

# Main\_Program [OB1]

## Main\_Program Properties

### General

Name	Main_Program	Number	1	Type	OB
Language	LAD	Numbering	Manual		

### Information

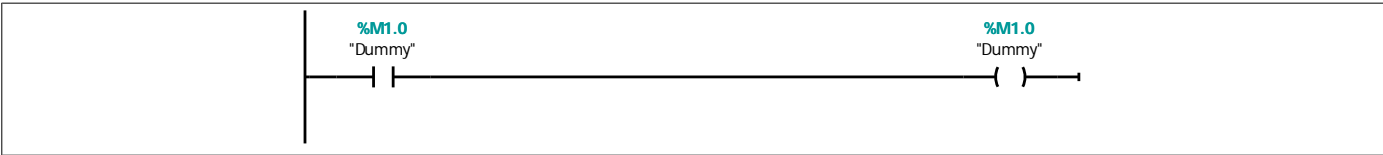
Title	SP9-8	Author		Comment	
Family		Version	0.1	User-defined ID	

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		

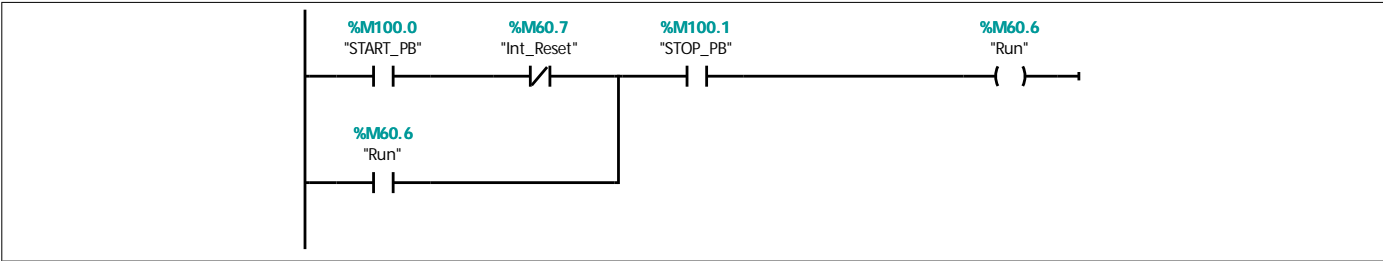
## Network 1: SP9-8

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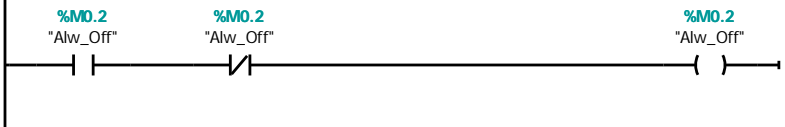
SP9-8 Erbia Blending Station with shift register-based sequence.



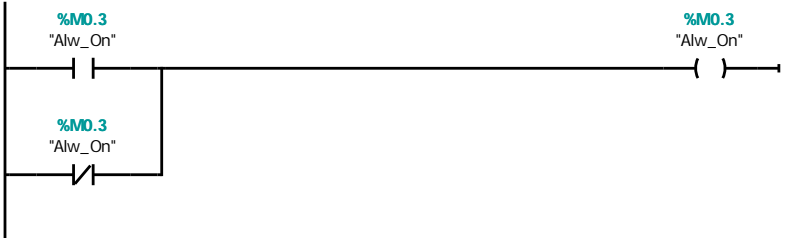
## Network 2: Start/stop/pause. Start prevented if reset in progress.



