

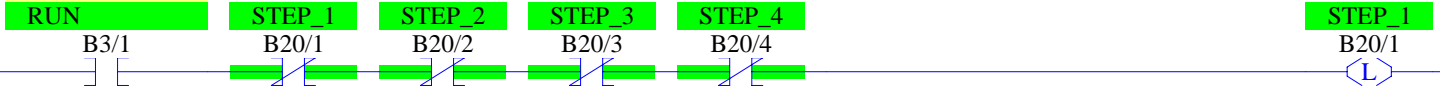
## Parts Transfer Station Control

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Additional internal memory:

Symbol	Address	
STEP_1 to STEP_4	B20/1 to B20/4	Step-in-progress bits
MOTOR1_TMR	T4:1	Turntable turn timer
PARTS_CTR	C5:1	Parts counter

## Initial start

Internal coil, on  
when operation  
enabled to run

## Step 1 Count Parts

Photoelectric  
sensor, off (open)  
when part passes

Counts 6 parts

PARTS\_CTR

STEP\_1  
B20/1

PE1

I:1/0

CTU  
Count Up  
Counter  
Preset  
Accum

C5:1

6&lt;

0&lt;

CU  
DN

Counts 6 parts  
PARTS\_CTR/DN  
C5:1/DNInternal coil, on  
when operation  
enabled to run

