

OB1 - <offline>

""

Name:

Author:

Time stamp Code:

Lengths (block/logic/data):

Family:

Version: 0.1

Block version: 2

12/31/2015 10:21:55 AM

02/15/1996 04:51:12 PM

00840 00674 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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SP7-9 Valve Leak Check Station Control

Additional internal memory:

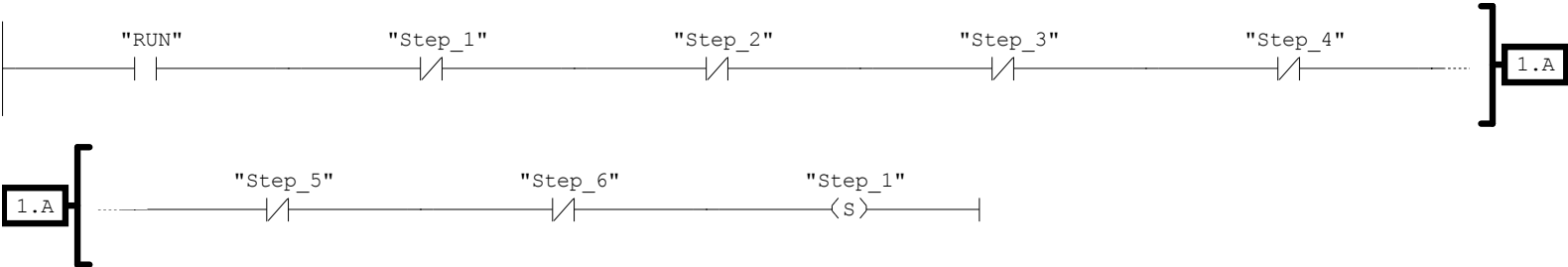
Symbol	Address		
Int_Reset	M5.1	BOOL	Internal reset
Step_1 to Step_6	M0.1 to M0.6	BOOL	Step-in-progress bits
Wait_Tmr	DB1	SFB4	Times leak test
TmpDI	MD120	DINT	Temporary double integer
TmpR	MD124	REAL	Temporary real
Ret_Val	MW12	WORD	Return value from SCALE block
Always_Off	M10.0	BOOL	Always off bit for SCALE block

Conversion formulas:

HD_HGT = (HGT_MEAS-5530)/22118.0) * (150.0-75.0) + 75.0

VLV_PRES = (PRES-5530)/22118.0) * (100.0)

