












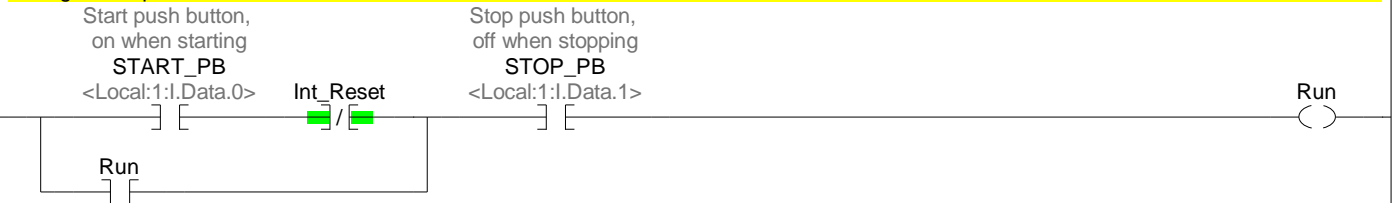


 Controller SP14_01 Controller Fault Handler Power-Up Handler**Tasks** MainTask MainProgram MainRoutine Part_Oiler Reset_Actions Simulation Simulation Unscheduled**Motion Groups** Ungrouped Axes**Add-On Instructions****Data Types** User-Defined Strings Add-On-Defined Module-Defined AB:1756_DI:C:0 AB:1756_DI:I:0 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_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 Using SFC - With Simulation

