

Case Erector Control

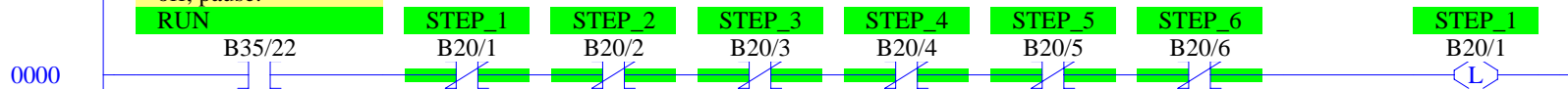
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Additional internal memory:

Symbol	Address	
STEP_1 to STEP_6	B20/1 to B20/6	Step-in-progress bits
UP_TMR	T4:1	Times opening up
BDOWN_TMR	T4:2	Times deactivate of bottom cylinder
PULSE_CNT	C5:1	Count encoder pulses

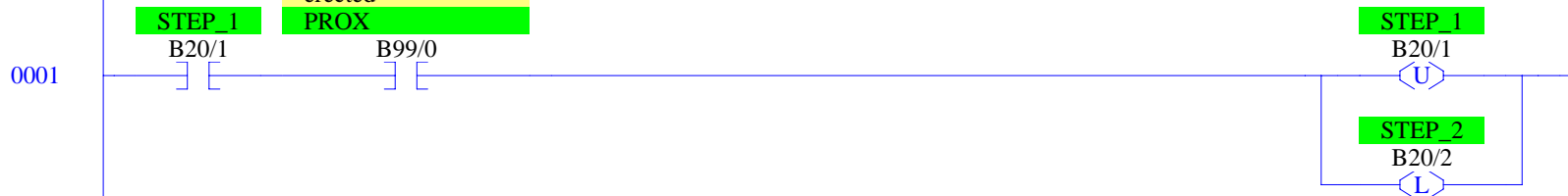
Initial start.

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



Step 1 Move in.

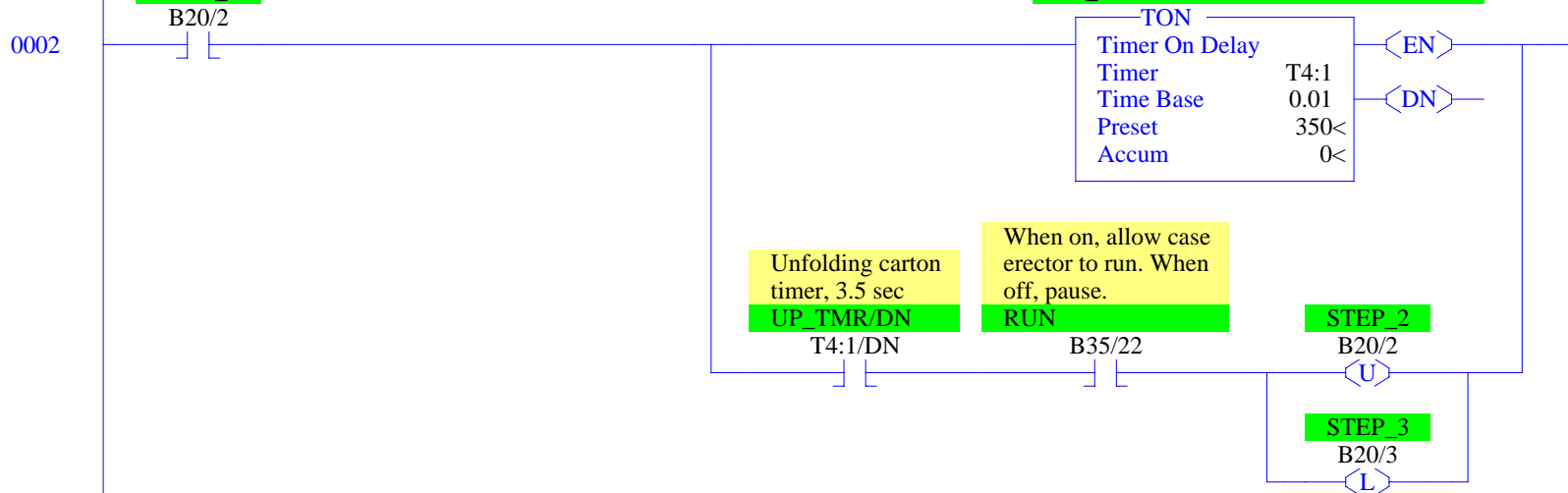
Proximity switch, on when flat carton is in position to be erected



Step 2 Open up.

