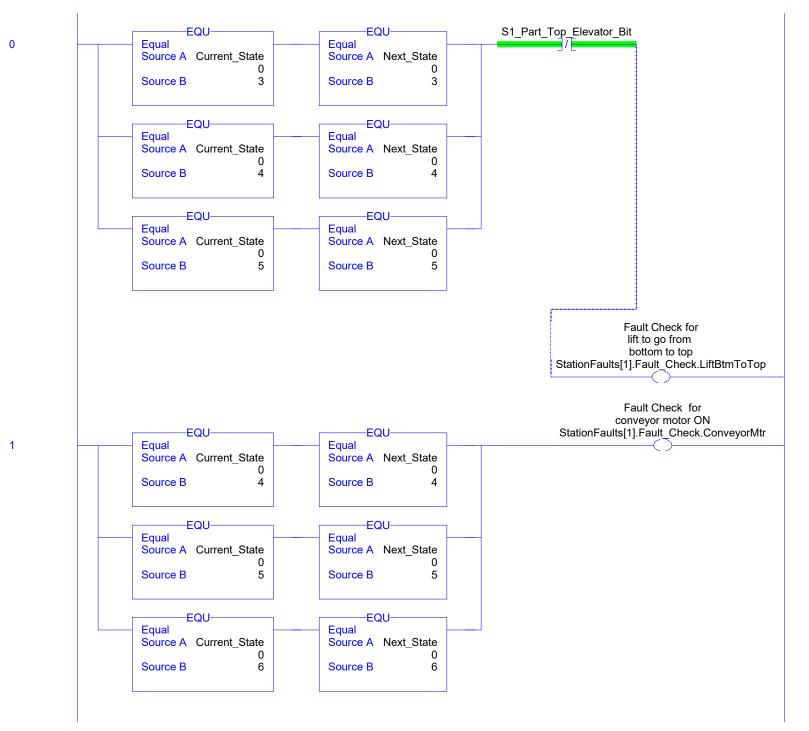
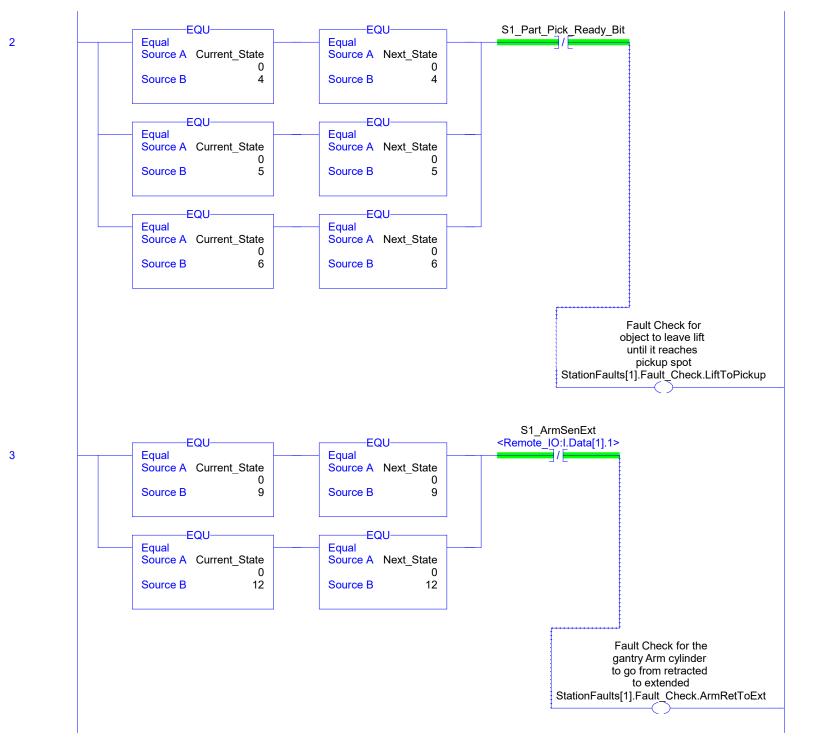
E:\Mechatronics Project\MultiStationMaster Version12.ACD



