

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: SP6-2

Copyright (c) 2011, 2015 Dogwood Valley Press, LLC

SP6-2 Batch Process Control

Additional internal memory:

Tag Address

Run M5.0 BOOL On while station running

Int_Override M5.1 BOOL Reset and empty tank

Step_1 to Step_7 M0.1 to M0.7 BOOL Step-in-progress bits

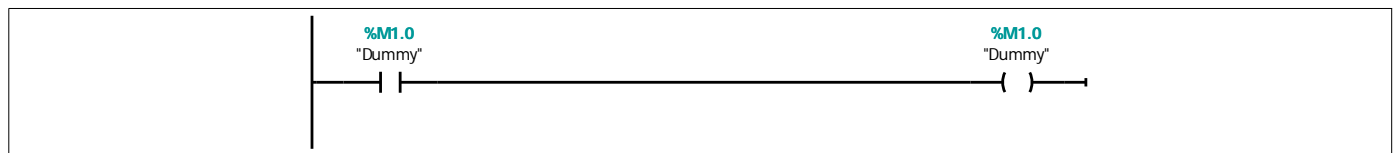
WaitA_Tmr DB3 TON_SFB Times wait after filling A

WaitB_Tmr DB4 TON_SFB Times wait after filling B

Stir_Tmr DB5 TON_SFB Times stirring

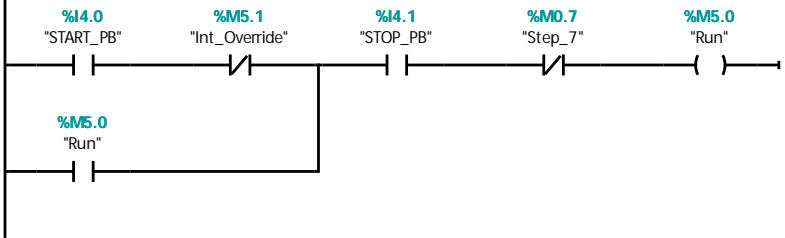
Empty_Tmr DB6 TON_SFB Used to determine when empty

