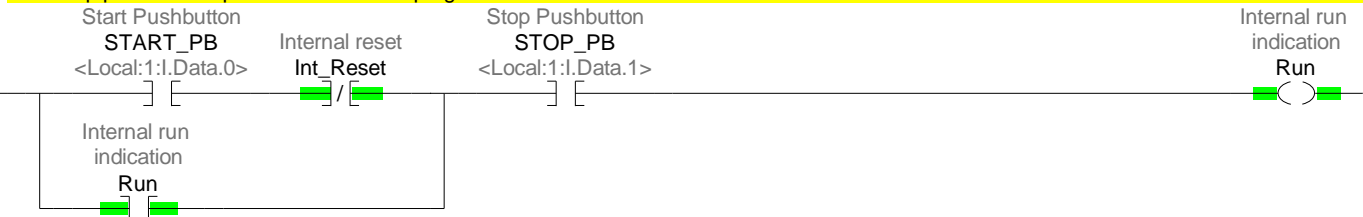


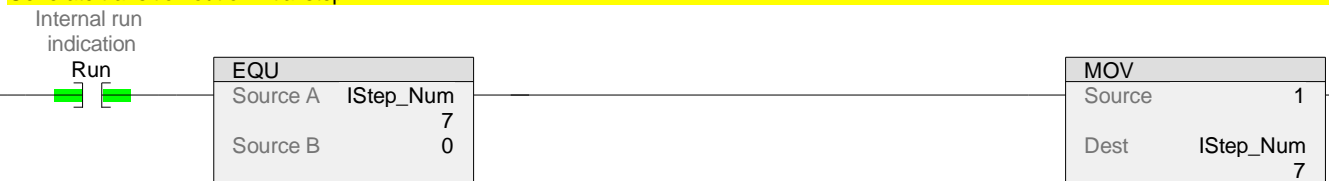
Example 9.1 - Engine Inverter with move-based sequencer

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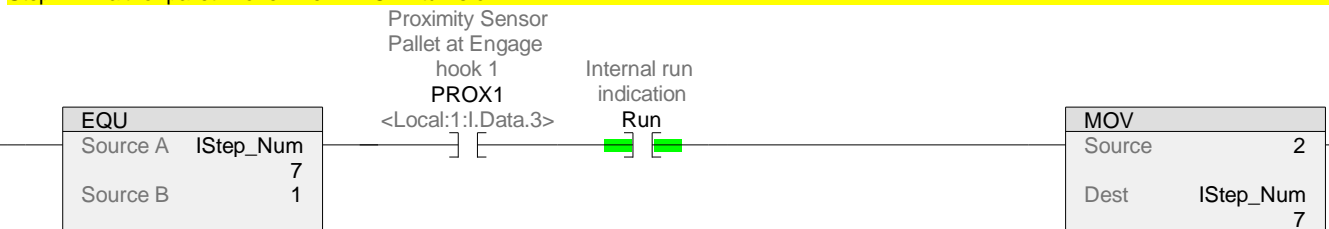
Start/stop/pause. Start prevented if reset in progress.



