

Bag Sealing 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
SEAL_TMR	T4:1	Sealing bag timer

Start/stop and initial start.

During restart, prevent start.

Start push button,
on when startingSTOP push button,
off when stopping

INT_RESET

I:1/0

B3/1

I:1/1

RUN

B3/0

STEP_1

B20/1

STEP_2

B20/2

STEP_3

B20/3

STEP_4

B20/4

STEP_5

B20/5

STEP_1

B20/1

STEP_2

B20/2

STEP_3

B20/3

STEP_4

B20/4

STEP_5

B20/5

STEP_1

B20/1

STEP_2

B20/2

STEP_3

B20/3

STEP_4

B20/4

STEP_5

B20/5

STEP_1

B20/1

STEP_2

B20/2

STEP_3

B20/3

STEP_4

B20/4

STEP_5

B20/5

STEP_1

B20/1

STEP_2

B20/2

STEP_3

B20/3

STEP_4

B20/4

STEP_5

B20/5

Step 1 Move bag in

Photoelectric
sensor, off (open)
when bag is in
station

PE1

I:1/3

STEP_1

B20/1

STEP_2

B20/2

STEP_3

B20/3

STEP_4

B20/4

STEP_5

B20/5

STEP_1

B20/1

STEP_2

B20/2

STEP_3

B20/3

STEP_4

B20/4

STEP_5

B20/5

STEP_1

B20/1

STEP_2

