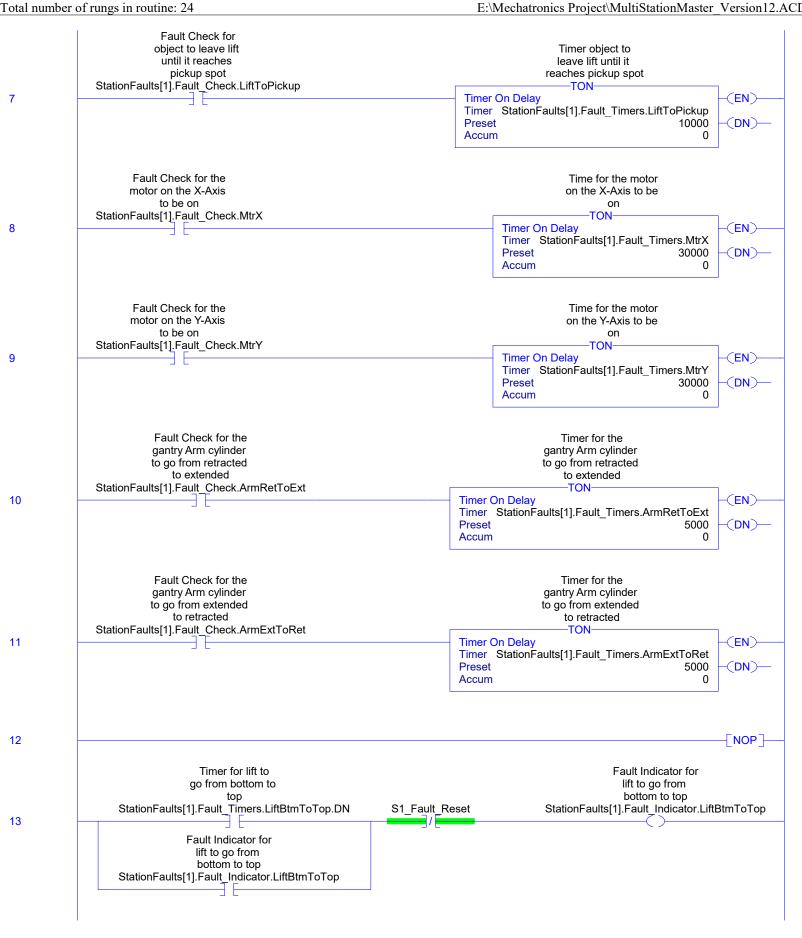**0**   s:fs

COP
Copy File
Source   StationFaults[0]
Dest   StationFaults[1]
Length   3

1   S1_Fault_Reset

COP
Copy File
Source   StationFaults[0]
Dest   StationFaults[1]
Length   1

2   Fault Check for lift to go from bottom to top
StationFaults[1].Fault_Check.LiftBtmToTop

Timer for lift to go from bottom to top
TON
Timer On Delay
Timer   StationFaults[1].Fault_Timers.LiftBtmToTop
Preset   5000
Accum   0
EN
DN

3   Fault Check for cylinder to go from retracted to extended
StationFaults[1].Fault_Check.LiftCylRetToExt

Timer for cylinder to go from retracted to extended
TON
Timer On Delay
Timer   StationFaults[1].Fault_Timers.LiftCylRetToExt
Preset   5000
Accum   0
EN
DN

4   Fault Check for cylinder to go from extended to retracted
StationFaults[1].Fault_Check.LiftCylExtToRet

Timer for cylinder to go from extended to retracted
TON
Timer On Delay
Timer   StationFaults[1].Fault_Timers.LiftCylExtToRet
Preset   3000
Accum   0
EN
DN

5   Fault Check for lift to go from top to bottom
StationFaults[1].Fault_Check.LiftTopToBtm

Timer for lift to go from top to bottom
TON
Timer On Delay
Timer   StationFaults[1].Fault_Timers.LiftTopToBtm
Preset   5000
Accum   0
EN
DN

6   Fault Check for conveyor motor ON
StationFaults[1].Fault_Check.ConveyorMtr

Timer for conveyor motor ON
TON
Timer On Delay
Timer   StationFaults[1].Fault_Timers.ConveyorMtr
Preset   10000
Accum   0
EN
DN

7

Fault Check for
object to leave lift
until it reaches
pickup spot
StationFaults[1].Fault_Check.LiftToPickup
─┤ ├─

Timer object to
leave lift until it
reaches pickup spot
TON
Timer On Delay   ⟨EN⟩
Timer   StationFaults[1].Fault_Timers.LiftToPickup
Preset   10000   ⟨DN⟩
Accum   0

8

Fault Check for the
motor on the X-Axis
to be on
StationFaults[1].Fault_Check.MtrX
─┤ ├─

Time for the motor
on the X-Axis to be
on
TON
Timer On Delay   ⟨EN⟩
Timer   StationFaults[1].Fault_Timers.MtrX
Preset   30000   ⟨DN⟩
Accum   0

9

Fault Check for the
motor on the Y-Axis
to be on
StationFaults[1].Fault_Check.MtrY
─┤ ├─

Time for the motor
on the Y-Axis to be
on
TON
Timer On Delay   ⟨EN⟩
Timer   StationFaults[1].Fault_Timers.MtrY
Preset   30000   ⟨DN⟩
Accum   0

10

Fault Check for the
gantry Arm cylinder
to go from retracted
to extended
StationFaults[1].Fault_Check.ArmRetToExt
─┤ ├─

Timer for the
gantry Arm cylinder
to go from retracted
to extended
TON
Timer On Delay   ⟨EN⟩
Timer   StationFaults[1].Fault_Timers.ArmRetToExt
Preset   5000   ⟨DN⟩
Accum   0

