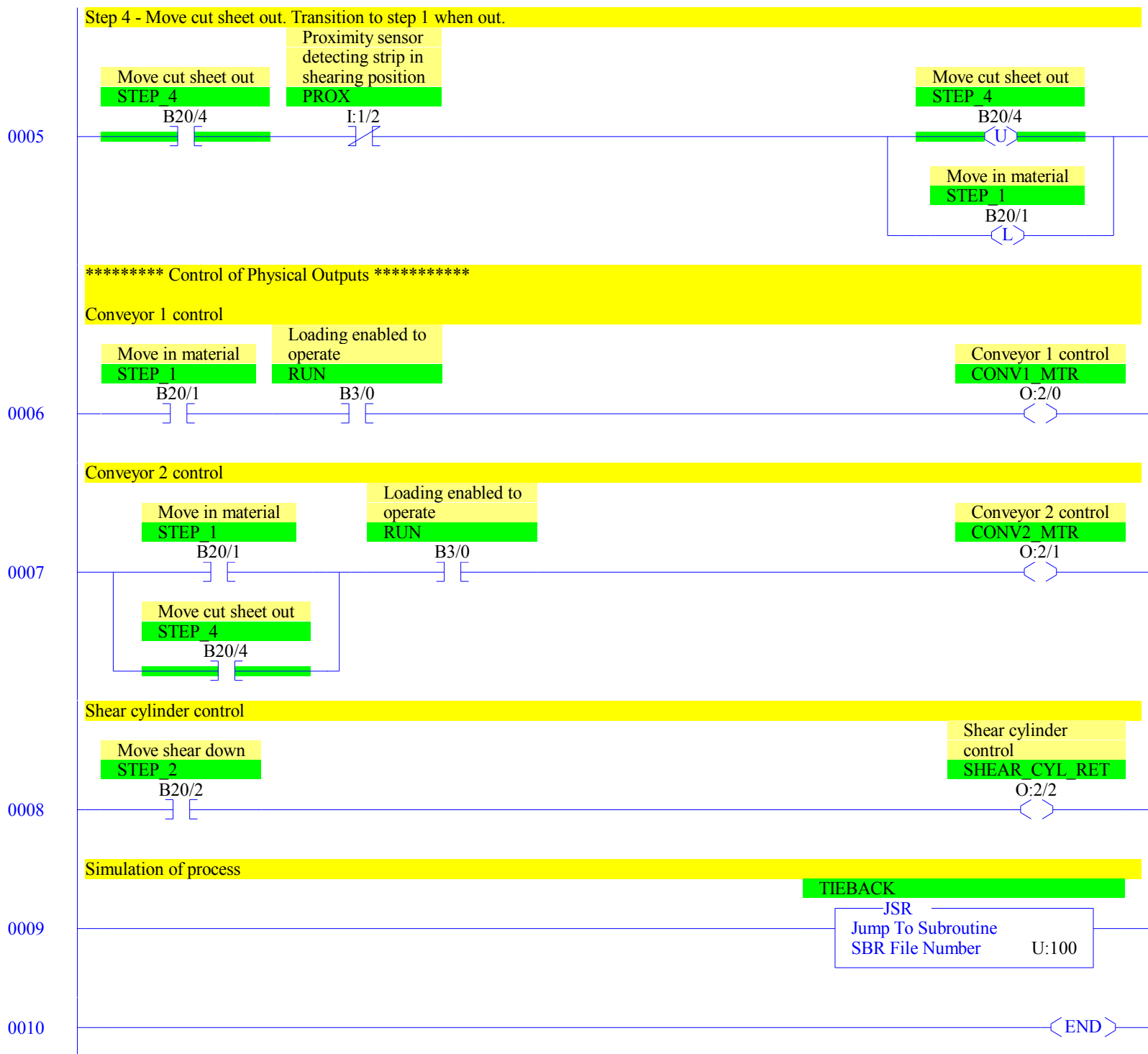


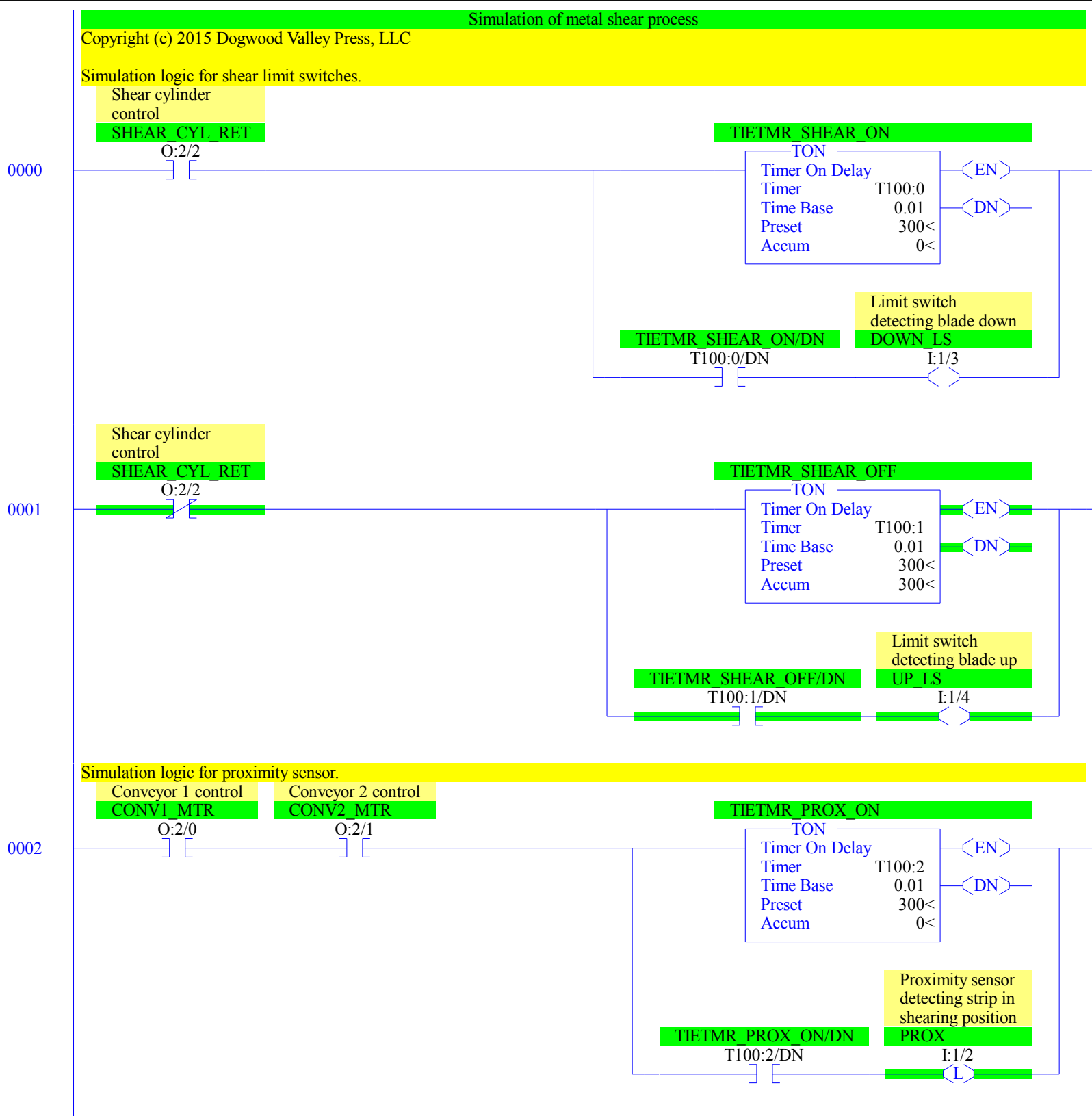
## Example 21.5 Metal Shear Control With Simulation

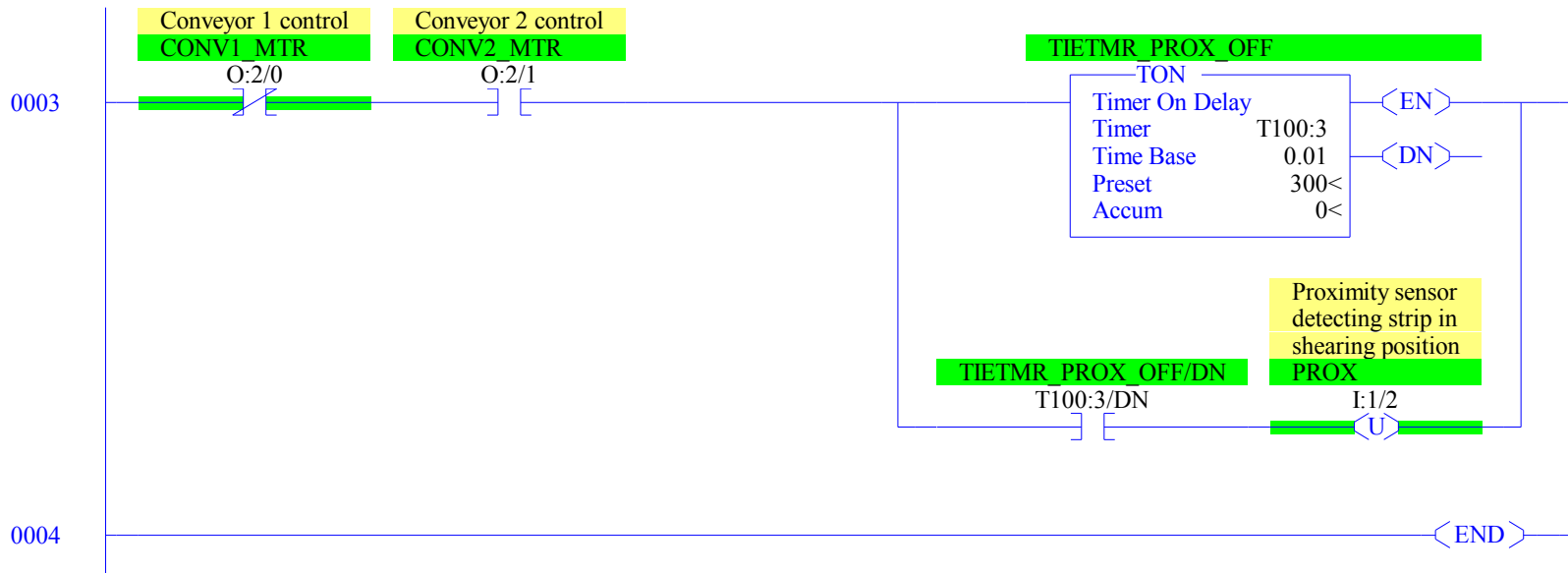
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Start/stop/pause









## RSLogix 500 Cross Reference Report - Sorted by Address

O:2/0	- {CONV1_MTR} Conveyor 1 control OTE - File #2 - 6 XIC - File #100 SIMULATION - 2 XIO - File #100 SIMULATION - 3
O:2/1	- {CONV2_MTR} Conveyor 2 control OTE - File #2 - 7 XIC - File #100 SIMULATION - 2, 3
O:2/2	- {SHEAR_CYL_RET} Shear cylinder control OTE - File #2 - 8 XIC - File #100 SIMULATION - 0 XIO - File #100 SIMULATION - 1
I:1/0	- {START_PB} Start push button XIC - File #2 - 0
