

## Main

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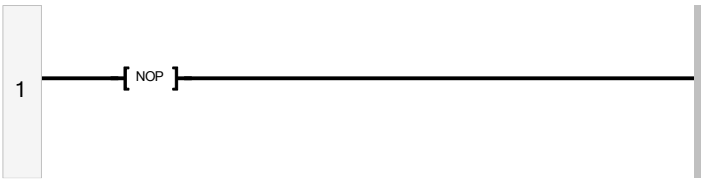
Main

Rung1 Diagram

SP6-1 Carton Sealer Copyright (c) 2023, Dogwood Valley Press, LLC

Additional internal memory:

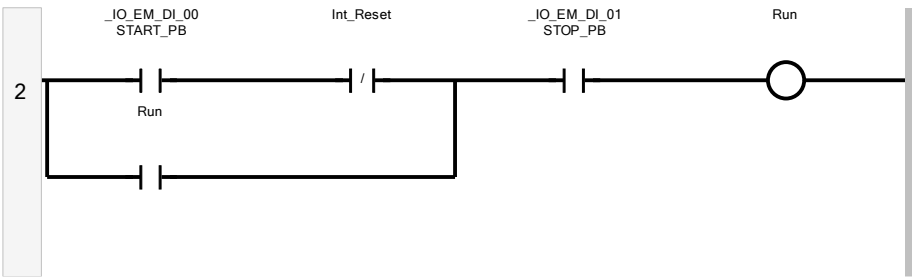
Tag	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Step_1 to Step_7	BOOL	Step-in-progress bits
Spray_Tmr	TON	Times spray
Dry_Tmr	TON	Times drying step
Retract_Tmr	TON	Times retract of rams
Reset_Tmr	TON	Times reset (retract of rams)



Rung2 Diagram

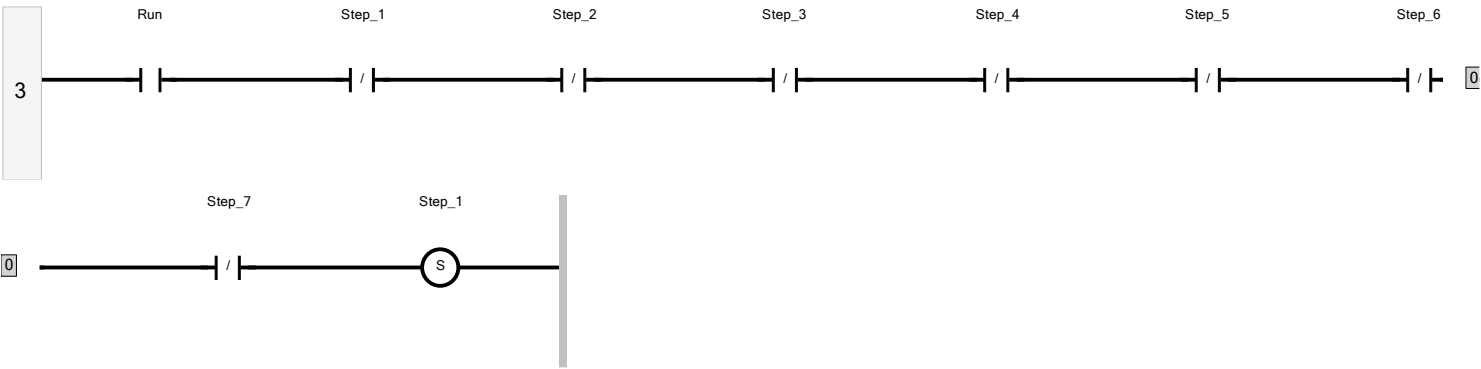
Start/stop and initial start.

During reset, prevent start.



