

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

Title	SP6-13	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 SP6-13 Erbia Can Tipper/Rotator Control

Additional internal memory:

Tag Address

Run %M5.0 BOOL On while station running

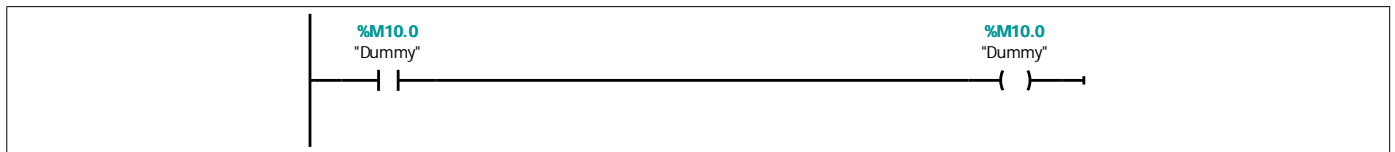
Int_Reset % M5.1 BOOL Internal reset

Step_1 to Step_9 %M0.1 to M1.1 BOOL Step-in-progress bits

Retract_Tmr %DB1 IEC_TIMER Times CYL_4 retract

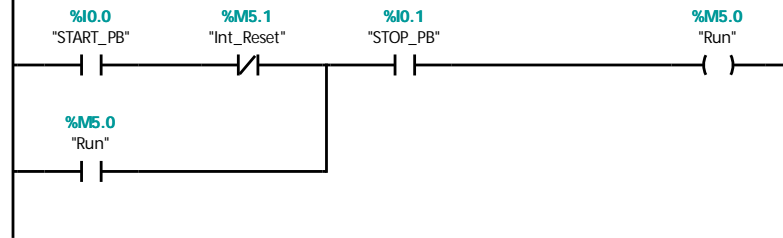
Blend_Tmr %DB3 IEC_TIMER Timer for blending

Blend_Ctr %DB6 CTU_SFB Counter for blend retentive timer

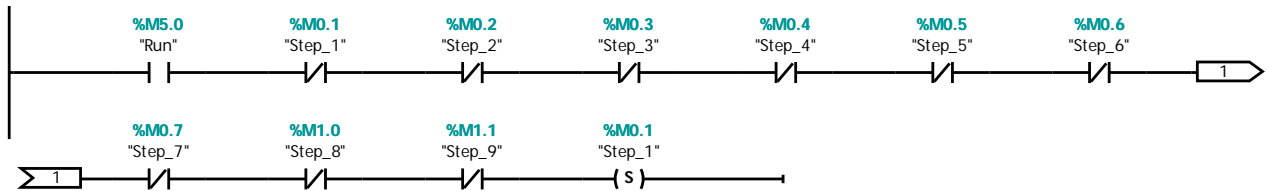


Network 2: Start/stop

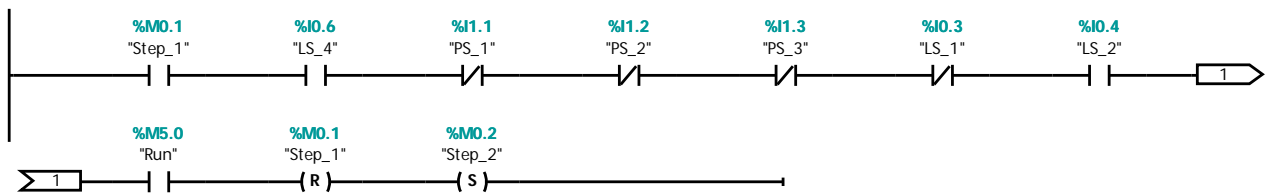
During reset prevent start



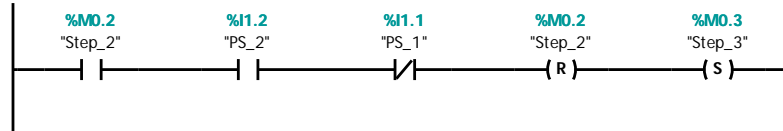
Network 3: Initial start



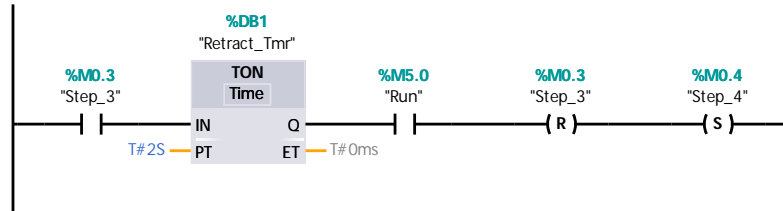
Network 4: Step 1 Wait for can



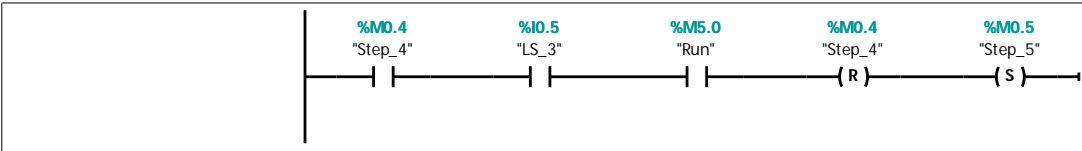
Network 5: Step 2 Push can into tipper.



