











-  **Controller SP14_01**
-  **Controller Fault Handler**
-  **Power-Up Handler**

Tasks










-  **MainTask**
-  **MainProgram**
-  **MainRoutine**
-  **Part_Oiler**
-  **Reset_Actions**
-  **Simulation**
-  **Simulation**
-  **Unscheduled**

Motion Groups

-  **Ungrouped Axes**









Add-On Instructions

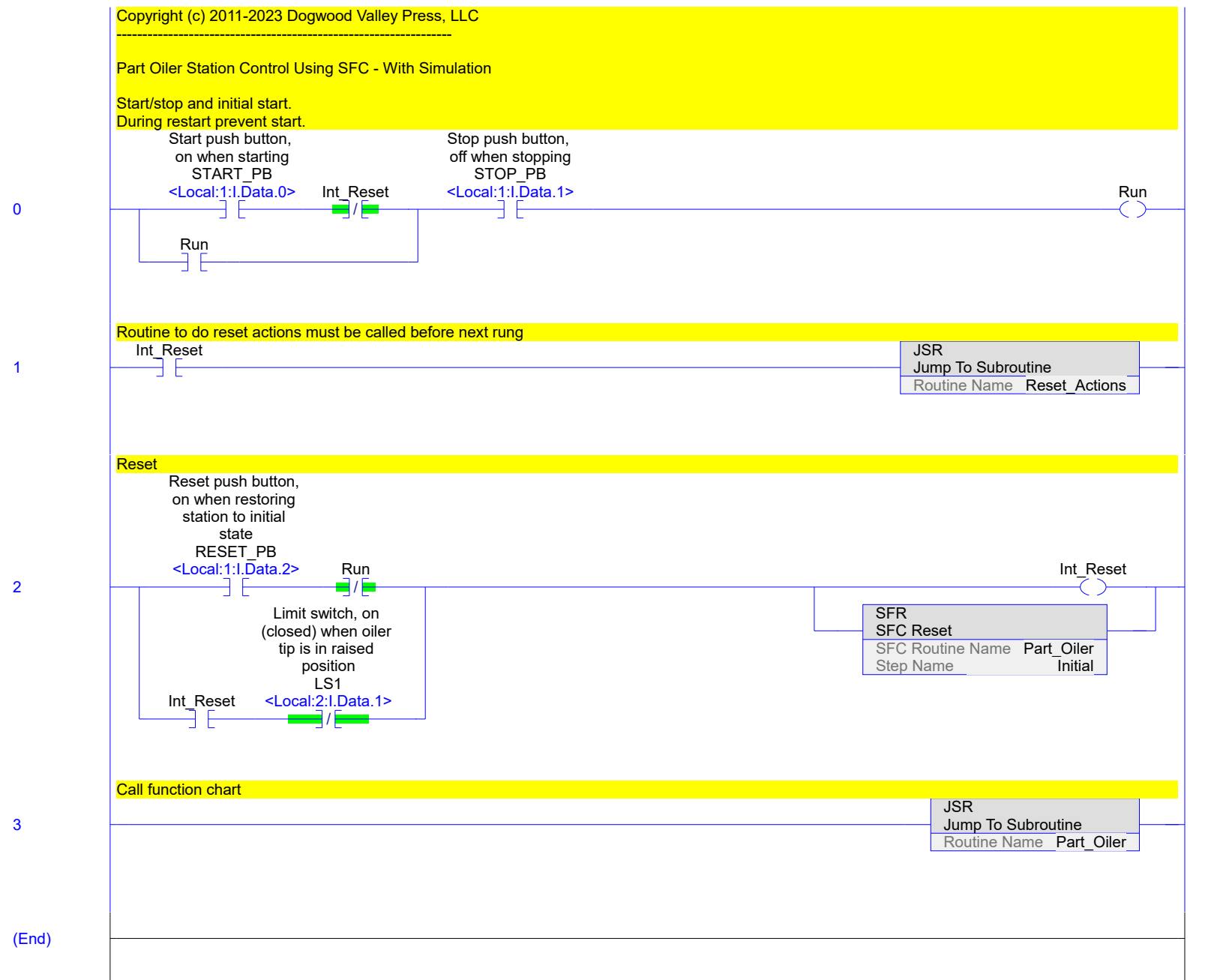
Data Types

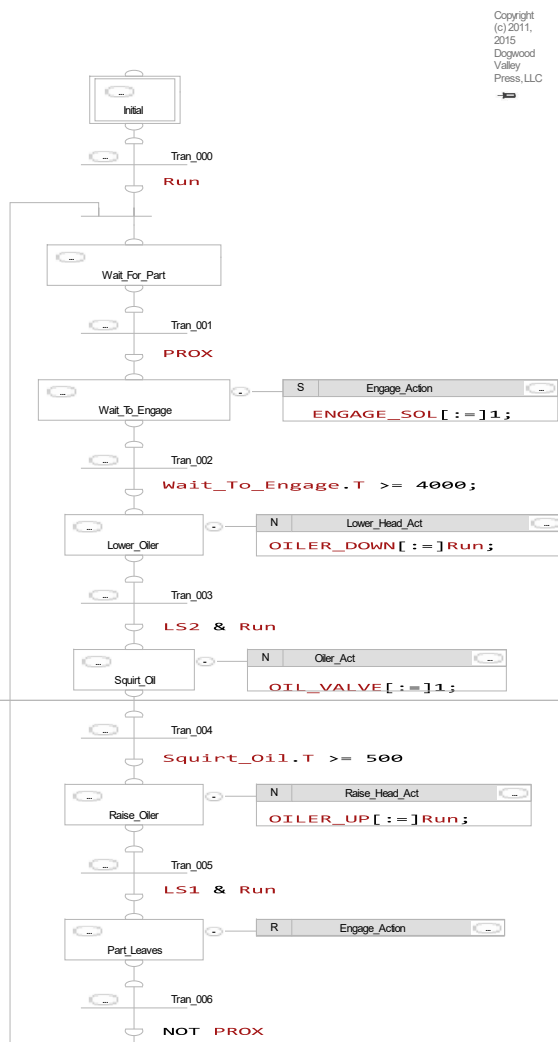
-  **User-Defined**
-  **Strings**
-  **Add-On-Defined**
-  **Module-Defined**
-  **AB:1756_DI:C:0**
-  **AB:1756_DI:I:0**
-  **AB:1756_DO:C:0**
-  **AB:1756_DO:I:0**
-  **AB:1756_DO:O:0**

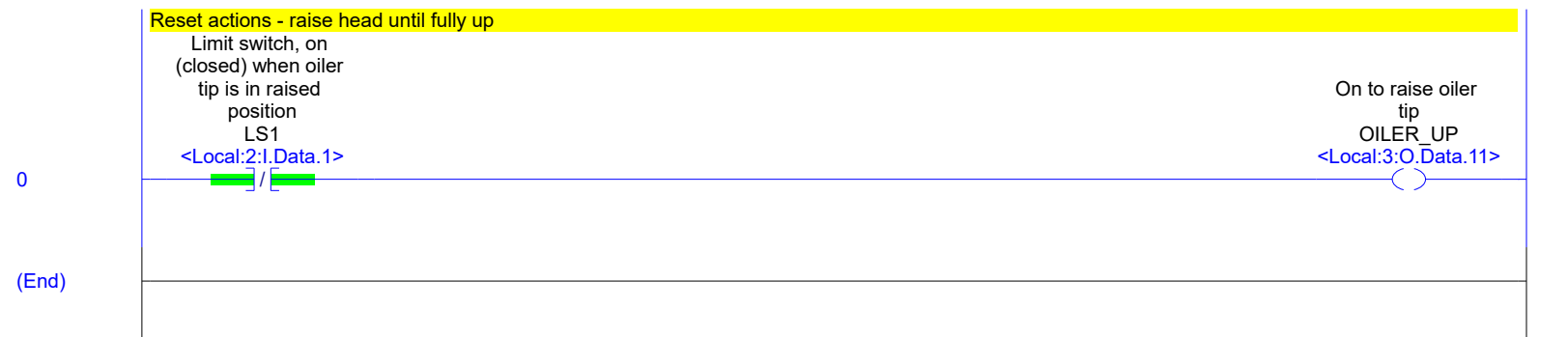
Trends

I/O Configuration

-  **1756 Backplane, 1756-A10**
-  **[0] 1756-L71 SP14_01**
-  **[1] 1756-IB32/A discrete_in1**
-  **[2] 1756-IB32/A discrete_in_2**
-  **[3] 1756-OB32 DISCRETE_OUT3**
-  **[4] 1756-OB32 discrete_out4**
-  **[6] 1756-IB32/A DISCRETE_IN6**
-  **[7] 1756-OB32 DISCRETE_OUT7**







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Part Oiler Station simulation

When reset, forget there is anything in station

Reset push button,
on when restoring
station to initial
state

RESET_PB

<Local:1:I.Data.2>

Run

Proximity sensor, on
when platform is in
station
PROX

<Local:2:I.Data.0>

(U)

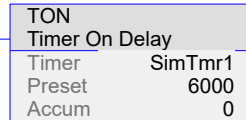
Simulate pallet up indication. Delay unlatch when pallet dropped.

