

**OB1 - <offline>**  
""  
**Name:** **Family:**  
**Author:** **Version:** 0.1  
**Block version:** 2  
**Time stamp Code:** 12/27/2015 06:54:15 AM  
**Interface:** 02/15/1996 04:51:12 PM  
**Lengths (block/logic/data):** 00518 00360 00026

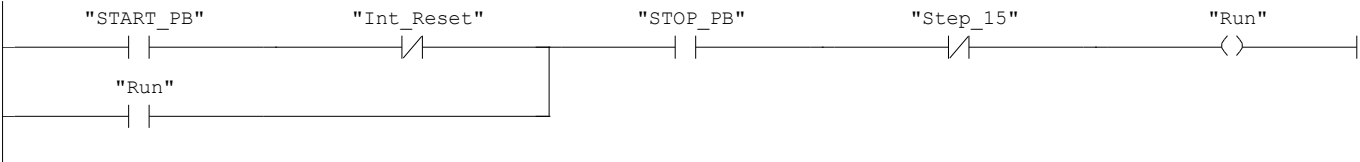
Name	Data Type	Address	Comment
TEMP		0.0	
OB1_EV_CLASS	Byte	0.0	Bits 0-3 = 1 (Coming event), Bits 4-7 = 1 (Event class 1)
OB1_SCAN_1	Byte	1.0	1 (Cold restart scan 1 of OB 1), 3 (Scan 2-n of OB 1)
OB1_PRIORITY	Byte	2.0	Priority of OB Execution
OB1_OB_NUMBR	Byte	3.0	1 (Organization block 1, OB1)
OB1_RESERVED_1	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 SP6-12 Batch 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\_15            M0.1 to M1.7                SFB4    Times stir step  
Stir\_Tmr                      DB1

