








-  Controller SP21\_04
-  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
  -  AB:1756\_IF4\_Float:C:0
  -  AB:1756\_IF4\_Float:I:0
  -  AB:1756\_IF8\_Integer:C:0
  -  AB:1756\_IF8\_Integer:I:0
  -  AB:1756\_NII\_Struct:C:0
  -  AB:1756\_OF4\_Integer:C:0
  -  AB:1756\_OF4\_Integer:I:0
  -  AB:1756\_OF4\_Integer:O:0

Trends

I/O Configuration

-  1756 Backplane, 1756-A10
  -  [0] 1756-L71 SP21\_04
  -  [1] 1756-IB32/A discrete\_in1
  -  [2] 1756-OB32 DISCRETE\_OUT2
  -  [3] 1756-IF8/A analo\_in
  -  [4] 1756-OF4/A
  -  [5] 1756-IB16 TW\_discin

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\*\*\*\*\* Pressure Check Station Control - With Simulation \*\*\*\*\*

Additional internal memory:

Tag	Data Type	Internal reset
Int_Reset	BOOL	Step-in-progress bits
Step_1 to Step_6	BOOL	Times leak test
Wait_Tmr	TIMER	

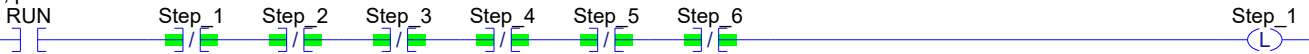
Conversion formulas

$HD\_HGT = (HGT\_MEAS/100) * (150-75) + 75$

$VLV\_PRES = (PRES\_MEAS/100) * (100-0) + 0$

Initial start

When on, allow  
pressure check  
station to run. When  
off, pause.



Step 1. Wait for valve.

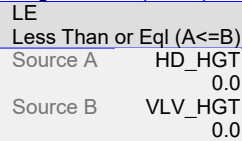
Reflective proximity  
switch that is on  
when valve is in  
position to be  
pressure checked  
PROX

When on, allow  
pressure check  
station to run. When  
off, pause.



Step 2. Head down.

Pressurizing head  
height, in mm (REAL)

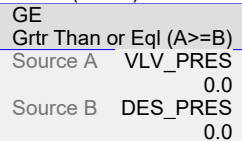


When on, allow  
pressure check  
station to run. When  
off, pause.



Step 3. Pressurize.

Pressure, in psi  
(REAL)



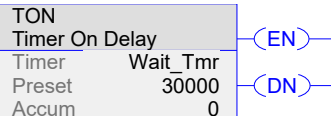
When on, allow  
pressure check  
station to run. When  
off, pause.



Step 4. Wait for pressure check.

