









 **Controller Example\_15\_1** **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**

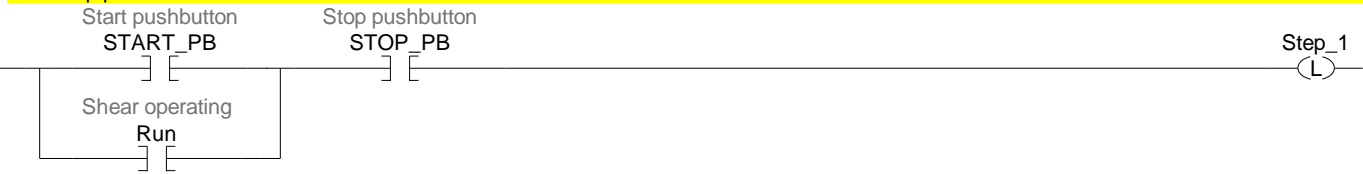
Counter-Based Sequencer

 **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\_15\_1** **[1] 1756-IB32/A Dig\_In** **[2] 1756-OB16I Dig\_Out**

Example 15.1 Metal Shear With Simulation

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Start/stop/pause



Generate transition out of initial step



Step 1 - Move in material. Trans. to step 2 when in position



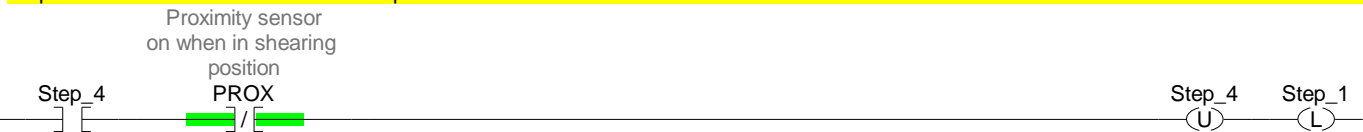
Step 2 - Move shear down. Trans. to step 3 when shear down



Step 3 - Move shear up. Trans. to step 4 when shear up.



Step 4 - Move cut sheet out. Trans to Step 1 when out.

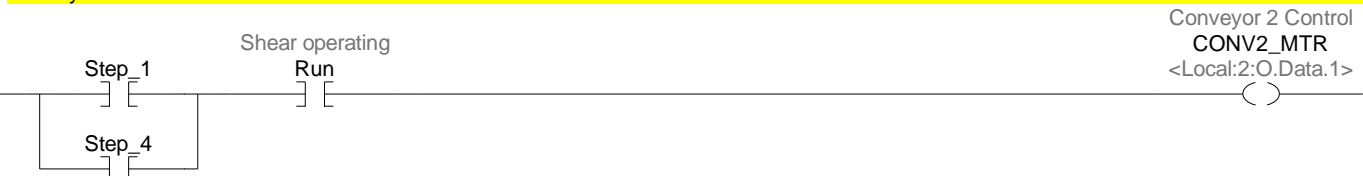


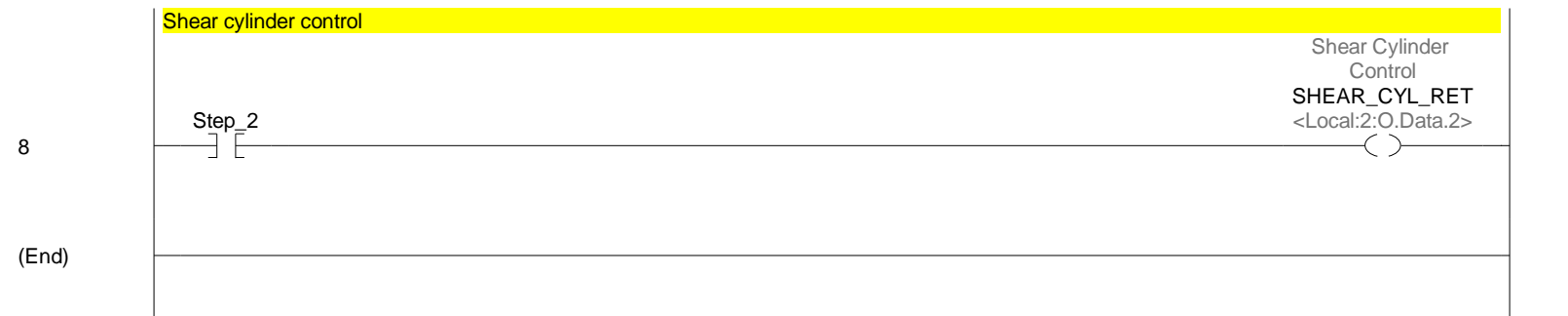
\*\*\*\*\* Control of Physical Outputs \*\*\*\*\*

