

OB1 - <offline>

""

Name:

Author:

Time stamp Code:

Interface:

Lengths (block/logic/data):

Family:

Version: 0.1

Block version: 2

12/31/2015 08:47:38 PM

02/15/1996 04:51:12 PM

00588 00444 00030

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)"

Weigh Scale Station Control

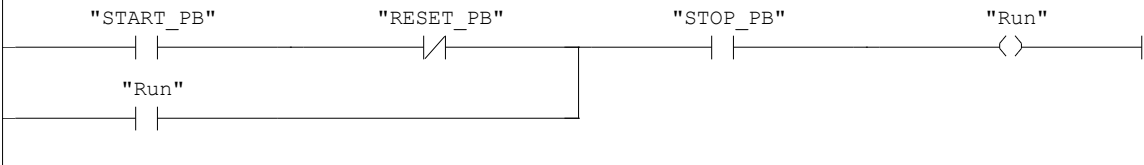
Additional internal memory:

Symbol	Address		
Run	M3.1	BOOL	On while station running
Step_1 to Step_4	M0.1 to M0.4	BOOL	Step-in-progress bits
Stab_Tmr	DB1	SFB4	Delay for weight to stabilize
MoveOut_Tmr	DB3	SFB4	Delay for detecting pallet gone
TmpDI	MD120	DINT	Temporary double integer
TmpR	MD124	REAL	Temporary real
Ret_Val	MW12	WORD	Return value from SCALE block
Always_Off	M10.0	BOOL	Always off bit for SCALE block

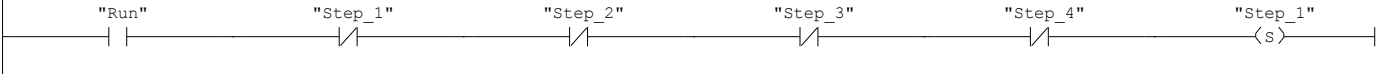
Conversion formula:

WT132_VAL = (WT132_MEAS-5530)/22118.0 * (900.0)

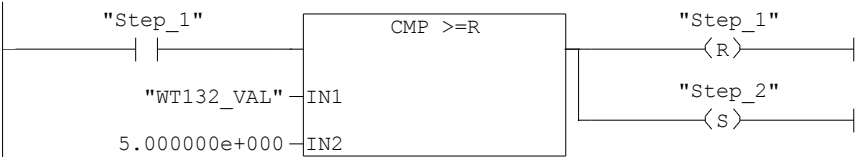
Network: 1 Start/stop



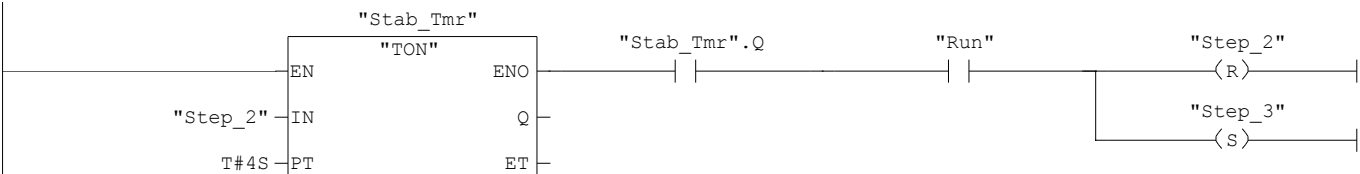
Network: 2 Initial Start



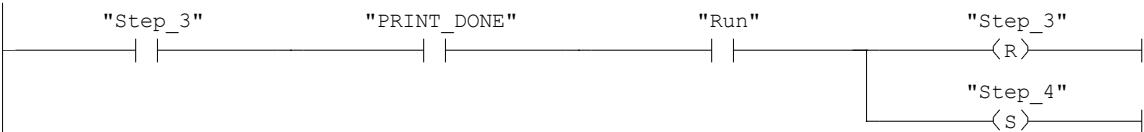
Network: 3 Step 1 Move in



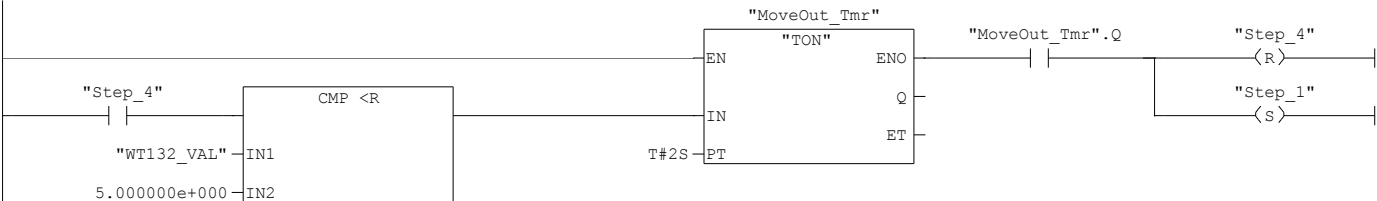
Network: 4 Step 2 Delay for weight to settle



