










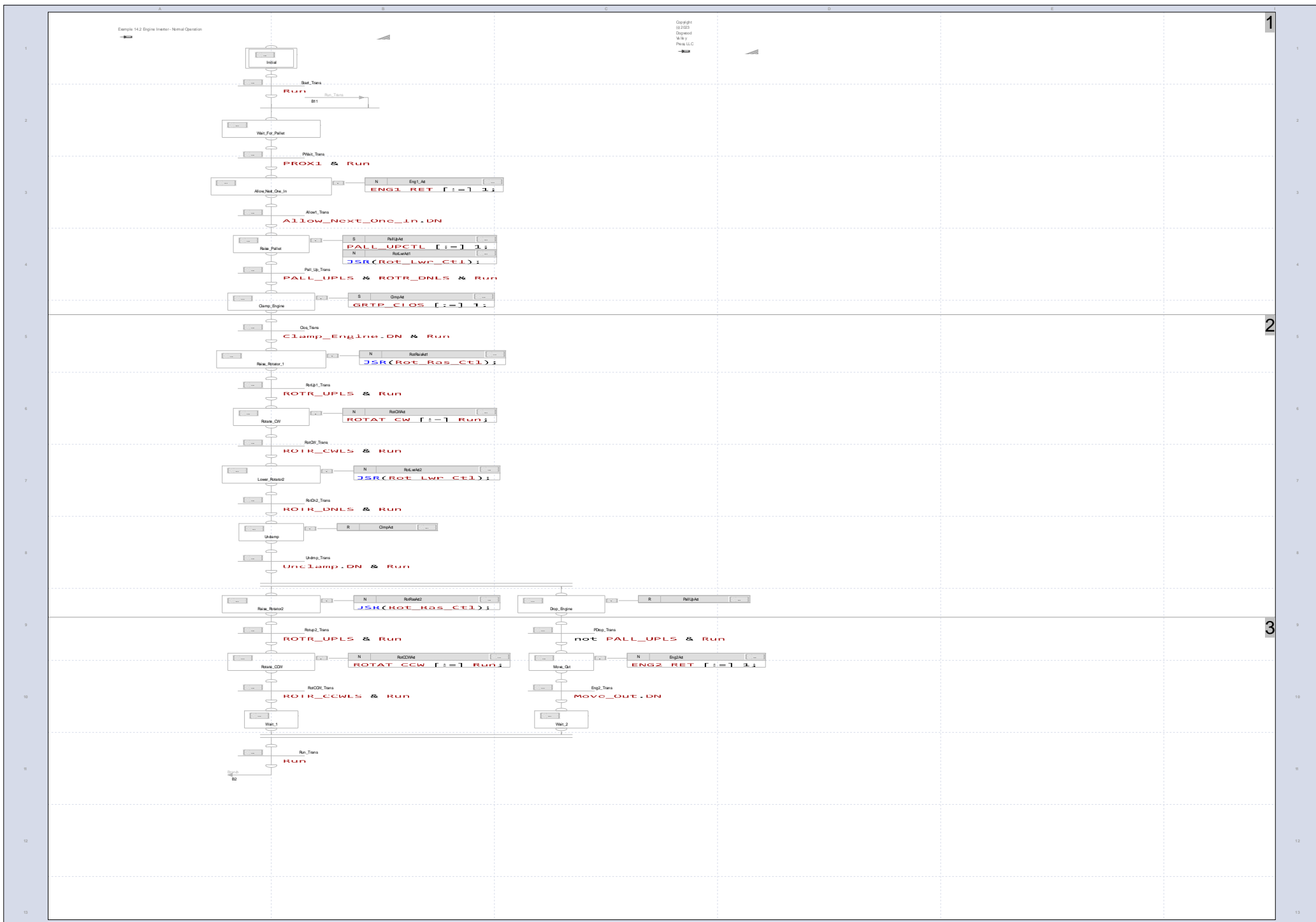
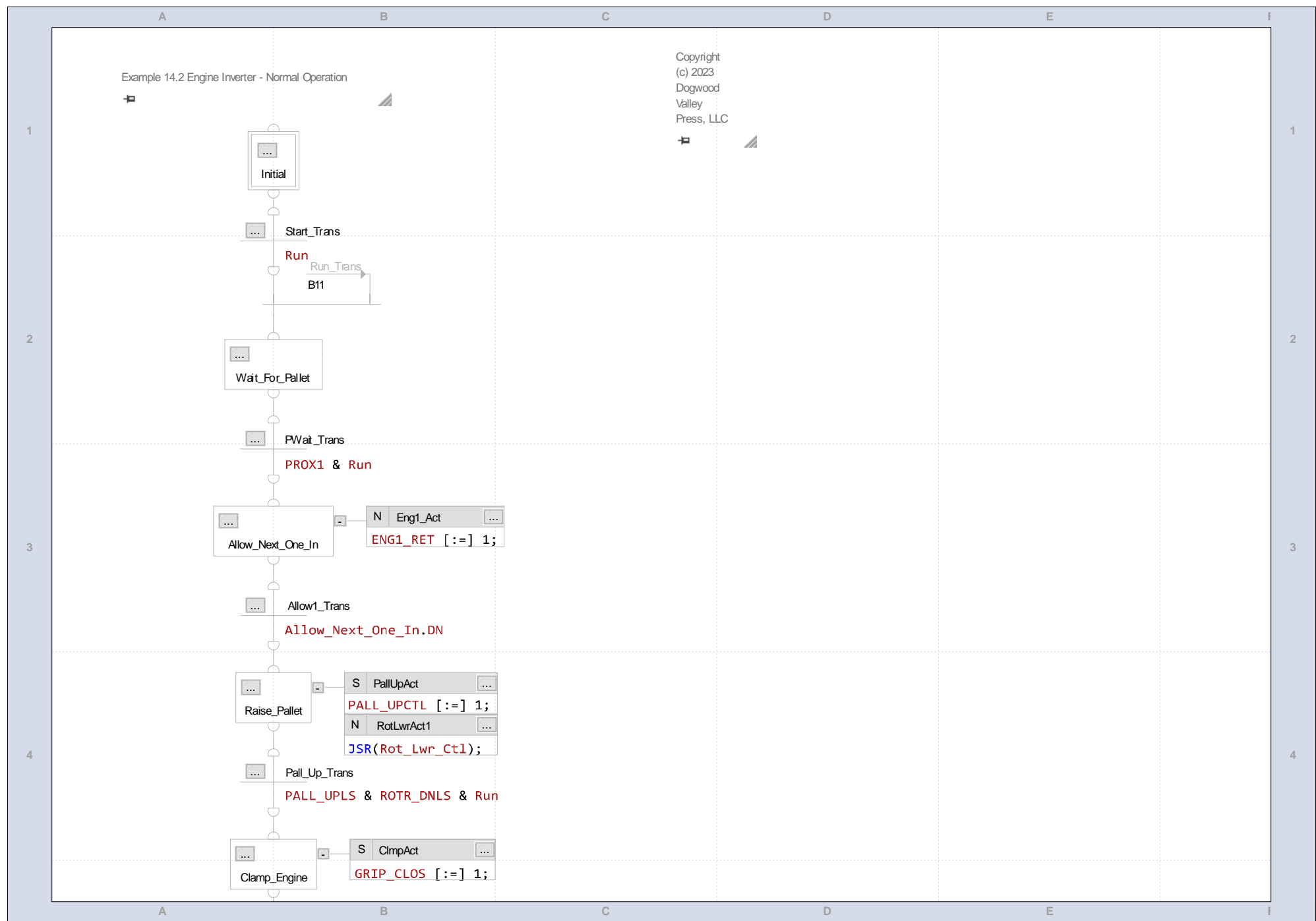
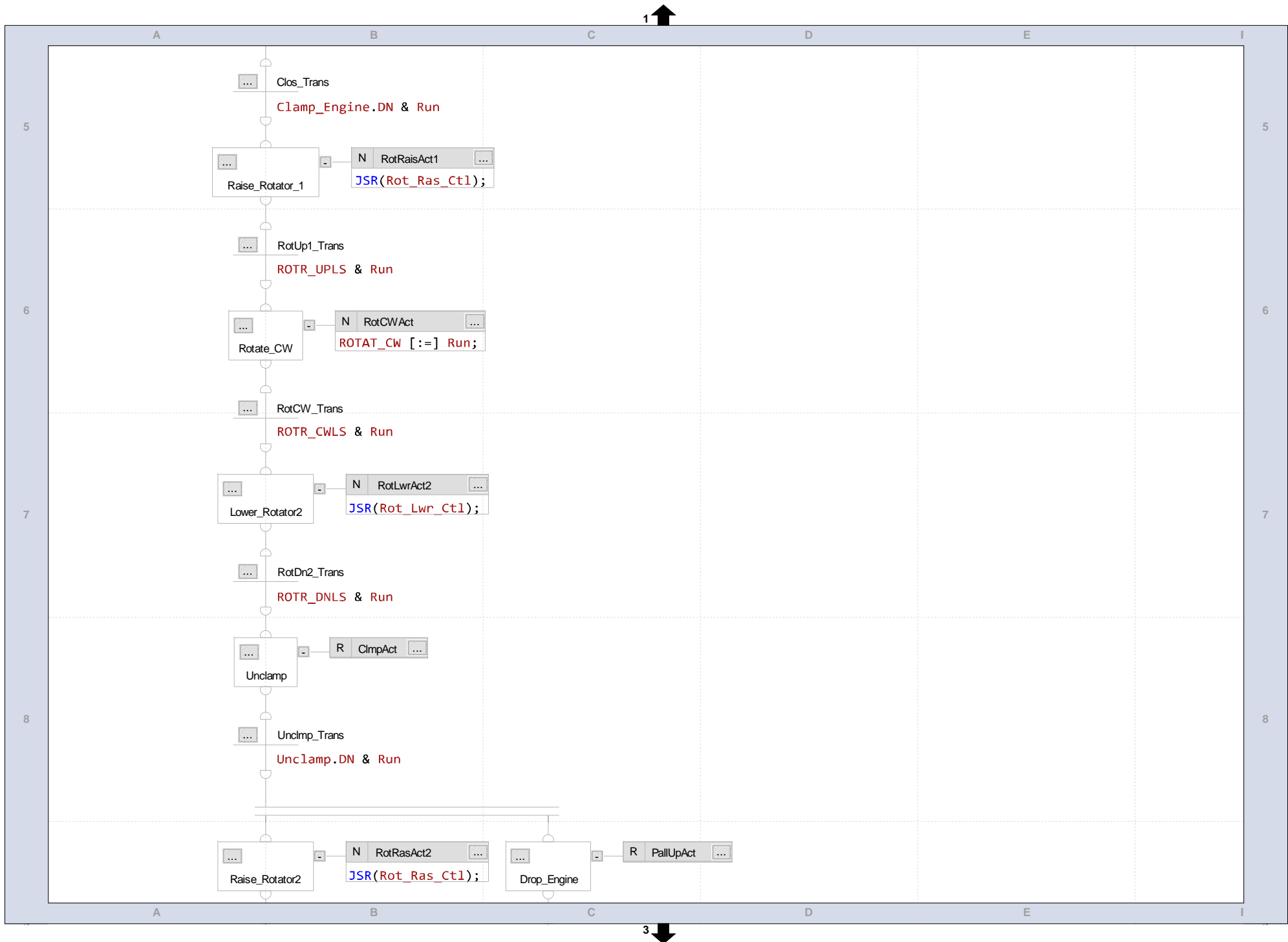
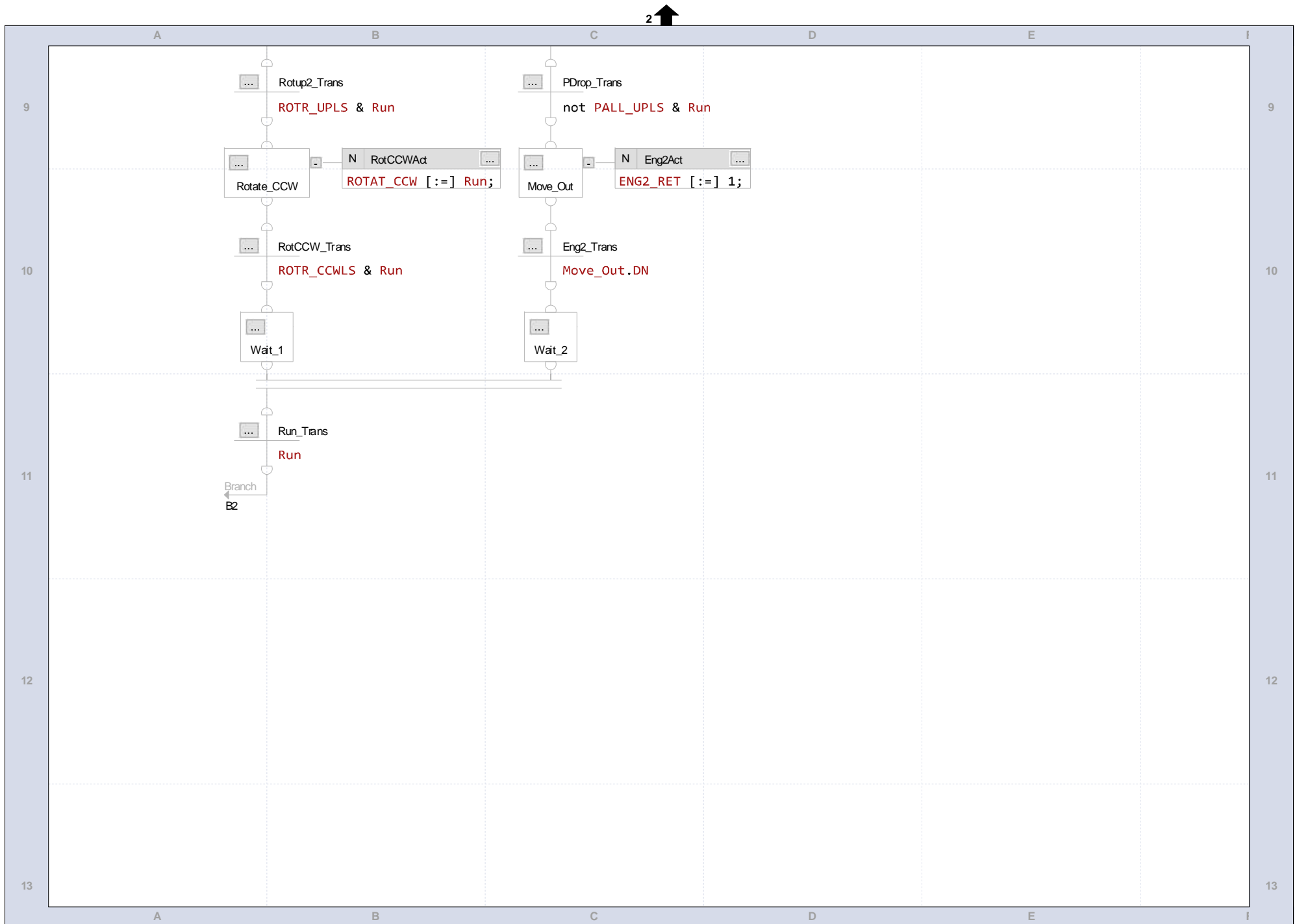


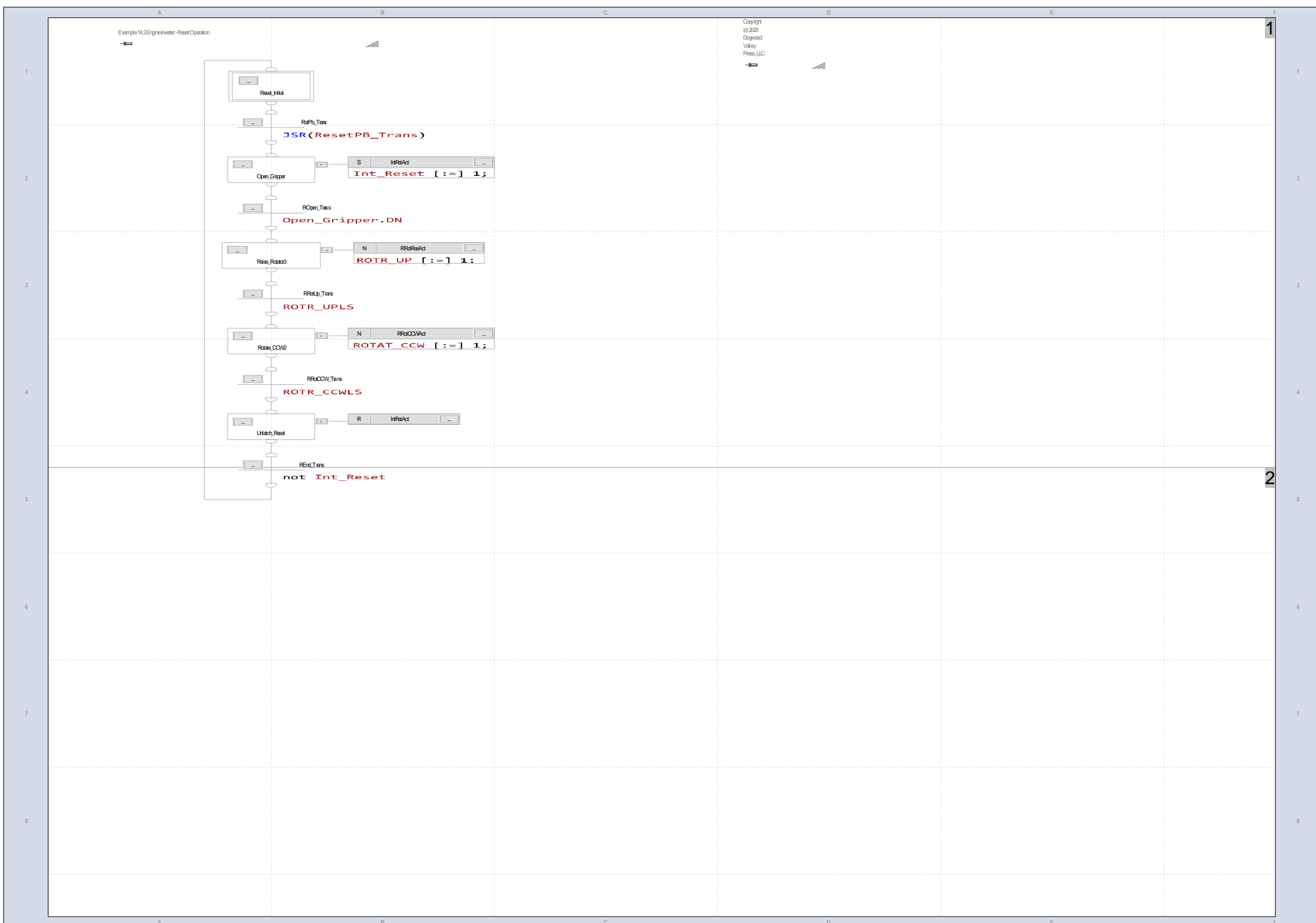
