

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
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Language	LAD	Numbering	Manual		
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Information

Title	SP6-12	Author		Comment	
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Family		Version	0.1	User-defined ID	
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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: SP6-12

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Problem SP6-12 Batch Control

Additional internal memory:

Tag Address

Run %M5.0 BOOL On while station running

Int_Reset %M5.1 BOOL Internal reset

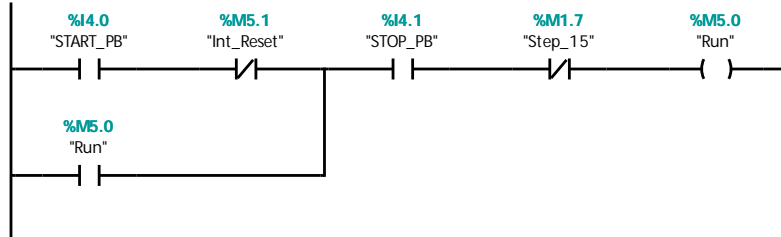
Step_1 to Step_15 %M0.1 to M1.7 BOOL Step-in-progress bits

Stir_Step_Tmr %DB2 IEC_TIMER Stir step retentive timer

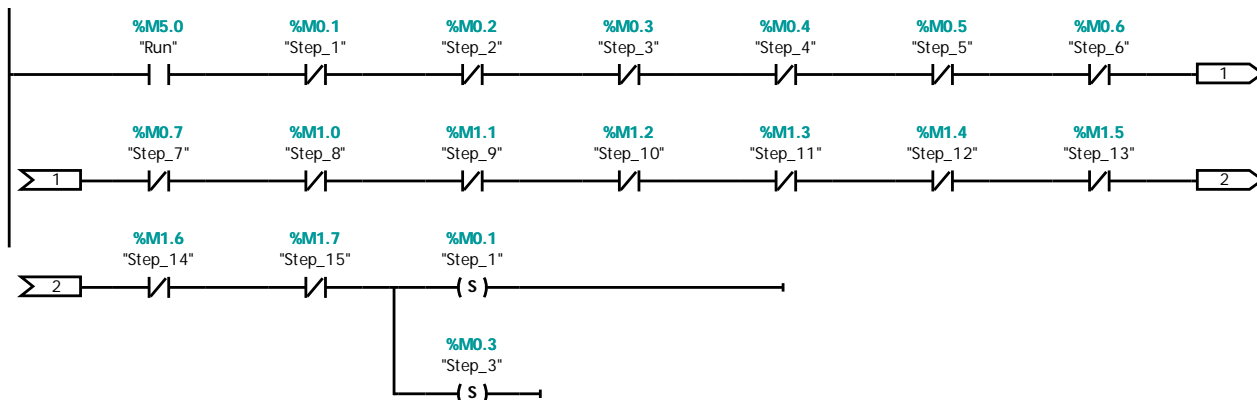


Network 2: Start/stop

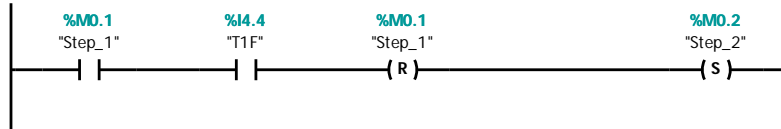
During reset prevent start



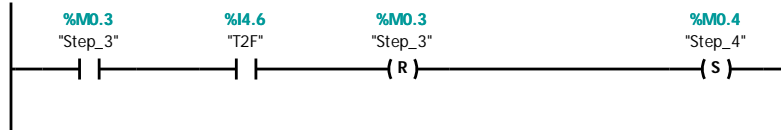
Network 3: Initial start



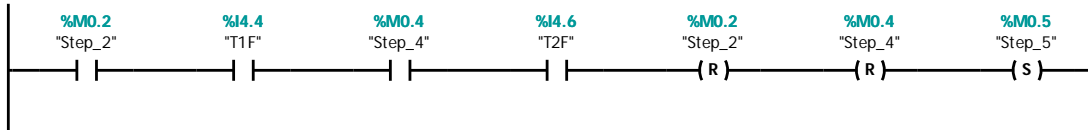
Network 4: Step 1 Fill Tank 1



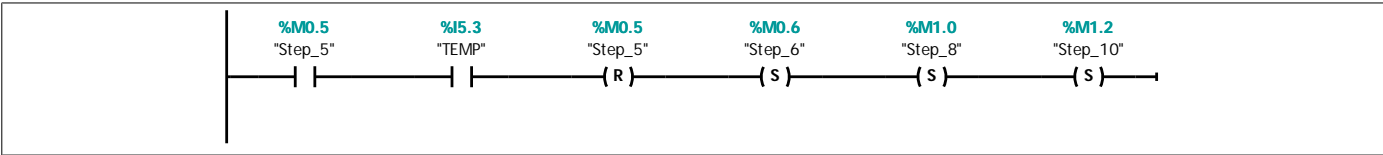
Network 5: Step 3 Fill Tank 2



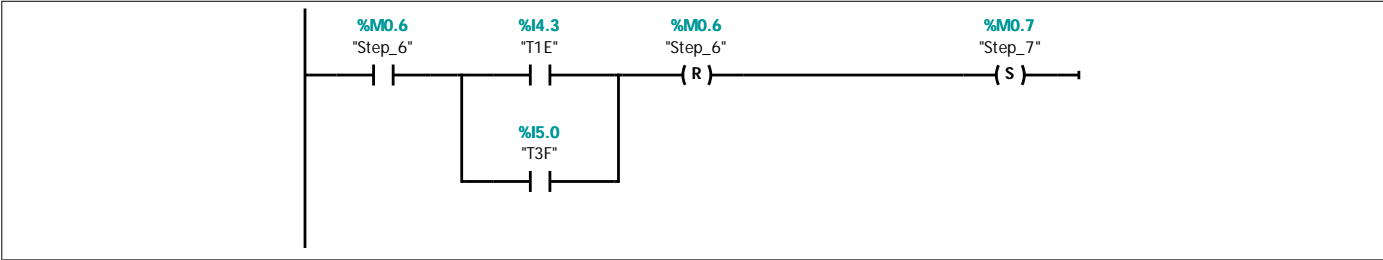
Network 6: Steps 2 and 4 Wait for Tanks 1 and 2 to be full