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



Routine to do reset actions must be called before next rung



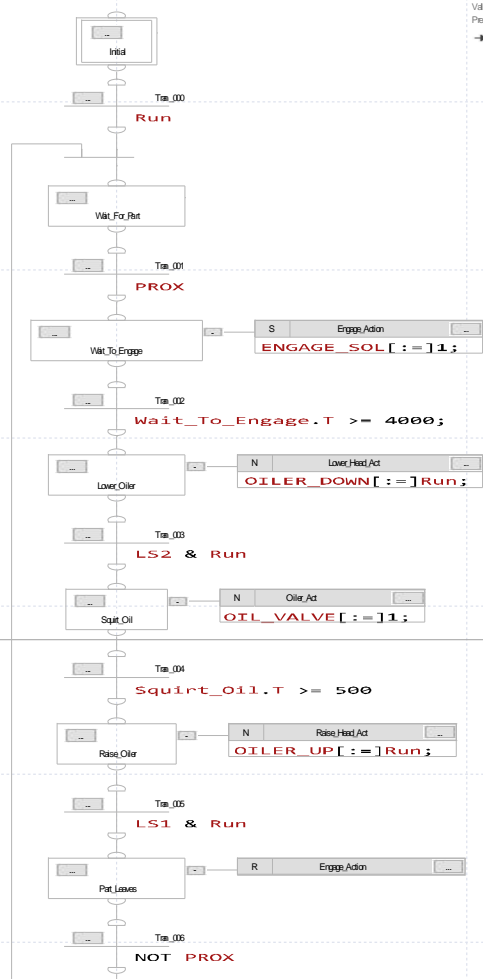
Reset

