

OB1 - <offline>
"
Name: **Family:**
Author: **Version:** 0.1
Block version: 2
Time stamp Code: 12/27/2015 07:05:13 AM
Interface: 02/15/1996 04:51:12 PM
Lengths (block/logic/data): 01020 00822 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)"**

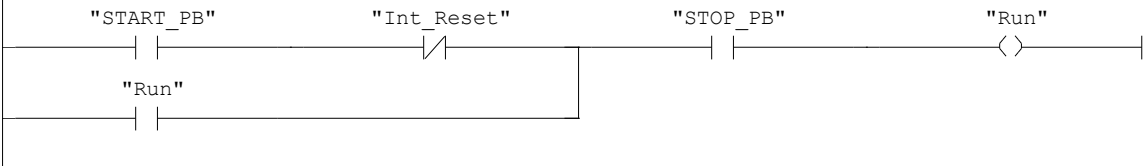
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Problem SP6-19 Revised Bolt Driving Control

Additional internal memory:
Symbol Address
Run M5.0 BOOL On while station running
Int_Reset M5.1 BOOL Internal reset
Step_1 to Step_13 M0.1 to M1.5 BOOL Step-in-progress bits
In_Tmr DB1 SFB4 Times engage cyl for bringing in
pallet
Raise_Tmr DB3 SFB4 Times raise of pallet
Push_Tmr DB4 SFB4 Times push of bolts
Motor_Tmr DB5 SFB4 Times air motor rotation
Lower_Tmr DB9 SFB4 Times lower of pallet
Out_Tmr DB10 SFB4 Times engage cyl for allowing out
pallet

