













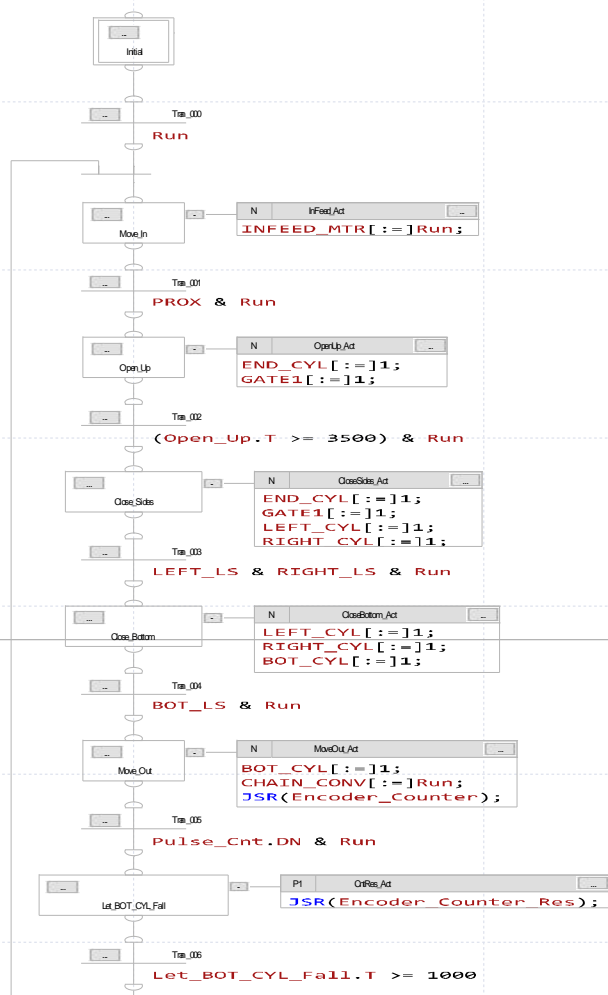
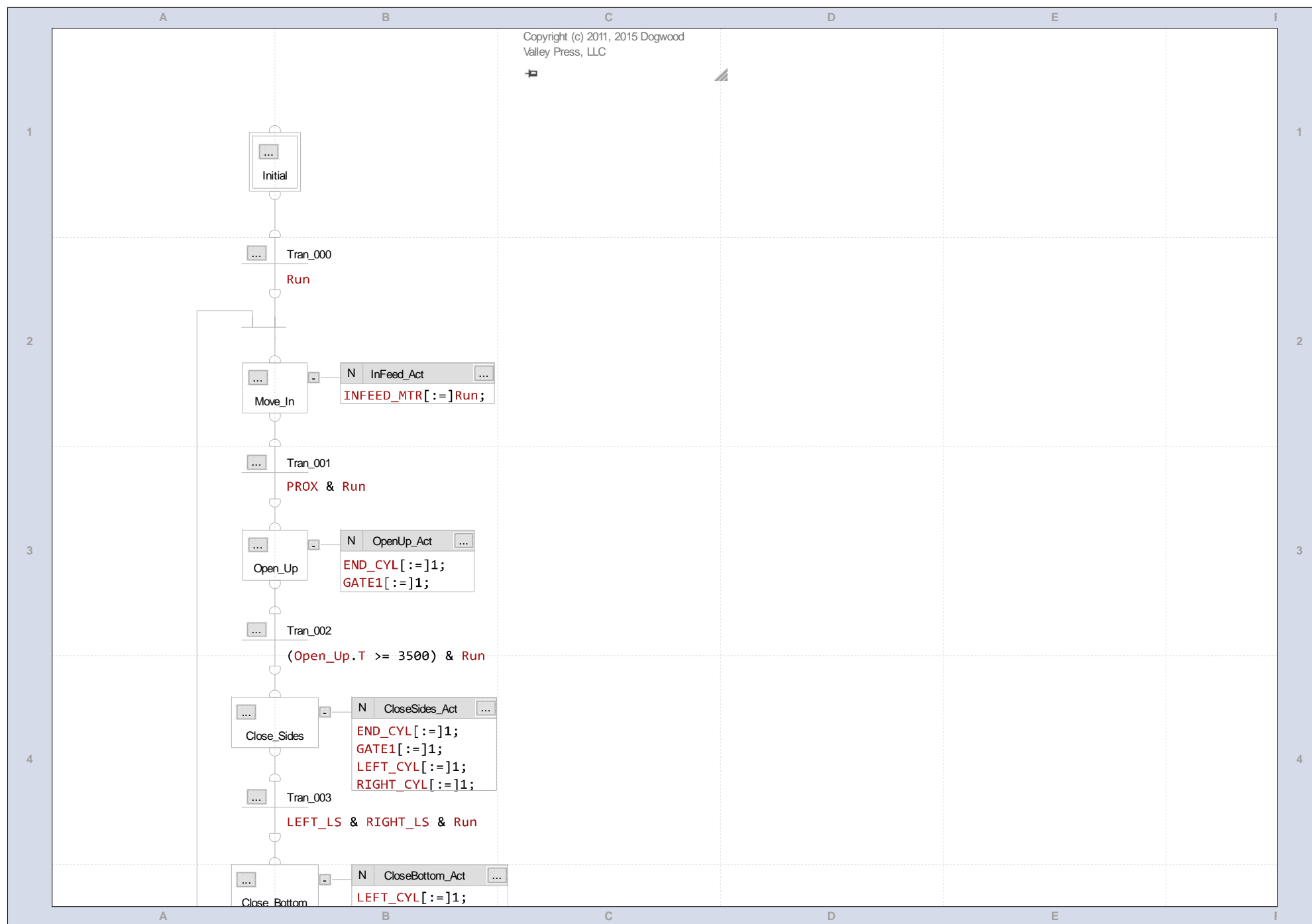
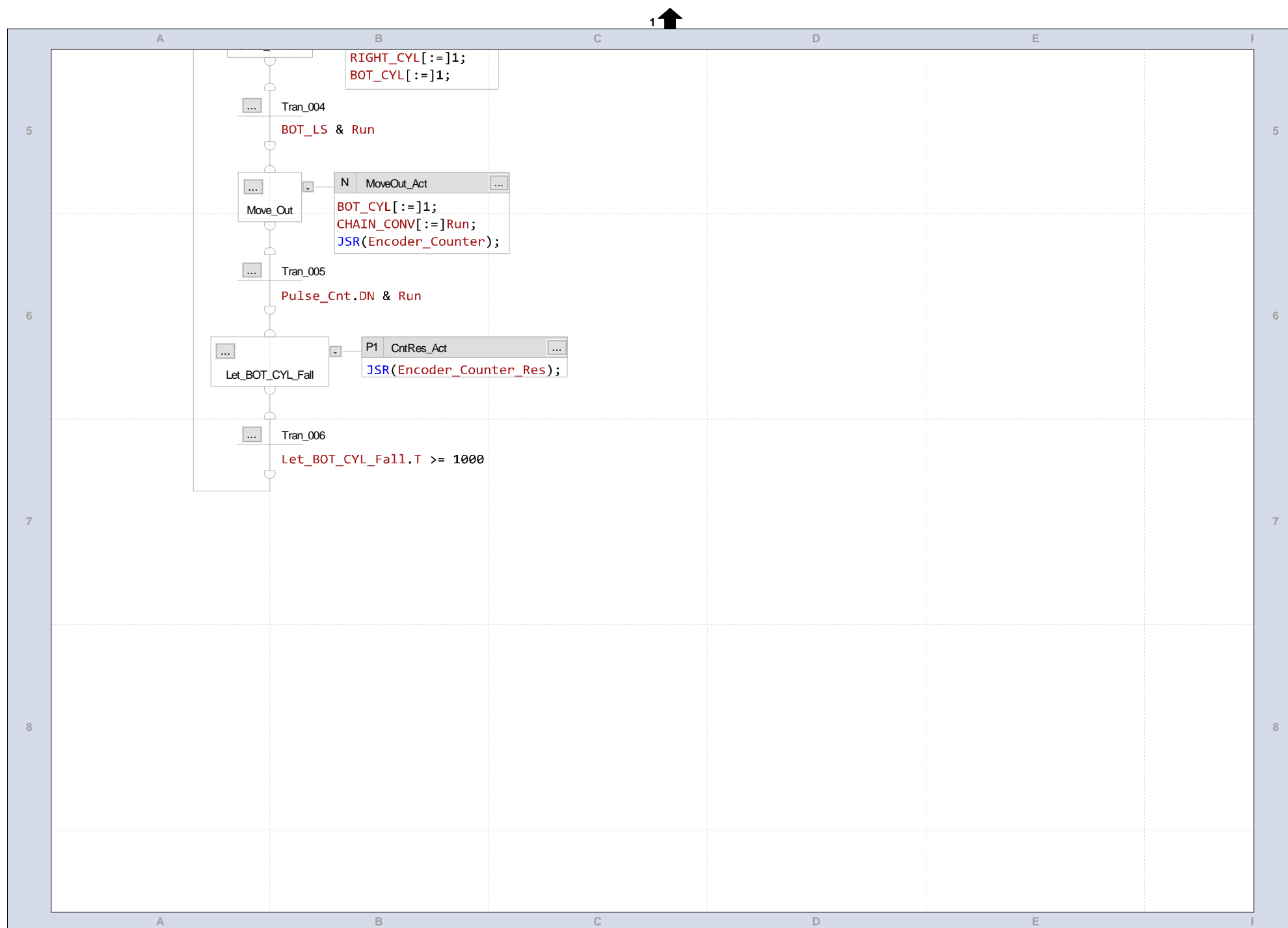
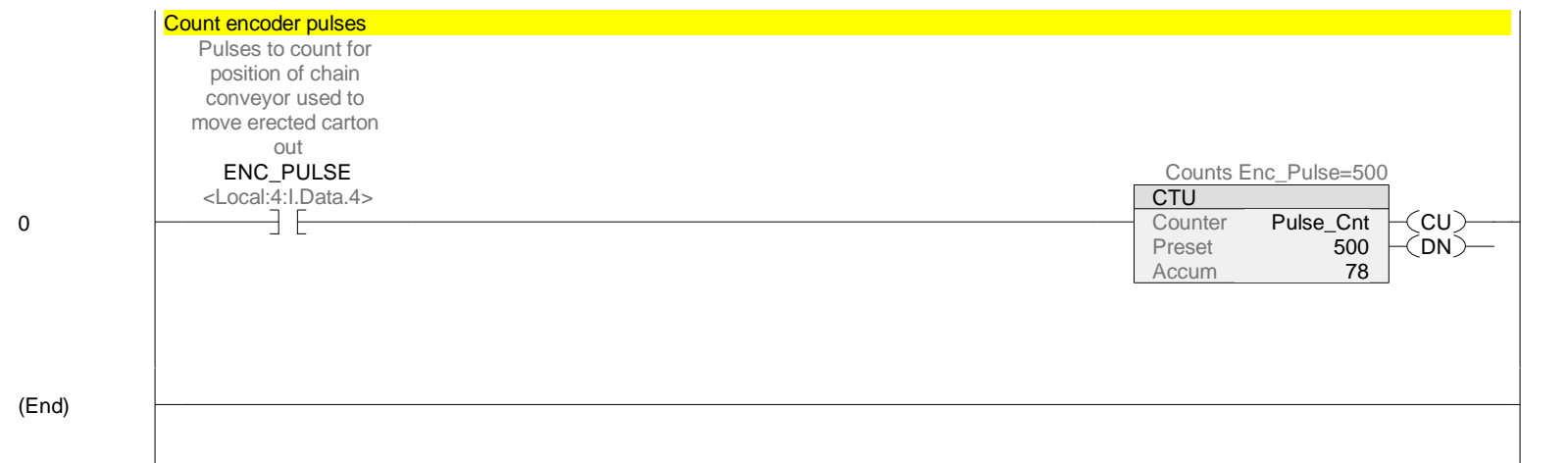


