

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: SP6-1

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Carton Sealer Control

Additional internal memory:

Tag Address

Run M5.0 BOOL On while station running

Int_Reset M5.1 BOOL Internal reset

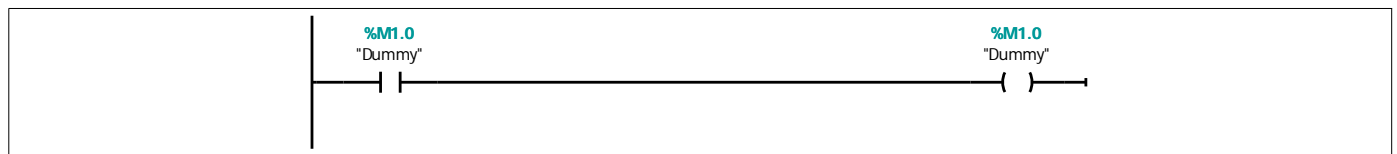
Step_1 to Step_7 M0.1 to M0.7 BOOL Step-in-progress bits

Spray_Tmr DB1 TON_SFB Times spray

Dry_Tmr DB3 TON_SFB Times drying step

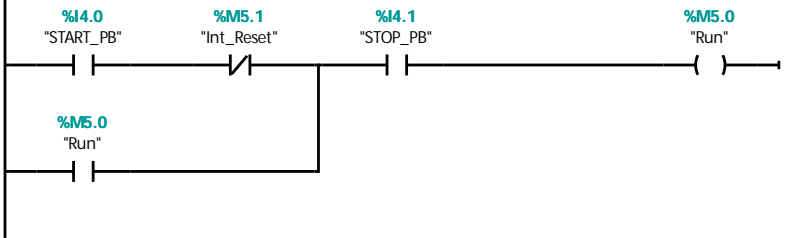
Retract_Tmr DB4 TON_SFB Times retract of rams

Reset_Tmr DB5 TON_SFB Times reset (retract of rams)

