

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: SP6-4

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Problem SP6-4 Bag Sealing Station Control

Additional internal memory:

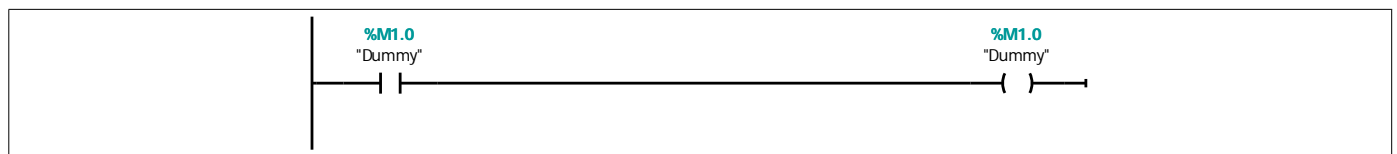
Tag Address

Run M5.0 BOOL On while station running

Int_Reset M5.1 BOOL Internal reset

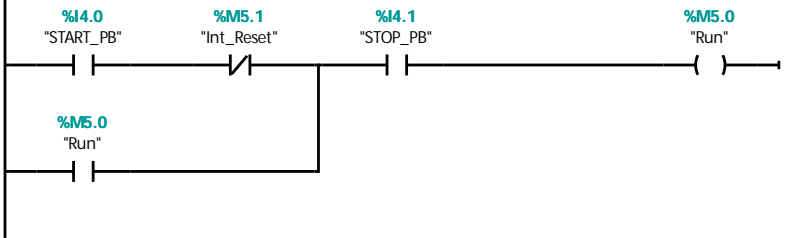
Step_1 to Step_5 M0.1 to M0.5 BOOL Step-in-progress bits

