

Totally Integrated Automation Portal

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

Title	SP7-9	Author		Comment	
Family		Version	0.1	User-defined ID	

Name	Data type	Offset	Default value	Comment
▼ Temp				
OB1_EV_CLASS	Byte	0.0		Bits 0-3 = 1 (Coming event), Bits 4-7 = 1 (Event class 1)
OB1_SCAN_1	Byte	1.0		1 (Cold restart scan 1 of OB 1), 3 (Scan 2-n of OB 1)
OB1_PRIORITY	Byte	2.0		Priority of OB Execution
OB1_OB_NUMBR	Byte	3.0		1 (Organization block 1, OB1)
OB1_RESERVED_1	Byte	4.0		Reserved for system
OB1_RESERVED_2	Byte	5.0		Reserved for system
OB1_PREV_CYCLE	Int	6.0		Cycle time of previous OB1 scan (milliseconds)
OB1_MIN_CYCLE	Int	8.0		Minimum cycle time of OB1 (milliseconds)
OB1_MAX_CYCLE	Int	10.0		Maximum cycle time of OB1 (milliseconds)
OB1_DATE_TIME	Date_And_Ti me	12.0		Date and time OB1 started
Constant				

Network 1: SP7-9

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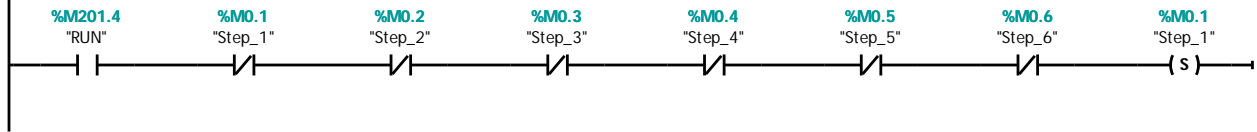
SP7-9 Valve Leak Check Station Control

Additional internal memory:  
Tag Address  
Int\_Reset %M5.1 BOOL Internal reset  
Step\_1 to Step\_6 %M0.1 to M0.6 BOOL Step-in-progress bits  
Wait\_Tmr %DB1 TON\_SFB Times leak test  
Ret\_Val %MW12 WORD Return value from SCALE block

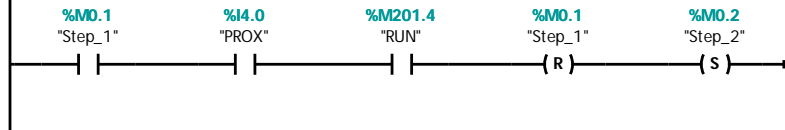
%M2.0  
"Dummy"

%M2.0  
"Dummy"

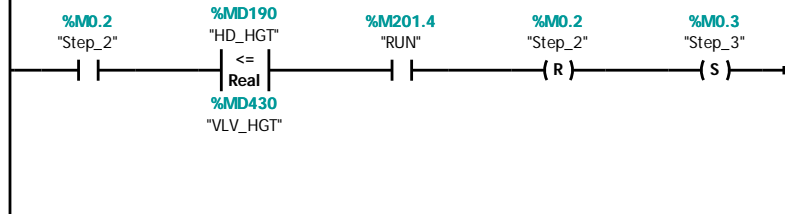
Network 2: Initial Start



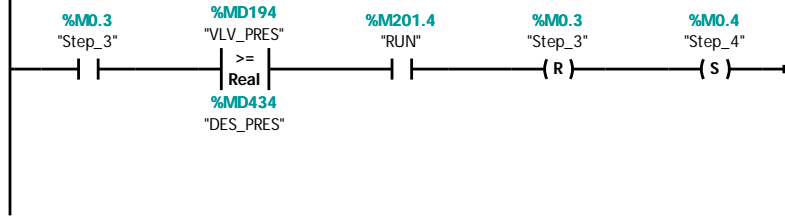
Network 3: Step 1 Wait for valve



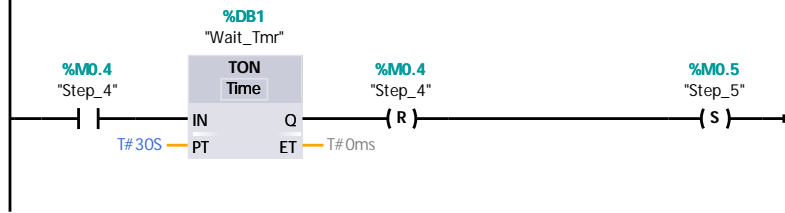
Network 4: Step 2 Head down



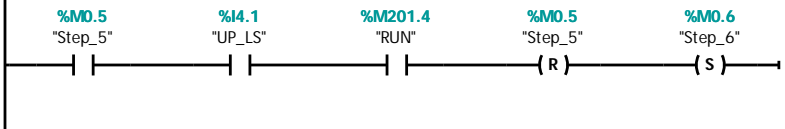
Network 5: Step 3 Pressurize



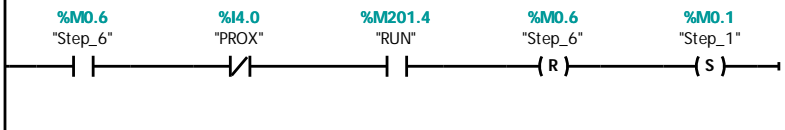
Network 6: Step 4 - Wait for pressure check



