

OB1 - <offline>
""
Name:
Author:
Family:
Version: 0.1
Block version: 2
Time stamp Code: 12/27/2015 06:50:46 AM
Interface: 02/15/1996 04:51:12 PM
Lengths (block/logic/data): 00408 00264 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)"**

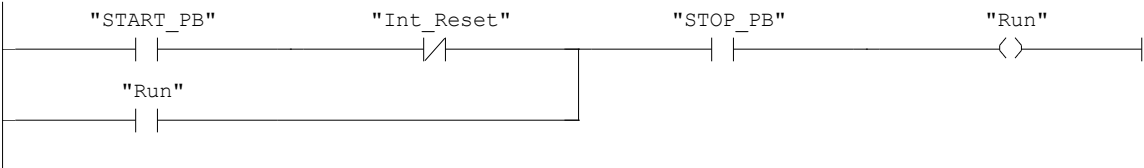
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Problem SP6-10 Pressing Station Control

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_6 M0.1 to M0.6 SFB4 Times pressing step
Press_Tmr DB1 SFB4 Times cool down
Cool_Tmr DB3

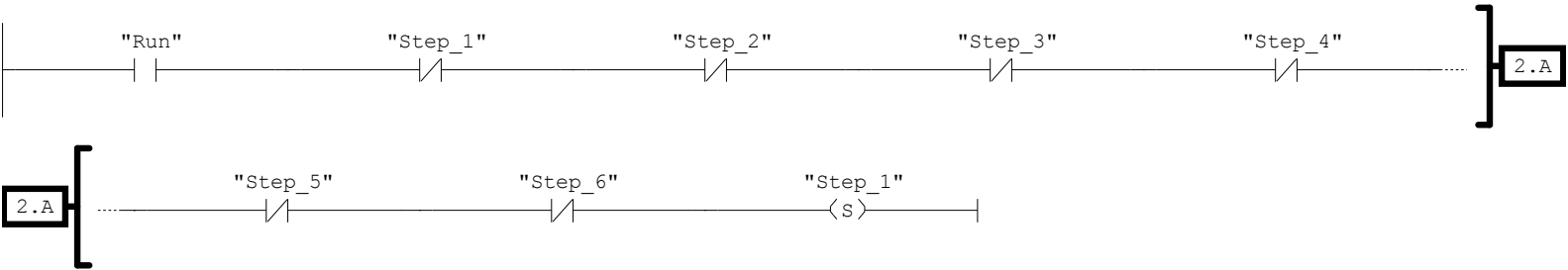
Network: 1 Start/stop

During reset prevent start



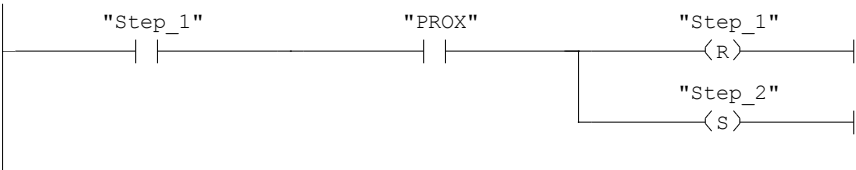
Network: 2

Initial start



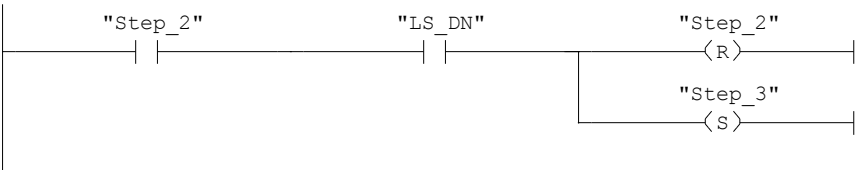
Network: 3

Step 1 Move in piece