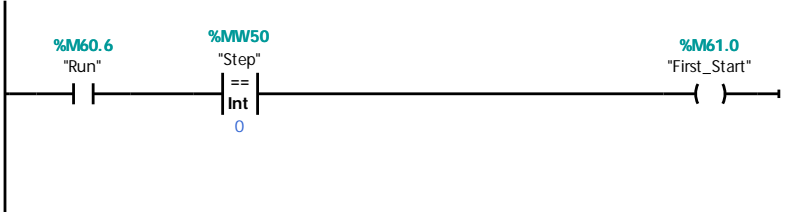
## Network 3: Always Off Logic



Network 4: Always On Logic

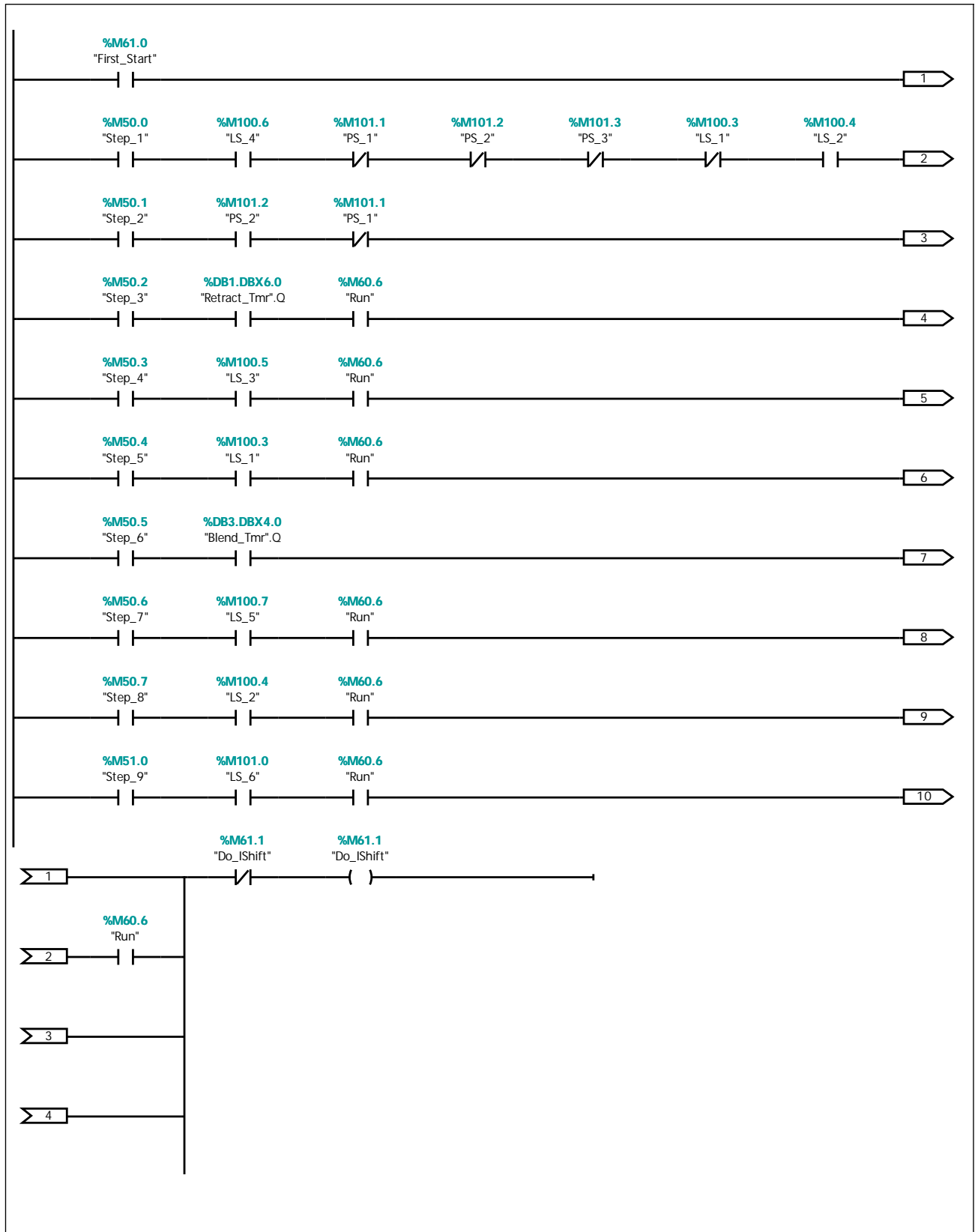