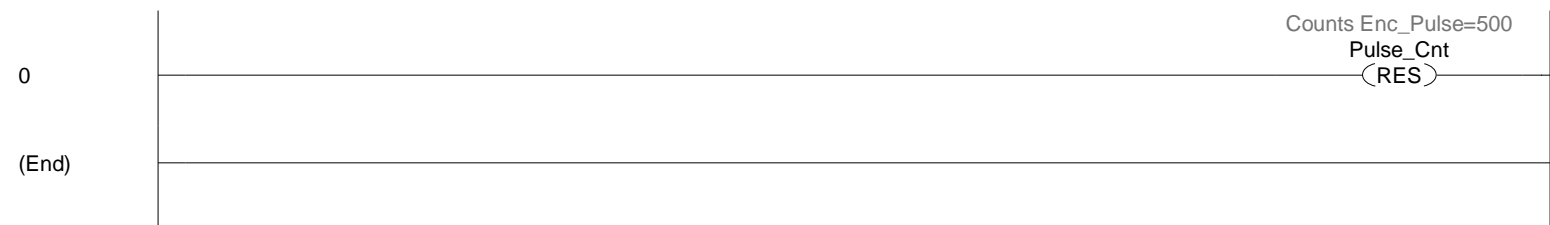
 Controller SP14_02 Controller Fault Handler Power-Up Handler**Tasks** MainTask MainProgram MainRoutine Case_Erector Encoder_Counter Encoder_Counter_Res Simulation