

FC1 - <offline>

"Simulation"

Name:

Author:

Time stamp Code:

Lengths (block/logic/data):

Family:

Version: 0.1

Block version: 2

12/28/2015 06:09:47 AM

05/28/2010 08:29:49 PM

00572 00458 00006

Name	Data Type	Address	Comment
IN		0.0	
OUT		0.0	
IN_OUT		0.0	
TEMP		0.0	
RETURN		0.0	
RET_VAL		0.0	

Block: FC1

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SIMULATION LOGIC

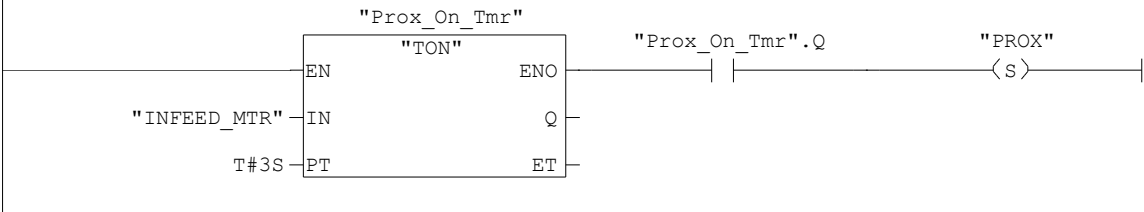
Network: 1      Proximity sensor, on when flat carton in position to be erected

On reset, reset PROX



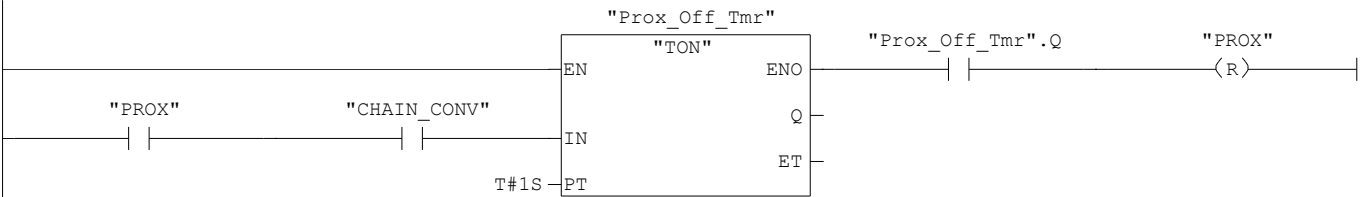
Network: 2      Proximity sensor, on when flat carton in position to be erected

PROX simulation: Set when INFEED running for 3 secs.  
Reset when PROX on and CHAIN\_CONV runs for one sec



Network: 3

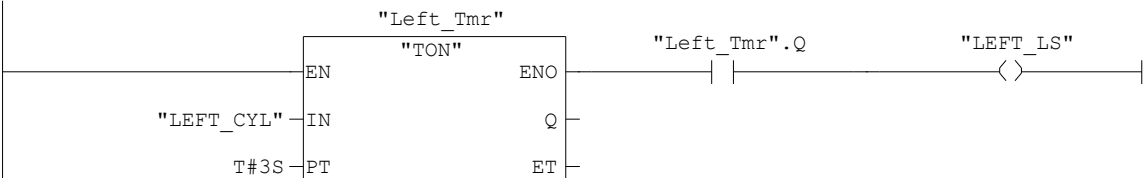
Proximity sensor, on when flat carton in position to be erected



Network: 4

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

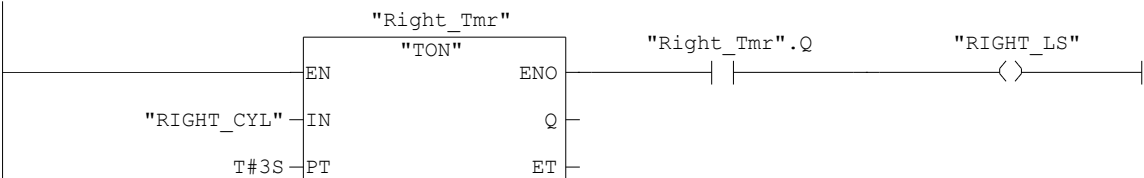
LEFT\_LS simulation: Turn on when LEFT\_CYL on for 3 sec



Network: 5

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

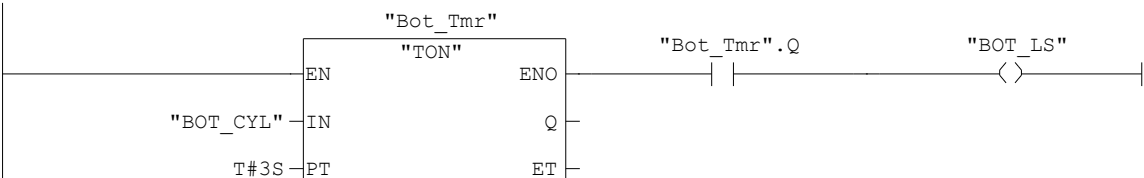
RIGHT\_LS simulation: Turn on when RIGHT\_CYL on for 3 sec



Network: 6

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

BOT\_LS simulation: Turn on when BOT\_CYL on for 3 sec



Network: 7      Pulses to count for position of chain conveyor used to move erec

ENC\_PULSE simulation: Generate one-scan pulse every 10 ms