Network 5: First Start - run and no step-in-progress bit set



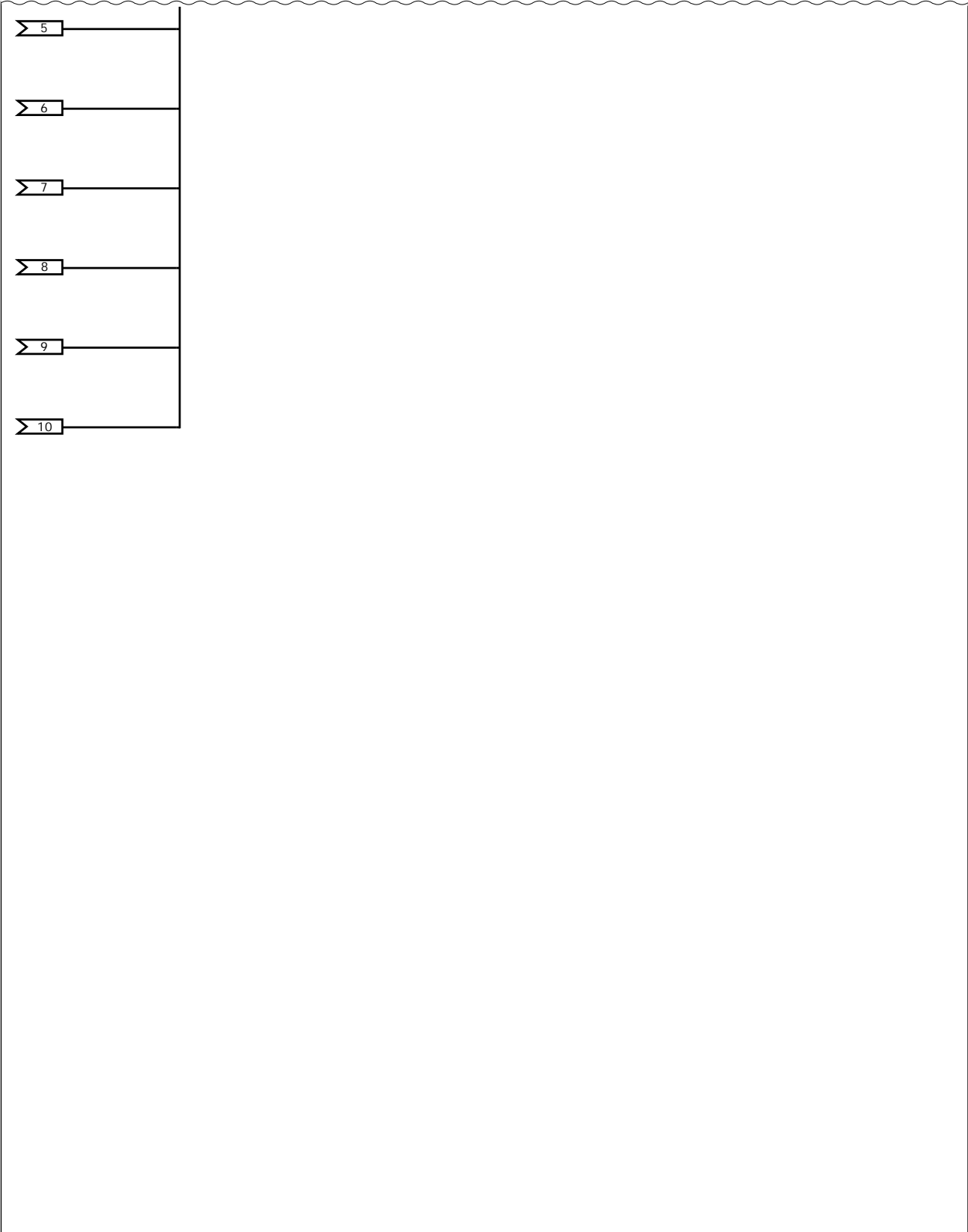
Network 6: All transition conditions. Any one causes shift.

