

Totally Integrated Automation Portal

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

Title	SP7-8	Author		Comment	
Family		Version	0.1	User-defined ID	

Name	Data type	Offset	Default value	Comment
▼ Temp				
OB1_EV_CLASS	Byte	0.0		Bits 0-3 = 1 (Coming event), Bits 4-7 = 1 (Event class 1)
OB1_SCAN_1	Byte	1.0		1 (Cold restart scan 1 of OB 1), 3 (Scan 2-n of OB 1)
OB1_PRIORITY	Byte	2.0		Priority of OB Execution
OB1_OB_NUMBR	Byte	3.0		1 (Organization block 1, OB1)
OB1_RESERVED_1	Byte	4.0		Reserved for system
OB1_RESERVED_2	Byte	5.0		Reserved for system
OB1_PREV_CYCLE	Int	6.0		Cycle time of previous OB1 scan (milliseconds)
OB1_MIN_CYCLE	Int	8.0		Minimum cycle time of OB1 (milliseconds)
OB1_MAX_CYCLE	Int	10.0		Maximum cycle time of OB1 (milliseconds)
OB1_DATE_TIME	Date_And_Ti me	12.0		Date and time OB1 started
Constant				

Network 1: SP7-8

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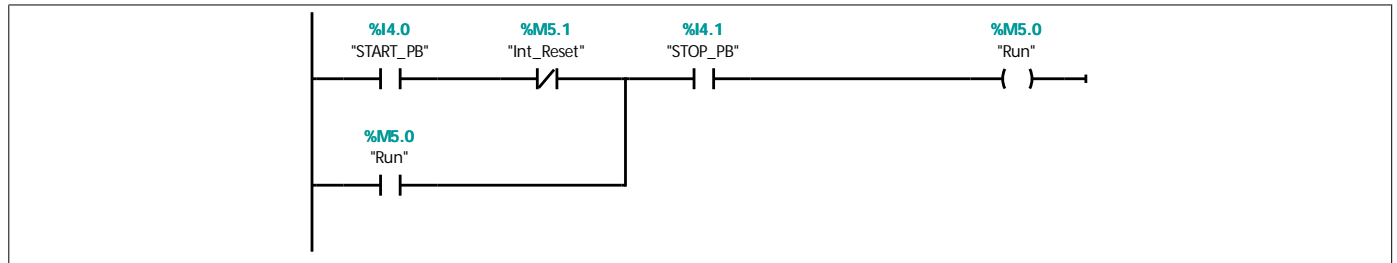
SP7-8 Stamping Station Control

Additional internal memory:  
Tag Address  
Run %M5.0 BOOL On while station running  
Int\_Reset %M5.1 BOOL Internal reset  
Step\_1 to Step\_8 %M0.1 to M1.0 BOOL Step-in-progress bits  
Ram\_Up\_Tmr %DB4 IEC\_TIMER Retentive timer for raising of stamp head  
Retract\_Tmr %DB1 IEC\_TIMER Times retract of PCYL2  
Rst\_Tmr % DB3 IEC\_TIMER Times raising of stamp head when reset  
Ret\_Val %MW12 WORD Return value from SCALE block

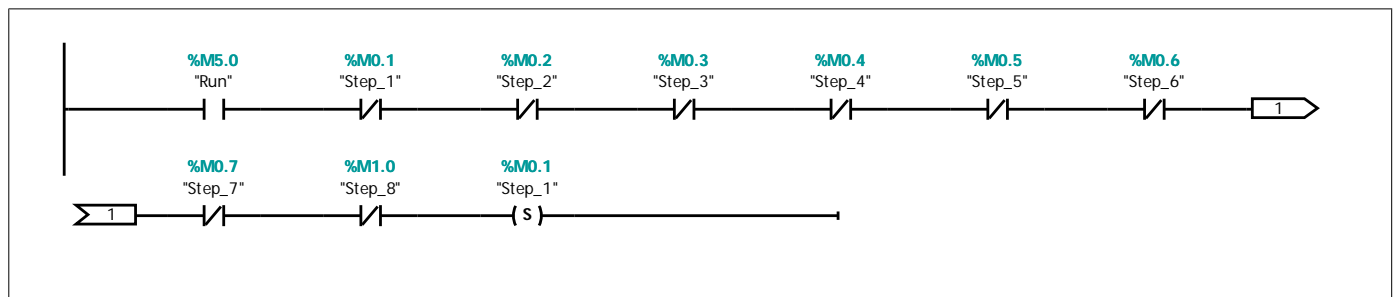
%M2.0  
"Dummy"

