

Totally Integrated Automation Portal

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: SP6-9

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Problem SP6-9 Part Oiler Station Control

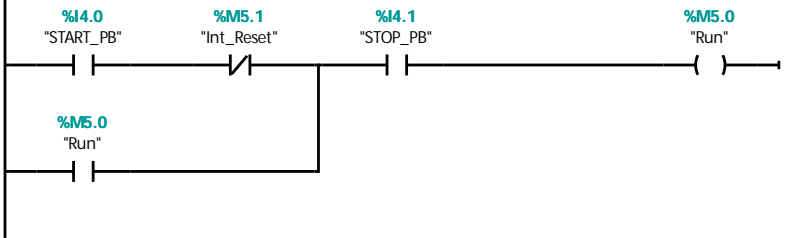
Additional internal memory:
Tag Address
Run M5.0 BOOL On while station running
Int_Reset M5.1 BOOL Internal reset
Step_1 to Step_6 M0.1 to M0.6 BOOL Step-in-progress bits
Engage_Tmr DB1 TON_SFB Times engage of part
Squirt_Tmr DB3 TON_SFB Times oil squirt

%M10.0
"Dummy"

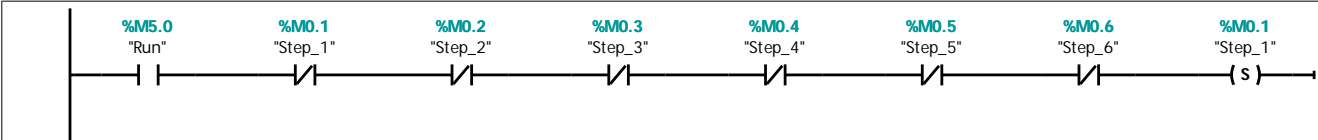
%M10.0
"Dummy"

