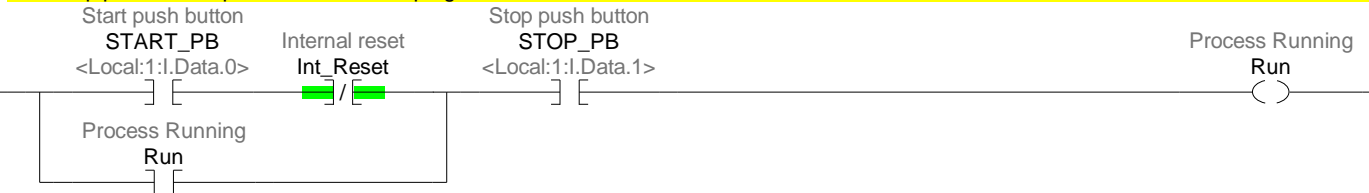


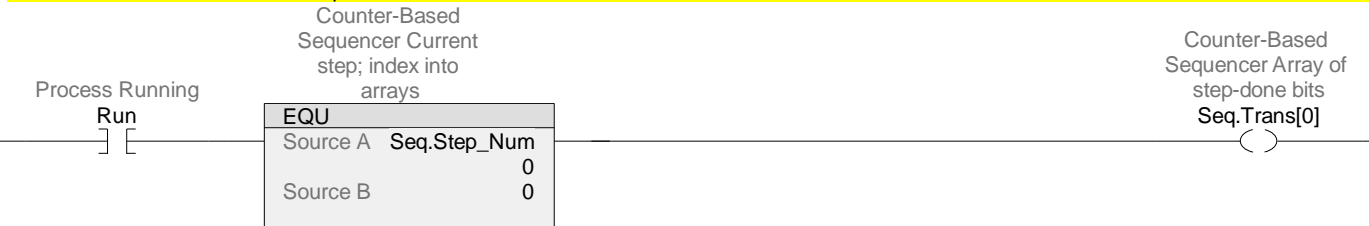
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Erbia Tipper/Rotator with counter-based sequencer

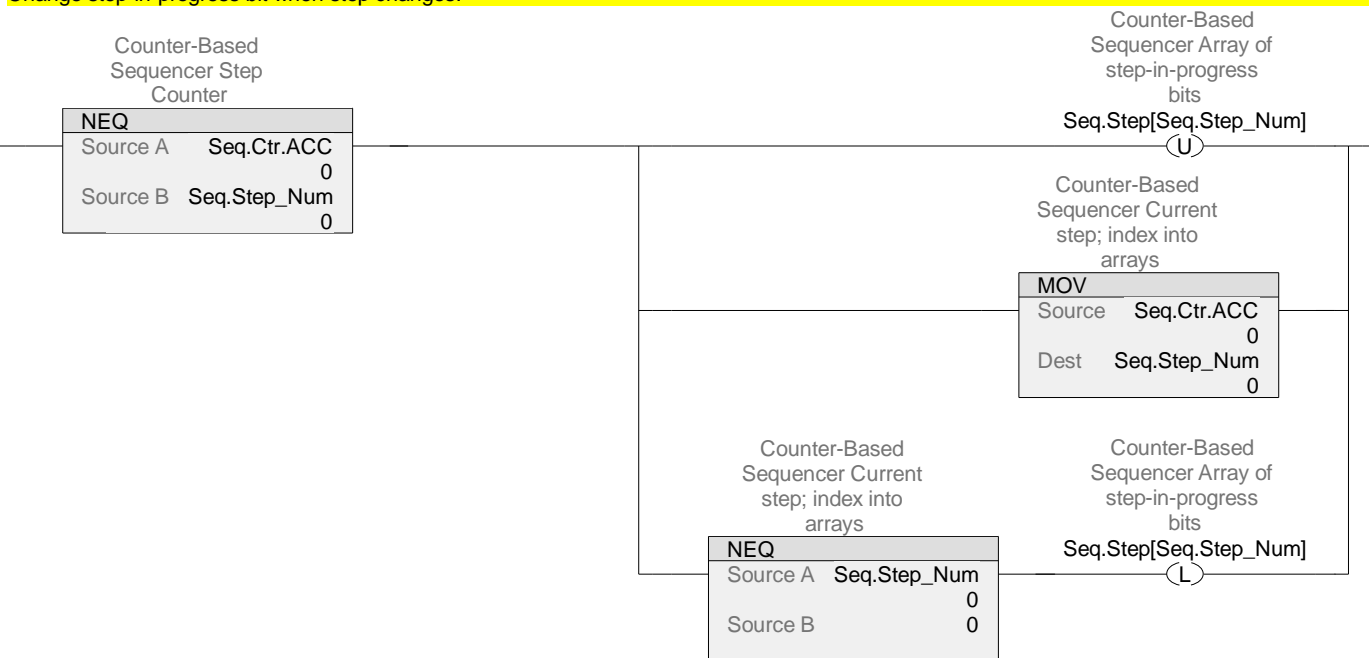
Start/stop/pause. Start prevented if reset in progress.



