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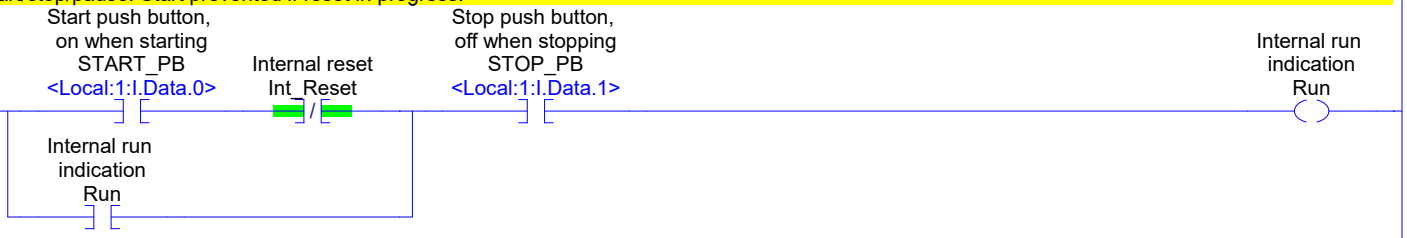
Part Oiler with Counter-based sequencer

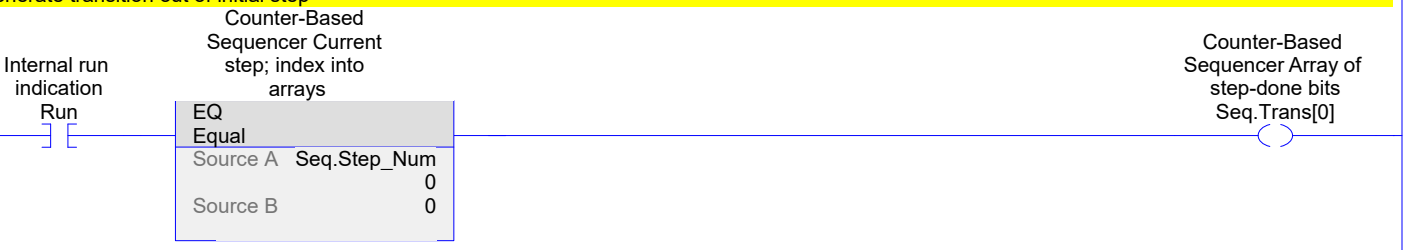
Start/stop/pause. Start prevented if reset in progress.

