

Main

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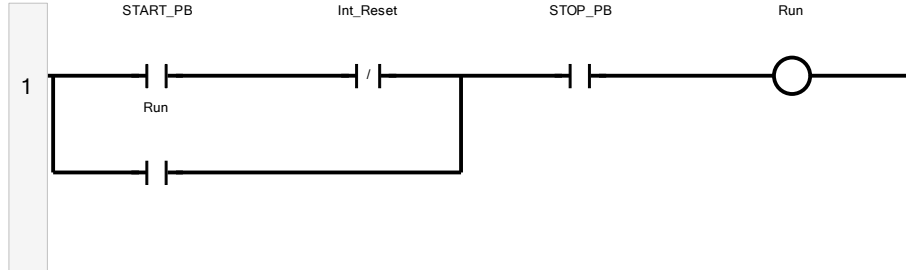
Main

Rung1 Diagram

Example 6.5 Engine Inverter Station control - with parallel branching

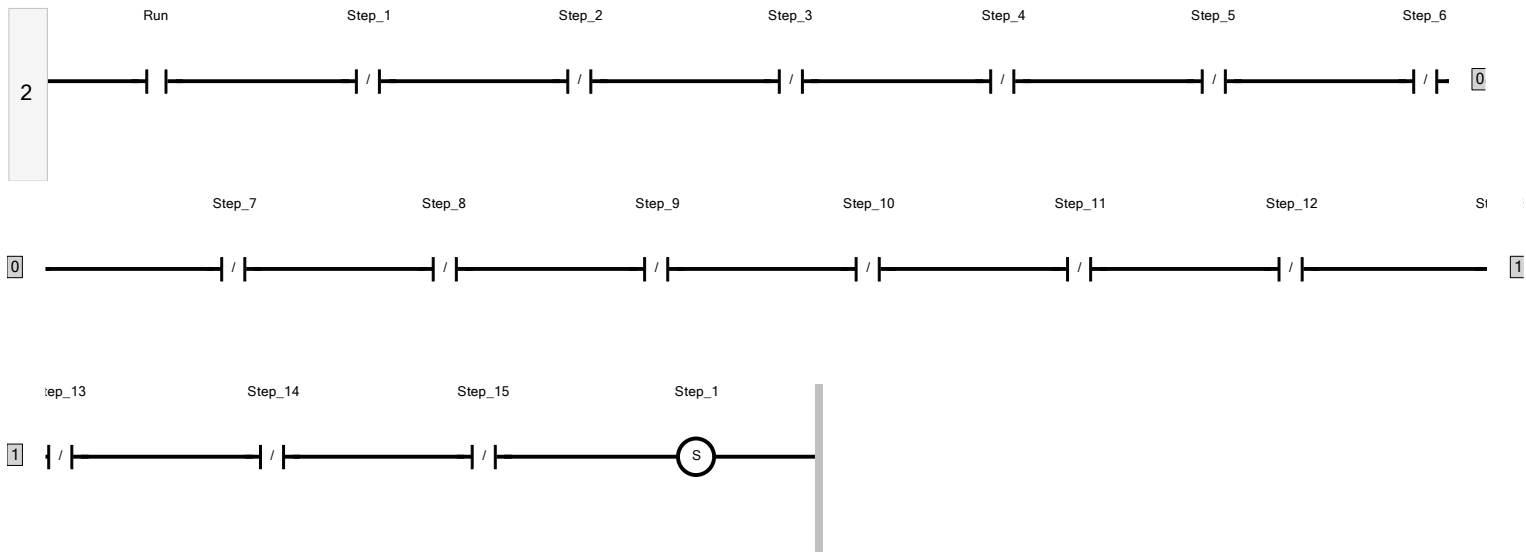
Start/stop/pause. Start prevented if reset in progress.