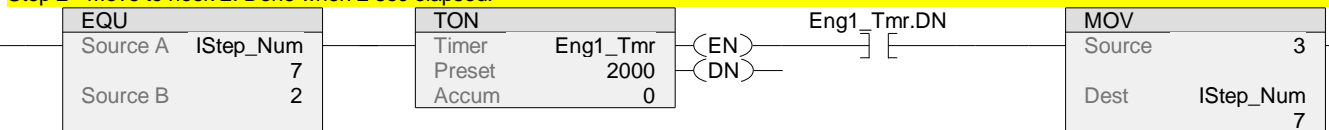
Generate transition out of initial step



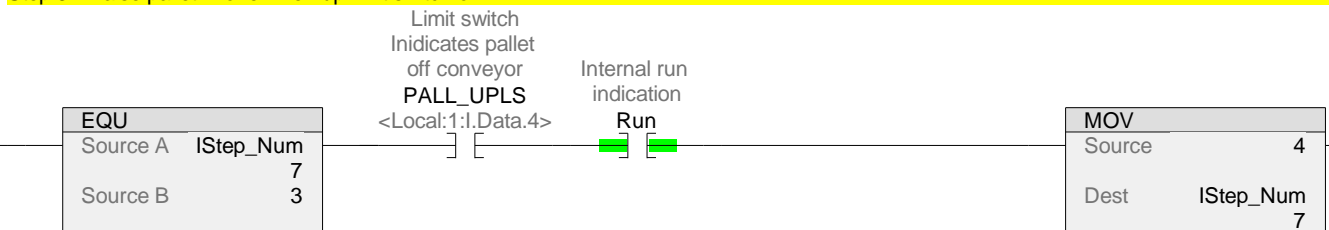
Step 1 - Wait for pallet. Done when PROX1 turns on.



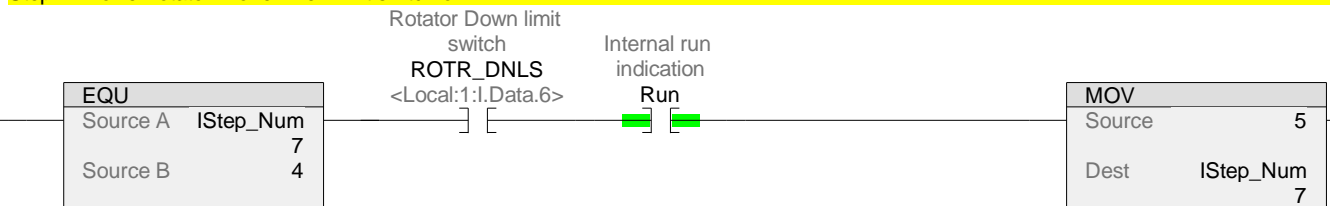
Step 2 - Move to hook 2. Done when 2 sec elapsed.



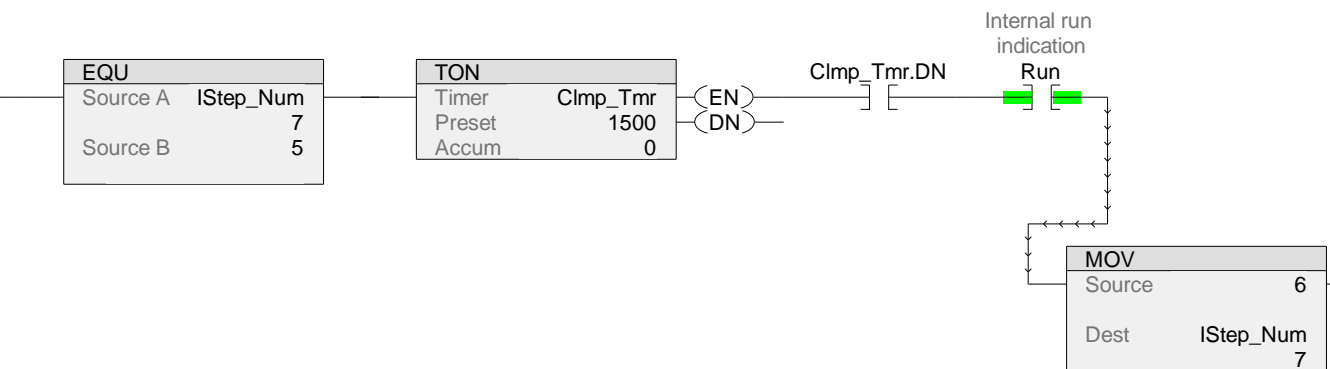
Step 3 - Raise pallet. Done when up limit switch on.



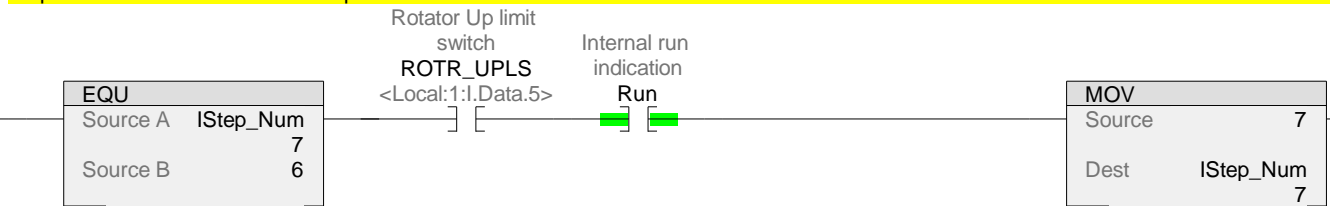
Step 4 - Lower rotator. Done when limit switch on.