I:1/1	- {STOP_PB} Stop push button XIC - File #2 - 0
I:1/2	- {PROX} Proximity sensor detecting strip in shearing position OTL - File #100 SIMULATION - 2 OTU - File #100 SIMULATION - 3 XIC - File #2 - 2 XIO - File #2 - 5
I:1/3	- {DOWN_LS} Limit switch detecting blade down OTE - File #100 SIMULATION - 0 XIC - File #2 - 3
I:1/4	- {UP_LS} Limit switch detecting blade up OTE - File #100 SIMULATION - 1 XIC - File #2 - 4
B3/0	- {RUN} Loading enabled to operate OTE - File #2 - 0 XIC - File #2 - 0, 1, 6, 7
B20/1	- {STEP_1} Move in material OTL - File #2 - 1, 5 OTU - File #2 - 2 XIC - File #2 - 2, 6, 7 XIO - File #2 - 1
B20/2	- {STEP_2} Move shear down OTL - File #2 - 2 OTU - File #2 - 3 XIC - File #2 - 3, 8 XIO - File #2 - 1
B20/3	- {STEP_3} Move shear up OTL - File #2 - 3 OTU - File #2 - 4 XIC - File #2 - 4 XIO - File #2 - 1
B20/4	- {STEP_4} Move cut sheet out OTL - File #2 - 4 OTU - File #2 - 5 XIC - File #2 - 5, 7 XIO - File #2 - 1
T100:0	- {TIETMR_SHEAR_ON} TON - File #100 SIMULATION - 0
T100:0/DN	- XIC - File #100 SIMULATION - 0
T100:1	- {TIETMR_SHEAR_OFF} TON - File #100 SIMULATION - 1
T100:1/DN	- XIC - File #100 SIMULATION - 1
T100:2	- {TIETMR_PROX_ON} TON - File #100 SIMULATION - 2
T100:2/DN	- XIC - File #100 SIMULATION - 2
T100:3	- {TIETMR_PROX_OFF} TON - File #100 SIMULATION - 3
T100:3/DN	- XIC - File #100 SIMULATION - 3
U:100	- {TIEBACK} JSR - File #2 - 9