











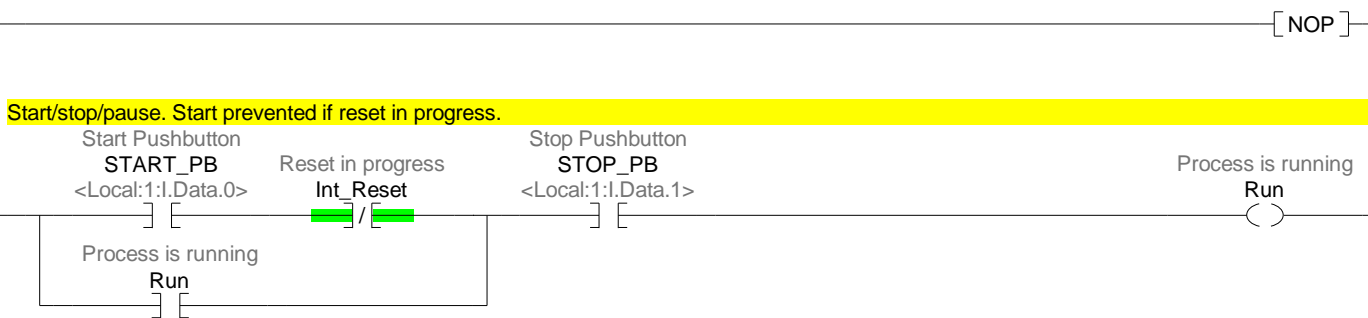
 **Controller Example_6_4** **Controller Fault Handler** **Power-Up Handler****Tasks** **MainTask** **MainProgram** **MainRoutine** **Simulation** **Simulation** **Unscheduled****Motion Groups** **Ungrouped Axes****Add-On Instructions****Data Types** **User-Defined** **Seq_Type**

Counter-Based Sequencer

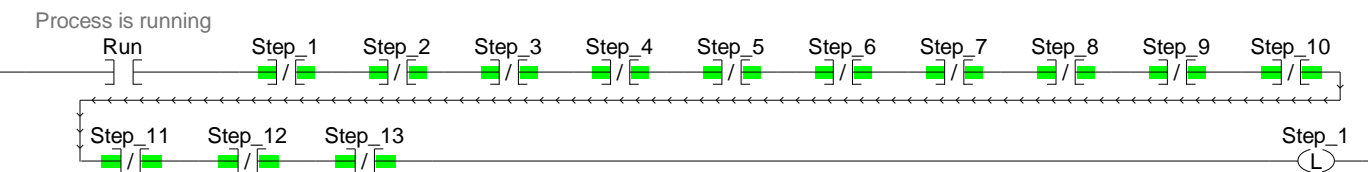
 **Strings** **Add-On-Defined** **Module-Defined** **AB:1756_DI:C:0** **AB:1756_DI:I:0** **AB:1756_DO:C:0** **AB:1756_DO:I:0** **AB:1756_DO:O:0****Trends****I/O Configuration** **1756 Backplane, 1756-A10** **[0] 1756-L71 Example_6_4** **[1] 1756-IB32/A Dig_In** **[2] 1756-OB16I Dig_Out**

Example 6.4 Engine Inverter With Simulation

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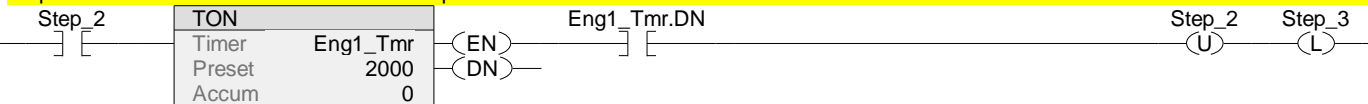
Generate transition out of initial step



