

OB1 - <offline>
"
Name: **Family:**
Author: **Version:** 0.1
Block version: 2
Time stamp Code: 12/27/2015 06:48:00 AM
Interface: 02/15/1996 04:51:12 PM
Lengths (block/logic/data): 00356 00212 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 |

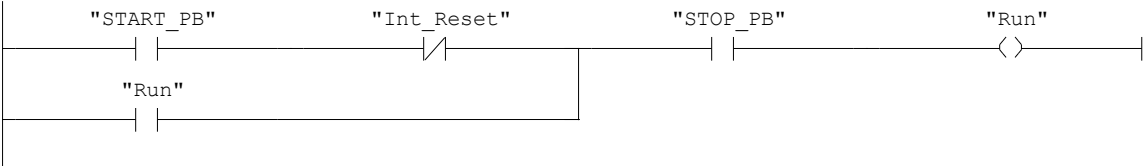
Block: OB1 **"Main Program Sweep (Cycle)"**

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Problem SP6-8 Hole Drilling Station 1 Control

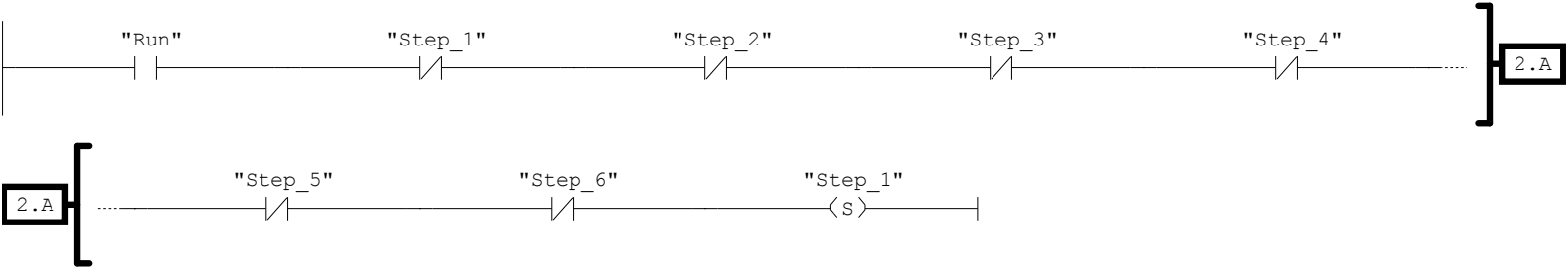
Additional internal memory:
Symbol Address BOOL On while station running
Run M5.0 BOOL Internal reset
Int_Reset M5.1 BOOL Step-in-progress bits
Step_1 to Step_6 M0.1 to M0.6 SFB4 Gate 1 timer
Gate_Tmr DB1

| | |
|----------------------------|------------|
| Network: 1 | Start/stop |
| During reset prevent start | |



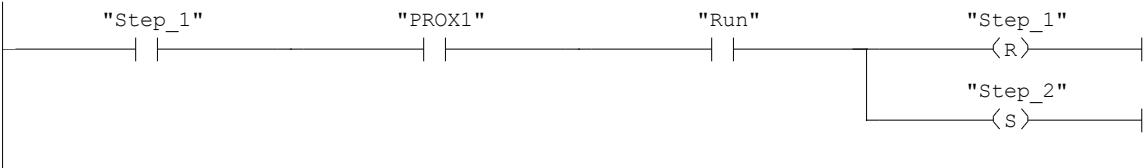
Network: 2

Initial start



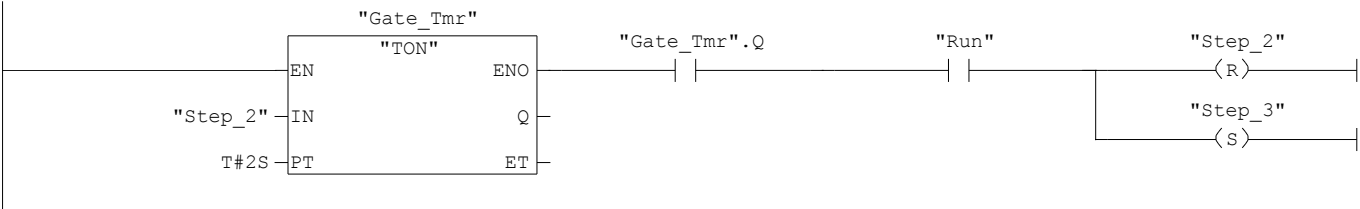
Network: 3

Step 1 Wait for part



Network: 4

Step 2 Open Gate 1



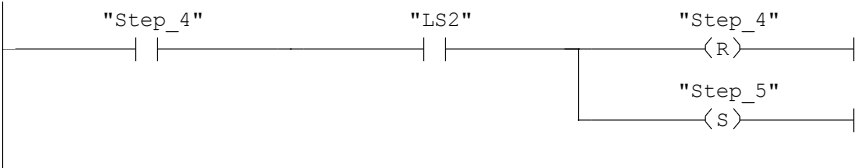
Network: 5

Step 3 Open Gate 2



Network: 6

Step 4 Extend drill



Network: 7

Step 5 Retract drill



Network: 8

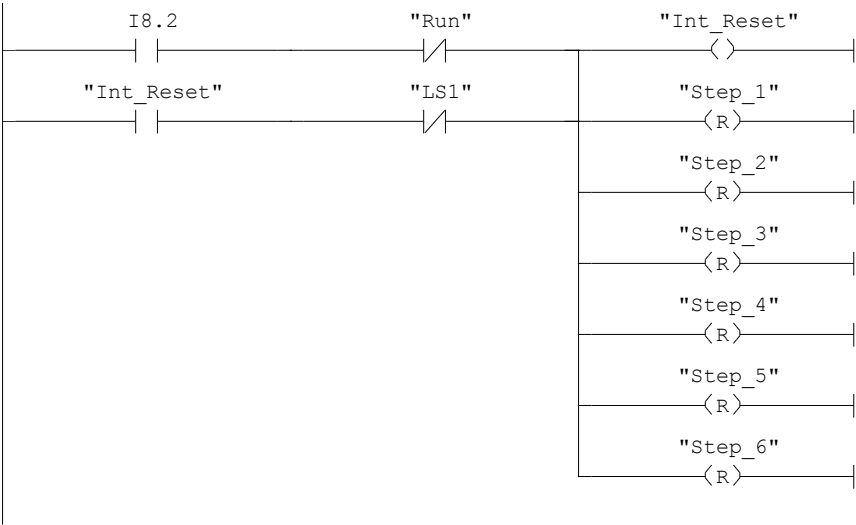
Step 6 Move out part



Network: 9

Reset

Keep internal reset on while retracting drill.



Network: 10

Gate 1 cylinder control, on to open gate 1

Can not turn off when paused.



Network: 11 Gate 2 cylinder control, on to open gate 2

Can not turn off when paused.



Network: 12 Gate 3 cylinder control, on to open gate 3

Can not turn off when paused.



Network: 13 Drill extension cylinder control, on to extend drill



Network: 14 Drill retraction cylinder control, on to retract drill



Network: 15 Drill motor control, on to cause drill to rotate

