

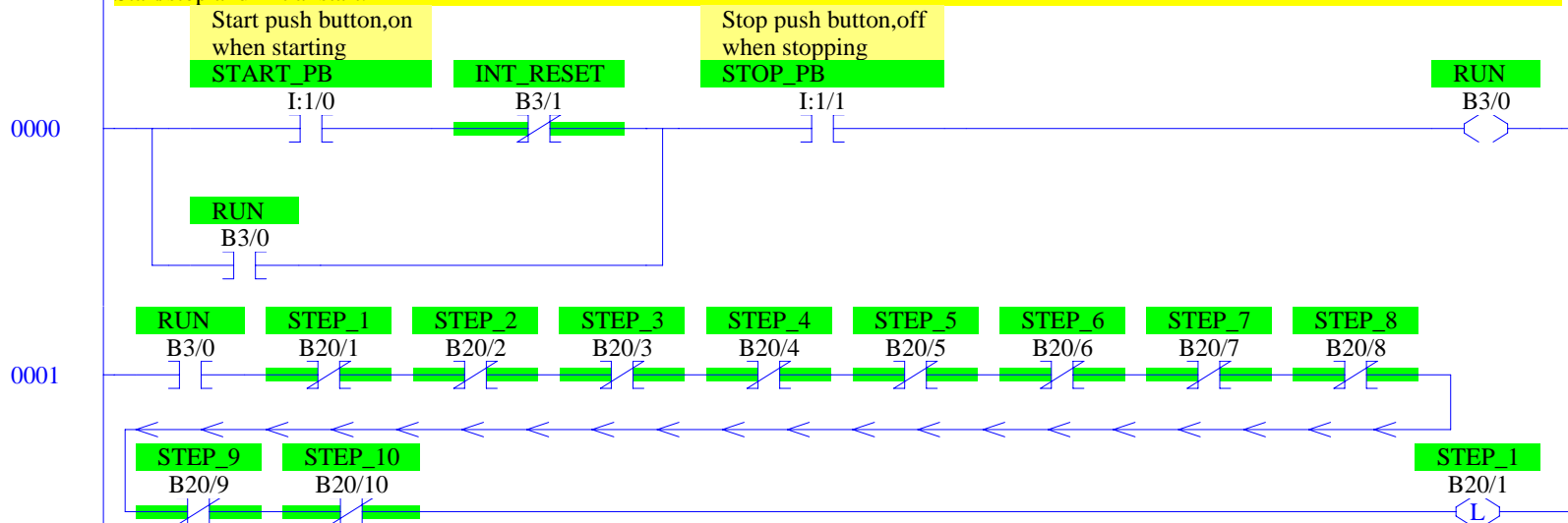
## Drilling Station Control

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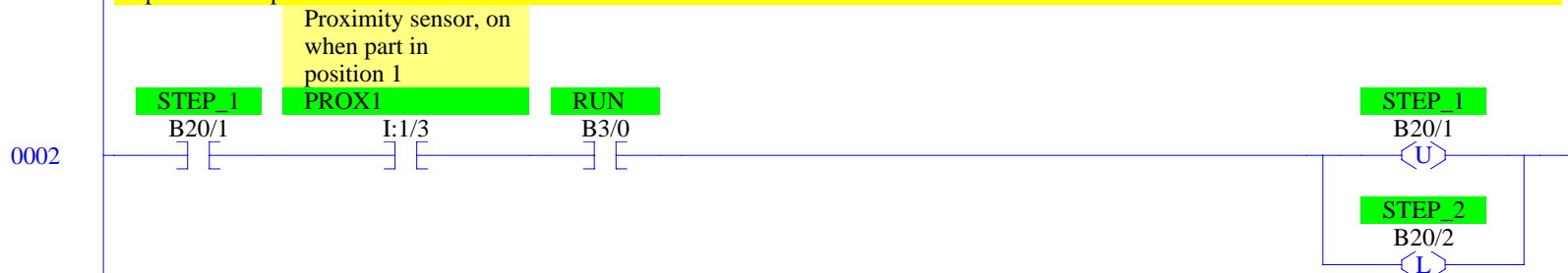
Additional internal memory:

Symbol	Address	
RUN	B3/0	On while station running
INT_RESET	B3/1	Internal reset
STEP_1 to STEP_10	B20/1 to B20/10	Step-in-progress bits
UNCLAMP_TMR	T4:2	Times unclamp of part carrier

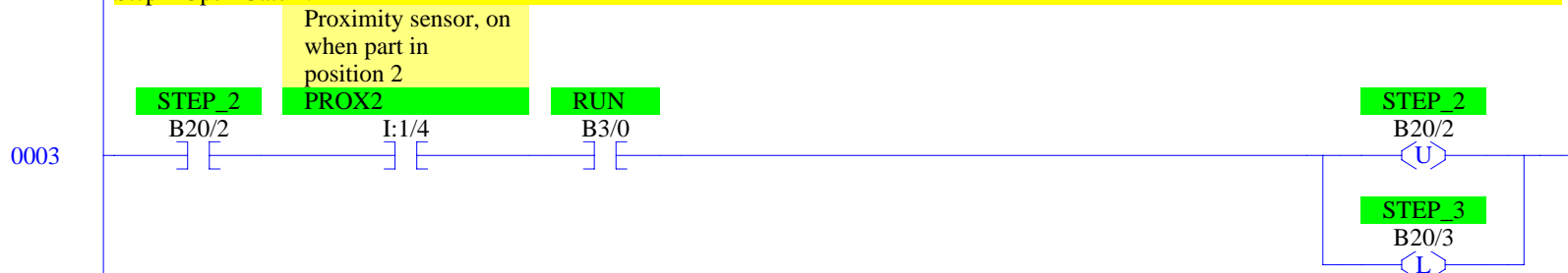
Start/stop and initial start.