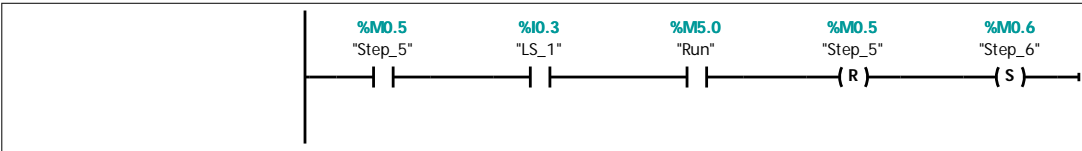
Network 6: Step 3 Wait for CYL_4 to retract



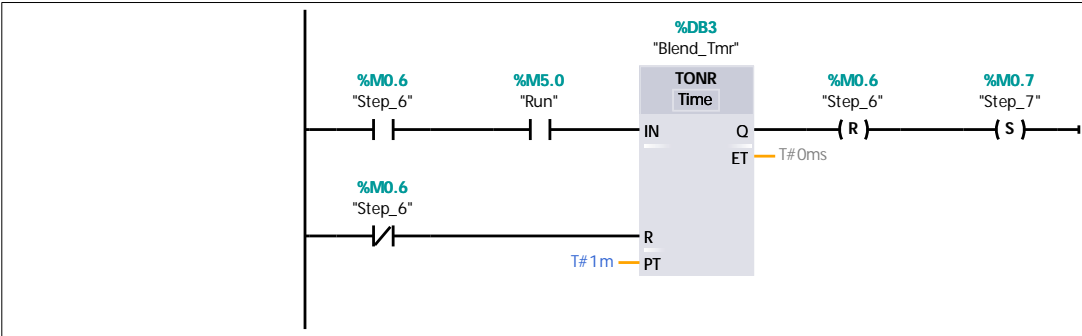
Network 7: Step 4 Clamp can



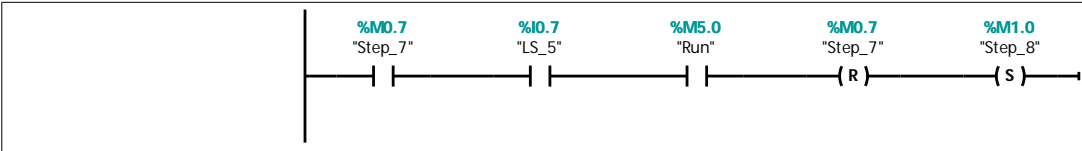
Network 8: Step 5 Tip rotator



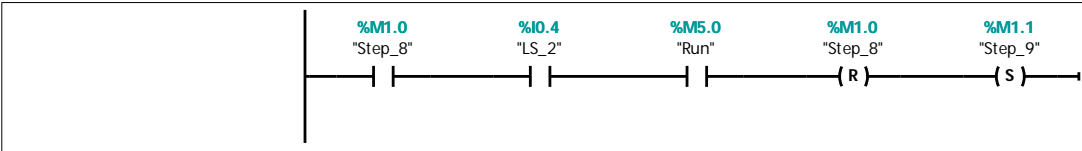
Network 9: Step 6 Blend



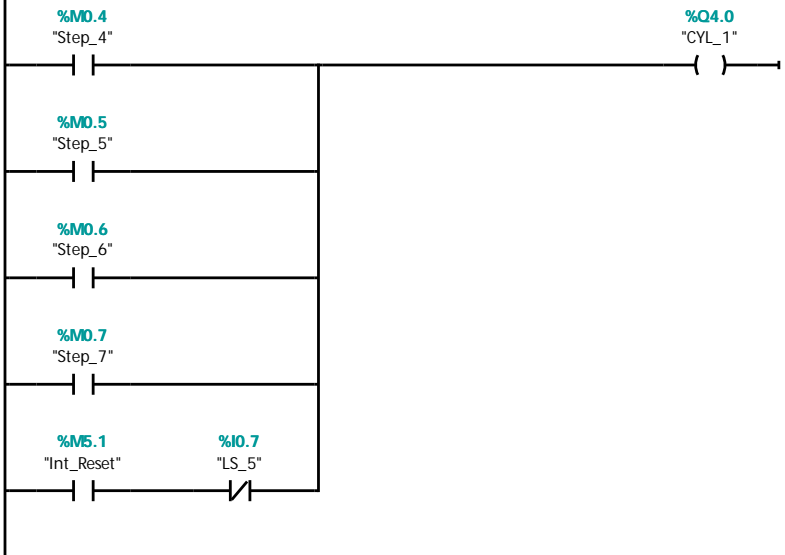
Network 10: Step 7 Untip



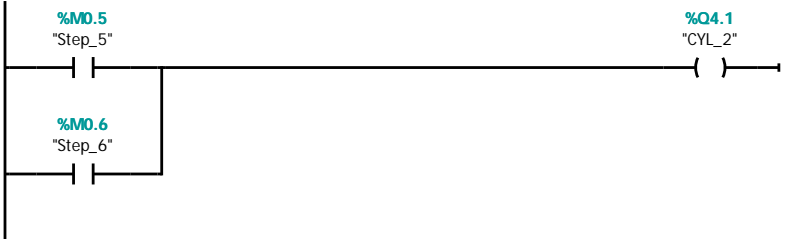
