

## Case Erector Control

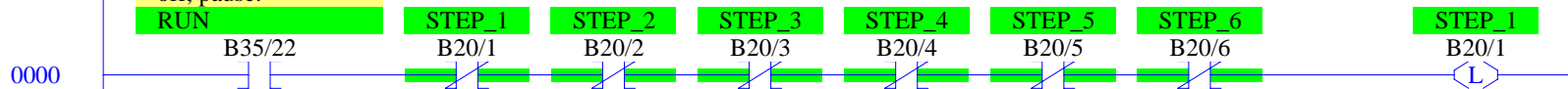
Copyright (c) 2013 Dogwood Valley Press, LLC

Additional internal memory:

Symbol	Address	
STEP_1 to STEP_6	B20/1 to B20/6	Step-in-progress bits
UP_TMR	T4:1	Times opening up
BDOWN_TMR	T4:2	Times deactivate of bottom cylinder
PULSE_CNT	C5:1	Count encoder pulses

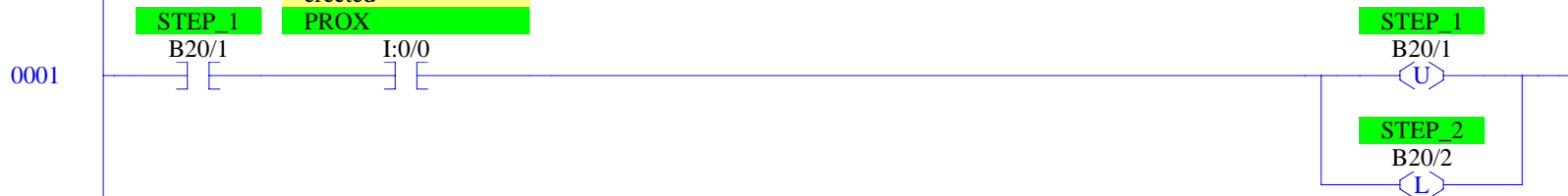
Initial start.

When on, allow case erector to run. When off, pause.



Step 1 Move in.

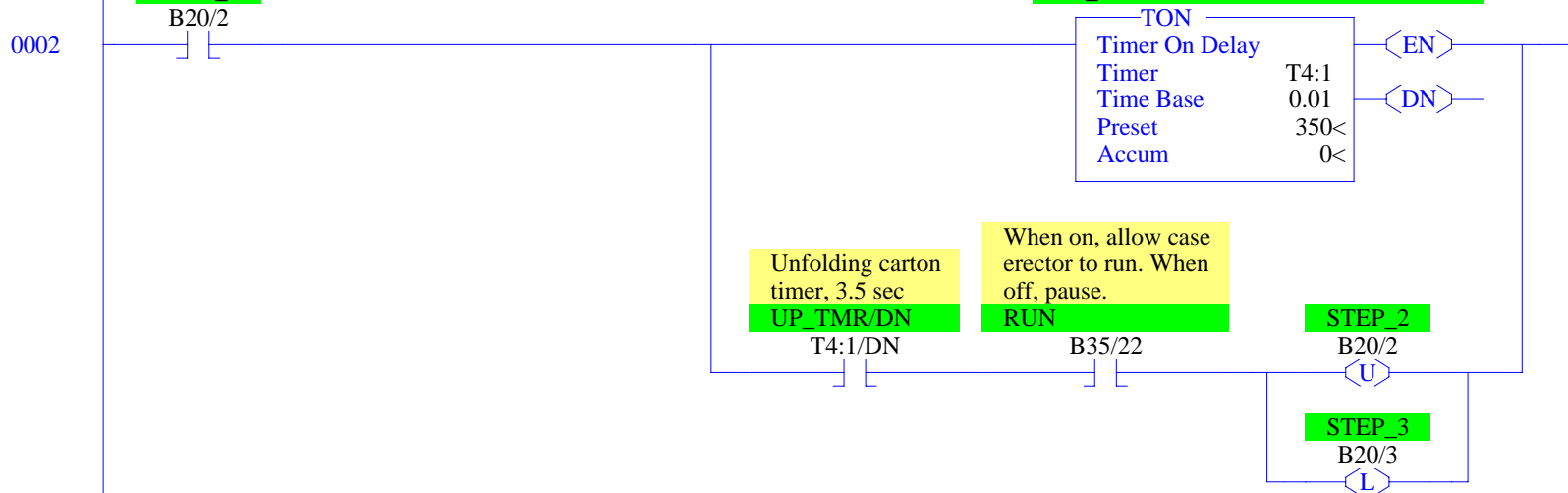
Proximity switch, on when flat carton is in position to be erected



Step 2 Open up.