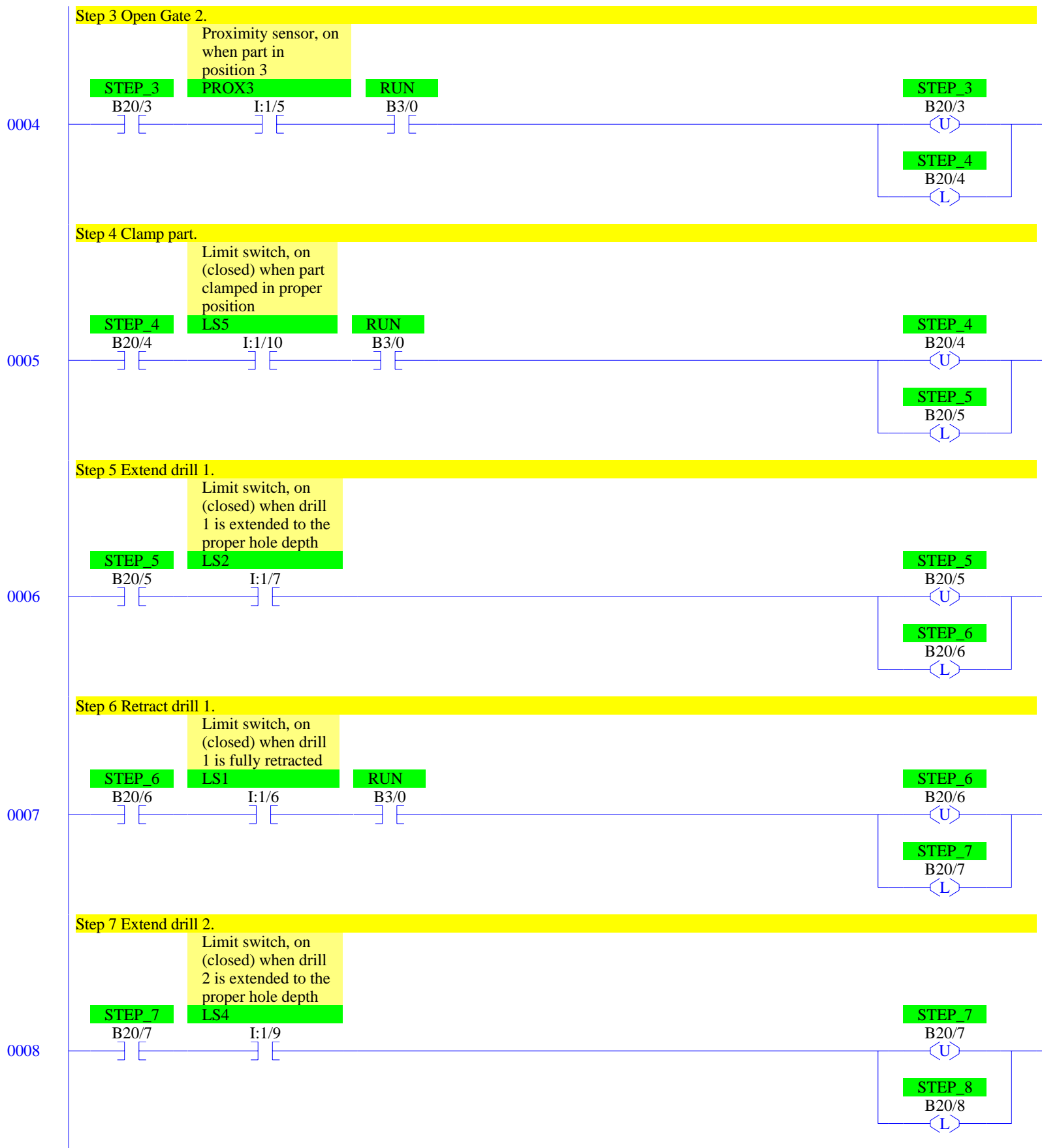


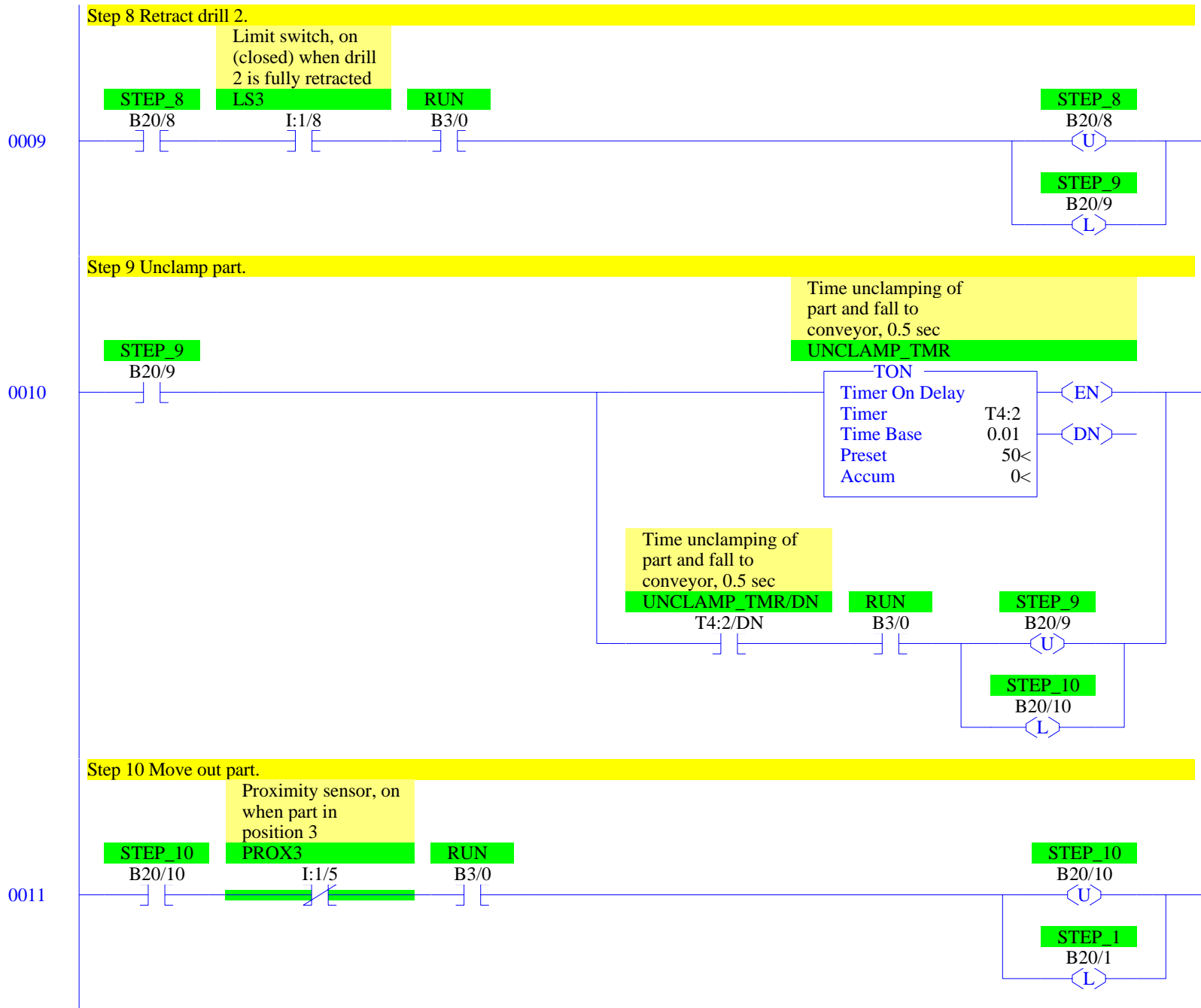
Step 1 Wait for part.



Step 2 Open Gate 1.







0012

Reset - Retract drills. Maintain reset until both retracted.

