

FC1 - <offline>

"Simulation"

**Name:**  
**Author:**  
  
**Time stamp Code:**  
**Interface:**  
**Lengths (block/logic/data):**

**Family:**  
**Version:** 0.1  
**Block version:** 2  
12/28/2015 06:14:20 AM  
05/28/2010 08:29:49 PM  
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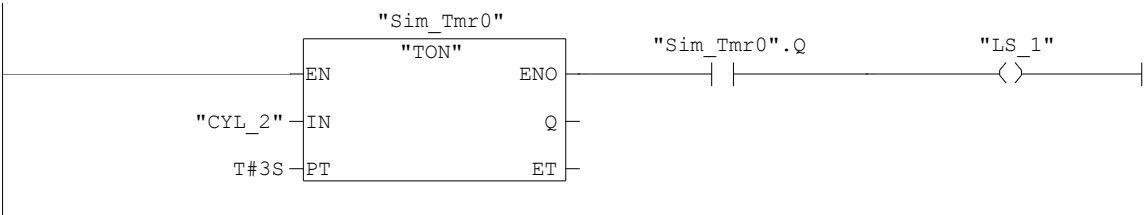
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IN		0.0	
OUT		0.0	
IN_OUT		0.0	
TEMP		0.0	
RETURN		0.0	
RET_VAL		0.0	

Block: FC1

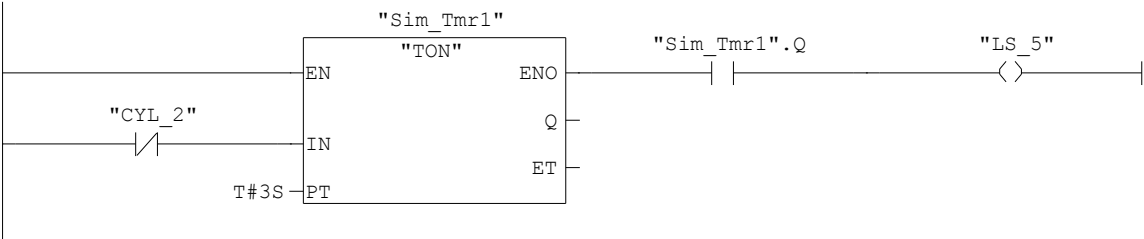
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SIMULATION LOGIC

Network: 1      Limit switch that closes when feeder ram is retracted.

Horizontal/vertical limit switch simulation: Turn on LS\_1 when CYL\_2 on for 3 secs. Turn on LS\_5 when CYL\_2 off for 3 secs.

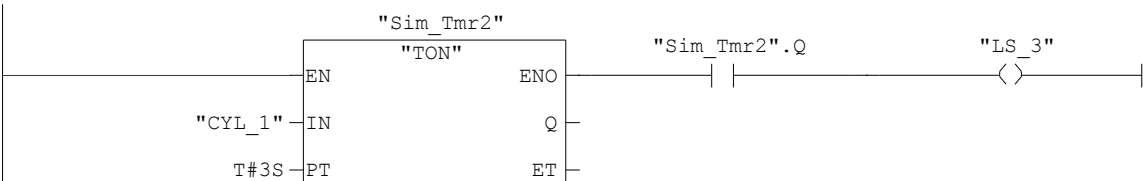


Network: 2      Vertical position limit switch

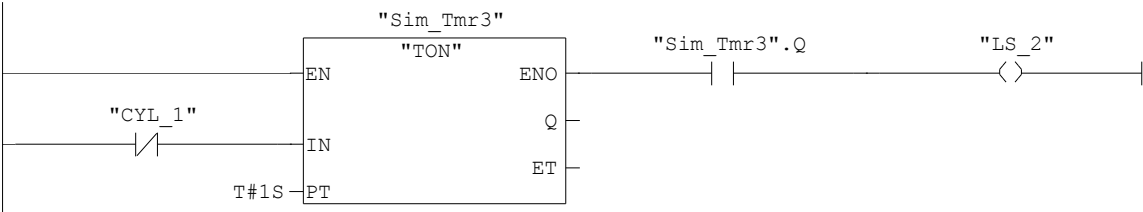


Network: 3Holder clear limit switch

Tieback for clamped can limit switches  
Clamped can limit switch simulation: Turn on LS\_3 when CYL\_1 on for 3 secs.  
Turn on LS\_2 when CYL\_1 off for 3 secs.



