









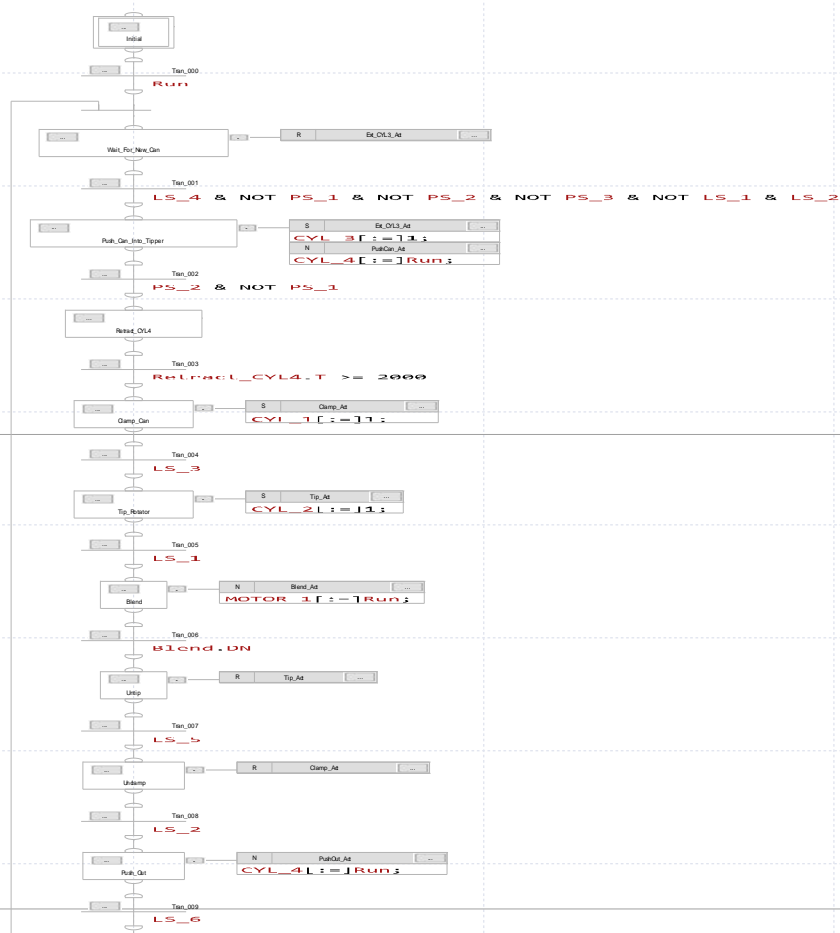
