

**OB1 - <offline>**  
"  
**Name:** **Family:**  
**Author:** **Version:** 0.1  
**Block version:** 2  
**Time stamp Code:** 12/27/2015 06:44:43 AM  
**Interface:** 02/15/1996 04:51:12 PM  
**Lengths (block/logic/data):** 00446 00302 00026

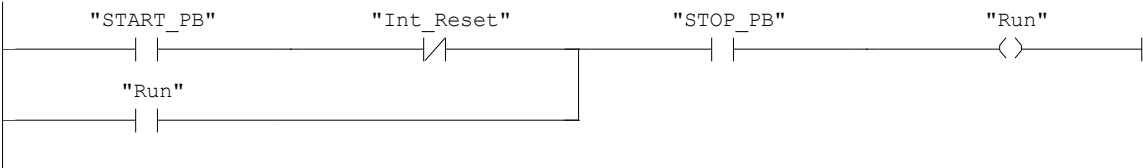
Name	Data Type	Address	Comment
TEMP		0.0	
OB1_EV_CLASS	Byte	0.0	Bits 0-3 = 1 (Coming event), Bits 4-7 = 1 (Event class 1)
OB1_SCAN_1	Byte	1.0	1 (Cold restart scan 1 of OB 1), 3 (Scan 2-n of OB 1)
OB1_PRIORITY	Byte	2.0	Priority of OB Execution
OB1_OB_NUMBR	Byte	3.0	1 (Organization block 1, OB1)
OB1_RESERVED_1	Byte	4.0	Reserved for system
OB1_RESERVED_2	Byte	5.0	Reserved for system
OB1_PREV_CYCLE	Int	6.0	Cycle time of previous OB1 scan (milliseconds)
OB1_MIN_CYCLE	Int	8.0	Minimum cycle time of OB1 (milliseconds)
OB1_MAX_CYCLE	Int	10.0	Maximum cycle time of OB1 (milliseconds)
OB1_DATE_TIME	Date_And_Time	12.0	Date and time OB1 started

**Block: OB1**    **"Main Program Sweep (Cycle)"**

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Problem SP6-6 Transfer Station Control  
  
Additional internal memory:  
Symbol                      Address                      BOOL    On while station running  
Run                          M5.0                          BOOL    Internal reset  
Int\_Reset                    M5.1                          BOOL    Step-in-progress bits  
Step\_1 to Step\_5            M0.1 to M0.5                SFB4    Times mechanism raise  
Raise\_Tmr                    DB1                          SFB0    Counts parts  
Parts\_Ctr                    DB2