Network: 4

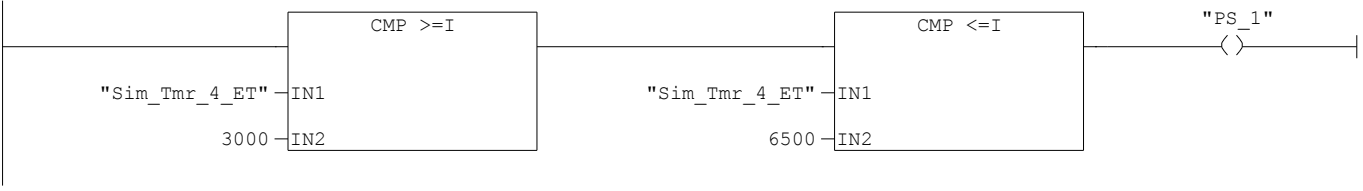


Network: 5

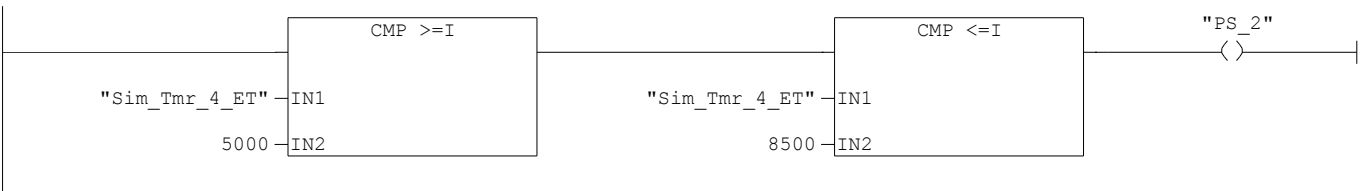
Switches that change because of CYL\_4 extension are driven based on time that CYL\_4 control is on.



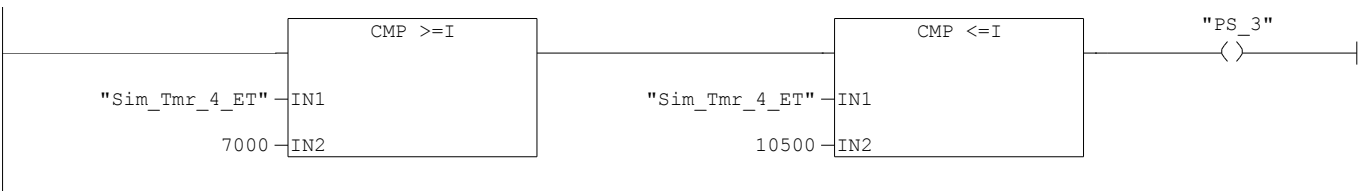
Network: 6Left can photoelectric switch



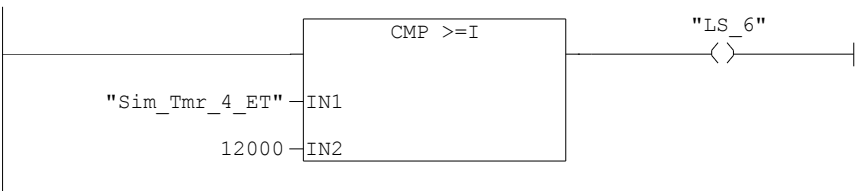
Network: 7



Network: 8



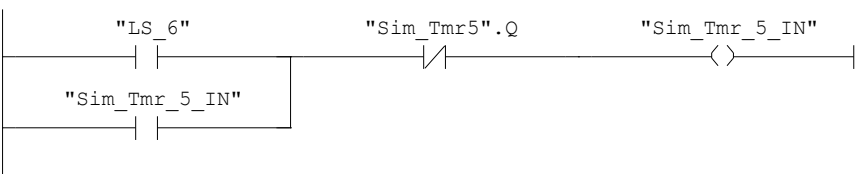
Network: 9



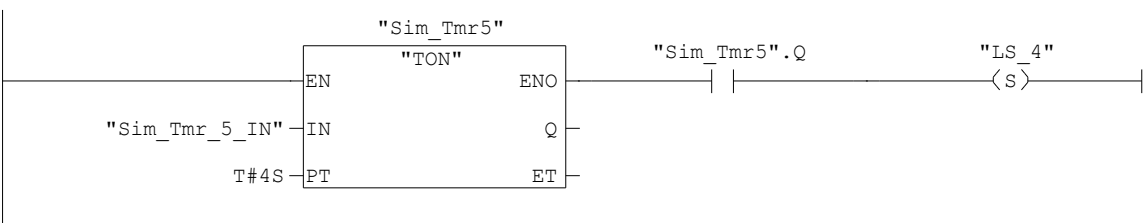
Network: 10

Simulate next one in 4 sec after LS\_6 is activated.  
Reset 2 seconds after CYL\_4 activated.

This will also generate first one in after reset since LS\_6 is always activated to push one out.



Network: 11 Can present on input conveyor limit switch



Network: 12

Can present on input conveyor limit switch