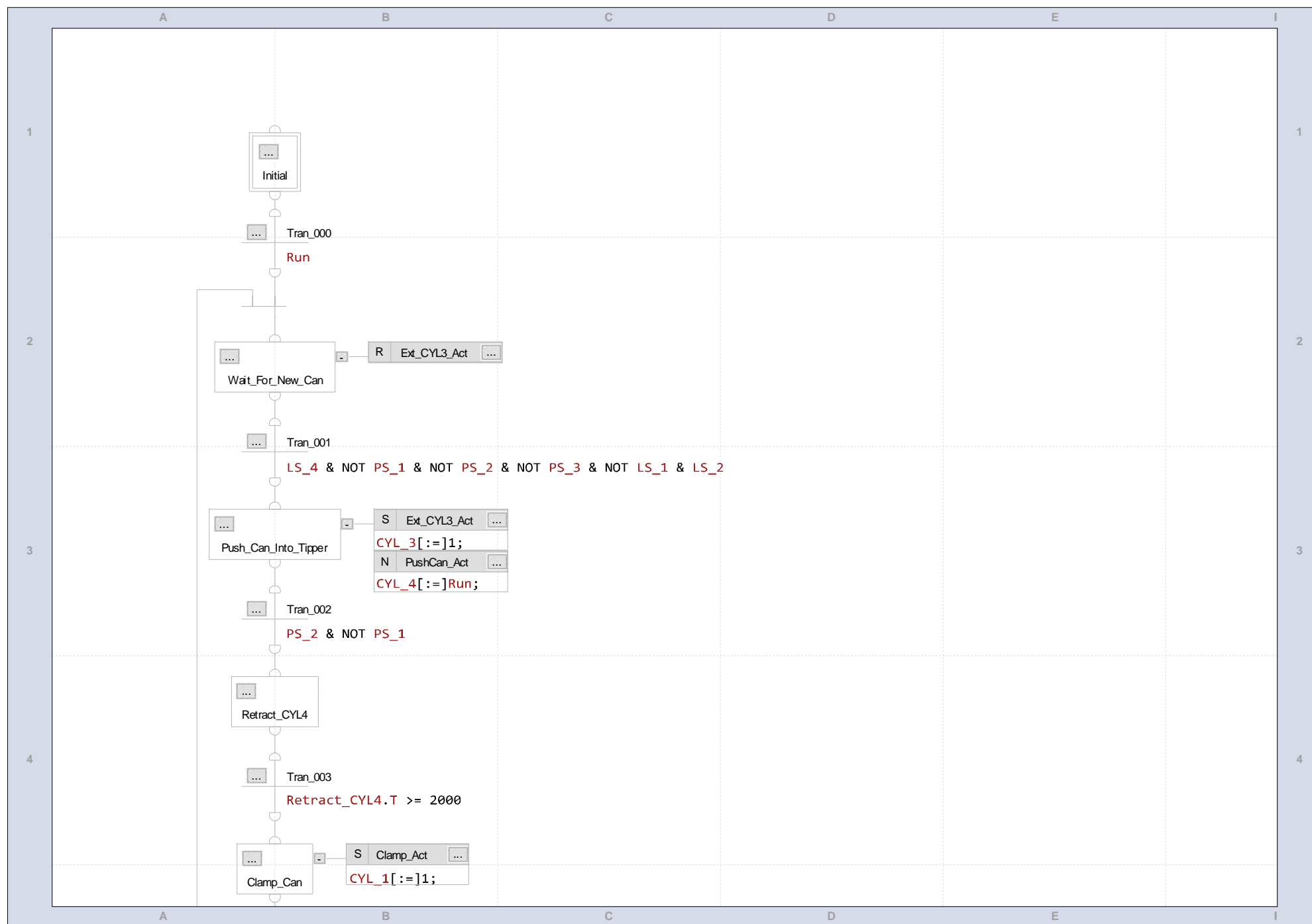
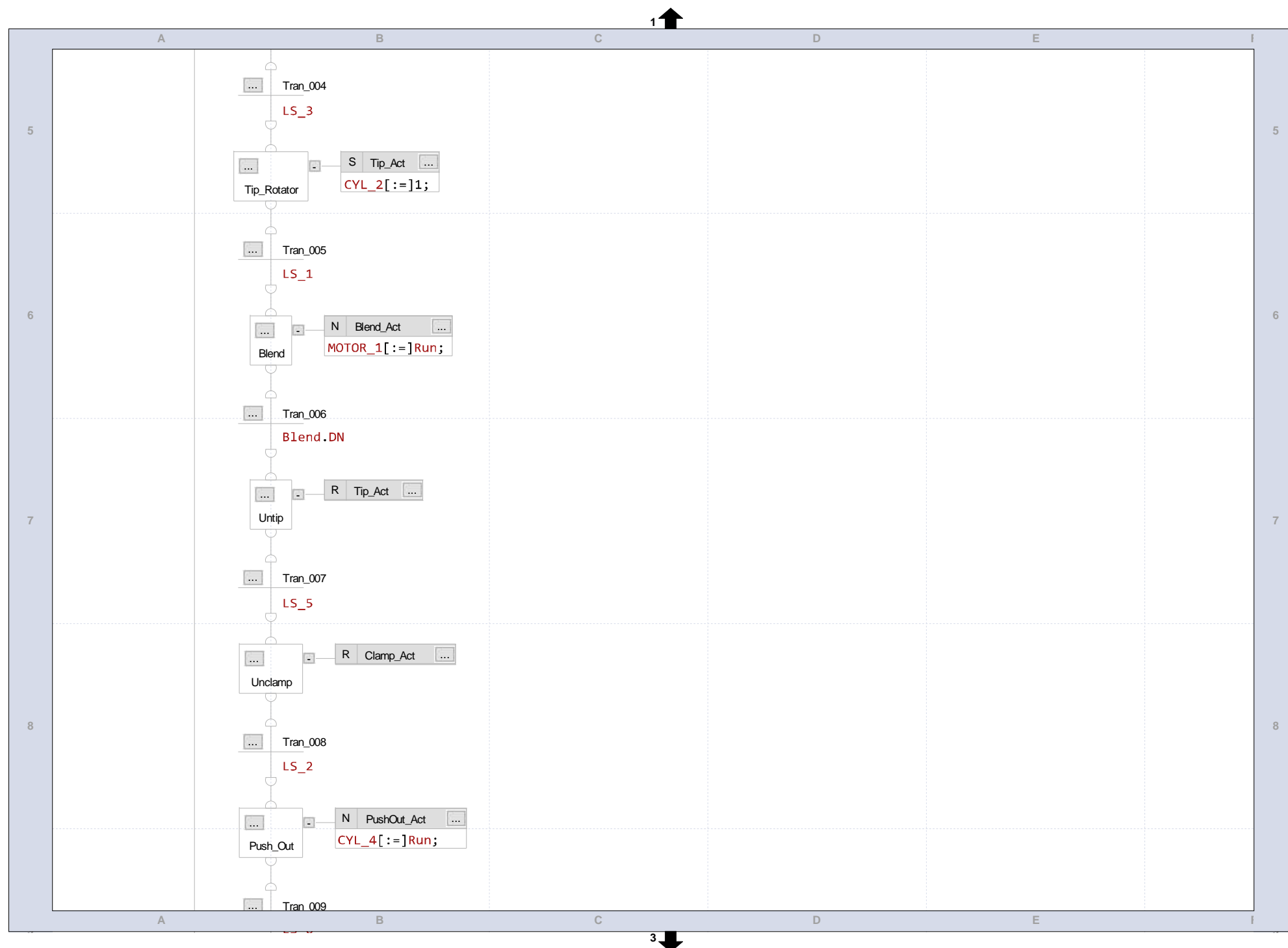