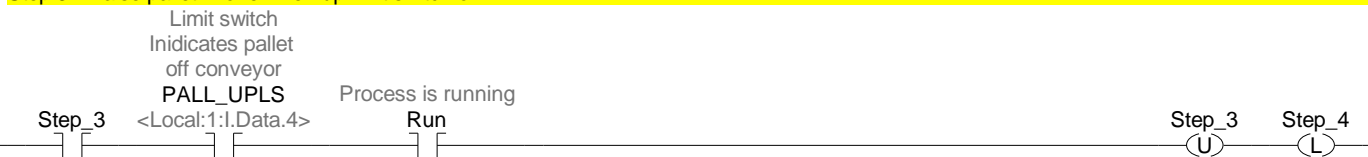
Step 1 - Wait for pallet. Done when PROX1 turns on.



Step 2 - Move to hook 2. Done when 2 sec elapsed.



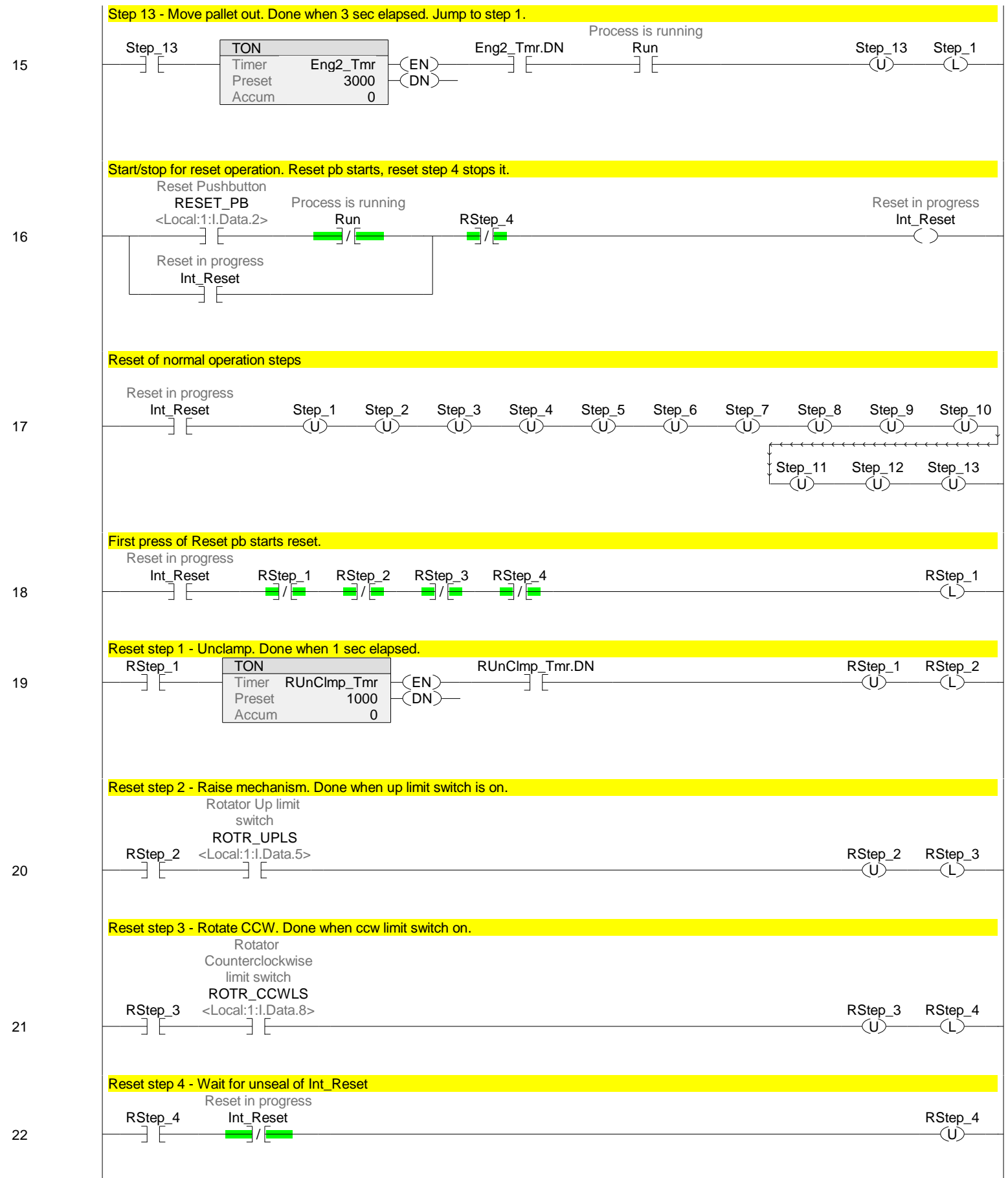
Step 3 - Raise pallet. Done when up limit switch on.