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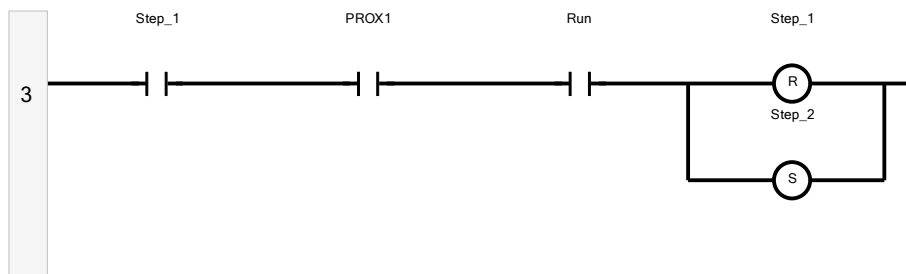
Rung2 Diagram

Transition out of initial step



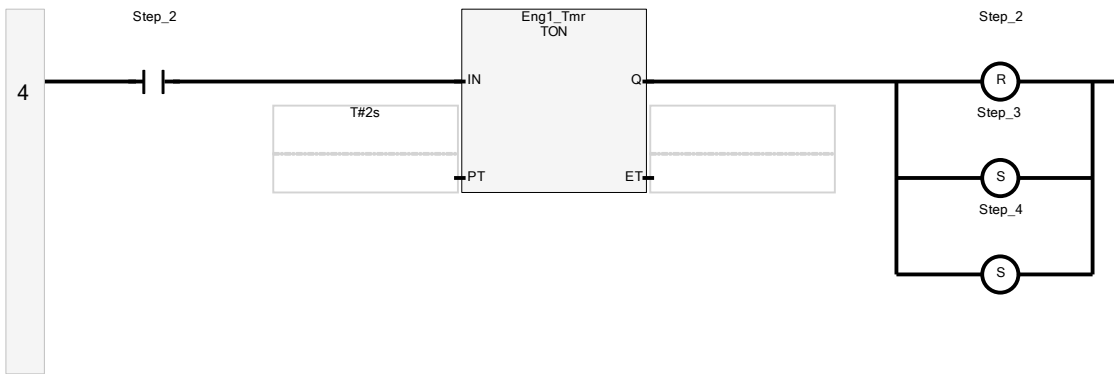
Rung3 Diagram

Step 1 - Wait for pallet. Trans. to step 2 when pallet present



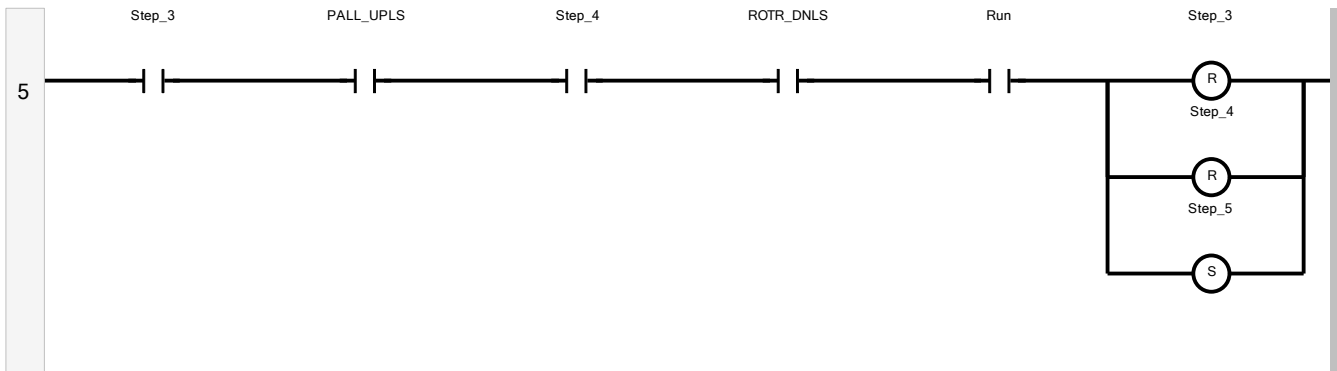
Rung4 Diagram

Step 2 - Move to hook 2. Trans. to steps 3 & 4 when engaging 1 hook open 2 sec



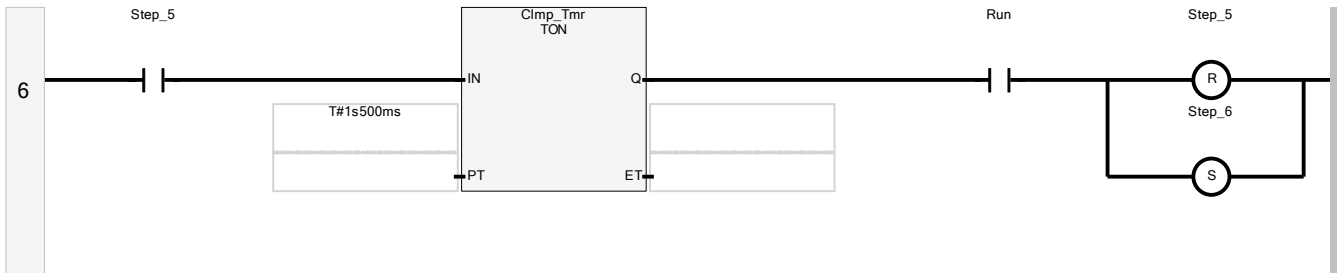
