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<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	SP6-16	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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Additional internal memory:

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_11 %M0.1 to M1.3 BOOL Step-in-progress bits
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In\_Tmr %DB1 IEC\_TIMER Times engage cyl for bringing in pallet

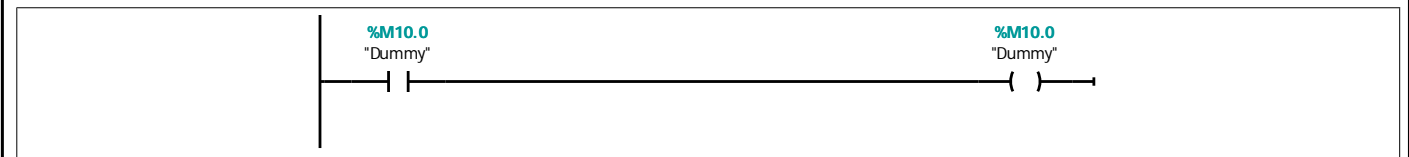
Raise\_Tmr %DB3 IEC\_TIMER Times raise of pallet

Push\_Tmr % DB4 IEC\_TIMER Times push of bolts

Motor\_Tmr %DB5 IEC\_TIMER Retentive timer for air motor rotation

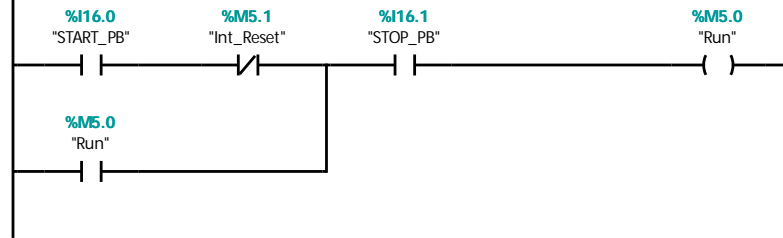
Lower\_Tmr %DB9 IEC\_TIMER Times lower of pallet

Out\_Tmr %DB10 IEC\_TIMER Times engage cyl for allowing out pallet



During reset prevent start	
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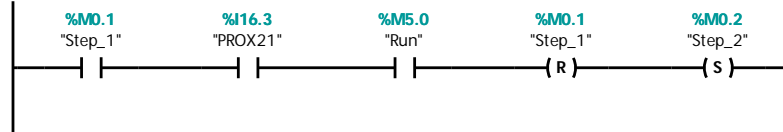
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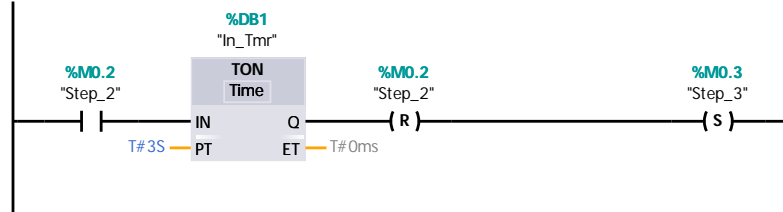
### Network 3: Initial start



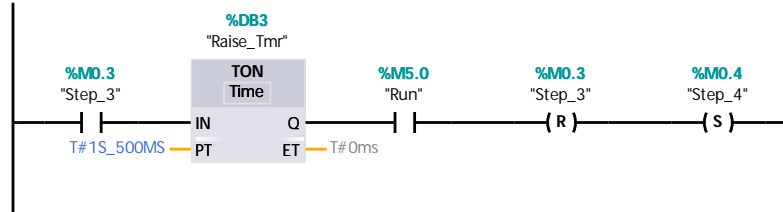
### Network 4: Step 1 Wait for pallet



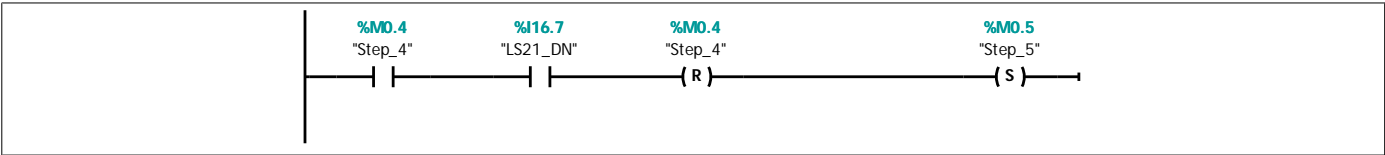
### Network 5: Step 2 Allow one pallet in



