

OB1 - <offline>

"Main_Program"

Name:	Family:
Author:	Version: 0.1
	Block version: 2
Time stamp Code:	12/31/2015 10:38:38 AM
Interface:	02/15/1996 04:51:12 PM
Lengths (block/logic/data):	00670 00516 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)"

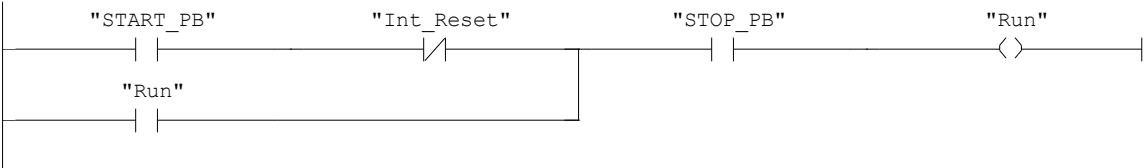
Copyright (c) 2011, 2015 Dogwood Valley Press, LLC

SP21-3 Erbia Can Tipper/Rotator 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_9 M20.1 to M21.1 SFB4 Times CYL_4 retract
Retract_Tmr DB1 SFB4 Times blend
Blend_Tmr DB3

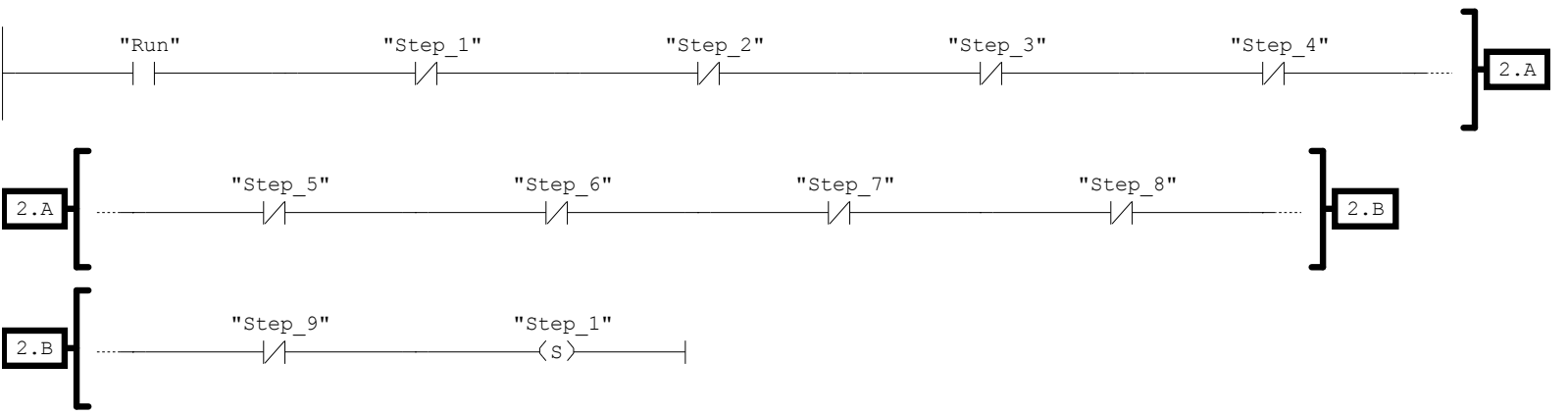
Network: 1 Start/stop

During reset prevent start



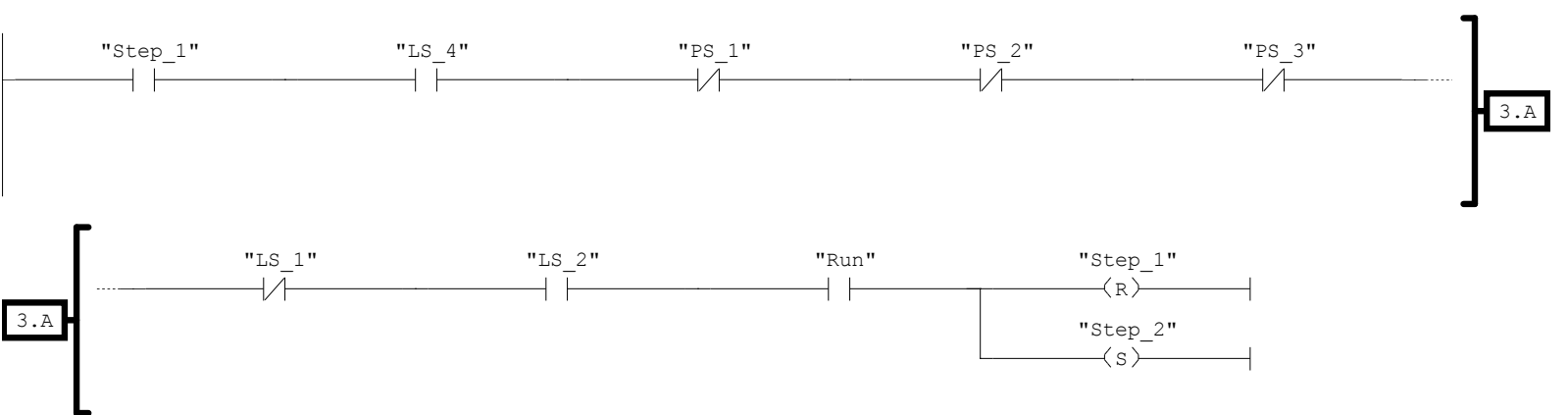
Network: 2

Initial start



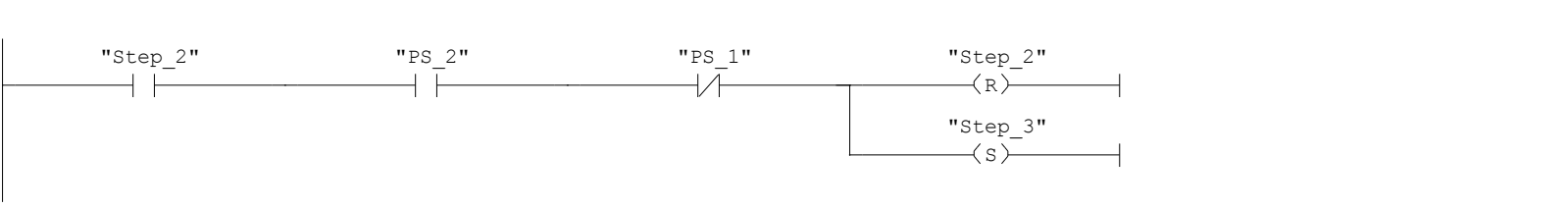
Network: 3

Step 1 Wait for can



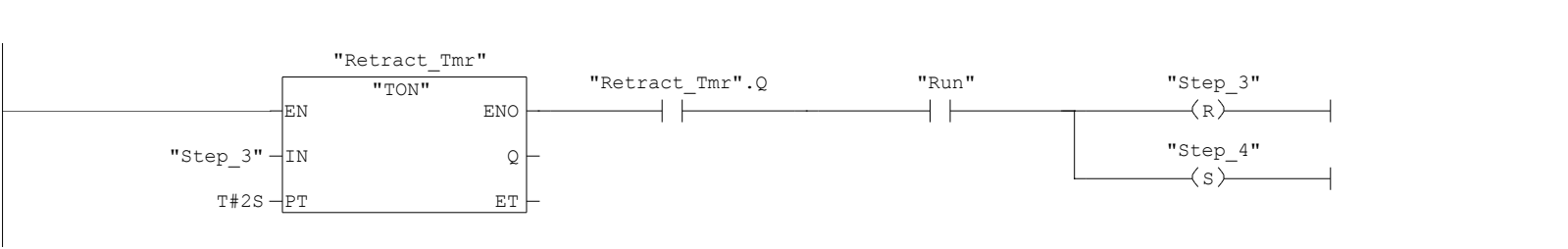
Network: 4

Step 2 Push can into tipper.



