PLC\_Lab:MainTask:MainProgram Total number of rungs in routine: 23

Lab5\_1 0 Lab5 1 Lab5\_1 ... Edit this rung to complete Part 1 Lab5\_1.Start\_Transfer CTU (CU) Counter Box\_Counter 1 ₹DN⊃ Preset 7 0 Accum Lab5\_1.Reset\_Counter MOV Source 0 Dest Box\_Counter.ACC 0 MOV 3 Box Counter.ACC Source Dest Lab5\_1.Current\_Count Box\_Counter.DN Lab5\_1.Shift\_Goal\_Met Lab5 2 Lab5\_2 ... 5 Lab5\_2 Lab5\_2.Reset Lab5\_2.Go\_Left Lab5\_2.Go\_Right Lab5\_2.Go\_Up Lab5\_2.Go\_Down MOV <del>-</del>(U)--(υ)-5000 6 -(U)--(U)-Source Dest Right1Timer.PRE MOV MOV MOV Source 17000 Source 19000 Source 12000 Dest Down1Timer.PRE Dest Left1Timer.PRE Dest Up1Timer.PRE 5000 10000 4000 MOV MOV MOV Source 4000 Source 5500 Source 11000 Dest Right2Timer.PRE Dest Down2Timer.PRE Dest Right3Timer.PRE MOV MOV 6000 7000 Source Source Dest Up2Timer.PRE Dest Left2Timer.PRE Lab5 2.Go Lab5\_2.Go\_Right TON 7 -(L)-Right1Timer (EN) Timer Preset 5000 **₹**DN 5000 Accum

Total number of rungs in routine: 23

Right1Timer.DN Lab5\_2.Go\_Right Lab5\_2.Go\_Down TON EN) 8 \_(U)\_ \_(L)\_ Timer Down1Timer Preset 5000 Accum 5000 Lab5\_2.Go\_Down Lab5\_2.Go\_Left Down1Timer.DN TON EN) 9 -(U)--(L)-Timer Left1Timer 10000 Preset 10000 Accum Left1Timer.DN Lab5\_2.Go\_Left Lab5\_2.Go\_Up TON EN) 10 -(U)--–(L)– Timer Up1Timer Preset 4000 Accum 4000 Up1Timer.DN Lab5 2.Go Up Lab5 2.Go Right TON EN) —(U)— Right2Timer 11 ——(L)— Timer Preset 5000 Accum 5000 Right2Timer.DN Lab5 2.Go Right Lab5 2.Go Down TON 12 -(U)-—(L)-Down2Timer EN) Timer Preset 5000 ■(DN)<del>--</del> Accum 5000 Lab5\_2.Go\_Down Lab5\_2.Go\_Right Down2Timer.DN TON EN DN 13 -(U)<sup>-</sup> (L)-Right3Timer Timer 4000 Preset Accum 4000 Right3Timer.DN Lab5\_2.Go\_Right Lab5\_2.Go\_Up TON EN) (U)-Up2Timer 14 Timer 4000 Preset Accum 4000 Up2Timer.DN Lab5 2.Go Up Lab5 2.Go Left TON —(U)— Left2Timer (EN) 15 ——(L)— Timer ■(DN) Preset 5000 Accum 5000 Left2Timer.DN Lab5 2.Go Left -(U)-16 -Edit this rung to complete part 3 Lab5\_3 Lab5\_3 .... 17 Lab5 3 MOV MOV 18 Source A Lab5\_3.Period HalfPeriod HalfPeriod Source Source 3000.0 1500.0 1500.0 Source B Dest TF1.PRE Dest TF2.PRE 1500 1500 Dest HalfPeriod 1500.0

PLC\_Lab:MainTask:MainProgram Total number of rungs in routine: 23