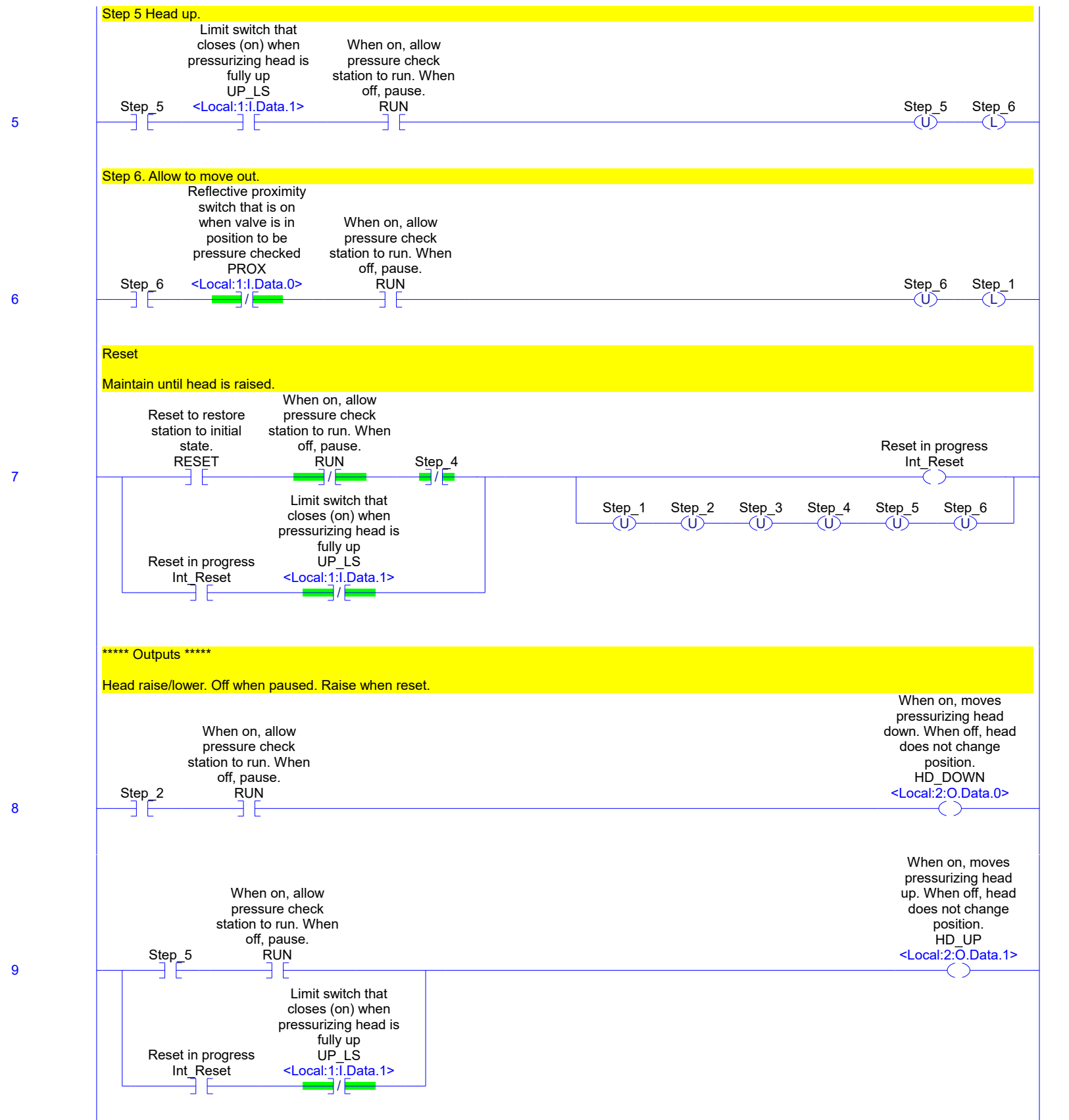
Wait 30 sec to see  
if valve leaks

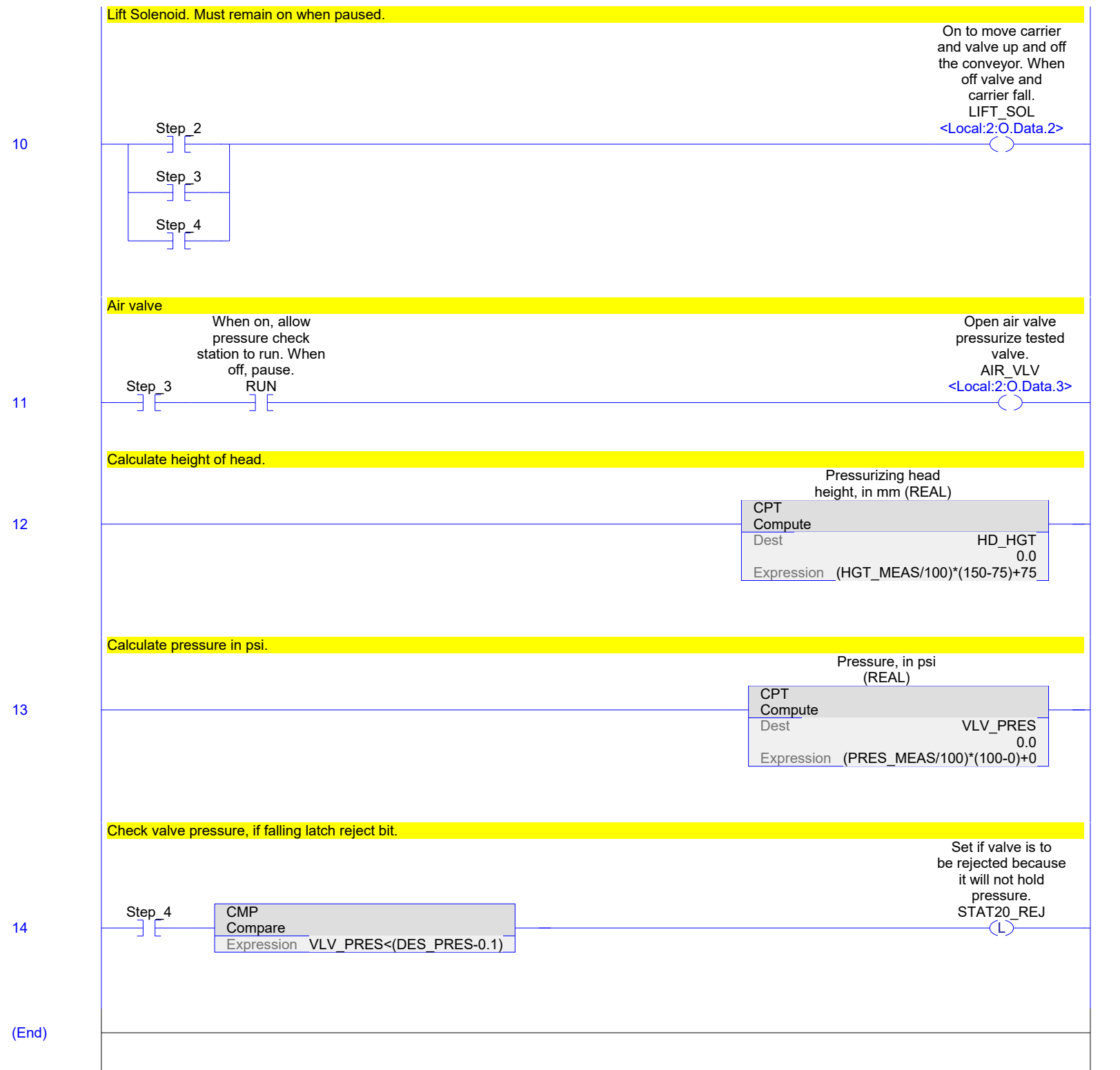
