

Main Properties

General	
1	General
2	General
3	General
4	General
5	General
6	General
7	General
8	General
9	General
10	General
11	General
12	General
13	General
14	General
15	General
16	General
17	General
18	General
19	General
20	General
21	General
22	General
23	General
24	General
25	General
26	General
27	General
28	General
29	General
30	General
31	General
32	General
33	General
34	General
35	General
36	General
37	General
38	General
39	General
40	General
41	General
42	General
43	General
44	General
45	General
46	General
47	General
48	General
49	General
50	General
51	General
52	General
53	General
54	General
55	General
56	General
57	General
58	General
59	General
60	General
61	General
62	General
63	General
64	General
65	General
66	General
67	General
68	General
69	General
70	General
71	General
72	General
73	General
74	General
75	General
76	General
77	General
78	General
79	General
80	General
81	General
82	General
83	General
84	General
85	General
86	General
87	General
88	General
89	General
90	General
91	General
92	General
93	General
94	General
95	General
96	General
97	General
98	General
99	General
100	General

Name	Main	Number	1	Type	OB
-------------	------	---------------	---	-------------	----

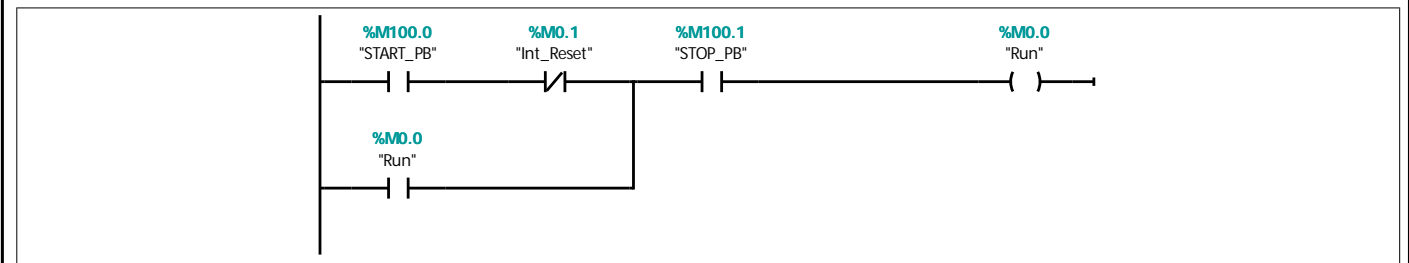
Language	LAD	Numbering	Manual	
-----------------	-----	------------------	--------	--

Information

Title	SP9-2	Author		Comment	Copyright (c) 2023 Dogwood Valley Press, LLC ----- ----- SP9-2 Erbia Can Tipper/Rotator with move-based sequencer
Family		Version	0.1	User-defined ID	

Name	Data type	Default value
▼ Temp		
OB1_EV_CLASS	Byte	
OB1_SCAN_1	Byte	
OB1_PRIORITY	Byte	
OB1_OB_NUMBR	Byte	
OB1_RESERVED_1	Byte	
OB1_RESERVED_2	Byte	
OB1_PREV_CYCLE	Int	
OB1_MIN_CYCLE	Int	
OB1_MAX_CYCLE	Int	
OB1_DATE_TIME	Date_And_Time	
Constant		

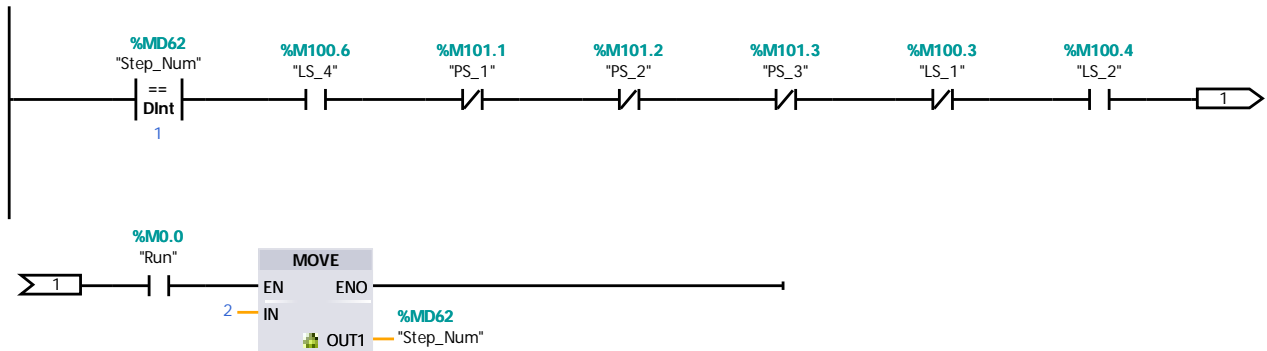
Network 1: Start/stop/pause. Start prevented if reset in progress.