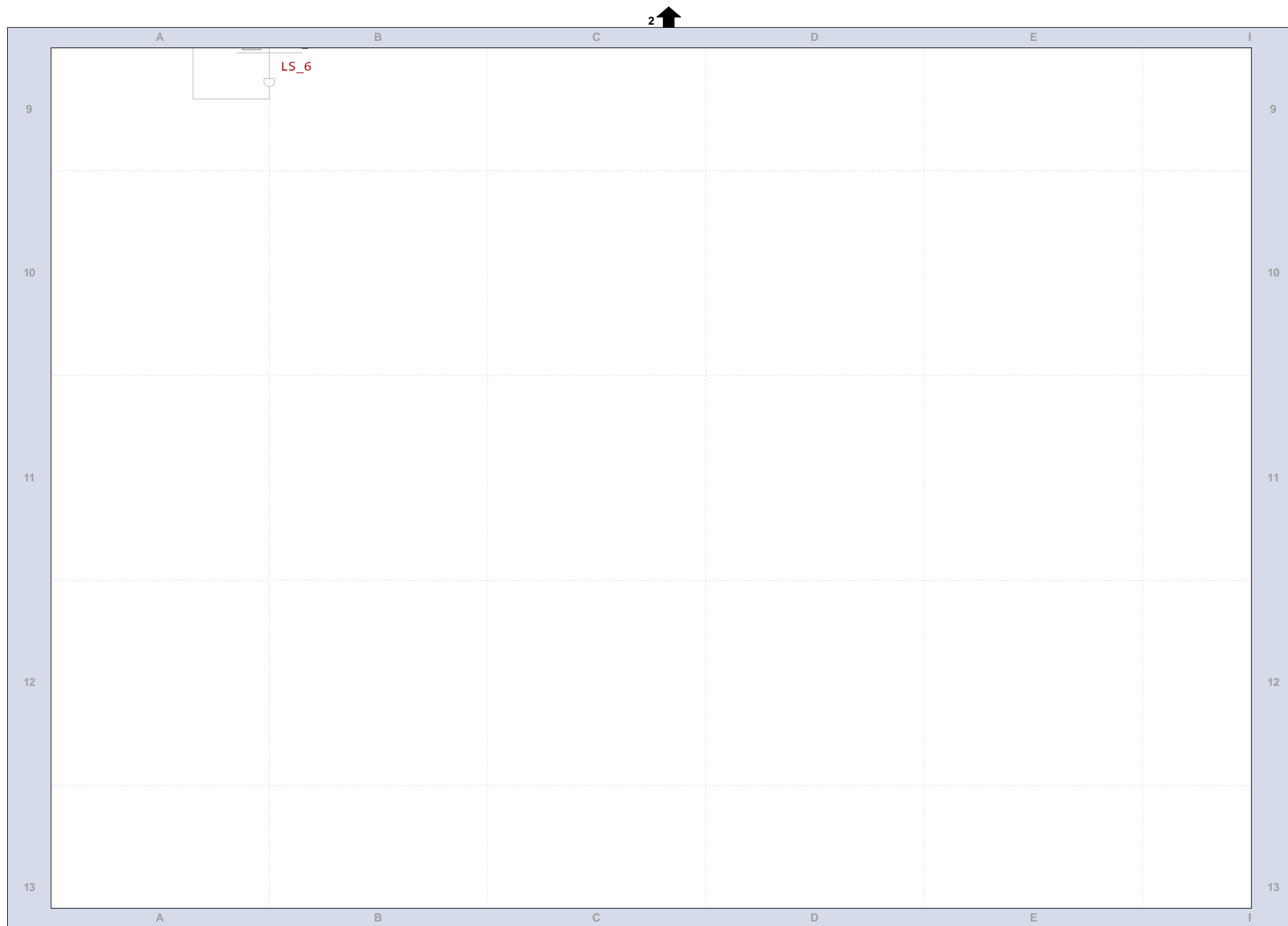


