

0021

Reset unlatches all normal operation step-in progress bits

Reset in progress

INT_RESET

B20/40

Wait for pallet

STEP_1

B20/1



Move to hook 2

STEP_2

B20/2



Raise pallet

STEP_3

B20/3



Lower rotator

STEP_4

B20/4



Clamp engine

STEP_5

B20/5



Raise rotator

STEP_6

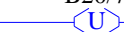
B20/6



Rotate clockwise

STEP_7

B20/7



Lower rotator

STEP_8

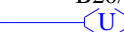
B20/8



Unclamp timer

STEP_9

B20/9



Raise rotator

STEP_10

B20/10



Rotate CCW

STEP_11

B20/11



Drop engine

STEP_12

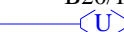
B20/12

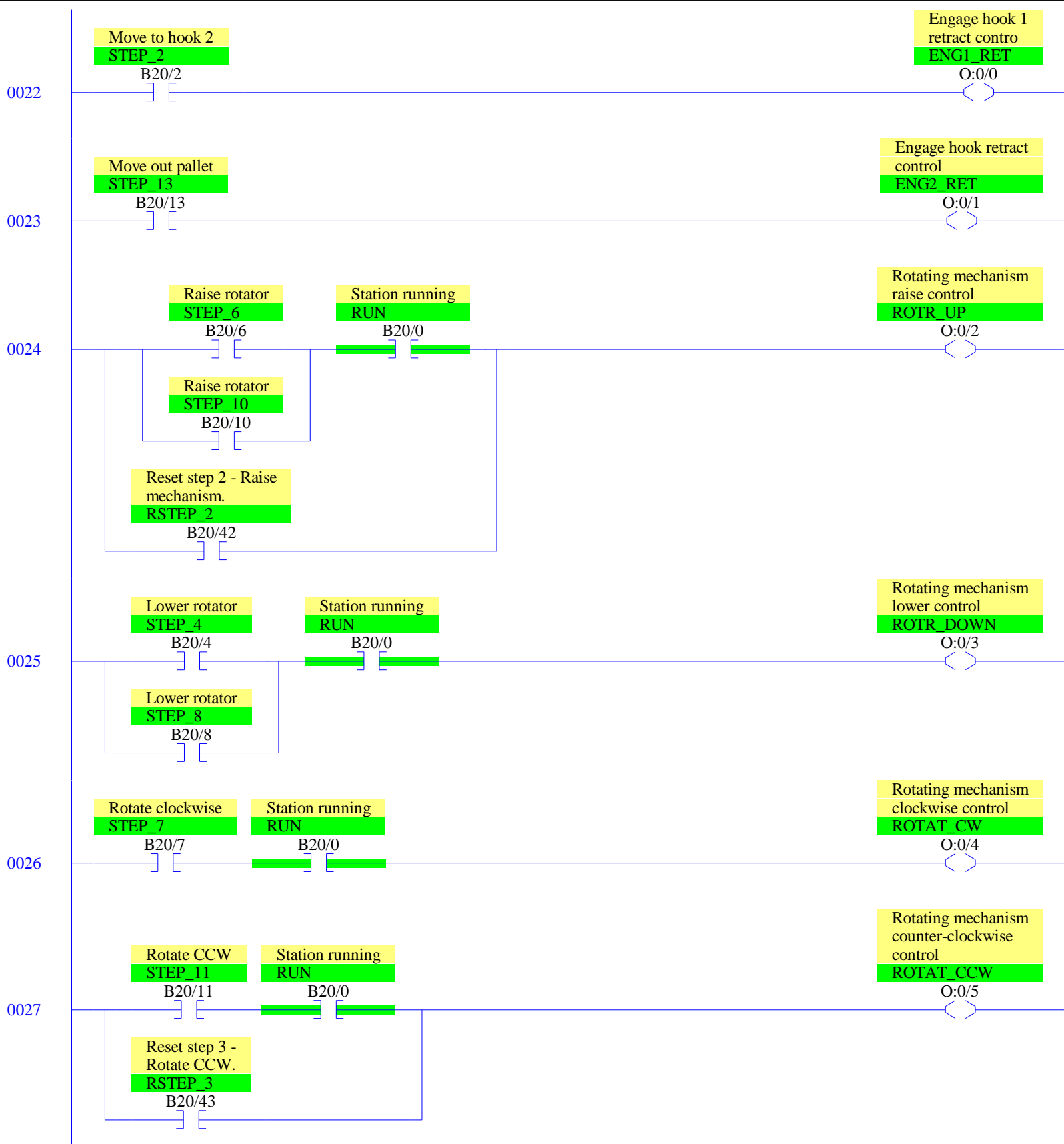


Move out pallet

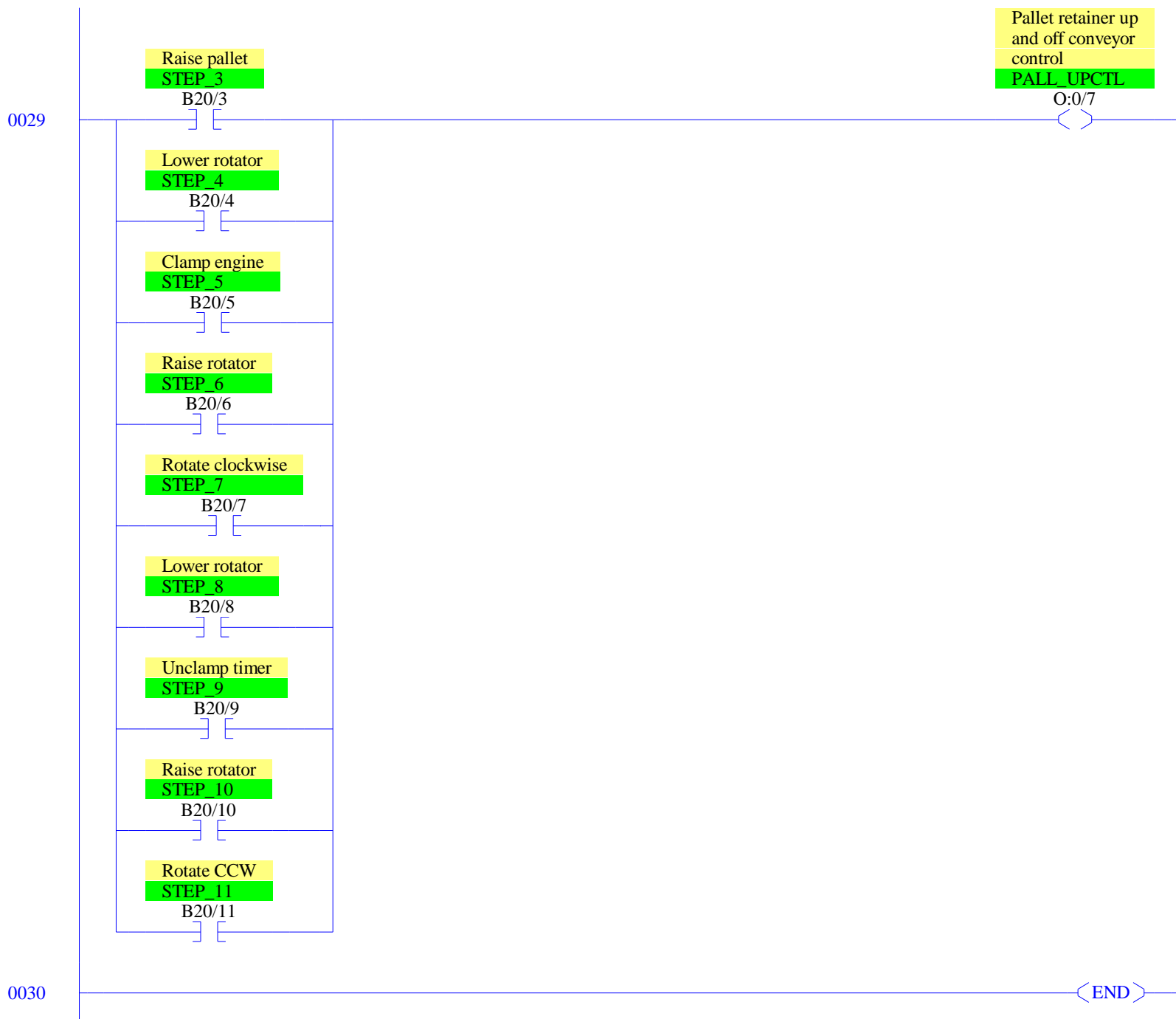
STEP_13

B20/13









RSLogix 500 Cross Reference Report - Sorted by Address

O:0/0	- {ENG1_RET} Engage hook 1 retract contro OTE - File #2 - 22
O:0/1	- {ENG2_RET} Engage hook retract control OTE - File #2 - 23
O:0/2	- {ROTR_UP} Rotating mechanism raise control OTE - File #2 - 24
O:0/3	- {ROTR_DOWN} Rotating mechanism lower control OTE - File #2 - 25
O:0/4	- {ROTAT_CW} Rotating mechanism clockwise control OTE - File #2 - 26
O:0/5	- {ROTAT_CCW} Rotating mechanism counter-clockwise control OTE - File #2 - 27
O:0/6	- {GRIP_CLOS} Gripper close control OTE - File #2 - 28
O:0/7	- {PALL_UPCTL} Pallet retainer up and off conveyor control OTE - File #2 - 29
I:0/0	- {START_PB} Start pushbutton XIC - File #2 - 0
I:0/1	- {STOP_PB} Stop pushbutton XIC - File #2 - 0
I:0/2	- {RESET_PB} Reset pushbutton XIC - File #2 - 15
I:0/3	- {PROX1} Proximity sensor Pallet at engaging hook 1 XIC - File #2 - 2
I:0/4	- {PALL_UPLS} Limit switch Indicates pallet off conveyor XIC - File #2 - 4 XIO - File #2 - 13
I:0/5	- {ROTR_UPLS} Rotator up limit switch XIC - File #2 - 7, 11, 18
