ANTI TIE DOWN CIRCUIT EXAMPLE

0000
OPTO RIGHT ANTIR I:0 4
OPTO LEFT ANTIL I:0 3
ANTI TIE DOWN RIGHT (CHECK IF PUSHED WITHIN .5SEC. OF RIGHT BUTTON)
TON
Timer On Delay
Timer T4:0
Time Base 0.01
Preset 50
Accum 0
EN
DN

0001
OPTO LEFT ANTIL I:0 3
OPTO RIGHT ANTIR I:0 4
ANTI TIE DOWN LEFT (CHECKS IF PUSHED WITHIN .5SEC. OF RIGHT BUTTON)
TON
Timer On Delay
Timer T4:1
Time Base 0.01
Preset 50
Accum 0
EN
DN

0002
OPTO RIGHT ANTIR I:0 4
OPTO LEFT ANTIL I:0 3
ANTI TIE DOWN RIGHT (CHECK IF PUSHED WITHIN .5SEC. OF RIGHT BUTTON) T4:0 DN
ANTI TIE DOWN LEFT (CHECKS IF PUSHED WITHIN .5SEC. OF RIGHT BUTTON) T4:1 DN
ANTI TIE DOWN OK (OUPUT) B3:0 0

CHECK FOR PALLET ROTATION IS IN POSTION BEFORE ALLOWING ANTI TIE DOWN OPERATION

0003
PALLET FINISH 1 PFIN1 I:0 10
PALLET FINISH 2 PFIN2 I:0 11
LIGHT CURTAIN OR DOOR NOT VIOLATED LCSTAT I:0 2
ANTI-TIE-DOWN CLAMP/UNCLAMP STATUS OK PALLET 1 B3:11 5

0004
PALLET FINISH 2 PFIN2 I:0 11
PALLET FINISH 1 PFIN1 I:0 10
LIGHT CURTAIN OR DOOR NOT VIOLATED LCSTAT I:0 2
ANTI-TIE-DOWN CLAMP/UNCLAMP STATUS OK PALLET 2 B3:13 7

DETERMINES AND MEMORIZESWHETHER CLAMP OR UNCLAMP WILL BE NEXT FOR EACH PALLET THE NEXT TIME OPTO TOUCH BUTTONS ARE PUSHED.

0005
ANTI TIE DOWN OK (OUPUT) B3:0 0
ANTI-TIE-DOWN CLAMP/UNCLAMP STATUS OK PALLET 1 B3:11 5
CLAMP PALLET 1 WILL BE NEXT
TOF
Timer Off Delay
Timer T4:31
Time Base 0.01
Preset 20
Accum 0
EN
DN

0006

PULSE TOGGLE BIT
T4:31
TT

PALLET 1
CLAMP NEXT(L)
UNCLAMP NEXT (U)
P1T
B3:11
4

PALLET 1
CLAMP NEXT(L)
UNCLAMP NEXT (U)
P1T
B3:11
U
4

PALLET 1
CLAMP NEXT(L)
UNCLAMP NEXT (U)
P1T
B3:11
4

PALLET 1
CLAMP NEXT(L)
UNCLAMP NEXT (U)
P1T
B3:11
L
4

DETERMINES CLAMP/UNCLAMP PALLET 2 NEXT

0007

ANTI TIE DOWN OK
(OUPUT)
B3:0
0

ANTI-TIE-DOWN
CLAMP/UNCLAMP
STATUS OK
PALLET 2
B3:13
7

CLAMP PALLET 2
WILL BE NEXT

TOF
Timer Off Delay
Timer T4:34
Time Base 0.01
Preset 20
Accum 0
EN
DN

0008

PULSE TOGGLE BIT
T4:34
TT

PALLET 2
CLAMP NEXT(L)
UNCLAMP NEXT (U)
P2T
B3:13
2

PALLET 2
CLAMP NEXT(L)
UNCLAMP NEXT (U)
P2T
B3:13
U
2

PALLET 2
CLAMP NEXT(L)
UNCLAMP NEXT (U)
P2T
B3:13
2

PALLET 2
CLAMP NEXT(L)
UNCLAMP NEXT (U)
P2T
B3:13
L
2

0009

END