

OB1 - <offline>

""

Name:

Author:

Time stamp Code:

Lengths (block/logic/data):

Family:

Version: 0.1

Block version: 2

12/27/2015 07:03:48 AM

02/15/1996 04:51:12 PM

00570 00406 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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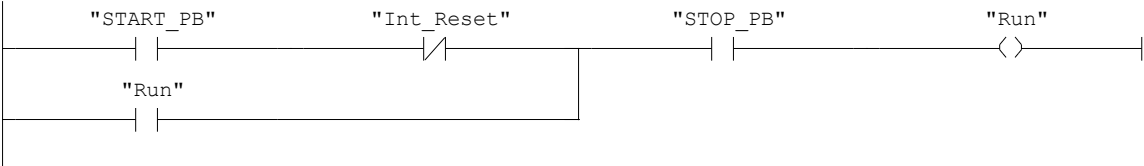
Problem SP6-18 Revised Drilling Station Control

Additional internal memory:

Symbol	Address		
Run	M5.0	BOOL	On while station running
Int_Reset	M5.1	BOOL	Internal reset
Step_1 to Step_16	M0.1 to M2.0	BOOL	Step-in-progress bits
Unclmp_Tmr	DB1	SFB4	Time unclamping of part

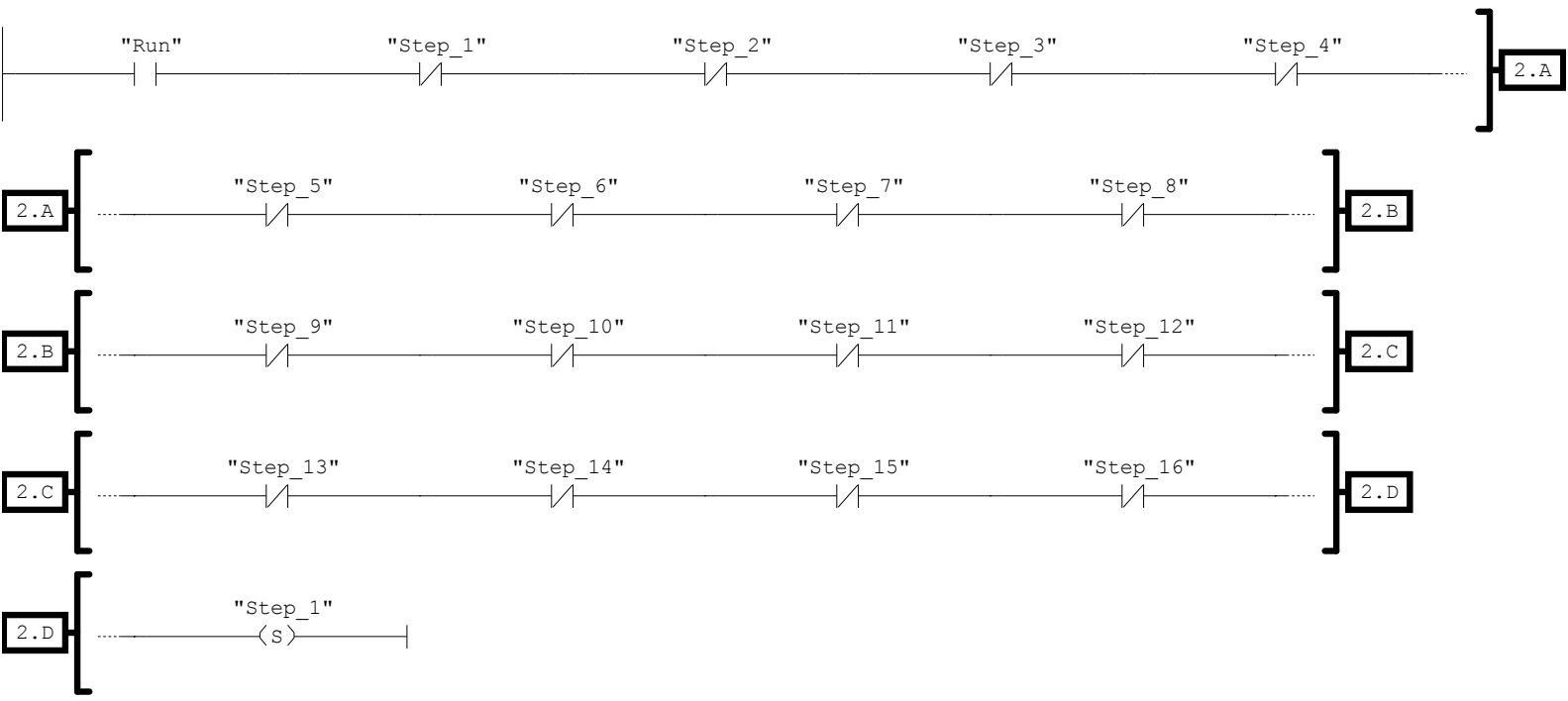
Network: 1        Start/stop

During reset prevent start



Network: 2

Initial start



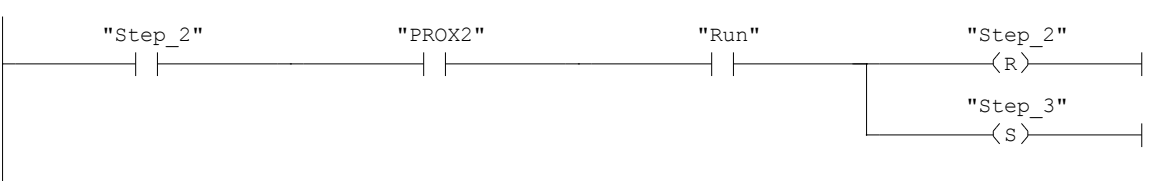
Network: 3

Step 1 Wait for first part



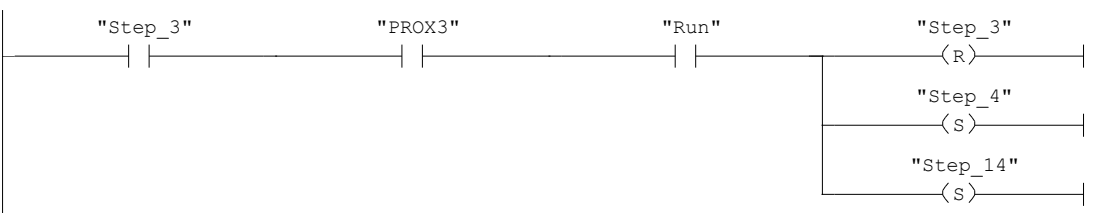
Network: 4

Step 2 Move part to position 2



Network: 5

Step 3 Move part to position 3



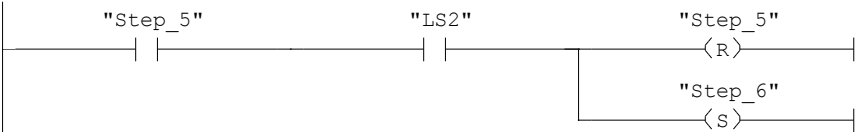
Network: 6

Step 4 Clamp part



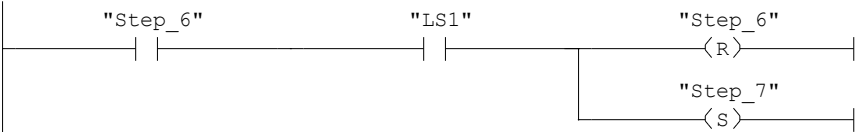
Network: 7

Step 5 Extend drill 1



