

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
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Language	LAD	Numbering	Manual		
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Information

Title	P6-14	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		

Network 1: SP6-14

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Problem SP6-14 Pick-and-Place Machine Control

Additional internal memory:

Tag Address

Run %M5.0 BOOL On while station running

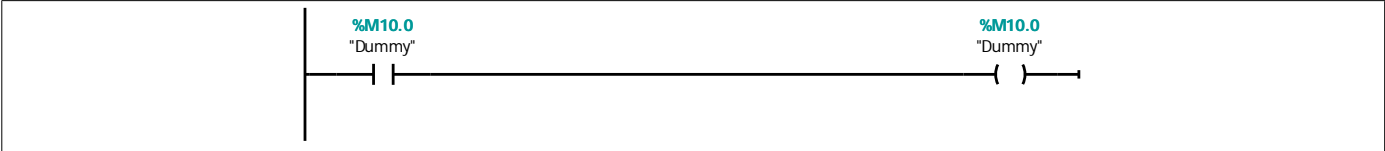
Int_Reset %M5.1 BOOL Internal reset

Step_1 to Step_10 %M0.1 to M1.2 BOOL Step-in-progress bits

Clamp_Tmr %DB1 IEC_TIMER Times clamping

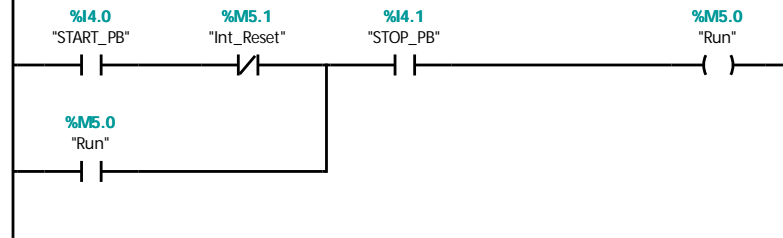
Unclamp_Tmr %DB3 IEC_TIMER Times unclamp

Reset_Tmr %DB4 IEC_TIMER Times unclamp during reset



Network 2: Start/stop

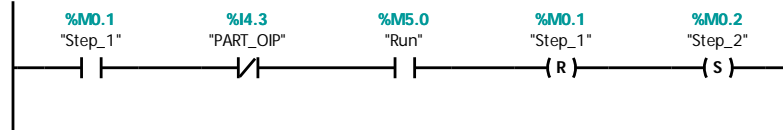
During reset prevent start



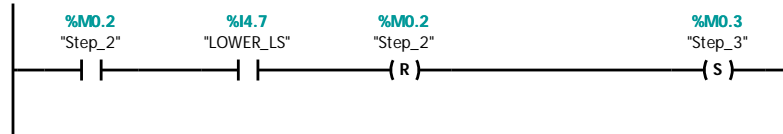
Network 3: Initial start



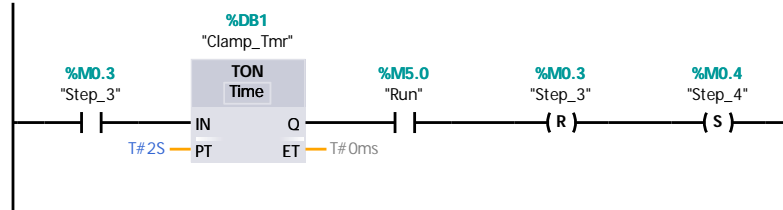
Network 4: Step 1 Wait for part ready.