Rung5 Diagram

When pallet raised & lowered, transition to step 5.



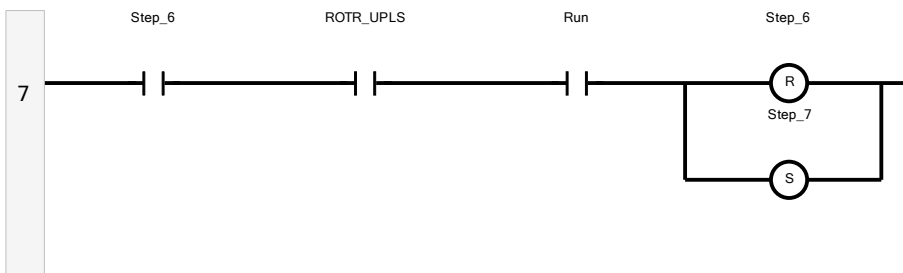
Rung6 Diagram

Step 5 - Clamp engine. Trans. to Step 6 when timer done and not paused



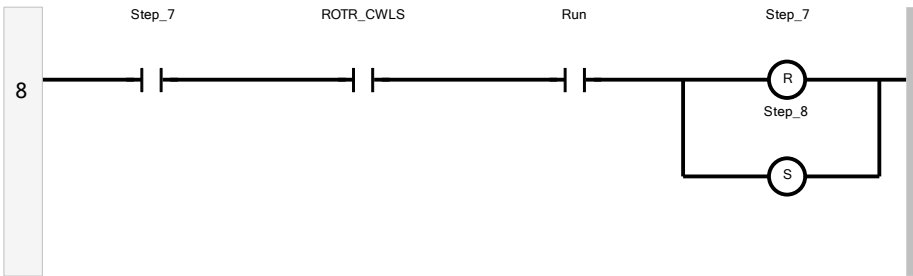
Rung7 Diagram

Step 6 - Raise rotator. Trans. to Step 7 when up.



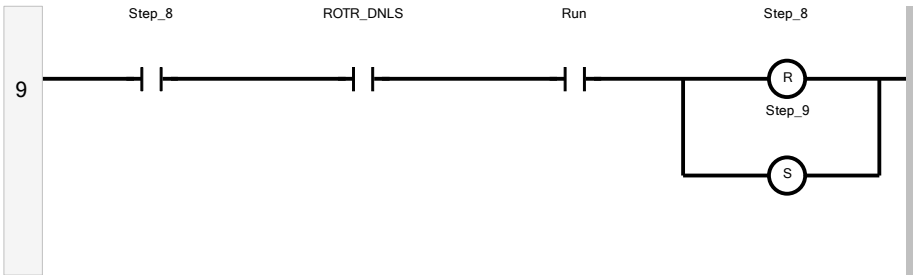
Rung8 Diagram

Step 7 - Rotate clockwise. Trans. to Step 8 when clockwise.