Override_Tmr DB1 TON_SFB Times emptying when override

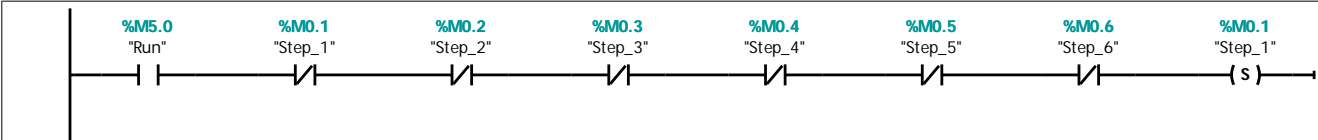


Network 2: Start/stop

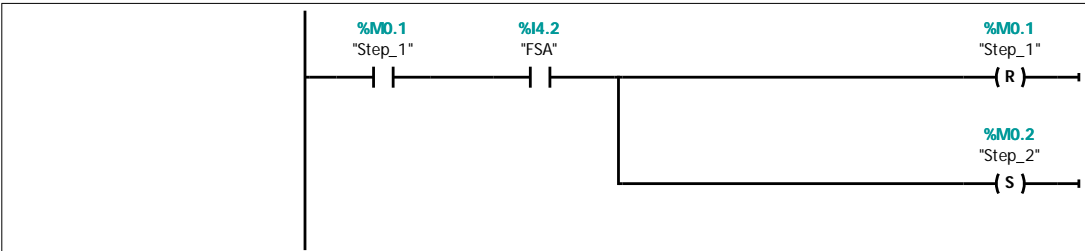
During override prevent start



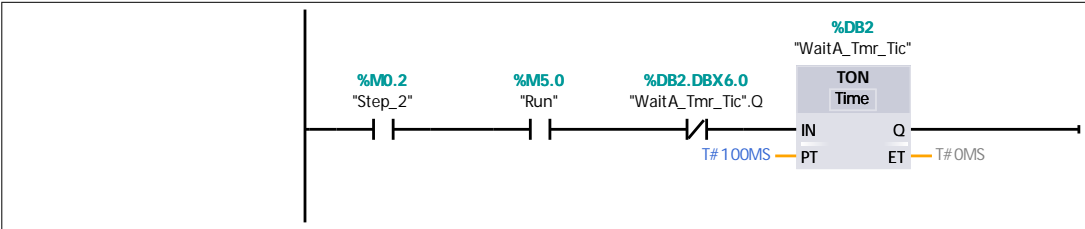
Network 3: Initial start



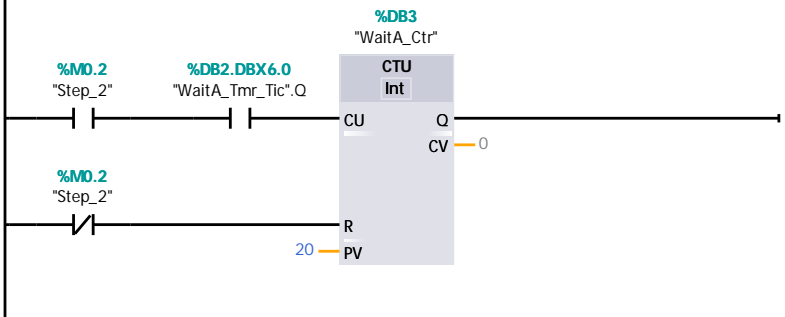
Network 4: Step 1 Fill A



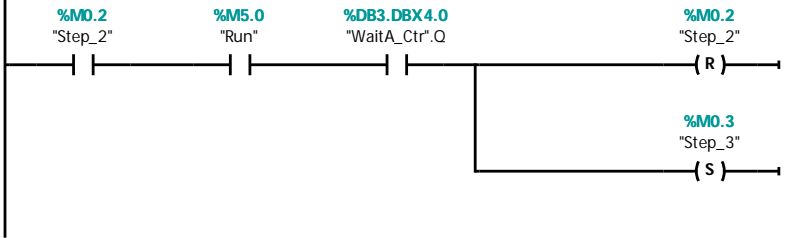
Network 5: Step 2 - Wait A timer tic for retentive function



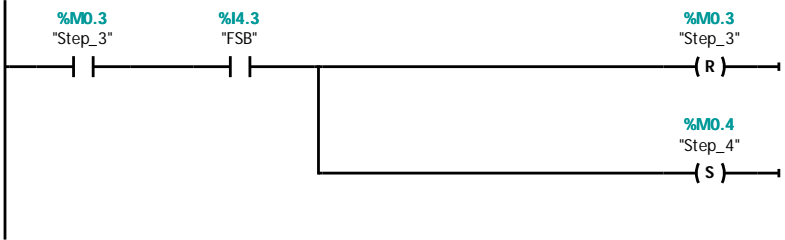
Network 6: Step 2 - Wait A counter for retentive function



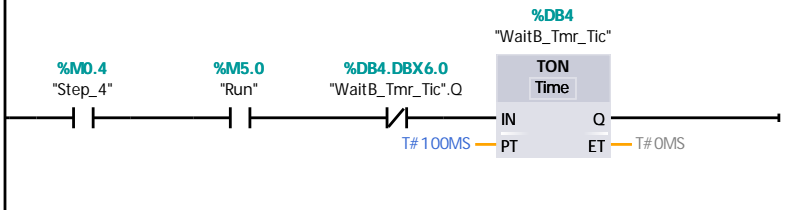
Network 7: Step 2 Wait 2 sec after A



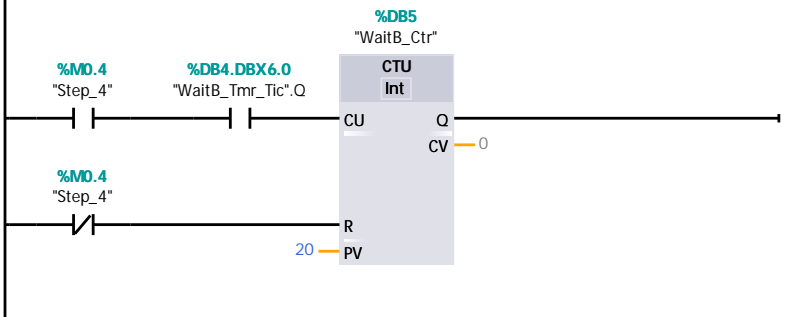
Network 8: Step 3 Fill B



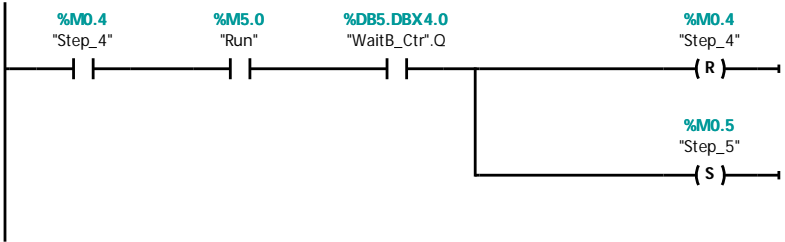
Network 9: Step 4 - Wait B timer tic for retentive function



