

OB1 - <offline>
""
Name: **Family:**
Author: **Version:** 0.1
Block version: 2
Time stamp Code: 12/27/2015 06:59:29 AM
Interface: 02/15/1996 04:51:12 PM
Lengths (block/logic/data): 00488 00332 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)"**

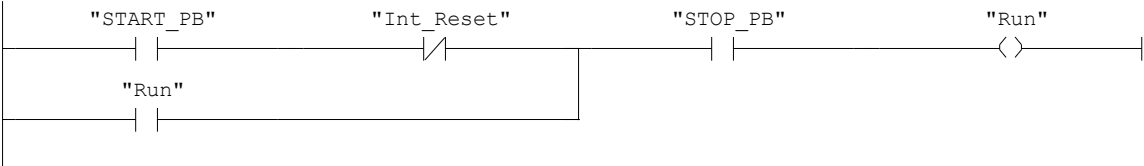
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Problem SP6-15 Drilling Station Control

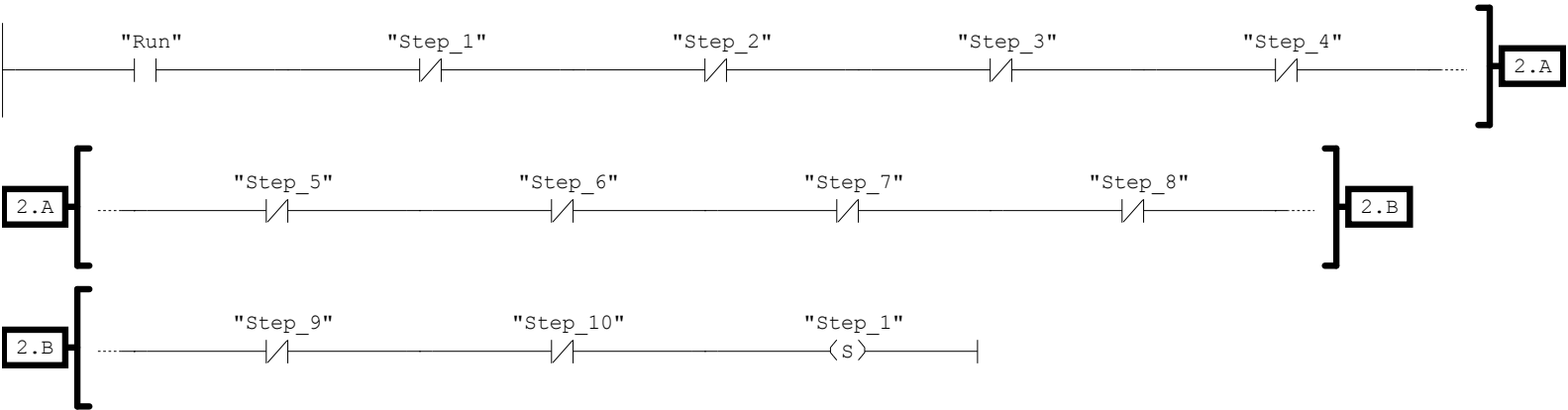
Additional internal memory:
Symbol Address BOOL On while station running
Run M5.0 BOOL Internal reset
Int_Reset M5.1 BOOL Step-in-progress bits
Step_1 to Step_10 M0.1 to M1.2 SFB4 Time unclamping of part
Unclmp_Tmr DB1