Network: 1 Initial Start



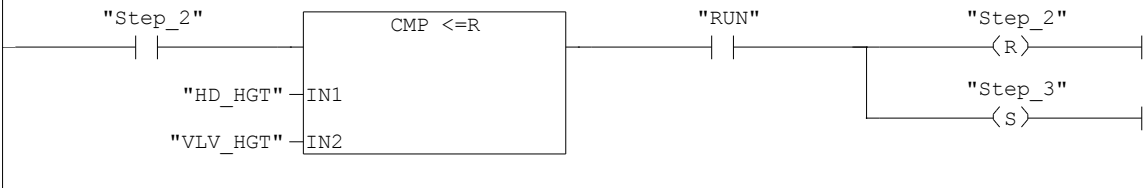
Network: 2

Step 1 Wait for valve



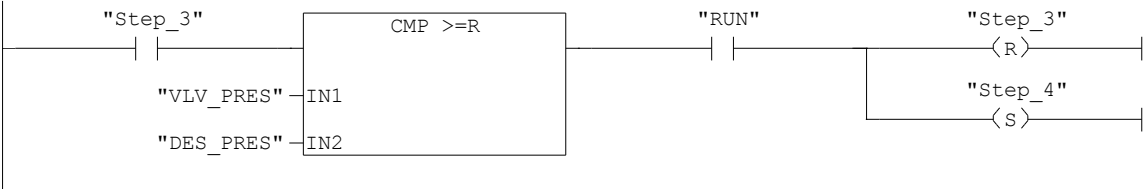
Network: 3

Step 2 Head down



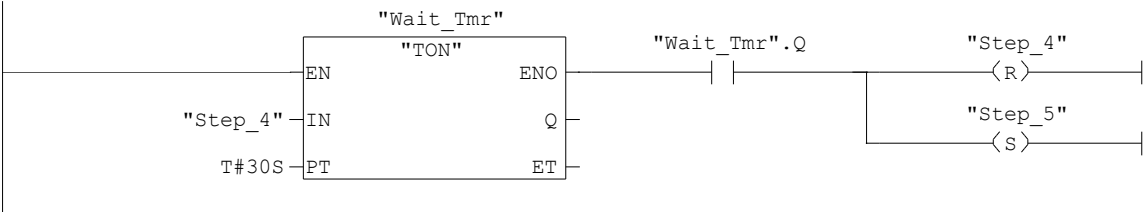
Network: 4

Step 3 Pressurize



Network: 5

Step 4 - Wait for pressure check



Network: 6

Step 5 Head up



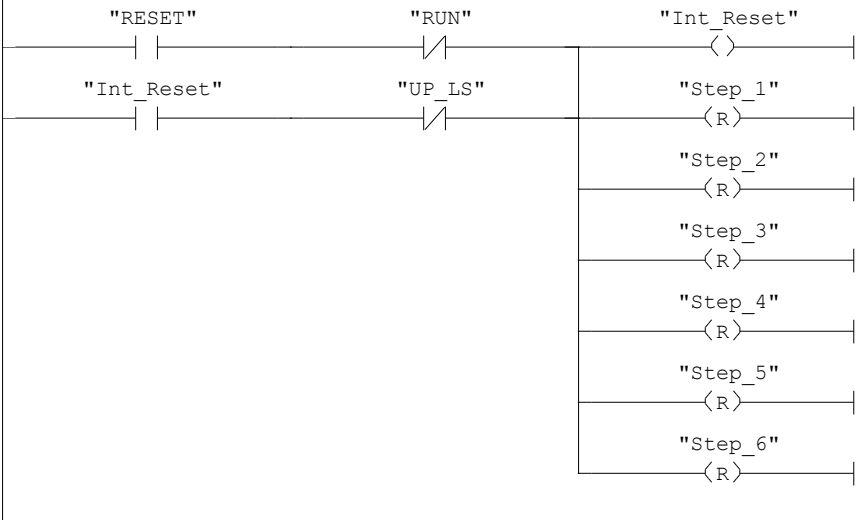
Network: 7

Step 6 - Push to conveyor



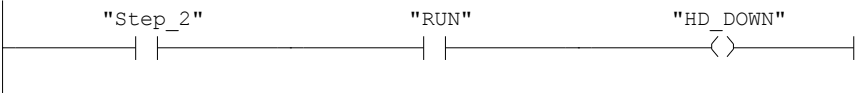