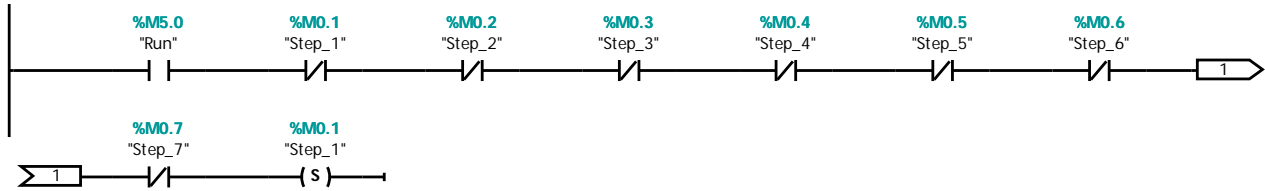


Network 2: Start/stop

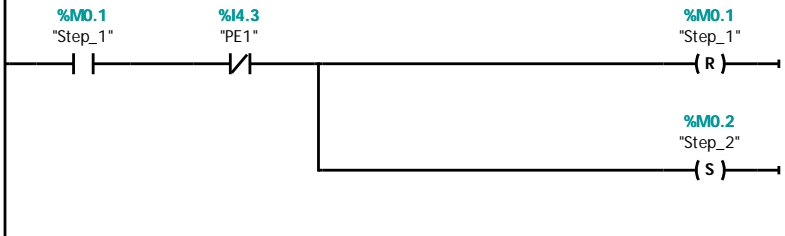
During reset prevent start



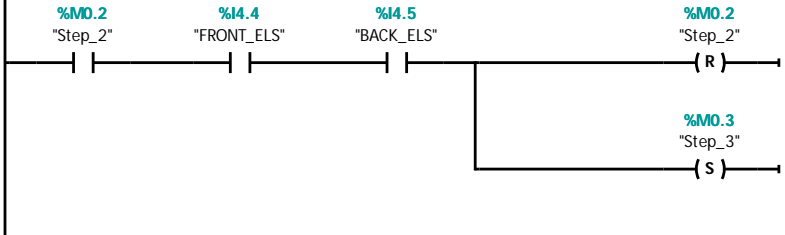
Network 3: Initial start



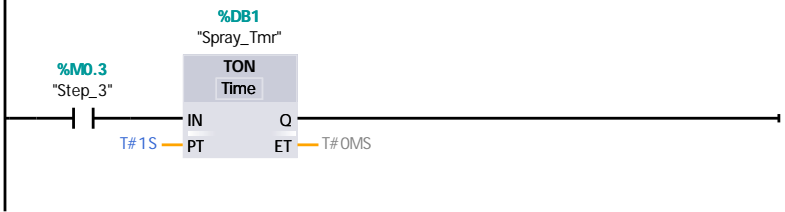
Network 4: Step 1 Wait for box



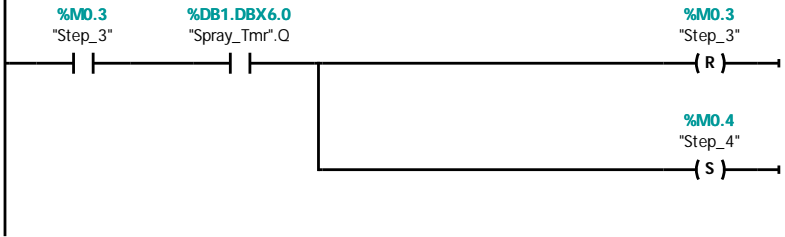
Network 5: Step 2 Push down end flaps



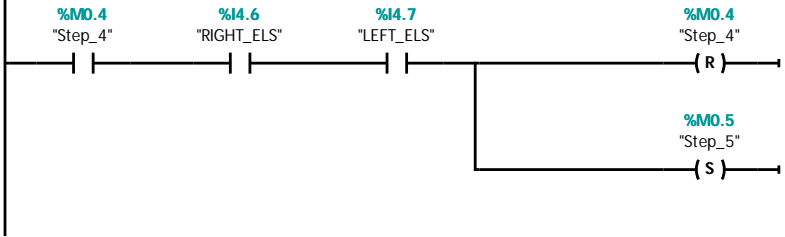
Network 6: Step 3 timer



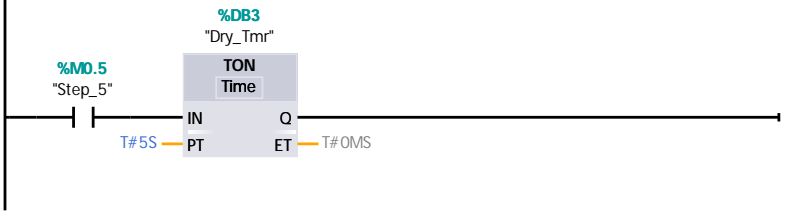
Network 7: Step 3 Spray Glue



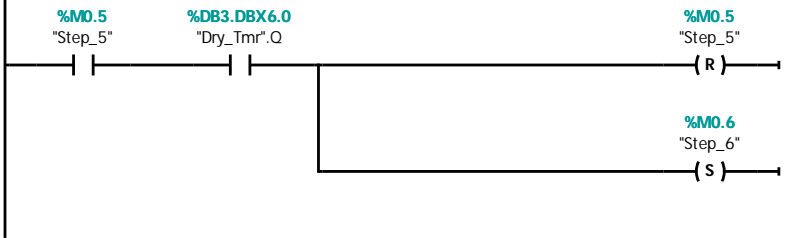
Network 8: Step 4 Push down side flaps



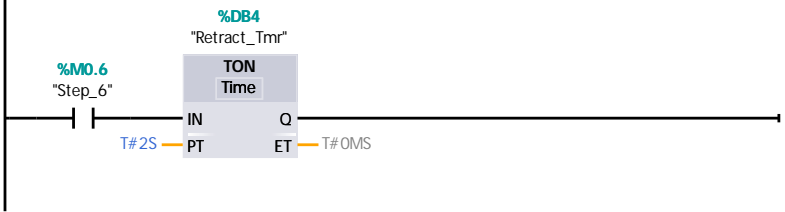
Network 9: Timer for Step 5



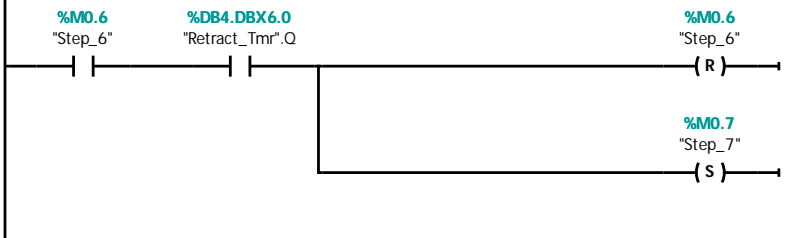
Network 10: Step 5 Drying wait



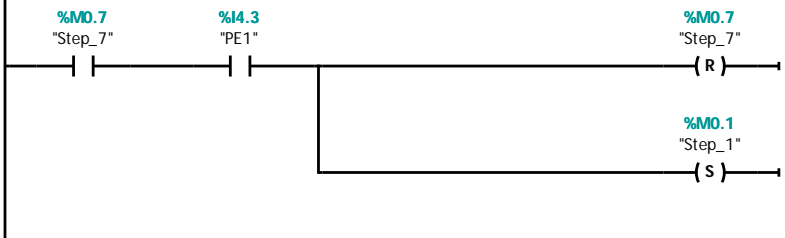
Network 11: Timer for Step 6



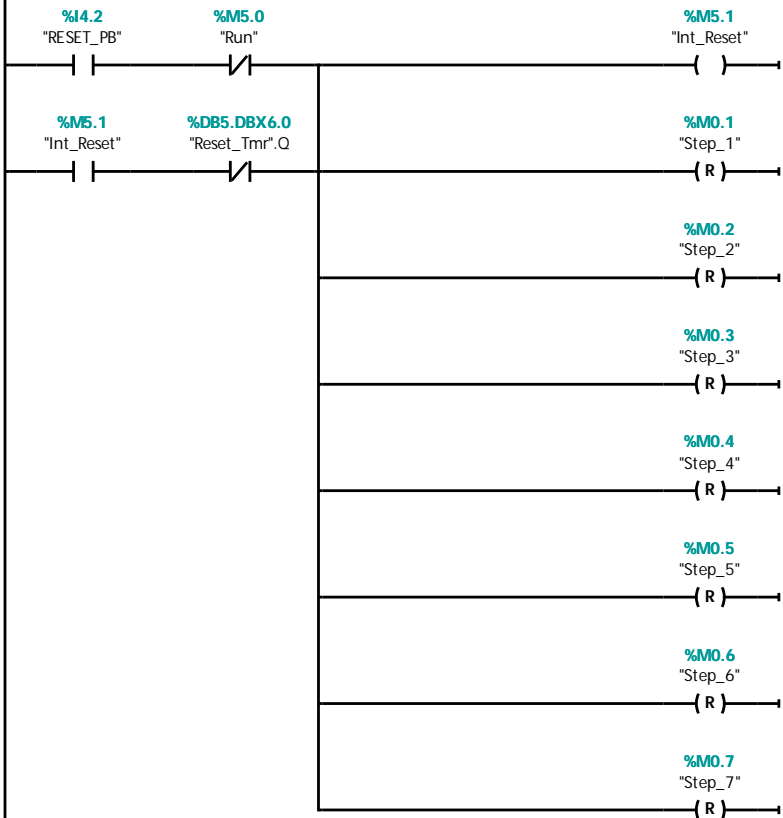
Network 12: Step 6 Retract rams



