

Main_Program Properties

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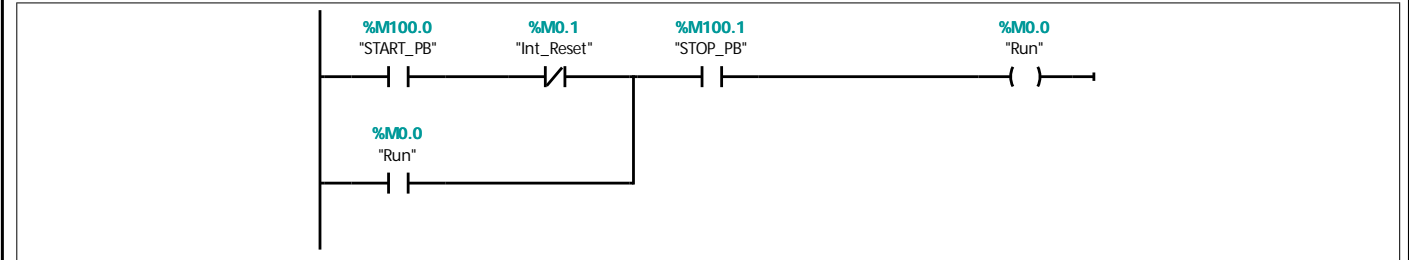
Name	Main_Program	Number	1	Type	OB
Language	LAD	Numbering	Manual		

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		

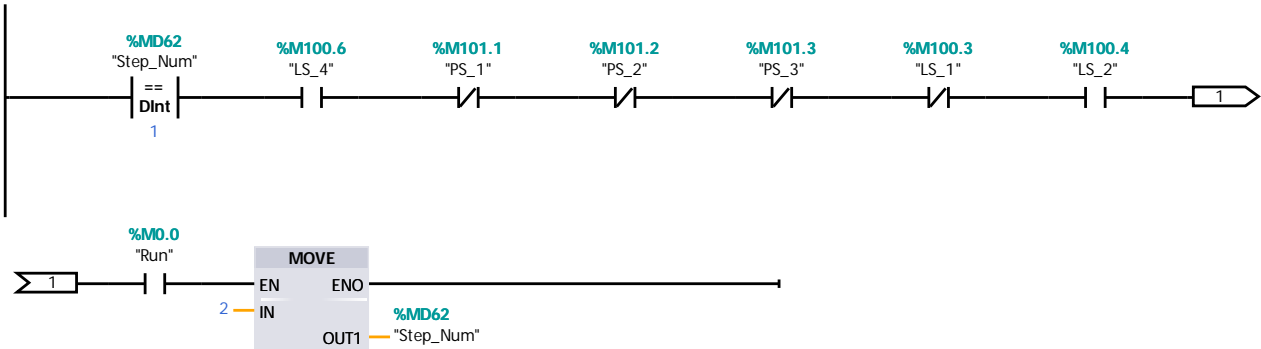
Network 1: Start/stop/pause. Start prevented if reset in progress.



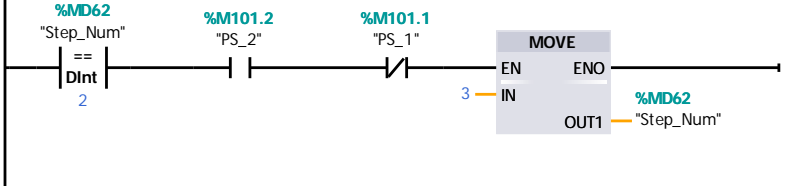
Network 2: First Start - transition out of initial step to step 1.



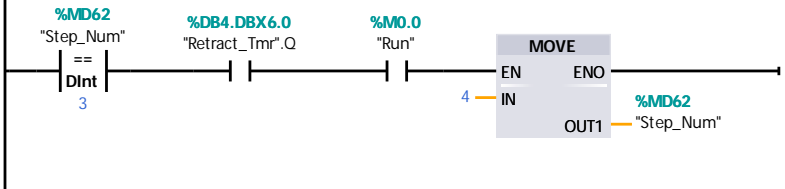
Network 3: Step 1 - Wait for can.