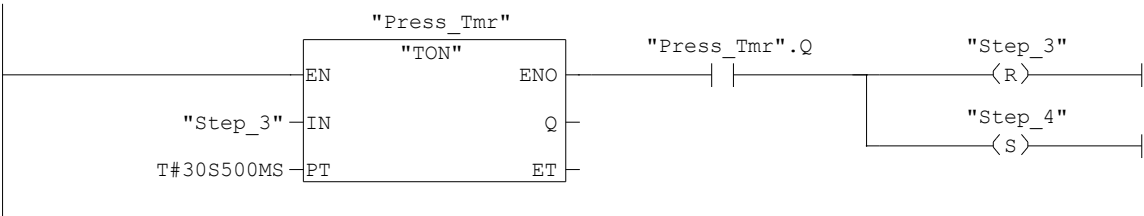
Network: 4

Step 2 Lower press



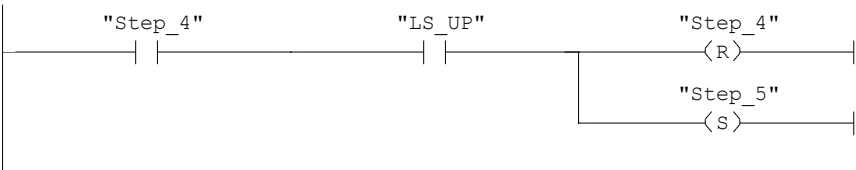
Network: 5

Step 3 Press piece



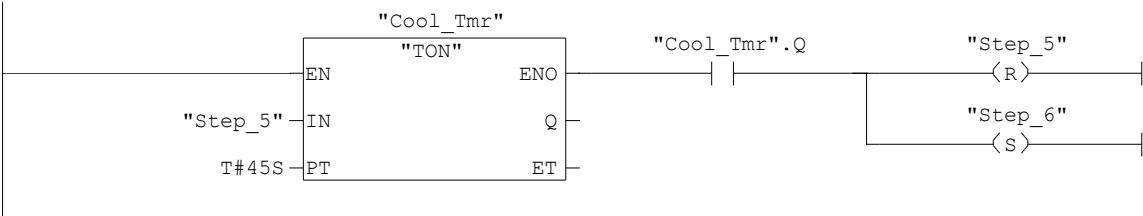
Network: 6

Step 4 Raise press



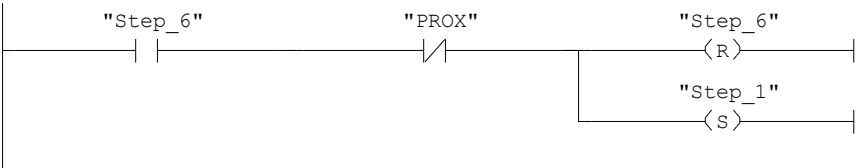
Network: 7

Step 5 Cool down



Network: 8

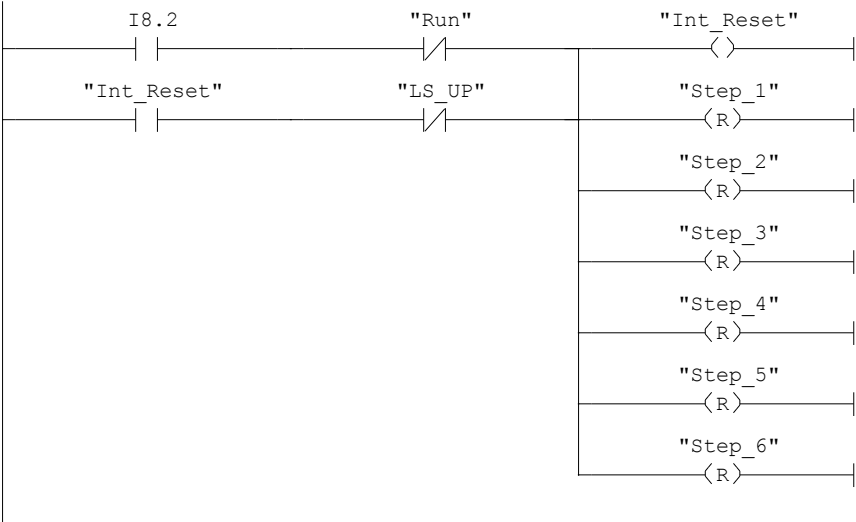
Step 6 Move out piece



Network: 9

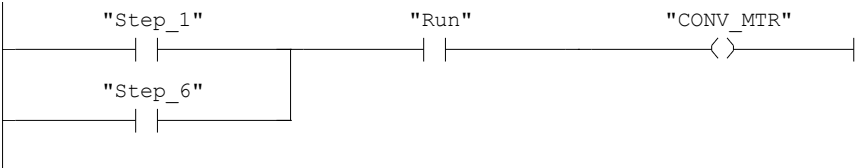
Reset

Keep internal reset on while raising press.

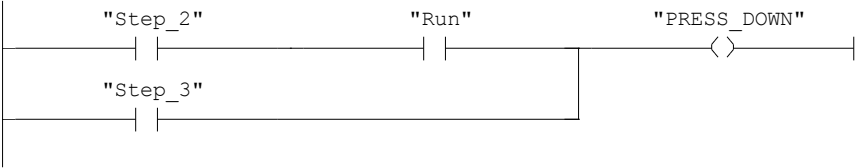


Network: 10

Infeed conveyor motor control, on to run conveyor motor



Network: 11	Press cylinder control, on to lower press
Can not pause in Step 3	



Network: 12	On to open valve that directs steam into die
Can not turn off when paused.	

