








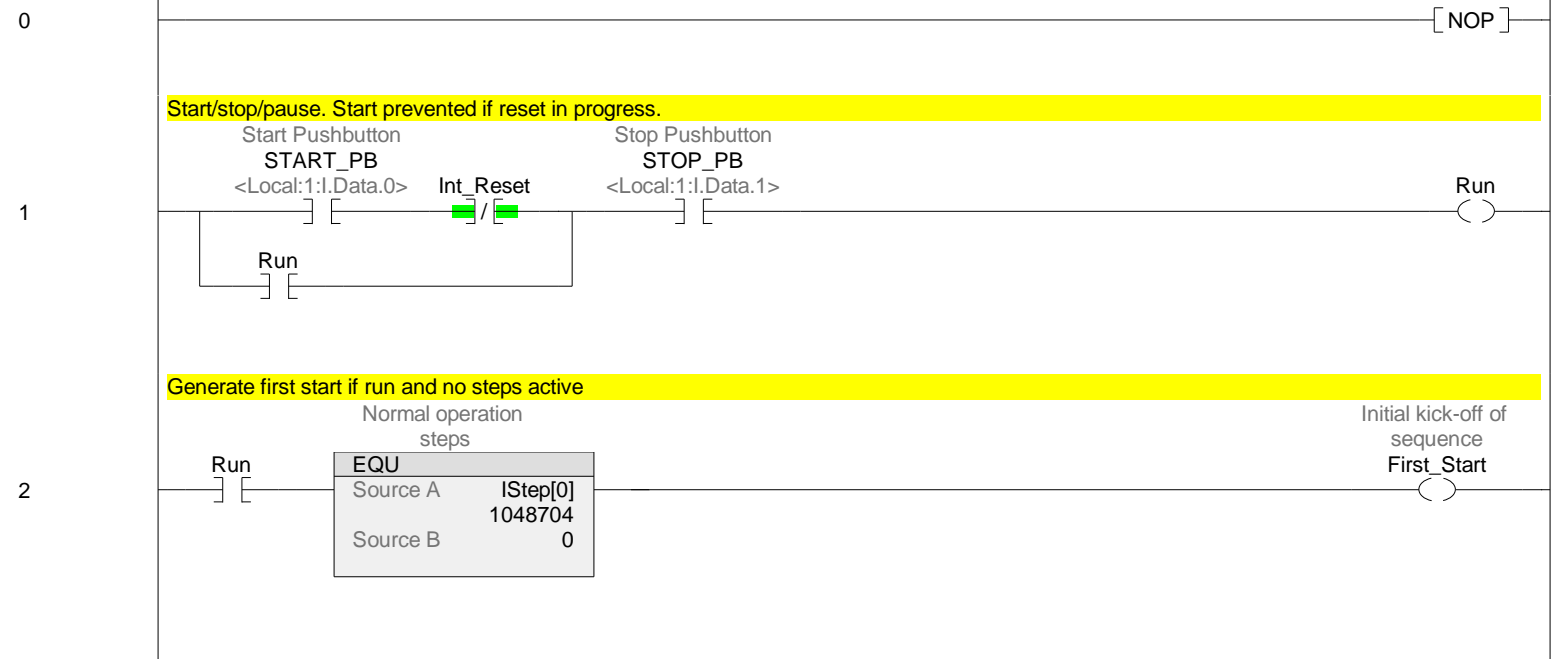


 Controller Example\_9\_3 Controller Fault Handler Power-Up Handler**Tasks** MainTask MainProgram MainRoutine Simulation Simulation