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3 SP6-1 Carton Sealer

4 Additional internal variable declarations:

Variables	Address	Data Type	
Run	%M1	BOOL	On while station running
Int_Reset %M2		BOOL	Internal reset
Step_1 to Step_7	%T1 to %T7	BOOL	Step-in-progress bits
Spray_Tmr %R1		INT[3]	Times spray
Dry_Tmr	%R4	INT[3]	Times drying step
Retract_Tmr %R7		INT[3]	Times retract of rams
Reset_Tmr %R10		INT[3]	Times reset (retract of rams)

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

6 START_PB %I00081 | Int_Reset %M00002 | STOP_PB %I00082 | %M00001 Run | Run M %M00001

7 Run %M00001 | Step_1 %T00001 | Step_2 %T00002 | Step_3 %T00003 | Step_4 %T00004 | Step_5 %T00005 | Step_6 %T00006 | Step_7 %T00007 | Step_1 S %T00001

8 Step 1 Wait for box

9 Step_1 %T00001 | PE1 %I00084 | Step_1 R %T00001 | Step_2 S %T00002

10 Step 2 Push down end flaps

11 Step_2 %T00002 | FRONT_ELS %I00085 | BACK_ELS %I00086 | Step_2 R %T00002 | Step_3 S %T00003

12 Step 3 Spray glue

13 Step_3 %T00003 | TMR HUNDS Spray_Tmr %R00001 PV 100 | Step_3 R %T00003 | Step_4 S %T00004

14 Step 4 Push down side flaps

15 Step_4 %T00004 | RIGHT_ELS %I00087 | LEFT_ELS %I00088 | Step_4 R %T00004 | Step_5 S %T00005

16 Step 5 Drying wait

17 Step_5 %T00005 | TMR HUNDS Dry_Tmr %R00004 PV 500 | Step_5 R %T00005 | Step_6 S %T00006

18 Step 6 Retract rams

19 Step_6 %T00006 | TMR HUNDS Retract_Tmr %R00007 PV 200 | Step_6 R %T00006 | Step_7 S %T00007

20 Step 7 Move box out

21 Step_7 %T00007 | PE1 %I00084 | Step_7 R %T00007 | Step_1 S %T00001

22 Outputs

23 Step_1 %T00001 Step_7 %T00007 Step_3 Run %M00001 CONV_MOTOR M %Q00001

24 %T00003 Step_2 GLUE_SPRAY M %Q00002

25 %T00002 Step_3 %T00003 Step_4 %T00004 Step_5 FRONT_EXT M %Q00003

26 %T00005 Step_2 %T00002 Step_3 %T00003 Step_4 %T00004 Step_5 BACK_EXT M %Q00004

27 %T00005 Step_4 %T00004 Step_5 RIGHT_EXT M %Q00005

28 %T00005 Step_4 %T00004 Step_5 LEFT_EXT M %Q00006

29 %T00005 Reset

30 RESET_PB %I00083 Int_Reset Run %M00001 Reset_Dn %M00002 %M00003 Int_Reset M %M00002 Step_1 R %T00001 Step_2 R %T00002 Step_3 R %T00003 Step_4 R %T00004 Step_5 R %T00005 Step_6 R %T00006

31 Int_Reset %M00002 TMR HUNDS Reset_Tmr 200 PV %R00010 Reset_Dn M %M00003

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