0



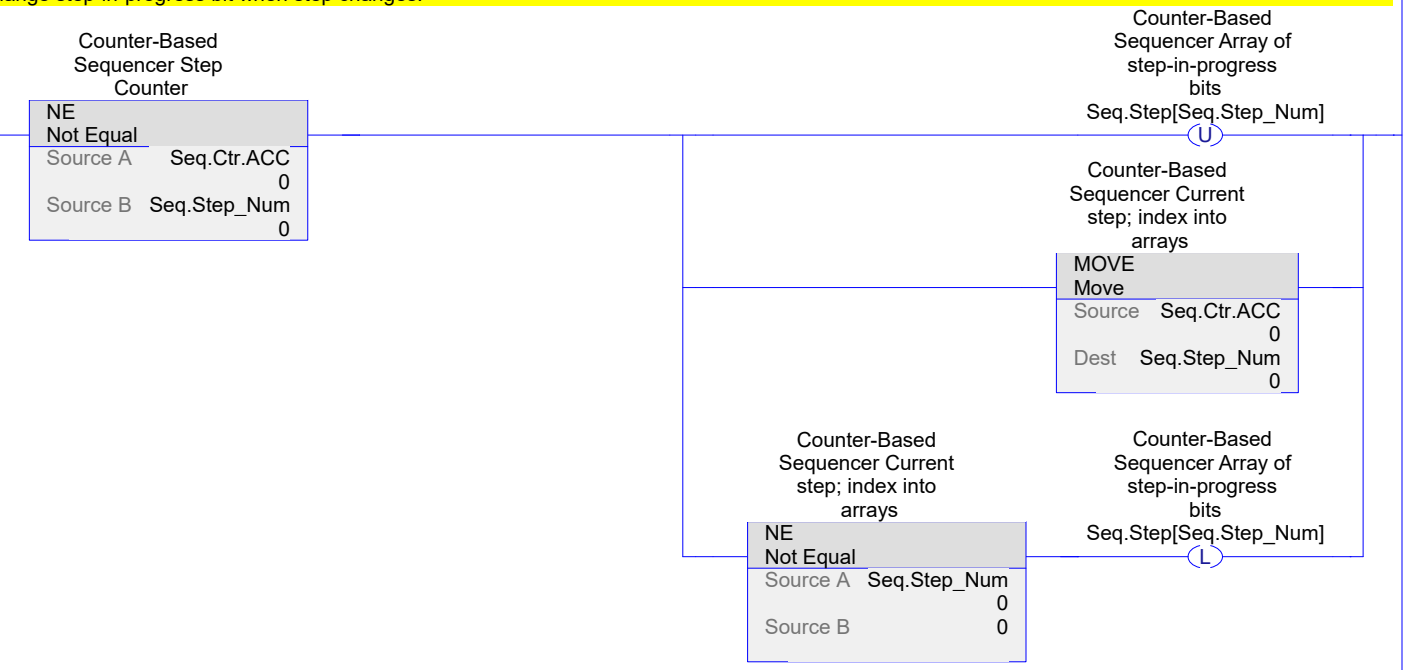
Generate transition out of initial step

1



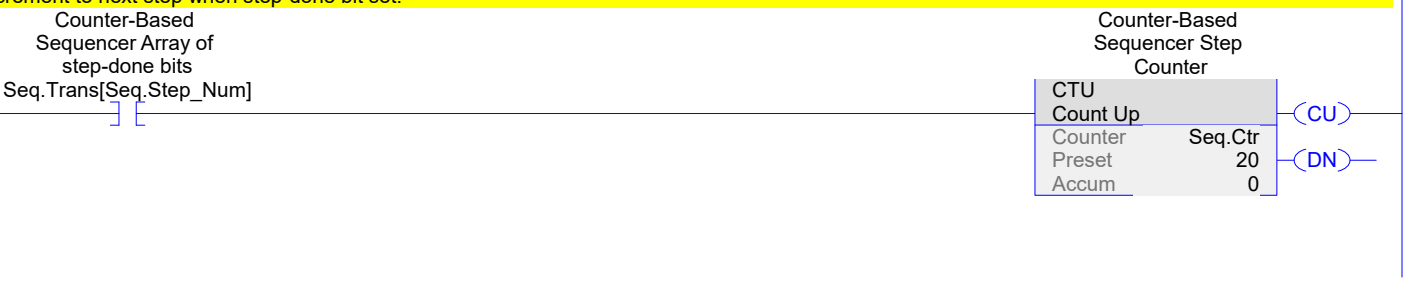
Change step-in-progress bit when step changes.

