

# Main\_Program [OB1]

## Main\_Program Properties

### General

Name	Main_Program	Number	1	Type	OB
Language	LAD	Numbering	Manual		

### Information

Title	"Main Program Sweep (Cycle)"	Author		Comment	
Family		Version	0.1	User-defined ID	

Name	Data type	Default value
▼ Temp		
OB1_EV_CLASS	Byte	
OB1_SCAN_1	Byte	
OB1_PRIORITY	Byte	
OB1_OB_NUMBR	Byte	
OB1_RESERVED_1	Byte	
OB1_RESERVED_2	Byte	
OB1_PREV_CYCLE	Int	
OB1_MIN_CYCLE	Int	
OB1_MAX_CYCLE	Int	
OB1_DATE_TIME	Date_And_Time	
Constant		

## Network 1:

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Problem SP6-17 Revised Parts Transfer Station Control

Additional internal memory:

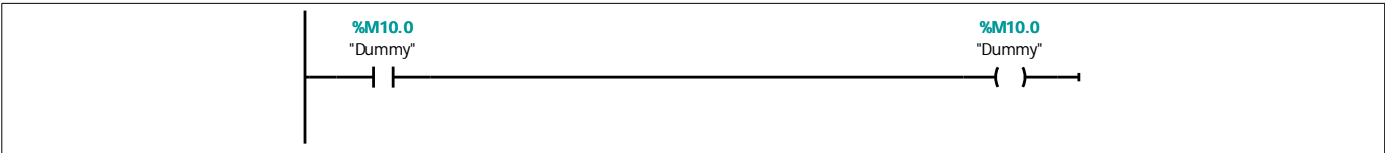
Tag Address

Run M3.1 BOOL On while station running

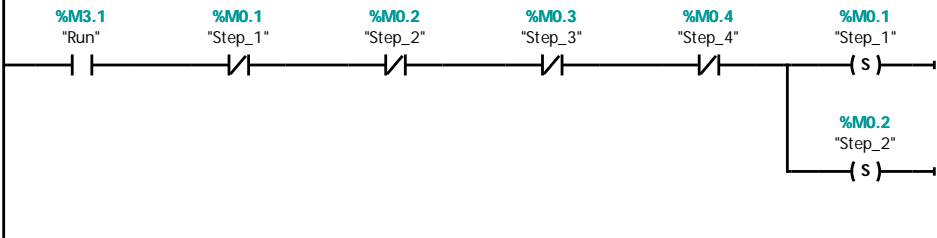
Step\_1 to Step\_4 M0.1 to M0.4 BOOL Step-in-progress bits

Motor1\_Tmr DB1 TON\_SFB Times rotation of table

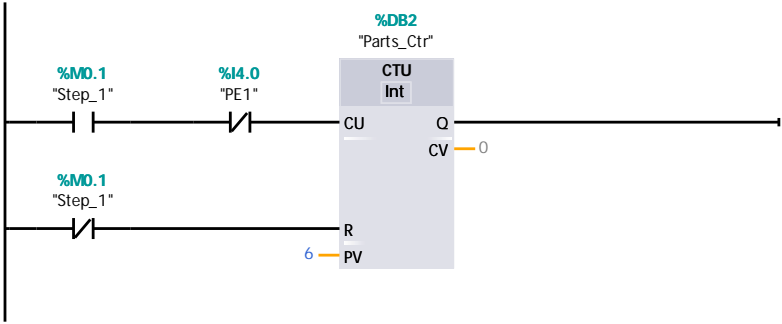
Parts\_Ctr DB2 CTU\_SFB Counts parts going to table



