

Totally Integrated Automation Portal

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

Title	SP6-1	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: SP6-1

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Carton Sealer 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_7 %M0.1 to M0.7 BOOL Step-in-progress bits

Spray_Tmr %DB1 IEC_TIMER Times spray

Dry_Tmr %DB3 IEC_TIMER Times drying step

Retract_Tmr %DB4 IEC_TIMER Times retract of rams

Reset_Tmr %DB5 IEC_TIMER Times reset (retract of rams)

%M1.0

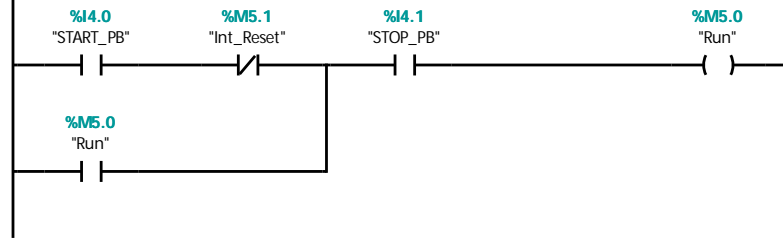
"Dummy"

%M1.0

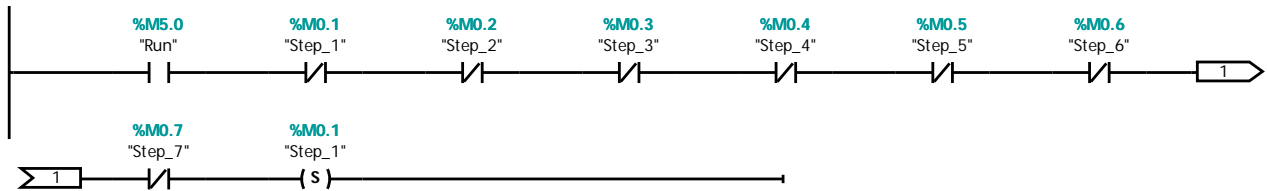
"Dummy"