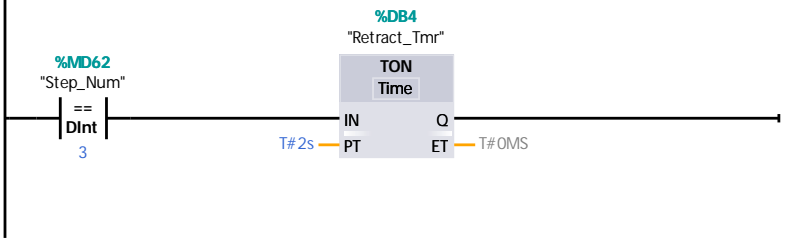
Network 4: Step 2 - Push can into tipper



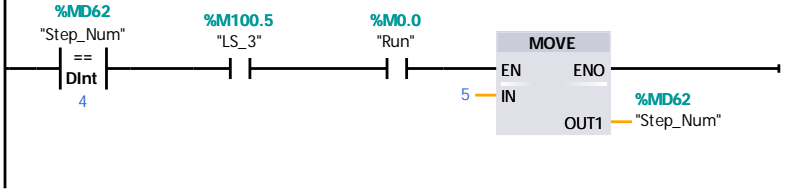
Network 5: Step 3 - Wait for CYL_3 to retract



