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2

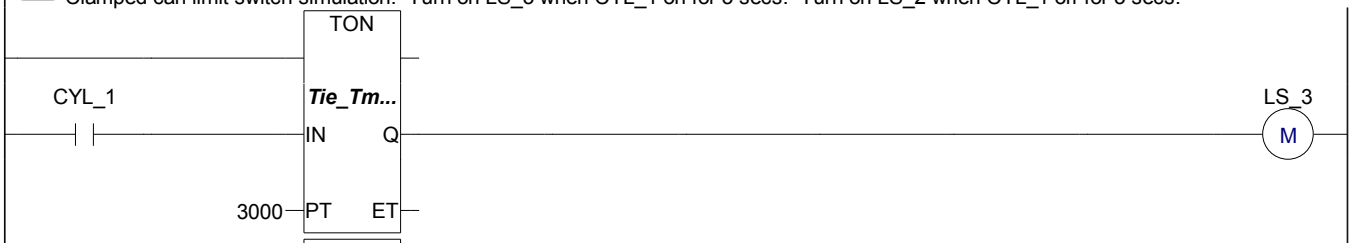
3 Simulation

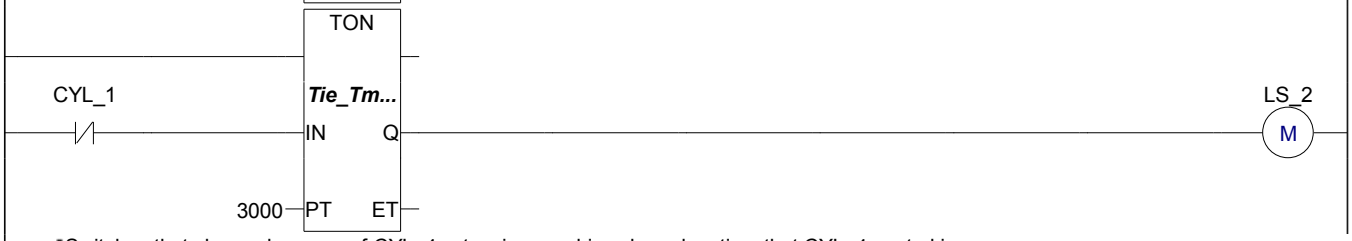
4 Horizontal/vertical limit switch simulation: Turn on LS_1 when CYL_2 on for 3 secs. Turn on LS_5 when CYL_2 off for 3 secs.

5

6

7 Tieback for clamped can limit switches
Clamped can limit switch simulation: Turn on LS_3 when CYL_1 on for 3 secs. Turn on LS_2 when CYL_1 off for 3 secs.

