

OB1 - <offline>

""

Name:

Author:

Time stamp Code:

Lengths (block/logic/data):

Family:

Version: 0.1

Block version: 2

12/27/2015 06:36:10 AM

02/15/1996 04:51:12 PM

00582 00438 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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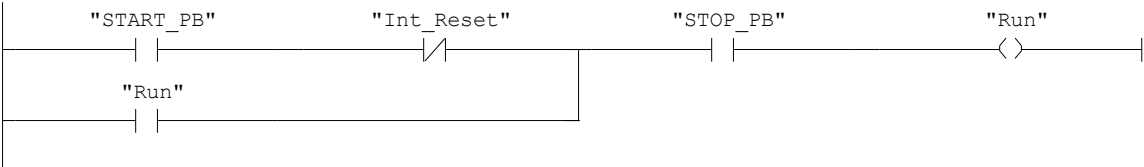
Problem SP6-1 Carton Sealer Control

Additional internal memory:

Symbol	Address		
Run	M5.0	BOOL	On while station running
Int_Reset	M5.1	BOOL	Internal reset
Step_1 to Step_7	M0.1 to M0.7	BOOL	Step-in-progress bits
Spray_Tmr	DB1	SFB4	Times spray
Dry_Tmr	DB3	SFB4	Times drying step
Retract_Tmr	DB4	SFB4	Times retract of rams
Reset_Tmr	DB5	SFB4	Times reset (retract of rams)

