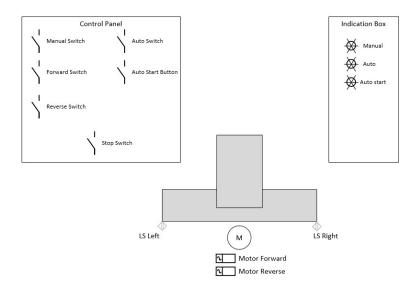
Drilling Control Machine



Manual operation:

- When *Forward Switch* is ON, motor moves forward. It can be stopped by *Stop Switch*. When the drill touches *Limit Switch Right*, the motor is cut-off.
- When *Reverse Switch* is ON, motor moves in reverse. It can be stopped by *Stop Switch*. When the drill touches *Limit Switch Left*, the motor is cut-off.

Automatic operation:

When *Auto Start Button* and *Limit Switch Left* are ON, the motor moves forward until *Limit Switch Right* is activated. The Timer makes delay of 4 sec. and motor reverses after this time. When it returns to *Limit Switch Left* position, the cycle is repeated.

```
PROGRAM MAIN
    VAR
3
        // Control Buttons
ManualSwitch: BOOL;
        AutoSwitch: BOOL;
        AutoStartButton: BOOL;
        ForwardSwitch: BOOL;
        ReverseSwitch: BOOL;
        StopSwitch: BOOL;
        // Limit switches
        LimitSwitchRight: BOOL;
        LimitSwitchLeft: BOOL;
        // Operation modes
        ManualMode: BOOL;
        AutoMode: BOOL;
        AutoStart: BOOL;
        ManualForward: BOOL;
        ManualReverse: BOOL;
        ConfirmAutoForward: BOOL;
        AutoForward: BOOL;
        AutoReverse: BOOL;
14
15
16
        // Output coils
        MotorForward: BOOL;
        MotorReverse: BOOL;
        // Aux. blocks
30
        tonForward: TON;
    END VAR
```

