

Totally Integrated Automation Portal

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

Title	SP6-6	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:

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Problem SP6-6 Transfer Station Control

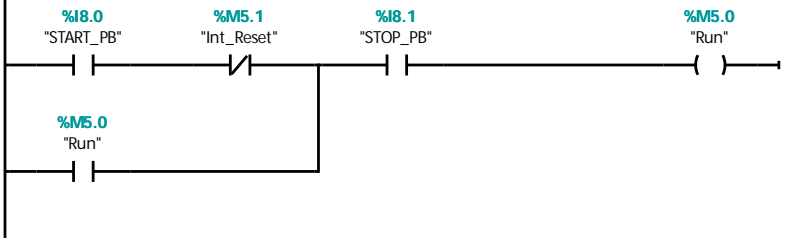
Additional internal memory:
Tag Address
Run %M5.0 BOOL On while station running
Int_Reset %M5.1 BOOL Internal reset
Step_1 to Step_5 %M0.1 to M0.5 BOOL Step-in-progress bits
Raise_Tmr %DB1 IEC_TIMER Times mechanism raise
Parts_Ctr %DB2 IEC_COUNTER Counts parts

%M10.0
"Dummy"

%M10.0
"Dummy"

Network 2: Start/stop

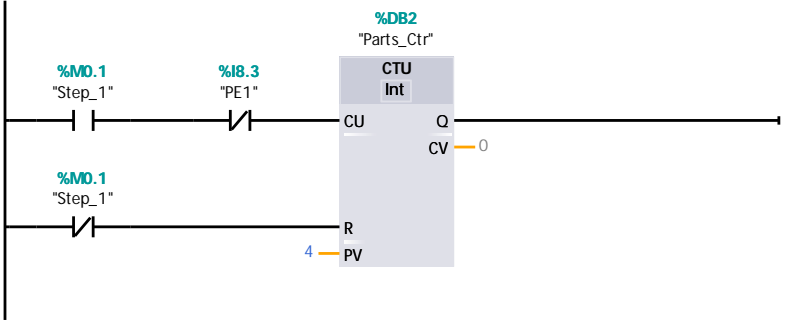
During reset prevent start



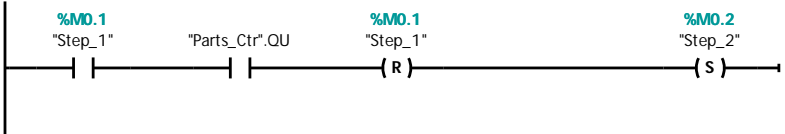
Network 3: Initial start



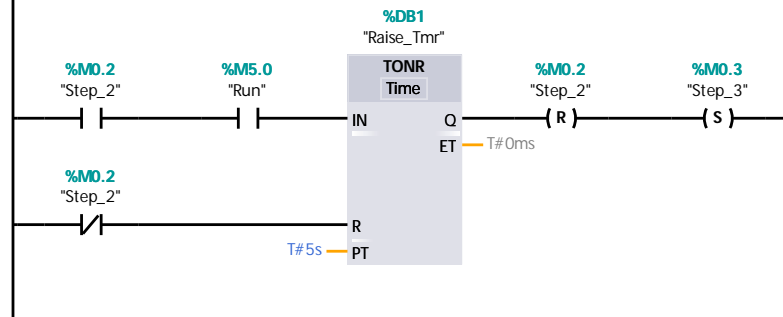
Network 4: Part Counter