Network: 1 Start/stop

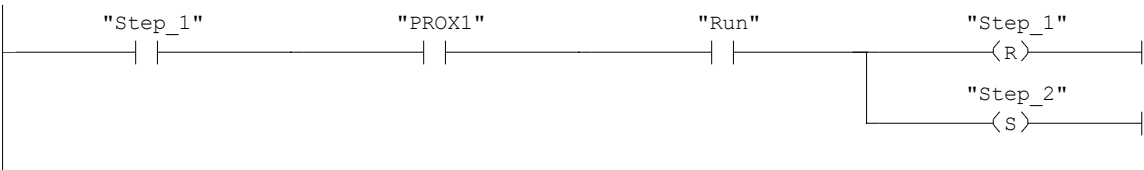
During reset prevent start



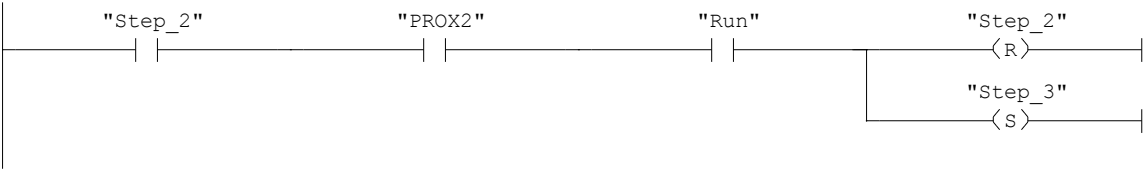
Network: 2 Initial start



Network: 3 Step 1 Wait for part



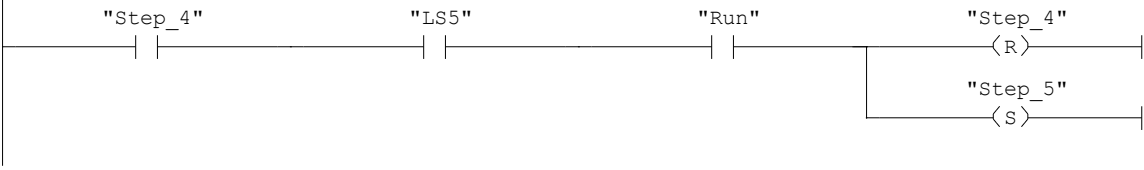
Network: 4 Step 2 Open gate 1



Network: 5 Step 3 Open gate 2

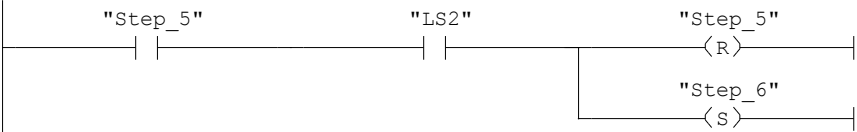


Network: 6 Step 4 Clamp part



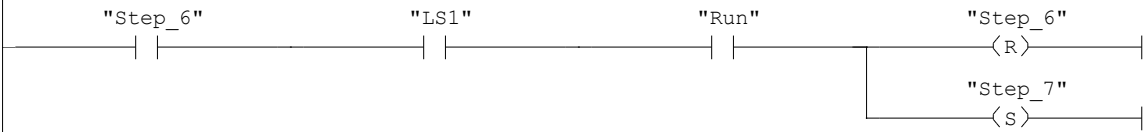
Network: 7

Step 5 Extend drill 1



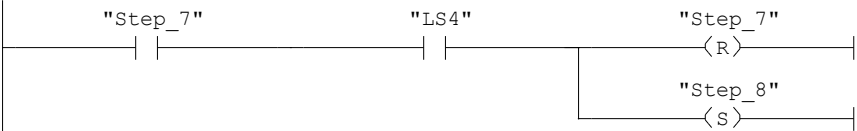
Network: 8

Step 6 Retract drill 1



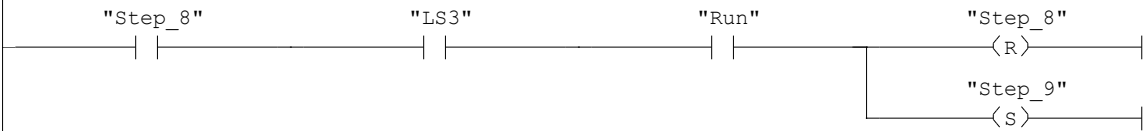
Network: 9

Step 7 Extend drill 2



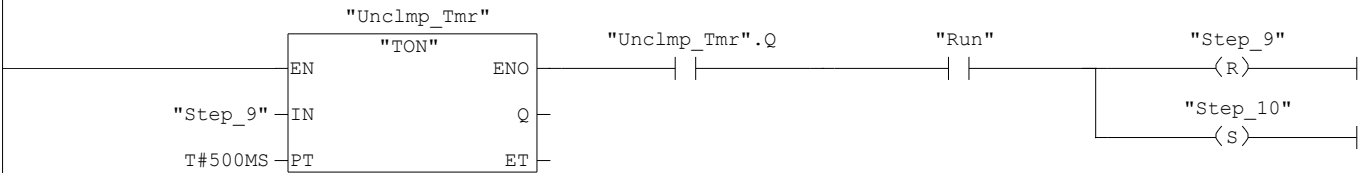
Network: 10

Step 8 Retract drill 2



Network: 11

Step 9 Unclamp part



Network: 12

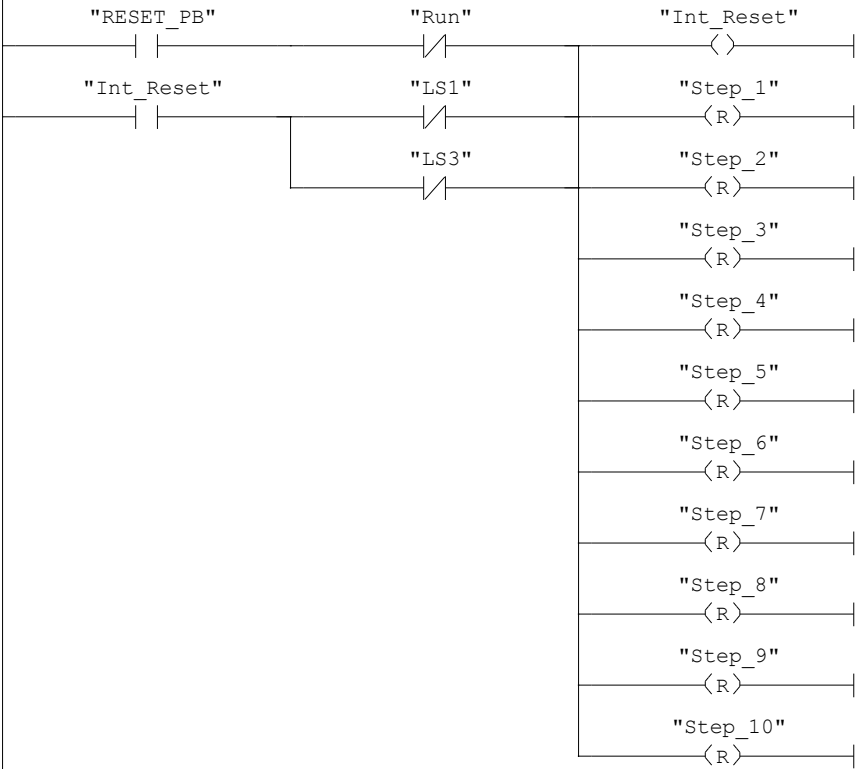
Step 10 Move out part



Network: 13

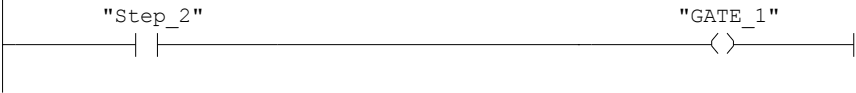
