

## Main Properties

General	
1	General
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99	General
100	General

<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	
1	Information
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99	Information
100	Information

Title	SP6-15	Author		Comment	
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Family		Version	0.1	User-defined	
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				ID	
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▼ Temp		
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OB1 EV CLASS	Byte	
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OB1_EV_CLASS	Byte	
OB1_SCAN_1	Byte	

OBJ_SCAN_T	Byte	
OBJ_PRIORITY	Byte	

OBJ_PRIORITY	Byte	
OBJ_OBJ_NUMBER	Byte	

OB1_OB_NUMBR	Byte	
OB1_RESERVED_1	Byte	

OBT_RESERVED_1	byte	
OBT_RESERVED_2	byte	

OBT_RESERVED_2	Byte	
OBT_RESERVED_3	Byte	

OB1_PREV_CYCLE	int	
OB1_MAX_CYCLE	int	

OB1_MIN_CYCLE	Int	

OB1_MAX_CYCLE	Int	

OB1_DATE_TIME	Date_And_Time	
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Constant		
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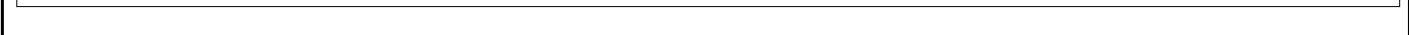
Tag Address	
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Run %M5.0 BOOL On while station running
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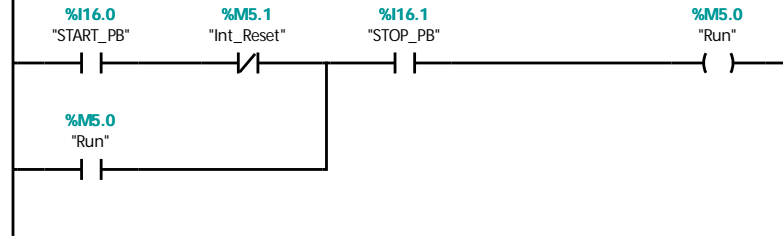
Int_Reset %M5.1 BOOL Internal reset
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Step_1 to Step_10 %M0.1 to M1.2 BOOL Step-in-progress bits
--

Unclmp_Tmr %DB1 IEC_TIMER Time unclamping of part
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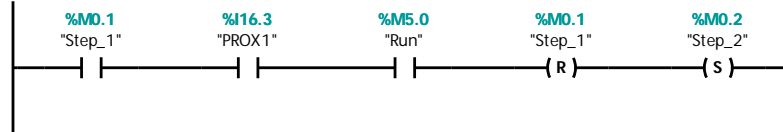
During reset prevent start