 Controller SP14_03 Controller Fault Handler Power-Up Handler**Tasks** MainTask MainProgram MainRoutine Erbia_Cans Reset_Actions Simulation Simulation Unscheduled**Motion Groups** Ungrouped Axes**Add-On Instructions****Data Types** User-Defined Strings Add-On-Defined Module-Defined AB:1756_DI:C:0 AB:1756_DI:I:0 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_03 [1] 1756-IB32/A discrete_in1 [2] 1756-OB32 discrete_out [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









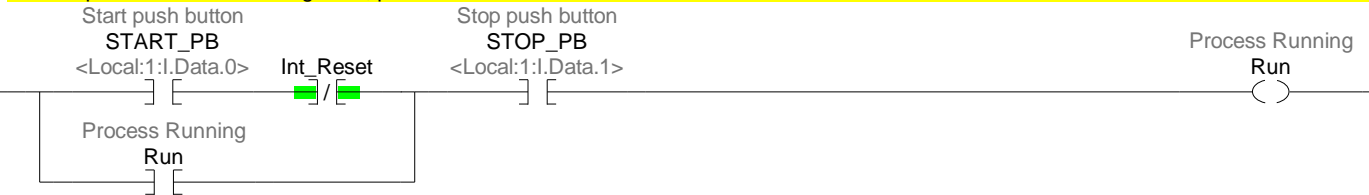
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Erbia Can Tipper/Rotator Control Using SFC - With Simulation

Additional internal memory:

Tag	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Blend_Tmr	TIMER	Times blend