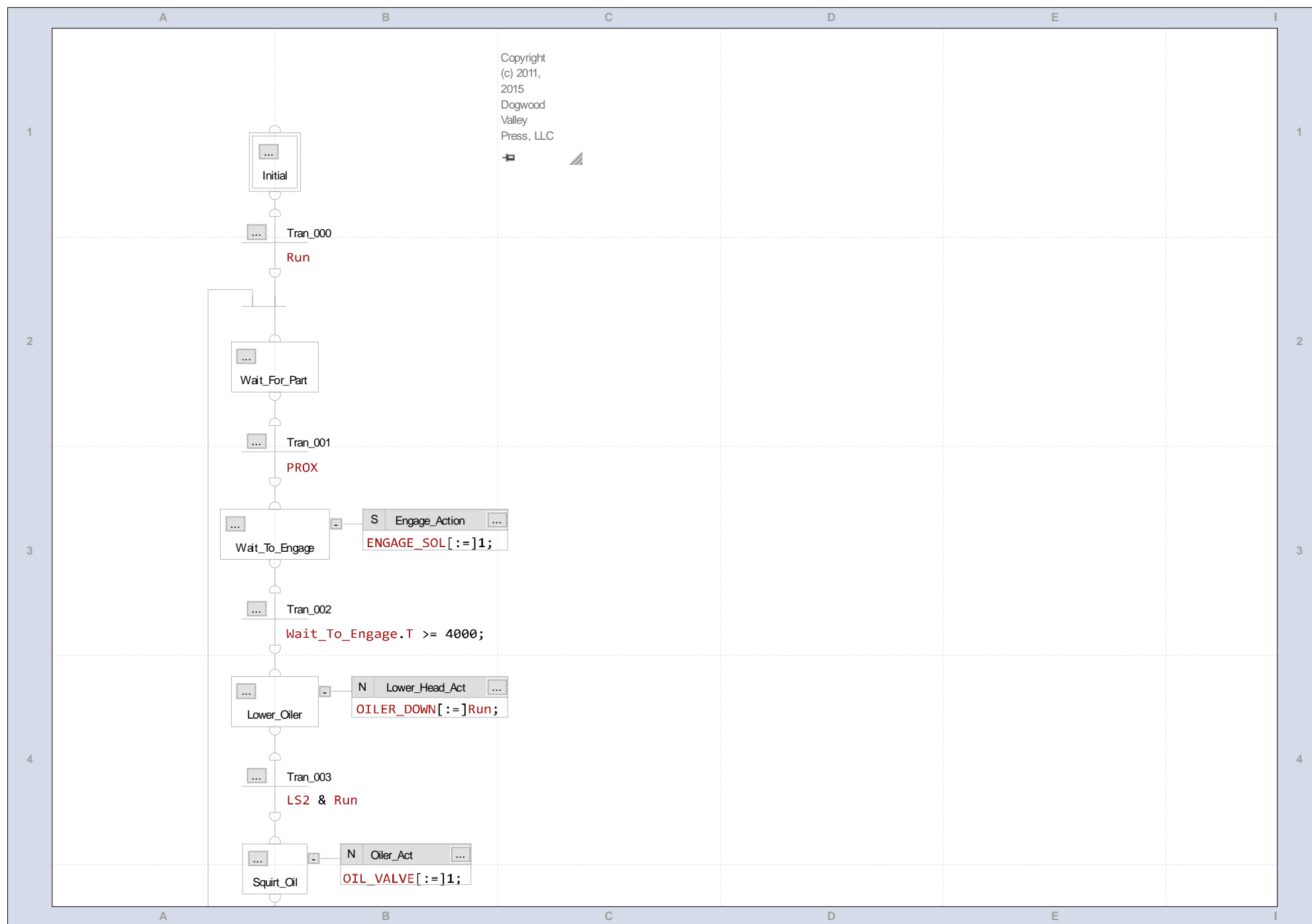


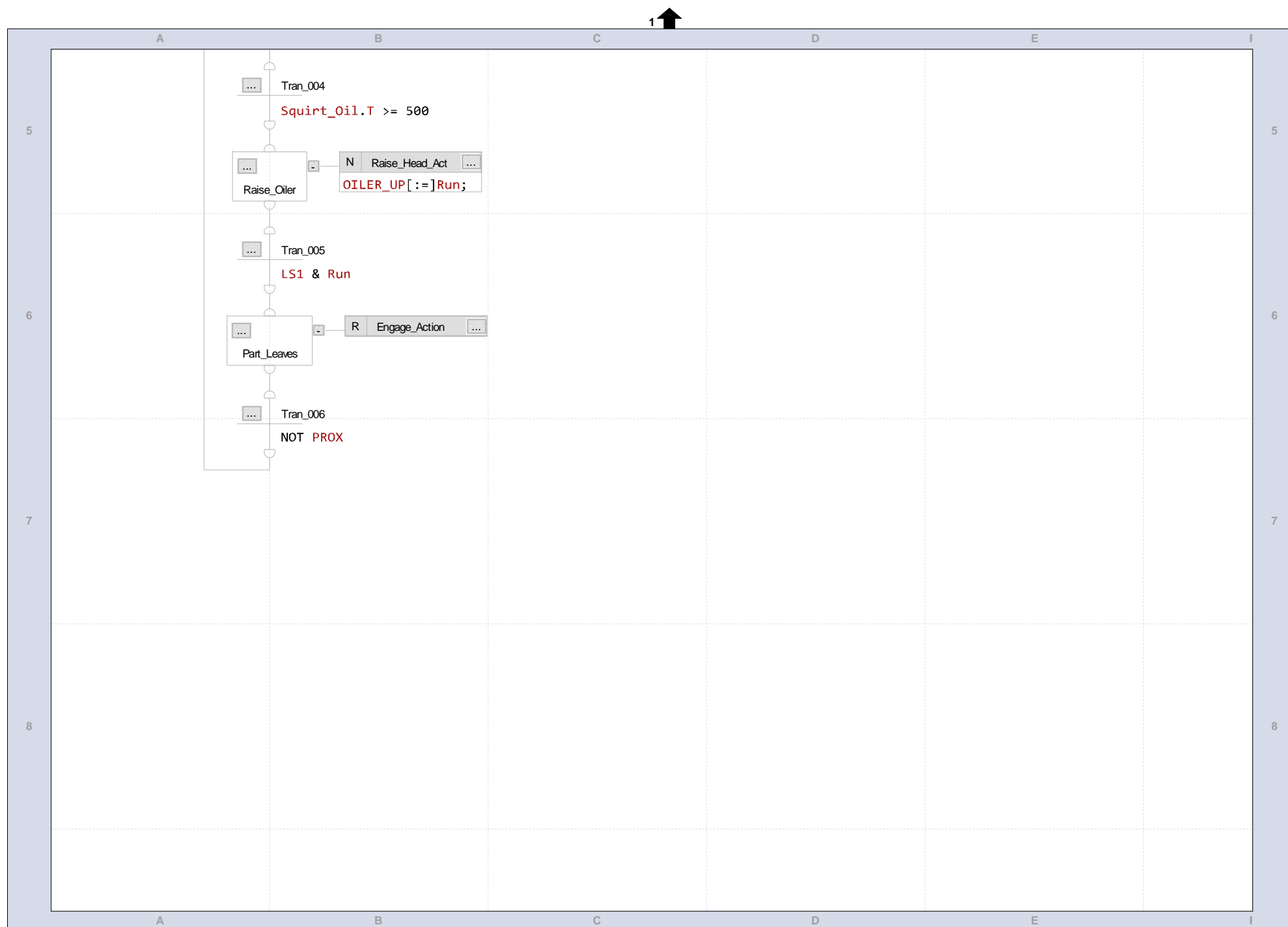
Call function chart

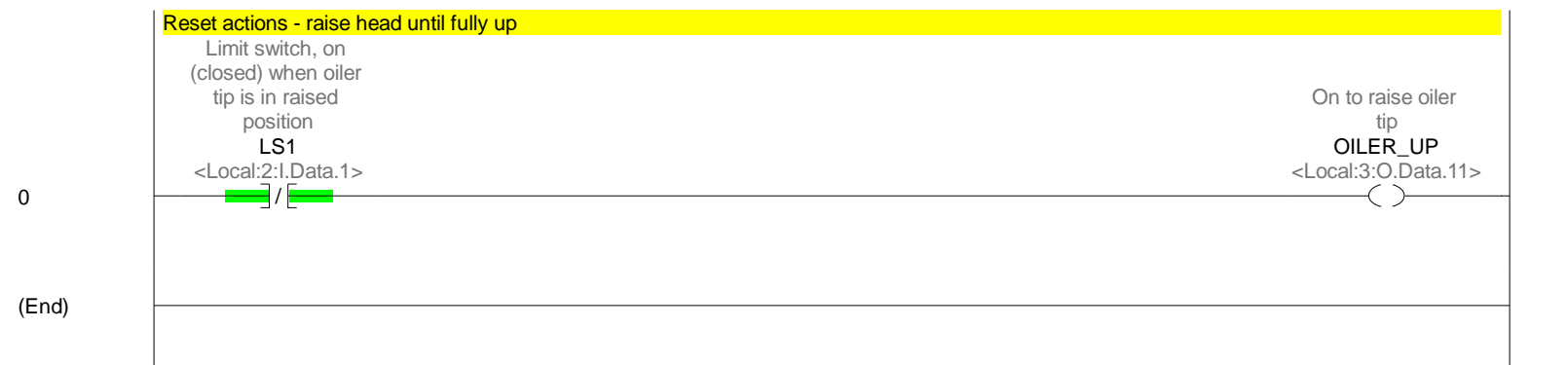


(End)









