










 Controller SP21_01 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_01 [1] 1756-IB32/A discrete_in1 [2] 1756-IB32/A discrete_in_2 [3] 1756-OB32 DISCRETE_OUT3 [4] 1756-OB32 discrete_out4 [6] 1756-IB32/A DISCRETE_IN6 [7] 1756-OB32 DISCRETE_OUT7

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Part Oiler Station Control - With Simulation

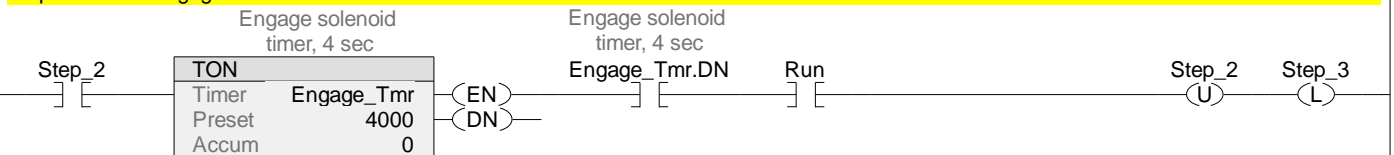
Start/stop and initial start.
During restart prevent start.



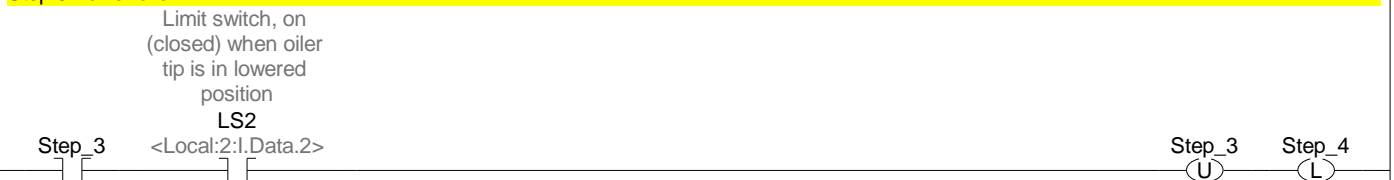
Step 1 Wait for part



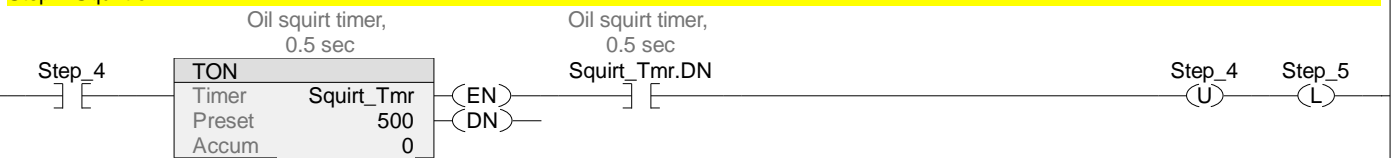
Step 2 Wait for engage



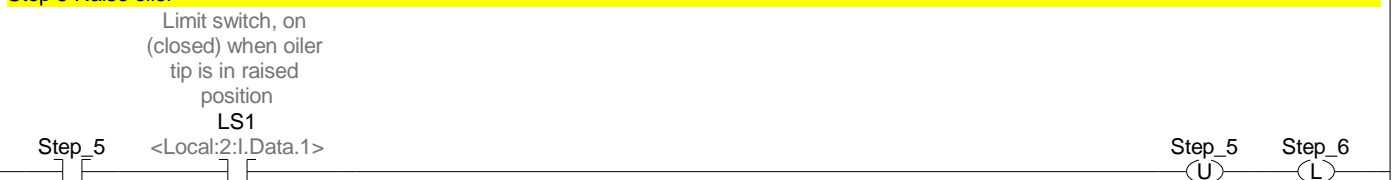
Step 3 Lower oiler



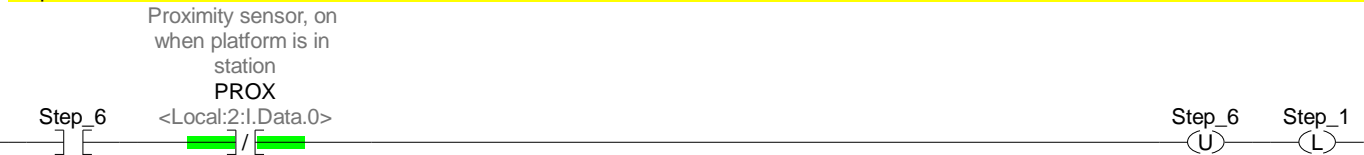
