









 **Controller Example_6_7** **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**

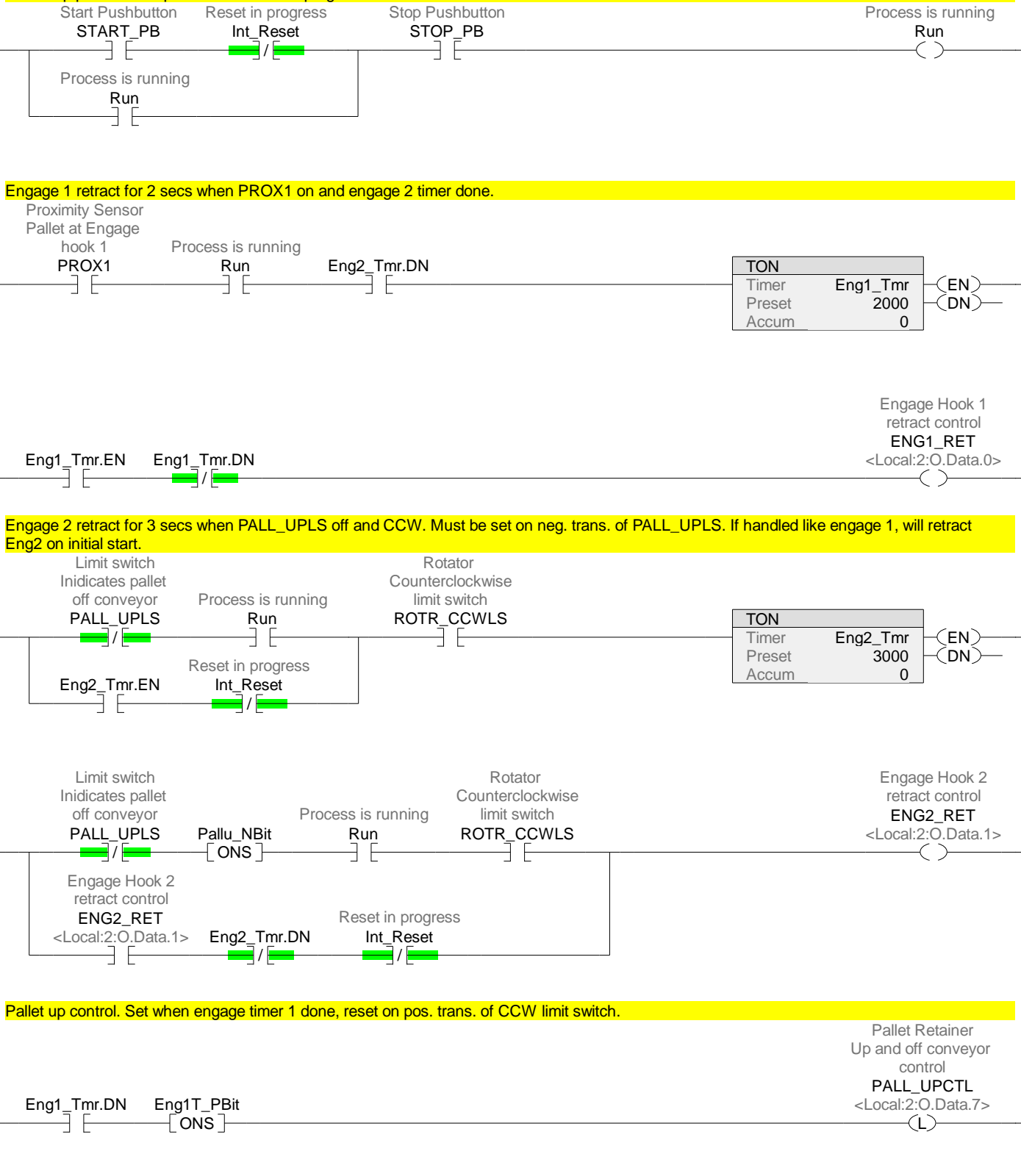
Counter-Based Sequencer