Unscheduled**Motion Groups** Ungrouped Axes**Add-On Instructions****Data Types** User-Defined Strings Add-On-Defined Module-Defined AB:1756\_DI:C:1 AB:1756\_DI:I:0 AB:1756\_DO:C:0 AB:1756\_DO:I:0 AB:1756\_DO:O:0**Trends****I/O Configuration** 1756 Backplane, 1756-A10 [0] 1756-L71 Example\_9\_3 [1] 1756-IB32/A Disc\_In [2] 1756-OB16I Disc\_Out

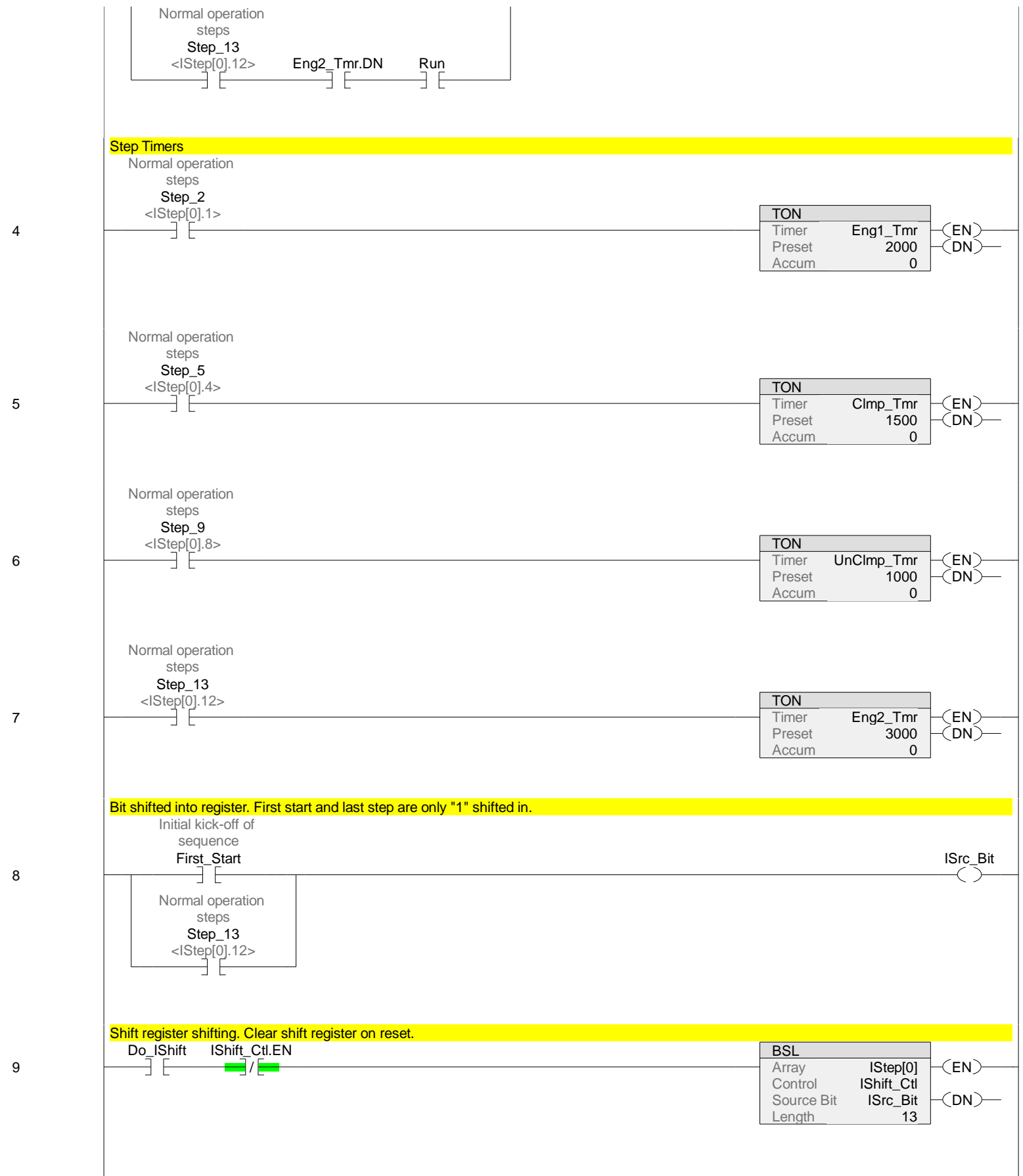