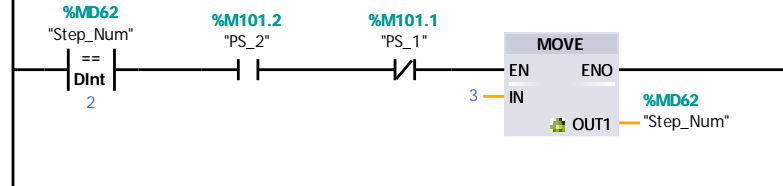
Network 2: First Start - transition out of initial step to step 1.



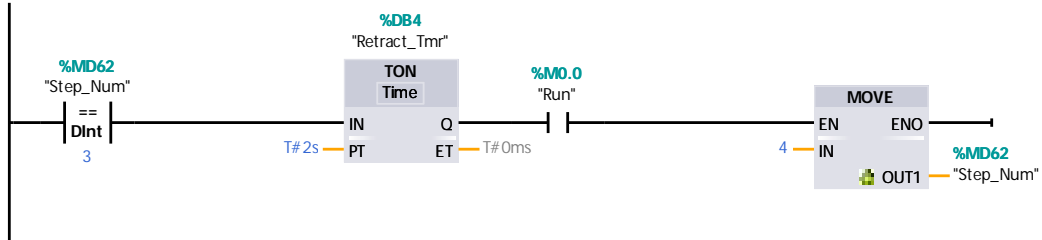
Network 3: Step 1 - Wait for can.



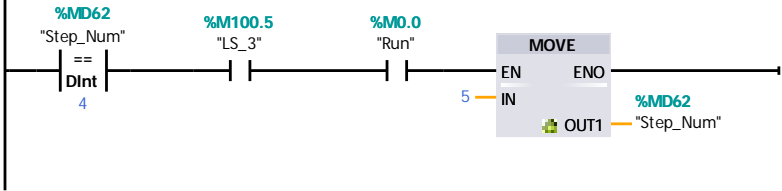
Network 4: Step 2 - Push can into tipper



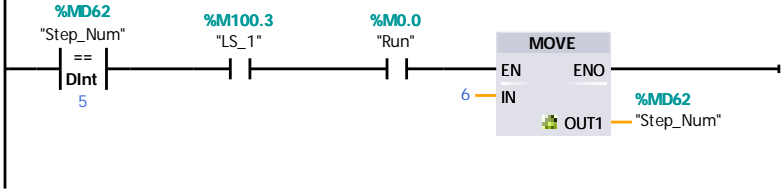
Network 5: Step 3 - Wait for CYL_3 to retract