 Controller Example_14_2 Controller Fault Handler Power-Up Handler**Tasks** MainTask MainProgram MainRoutine Invert_Main Invert_Reset ResetPB_Trans Rot_Lwr_Ctl Rot_Ras_Ctl Simulation Simulation Unscheduled**Motion Groups** Ungrouped Axes**Add-On Instructions****Data Types** User-Defined Strings Add-On-Defined Module-Defined AB:1756_DI:C:1 AB:1756_DI:I:0 AB:1756_DO:C:0 AB:1756_DO:I:0 AB:1756_DO:O:0**Trends****I/O Configuration** 1756 Backplane, 1756-A10 [0] 1756-L71 Example_14_2 [1] 1756-IB32/A Disc_In [2] 1756-OB16I Disc_Out

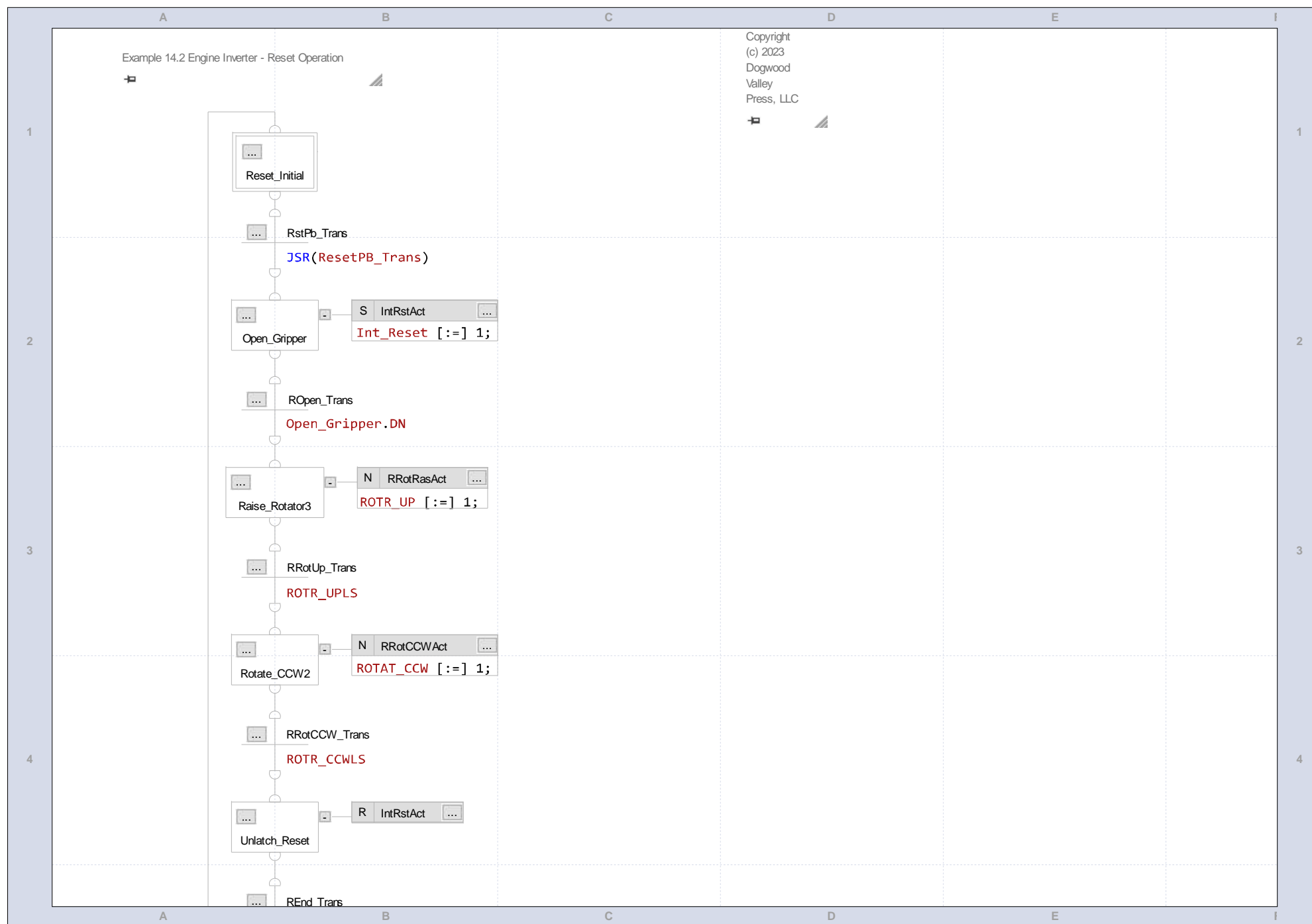


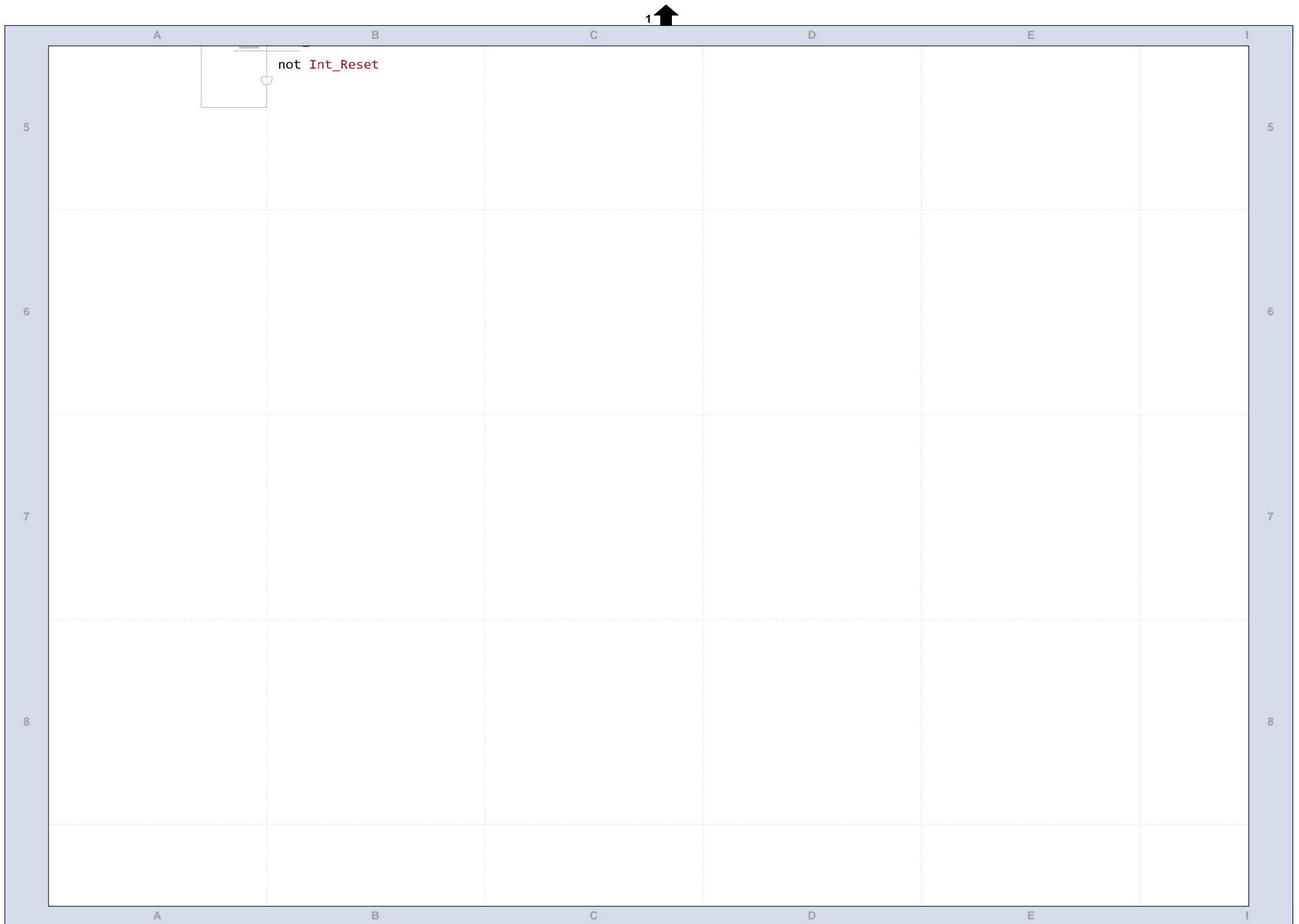


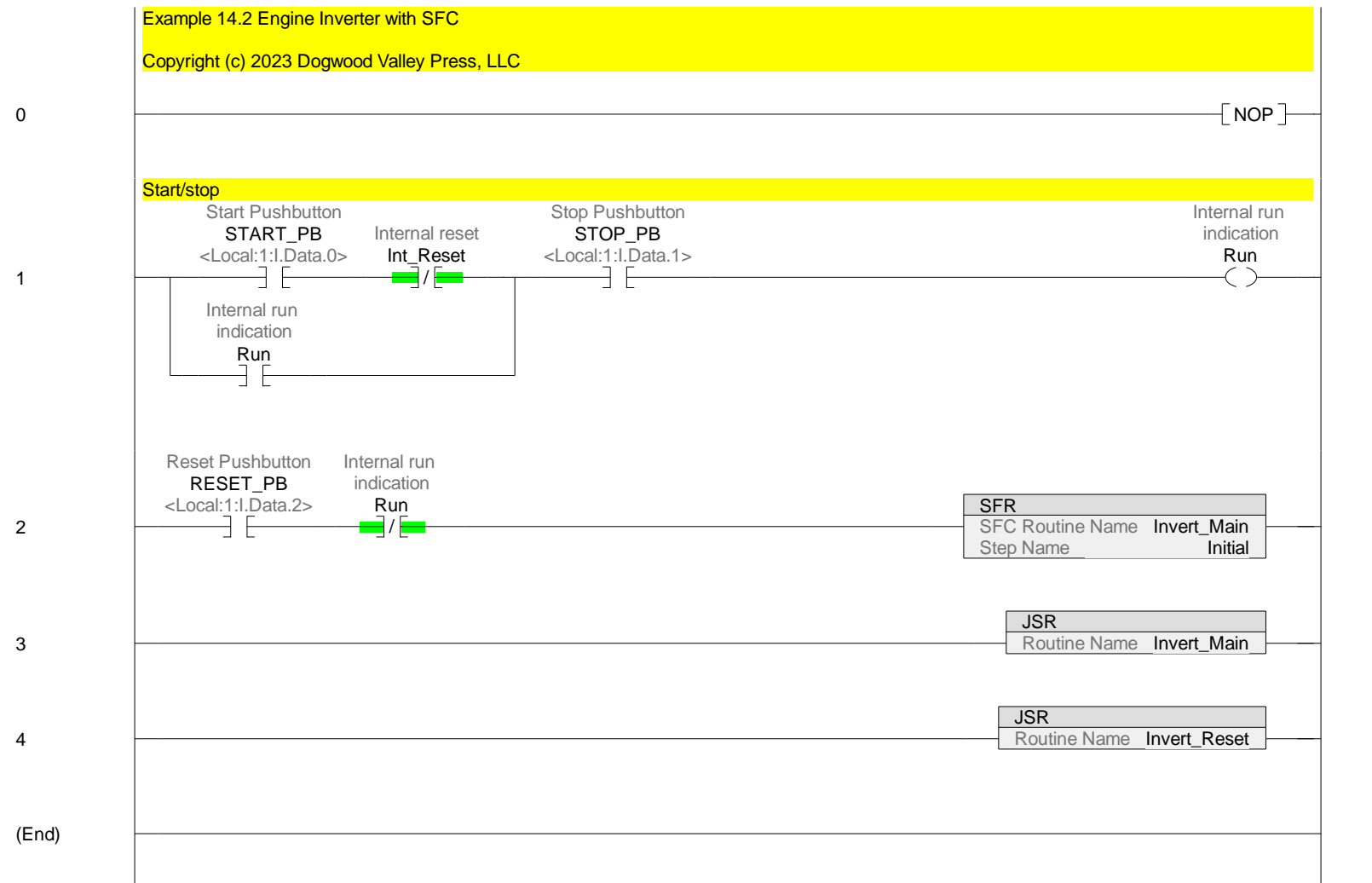








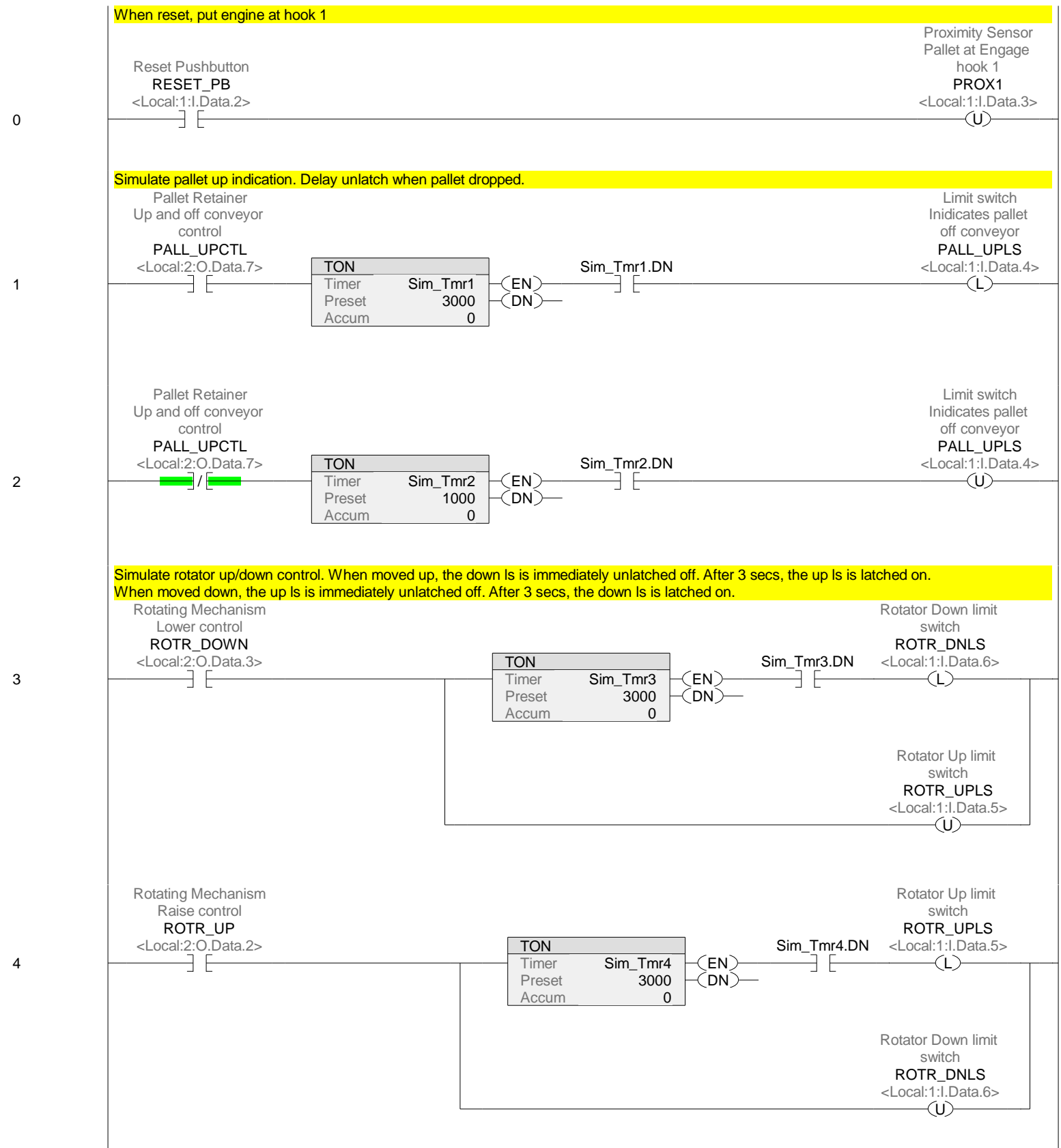




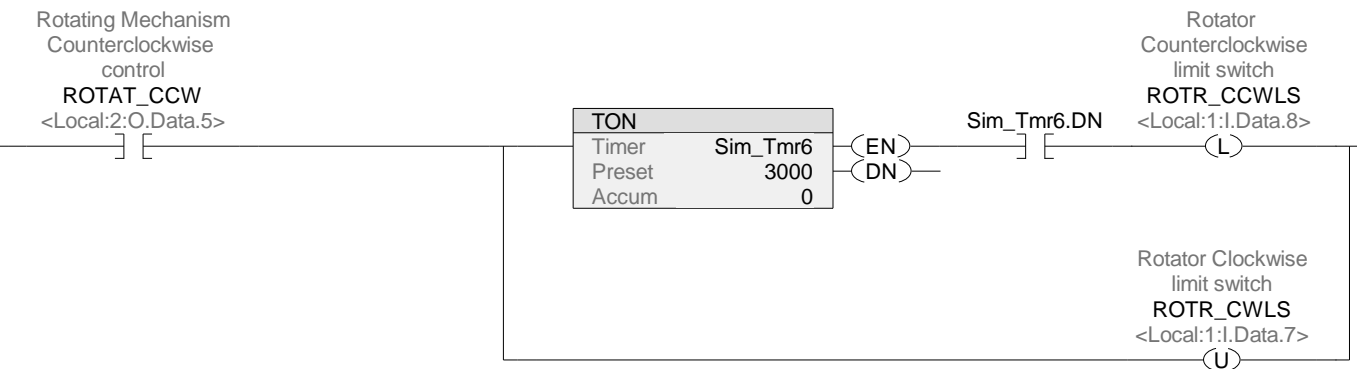