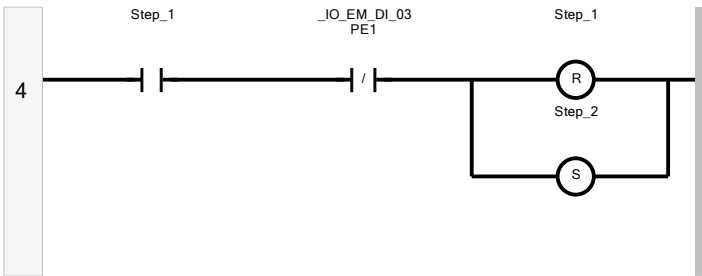
Rung3 Diagram

Initial start



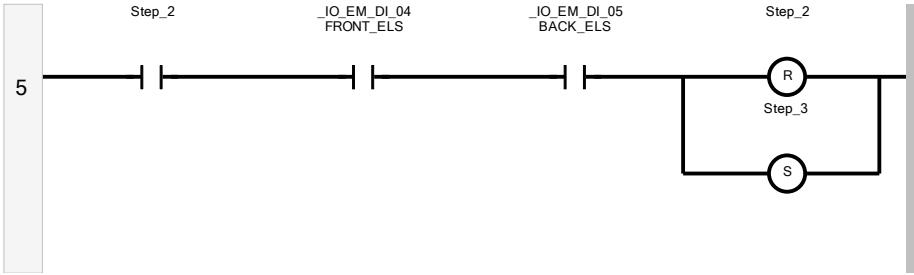
Rung4 Diagram

Step 1 - Wait for box



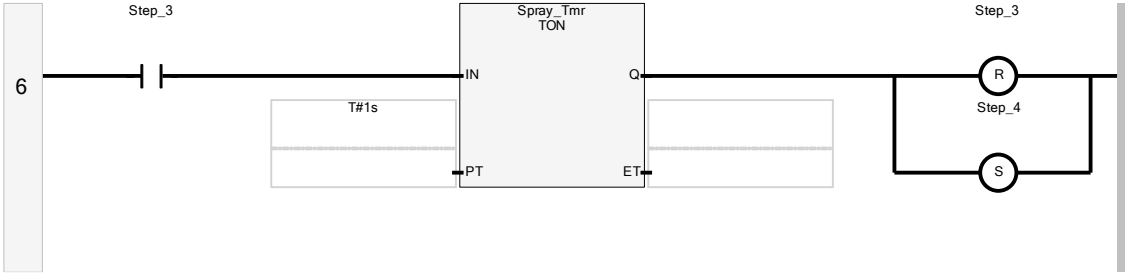
Rung5 Diagram

Step 2 - Push down end flaps



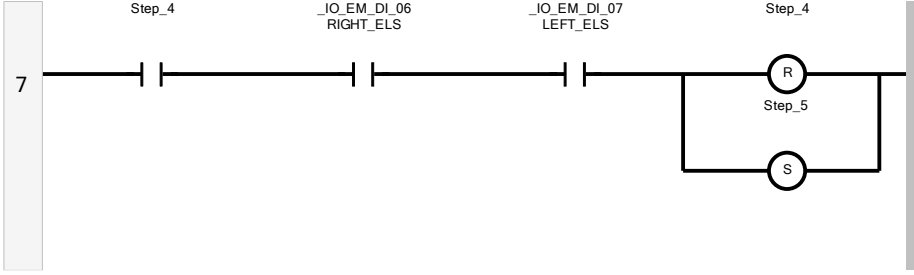
Rung6 Diagram

Step\_3 - Spray glue



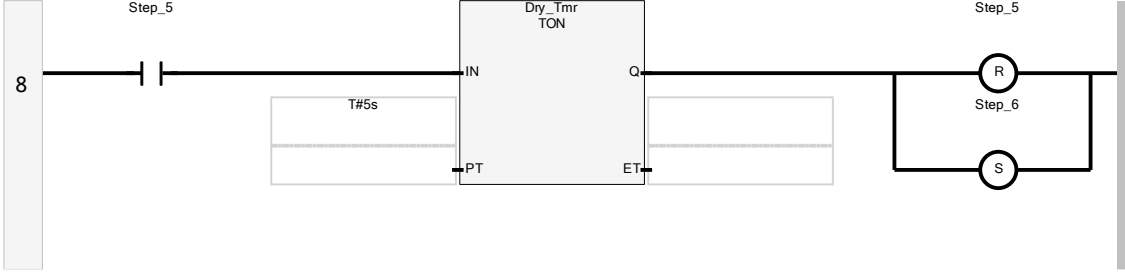
Rung7 Diagram

Step 4 - Push down side flaps



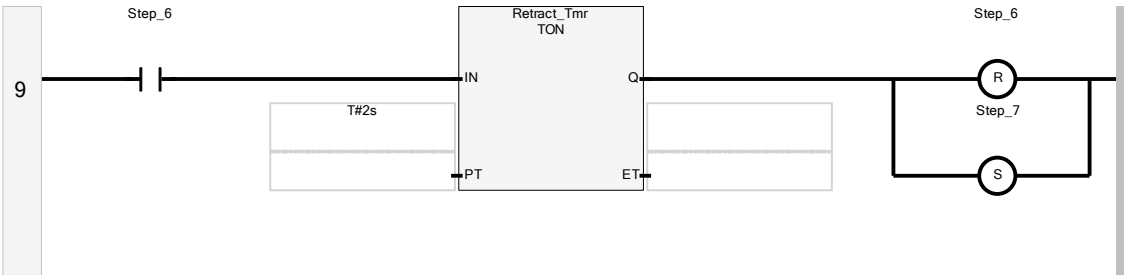
Rung8 Diagram

Step 5 - Drying wait



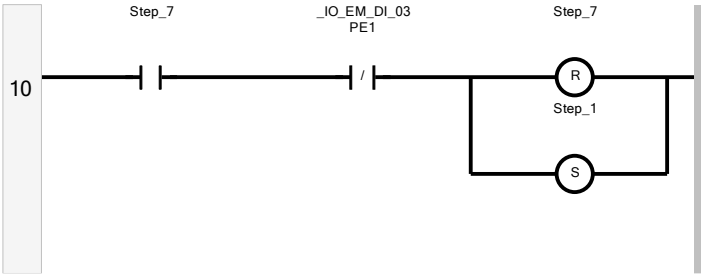
Rung9 Diagram

Step 6 - Retract rams



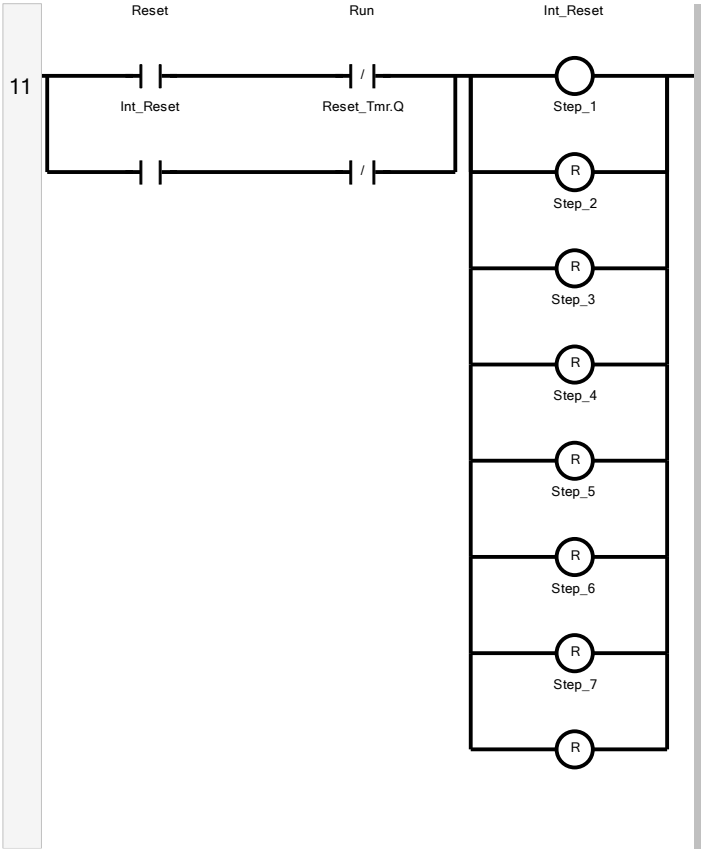
Rung10 Diagram

Step 7 - Move box out



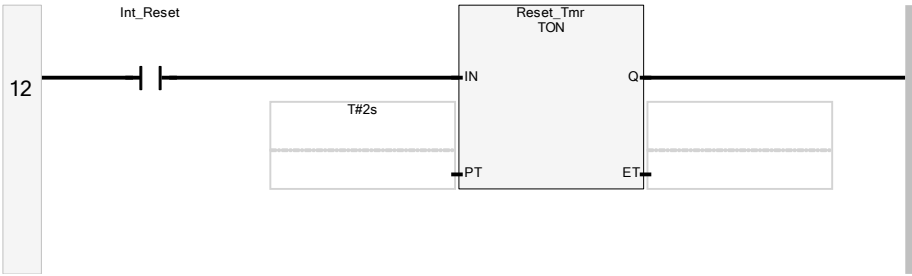
Rung11 Diagram

Reset steps



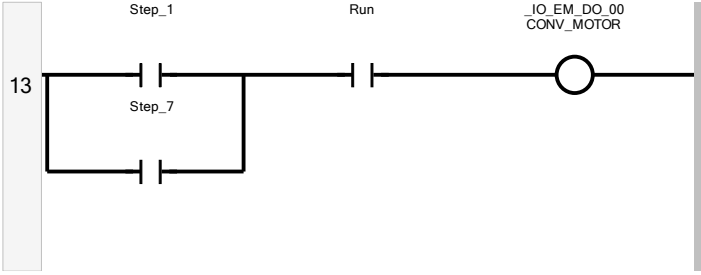