Wait 30 sec to see  
if valve leaks

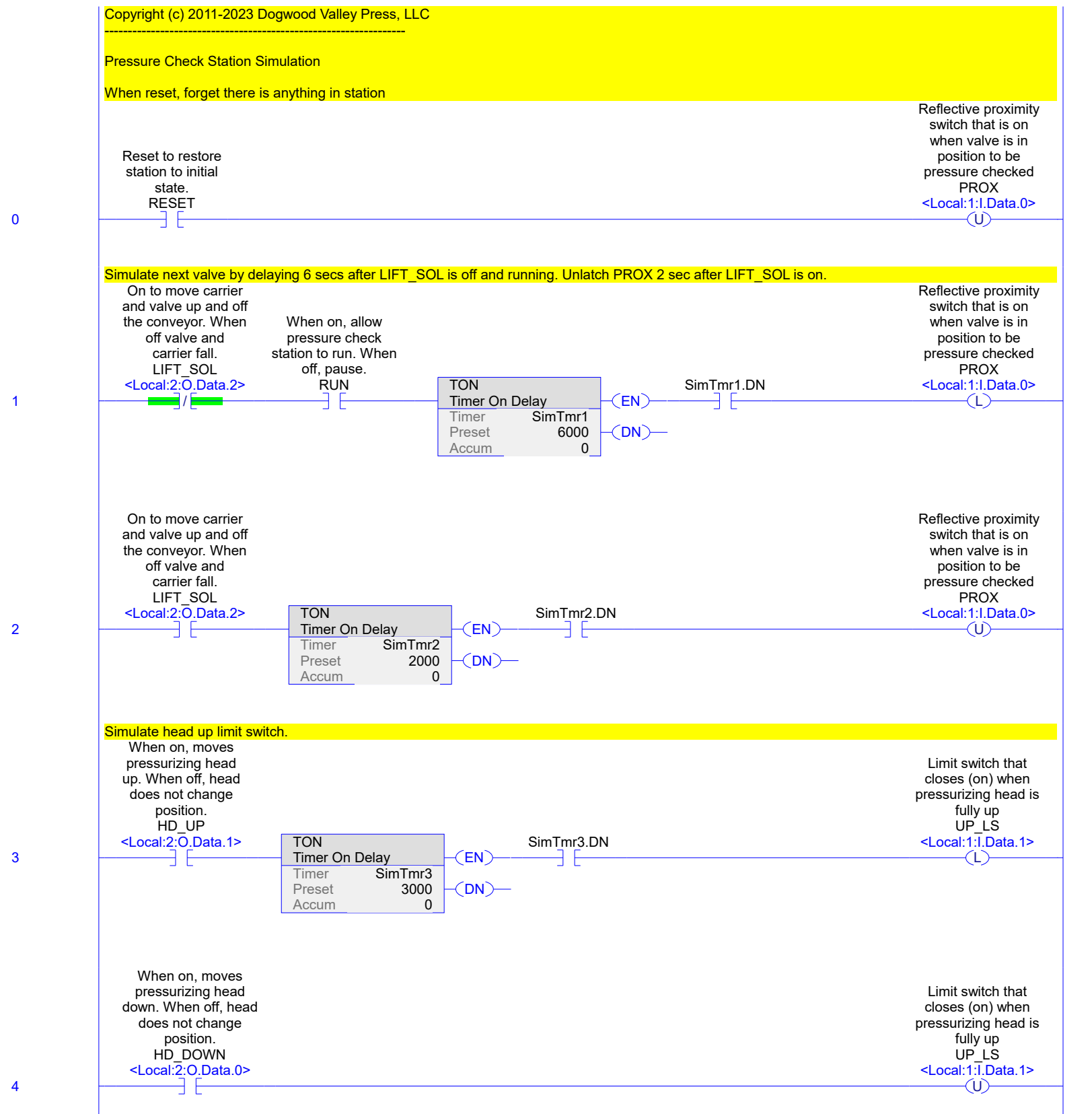


