













 Controller SP21_03 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_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

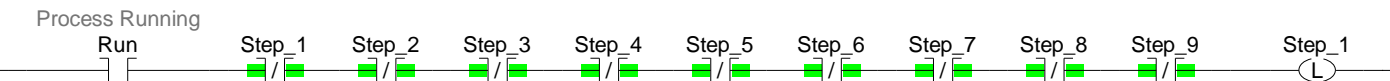
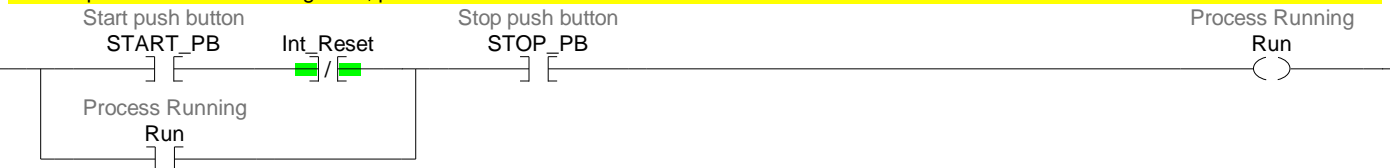
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Erbia Can Tipper/Rotator Control - With Simulation

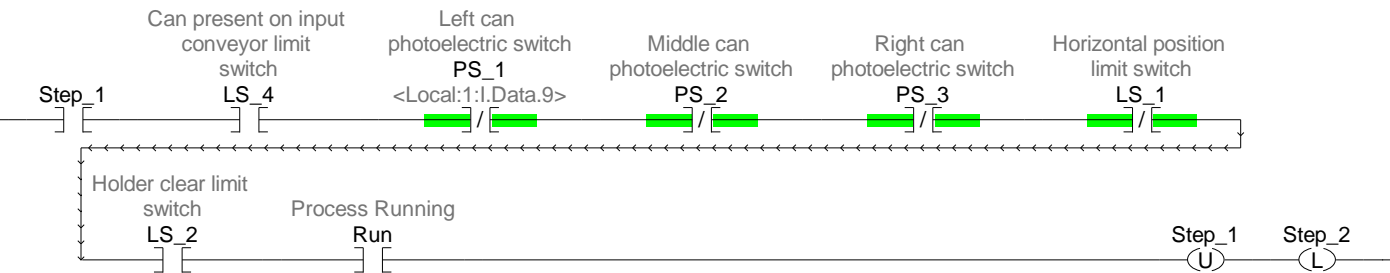
Additional internal memory:

Tag	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Step_1 to Step_9	BOOL	Step-in-progress bits
Retract_Tmr	TIMER	Times retract of CYL_4
Blend_Tmr	TIMER	Times blend

