

- Controller SP15_03
- Controller Fault Handler
- Power-Up Handler

Tasks

- MainTask
 - MainProgram
 - MainRoutine
 - Simulation
 - Simulation
- Unscheduled

Motion Groups

- Ungrouped Axes

Add-On Instructions**Data Types**

- User-Defined
- Strings
- Add-On-Defined
- Module-Defined
 - AB:1756_DI:C:0
 - AB:1756_DI:I:0
 - AB:1756_DO:C:0
 - AB:1756_DO:I:0
 - AB:1756_DO:O:0

Trends**I/O Configuration**

- 1756 Backplane, 1756-A10
 - [0] 1756-L71 SP15_03
 - [1] 1756-IB32/A discrete_in1
 - [2] 1756-OB32 discrete_out
 - [3] 1756-IB32/A discrete_in3
 - [4] 1756-IB32/A discete_in_4
 - [5] 1756-OB32 DISCRETE_OUT5
 - [6] 1756-IB32/A DISCRETE_IN6
 - [7] 1756-OB32 DISCRETE_OUT7

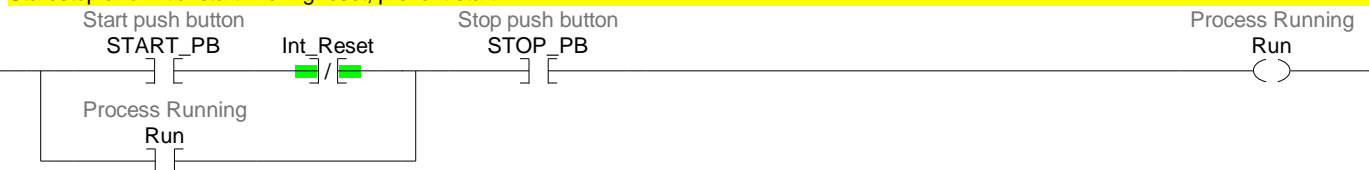
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Erbia Can Tipper/Rotator Control - With Simulation

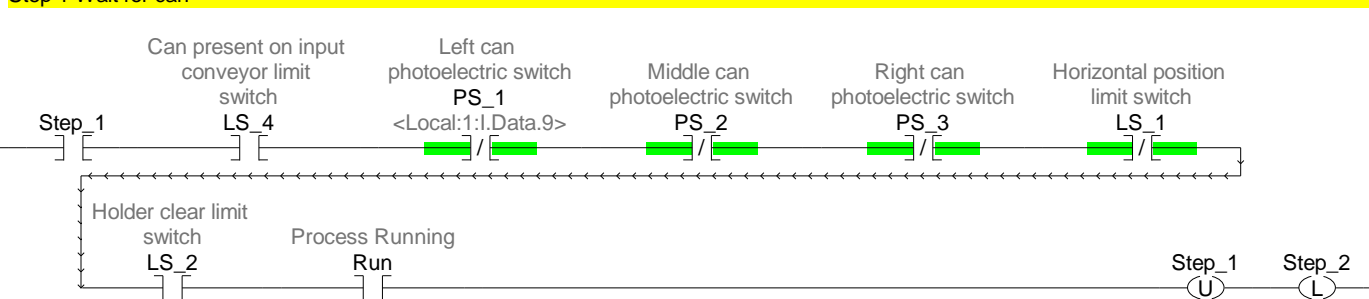
Additional internal memory:

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



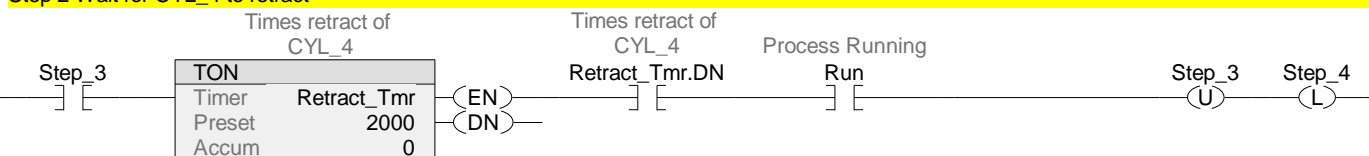
Step 1 Wait for can



Step 2 Push can into tipper



Step 2 Wait for CYL_4 to retract



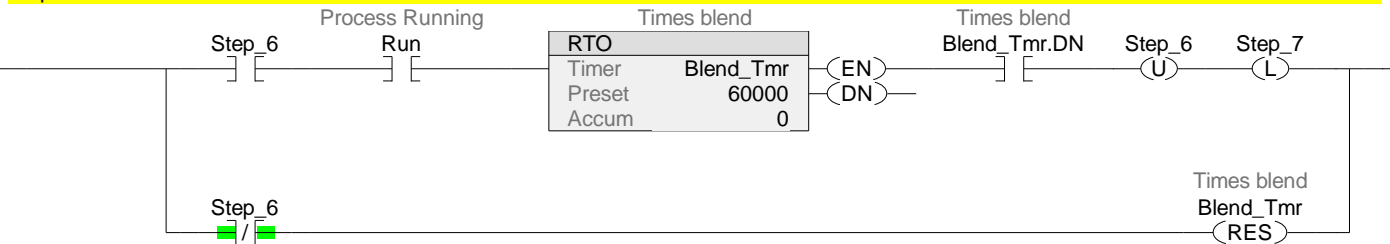
Step 4 Clamp can



Step 5 Tip rotator



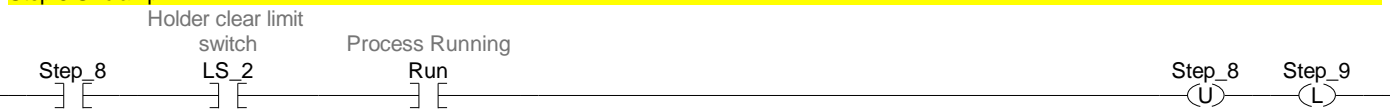
Step 6 Blend



Step 7 Untip



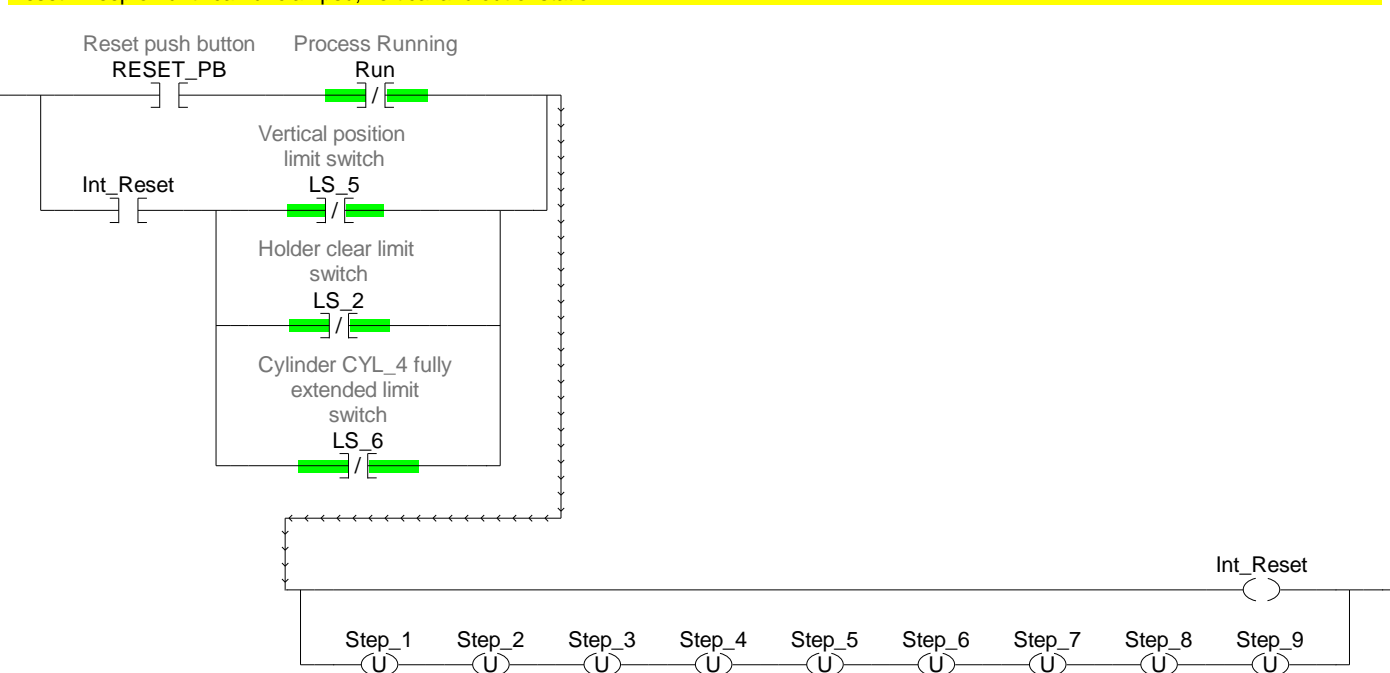
Step 8 Unclamp



Step 9 Push Out



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



Physical Outputs

Cannot turn off CYL_1 to CYL_3 when paused.

On reset, do not unclamp until vertical.