Network: 8

Reset



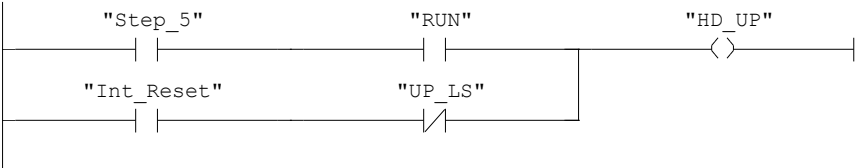
Network: 9

Head Raise/Lower



Network: 10

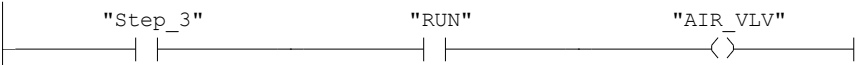
PCYL controls



Network: 11 Lift Solenoid. Must remain on when paused

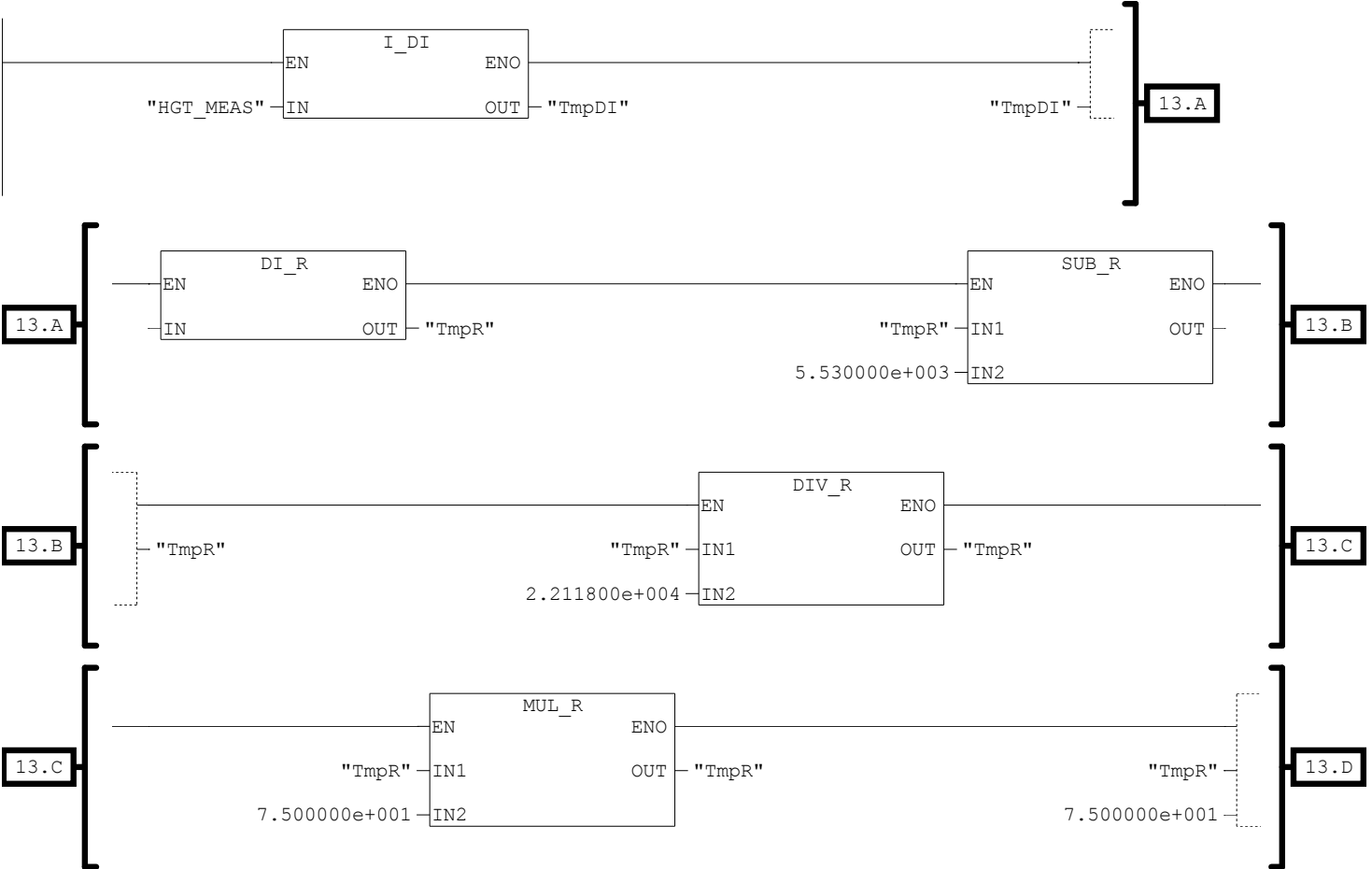


Network: 12 Air Valve



Network: 13

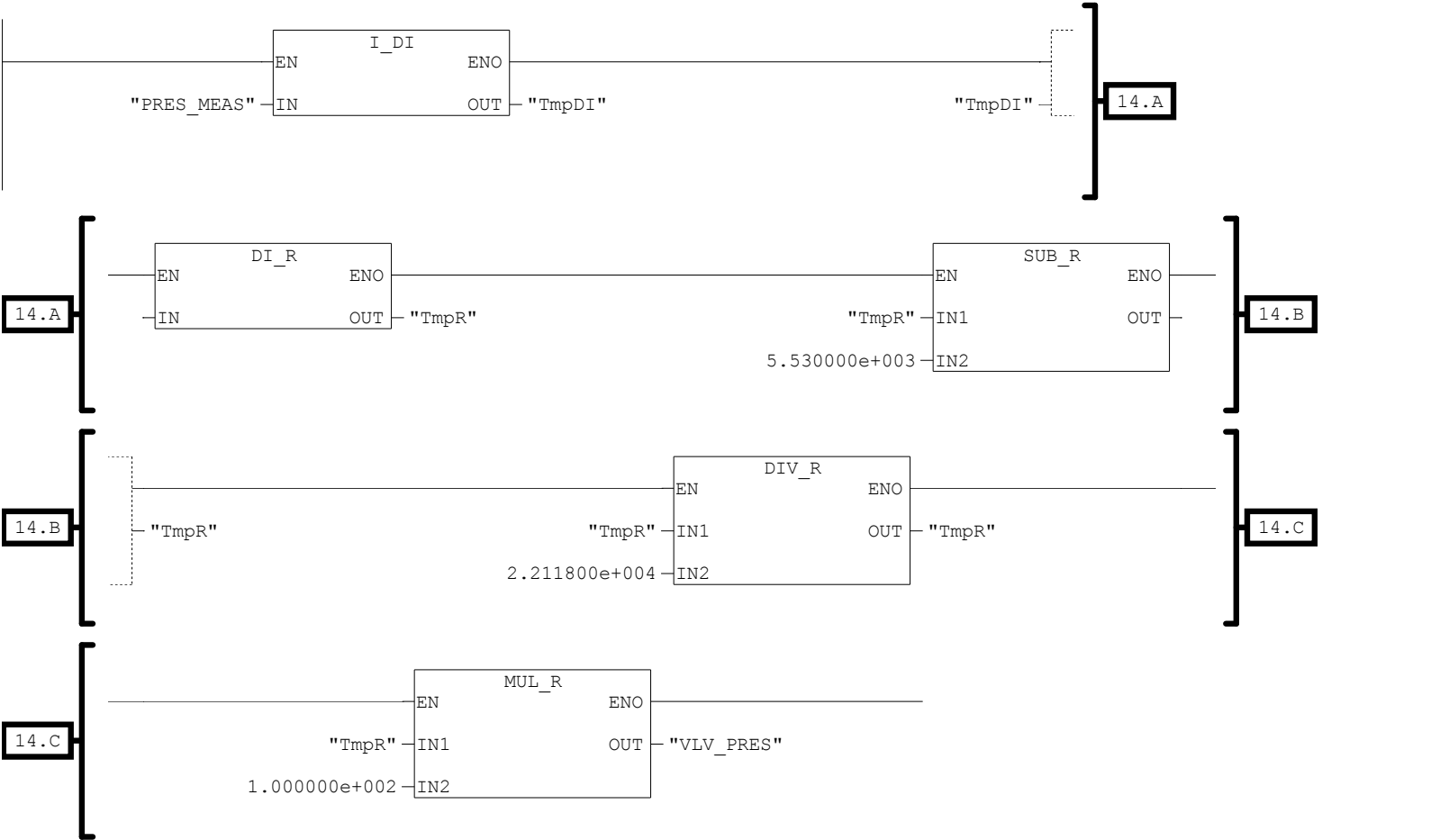
Convert height measurement to mm.
Uses individual computation blocks.





