

**OB1 - <offline>**  
""  
**Name:** **Family:**  
**Author:** **Version:** 0.1  
**Block version:** 2  
**Time stamp Code:** 12/27/2015 06:46:31 AM  
**Interface:** 02/15/1996 04:51:12 PM  
**Lengths (block/logic/data):** 00332 00188 00026

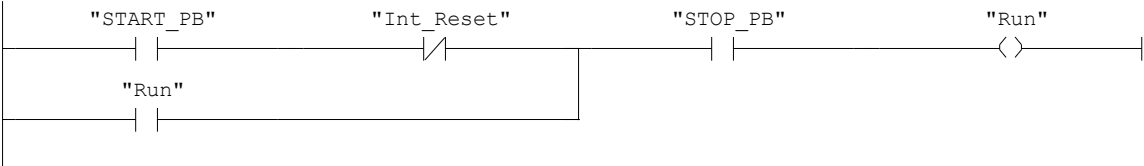
Name	Data Type	Address	Comment
TEMP		0.0	
OB1_EV_CLASS	Byte	0.0	Bits 0-3 = 1 (Coming event), Bits 4-7 = 1 (Event class 1)
OB1_SCAN_1	Byte	1.0	1 (Cold restart scan 1 of OB 1), 3 (Scan 2-n of OB 1)
OB1_PRIORITY	Byte	2.0	Priority of OB Execution
OB1_OB_NUMBR	Byte	3.0	1 (Organization block 1, OB1)
OB1_RESERVED_1	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 SP6-7 Conveyor Transfer 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\_5          M0.1 to M0.5                BOOL    2 sec delay  
Dly\_Tmr                    DB1                        SFB4

