

## Main Properties

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<b>Name</b>	Main	<b>Number</b>	1	<b>Type</b>	OB
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<b>Language</b>	LAD	<b>Numbering</b>	Manual	
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## Information

<b>Title</b>	SP6-8	<b>Author</b>		<b>Comment</b>	
<b>Family</b>		<b>Version</b>	0.1	<b>User-defined ID</b>	

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 SP6-8 Hole Drilling Station 1 Control

Additional internal memory:

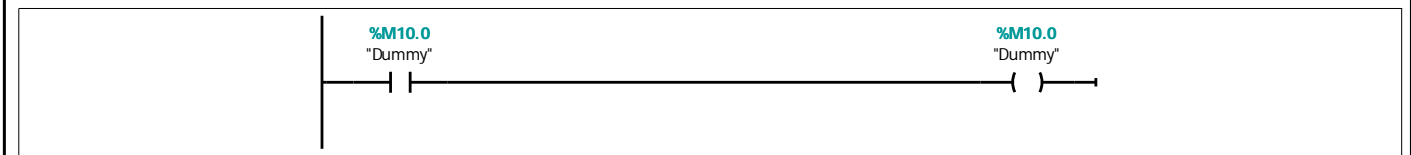
Tag Address	
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Run %M5.0 BOOL On while station running

Int_Reset %M5.1 BOOL Internal reset	0
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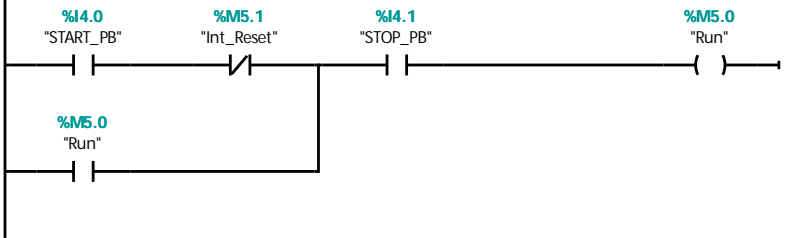
Step_1 to Step_6 %M0.1 to M0.6 BOOL Step-in-progress bits
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Gate\_Tmr %DB1 IEC\_TIMER Gate 1 timer

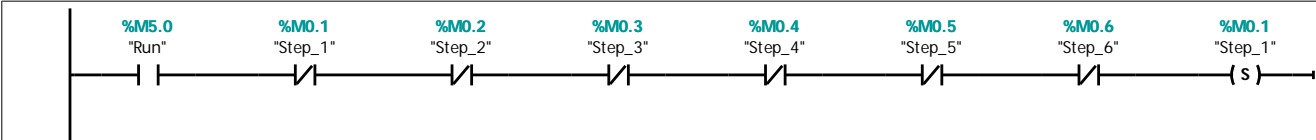


### Network 2: Start/stop

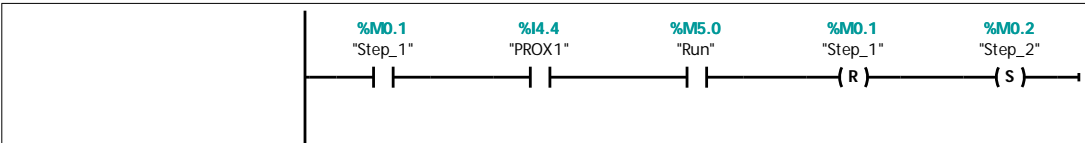
During reset prevent start	
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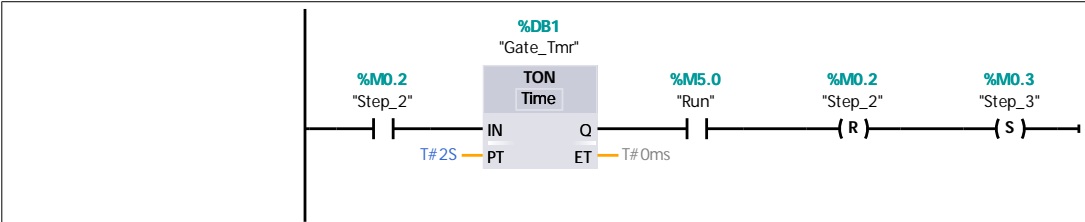
**Network 3: Initial start**