Simulation Unscheduled**Motion Groups** Ungrouped Axes**Add-On Instructions****Data Types** User-Defined Strings Add-On-Defined Module-Defined 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 SP14_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

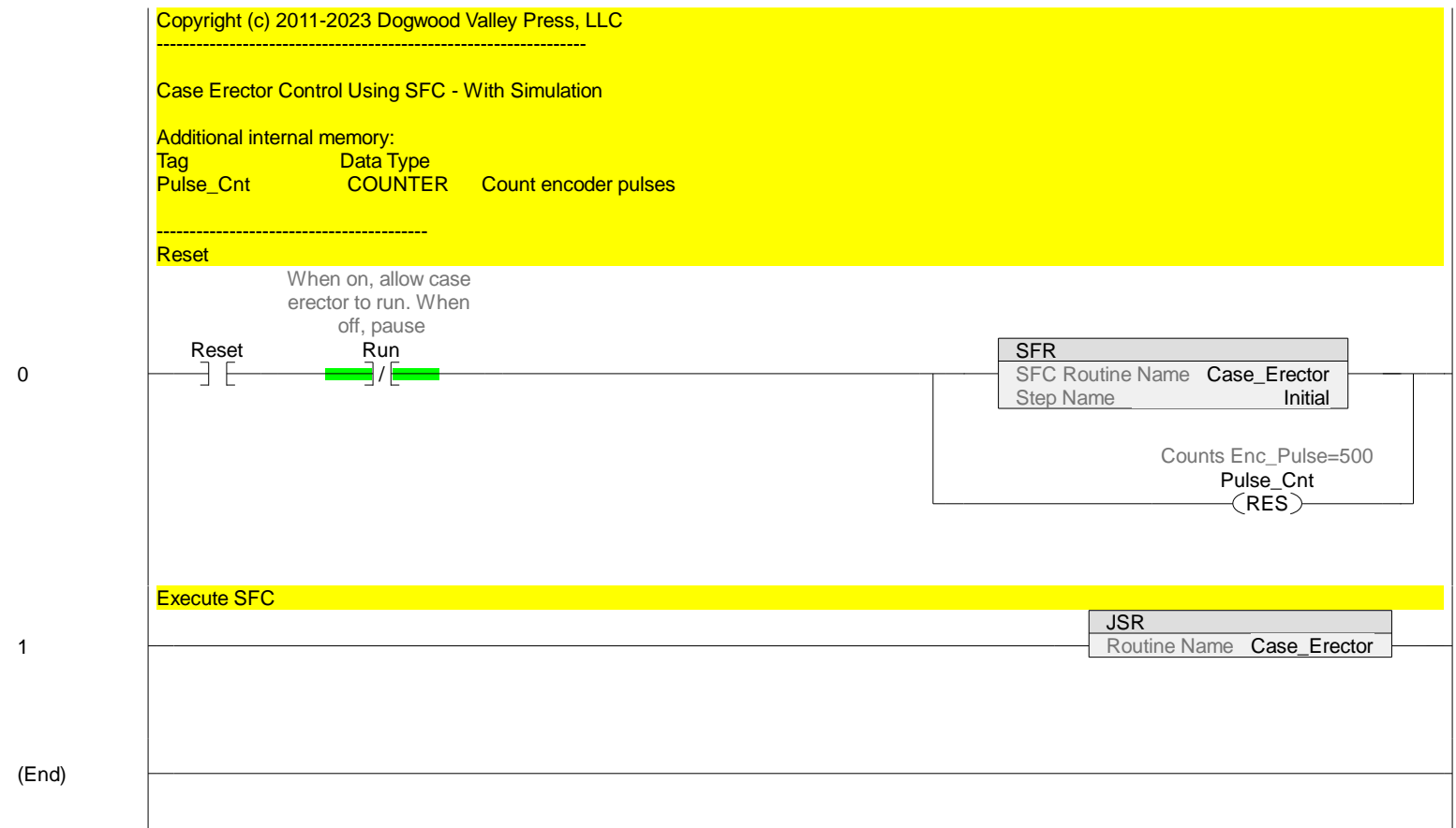












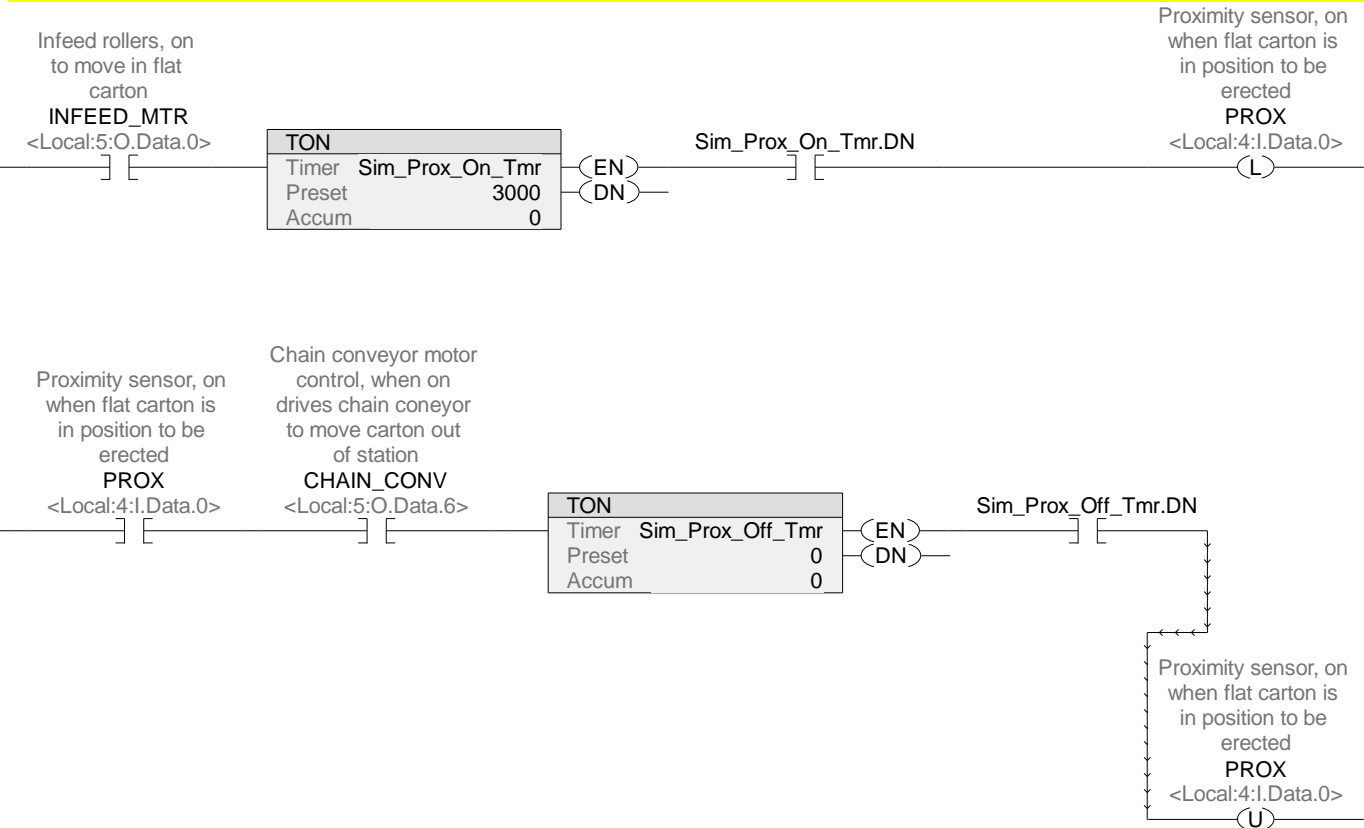
