

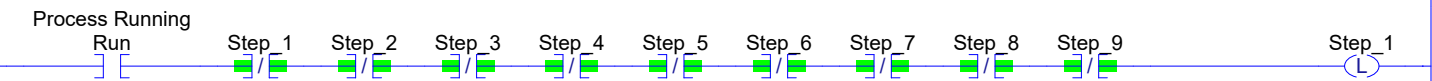
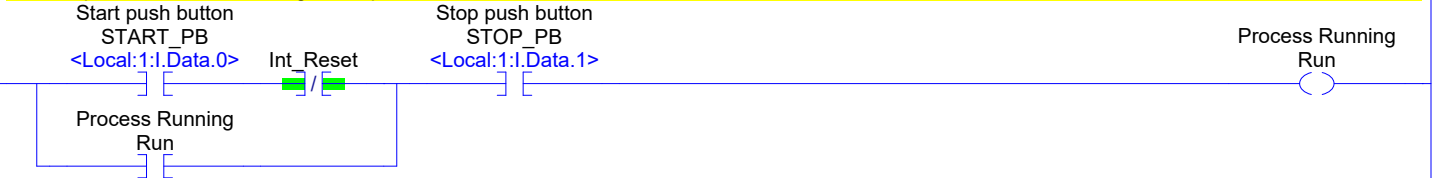
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Erbia Can Tipper/Rotator Control

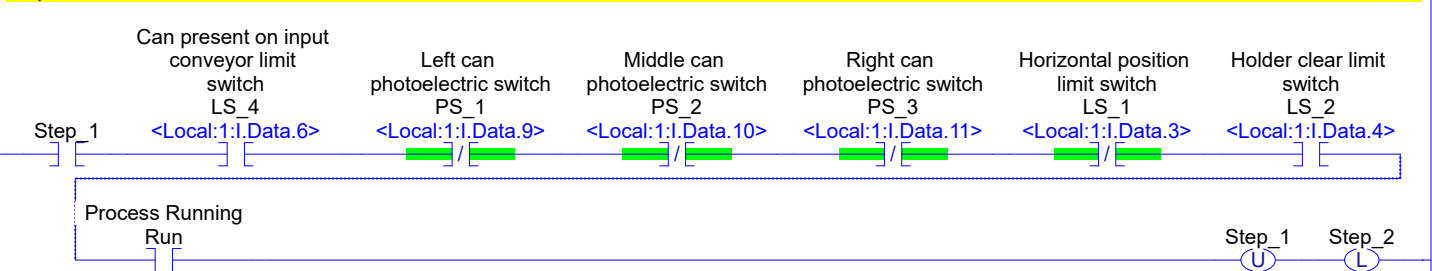
Additional internal memory:

Tag	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Step_1 to Step_9	BOOL	Step-in-progress bits
Retract_Tmr	TIMER	Times retract of CYL_4
Blend_Tmr	TIMER	Times blend

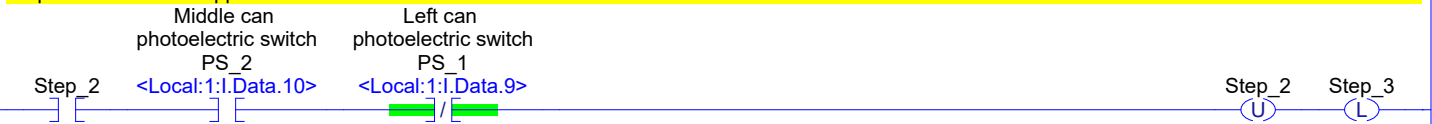
Start/stop and initial start. During reset, prevent start