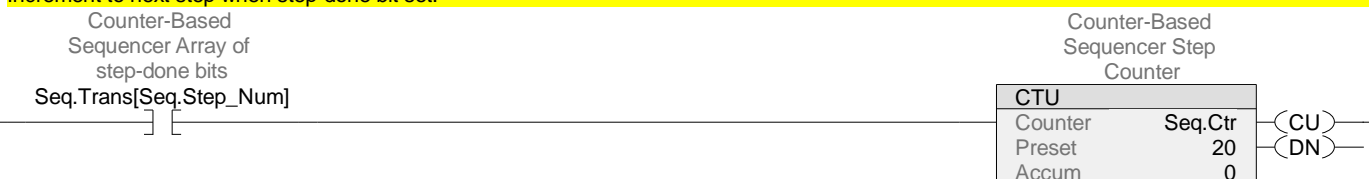
Generate transition out of initial step



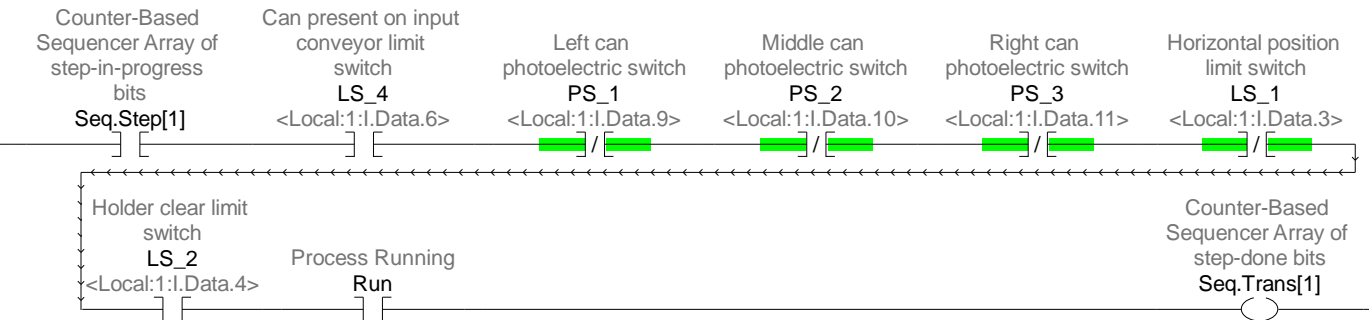
Change step-in-progress bit when step changes.



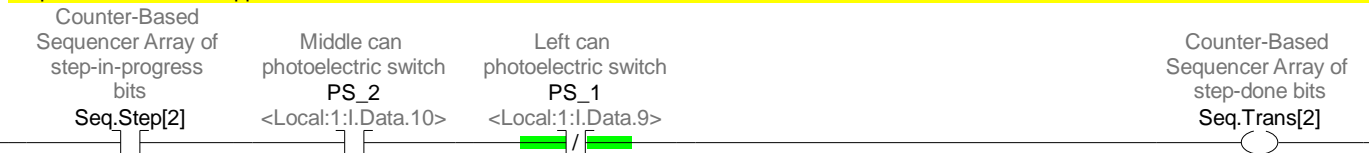
Increment to next step when step-done bit set.



