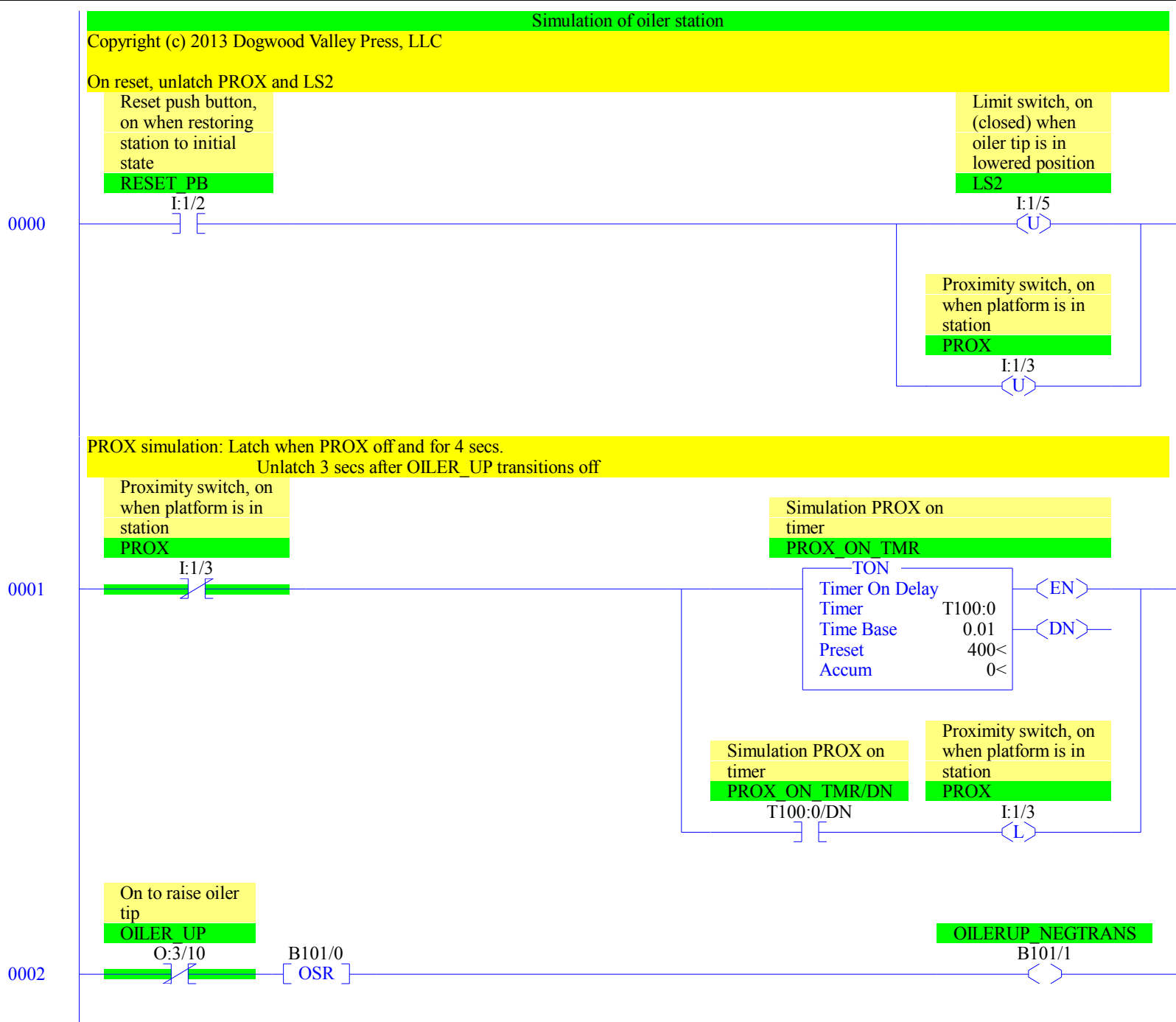
During restart prevent start.

