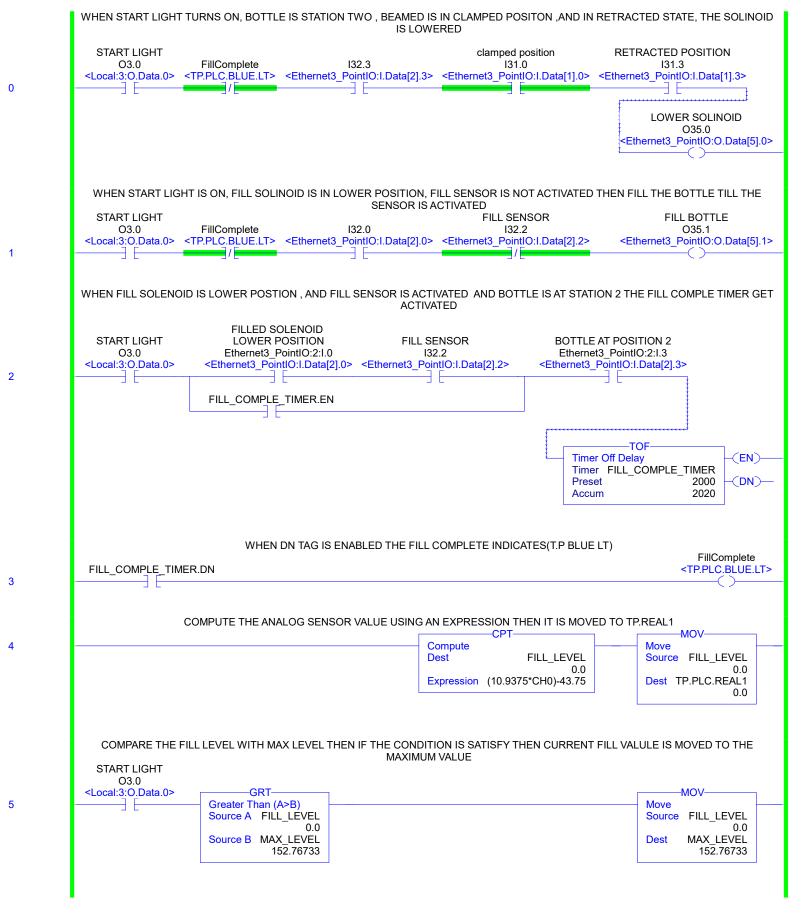
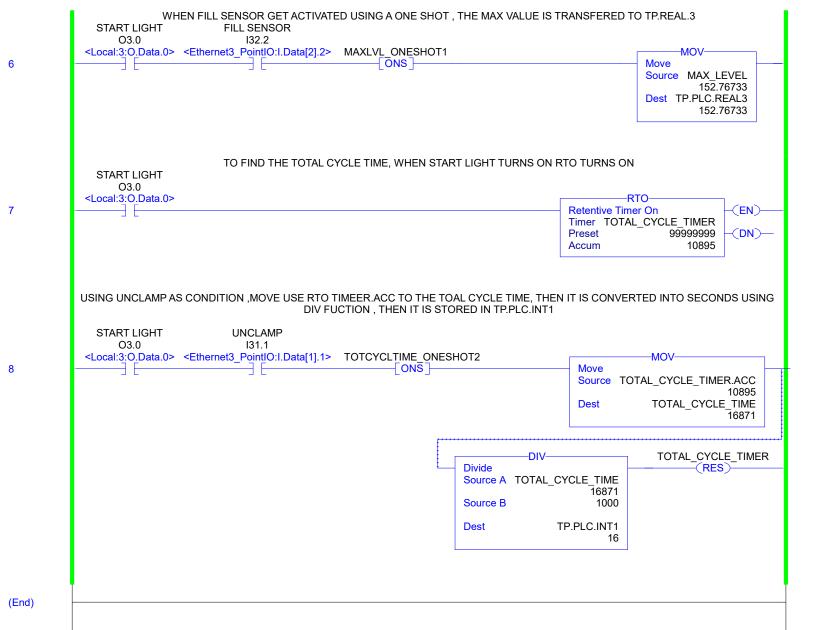
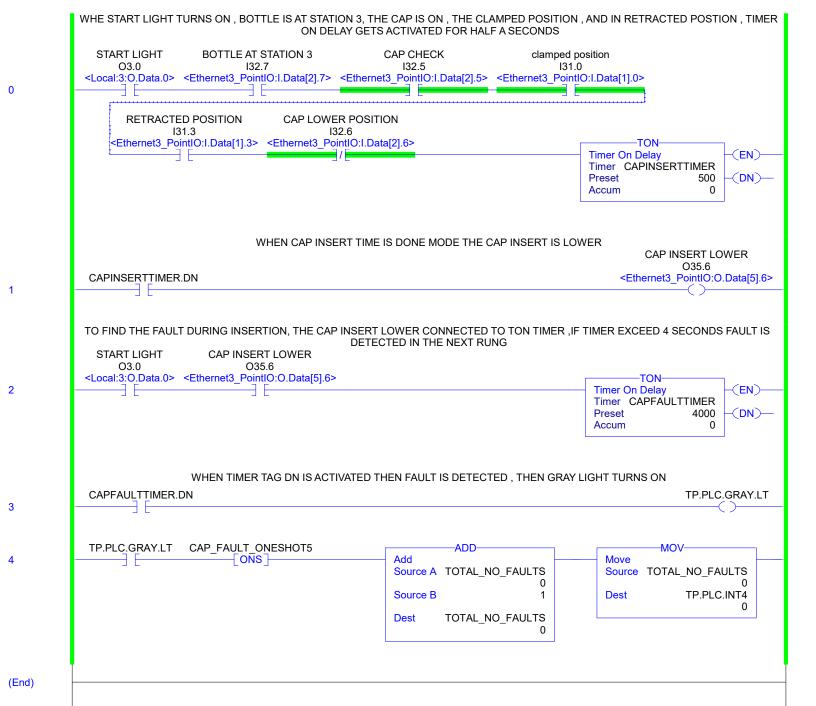