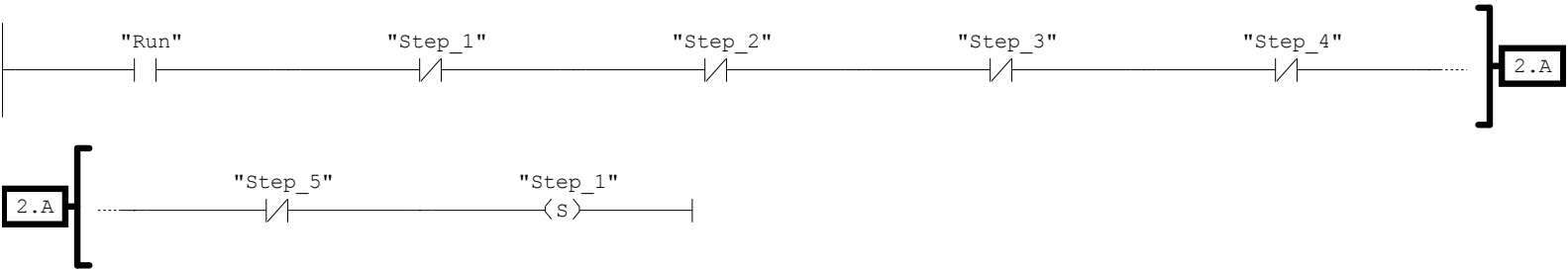
Network: 1            Start/stop

During reset prevent start



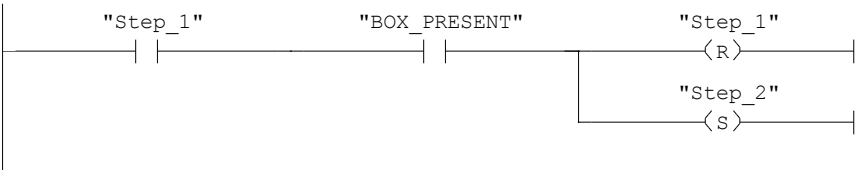
Network: 2

Initial start



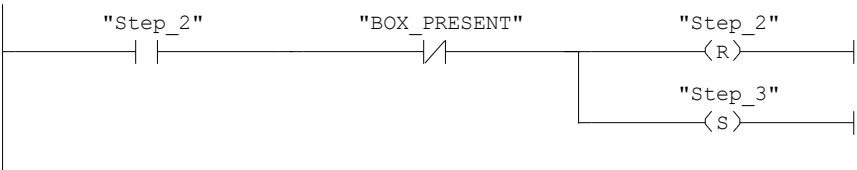
Network: 3

Step 1 Wait for box



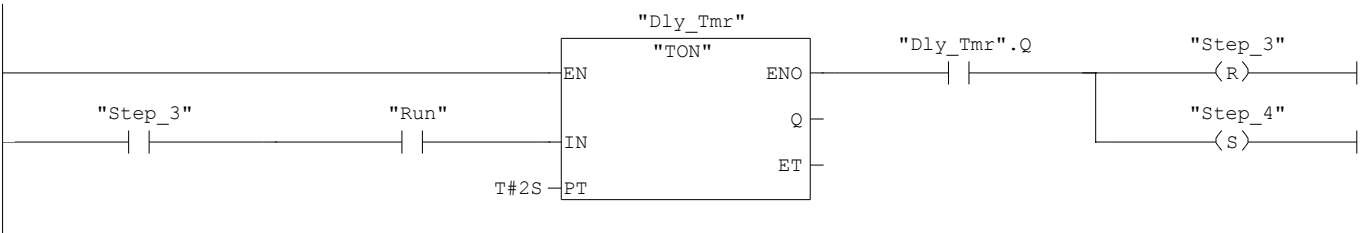
Network: 4

Step 2 Move box on



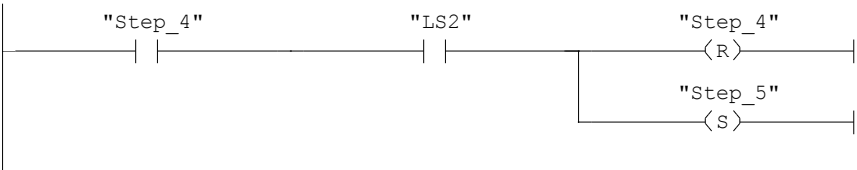
Network: 5

Step 3 Delay 2 sec. If paused, reset timer.



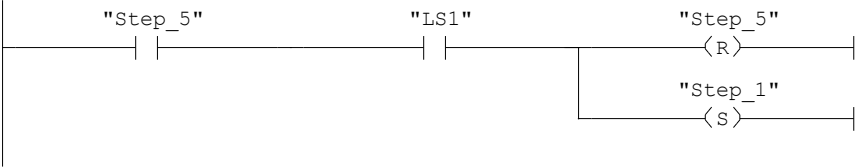
Network: 6

Step 4 Extend ram



Network: 7

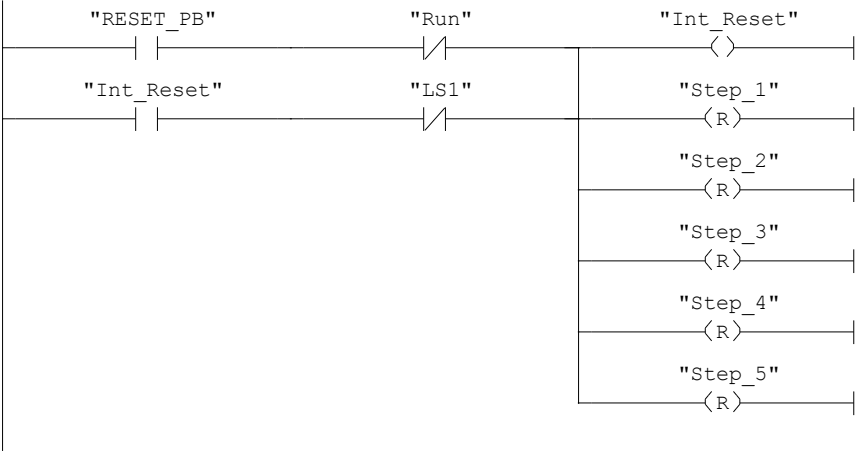
Step 5 Retract ram



Network: 8

Reset

Keep internal reset on while retracting ram.



Network: 9

Cylinder control to drop gate, on to hold down gate.

Can not turn off when paused.



Network: 10

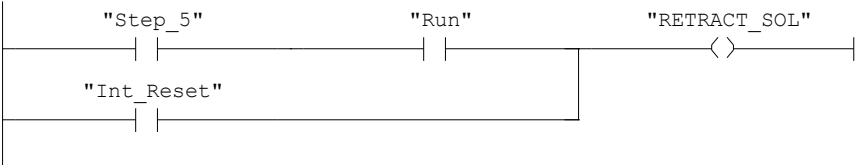
Pneumatic ram extension solenoid, on to extend ram.



Network: 11

Pneumatic ram retraction solenoid, on to retract ram.

Retract during reset.



Network: 12      Inbound conveyor control, on to move inbound conveyor

Can not pause in Step 2.



Network: 13      Outbound conveyor control, on to move outbound conveyor