**Network 6: All transition conditions. Any one causes shift. (1.1 / 2.1)**

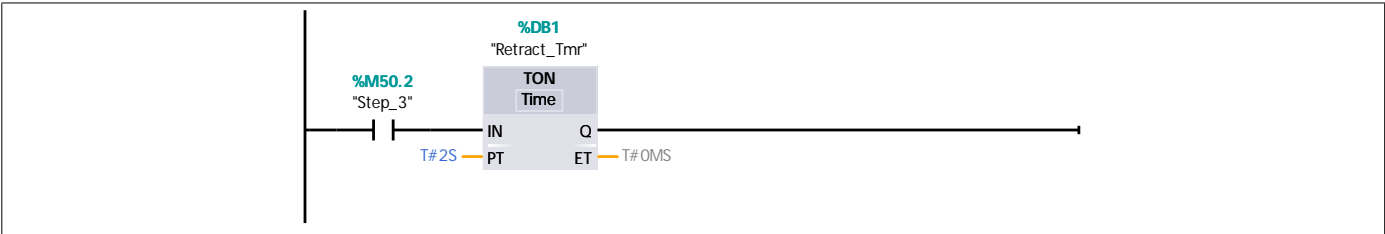


**Network 6: All transition conditions. Any one causes shift. (2.1 / 2.1)**

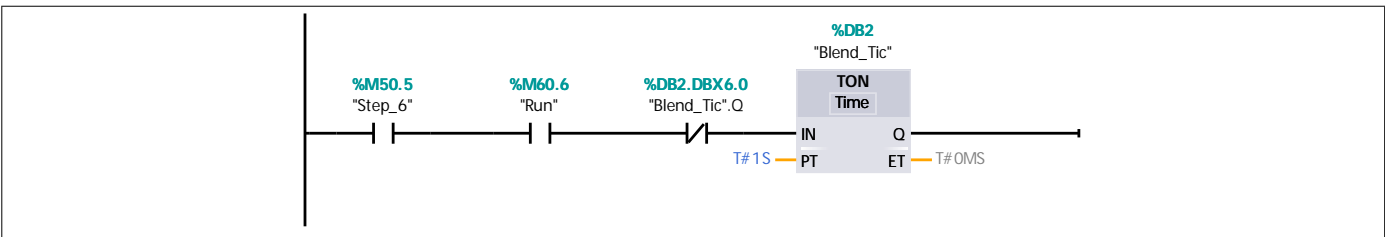
1.1 ( Page1 - 3)



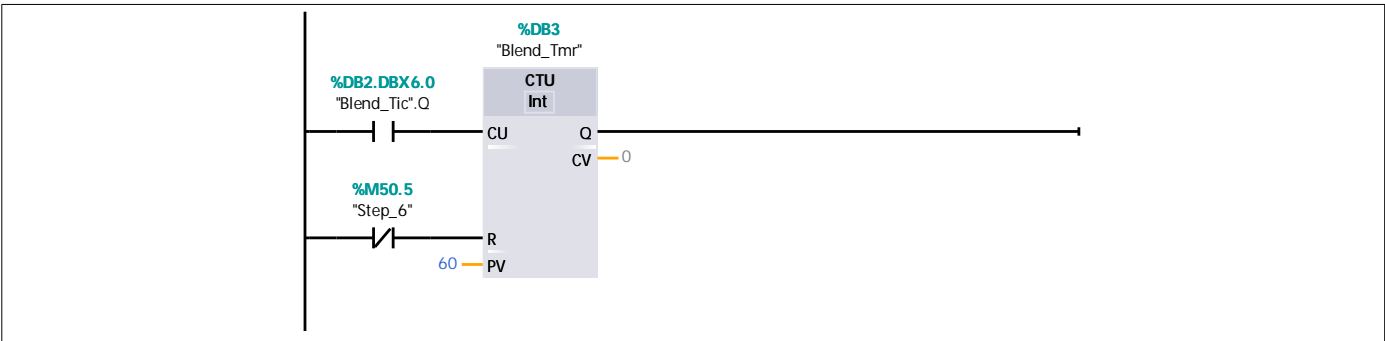
**Network 7: Timers for transitions**



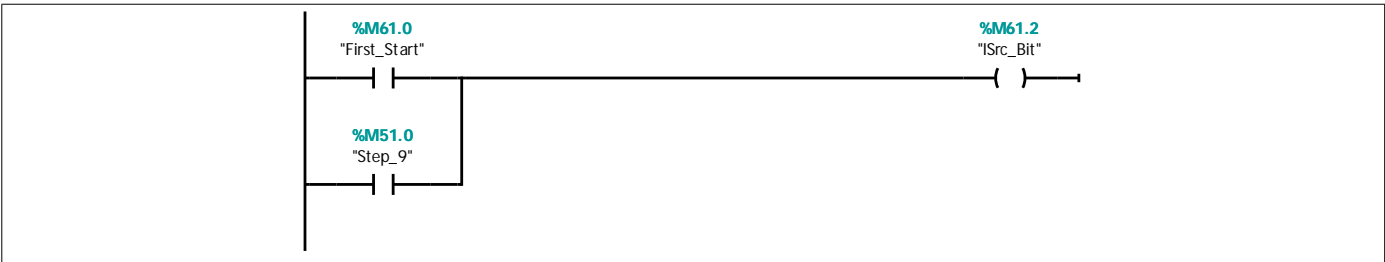
**Network 8: Retentive Timer for Blend step**



