

OB1 - <offline>

""

Name:

Family:

Author:Version: 0.1

Block version: 2

Time stamp Code:01/01/2016 06:18:18 PM

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

Lengths (block/logic/data): 00762 00612 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: OB1Main Program Sweep (Cycle)"

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SP7-7 Width Check Station Control

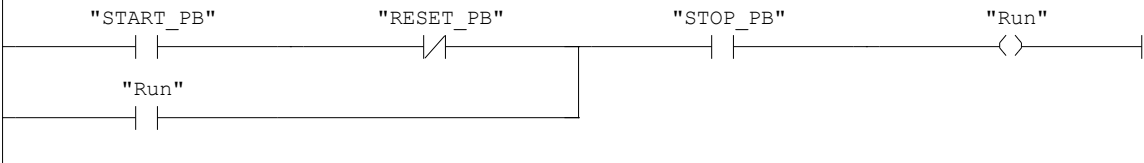
Additional internal memory:

Symbol	Address		
Run	M3.1	BOOL	On while station running
Step_1 to Step_3	M0.1 to M0.3	BOOL	Step-in-progress bits
Clamp_Tmr	DB1	SFB4	Delay for measurement to stabilize
Release_Tmr	DB3	SFB4	Tic for delay to allow parts to
move out			
Release_Ctr	DB7	SFB0	Counter part of retentive delay
to			
move out parts			
Part_Ctr	DB2	SFB0	Counts parts
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:

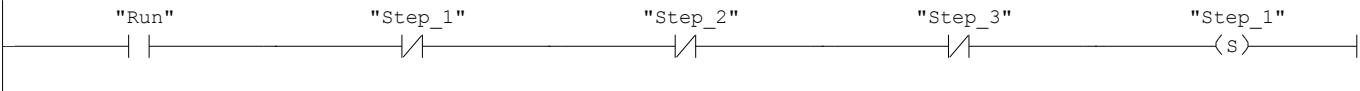
WIDTH_VAL = (WIDTH_MEAS-5530)/22118.0) * (70.0)