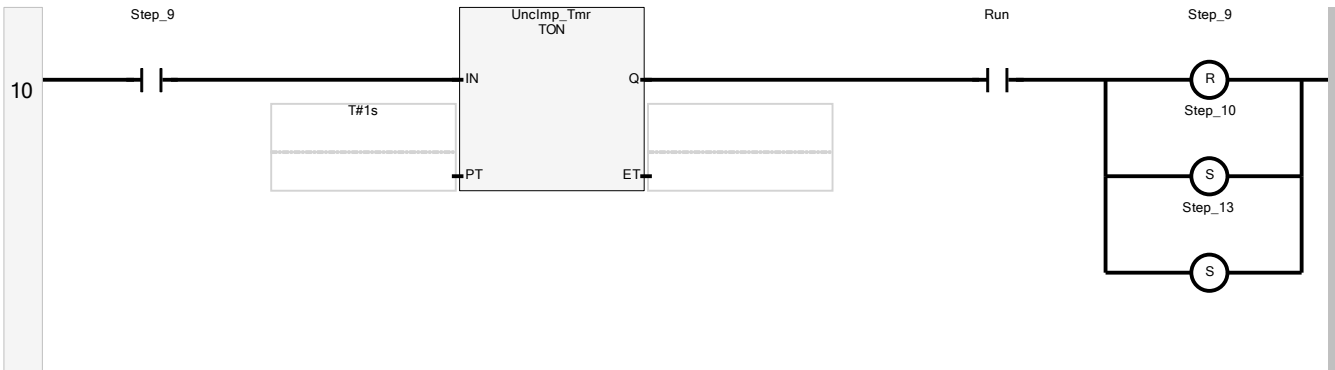
Rung9 Diagram

Step 8 - Lower rotator. Trans. to Step 9 when down.



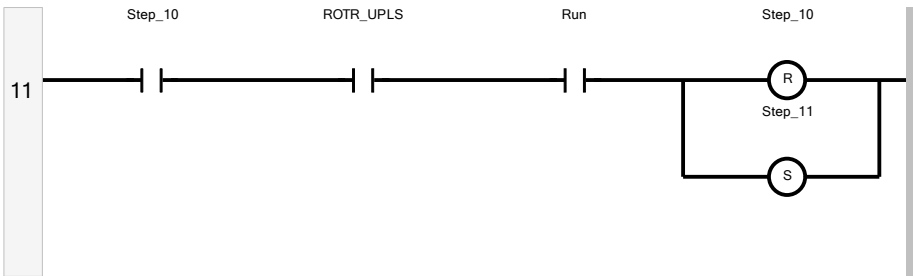
Rung10 Diagram

Step 9 - Unclamp timer. Trans. to Steps 10 & 13 after 1 sec.



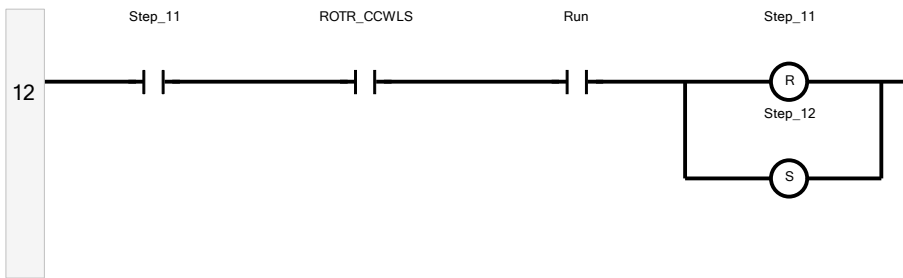
Rung11 Diagram

Step 10 - Raise rotator. Trans. to Step 11 when up.



