









 **Controller Example_6_7** **Controller Fault Handler** **Power-Up Handler****Tasks** **MainTask** **MainProgram** **MainRoutine** **Unscheduled****Motion Groups** **Ungrouped Axes****Add-On Instructions****Data Types** **User-Defined** **Seq_Type**

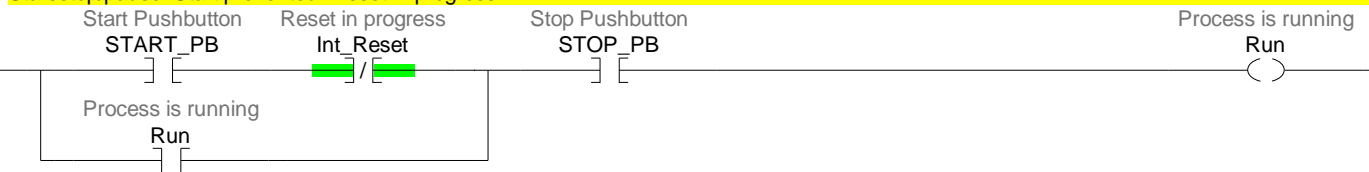
Counter-Based Sequencer

 **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_7** **[1] 1756-IB32/A Dig_In** **[2] 1756-OB16I Dig_Out**

Example 6.7 Engine Inverter Using Ad-hoc Approach

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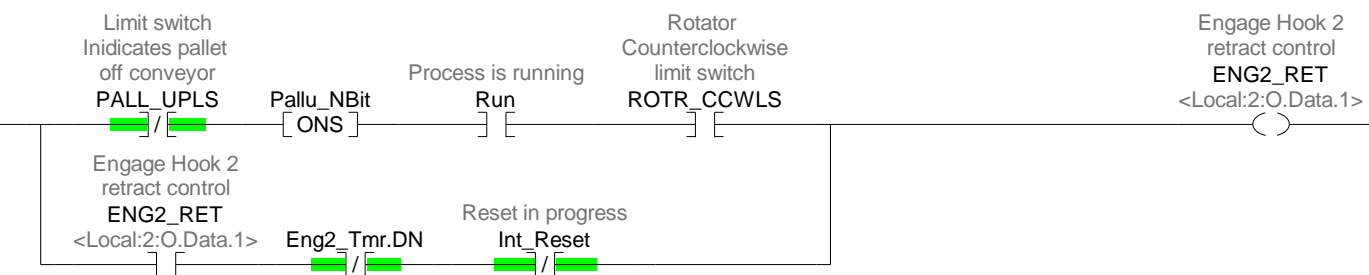
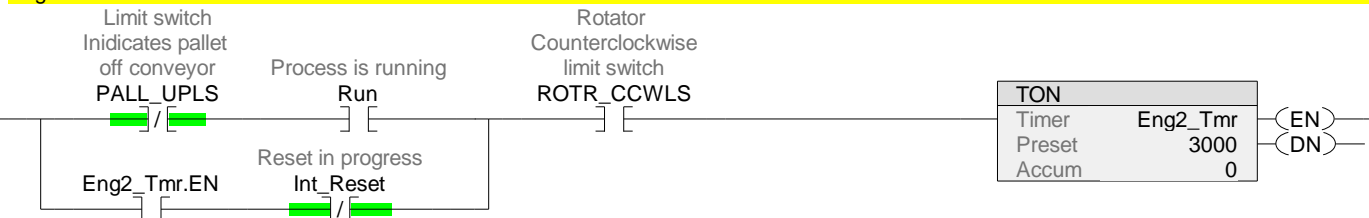
Start/stop/pause. Start prevented if reset in progress.



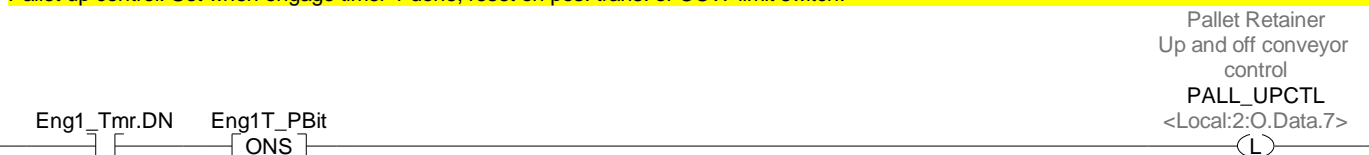
Engage 1 retract for 2 secs when PROX1 on and engage 2 timer done.

