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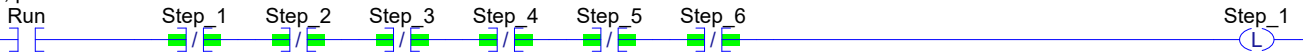
Case Erector Control

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

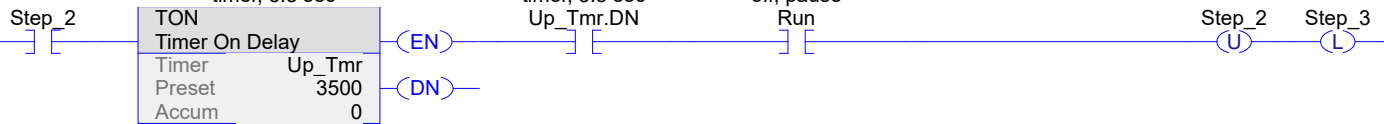


Step 2 Open up

Unfolding carton
timer, 3.5 sec

Unfolding carton
timer, 3.5 sec

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

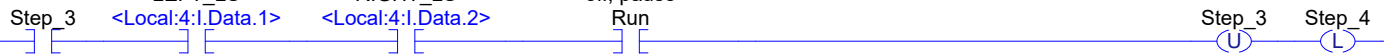


Step 3 Close sides

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