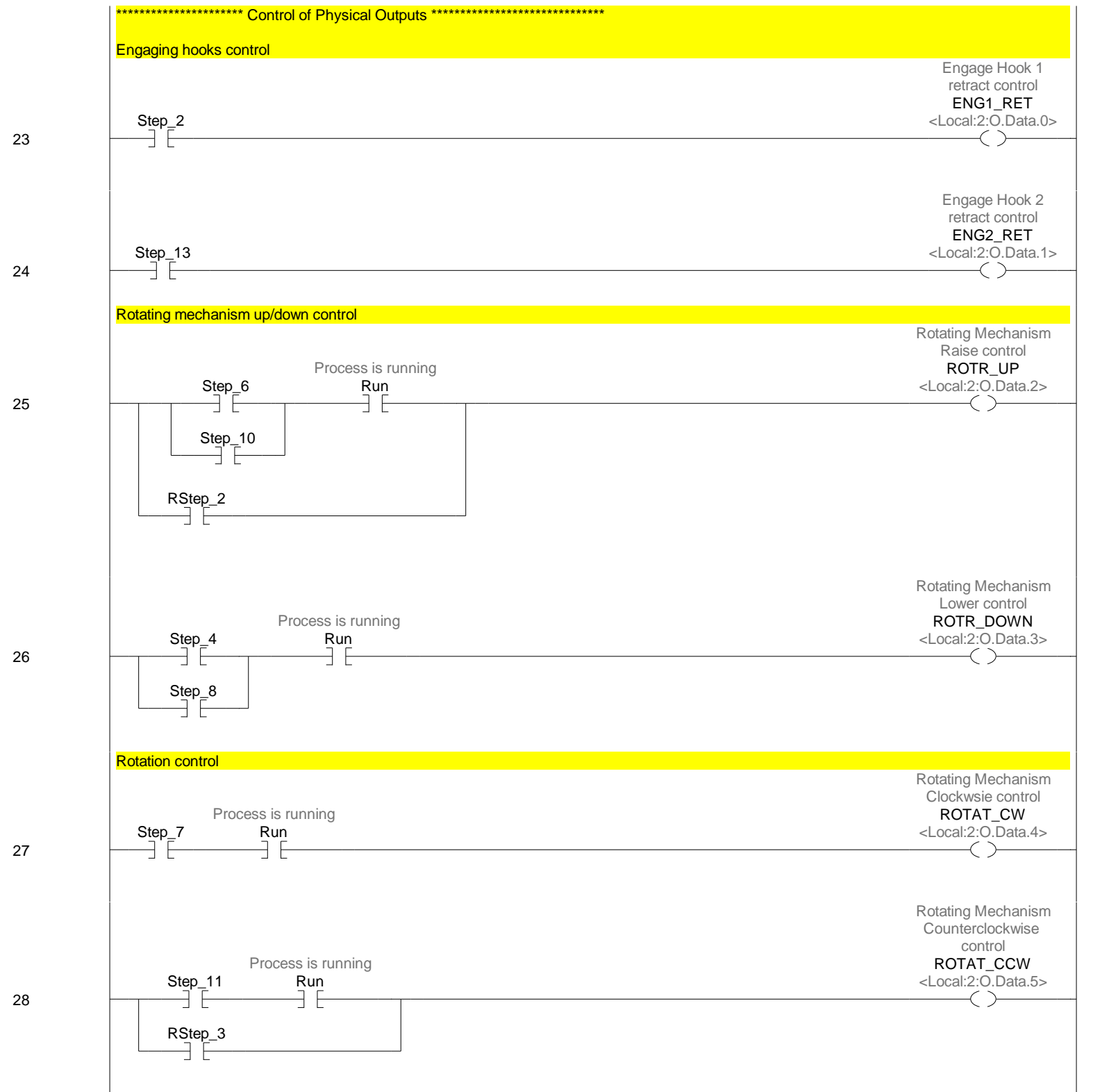


Step 4 - Lower rotator. Done when limit switch on.









