

OB1 - <offline>

""

Name:

Family:

Author:Version: 0.1

Block version: 2

Time stamp Code:01/01/2016 06:34:08 PM

Interface:02/15/1996 04:51:12 PM

Lengths (block/logic/data): 00900 00736 00030

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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SP7-8 Stamping Station Control

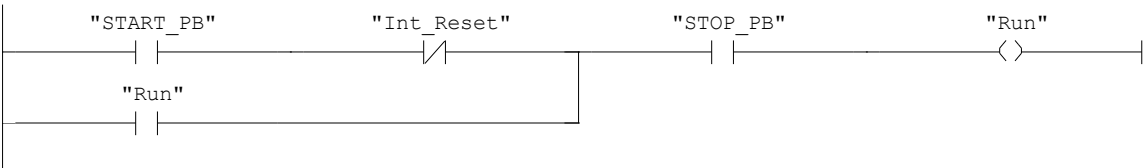
Additional internal memory:

Symbol	Address		
Run	M5.0	BOOL	On while station running
Int_Reset	M5.1	BOOL	Internal reset
Step_1 to Step_8	M0.1 to M1.0	BOOL	Step-in-progress bits
Ram_Up_Tmr	DB4	SFB4	Times raising of stamp head
Ram_Up_Tic_Ctr	DB7	SFB0	Counter for retentive timer
Retract_Tmr	DB1	SFB4	Times retract of PCYL2
Rst_Tmr	DB3	SFB4	Times raising of stamp head when
reset			
TmpDI	MD120	DINT	Temporary double integer
TmpR	MD124	REAL	Temporary real
Ret_Val	MW12	WORD	Return value from SCALE block
Always_Off	M10.0	BOOL	Always off bit for SCALE block

Conversion formula:

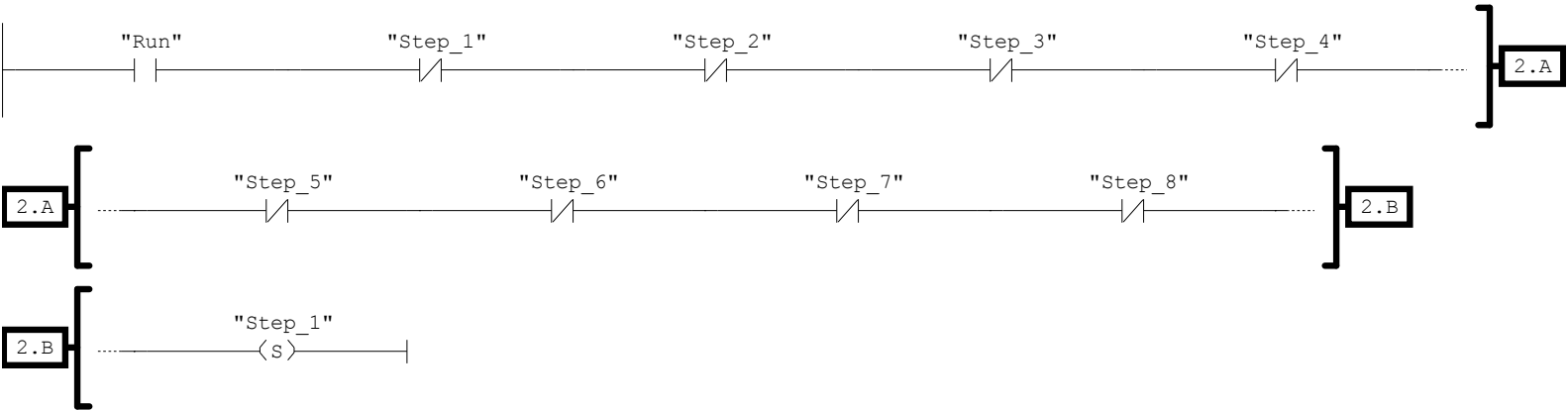
PT214_VAL = (PT214_MEAS-5530)/22118.0) * (3000.0) + 2000.0