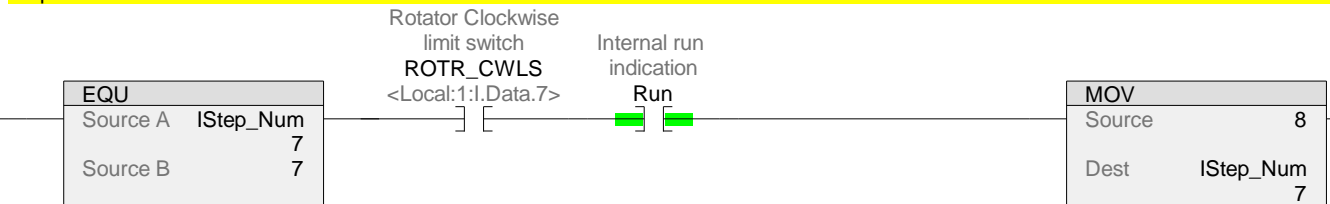
Step 5 - Clamp engine. Done when 1.5 sec elapsed.



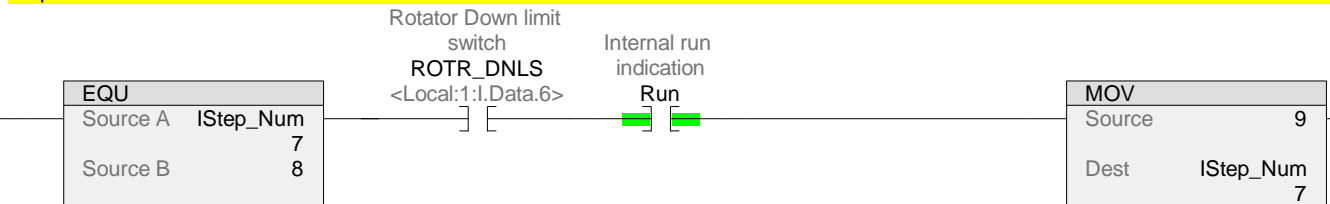
Step 6 - Raise rotator. Done when up limit switch on.



Step 7 - Rotate CW. Done when cw limit switch on.

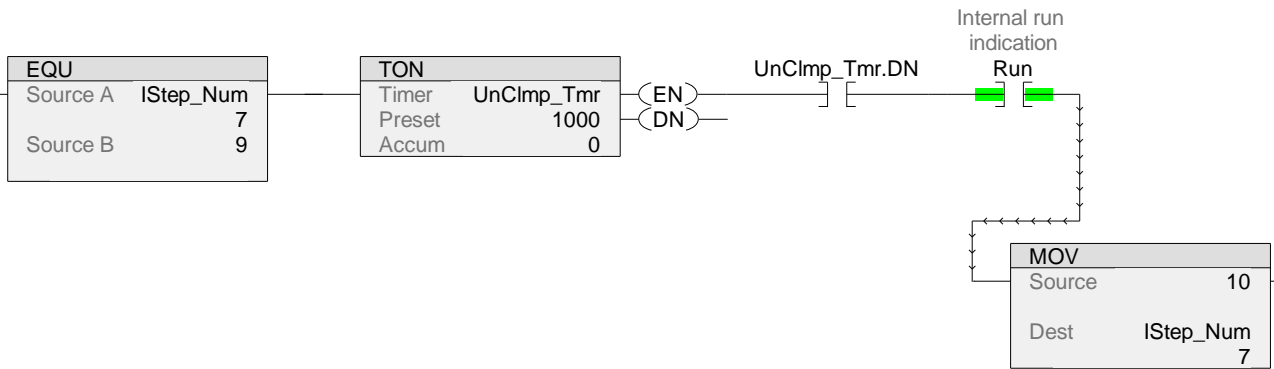


Step 8 - Lower rotator. Done when down limit switch on.



