

Erbia Can Tipper/Rotator Control

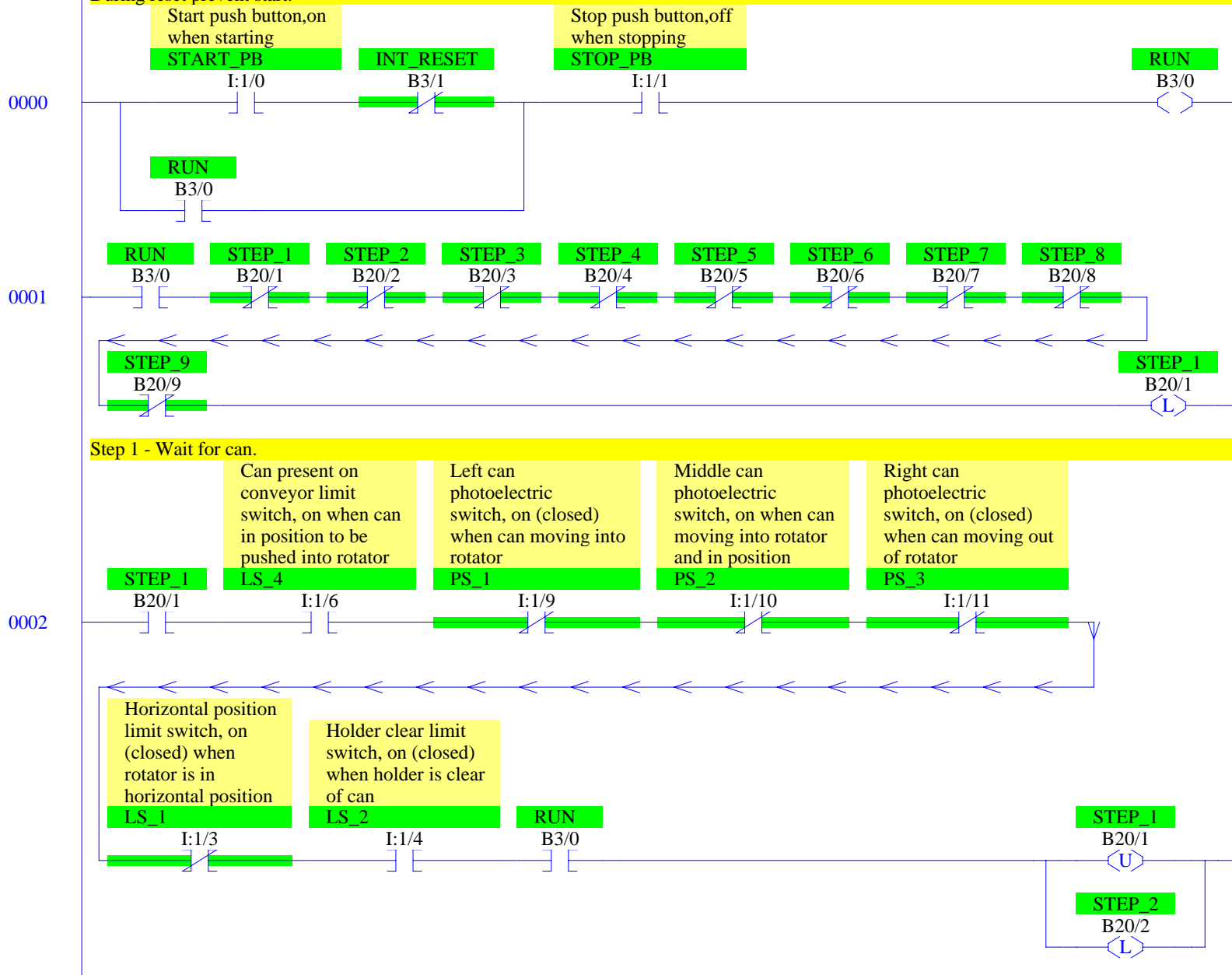