Network 11: Step 8 Unclamp



Network 12: Step 9 - Push out

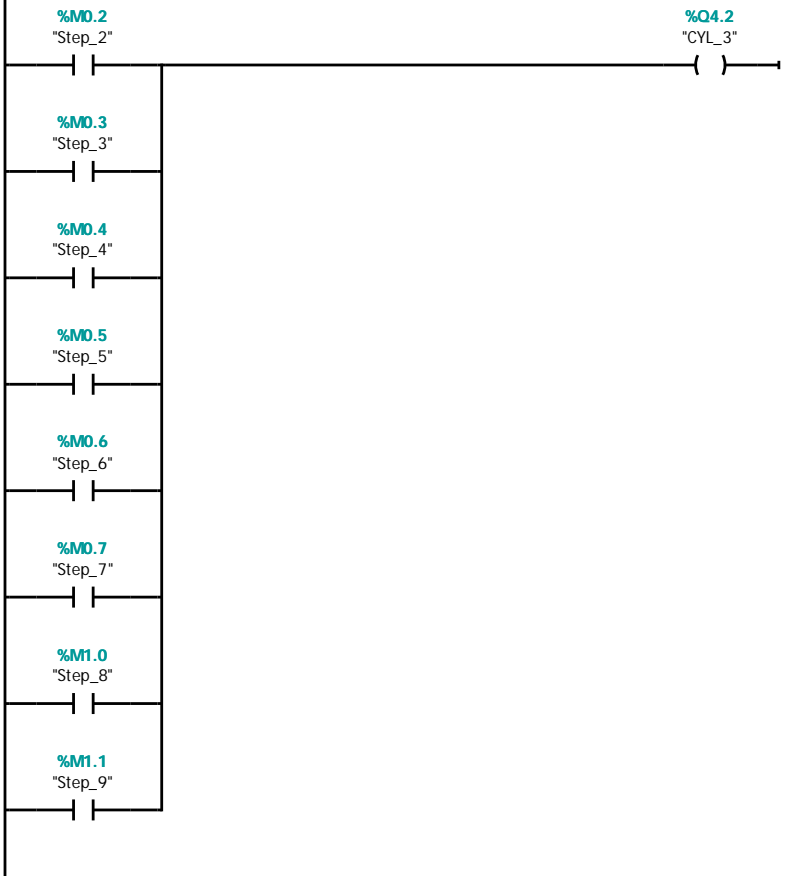


Network 15: CYL_2 control



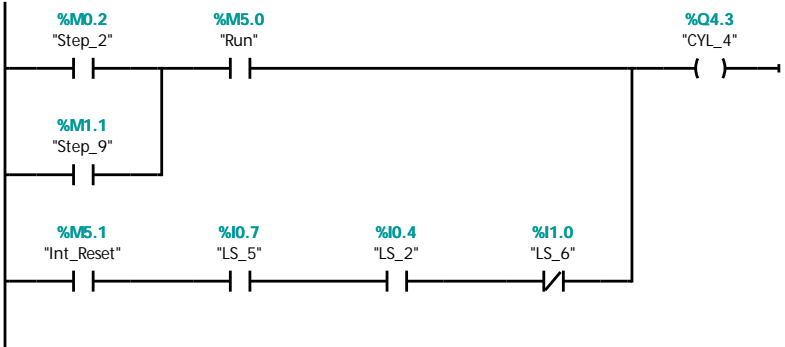
Network 16: CYL_3 control

Retract on reset



Network 17: CYL_4 control

On reset, do not push out until in vertical position and unclamped.



Network 18: Rotator motor control

Retract on reset

