

Totally Integrated Automation Portal		
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Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

Title	SP9-9	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: SP9-9

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SP9-9 Pressure Check Station with shift register-based sequence.

%M1.0

"Dummy"

%M1.0

"Dummy"

Network 2: First Start - run and no step-in-progress bit set

%M201.4

"RUN"

%MD50

"Step"

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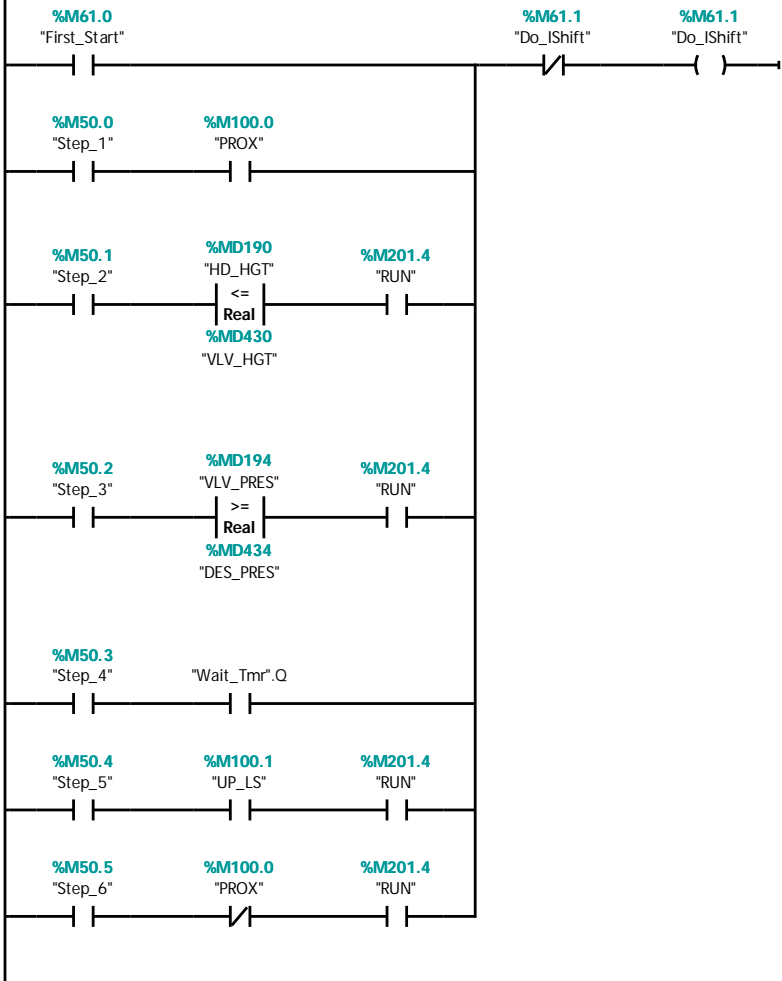
DInt

0

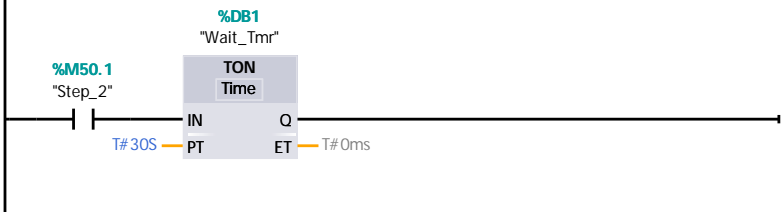
%M61.0

"First_Start"

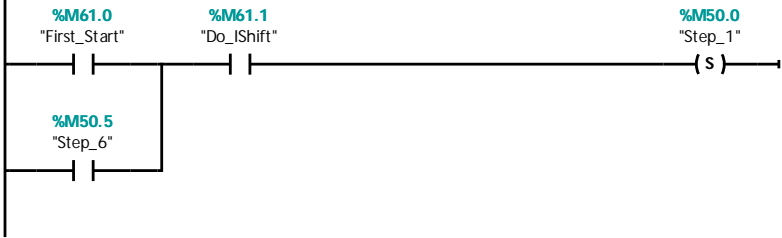
Network 3: All transition conditions. Any one causes shift.