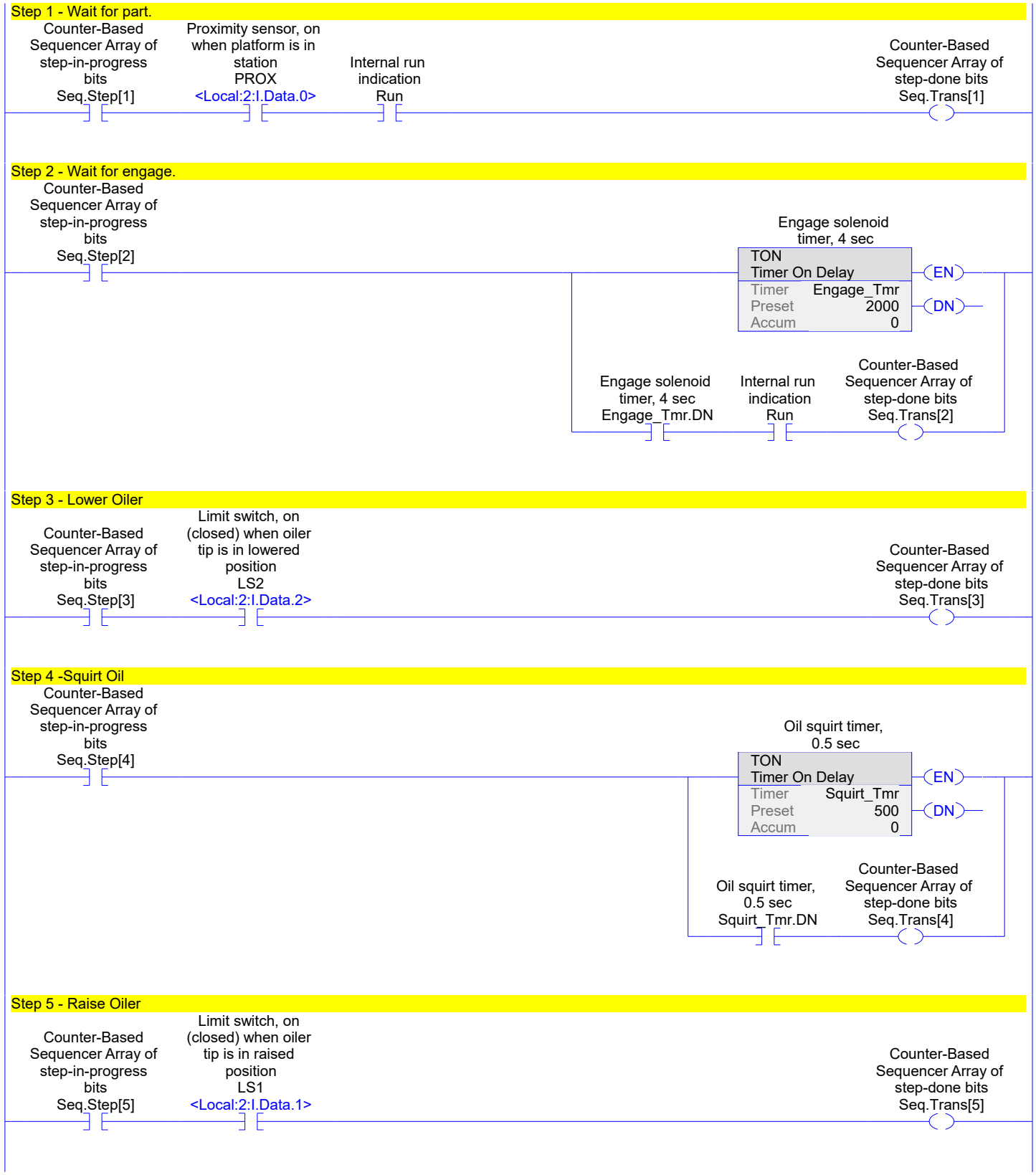
2



Increment to next step when step-done bit set.

3





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Step 6 - Part Leaves. Then jump to step 1

9

Counter-Based Sequencer Array of step-in-progress bits Seq.Step[6]

Proximity sensor, on when platform is in station PROX <Local:2:I.Data.0>

Counter-Based Sequencer Step Counter

MOVE Move
Source 1
Dest Seq.Ctr.ACC 0

Start/stop for reset operation. Reset pb starts, LS1 stops it.

10

Reset push button, on when restoring station to initial state RESET_PB <Local:1:I.Data.2>

Internal run indication Run

Internal reset Int_Reset

Limit switch, on (closed) when oiler tip is in raised position LS1 <Local:2:I.Data.1>

Internal reset Int_Reset

Counter-Based Sequencer Step Counter Seq.Ctr RES

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

Engage solenoid. Cannot be off when paused.