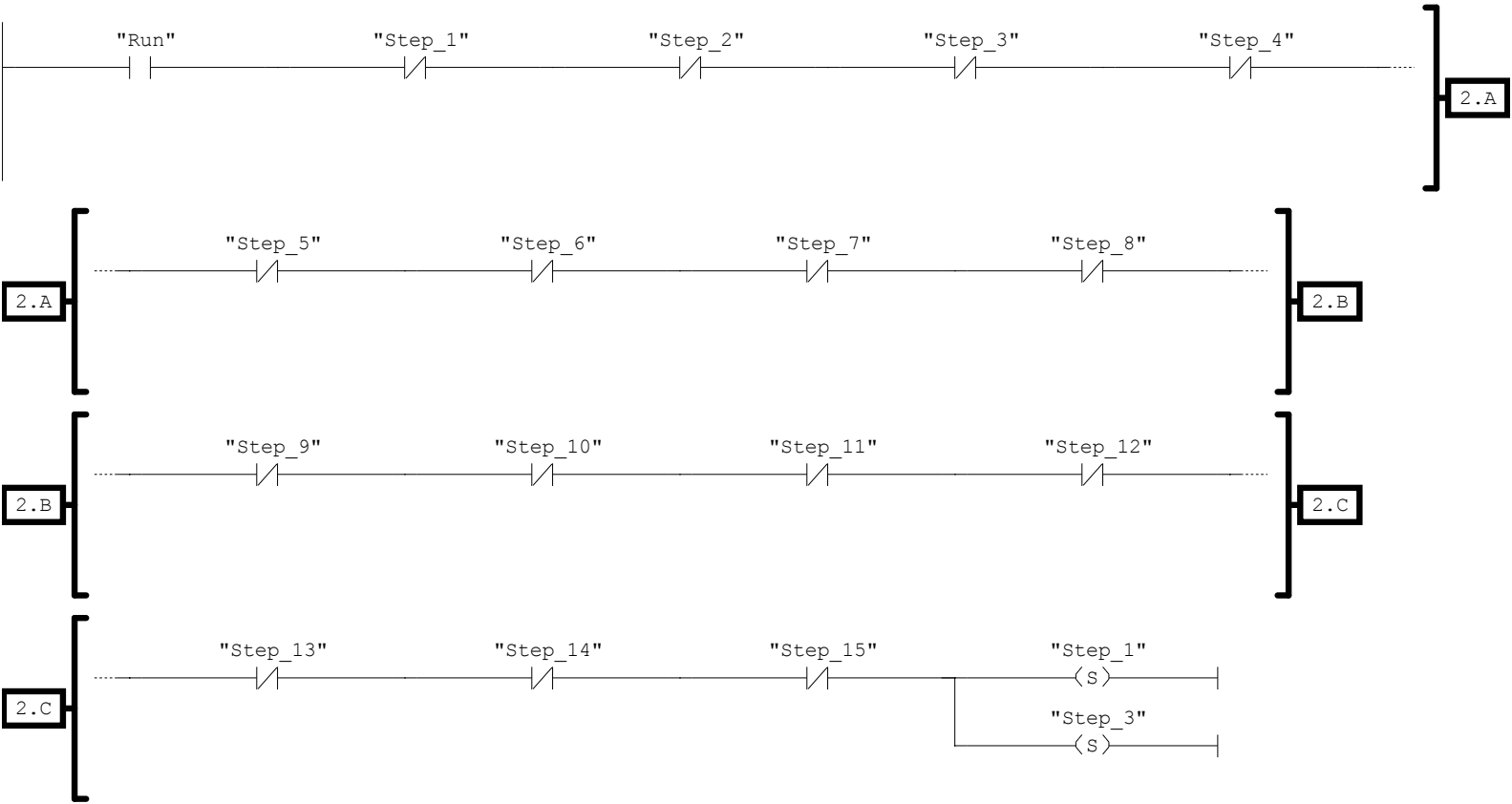
Network: 1            Start/stop

During reset prevent start



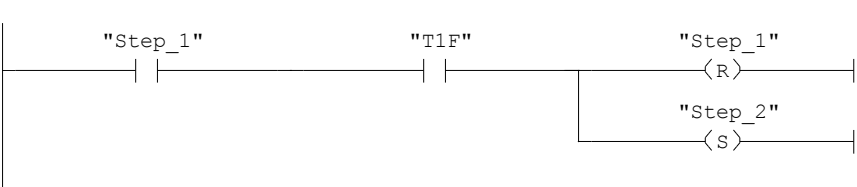
Network: 2

Initial start



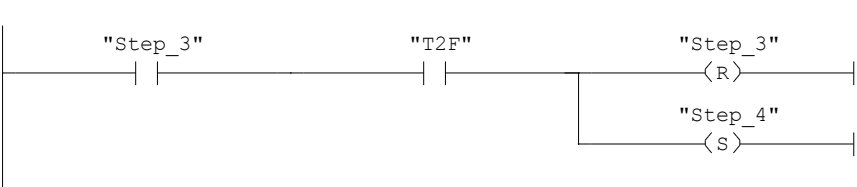
Network: 3

