

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:

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

Problem SP6-6 Transfer Station Control

Additional internal memory:

Tag Address

Run M5.0 BOOL On while station running

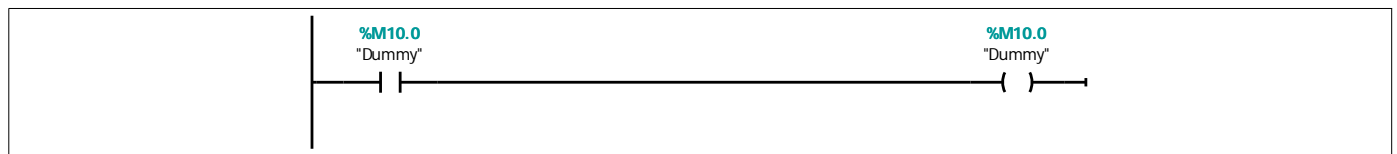
Int_Reset M5.1 BOOL Internal reset

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

Tic_Tmr DB1 TON_SFB Tic for retentive timer

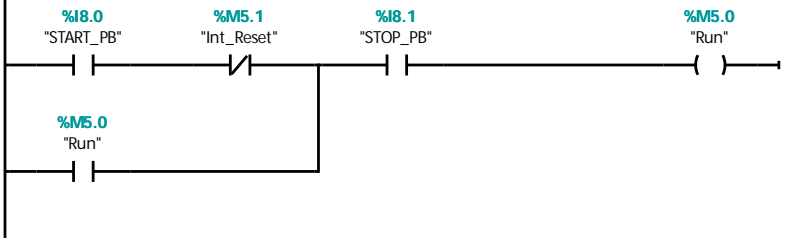
Raise_Tmr DB3 CTU_SFB Times mechanism raise

