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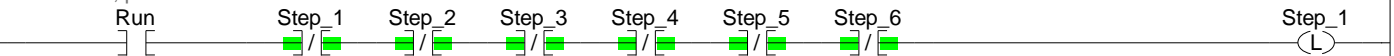
### Case Erector Control

Additional internal memory:

Tag	Data Type	
Step_1 to Step_6	BOOL	Step-in-progress bits
Up_Tmr	TIMER	Times opening up
BDown_Tmr	TIMER	Times deactivate of bottom cylinder
Pulse_Cnt	COUNTER	Count encoder pulses

Initial start. When on, allow case erector to run. When off pause

When on, allow case  
erector to run. When  
off, pause



### Step 1 Move in

Proximity sensor, on  
when flat carton is  
in position to be  
erected

PROX

<Local:4:I.Data.0>

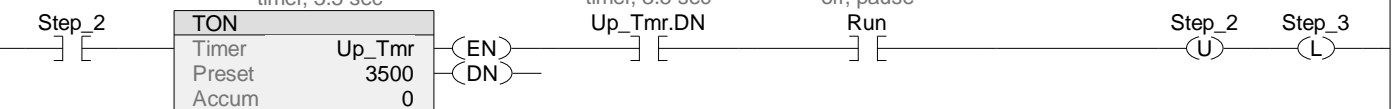
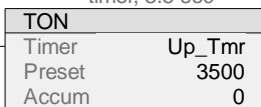


### Step 2 Open up

Unfolding carton  
timer, 3.5 sec

Unfolding carton  
timer, 3.5 sec

When on, allow case  
erector to run. When  
off, pause



### Step 3 Close sides

Limit switch, on  
(closed) when left  
flap is folded in  
position

LEFT\_LS

<Local:4:I.Data.1>

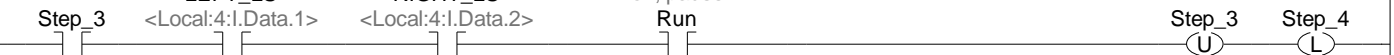
Limit switch, on  
(closed) when right  
flap is folded in  
position

RIGHT\_LS

<Local:4:I.Data.2>

When on, allow case  
erector to run. When  
off, pause

Run



### Step 4 Close bottom

Limit switch, on  
(closed) when bottom  
flap is in position

BOT\_LS

<Local:4:I.Data.3>

When on, allow case  
erector to run. When  
off, pause

Run