Unfolding carton  
timer, 3.5 sec

UP\_TMR

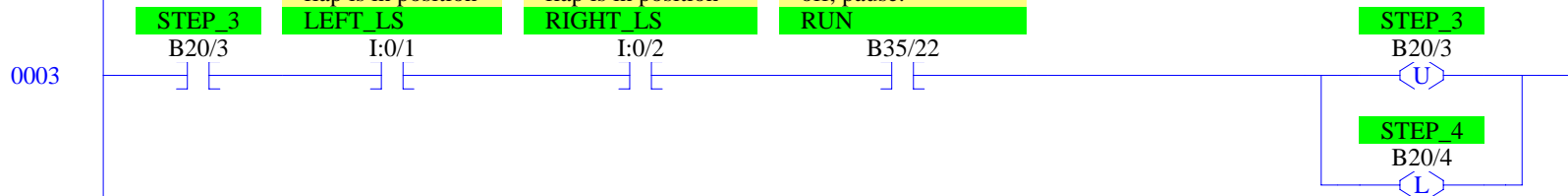


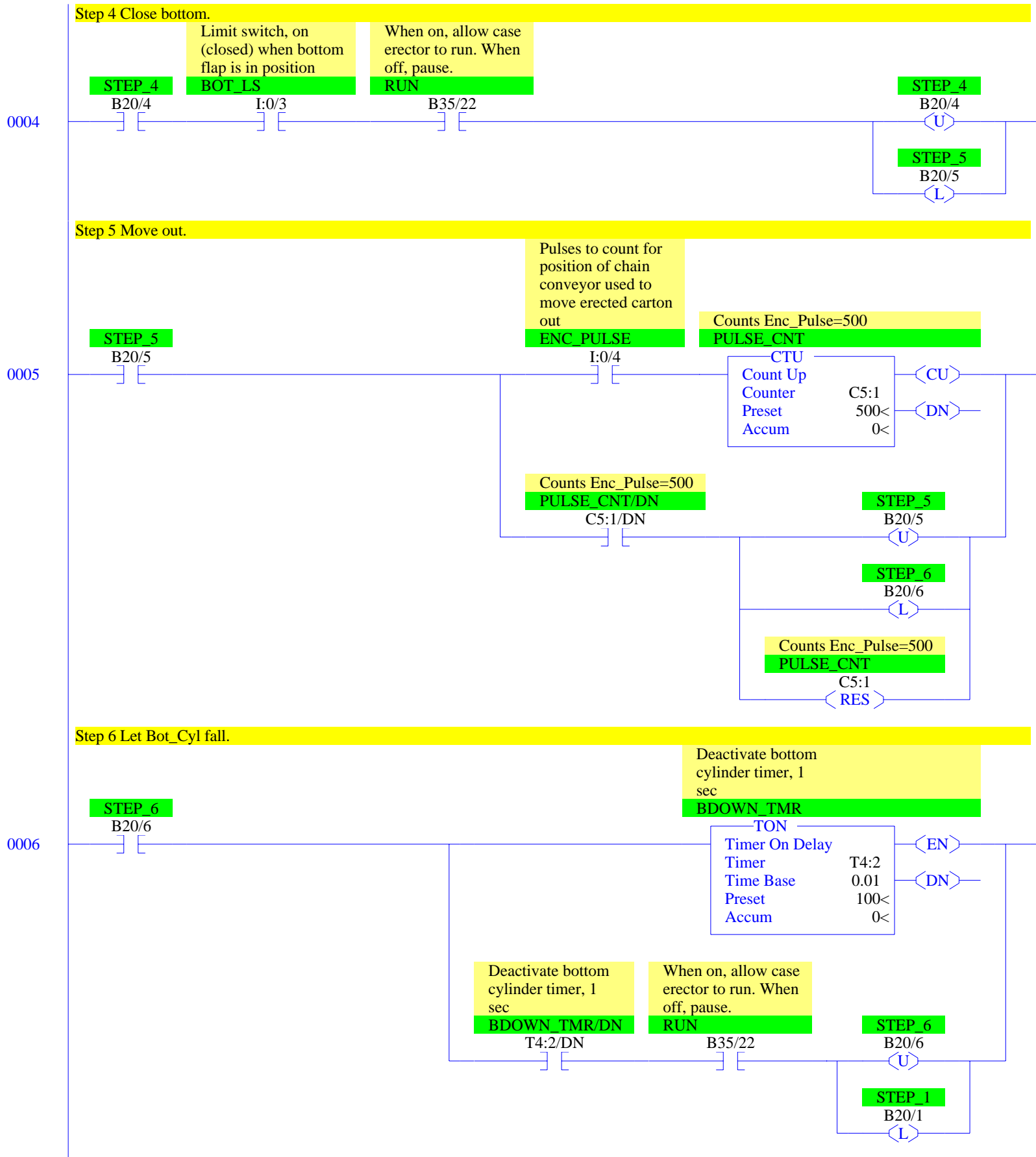
Step 3 Close sides.

