










-  Controller SP21\_01
-  Controller Fault Handler
-  Power-Up Handler

Tasks










-  MainTask
  -  MainProgram
  -  MainRoutine
  -  Simulation
  -  Simulation
-  Unscheduled

Motion Groups

-  Ungrouped Axes









Add-On Instructions

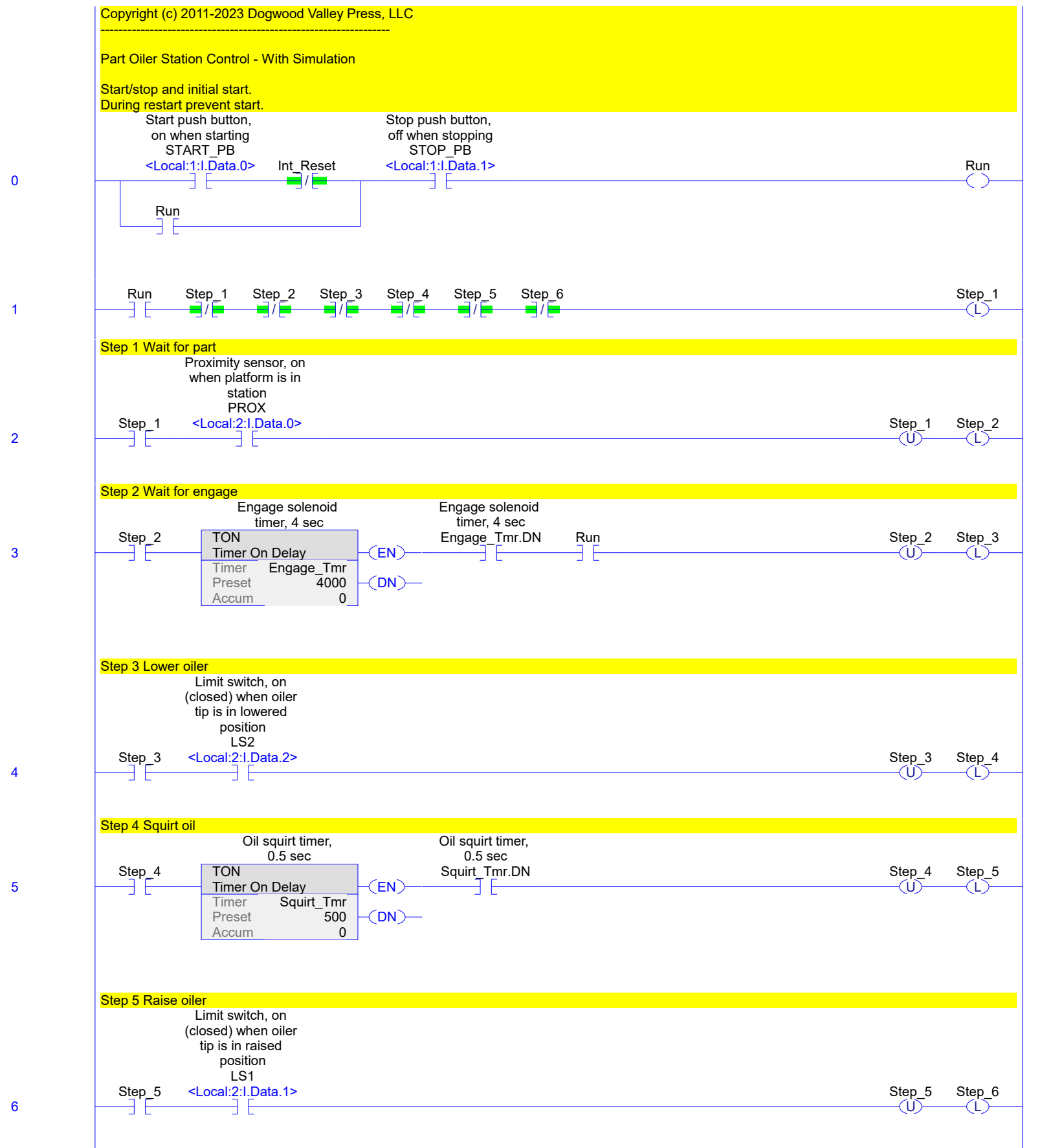
Data Types

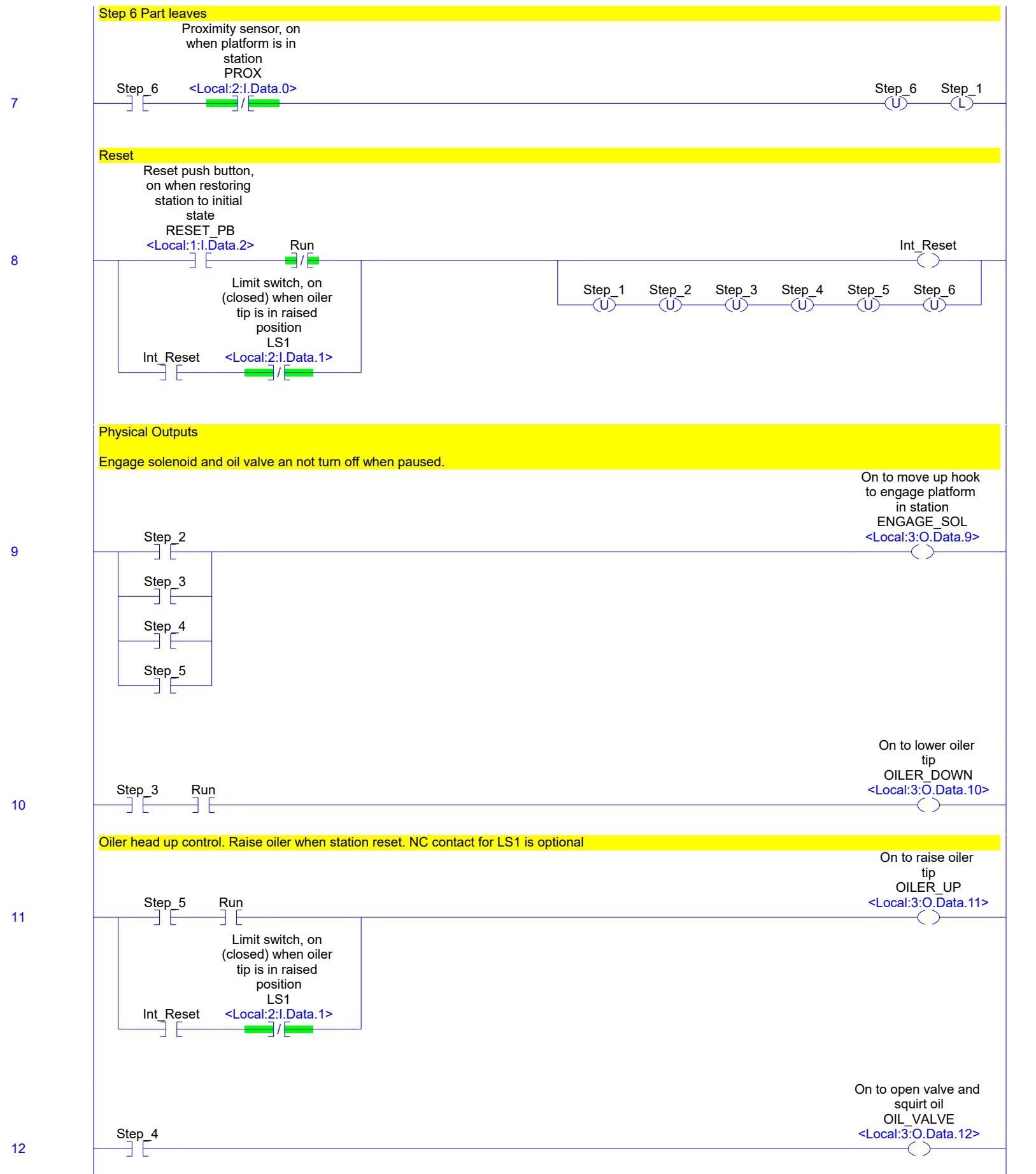
-  User-Defined
-  Strings
-  Add-On-Defined
-  Module-Defined
  -  AB:1756\_DI:C:0
  -  AB:1756\_DI:I:0
  -  AB:1756\_DO:C:0
  -  AB:1756\_DO:I:0
  -  AB:1756\_DO:O:0

Trends

I/O Configuration

-  1756 Backplane, 1756-A10
  -  [0] 1756-L71 SP21\_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





(End)

Copyright (c) 2011-2023 Dogwood Valley Press, LLC

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)

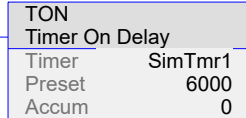
Simulate pallet up indication. Delay unlatch when pallet dropped.

