

# Main\_Program [OB1]

## Main\_Program Properties

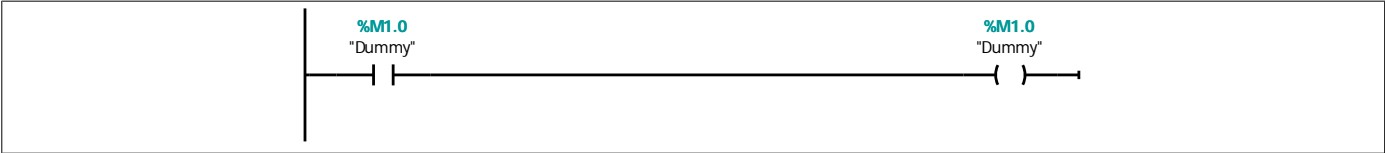
General					
Name	Main_Program	Number	1	Type	OB
Language	LAD	Numbering	Manual		
Information					
Title	SP9-3	Author		Comment	
Family		Version	0.1	User-defined ID	

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: SP9-3

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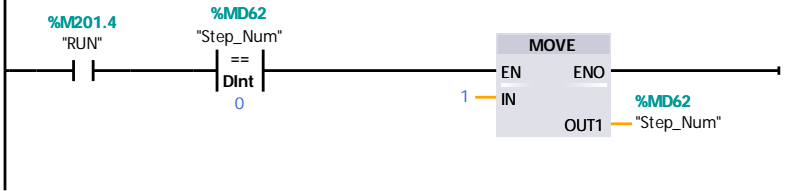
SP9-3 Pressure check station with move-based sequencer



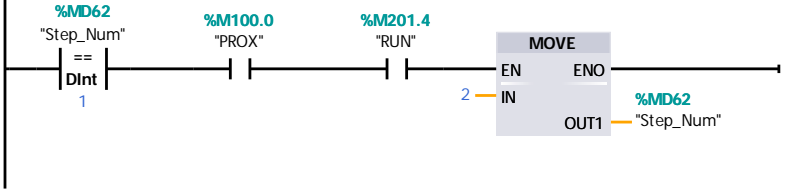
## Network 2: Always Off Logic



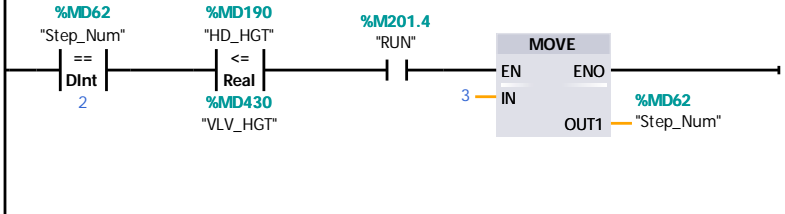
## Network 3: First Start - transition out of initial step to step 1.



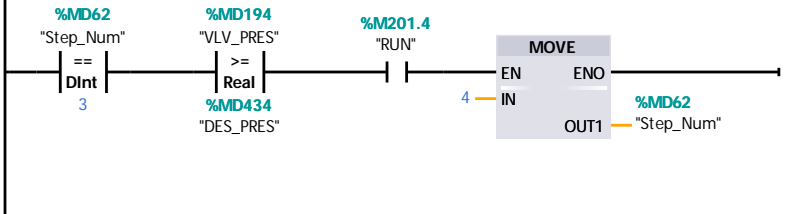
Network 4: Step 1 - Wait for valve.



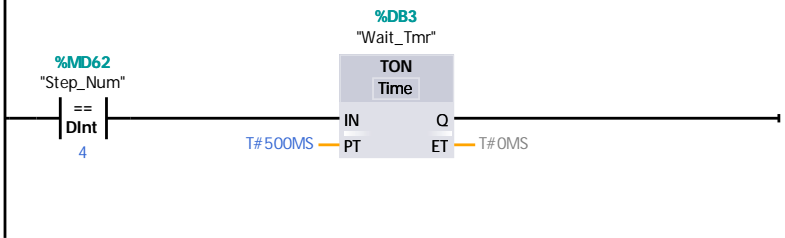
Network 5: Step 2 - Head down



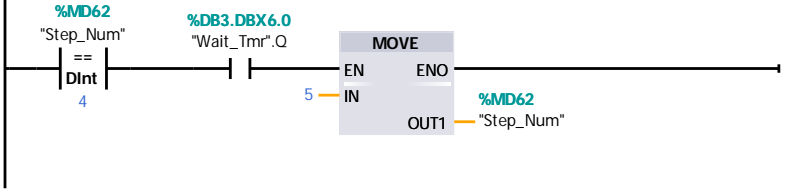
Network 6: Step 3 - Pressurize



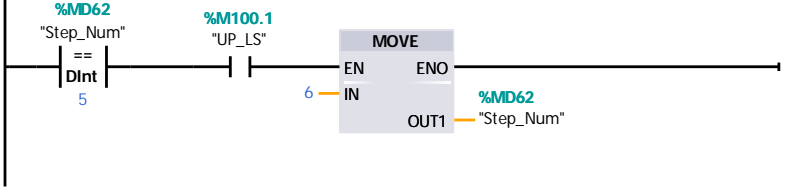
Network 7: Step 4 timer



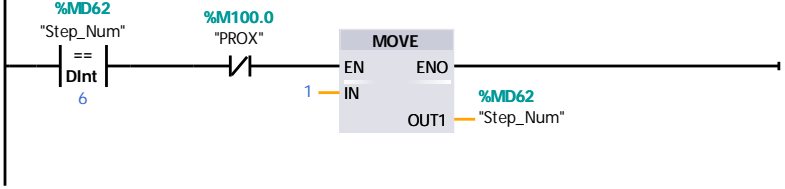
Network 8: Step 4 - Wait for pressure check