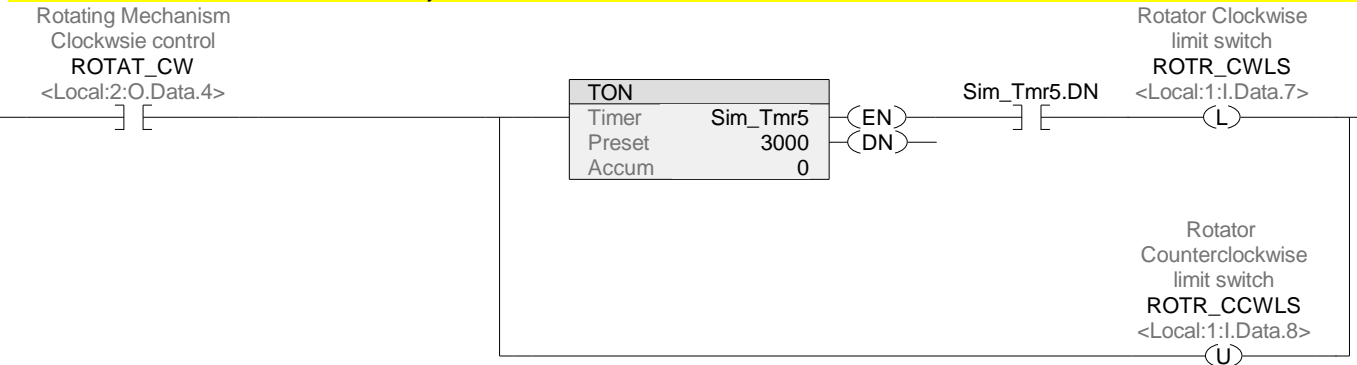
```
1 //Detect only one transition of reset pushbutton
2 OSRI_Rst_PB.InputBit := RESET_PB;
3 OSRI(OSRI_Rst_PB);
4 TmpBit := OSRI_Rst_PB.OutputBit & not Run;
5 EOT(TmpBit);
```

```
1 // Rotating mechanism lower cylinder control