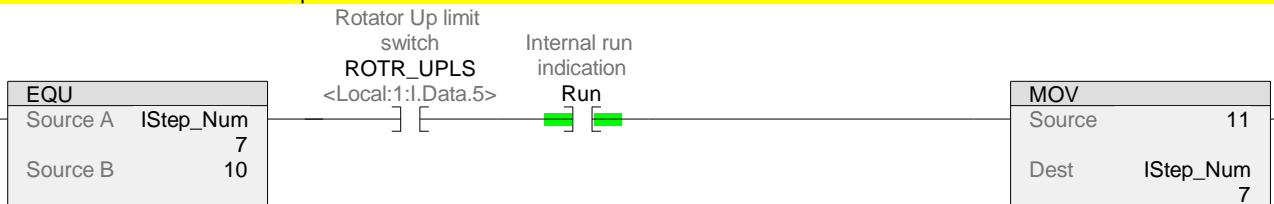
Step 9 - Unclamp engine. Done when 1 sec elapsed.

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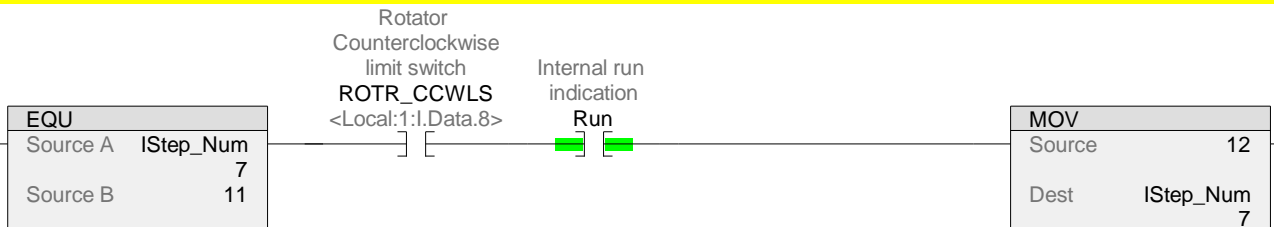
Step 10 - Raise rotator. Done when up limit switch on.

12



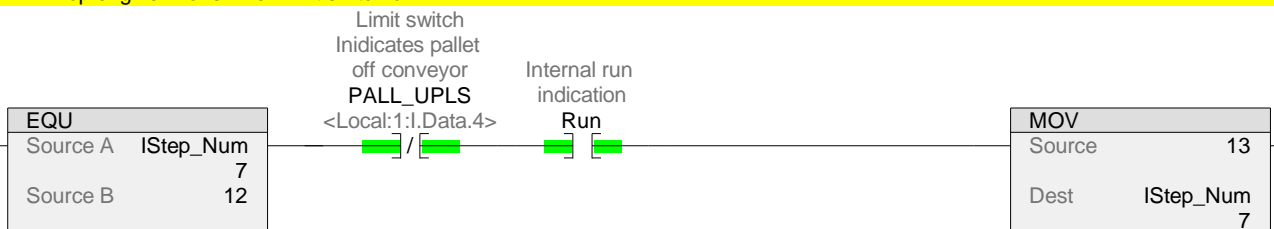
Step 11 - Rotate CCW. Done when ccw switch on.