## Example 9.3 Engine Inverter with shift register-based sequence - With Simulation

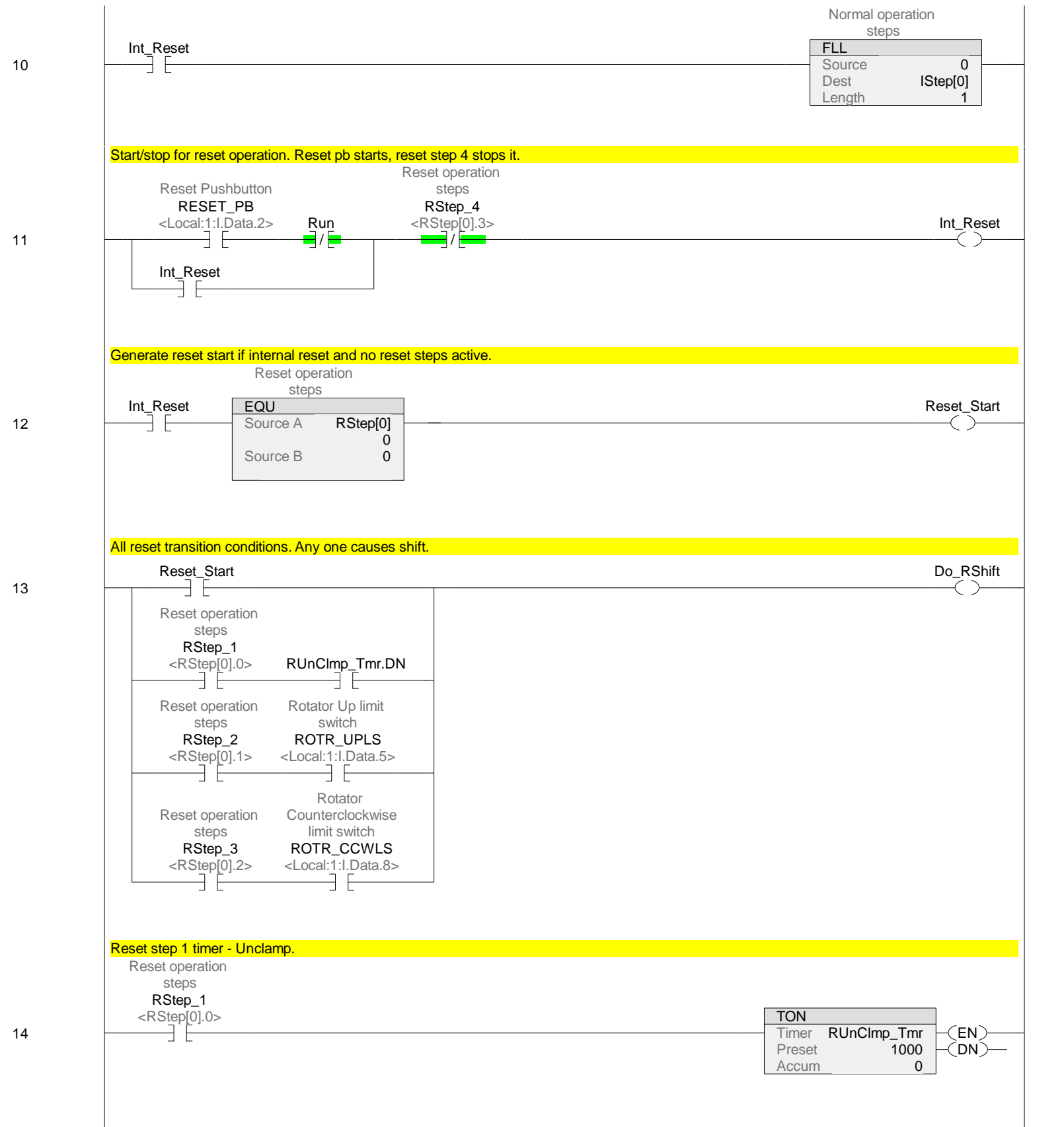
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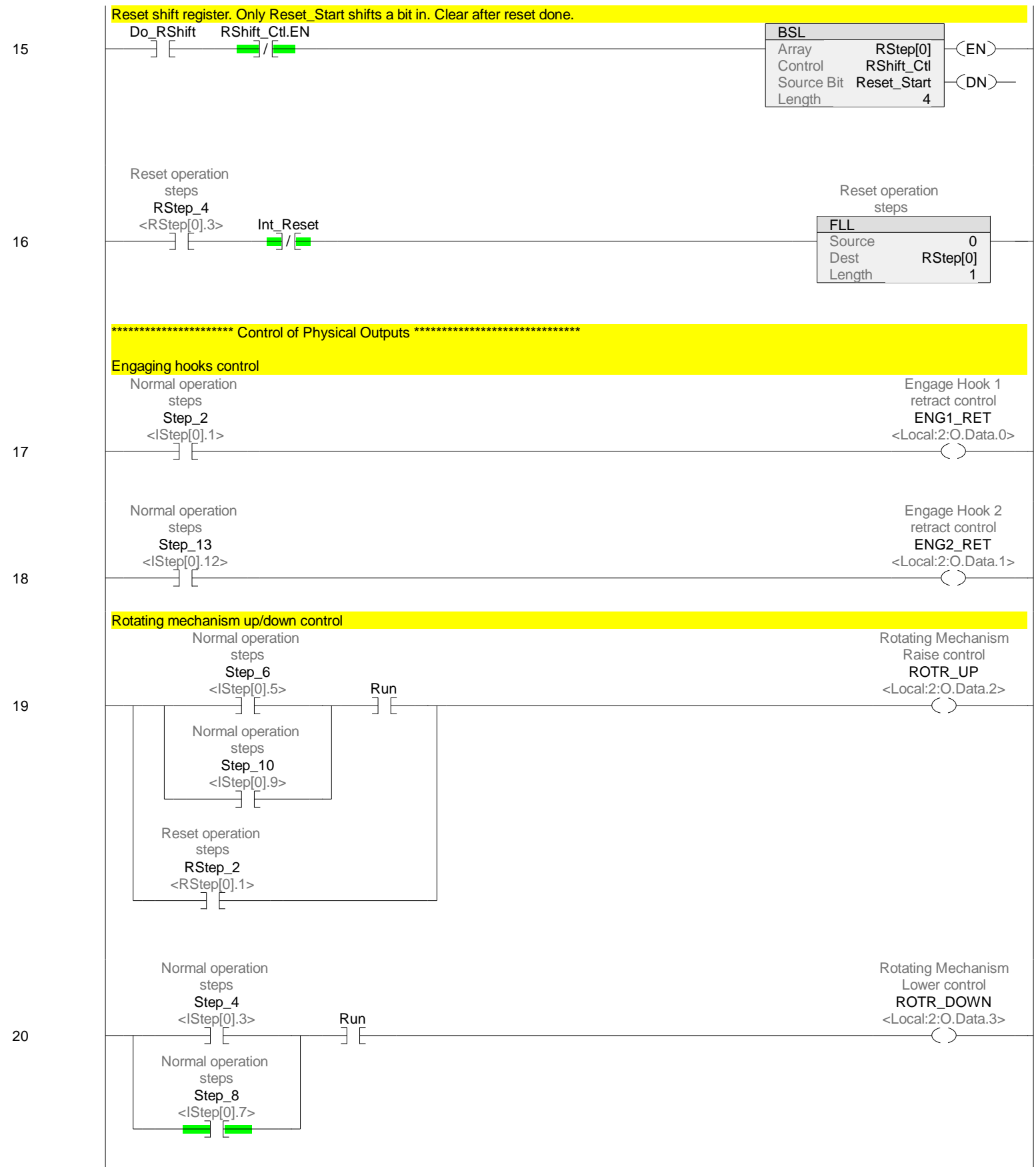