I:0/6	- {ROTR_DNLS} Rotator down limit switch XIC - File #2 - 5, 9
I:0/7	- {ROTR_CWLS} Rotator clockwise limit switch XIC - File #2 - 8
I:0/10	- {ROTR_CCWLS} Rotator counter- clockwise limit switch XIC - File #2 - 12, 19
T4:1	- {ENG1_TMR} Hook 1 engage timer TON - File #2 - 3
T4:1/DN	- XIC - File #2 - 3
T4:2	- {ENG2_TMR} Hook 2 disengage timer TON - File #2 - 14
T4:2/DN	- XIC - File #2 - 14
T4:3	- {CLMP_TMR} Clamp timer TON - File #2 - 6
T4:3/DN	- XIC - File #2 - 6
T4:4	- {UNCLMP_TMR} Unclamp timer TON - File #2 - 10
T4:4/DN	- XIC - File #2 - 10
T4:5	- {RUNCLMP_TMR} Reset unclamp timer TON - File #2 - 17
T4:5/DN	- XIC - File #2 - 17
B20/0	- {RUN} Station running OTE - File #2 - 0 XIC - File #2 - 0, 1, 2, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 24 25, 26, 27 XIO - File #2 - 15
B20/1	- {STEP_1} Wait for pallet OTL - File #2 - 1, 14 OTU - File #2 - 2, 21 XIC - File #2 - 2 XIO - File #2 - 1
B20/2	- {STEP_2} Move to hook 2 OTL - File #2 - 2 OTU - File #2 - 3, 21 XIC - File #2 - 3, 22 XIO - File #2 - 1
B20/3	- {STEP_3} Raise pallet

RSLogix 500 Cross Reference Report - Sorted by Address

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      OTL - File #2 - 3
      OTU - File #2 - 4, 21
      XIC - File #2 - 4, 29
      XIO - File #2 - 1
B20/4  - {STEP_4} Lower rotator
      OTL - File #2 - 4
      OTU - File #2 - 5, 21
      XIC - File #2 - 5, 25, 29
      XIO - File #2 - 1
B20/5  - {STEP_5} Clamp engine
      OTL - File #2 - 5
      OTU - File #2 - 6, 21
      XIC - File #2 - 6, 28, 29
      XIO - File #2 - 1
B20/6  - {STEP_6} Raise rotator
      OTL - File #2 - 6
      OTU - File #2 - 7, 21
      XIC - File #2 - 7, 24, 28, 29
      XIO - File #2 - 1
B20/7  - {STEP_7} Rotate clockwise