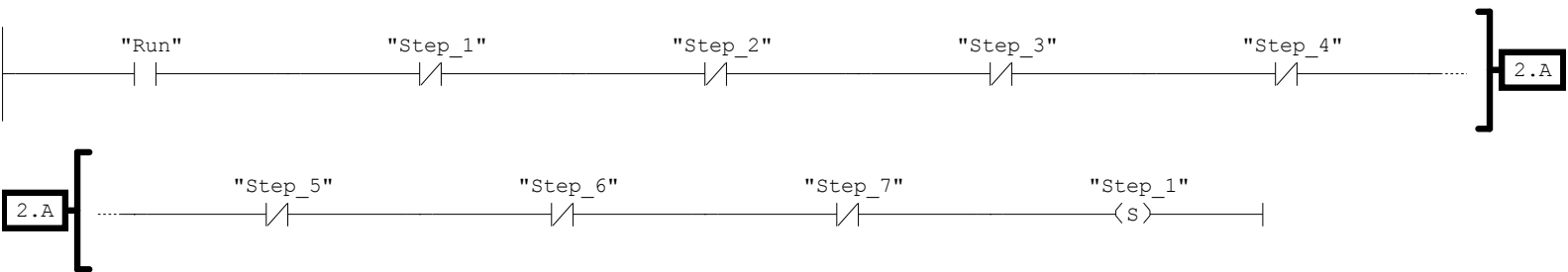
Network: 1 Start/stop

During reset prevent start



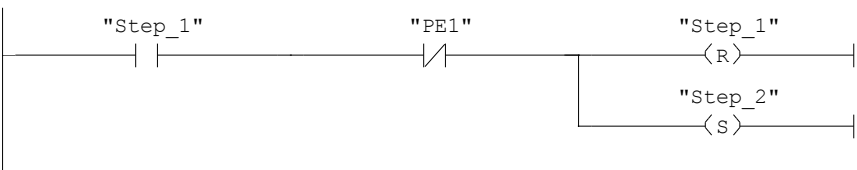
Network: 2

Initial start



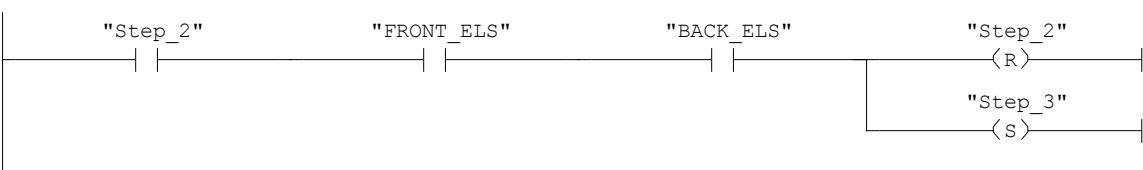
Network: 3

Step 1 Wait for box



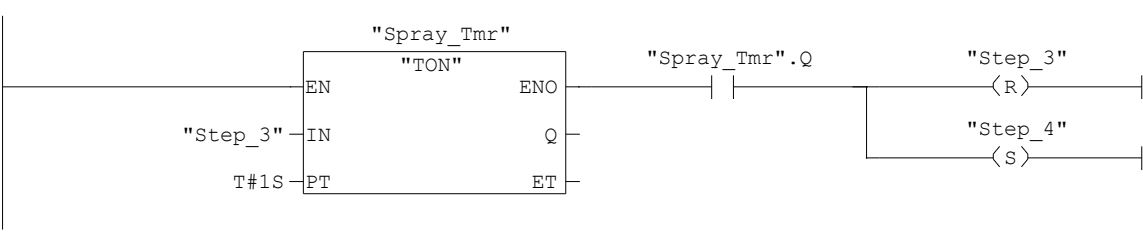
Network: 4

Step 2 Push down end flaps



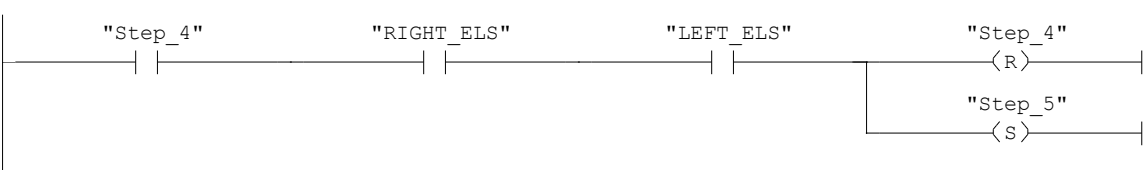
Network: 5

Step 3 Spray Glue



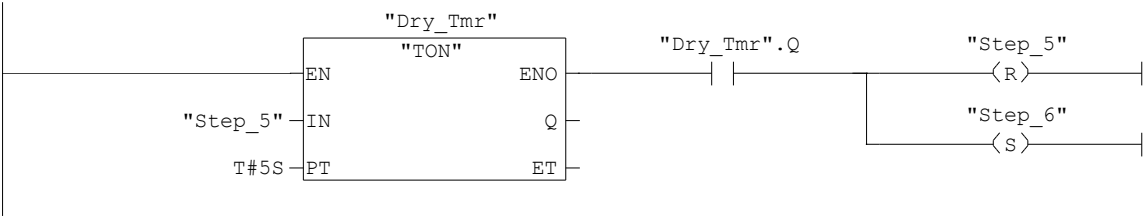
Network: 6

Step 4 Push down side flaps



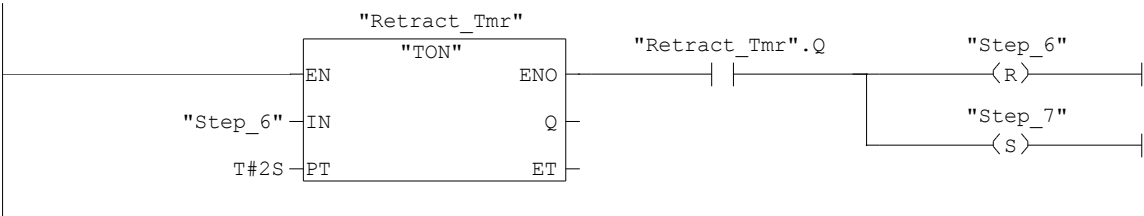
Network: 7

Step 5 Drying wait



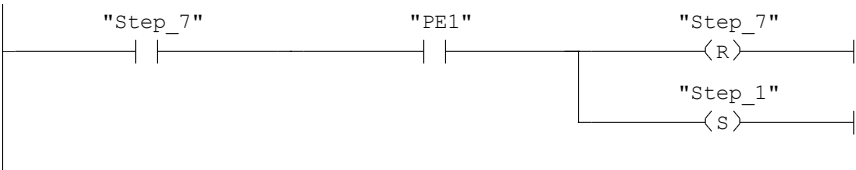
Network: 8

Step 6 Retract rams



