

OB1 - <offline>
"
Name: **Family:**
Author: **Version:** 0.1
Block version: 2
Time stamp Code: 12/27/2015 06:55:56 AM
Interface: 02/15/1996 04:51:12 PM
Lengths (block/logic/data): 00618 00472 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)"**

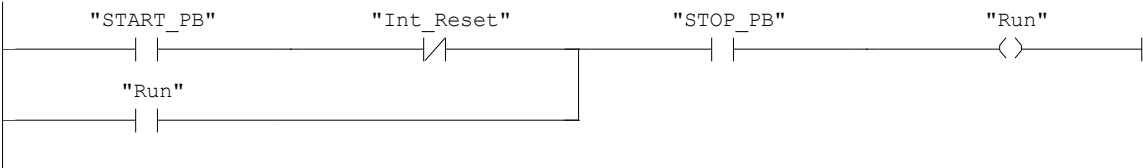
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Problem SP6-13 Erbia Can Tipper/Rotator Control

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_9 M0.1 to M1.1 SFB4 Times CYL_4 retract
Retract_Tmr DB1 SFB4 Times blend
Blend_Tmr DB3

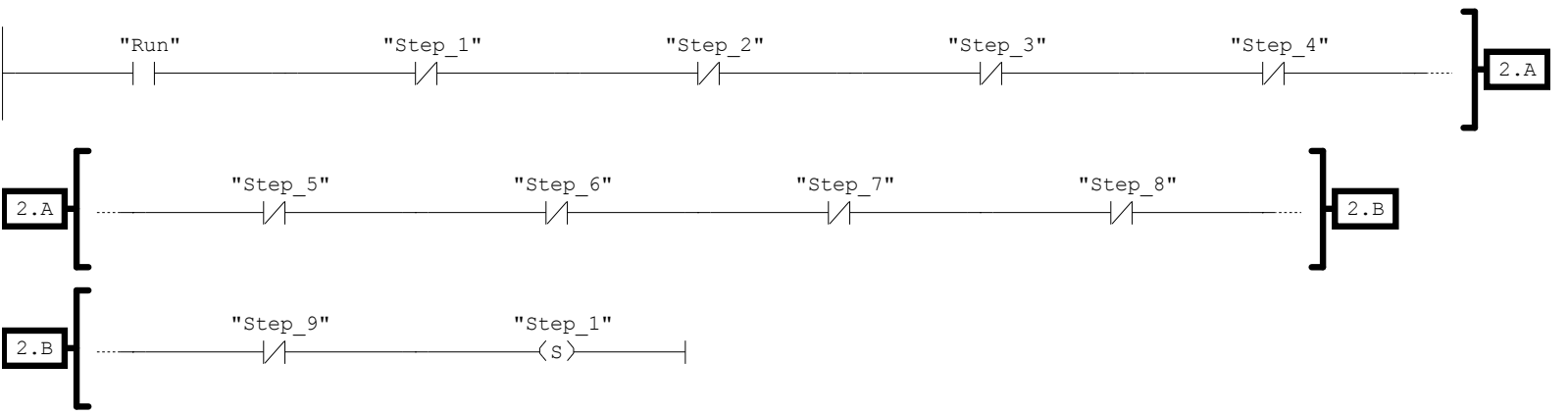
Network: 1 Start/stop

During reset prevent start



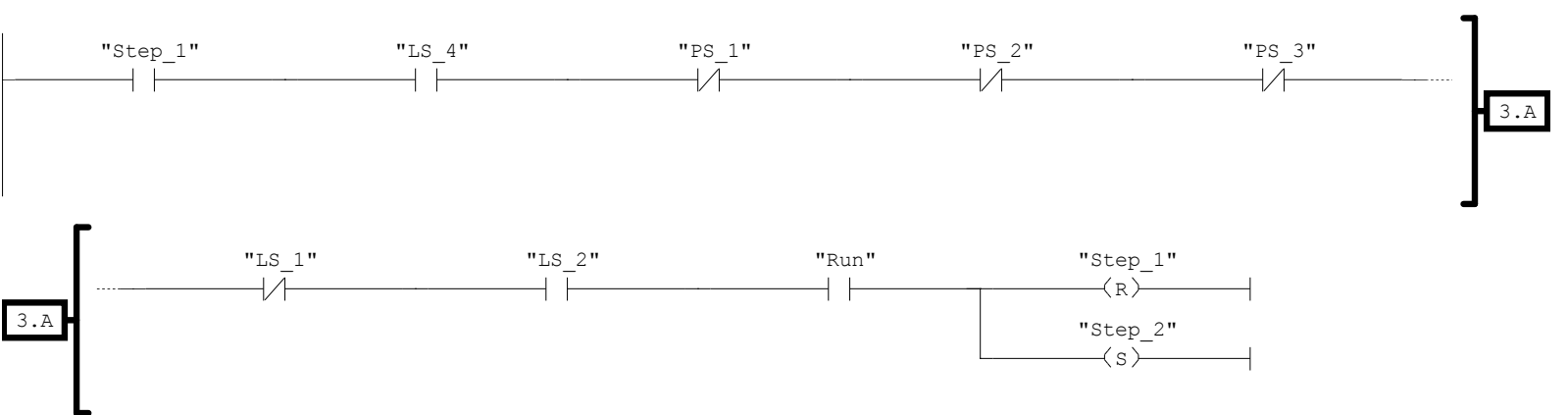
Network: 2

Initial start



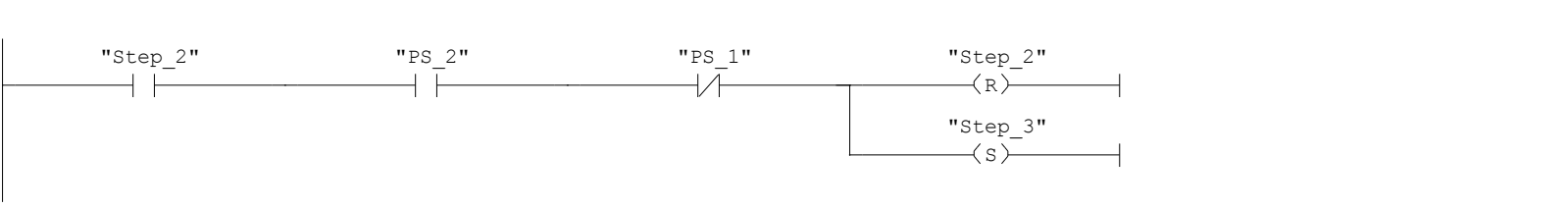
Network: 3

Step 1 Wait for can



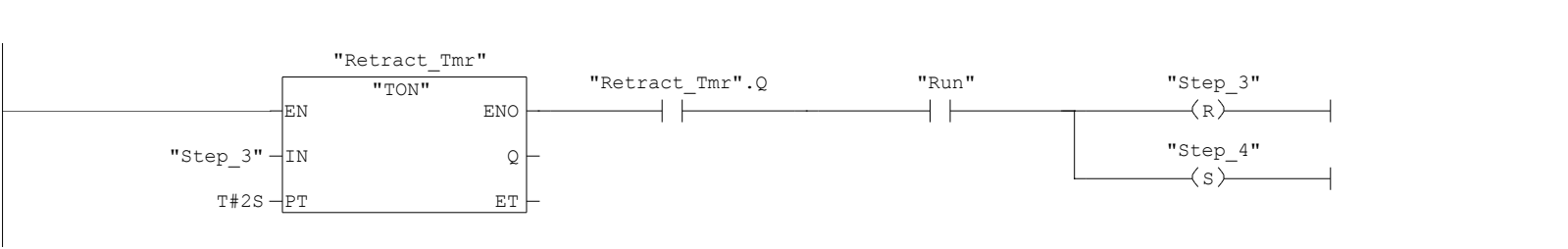
Network: 4

Step 2 Push can into tipper.