%M2.0  
"Dummy"

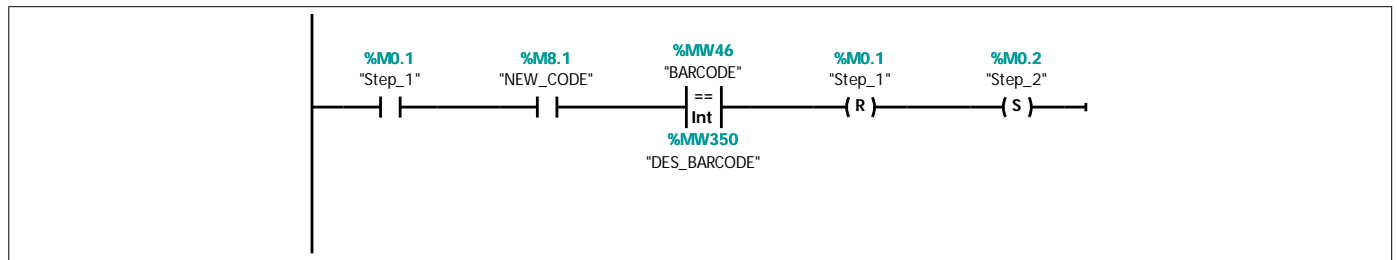
## Network 2: Start/stop



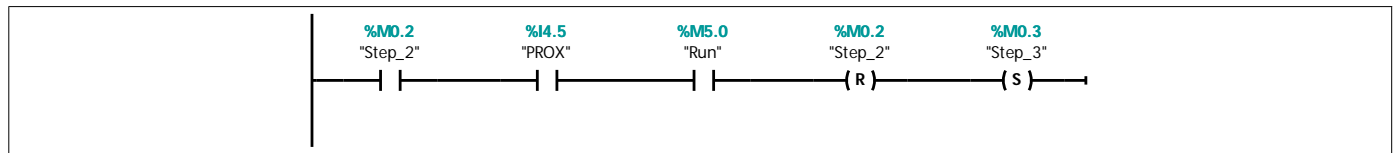
## Network 3: Initial Start



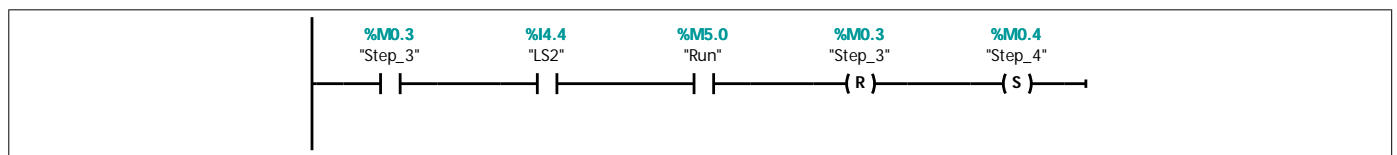
## Network 4: Step 1 Wait for correct code



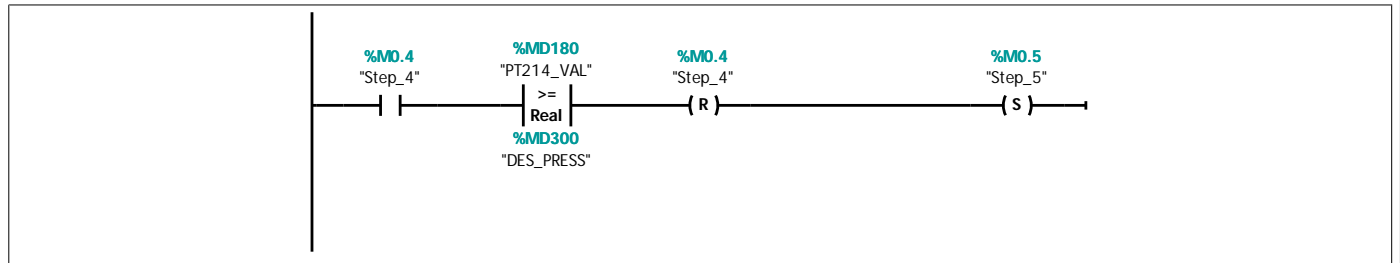
## Network 5: Step 2 Wait for piece in position



