









 **Controller Example_6_2** **Controller Fault Handler** **Power-Up Handler****Tasks** **MainTask** **MainProgram** **MainRoutine** **Unscheduled****Motion Groups** **Ungrouped Axes****Add-On Instructions****Data Types** **User-Defined** **Seq_Type**

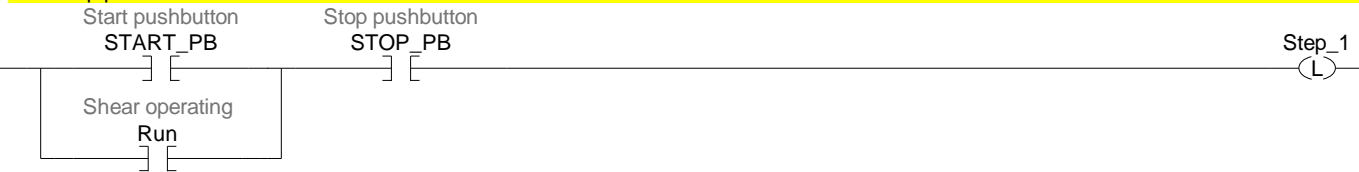
Counter-Based Sequencer

 **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_2** **[1] 1756-IB32/A Dig_In** **[2] 1756-OB16I Dig_Out**

Example 6.2 Metal Shear

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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



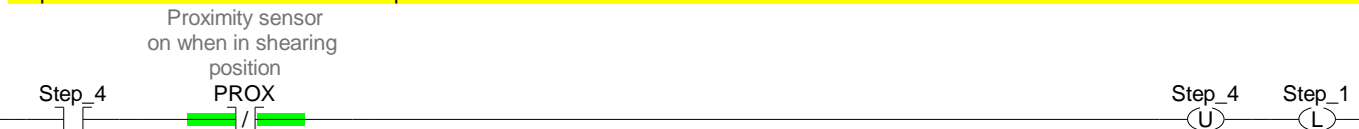
Step 2 - Move shear down. Trans. to step 3 when shear down



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



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



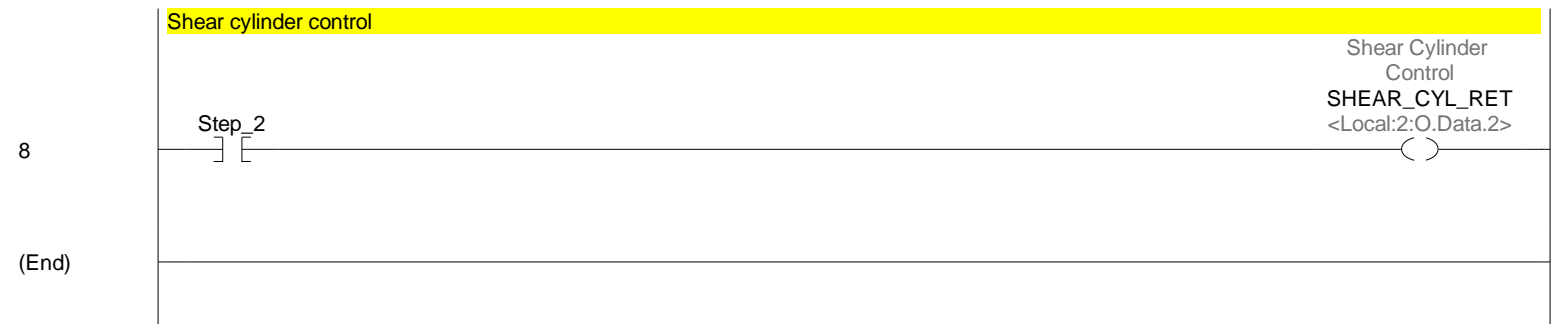
***** Control of Physical Outputs *****

Conveyor 1 control



Conveyor 2 control





Example_6_2	
Label does not exist	1
MainTask	
MainProgram	
MainRoutine	
Ladder Diagram	2