Network: 5

Step 3 Wait for CYL_4 to retract



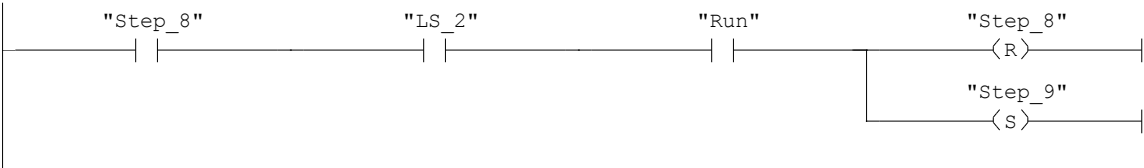
Network: 9

Step 7 Untip



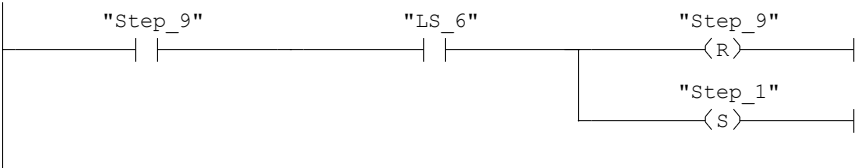
Network: 10

Step 8 Unclamp



Network: 11

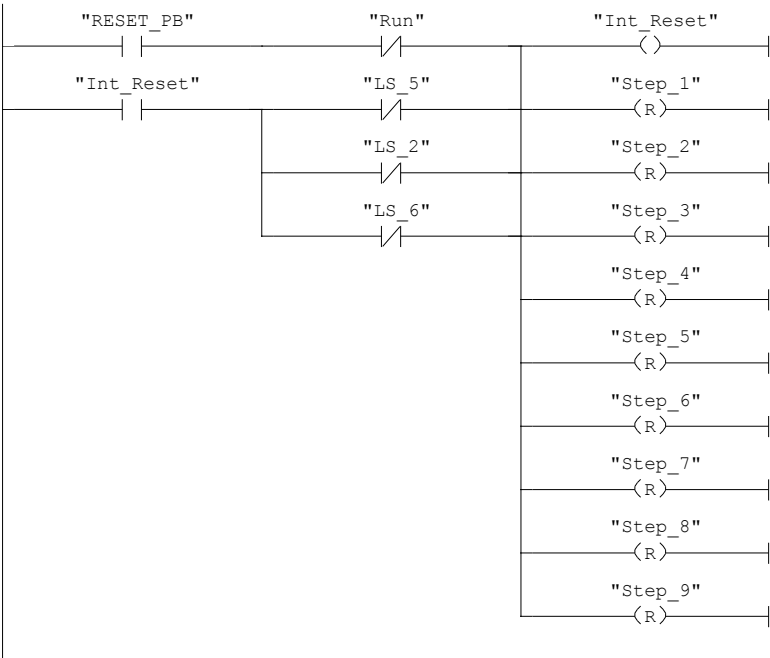
Step 9 - Push out



Network: 12

Reset

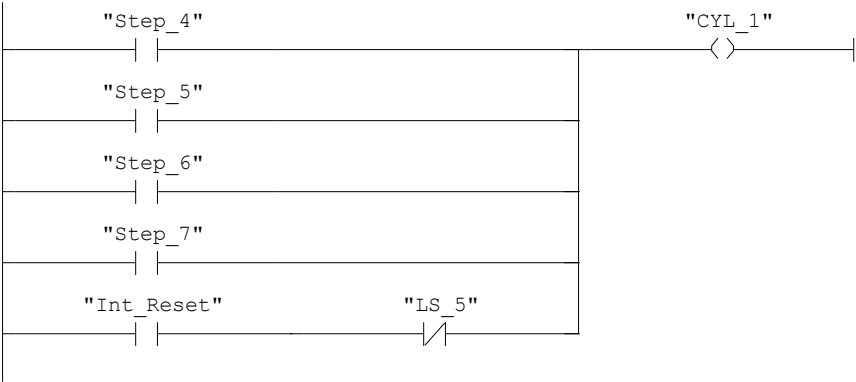
Keep internal reset on until can unclamped, vertical and out of station.



Network: 13Physical Outputs

Gate cylinder controls. Cannot turn off CYL_1 to CYL_3 when paused.

On reset, do not unclamp until vertical.

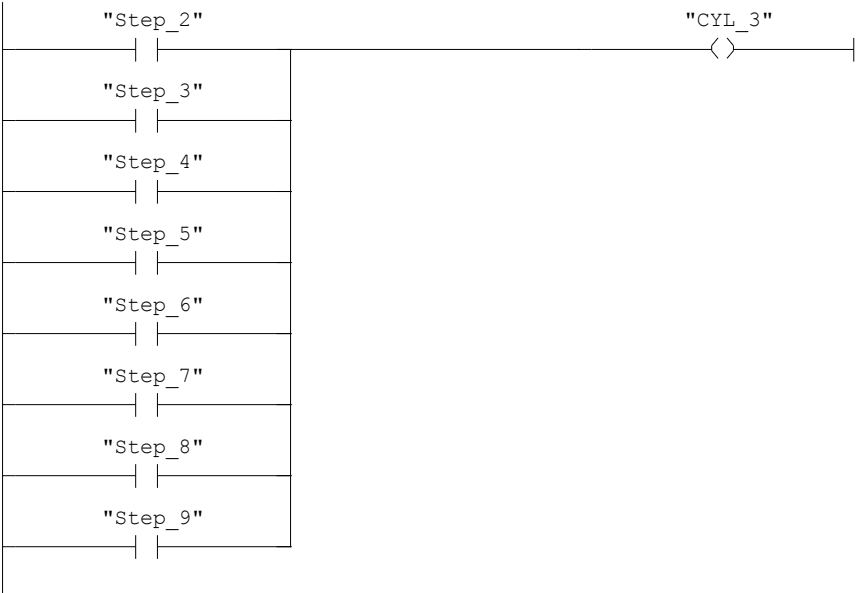


Network: 14CYL_2 control



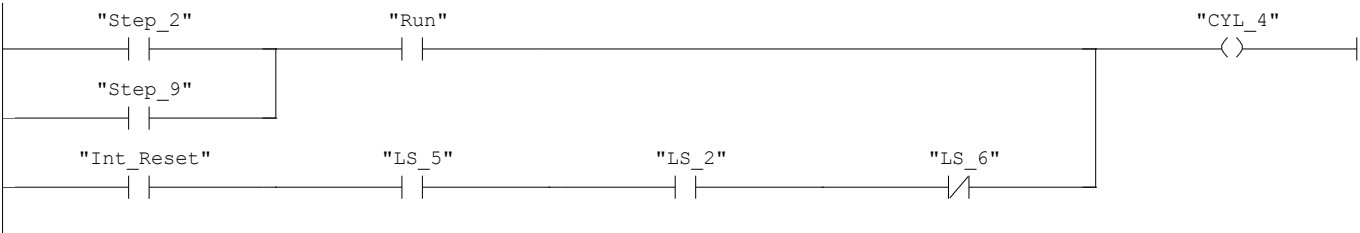
Network: 15CYL_3 control

Retract on reset



Network: 16CYL_4 control

On reset, do not push out until in vertical position and unclamped.



Network: 17Rotator motor control

Retract on reset