Gripper Control

Gripper
close control
GRIP_CLOS
<Local:2:O.Data.6>

Step_5

Step_6

Step_7

Step_8

Pallet up control

Pallet Retainer
Up and off conveyor
control
PALL_UPCTL
<Local:2:O.Data.7>

Step_3

Step_4

Step_5

Step_6

Step_7

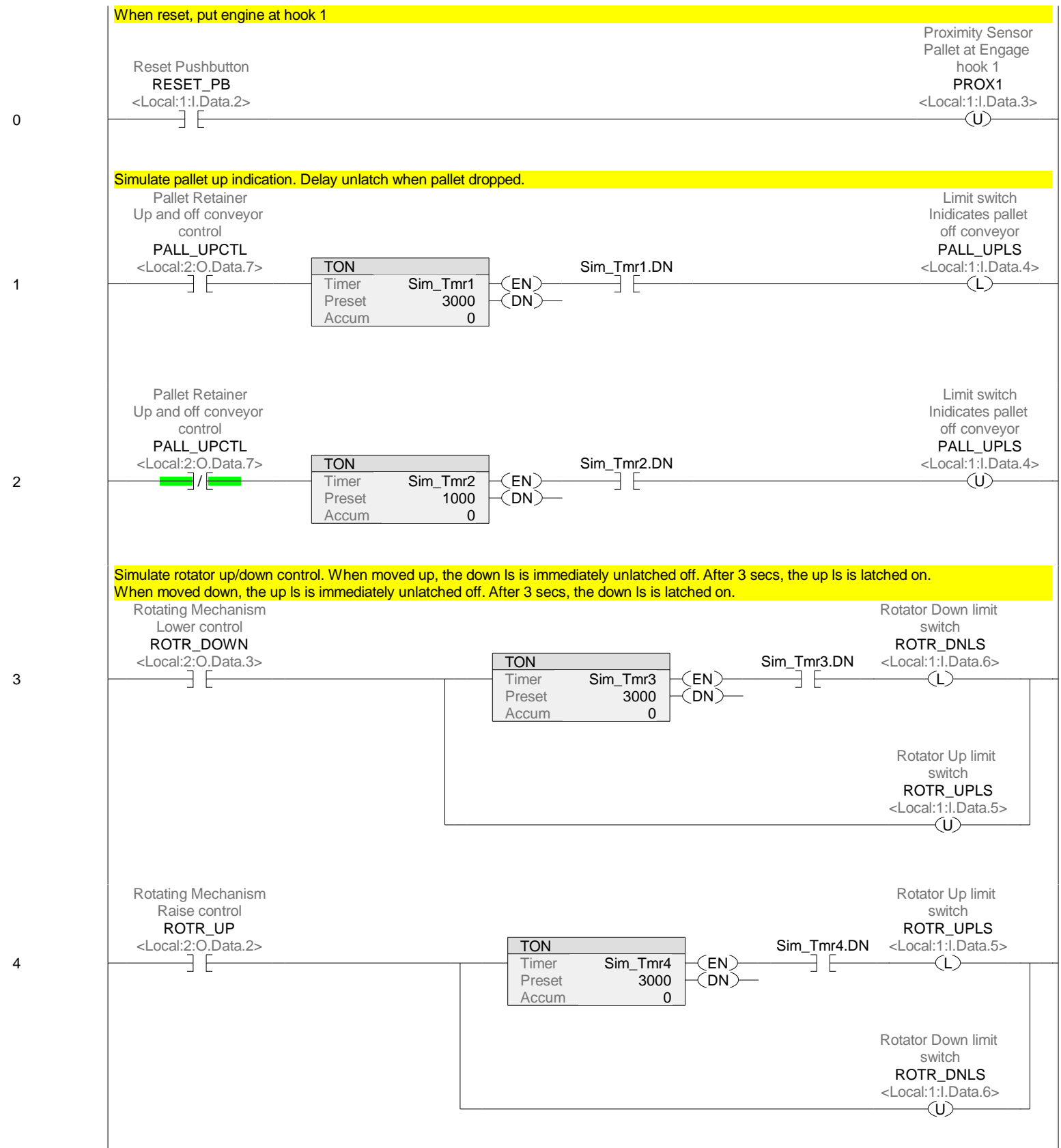
Step_8

Step_9

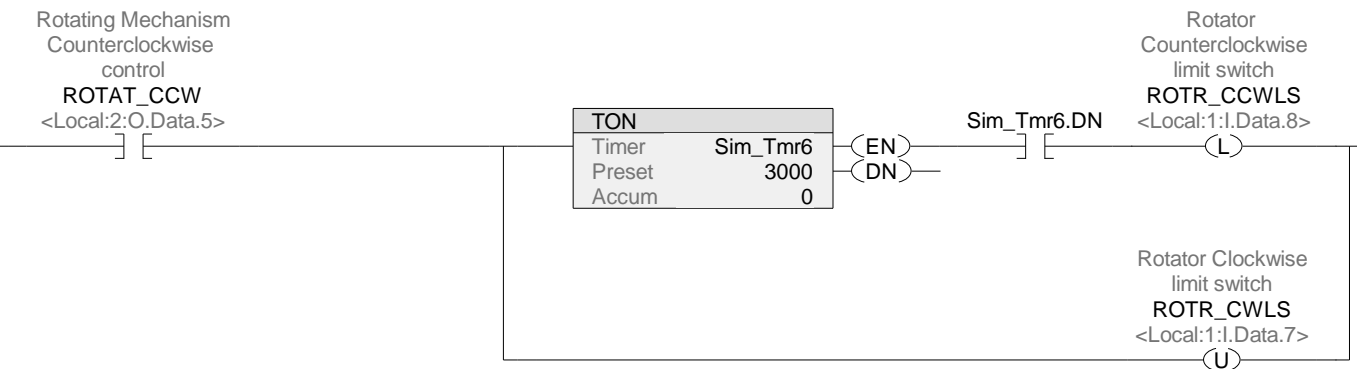
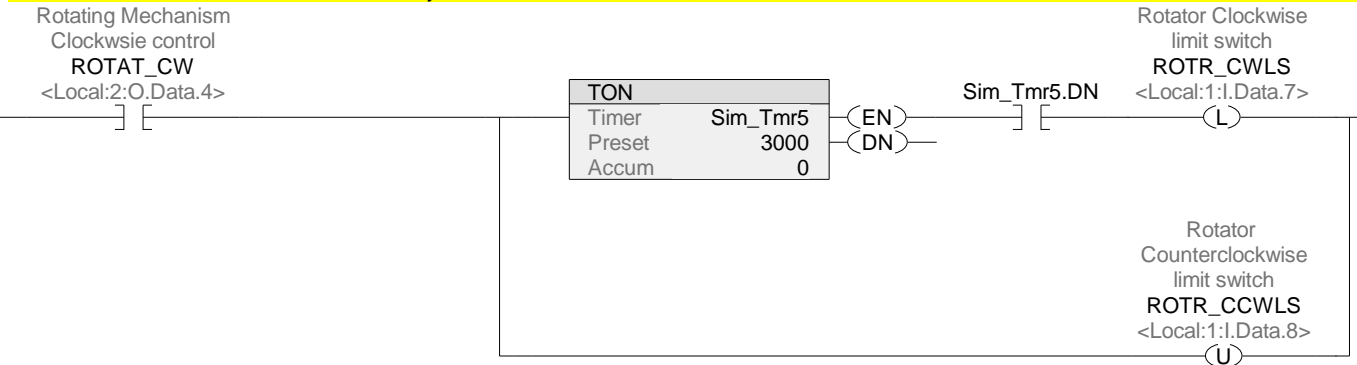
Step_10