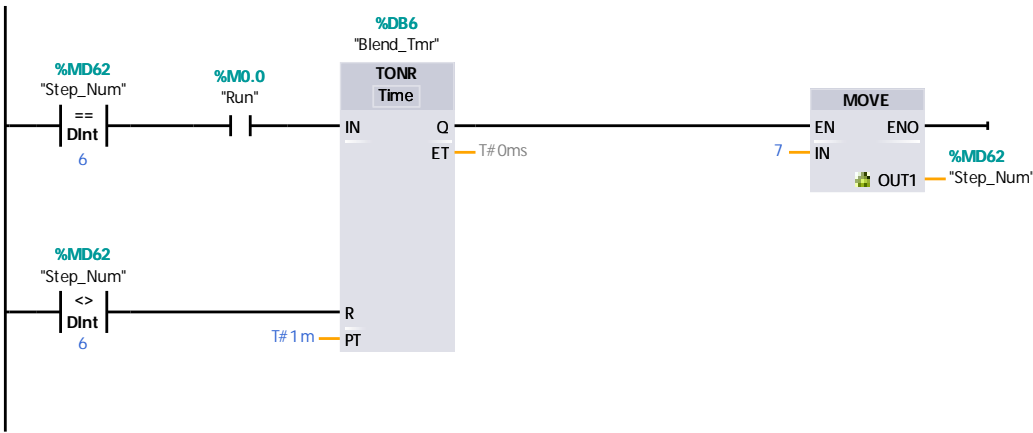
Network 6: Step 4 - Clamp can



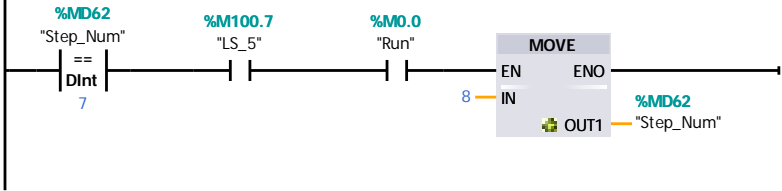
Network 7: Step 5 - Tip rotator



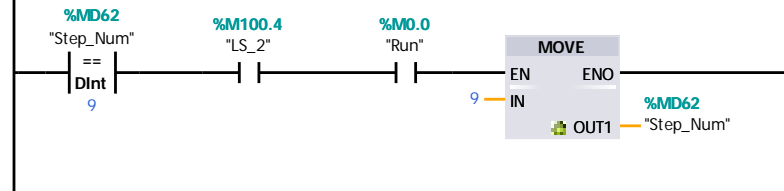
Network 8: Step 6 - Blend



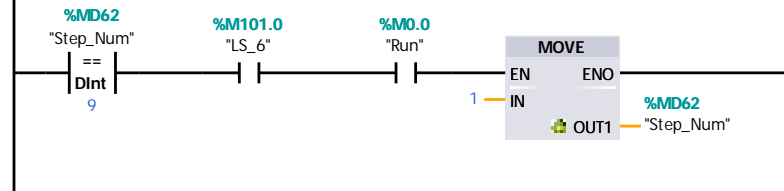
Network 9: Step 7 - Untip



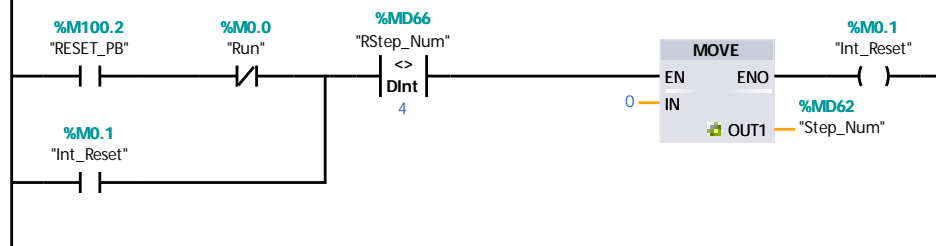
Network 10: Step 8 - Unclamp



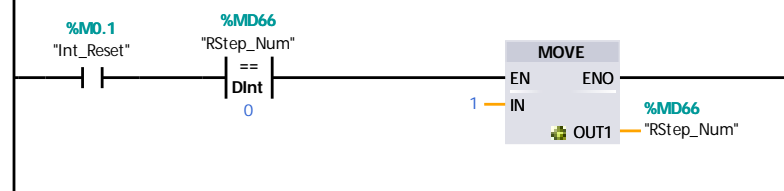
Network 11: Step 9 - Push out



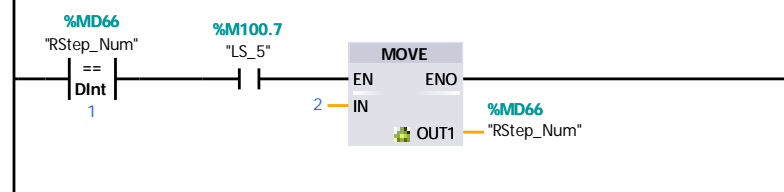
Network 12: Start/stop for reset operation. Reset pb starts, reset step 4 stops it.