Network: 5 Step 3 Print a weight

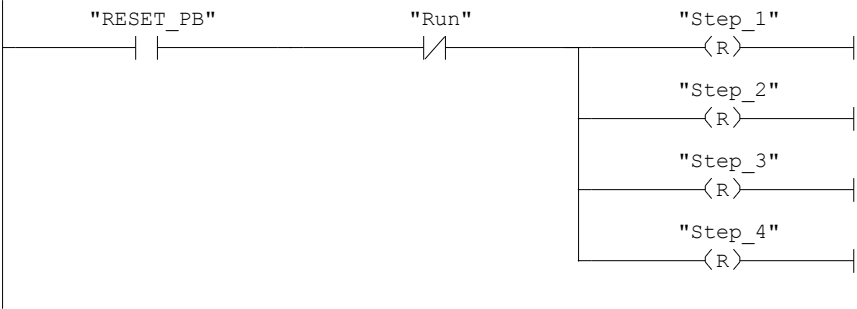


Network: 6 Step 4 Move Out



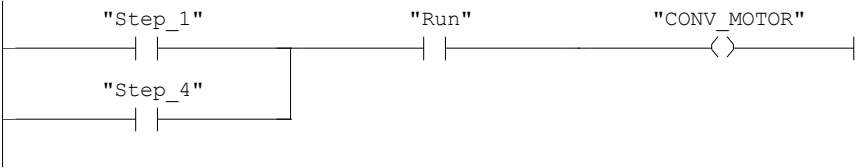
Network: 7

Reset



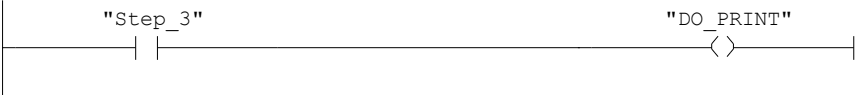
Network: 8

Conveyor control



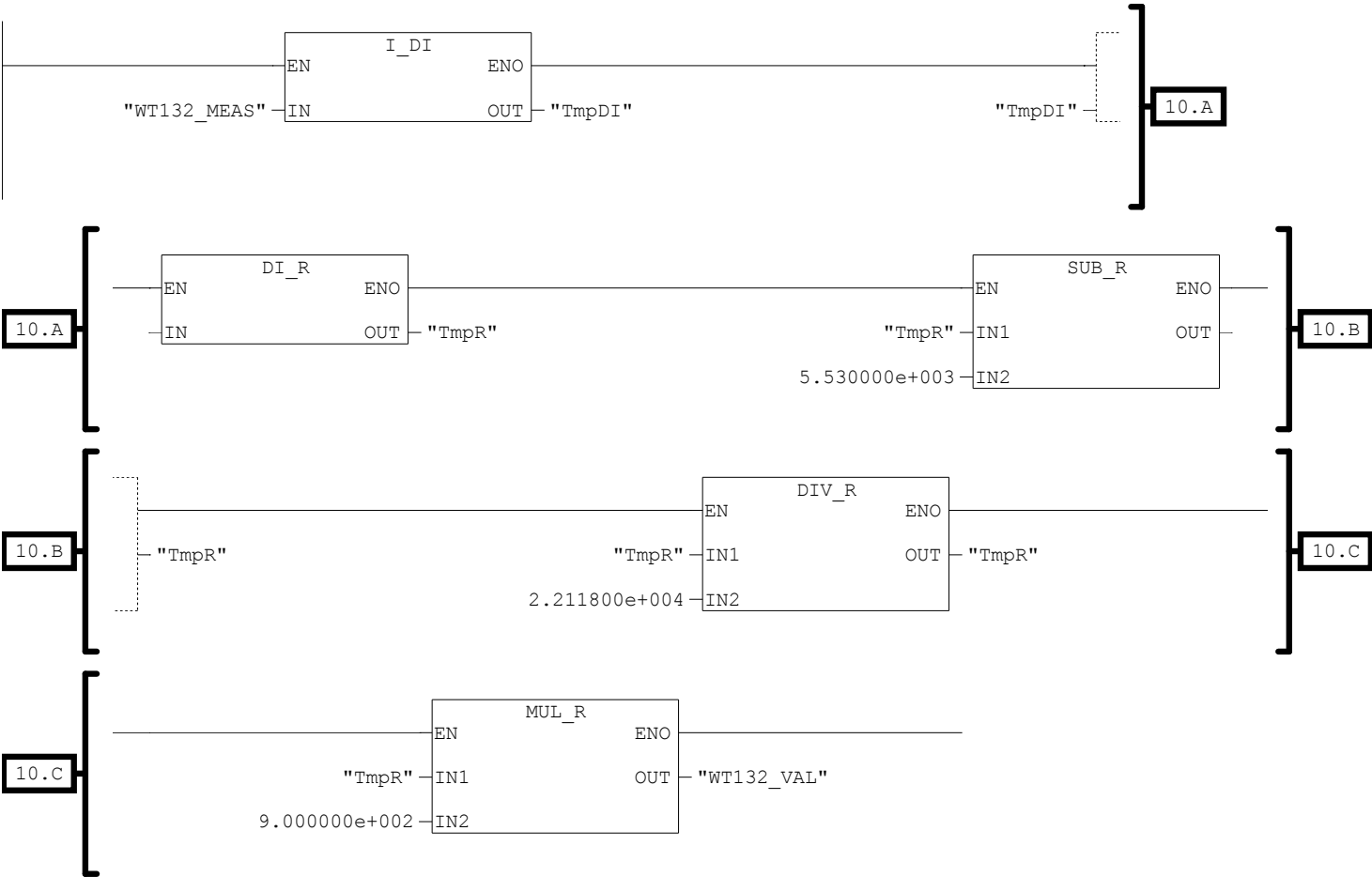
Network: 9

Print Start command



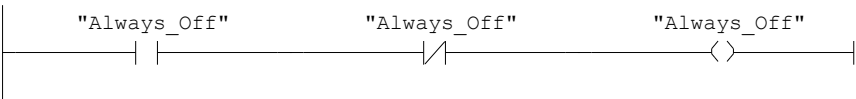
Network: 10

Convert weight measurement to pounds.
Uses individual computation blocks.



Network: 11

Always Off



Network: 12

Convert level measurement to level in inches.
Uses SCALE block. Note that the lo_lim input is 25% lower than zero weight to account for this block assuming the minimum value of the analog in is zero rather than the 5530 (which corresponds to 4 mA).