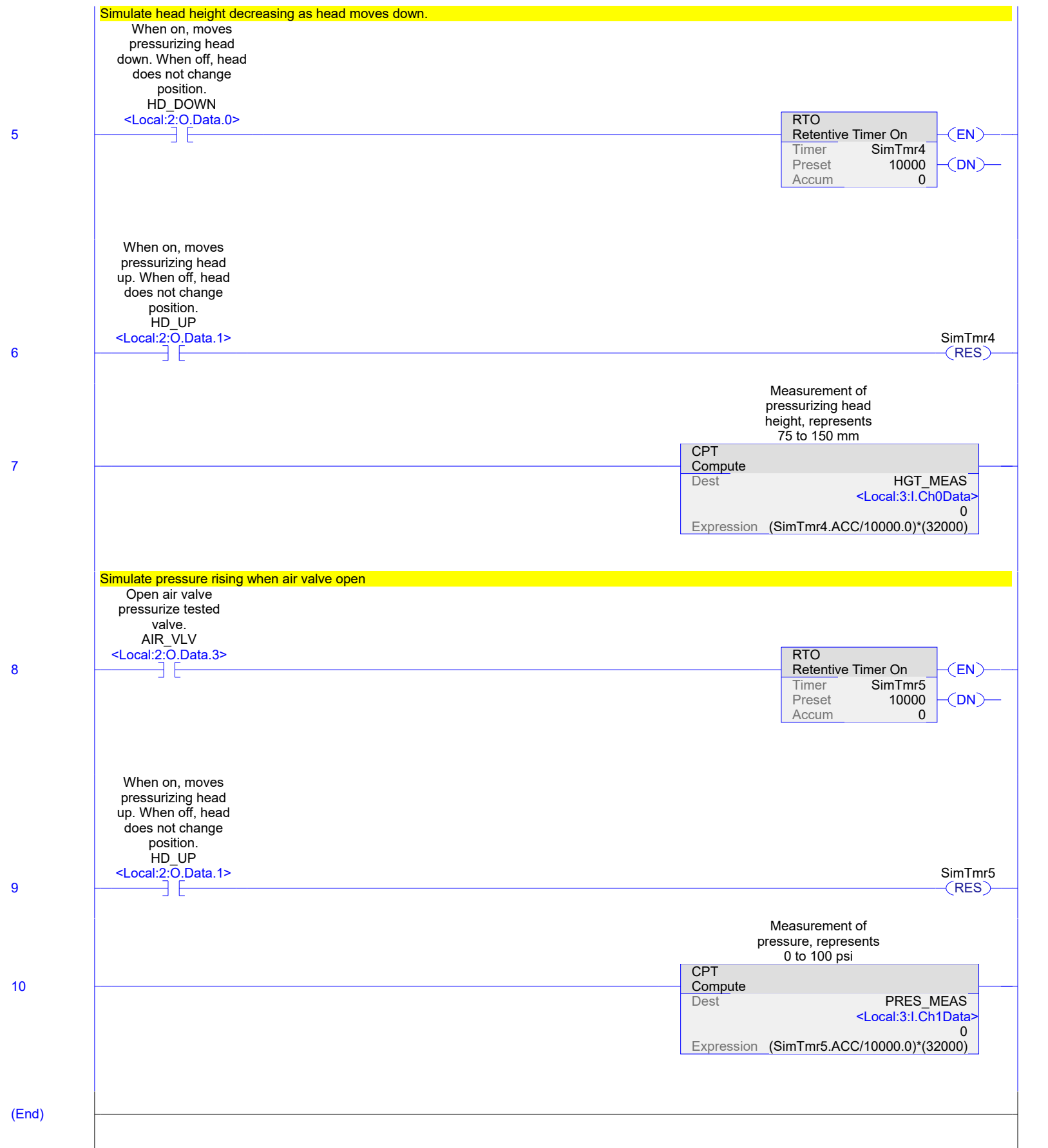
Wait\_Tmr.DN











<b>SP21_04</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