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

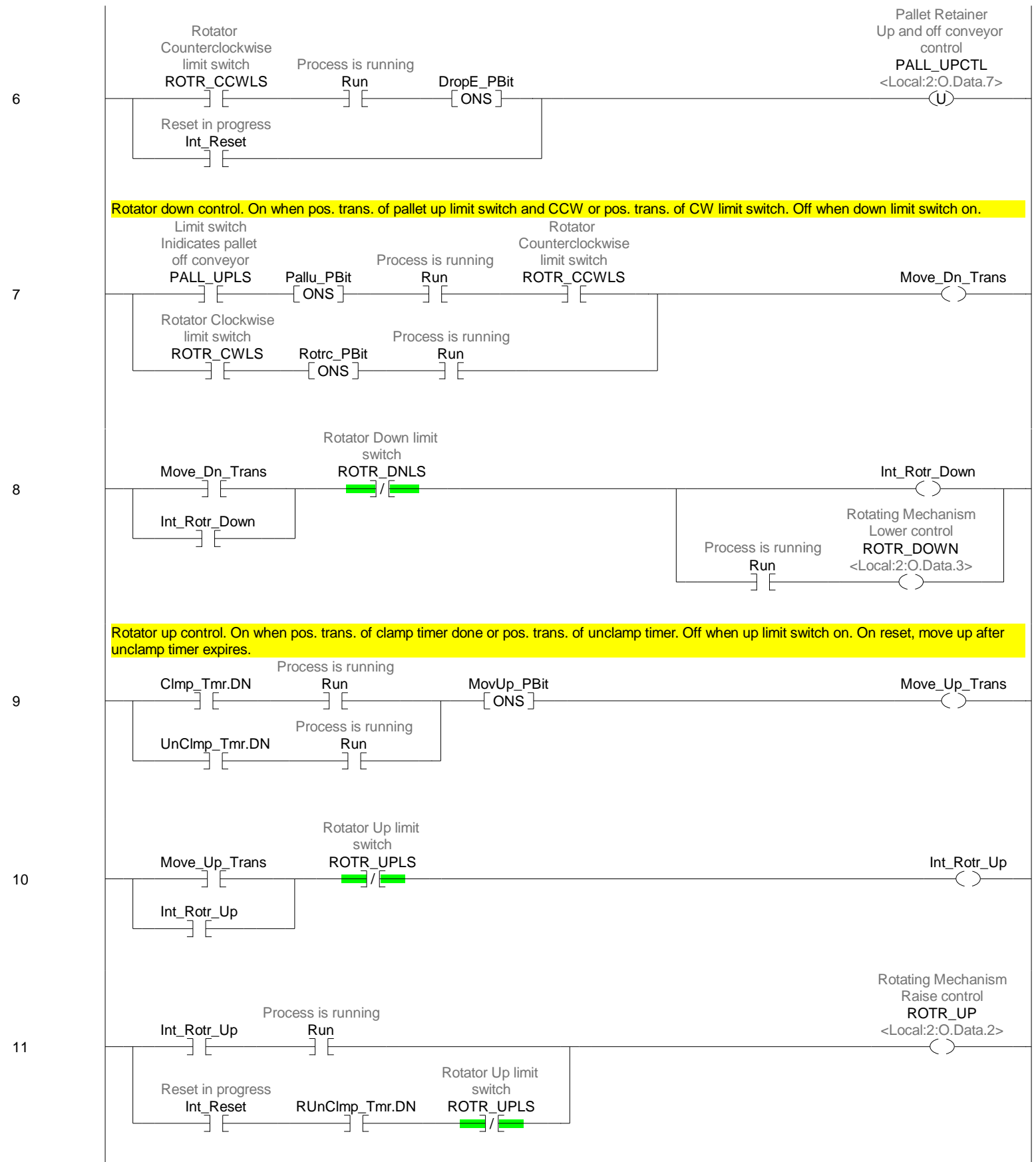
Example 6.7 Engine Inverter Using Ad-hoc Approach With Simulation

