











 **Controller Example_6_3** **Controller Fault Handler** **Power-Up Handler****Tasks** **MainTask** **MainProgram** **MainRoutine** **Simulation** **Simulation** **Unscheduled****Motion Groups** **Ungrouped Axes****Add-On Instructions****Data Types** **User-Defined** **Seq_Type**

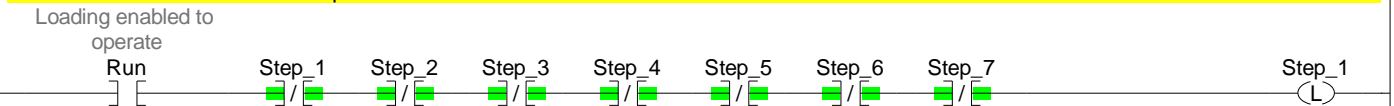
Counter-Based Sequencer

 **Strings** **Add-On-Defined** **Module-Defined** **AB:1756_DI:C:0** **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_6_3** **[1] 1756-IB32/A Dig_In** **[2] 1756-OB16I Dig_Out**

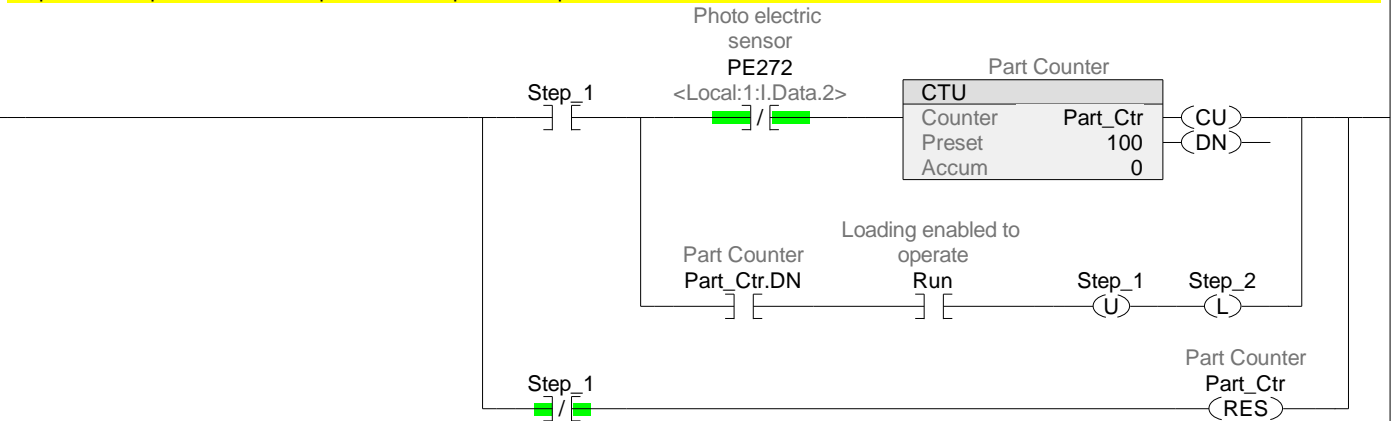
Example 6.3 Tub Loader With Simulation

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Generate transition out of initial step



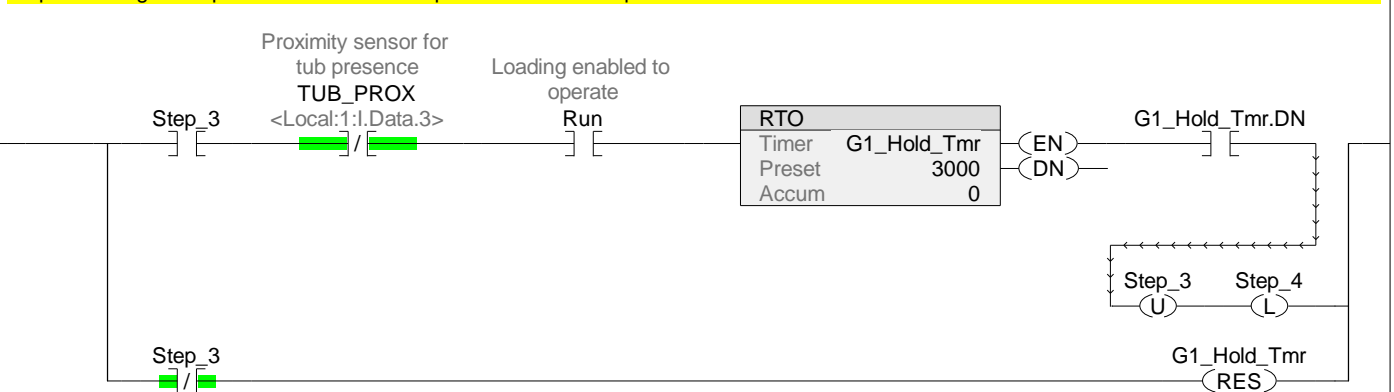
Step 1 - Count parts. Trans to step 2 when 100 parts have passed.