Step 1 Fill Tank 1

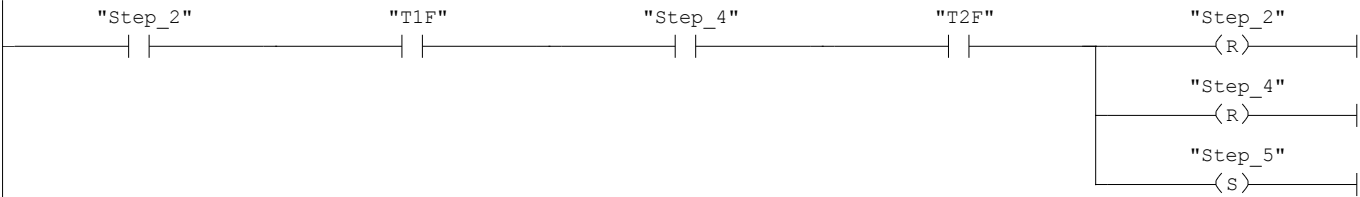


Network: 4

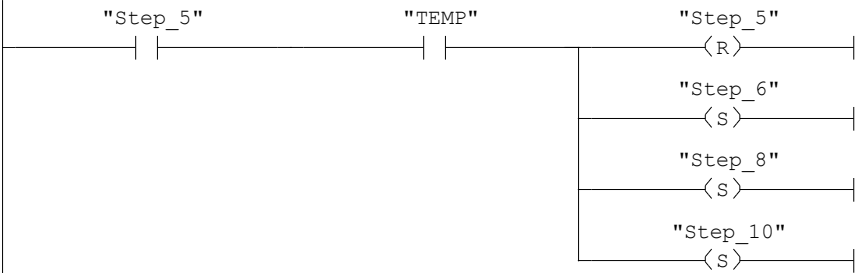
Step 3 Fill Tank 2



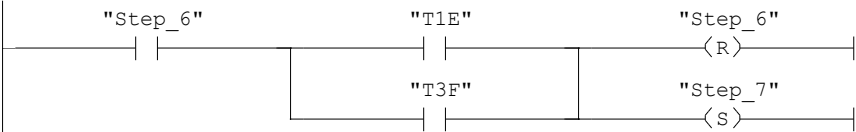
Network: 5      Steps 2 and 4 Wait for Tanks 1 and 2 to be full