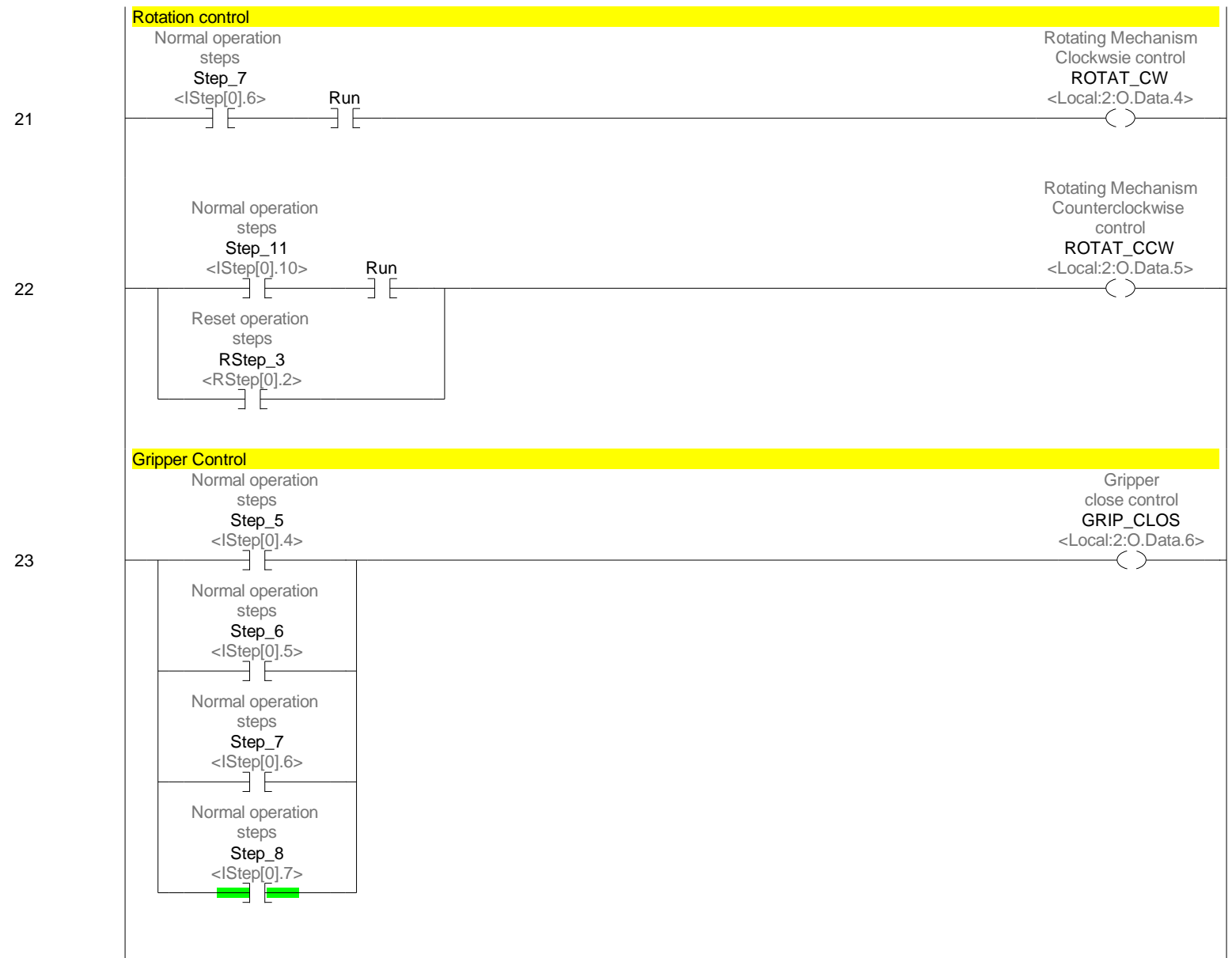
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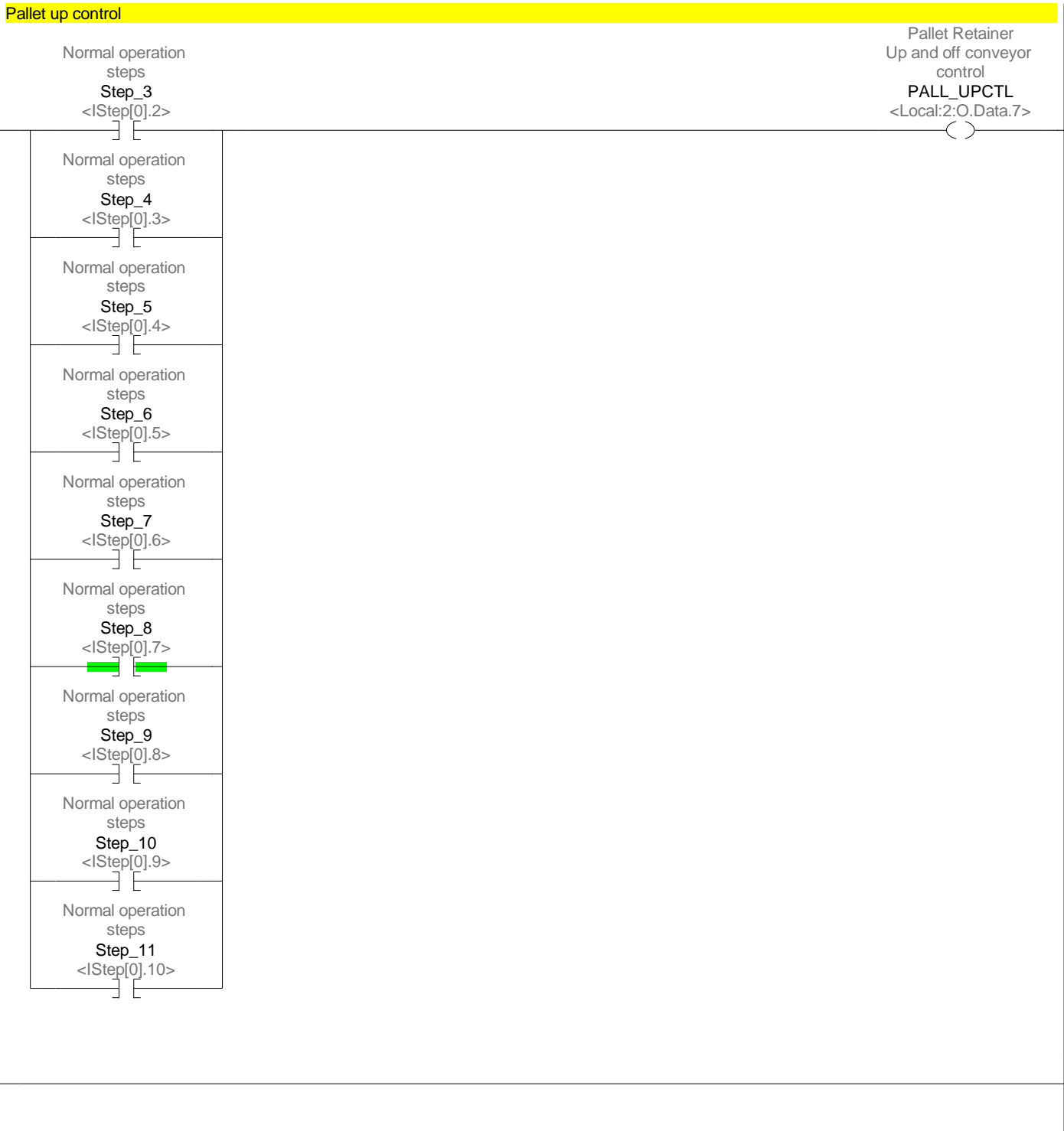




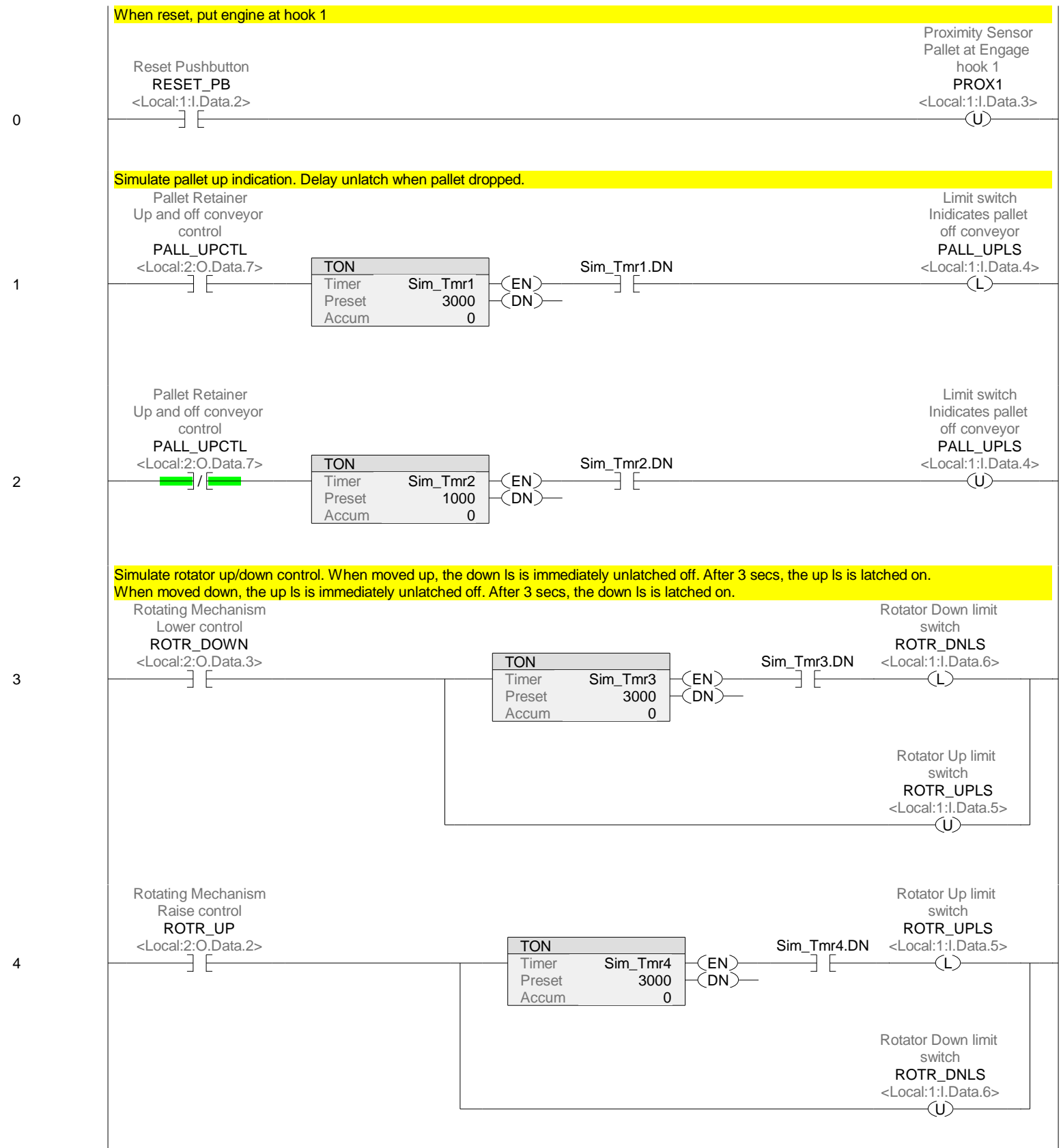