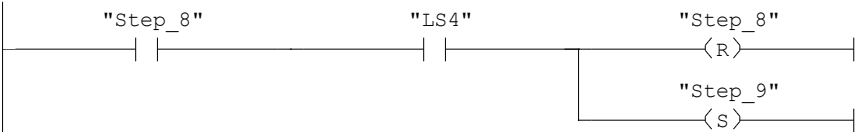
Network: 8

Step 6 Retract drill 1



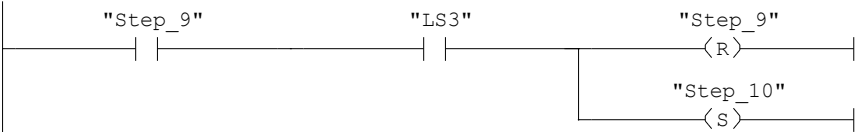
Network: 9

Step 8 Extend drill 2



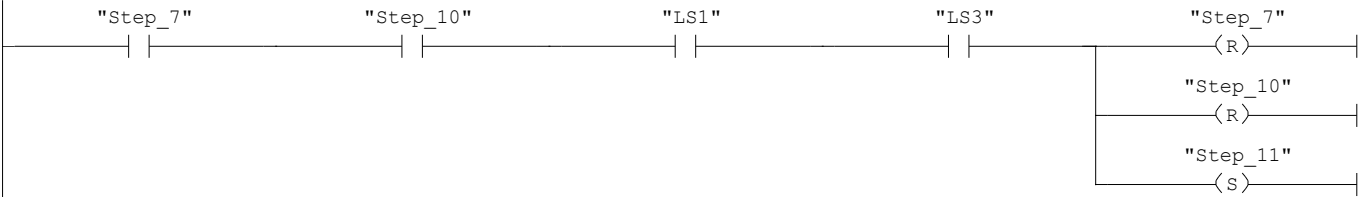
Network: 10

Step 9 Retract drill 2



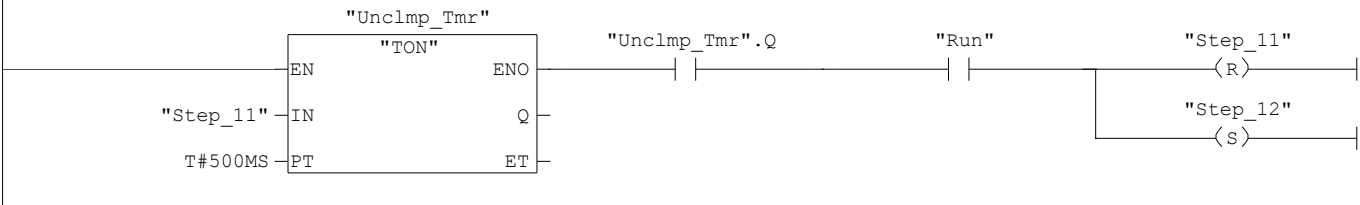
Network: 11

Steps 7 and 10 Wait for both holes to be drilled



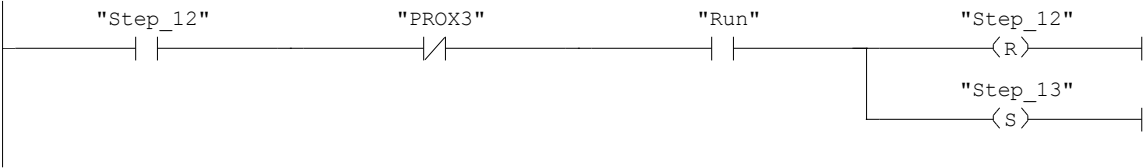
Network: 12

Step 11 Unclamp part



Network: 13

Step 12 Move out part



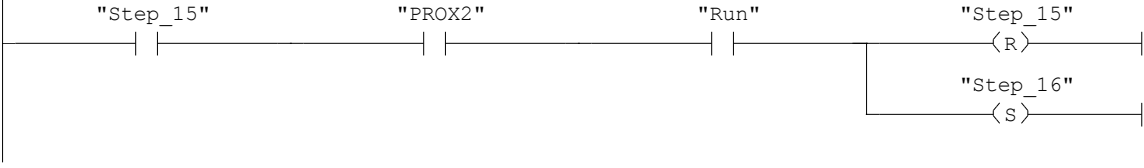
Network: 14

Step 14 - Wait for part in position 1