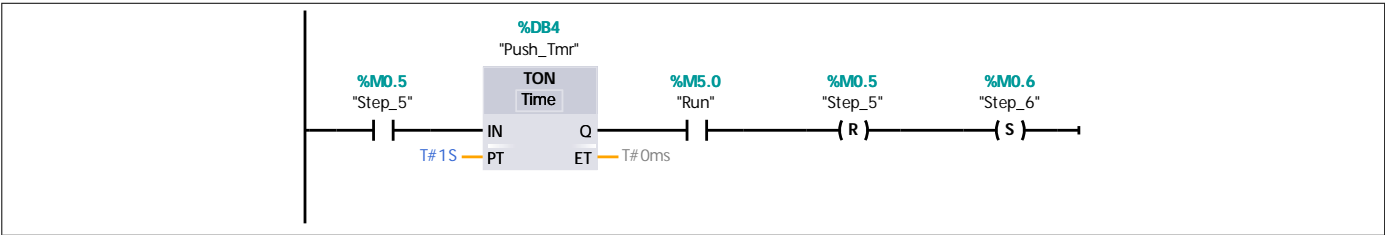
### Network 6: Step 3 Raise pallet



Network 7: Step 4 Lower mechanism



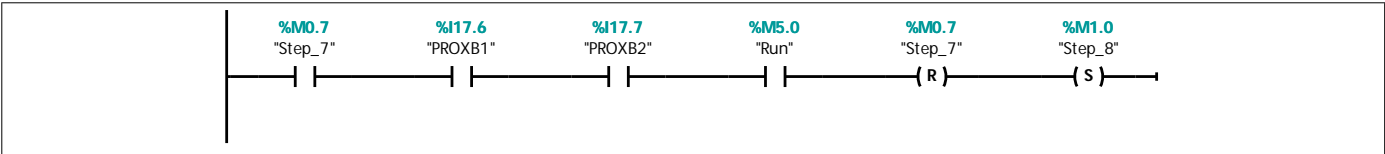
Network 8: Step 5 Push bolts



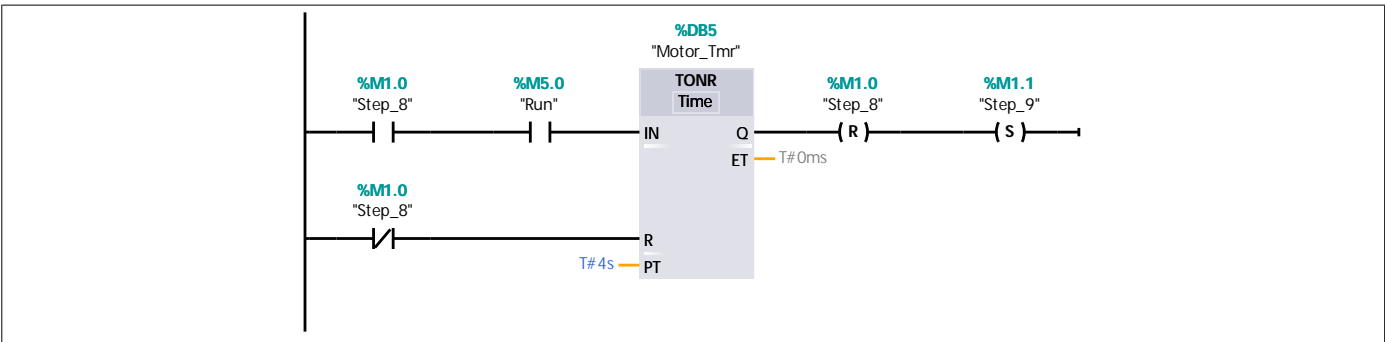
Network 9: Step 6 Close gate valves



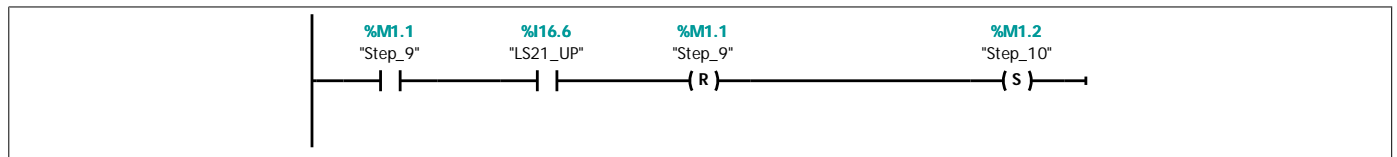
Network 10: Step 7 Convey bolts



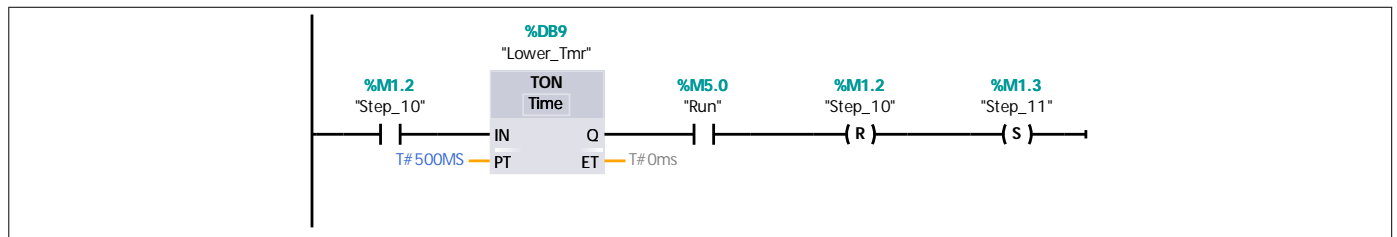