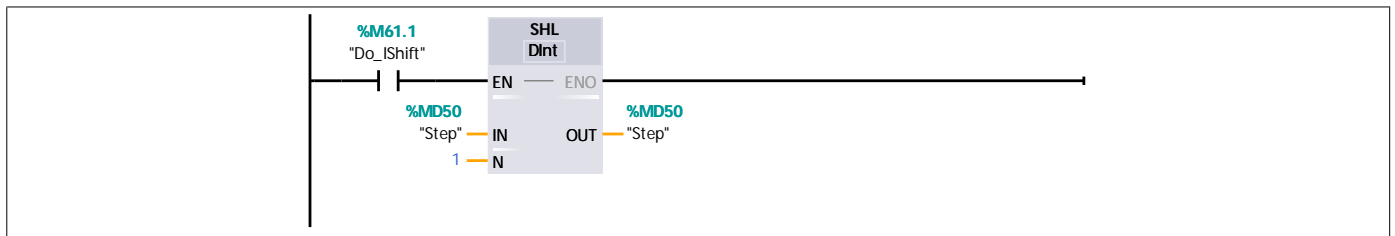
Network 4: Timers for transitions



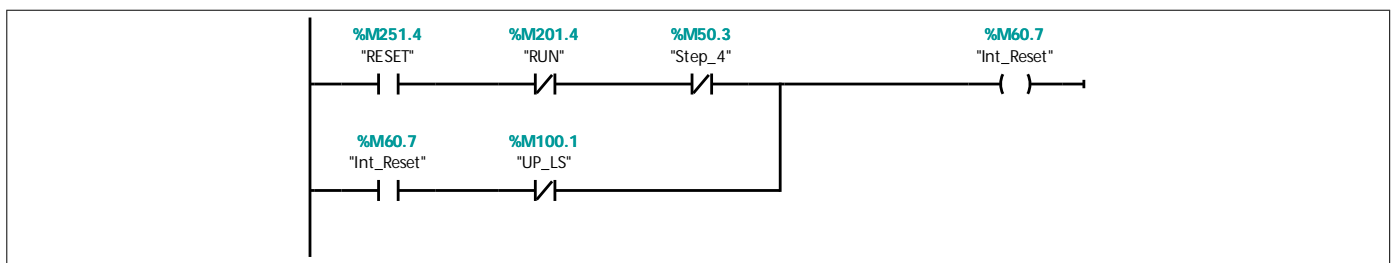
Network 5: Bit shifted into register. First start and last step are only "1" shifted in



Network 6:



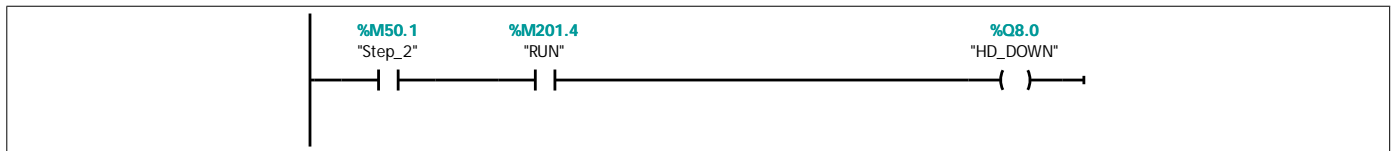
Network 7: Reset. Do not allow in step 4