Copyright (c) 2011-2023 Dogwood Valley Press, LLC

Case Erector simulation

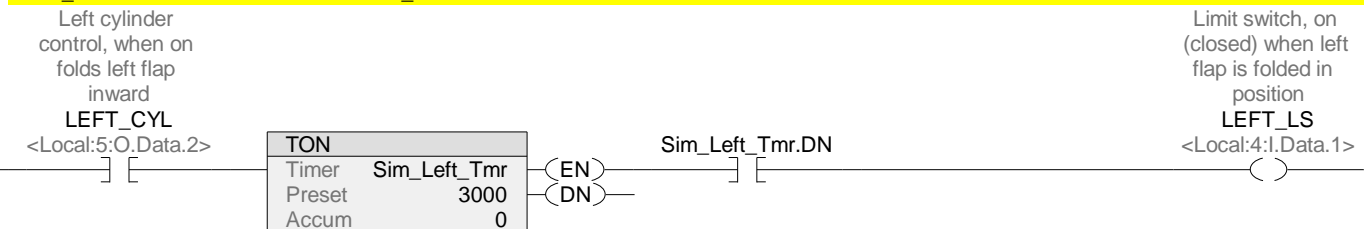
On reset, unlatch PROX

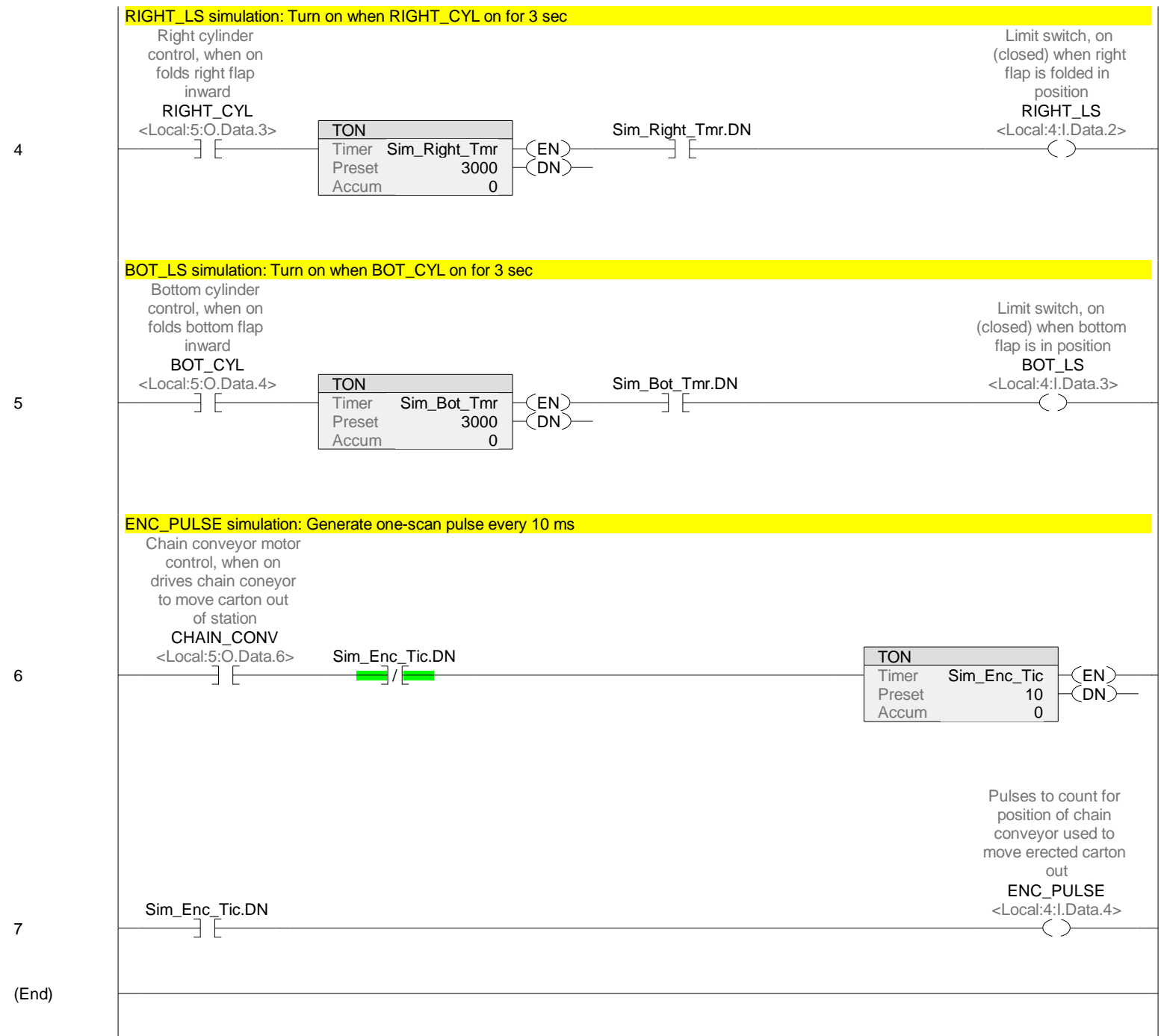


PROX simulation: Latch when INFEED running for 3 secs.
Unlatch when PROX on and CHAIN_CONV runs for one sec



LEFT_LS simulation: Turn on when LEFT_CYL on for 3 sec





SP14_02	
Label does not exist	1
MainTask	
MainProgram	
Case_Erector	
Sequential Function Chart	2
Encoder_Counter	
Ladder Diagram	5
Encoder_Counter_Res	
Ladder Diagram	6
MainRoutine	
Ladder Diagram	7
Simulation	
Simulation	
Ladder Diagram	8