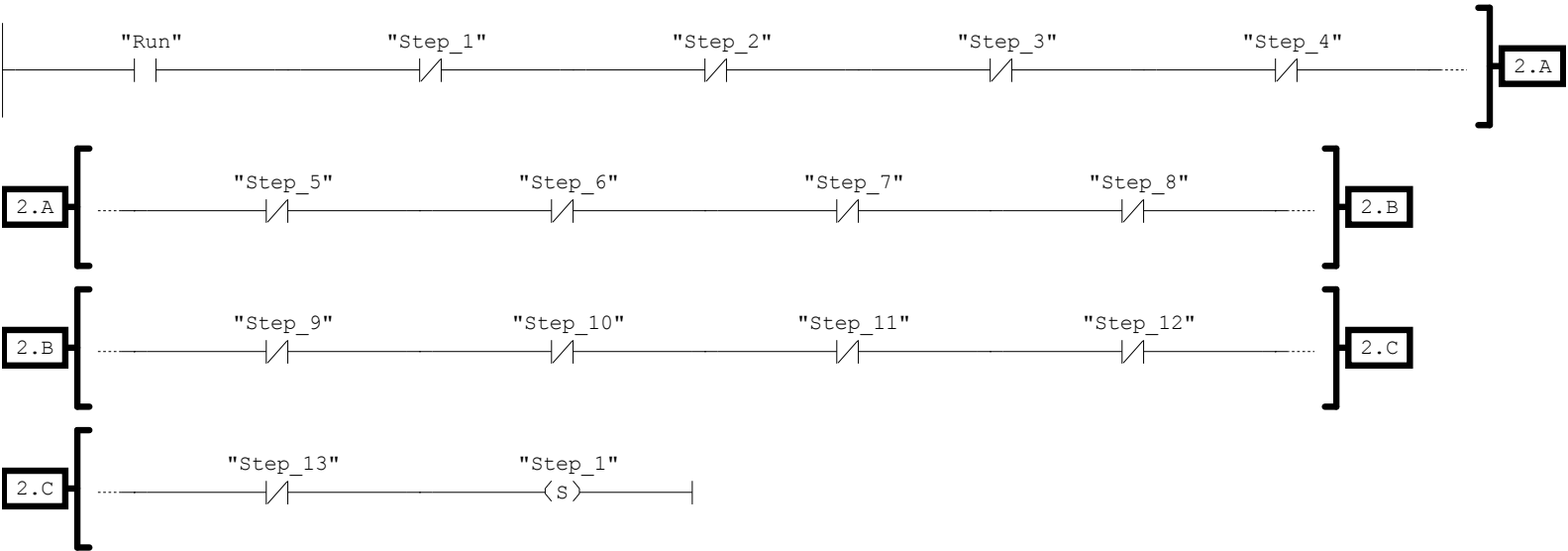
Network: 1 Start/stop

During reset prevent start



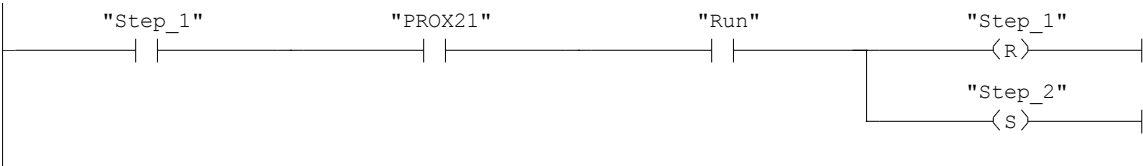
Network: 2

Initial start



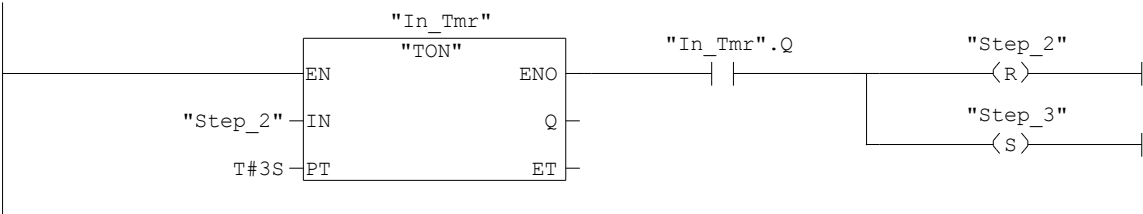