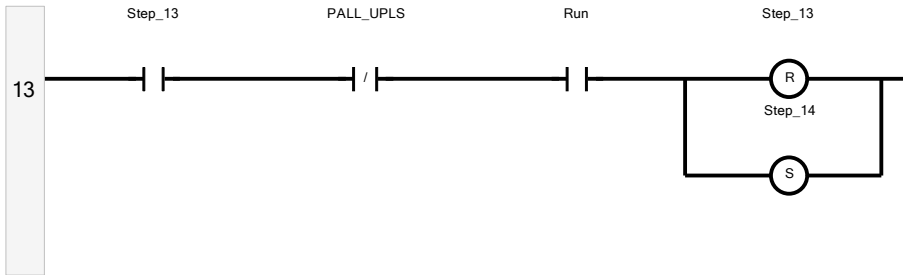
Rung12 Diagram

Step 11 - Rotate CCW. Trans. to Step 12 (wait) when CCW.



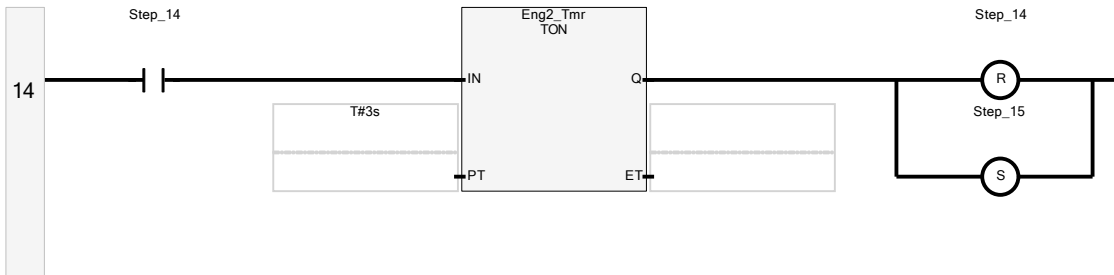
Rung13 Diagram

Step 13 - Drop engine. Trans. to Step 14 when not up.



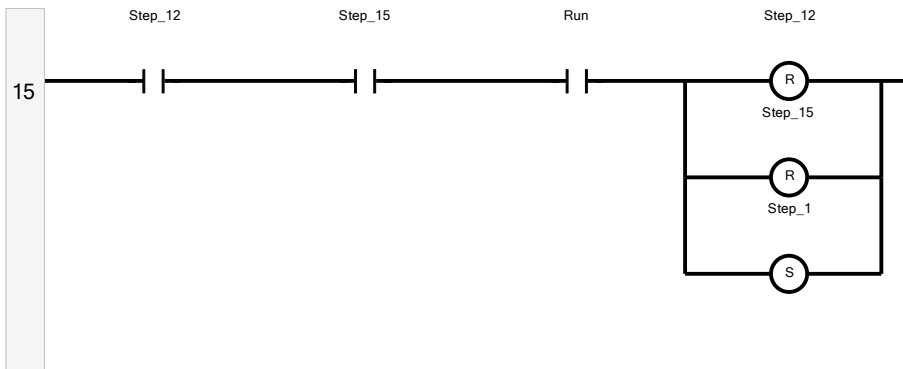
Rung14 Diagram

Step 14 - Move out pallet. Trans. to Step 15 (wait) when time done.