Network 6: Step 3 timer



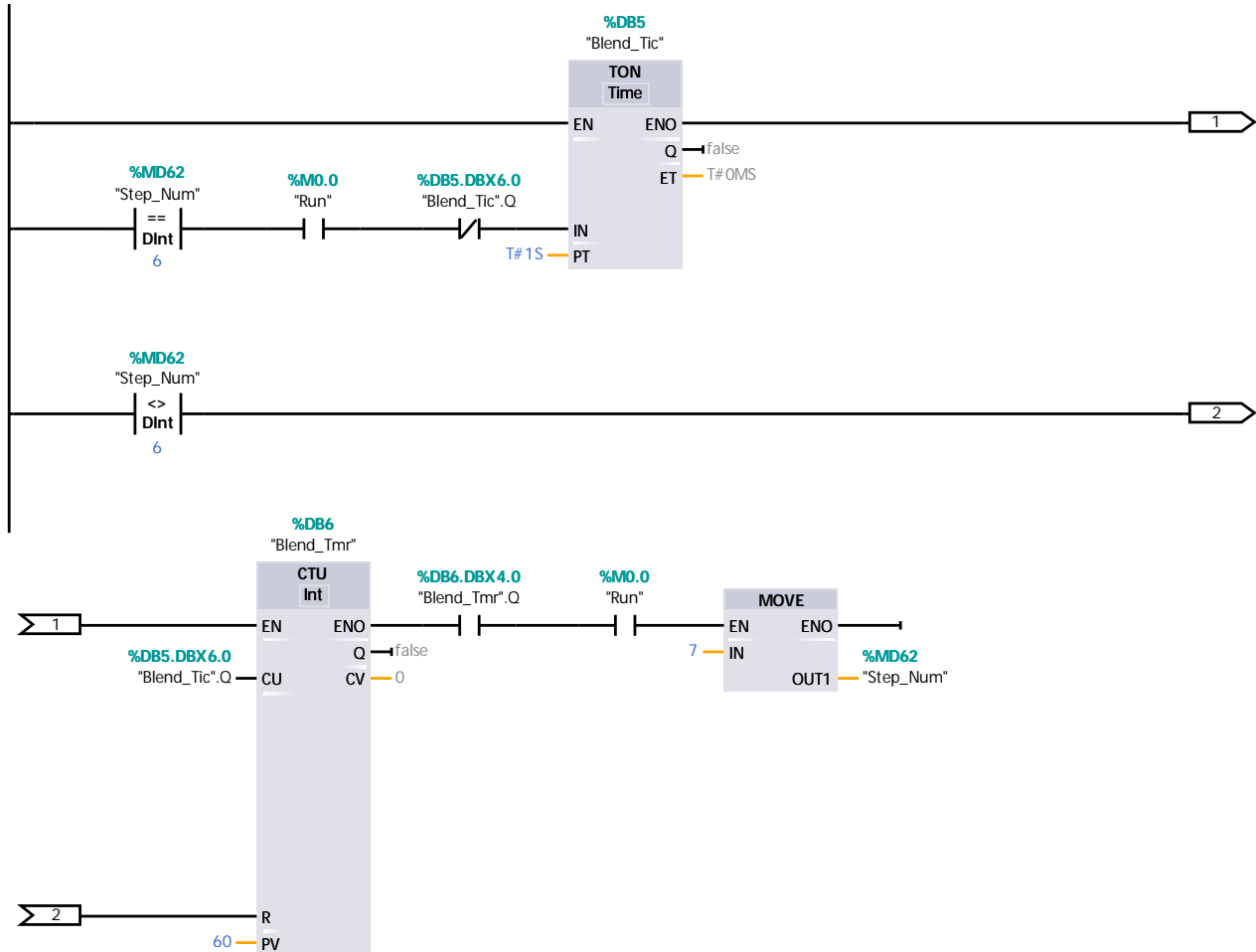
Network 7: Step 4 - Clamp can



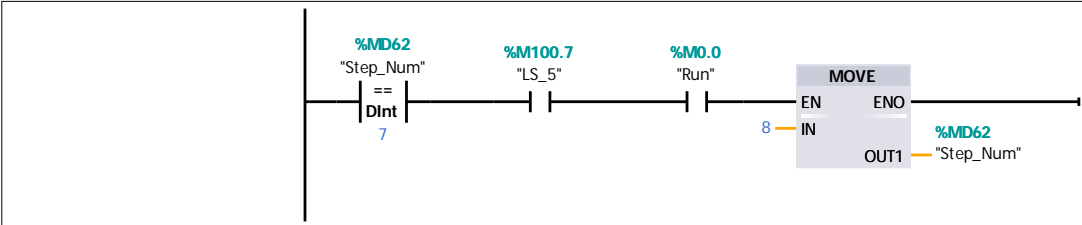
Network 8: Step 5 - Tip rotator



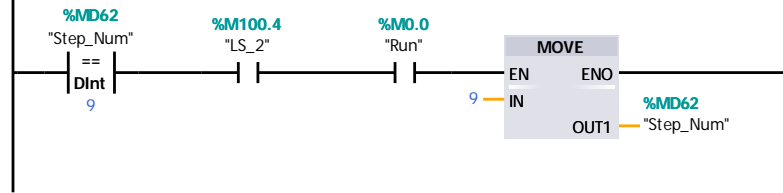
Network 9: Step 6 - Blend



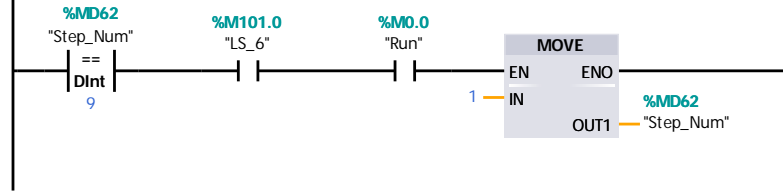
Network 10: Step 7 - Untip



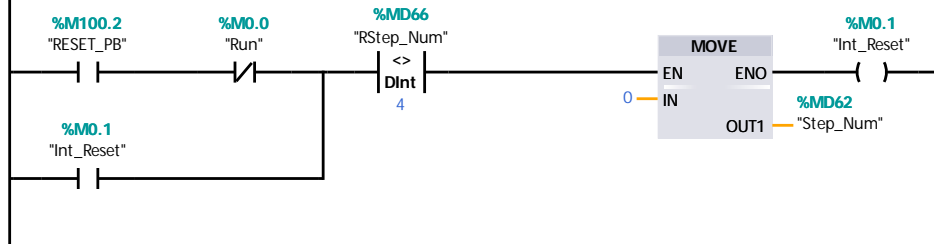
Network 11: Step 8 - Unclamp



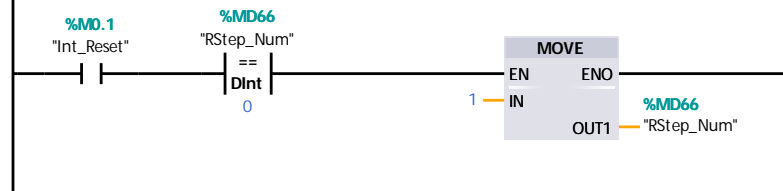