Can holder cylinder
control
CYL_1
<Local:2:O.Data.0>

Step_4

Step_5

Step_6

Step_7

Vertical position
limit switch

Int_Reset

LS_5

Tipper cylinder
control
CYL_2
<Local:2:O.Data.1>

Step_5

Step_6

Gate cylinder
control
CYL_3
<Local:2:O.Data.2>

Step_2

Step_3

Step_4

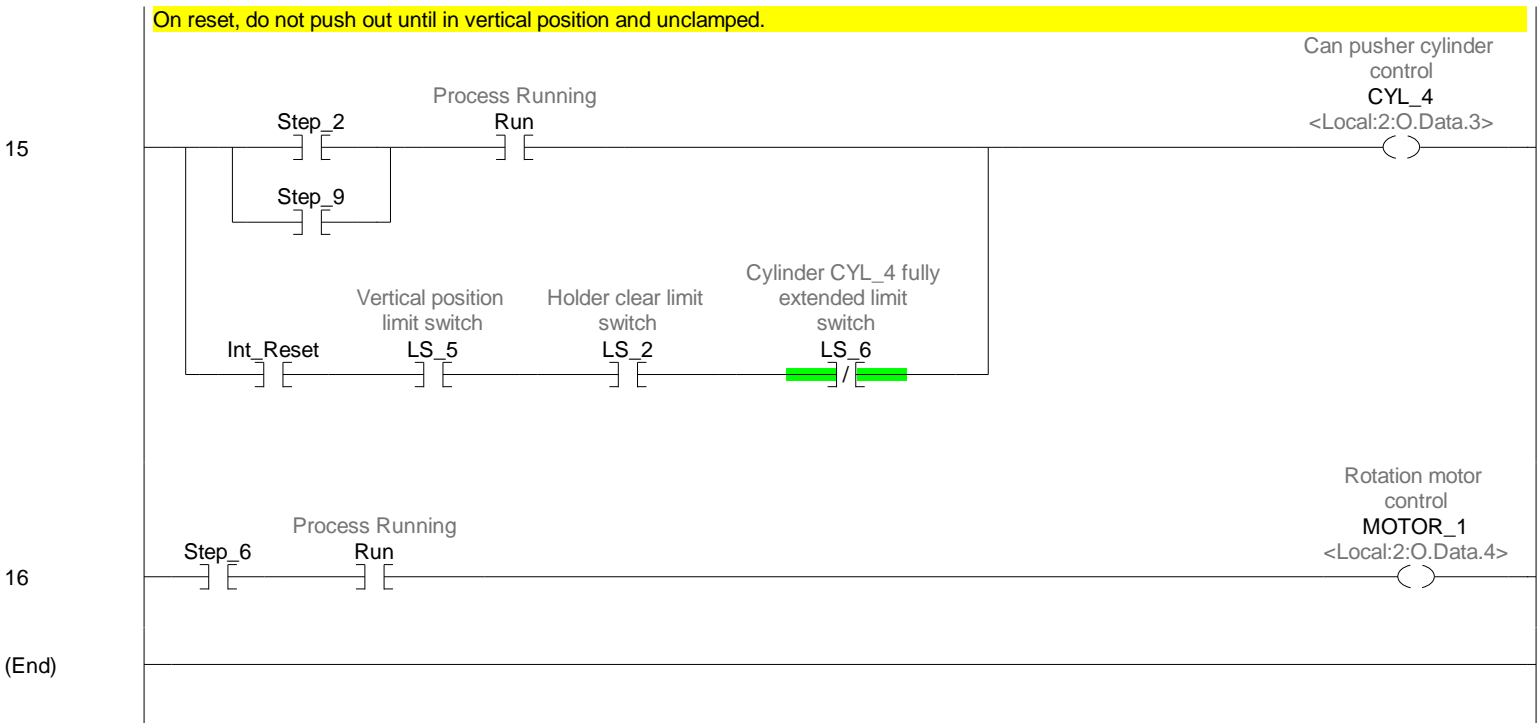
Step_5

Step_6

Step_7

Step_8

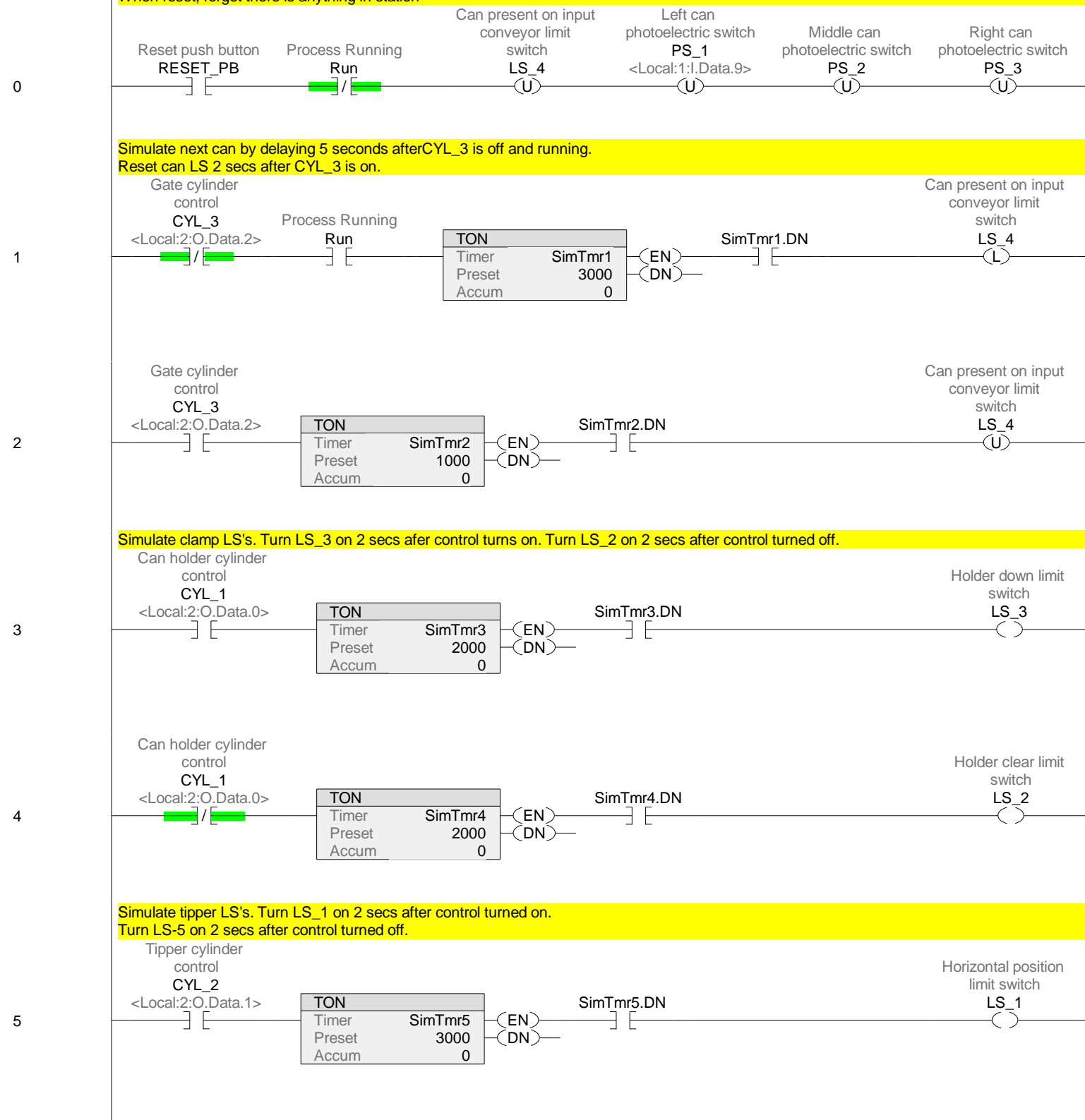
Step_9

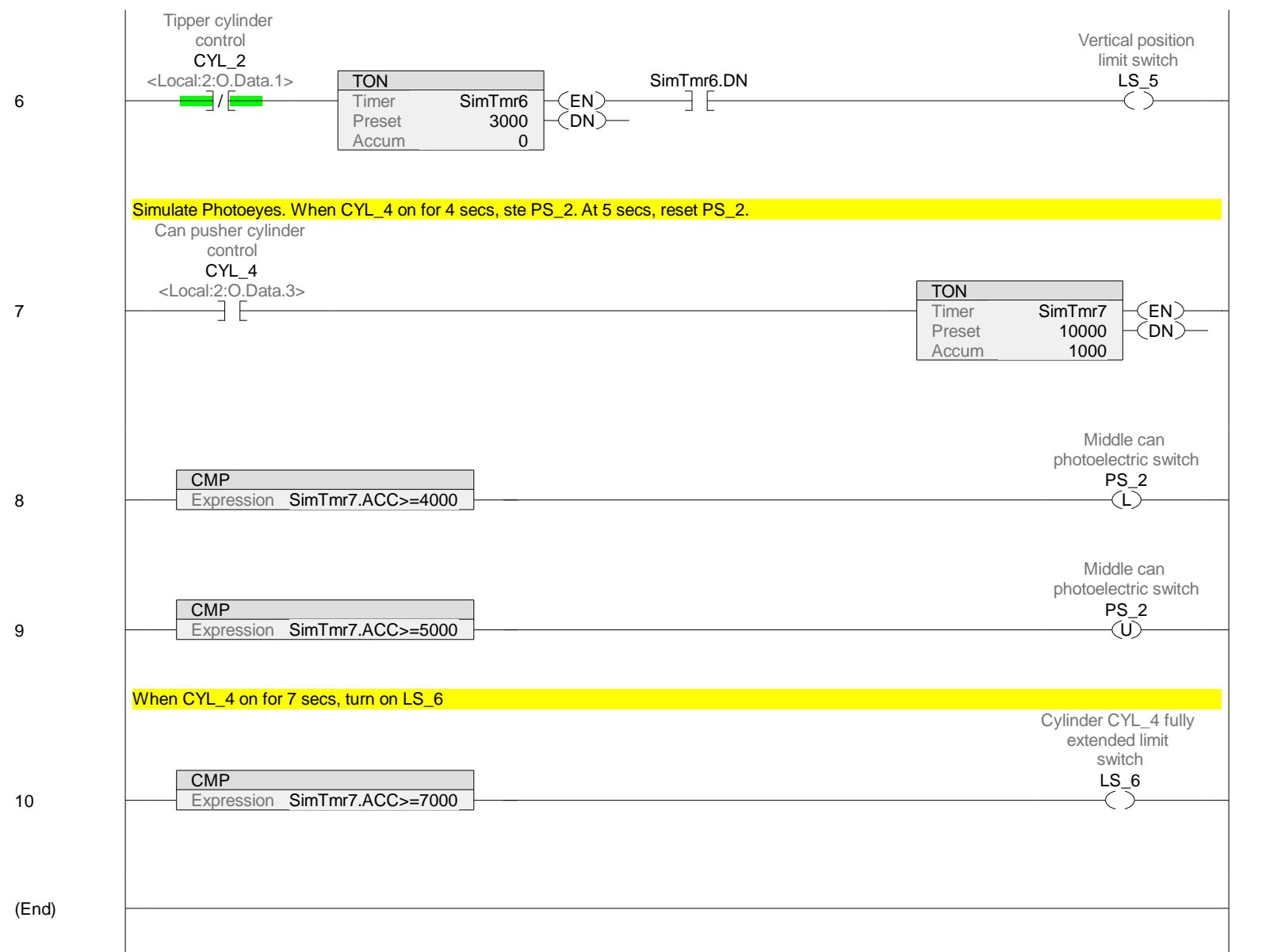


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Erbia Blender Station Simulation

When reset, forget there is anything in station





SP15_03

Label does not exist	1
MainTask	
MainProgram	
MainRoutine	
Ladder Diagram	2
Simulation	
Simulation	
Ladder Diagram	6