Network: 5

Step 3 Wait for CYL_4 to retract



Network: 6

Step 4 Clamp can



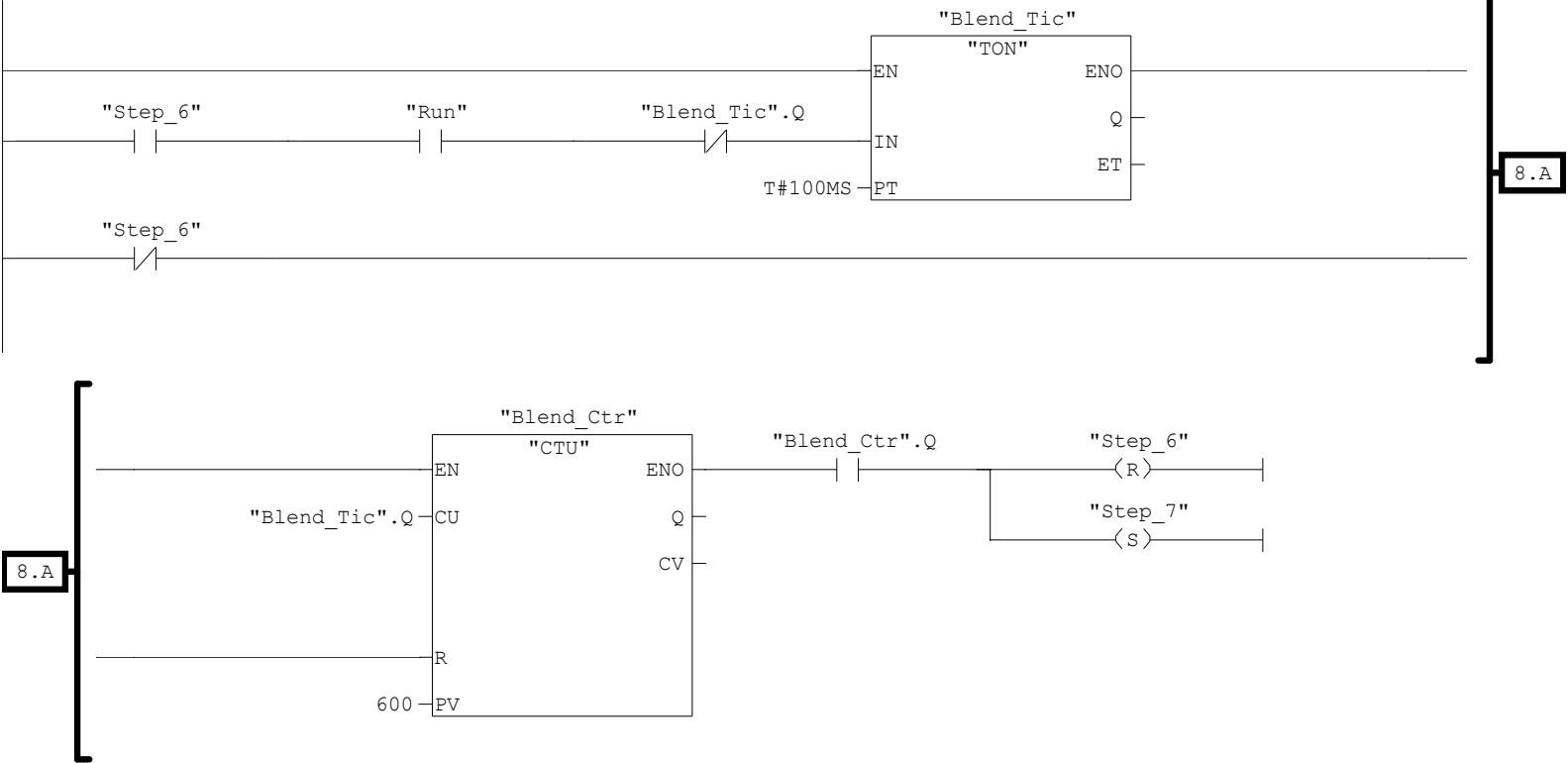
Network: 7

Step 5 Tip rotator



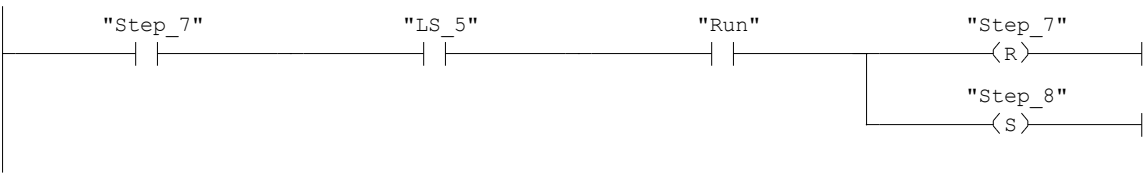
Network: 8

Step 6 Blend



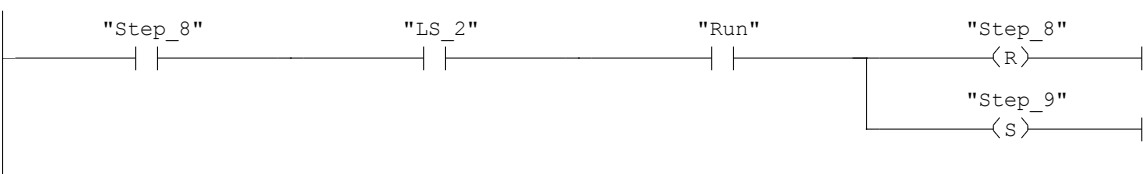
Network: 9

Step 7 Untip



