

OB1 - <offline>
"
Name: **Family:**
Author: **Version:** 0.1
Block version: 2
Time stamp Code: 12/27/2015 06:49:19 AM
Interface: 02/15/1996 04:51:12 PM
Lengths (block/logic/data): 00418 00274 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)"**

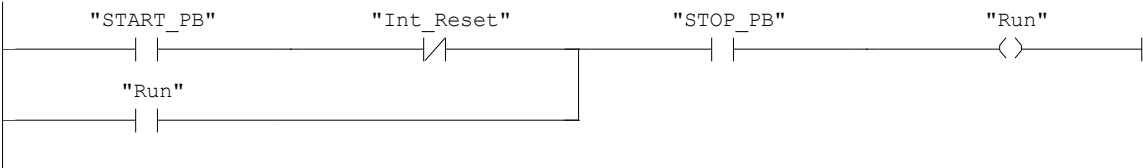
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Problem SP6-9 Part Oiler Station Control

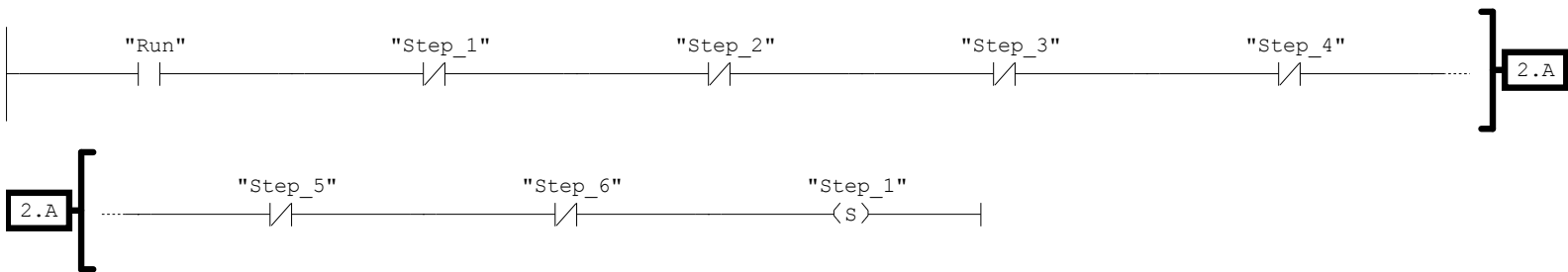
Additional internal memory:
Symbol Address BOOL On while station running
Run M5.0 BOOL Internal reset
Int_Reset M5.1 BOOL Step-in-progress bits
Step_1 to Step_6 M0.1 to M0.6 SFB4 Times engage of part
Engage_Tmr DB1 SFB4 Times oil squirt
Squirt_Tmr DB3

Network: 1 Start/stop

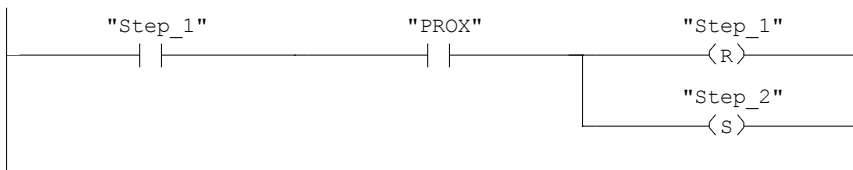
During reset prevent start



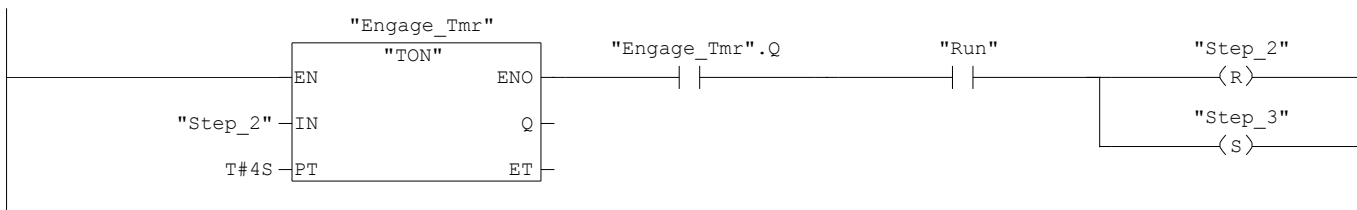
Network: 2	Initial start
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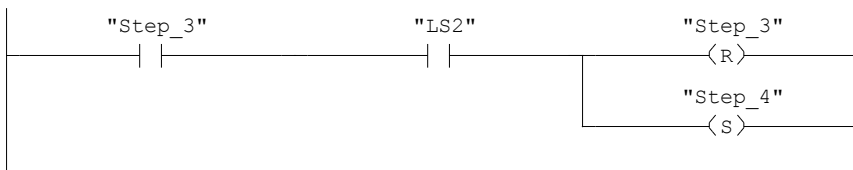
Network: 3	Step 1 Wait for part
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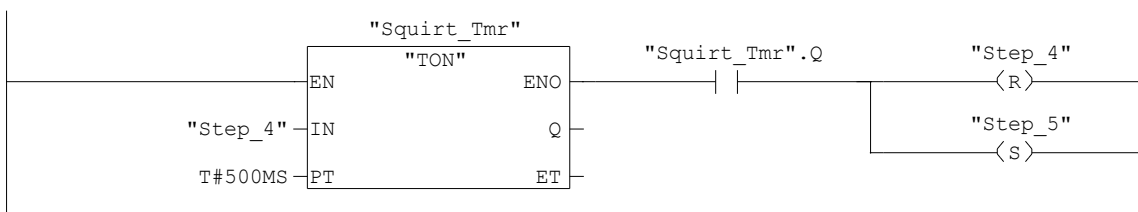
Network: 4	Step 2 Wait for engage
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Network: 5	Step 3 Lower oiler
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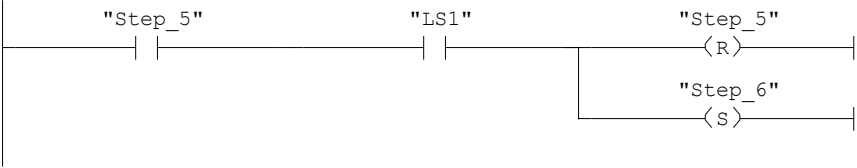