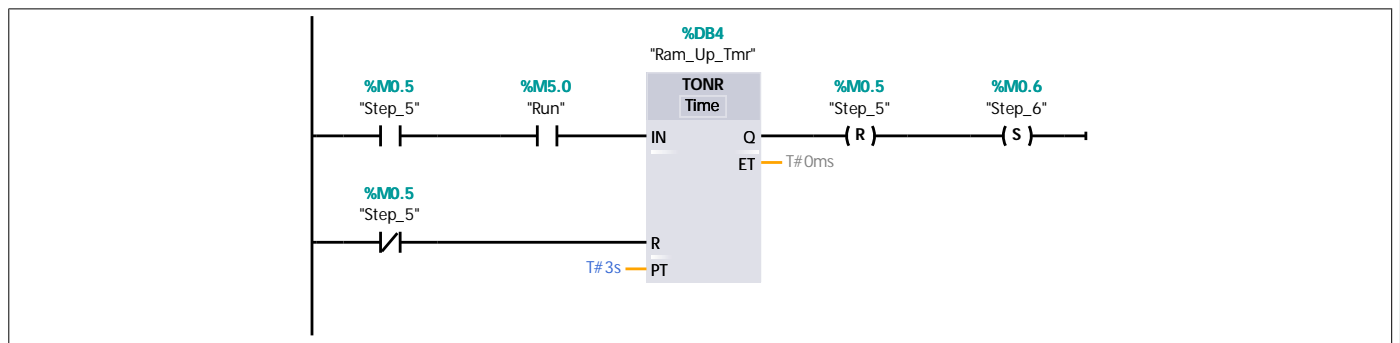
## Network 6: Step 3 Push piece in



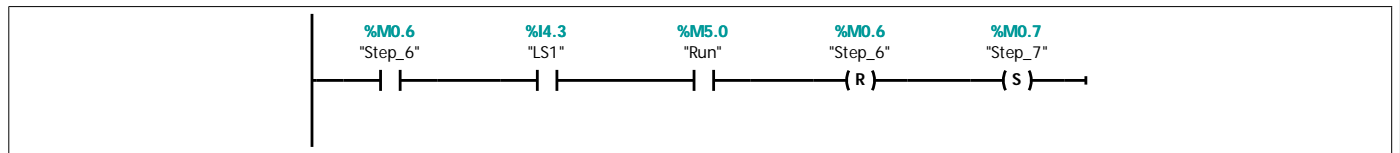
## Network 7: Step 4 - Stamp part



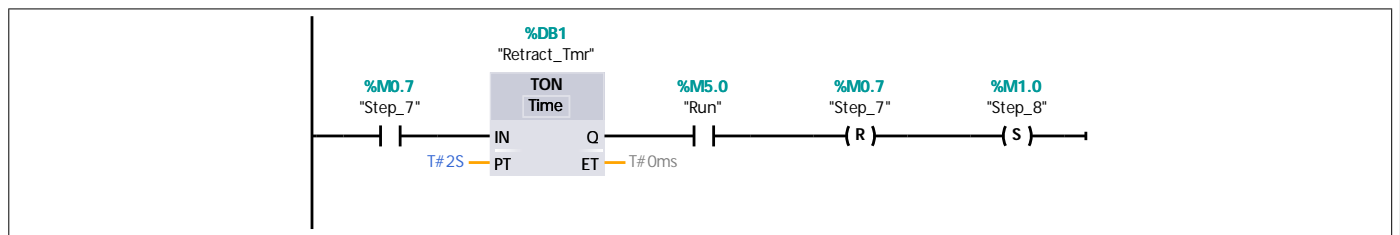
## Network 8: Step 5 Move stamp up, retentive timer



