

Program Listing Report

Rung 2:1501

D.B.
SENSOR
TRIMMER 1
SELECT
B3

252

D.B.
SENSOR
TRIMMER 3
SELECT
B3

254

D.B.
SENSOR
TRIMMER 5
SELECT
B3

256

Run 2:1502

D.B.
SENSOR
TRIMMER 2
SELECT
B3

253

D.B.
SENSOR
TRIMMER 3
SELECT B3

254

D.B.
SENSOR
TRIMMER 6
SELECT
B3

257

D.B.
SENSOR
D.B. DATA
BIT 0
B3
---()---
660

D.B.
SENSOR
D.B. DATA
BIT 1
B3
---()---
661

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D.B.
SENSOR
TRIMMER
SELECT B3

255
D.B.
SENSOR
TRIMMER
SELECT
B3

D.B.
SENSOR
TRIMMER
SELECT
R3

D.B.
SENSOR
D.B. DATA
BIT 0 B3

660
D.B.
SENSOR
D.B. DATA
BIT 1 B3

661
D.B.
SENSOR
D.B. DATA
BIT 2
B3

662
D.B.
SENSOR
D.B. DATA
BIT 0

660 / []

OR
+---] [---
B3 14

14
A.D.C.
OPERATION
OK

MANUAL 15

OPERATION
OK

16

D.B.
SENSOR
D.B. DATA
BIT 2
B3
()
662

D.B.
SENSOR
STROBE ON
B3
----- () -----
663

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Rung 2:1505	D.B. SENSOR D.B. DATA BIT 0 B3	D.B. SENSOR A DATA BIT 0 O:061	01
Rung 2:1506	D.B. SENSOR D.B. DATA BIT 1 B3	D.B. SENSOR A DATA BIT 1 O:061	02
Rung 2:1507	D.B. SENSOR D.B. DATA BIT 2 B3	D.B. SENSOR A DATA BIT 2 O:061	03
Rung 2:1508	D.B. SENSOR STROBE ON B3	D.B. SENSOR A STROBE O:061	04
Rung 2:1509	D.B. SENSOR D.B. DATA BIT 0 B3	D.B. SENSOR B DATA BIT 0 O:061	06
Rung 2:1510	D.B. SENSOR D.B. DATA BIT 1 B3	D.B. SENSOR B DATA BIT 1 O:061	07
Rung 2:1511	D.B. SENSOR D.B. DATA BIT 2 B3	D.B. SENSOR B DATA BIT 2 O:061	10

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Run	Address	Field	Value	Unit	Limit	Notes
Rung 2:1512	D.B.	SENSOR				
	B	STROBE ON				
	B3					
	663					
Rung 2:1513	D.B.	SENSOR				
	A	SELECT				
	A-1					
	B3					
Rung 2:1514	D.B.	SENSOR				
	B	SELECT				
	B-1					
	B3					
Rung 2:1515	D.B.	SENSOR				
	A	SELECT				
	A-1					
	B3					
Rung 2:1516	D.B.	SENSOR				
	A	SELECT				
	A-1					
	B3					
Rung 2:1517	D.B.	SENSOR				
	A	SELECT				
	A-1					
	B3					

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Rung 2:1518		D.B. SENSOR LOWER LIMIT T4:215		D.B. SENSOR DETECT CONFIRM		+TON- +TIMER ON DELAY +-(EN)- Timer T4:216 Time base 0.01 +-(DN) Preset 20 Accum 0	
] [-		EN					
Rung 2:1519		No.1 BLANK FEEDER I1 SHEET CONFIRM 1 I:153				i1 SHEET CONFIRM B3 ()	
] [-		16				667	
Rung 2:1520		No.1 BLANK FEEDER I1 SHEET CONFIRM 2 I:153					
] [-		17					
Rung 2:1521		STACK LIFTER LOWER LIMIT B3 491		AUTO FORK LIFTER RETURN LOWER LIMIT B3 511		NO STACK CONFIRM B3 ()	
] [-		531				668	
Rung 2:1522		D.B. SENSOR DETECT CONFIRM B3 635		D.B. SENSOR RELAY OUTPUT I:110 T4:216 DN 00		i0 1 SHEET CONFIRM B3 (L)	
] [-		670				669	
Rung 2:1523		D.B. SENSOR DETECT CONFIRM B3 635		D.B. SENSOR RELAY OUTPUT I:110 T4:216 DN 00		i0 2 SHEET CONFIRM B3 (L)	
] [-		670				670	