Unfolding carton
timer, 3.5 sec

UP_TMR

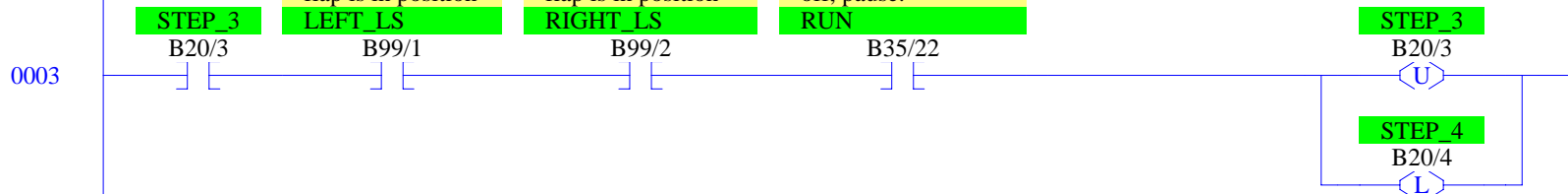


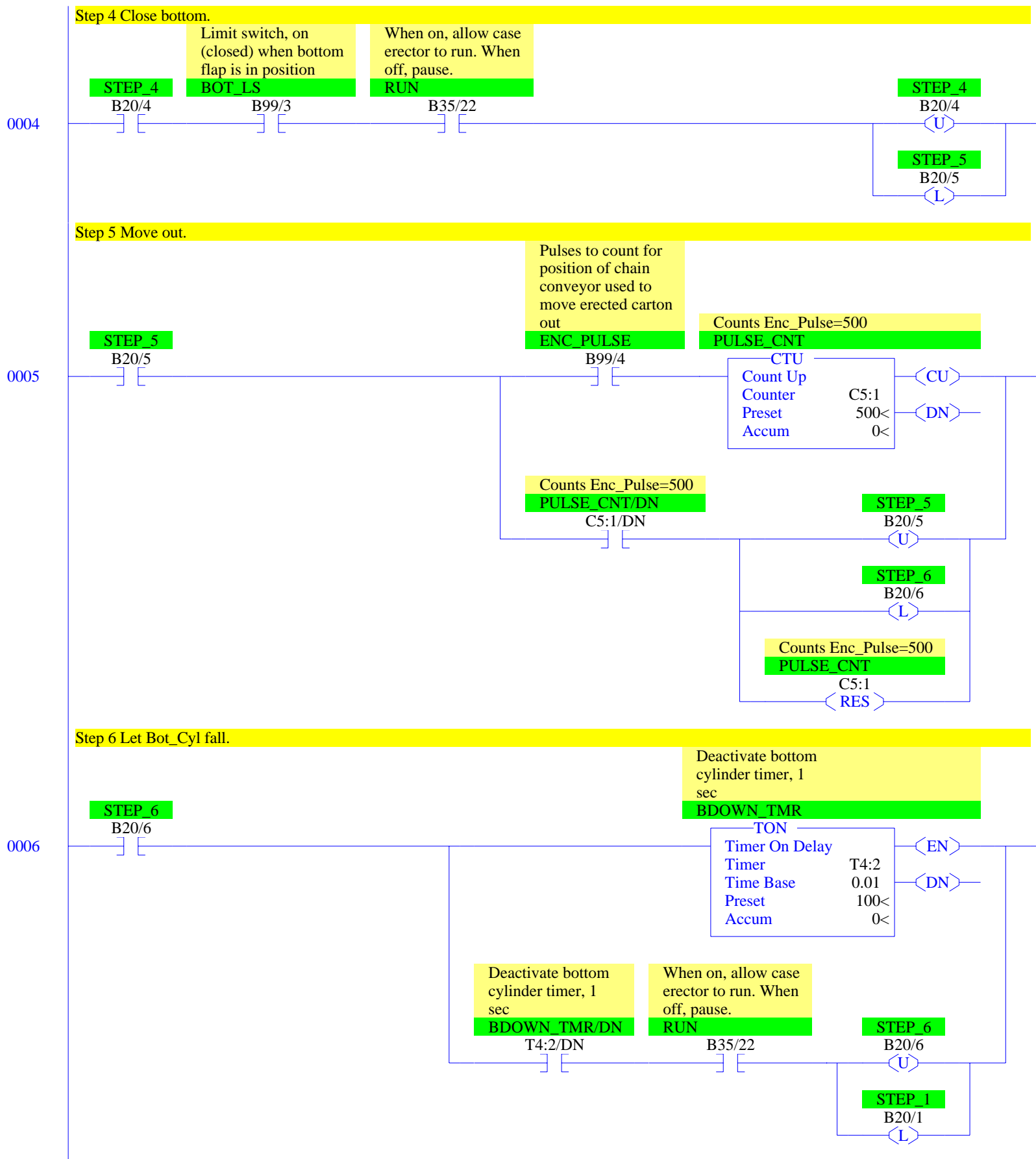
Step 3 Close sides.