On to move up hook
to engage platform
in station

ENGAGE_SOL

<Local:3:O.Data.9>

Run



(EN)

SimTmr1.DN

(DN)

Proximity sensor, on
when platform is in
station
PROX

<Local:2:I.Data.0>

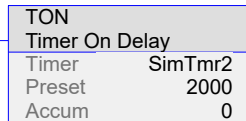
(L)

On to move up hook
to engage platform
in station

ENGAGE_SOL

<Local:3:O.Data.9>

Run



(EN)

SimTmr2.DN

(DN)

Proximity sensor, on
when platform is in
station
PROX

<Local:2:I.Data.0>

(U)

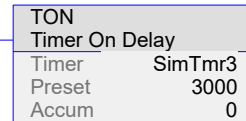
Simulate oiler up/down control. When moved up, the down ls is immediately unlatched off. After 3 secs, the up ls is latched on.
When moved down, the up ls is immediately unlatched off. After 3 secs, the down ls is latched on.

On to lower oiler
tip

OILER_DOWN

<Local:3:O.Data.10>

Run



(EN)

SimTmr3.DN

(DN)

Limit switch, on
(closed) when oiler
tip is in lowered
position
LS2

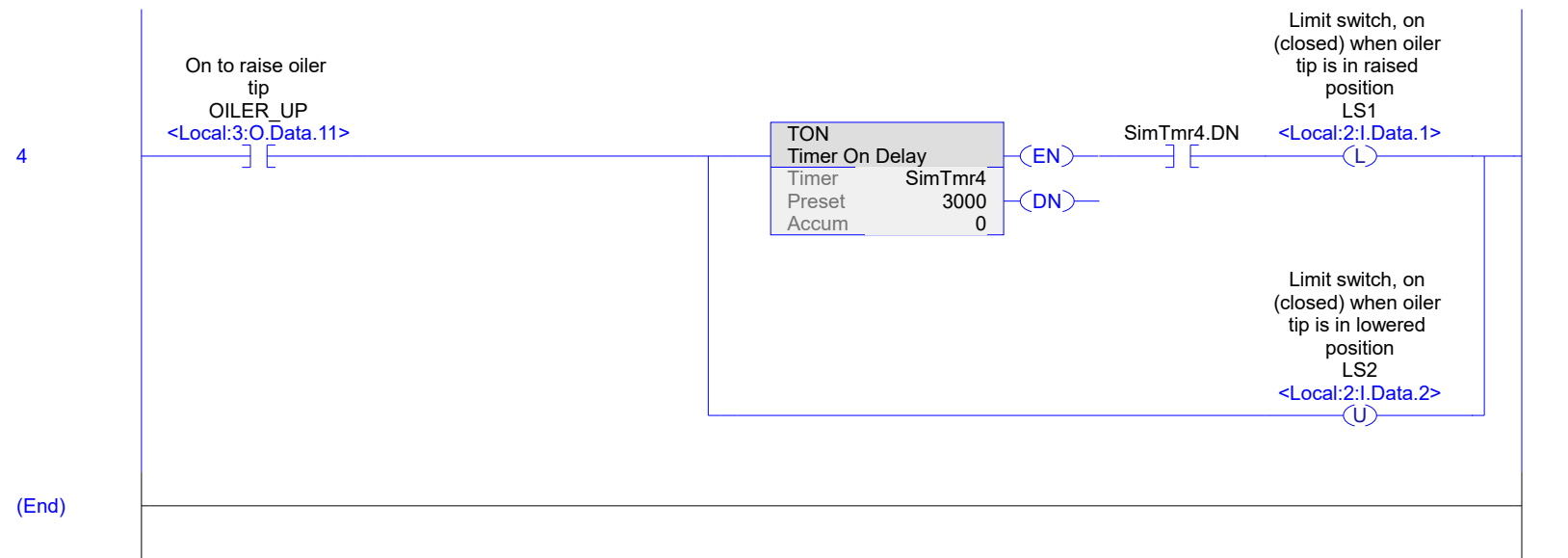
<Local:2:I.Data.2>

(L)

Limit switch, on
(closed) when oiler
tip is in raised
position
LS1

<Local:2:I.Data.1>

(U)



SP14_01	
Label does not exist	1
MainTask	
MainProgram	
MainRoutine	
Ladder Diagram	2
Part_Oiler	
Sequential Function Chart	3
Reset_Actions	
Ladder Diagram	4
Simulation	
Simulation	
Ladder Diagram	5