

Totally Integrated Automation Portal

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

Title	SP6-17	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 SP6-17 Revised Parts Transfer Station Control

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

%M10.0

"Dummy"

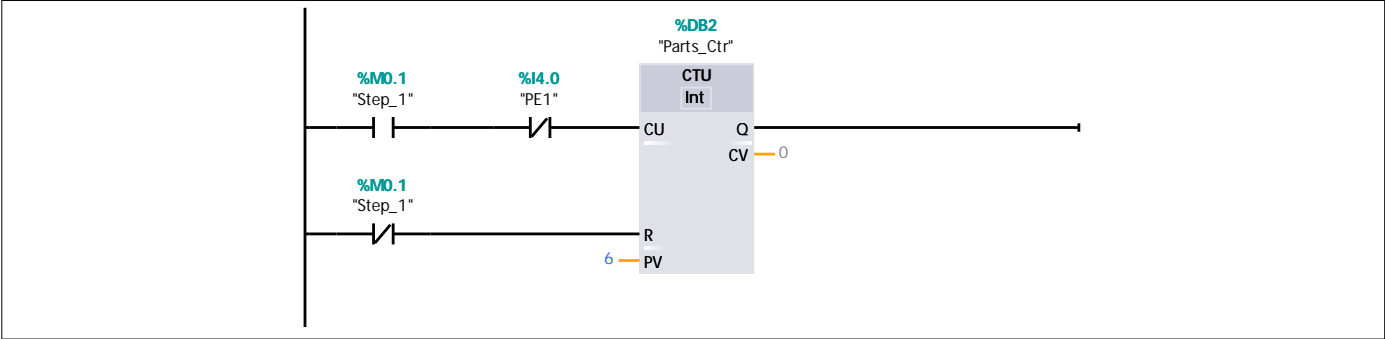
%M10.0

"Dummy"

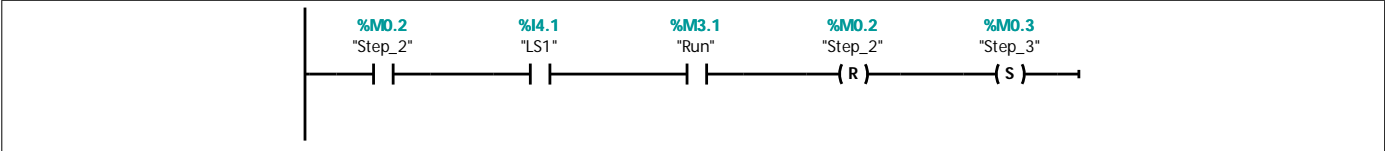
Network 2: Initial start



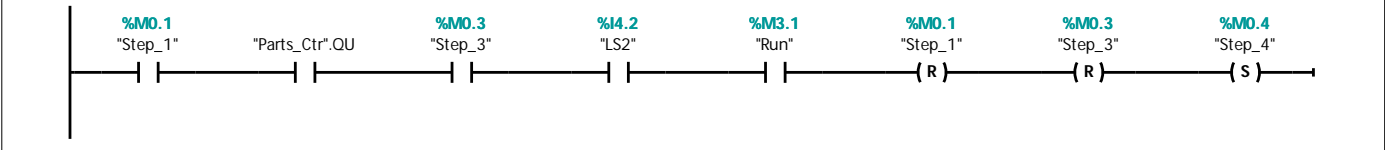
Network 3: Step 1 Count parts



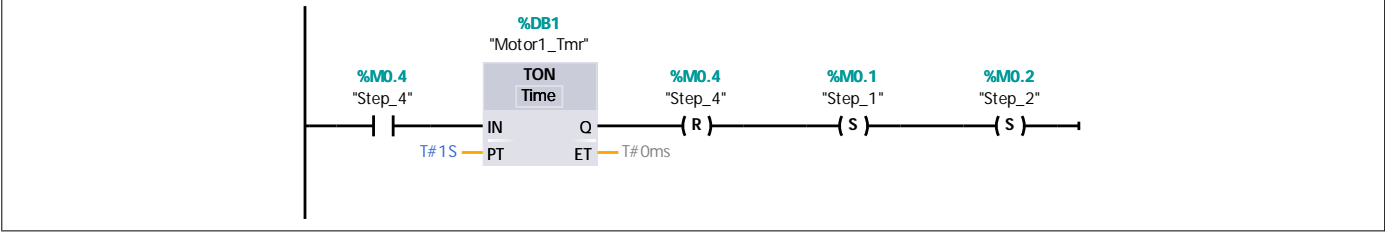
Network 4: Step 2 Extend Ram



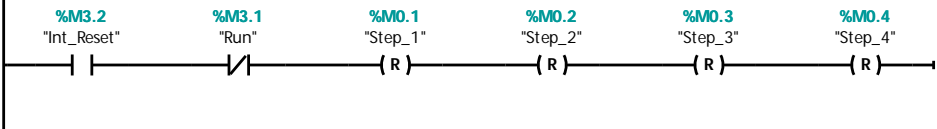
Network 5: Transition out of Step 1, Count Parts, and Step 3, Retract Ram



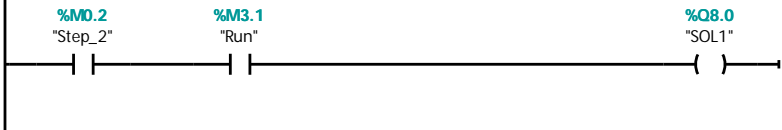
Network 6: Step 4 Rotate table



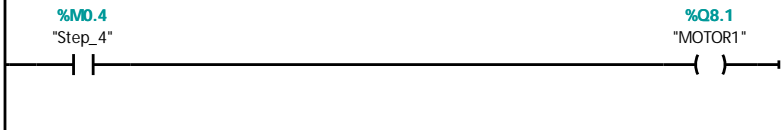
Network 7: Reset



Network 8: Pneumatic ram extension solenoid control, on to extend ram



Network 9: Turntable motor control, on to turn turntable



Network 10: Belt conveyor motor control, on to run conveyor