Rung12 Diagram

Timer for reset



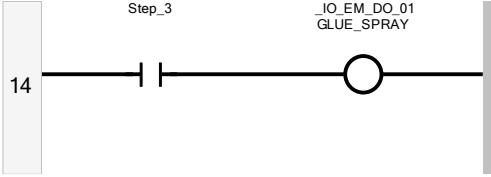
Rung13 Diagram

Conveyor control



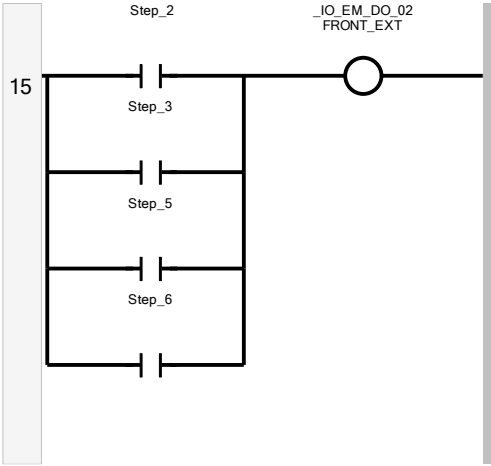
Rung14 Diagram

Glue spray

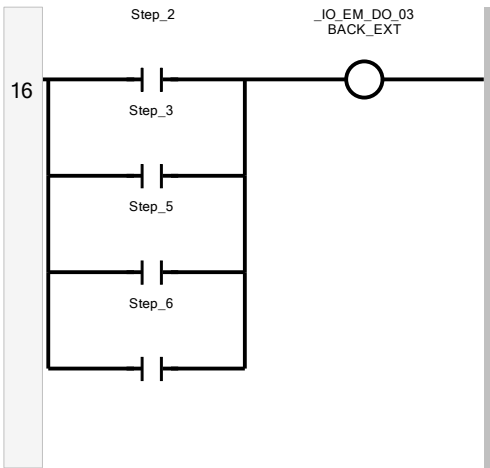


Rung15 Diagram

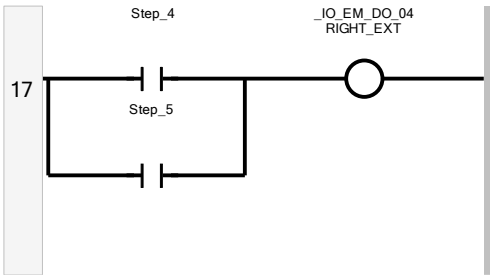
Cylinder controls



Rung16 Diagram



Rung17 Diagram



Rung18 Diagram