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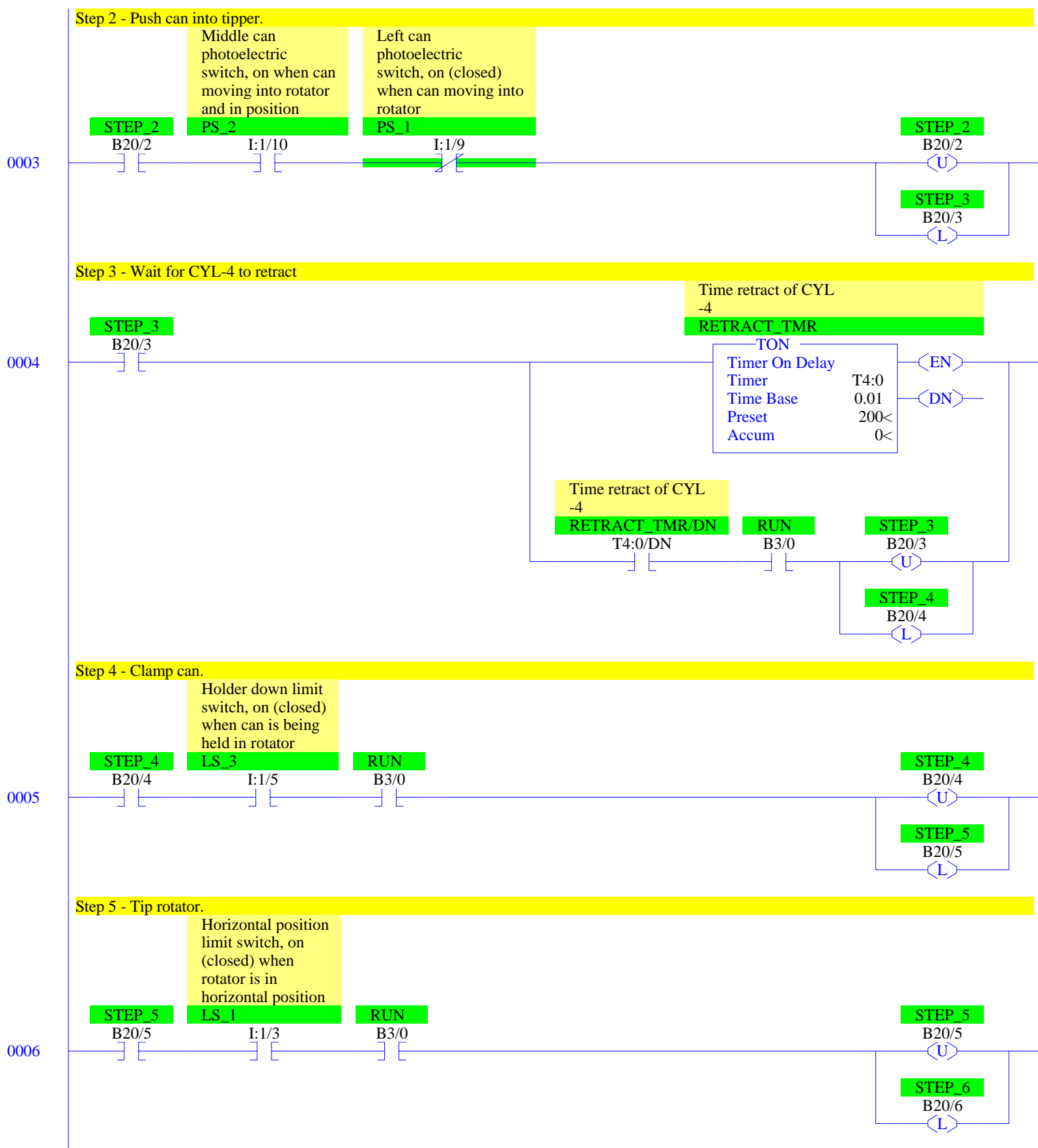
Additional internal memory:

Symbol	Address	
RUN	B3/0	On while station running
INT_RESET	B3/1	Internal reset
STEP_1 to STEP_9	B20/1 to B20/9	Step-in-progress bits
RETRACT_TMR	T4:0	Times retract of CYL-4
BLEND_TMR	T4:1	Times rotation for blend

Start/stop and initial start.

During reset prevent start.





0007

Step 6 - Blend.

Blend timer, 60
sec

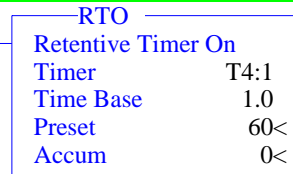
STEP_6

B20/6

RUN

B3/0

BLEND_TMR



EN

DN

Blend timer, 60
sec

BLEND_TMR/DN

T4:1/DN

STEP_6

B20/6

U

STEP_7

B20/7

L

Blend timer, 60
sec

BLEND_TMR

T4:1

RES

0008

Step 7 - Untip.

Vertical position
limit switch, on
(closed) when
rotator in vertical
position

STEP_7

B20/7

LS_5

I:1/7

RUN

B3/0

STEP_7

B20/7

U

STEP_8

B20/8

L

0009

Step 8 - Unclamp.

Holder clear limit
switch, on (closed)
when holder is clear
of can

STEP_8

B20/8

LS_2

I:1/4

RUN

B3/0

STEP_8

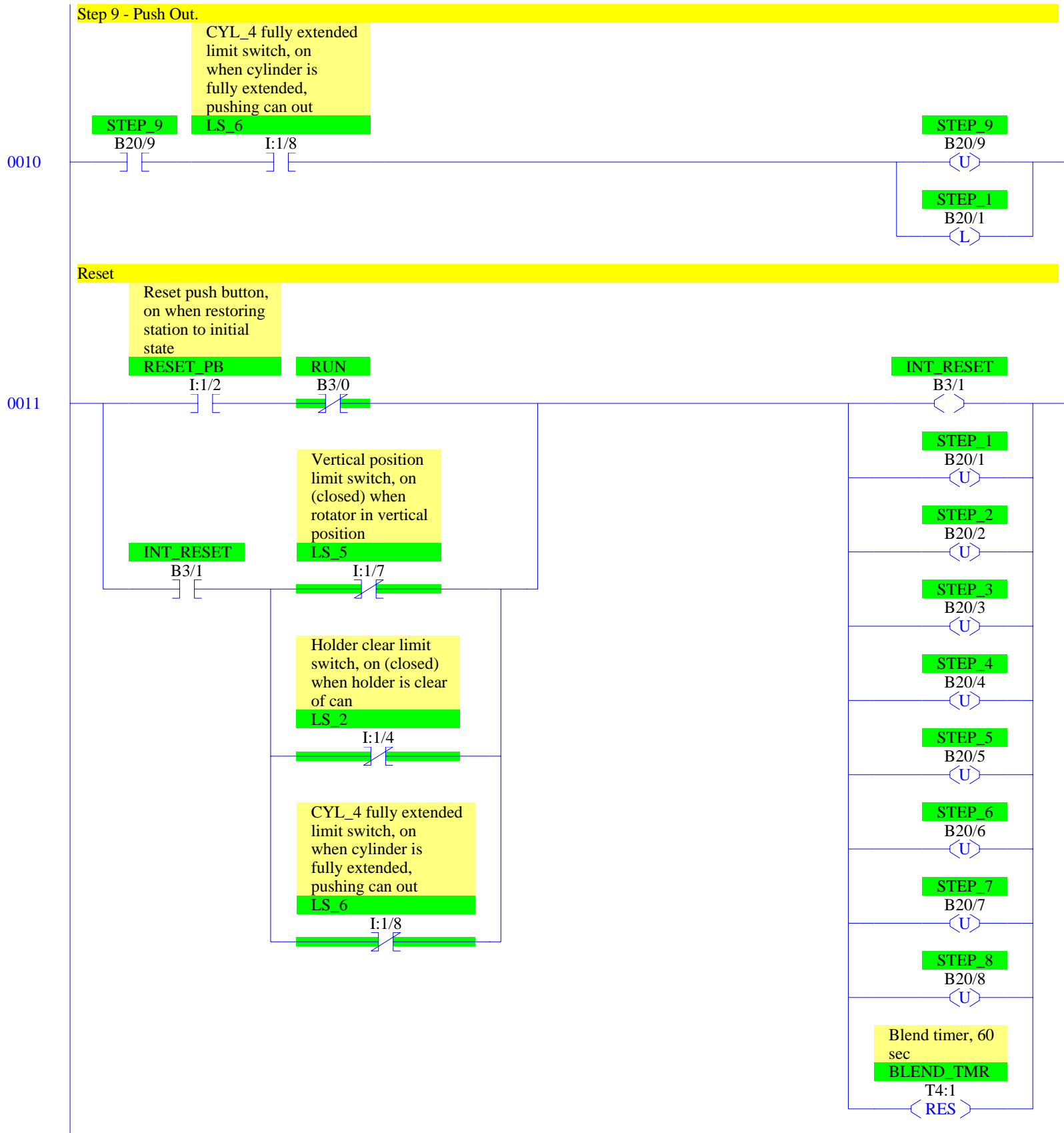
B20/8

U

STEP_9

B20/9

L



Physical Outputs

Can not turn off CYL_1, CYL_2, or CYL_3 when paused.

On reset, do not unclamp until in vertical position.