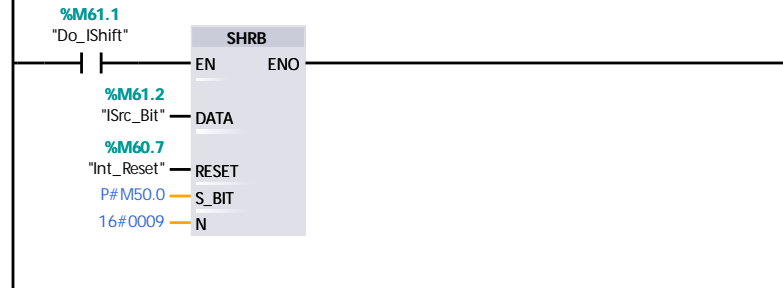
**Network 9:**



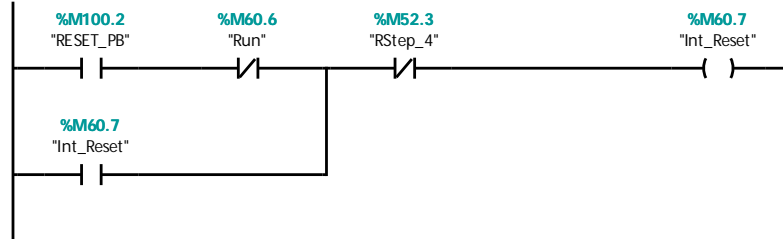
**Network 10: Bit shifted into register. First start and last step are only "1" shifted in**



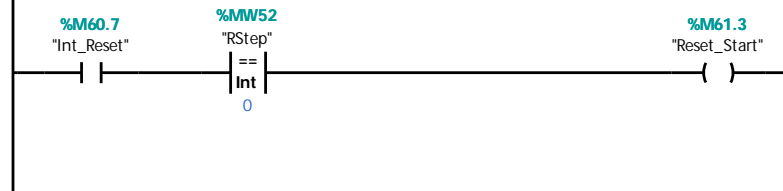
**Network 11:**



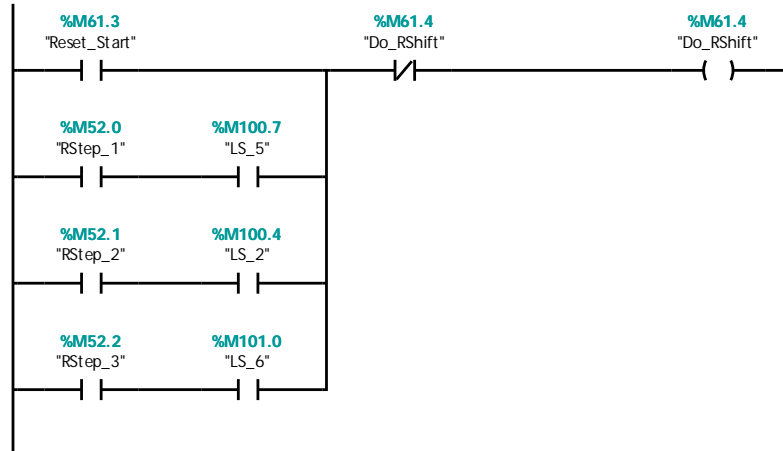
**Network 12: Start/stop for reset operation. Reset pb starts, reset step 4 stops it.**