11

Counter-Based Sequencer Array of step-in-progress bits Seq.Step[2]

On to move up hook to engage platform in station ENGAGE_SOL <Local:3:O.Data.9>

Counter-Based Sequencer Array of step-in-progress bits Seq.Step[3]

Counter-Based Sequencer Array of step-in-progress bits Seq.Step[4]

Counter-Based Sequencer Array of step-in-progress bits Seq.Step[5]

Oiler mechanism up/down control

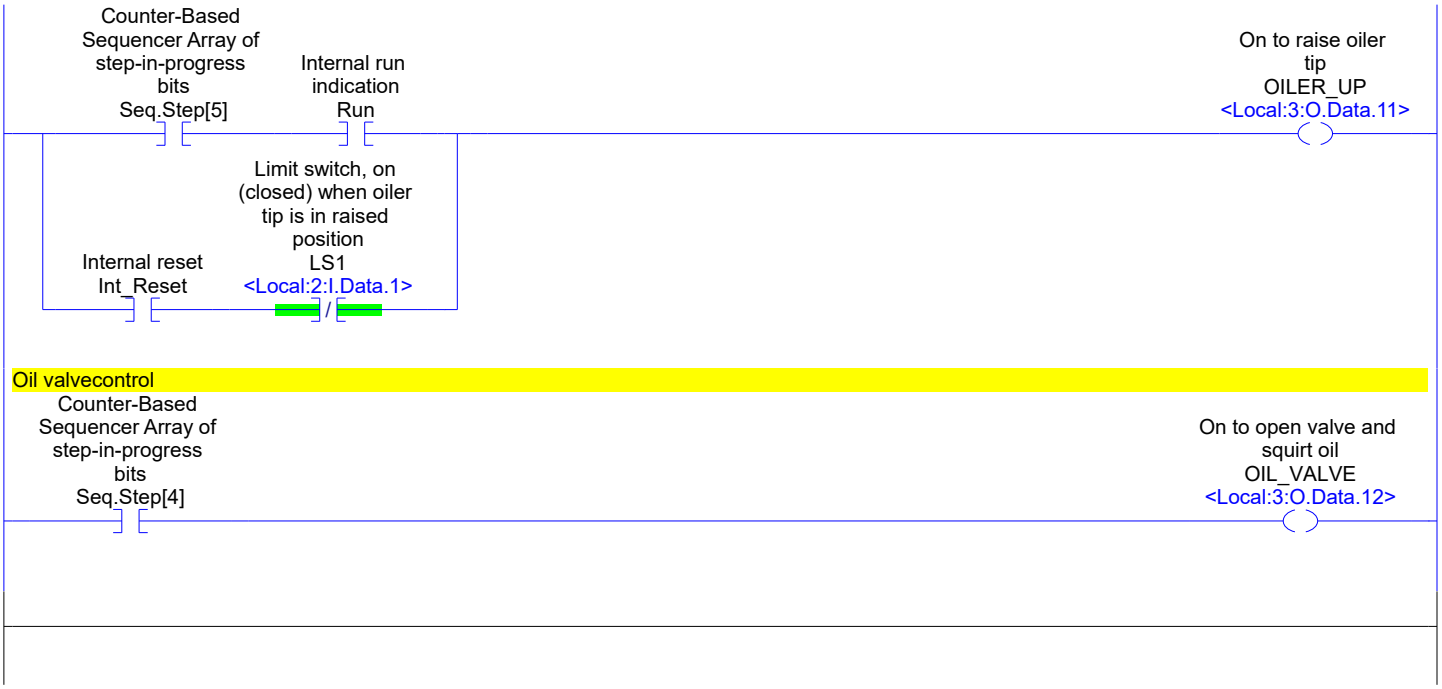
12

Counter-Based Sequencer Array of step-in-progress bits Seq.Step[3]

Internal run indication Run

On to lower oiler tip OILER_DOWN <Local:3:O.Data.10>

13


Counter-Based Sequencer Array of step-in-progress bits Seq.Step[5]
Internal run indication Run
On to raise oiler tip OILER_UP <Local:3:O.Data.11>
Limit switch, on (closed) when oiler tip is in raised position LS1 <Local:2:I.Data.1>
Internal reset Int_Reset
Oil valvecontrol
Counter-Based Sequencer Array of step-in-progress bits Seq.Step[4]
On to open valve and squirt oil OIL_VALVE <Local:3:O.Data.12>
14
(End)