

Totally Integrated Automation Portal

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

Title	SP6-7	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: SP6-7

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Problem SP6-7 Conveyor Transfer 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_5 %M0.1 to M0.5 BOOL Step-in-progress bits
Dly_Tmr %DB1 IEC_TIMER 2 sec delay

%M10.0

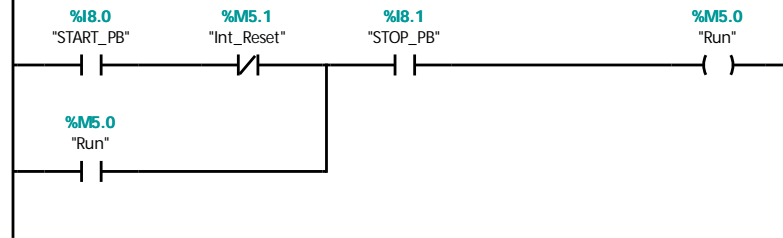
"Dummy"

%M10.0

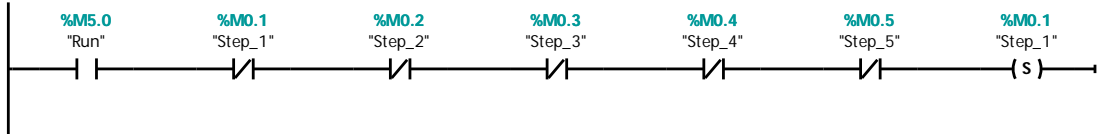
"Dummy"

Network 2: Start/stop

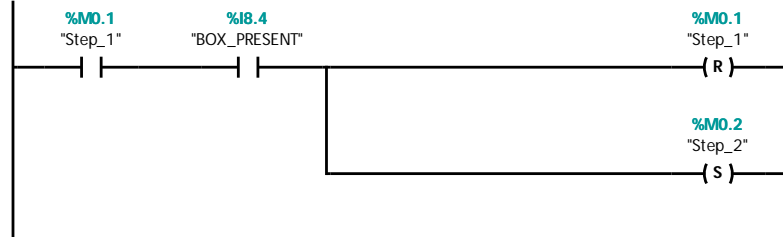
During reset prevent start



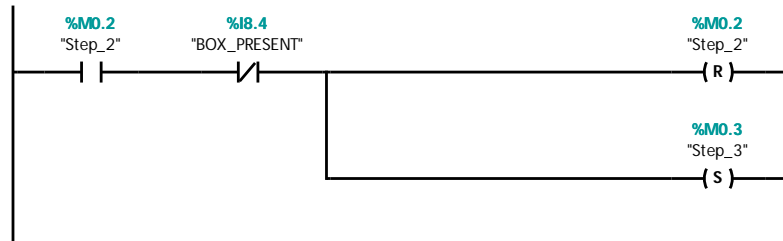
Network 3: Initial start



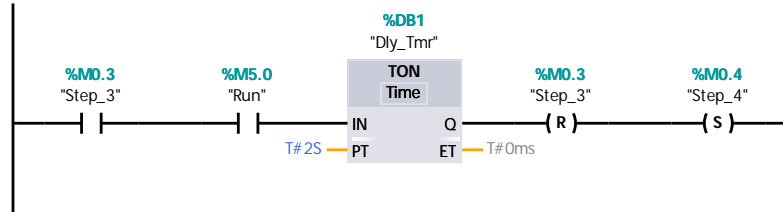
Network 4: Step 1 Wait for box



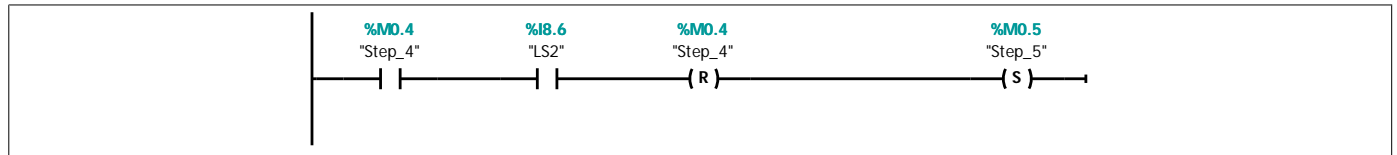
Network 5: Step 2 Move box on



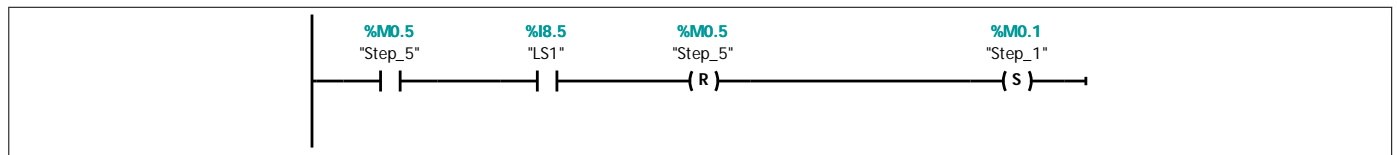
Network 6: Step 3 Delay 2 sec. If paused, reset timer.