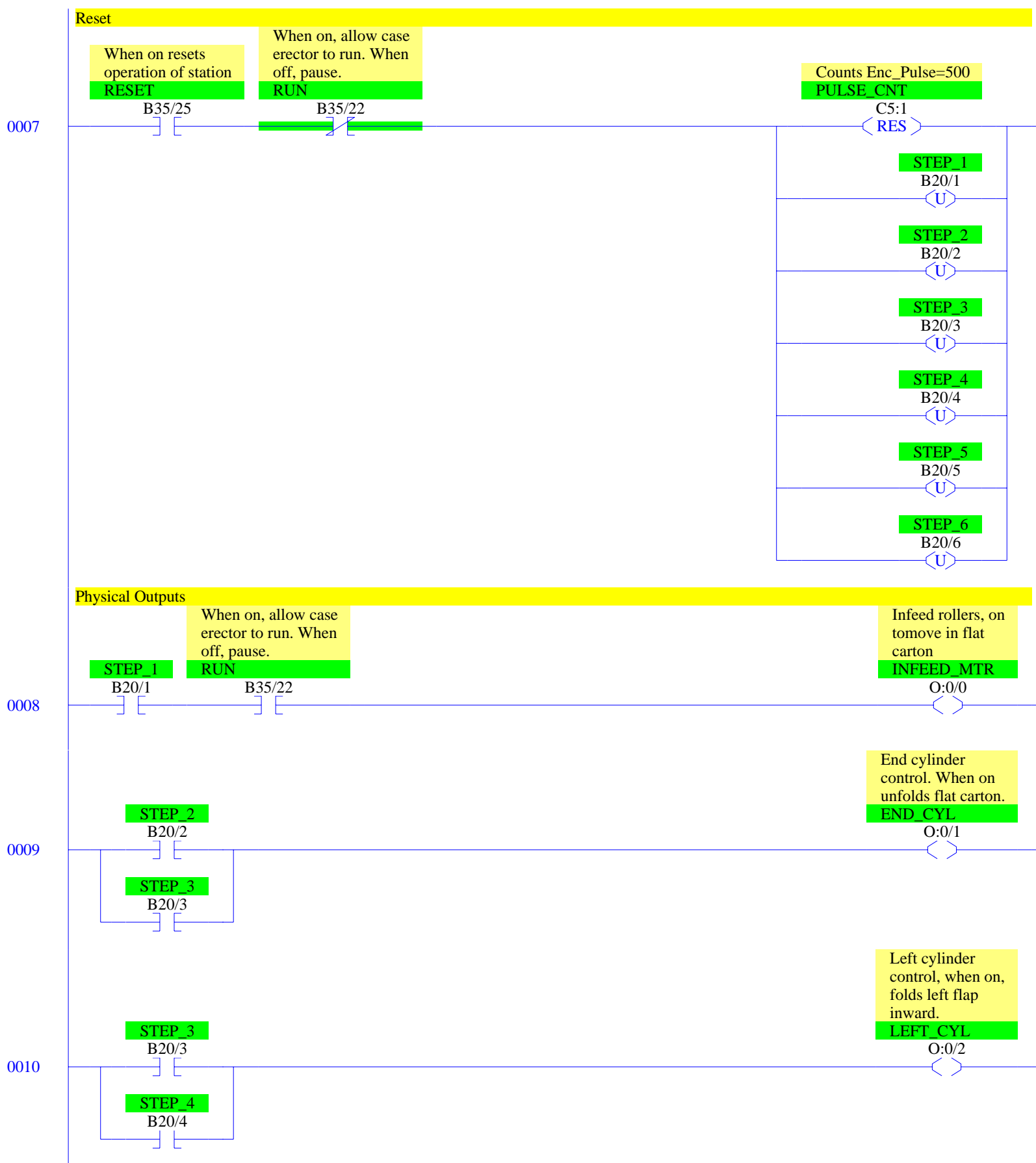
Limit switch, on (closed) when left flap is in position