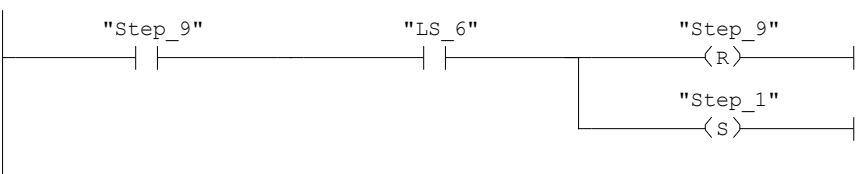
Network: 10

Step 8 Unclamp



Network: 11

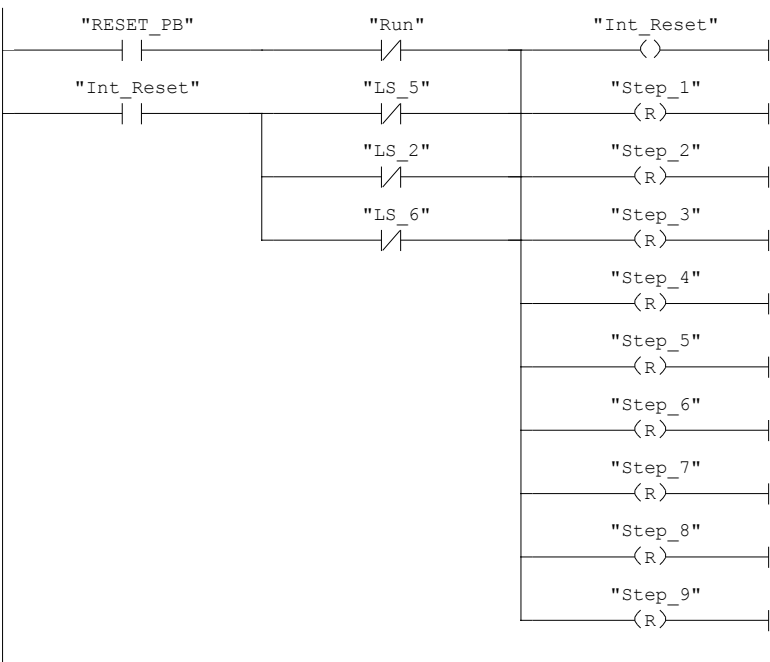
Step 9 - Push out



Network: 12

Reset

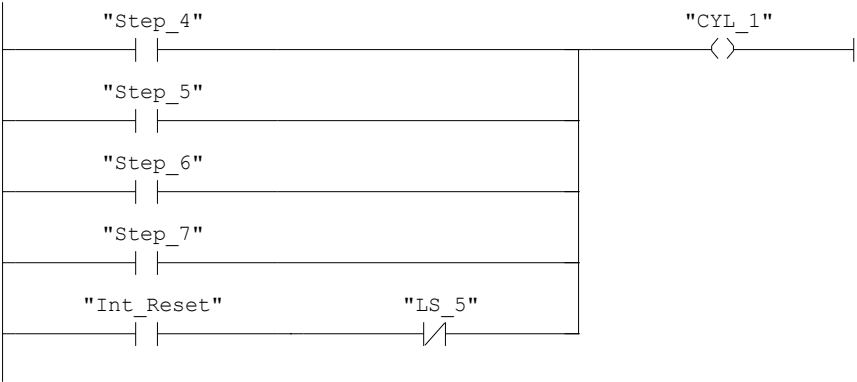
Keep internal reset on until can unclamped, vertical and out of station.



