

OB1 - <offline>

""

Name:

Author:

Time stamp Code:

Lengths (block/logic/data):

Family:

Version: 0.1

Block version: 2

12/27/2015 06:52:26 AM

02/15/1996 04:51:12 PM

00498 00354 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

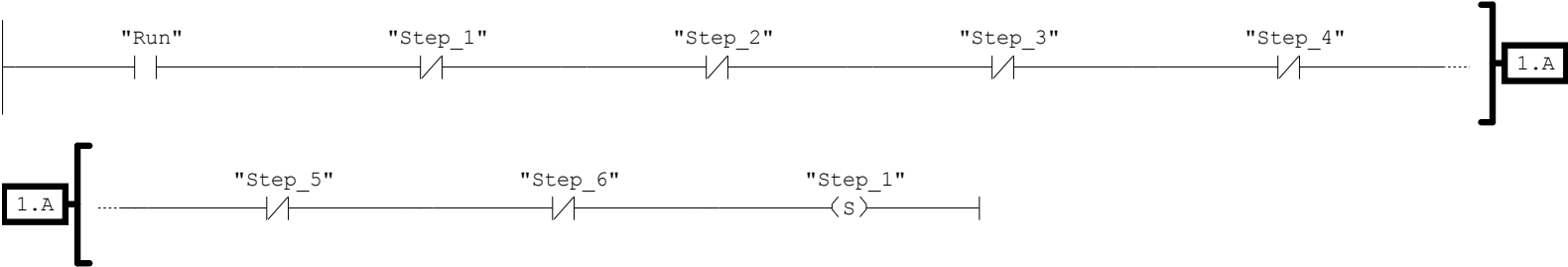
Block: OB1 "Main Program Sweep (Cycle)"

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Problem SP6-11 Case Erector Control

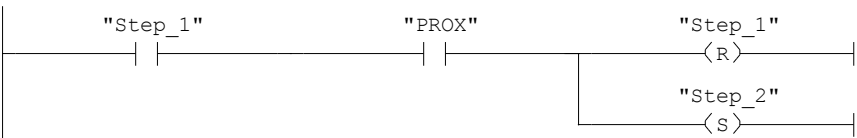
Additional internal memory:
Symbol Address
Run M5.0 BOOL On while station running
Step_1 to Step_6 M0.1 to M0.6 BOOL Step-in-progress bits
Up_Tmr DB1 SFB4 Times carton unfolding
Pulse_Cnt DB2 SFB0 Counts encoder pulses
BDown_Tmr DB4 SFB4 Times retract of rams