B20/2

STEP_3

B20/3

STEP_4

B20/4

STEP_5

B20/5

STEP_1

B20/1

STEP_2

B20/2

STEP_3

B20/3

STEP_4

B20/4

Step 2 Move bars in

Limit switch, on
(closed) when 2 bars
are together

LS1

I:1/4

STEP_1

B20/1

STEP_2

B20/2

STEP_3

B20/3

STEP_4

B20/4

STEP_5

B20/5

STEP_1

B20/1

STEP_2

B20/2

STEP_3

B20/3

STEP_4

B20/4

STEP_5

B20/5

STEP_1

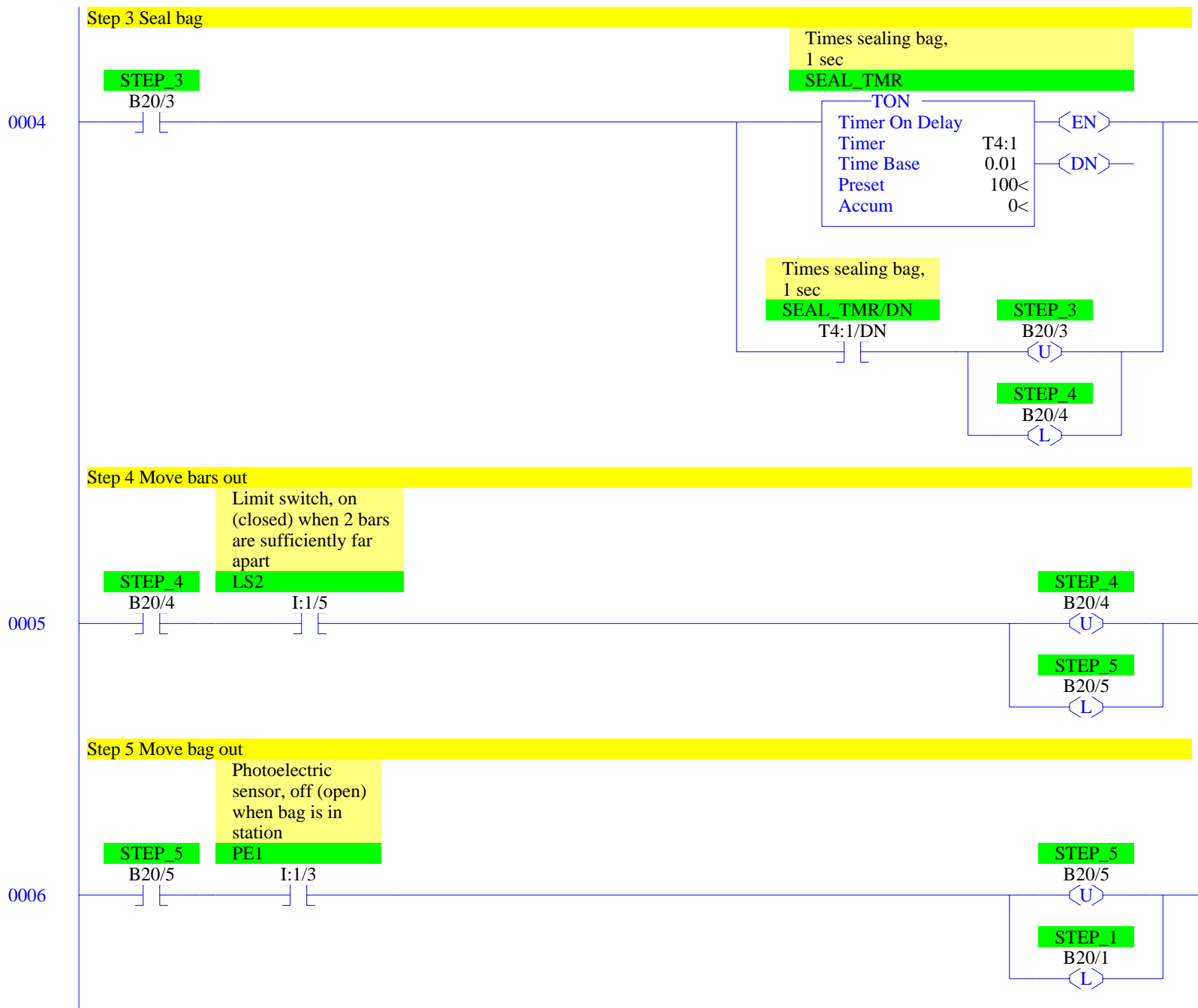
B20/1

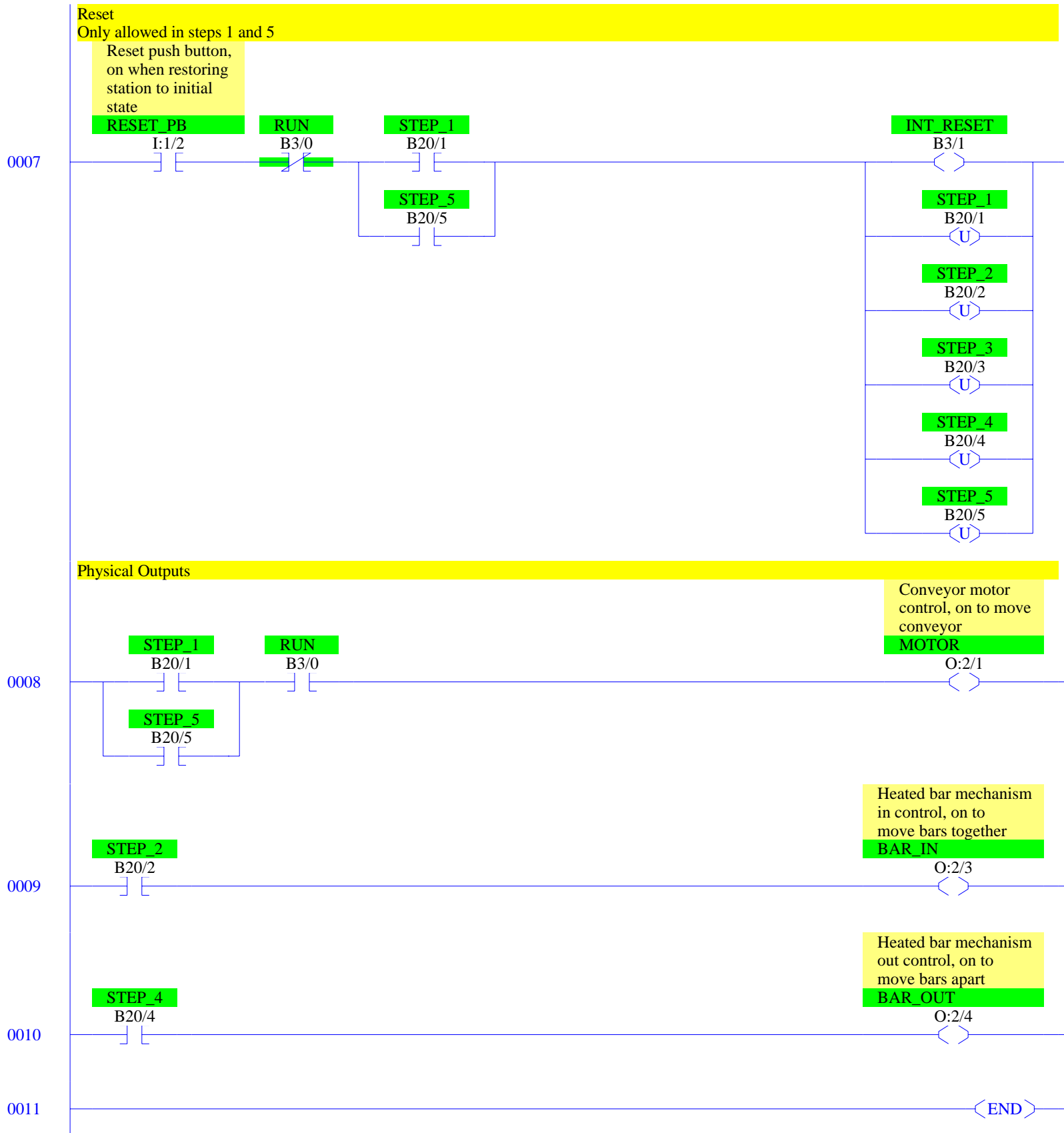
STEP_2

B20/2

STEP_3

B20/3





RSLogix 500 Cross Reference Report - Sorted by Address

O:2/1	- {MOTOR} Conveyor motor control, on to move conveyor OTE - File #2 - 8
O:2/3	- {BAR_IN} Heated bar mechanism in control, on to move bars together OTE - File #2 - 9
O:2/4	- {BAR_OUT} Heated bar mechanism out control, on to move bars apart OTE - File #2 - 10
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 - 7
I:1/3	- {PE1} Photoelectric sensor, off (open) when bag is in station XIC - File #2 - 6 XIO - File #2 - 2
