

Main [OB1]

Main Properties

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| 100 | General |

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|-----------------|------|------------------|--------|-------------|----|
| Name | Main | Number | 1 | Type | OB |
| Language | LAD | Numbering | Manual | | |

Information

| | | | | | |
|---------------|--------|----------------|-----|------------------------|--|
| Title | SP6-11 | 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: SP6-11

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Problem SP6-11 Case Erector Control

Additional internal memory:

Tag Address

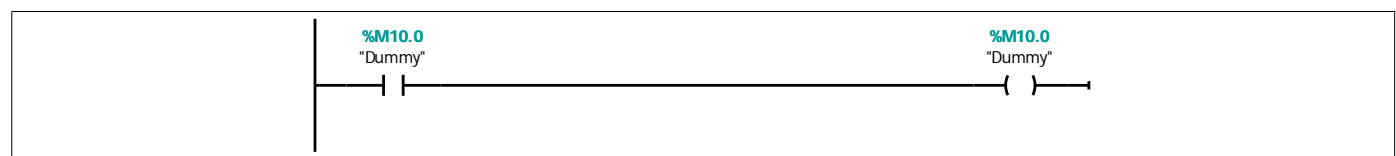
Run %M5.0 BOOL On while station running

Step_1 to Step_6 %M0.1 to M0.6 BOOL Step-in-progress bits

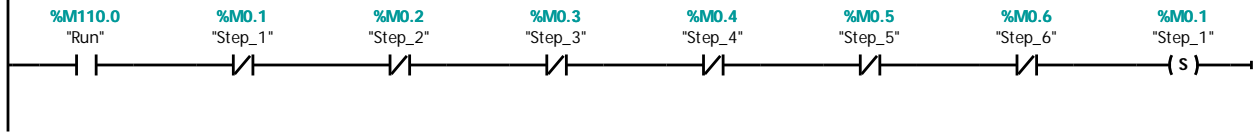
Up_Tmr %DB1 IEC_TIMER Times carton unfolding

Pulse_Cnt %DB2 IEC_COUNTER Counts encoder pulses

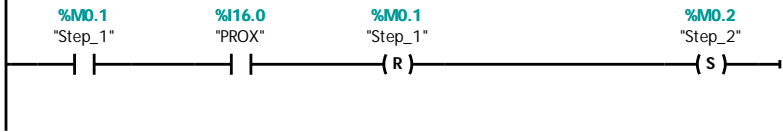
BDown_Tmr %DB4 IEC_TIMER Times retract of rams