Step 4 Squirt oil



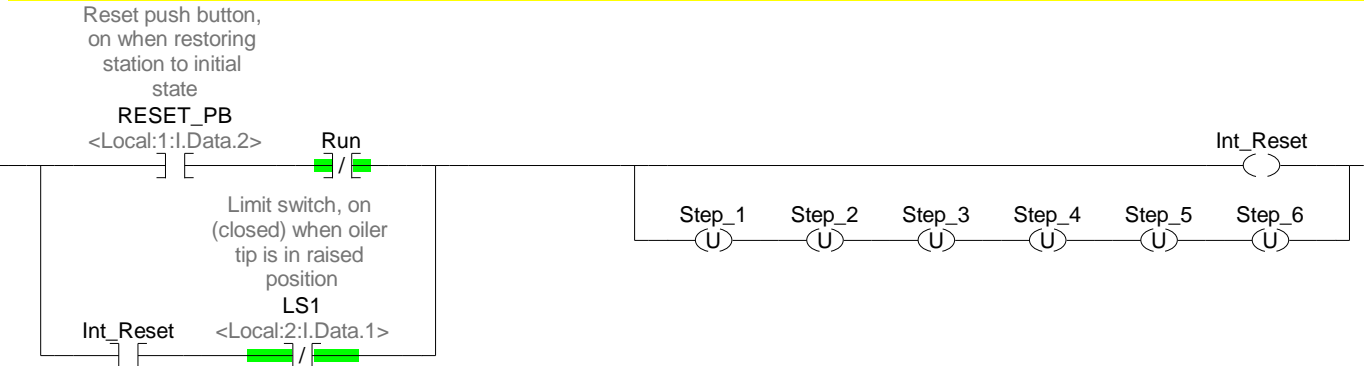
Step 5 Raise oiler



Step 6 Part leaves

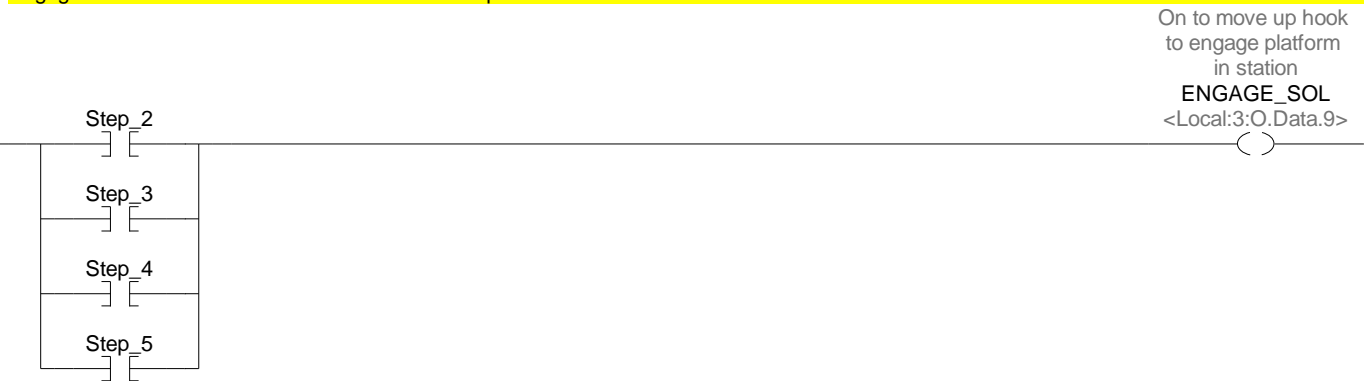


Reset

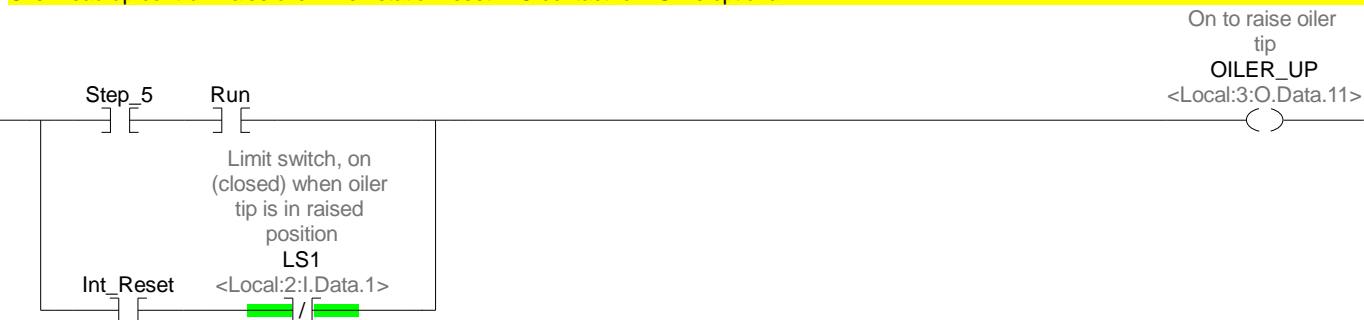


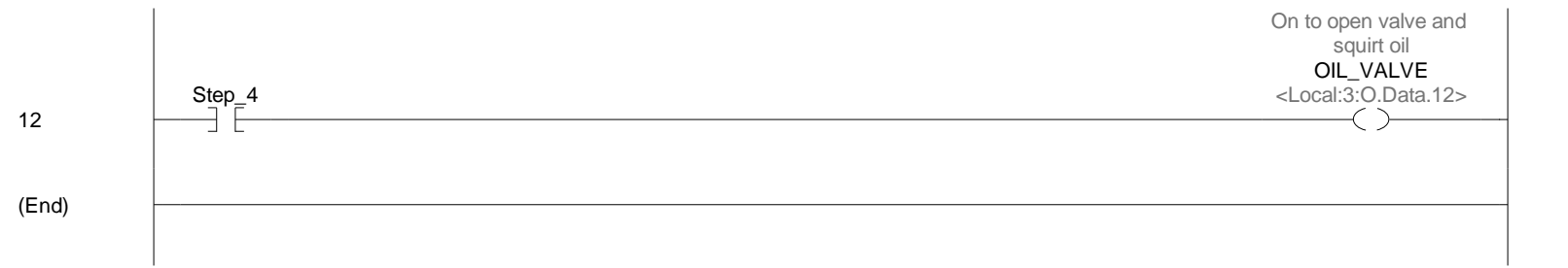
Physical Outputs

Engage solenoid and oil valve an not turn off when paused.



Oiler head up control. Raise oiler when station reset. NC contact for LS1 is optional





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Part Oiler Station simulation

When reset, forget there is anything in station

Reset push button,
on when restoring
station to initial
state

RESET_PB
<Local:1:I.Data.2>

Run

Proximity sensor, on
when platform is in
station

PROX
<Local:2:I.Data.0>

Simulate pallet up indication. Delay unlatch when pallet dropped.

On to move up hook
to engage platform
in station

ENGAGE_SOL
<Local:3:O.Data.9>

Run

TON	SimTmr1
Timer	6000
Preset	0
Accum	0

SimTmr1.DN

Proximity sensor, on
when platform is in
station

PROX
<Local:2:I.Data.0>

On to move up hook
to engage platform
in station

ENGAGE_SOL
<Local:3:O.Data.9>

TON	SimTmr2
Timer	2000
Preset	0
Accum	0

SimTmr2.DN

Proximity sensor, on
when platform is in
station

PROX
<Local:2:I.Data.0>

Simulate oiler up/down control. When moved up, the down ls is immediately unlatched off. After 3 secs, the up ls is latched on.
When moved down, the up ls is immediately unlatched off. After 3 secs, the down ls is latched on.