8


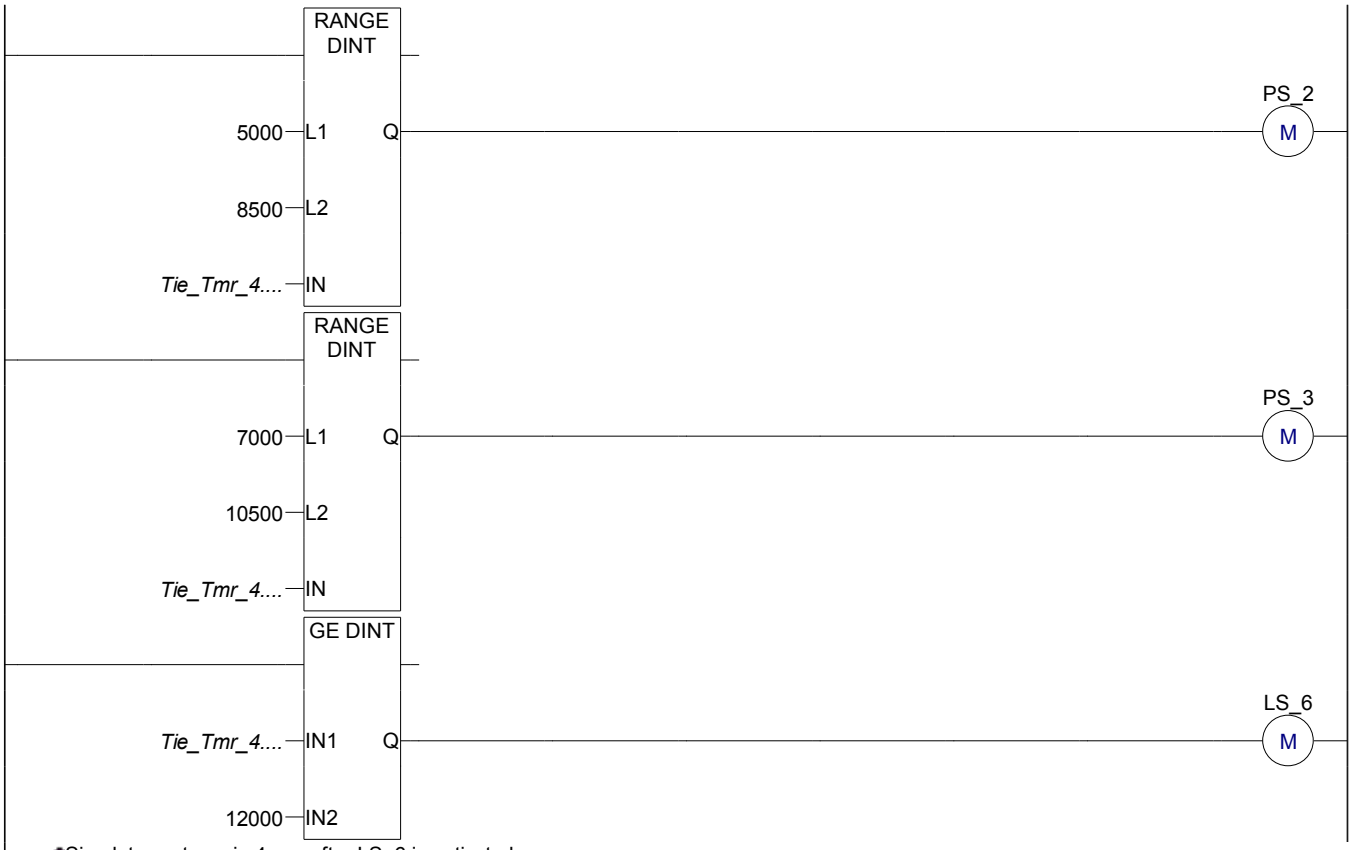
9


10 Switches that change because of CYL_4 extension are driven based on time that CYL_4 control is on.

11

12

13



14

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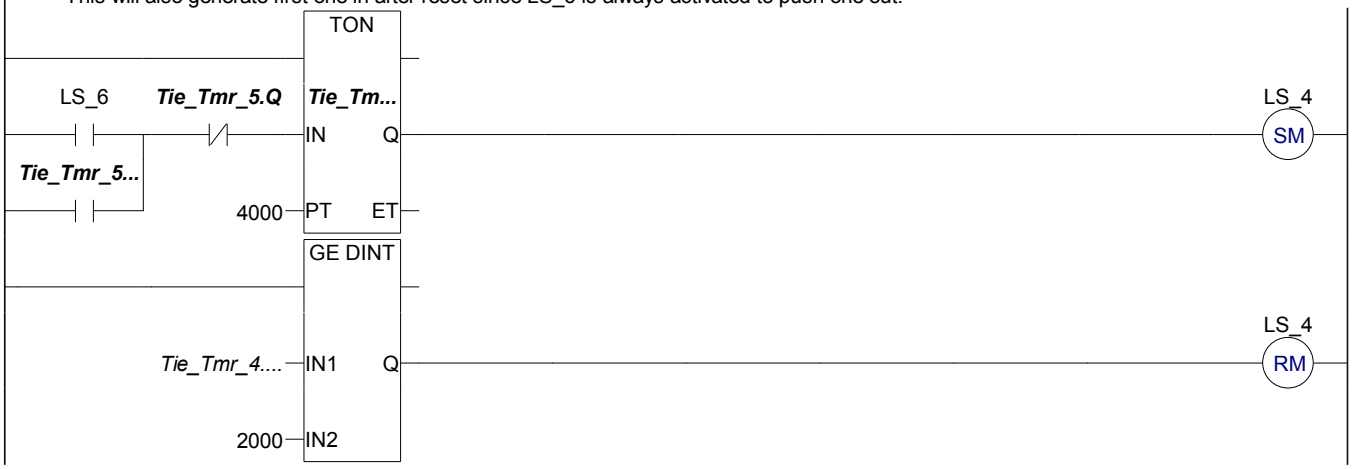
16

Simulate next one in 4 sec after LS_6 is activated.
Reset 2 seconds after CYL_4 activated.

This will also generate first one in after reset since LS_6 is always activated to push one out.

17



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