I:1/4	- {LS1} Limit switch, on (closed) when 2 bars are together XIC - File #2 - 3
I:1/5	- {LS2} Limit switch, on (closed) when 2 bars are sufficiently far apart XIC - File #2 - 5
B3/0	- {RUN} OTE - File #2 - 0 XIC - File #2 - 0, 1, 8 XIO - File #2 - 7
B3/1	- {INT_RESET} OTE - File #2 - 7 XIO - File #2 - 0
T4:1	- {SEAL_TMR} Times sealing bag, 1 sec TON - File #2 - 4
T4:1/DN	- XIC - File #2 - 4
B20/1	- {STEP_1} OTL - File #2 - 1, 6 OTU - File #2 - 2, 7 XIC - File #2 - 2, 7, 8 XIO - File #2 - 1
B20/2	- {STEP_2} OTL - File #2 - 2 OTU - File #2 - 3, 7 XIC - File #2 - 3, 9 XIO - File #2 - 1
B20/3	- {STEP_3} OTL - File #2 - 3 OTU - File #2 - 4, 7 XIC - File #2 - 4 XIO - File #2 - 1
B20/4	- {STEP_4} OTL - File #2 - 4 OTU - File #2 - 5, 7 XIC - File #2 - 5, 10 XIO - File #2 - 1
B20/5	- {STEP_5} OTL - File #2 - 5 OTU - File #2 - 6, 7 XIC - File #2 - 6, 7, 8 XIO - File #2 - 1