

Totally Integrated Automation Portal		
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Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

Title	SP6-4	Author		Comment	
Family		Version	0.1	User-defined ID	

Name	Data type	Default value
▼ Temp		
OB1_EV_CLASS	Byte	
OB1_SCAN_1	Byte	
OB1_PRIORITY	Byte	
OB1_OB_NUMBR	Byte	
OB1_RESERVED_1	Byte	
OB1_RESERVED_2	Byte	
OB1_PREV_CYCLE	Int	
OB1_MIN_CYCLE	Int	
OB1_MAX_CYCLE	Int	
OB1_DATE_TIME	Date_And_Time	
Constant		

Network 1: SP6-4

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Problem SP6-4 Bag Sealing Station Control

Additional internal memory:  
Tag Address  
Run %M5.0 BOOL On while station running  
Int\_Reset %M5.1 BOOL Internal reset  
Step\_1 to Step\_5 %M0.1 to M0.5 BOOL Step-in-progress bits  
Seal\_Tmr %DB1 IEC\_TIMER Times bag seal

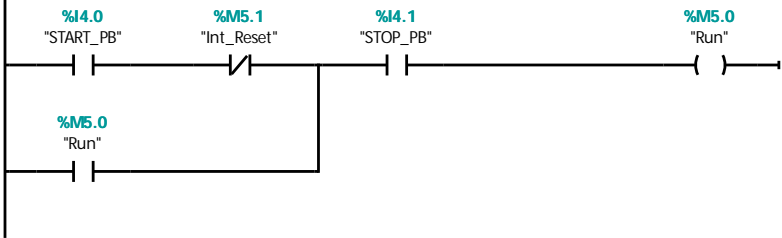
%M1.0  
"Dummy"

%M1.0  
"Dummy"

Network 2: Start/stop

During reset prevent start

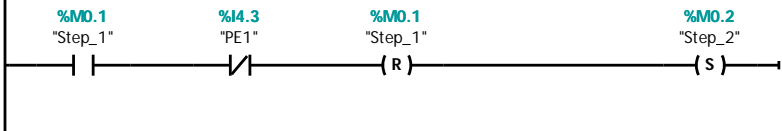
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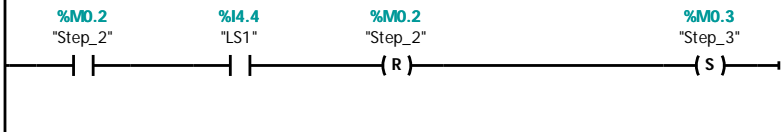
Network 3: Initial start



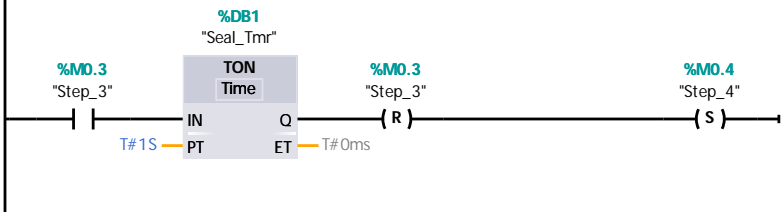
Network 4: Step 1 Move bag in



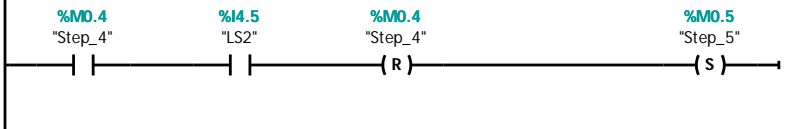
Network 5: Step 2 Move bars in



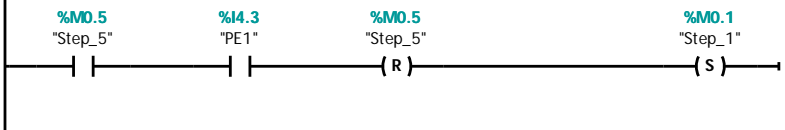
Network 6: Step 3 Seal bag



Network 7: Step 4 Move bars out

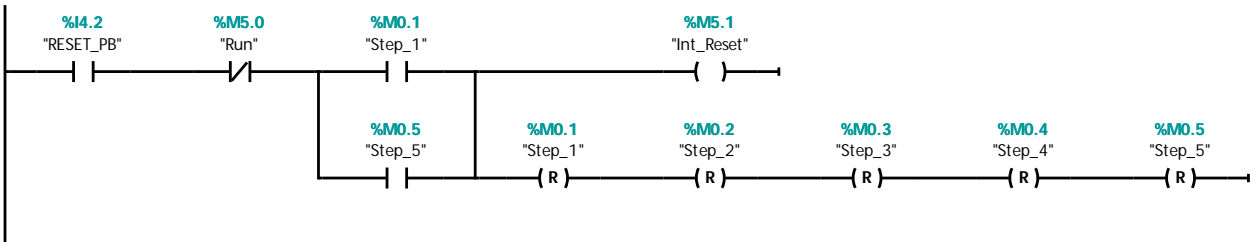


**Network 8: Step 5 Move bag out**

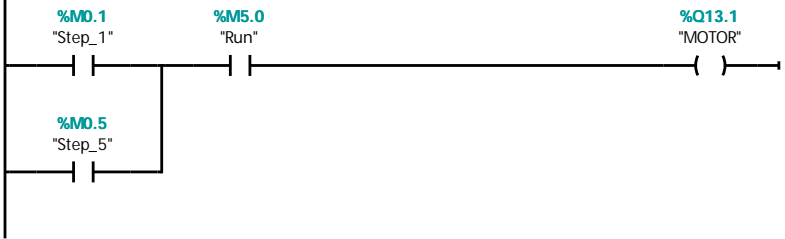


**Network 9: Reset**

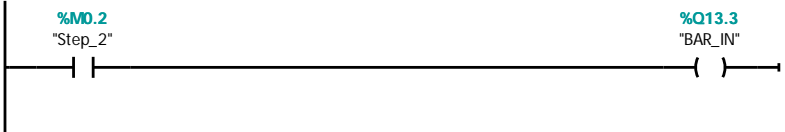
Only allowed in step 1 and 5



**Network 10: Conveyor motor control, on to move conveyor**



**Network 11: Heated bar mechanism in control, on to move bars together**



**Network 12: Heated bar mechanism out control, on to move bars apart**

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	<div><div><div>%M0.4 "Step_4"</div><div><div></div><div></div></div></div><div><div></div><div></div></div><div><div>%Q13.4 "BAR_OUT"</div><div><div></div><div></div></div></div></div>	