Network: 1Start/stop



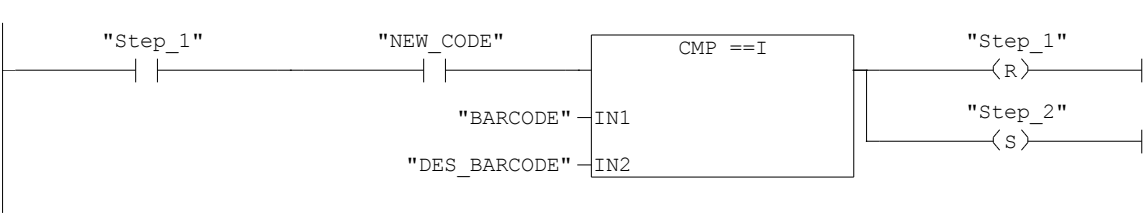
Network: 2

Initial Start



Network: 3

Step 1 Wait for correct code



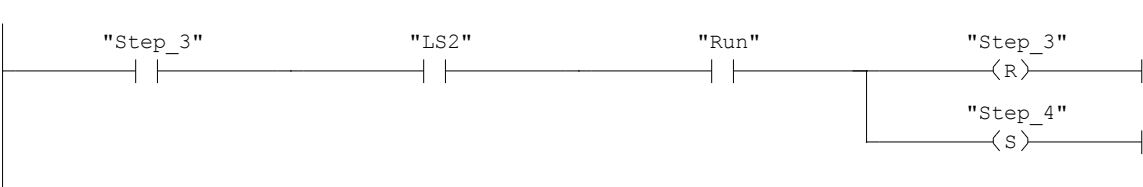
Network: 4

Step 2 Wait for piece in position



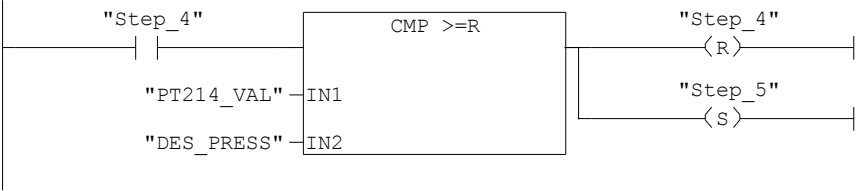
Network: 5

Step 3 Push piece in



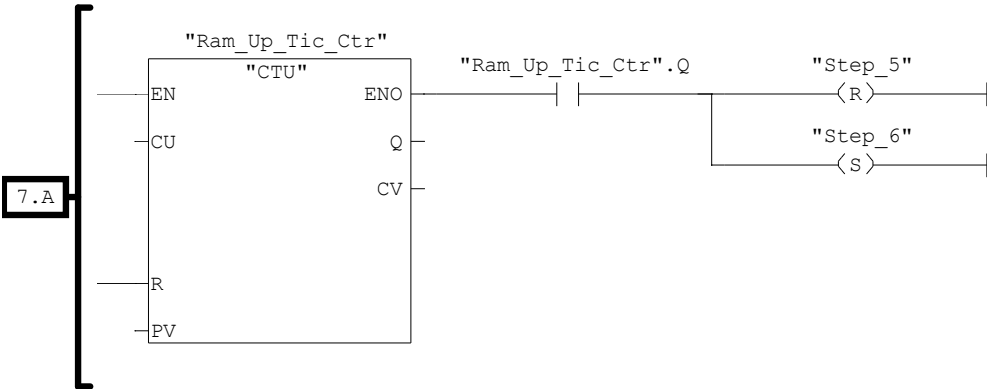
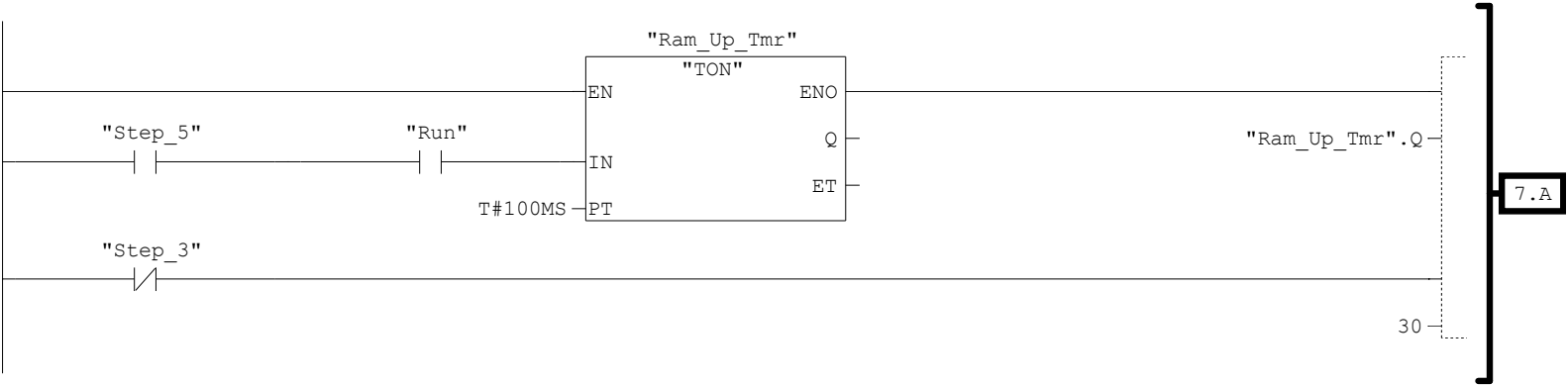
Network: 6