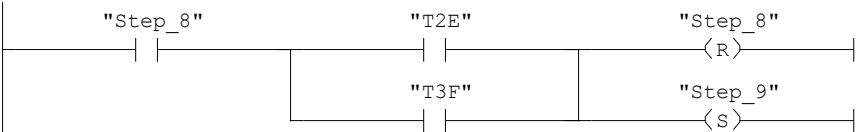
Network: 6      Step 5 Heat Tank 2



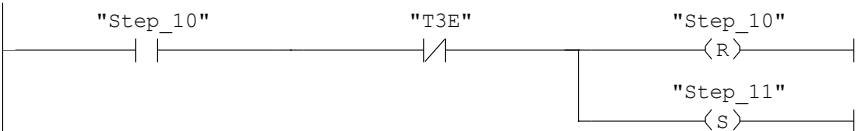
Network: 7      Step 6 Empty Tank 1



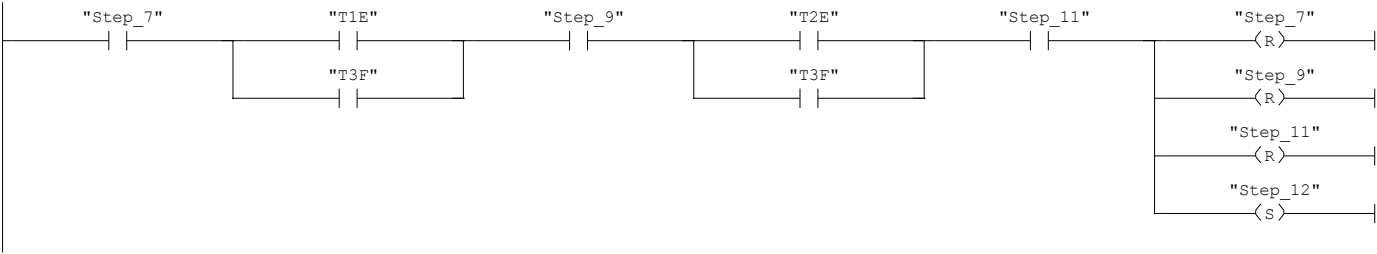
Network: 8      Step 8 Empty Tank 2



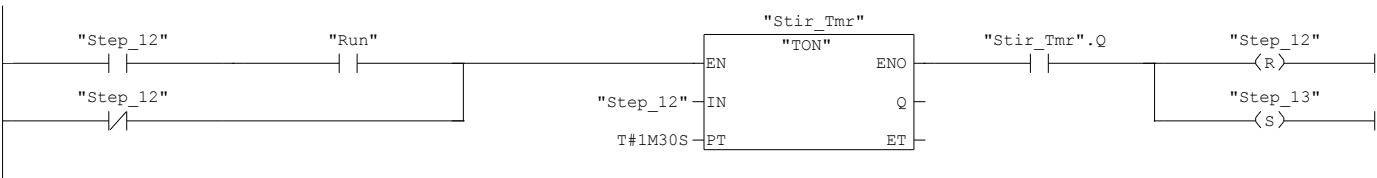
Network: 9      Step 10 Wait for liquid in Tank 3



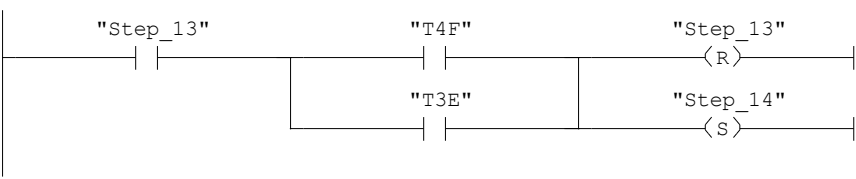
Network: 10      Step 7, 9, 11 Wait for Tanks 1 & 2 to be empty and stirrer start



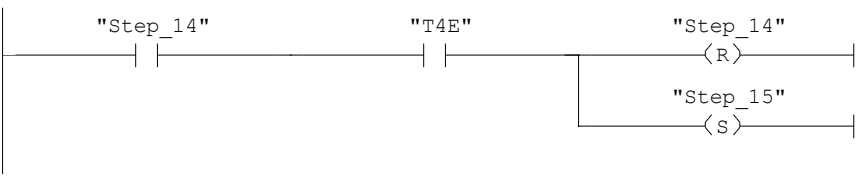
Network: 11      Step 12 Stir Tank 3 for 90 sec



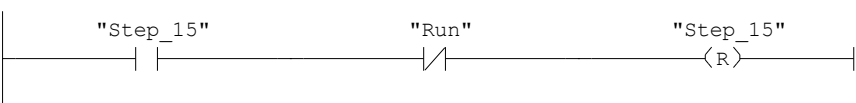
Network: 12      Step 13 Transfer to Tank 4