Reset

Maintain reset until both drills retracted.



Network: 14

Gate controls



Network: 15

Gate 2 control

Retract on reset



Network: 16Knife controls

Retract on reset

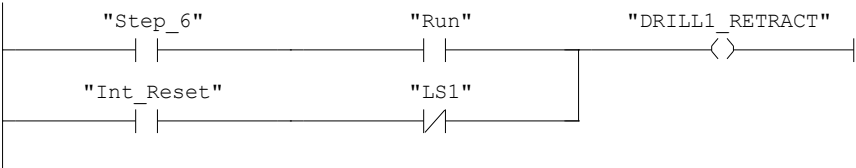


Network: 17Drill 1 controls



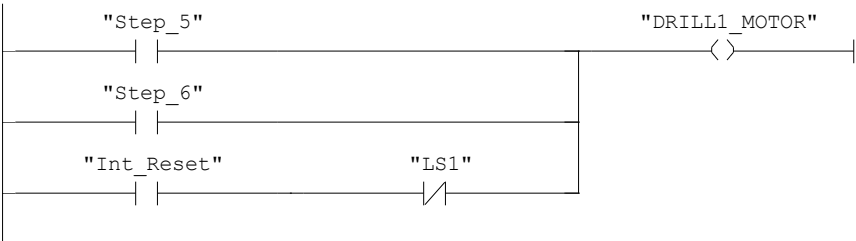
Network: 18Drill 1 retraction control

Must also retract on reset



Network: 19Drill 1 motor control

Must continue to run drill motor while retracting due to reset

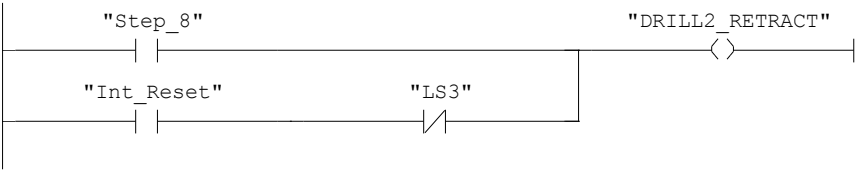


Network: 20Drill 2 controls



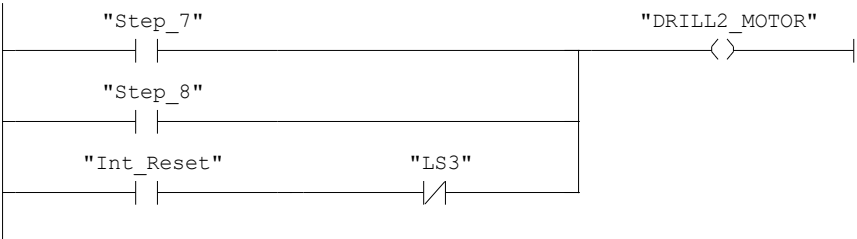
Network: 21 Drill 2 retraction control

Must also retract on reset



Network: 22 Drill 2 motor control

Must continue to run drill motor while retracting due to reset



Network: 23 Clamp control

Must remain on when paused and when resetting, before both drills retracted.