Network: 3

Step 1 Wait for pallet



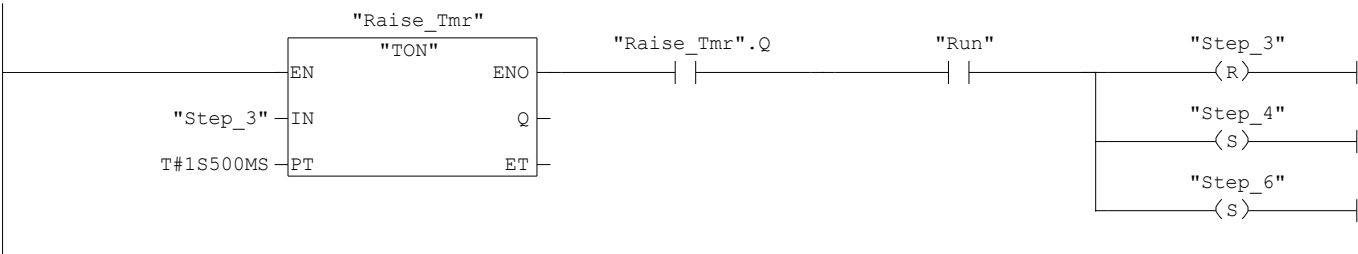
Network: 4

Step 2 Allow one pallet in



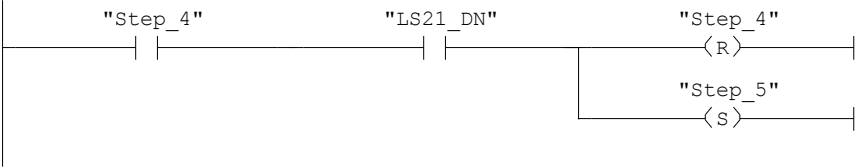
Network: 5

Step 3 Raise pallet