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



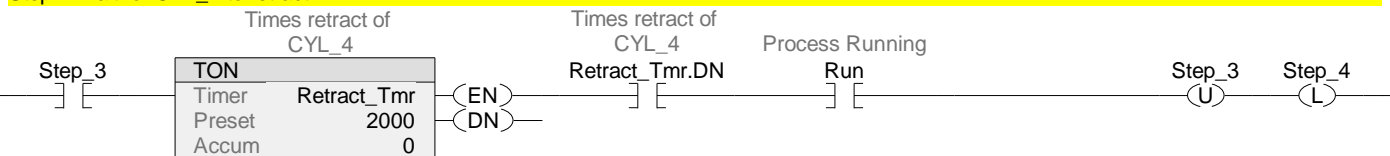
Step 1 Wait for can



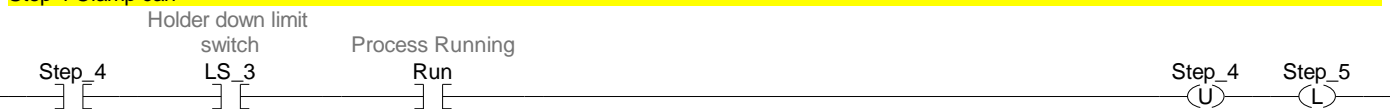
Step 2 Push can into tipper



Step 2 Wait for CYL_4 to retract



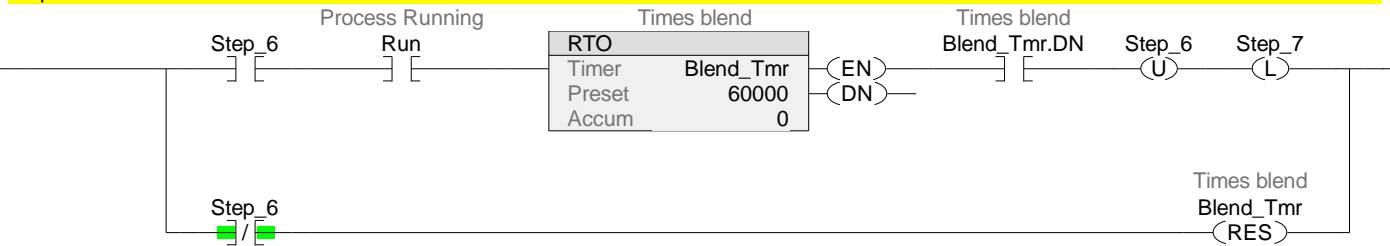
Step 4 Clamp can



Step 5 Tip rotator



Step 6 Blend



Step 7 Untip



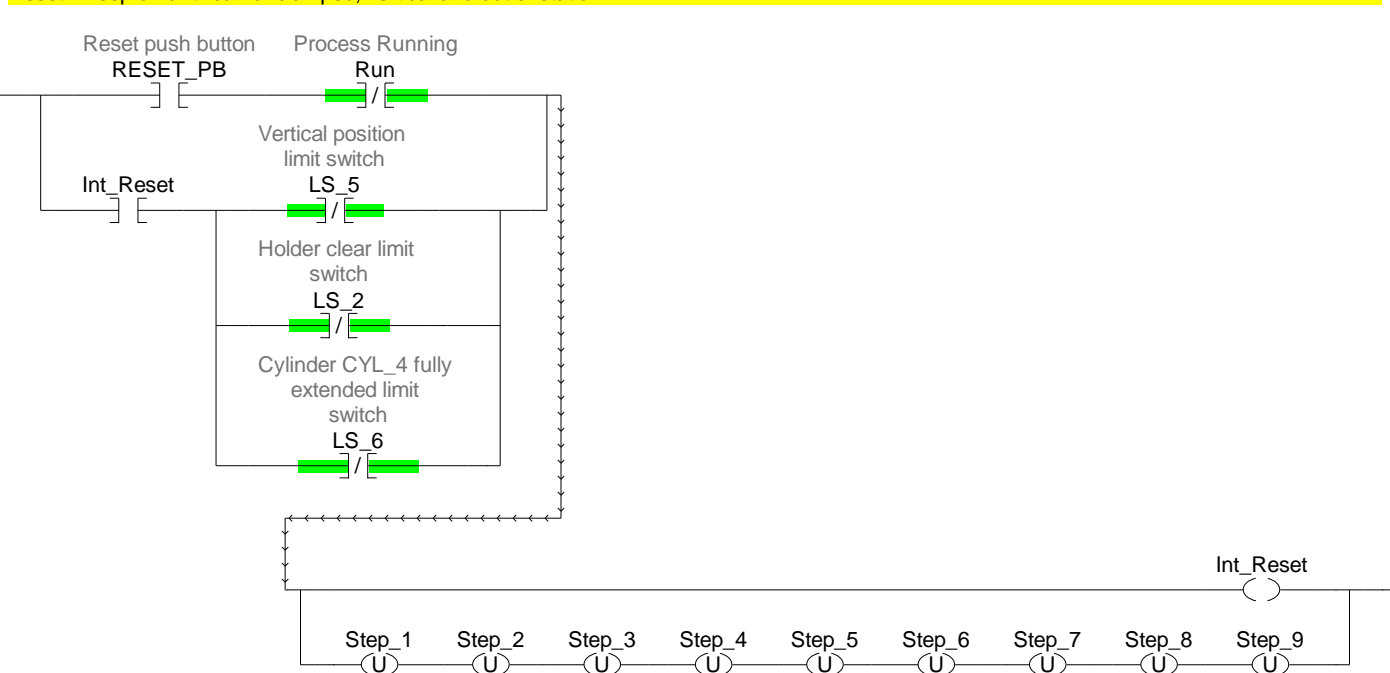
Step 8 Unclamp



Step 9 Push Out



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



Physical Outputs

Cannot turn off CYL_1 to CYL_3 when paused.

On reset, do not unclamp until vertical.

