

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: SP6-11

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Problem SP6-11 Case Erector Control

Additional internal memory:

Tag Address

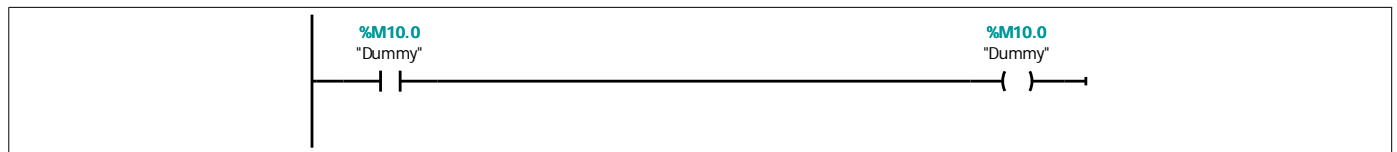
Run M5.0 BOOL On while station running

Step_1 to Step_6 M0.1 to M0.6 BOOL Step-in-progress bits

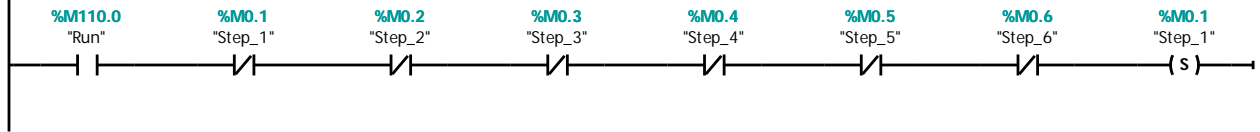
Up_Tmr DB1 TON_SFB Times carton unfolding

Pulse_Cnt DB2 CTU_SFB Counts encoder pulses

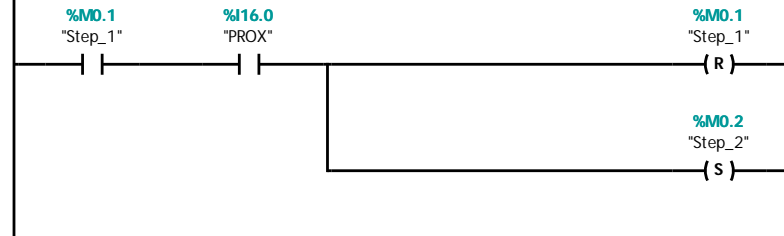
BDown_Tmr DB4 TON_SFB Times retract of rams