Parts_Ctr DB2 CTU_SFB Counts parts



Network 2: Start/stop

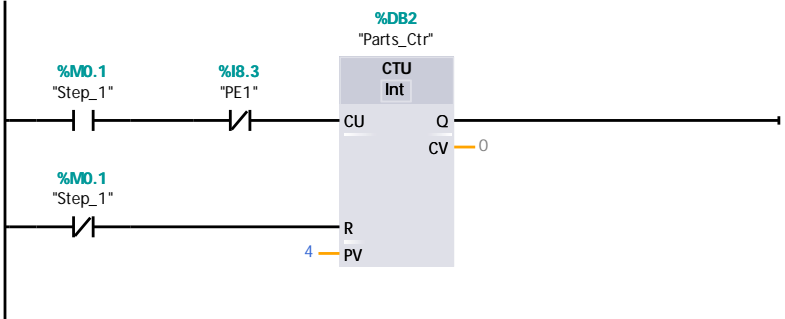
During reset prevent start



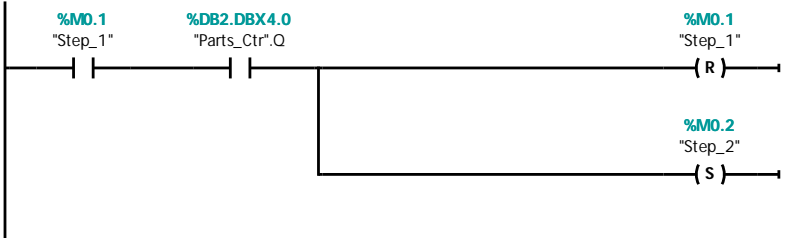
Network 3: Initial start



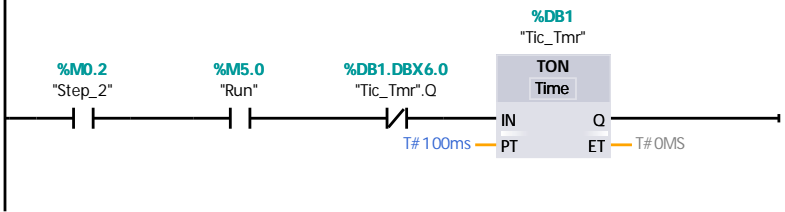
Network 4: Part Counter



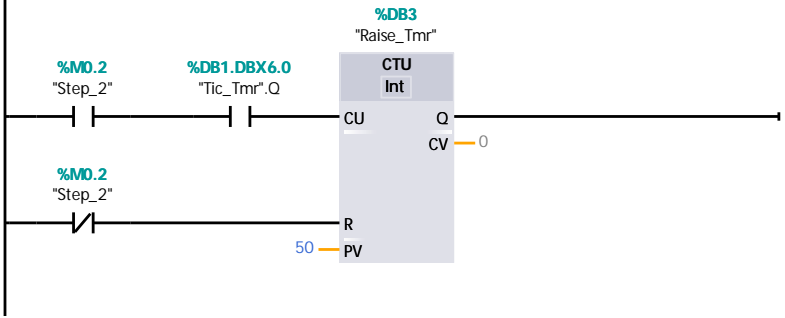
Network 5: Step 1 Wait for 4 parts



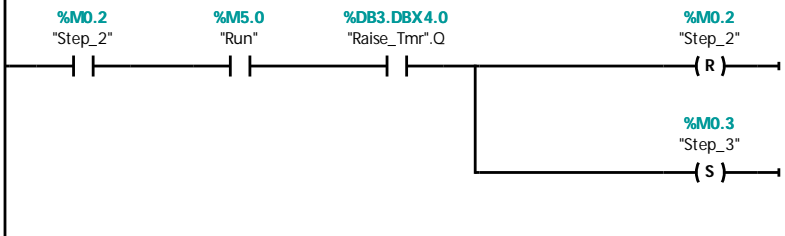
Network 6: Move Up Timer - retentive



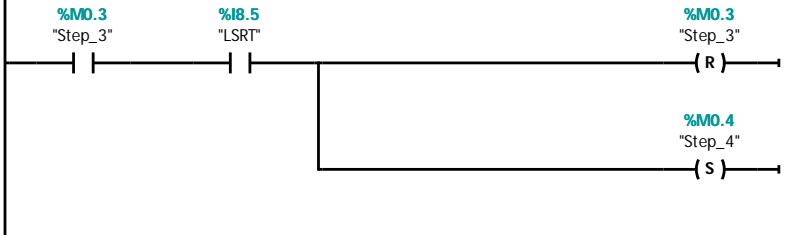
Network 7: Counter for retentive timer



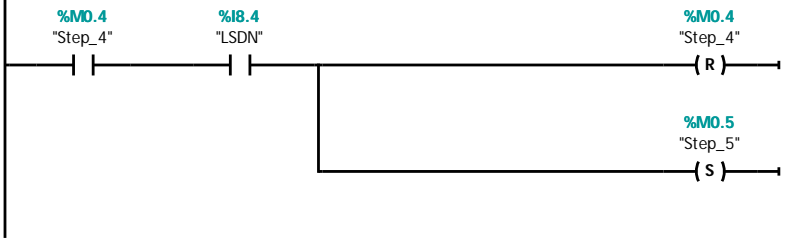
Network 8: Step 2 Move up



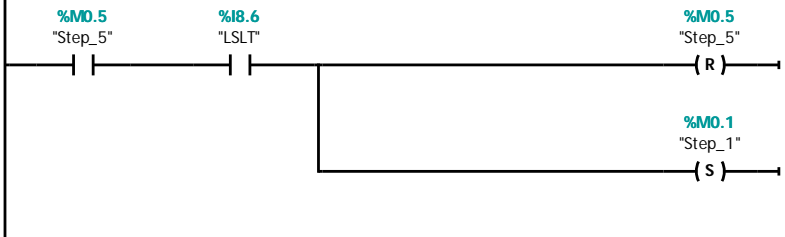