Actor Deficiency Deficien	1	Manual indication	
Accordance Semantification Accordance Semantification Accordance Semantification Semanti		ManualSwitch AutoSwitch	
Accidence Managification of Control Managifi			()
Manual Contract Manual Manual Manual Contract Manual Contrac	2	Auto indication	
Manual Toward Manual Movement Manual Movem			
Status Hotel France Status Hotel		- 1	()
Manual Process Manual Process	3	Manual forward	
Handle Fewer Handle Sophiston Limithus older Handle		ManualMode ForwardSwitch StopSwitch LimitSwitchRight ManualReverse	
Manual lowerse Manual coverse Manu			
Manual Reverse Manual Reverse			
Manual Reverse Manu			
Mutableware Autodeat Autodeat Autodeat Autodeat Linitarioreward Autoforward	4	Manual reverse	
Manual Reverse Autoflore Autofl		ManualMode ReverseSwitch StopSwitch LimitSwitchLeft ManualForward	
AutoSteet AutoSteet AutoSteet AutoSteet AutoSteet AutoSteet ConfirmAntoForward AutoForward AutoForward AutoForward AutoSteet ConfirmAntoForward AutoSteet ConfirmAntoForward THAS THAS THAS AutoSteet Auto			()
Autoforward Autof			
AutoStart			
Autoforward Autoforward	5	Auto start	
Autoforward Occitimatoforward IN Occitimatofo		AutoMode AutoStartButton LimitSwitchLeft StopSwitch	
Confirmation of covered Autoforward Autoforward Autoforward Autoforward Confirmation forward Autoforward Confirmation forward Autoforward Confirmation forward Title F2 Title F2 Monation of Confirmation forward Autoforward Confirmation forward Title F2 Autoforward Monation of Confirmation forward Autoforward Confirmation forward Confirmation forward Autoforward Autoforward Autoforward Monation of Confirmation forward Autoforward Monation of Confirmation forward Autoforward Monation of Confirmation forward Monation of		10 10 10	(J
Confirmation of covered Autoforward Autoforward Autoforward Autoforward Confirmation forward Autoforward Confirmation forward Autoforward Confirmation forward Title F2 Title F2 Monation of Confirmation forward Autoforward Confirmation forward Title F2 Autoforward Monation of Confirmation forward Autoforward Confirmation forward Confirmation forward Autoforward Autoforward Autoforward Monation of Confirmation forward Autoforward Monation of Confirmation forward Autoforward Monation of Confirmation forward Monation of		AutoStart	
AutoForward AutoForward AutoForward AutoForward AutoForward AutoForward ConfirmatioForward AutoForward AutoForward AutoForward AutoForward ConfirmatioForward TAUS TO PETERAD Motor FORMAD Manual Forward			
Autoforward Autoforward Autoforward Autoforward Autoforward Autoforward Autoforward Confirmautoforward Confirmautoforward THAS - FT		ConfirmAutoForward	
AutoForward AutoForward Confirm autoForward AutoForward LimitSwitchleft ConfirmAutoForward Confirm autoForward ConfirmAutoForward ConfirmAutoForward T#45 FI D T T T T T T T T T T T T T T T T T T			
AutoForward AutoForward Confirm autoForward AutoForward LimitSwitchleft ConfirmAutoForward Confirm autoForward ConfirmAutoForward ConfirmAutoForward T#45 FI D T T T T T T T T T T T T T T T T T T	6	Turks Samural	
AutoForward AutoMode LimitSwitchRight LimitSwitchLeft StopSwitch ConfirmAutoForward TonForward Ton		550-550-650-6	
Confirm auto forward AutoMode LimitSwitchRight LimitSwitchLeft StopSwitch ConfirmAutoForward ConfirmAutoForward ConfirmAutoForward ConfirmAutoForward Auto reverse tonForward.Q AutoReverse Motor FORWARD ManualForward AutoForward AutoForward AutoForwa		Autostare Emiliasticinete Confirmationorward Stopswicen	
Confirm auto forward AutoMode LimitSwitchRight LimitSwitchLeft StopSwitch ConfirmAutoForward ConfirmAutoForward ConfirmAutoForward ConfirmAutoForward Auto reverse tonForward.Q AutoReverse Motor FORWARD ManualForward AutoForward AutoForward AutoForwa			
Confirm auto forward AutoMode LimitSwitchRight LimitSwitchLeft StopSwitch ConfirmAutoForward ConfirmAutoForward TM THAS PI DET AutoReverse TonForward AutoPorward Motor FORWARD ManualForward MotorForward MotorForward MotorForward AutoPorward MotorReverse MotorReverse MotorReverse AutoReverse MotorReverse			
AutoMode LimitSwitchRight LimitSwitchLeft StopSwitch ConfirmAutoForward TON TH4S - FT	7	Confirm with Formand	
Confirmation forward Taks — ET			G6(
ConfirmAutoForward T+4S = FT TON O ET		Automode Limitswitchkight Limitswitchkeit Stopswitch	
Auto reverse tonForward.Q Motor FORWARD ManualForward AutoForward AutoForward MotorForward AutoForward AutoForward AutoForward AutoForward MotorReverse MotorReverse MotorReverse		tonForward	
Autoreverse tonForward.Q Motor FORWARD ManualForward AutoForward MotorForward MotorForward AutoForward AutoForward Motor REVERSE ManualReverse MotorReverse MotorReverse		IUN	
tonForward.Q Motor FORWARD ManualForward AutoForward AutoForward MotorForward () Motor REVERSE ManualReverse MotorReverse MotorReverse		T#4S — PT ET —	
tonForward.Q Motor FORWARD ManualForward AutoForward AutoForward MotorForward () Motor REVERSE ManualReverse MotorReverse MotorReverse	8	Auto reverse	
Motor FORWARD ManualForward AutoForward Motor REVERSE ManualReverse MotorReverse MutoReverse		5000 (CONSTRUCTOR)	AutoReverse
ManualForward AutoForward Motor Reverse ManualReverse MutoReverse MutoReverse			
AutoForward Motor REVERSE ManualReverse MotorReverse AutoReverse	9	Motor FORWARD	
AutoForward Motor REVERSE MotorReverse MotorReverse		ManualForward	MotorForward
Motor REVERSE Manual Reverse MotorReverse AutoReverse			D
Motor REVERSE Manual Reverse MotorReverse AutoReverse		autoForward	
ManualReverse MotorReverse MotorReverse			
ManualReverse MotorReverse MotorReverse			
AutoReverse	10	Motor REVERSE	
AutoReverse			
AutoReverse			W 19
		AutoReverse	