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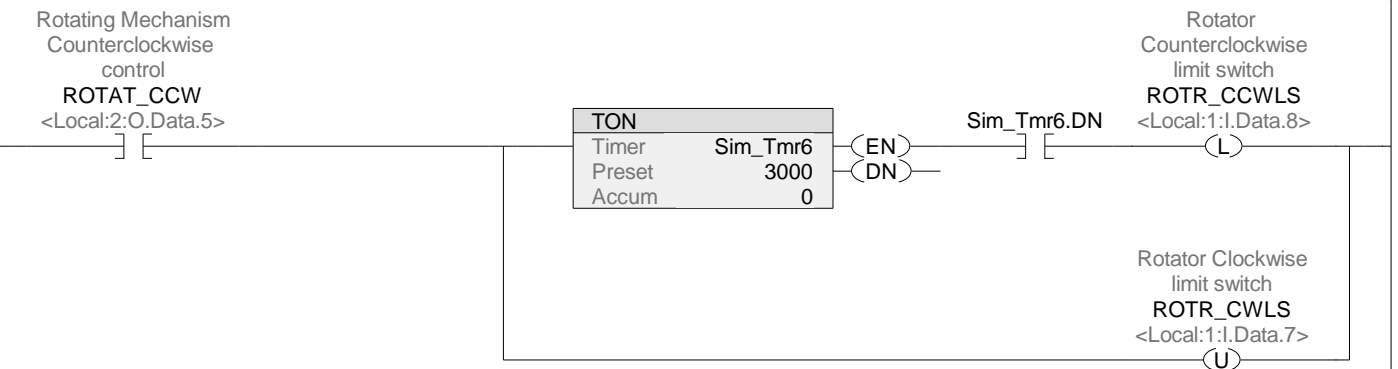
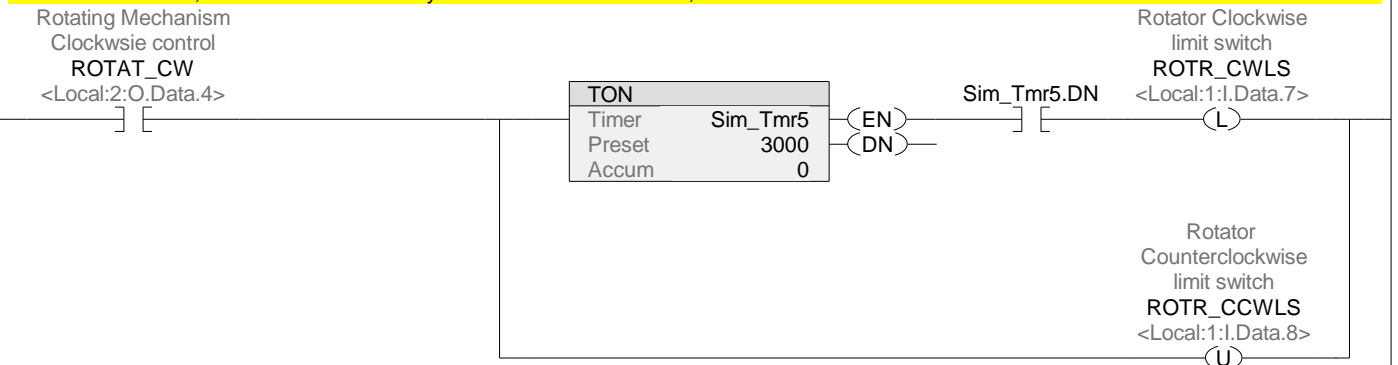
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