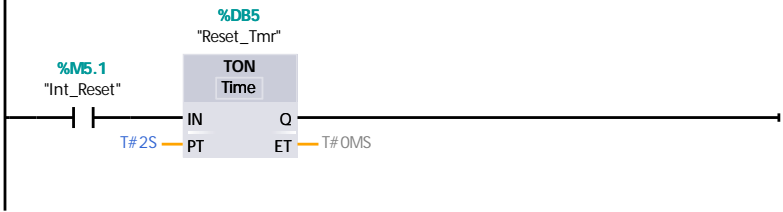
Network 13: Step 7 Move box out



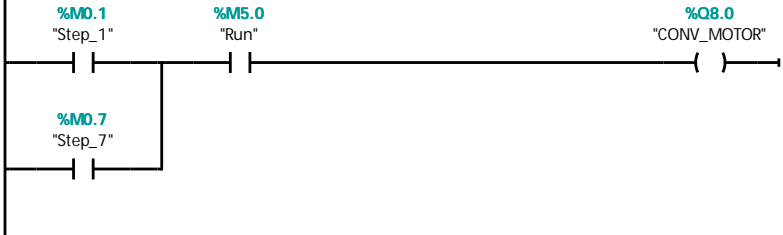
Network 14: Reset



Network 15: Reset Timer



Network 16: Conveyor motor, on to move conveyor



Network 17: Glue sprayer control, on to spray glue

%M0.3
"Step_3"

%Q8.1
"GLUE_SPRAY"



Network 18: Front flap ram extend direction control, on to extend ram

%M0.2
"Step_2"

%Q8.2
"FRONT_EXT"

%M0.3
"Step_3"

%M0.4
"Step_4"

%M0.5
"Step_5"



Network 19: Back flap ram extend direction control, on to extend ram

%M0.2
"Step_2"

%Q8.3
"BACK_EXT"

%M0.3
"Step_3"

%M0.4
"Step_4"

%M0.5
"Step_5"



Network 20: Right flap ram extend direction control, on to extend ram

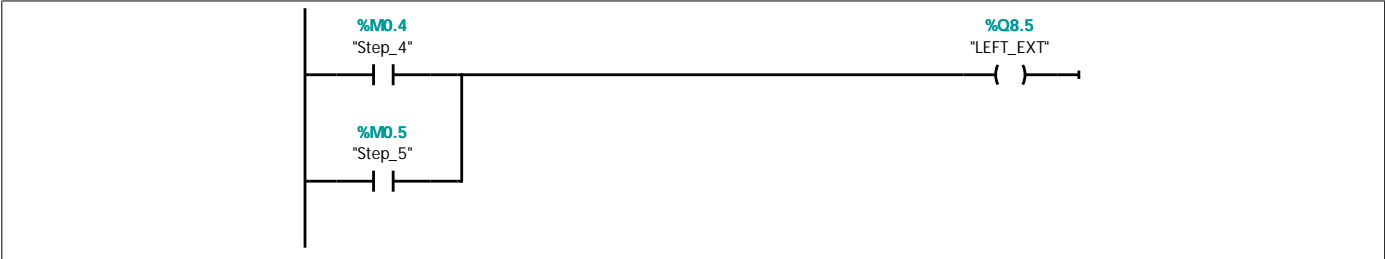
%M0.4
"Step_4"

%Q8.4
"RIGHT_EXT"

%M0.5
"Step_5"



Network 21: Left flap ram extend direction control, on to extend ram



Network 22:

