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| Name |  | Station | |  | Date |  |
| Filename | Intro to PLC Job 23 *[name].*RSS | | Location | | U:\Electrical\*[firstname\_lastname]* | |
| Objective | | | | | | |
| Using what you have programmed in Job 22, add the following functionality.  Add a motor that runs a conveyer (the relay @ output 4)  CASE 1 – Working conveyor  When you press the start button, the motor shall come on until the box limit switch is closed.  From Job 22, the timer will time the box being filled. Once the box is filled (timer complete), the conveyor comes on until the limit switch opens (box is gone) and the limit switch closes again (new box present).  CASE 2 – Box Jam  If the motor runs for 15 seconds without a box hitting the limit switch, the motor will stop. The operator will have to press the stop button to halt the system (as to remove a box jam) then press start to restart the system. This case should not reset 6,12,24 counters. | | | | | | |
| Job Instructions | | | | | | |
| Before any programming, get an instructor to print out Job 22. You shall use this printout to mark up your changes. Use references to the address locations of all components in your designed circuit. After completing your markup, have your instructor look over your design. Once the design is approved, you may start programming your ladder logic. | | | | | | |