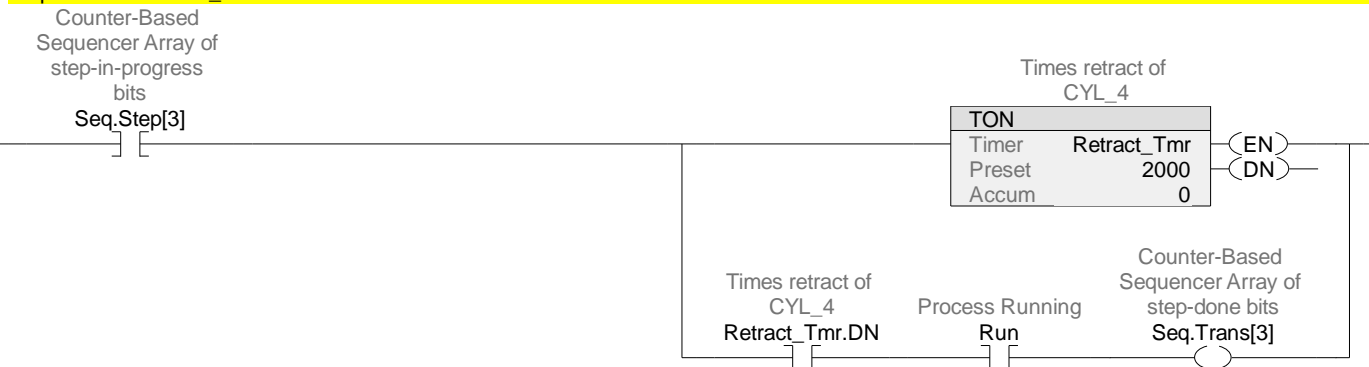
Step 1 - Wait for can.



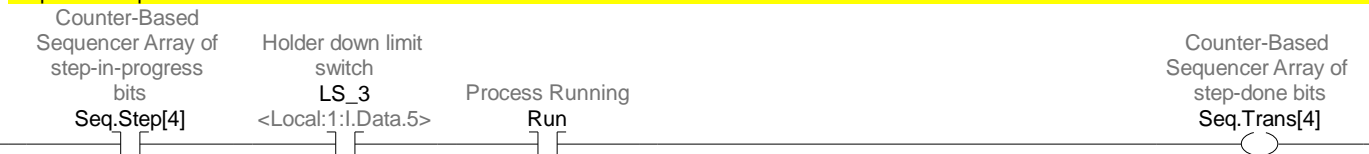
Step 2 - Push can into tipper.



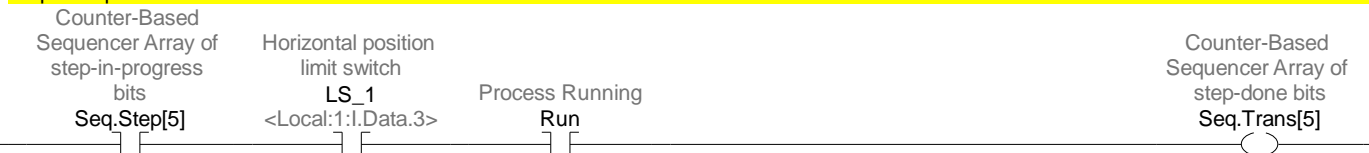
Step 3 - Wait for CYL_4 to retract.



Step 4 - Clamp Can.