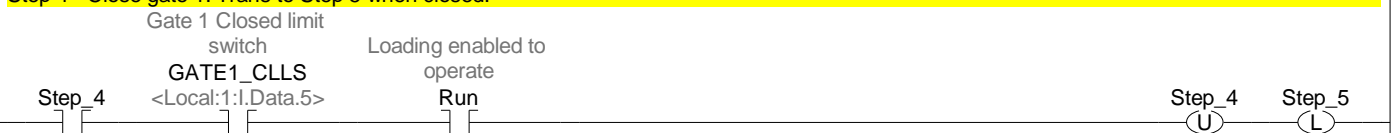
Step 2 - Open gate 1. Trans to step 3 when open.



Step 3 - Hold gate 1 open for 3 secs after tub passes. Trans to step 4 when done.



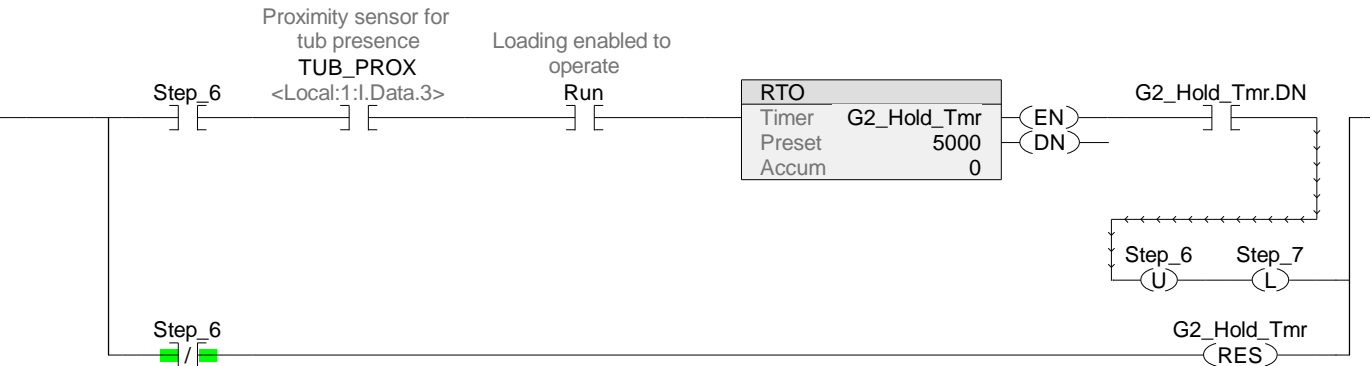
Step 4 - Close gate 1. Trans to Step 5 when closed.



Step 5 - Open gate 2. Trans to step 6 when open.



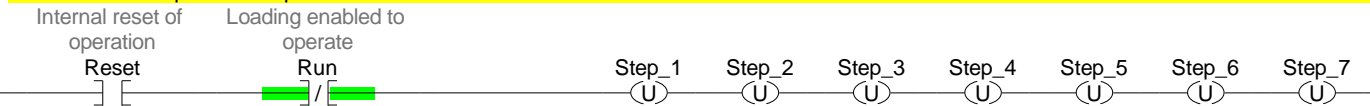
Step 6 - Hold gate 2 open for 5 secs after tub in. Trans to step 7 when delay done.



Step 7 - Close gate 2. Trans to step 1 when closed.



Reset of normal operation steps



***** Control of Physical Outputs *****

Belt conveyor control



Roll conveyor control