Network: 13      Step 14 Empty Tank 4

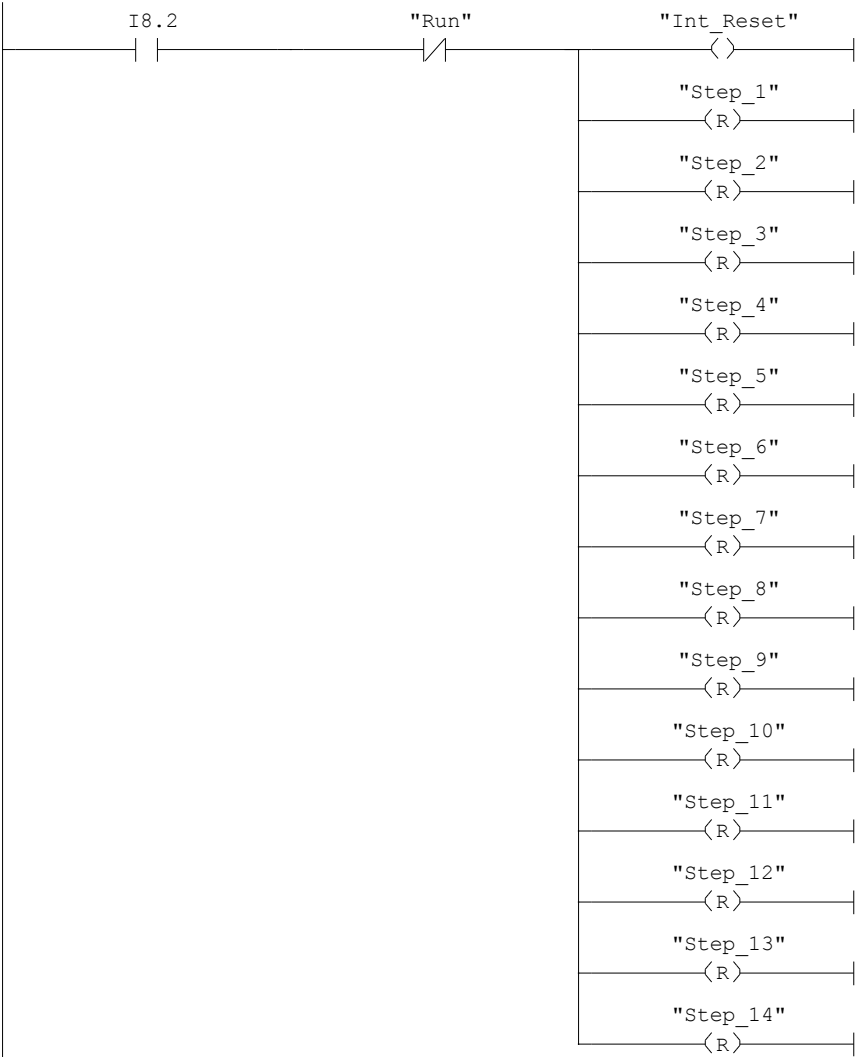


Network: 14      Step 15 - Unlatch run



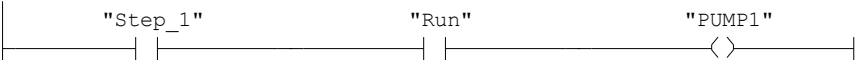
Network: 15

Reset



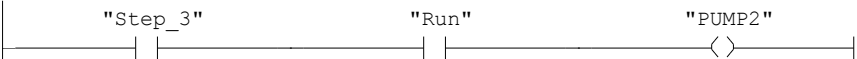
Network: 16

Pump 1 motor control, on to run Pump 1

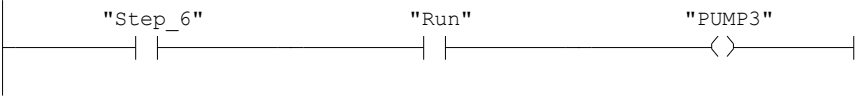


Network: 17

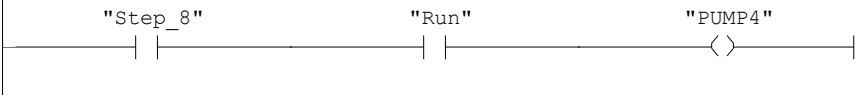
Pump 2 motor control, on to run Pump 2



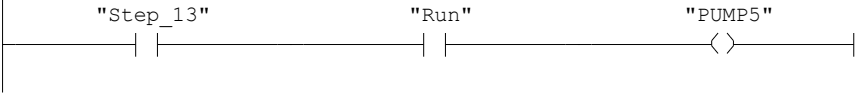
Network: 18      Pump 3 motor control, on to run Pump 3



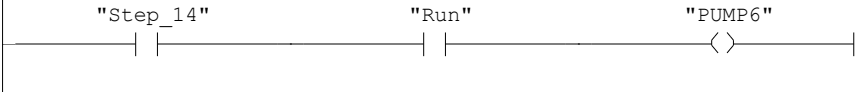
Network: 19      Pump 4 motor control, on to run Pump 4



Network: 20      Pump 5 motor control, on to run Pump 5



Network: 21      Pump 6 motor control, on to run Pump 6



Network: 22      Tank 2 heater control, on to heat tank 2

Can not turn off



Network: 23      Tank 3 stirrer motor control, on o stir Tank 3 contents