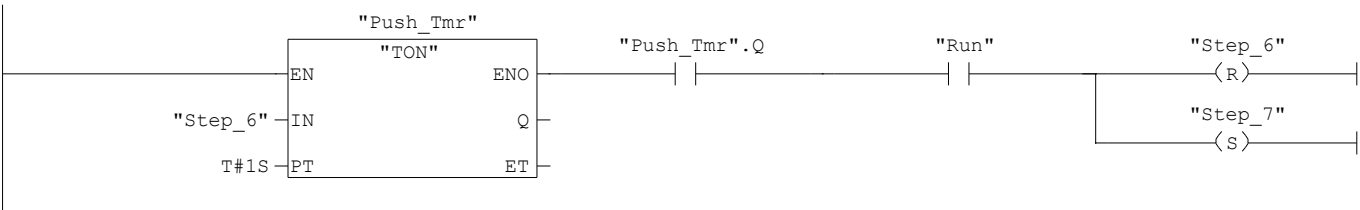
Network: 6

Step 4 Lower mechanism



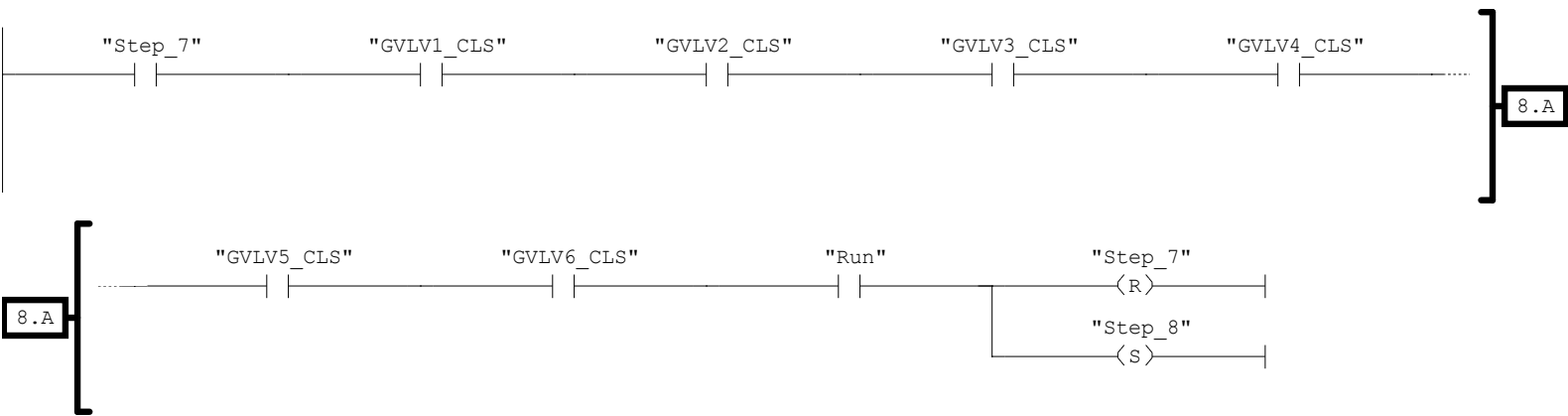
Network: 7

Step 6 Push bolts



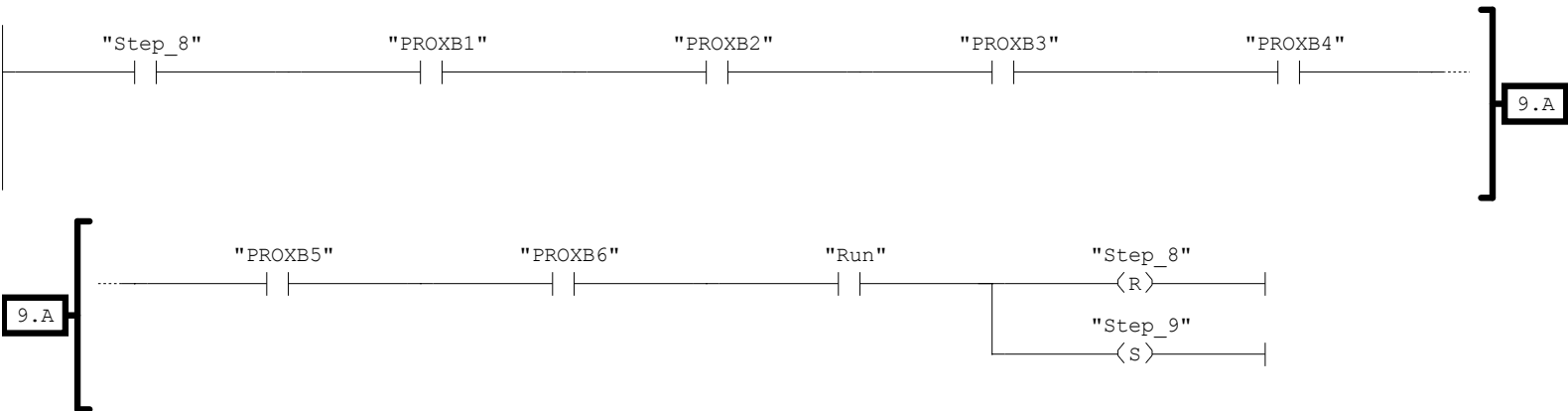
