

In the example below, the PLC sets up a move of one of seven positions from the IAI DS controller's position table. The DS controller needs to have output 302 wired to a PLC input, and inputs 012 to 015 wired to PLC outputs.

#### PLC Logic:

1. wait for IAI ready (IAI 302)
2. Set up position code (1 to 7, corresponding to IAI position table entries 1 to 7). This can be done with the OUTF box. See p.286 of DL06UM1.pdf.
3. Turn on output to IAI 012
4. wait for input from IAI 302 to go low, then turn off output to IAI 012.
5. wait for input from IAI 302 to go high.
6. Go on with other logic

#### IAI Logic:

- |          |         |  |
|----------|---------|--|
| 1. BTOF  | 302     | Signal PLC not ready                                     |
| 2. SVON  | 1       | Servo On   |
| 3. HOME  | 1       | Home servo   |
| 4. ACC   | 0.9     | Set accel  |
| 5. VEL   | 200     | Set vel  |
| 6. MOVP  | 10      | Move to initial pos.                                     |
| 7. BTON  | 302     | Signal PLC we are rdy                                    |
| 8. TAG   | 1       | Return point for loop                                    |
| 9. WTON  | 012     | wait for PLC go signal                                   |
| 10. BTOF | 302     | Signal PLC we're moving                                  |
| 11. IN   | 013 015 | Input position code to register 99                       |
| 12. MOVP | *99     | Look up position table value from address in register 99 |
| 13. BTON | 302     | Tell PLC we're ready                                     |
| 14. WTOF | 012     | Be sure PLC knows  |
| 15. GOTO | 1       | cycle back around  |