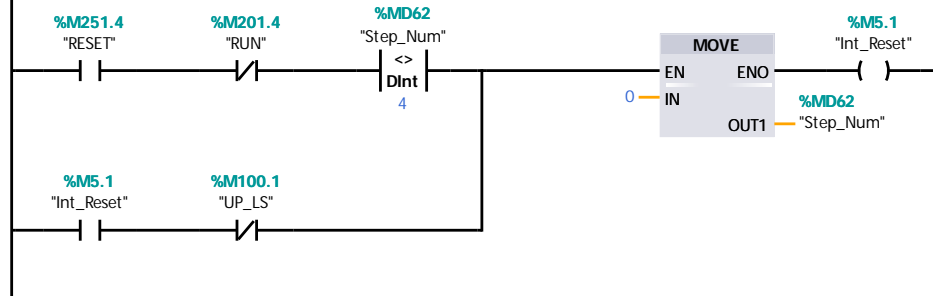
Network 9: Step 5 - Head up



Network 10: Step 6 - Part leaves



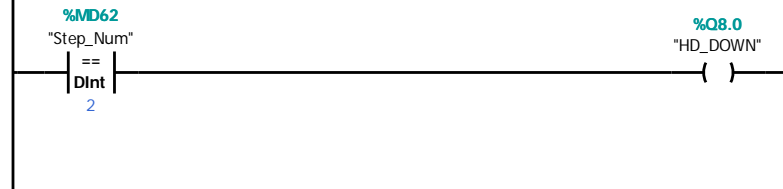
Network 11: Start/stop for reset operation. One step, no need for counter sequencer.



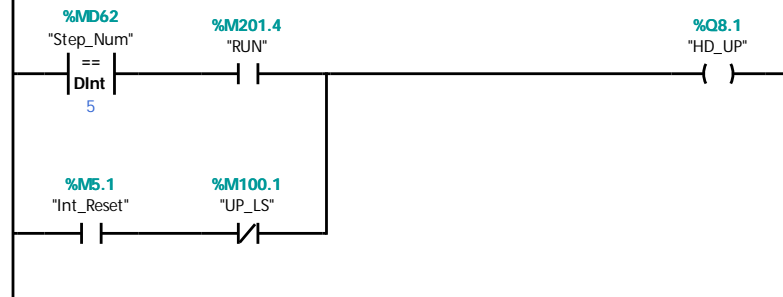
### Network 12: When on, moves the pressurizing head down

Physical Outputs

Head raise/lower. Off when paused. Raise when reset.

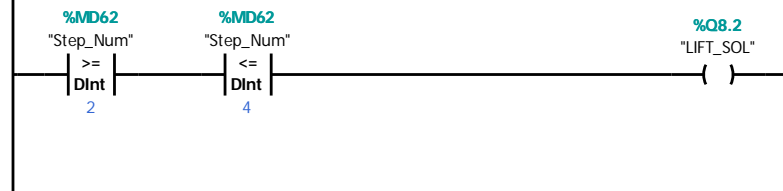


### Network 13: When on, moves the pressurizing head up

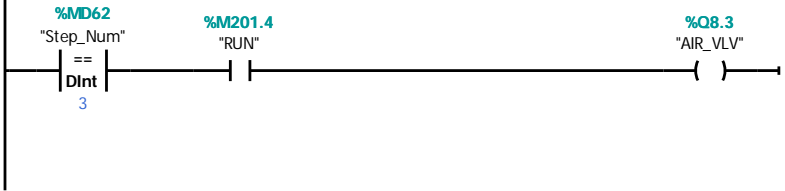


### Network 14: On to move carrier (and valve) up and off the conveyor

Lift solenoid. Can not turn off when paused.

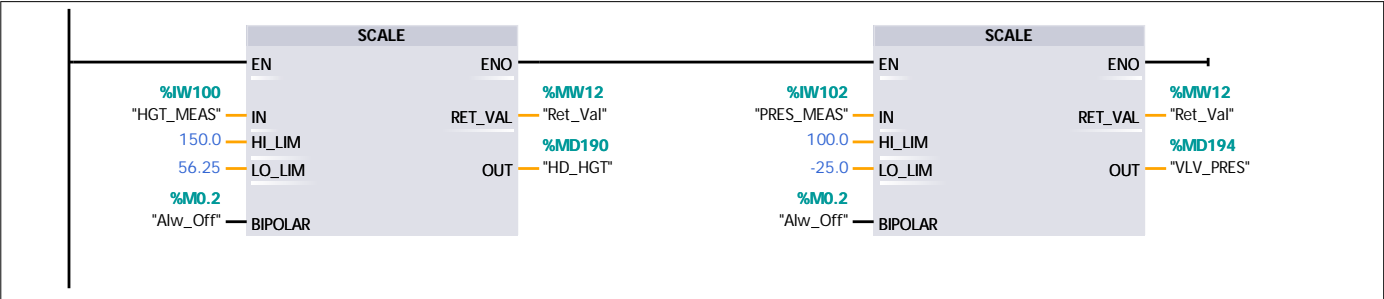


### Network 15: Opens air valve pressurize tested valve



**Network 16: Convert height measurement to mm and pressure measurement to psi.**

Uses SCALE block. Note that the lo\_lim input is 25% lower than zero weight to account for this block assuming the minimum value of the analog in is zero rather than the 5530 (which corresponds to 4 mA).



**Network 17: Set if valve is to be rejected because it will not hold pressure**

Check valve pressure during step 4. If falling, set reject bit.