Reset push button,  
on when restoring  
process to initial  
state

RESET\_PB

I:1/2

RUN

B3/0

INT\_RESET

B3/1

INT\_RESET

B3/1

Limit switch, on  
(closed) when drill  
1 is fully retracted

LS1

I:1/6

Limit switch, on  
(closed) when drill  
2 is fully retracted

LS3

I:1/8

STEP\_1

B20/1

STEP\_2

B20/2

STEP\_3

B20/3

STEP\_4

B20/4

STEP\_5

B20/5

STEP\_6

B20/6

STEP\_7

B20/7

STEP\_8

B20/8

STEP\_9

B20/9

STEP\_10

B20/10

Physical Outputs

Gate Controls

Gate 1 control, on  
to open gate 1, off  
closes gate

GATE\_1

O:2/0

Gate 2 control, on  
to open gate 2, off  
closes gate

GATE\_2

O:2/1

0013

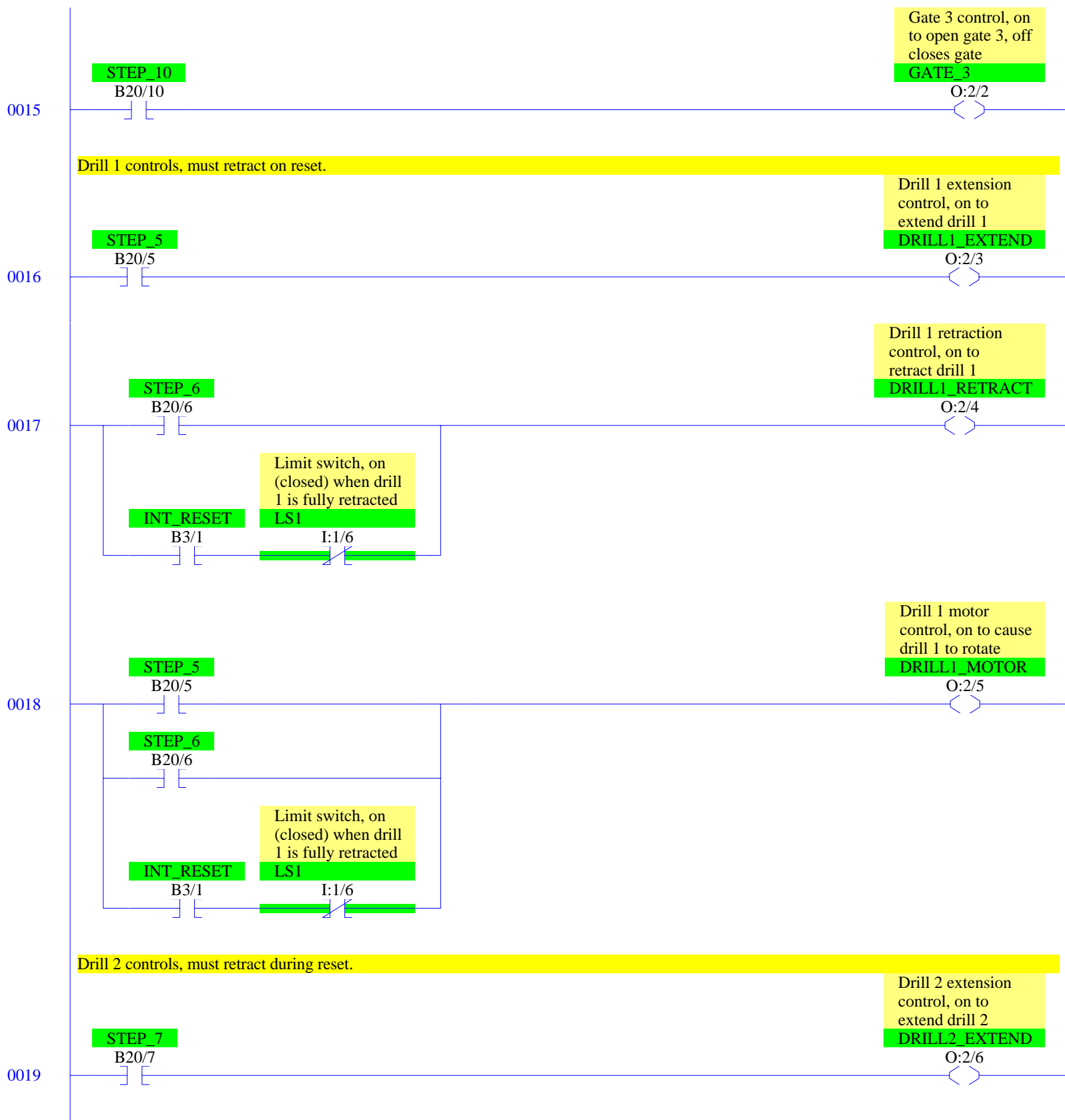
STEP\_2

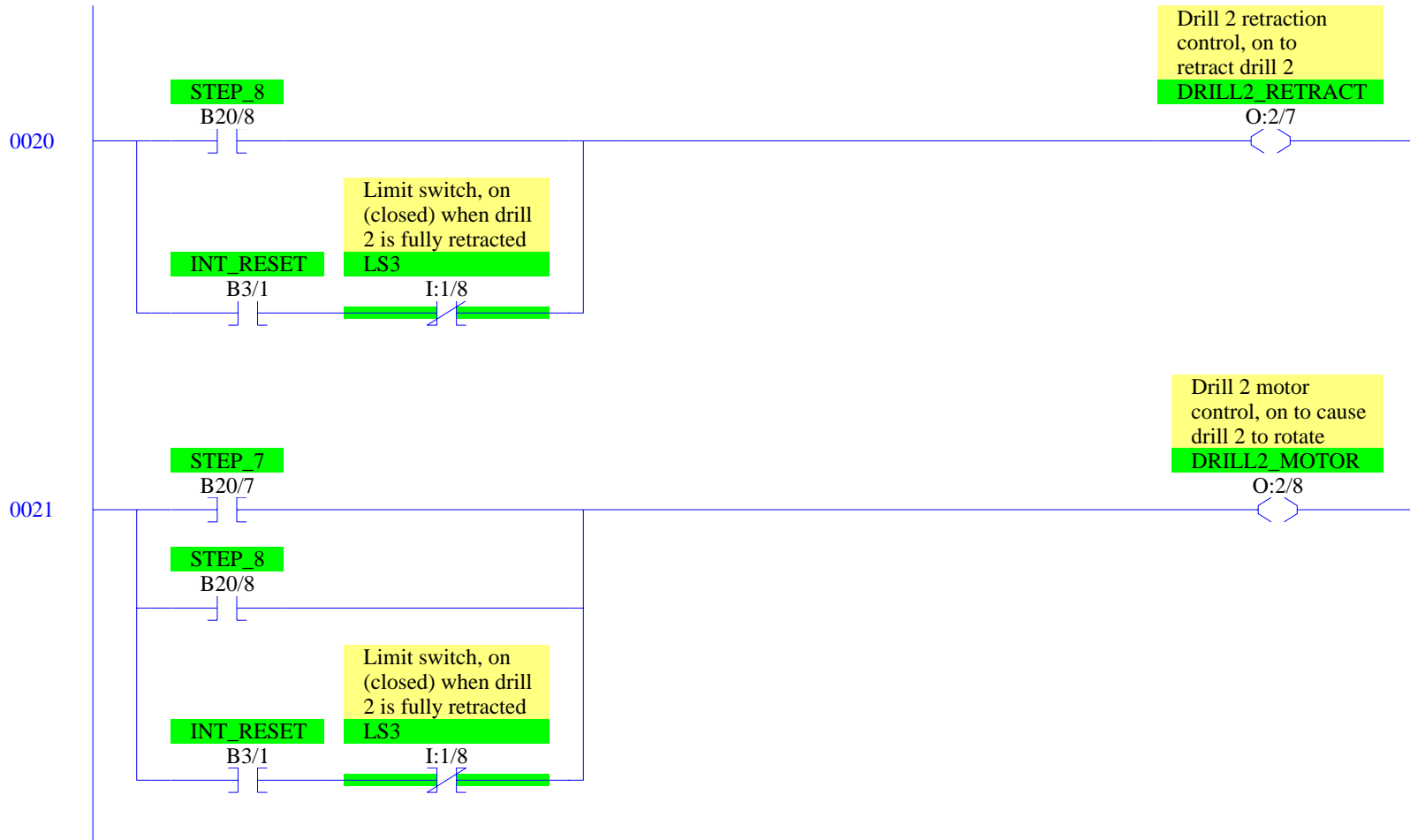
B20/2

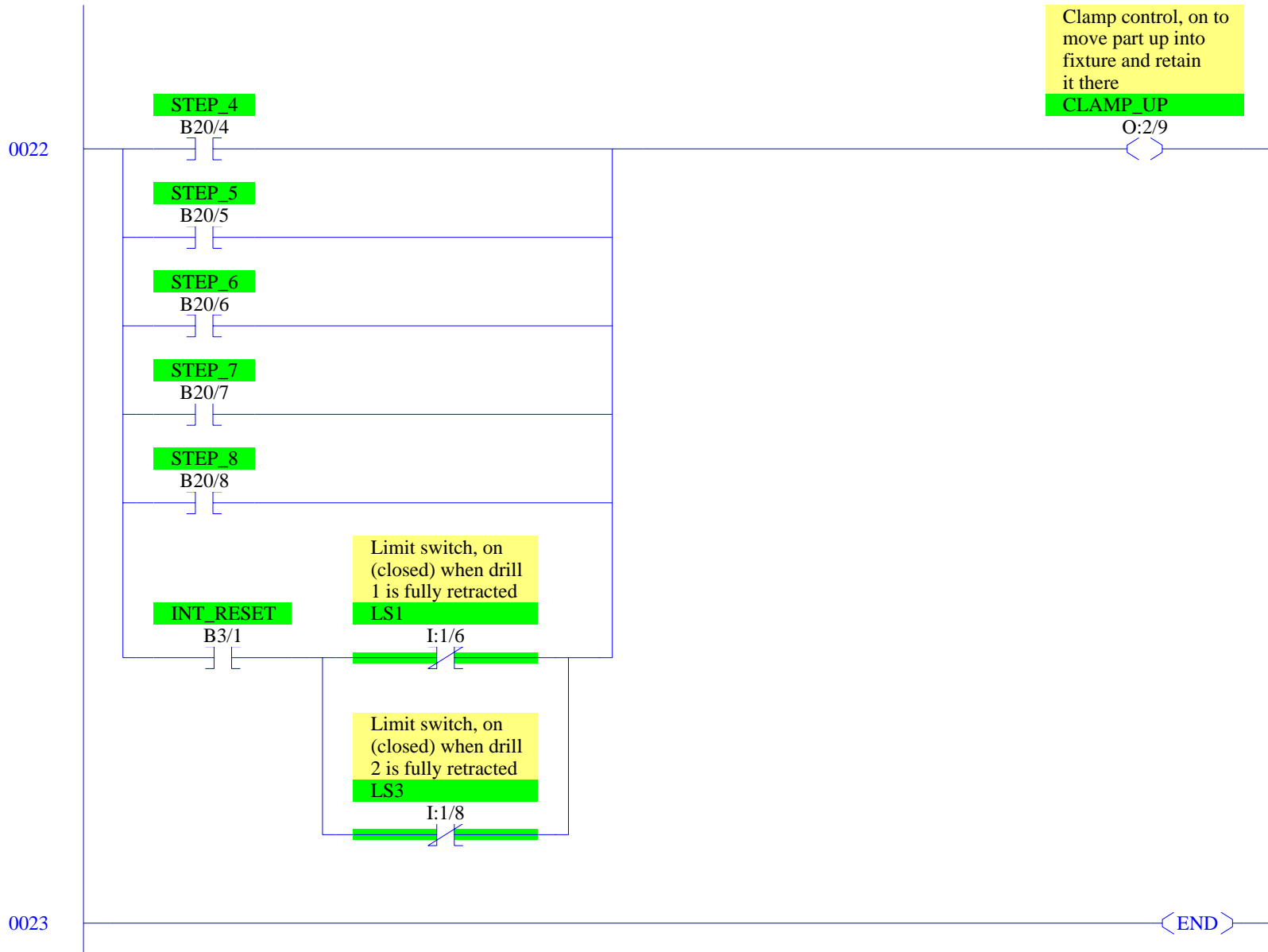
0014

STEP\_3

B20/3







## RSLogix 500 Cross Reference Report - Sorted by Address

O:2/0	- {GATE_1} Gate 1 control, on to open gate 1, off closes gate OTE - File #2 - 13
O:2/1	- {GATE_2} Gate 2 control, on to open gate 2, off closes gate OTE - File #2 - 14