      OTL - File #2 - 7
      OTU - File #2 - 8, 21
      XIC - File #2 - 8, 26, 28, 29
      XIO - File #2 - 1
B20/8  - {STEP_8} Lower rotator
      OTL - File #2 - 8
      OTU - File #2 - 9, 21
      XIC - File #2 - 9, 25, 28, 29
      XIO - File #2 - 1
B20/9  - {STEP_9} Unclamp timer
      OTL - File #2 - 9
      OTU - File #2 - 10, 21
      XIC - File #2 - 10, 29
      XIO - File #2 - 1
B20/10 - {STEP_10} Raise rotator
      OTL - File #2 - 10
      OTU - File #2 - 11, 21
      XIC - File #2 - 11, 24, 29
      XIO - File #2 - 1
B20/11 - {STEP_11} Rotate CCW
      OTL - File #2 - 11
      OTU - File #2 - 12, 21
      XIC - File #2 - 12, 27, 29
      XIO - File #2 - 1
B20/12 - {STEP_12} Drop engine
      OTL - File #2 - 12
      OTU - File #2 - 13, 21
      XIC - File #2 - 13
      XIO - File #2 - 1
B20/13 - {STEP_13} Move out pallet
      OTL - File #2 - 13
      OTU - File #2 - 14, 21
      XIC - File #2 - 14, 23
      XIO - File #2 - 1
B20/40 - {INT_RESET} Reset in progress
      OTE - File #2 - 15
      XIC - File #2 - 15, 16, 21
      XIO - File #2 - 0, 20
B20/41 - {RSTEP_1} Reset step 1 - Delay to unclamp.
      OTL - File #2 - 16
      OTU - File #2 - 17
      XIC - File #2 - 17
      XIO - File #2 - 16
B20/42 - {RSTEP_2} Reset step 2 - Raise mechanism.
      OTL - File #2 - 17
      OTU - File #2 - 18

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RSLogix 500 Cross Reference Report - Sorted by Address

	XIC - File #2 - 18, 24
	XIO - File #2 - 16
B20/43	- {RSTEP_3} Reset step 3 - Rotate CCW.
	OTL - File #2 - 18
	OTU - File #2 - 19
	XIC - File #2 - 19, 27
	XIO - File #2 - 16
B20/44	- {RSTEP_4} Reset step 4 - unlatch internal reset.
	OTL - File #2 - 19
	OTU - File #2 - 20
	XIC - File #2 - 20
	XIO - File #2 - 15, 16