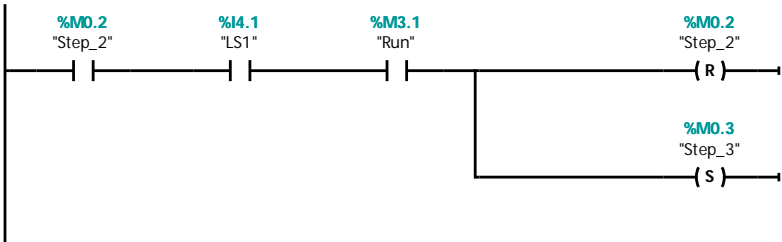
## Network 2: Initial start



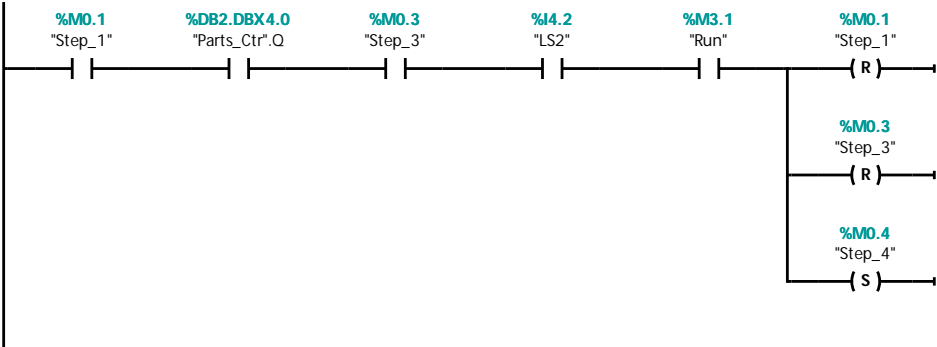
Network 3: Step 1 Count parts



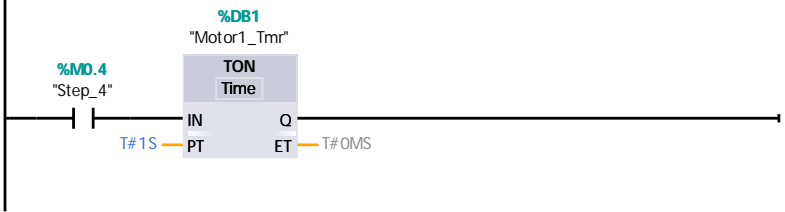
Network 4: Step 2 Extend Ram



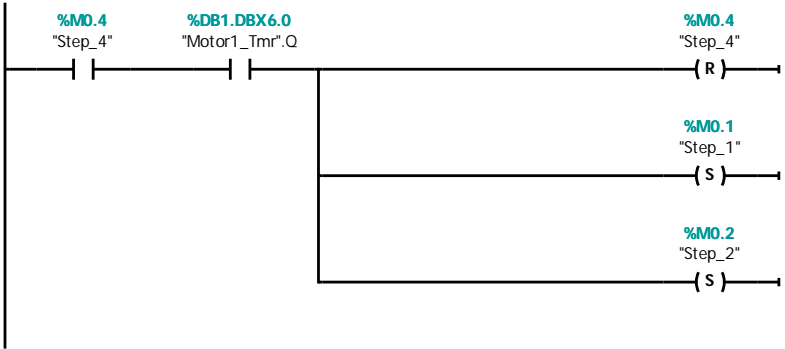
Network 5: Transition out of Step 1, Count Parts, and Step 3, Retract Ram



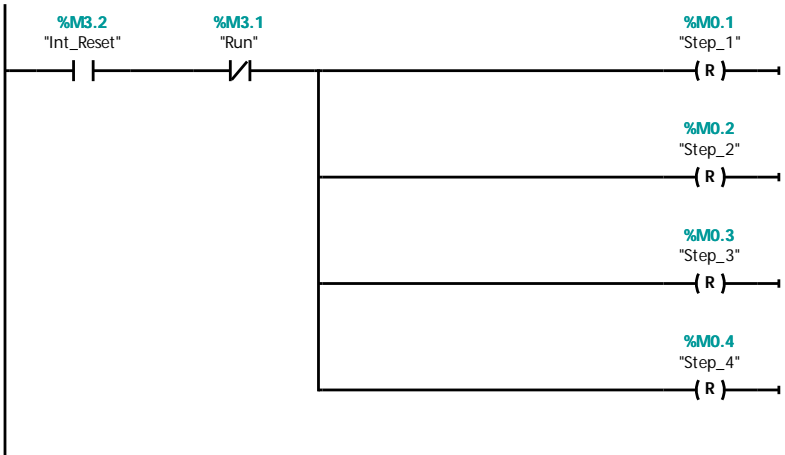
Network 6:



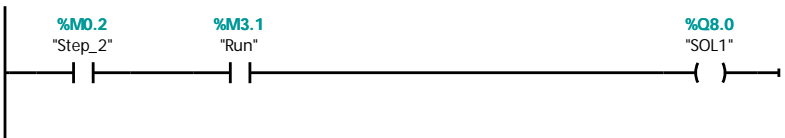
Network 7: Step 4 Rotate table



Network 8: Reset



Network 9: Pneumatic ram extension solenoid control, on to extend ram



Network 10: Turntable motor control, on to turn turntable

%M0.4  
"Step\_4"

%Q8.1  
"MOTOR1"



**Network 11: Belt conveyor motor control, on to run conveyor**

%M0.1  
"Step\_1"

%M3.1  
"Run"

%Q8.2  
"MOTOR2"