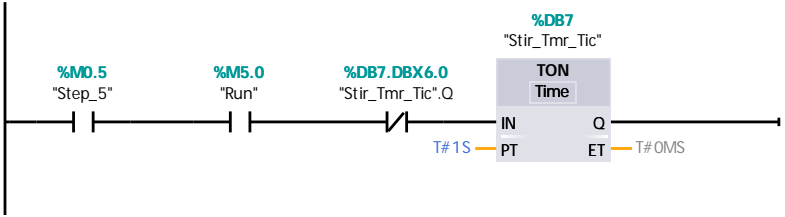
Network 10: Step 4 - Wait B counter for retentive function



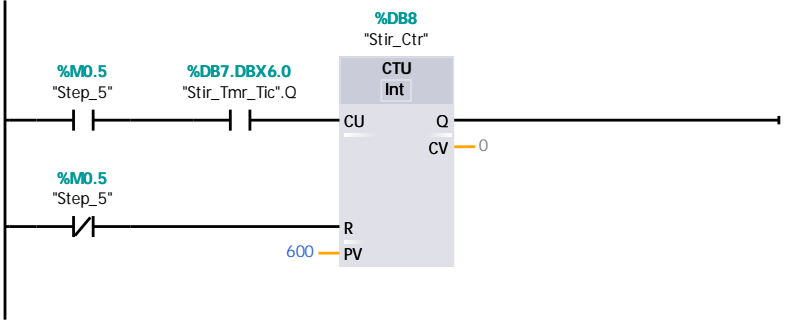
Network 11: Step 4 Wait 2 sec after B



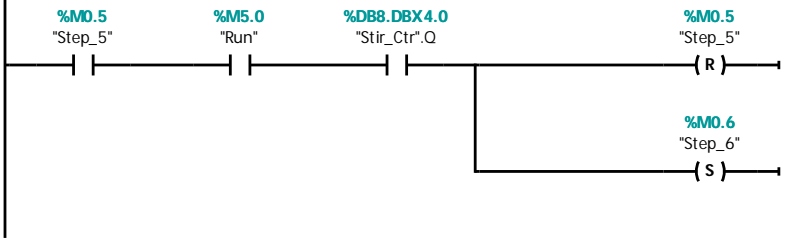
Network 12: Step 5 - Stir timer tic for retentive function



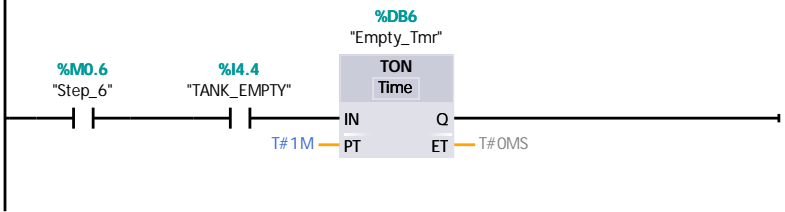
Network 13: Step 5 - Stir counter for retentive function



