

Totally Integrated Automation Portal

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

Title	SP6-3	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: SP6-3

Problem SP6-3 Parts Transfer Station Control

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Additional internal memory:
Tag Address
Run %M3.1 BOOL On while station running
Step_1 to Step_4 %M0.1 to M0.4 BOOL Step-in-progress bits
Motor1_Tmr %DB1 IEC_TIMER Times rotation of table
Parts_Ctr %DB2 IEC_COUNTER Counts parts going to table

%M1.0

"Dummy"

%M1.0

"Dummy"

Network 2: Initial start

%M3.1

"Run"

%M0.1

"Step_1"

%M0.2

"Step_2"

%M0.3

"Step_3"

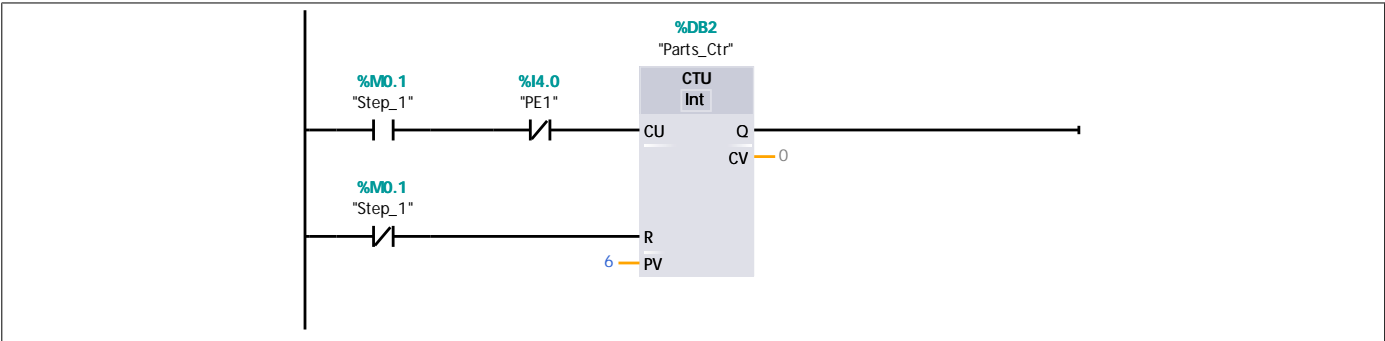
%M0.4

"Step_4"

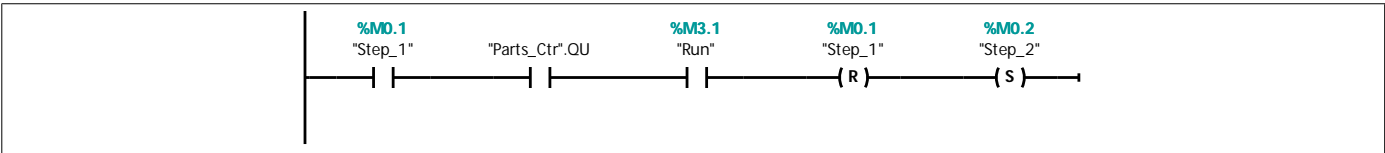
%M0.1

"Step_1"

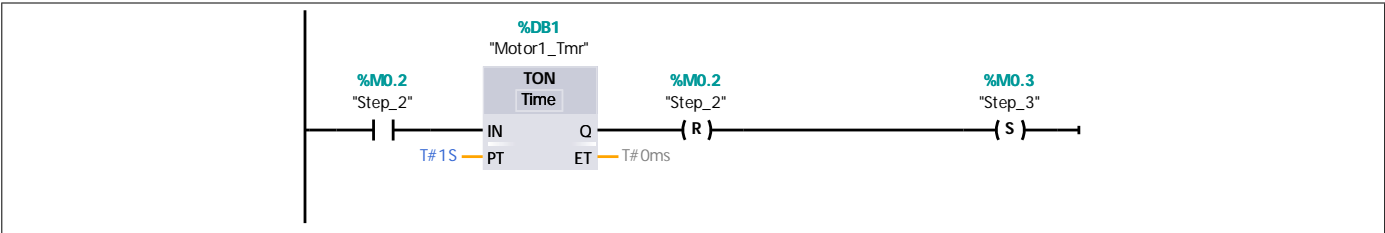
Network 3: Part Counter



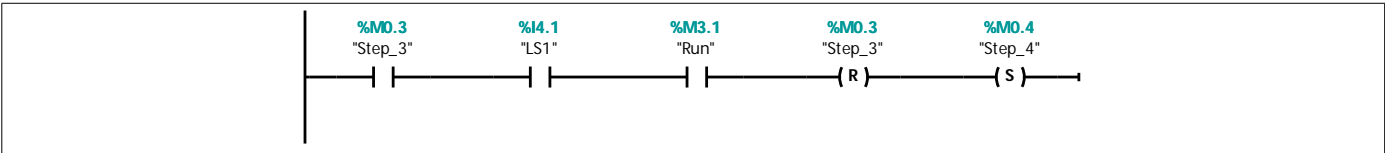
Network 4: Step 1 Count parts



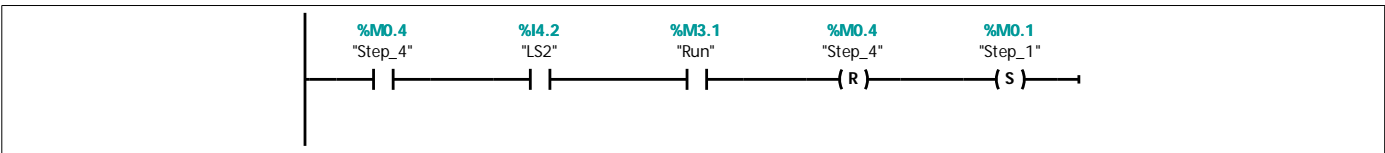
Network 5: Step 2 Rotate Table



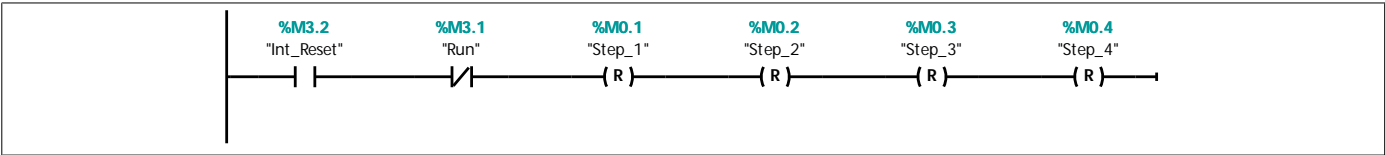
Network 6: Step 3 Extend Ram



Network 7: Step 4 Retract Ram



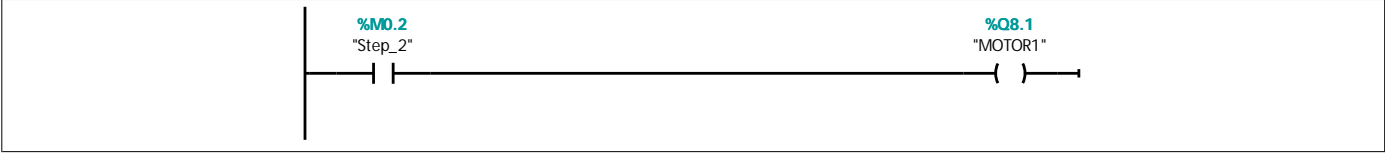
Network 8: Reset



Network 9: Pneumatic ram extension solenoid control, on to extend ram



Network 10: Turntable motor control, on to turn turntable



Network 11: Belt conveyor motor control, on to run conveyor