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

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



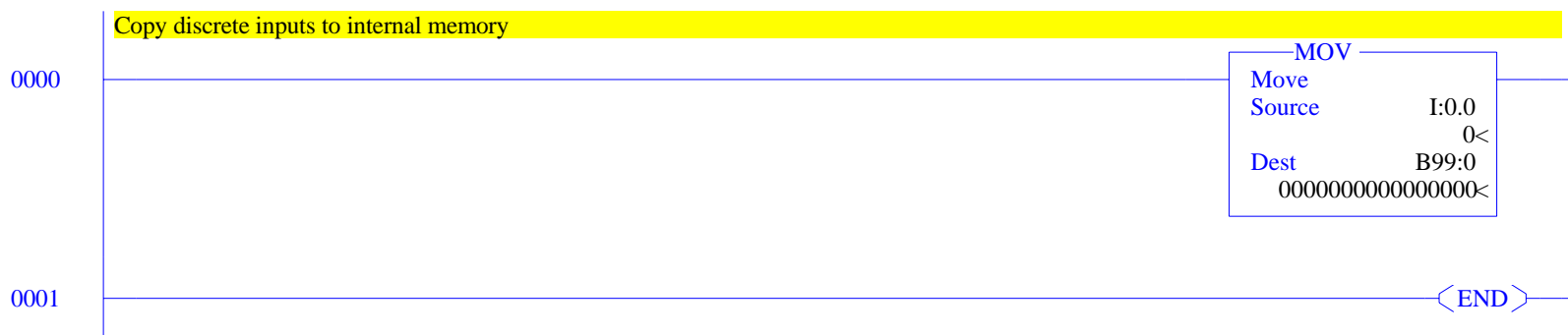






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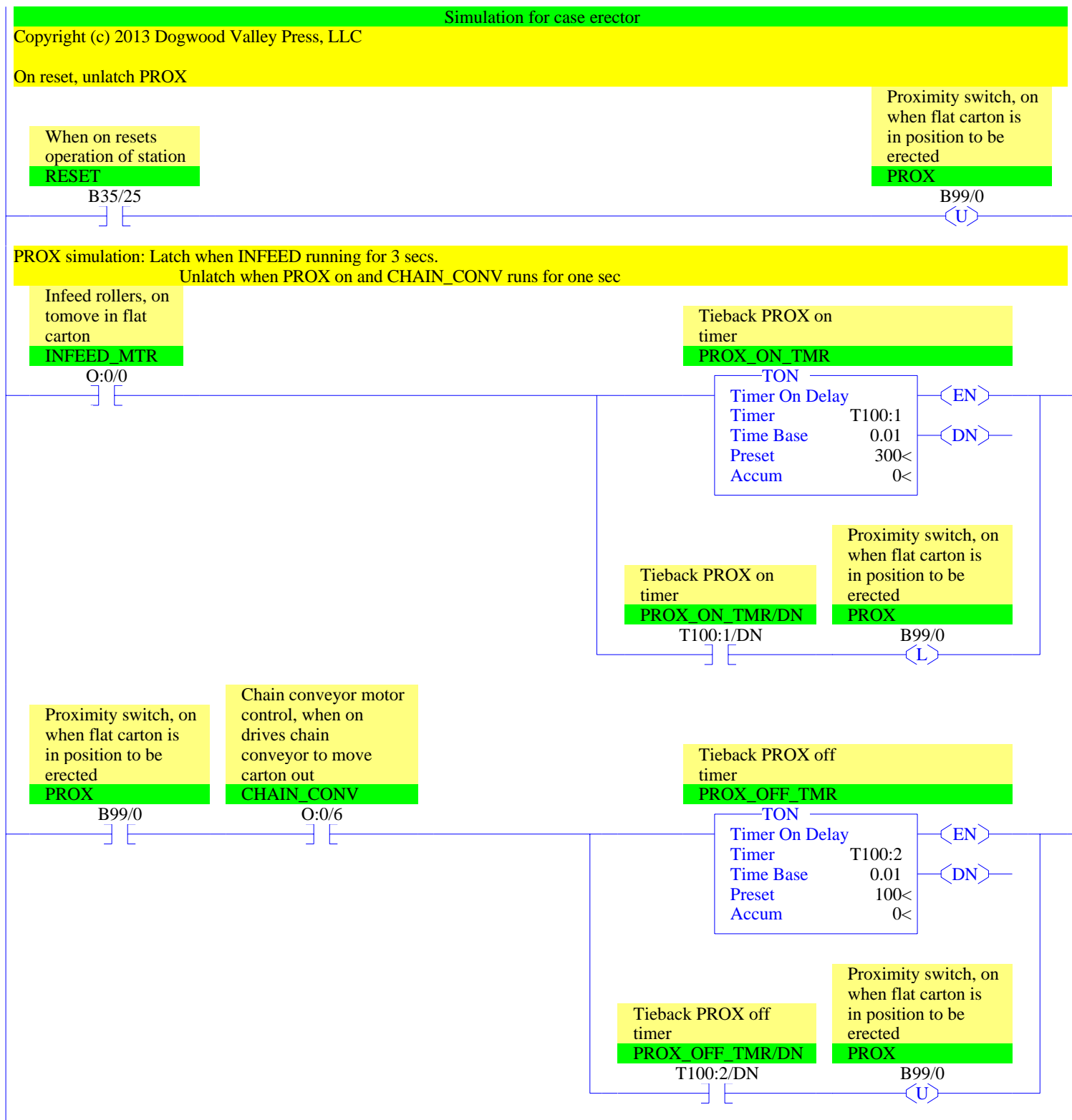
⟨END⟩

