

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

Title	SP6-9	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: SP6-9

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Problem SP6-9 Part Oiler Station 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_6 %M0.1 to M0.6 BOOL Step-in-progress bits

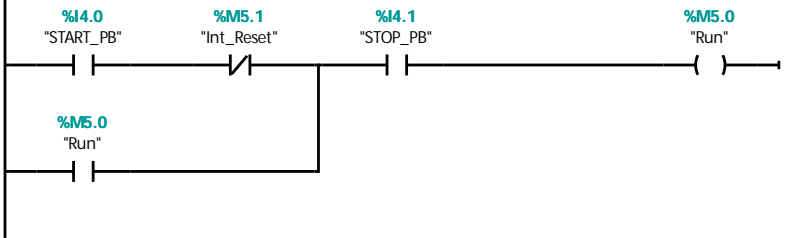
Engage_Tmr %DB1 IEC_TIMER Times engage of part

Squirt_Tmr %DB3 IEC_TIMER Times oil squirt

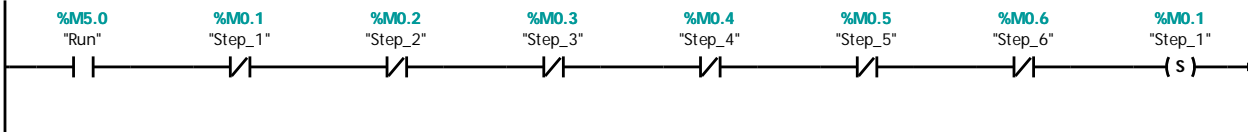


Network 2: Start/stop

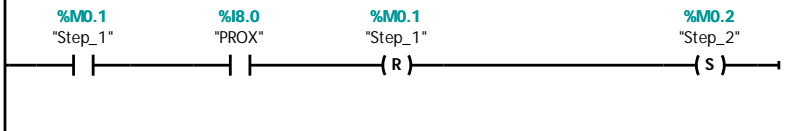
During reset prevent start



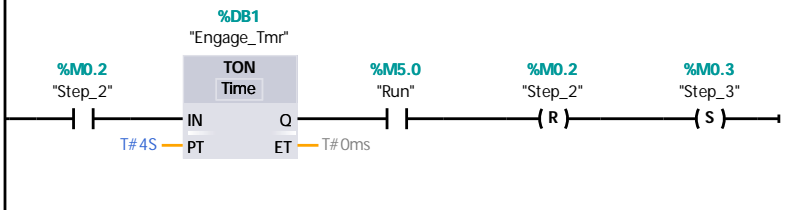
Network 3: Initial start



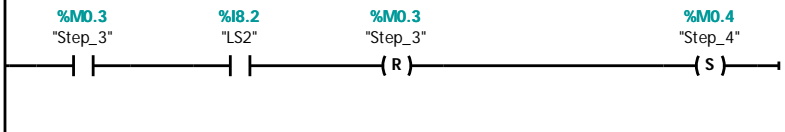
Network 4: Step 1 Wait for part



Network 5: Step 2 Wait for engage



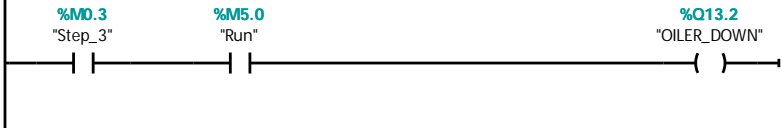
Network 6: Step 3 Lower oiler



Network 7: Step 4 Squirt oil

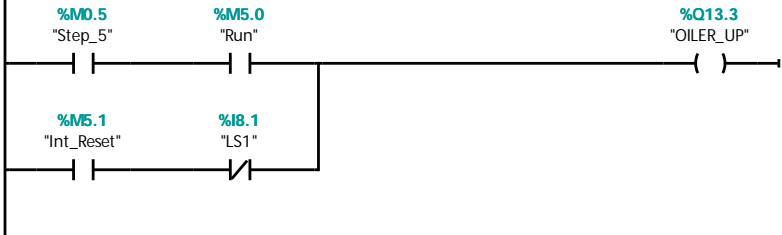


Network 12: On to lower oiler tip



Network 13: On to raise oiler tip

Raise oiler tip during reset



Network 14: On to open valve and squirt oil

Can not turn off when paused.

