

Component	Signal Name	Signal Type	Data Type	Comment
Rotary Indexing Table	Emergency Stop	Input	bool	Emergency Stop (0, when activated)
	Start	Input	bool	Start Button (1, when activated)
	Stop	Input	bool	Stop Button (1, when activated)
	TableInPosition	Input	bool	Rotary indexing table is in position
	TableRotating	Input	bool	Rotary indexing table is rotating (0, when rotating)
	TableAutomatic	Input	bool	Rotary indexing table in automatic mode
	TableManual	Input	bool	Rotary indexing table in manual mode
	StartTable	Output	bool	Start rotary indexing table (rotation)
	Station1_start	Marker	bool	(internal) Starting signal for Station 1
	Station2_start	Marker	bool	(internal) Starting signal for Station 2
	Station3_start	Marker	bool	(internal) Starting signal for Station 3
	Station5_start	Marker	bool	(internal) Starting signal for Station 5
	Station6_start	Marker	bool	(internal) Starting signal for Station 6
	Station7_start	Marker	bool	(internal) Starting signal for Station 7
Station 1	LinearBack1	Input	bool	Linear unit is in rear position
	LinearFront1	Input	bool	Linear unit is in front position
	HandlingUp1	Input	bool	Gripper is in upper position
	HandlingDown1	Input	bool	Gripper is in lower position
	ClampOpen1	Input	bool	Gripper clamp is open
	ClampClosed1	Input	bool	Gripper clamp is closed
	PartInSingulation1	Input	bool	Test part in singulation
	PartEntered1	Input	bool	Test part in transfer area
	PreSingulationUp1	Input	bool	Pre-singulation in upper position
	PreSingulationDown1	Input	bool	Pre-singulation in lower position
	SingulationDown1	Input	bool	Singulation in lower position
	SingulationUp1	Input	bool	Singulation in upper position
	ConveyorBelt	Output	bool	Turn on conveyor belt
	PreSingulation1	Output	bool	Pre-singulation down (when activated)
	Singulation1	Output	bool	Singulation up (when activated)
	LinearUnit1	Output	bool	Move linear unit to Station 1
	Handling1	Output	bool	Handling unit down (when activated)
	Clamp1	Output	bool	Close handling clamp
	Station1_finished	Marker	bool	= 1, when processing is complete
Station 2	PressingUp2	Input	bool	Piston in upper position
	PressingDown2	Input	bool	Piston in lower position
	Pressing2	Output	bool	Press part down
	Fault2	Marker	bool	Station 2: Fault
	Station2_finished	Marker	bool	= 1, when processing is complete
Station 3	ClampingUp3	Input	bool	Clamping in upper position
	ClampingDown3	Input	bool	Clamping in lower position
	PlungerUp3	Input	bool	Plunger in upper position
	PlungerDown3	Input	bool	Plunger in lower position
	TriggerBack3	Input	bool	Trigger in rear position
	TriggerFront3	Input	bool	Trigger in front position
	Clamping3	Output	bool	Clamping cylinder down
	Plunger3	Output	bool	Switching plunger down
	Trigger3	Output	bool	Move trigger to Station 3
	Station3_finished	Marker	bool	= 1, when processing is complete
Station 5	TriggerBack5	Input	bool	Trigger in rear position
	TriggerFront5	Input	bool	Trigger in front position
	ClampingUp5	Input	bool	Clamping in upper position
	ClampingDown5	Input	bool	Clamping in lower position

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	PlungerUp5	Input	bool	Plunger in upper position
	PlungerDown5	Input	bool	Plunger in lower position
	Control1	Input	bool	Contacting control 1 performed
	Control2	Input	bool	Contacting control 2 performed
Station 5	ContactingBack5	Input	bool	Contacting in rear position
	ContactingFront5	Input	bool	Contacting in front position
	Clamping5	Output	bool	Clamping cylinder down
	Plunger5	Output	bool	Switching plunger down
	Trigger5	Output	bool	Move trigger to Station 5
	Contacting5	Output	bool	Move contacting to Station 5
	GOODPART	Marker	bool	= 1 for good part; = 0 for bad part
	Station5_finished	Marker	bool	= 1, when processing is complete
Station 6	StampBack6	Input	bool	Stamp in rear position
	StampFront6	Input	bool	Stamp in front position
	Stamping6	Output	bool	Move stamp cylinder to Station 6
	Station6_finished	Marker	bool	= 1, when processing is complete
Station 7	LinearBack7	Input	bool	Linear unit in rear position
	LinearFront7	Input	bool	Linear unit in front position
	HandlingUp7	Input	bool	Gripper in upper position
	HandlingDown7	Input	bool	Gripper in lower position
	ClampOpen7	Input	bool	Gripper clamp open
	ClampClosed7	Input	bool	Gripper clamp closed
	LinearInPos7	Input	bool	Linear drive in bad position
	PartOnTable7	Input	bool	Workpiece at transfer point from rotary table to Station 7
	LinearUnitForward7	Output	bool	Move linear unit forward
	LinearUnitBack7	Output	bool	Move linear unit back
	Handling7	Output	bool	Handling unit down
	Clamp7	Output	bool	Close handling clamp
	Station7_finished	Marker	bool	= 1, when processing is complete