

## Case Erector Control

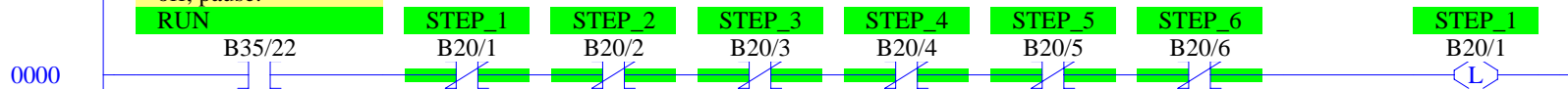
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Additional internal memory:

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

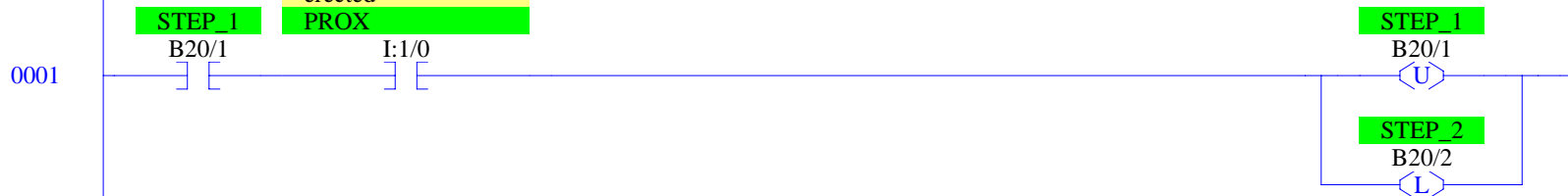
Initial start.

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



Step 1 Move in.

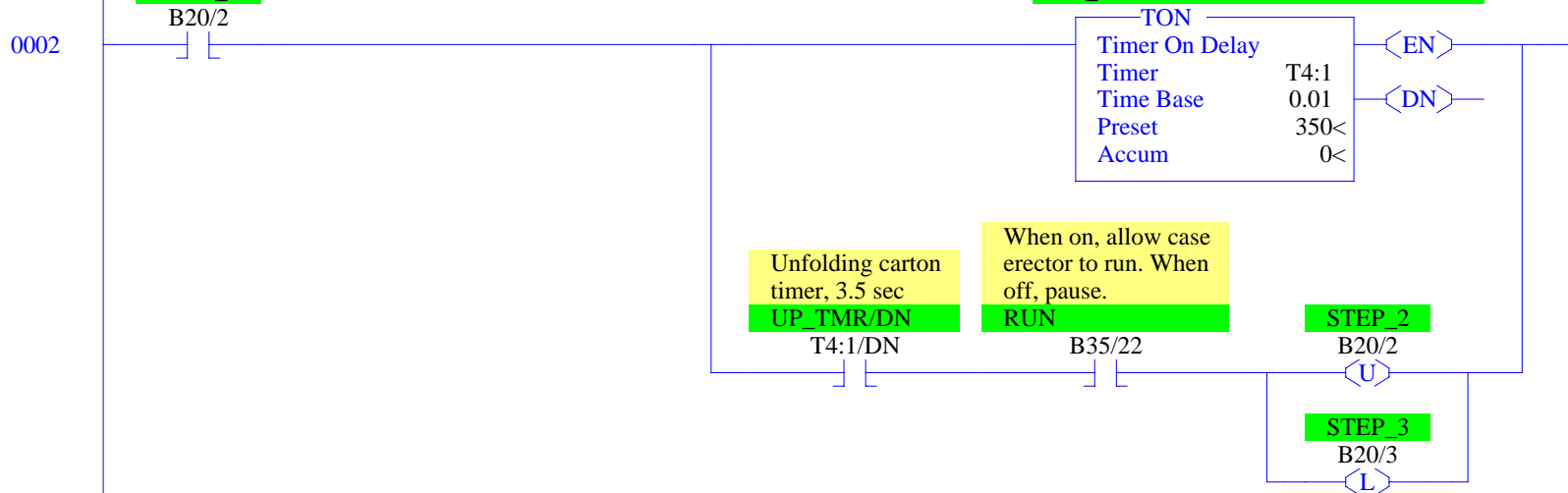
Proximity switch, on when flat carton is in position to be erected



Step 2 Open up.