Can holder cylinder
control
CYL_1
<Local:2:O.Data.0>

Step_4

Step_5

Step_6

Step_7

Vertical position
limit switch

Int_Reset

LS_5

Tipper cylinder
control
CYL_2
<Local:2:O.Data.1>

Step_5

Step_6

Gate cylinder
control
CYL_3
<Local:2:O.Data.2>

Step_2

Step_3

Step_4

Step_5

Step_6

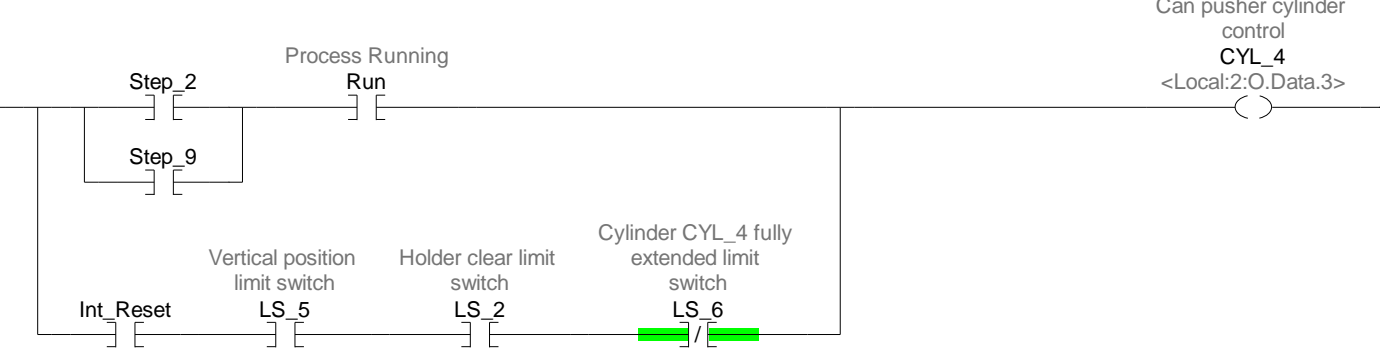
Step_7

Step_8

Step_9

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

15



16

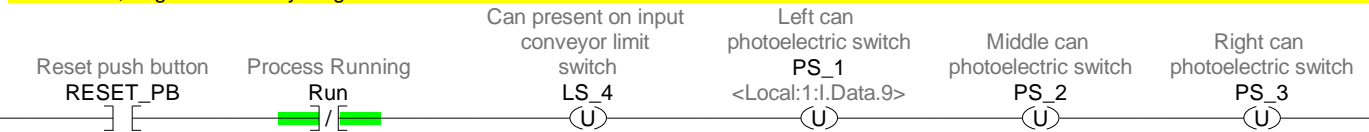


(End)

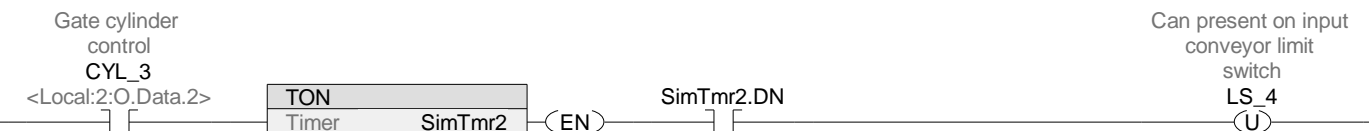
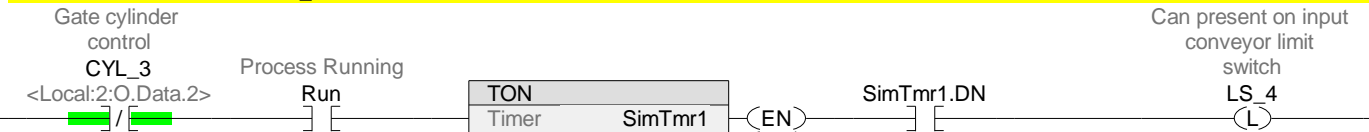
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Erbia Blender Station Simulation

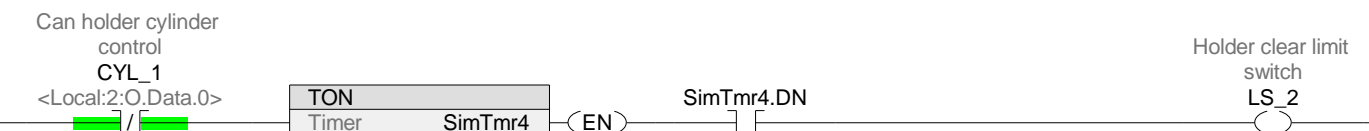
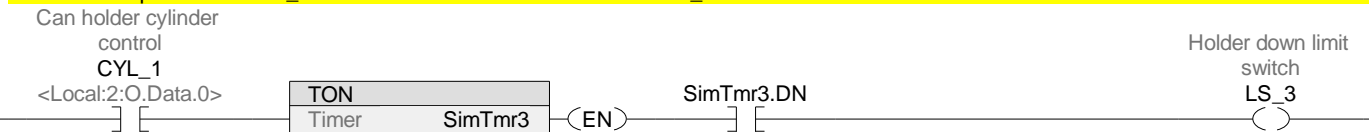
When reset, forget there is anything in station



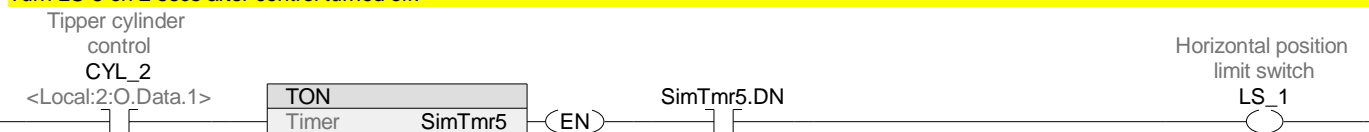
Simulate next can by delaying 5 seconds after CYL_3 is off and running.
Reset can LS 2 secs after CYL_3 is on.