Total number of rungs in routine: 9 ...ming\Unit 2\PROJECT\FILES\Project 2 Template with P1 Solution.ACD

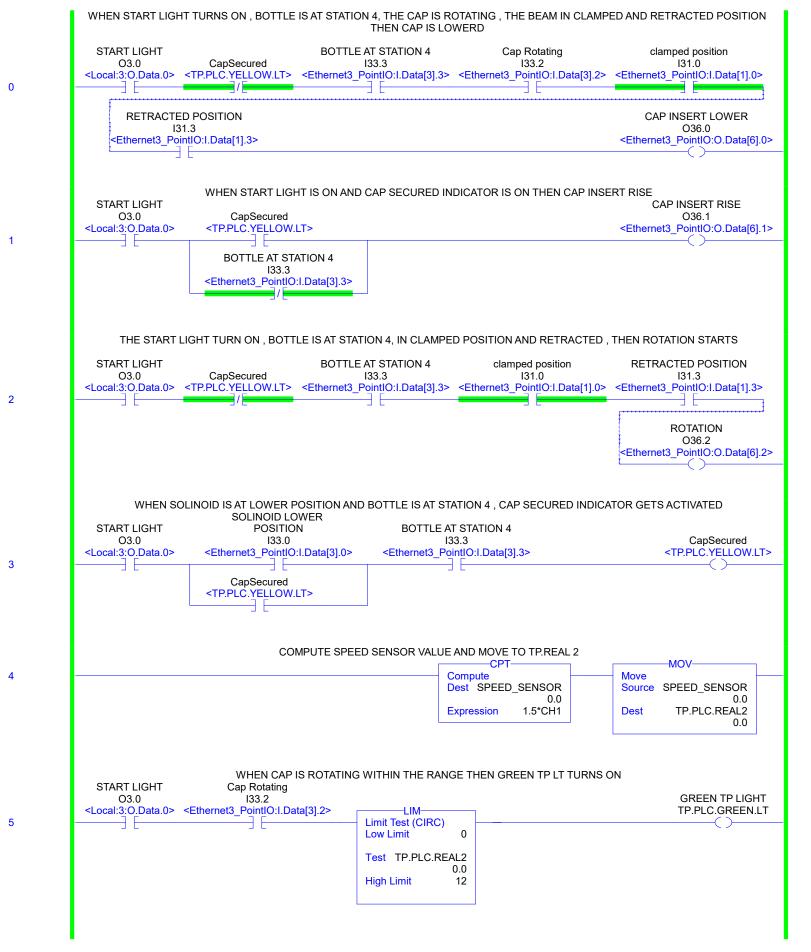


Total number of rungs in routine: 9 ...ming\Unit 2\PROJECT\FILES\Project 2 Template with P1 Solution.ACD