Unfolding carton  
timer, 3.5 sec

UP\_TMR

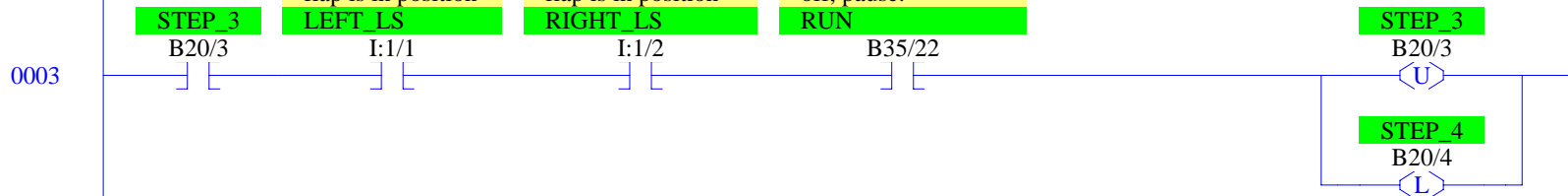


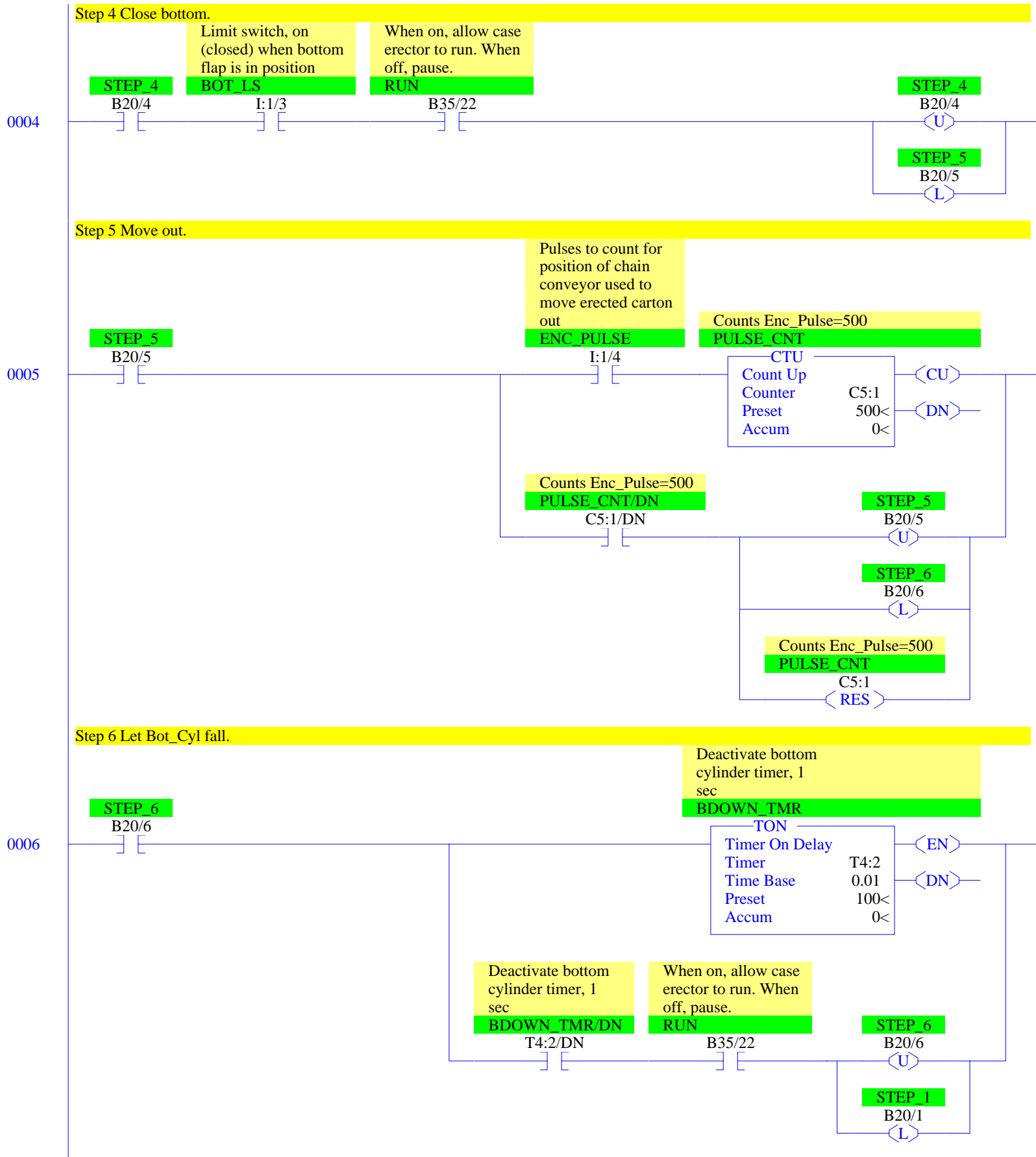
