PLC Program Version 39 Timer Data

Timer Address	*Description of Timer Purpose*	*Time (in seconds)*
ID SECTION		
000	The time it takes for the part to get from the PPG Sensor to the closed exit gate.	6
001	The time required to push the part into the station from the conveyor.	3
002	The time it takes for the pusher to get out of the way of the clamps.	1
003	The time it takes to fully clamp the part from the first signal to clamp.	2
004	The time it takes to fully unclamp from the first signal to unclamp.	1
005	The time to wait before opening the front gate upon reset.	2
006	The time it takes for the PUSH/ELEVATE to retract to home after losing signal.	3
007	The time it takes to fully PUSH/ELEVATE from first activation signal.	6
008	Length of SYSTEM RESET pulse.	0.2
009	Length of time the trap door should be open upon activation.	2
010	The time it takes for the JURASSIC GATE to open.	1.5
TESTING SECTION		
100	The time it takes to pull in the part.	3
101	Length of the carrier PAG notification oneshot.	2
102	Length of the on-delay formant for PAG oneshot. (Pulse is .5 with 3 and 2.5)	1.5
103	Collision avoidance delay for station 2 and 3 work.	20
104	UNUSED Pull in mechanism retraction time (must be amount (2) plus TIM100 amou	7
105	The time it takes to clamp.	2
106	The time it takes to forward (static) rotate.	2
107	The time it takes to unclamp all three clamps.	1.5
108	The time it takes to backward (dynamic) rotate.	3
109	“REORIENT DONE” notification oneshot pulse length	0.5
110	Length of Buzzer state.	3
111	Length of LED testing state.	5
112	The time it takes to unclamp only main clamps.	1.5
113	The time it takes to PUSH OUT.	4
114	The length of time the EXIT GATE should stay open immediately after unclamped.	8
115	The length of time until SEQ START after unclamped.	10
116	The pulse width of the SEQ START pulse.	0.3

117	UNUSED Duplicate of 104	7
118	The time it takes to pull the part in (not retract.)	3
119	The time it takes to reseat the part (not retract.)	3

FEEDER SECTION

(push times)

301	Feeder 1 Push Oneshot Length	3
302	Feeder 2 Push Oneshot Length	3

(part times – all offset from T=0 start time)

200	Time offset from 0 for SEQUENCE END	999.9
201	Time offset from 0 for PART 1 to be ejected. (Large)	1
202	Time offset from 0 for PART 2 to be ejected. (Electronic)	1
203	Time offset from 0 for PART 3 to be ejected. (Reject)	8
204	Time offset from 0 for PART 4 to be ejected. (Small)	26
205	Time offset from 0 for PART 5 to be ejected. (Large)	48.5
206	Time offset from 0 for PART 6 to be ejected. (Electronic)	70
207	Time offset from 0 for PART 7 to be ejected. (Small)	121
208	Time offset from 0 for PART 8 to be ejected. (Large)	130
209	Time offset from 0 for PART 9 to be ejected. (Reject)	158
210	Time offset from 0 for PART 10 to be ejected. (Electronic)	170
211	Time offset from 0 for PART 8 to be ejected. (Large)	178
212	Time offset from 0 for PART 9 to be ejected. (Small)	198
213	Time offset from 0 for PART 10 to be ejected. (Reject)	245