RUN

B3/1

STEP\_1

B20/1

U

STEP\_2

B20/2

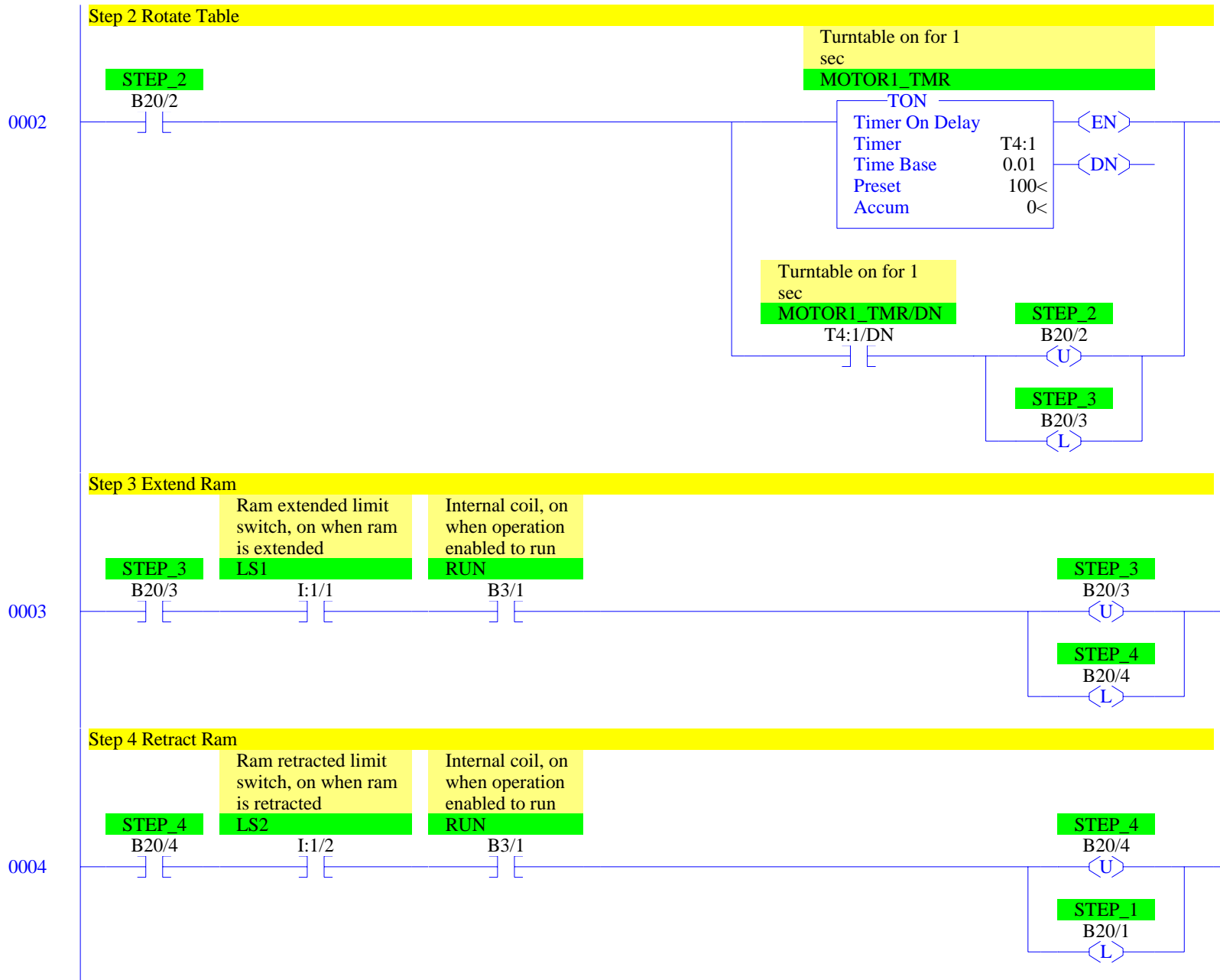
L

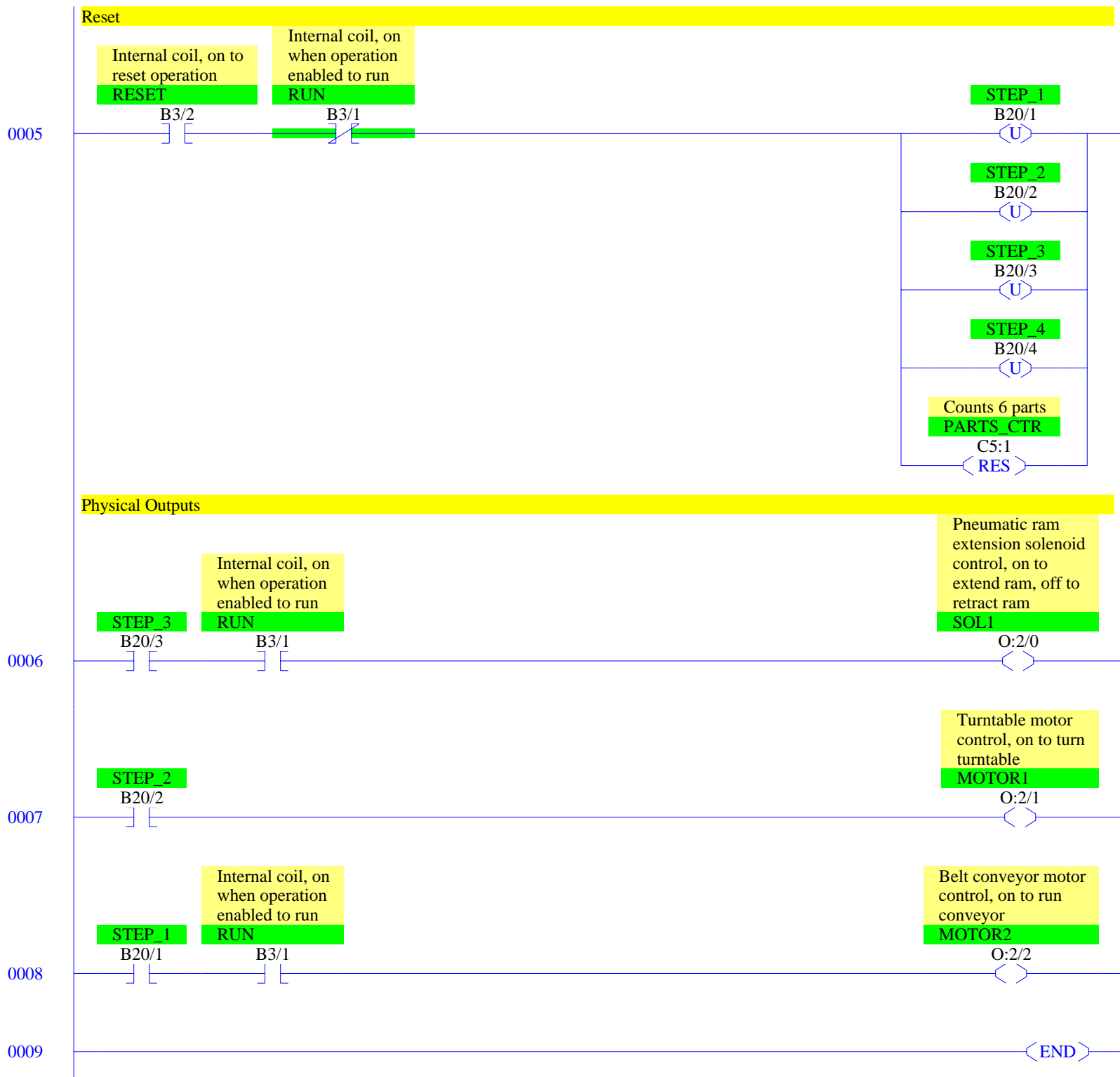
Counts 6 parts

PARTS\_CTR

C5:1

RES





## RSLogix 500 Cross Reference Report - Sorted by Address

O:2/0	- {SOL1} Pneumatic ram extension solenoid control, on to extend ram, off to retract ram OTE - File #2 - 6
O:2/1	- {MOTOR1} Turntable motor control, on to turn turntable OTE - File #2 - 7
O:2/2	- {MOTOR2} Belt conveyor motor control, on to run conveyor OTE - File #2 - 8
I:1/0	- {PE1} Photoelectric sensor, off (open) when part passes XIO - File #2 - 1
I:1/1	- {LS1} Ram extended limit switch, on when ram is extended XIC - File #2 - 3
I:1/2	- {LS2} Ram retracted limit switch, on when ram is retracted XIC - File #2 - 4
B3/1	- {RUN} Internal coil, on when operation enabled to run XIC - File #2 - 0, 1, 3, 4, 6, 8 XIO - File #2 - 5
B3/2	- {RESET} Internal coil, on to reset operation XIC - File #2 - 5
T4:1	- {MOTOR1_TMR} Turntable on for 1 sec TON - File #2 - 2
T4:1/DN	- XIC - File #2 - 2
C5:1	- {PARTS_CTR} Counts 6 parts CTU - File #2 - 1 RES - File #2 - 1, 5
C5:1/DN	- XIC - File #2 - 1
B20/1	- {STEP_1} OTL - File #2 - 0, 4 OTU - File #2 - 1, 5 XIC - File #2 - 1, 8 XIO - File #2 - 0
B20/2	- {STEP_2} OTL - File #2 - 1 OTU - File #2 - 2, 5 XIC - File #2 - 2, 7 XIO - File #2 - 0
B20/3	- {STEP_3} OTL - File #2 - 2 OTU - File #2 - 3, 5 XIC - File #2 - 3, 6 XIO - File #2 - 0
B20/4	- {STEP_4} OTL - File #2 - 3 OTU - File #2 - 4, 5 XIC - File #2 - 4 XIO - File #2 - 0