Network 12: Step 9 - Push out



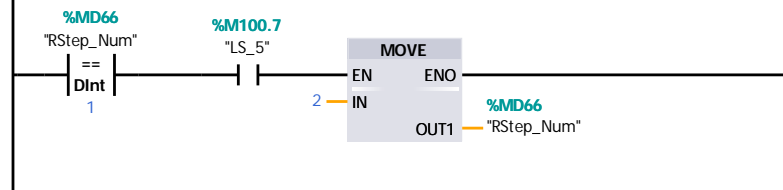
Network 13: Start/stop for reset operation. Reset pb starts, reset step 4 stops it.



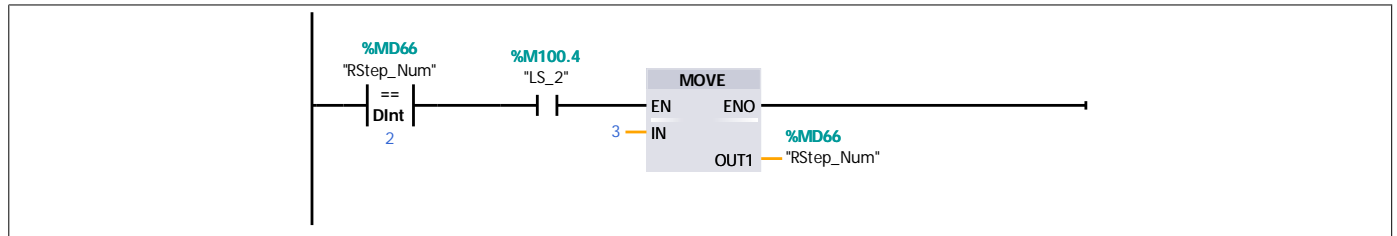
Network 14: First press of reset pb starts reset



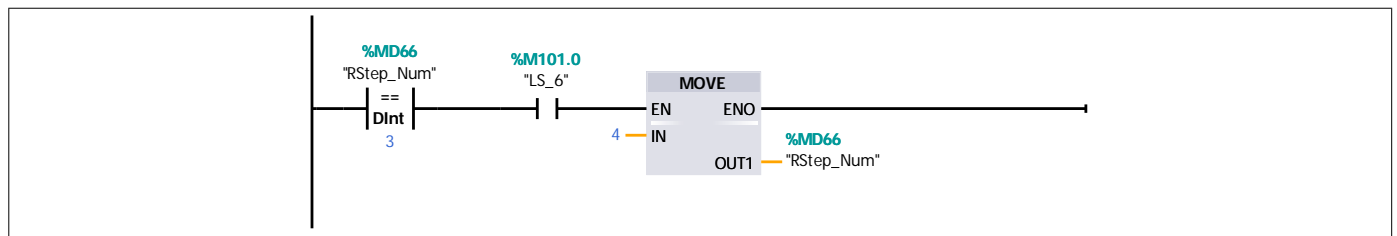
Network 15: Reset step 1 - Untip.



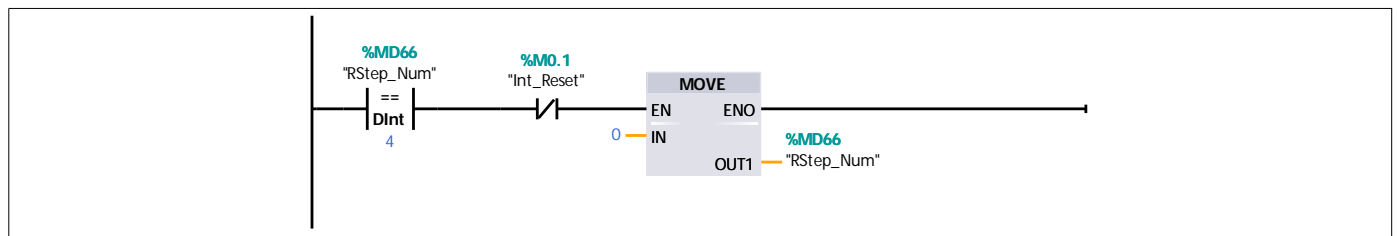
Network 16: Reset step 2 - Unclamp.