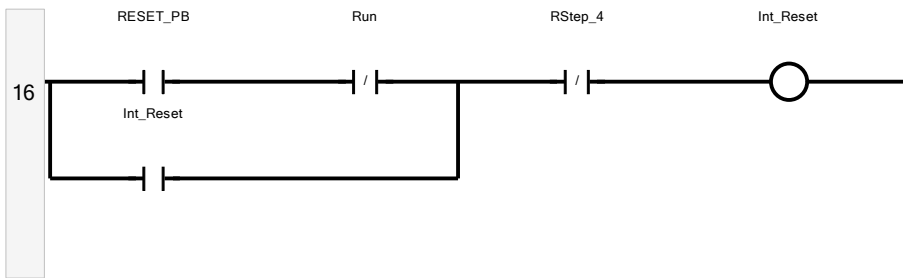
Rung15 Diagram

Transition to Step 1 when in step 12 and 15



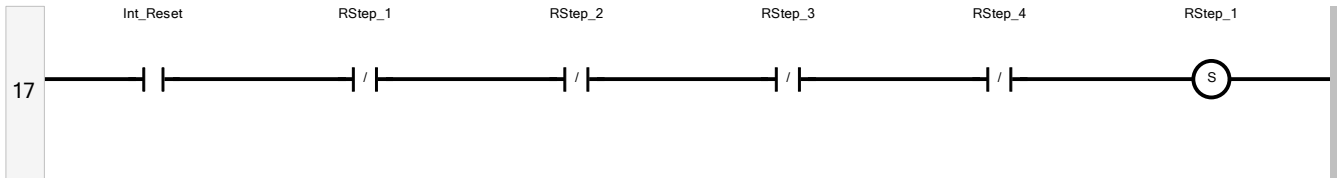
Rung16 Diagram

Start/stop for reset operation. Reset pb starts it, reset step 4 stops it.



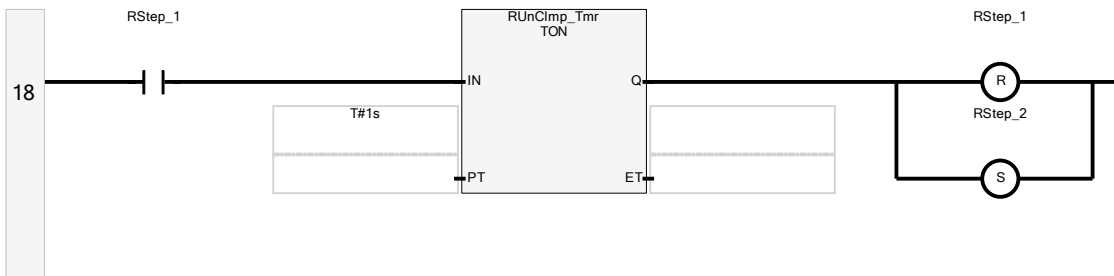
Rung17 Diagram

First press of reset pb starts reset



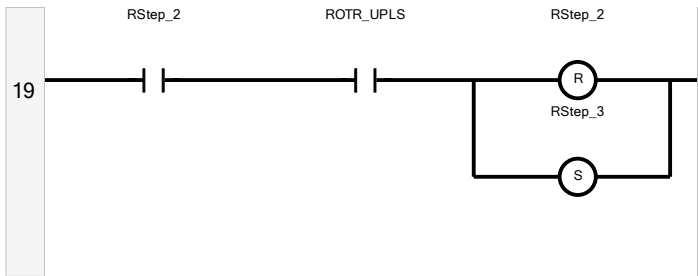
Rung18 Diagram

Reset Step 1 - Delay to unclamp. Trans. to Reset Step 2 when done.



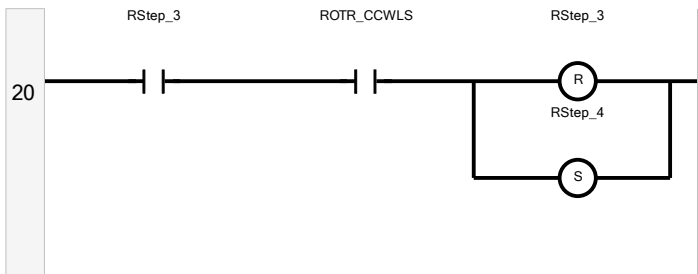
Rung19 Diagram

Reset Step 2 - Raise mechanism. Trans. to Reset Step 3 when up.