Step 4 - Stamp part



Network: 7

Step 5 Move stamp up, retentive timer



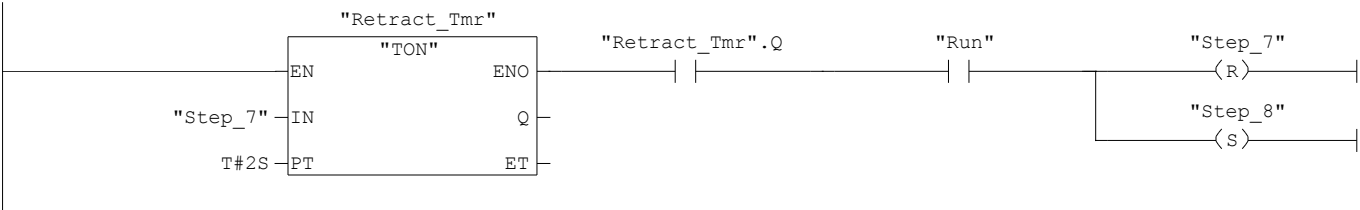
Network: 8

Step 6 - Push to conveyor



Network: 9

Step 7 Retract PCYL2



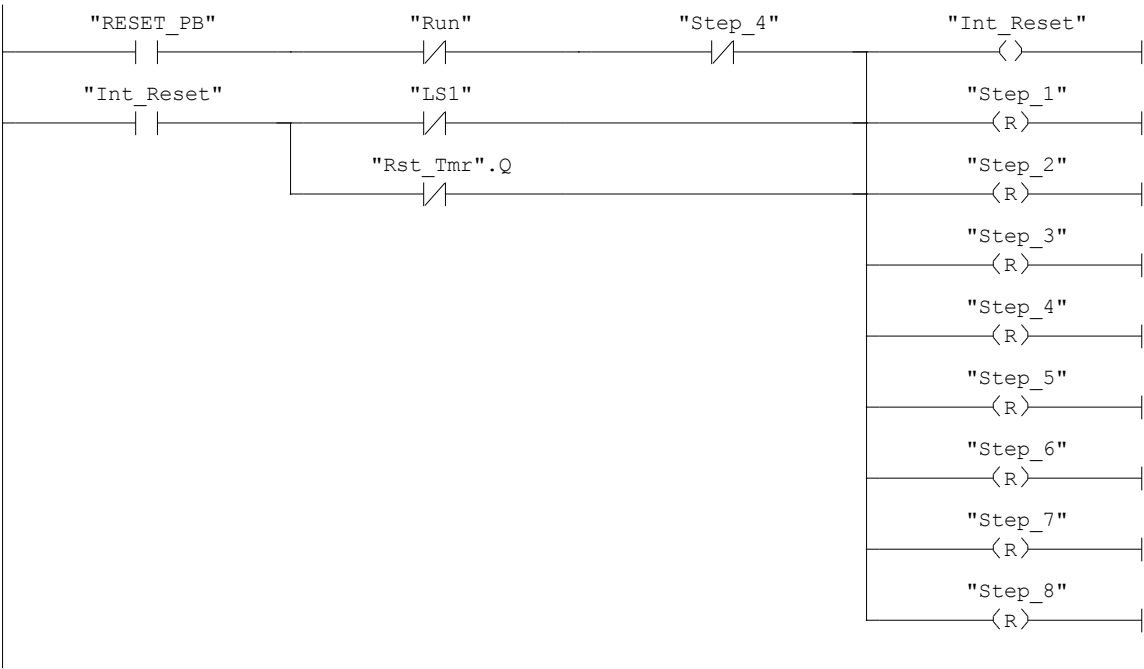
Network: 10

Step 8 Move Out



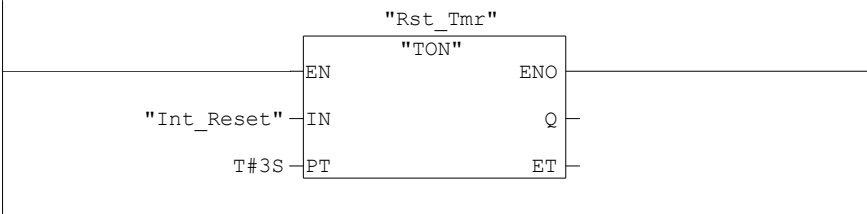
Network: 11

Reset



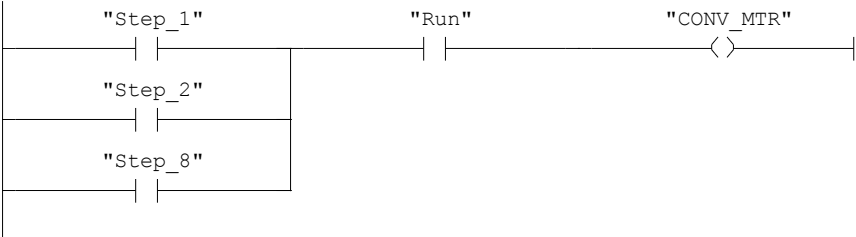
Network: 12

Timer for raising stamp when reset



