

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

Title	"Main Program Sweep (Cycle)"	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: SP7-6

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Problem SP7-6 Weigh Scale Station Control

Additional internal memory:

Tag Address

Run %M3.1 BOOL On while station running

Step_1 to Step_4 %M0.1 to M0.4 BOOL Step-in-progress bits

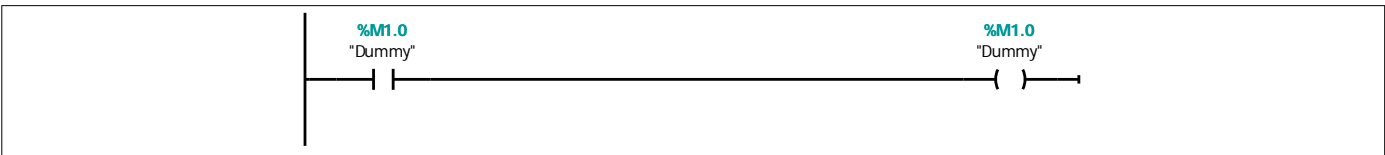
Stab_Tmr %DB1 TON_SFB Delay for weight to stabilize

MoveOut_Tmr %DB3 TON_SFB Delay for detecting pallet gone

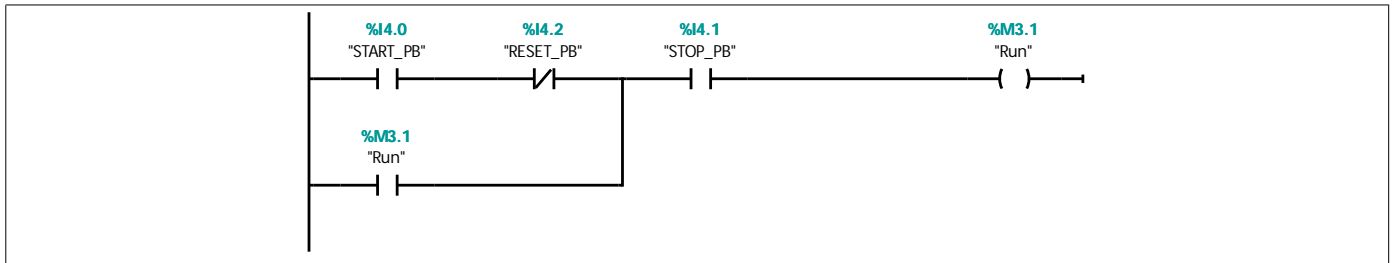
Ret_Val %MW12 WORD Return value from SCALE block

Conversion formula:

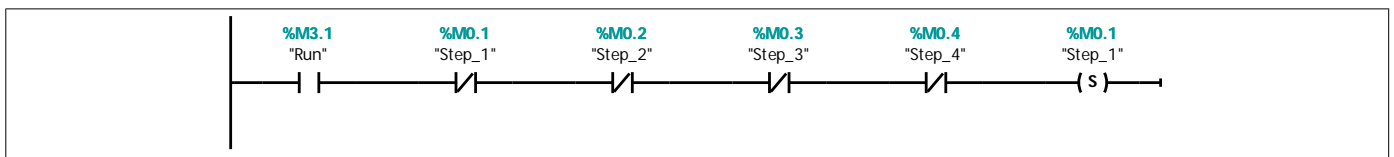
$WT132_VAL = (WT132_MEAS - 5530) / 22118.0 * (900.0)$