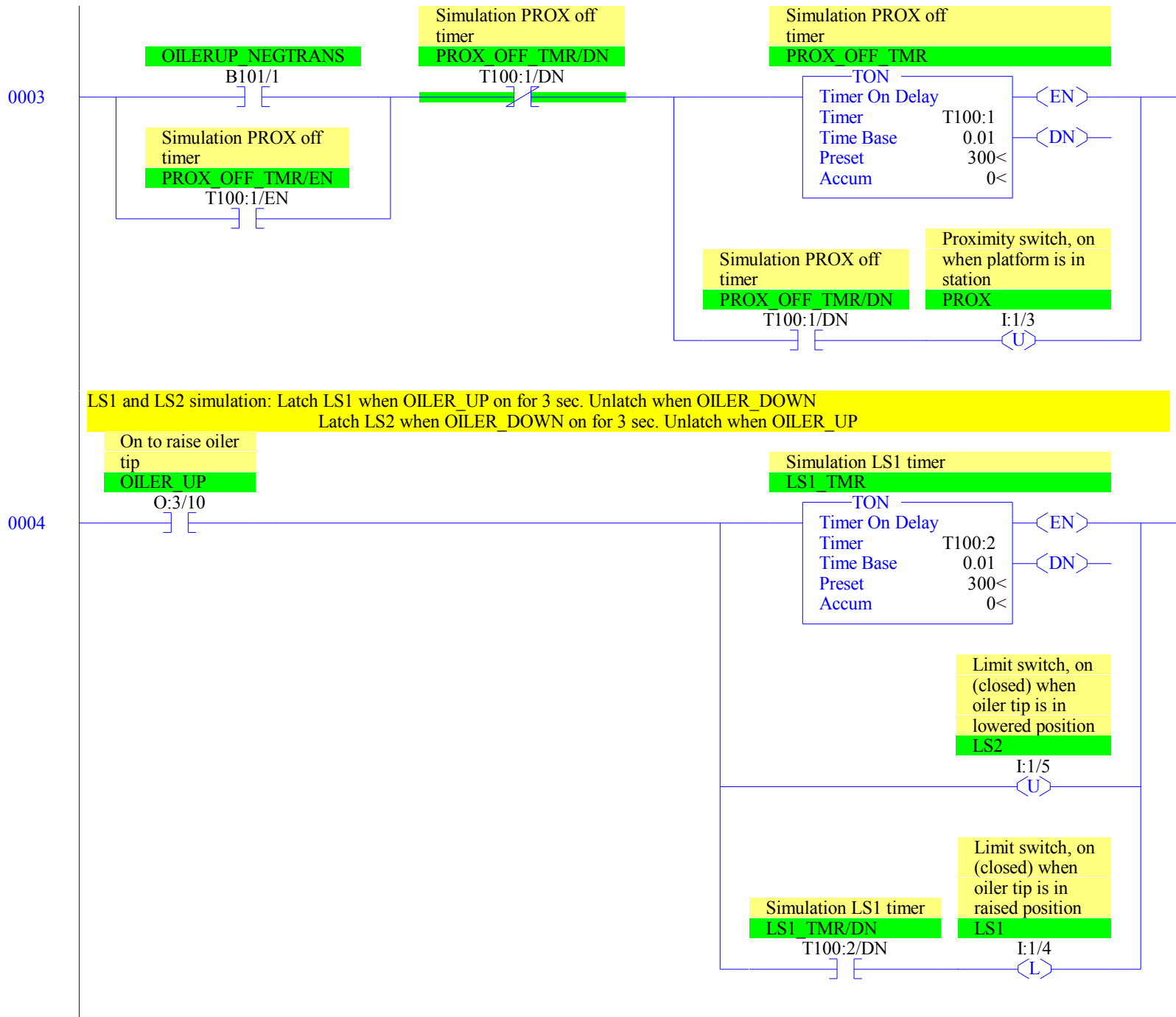


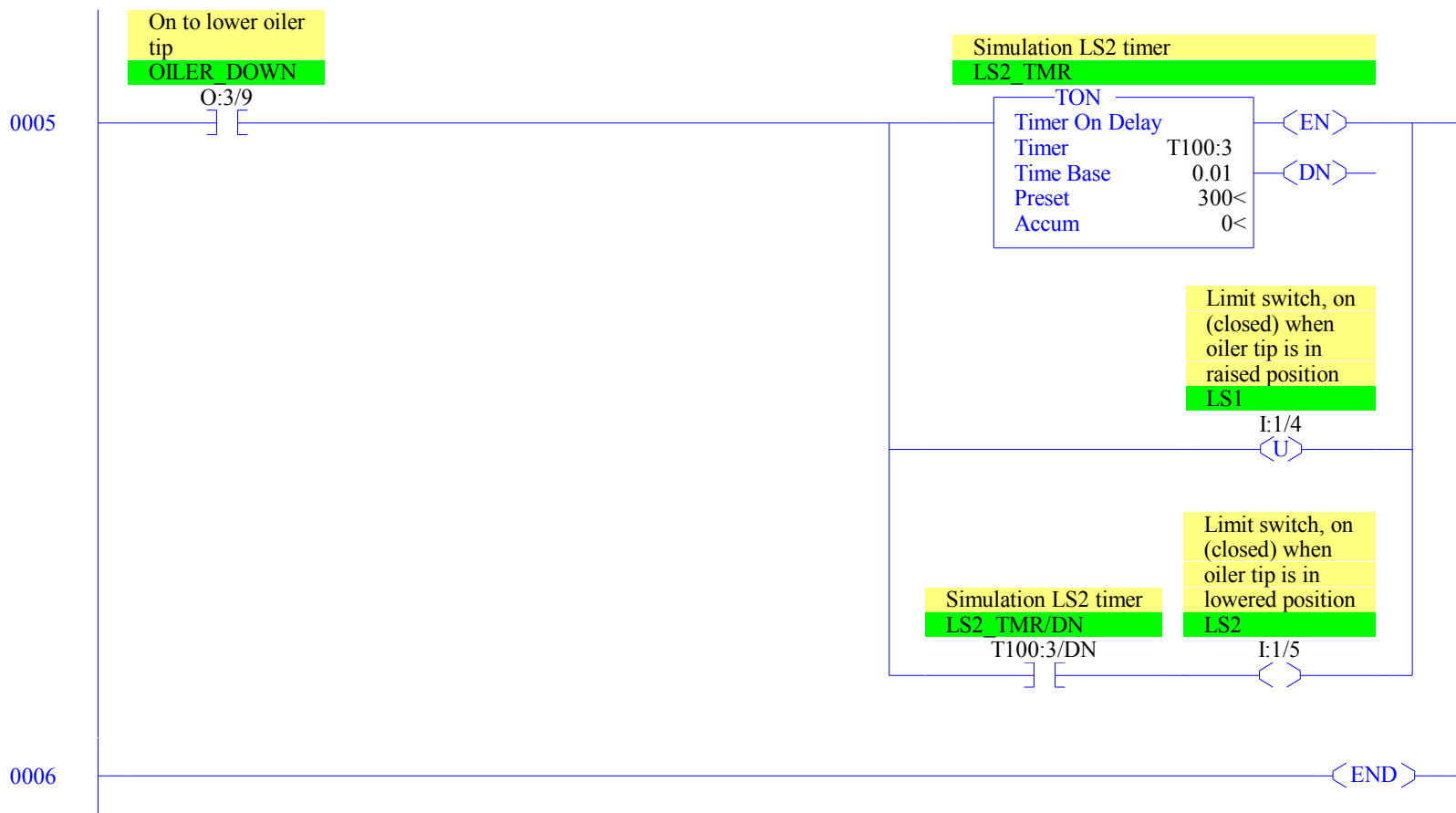












## RSLogix 500 Cross Reference Report - Sorted by Address

O:3/8	- {ENGAGE_SOL} On to move up hook to engage platform in station OTE - File #2 - 9
O:3/9	- {OILER_DOWN} On to lower oiler tip OTE - File #2 - 10 XIC - File #100 SIMULATE - 5
O:3/10	- {OILER_UP} On to raise oiler tip OTE - File #2 - 11 XIC - File #100 SIMULATE - 4 XIO - File #100 SIMULATE - 2
O:3/11	- {OIL_VALVE} On to open valve and squirt oil OTE - File #2 - 12
I:1/0	- {START_PB} Start push button, on when starting XIC - File #2 - 0
I:1/1	- {STOP_PB} Stop push button, off when stopping XIC - File #2 - 0
I:1/2	- {RESET_PB} Reset push button, on when restoring station to initial state XIC - File #2 - 8 File #100 SIMULATE - 0
I:1/3	- {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
I:1/4	- {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
I:1/5	- {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
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
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



## RSLogix 500 Cross Reference Report - Sorted by Address

	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
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	- OSR - File #100 SIMULATE - 2
B101/1	- {OILERUP_NEGTRANS}
	OTE - File #100 SIMULATE - 2
	XIC - File #100 SIMULATE - 3
U:100	- {SIMULATION}
	JSR - File #2 - 13