**Step 3 Close sides.**

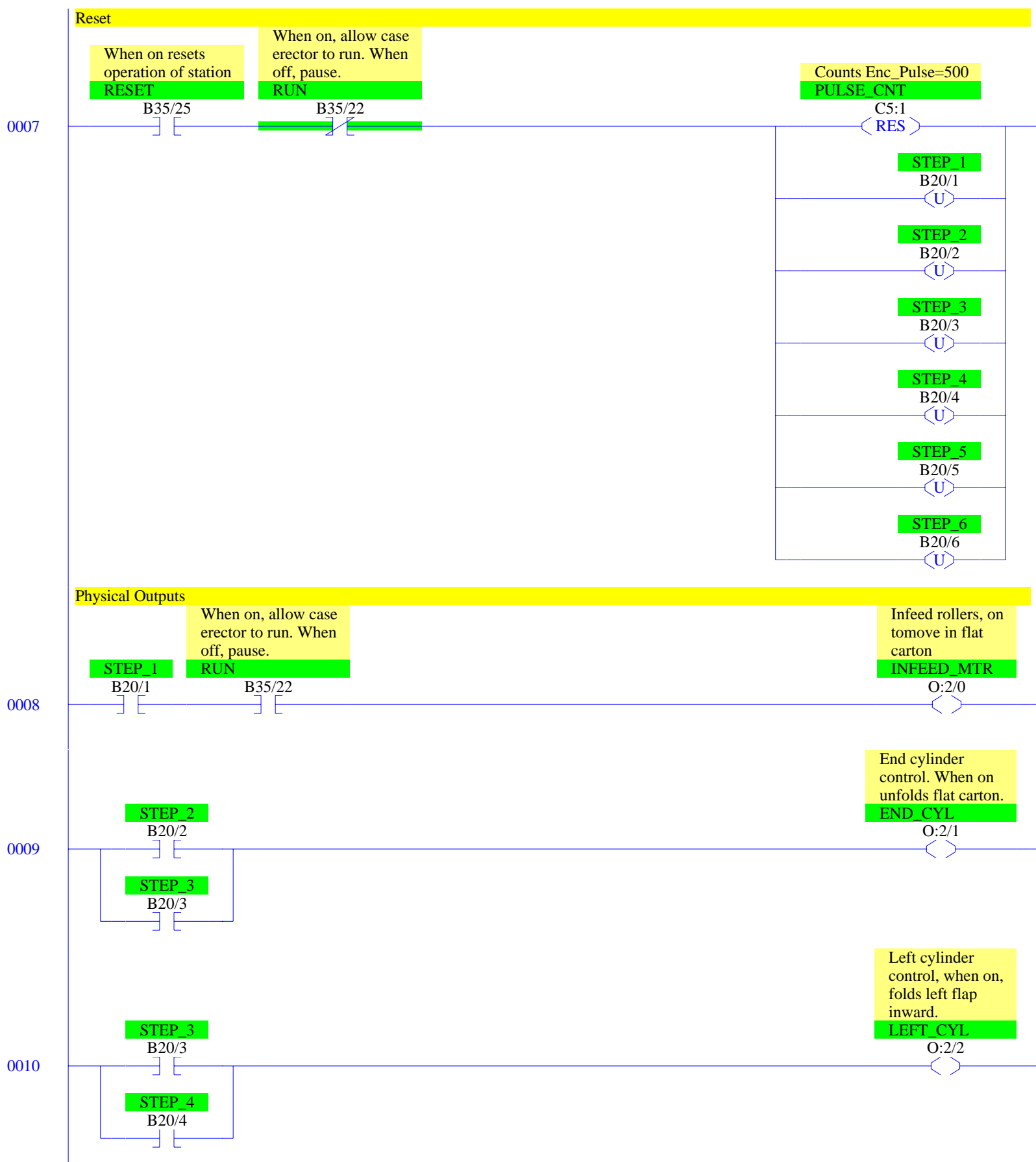
Limit switch, on (closed) when left flap is in position