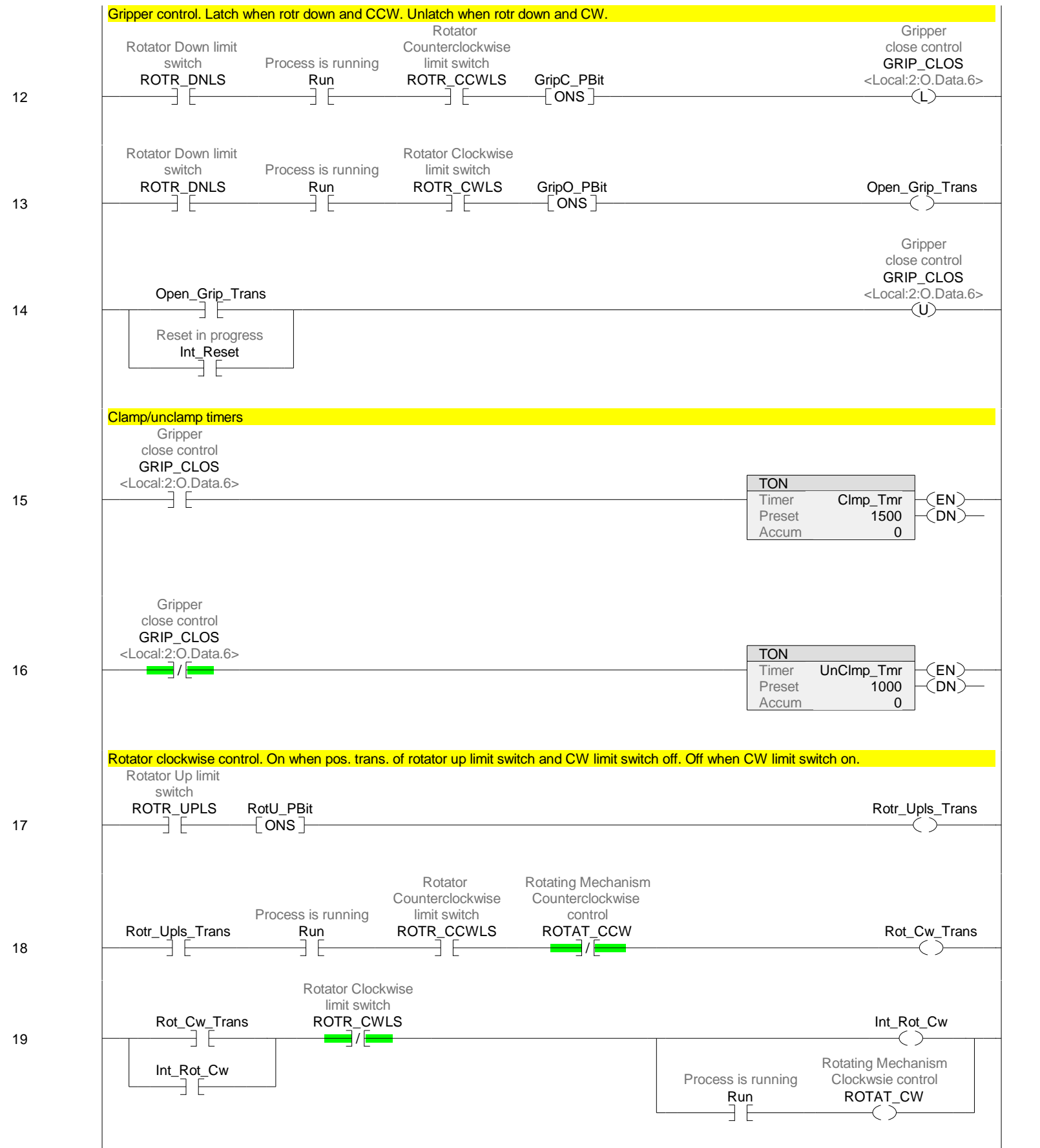
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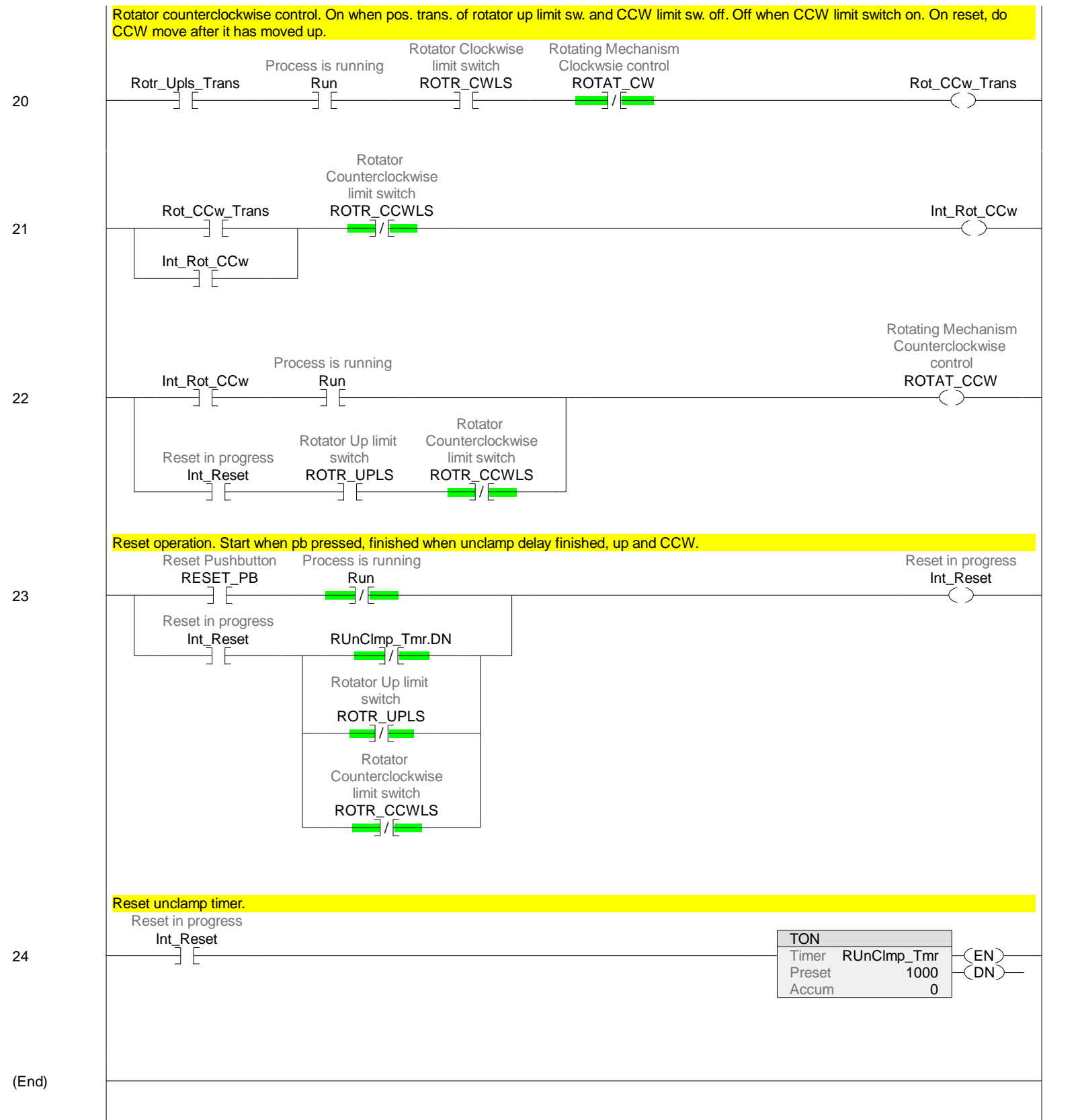
Start/stop/pause. Start prevented if reset in progress.