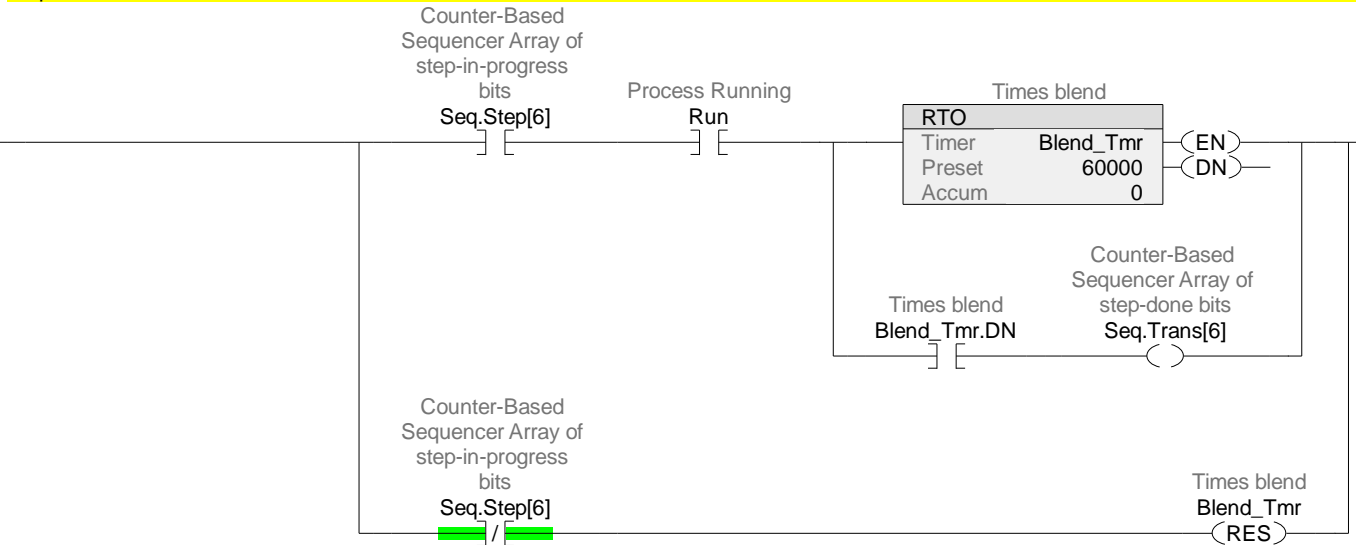


Step 5 - Tip rotator.



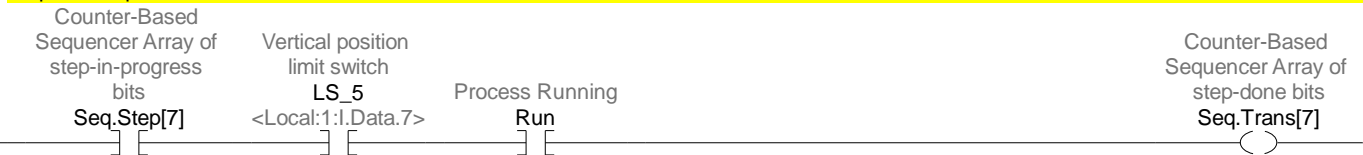
9

Step 6 - Blend.