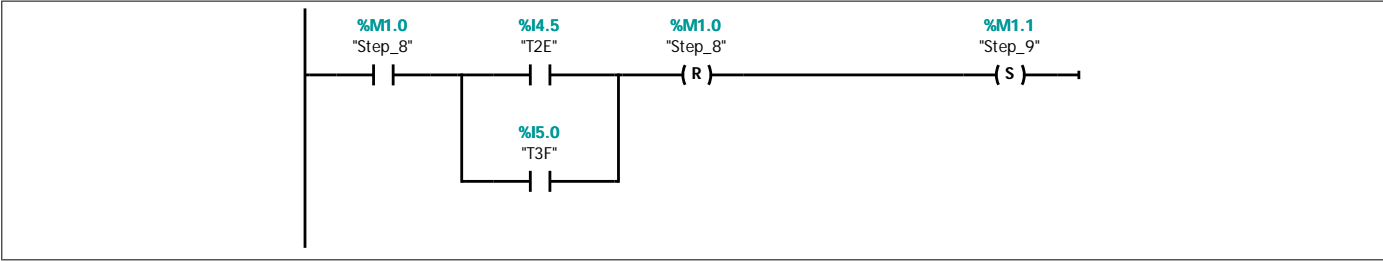
Network 7: Step 5 Heat Tank 2



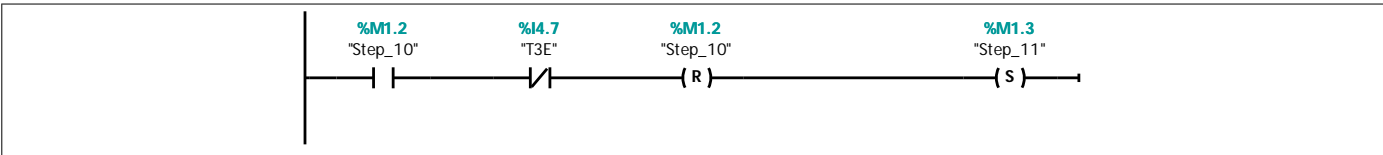
Network 8: Step 6 Empty Tank 1



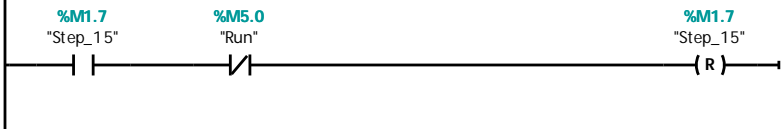
Network 9: Step 8 Empty Tank 2



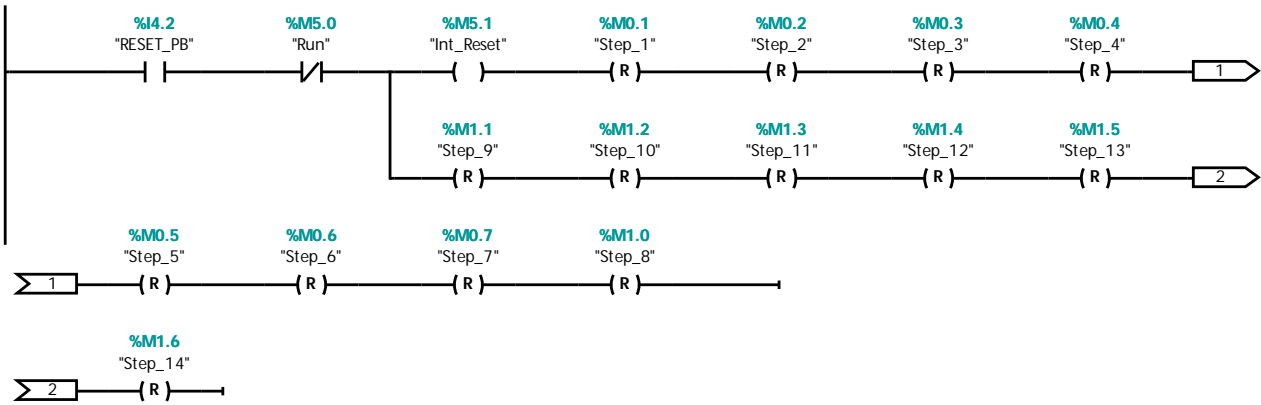
Network 10: Step 10 Wait for liquid in Tank 3



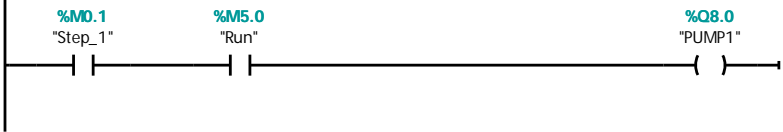
Network 11: Step 7, 9, 11 Wait for Tanks 1 & 2 to be empty and stirrer start



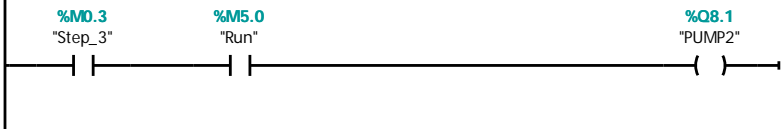
Network 16: Reset



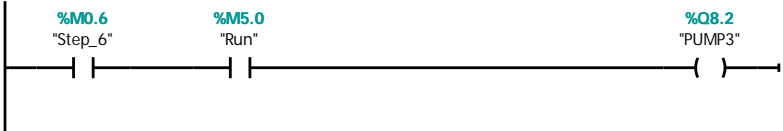
Network 17: Pump 1 motor control, on to run Pump 1