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>

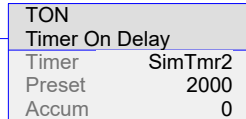
(L)

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)

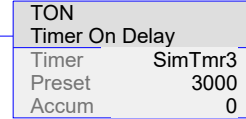
Simulate oiler up/down control. When moved up, the down ls is immediately unlatched off. After 3 secs, the up ls is latched on.  
When moved down, the up ls is immediately unlatched off. After 3 secs, the down ls is latched on.

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

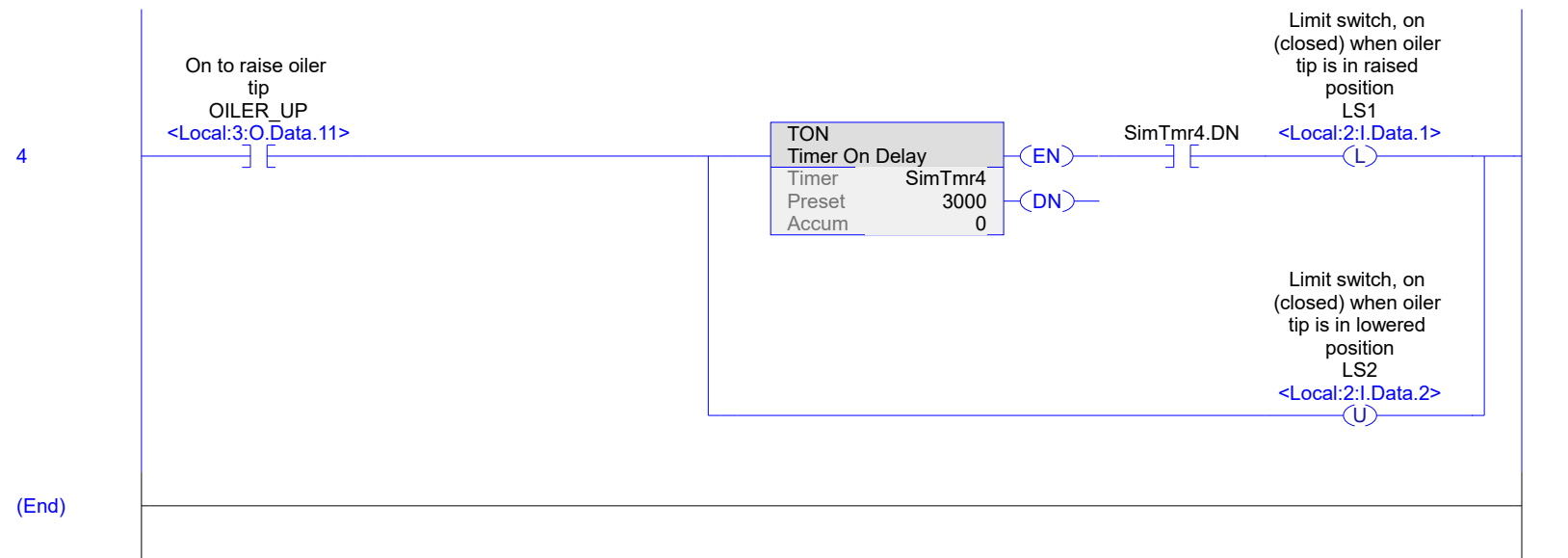
<Local:2:I.Data.2>

(L)

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

<Local:2:I.Data.1>

(U)



<b>SP21_01</b>	
Label does not exist .....	1
<b>MainTask</b>	
<b>MainProgram</b>	
<b>MainRoutine</b>	
Ladder Diagram .....	2
<b>Simulation</b>	
<b>Simulation</b>	
Ladder Diagram .....	5