Can holder cylinder
control, on to clamp
can into rotator

CYL_1

O:2/0

STEP_4

B20/4

STEP_5

B20/5

STEP_6

B20/6

STEP_7

B20/7

INT_RESET

B3/1

Vertical position
limit switch, on
(closed) when
rotator in vertical
position

LS_5

I:1/7

Tipper cylinder
control, on to tip
rotator

CYL_2

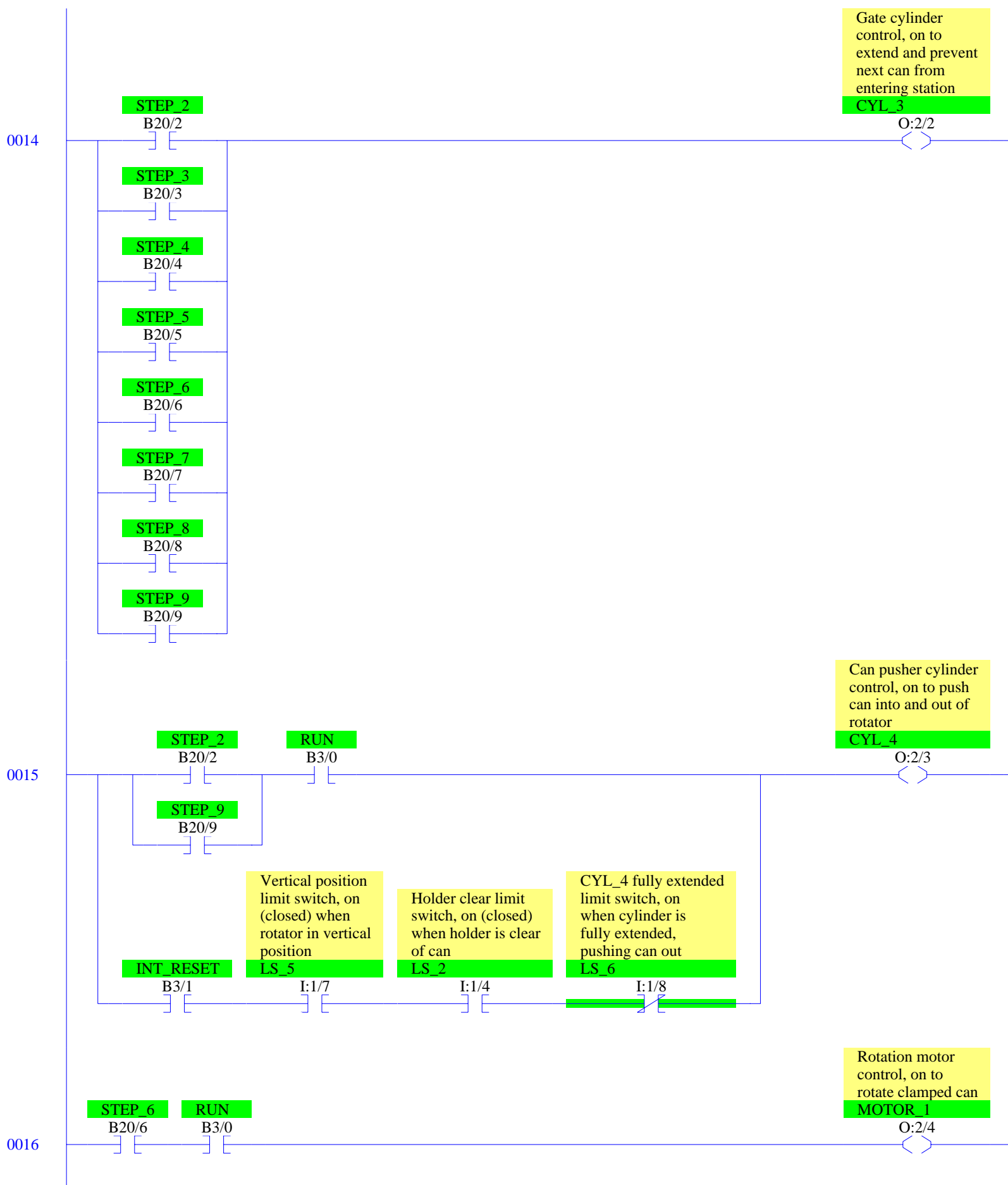
O:2/1

STEP_5

B20/5

STEP_6

B20/6



0017

⟨END⟩

RSLogix 500 Cross Reference Report - Sorted by Address

O:2/0	- {CYL_1} Can holder cylinder control, on to clamp can into rotator OTE - File #2 - 12
O:2/1	- {CYL_2} Tipper cylinder control, on to tip rotator OTE - File #2 - 13
O:2/2	- {CYL_3} Gate cylinder control, on to extend and prevent next can from entering station OTE - File #2 - 14
O:2/3	- {CYL_4} Can pusher cylinder control, on to push can into and out of rotator OTE - File #2 - 15
O:2/4	- {MOTOR_1} Rotation motor control, on to rotate clamped can OTE - File #2 - 16
I:1/0	- {START_PB} Start push button, on when starting XIC - File #2 - 0
I:1/1	- {STOP_PB} Stop push button, off when stopping XIC - File #2 - 0
I:1/2	- {RESET_PB} Reset push button, on when restoring station to initial state XIC - File #2 - 11
I:1/3	- {LS_1} Horizontal position limit switch, on (closed) when rotator is in horizontal position XIC - File #2 - 6 XIO - File #2 - 2
I:1/4	- {LS_2} Holder clear limit switch, on (closed) when holder is clear of can XIC - File #2 - 2, 9, 15 XIO - File #2 - 11
I:1/5	- {LS_3} Holder down limit switch, on (closed) when can is being held in rotator XIC - File #2 - 5
I:1/6	- {LS_4} Can present on conveyor limit switch, on when can in position to be pushed into rotator XIC - File #2 - 2
I:1/7	- {LS_5} Vertical position limit switch, on (closed) when rotator in vertical position XIC - File #2 - 8, 15 XIO - File #2 - 11, 12
