

OB1 - <offline>

""

Name:

Author:

Time stamp Code:

Lengths (block/logic/data):

Family:

Version: 0.1

Block version: 2

12/27/2015 06:40:21 AM

02/15/1996 04:51:12 PM

00376 00232 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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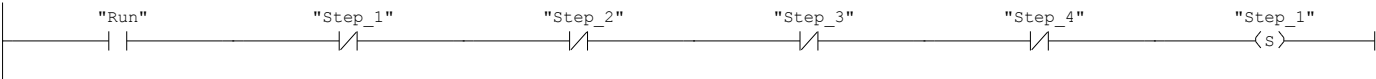
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Problem SP6-3 Parts Transfer Station Control

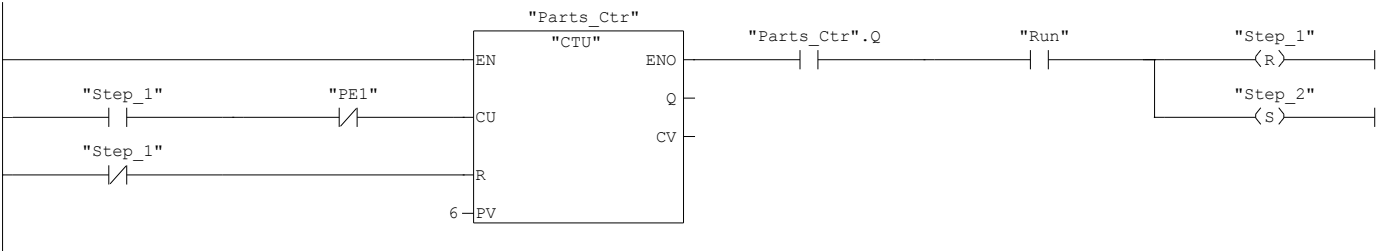
Additional internal memory:

|                  |              |      |                             |
|------------------|--------------|------|-----------------------------|
| 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       |
| Motor1_Tmr       | DB1          | SFB4 | Times rotation of table     |
| Parts_Ctr        | DB2          | SFB0 | Counts parts going to table |

Network: 1      Initial start

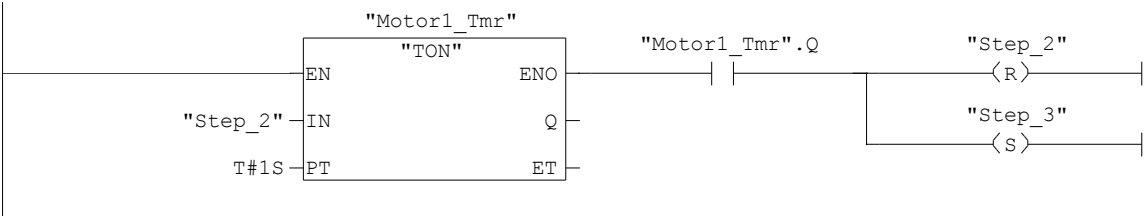


Network: 2      Step 1 Count parts



Network: 3

Step 2 Rotate Table



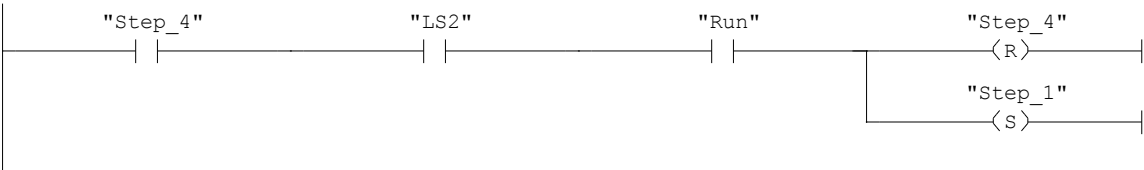
Network: 4

Step 3 Extend Ram



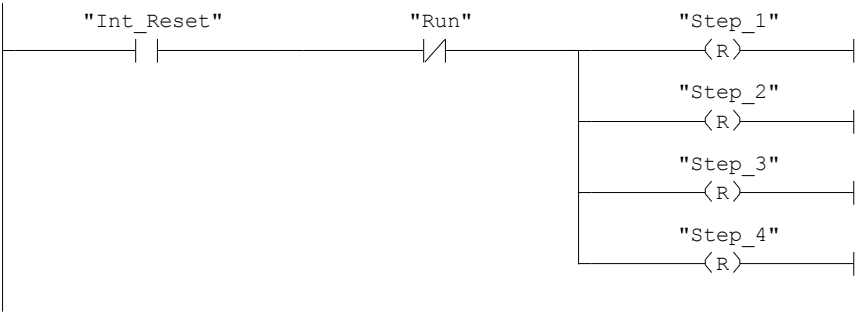
Network: 5

Step 4 Retract Ram



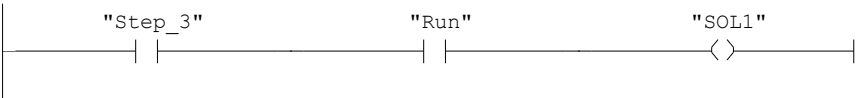
Network: 6

Reset



Network: 7

Pneumatic ram extension solenoid control, on to extend ram



Network: 8

Turntable motor control, on to turn turntable



Network: 9

Belt conveyor motor control, on to run conveyor

