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3 Case Erector Control - With Simulation

4 Additional internal variable declarations:

Variables	Data Type	
Run	BOOL	On while station running
Step_1 to Step_6	BOOL	Step-in-progress bits
Up_Tmr	TON	Times opening up
BDown_Tmr	TON	Times deactivate of bottom cylinder
Pulse_Cnt	INT[3]	Count encoder pulses

5 Initial start.

6 Run, Step_1, Step_2, Step_3, Step_4, Step_5, Step_6 → Step_1 (S)

7 Step 1 Move in

8 Step_1, PROX → Step_1 (R), Step_2 (S)

9 Step 2 Open up

10 Step_2 → TON Up_Tmr (IN, PT 3500, Q, ET); Run → Step_2 (R), Step_3 (S)

11 Step 3 Close sides

12 Step_3, LEFT_LS, RIGHT_LS, Run → Step_3 (R), Step_4 (S)

13 Step 4 Close bottom

14 Step_4, BOT_LS, Run → Step_4 (R), Step_5 (S)

15 Step 5 Move out

16 Step_5, ENC_PULSE → UPCTR Pulse_... (R, PV 500, CV); Step_5 → Step_5 (R), Step_6 (S)

17 Step 6 Let Bot_Cyl fall

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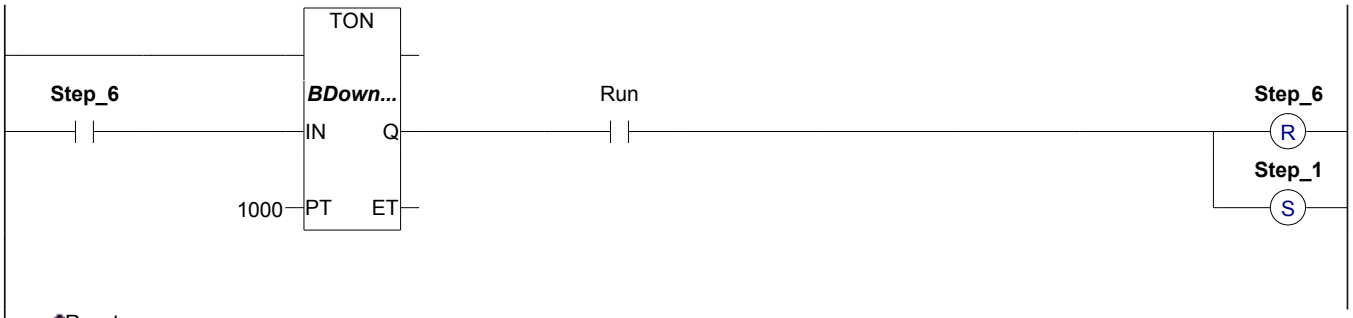
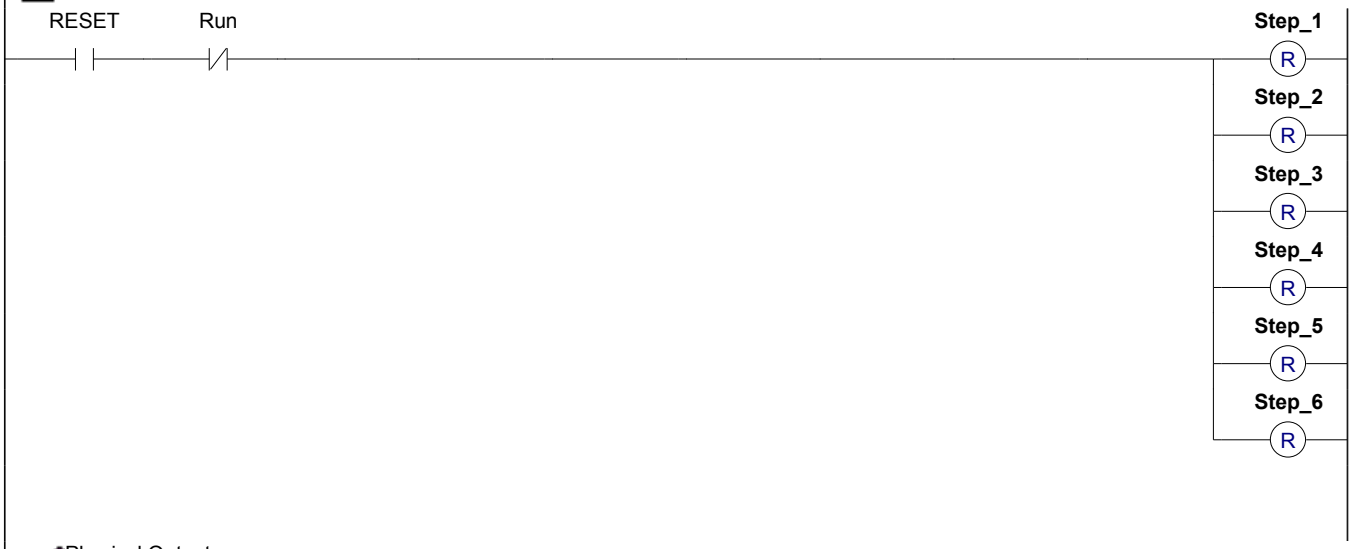
18



19 Reset

20



21 Physical Outputs

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29 Call simulation

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