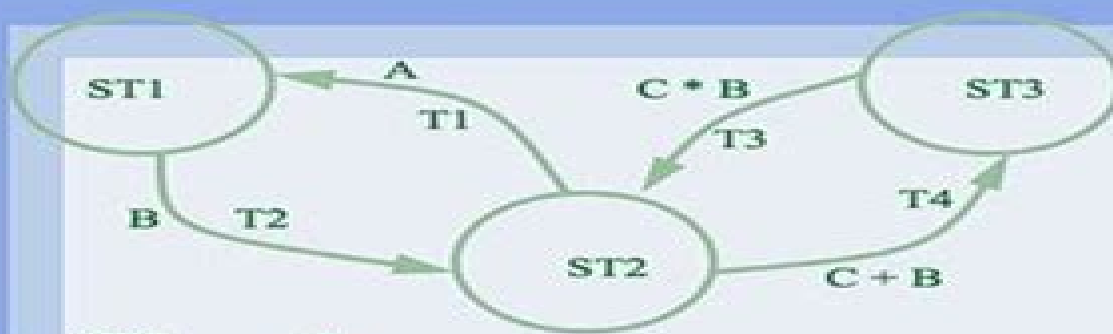




FS = first scan

$T1 = ST2 \cdot A$

$T2 = ST1 \cdot B$

$T3 = ST3 \cdot (C \cdot B)$

$T4 = ST2 \cdot (C + B)$

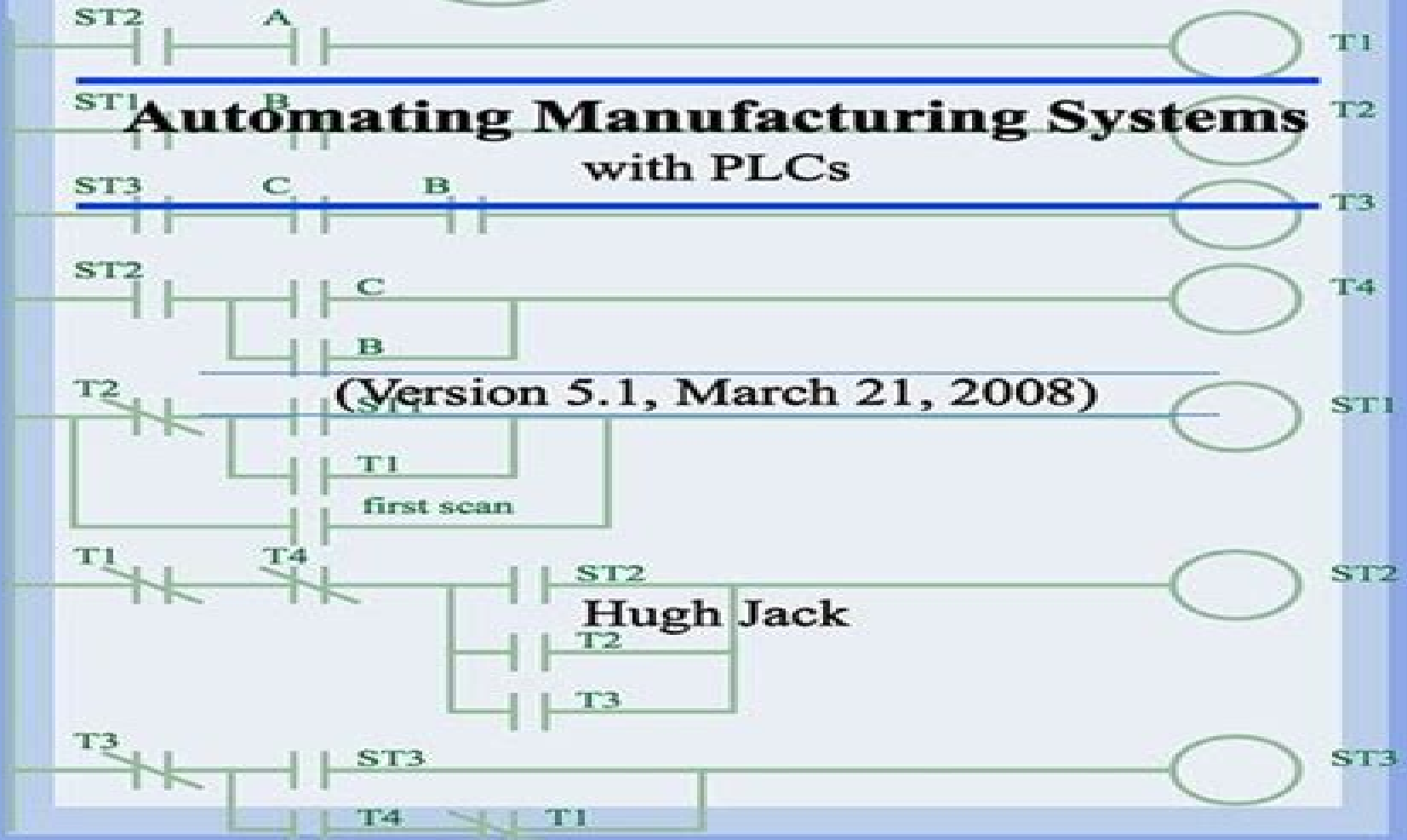
$ST1 = (ST1 + T1) \cdot \bar{T2} + FS$

$ST2 = (ST2 + T2 + T3) \cdot \bar{T1} \cdot \bar{T4}$

$ST3 = (ST3 + T4 \cdot \bar{T1}) \cdot \bar{T3}$

## Automating Manufacturing Systems with PLCs

(Version 5.1, March 21, 2008)



Hugh Jack

# Automating Manufacturing Systems With Plcs

**Wenbin Ji**



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