Step_11

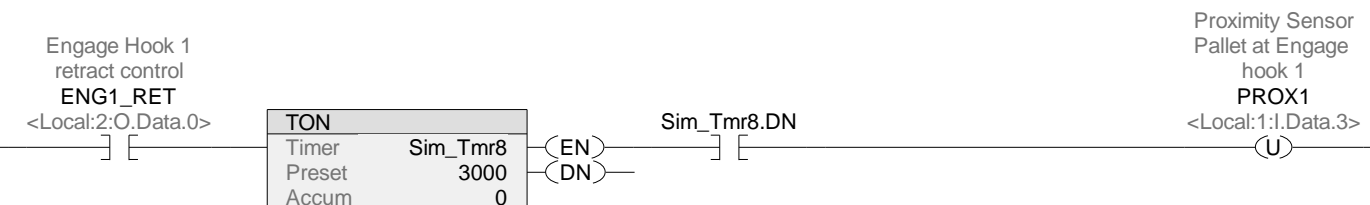
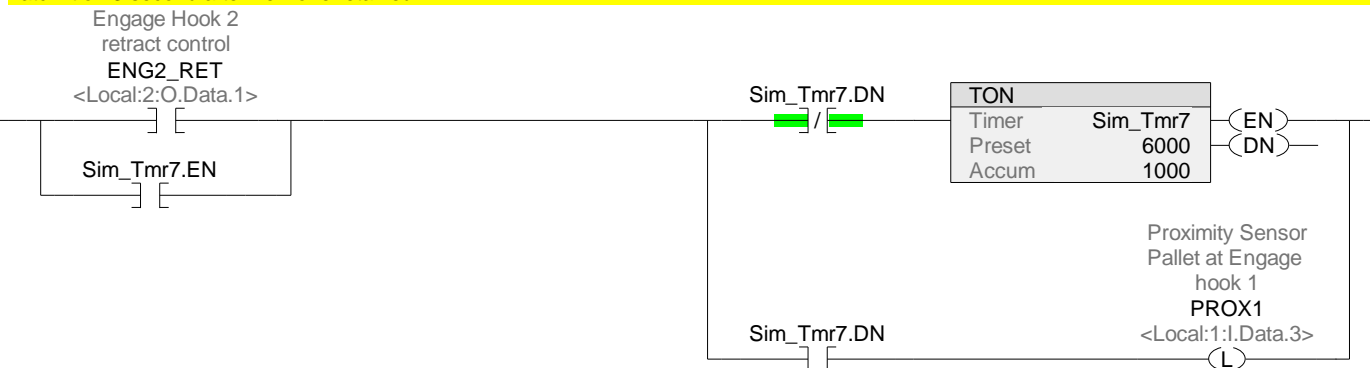
(End)



Simulate rotator rotating control. When rotated CW, the CCW Is is immediately unlatched off. After 3 secs, the CW Is is latched on.
When rotated CCW, the CW Is is immediately unlatched off. After 3 secs, the CCW Is is latched on.



Simulate Pallet Prox
Latch it on 6 seconds after one has left the station.
Latch it off 3 second after new one retained.



(End)