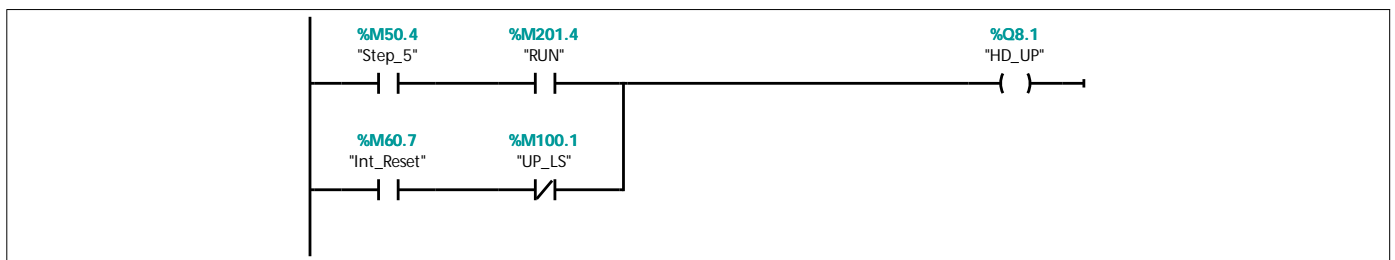
Network 8: Head down control

Physical Outputs

Head raise/lower. Off when paused. Raise when reset.

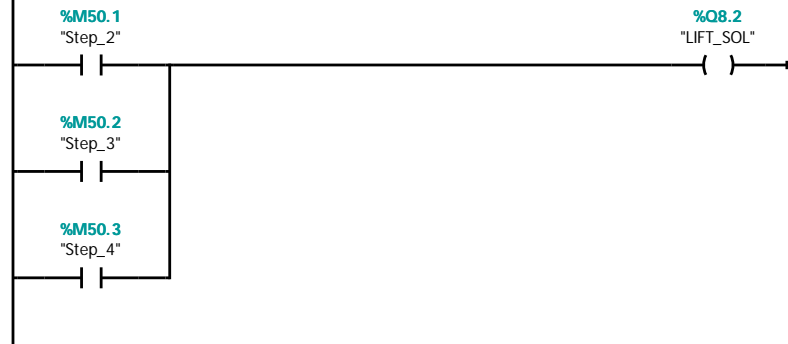


Network 9: Head up control



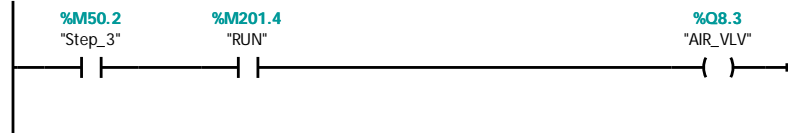
Network 10: On to move carrier (and valve) up and off the conveyor

Lift solenoid. Must remain on when paused.



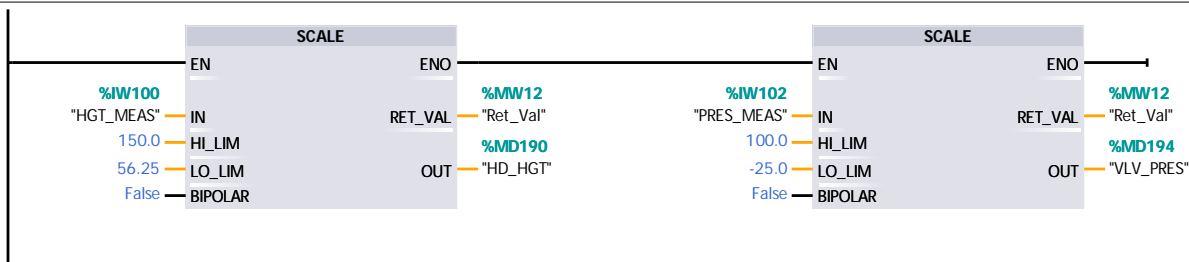
Network 11: Opens air valve pressurize tested valve

Air valve



Network 12: 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 13: Set if valve is to be rejected because it will not hold pressure

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