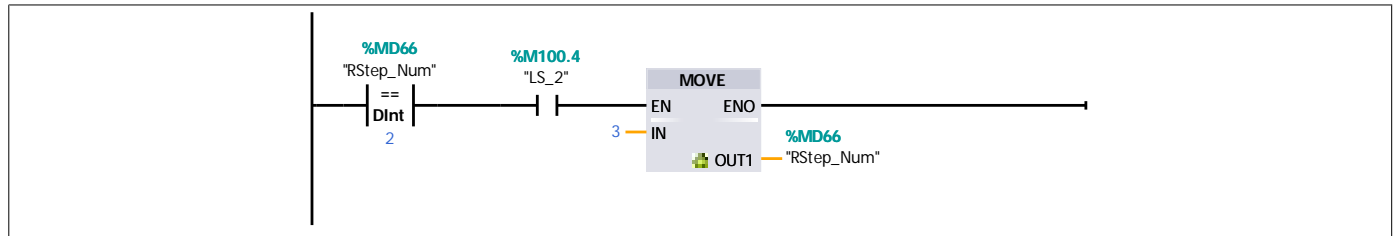
Network 13: First press of reset pb starts reset



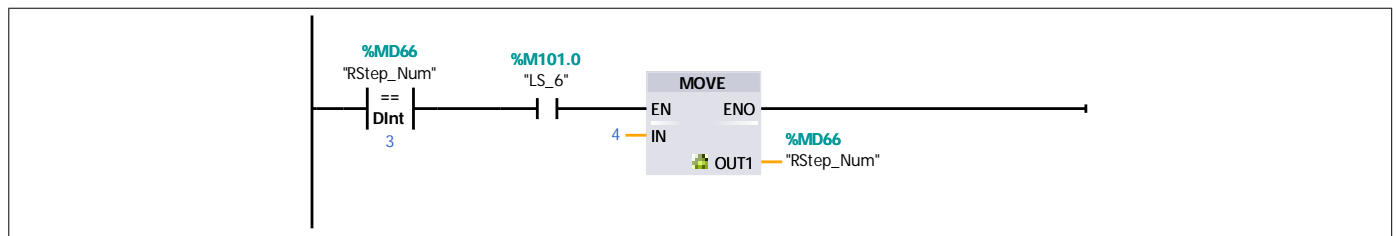
Network 14: Reset step 1 - Untip.



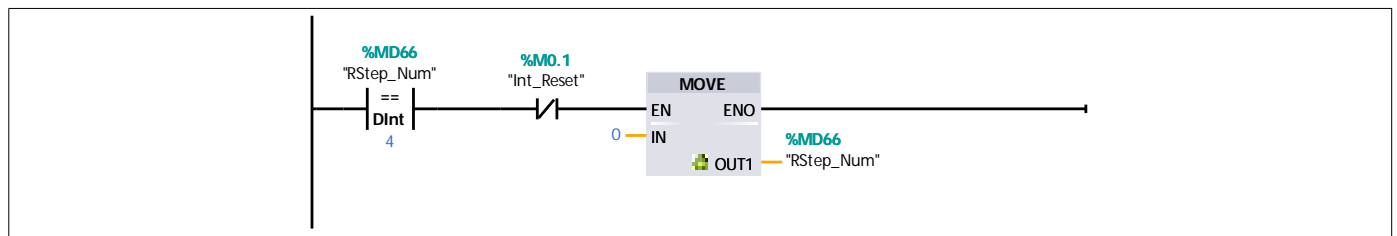
Network 15: Reset step 2 - Unclamp.



Network 16: Reset step 3 - Push Out.