Network 17: Reset step 3 - Push Out.

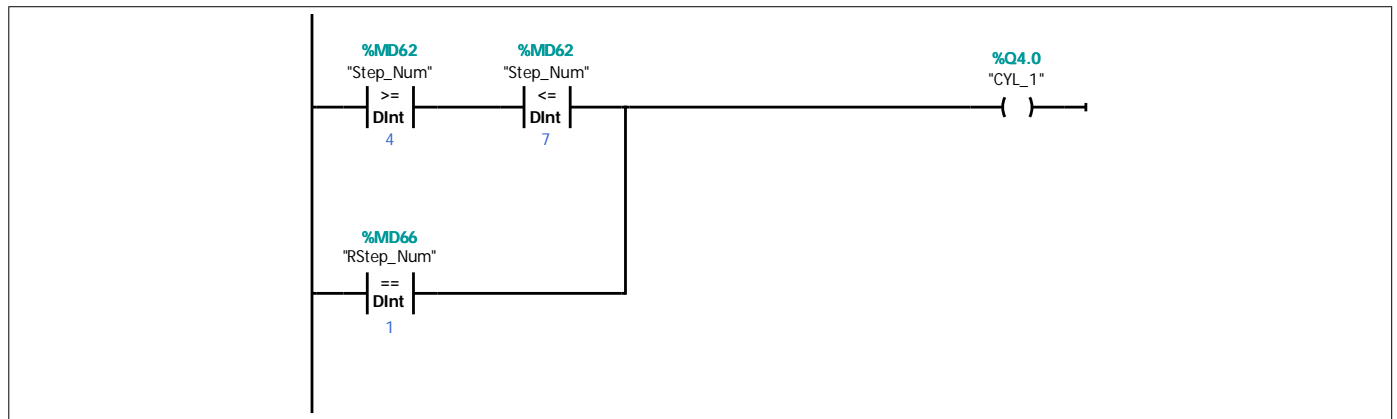


Network 18: Reset step 4 - Wait for Int_Reset off.

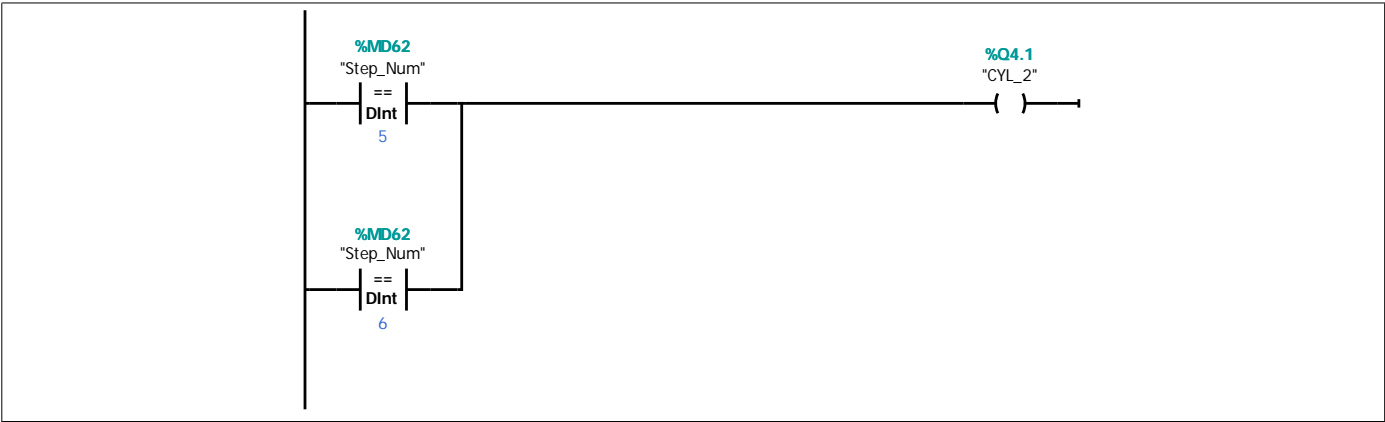


Network 19: Can holder cylinder control

Cylinder controls
Cannot turn off CYL_1 to CYL_3 when paused.