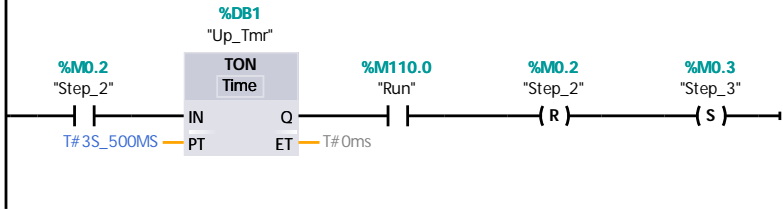
Network 2: Initial start



Network 3: Step 1 Move in



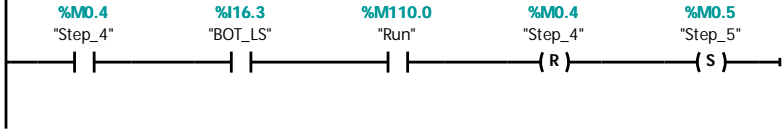
Network 4: Step 2 Open up



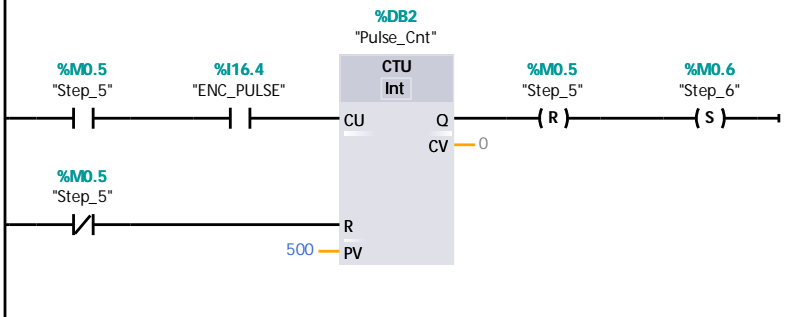
Network 5: Step 3 Close sides



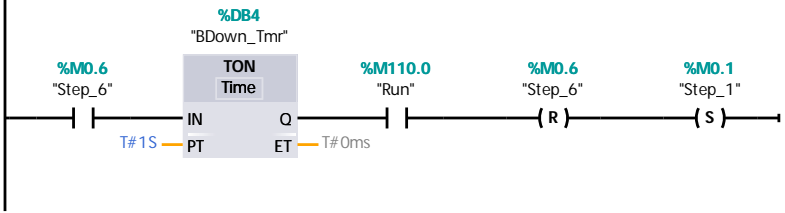
Network 6: Step 4 Close bottom



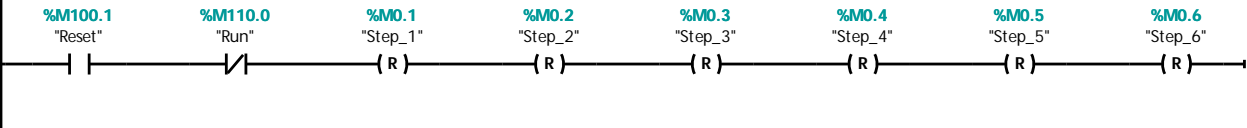
Network 7: Step 5 Move out



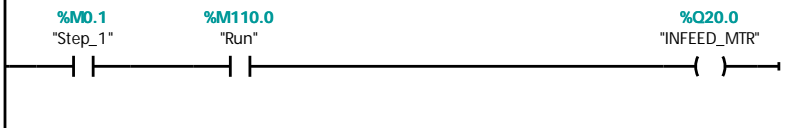
Network 8: Step 6 Let Bot_Cyl fall



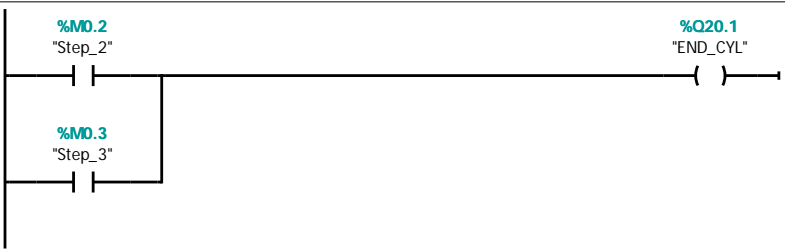
Network 9: Reset



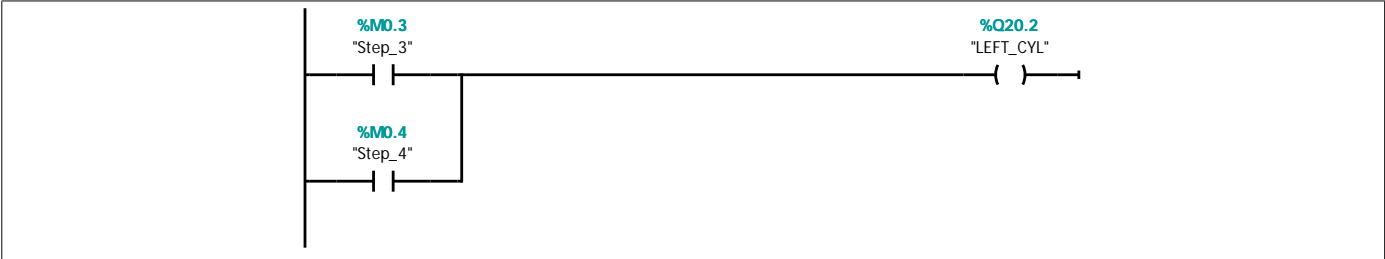
Network 10: Infeed rollers, on to move in flat carton



Network 11: End cylinder control, when on unfolds flat carton



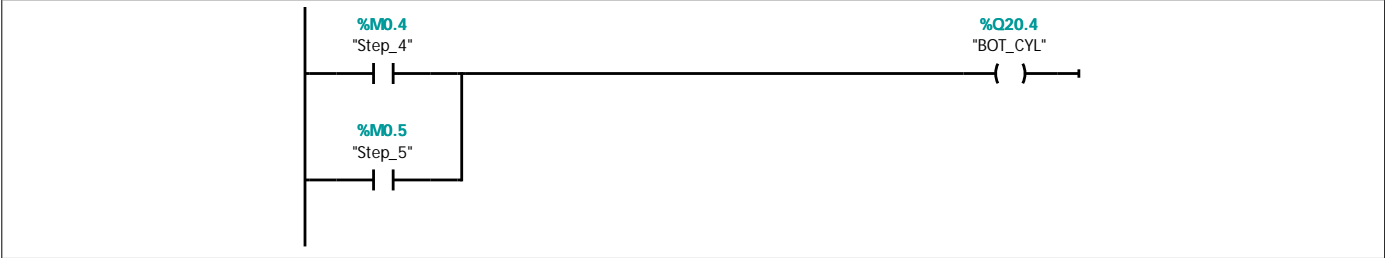
Network 12: Left cylinder control when on folds left flap inward



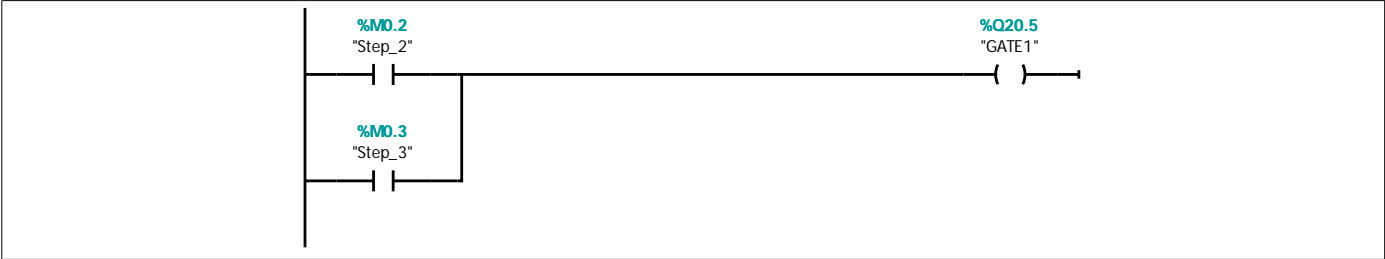
Network 13: Right cylinder control, when on folds right flap inward



Network 14: Bottom cylinder control, when on folds bottom flap inward



Network 15: Gate cylinder control, on to prevent carton from sliding out sta



Network 16: Chain conveyor motor control, when on moves carton out

