

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: SP5-3

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Press Control

For safety reasons, an operator is required to actuate 2 pushbuttons in order to close a stamping press. The intention is to ensure that both of the operator's hands are out of the press when it closes. The logic incorporates timing delays that prevent the operator from taping 1 pushbutton down and making the press faster but unsafe to operate.

Additional internal memory:

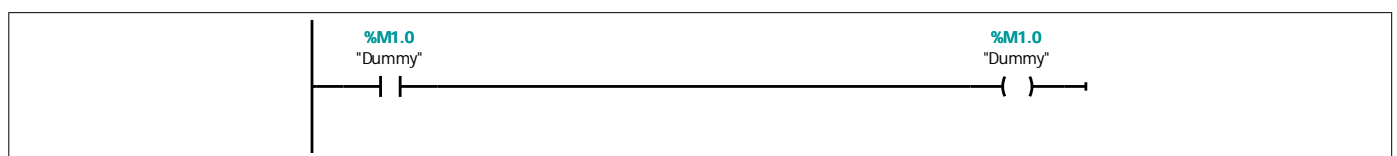
Tag Address

HP3TR1 M0.0 No delay for timing PB1

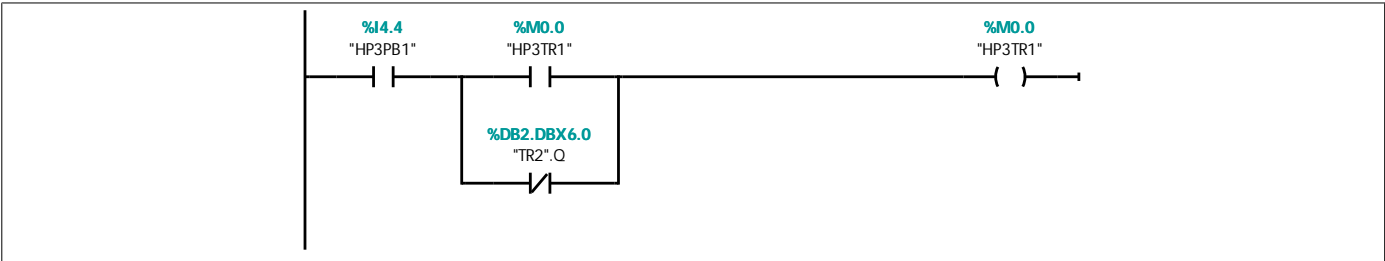
HP3TR2 M0.1 No delay for timing PB2

TR1 DB1 (TON_SFB) Timer for PB1 delay

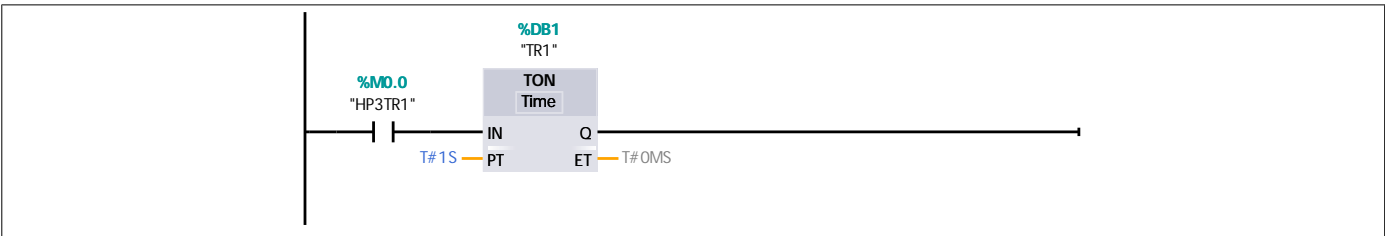
TR2 DB2 (TON_SFB) Timer for PB2 delay



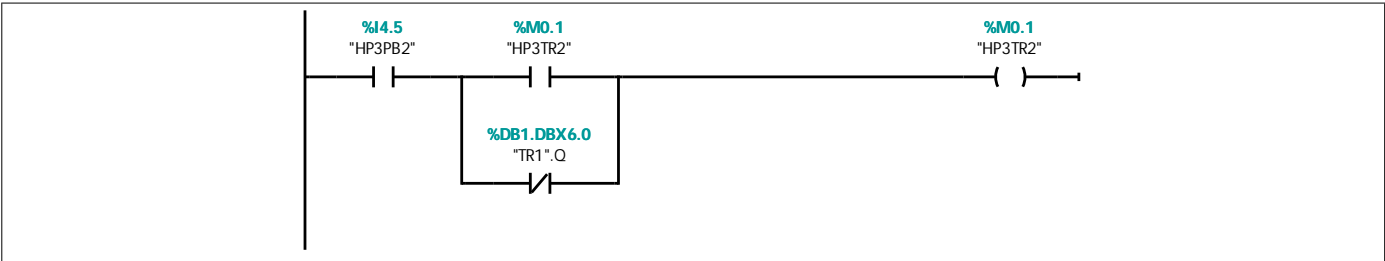
Network 2: No delay for timing PB1 delay



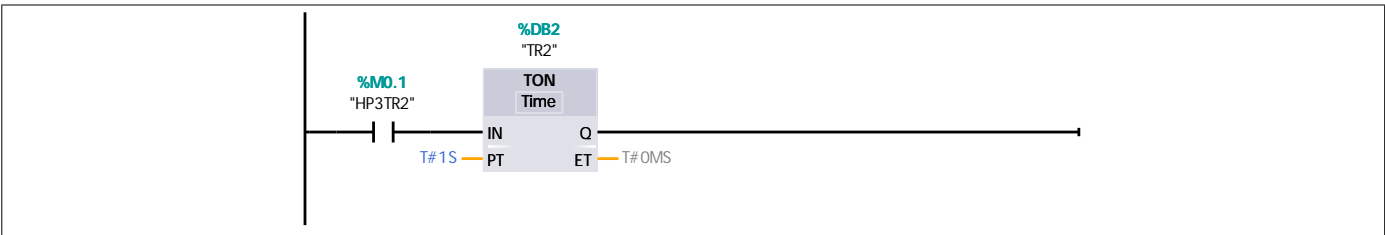
Network 3:



Network 4: No delay for timing PB2 delay



Network 5:



Network 6: Press solenoid, on to run press

Totally Integrated Automation Portal		
	<div><div><div>%M0.0 "HP3TR1"</div><div>%M0.1 "HP3TR2"</div><div>%Q24.3 "HP3SQL"</div></div><div></div></div>	