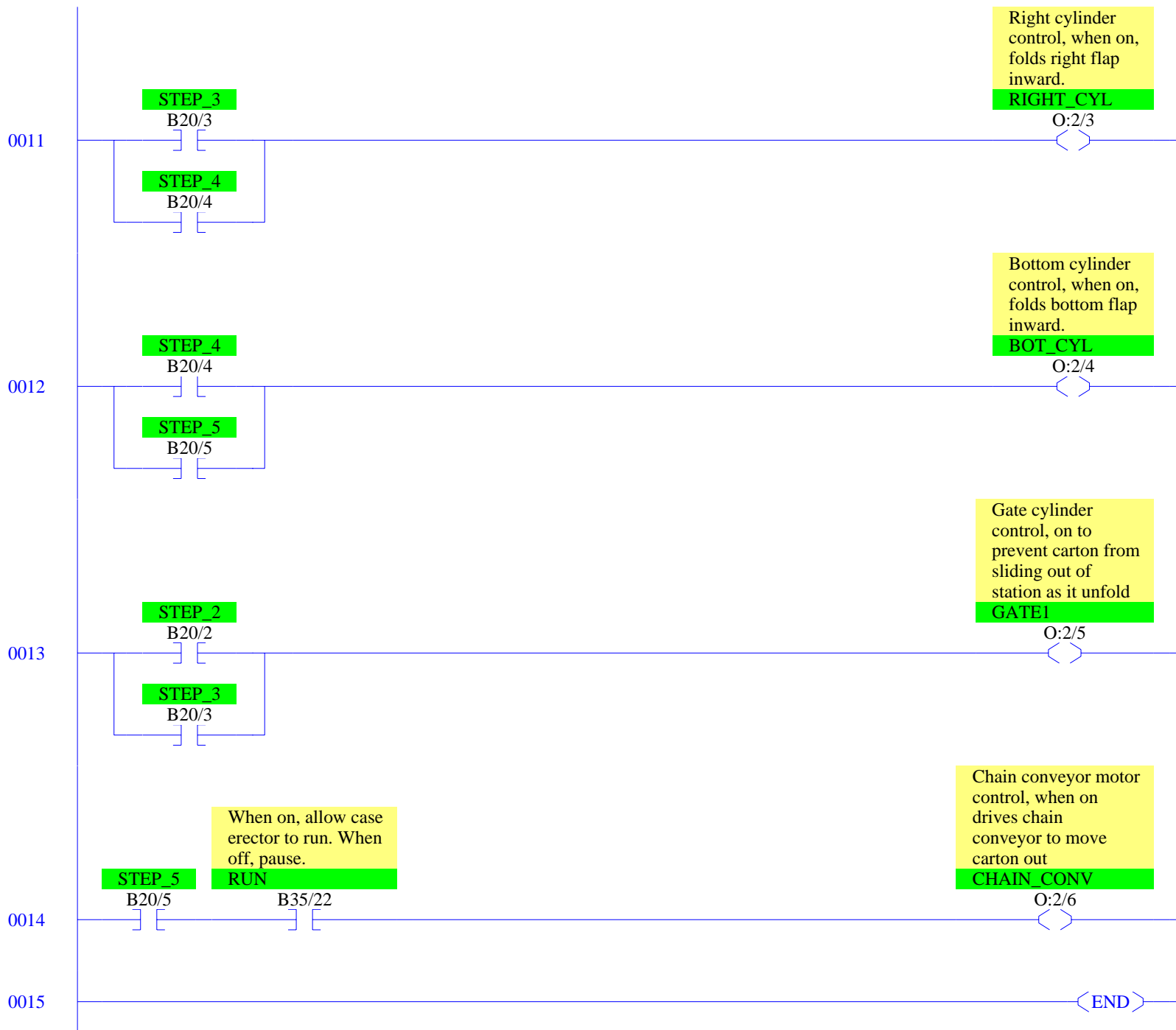
Limit switch, on (closed) when right flap is in position

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









## RSLogix 500 Cross Reference Report - Sorted by Address

O:2/0	- {INFEED_MTR} Infeed rollers, on to move in flat carton OTE - File #2 - 8
O:2/1	- {END_CYL} End cylinder control. When on unfolds flat carton. OTE - File #2 - 9
O:2/2	- {LEFT_CYL} Left cylinder control, when on, folds left flap inward. OTE - File #2 - 10
O:2/3	- {RIGHT_CYL} Right cylinder control, when on, folds right flap inward. OTE - File #2 - 11
O:2/4	- {BOT_CYL} Bottom cylinder control, when on, folds bottom flap inward. OTE - File #2 - 12
O:2/5	- {GATE1} Gate cylinder control, on to prevent carton from sliding out of station as it OTE - File #2 - 13
O:2/6	- {CHAIN_CONV} Chain conveyor motor control, when on drives chain conveyor to move cart OTE - File #2 - 14
I:1/0	- {PROX} Proximity switch, on when flat carton is in position to be erected XIC - File #2 - 1
I:1/1	- {LEFT_LS} Limit switch, on (closed) when left flap is in position XIC - File #2 - 3
I:1/2	- {RIGHT_LS} Limit switch, on (closed) when right flap is in position XIC - File #2 - 3
I:1/3	- {BOT_LS} Limit switch, on (closed) when bottom flap is in position XIC - File #2 - 4
I:1/4	- {ENC_PULSE} Pulses to count for position of chain conveyor used to move erected cart XIC - File #2 - 5
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

RSLogix 500 Cross Reference Report - Sorted by Address

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B35/25	XIO - File #2 - 7
	- {RESET} When on resets operation of station
	XIC - File #2 - 7