

Totally Integrated Automation Portal

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

Title	SP7-7	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: SP7-7

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SP7-7 Width Check Station Control

Additional internal memory:
Tag Address
Run %M3.1 BOOL On while station running
Step_1 to Step_3 %M0.1 to M0.3 BOOL Step-in-progress bits
Clamp_Tmr %DB1 IEC_TIMER Delay for measurement to stabilize
Release_Tmr %DB3 IEC_TIMER Delay to allow parts to move out
Part_Ctr %DB2 IEC_COUNTER Counts parts
Ret_Val %MW12 WORD Return value from SCALE block

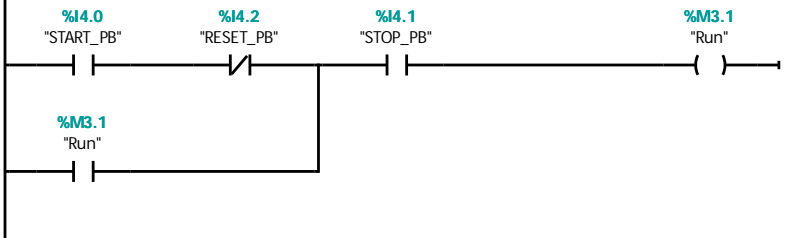
%M1.0

"Dummy"

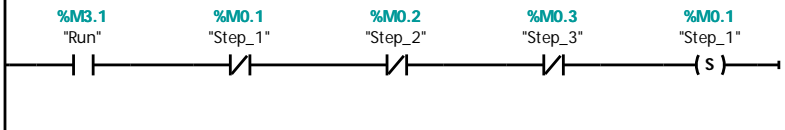
%M1.0

"Dummy"

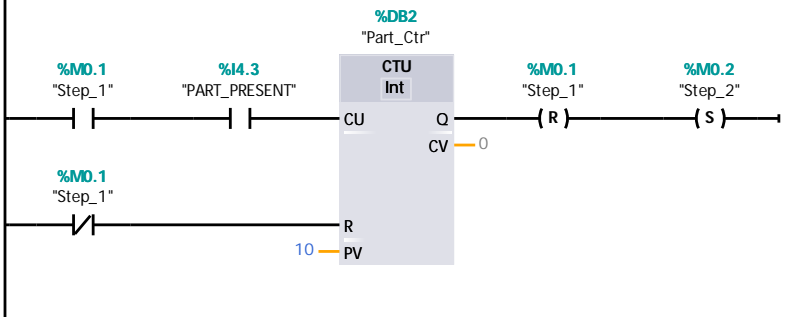
Network 2: Start/stop



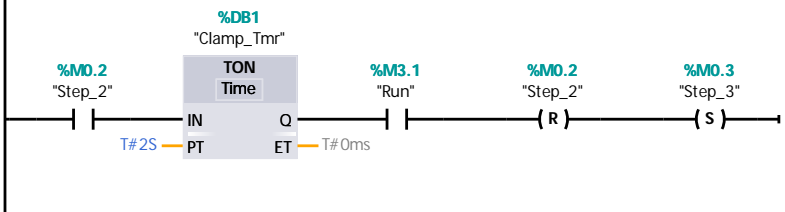
Network 3: Initial Start



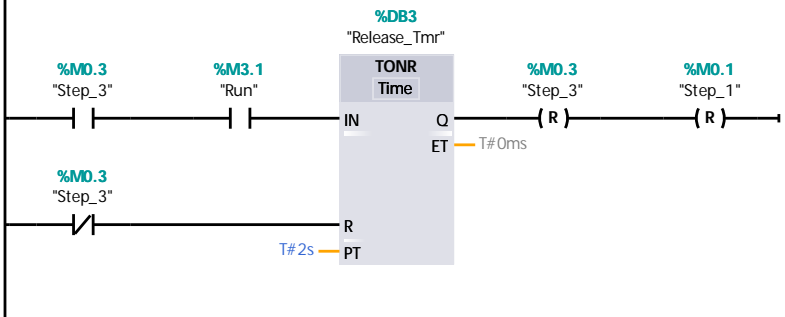
Network 4: Step 1 Wait for tenth part



Network 5: Step 2 Wait 2 sec for width to stabilize.



Network 6: Step 3 Release part and wait 2 sec



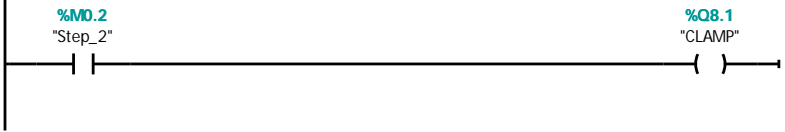
Network 7: Reset



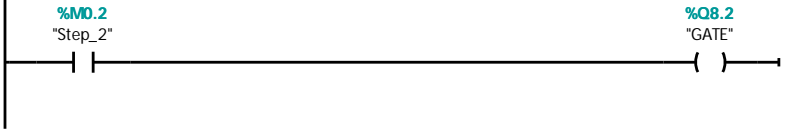
Network 8: Conveyor control



Network 9: Clamp control



Network 10: Gate control



Network 11: Coil to let other part of program know there is a new width.