O:2/2	- {GATE_3} Gate 3 control, on to open gate 3, off closes gate OTE - File #2 - 15
O:2/3	- {DRILL1_EXTEND} Drill 1 extension control, on to extend drill 1 OTE - File #2 - 16
O:2/4	- {DRILL1_RETRACT} Drill 1 retraction control, on to retract drill 1 OTE - File #2 - 17
O:2/5	- {DRILL1_MOTOR} Drill 1 motor control, on to cause drill 1 to rotate OTE - File #2 - 18
O:2/6	- {DRILL2_EXTEND} Drill 2 extension control, on to extend drill 2 OTE - File #2 - 19
O:2/7	- {DRILL2_RETRACT} Drill 2 retraction control, on to retract drill 2 OTE - File #2 - 20
O:2/8	- {DRILL2_MOTOR} Drill 2 motor control, on to cause drill 2 to rotate OTE - File #2 - 21
O:2/9	- {CLAMP_UP} Clamp control, on to move part up into fixture and retain it there OTE - File #2 - 22
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 process to initial state XIC - File #2 - 12
I:1/3	- {PROX1} Proximity sensor, on when part in position 1 XIC - File #2 - 2
I:1/4	- {PROX2} Proximity sensor, on when part in position 2 XIC - File #2 - 3
I:1/5	- {PROX3} Proximity sensor, on when part in position 3 XIC - File #2 - 4 XIO - File #2 - 11
I:1/6	- {LS1} Limit switch, on (closed) when drill 1 is fully retracted XIC - File #2 - 7 XIO - File #2 - 12, 17, 18, 22
I:1/7	- {LS2} Limit switch, on (closed) when drill 1 is extended to the proper hole depth XIC - File #2 - 6
I:1/8	- {LS3} Limit switch, on (closed) when drill 2 is fully retracted XIC - File #2 - 9 XIO - File #2 - 12, 20, 21, 22
I:1/9	- {LS4} Limit switch, on (closed) when drill 2 is extended to the proper hole depth XIC - File #2 - 8
I:1/10	- {LS5} Limit switch, on (closed) when part clamped in proper position XIC - File #2 - 5
B3/0	- {RUN} OTE - File #2 - 0 XIC - File #2 - 0, 1, 2, 3, 4, 5, 7, 9, 10, 11 XIO - File #2 - 12
B3/1	- {INT_RESET} OTE - File #2 - 12 XIC - File #2 - 12, 17, 18, 20, 21, 22 XIO - File #2 - 0
T4:2	- {UNCLAMP_TMR} Time unclamping of part and fall to conveyor, 0.5 sec TON - File #2 - 10