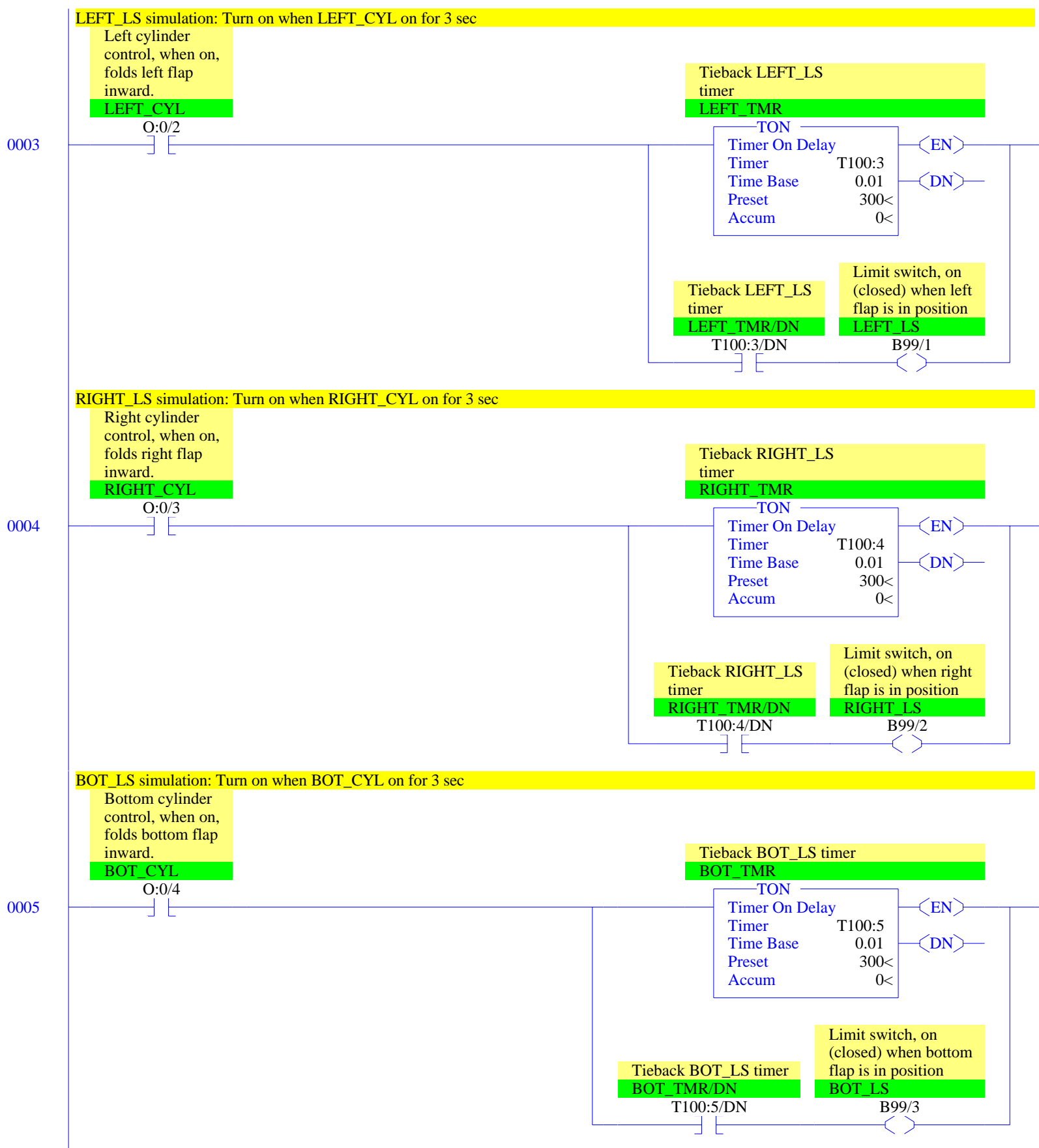


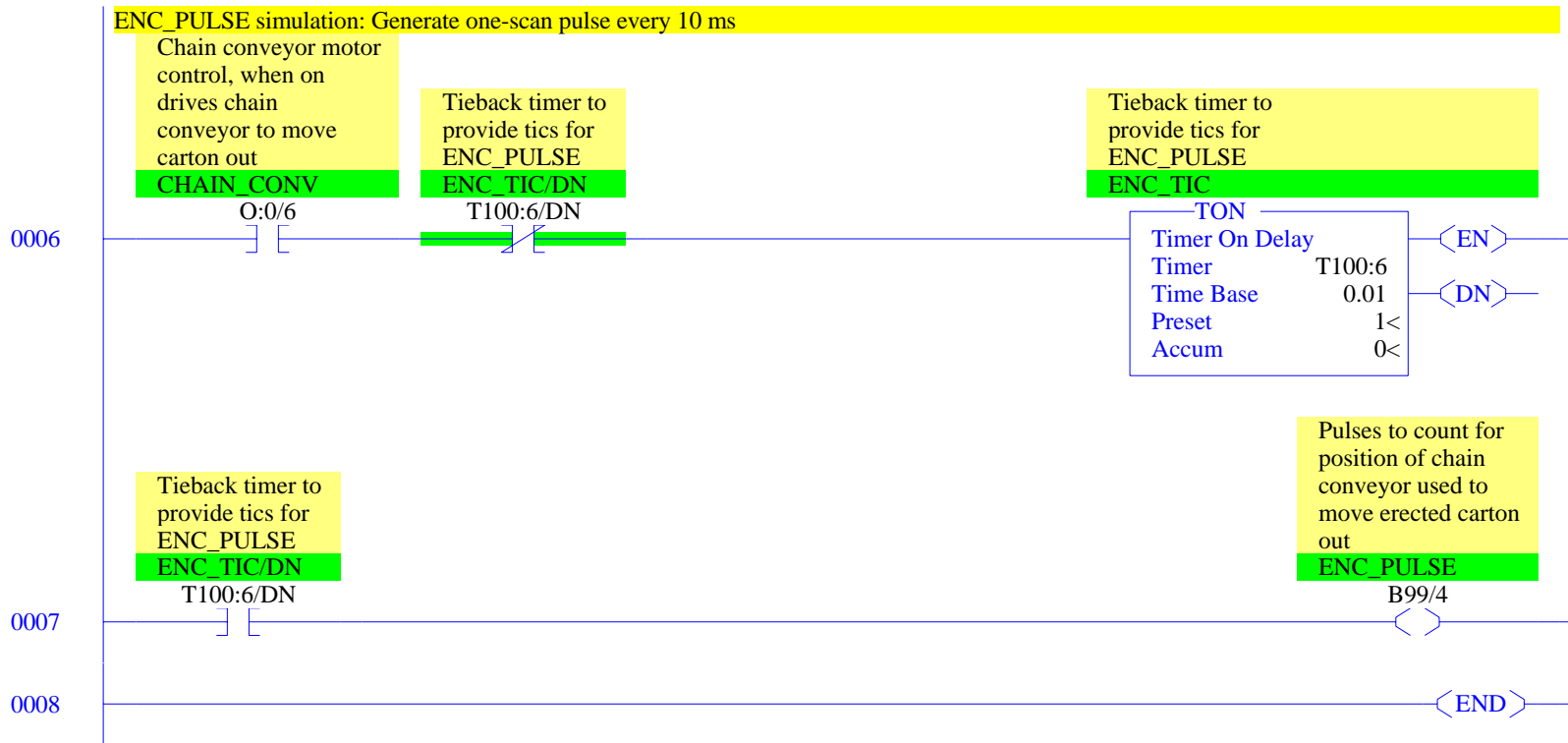
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RSLogix 500 Cross Reference Report - Sorted by Address