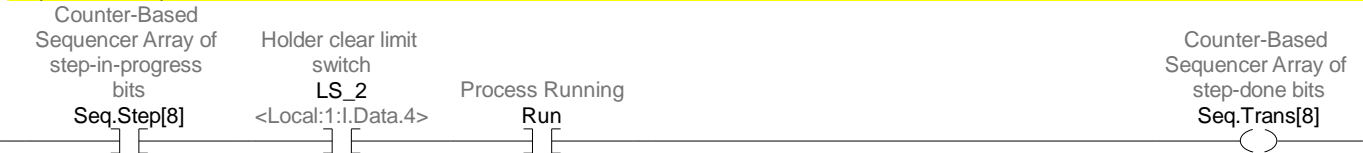
10

Step 7 - Untip



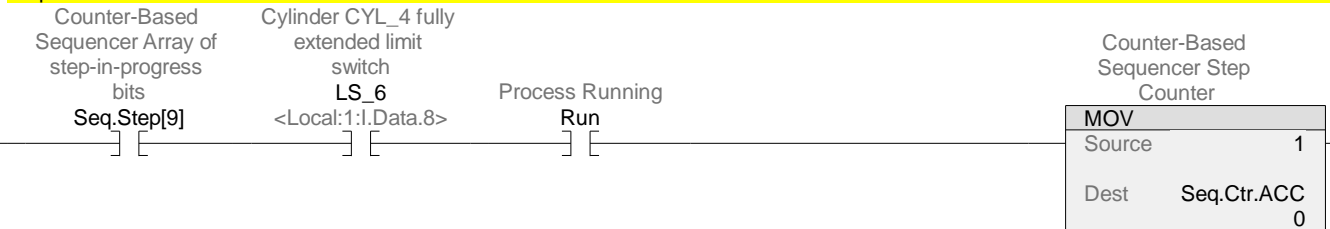
11

