










-  Controller SP21_02
-  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_02
 -  [1] 1756-IB32/A discrete_in1
 -  [2] 1756-IB32/A discrete_in_2
 -  [3] 1756-IB32/A discrete_in3
 -  [4] 1756-IB32/A discete_in_4
 -  [5] 1756-OB32 DISCRETE_OUT5
 -  [6] 1756-IB32/A DISCRETE_IN6
 -  [7] 1756-OB32 DISCRETE_OUT7

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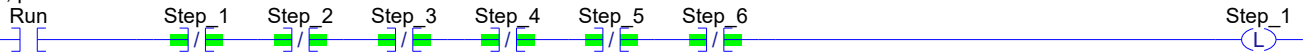
Case Erector Control - With Simulation

Additional internal memory:

Tag	Data Type	
Step_1 to Step_6	BOOL	Step-in-progress bits
Up_Tmr	TIMER	Times opening up
BDown_Tmr	TIMER	Times deactivate of bottom cylinder
Pulse_Cnt	COUNTER	Count encoder pulses

Initial start. When on, allow case erector to run. When off pause

When on, allow case
erector to run. When
off, pause



Step 1 Move in

Proximity sensor, on
when flat carton is
in position to be
erected
PROX

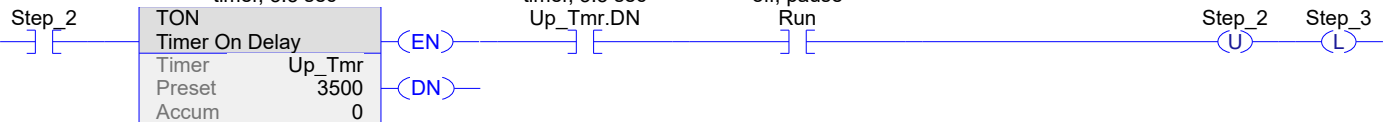


Step 2 Open up

Unfolding carton
timer, 3.5 sec

Unfolding carton
timer, 3.5 sec

When on, allow case
erector to run. When
off, pause

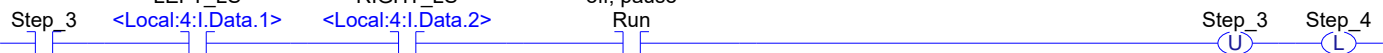


Step 3 Close sides

Limit switch, on
(closed) when left
flap is folded in
position
LEFT_LS

Limit switch, on
(closed) when right
flap is folded in
position
RIGHT_LS

When on, allow case
erector to run. When
off, pause



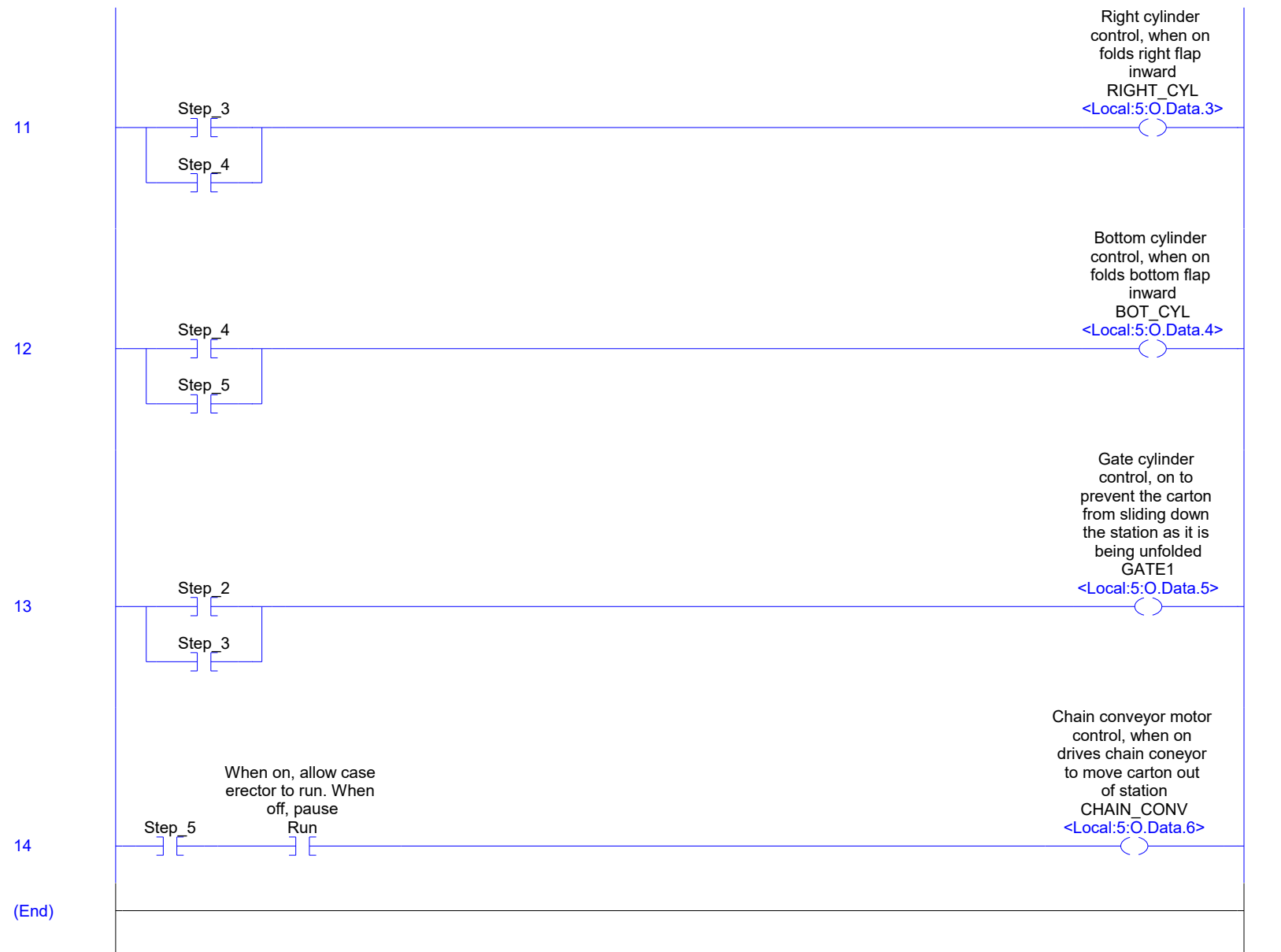
Step 4 Close bottom

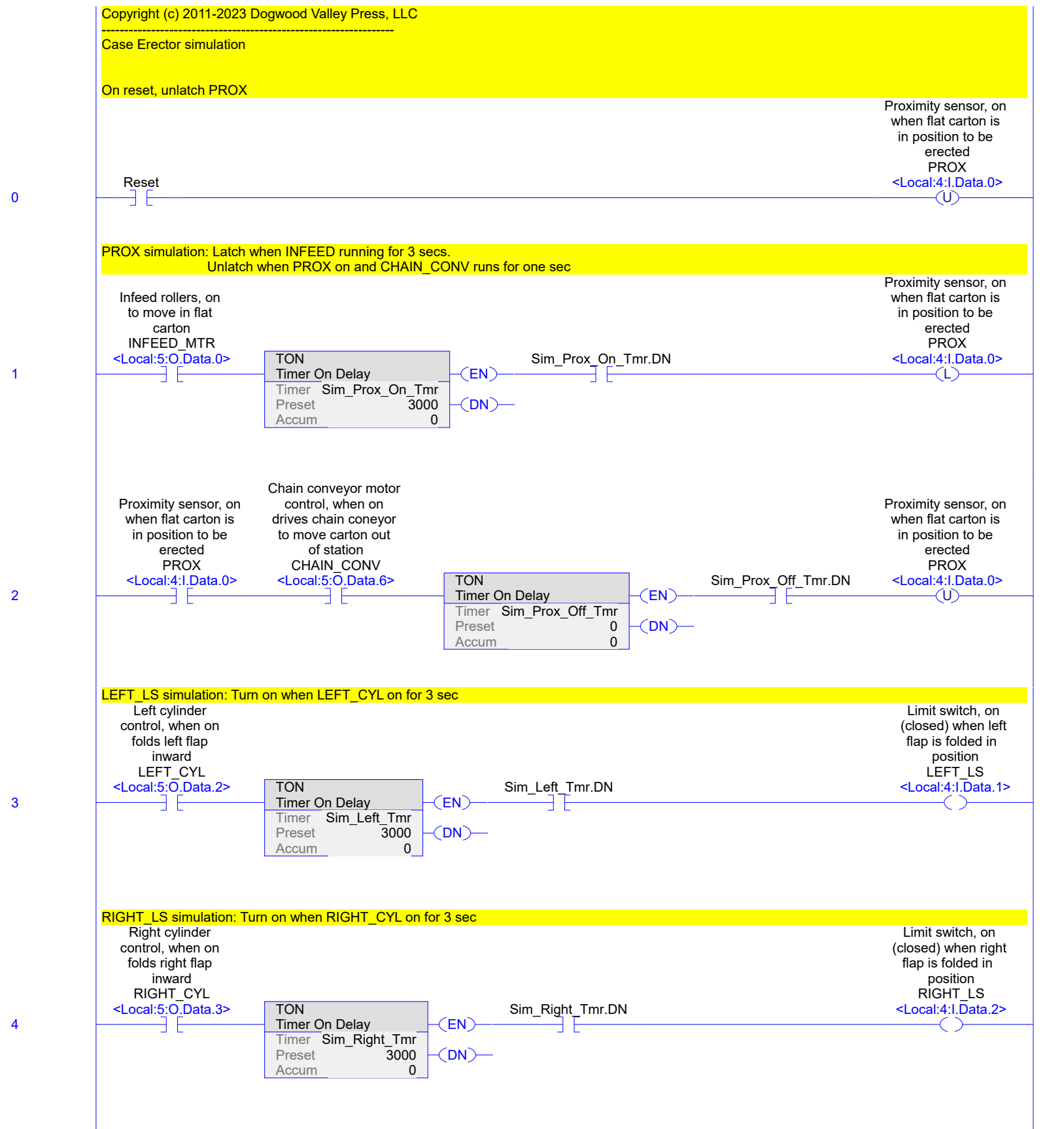
Limit switch, on
(closed) when bottom
flap is in position
BOT_LS