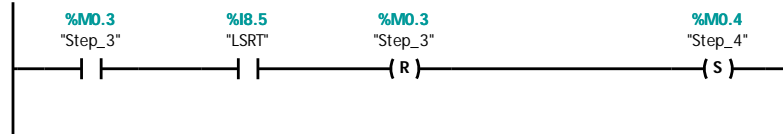
Network 5: Step 1 Wait for 4 parts



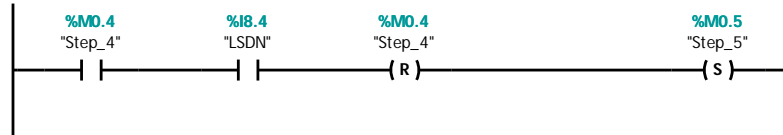
Network 6: Step 2 Move up



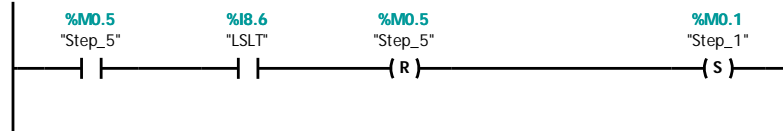
Network 7: Step 3 Move right



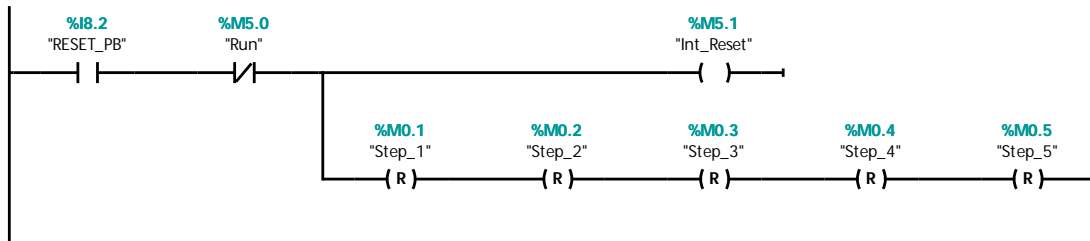
Network 8: Step 4 Move down



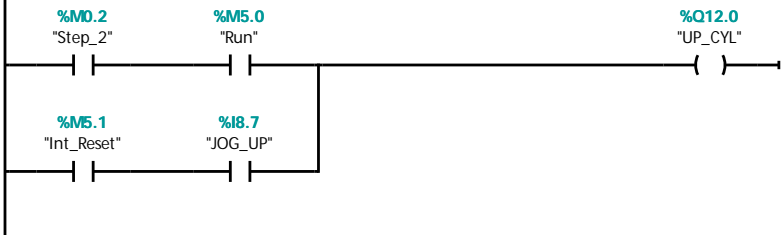
Network 9: Step 5 Move left



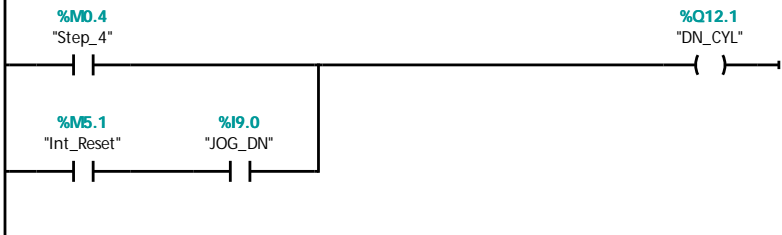
Network 10: Reset



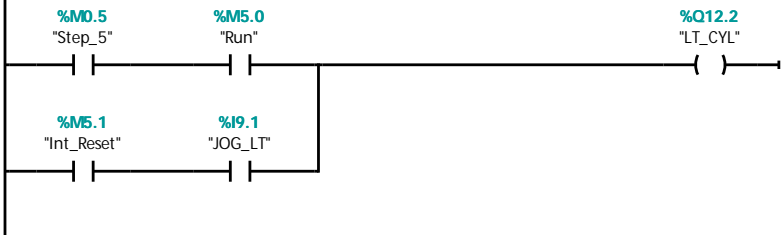
Network 11: Raising control, on to raise mechanism



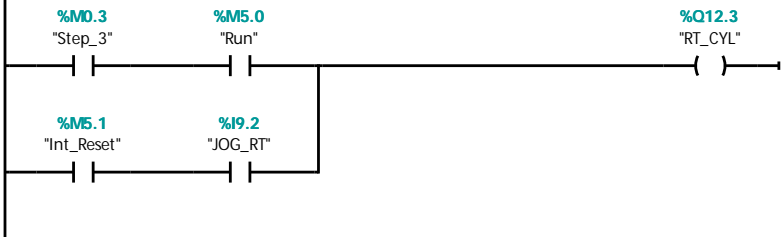
Network 12: Lowering control, on to lower mechanism



Network 13: Left motion control, on to move mechanism left



Network 14: Right motion control, on to move mechanism right



Network 15: Inbound conveyor control, on to move conveyor