13

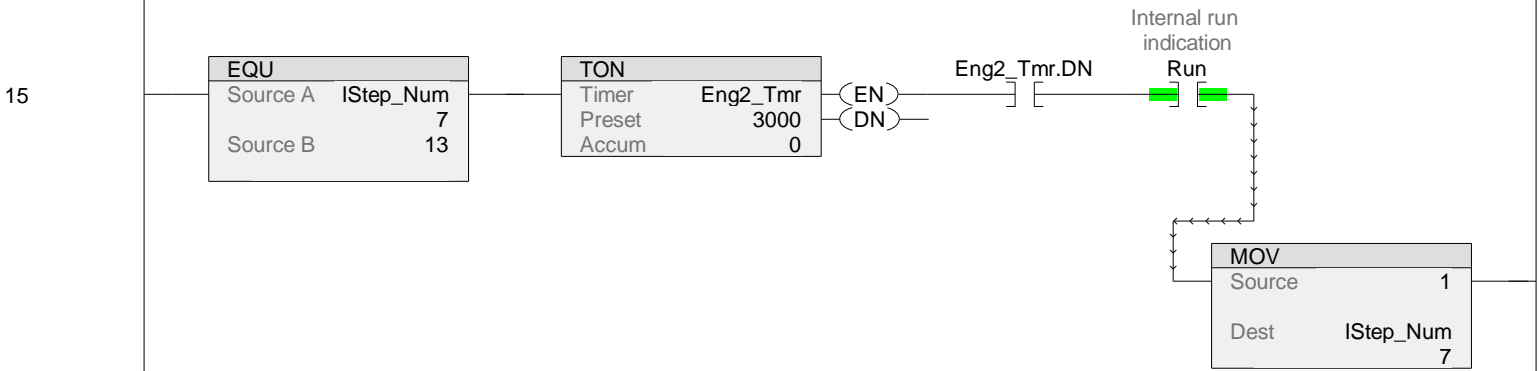


Step 12 - Drop engine. Done when limit switch off.

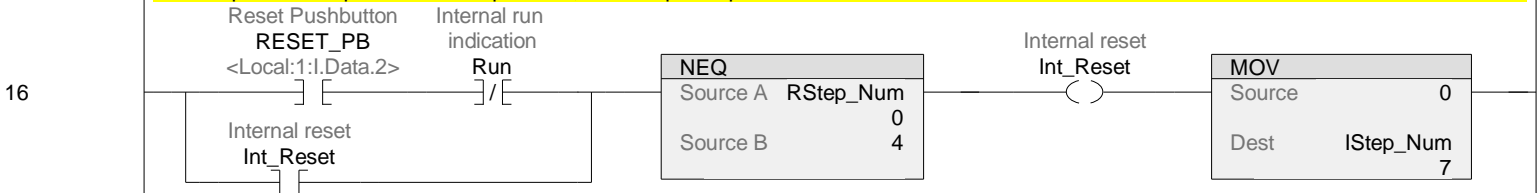
14



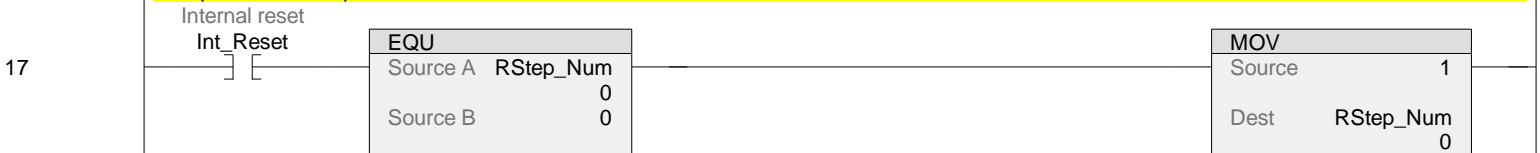
Step 13 - Move pallet out. Done when 3 sec elapsed. Jump to step 1.



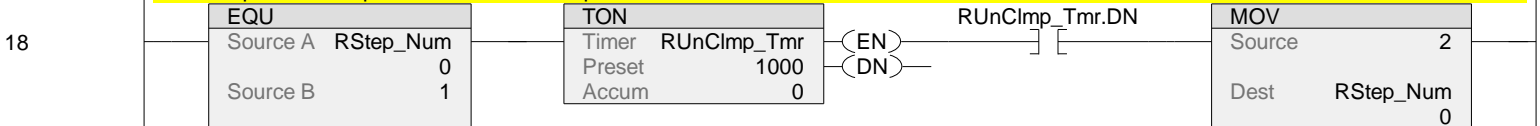
Start/stop for reset operation. Reset pb starts, reset step 4 stops it.



First press of Reset pb starts reset.



Reset step 1 - Unclamp. Done when 1 sec elapsed.



Reset step 2 - Raise mechanism. Done when up limit switch is on.