Network 2: Start/stop

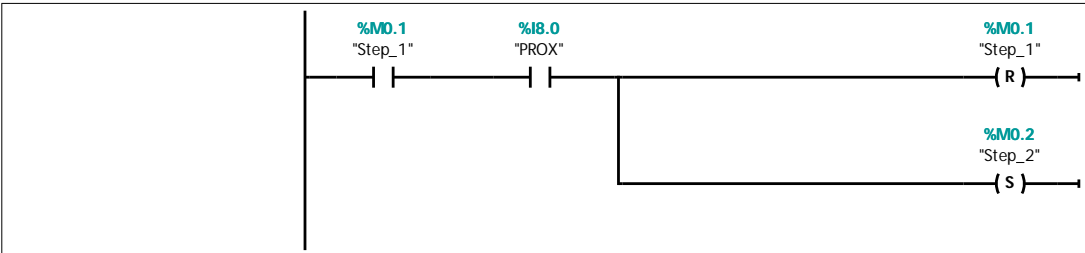
During reset prevent start



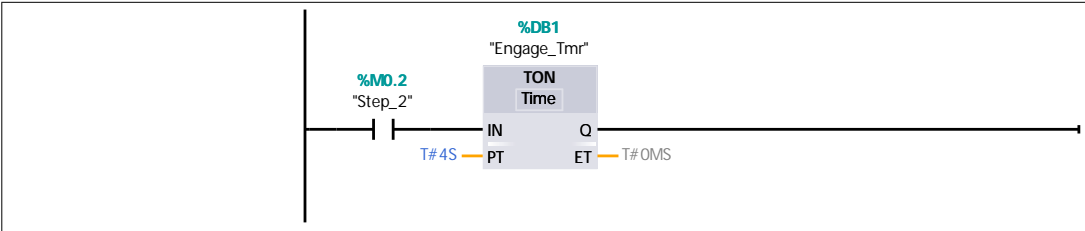
Network 3: Initial start



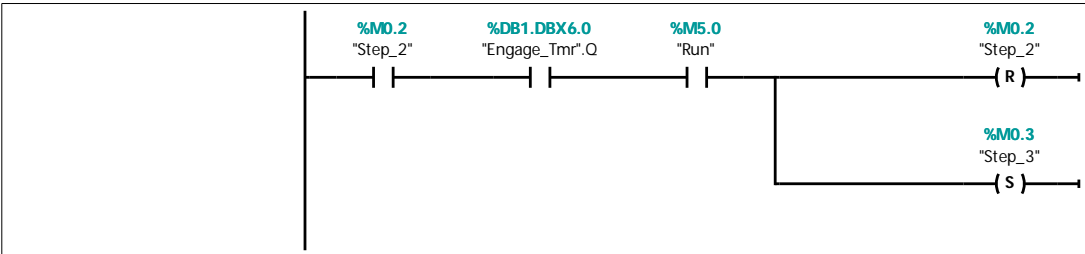
Network 4: Step 1 Wait for part



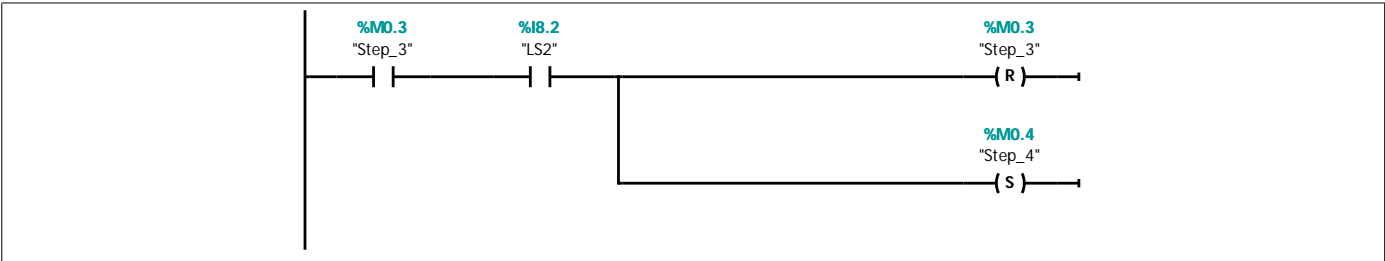
Network 5: Engage timer



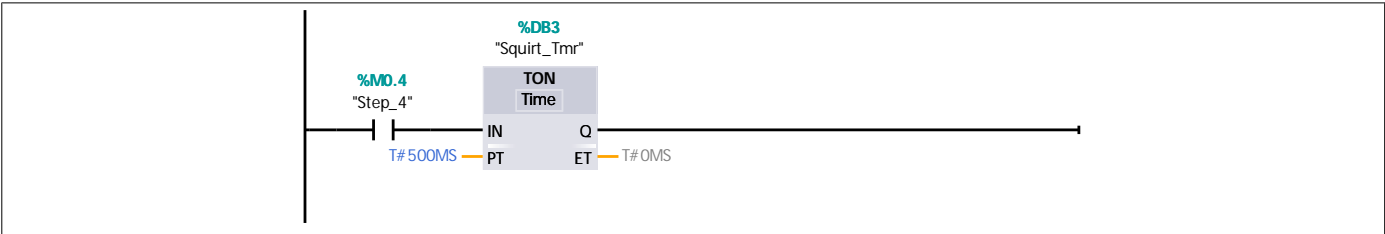
Network 6: Step 2 Wait for engage



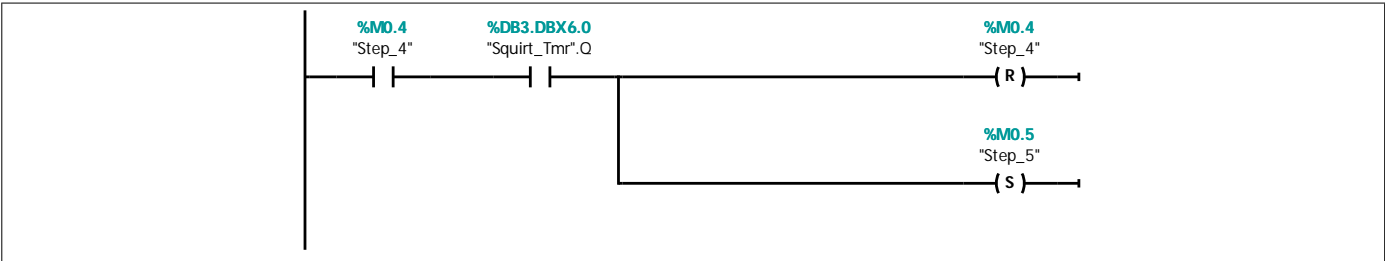
Network 7: Step 3 Lower oiler



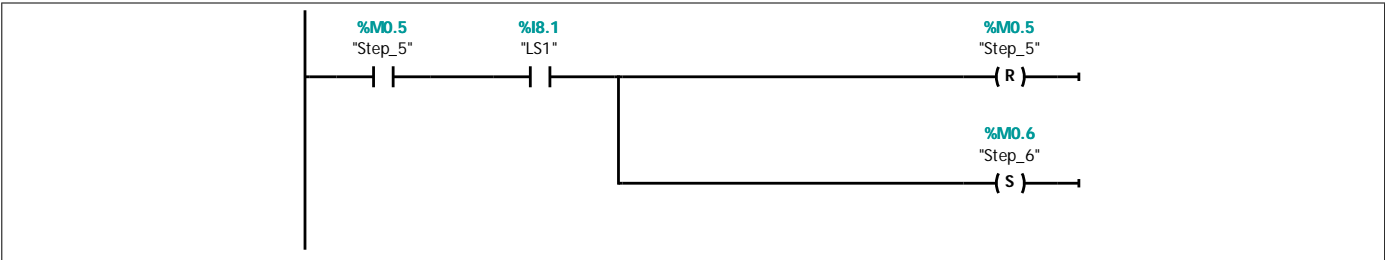
Network 8: Squirt timer



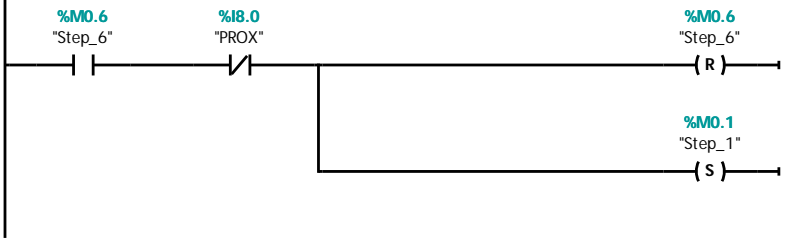