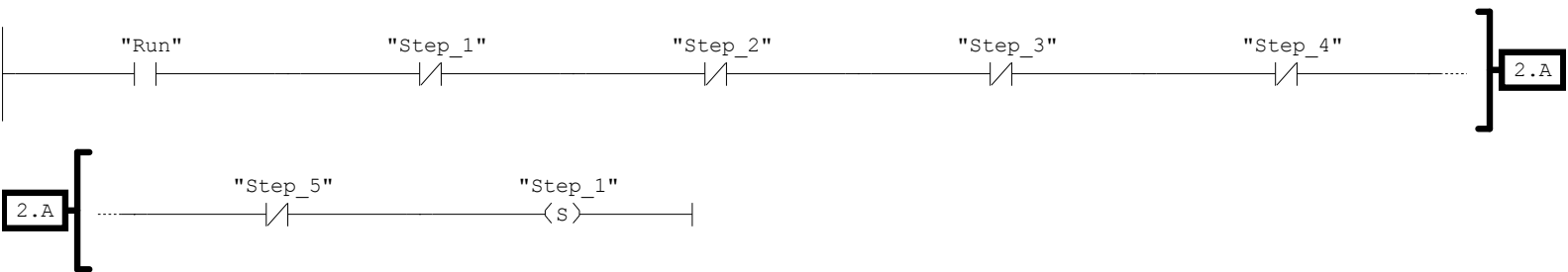
Network: 1            Start/stop

During reset prevent start



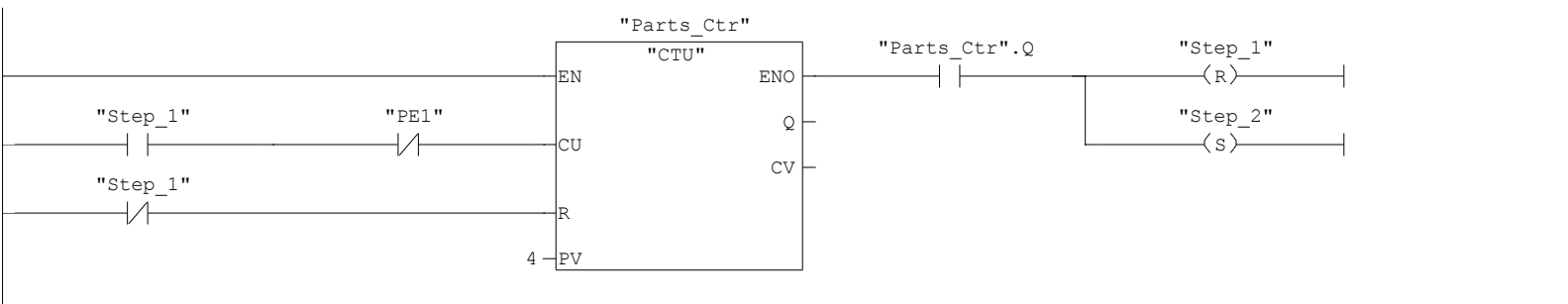
Network: 2

Initial start



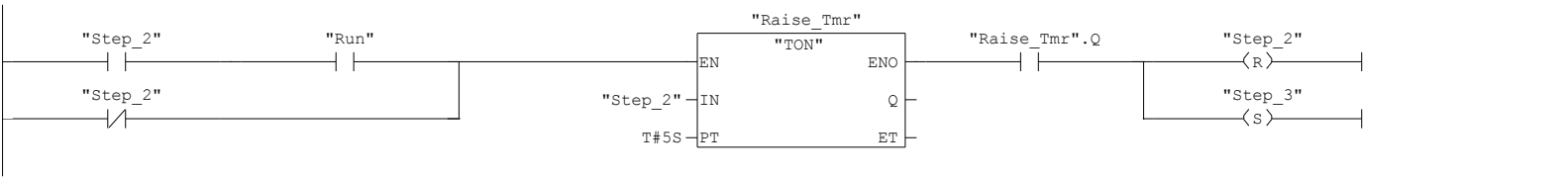
Network: 3

Step 1 Wait for 4 parts



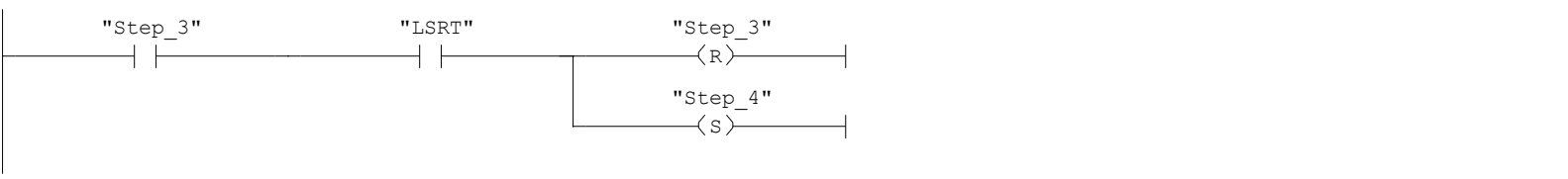
Network: 4

Step 2 Move up



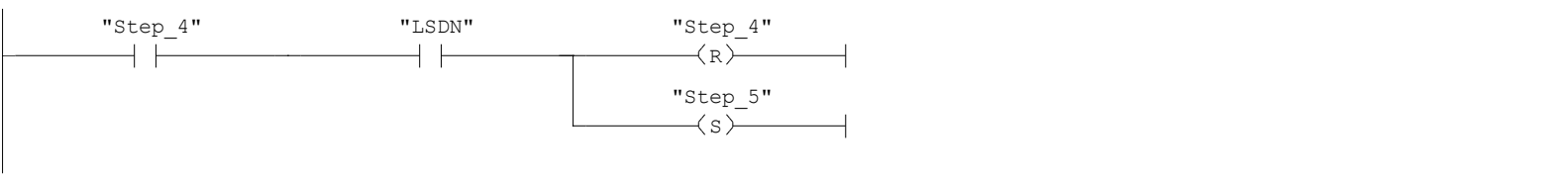
Network: 5

Step 3 Move right



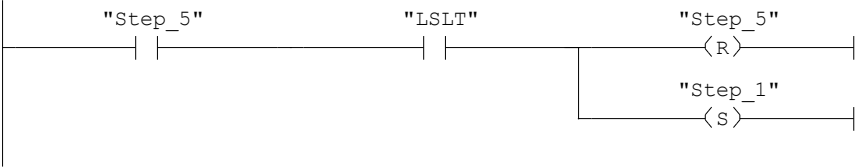
Network: 6

Step 4 Move down



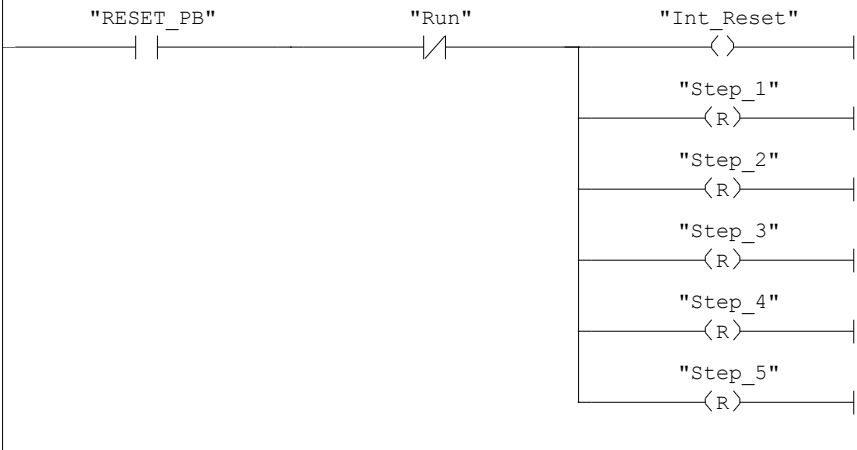