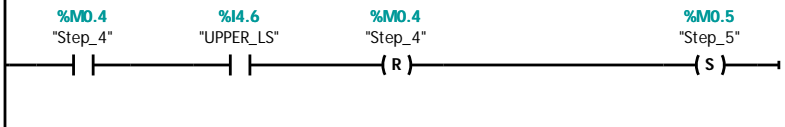
Network 5: Step 2 Lower to left table



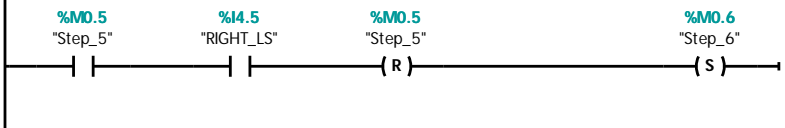
Network 6: Step 3 Clamp part



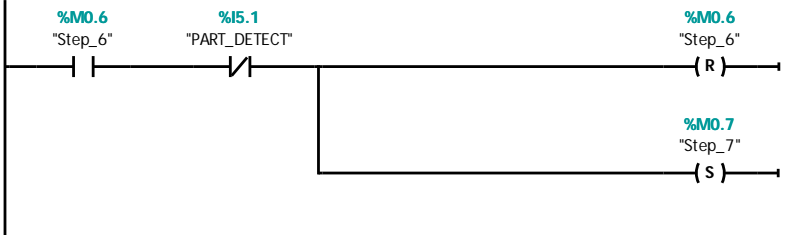
Network 7: Step 4 Raise to home



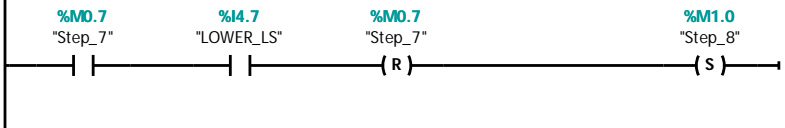
Network 8: Step 5 Move to right



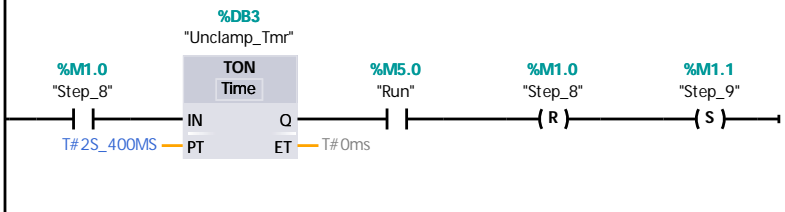
Network 9: Step 6 Wait for part removed



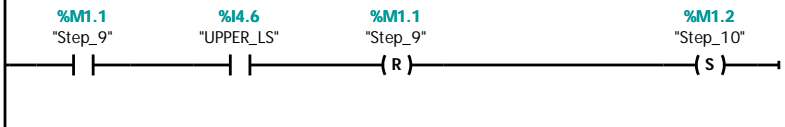
Network 10: Step 7 Lower to right table



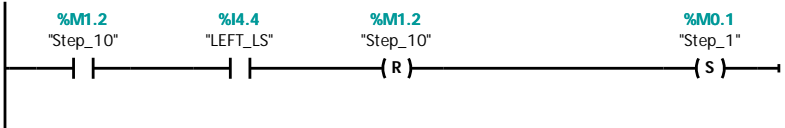
Network 11: Step 8 Unclamp



Network 12: Step 9 Raise

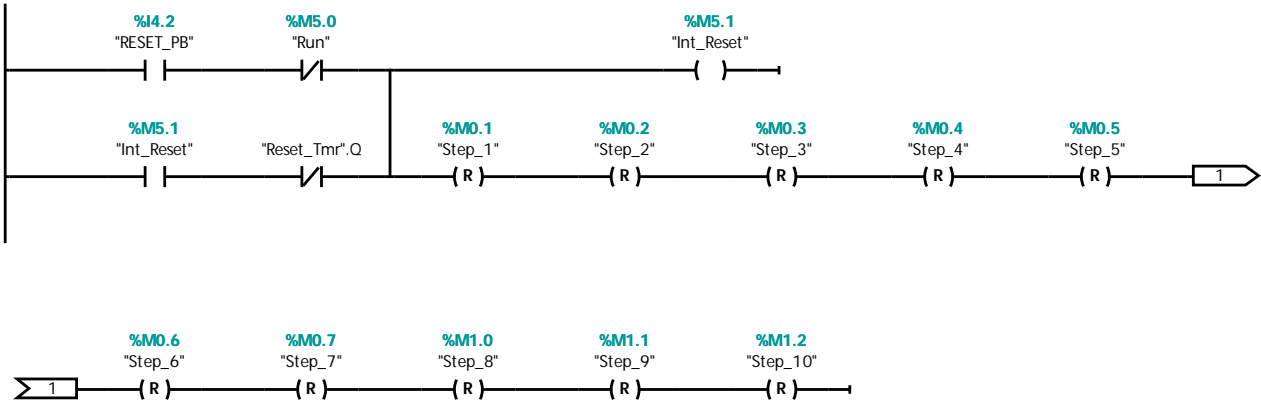


Network 13: Step 10 Move to left

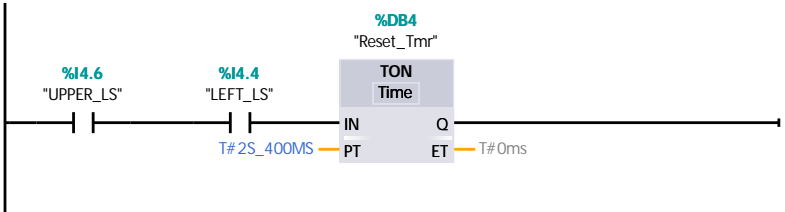


Network 14: Reset

Keep internal reset on while cylinders are not retracted.

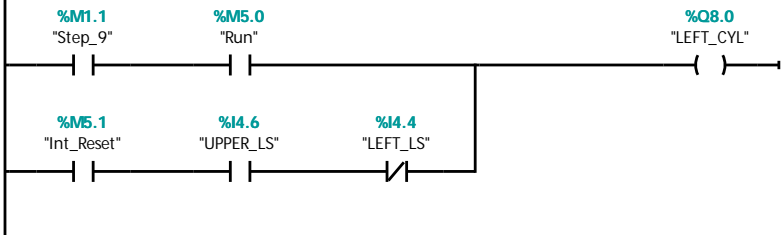


Network 15: Reset timer

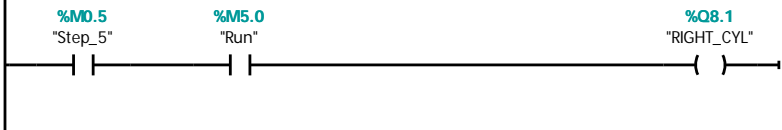


Network 16: Left cylinder control

When reset, do not move until fully up.



Network 17: Right cylinder control

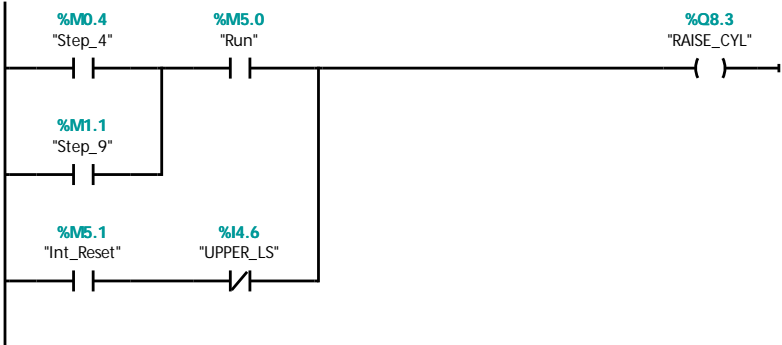


Network 18: Lowering cylinder control

Retract on reset



Network 19: Raise cylinder control



Network 20: Clamp cylinder control

Maintain clamp while moving home during reset.