Total number of rungs in routine: 6 ...ming\Unit 2\PROJECT\FILES\Project 2 Template with P1 Solution.ACD



R03_CapSecureStn - Ladder Diagram PROJECT2:MainTask:MainProgram Total number of rungs in routine: 6 **Page 6** 2022-03-19 3:41:26 PM

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(End)

WHEN START LIGHT IS ON AND WALKING BEAM IS IN RETRACTED POSITION THE BEAM CLAMPS START LIGHT RETRACTED POSITION CLAMP 131.3 O34.0 O3.0 <Local:3:O.Data.0> <Ethernet3 PointIO:I.Data[1].3> <Ethernet3 PointIO:O.Data[4].0> WHEN FILL SENSOR ON, TIMER ON DELAY ACTIVATES FILL SENSOR START LIGHT O3.0 132.2 <Local:3:O.Data.0> <Ethernet3 PointIO:I.Data[2].2> TON-Timer On Delay (EN) Timer FILLSENSDELAYTIMER Preset 500 (DN) Accum 0 FOR EXTENDING WALKING BEAM THE START LIGHT AND BEAM SHOULD BE IN RETRACTED POSITION. CLAMPED POSITION.AND TIMER SET TO .5 SECONDS, AND STOPS EXTENDING TILL REACHES THE EXTENDING POSTION RETRACTED POSITION START LIGHT START LIGHT EXTENDED POSITION clamped position O3.0 O3.0 131.3 131.0 131.2 <Local:3:O.Data.0> <Local:3:O.Data.0> <Ethernet3_PointIO:I.Data[1].3> <Ethernet3_PointIO:I.Data[1].0> <Ethernet3 PointIO:I.Data[1].2> CAP LOWER POSITION 132 6 <Ethernet3 PointIO:I.Data[2].6> FILLSENSDELAYTIMER.DN / EXTEND WALKING BEAM O34.2 <Ethernet3_PointIO:O.Data[4].2> EXTEND WALKING BEAM 034.2 Ethernet3 PointIO:O.Data[4].2> WHEN START LIGHT TURNS ON AND WHEN IT IS IN EXTENDED POSTION, UNCLAMP TAKE PLACE START LIGHT **EXTENDED POSITION UNCLAMP** O34.1 131.2 O3.0 <Ethernet3 PointIO:I.Data[1].2> <Ethernet3 PointIO:O.Data[4].1> <Local:3:O.Data.0> 3 WHEN START LIGHT IS ON, WHEN IT IS EXTENDED POSTION, AND WHEN IT IS UNCLAMPED, RETRACTION TAKE PLACE START LIGHT **EXTENDED POSITION UNCLAMP** RETRACTED POSITION O3.0 131.2 131.1 131.3 <Ethernet3_PointIO:I.Data[1].3> <Ethernet3_PointIO:I.Data[1].2> <Ethernet3_PointIO:I.Data[1].1> <Local:3:O.Data.0> RETRACTION O34.3 <Ethernet3_PointIO:O.Data[4].3> RETRACTION O34.3 Ethernet3_PointIO:O.Data[4].3>

(End)

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WHEN BOTTLE IS AT POSITON 5, THE COUNTER ACTIVATES AND COUNTS THE NO OF BOTTLES START LIGHT **BOTTLE AT POSITION 5** O3.0 133.6 <Local:3:O.Data.0> <Ethernet3 PointIO:I.Data[3].6> Count Up (CU) Counter NO_OF_BOTTLES -(DN)-Preset 99999999 Accum WHEN BLUE TP PB IS PRESSED THE NO OF BOTTLES IN ACC IS MOVED TO CURRENT NO OF BOTTLES AND USING THE ADD FUNCTION THE CURRENT NO OF BOTTLE IS STORED IN TOTAL NO OF BOTTLE THEN COUTER IS RESETED START LIGHT O3.0 TP.PLC.BLUE.PB NOOFBOT_ONESHOT3 <Local:3:O.Data.0> -ADD-[ONS] Add 3 E TOTAL_NO_OF_BOT Source A Source B NO OF BOTTLES.ACC TOTAL_NO_OF_BOT Dest NO OF BOTTLES -MOV-Move (RES) Source TOTAL_NO_OF_BOT TP.PLC.INT3 Dest MOVE THE NO OF BOTTLES.ACC TO TP.PLC.INT2 -MOV-Move Source NO_OF_BOTTLES.ACC TP.PLC.INT2 1