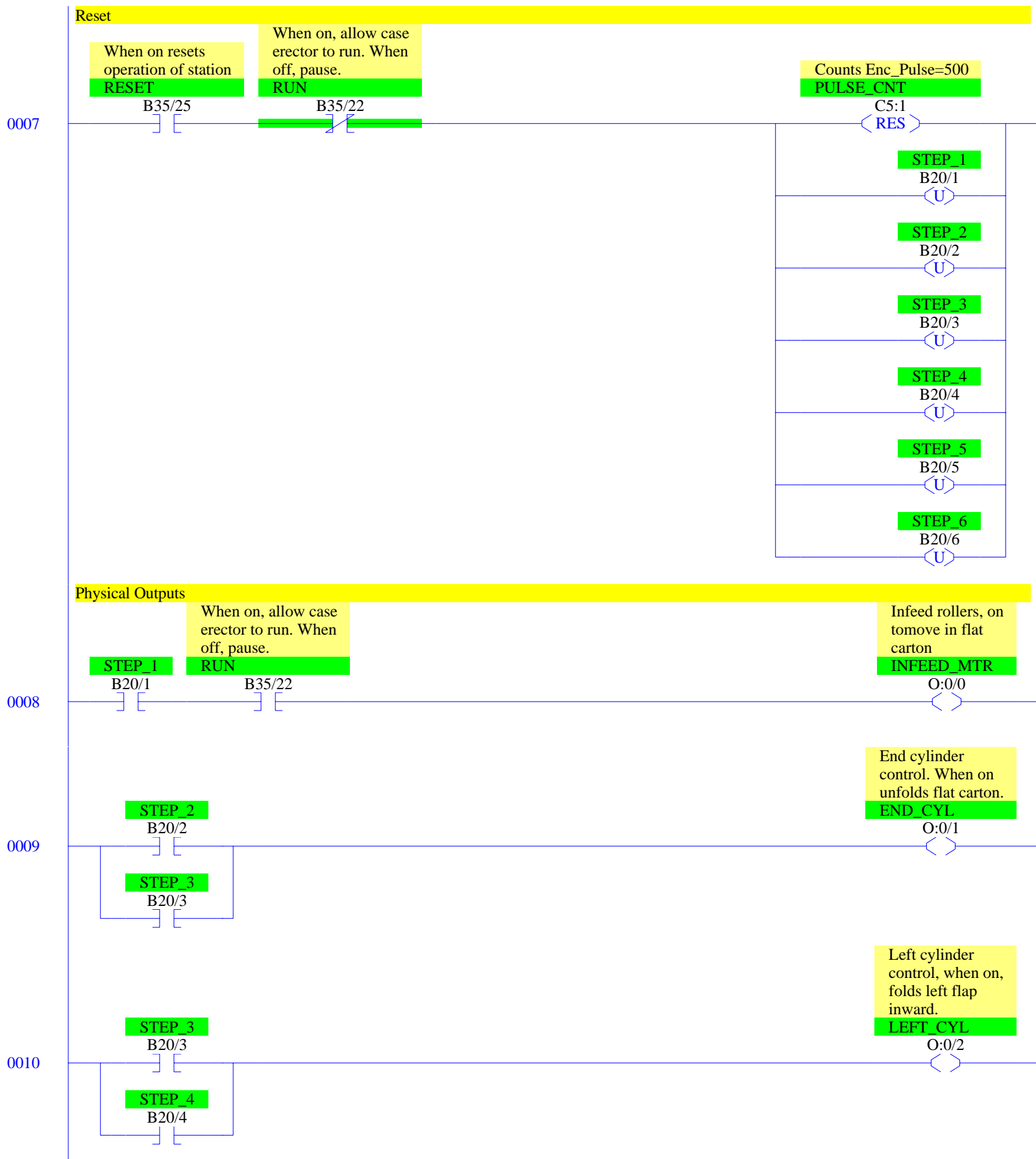
Limit switch, on (closed) when left flap is in position