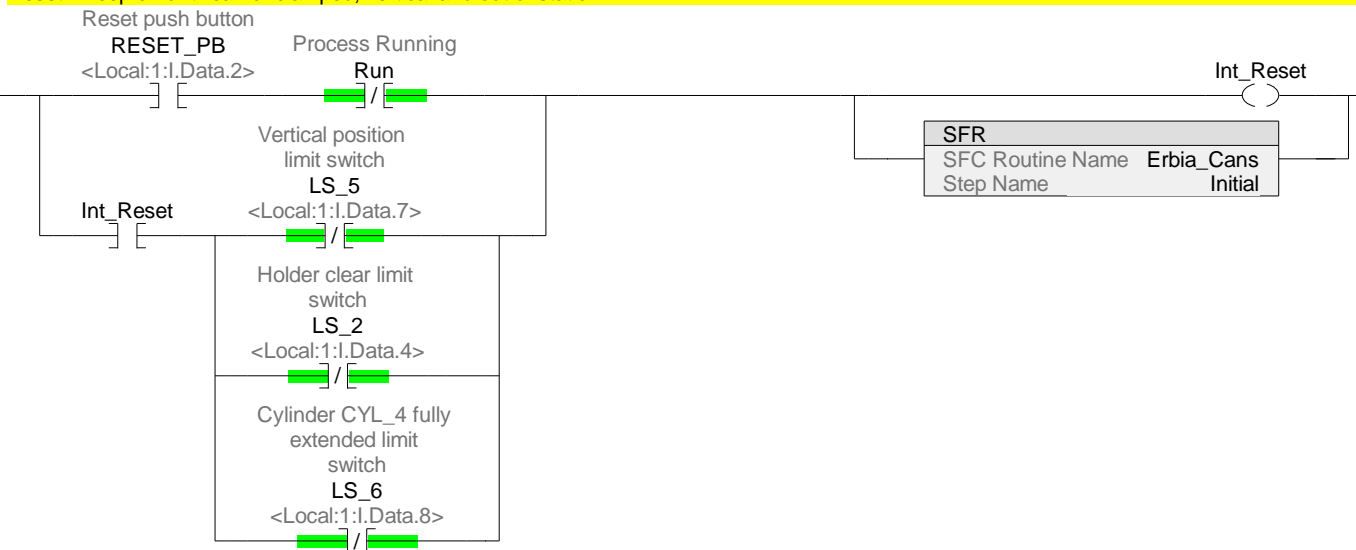
Start/stop and initial start. During reset, prevent start



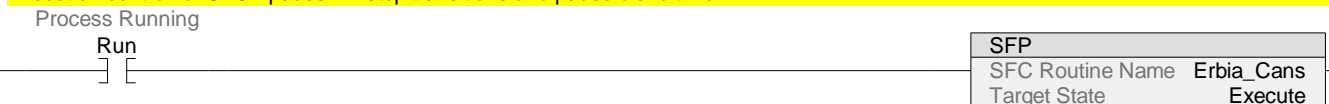
Reset actions - must be called before next rung