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Rung 2:1523

```
NO STACK 10 SHEET  
CONFIRM B3 635  
] [/ DN 00  
668  
Rung 2:1524
```

```
10  
1 SHEET  
CONFIRM B3
```

```
10 669  
2 SHEET  
CONFIRM B3
```

```
10 670  
NO SHEET  
CONFIRM B3
```

Rung 2:1525

```
No.1 BLANK  
FEEDER IN 10 SHEET  
POSITION D9:3 DONE CONFIRM B3  
] [/ 1 635  
0
```

```
10  
2 SHEET  
CONFIRM B3
```

```
670  
VACUUM CUP  
DOWN B3  
] [/ 639
```

```
D.B. SENSOR  
A RELAY  
OUTPUT I:110  
T4:216  
] [/ DN
```

```
10  
NO SHEET  
CONFIRM B3  
(L) 671
```

```
10  
D.B. DETECT  
CONFIRM B3  
( ) 672
```

```
10  
1 SHEET  
CONFIRM B3  
(U) 669
```

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Run	Address	Function	Input	Output	Notes
Rung 2:1526	No.1 BLANK	FEEDER			
	SHEET	DETECT			
	AUX.				
	B3				
Rung 2:1527	VACUUM CUP	DOWN			
	B3				
	639				
	No.1 BLANK	FEEDER			
Rung 2:1528	IN POSITION	D9:3			
	D9:3				
	VACUUM CUP	DOWN			
	B3				
Rung 2:1529	11 SHEET	CONFIRM			
	B3				
	667				
	D.B. SENSOR	RELAY OUTPUT			
Rung 2:1530	11 SHEET	CONFIRM			
	B3				
	667				
	D.B. SENSOR	RELAY OUTPUT			
Rung 2:1531	11 SHEET	CONFIRM			
	B3				
	667				
	D.B. SENSOR	RELAY OUTPUT			
Rung 2:1532	11 SHEET	CONFIRM			
	B3				
	667				
	D.B. SENSOR	RELAY OUTPUT			

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Rung 2:1531

```
l1  
1 SHEET  
CONFIRM  
B3  
-----  
l1  
2 SHEET  
CONFIRM  
B3  
-----  
l1  
NO SHEET  
CONFIRM  
B3  
-----  
l1  
D.B.  
DETECT  
CONFIRM  
B3  
-----  
( )  
676
```

Rung 2:1532

```
No.1 BLANK  
FEEDER IN  
POSITION  
D9:3  
-----  
No.1 BLANK  
FEEDER DONE  
D9:3  
-----  
l1  
2 SHEET  
CONFIRM  
B3  
-----  
l1  
1 SHEET  
CONFIRM  
B3  
-----  
(U)  
673
```

Rung 2:1533

```
OPERATION  
RESET  
ON  
B3  
-----  
l1  
2 SHEET  
CONFIRM  
B3  
-----  
(U)  
674
```

Rung 2:1534

```
No.1 BLANK  
FEEDER IN  
POSITION  
D9:3  
-----  
No.1 BLANK  
FEEDER DONE  
D9:3  
-----  
l1  
NO SHEET  
CONFIRM  
B3  
-----  
(U)  
675
```

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Rung 2:1535		No.1 BLANK FEEDER IN POSITION D9:3		No.1 BLANK FEEDER DONE D9:3		D.B. SENSOR DOWN CONDITION B3	
D.B. SENSOR FAULT B3		D9:3		D9:3		D.B. SENSOR DOWN CONDITION B3	
686		0		1		687	
Rung 2:1536		10		D.B. DETECT CONFIRM B3		D.B. SENSOR DOWN ORDER B3	
D.B. DETECT CONFIRM B3		10 SHEET CONFIRM B3		11 SHEET CONFIRM B3		D.B. SENSOR DOWN ORDER B3	
672		635		667		677	
11		10 SHEET CONFIRM B3		11 SHEET CONFIRM B3			
D.B. DETECT CONFIRM B3		635		667			
676		NO STACK CONFIRM B3		10 SHEET CONFIRM B3			
		668		635			
		PRESS INTERLOCK SHEET SUPPLY ON PB		0:261			
		17		17			
Rung 2:1537		10		D.B. DETECT CONFIRM B3		D.B. SENSOR UP ORDER B3	
D.B. DETECT CONFIRM B3		11		No.1 BLANK FEEDER IN POSITION D9:3		D.B. SENSOR UP ORDER B3	
672		676		0		678	
PRESS INTERLOCK SHEET SUPPLY ON PB		No.1 BLANK FEEDER DONE D9:3		1			
0:261							
17							

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Rung 2:1538				D.B. SENSOR DOWN B3 679			
LINE	D.B. SENSOR	D.B. SENSOR	D.B. SENSOR	D.B. SENSOR	D.B. SENSOR	D.B. SENSOR	D.B. SENSOR
OPERATION	DOWN	UP	ORDER	DOWN	DOWN	DOWN	DOWN
OK	B3	B3	B3	B3	B3	B3	B3
14				677			
16				D.B. SENSOR DOWN B3 679			
MANUAL OPERATION				MANUAL OPERATION			
OK				ENABLE			
B3				I:044			
16				10			
MANUAL OPERATION				D.B. SENSOR			
OK				UP			
B3				I:042			
16				11			
MANUAL OPERATION				D.B. SENSOR			
OK				DOWN			
B3				I:042			
16				11			
Rung 2:1539				679			
D.B. SENSOR DOWN				D.B. SENSOR DOWN			
B3				0:137			
679				04			
Rung 2:1540				D.B. SENSOR UPPER LIMIT			
D.B. SENSOR UPPER LIMIT				D.B. SENSOR UPPER LIMIT			
B3				0:113			
664				06			
LAMP TEST				LAMP TEST			
I:004				I:004			
06				06			
Rung 2:1541				D.B. SENSOR LOWER LIMIT			
D.B. SENSOR LOWER LIMIT				D.B. SENSOR LOWER LIMIT			
B3				0:113			
665				07			
LAMP TEST				LAMP TEST			
I:004				I:004			
06				06			

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Rung 2:1542	
D.B. SENSOR A-1 DOWN LIMIT O:137	D.B. SENSOR A-1 DOWN FAULT +TON TIMER ON DELAY T4:217 Time base 0.01 Preset 100 Accum 0
04	13
Rung 2:1543	
D.B. SENSOR A-1 DOWN FAULT T4:217	D.B. SENSOR A-1 DOWN FAULT B3
DN	()
680	680
Rung 2:1544	
D.B. SENSOR A-1 DOWN LIMIT O:137	D.B. SENSOR A-1 UP FAULT +TON TIMER ON DELAY T4:218 Time base 0.01 Preset 100 Accum 0
04	12

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Rung 2:1545

```
D.B.
SENSOR
A-1
UP
FAULT
T4:218
DN
D.B.
SENSOR
A-1
UP
RESET
ON
B3
681
17
```

Rung 2:1546

```
D.B.
SENSOR
A-2
DOWN
LIMIT
I:153
0:137
04
D.B.
SENSOR
A-2
DOWN
FAULT
+TON-
TIMER ON DELAY
T4:219
Time base
0.01
Preset
100
Accum
0
(EN)
(DN)
```

Rung 2:1547

```
D.B.
SENSOR
A-2
DOWN
FAULT
T4:219
DN
D.B.
SENSOR
A-2
DOWN
RESET
ON
B3
682
17
```

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Program Listing Report

[illegible]