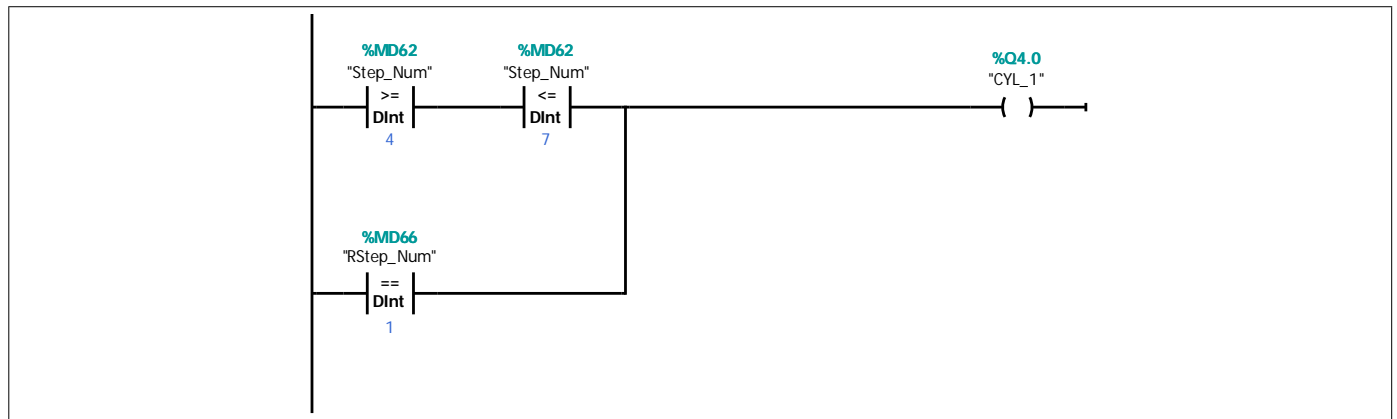


Network 17: Reset step 4 - Wait for Int_Reset off.

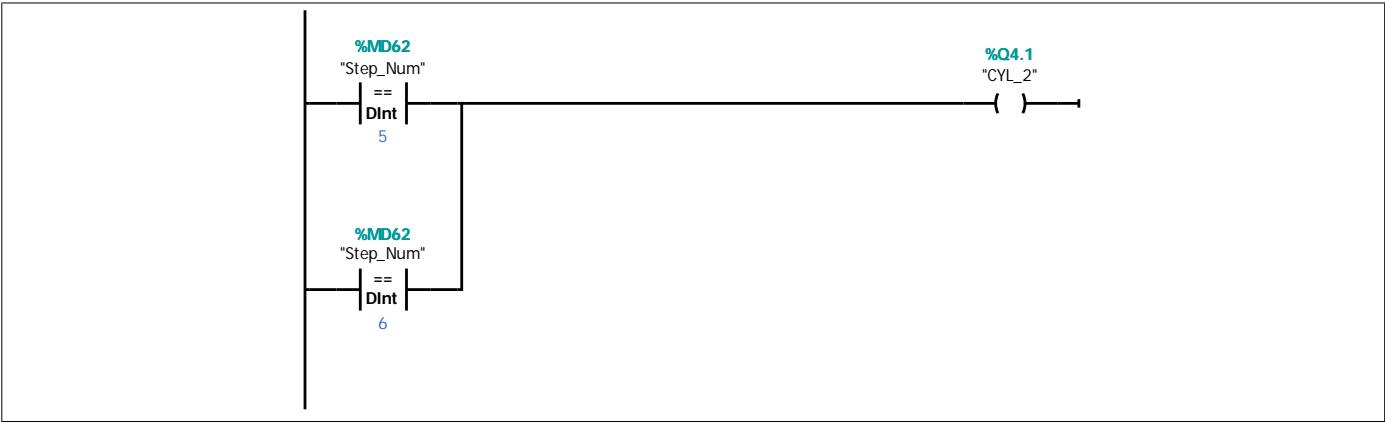


Network 18: Can holder cylinder control

Cylinder controls
Cannot turn off CYL_1 to CYL_3 when paused.

