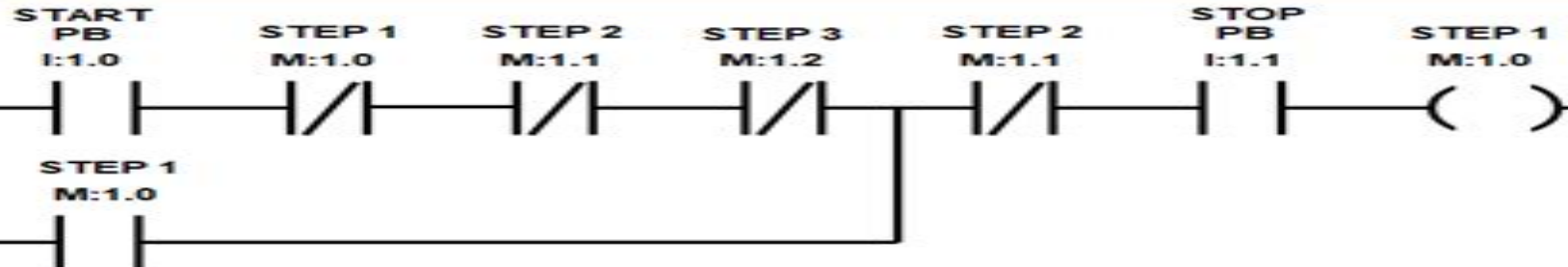


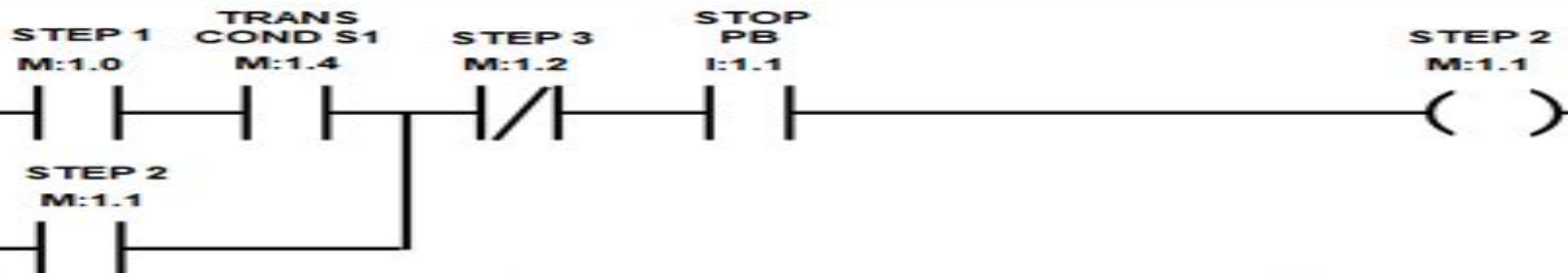
Sequence Step No.1 - Trolley Running Forward to Loading Area -

The sequence is started using the Start Push Button (wired NO) and stopped using the Stop Push Button (wired NC). The sequence can only be started if there are no steps active.



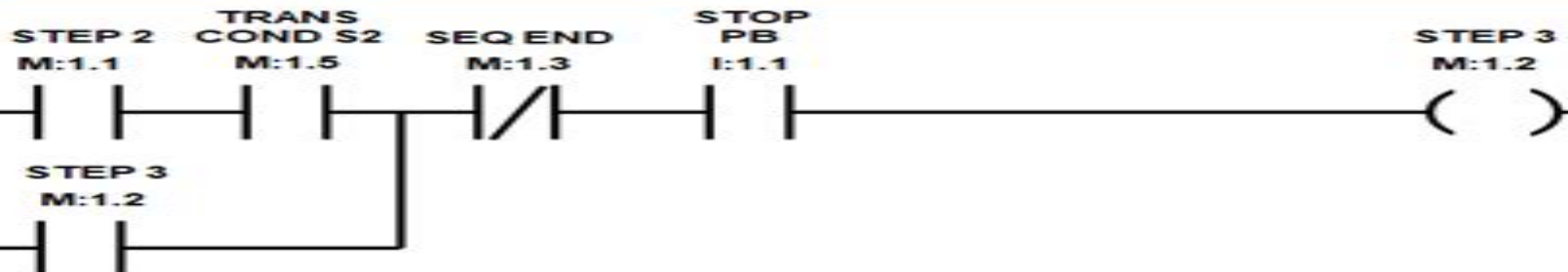
Sequence Step No.2 - Trolley waiting to be Loaded at Loading Area -

Step1 transitions to step 2 when the Loading End Limit Switch is triggered. Step 2 can only be latched if steps 2 and 3 are NOT active.



Sequence Step No.3 - Trolley Reversing Back to the Un-Loading Area -

Step2 transitions to step3 when the Trolley Pallet Proximity Sensor is active and the Loading Area is clear. Step 3 can only be latched if steps 1 and 3 are NOT active.



Sequence End-

Step3 transitions to sequence end when the Un-Loading End Limit Switch is triggered.



Ladder Logic Training Manual

Ying Liu



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