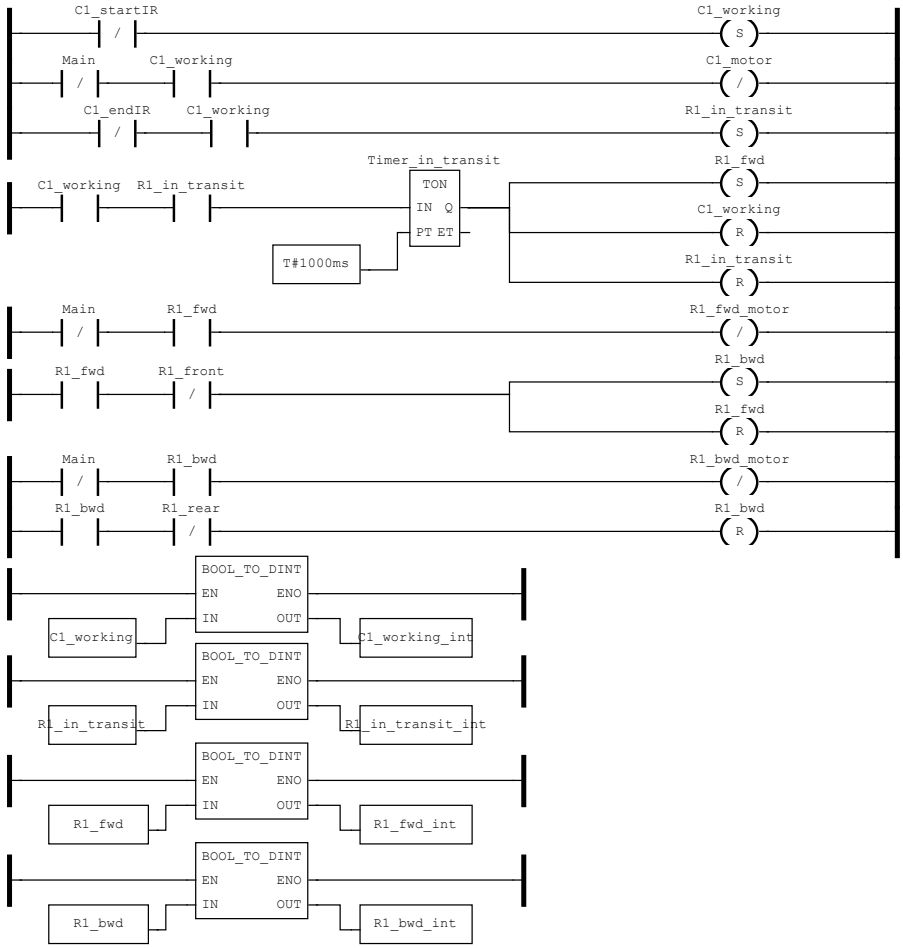
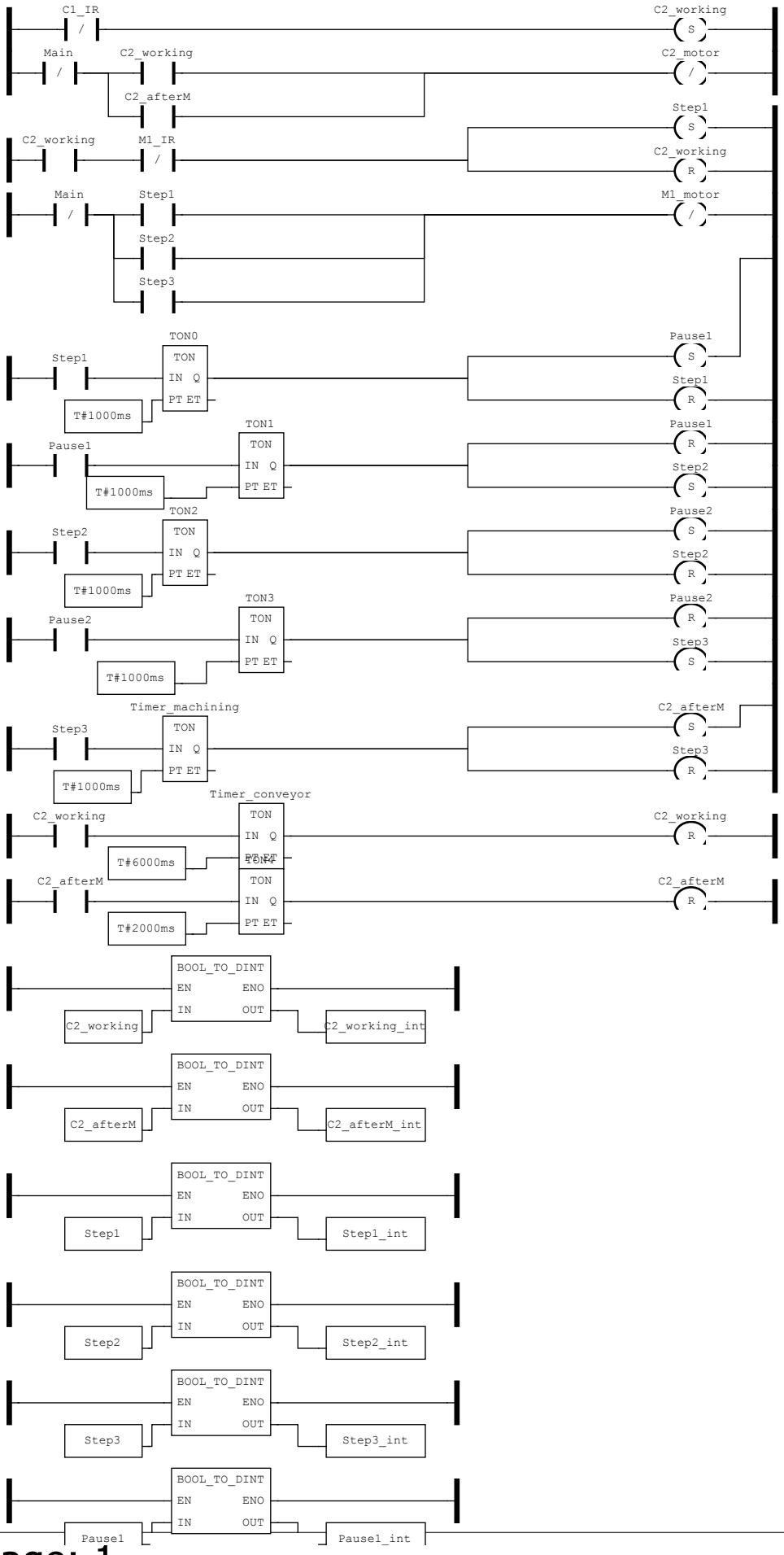
# Cell1

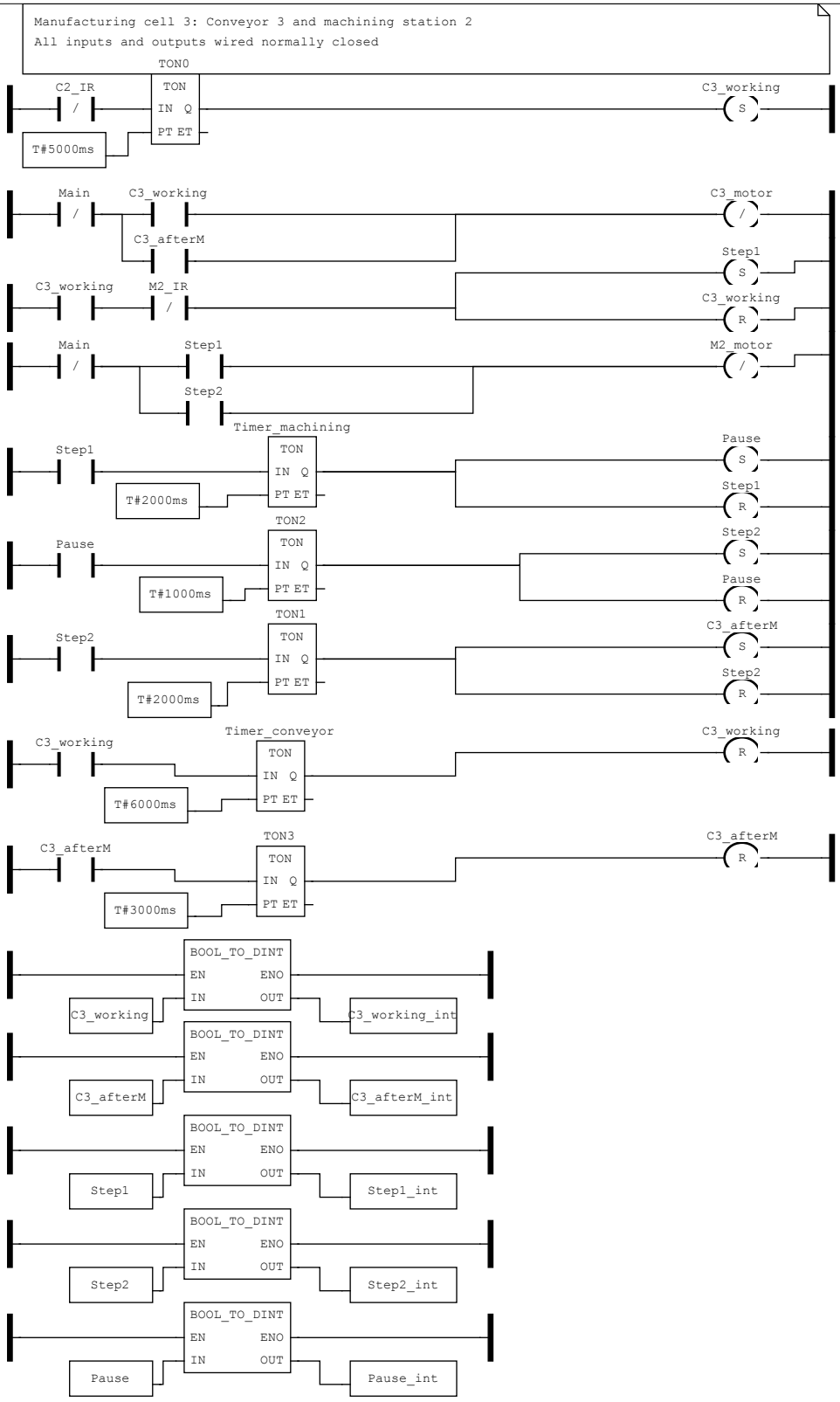
Manufacturing cell 1: Conveyor 1 and ram 1
Note: all inputs and outputs wired normally closed



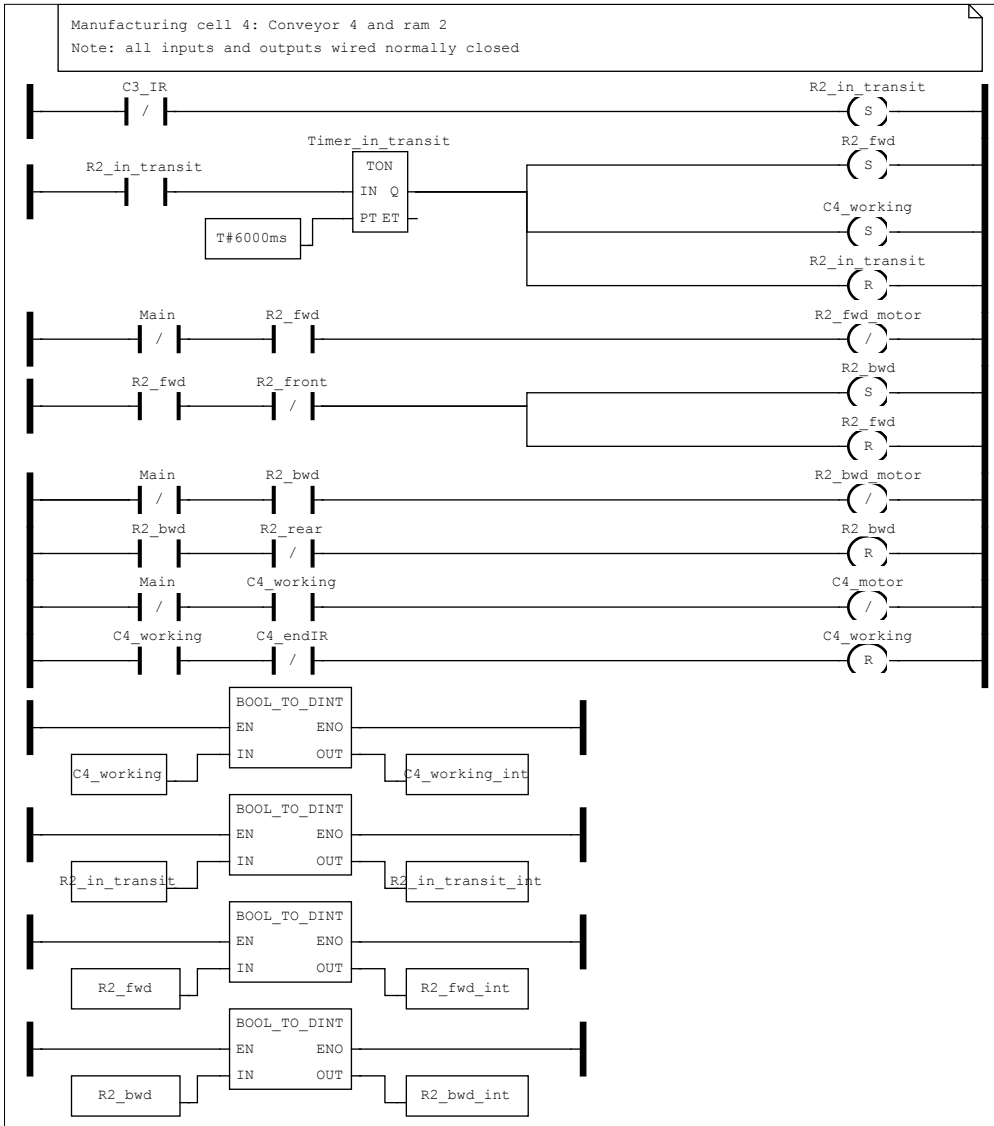
Manufacturing cell 2: Conveyor 2 and machining station 1
All inputs and outputs wired normally closed