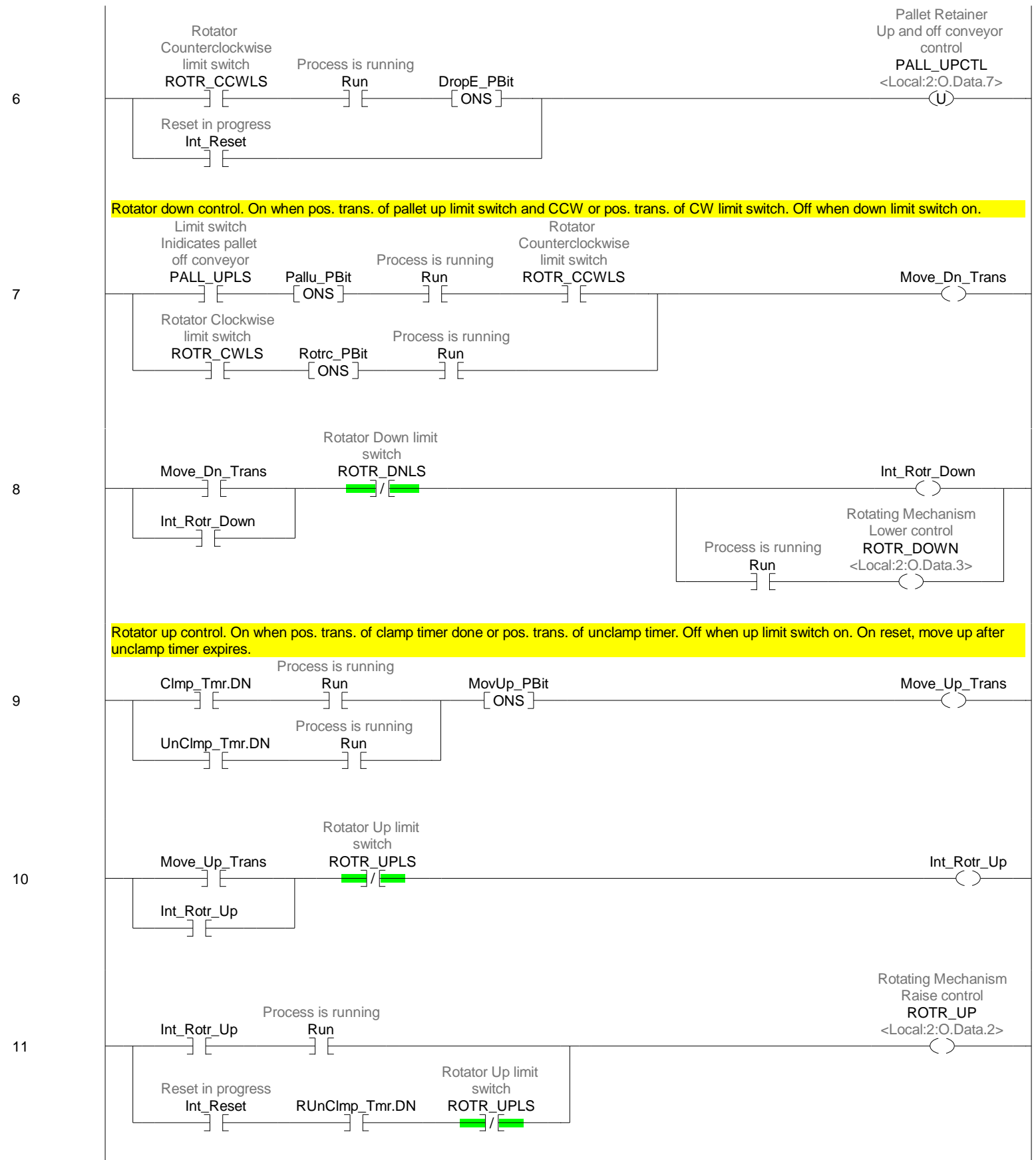


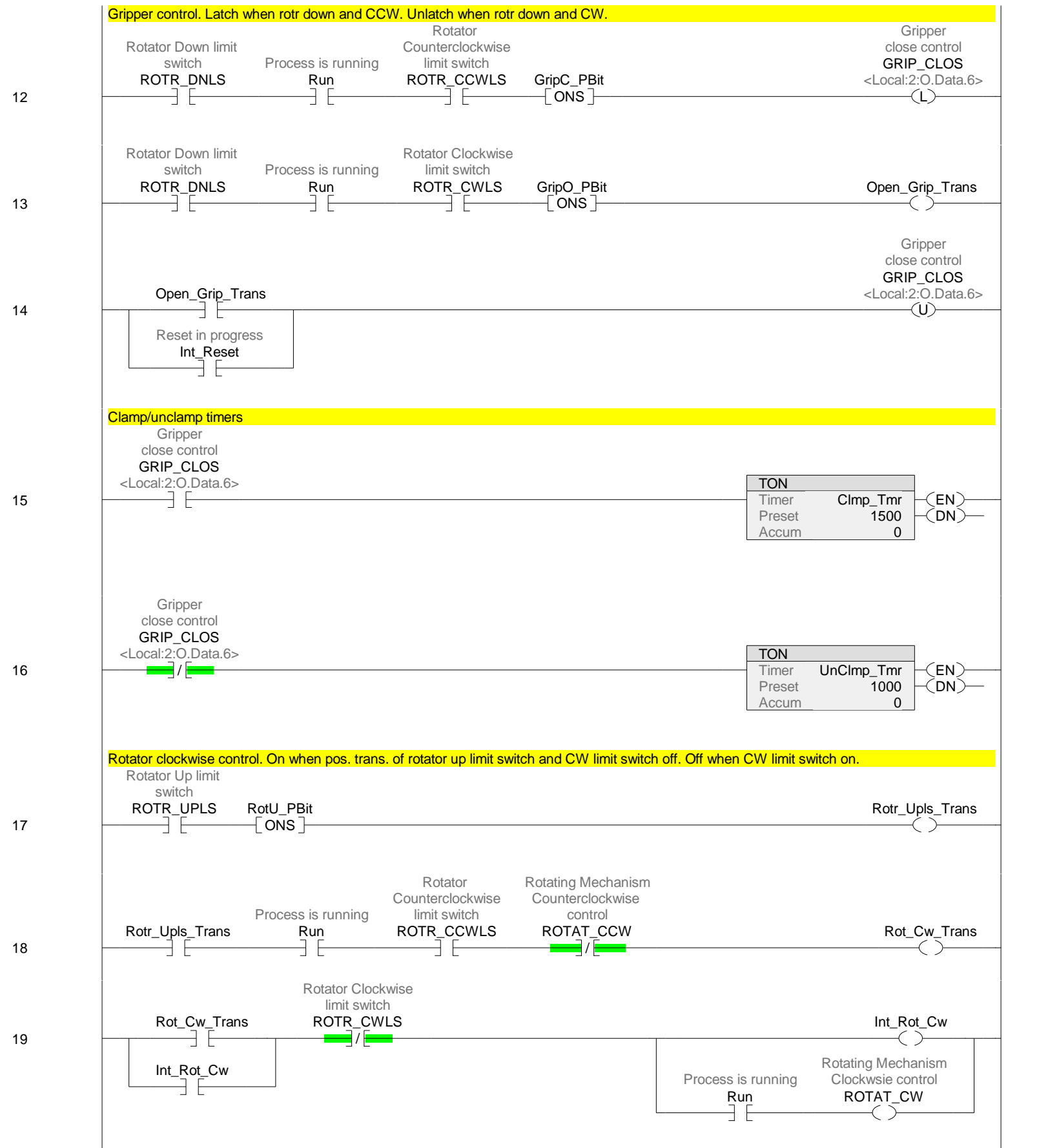
Engage 2 retract for 3 secs when PALL_UPLS off and CCW. Must be set on neg. trans. of PALL_UPLS. If handled like engage 1, will retract Eng2 on initial start.