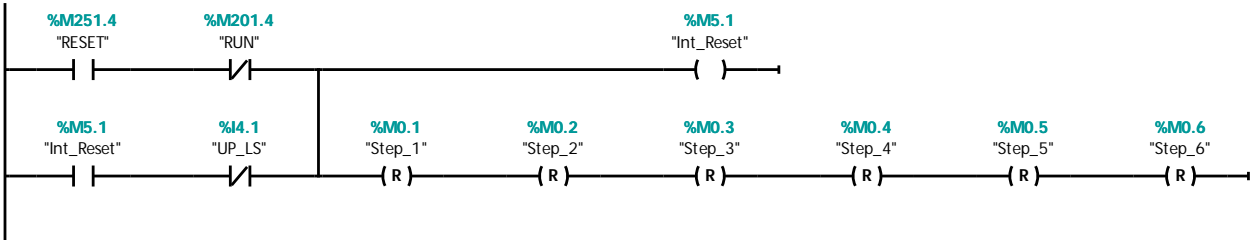
Network 7: Step 5 Head up



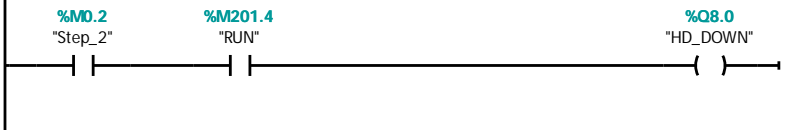
**Network 8: Step 6 - Push to conveyor**



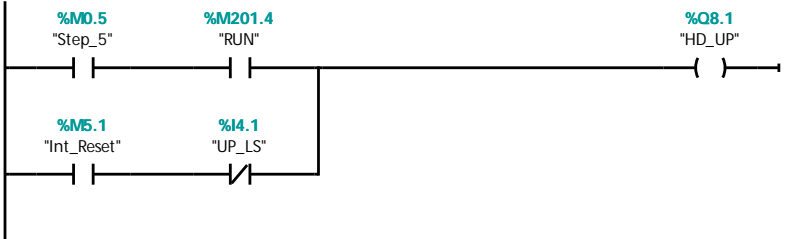
**Network 9: Reset**



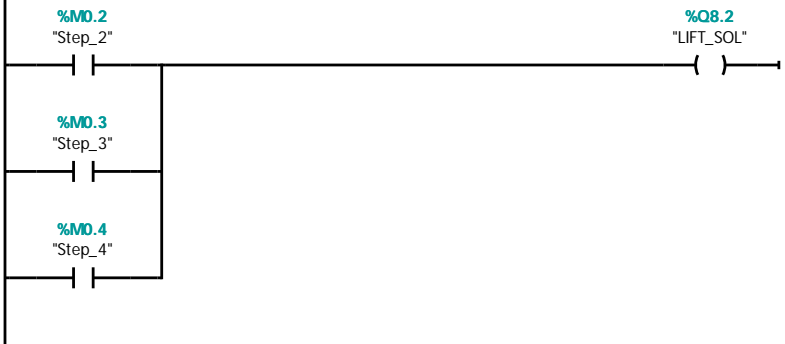
**Network 10: Head Raise/Lower**



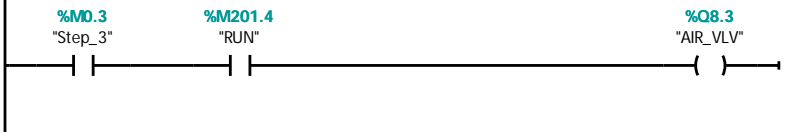
**Network 11: PCYL controls**



**Network 12: Lift Solenoid. Must remain on when paused**

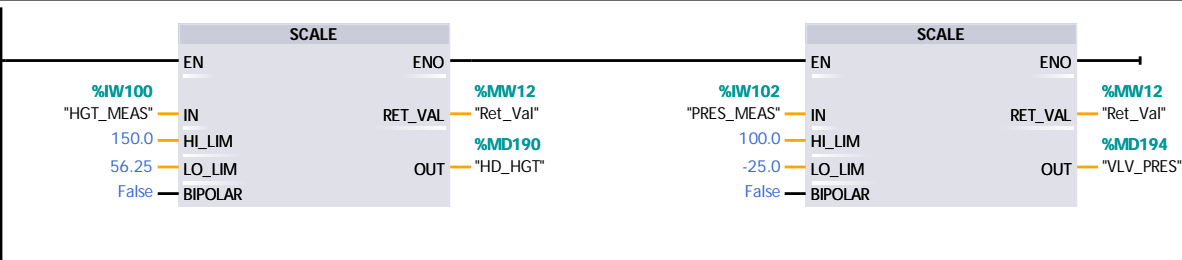


**Network 13: Air Valve**



**Network 14: Convert height and pressure measurements using SCALE**

Convert height measurement to mm and pressure measurement to psi.  
Uses SCALE block. Note that the lo\_lim input is 25% lower than zero weight to account for this block assuming the minimum value of the analog in is zero rather than the 5530 (which corresponds to 4 mA).



**Network 15: Set if valve is to be rejected because it will not hold pressure**

Check valve pressure during step 4. If falling, set reject bit.

