

## Main Properties

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100	General

<b>Name</b>	Main	<b>Number</b>	1	<b>Type</b>	OB
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<b>Language</b>	LAD	<b>Numbering</b>	Manual	
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Title	SP6-10	Author		Comment	
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Family		Version	0.1	User-defined ID	
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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		

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Tag Address	
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Run %M5.0 BOOL On while station running
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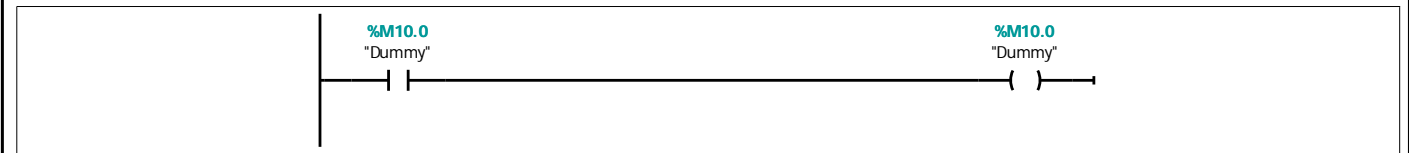
Int_Reset %M5.1 BOOL Internal reset	
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Step\_1 to Step\_6 %M0.1 to M0.6 BOOL Step-in-progress bits

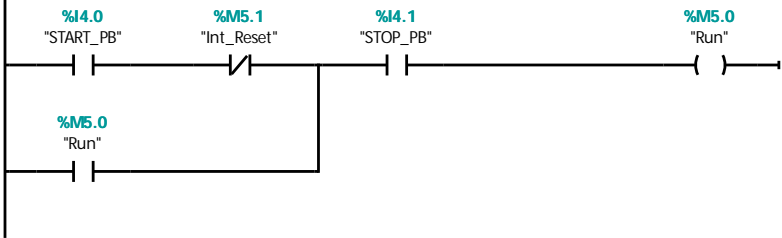
Press_Tmr	%DB1	IEC_TIMER	Times pressing step
0	0	0	0
1	1	1	1
2	2	2	2
3	3	3	3
4	4	4	4
5	5	5	5
6	6	6	6
7	7	7	7
8	8	8	8
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96	96	96	96
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98	98	98	98
99	99	99	99
100	100	100	100

Cool_Tmr %DB3 IEC_TIMER Times cool down
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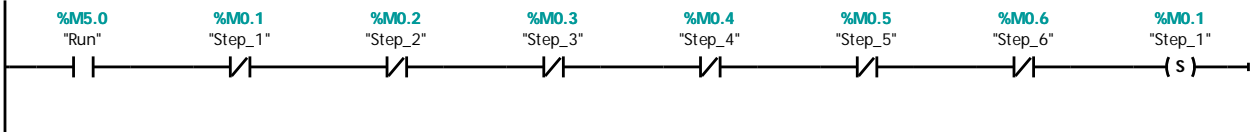
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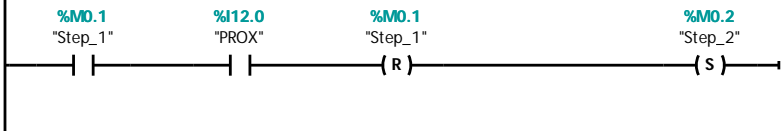
During reset prevent start