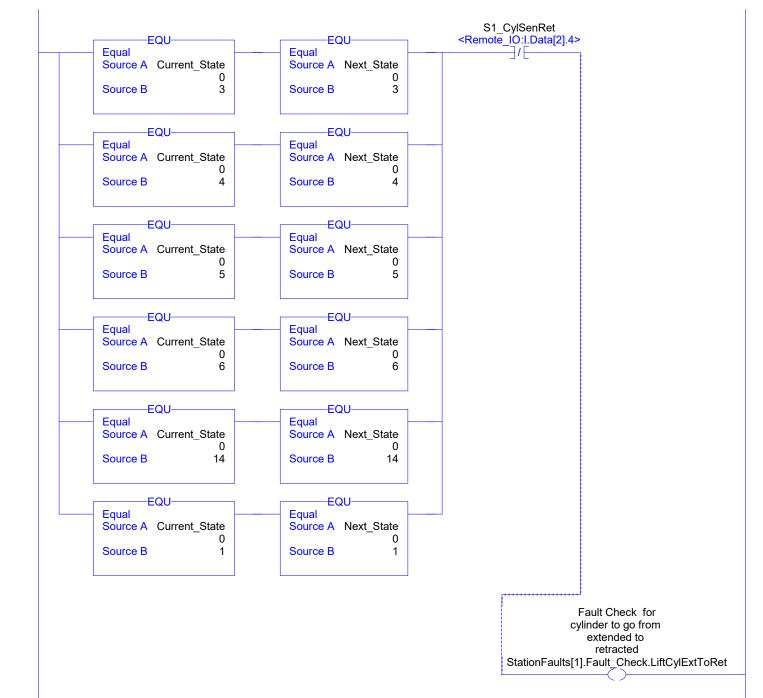


S1_CylSenExt <Remote_IO:I.Data[2].3> -EQU--EQU-Equal Equal Source A Current_State Source A Next_State 0 0 Source B 5 Source B 5 S1_Lift_Drop_timer.DN -EQU-EQU-Equal Equal Source A Current_State Source A Next_State Source B Source B Fault Check for cylinder to go from retracted to extended StationFaults[1].Fault_Check.LiftCylRetToExt

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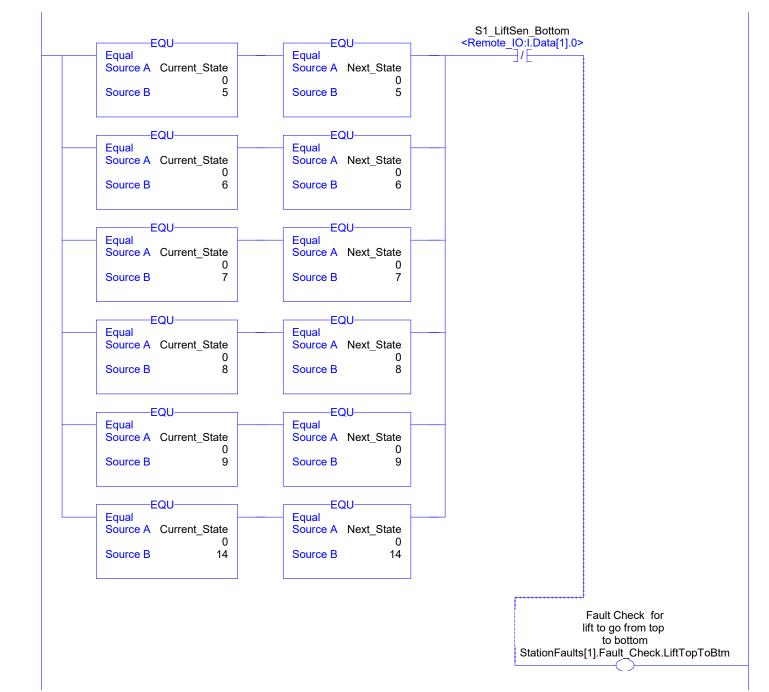
Total number of rungs in routine: 10

5



6

MultiStation_test:MainTask:Station1_Program Total number of rungs in routine: 10



S1_ArmSenRet <Remote_IO:I.Data[1].2> -EQU--EQU-Equal Equal Source A Current State Source A Next State 0 0 Source B Source B -EQU--EQU-Equal Equal Source A Current State Source A Next State 0 0 Source B Source B -EQU--EQU-Equal Equal Source A Current_State Source A Next_State Source B Source B 13 Fault Check for the gantry Arm cylinder to go from extended to retracted StationFaults[1].Fault Check.ArmExtToRet Fault Check for the motor on the Y-Axis S1 LimSw Y1 S1 LimSw Y2 to be on StationFaults[1].Fault_Check.MtrY <Remote_IO:O.Data[7].0> <Remote_IO:O.Data[7].1> 8 S1_LimSw_Y1 S1 LimSw Y2 <Remote_IO:O.Data[7].1> <Remote_IO:O.Data[7].0> Fault Check for the motor on the X-Axis S1 LimSw X1 S1_LimSw_X2 to be on StationFaults[1].Fault Check.MtrX <Remote IO:O.Data[7].3> <Remote IO:O.Data[7].2> 9 S1 LimSw X2 S1_LimSw_X1 <Remote_IO:O.Data[7].2> <Remote_IO:O.Data[7].3> (End)