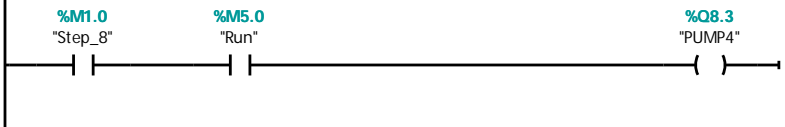
Network 18: Pump 2 motor control, on to run Pump 2



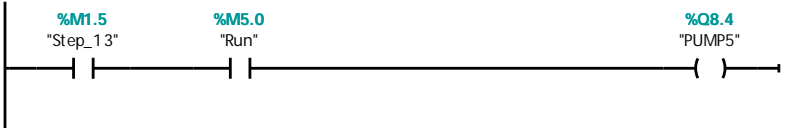
Network 19: Pump 3 motor control, on to run Pump 3



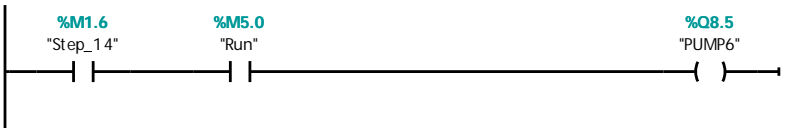
Network 20: Pump 4 motor control, on to run Pump 4



Network 21: Pump 5 motor control, on to run Pump 5

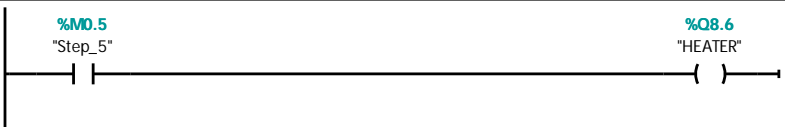


Network 22: Pump 6 motor control, on to run Pump 6



Network 23: Tank 2 heater control, on to heat tank 2

Can not turn off



Network 24: Tank 3 stirrer motor control, on o stir Tank 3 contents