I:1/8	- {LS_6} CYL_4 fully extended limit switch, on when cylinder is fully extended, pushing XIC - File #2 - 10 XIO - File #2 - 11, 15
I:1/9	- {PS_1} Left can photoelectric switch, on (closed) when can moving into rotator XIO - File #2 - 2, 3
I:1/10	- {PS_2} Middle can photoelectric switch, on when can moving into rotator and in position XIC - File #2 - 3 XIO - File #2 - 2
I:1/11	- {PS_3} Right can photoelectric switch, on (closed) when can moving out of rotator XIO - File #2 - 2
B3/0	- {RUN} OTE - File #2 - 0 XIC - File #2 - 0, 1, 2, 4, 5, 6, 7, 8, 9, 15, 16 XIO - File #2 - 11
B3/1	- {INT_RESET} OTE - File #2 - 11 XIC - File #2 - 11, 12, 15 XIO - File #2 - 0
T4:0	- {RETRACT_TMR} Time retract of CYL -4 TON - File #2 - 4
T4:0/DN	- XIC - File #2 - 4
T4:1	- {BLEND_TMR} Blend timer, 60 sec RTO - File #2 - 7 RES - File #2 - 7, 11
T4:1/DN	- XIC - File #2 - 7
B20/1	- {STEP_1} OTL - File #2 - 1, 10 OTU - File #2 - 2, 11 XIC - File #2 - 2 XIO - File #2 - 1
B20/2	- {STEP_2} OTL - File #2 - 2 OTU - File #2 - 3, 11 XIC - File #2 - 3, 14, 15 XIO - File #2 - 1
B20/3	- {STEP_3} OTL - File #2 - 3

RSLogix 500 Cross Reference Report - Sorted by Address

	OTU - File #2 - 4, 11
	XIC - File #2 - 4, 14
	XIO - File #2 - 1
B20/4	- {STEP_4}
	OTL - File #2 - 4
	OTU - File #2 - 5, 11
	XIC - File #2 - 5, 12, 14
	XIO - File #2 - 1
B20/5	- {STEP_5}
	OTL - File #2 - 5
	OTU - File #2 - 6, 11
	XIC - File #2 - 6, 12, 13, 14
	XIO - File #2 - 1
B20/6	- {STEP_6}
	OTL - File #2 - 6
	OTU - File #2 - 7, 11
	XIC - File #2 - 7, 12, 13, 14, 16
	XIO - File #2 - 1
B20/7	- {STEP_7}
	OTL - File #2 - 7
	OTU - File #2 - 8, 11
	XIC - File #2 - 8, 12, 14
	XIO - File #2 - 1
B20/8	- {STEP_8}
	OTL - File #2 - 8
	OTU - File #2 - 9, 11
	XIC - File #2 - 9, 14
	XIO - File #2 - 1
B20/9	- {STEP_9}
	OTL - File #2 - 9
	OTU - File #2 - 10
	XIC - File #2 - 10, 14, 15
	XIO - File #2 - 1