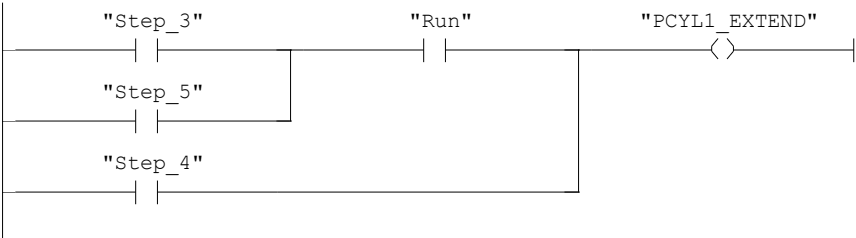
Network: 13

Conveyor control



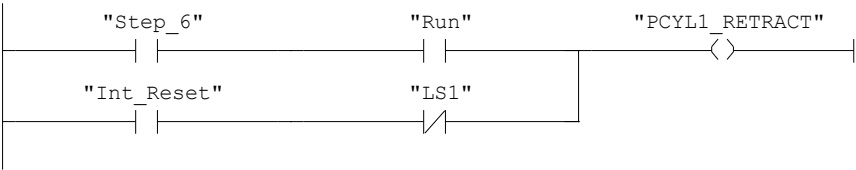
Network: 14

PCYL controls



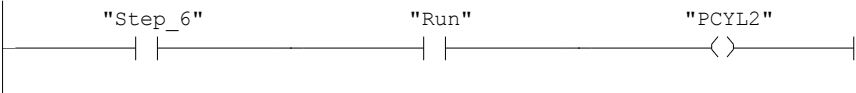
Network: 15

PCYL1 retract ram control



Network: 16

PCYL2 ram control



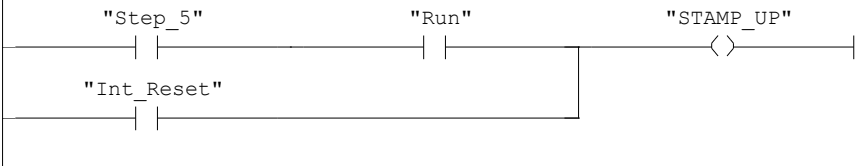
Network: 17

Stamp control



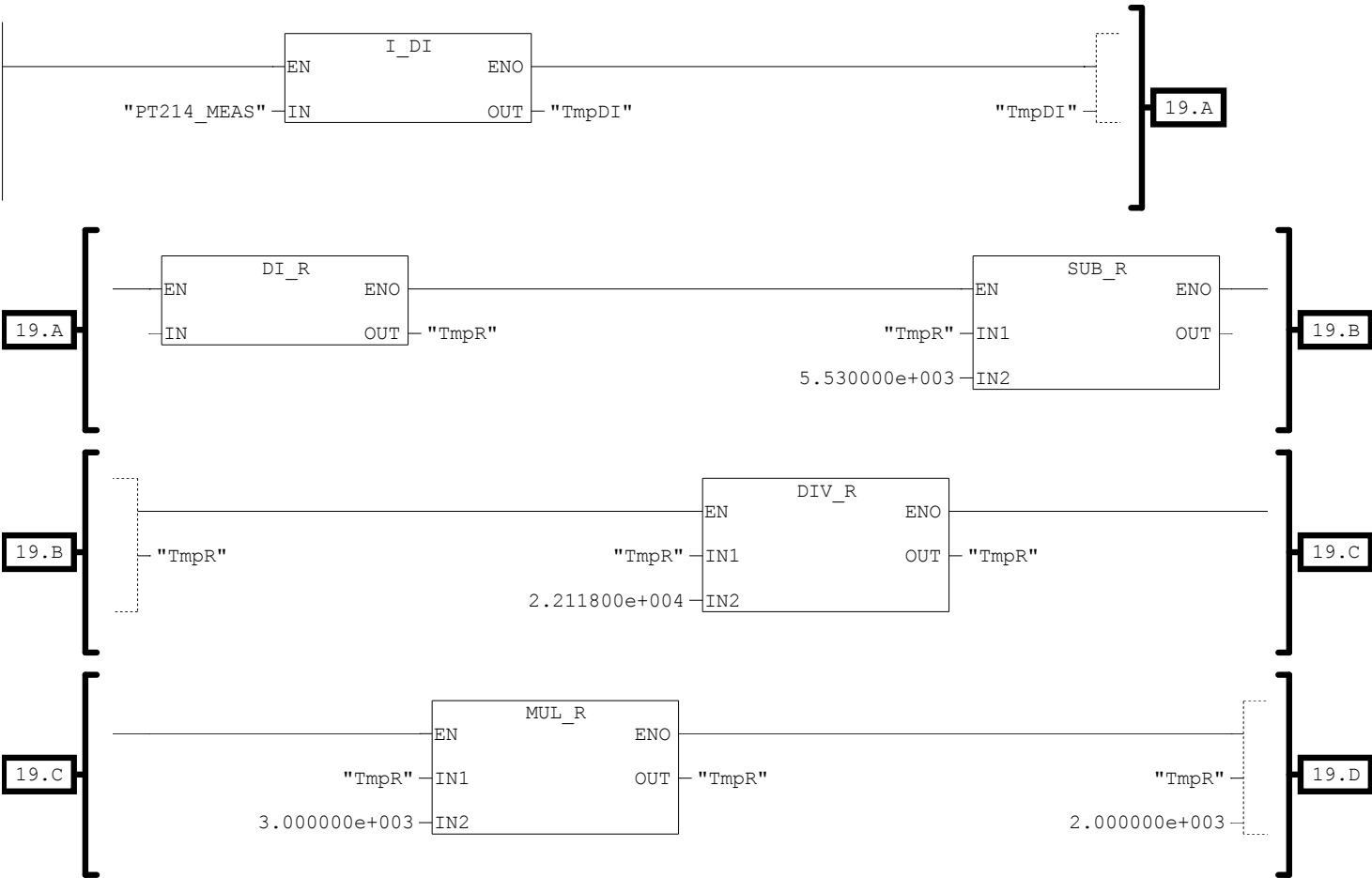
Network: 18

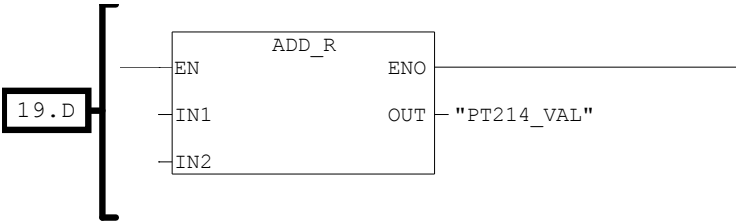
On to move stamp ram up



Network: 19

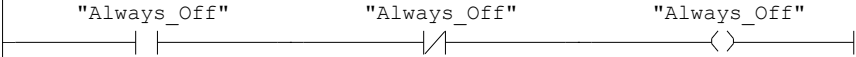
Convert pressure measurement to psi.
Uses individual computation blocks.





Network: 20

Always Off



Network: 21

Convert pressure measurement to psi.
Uses SCALE block. Note that the lo_lim input is 25% lower than zero weight to
account for this block assuming the minimum value of the analog in is zero
rather than the 5530 (which corresponds to 4 mA).

