1 Copyright (c) 2011 Dogwood Valley Press, LLC. Copying and posting without permission strictly prohibited.

2

3 Erbia Can Blender Control - With Simulation

4 Additional internal variable declarations:

Variables	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Step_1 to Step_9	BOOL	Step-in-progress bits
Blend_Tmr	INT[3]	Times blend step (retentive)
Retract_Tmr	TON	Times retract of CYL_4

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

6 START_PB Int_Reset STOP_PB Run M
Run

7 Run Step_1 Step_2 Step_3 Step_4 Step_5 Step_6 Step_7 Step_8 Step_9 Step_1 S

8 Step 1 Wait for can

9 Step_1 LS_4 PS_1 PS_2 PS_3 LS_1 LS_2 Run Step_1 R
Step_2 S

10 Step 2 Push can into tipper.

11 Step_2 PS_2 PS_1 Step_2 R
Step_3 S

12 Step 3 Wait for CYL_4 to retact

13 TON
Step_3 Retract... IN Q Run Step_3 R
2000 PT ET Step_4 S

14 Step 4 Clamp can

15 Step_4 LS_3 Run Step_4 R
Step_5 S

16 Step 5 Tip rotator

17 Step_5 LS_1 Run Step_5 R
Step_6 S

18 Step 6 Blend

19 Step_6 Run ONDTR TENTHS Step_6 R
Step_6 Blend_... R Step_7 S
600 PV CV

20 Step 7 Untip

21 Step_7 LS_5 Run → Step_7 (R), Step_8 (S)

22 Step 8 Unclamp

23 Step_8 LS_2 Run → Step_8 (R), Step_9 (S)

24 Step 9 Push Out

25 Step_9 LS_6 Run → Step_9 (R), Step_1 (S)

26 Reset - keep on until can unclamped, vertical and out of station

27 RESET_PB Run → Int_Reset (M), Step_1 (R), Step_2 (R), Step_3 (R), Step_4 (R), Step_5 (R), Step_6 (R), Step_7 (R), Step_8 (R), Step_9 (R)

Int_Reset LS_5 LS_2 LS_6

Copyright (c) 2011 Dogwood Valley Press, LLC Copying and posting without permission prohibited.

28 Physical Outputs

Cannot turn off CYL_1 to CYL_3 when paused

On reset, do not unclamp until vertical.

29 Step_4 | Step_5 | Step_6 | Step_7 | Int_Reset | LS_5 → CYL_1 (M)

30 Step_5 | Step_6 → CYL_2 (M)

31 Step_2 | Step_3 | Step_4 | Step_5 | Step_6 | Step_7 | Step_8 | Step_9 → CYL_3 (M)

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

33 Step_2 | Step_9 | Int_Reset | LS_5 | LS_2 | LS_6 | Run → CYL_4 (M)

34 Step_6 | Run → MOTOR_1 (M)

35 Simulation

36 CALL Simulation

Copyright (c) 2011 Dogwood Valley Press, LLC Copying and posting without permission prohibited.