11

Fault Check for the
gantry Arm cylinder
to go from extended
to retracted
StationFaults[1].Fault_Check.ArmExtToRet
─┤ ├─

Timer for the
gantry Arm cylinder
to go from extended
to retracted
TON
Timer On Delay   ⟨EN⟩
Timer   StationFaults[1].Fault_Timers.ArmExtToRet
Preset   5000   ⟨DN⟩
Accum   0

12   ─[NOP]─

13

Timer for lift to
go from bottom to
top
StationFaults[1].Fault_Timers.LiftBtmToTop.DN
─┤ ├─

Fault Indicator for
lift to go from
bottom to top
StationFaults[1].Fault_Indicator.LiftBtmToTop
─┤ ├─

S1_Fault_Reset
─┤/├─

Fault Indicator for
lift to go from
bottom to top
StationFaults[1].Fault_Indicator.LiftBtmToTop
─( )─

14

Timer for cylinder to go from retracted to extended
StationFaults[1].Fault_Timers.LiftCylRetToExt.DN

S1_Fault_Reset

Fault Indicator for cylinder to go from retracted to extended
StationFaults[1].Fault_Indicator.LiftCylRetToExt

Fault Indicator for cylinder to go from retracted to extended
StationFaults[1].Fault_Indicator.LiftCylRetToExt

15

Timer for cylinder to go from extended to retracted
StationFaults[1].Fault_Timers.LiftCylExtToRet.DN

S1_Fault_Reset

Fault Indicator for cylinder to go from extended to retracted
StationFaults[1].Fault_Indicator.LiftCylExtToRet

Fault Indicator for cylinder to go from extended to retracted
StationFaults[1].Fault_Indicator.LiftCylExtToRet

16

Timer for lift to go from top to bottom
StationFaults[1].Fault_Timers.LiftTopToBtm.DN

S1_Fault_Reset

Fault Indicator for lift to go from top to bottom
StationFaults[1].Fault_Indicator.LiftTopToBtm

Fault Indicator for lift to go from top to bottom
StationFaults[1].Fault_Indicator.LiftTopToBtm

17

Timer for conveyor motor ON
StationFaults[1].Fault_Timers.ConveyorMtr.DN

S1_Fault_Reset

Fault Indicator for conveyor motor ON
StationFaults[1].Fault_Indicator.ConveyorMtr

Fault Indicator for conveyor motor ON
StationFaults[1].Fault_Indicator.ConveyorMtr

18

Timer object to leave lift until it reaches pickup spot
StationFaults[1].Fault_Timers.LiftToPickup.DN

S1_Fault_Reset

Fault Indicator for object to leave lift until it reaches pickup spot
StationFaults[1].Fault_Indicator.LiftToPickup

Fault Indicator for object to leave lift until it reaches pickup spot
StationFaults[1].Fault_Indicator.LiftToPickup

19

Time for the motor on the X-Axis to be on
StationFaults[1].Fault_Timers.MtrX.DN
S1_Fault_Reset ─]/[─
Fault Indicator for the motor on the X-Axis to be on
StationFaults[1].Fault_Indicator.MtrX ─( )─

Fault Indicator for the motor on the X-Axis to be on
StationFaults[1].Fault_Indicator.MtrX

20

Time for the motor on the Y-Axis to be on
StationFaults[1].Fault_Timers.MtrY.DN
S1_Fault_Reset ─]/[─
Fault Indicator for the motor on the Y-Axis to be on
StationFaults[1].Fault_Indicator.MtrY ─( )─

Fault Indicator for the motor on the Y-Axis to be on
StationFaults[1].Fault_Indicator.MtrY

21

Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[1].Fault_Timers.ArmRetToExt.DN
S1_Fault_Reset ─]/[─
Fault Indicator for the gantry Arm cylinder to go from retracted to extended
StationFaults[1].Fault_Indicator.ArmRetToExt ─( )─

Fault Indicator for the gantry Arm cylinder to go from retracted to extended
StationFaults[1].Fault_Indicator.ArmRetToExt

22

Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[1].Fault_Timers.ArmExtToRet.DN
S1_Fault_Reset ─]/[─
Fault Indicator for the gantry Arm cylinder to go from extended to retracted
StationFaults[1].Fault_Indicator.ArmExtToRet ─( )─

Fault Indicator for the gantry Arm cylinder to go from extended to retracted
StationFaults[1].Fault_Indicator.ArmExtToRet

23

Fault Indicator for
lift to go from
bottom to top
StationFaults[1].Fault_Indicator.LiftBtmToTop

S1_Fault_Reset

S1_FaultFlag

Fault Indicator for
cylinder to go from
retracted to
extended
StationFaults[1].Fault_Indicator.LiftCylRetToExt

Fault Indicator for
cylinder to go from
extended to
retracted
StationFaults[1].Fault_Indicator.LiftCylExtToRet

Fault Indicator for
lift to go from top
to bottom
StationFaults[1].Fault_Indicator.LiftTopToBtm

Fault Indicator for
conveyor motor ON
StationFaults[1].Fault_Indicator.ConveyorMtr

Fault Indicator for
object to leave lift
until it reaches
pickup spot
StationFaults[1].Fault_Indicator.LiftToPickup

Fault Indicator for
the motor on the
X-Axis to be on
StationFaults[1].Fault_Indicator.MtrX

Fault Indicator for
the motor on the
Y-Axis to be on
StationFaults[1].Fault_Indicator.MtrY

Fault Indicator for
the gantry Arm
cylinder to go from
retracted to
extended
StationFaults[1].Fault_Indicator.ArmRetToExt

Fault Indicator for
the gantry Arm
cylinder to go from
extended to
retracted
StationFaults[1].Fault_Indicator.ArmExtToRet

S1_FaultFlag

(End)