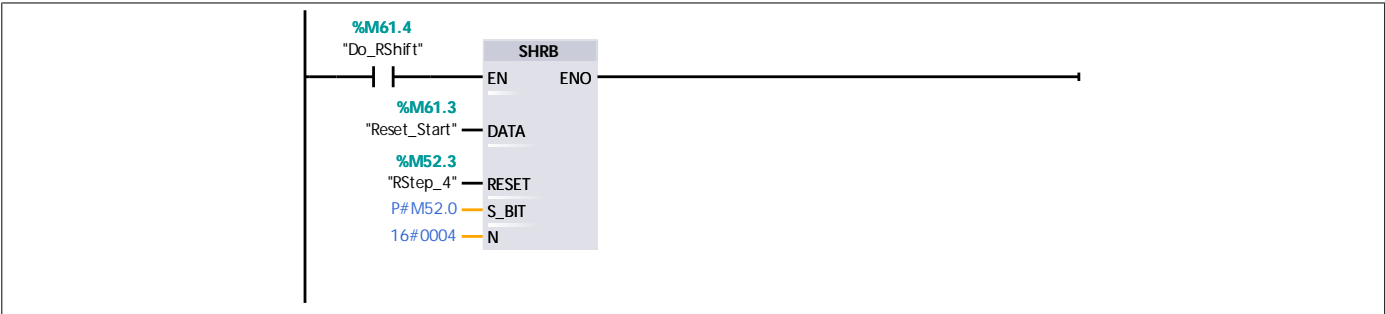
**Network 13: Reset start - in reset and not step-in-progress bits set**



**Network 14: All transition conditions. Any one causes shift.**



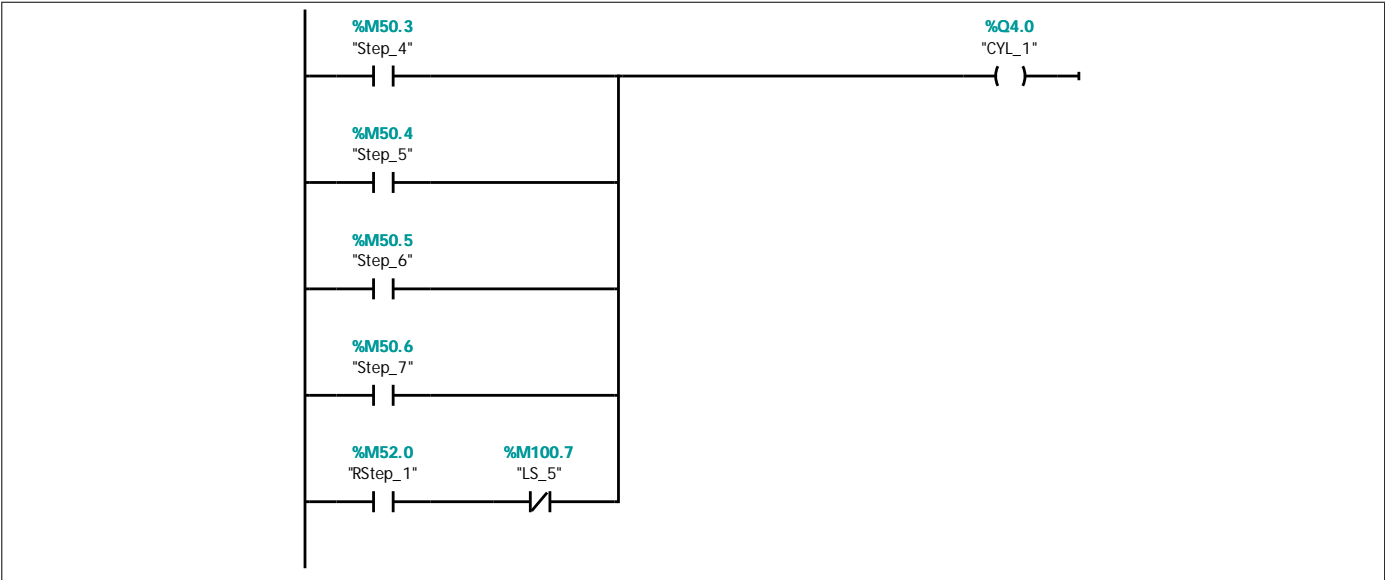
**Network 15: Reset shift register. Only Reset\_Start shifts a bit in.**