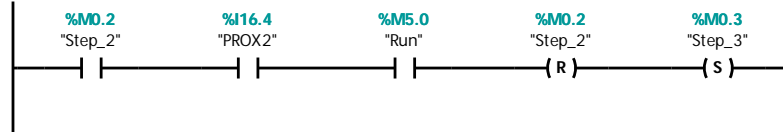
### Network 3: Initial start



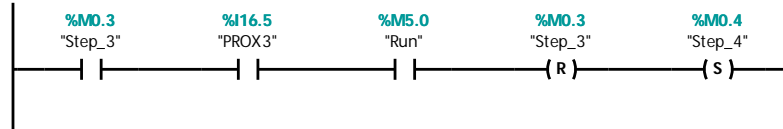
### Network 4: Step 1 Wait for part



### Network 5: Step 2 Open gate 1



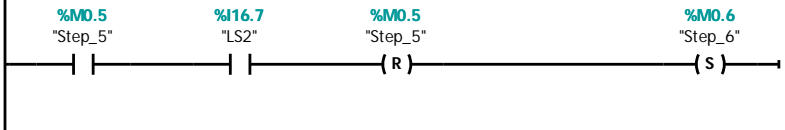
### Network 6: Step 3 Open gate 2



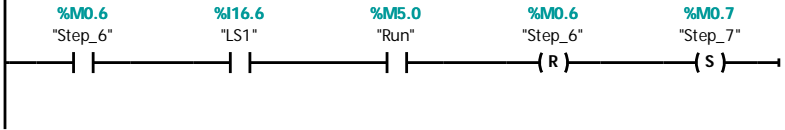
### Network 7: Step 4 Clamp part



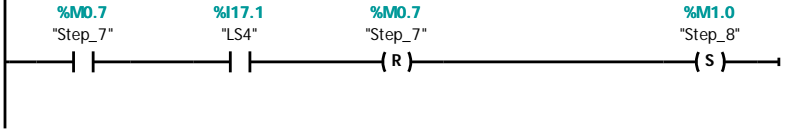
Network 8: Step 5 Extend drill 1



