

OB1 - <offline>

""

Name:

Author:

Time stamp Code:

Lengths (block/logic/data):

Family:

Version: 0.1

Block version: 2

12/27/2015 07:02:24 AM

02/15/1996 04:51:12 PM

00374 00230 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)"

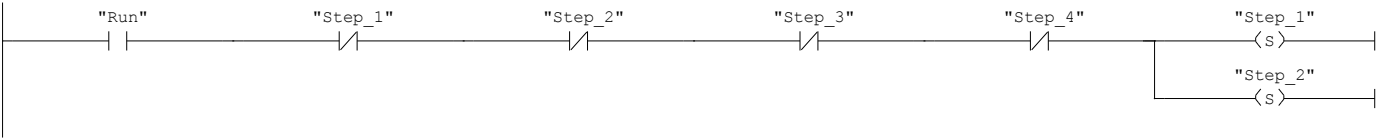
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Problem SP6-17 Revised Parts Transfer Station Control

Additional internal memory:

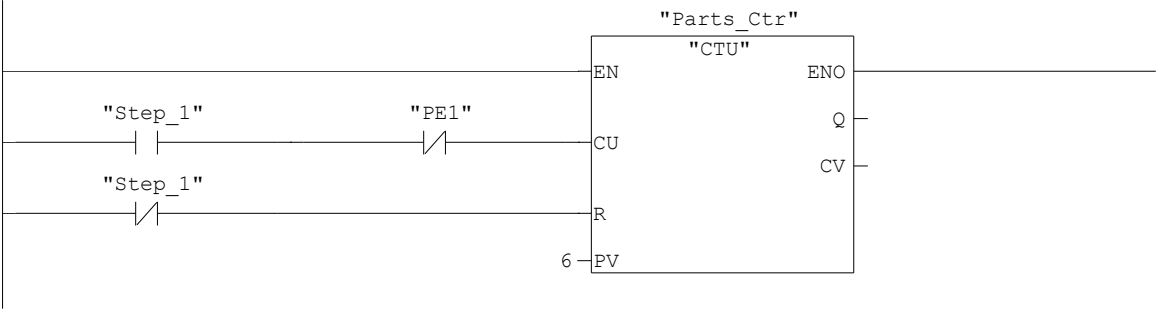
| | | | |
|------------------|--------------|------|-----------------------------|
| Symbol | Address | | |
| Run | M3.1 | BOOL | On while station running |
| Step_1 to Step_4 | M0.1 to M0.4 | BOOL | Step-in-progress bits |
| Motor1_Tmr | DB1 | SFB4 | Times rotation of table |
| Parts_Ctr | DB2 | SFB0 | Counts parts going to table |

Network: 1 Initial start



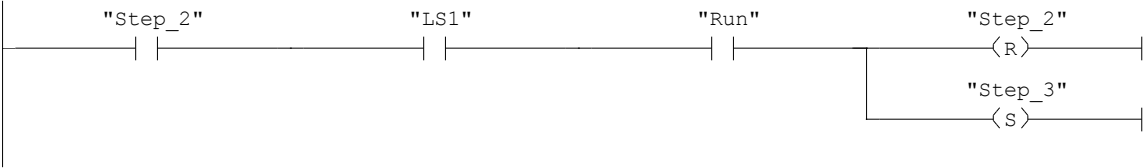
Network: 2

Step 1 Count parts



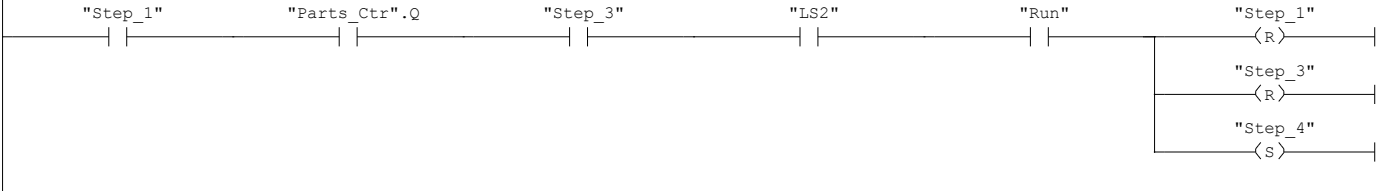
Network: 3

Step 2 Extend Ram



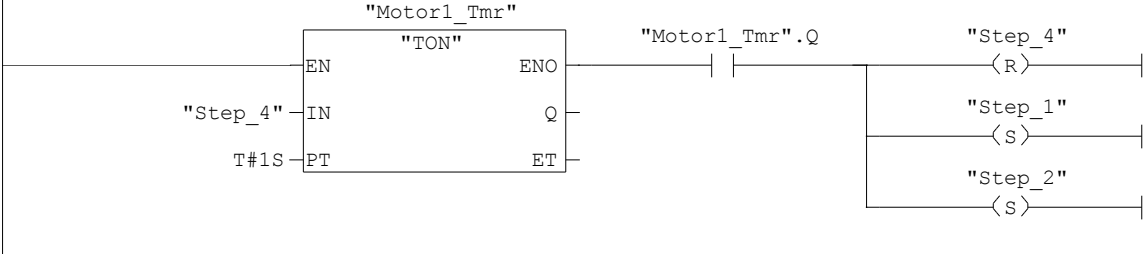
Network: 4

Transition out of Step 1, Count Parts, and Step 3, Retract Ram



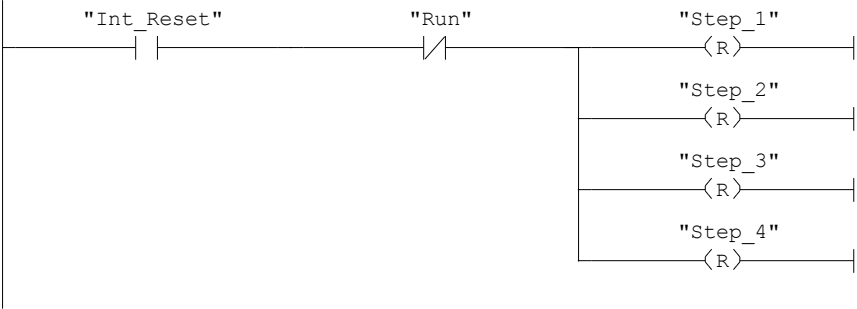
Network: 5

Step 4 Rotate table



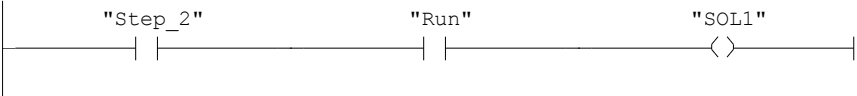
Network: 6

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