Network: 1Start/stop



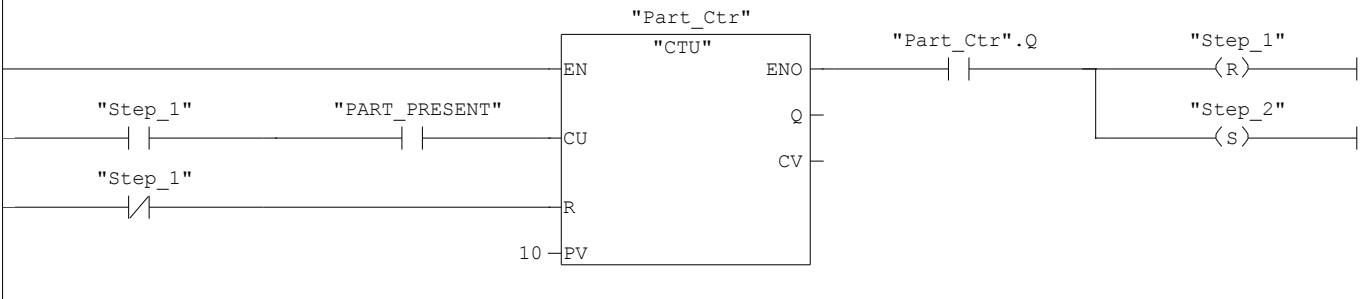
Network: 2

Initial Start



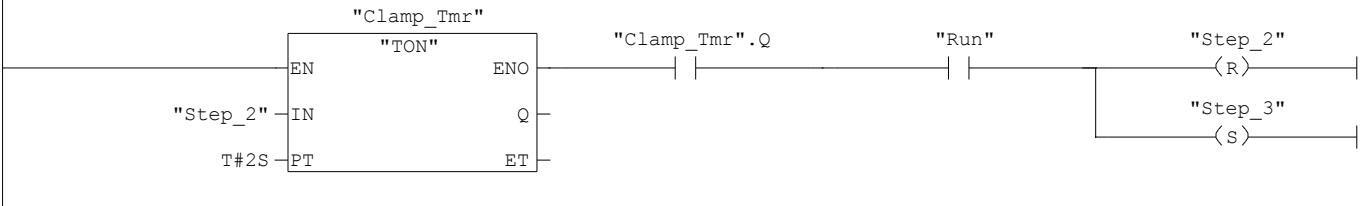
Network: 3

Step 1 Wait for tenth part

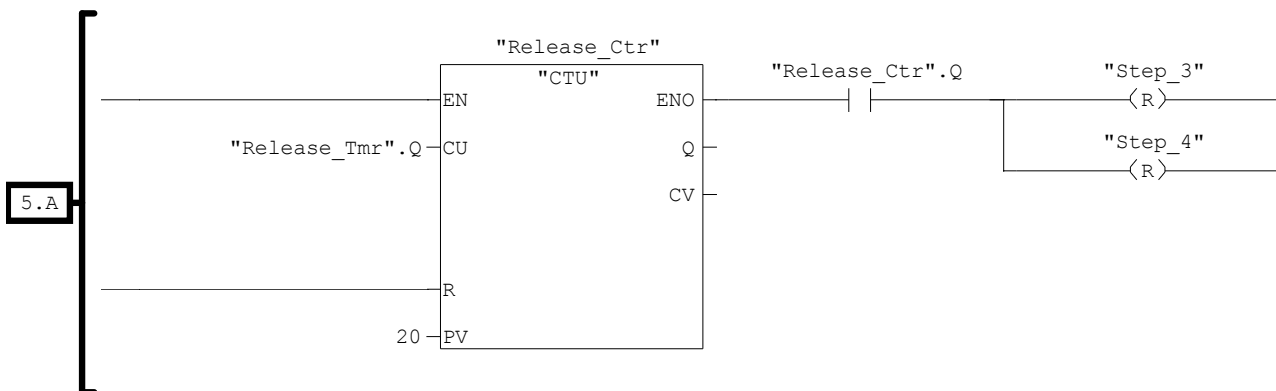
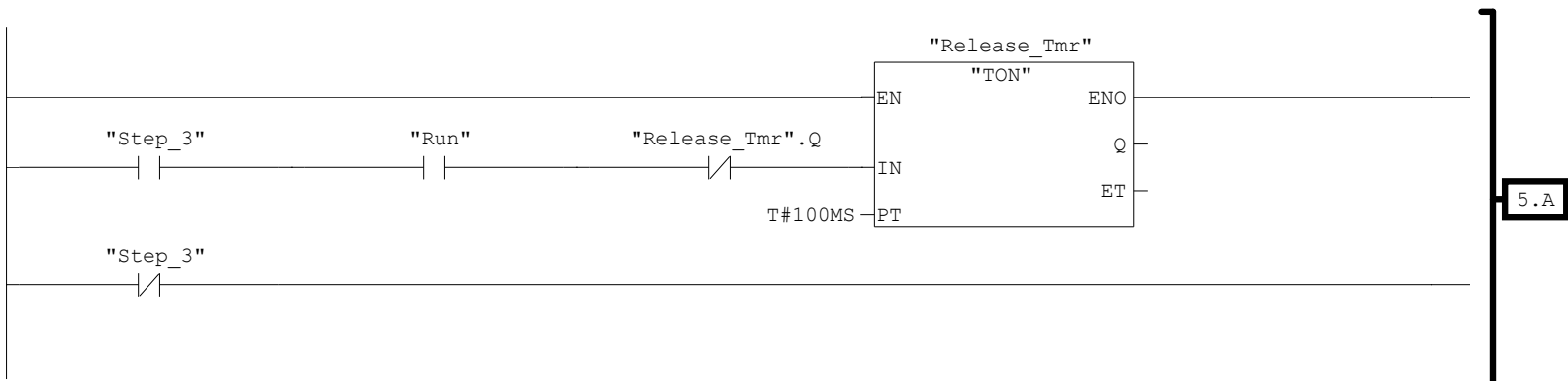


Network: 4

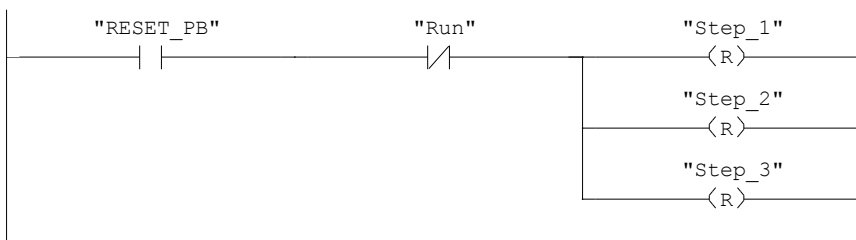
Step 2 Wait 2 sec for width to stabilize.



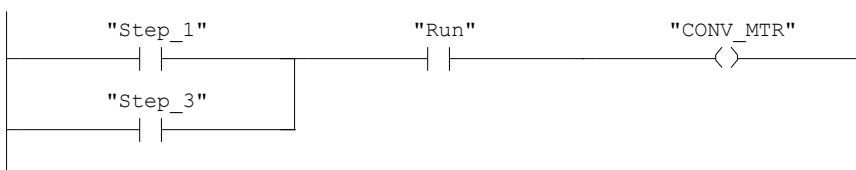
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Network: 5      Step 3 Release part and wait 2 sec
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Network: 6	Reset
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Network: 7	Conveyor control
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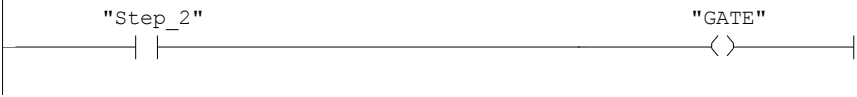
Network: 8