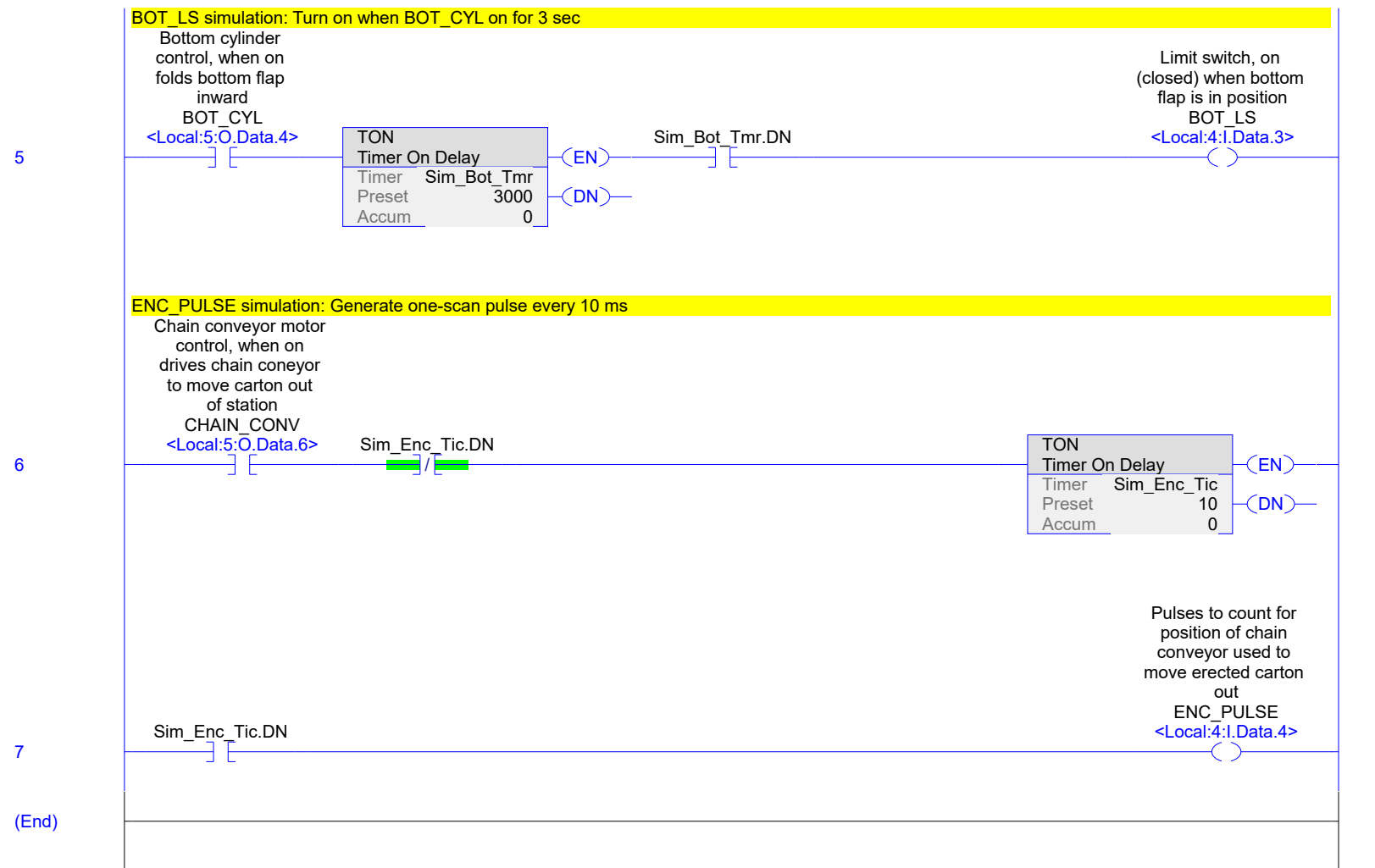
When on, allow case
erector to run. When
off, pause











SP21_02	
Label does not exist	1
MainTask	
MainProgram	
MainRoutine	
Ladder Diagram	2
Simulation	
Simulation	
Ladder Diagram	5