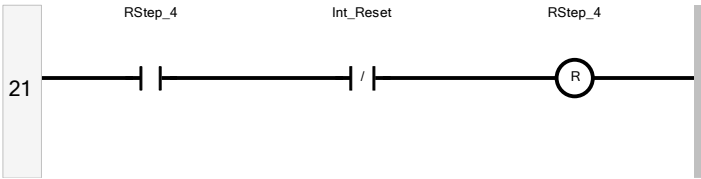
Rung20 Diagram

Reset Step 3 - Rotate CCW. Trans. to Reset Step 3 when CCW.



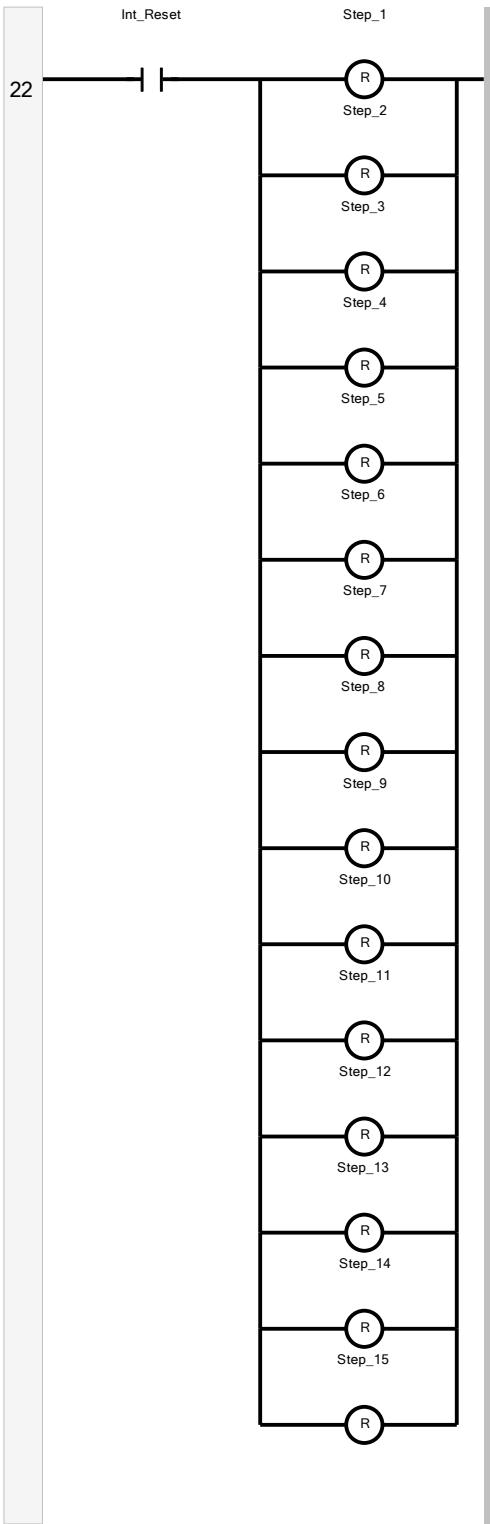
Rung21 Diagram

Transition out of Reset Step 4 when internal reset unlatched.