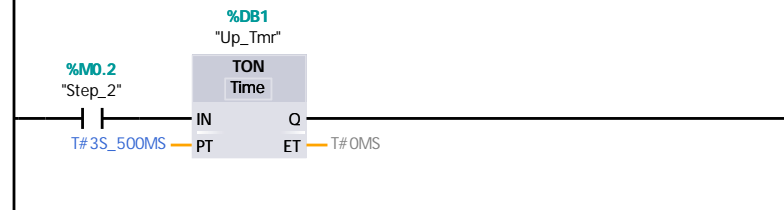
Network 2: Initial start



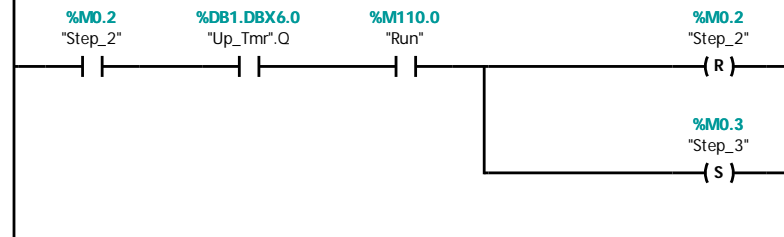
Network 3: Step 1 Move in



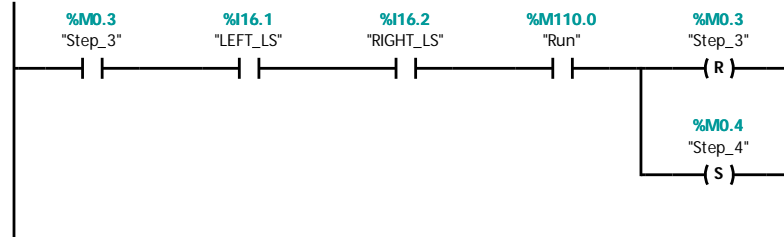
Network 4: Open up timer



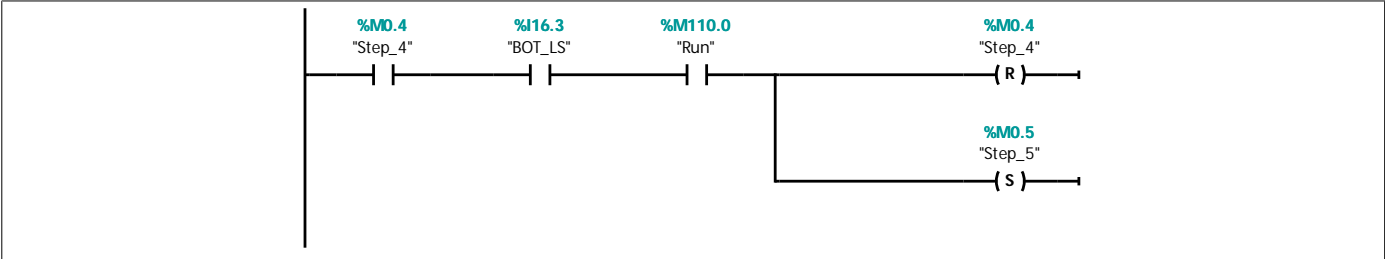
Network 5: Step 2 Open up



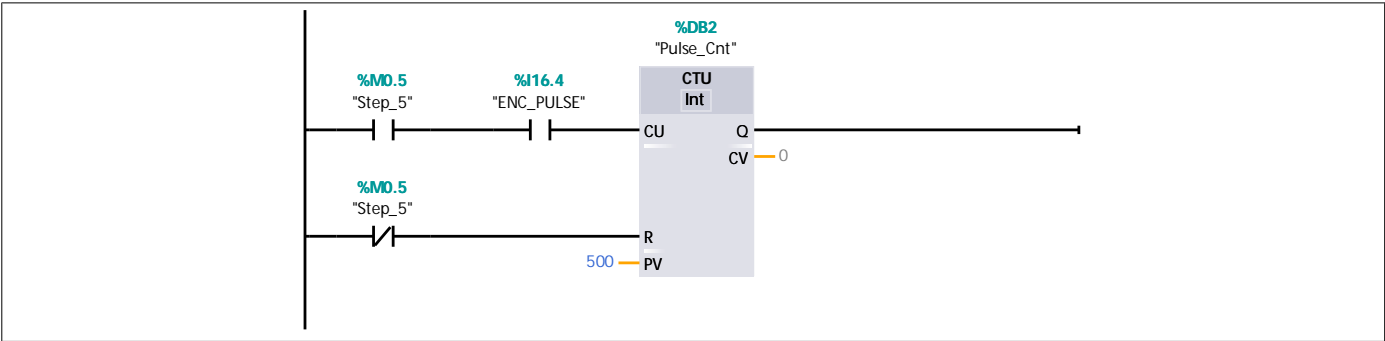
Network 6: Step 3 Close sides



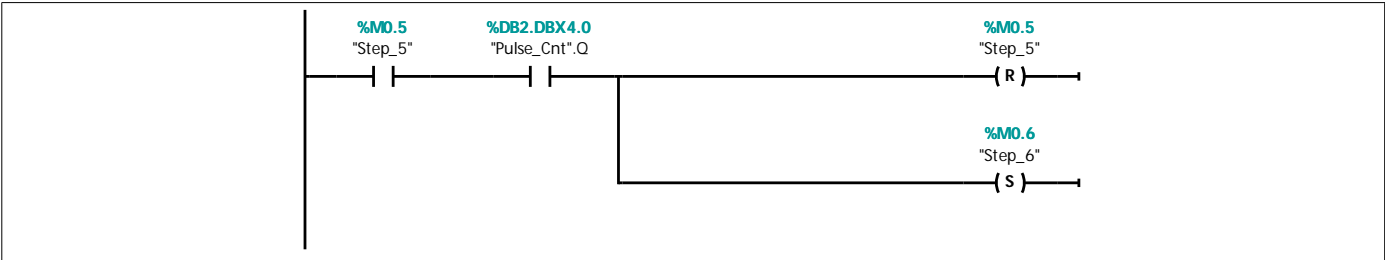
Network 7: Step 4 Close bottom



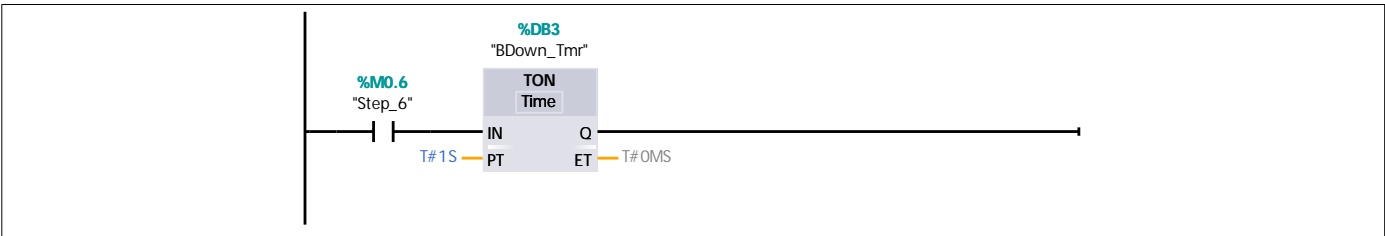
Network 8: Pulse counter



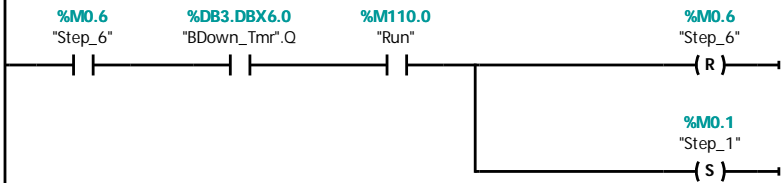