Network: 1 Initial start



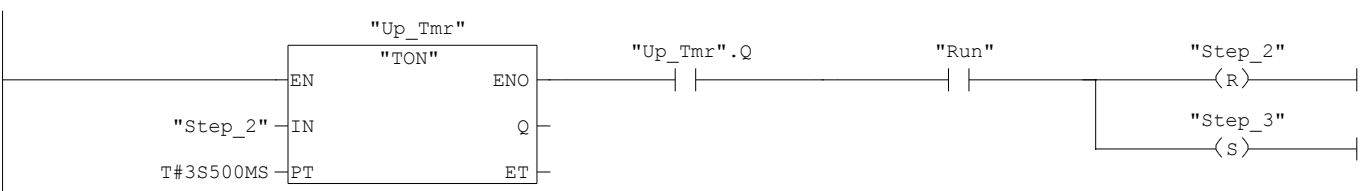
Network: 2

Step 1 Move in



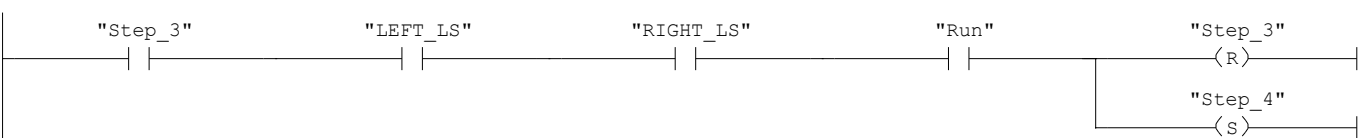
Network: 3

Step 2 Open up



Network: 4

Step 3 Close sides



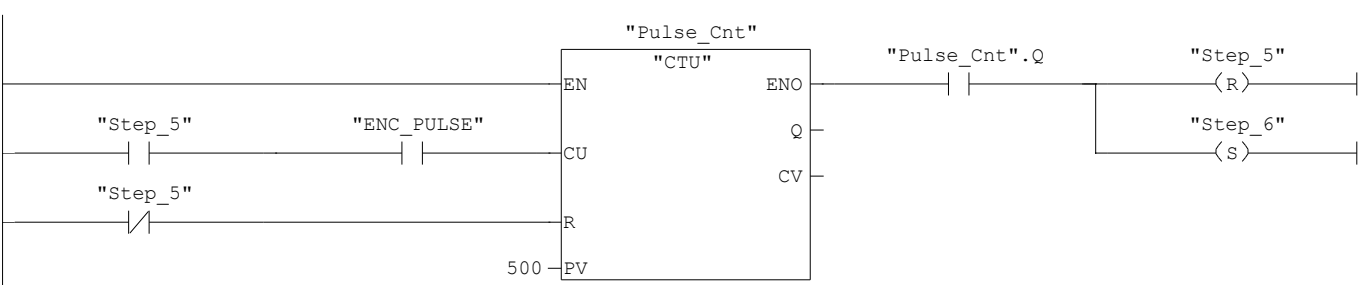
Network: 5

Step 4 Close bottom



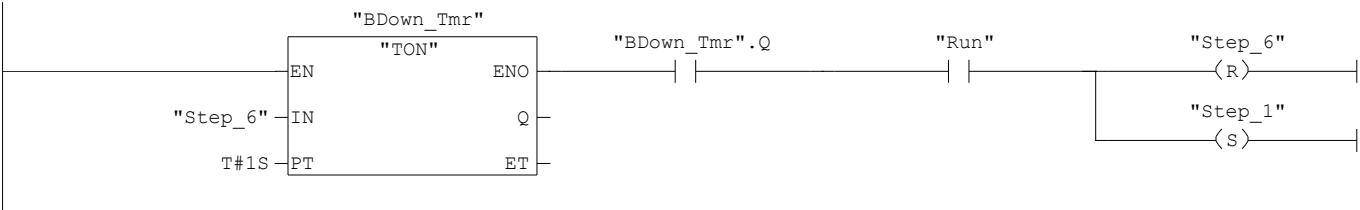
Network: 6

Step 5 Move out



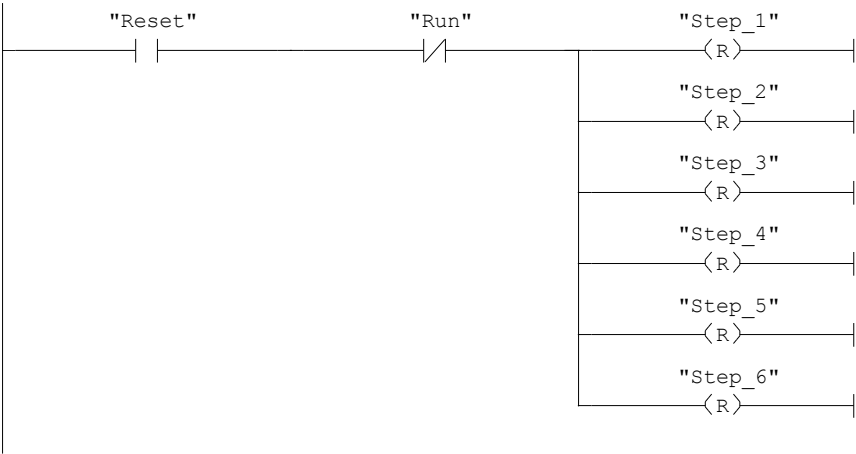
Network: 7

Step 6 Let Bot_Cyl fall



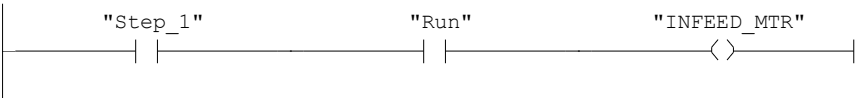
Network: 8

Reset



Network: 9

Infeed rollers, on to move in flat carton



Network: 10

End cylinder control, when on unfolds flat carton



Network: 11

Left cylinder control when on folds left flap inward



Network: 12

Right cylinder control, when on folds right flap inward



Network: 13

Bottom cylinder control, when on folds bottom flap inward



Network: 14

Gate cylinder control, on to prevent carton from sliding out sta



Network: 15

Chain conveyor motor control, when on moves carton out