Network: 13Physical Outputs

Gate cylinder controls. Cannot turn off CYL_1 to CYL_3 when paused.

On reset, do not unclamp until vertical.

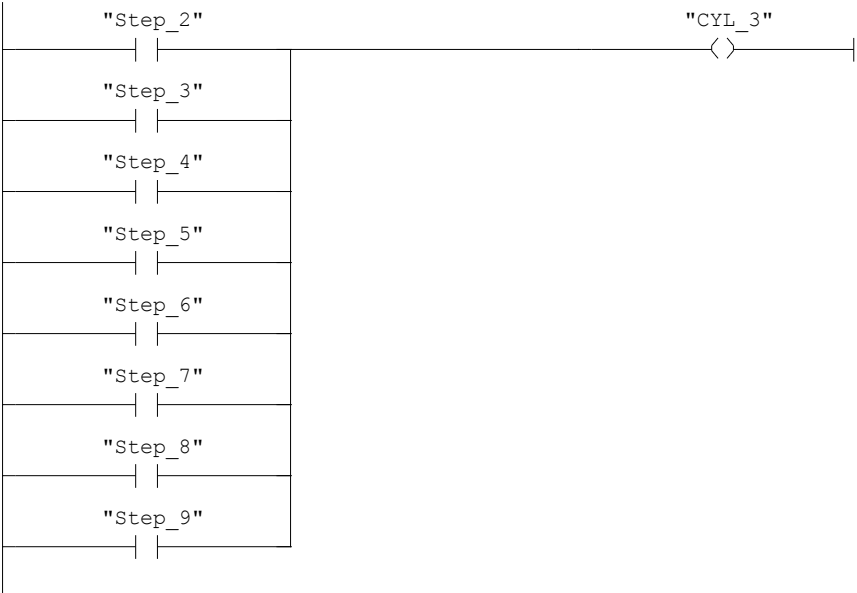


Network: 14CYL_2 control



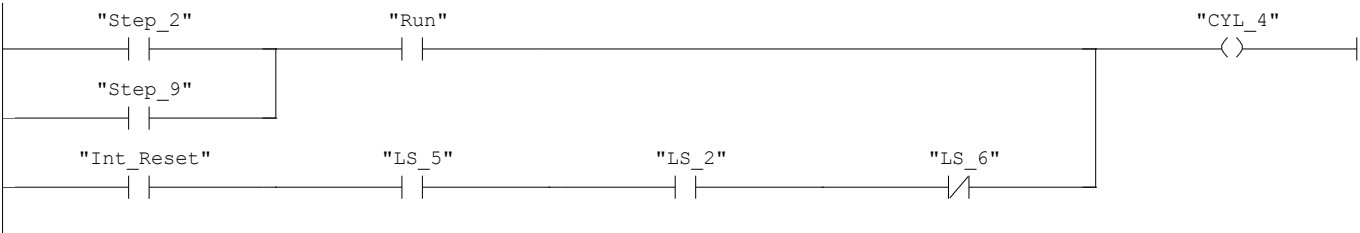
Network: 15CYL_3 control

Retract on reset



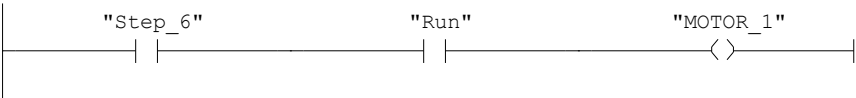
Network: 16CYL_4 control

On reset, do not push out until in vertical position and unclamped.



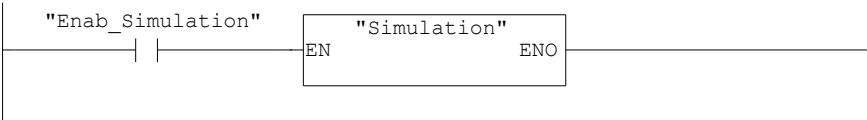
Network: 17Rotator motor control

Retract on reset



Network: 18

Simulation



Network: 19

Copy real inputs to input image if not simulating