Network 9: Step 5 Move out



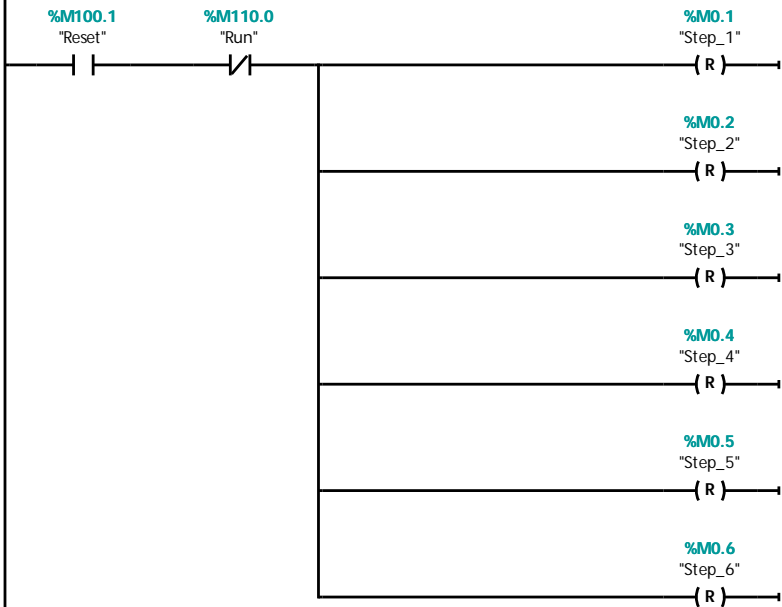
Network 10: Bottom down timer



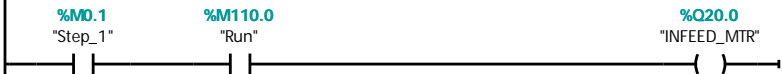
Network 11: Step 6 Let Bot_Cyl fall



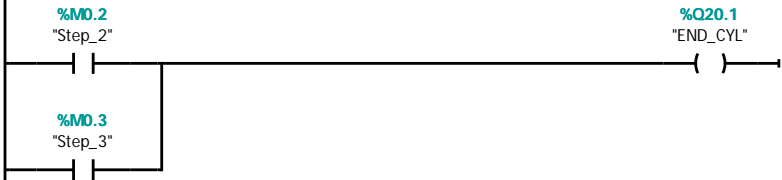
Network 12: Reset



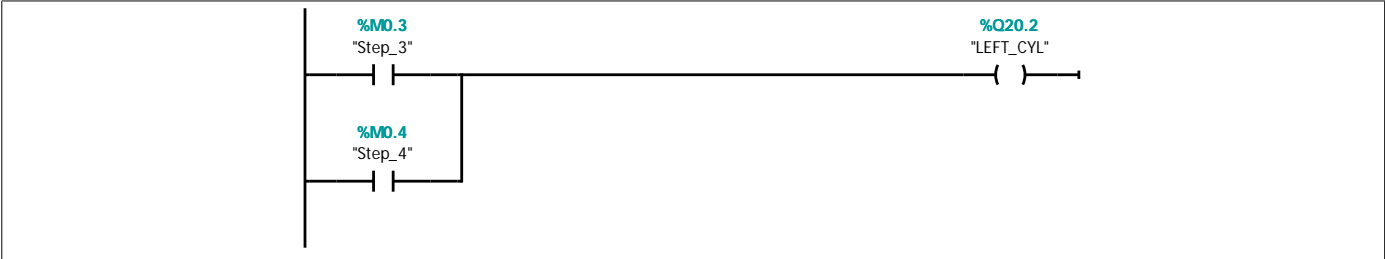
Network 13: Infeed rollers, on to move in flat carton



Network 14: End cylinder control, when on unfolds flat carton



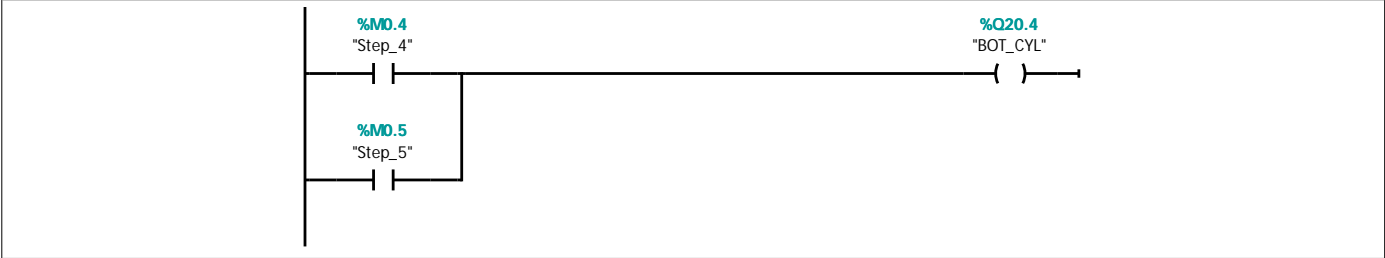
Network 15: Left cylinder control when on folds left flap inward



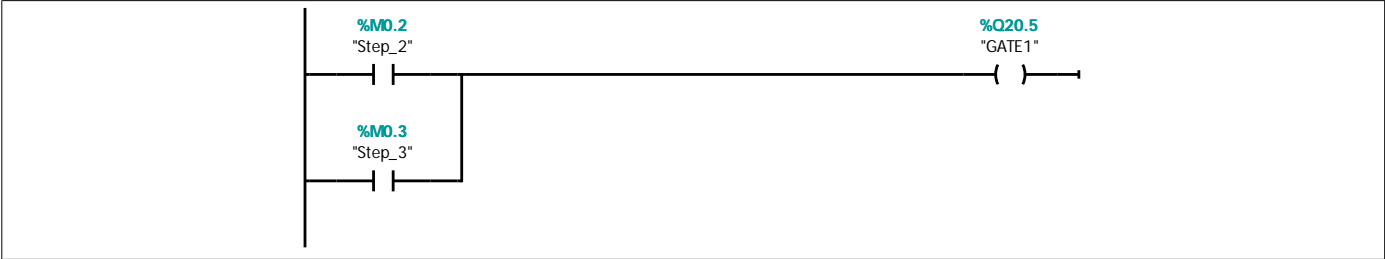
Network 16: Right cylinder control, when on folds right flap inward



Network 17: Bottom cylinder control, when on folds bottom flap inward



Network 18: Gate cylinder control, on to prevent carton from sliding out sta



Network 19: Chain conveyor motor control, when on moves carton out

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<div><div><div><div><div></div><div></div></div><div><div><div>%M0.5 "Step_5"</div><div>%M110.0 "Run"</div><div>%Q20.6 "CHAIN_CONV"</div></div></div><div></div></div></div></div>		