Network: 8

Step 7 Close gate valves

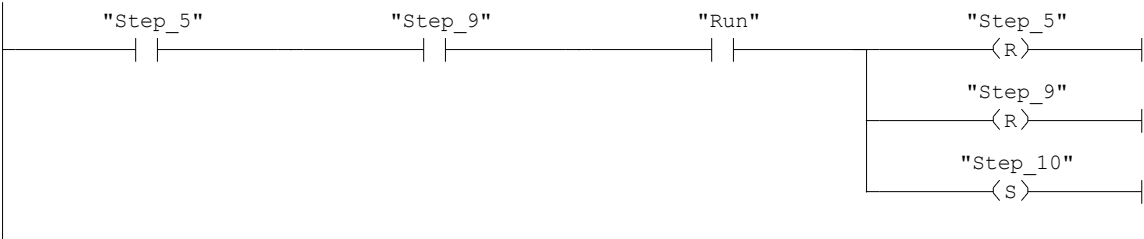


Network: 9

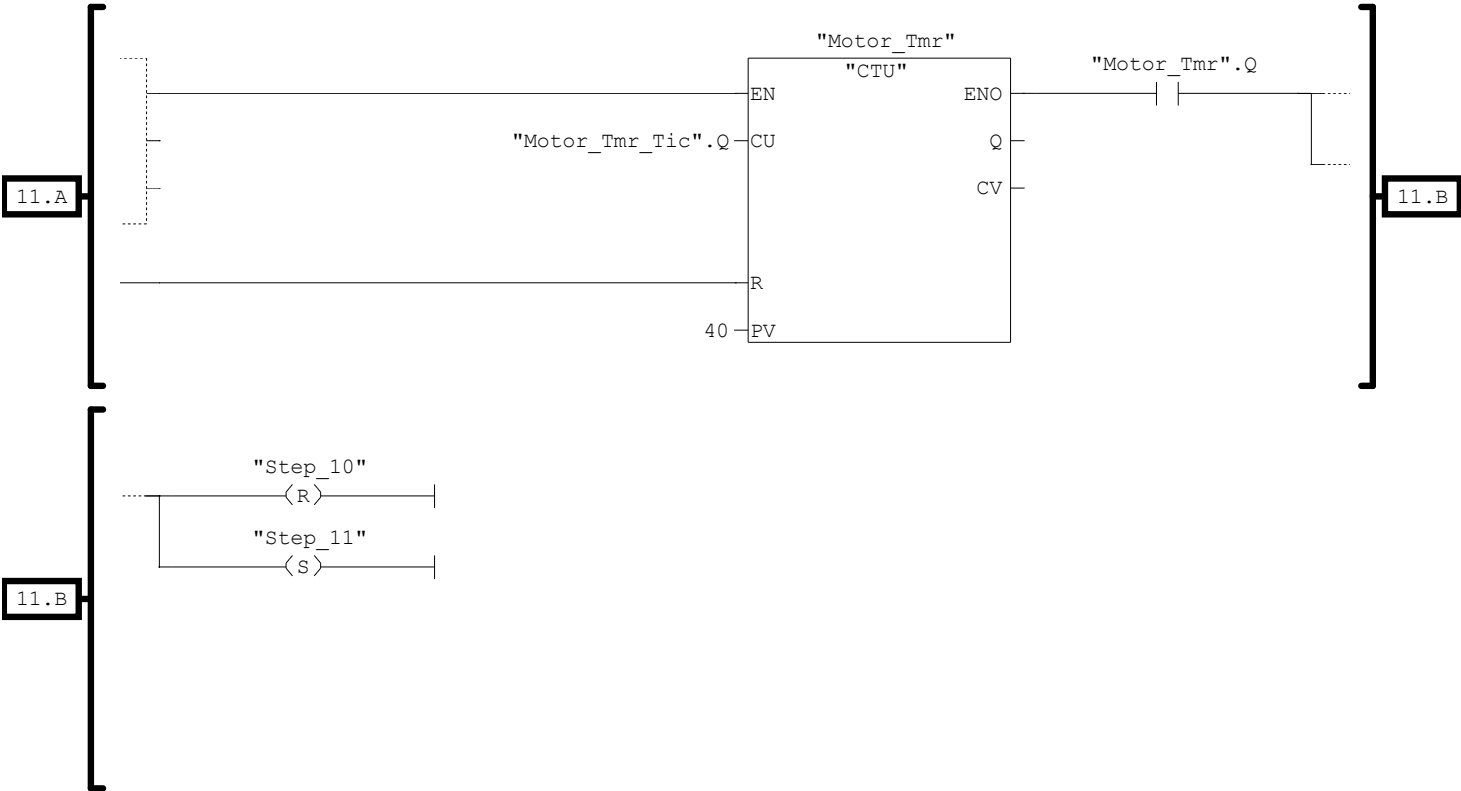
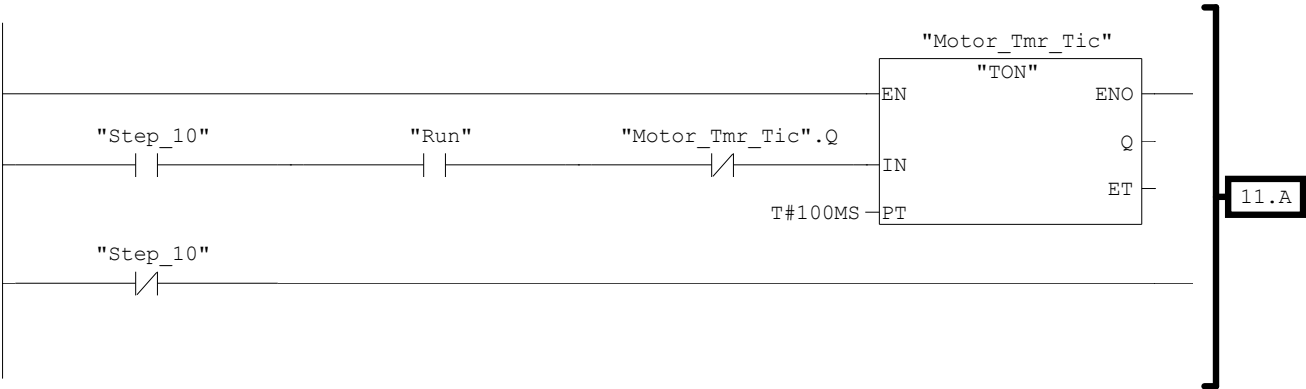
Step 8 Convey bolts