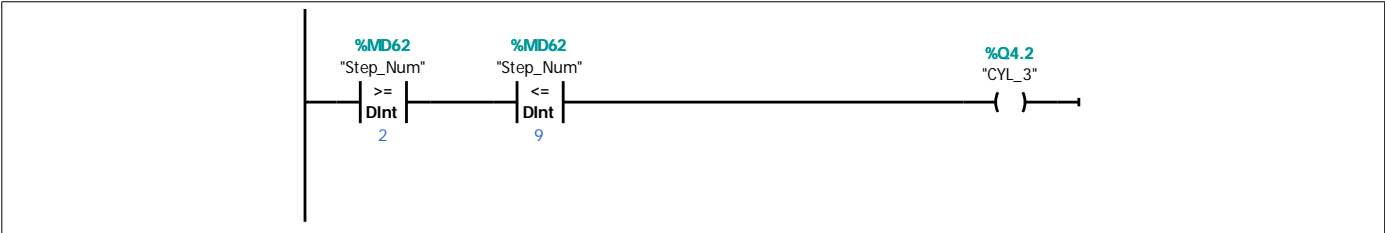


Network 20: Tipper cylinder control



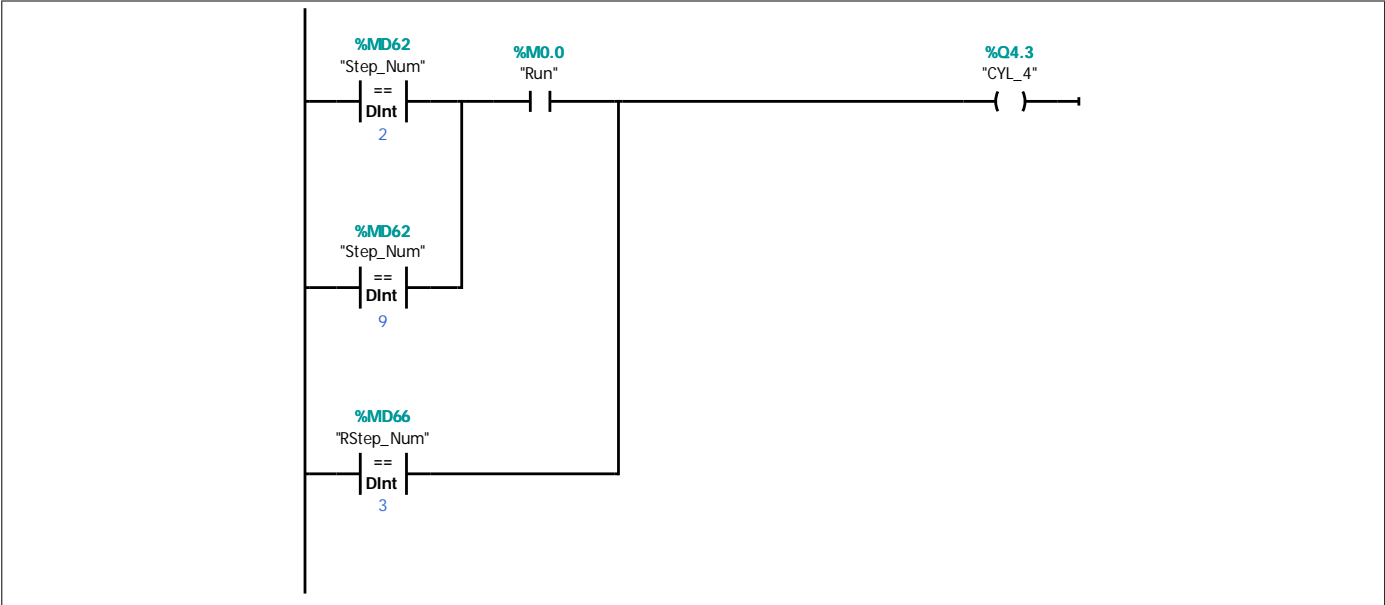
Network 21: Gate cylinder control

Gripper Control



Network 22: Can pusher cylinder control

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



Network 23: Rotation motor control