Network: 7

Step 5 Move left



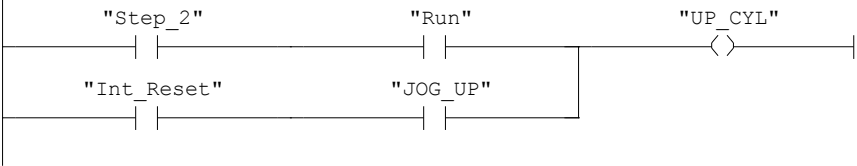
Network: 8

Reset



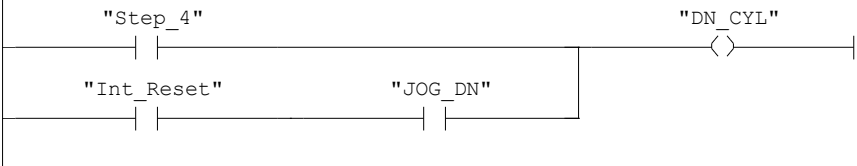
Network: 9

Raising control, on to raise mechanism



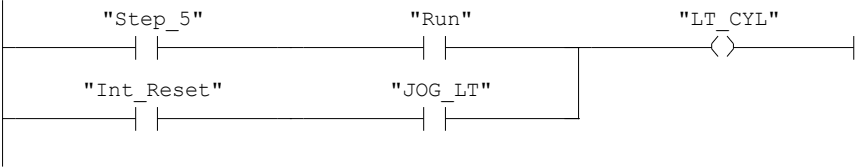
Network: 10

Lowering control, on to lower mechanism



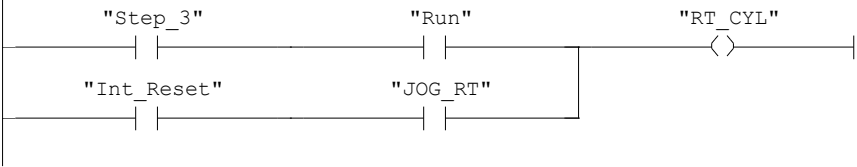
Network: 11

Left motion control, on to move mechanism left



Network: 12

Right motion control, on to move mechanism right



Network: 13

Inbound conveyor control, on to move conveyor

