

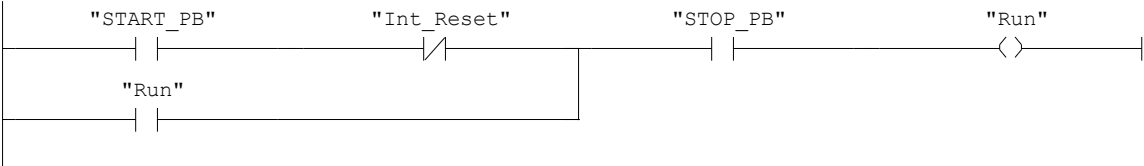
**OB1 - <offline>**  
"  
**Name:**  
**Author:**  
**Family:**  
**Version:** 0.1  
**Block version:** 2  
**Time stamp Code:** 12/27/2015 06:41:49 AM  
**Interface:** 02/15/1996 04:51:12 PM  
**Lengths (block/logic/data):** 00326 00182 00026

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

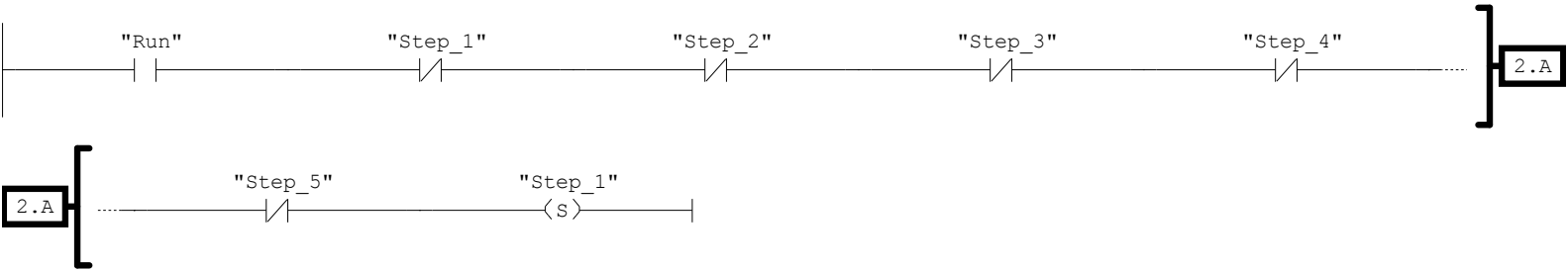
**Block: OB1**    **"Main Program Sweep (Cycle)"**

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Problem SP6-4 Bag Sealing 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                BOOL    Times bag seal  
Seal\_Tmr                    DB1                          SFB4

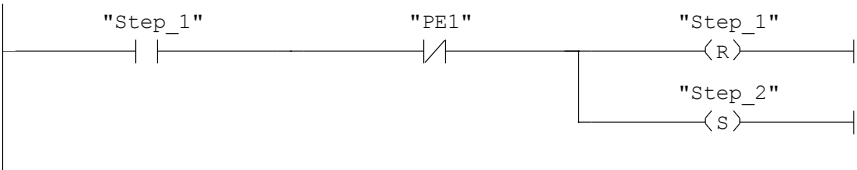
Network: 1	Start/stop
During reset prevent start	



