

OB1 - <offline>

"Main_Program"

Name:	Family:
Author:	Version: 0.1
	Block version: 2
Time stamp Code:	12/31/2015 10:33:08 AM
Interface:	02/15/1996 04:51:12 PM
Lengths (block/logic/data):	00396 00244 00030

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) "

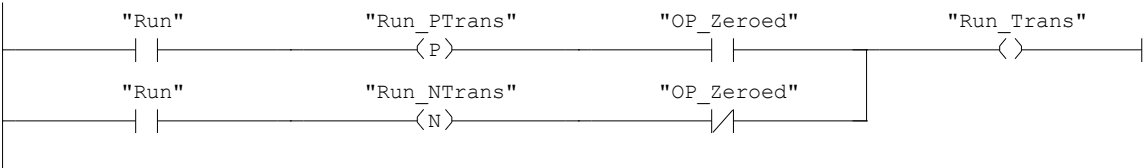
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SP14-2 Case Erector Control Using S7-GRAPH With Simulation

Additional internal memory:
Symbol Address BOOL Run has changed
SRun_Trans M61.0 BOOL Bit for Run neg transition
Run_PTrans M61.1 BOOL Bit for Run pos transition
Run_NTrans M61.2 BOOL Operation paused
OP_Zeroed M61.3

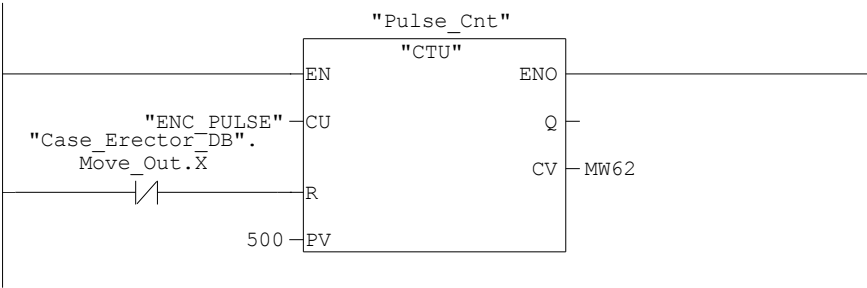
Network: 1

Generate pulse to toggle pause for SFC. Positive transition on Run used only when already paused. Negative transition on Run used when not paused.



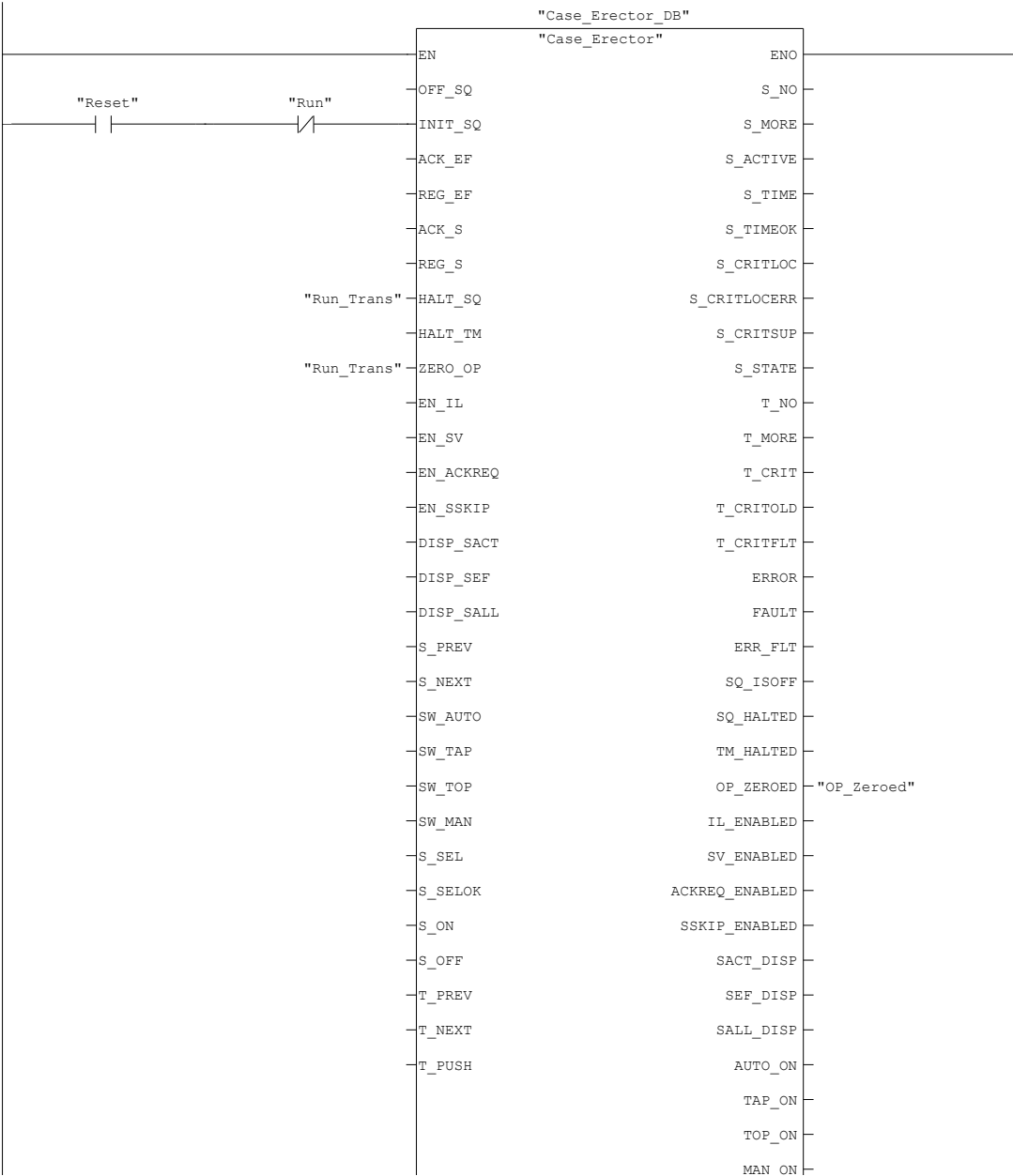
Network: 2

Counts encoder pulses

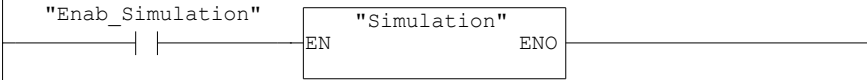


Network: 3

Case Erector in S7-GRAPH



Network: 4
Simulation



Network: 5
Copy real inputs to input image if not simulating