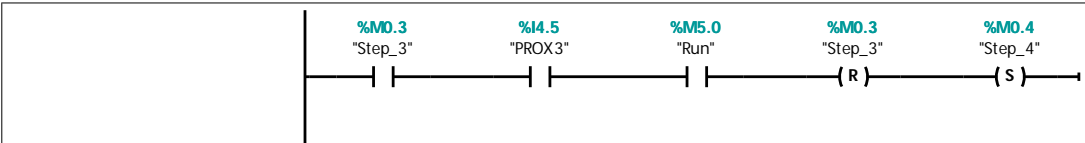
**Network 4: Step 1 Wait for part**



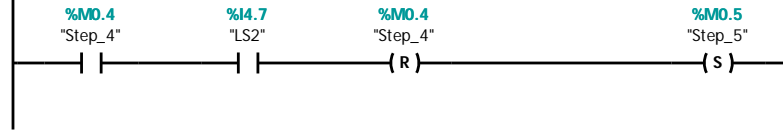
**Network 5: Step 2 Open Gate 1**



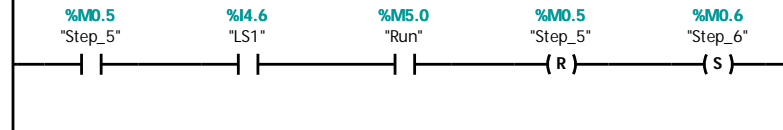
**Network 6: Step 3 Open Gate 2**



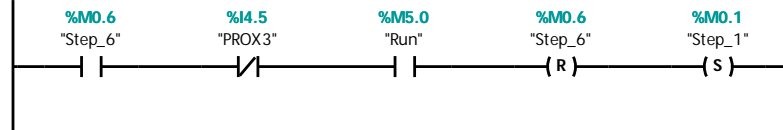
**Network 7: Step 4 Extend drill**



### Network 8: Step 5 Retract drill

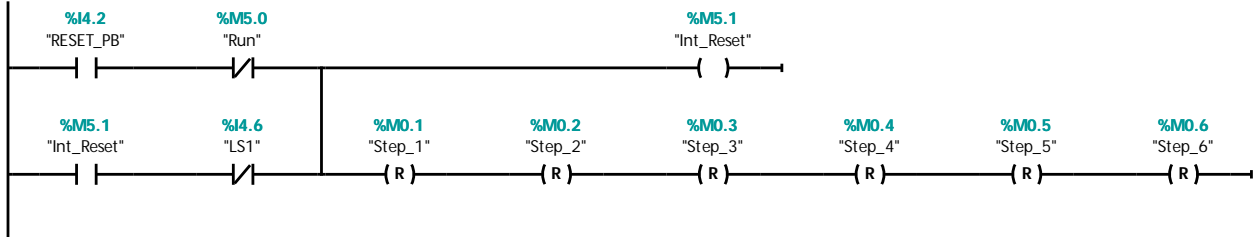


### Network 9: Step 6 Move out part



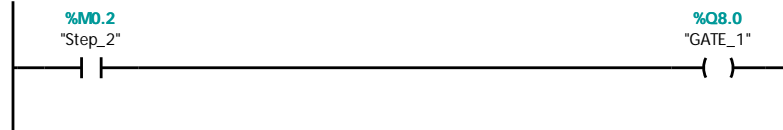
### Network 10: Reset

Keep internal reset on while retracting drill.



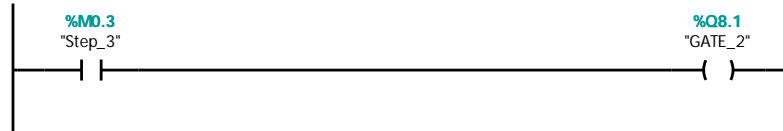
### Network 11: Gate 1 cylinder control, on to open gate 1

Can not turn off when paused.



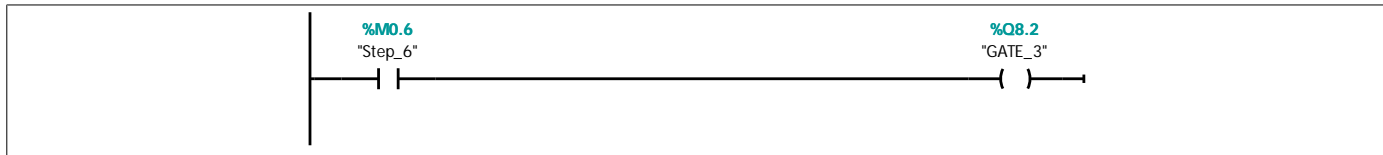
### Network 12: Gate 2 cylinder control, on to open gate 2

Can not turn off when paused.

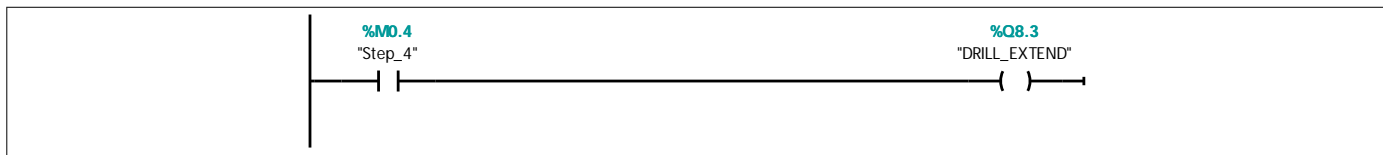


### Network 13: Gate 3 cylinder control, on to open gate 3

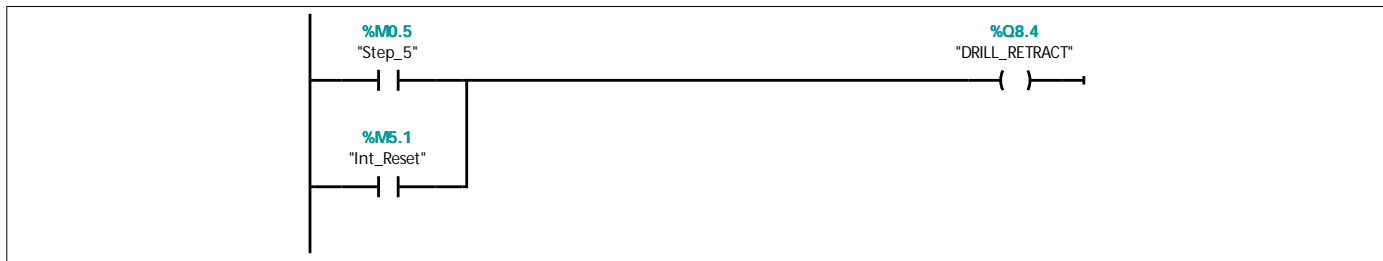
Can not turn off when paused.



### Network 14: Drill extension cylinder control, on to extend drill



### Network 15: Drill retraction cylinder control, on to retract drill



### Network 16: Drill motor control, on to cause drill to rotate