T4:2/DN	- XIC - File #2 - 10
B20/1	- {STEP_1} OTL - File #2 - 1, 11 OTU - File #2 - 2, 12 XIC - File #2 - 2 XIO - File #2 - 1
B20/2	- {STEP_2} OTL - File #2 - 2 OTU - File #2 - 3, 12 XIC - File #2 - 3, 13 XIO - File #2 - 1



## RSLogix 500 Cross Reference Report - Sorted by Address

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, 22
	XIO - File #2 - 1
B20/5	- {STEP_5}
	OTL - File #2 - 5
	OTU - File #2 - 6, 12
	XIC - File #2 - 6, 16, 18, 22
	XIO - File #2 - 1
B20/6	- {STEP_6}
	OTL - File #2 - 6
	OTU - File #2 - 7, 12
	XIC - File #2 - 7, 17, 18, 22
	XIO - File #2 - 1
B20/7	- {STEP_7}
	OTL - File #2 - 7
	OTU - File #2 - 8, 12
	XIC - File #2 - 8, 19, 21, 22
	XIO - File #2 - 1
B20/8	- {STEP_8}
	OTL - File #2 - 8
	OTU - File #2 - 9, 12
	XIC - File #2 - 9, 20, 21, 22
	XIO - File #2 - 1
B20/9	- {STEP_9}
	OTL - File #2 - 9
	OTU - File #2 - 10, 12
	XIC - File #2 - 10
	XIO - File #2 - 1
B20/10	- {STEP_10}
	OTL - File #2 - 10
	OTU - File #2 - 11, 12
	XIC - File #2 - 11, 15
	XIO - File #2 - 1