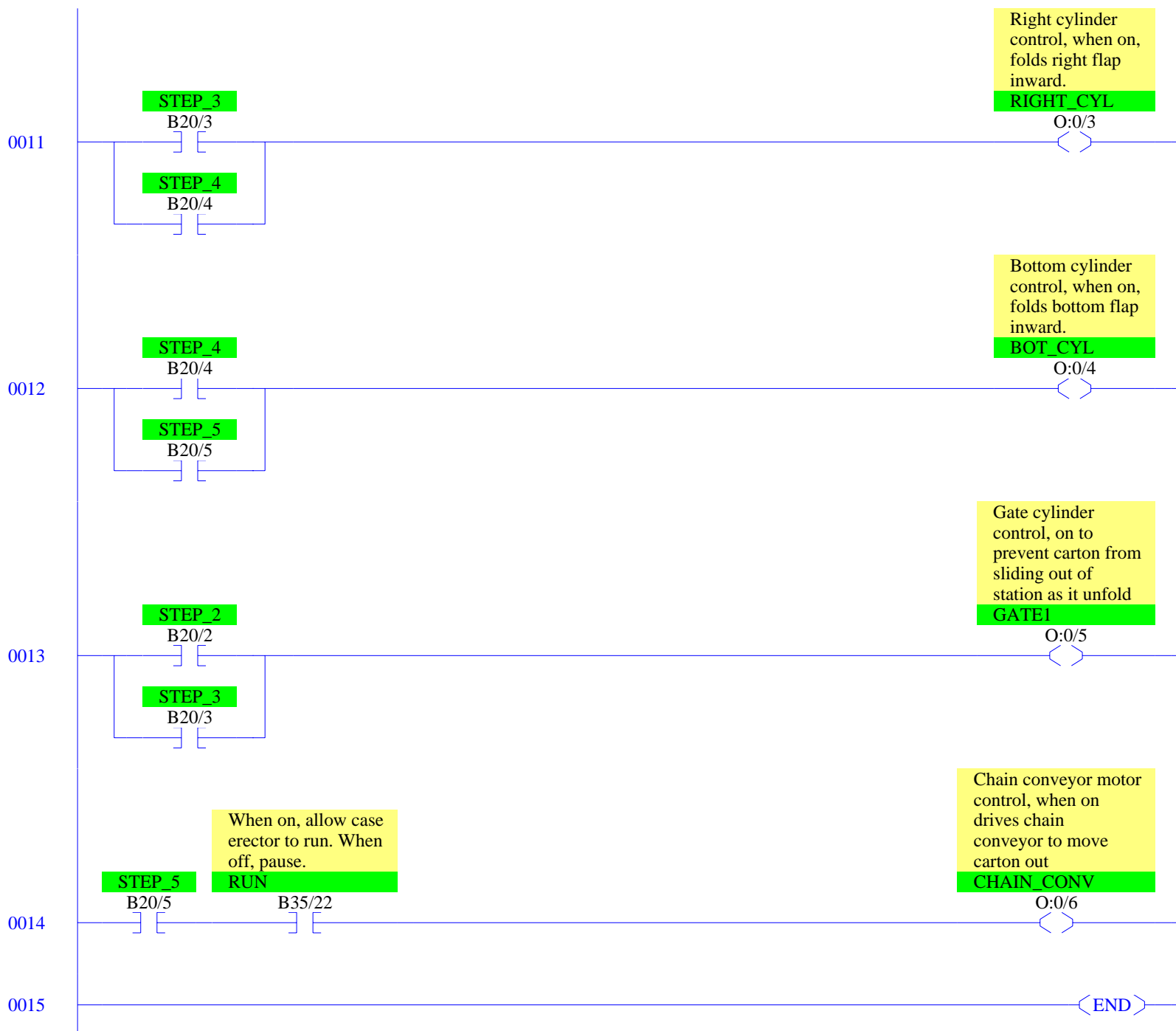
Limit switch, on (closed) when right flap is in position

