

## Main\_Program [OB1]

### Main\_Program Properties

#### General

<b>Name</b>	Main_Program	<b>Number</b>	1	<b>Type</b>	OB
<b>Language</b>	LAD	<b>Numbering</b>	Manual		

#### Information

<b>Title</b>	"Main Program Sweep (Cycle)"	<b>Author</b>		<b>Comment</b>	
<b>Family</b>		<b>Version</b>	0.1	<b>User-defined ID</b>	

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: SP6-10

Copyright (c) 2011, 2015 Dogwood Valley Press, LLC

-----

Problem SP6-10 Pressing Station Control

Additional internal memory:

Tag Address

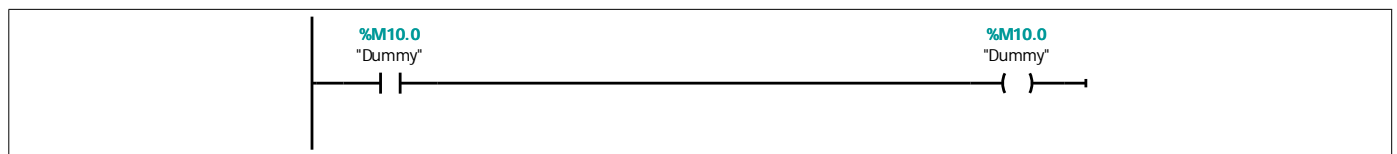
Run M5.0 BOOL On while station running

Int\_Reset M5.1 BOOL Internal reset

Step\_1 to Step\_6 M0.1 to M0.6 BOOL Step-in-progress bits

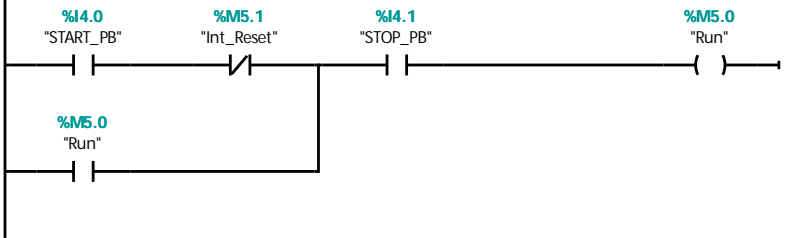
Press\_Tmr DB1 TON\_SFB Times pressing step