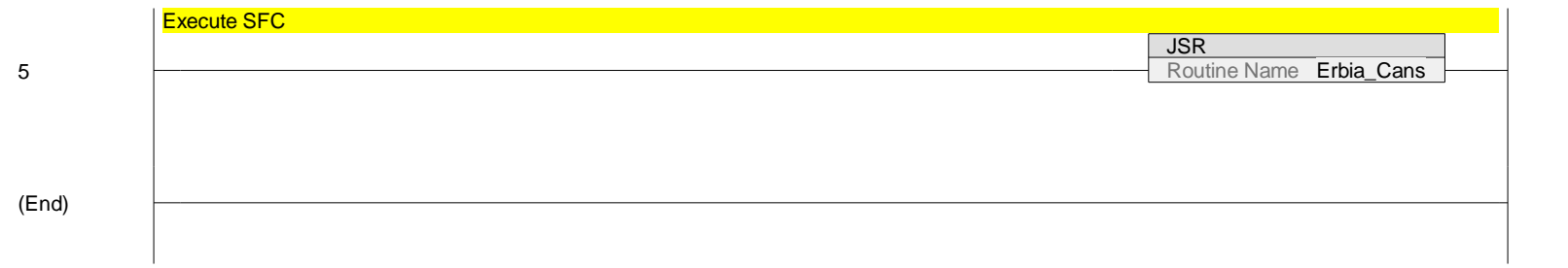


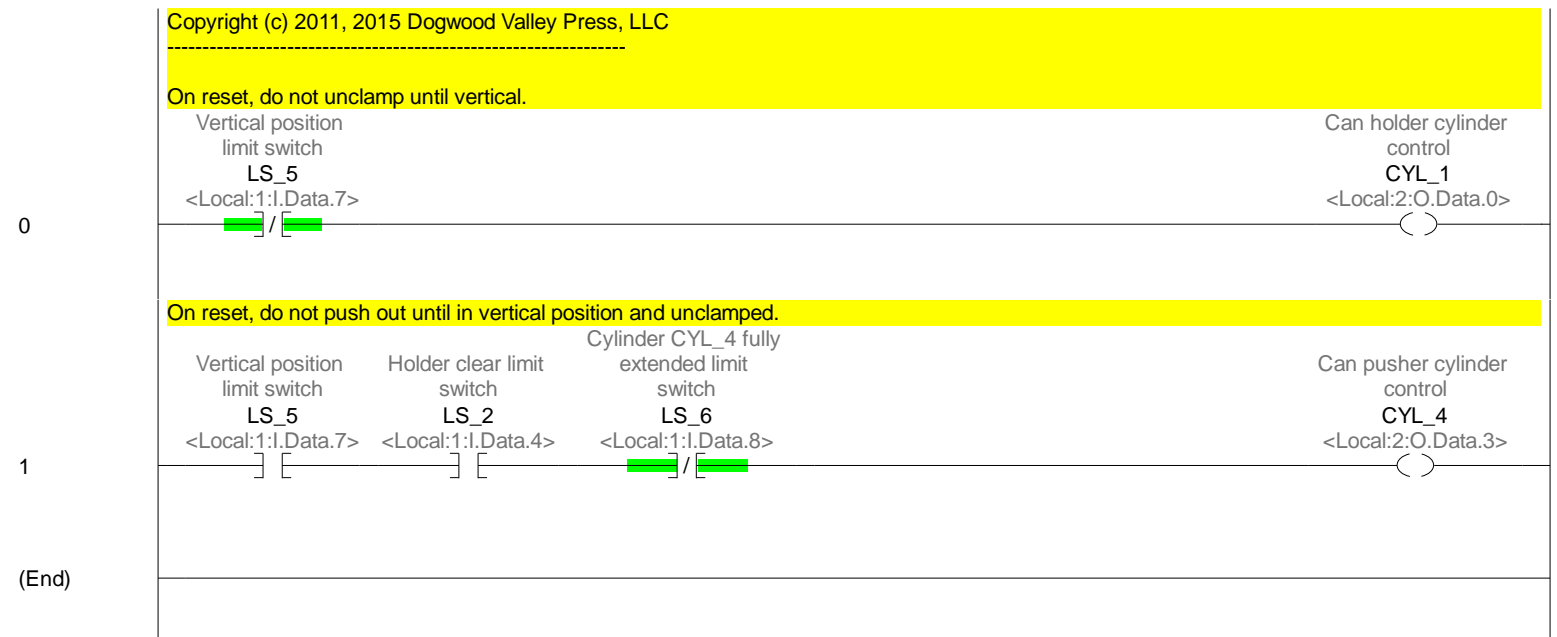
Reset - Keep on until can unclamped, vertical and out of station.