When on, allow case erector to run. When off, pause.









## RSLogix 500 Cross Reference Report - Sorted by Address

O:0/0	- {INFEED_MTR} Infeed rollers, on to move in flat carton OTE - File #2 - 8
O:0/1	- {END_CYL} End cylinder control. When on unfolds flat carton. OTE - File #2 - 9
O:0/2	- {LEFT_CYL} Left cylinder control, when on, folds left flap inward. OTE - File #2 - 10
O:0/3	- {RIGHT_CYL} Right cylinder control, when on, folds right flap inward. OTE - File #2 - 11
O:0/4	- {BOT_CYL} Bottom cylinder control, when on, folds bottom flap inward. OTE - File #2 - 12
O:0/5	- {GATE1} Gate cylinder control, on to prevent carton from sliding out of station as it OTE - File #2 - 13
O:0/6	- {CHAIN_CONV} Chain conveyor motor control, when on drives chain conveyor to move cart OTE - File #2 - 14
I:0/0	- {PROX} Proximity switch, on when flat carton is in position to be erected XIC - File #2 - 1
I:0/1	- {LEFT_LS} Limit switch, on (closed) when left flap is in position XIC - File #2 - 3
I:0/2	- {RIGHT_LS} Limit switch, on (closed) when right flap is in position XIC - File #2 - 3
I:0/3	- {BOT_LS} Limit switch, on (closed) when bottom flap is in position XIC - File #2 - 4
I:0/4	- {ENC_PULSE} Pulses to count for position of chain conveyor used to move erected cart XIC - File #2 - 5
T4:1	- {UP_TMR} Unfolding carton timer, 3.5 sec TON - File #2 - 2
T4:1/DN	- XIC - File #2 - 2
T4:2	- {BDOWN_TMR} Deactivate bottom cylinder timer, 1 sec TON - File #2 - 6
T4:2/DN	- XIC - File #2 - 6
C5:1	- {PULSE_CNT} Counts Enc_Pulse=500 CTU - File #2 - 5 RES - File #2 - 5, 7
C5:1/DN	- XIC - File #2 - 5
B20/1	- {STEP_1} OTL - File #2 - 0, 6 OTU - File #2 - 1, 7 XIC - File #2 - 1, 8 XIO - File #2 - 0
B20/2	- {STEP_2} OTL - File #2 - 1 OTU - File #2 - 2, 7 XIC - File #2 - 2, 9, 13 XIO - File #2 - 0
B20/3	- {STEP_3} OTL - File #2 - 2 OTU - File #2 - 3, 7 XIC - File #2 - 3, 9, 10, 11, 13 XIO - File #2 - 0
B20/4	- {STEP_4} OTL - File #2 - 3 OTU - File #2 - 4, 7 XIC - File #2 - 4, 10, 11, 12 XIO - File #2 - 0
B20/5	- {STEP_5} OTL - File #2 - 4 OTU - File #2 - 5, 7 XIC - File #2 - 5, 12, 14 XIO - File #2 - 0
B20/6	- {STEP_6} OTL - File #2 - 5 OTU - File #2 - 6, 7 XIC - File #2 - 6 XIO - File #2 - 0
B35/22	- {RUN} When on, allow case erector to run. When off, pause. XIC - File #2 - 0, 2, 3, 4, 6, 8, 14

RSLogix 500 Cross Reference Report - Sorted by Address

---

B35/25	XIO - File #2 - 7
	- {RESET} When on resets operation of station
	XIC - File #2 - 7