Step 8 - Unclamp



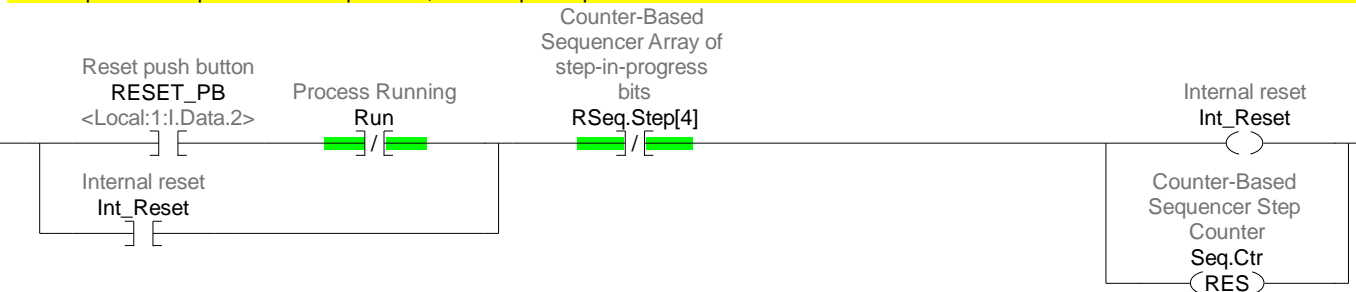
12

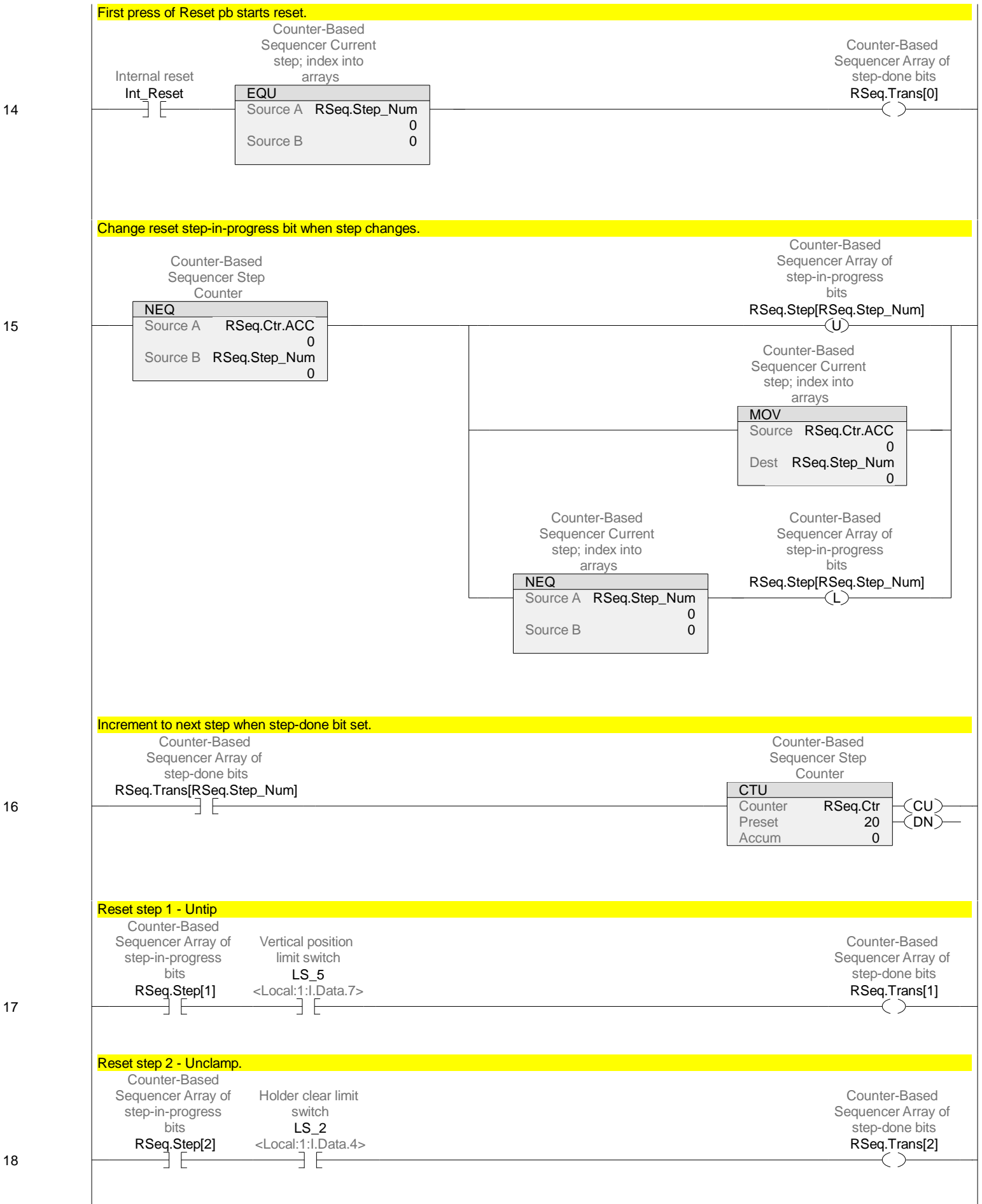
Step 9 - Push out.