Network 2: Start/stop

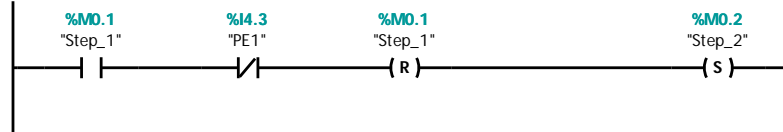
During reset prevent start



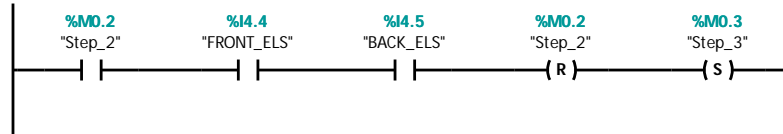
Network 3: Initial start



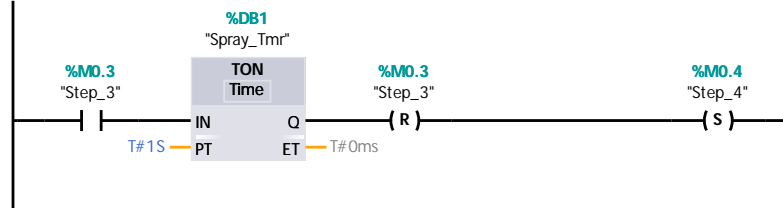
Network 4: Step 1 Wait for box



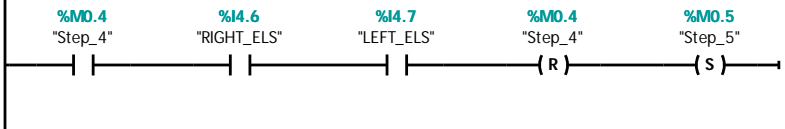
Network 5: Step 2 Push down end flaps



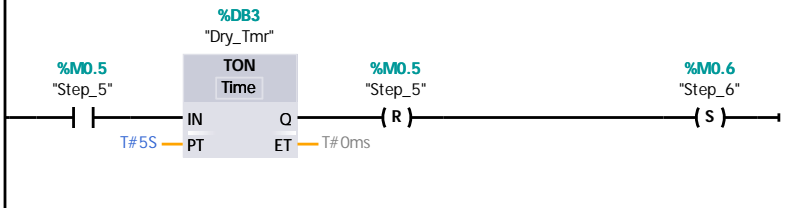
Network 6: Step 3 Spray Glue



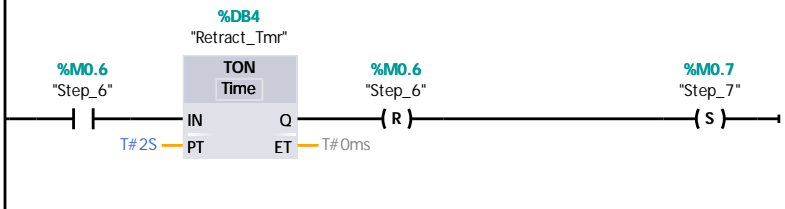
Network 7: Step 4 Push down side flaps



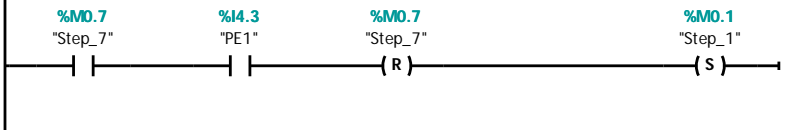
Network 8: Step 5 Drying wait



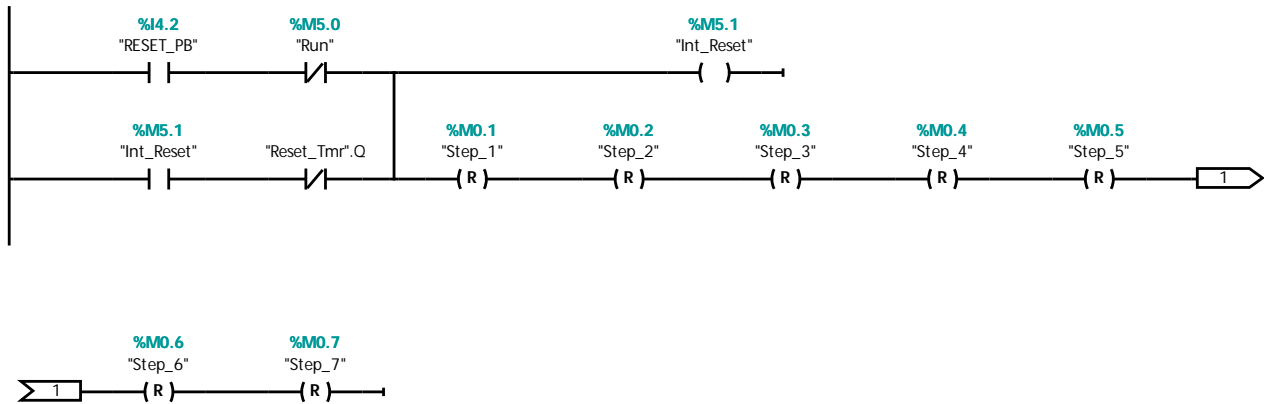
Network 9: Step 6 Retract rams



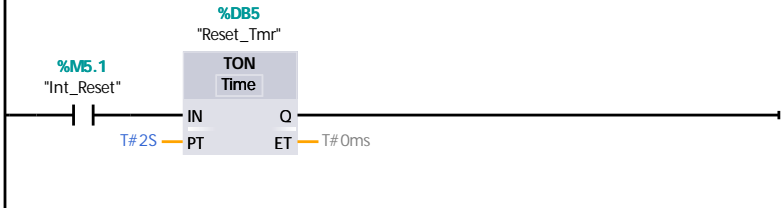
Network 10: Step 7 Move box out



Network 11: Reset



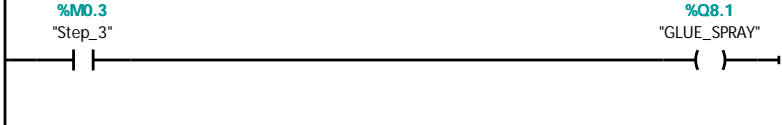
Network 12: Reset Timer



Network 13: Conveyor motor, on to move conveyor



Network 14: Glue sprayer control, on to spray glue



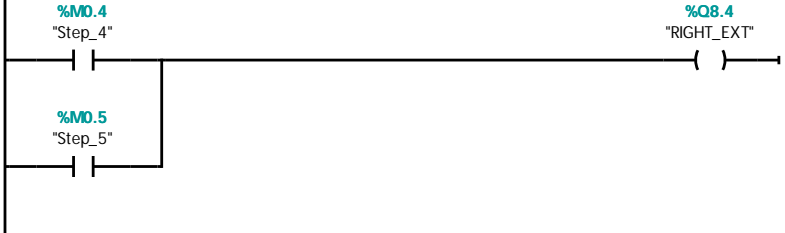
Network 15: Front flap ram extend direction control, on to extend ram



Network 16: Back flap ram extend direction control, on to extend ram



Network 17: Right flap ram extend direction control, on to extend ram



Network 18: Left flap ram extend direction control, on to extend ram

%M0.4
"Step_4"

%M0.5
"Step_5"

%Q8.5
"LEFT_EXT"