Execution control for SFC - pause will stop transitions and pause blend timer



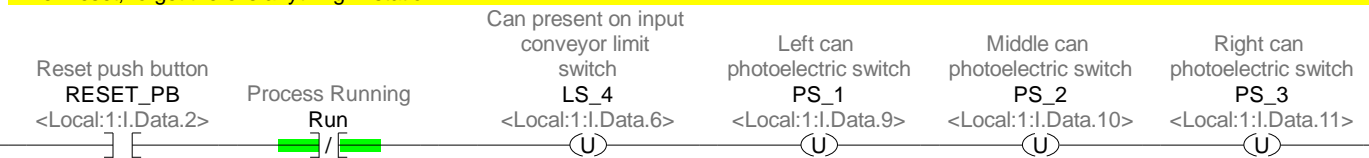




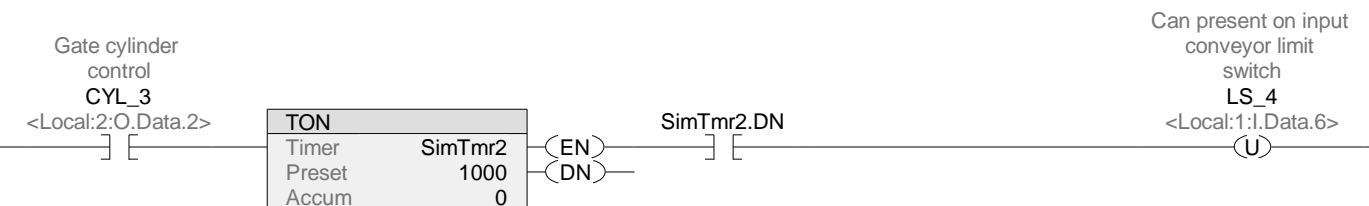
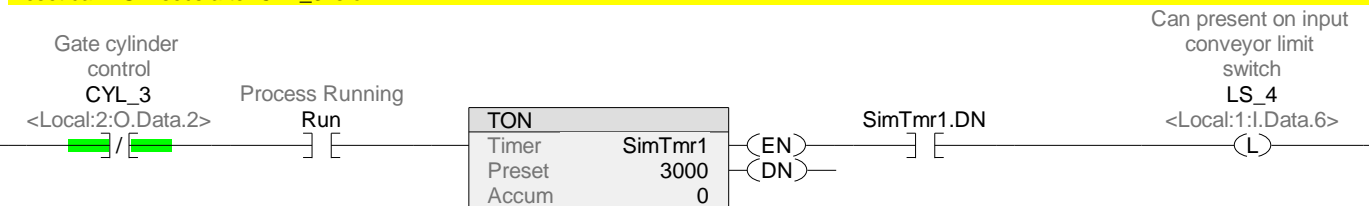
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Erbia Blender Station Simulation

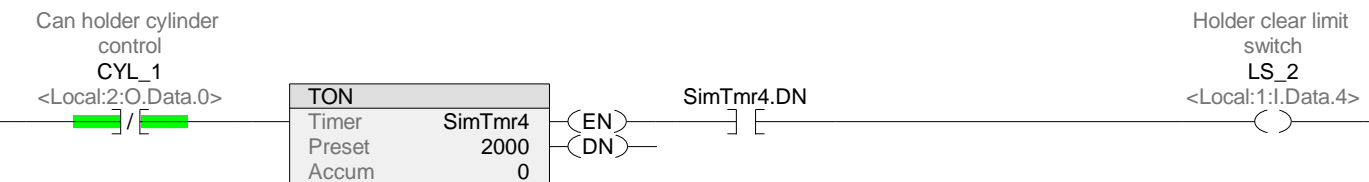
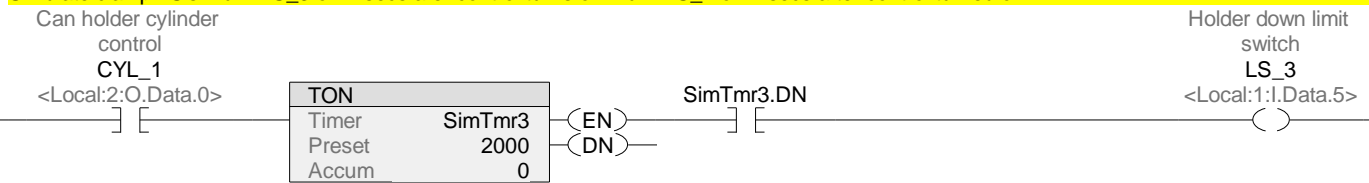
When reset, forget there is anything in station



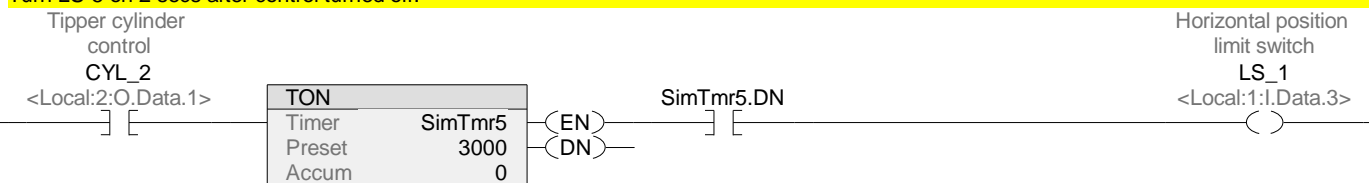
Simulate next can by delaying 5 seconds after CYL_3 is off and running.
Reset can LS 2 secs after CYL_3 is on.