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







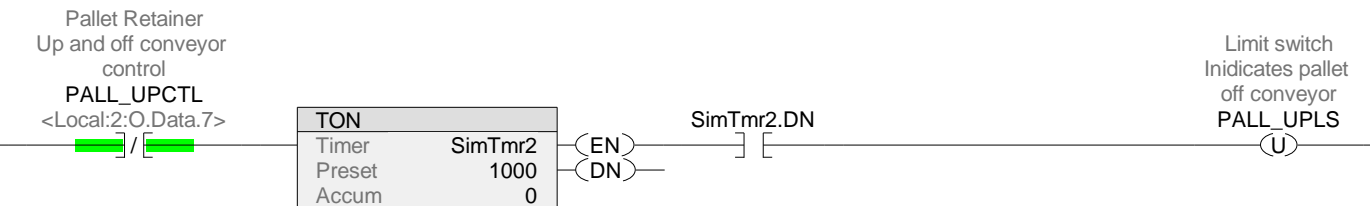
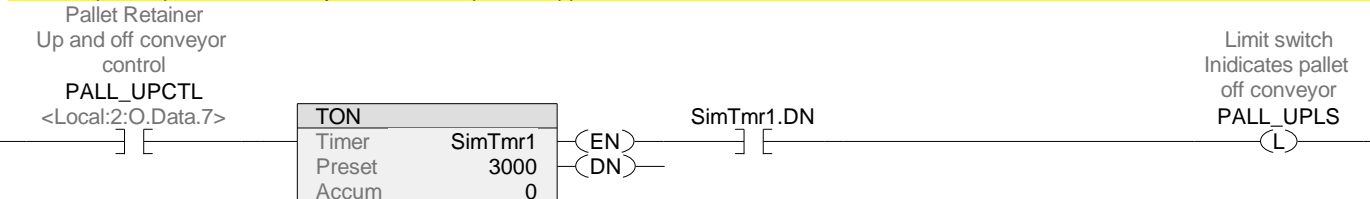
Simulation for engine inverter process

