

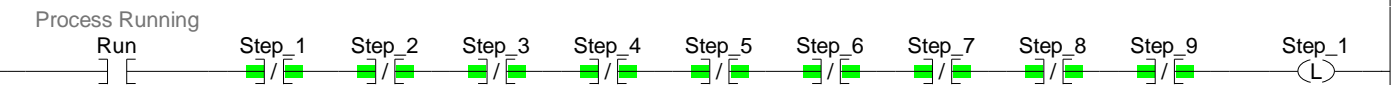
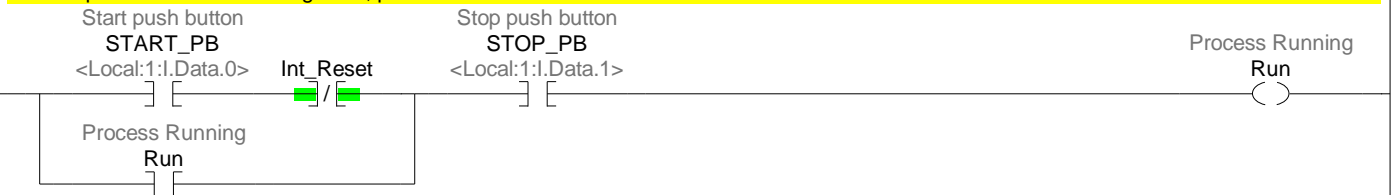
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### Erbia Can Tipper/Rotator Control

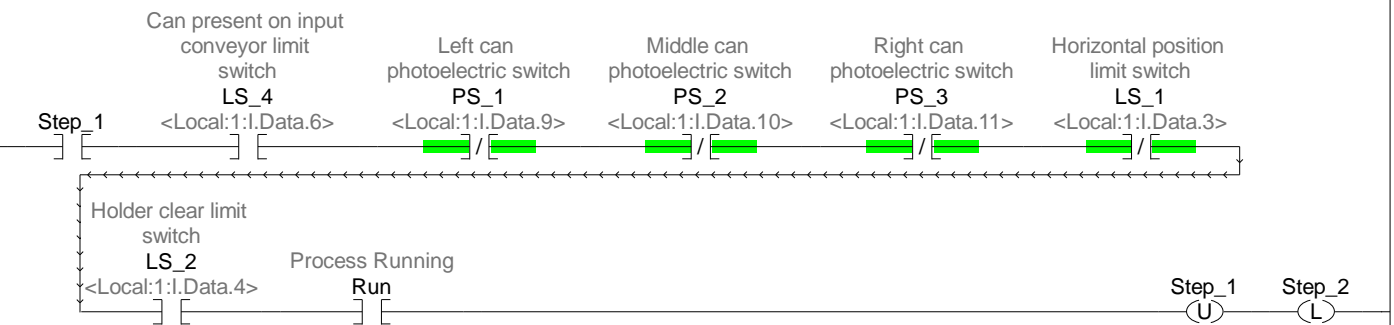
#### Additional internal memory:

Tag	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Step_1 to Step_9	BOOL	Step-in-progress bits
Retract_Tmr	TIMER	Times retract of CYL_4
Blend_Tmr	TIMER	Times blend