Seal_Tmr DB1 TON_SFB Times bag seal



Network 2: Start/stop

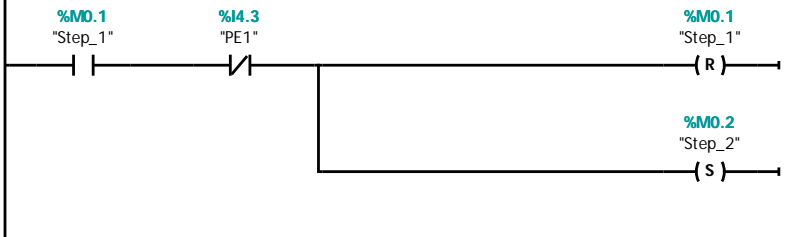
During reset prevent start



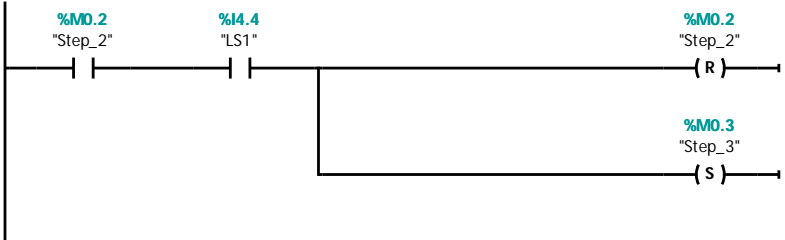
Network 3: Initial start



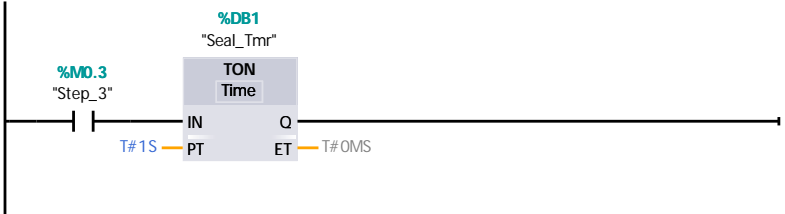
Network 4: Step 1 Move bag in



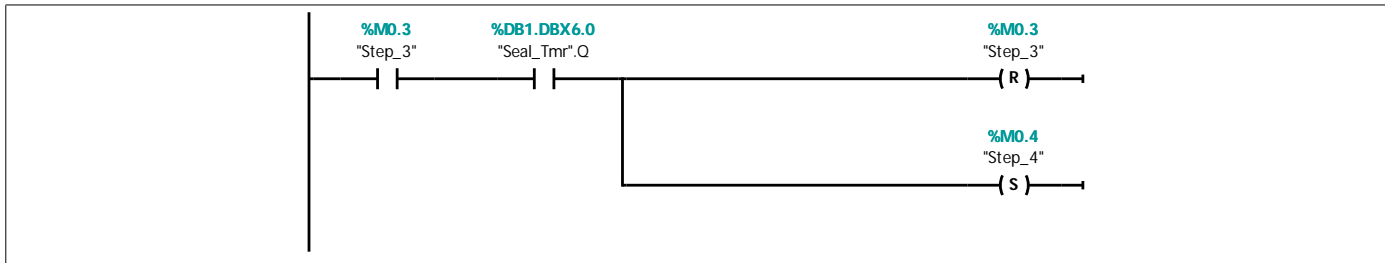
Network 5: Step 2 Move bars in



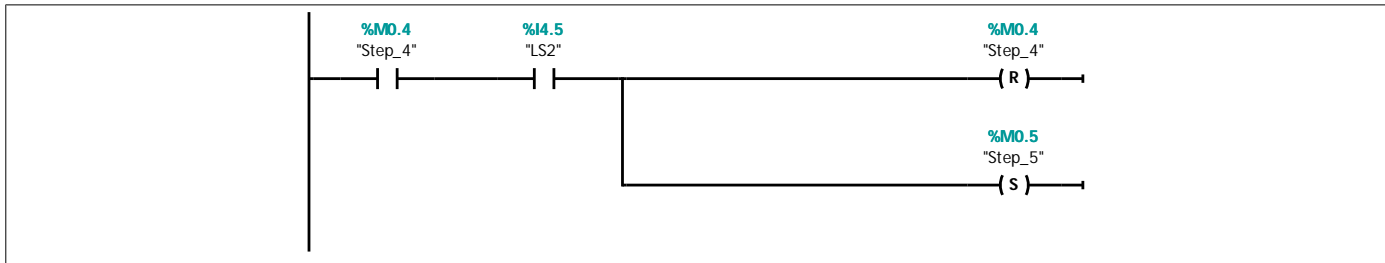
Network 6: Seal timer



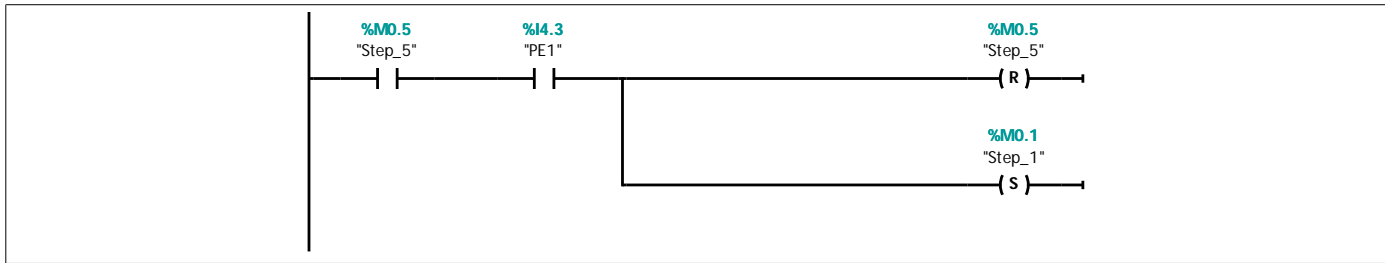
Network 7: Step 3 Seal bag



Network 8: Step 4 Move bars out



Network 9: Step 5 Move bag out



Network 10: Reset

Only allowed in step 1 and 5

