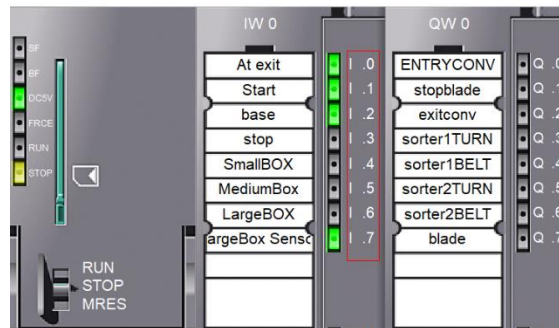## -Connections (PLC):

PLC Program:

"Sorting Station"

Block comment=

Network comment=

```
"Start"          "ENTRYCONV"
--| |----------------( )----

"ENTRYCONV"      "exitconv"
--| |----------------( )----
```

Network comment=

```
"Start"          "sorter2BELT"
--| |----------------( )----

"sorter2BELT"    "sorter1BELT"
--| |----------------( )----
```

Network comment=

```
"SmallBOX"       "MediumBox"      "sorter1TURN"
--| |---------------|/|----------------( )----

"sorter1TURN"
--| |----
```

Network comment=

```
"MediumBox"      "LargeBOX"       "sorter2TURN"
--| |---------------|/|----------------( )----

"sorter2TURN"
--| |----
```

Network comment=

```
                 T0
"At exit"     T (SP)  Q      "sorter1TURN"
--| |--------|          |--------( R )----
      SST#4S -- TV    BI --...
        ... -- R  .. BCD --...
```

Network comment=

```
                 T1
"At exit"     T (SP)  Q      "sorter2TURN"
--| |--------|          |--------( R )----
      SST#4S -- TV    BI --...
        ... -- R  .. BCD --...
```

Network comment=

```
"sorter1TURN"    "stopblade"
--| |----------------( S )----
```

Network comment=

```
"sorter2TURN"    "stopblade"
--| |----------------( S )----
```

Network comment=

```
"At exit"        "stopblade"
--| |----------------( R )----
```

Network comment=

```
"At exit"        "stopblade"
--| |----------------( R )----
```

Network comment=

```
"SmallBOX"       "MediumBox"      "LargeBOX"      T4                "stopblade"
--| |---------------| |--------------| |-------T (SD)  Q-------------( )----
"stopblade"                                  |          |
--| |----                          SST#2S -- TV    BI --...
                                        ... -- R  .. BCD --...
```