#### Start/stop and initial start. During reset, prevent start



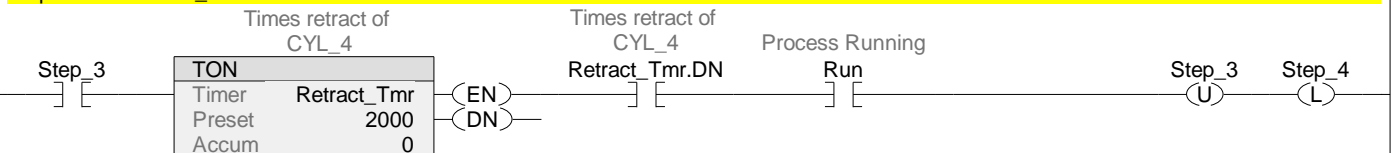
#### Step 1 Wait for can



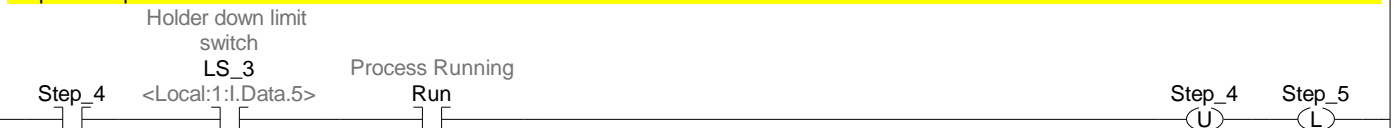
#### Step 2 Push can into tipper

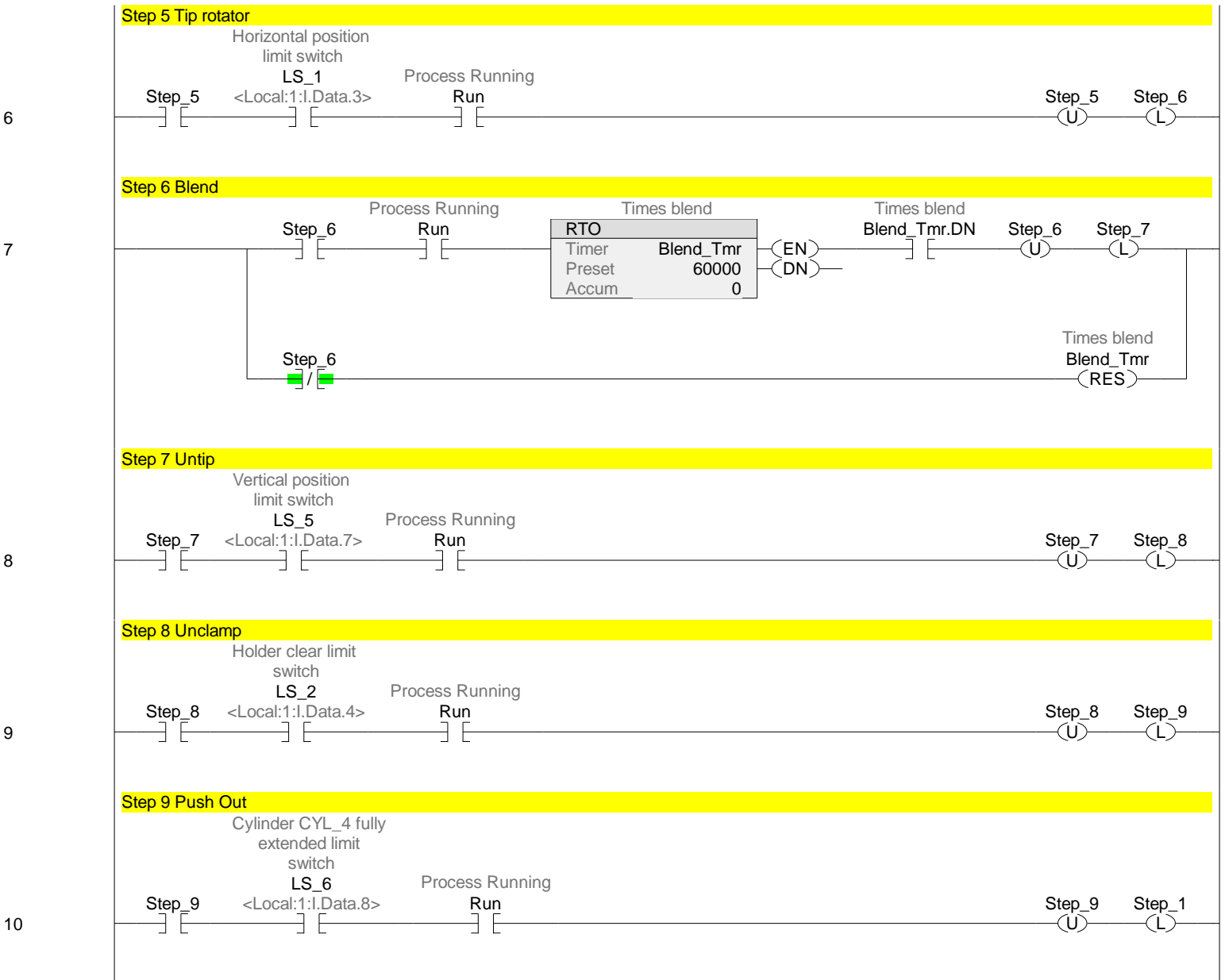


#### Step 2 Wait for CYL\_4 to retract



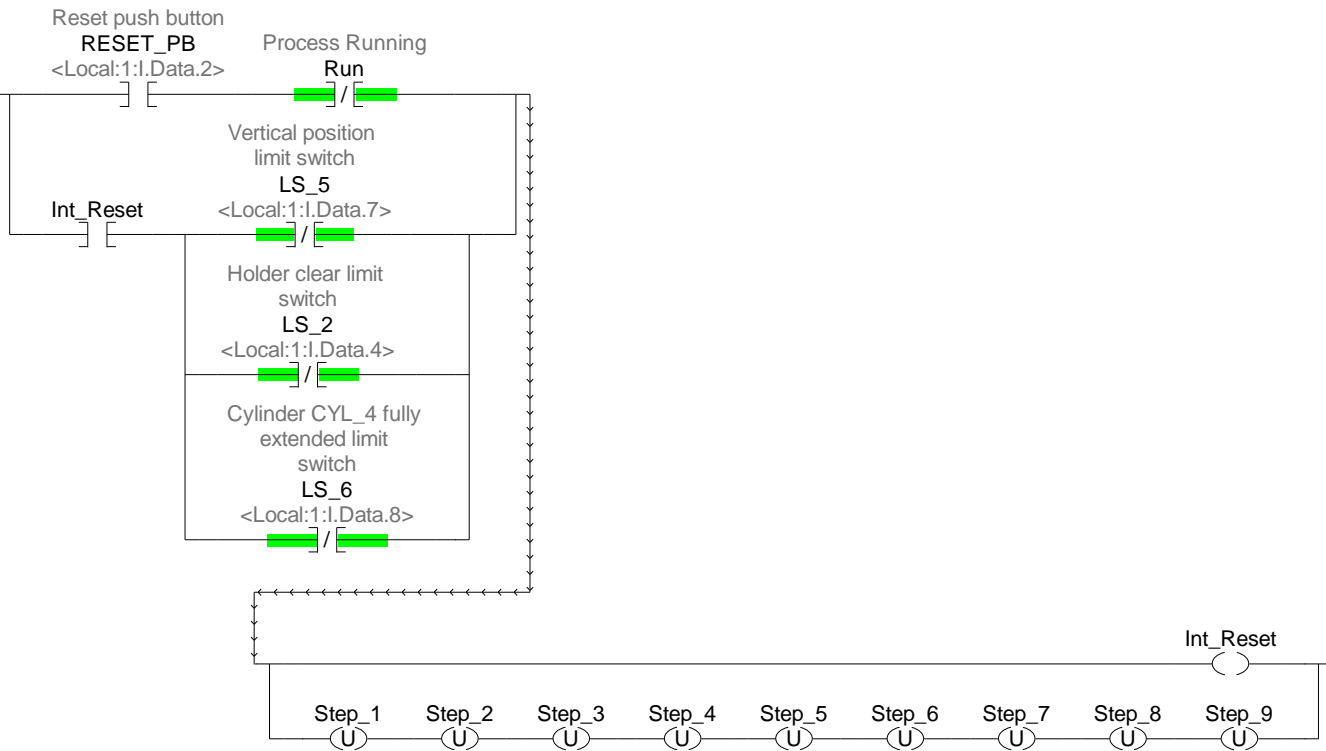
#### Step 4 Clamp can





Reset - Keep on until can unclamped, vertical and out of station.