On to lower oiler
tip

OILER_DOWN
<Local:3:O.Data.10>

TON	SimTmr3
Timer	3000
Preset	0
Accum	0

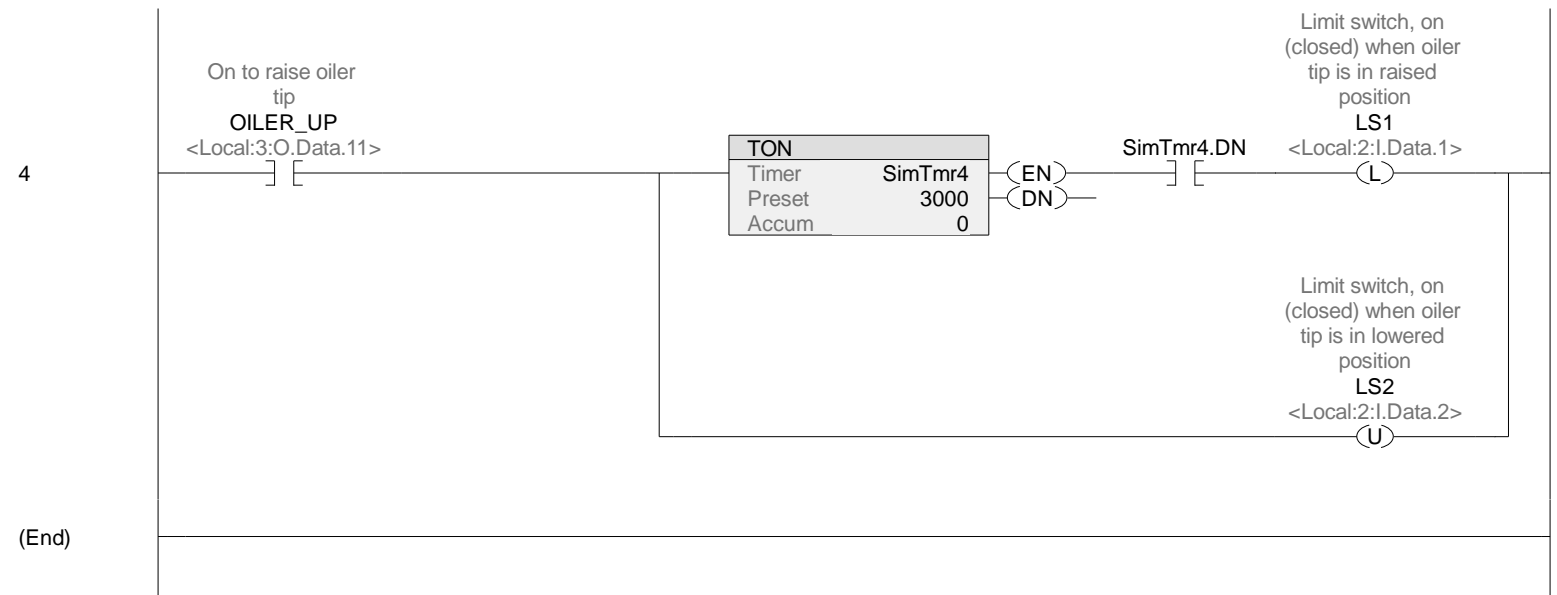
SimTmr3.DN

Limit switch, on
(closed) when oiler
tip is in lowered
position

LS2
<Local:2:I.Data.2>

Limit switch, on
(closed) when oiler
tip is in raised
position

LS1
<Local:2:I.Data.1>



SP21_01	
Label does not exist	1
MainTask	
MainProgram	
MainRoutine	
Ladder Diagram	2
Simulation	
Simulation	
Ladder Diagram	5