Clamp control



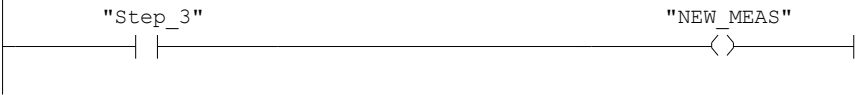
Network: 9

Gate control



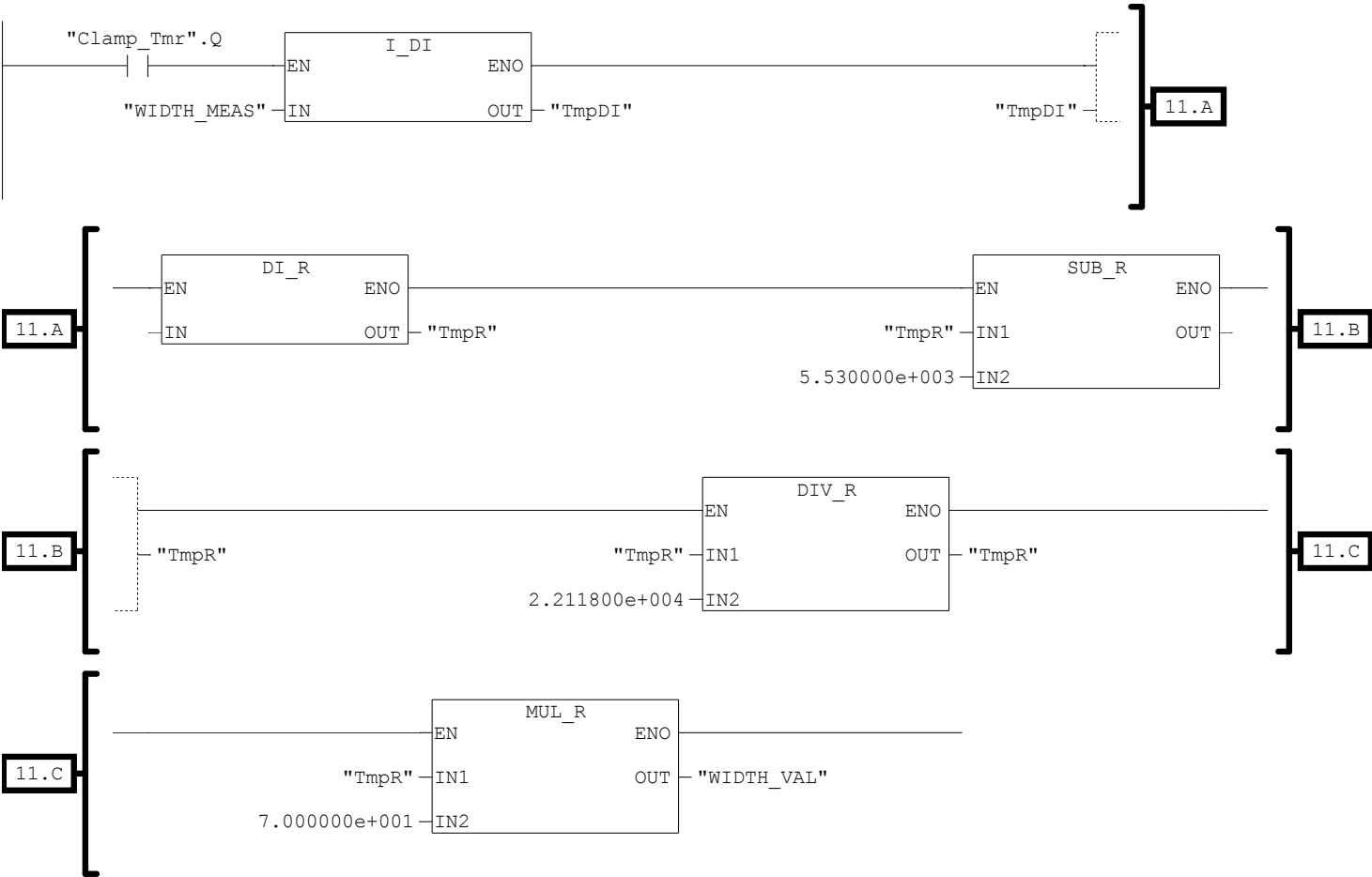
Network: 10

Coil to let other part of program know there is a new width.

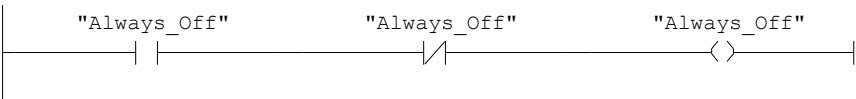


Network: 11

Convert width measurement to mm after 2 sec delay to let width settle.
Uses individual computation blocks.



Network: 12 Always Off



Network: 13

Convert width measurement to mm after 2 sec delay to let width settle..
Uses SCALE block. Note that the lo_lim input is 25% lower than zero width to
account for this block assuming the minimum value of the analog in is zero
rather than the 5530 (which corresponds to 4 mA).