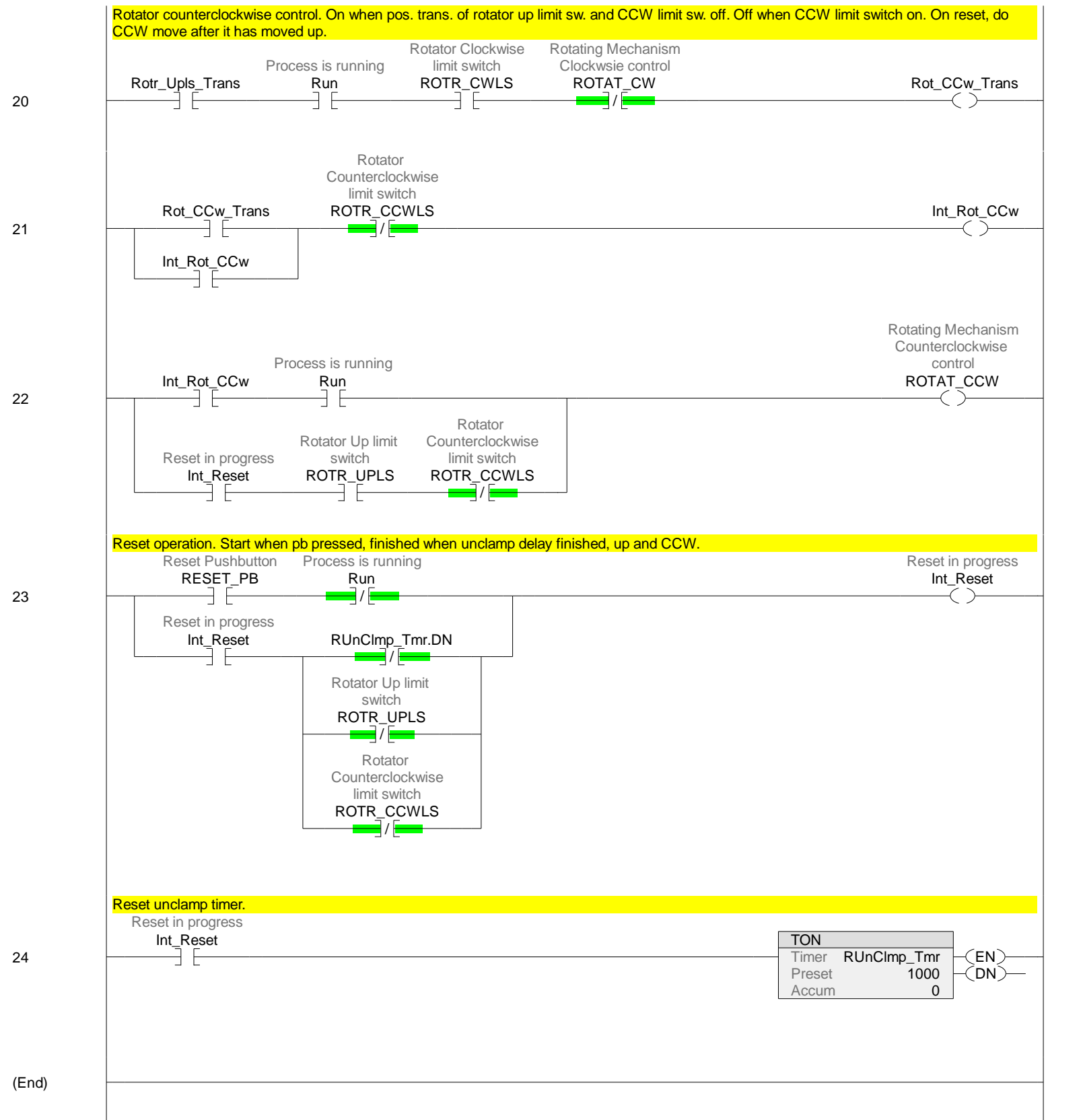


Pallet up control. Set when engage timer 1 done, reset on pos. trans. of CCW limit switch.









Example_6_7
Label does not exist1

MainTask
MainProgram
MainRoutine
Ladder Diagram2