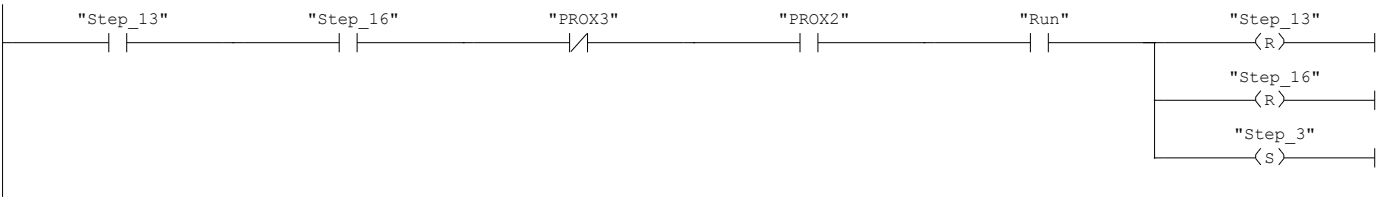


Network: 15

Step 15 - Move part to position 2

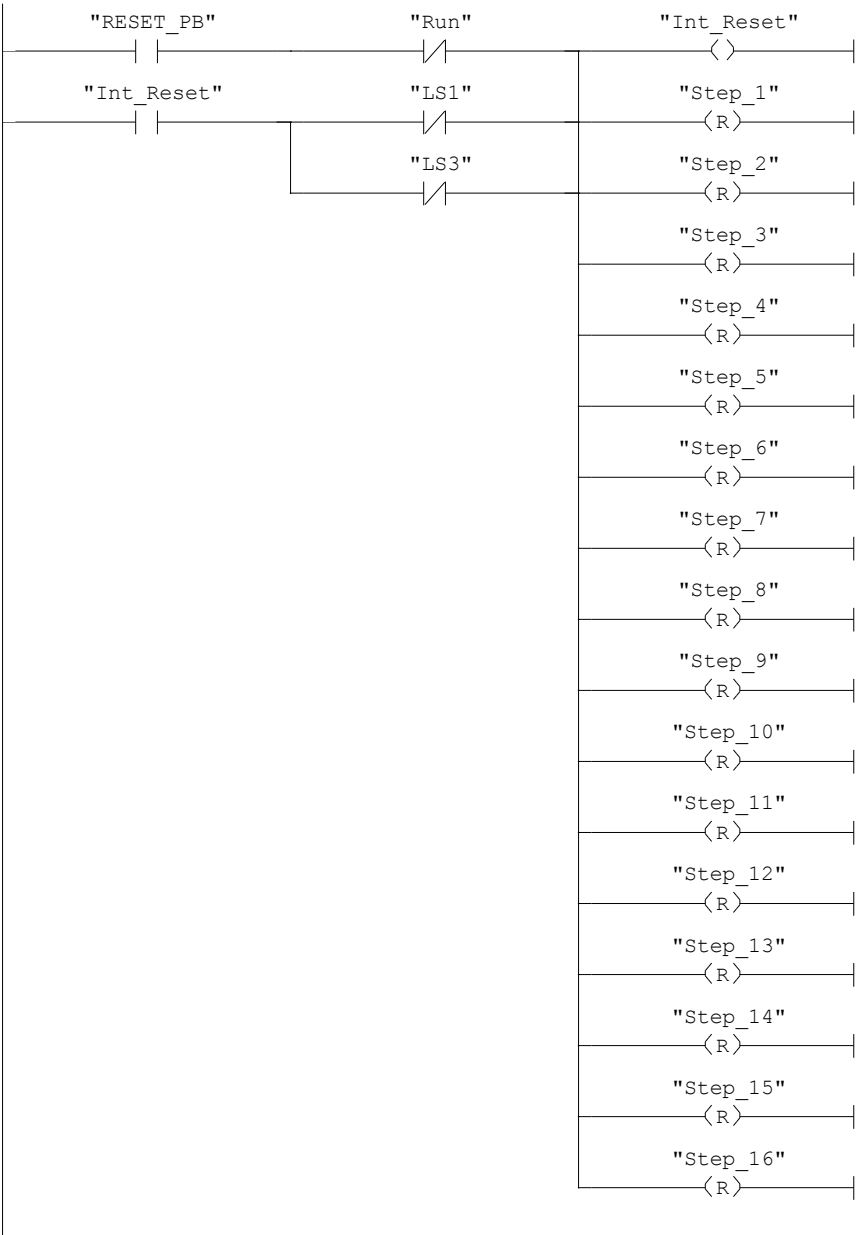


Network: 16      Steps 13 and 16 - Wait for one part unclamped and another in pos



Network: 17      Reset

Maintain reset until both drill retracted.



Network: 18

Gate controls



Network: 19

Gate 2 control

Retract on reset



Network: 20

Knife controls

Retract on reset



Network: 21

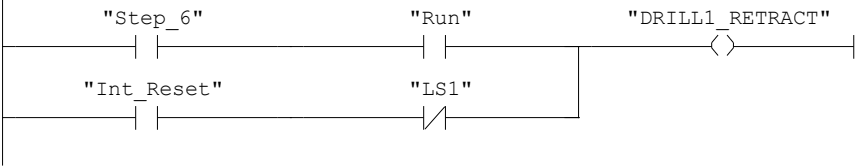
Drill 1 controls



Network: 22

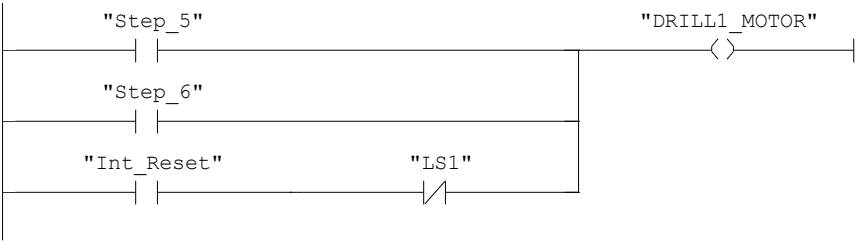