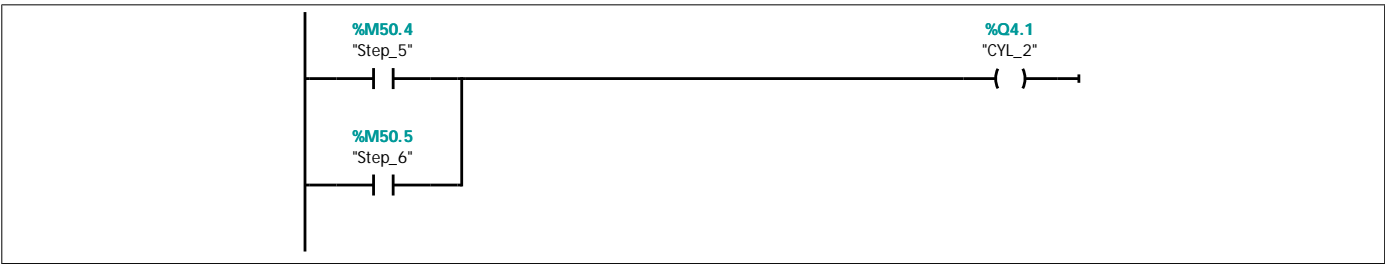
**Network 16: Physical Outputs**

Gate cylinder controls. Cannot turn off CYL\_1 to CYL\_3 when paused.

On reset, do not unclamp until vertical.

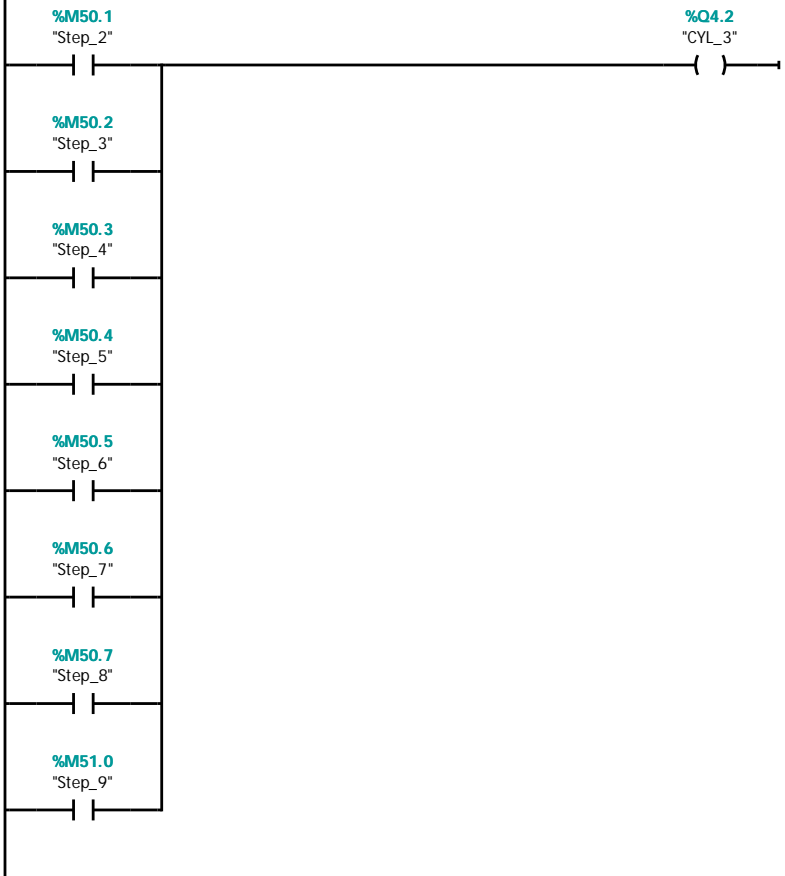


**Network 17: CYL\_2 control**



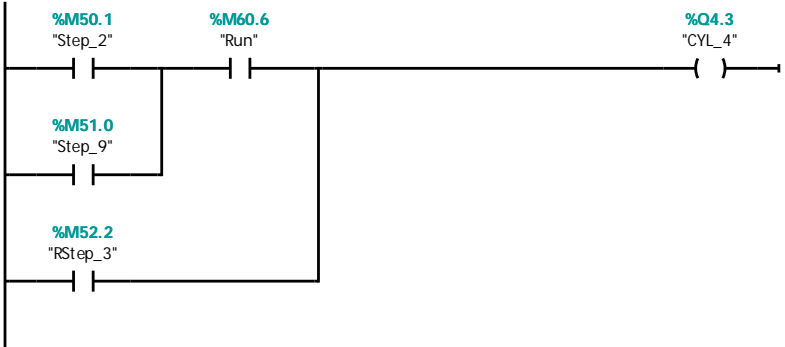
**Network 18: CYL\_3 control**

Retract on reset



**Network 19: CYL\_4 control**

On reset, do not push out until in vertical position and unclamped.



**Network 20: Rotator motor control**

Retract on reset