Network: 10 Step 5 and Step 9 Wait for mechanism down and bolts in place.

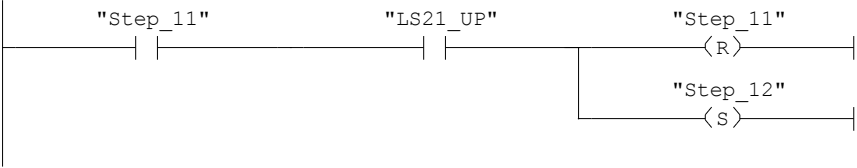


Network: 11 Step 10 Run air motors



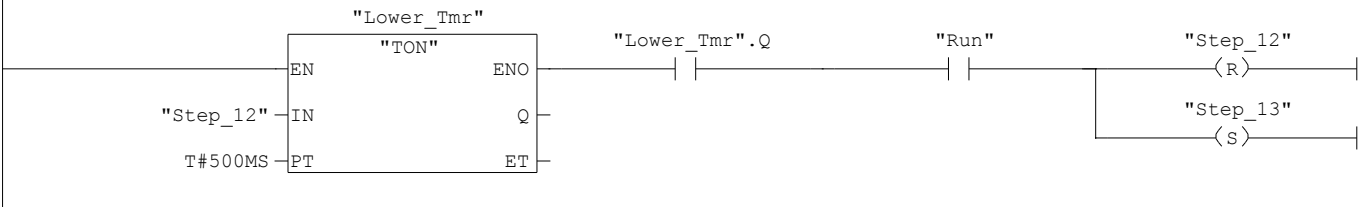
Network: 12

Step 11 Raise mechanism



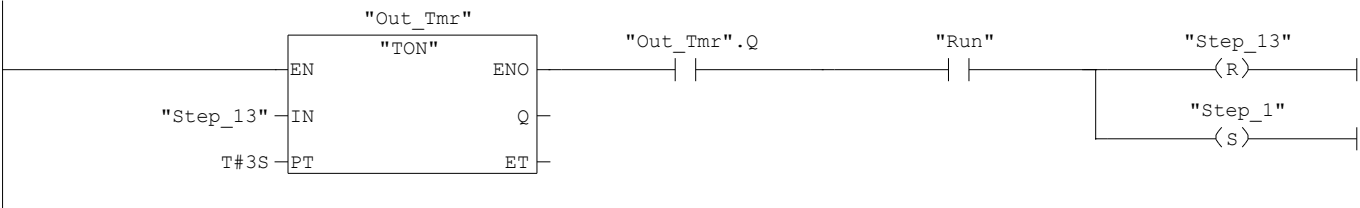
Network: 13

Step 12 Drop pallet



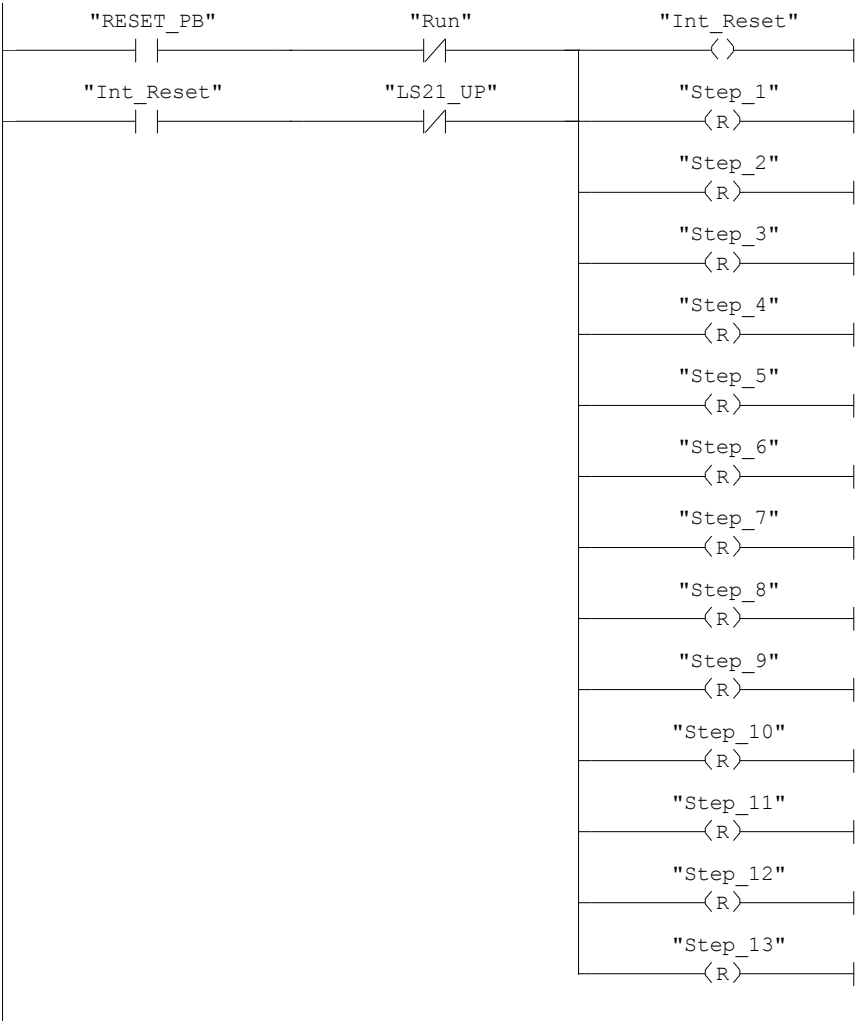
Network: 14

Step 13 Move out pallet



Network: 15Reset

Maintain reset until mechanism fully raised.



