

Name	Data Type	Address / Value	Rack Location	Usage	Comment
ControlOn	BOOL	0.00		Work	E-stop released and reset
LightCurtain	BOOL	0.01		Work	Light curtain clear
AirPressureOkay	BOOL	0.02		Work	Air pressure is sufficient
ClipPresent	BOOL	0.03		Work	Clip presence sensor active
SubstratePresent	BOOL	0.04		Work	Substrate sensor active
PressHome	BOOL	0.05		Work	Press cylinder in home position
PressDown	BOOL	0.06		Work	Press cylinder fully extended
Start	BOOL	0.07		Work	Start button pressed
ControlOnIndicator	BOOL	10.00		Work	Turn on control power indicator only when e-stop is ...
MovePressUp	BOOL	10.01		Work	Three position, double solenoid valve is used to con...
MovePressDown	BOOL	10.02		Work	Move press down when active
EnableOutputs	BOOL	100.00		Work	Outputs are disabled when e-stop is activated, light ...
B_Initialize	BOOL	100.01		Work	Wait for part sensors off and press cylinder home
B_WaitForParts	BOOL	100.02		Work	Wait for operator to load clip and substrate
B_WaitForPressDown	BOOL	100.03		Work	Wait for press to move down
B_WaitForPressUp	BOOL	100.04		Work	Wait for press to home
ClipInsertion	UINT	D100		Work	Sequencer for clip insertion
S_Initialize	NUMBER	0			Wait for part sensors off and press cylinder home
S_WaitForParts	NUMBER	1			Wait for operator to load clip and substrate
S_WaitForPressDown	NUMBER	2			Wait for press to move down
S_WaitForPressUp	NUMBER	3			Wait for press to home
A_ClipInsertion	NUMBER	#64			(D100) Sequencer for clip insertion