Network 11: Step 8 Run air motor Retentive timer



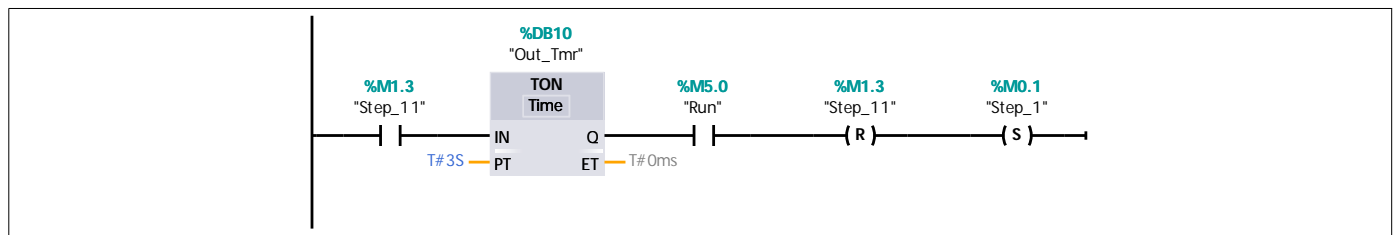
## Network 12: Step 9 Raise mechanism



## Network 13: Step 10 Drop pallet

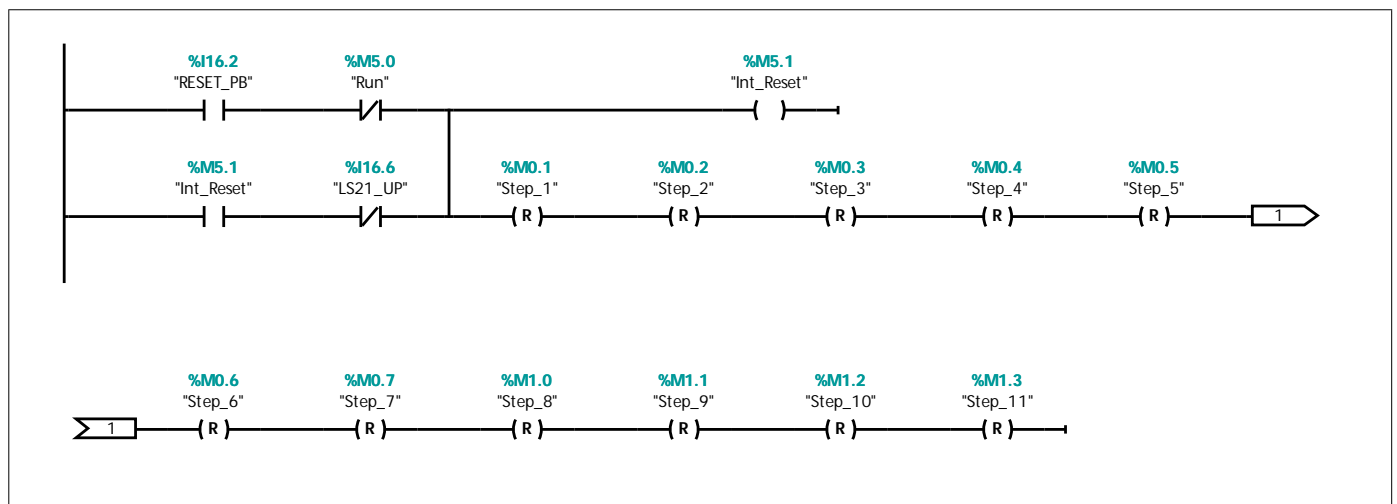


## Network 14: Step 11 Move out pallet

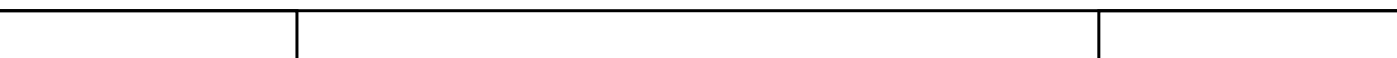


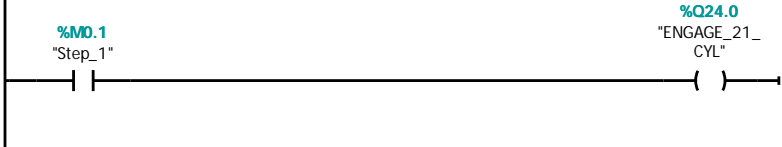
## Network 15: Reset

Maintain reset until mechanism fully raised.

