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Part Oiler Station Control

Start/stop and initial start.
During restart prevent start.

0
Start push button, on when starting START_PB <Local:1:I.Data.0> — Int_Reset — Stop push button, off when stopping STOP_PB <Local:1:I.Data.1> — Run
Run

1
Run — Step_1 — Step_2 — Step_3 — Step_4 — Step_5 — Step_6 — Step_1 (L)

Step 1 Wait for part

2
Step_1 — Proximity sensor, on when platform is in station PROX <Local:2:I.Data.0> — Step_1 (U) — Step_2 (L)

Step 2 Wait for engage

3
Step_2 — TON Timer On Delay, Timer: Engage_Tmr, Preset: 4000, Accum: 0 — EN — Engage solenoid timer, 4 sec Engage_Tmr.DN — Run — Step_2 (U) — Step_3 (L)
DN

Step 3 Lower oiler

4
Step_3 — Limit switch, on (closed) when oiler tip is in lowered position LS2 <Local:2:I.Data.2> — Step_3 (U) — Step_4 (L)

Step 4 Squirt oil

5
Step_4 — TON Timer On Delay, Timer: Squirt_Tmr, Preset: 500, Accum: 0 — EN — Oil squirt timer, 0.5 sec Squirt_Tmr.DN — Step_4 (U) — Step_5 (L)
DN

Step 5 Raise oiler

6
Step_5 — Limit switch, on (closed) when oiler tip is in raised position LS1 <Local:2:I.Data.1> — Step_5 (U) — Step_6 (L)

Step 6 Part leaves

7

Step_6 — Proximity sensor, on when platform is in station PROX <Local:2:I.Data.0> — Step_6 (U) Step_1 (L)

Reset

8

Reset push button, on when restoring station to initial state RESET_PB <Local:1:I.Data.2> — Run — Limit switch, on (closed) when oiler tip is in raised position LS1 <Local:2:I.Data.1> — Int_Reset

Int_Reset ( ) — Step_1 (U) Step_2 (U) Step_3 (U) Step_4 (U) Step_5 (U) Step_6 (U)

Physical Outputs

Engage solenoid and oil valve an not turn off when paused.

9

Step_2 | Step_3 | Step_4 | Step_5 — On to move up hook to engage platform in station ENGAGE_SOL <Local:3:O.Data.9> ( )

10

Step_3 — Run — On to lower oiler tip OILER_DOWN <Local:3:O.Data.10> ( )

Oiler head up control. Raise oiler when station reset. NC contact for LS1 is optional

11

Step_5 — 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> — Int_Reset

12

Step_4 — On to open valve and squirt oil OIL_VALVE <Local:3:O.Data.12> ( )

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(End)

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