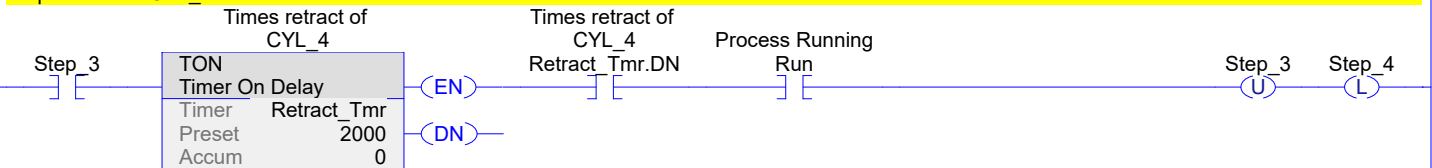
Step 1 Wait for can



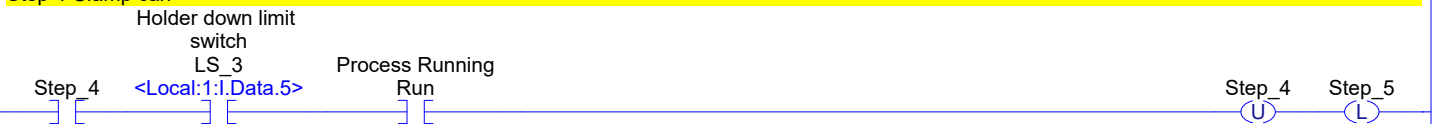
Step 2 Push can into tipper



Step 2 Wait for CYL_4 to retract

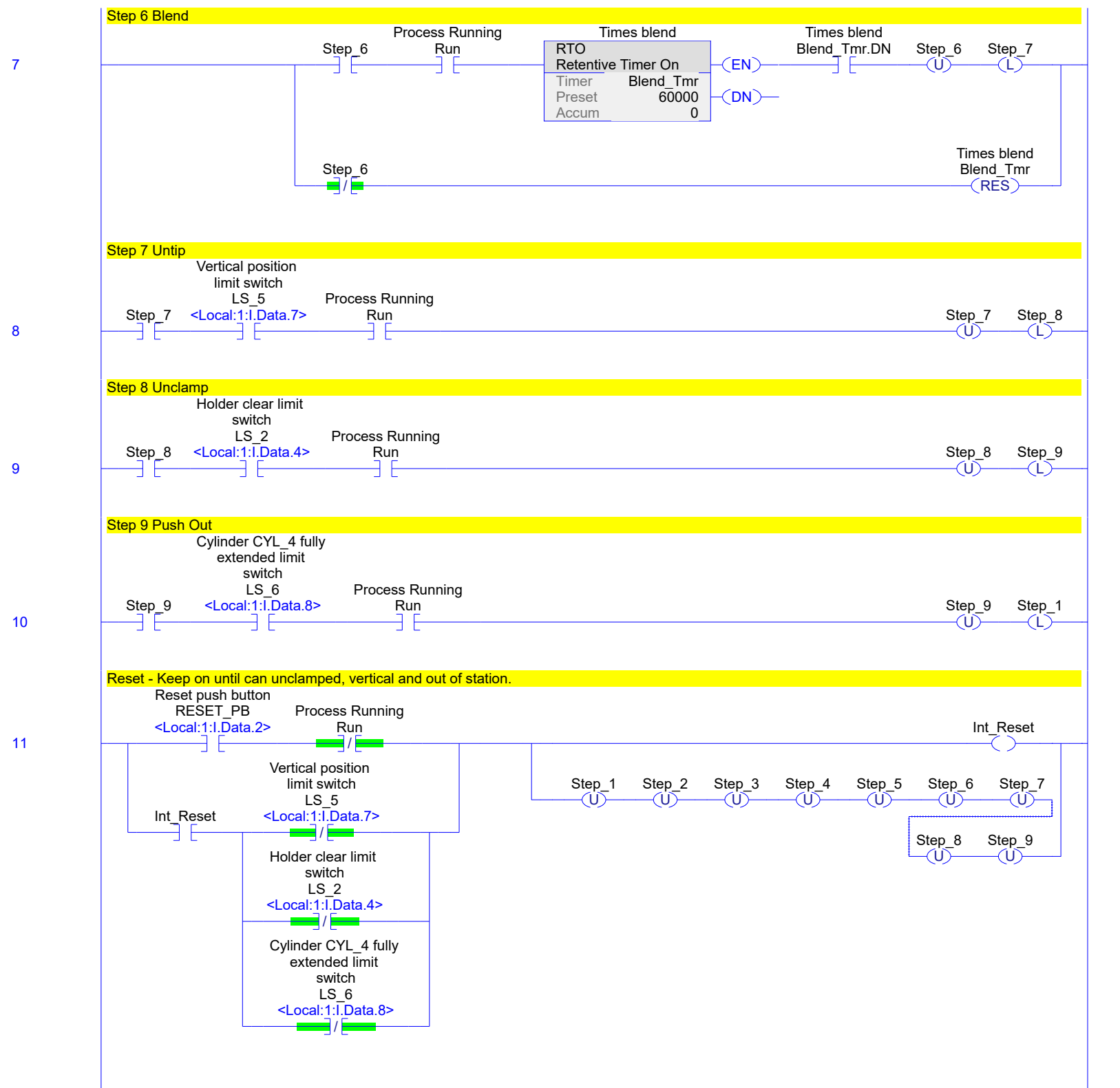


Step 4 Clamp can



Step 5 Tip rotator





Physical Outputs

Cannot turn off CYL_1 to CYL_3 when paused.

On reset, do not unclamp until vertical.

Can holder cylinder
control
CYL_1
<Local:2:O.Data.0>

Step_4

Step_5

Step_6

Step_7

Vertical position
limit switch
LS_5

Int_Reset <Local:1:I.Data.7>

Tipper cylinder
control
CYL_2
<Local:2:O.Data.1>

Step_5

Step_6

Gate cylinder
control
CYL_3
<Local:2:O.Data.2>

Step_2

Step_3

Step_4

Step_5

Step_6

Step_7

Step_8

Step_9