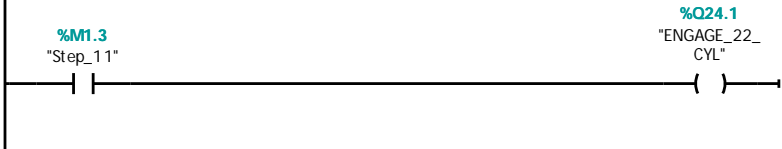


## Network 16: Engage solenoids



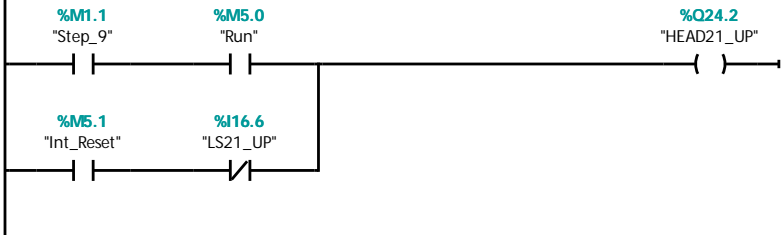


**Network 17:**

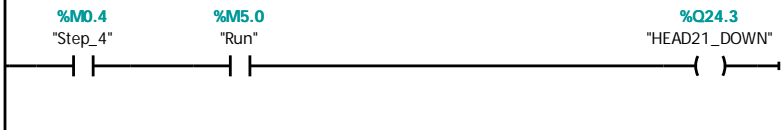


**Network 18: Raise/lower mechanism**

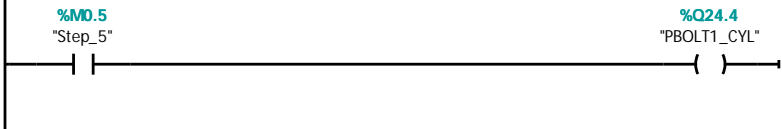
Move up on reset



**Network 19:**



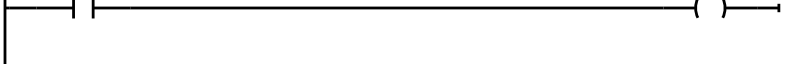
**Network 20: Push bolt solenoids**



**Network 21:**

%M0.5  
"Step\_5"

%Q24.5  
"PBOLT2\_CYL"



Network 22: Gate valves

%M0.6  
"Step\_6"

%Q25.2  
"GVLV1"

%M0.7  
"Step\_7"



Network 23: Open convey valve #2 to convey bolt #2 to driver

%M0.6  
"Step\_6"

%Q25.3  
"GVLV2"

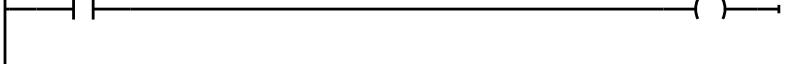
%M0.7  
"Step\_7"



Network 24: Convey valves

%M0.7  
"Step\_7"

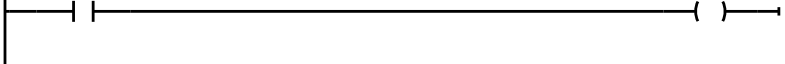
%Q28.0  
"CVLV1"



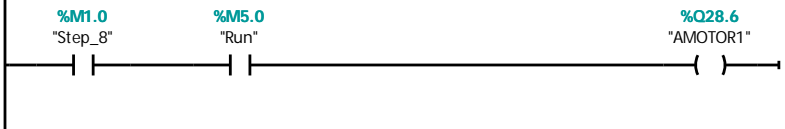
Network 25: Clamp control

%M0.7  
"Step\_7"

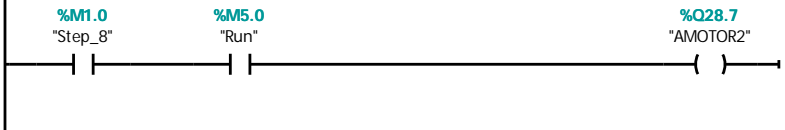
%Q28.1  
"CVLV2"



Network 26: Air motors



**Network 27: Open valve to air motor #2 to drive bolt #2**



**Network 28: Pallet up control**

Must remain on when paused