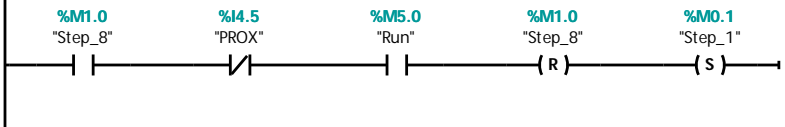
## Network 9: Step 6 - Push to conveyor



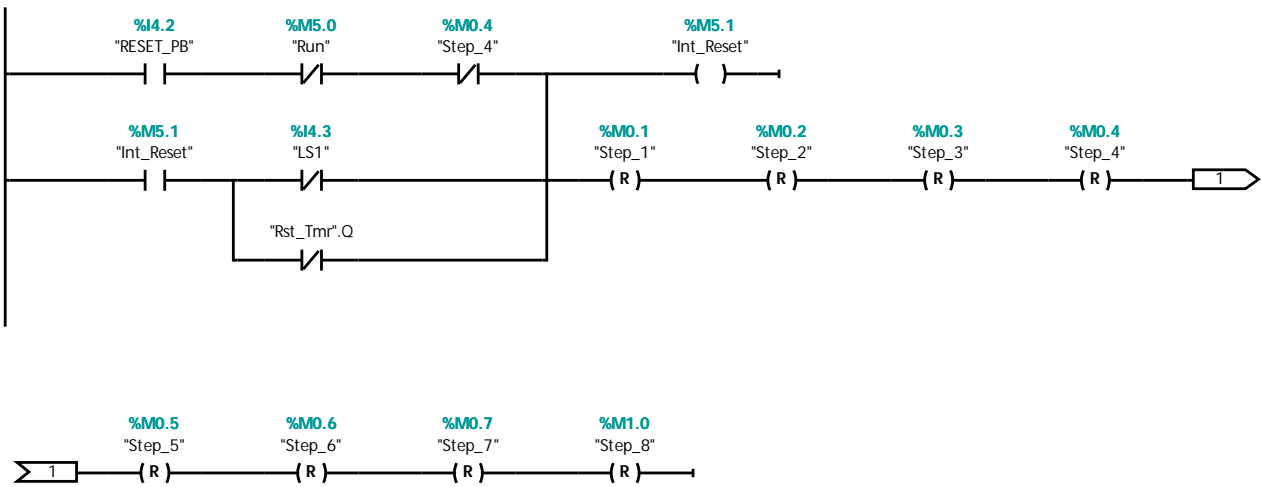
## Network 10: Step 7 Retract PCYL2



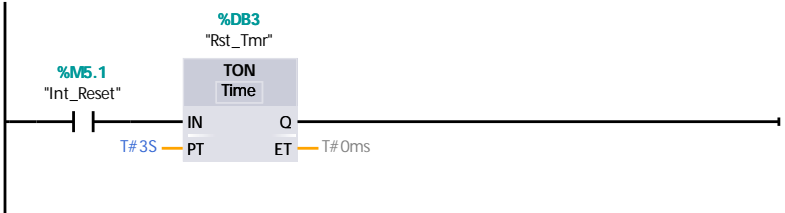
## Network 11: Step 8 Move Out



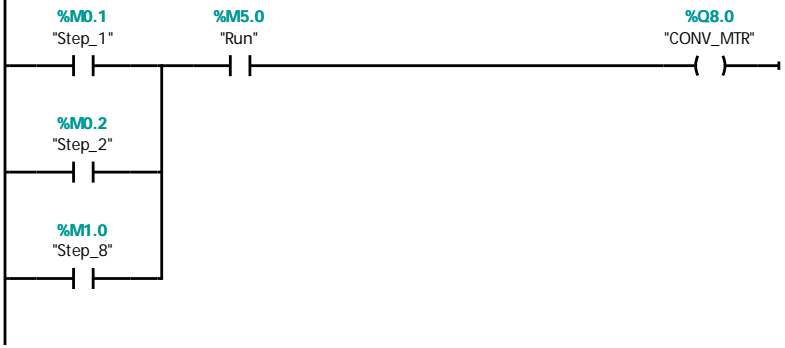
Network 12: Reset



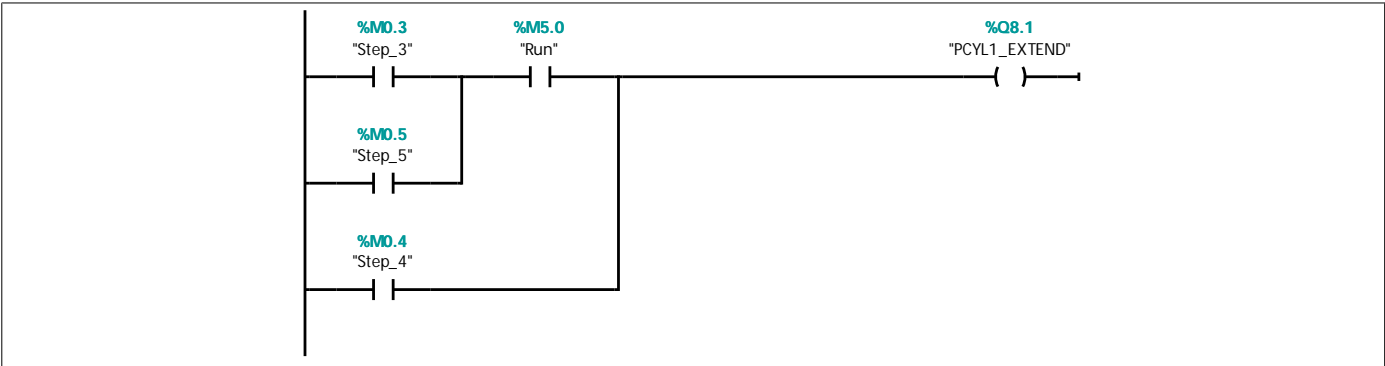
Network 13: Timer for raising stamp when reset



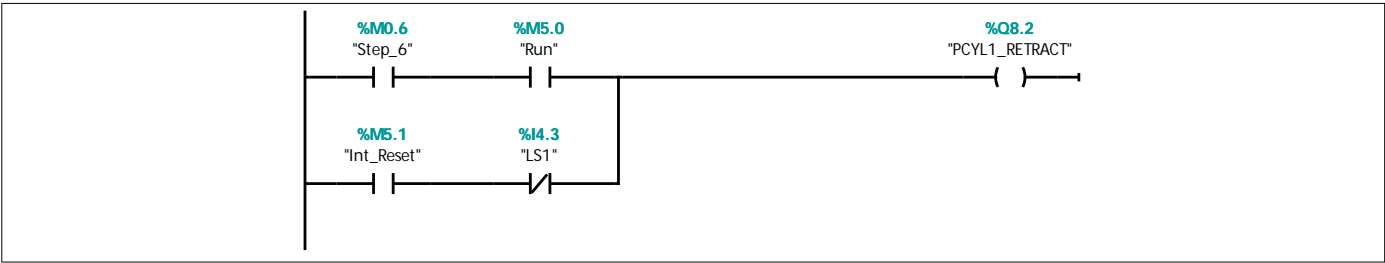
Network 14: Conveyor control



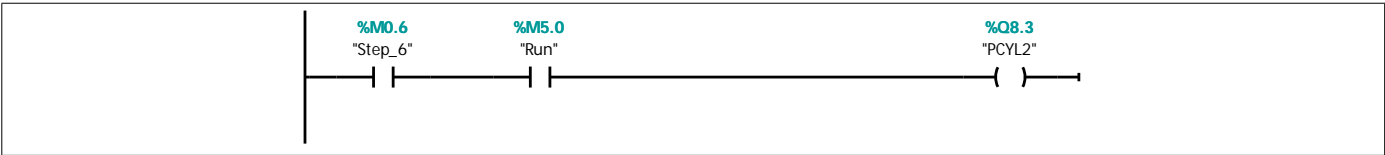
**Network 15: PCYL controls**



**Network 16: PCYL1 retract ram control**



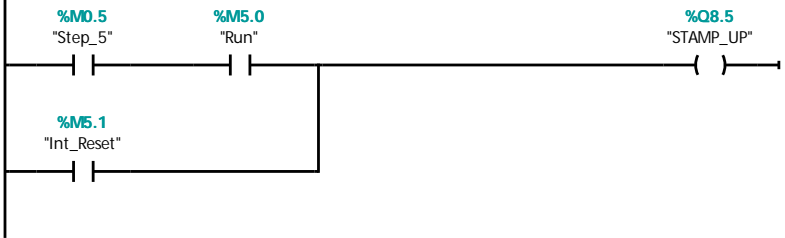
**Network 17: PCYL2 ram control**



**Network 18: Stamp control**



**Network 19: On to move stamp ram up**



**Network 20: Convert pressure measurement with SCALE**

Convert pressure measurement to psi.  
Uses SCALE block. Note that the lo\_lim input is 25% lower than zero weight to account for this block assuming the minimum value of the analog in is zero rather than the 5530 (which corresponds to 4 mA).