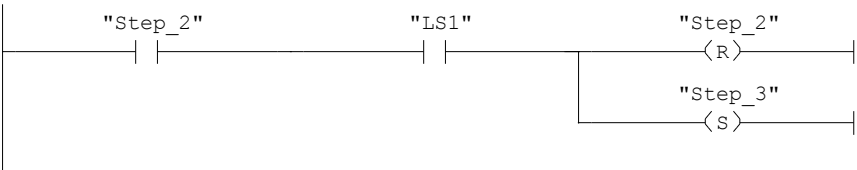
Network: 2 Initial start



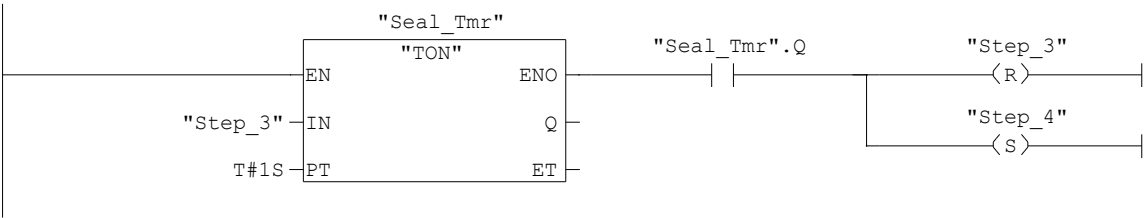
Network: 3 Step 1 Move bag in



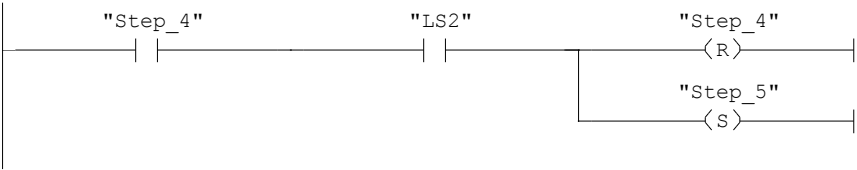
Network: 4 Step 2 Move bars in



Network: 5 Step 3 Seal bag

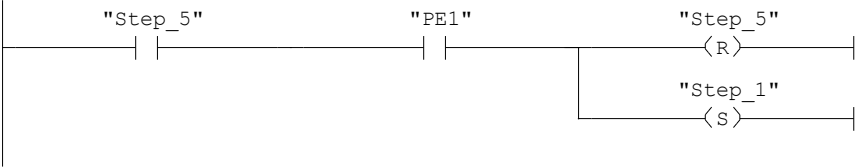


Network: 6 Step 4 Move bars out



Network: 7

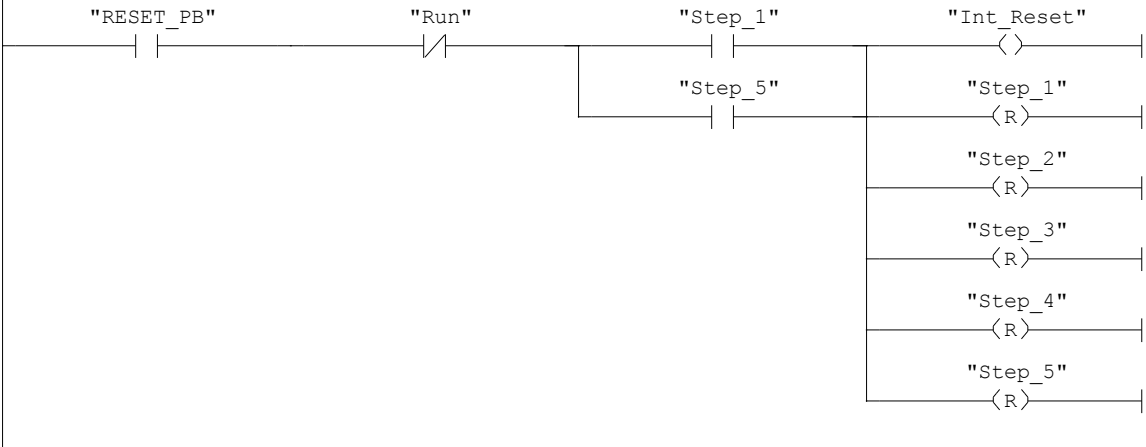
Step 5 Move bag out



Network: 8

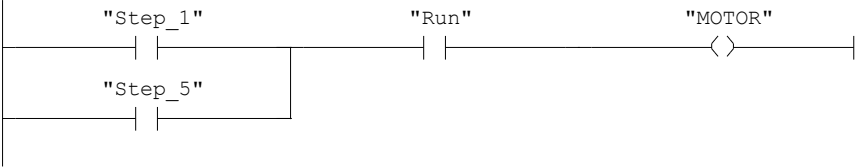
Reset

Only allowed in step 1 and 5



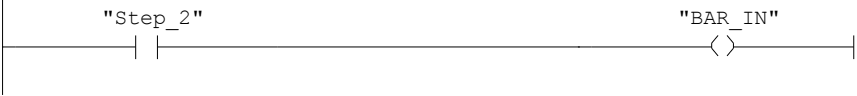
Network: 9

Conveyor motor control, on to move conveyor



Network: 10

Heated bar mechanism in control, on to move bars together



Network: 11

Heated bar mechanism out control, on to move bars apart

