

OB1 - <offline>

"Cycle Execution"

Name:

Author:

Time stamp Code:

Lengths (block/logic/data):

Family:

Version: 0.1

Block version: 2

12/27/2015 06:27:28 AM

02/15/1996 04:51:12 PM

00306 00180 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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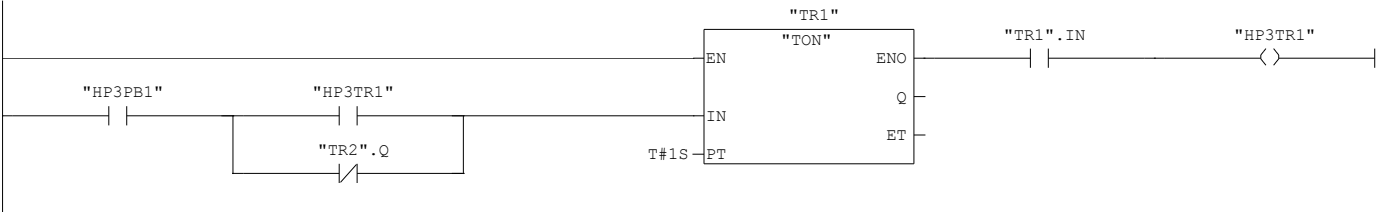
SP 5-3 Press Control

For safety reasons, an opeator is required to actuate 2 pushbuttons in order to close a stamping press. The intention is to ensure that both of the operator's hands are out of the press when it closes. The logic incorporates timing delays that prevent the operator from taping 1 pushbutton down and making the press faster but unsafe to operate.

Additional internal memory:

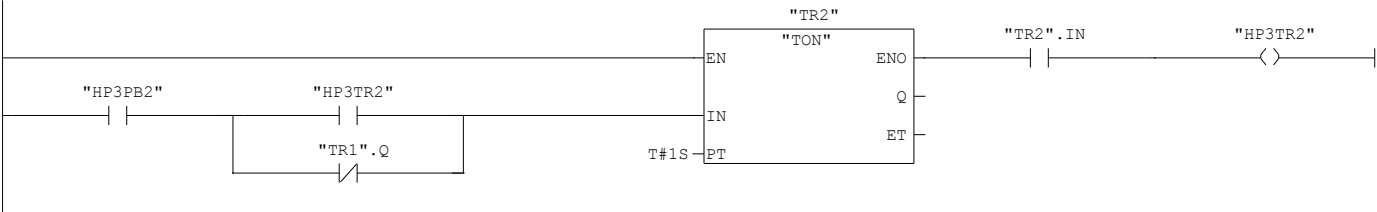
Symbol	Address	
HP3TR1	M0.0	No delay for timing PB1
HP3TR2	M0.1	No delay for timing PB2
TR1	DB1 (SFB4)	Timer for PB1 delay
TR2	DB2 (SFB4)	Timer for PB2 delay

Network: 1 No delay for timing PB1 delay



Network: 2

No delay for timing PB2 delay



Network: 3

Press solenoid, on to run press