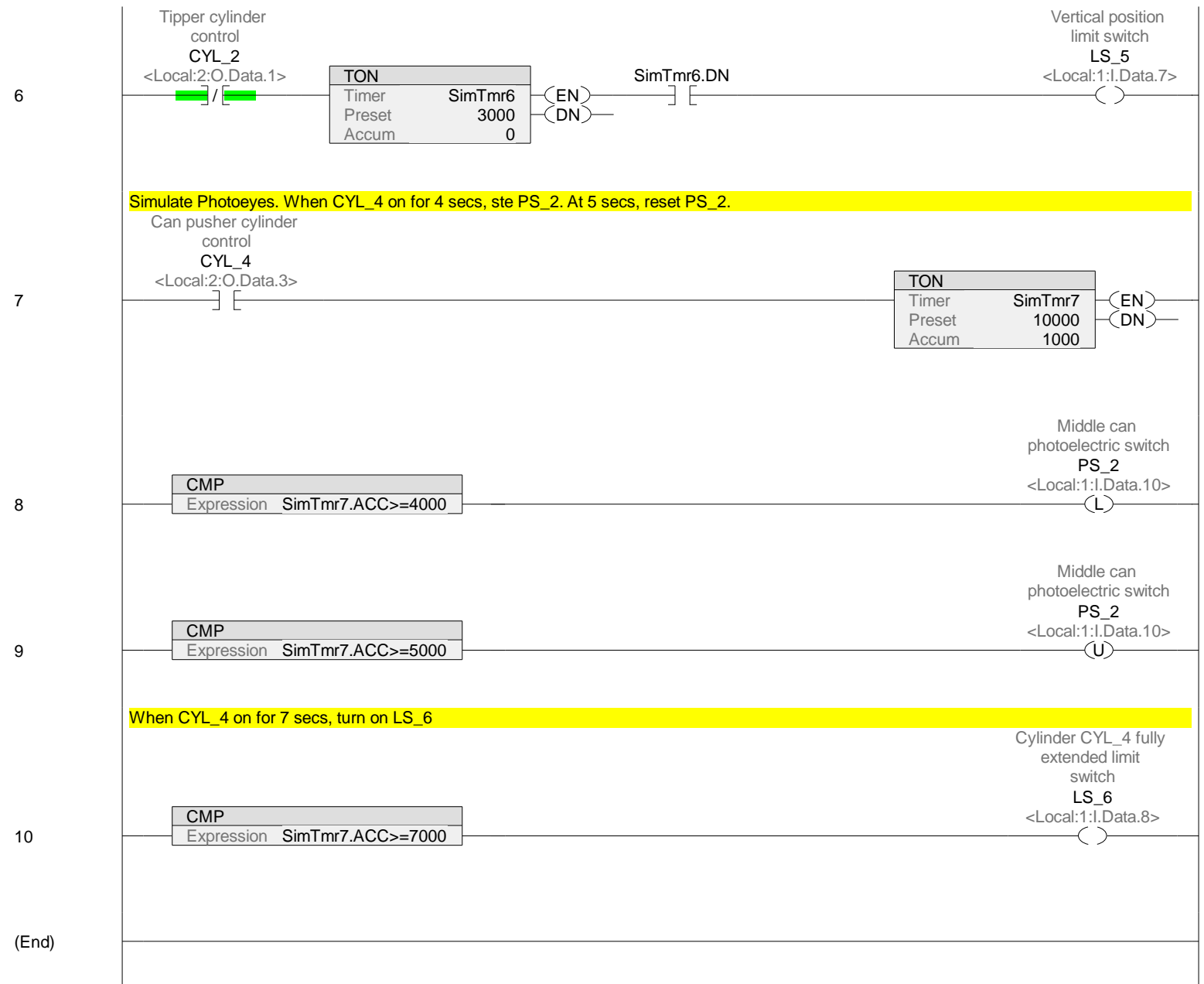


Simulate clamp LS's. Turn LS_3 on 2 secs afer control turns on. Turn LS_2 on 2 secs after control turned off.



Simulate tipper LS's. Turn LS_1 on 2 secs after control turned on.
Turn LS-5 on 2 secs after control turned off.





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