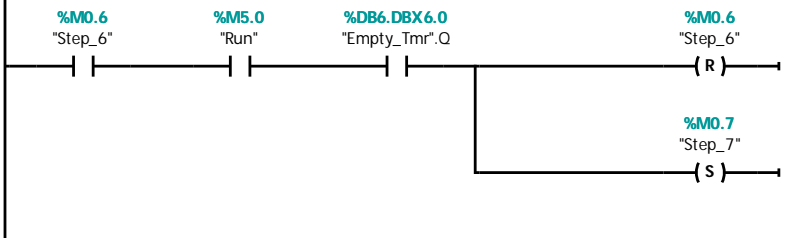
Network 14: Step 5 Stir 10 minutes



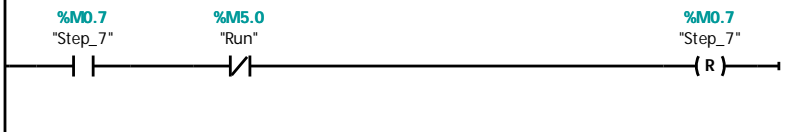
Network 15: Drain Timer



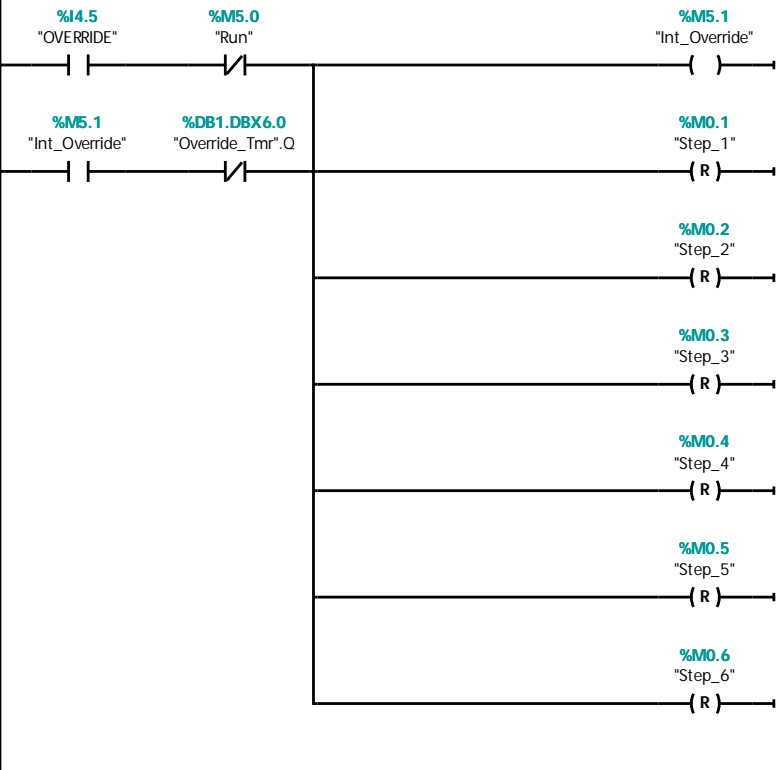
Network 16: Step 6 Drain Tank



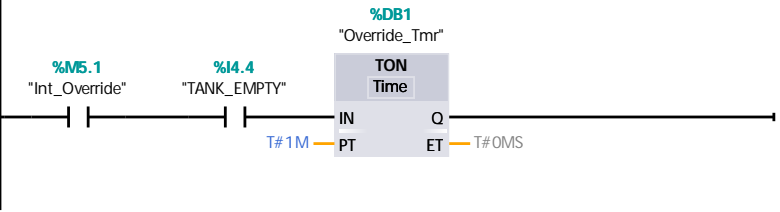
Network 17: Step 7 Unlatch Run



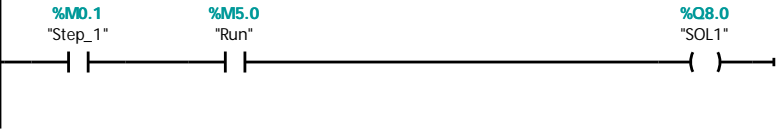
Network 18: Override



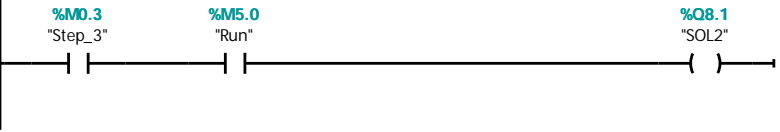
Network 19: Override Timer



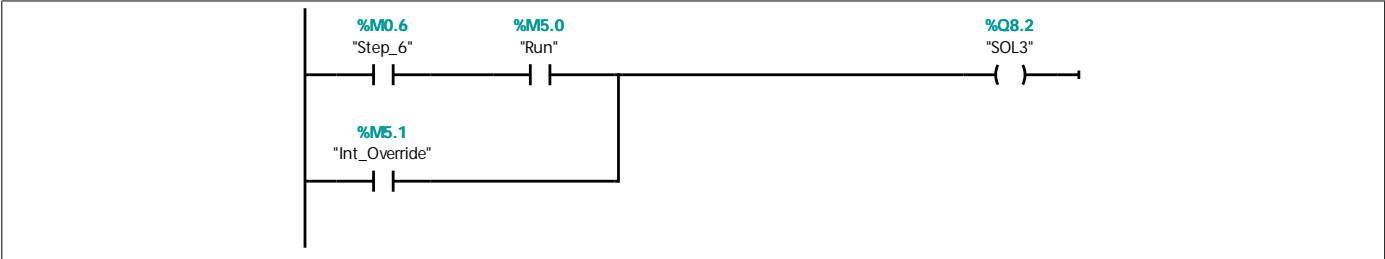
Network 20: Ingredient A fill solenoid, on to allow ingredient A into tank



Network 21: Ingredient B fill solenoid, on to allow ingredient B into tank



Network 22: Tank outlet solenoid, on to empty tank



Network 23: Stirrer motor control on to run stirrer