2 ROTR_DOWN [:=] Run;
```

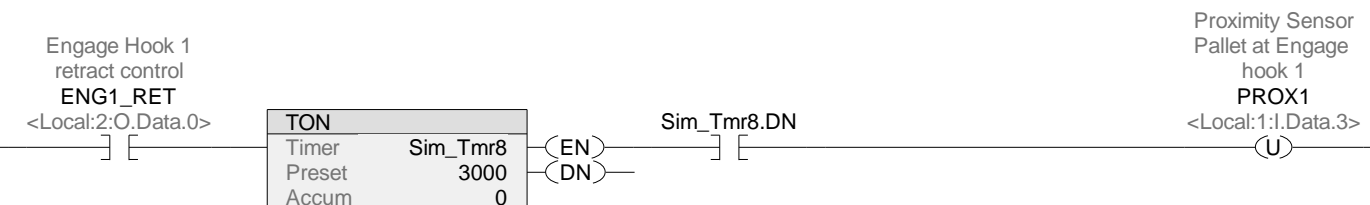
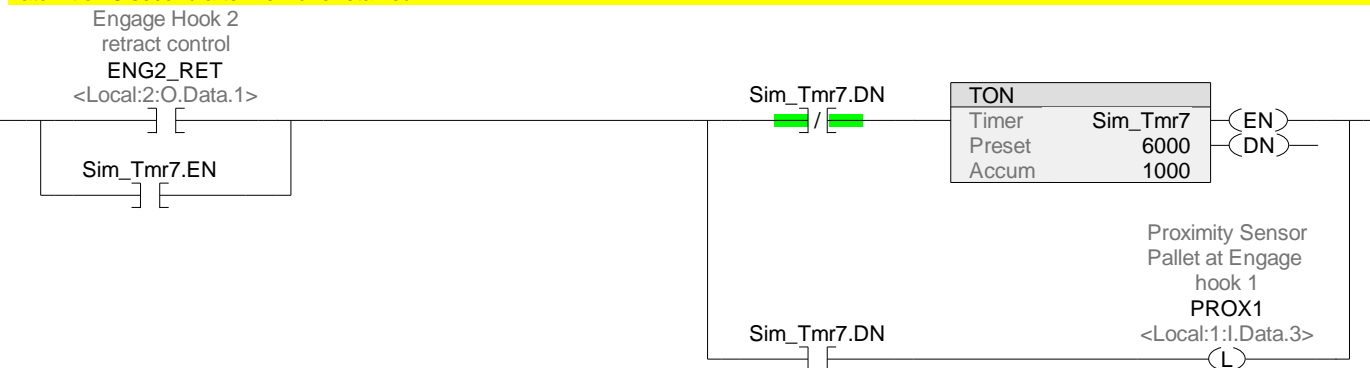
```
1 // Rotating mechanism raise cylinder control
2 ROTR_UP [:=] Run;
```



Simulate rotator rotating control. When rotated CW, the CCW Is is immediately unlatched off. After 3 secs, the CW Is is latched on.
When rotated CCW, the CW Is is immediately unlatched off. After 3 secs, the CCW Is is latched on.



Simulate Pallet Prox
Latch it on 6 seconds after one has left the station.
Latch it off 3 second after new one retained.



(End)

Example_14_2

Label does not exist	1
MainTask	
MainProgram	
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ResetPB_Trans	
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