

Sensor Pallet Stop RFID2 (Cell 2 Hold Back Stop) PPX2 <Conv\_N053:LData[3].0> Part in transit from hold back to robot stop Cell\_2.PartEnte RFID Tag at Cell 2 Hold Back Stop RFID\_N054:I.Channel[1].TagPresent> Timer On Delay
Timer DeBounce3
Preset 500
Accum Mode\_Start ring -CEND RFID Tag at Cell 2 Hold Back Stop -(ND)-Mode\_Semi RFIDTP2 <RFID\_N054:I.Channel[1].TagPresent> Sensor Pallet Stop RFID3 (Cell 2 Fanuc Robot Stop) PPX3 Part in transit from hold back to robot stop Cell\_2.PartEnte Manifold\_N058:1 :O.Pt04Data <Conv\_N053:I.Data[3].1> Mode\_Start DeBounce3.DN (EN)-(DN)-RelC2HoldBack.T Retract Stop C2HoldBack.Ret Mode\_Start Extend Stop C2HoldBack.Ext Part in transit from hold back to robot stop Cell\_2.PartEnte ring Retract Stop C2HoldBack.Ret RelC2HoldBack.T Mode Start -(v)-Extend Stop C2HoldBack.Ext Mode\_Semi Sensor Pallet Stop RFID3 (Cell 2 Fanuc Robot Stop) PPX3 <Conv\_N053:I.Data[3].1> | TON | Timer On Delay | Timer | DeBounce4 | Preset | 500 | Accum | 0 Mode\_Start (EN)--(DN)-







