

FS = first scan

$$T1 = ST2 \cdot A$$

$$T2 = ST1 \cdot B$$

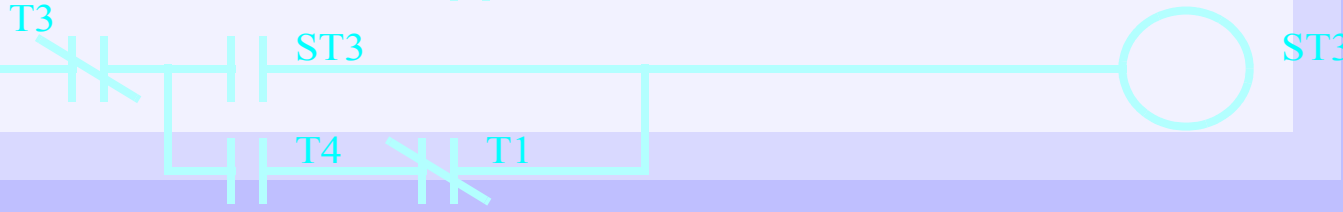
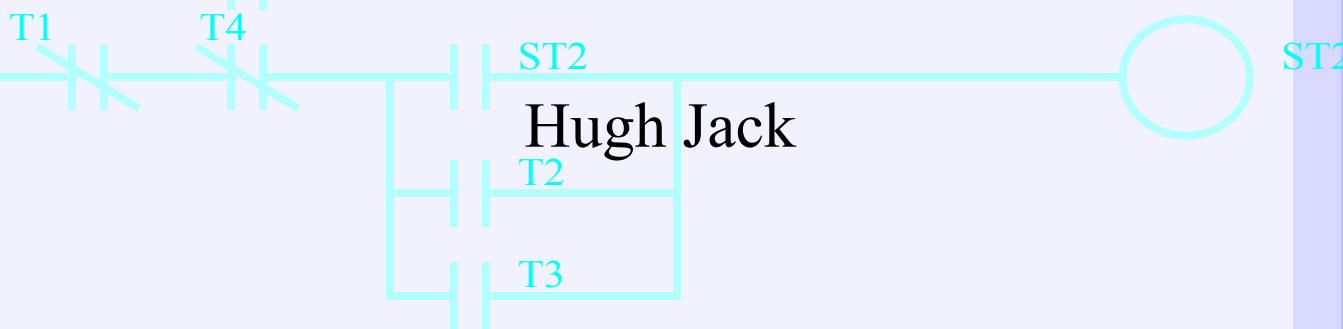
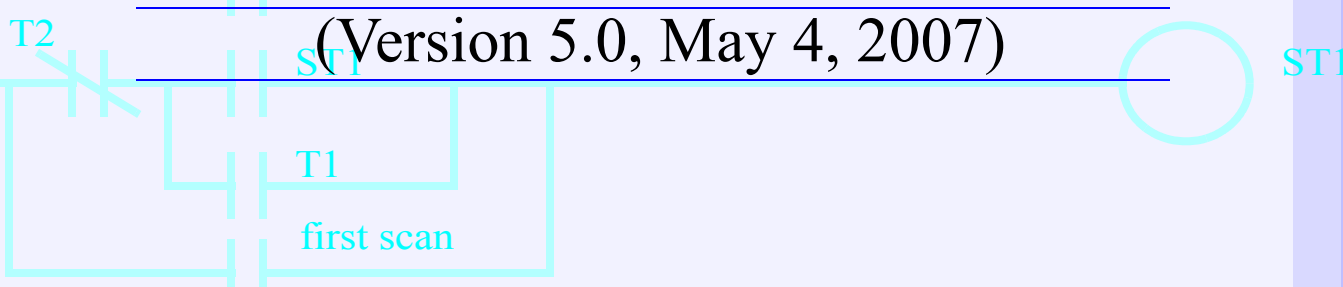
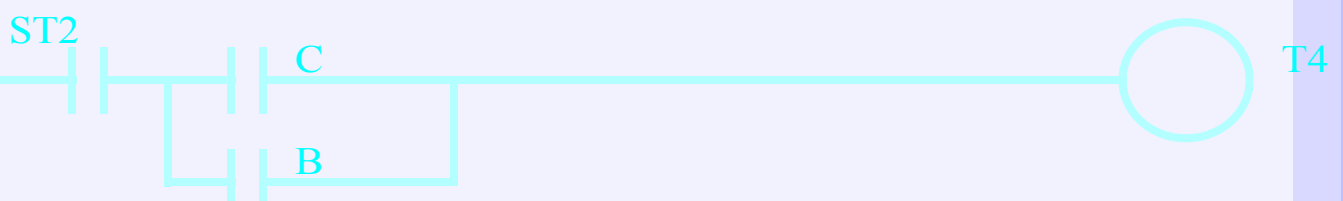
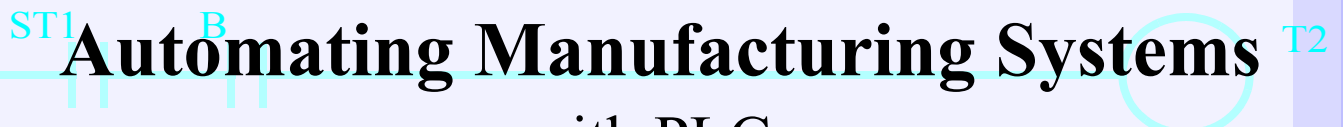
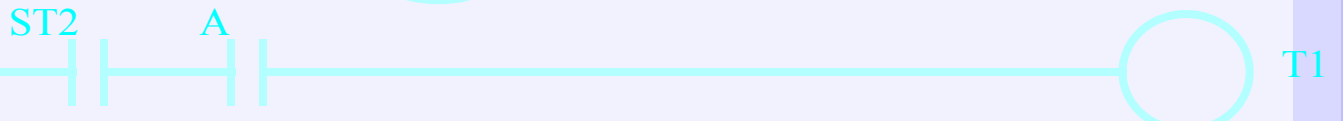
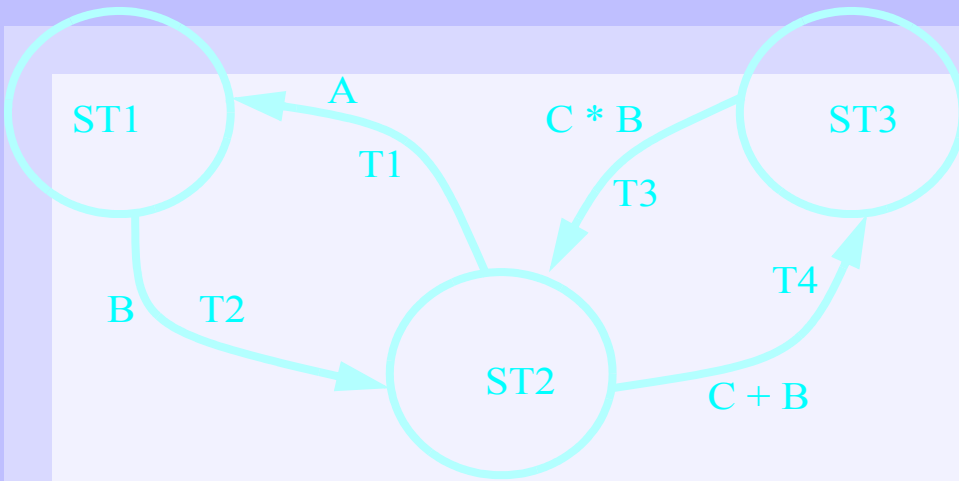
$$T3 = ST3 \cdot (C \cdot B)$$

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

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

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

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



Automating Manufacturing Systems with PLCs

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