Network: 6	Step 4 Squirt oil
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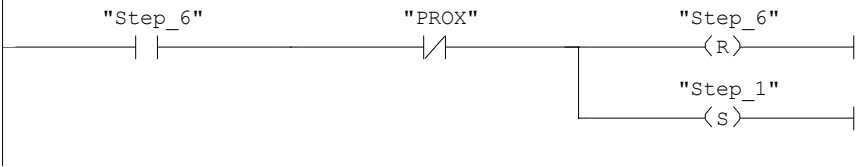
Network: 7

Step 5 Raise oiler



Network: 8

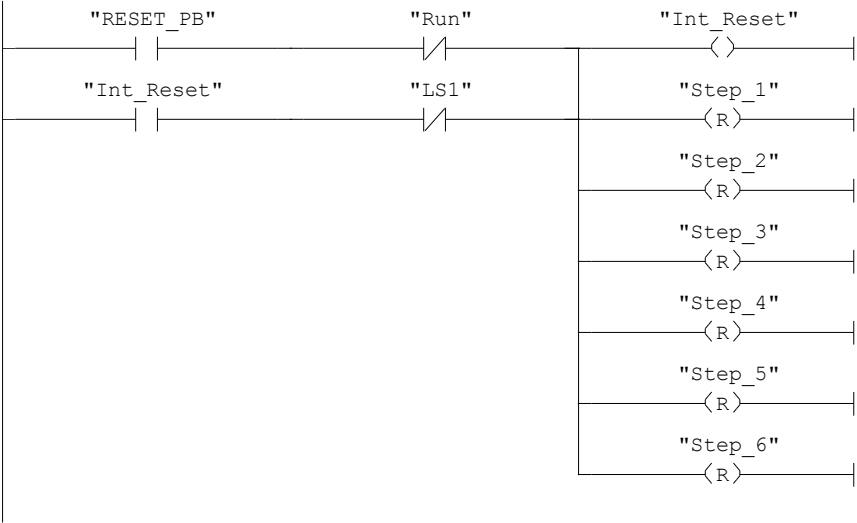
Step 6 Part leaves



Network: 9

Reset

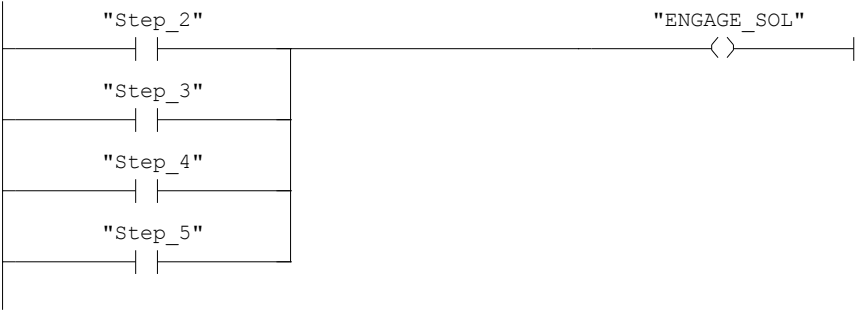
Keep internal reset on while raising oiler tip.



Network: 10

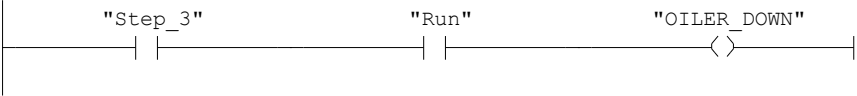
Gate 1 cylinder control, on to open gate 1

Can not turn off when paused.



Network: 11

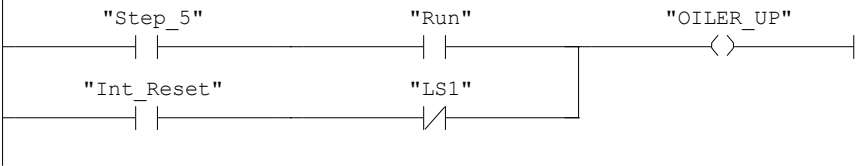
On to lower oiler tip



Network: 12

On to raise oiler tip

Raise oiler tip during reset



Network: 13

On to open valve and squirt oil

Can not turn off when paused.