Network 7: Step 4 Extend ram

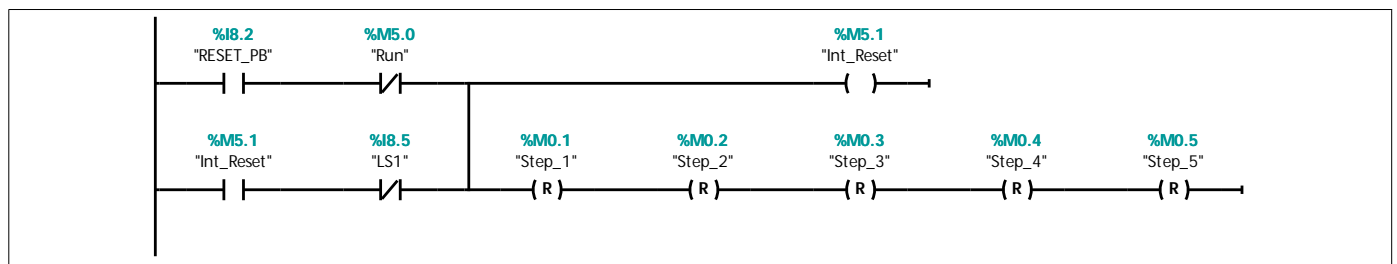


Network 8: Step 5 Retract ram



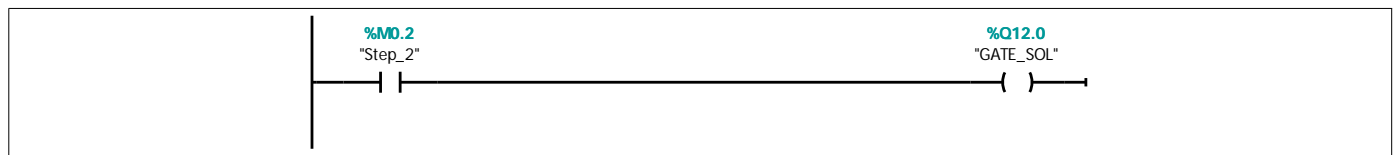
Network 9: Reset

Keep internal reset on while retracting ram.

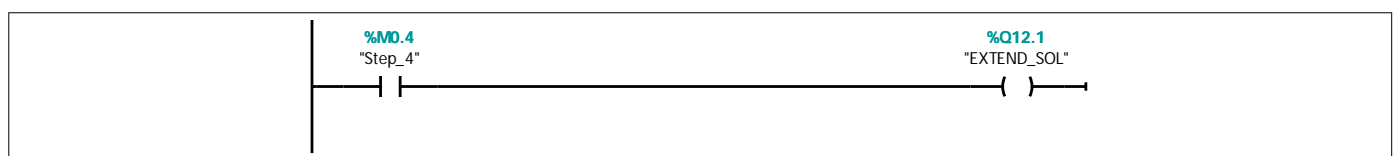


Network 10: Cylinder control to drop gate, on to hold down gate.

Can not turn off when paused.

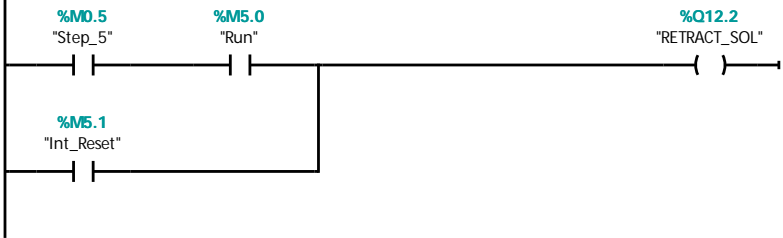


Network 11: Pneumatic ram extension solenoid, on to extend ram.



Network 12: Pneumatic ram retraction solenoid, on to retract ram.

Retract during reset.



Network 13: Inbound conveyor control, on to move inbound conveyor

Can not pause in Step 2.



Network 14: Outbound conveyor control, on to move outbound conveyor