Network 9: Step 4 Squirt oil



Network 10: Step 5 Raise oiler

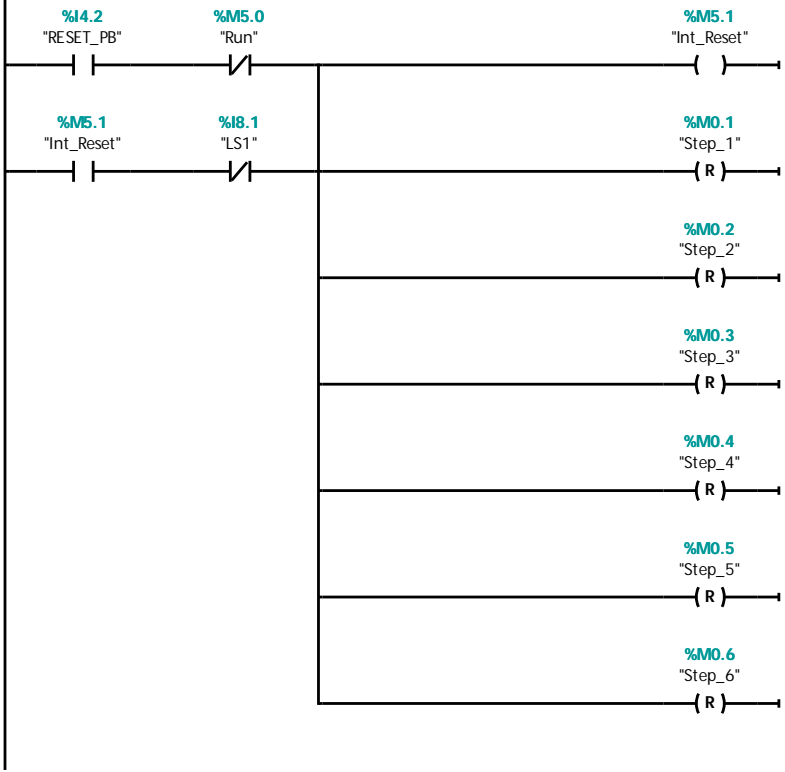


Network 11: Step 6 Part leaves



Network 12: Reset

Keep internal reset on while raising oiler tip.

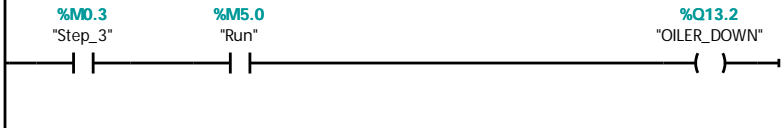


Network 13: Gate 1 cylinder control, on to open gate 1

Can not turn off when paused.

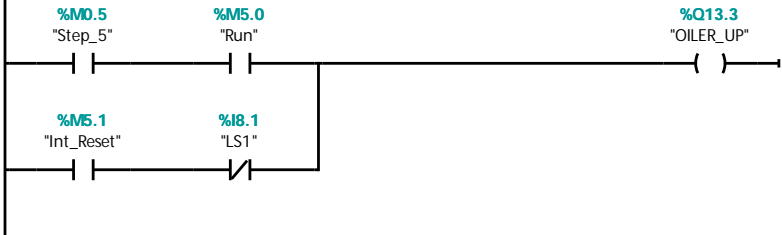


Network 14: On to lower oiler tip



Network 15: On to raise oiler tip

Raise oiler tip during reset



Network 16: On to open valve and squirt oil

Can not turn off when paused.