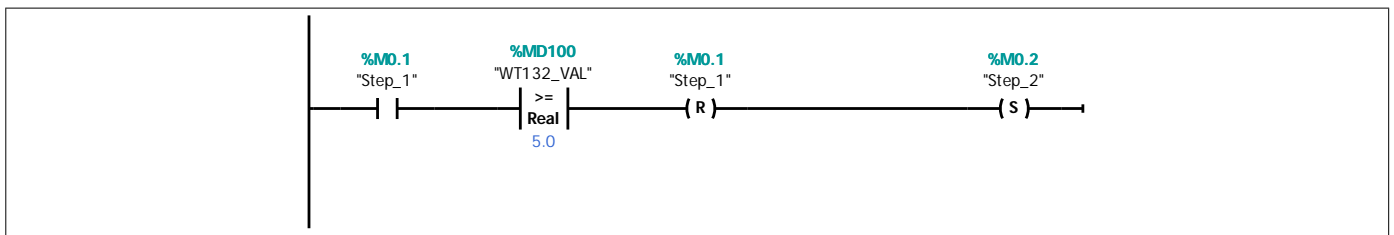
Network 2: Start/stop



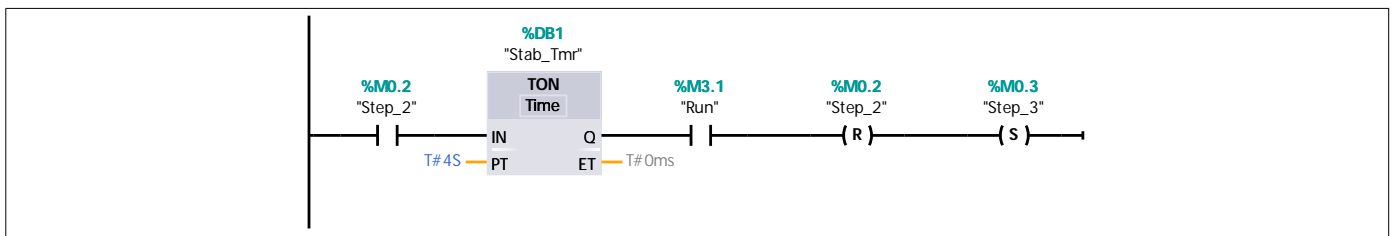
Network 3: Initial Start



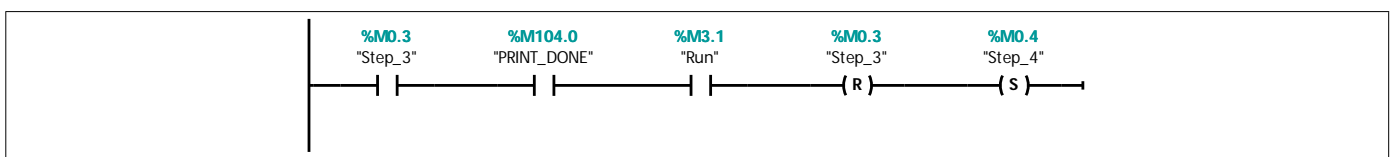
Network 4: Step 1 Move in



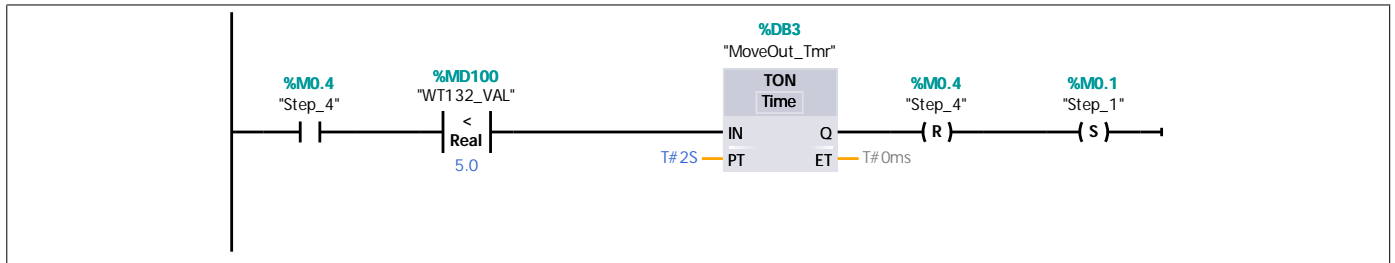
Network 5: Step 2 Delay for weight to settle



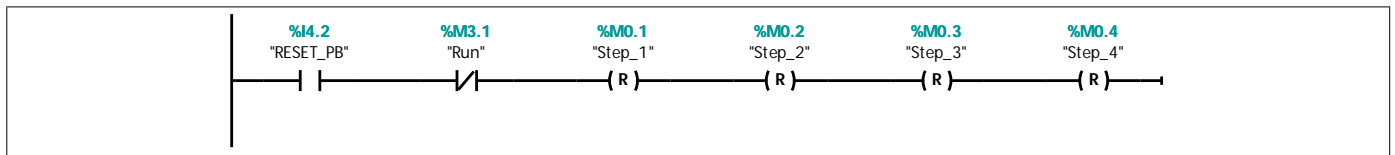
Network 6: Step 3 Print a weight



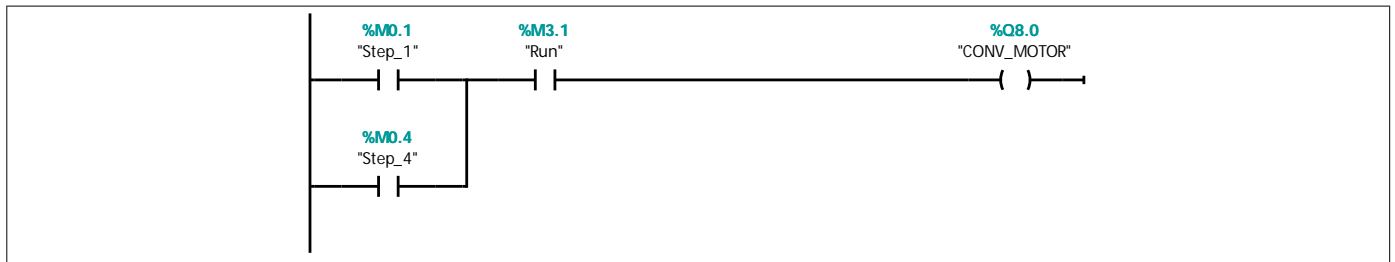
Network 7: Step 4 Move Out



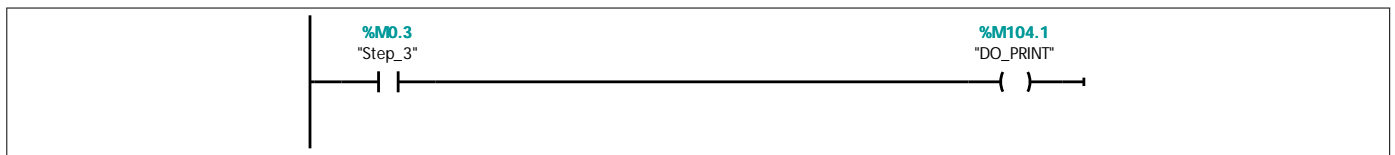
Network 8: Reset



Network 9: Conveyor control



Network 10: Print Start command



Network 11: Convert weight measurement using SCALE

Convert weight measurement to pounds.
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).