Network 9: Step 3 Move right



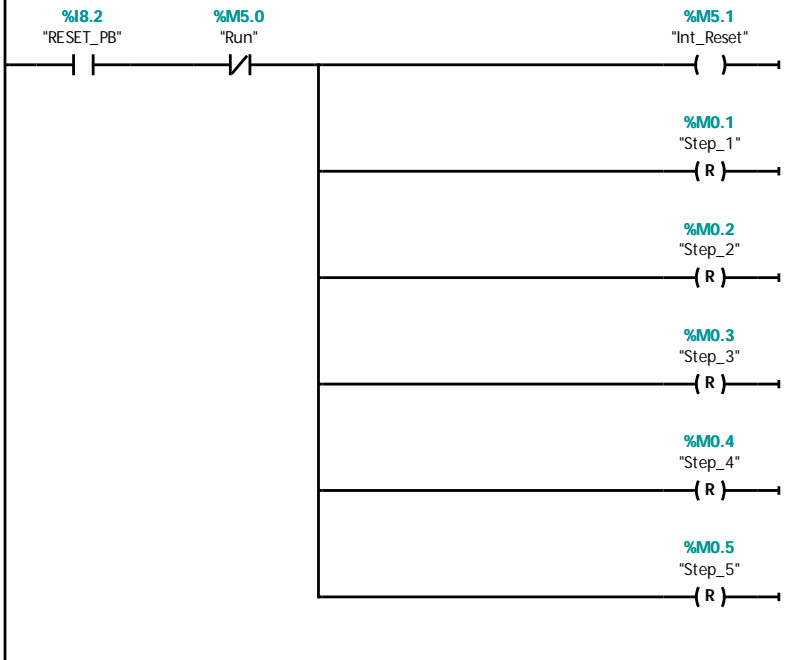
Network 10: Step 4 Move down



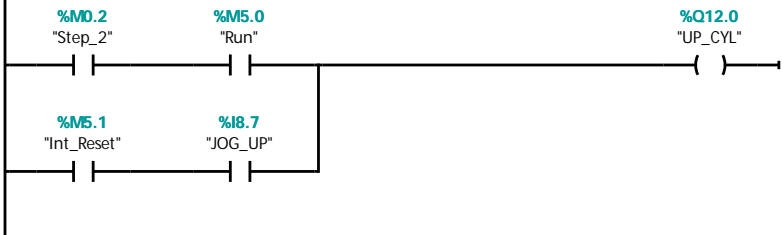
Network 11: Step 5 Move left



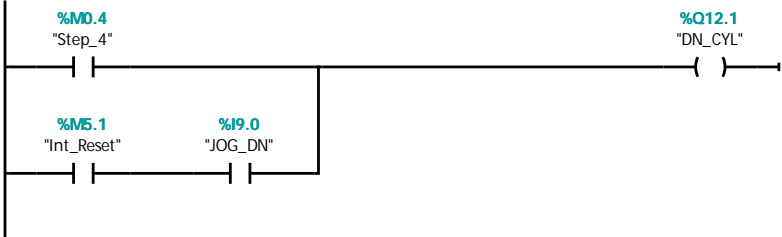
Network 12: Reset



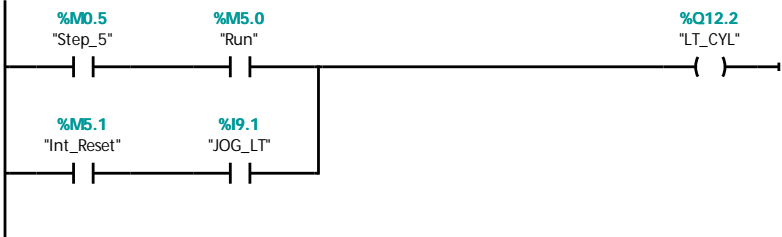
Network 13: Raising control, on to raise mechanism



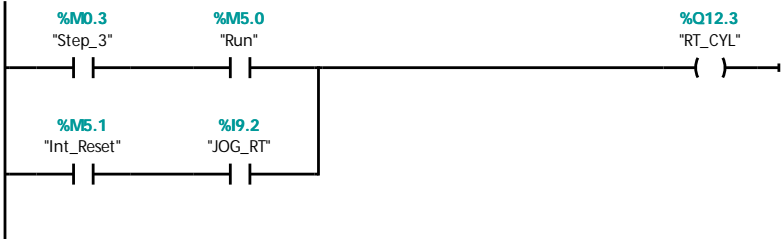
Network 14: Lowering control, on to lower mechanism



Network 15: Left motion control, on to move mechanism left



Network 16: Right motion control, on to move mechanism right



Network 17: Inbound conveyor control, on to move conveyor