O:0/0	- {INFEED_MTR} Infeed rollers, on to move in flat carton OTE - File #2 - 8 XIC - File #100 TIEBACK - 1
O:0/1	- {END_CYL} End cylinder control. When on unfolds flat carton. OTE - File #2 - 9
O:0/2	- {LEFT_CYL} Left cylinder control, when on, folds left flap inward. OTE - File #2 - 10 XIC - File #100 TIEBACK - 3
O:0/3	- {RIGHT_CYL} Right cylinder control, when on, folds right flap inward. OTE - File #2 - 11 XIC - File #100 TIEBACK - 4
O:0/4	- {BOT_CYL} Bottom cylinder control, when on, folds bottom flap inward. OTE - File #2 - 12 XIC - File #100 TIEBACK - 5
O:0/5	- {GATE1} Gate cylinder control, on to prevent carton from sliding out of station as it OTE - File #2 - 13
O:0/6	- {CHAIN_CONV} Chain conveyor motor control, when on drives chain conveyor to move cart OTE - File #2 - 14 XIC - File #100 TIEBACK - 2, 6
I:0.0	- MOV - File #99 DUPLIC_INS - 0
B3/200	- {ENAB_TIE_BACK} Enable tie-back simulation logic XIC - File #2 - 15 XIO - File #2 - 16
T4:1	- {UP_TMR} Unfolding carton timer, 3.5 sec TON - File #2 - 2
T4:1/DN	- XIC - File #2 - 2
T4:2	- {BDOWN_TMR} Deactivate bottom cylinder timer, 1 sec TON - File #2 - 6
T4:2/DN	- XIC - File #2 - 6
C5:1	- {PULSE_CNT} Counts Enc_Pulse=500 CTU - File #2 - 5 RES - File #2 - 5, 7
C5:1/DN	- XIC - File #2 - 5
B20/1	- {STEP_1} OTL - File #2 - 0, 6 OTU - File #2 - 1, 7 XIC - File #2 - 1, 8 XIO - File #2 - 0
B20/2	- {STEP_2} OTL - File #2 - 1 OTU - File #2 - 2, 7 XIC - File #2 - 2, 9, 13 XIO - File #2 - 0
B20/3	- {STEP_3} OTL - File #2 - 2 OTU - File #2 - 3, 7 XIC - File #2 - 3, 9, 10, 11, 13 XIO - File #2 - 0
B20/4	- {STEP_4} OTL - File #2 - 3 OTU - File #2 - 4, 7 XIC - File #2 - 4, 10, 11, 12 XIO - File #2 - 0
B20/5	- {STEP_5} OTL - File #2 - 4 OTU - File #2 - 5, 7 XIC - File #2 - 5, 12, 14 XIO - File #2 - 0
B20/6	- {STEP_6} OTL - File #2 - 5 OTU - File #2 - 6, 7 XIC - File #2 - 6 XIO - File #2 - 0
B35/22	- {RUN} When on, allow case erector to run. When off, pause. XIC - File #2 - 0, 2, 3, 4, 6, 8, 14 XIO - File #2 - 7

RSLogix 500 Cross Reference Report - Sorted by Address

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B35/25      - {RESET} When on resets operation of station
             XIC - File #2 - 7
             File #100 TIEBACK - 0
B99:0       - MOV - File #99 DUPLIC_INS - 0
B99/0       - {PROX} Proximity switch, on when flat carton is in position to be erected
             OTL - File #100 TIEBACK - 1
             OTU - File #100 TIEBACK - 0, 2
             XIC - File #2 - 1
             File #100 TIEBACK - 2
B99/1       - {LEFT_LS} Limit switch, on (closed) when left flap is in position
             OTE - File #100 TIEBACK - 3
             XIC - File #2 - 3
B99/2       - {RIGHT_LS} Limit switch, on (closed) when right flap is in position
             OTE - File #100 TIEBACK - 4
             XIC - File #2 - 3
B99/3       - {BOT_LS} Limit switch, on (closed) when bottom flap is in position
             OTE - File #100 TIEBACK - 5
             XIC - File #2 - 4
B99/4       - {ENC_PULSE} Pulses to count for position of chain conveyor used to move erected cart
             OTE - File #100 TIEBACK - 7
             XIC - File #2 - 5
T100:1      - {PROX_ON_TMR} Tieback PROX on timer
             TON - File #100 TIEBACK - 1
T100:1/DN   - XIC - File #100 TIEBACK - 1
T100:2      - {PROX_OFF_TMR} Tieback PROX off timer
             TON - File #100 TIEBACK - 2
T100:2/DN   - XIC - File #100 TIEBACK - 2
T100:3      - {LEFT_TMR} Tieback LEFT_LS timer
             TON - File #100 TIEBACK - 3
T100:3/DN   - XIC - File #100 TIEBACK - 3
T100:4      - {RIGHT_TMR} Tieback RIGHT_LS timer
             TON - File #100 TIEBACK - 4
T100:4/DN   - XIC - File #100 TIEBACK - 4
T100:5      - {BOT_TMR} Tieback BOT_LS timer
             TON - File #100 TIEBACK - 5
T100:5/DN   - XIC - File #100 TIEBACK - 5
T100:6      - {ENC_TIC} Tieback timer to provide tics for ENC_PULSE
             TON - File #100 TIEBACK - 6
T100:6/DN   - XIC - File #100 TIEBACK - 7
             XIO - File #100 TIEBACK - 6
U:99        - JSR - File #2 - 16
U:100       - {TIEBACK}
             JSR - File #2 - 15

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