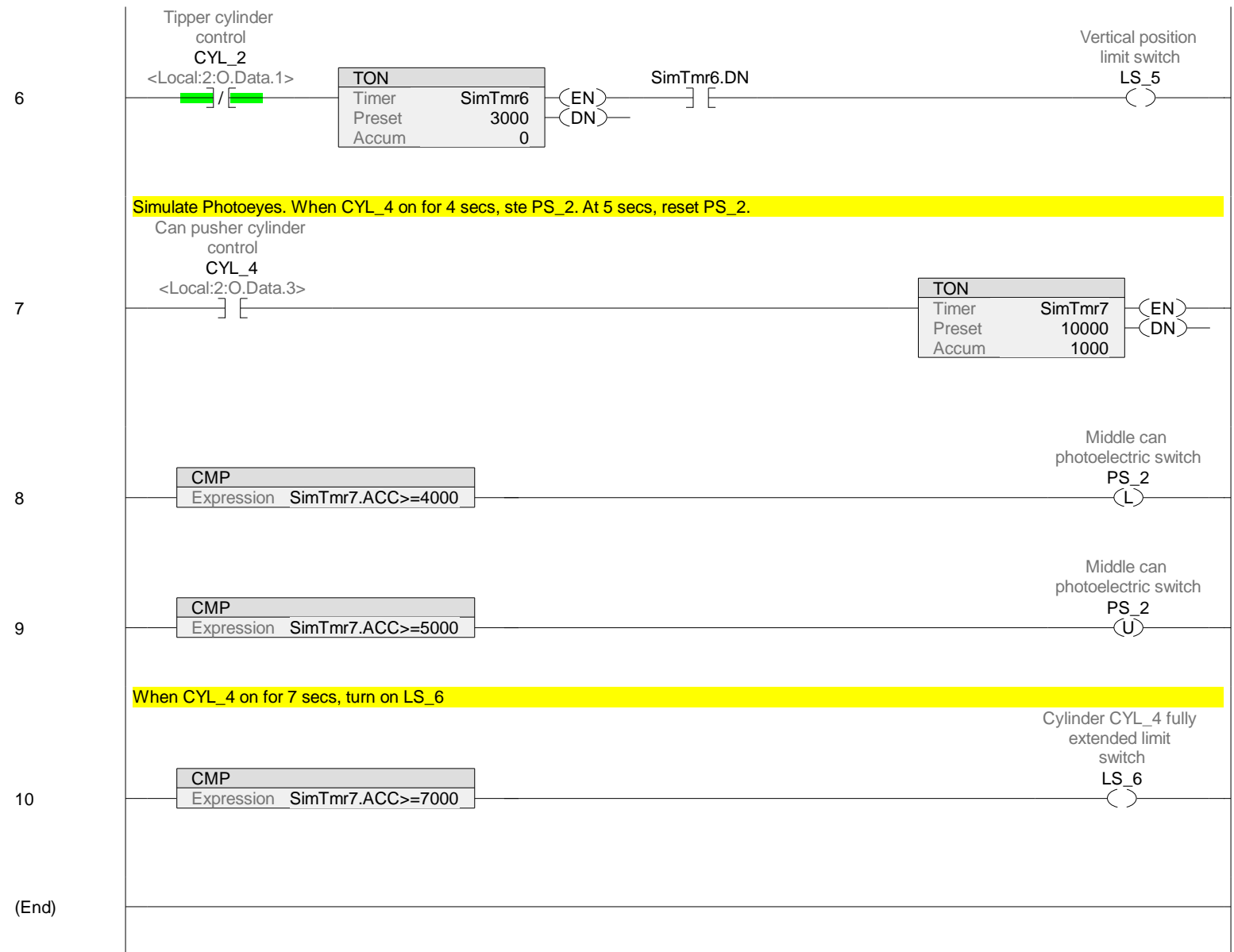


Simulate clamp LS's. Turn LS_3 on 2 secs afer control turns on. Turn LS_2 on 2 secs after control turned off.



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





SP21_03	
Label does not exist	1
MainTask	
MainProgram	
MainRoutine	
Ladder Diagram	2
Simulation	
Simulation	
Ladder Diagram	6