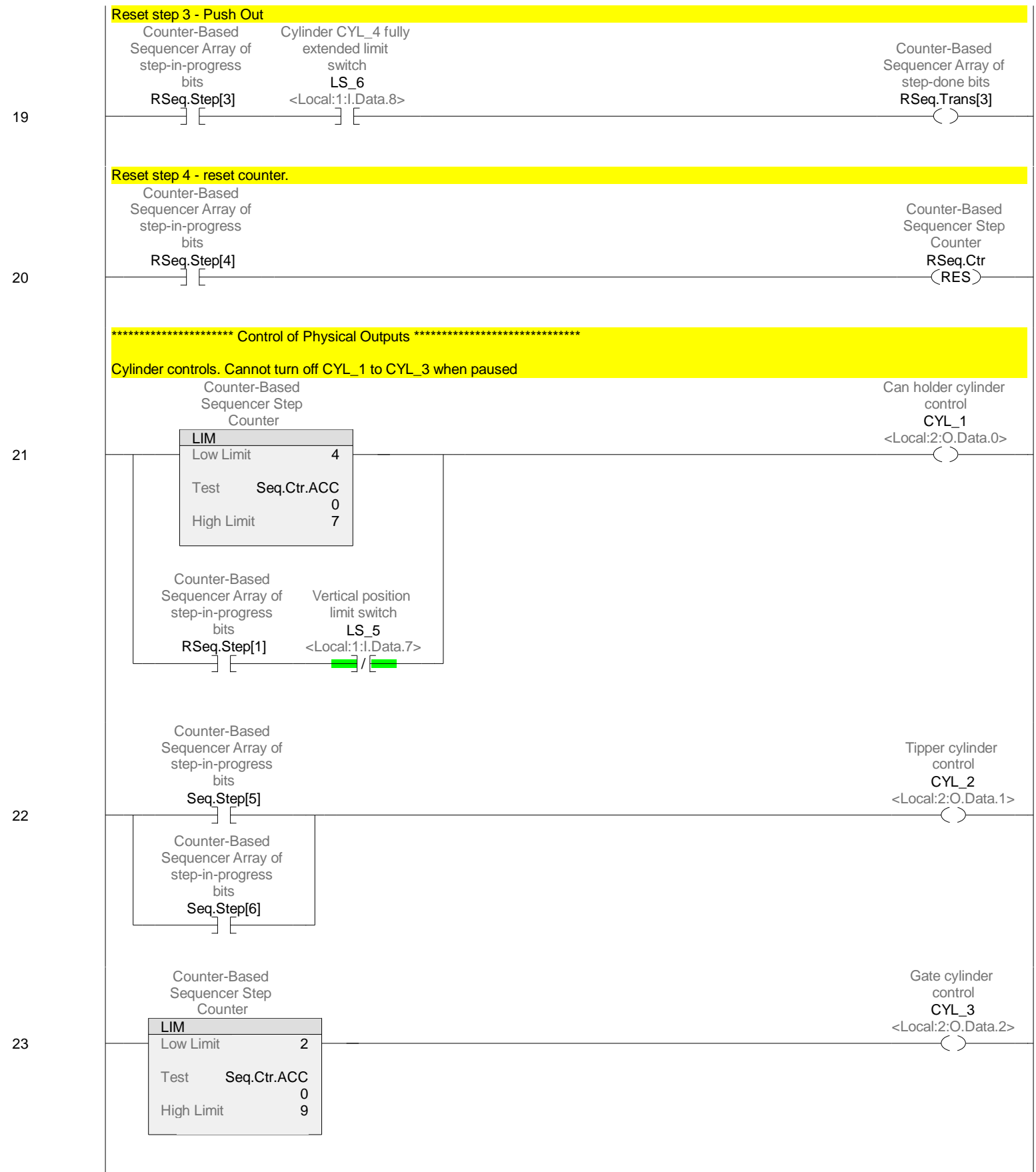


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Start/stop for reset operation. Reset pb starts, reset step 4 stops it.

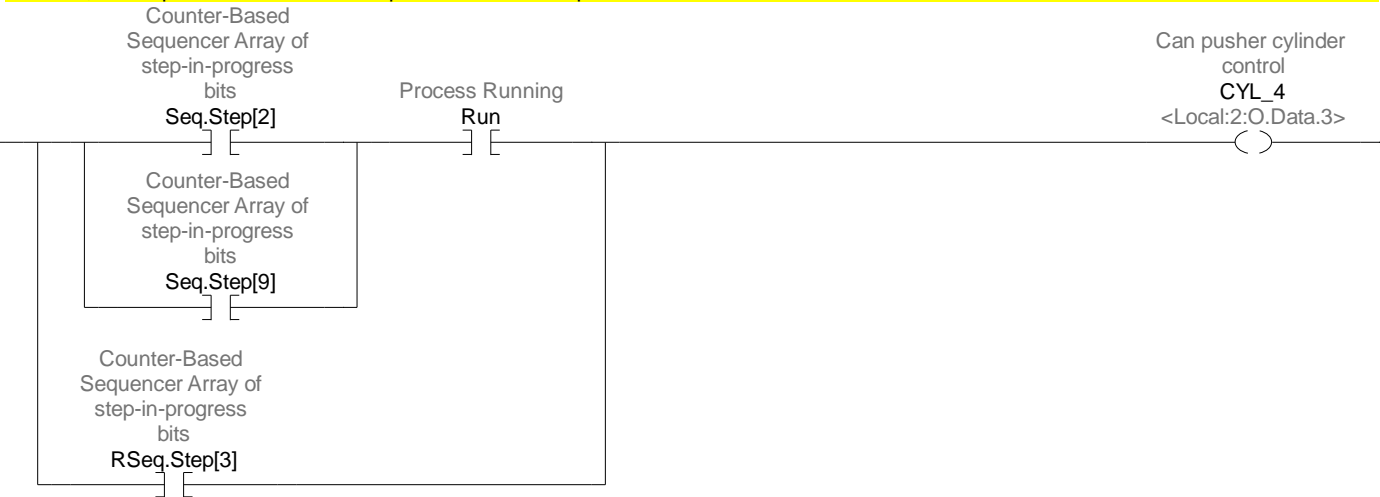






On reset, do not push out until in vertical position and unclamped

24



25



(End)