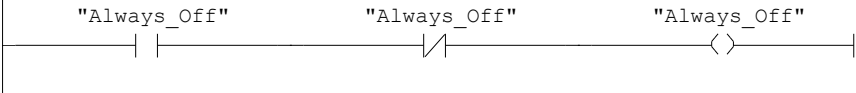
Network: 14

Convert pressure measurement to psi.
Uses individual computation blocks.



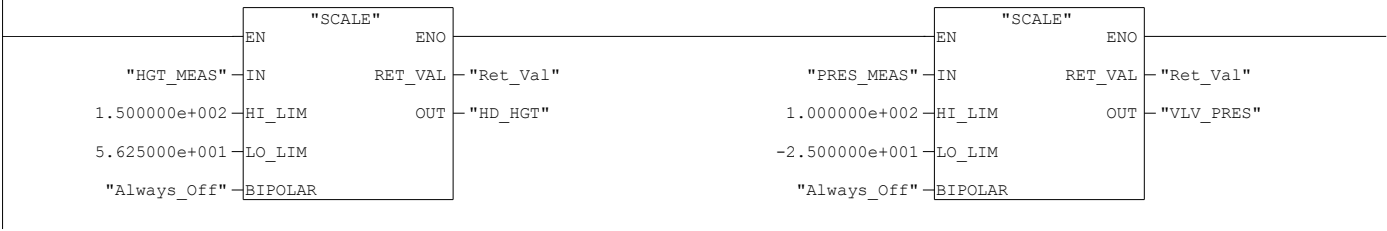
Network: 15

Always Off



Network: 16

Convert height measurement to mm and 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).



Network: 17 Set if valve is to be rejected because it will not hold pressure

Check valve pressure during step 4. If falling, set reject bit.