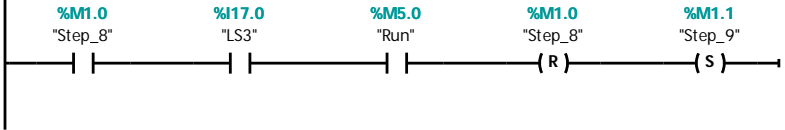
Network 9: Step 6 Retract drill 1



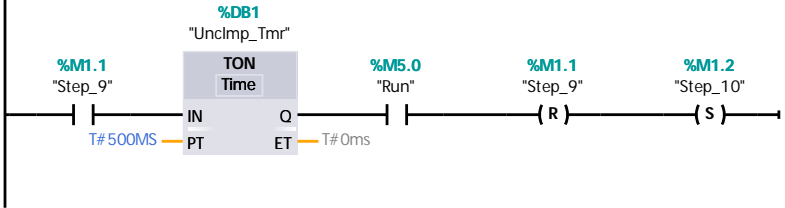
Network 10: Step 7 Extend drill 2



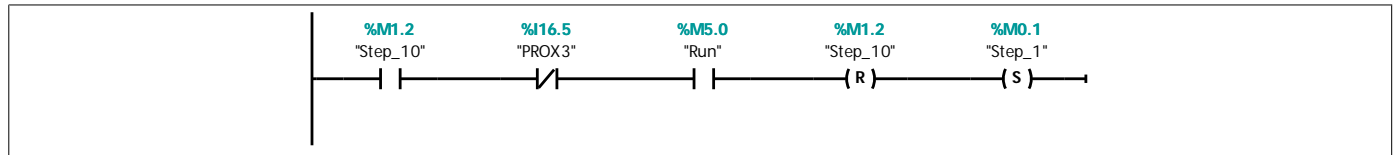
Network 11: Step 8 Retract drill 2



Network 12: Step 9 Unclamp part

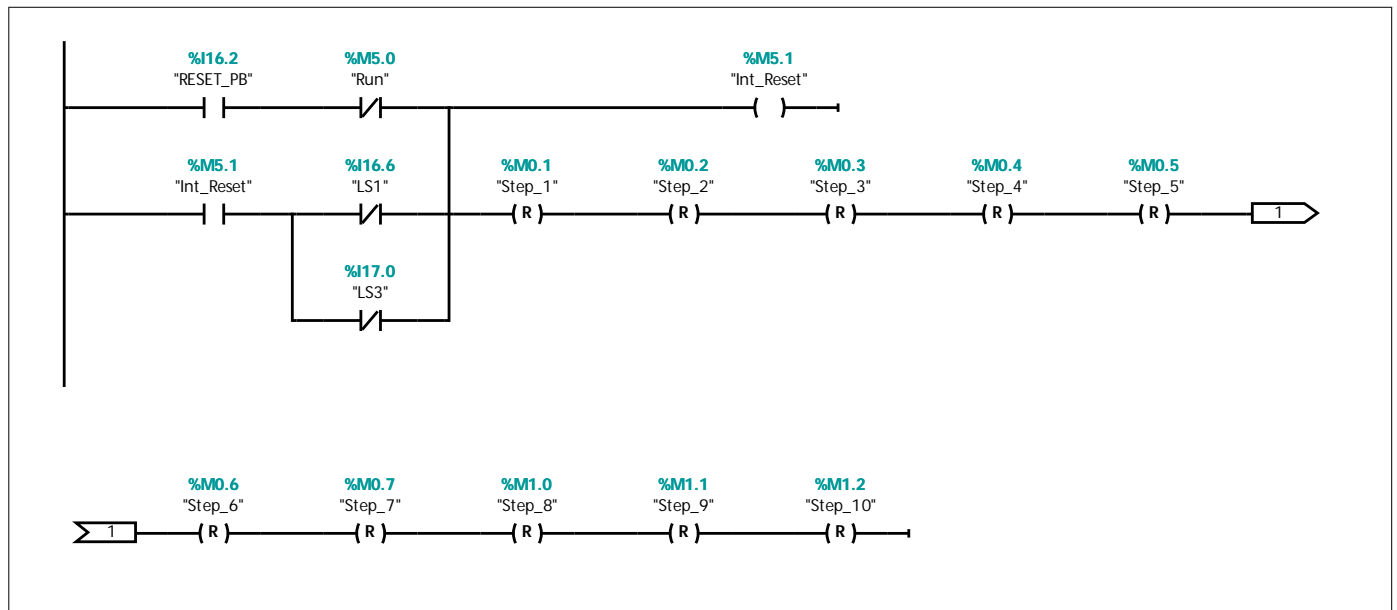


### Network 13: Step 10 Move out part

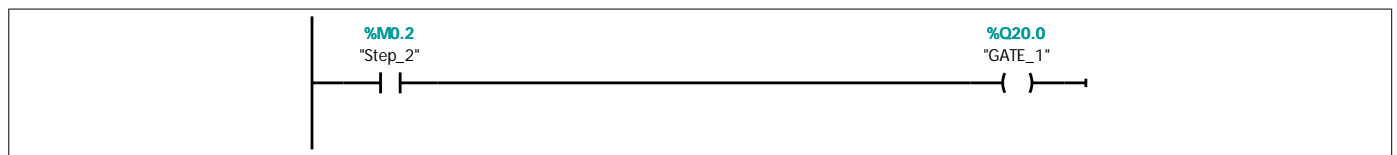


### Network 14: Reset

Maintain reset until both drill retracted.