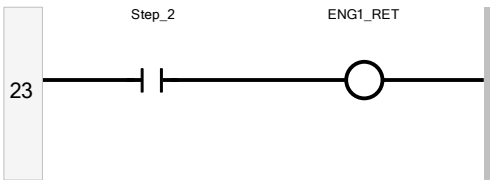


Rung22 Diagram

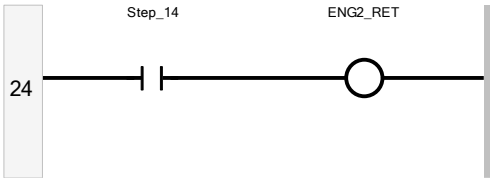
Reset steps



Rung23 Diagram
Engaging hooks control

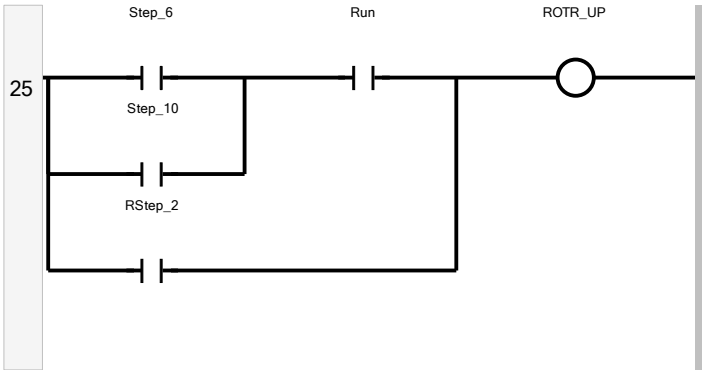


Rung24 Diagram

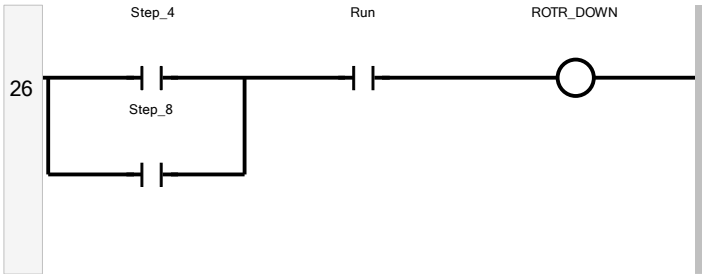


Rung25 Diagram

Rotating mechanism up/dpwn control

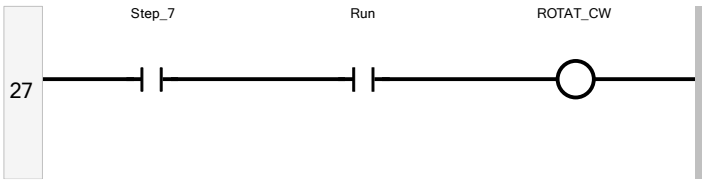


Rung26 Diagram

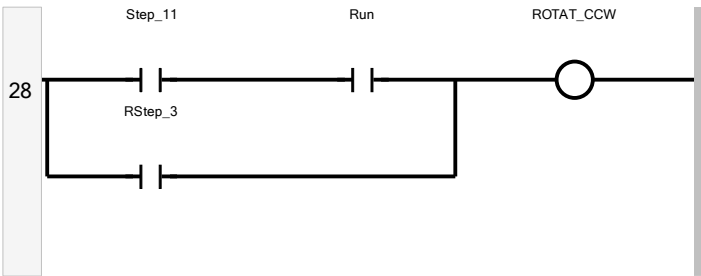


Rung27 Diagram

Rotation control

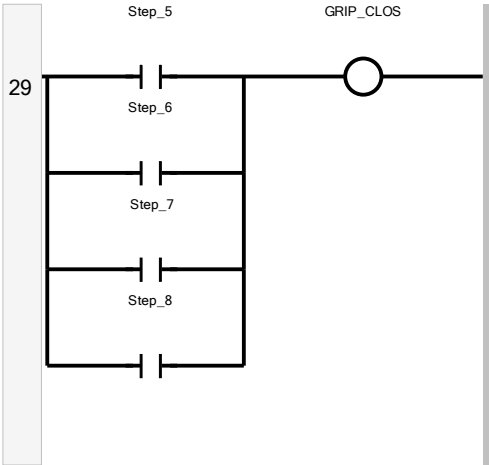


Rung28 Diagram



Rung29 Diagram

Gripper control



Rung30 Diagram

Pallet up control