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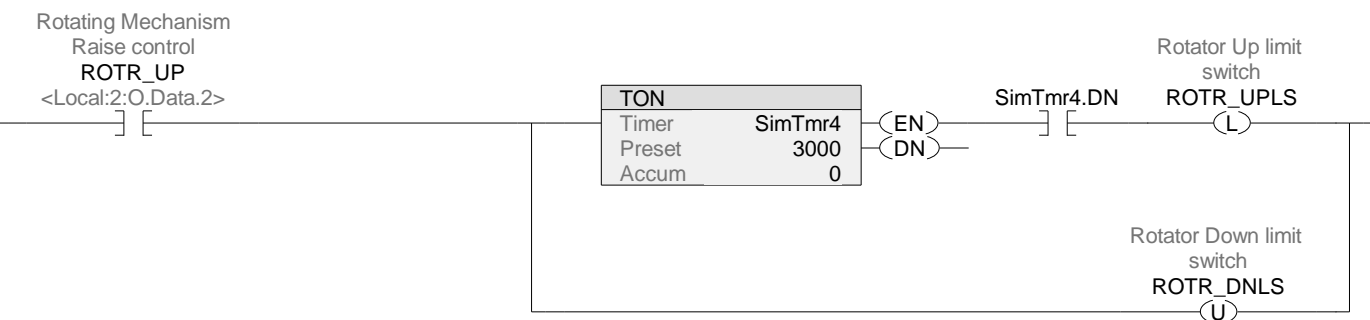
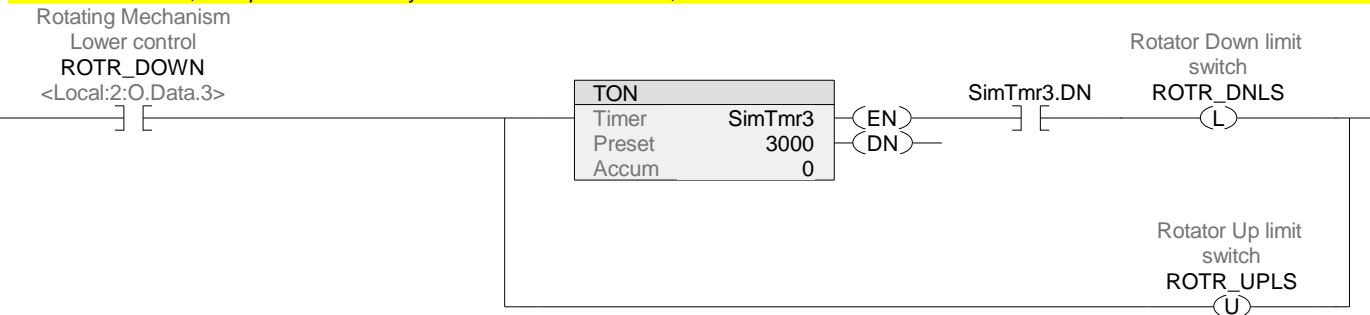
When reset, forget there is anything at hook 1