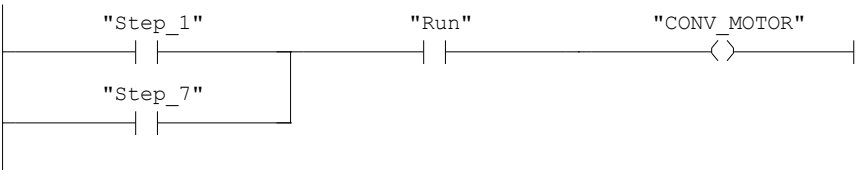
Network: 9

Step 7 Move box out



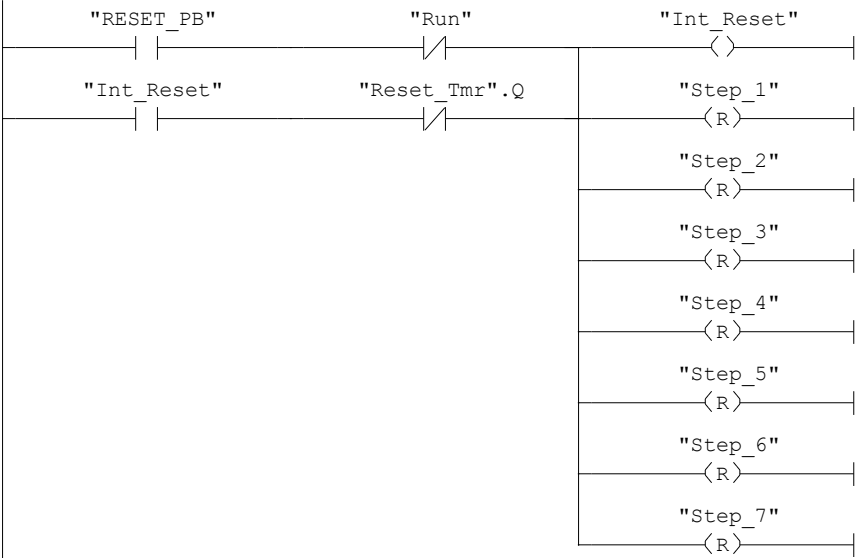
Network: 10

Conveyor motor, on to move conveyor



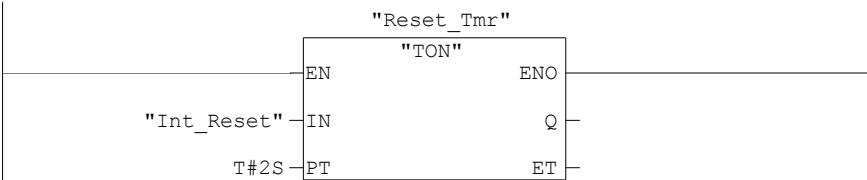
Network: 11

Reset



Network: 12

Reset timer



Network: 13

Glue sprayer control, on to spray glue



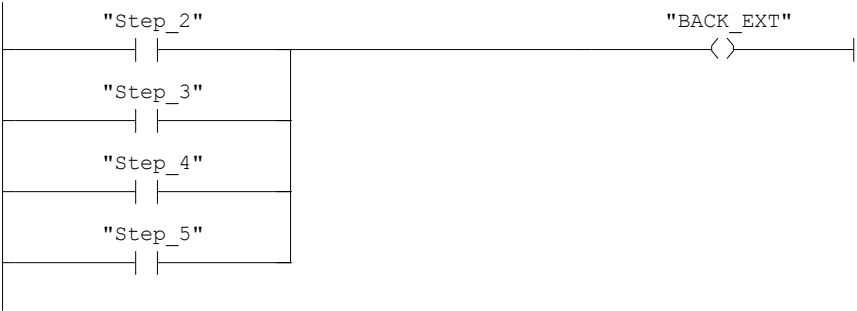
Network: 14

Front flap ram extend direction control, on to extend ram



Network: 15

Back flap ram extend direction control, on to extend ram



Network: 16

Right flap ram extend direction control, on to extend ram



Network: 17

Left flap ram extend direction control, on to extend ram