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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

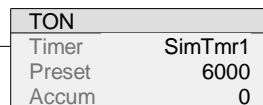
PROX
<Local:2:I.Data.0>

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



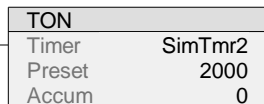
SimTmr1.DN

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>



SimTmr2.DN

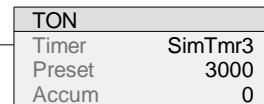
Proximity sensor, on
when platform is in
station

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>



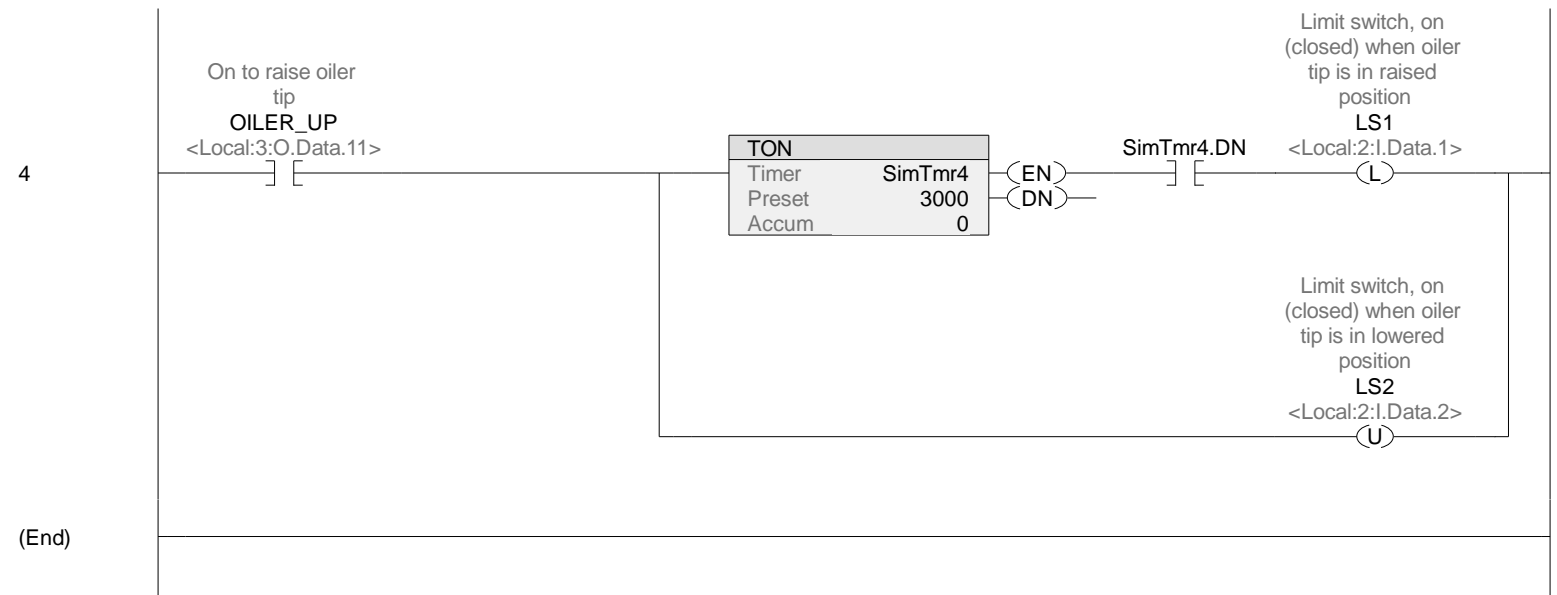
SimTmr3.DN

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>



SP14_01	
Label does not exist	1
MainTask	
MainProgram	
MainRoutine	
Ladder Diagram	2
Part_Oiler	
Sequential Function Chart	3
Reset_Actions	
Ladder Diagram	6
Simulation	
Simulation	
Ladder Diagram	7