Network: 16Engage solenoids



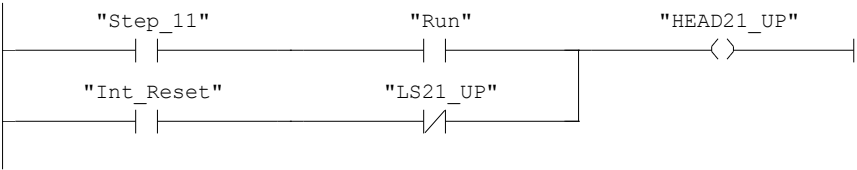
Network: 17Gate 2 control



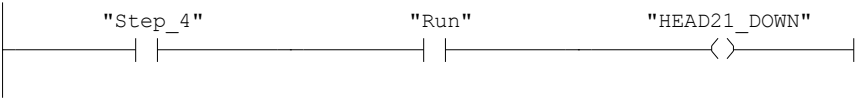
Network: 18

Raise/lower mechanism

Move up on reset

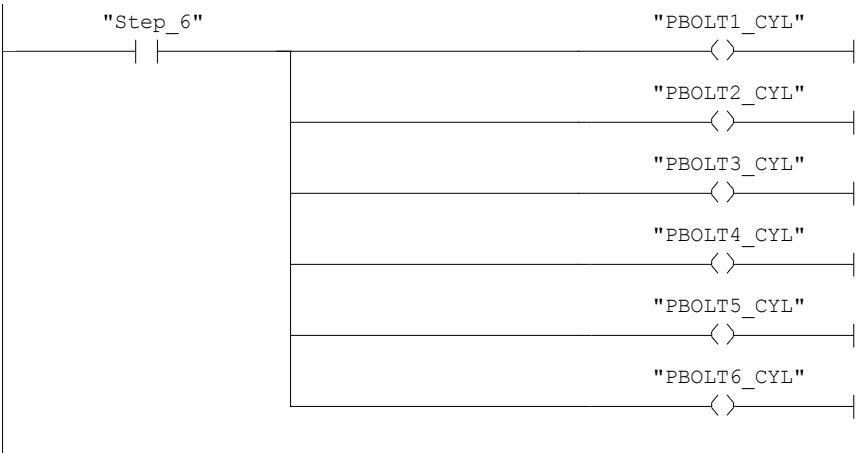


Network: 19



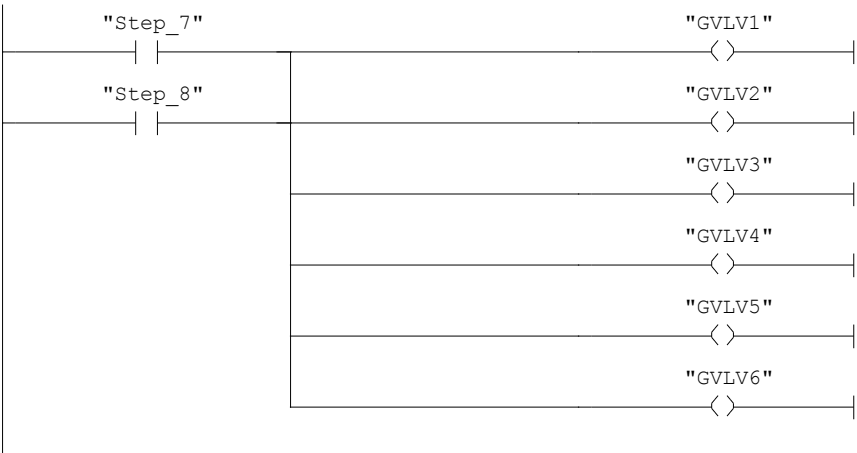
Network: 20

Push bolt solenoids



Network: 21

Gate valves



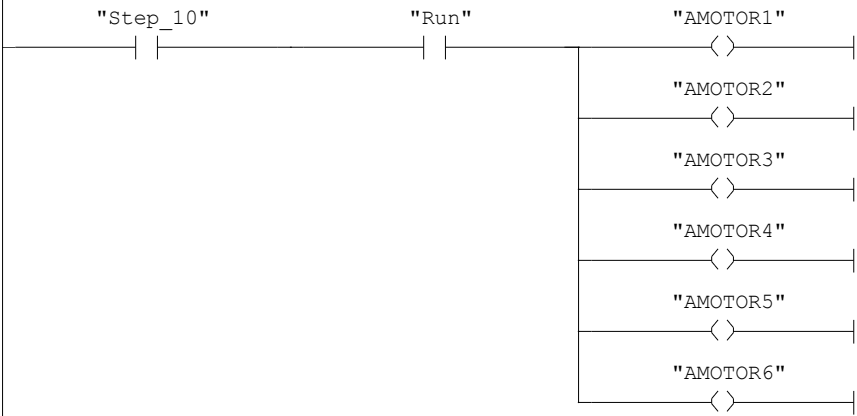
Network: 22

Convey valves



Network: 23

Air motors



Network: 24

Pallet up control

Must remain on when paused