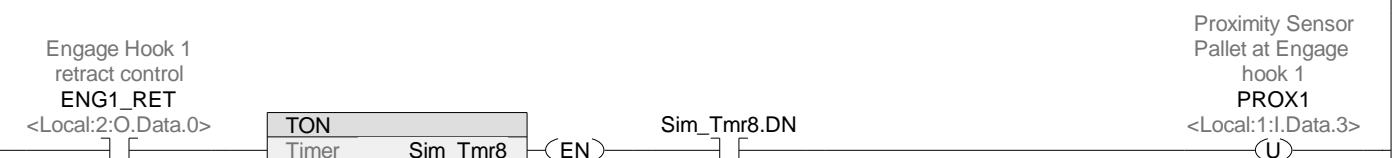
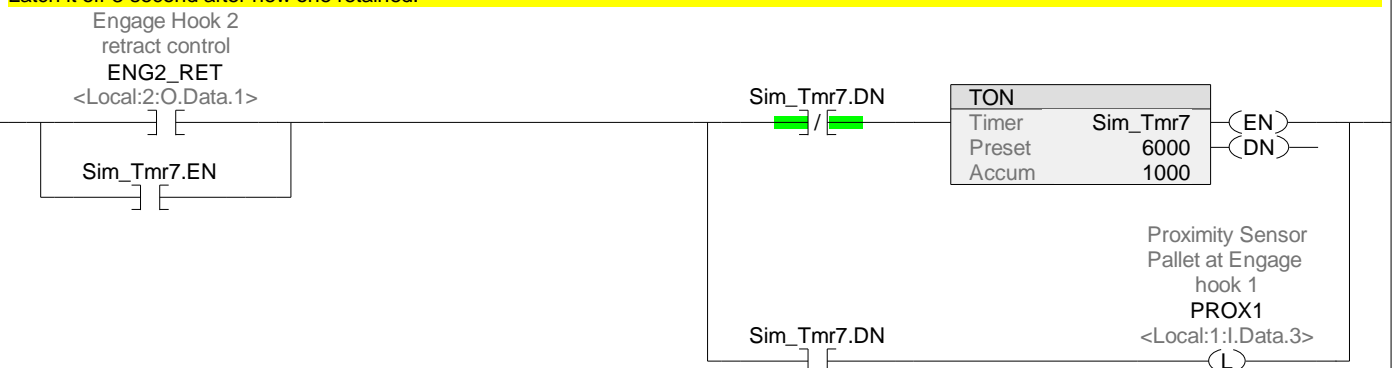




Simulate rotator rotating control. When rotated CW, the CCW Is is immediately unlatched off. After 3 secs, the CW Is is latched on.  
When rotated CCW, the CW Is is immediately unlatched off. After 3 secs, the CCW Is is latched on.



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



(End)