Conveyor 1 control



Conveyor 2 control

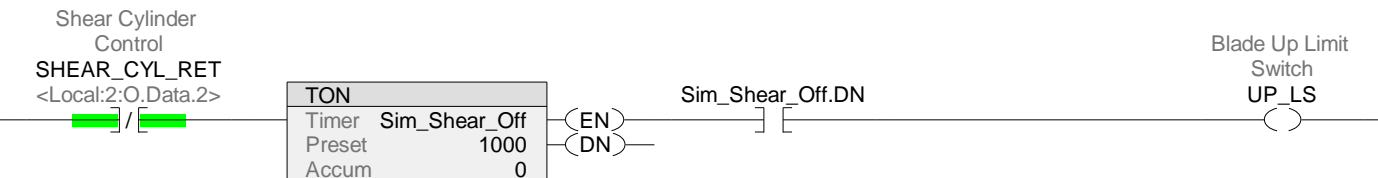
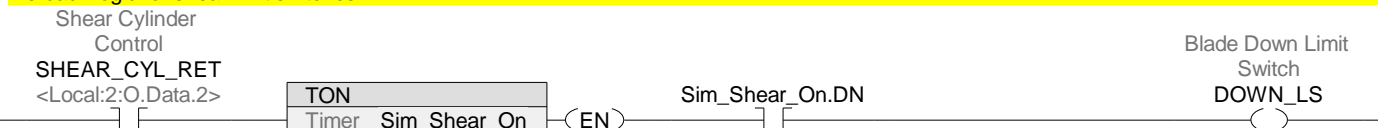




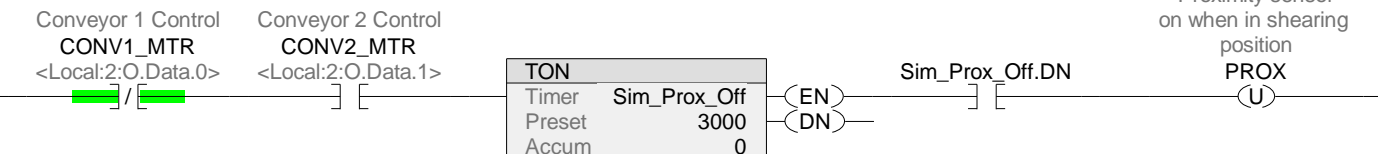
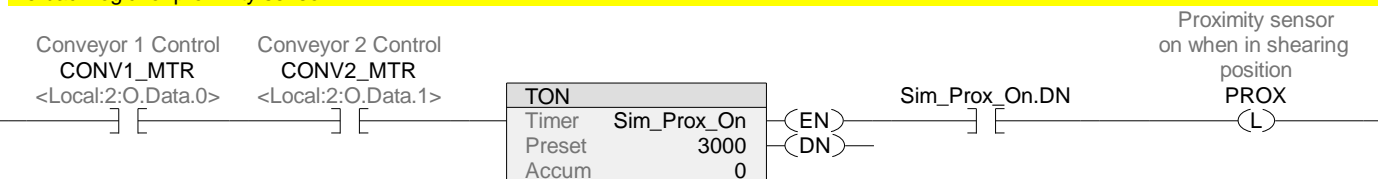
Simulation for metal shear process

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Tie-back logic for shear limit switches



Tie-back logic for proximity sensor



(End)

<b>Example_15_1</b>	
Label does not exist .....	1
<b>MainTask</b>	
<b>MainProgram</b>	
<b>MainRoutine</b>	
Ladder Diagram .....	2
<b>Simulation</b>	
<b>Simulation</b>	
Ladder Diagram .....	4