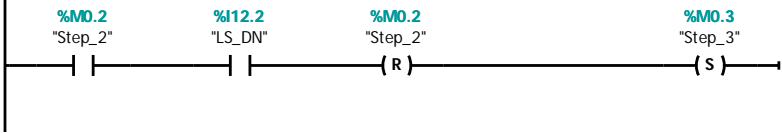
Network 3: Initial start



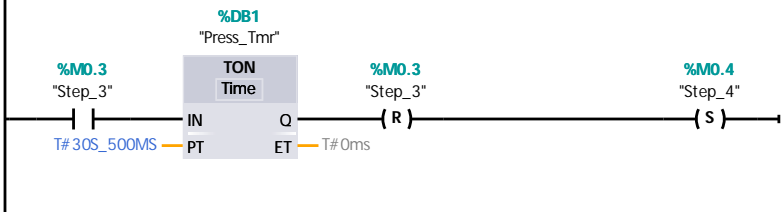
Network 4: Step 1 Move in piece



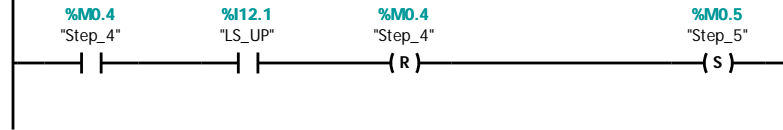
Network 5: Step 2 Lower press



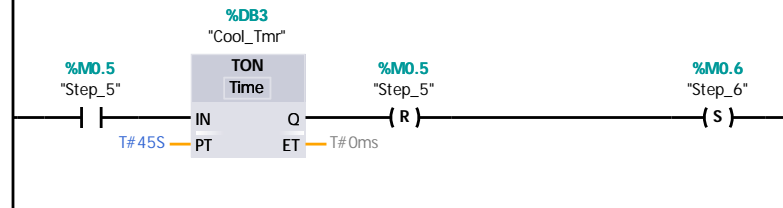
Network 6: Step 3 Press piece



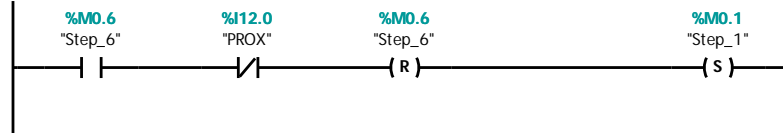
Network 7: Step 4 Raise press



### Network 8: Step 5 Cool down

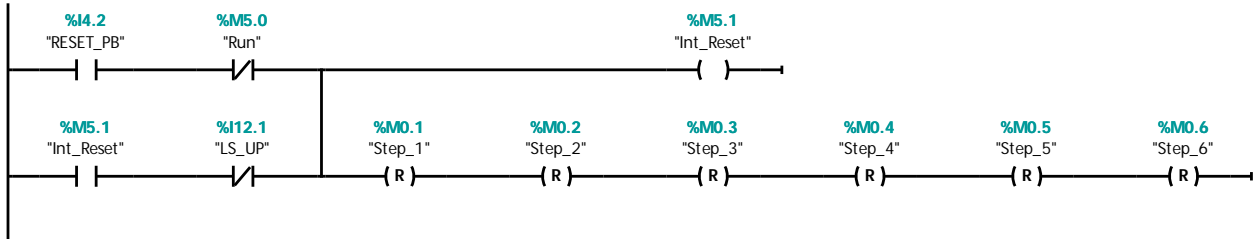


### Network 9: Step 6 Move out piece

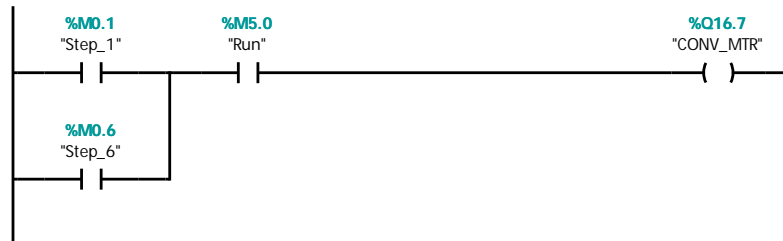


### Network 10: Reset

Keep internal reset on while raising press.

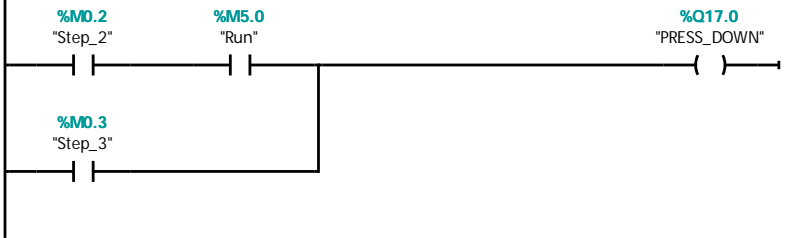


### Network 11: Infeed conveyor motor control, on to run conveyor motor



### Network 12: Press cylinder control, on to lower press

Can not pause in Step 3



**Network 13: On to open valve that directs steam into die**

Can not turn off when paused.