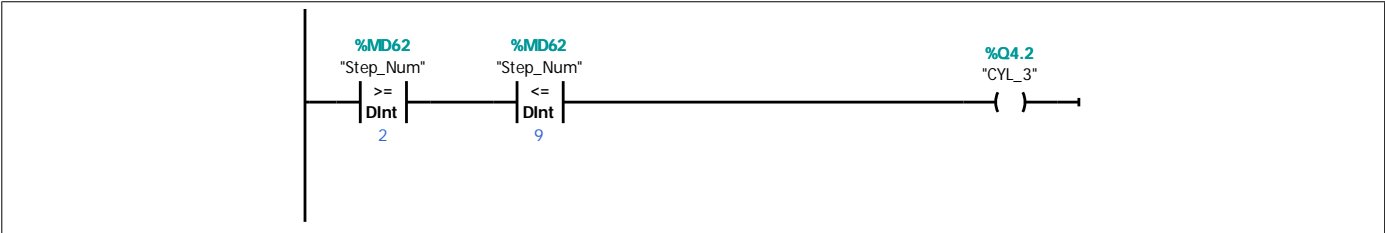


Network 19: Tipper cylinder control



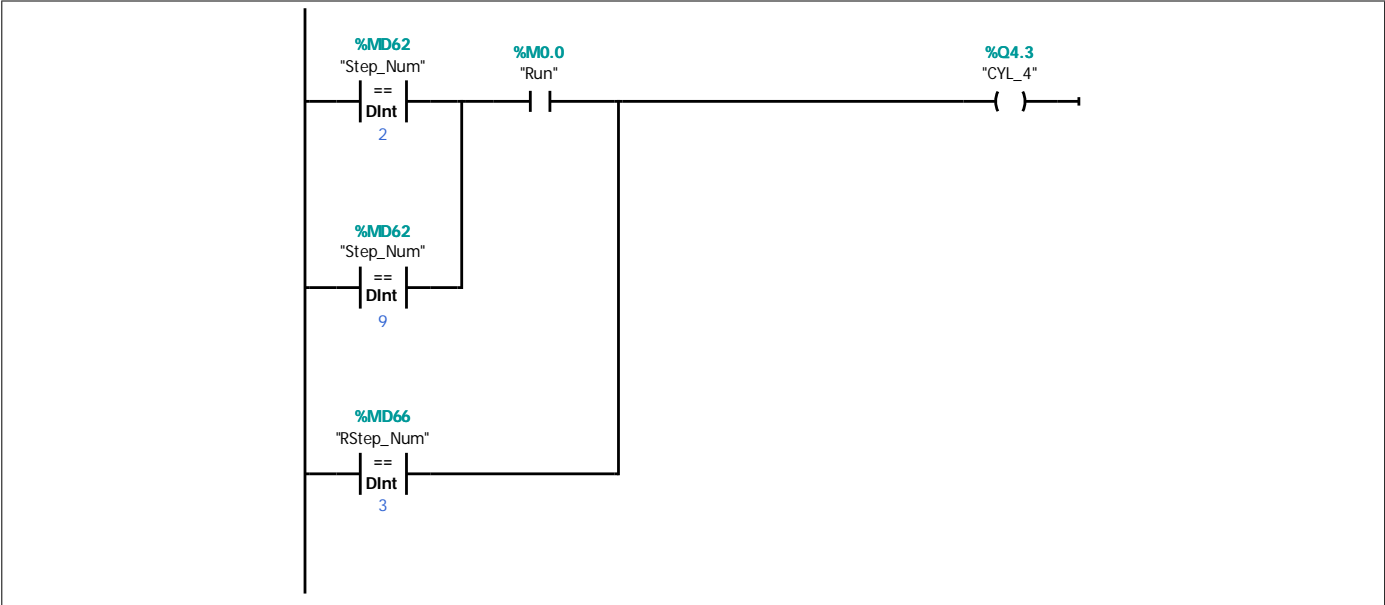
Network 20: Gate cylinder control

Gripper Control



Network 21: Can pusher cylinder control

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



Network 22: Rotation motor control