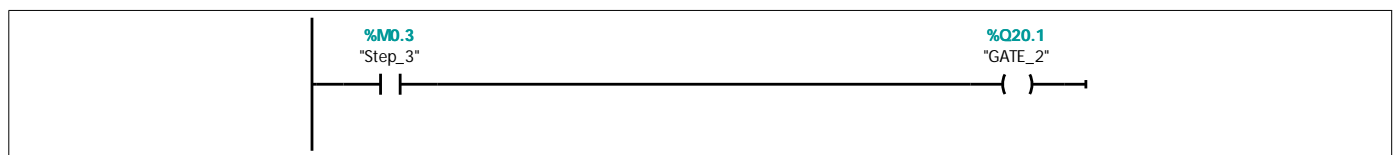


### Network 15: Gate controls



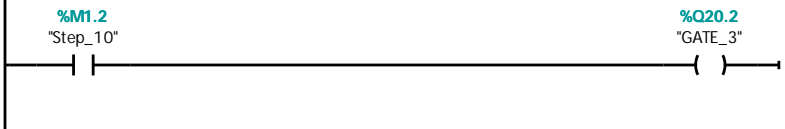
### Network 16: Gate 2 control

Retract on reset

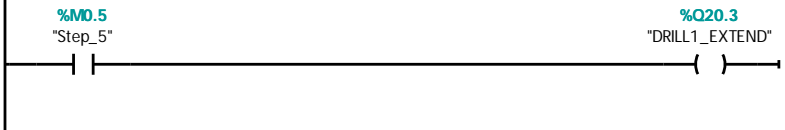


### Network 17: Knife controls

Retract on reset

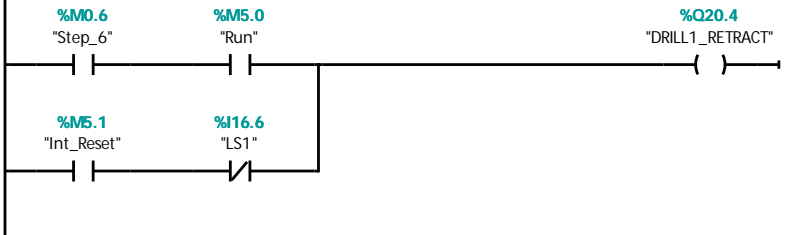


**Network 18: Drill 1 controls**



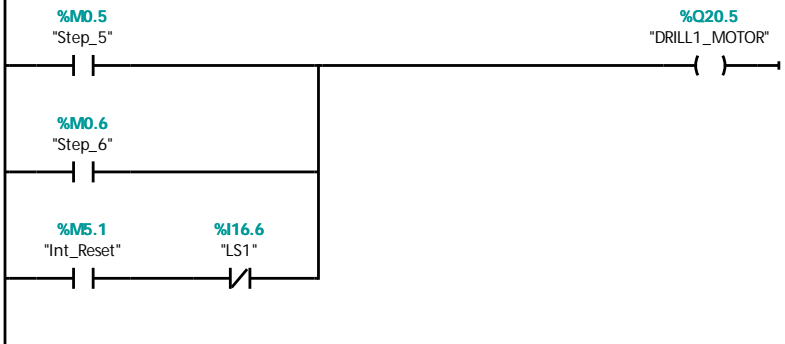
**Network 19: Drill 1 retraction control**

Must also retract on reset

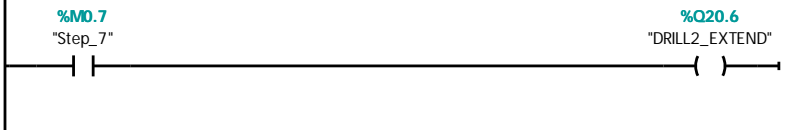


**Network 20: Drill 1 motor control**

Must continue to run drill motor while retracting due to reset

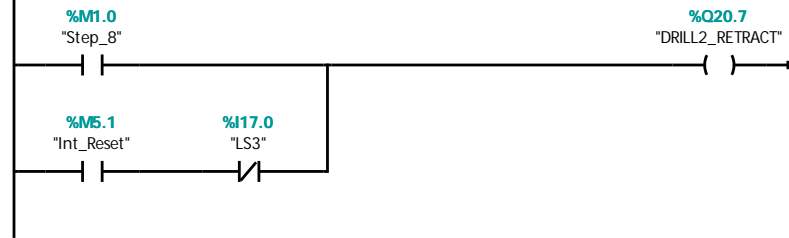


**Network 21: Drill 2 controls**



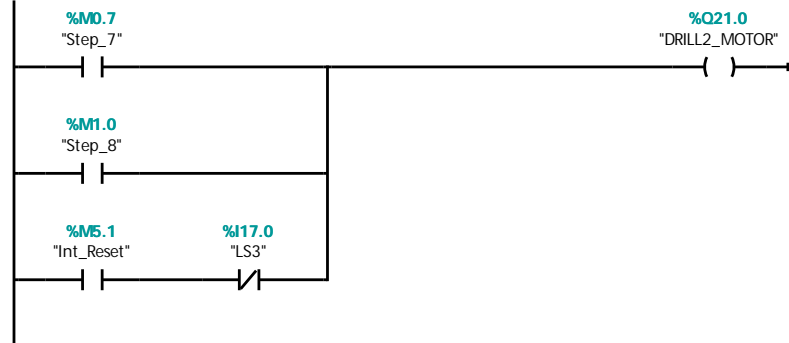
**Network 22: Drill 2 retraction control**

Must also retract on reset



### Network 23: Drill 2 motor control

Must continue to run drill motor while retracting due to reset



### Network 24: Clamp control

Must remain on when paused and when resetting, before both drills retracted.