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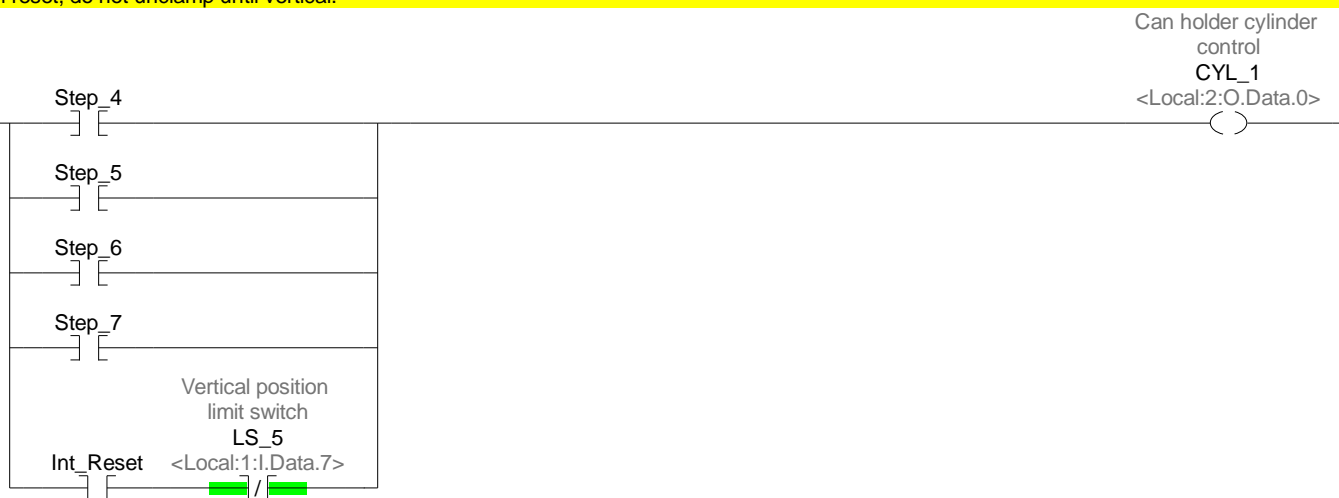


Physical Outputs

Cannot turn off CYL\_1 to CYL\_3 when paused.

On reset, do not unclamp until vertical.

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Can holder cylinder control  
**CYL\_1**  
<Local:2:O.Data.0>

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Tipper cylinder control  
**CYL\_2**  
<Local:2:O.Data.1>