Drill 1 retraction control

Must also retract on reset



Network: 23      Drill 1 motor control

Must continue to run drill motor while retracting due to reset

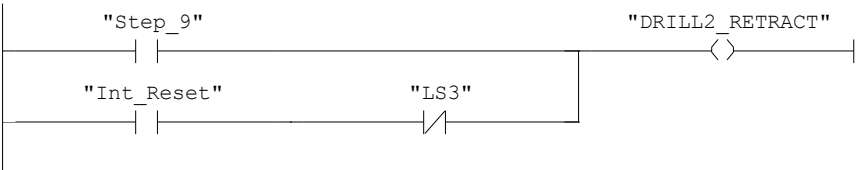


Network: 24      Drill 2 controls



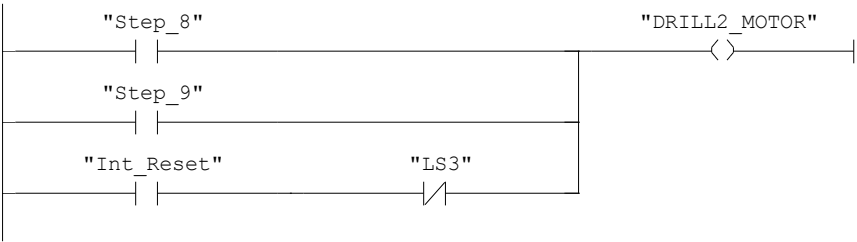
Network: 25      Drill 2 retraction control

Must also retract on reset



Network: 26      Drill 2 motor control

Must continue to run drill motor while retracting due to reset



Network: 27      Clamp control

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