# Cell3


Manufacturing cell 3: Conveyor 3 and machining station 2
All inputs and outputs wired normally closed
TON0
C2_IR
TON
IN Q
PT ET
T#5000ms
C3_working
S
Main
C3_working
C3_afterM
C3_motor
Step1
C3_working
M2_IR
R
Step2
M2_motor
Timer_machining
T#2000ms
Pause
TON2
T#1000ms
TON1
C3_afterM
Timer_conveyor
T#6000ms
TON3
T#3000ms
BOOL_TO_DINT
EN ENO
IN OUT
C3_working_int
C3_afterM_int
Step1_int
Step2_int
Pause_int

# Cell4


Manufacturing cell 4: Conveyor 4 and ram 2
Note: all inputs and outputs wired normally closed
C3_IR
/
R2_in_transit
S
Timer_in_transit
TON
IN Q
PT ET
T#6000ms
R2_in_transit
R2_fwd
S
C4_working
S
R2_in_transit
R
Main
/
R2_fwd
R2_fwd_motor
/
R2_fwd
/
R2_front
/
R2_bwd
S
R2_fwd
R
Main
/
R2_bwd
R2_bwd_motor
/
R2_bwd
/
R2_rear
/
R2_bwd
R
Main
/
C4_working
C4_motor
/
C4_working
C4_endIR
/
C4_working
R
BOOL_TO_DINT
EN ENO
IN OUT
C4_working
C4_working_int
BOOL_TO_DINT
EN ENO
IN OUT
R2_in_transit
R2_in_transit_int
BOOL_TO_DINT
EN ENO
IN OUT
R2_fwd
R2_fwd_int
BOOL_TO_DINT
EN ENO
IN OUT
R2_bwd
R2_bwd_int