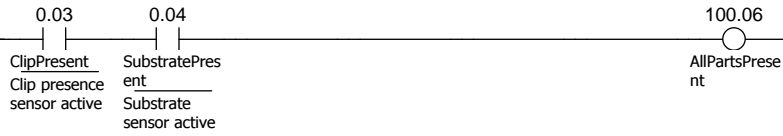


000000  
(000000)

[Program Name : ClipInsertion]  
[Section Name : Inputs]  
Generate signal when all parts are present



All parts are present

000001  
(000003)

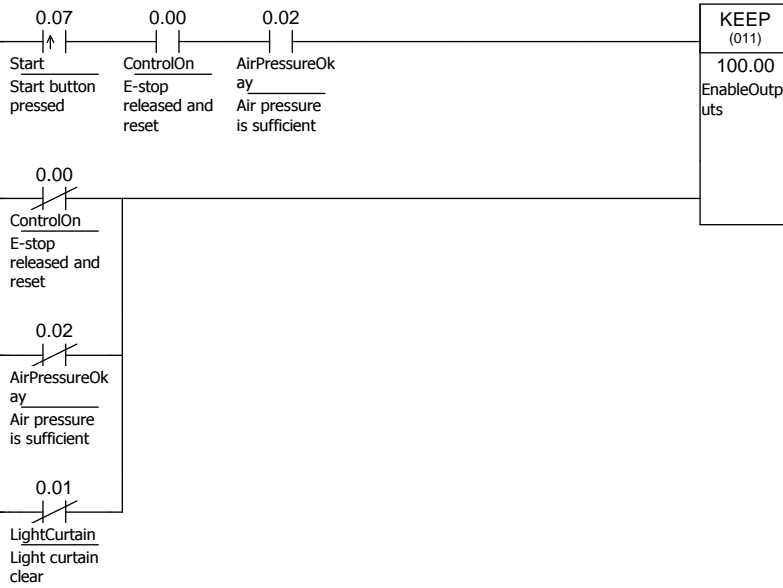
Generate signal when all part sensors are off



All parts sensors are off

000002  
(000006)

Disable cylinder when light curtain blocked, e-stop activated or air pressure low  
Enable cylinder only if start button has been pressed



Outputs are disabled when e-stop is activated, light curtain blocked or air pressure drops. Start must be pressed to re-enable outputs.

Title	Clip Insertion Sample Program	Author	A. Zeeman	Step Number	000000
Number		Revision	1	Date	5/2/2010