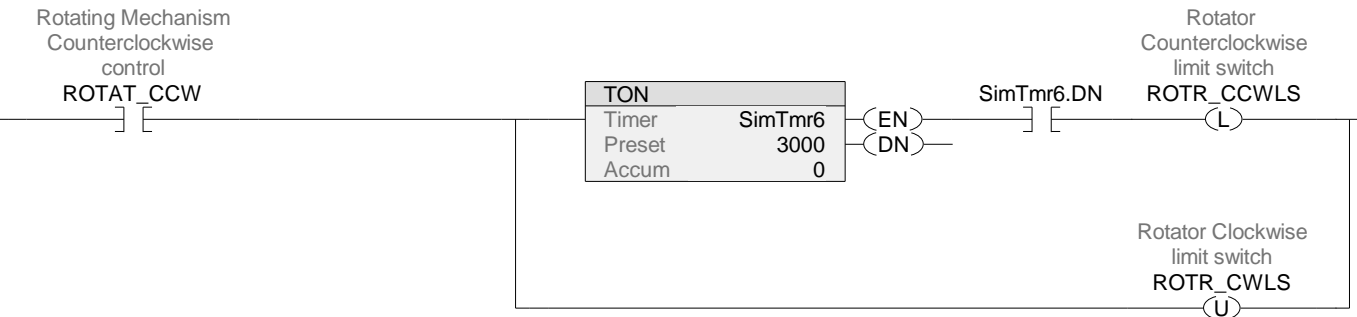
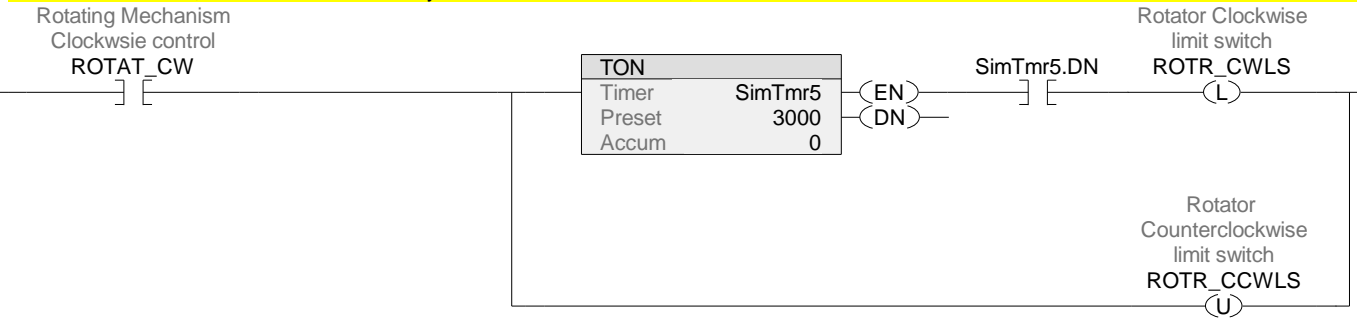
Simulate pallet up indication. Delay unlatch when pallet dropped.



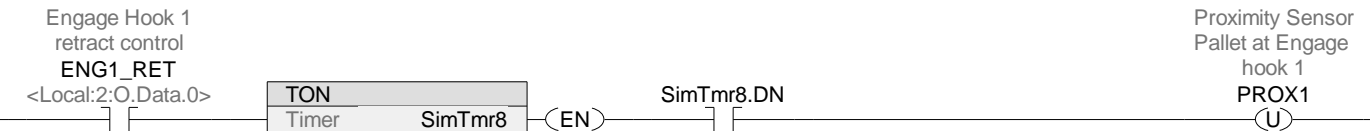
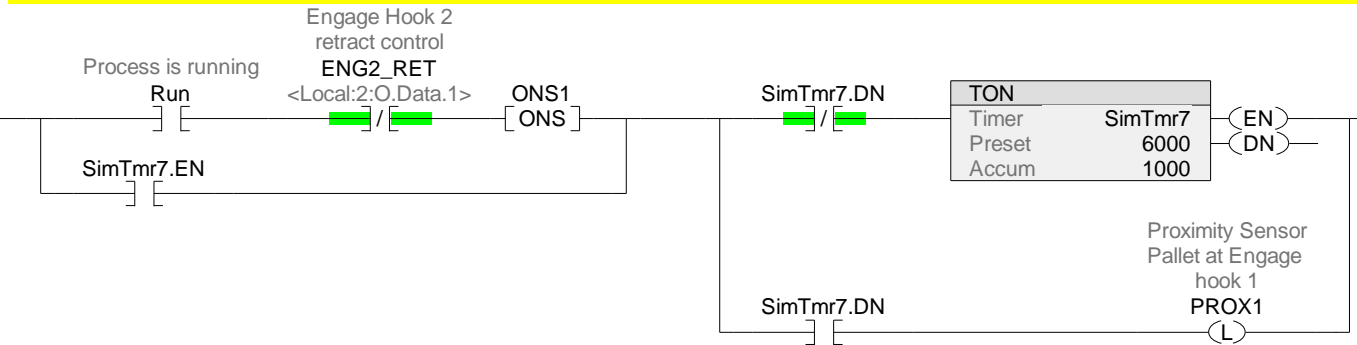
Simulate rotator up/down control. When moved up, the down ls is immediately unlatched off. After 3 secs, the up ls is latched on.
When moved down, the up ls is immediately unlatched off. After 3 secs, the down ls is latched on.



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)

Example_6_7	
Label does not exist	1
MainTask	
MainProgram	
MainRoutine	
Ladder Diagram	2
Simulation	
Simulation	
Ladder Diagram	6