Cool\_Tmr DB3 TON\_SFB Times cool down

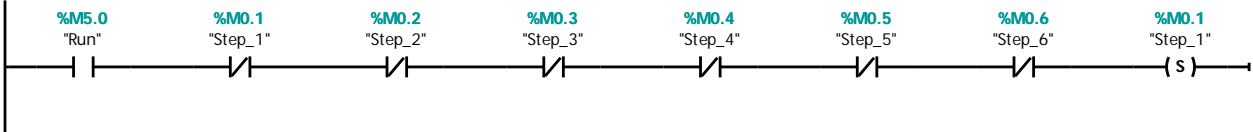


### Network 2: Start/stop

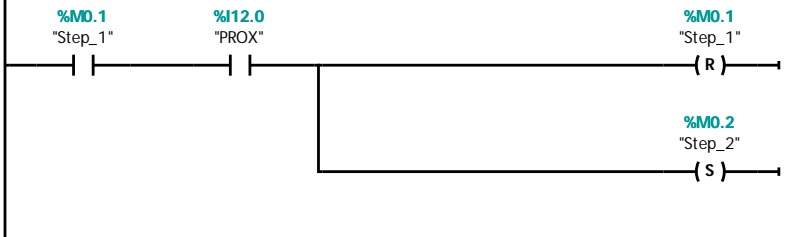
During reset prevent start



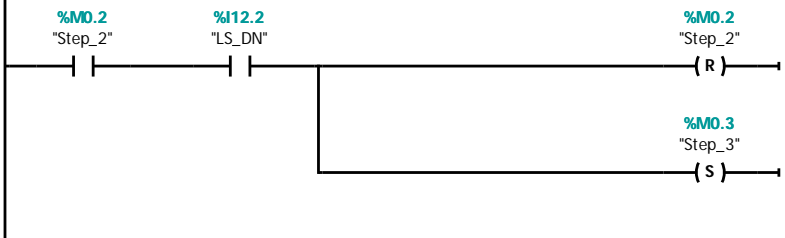
Network 3: Initial start



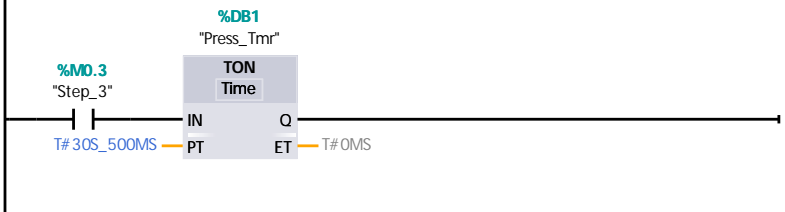
Network 4: Step 1 Move in piece



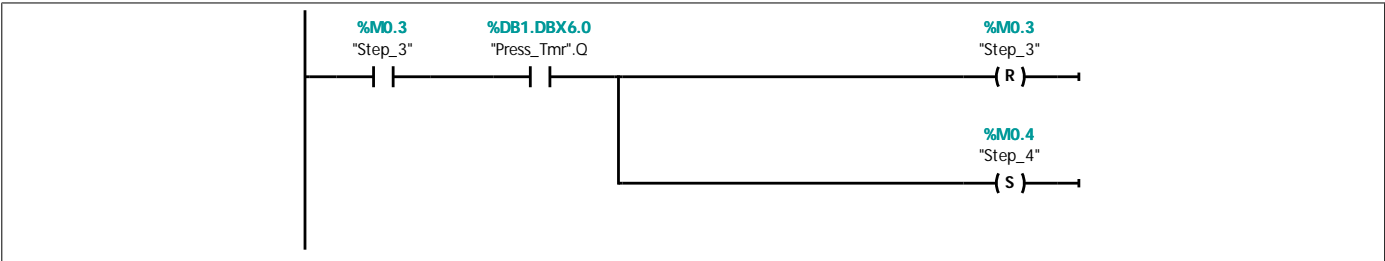
Network 5: Step 2 Lower press



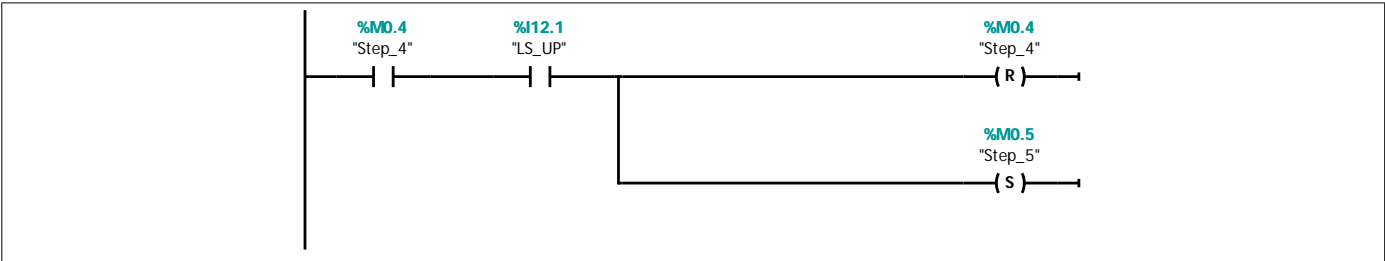
Network 6: Press timer



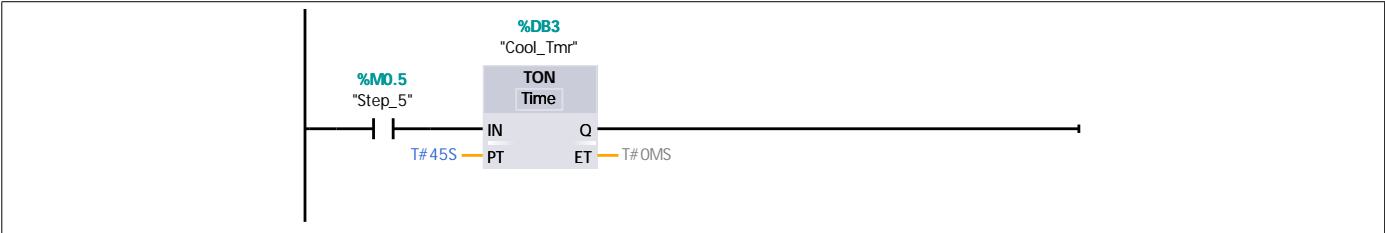
Network 7: Step 3 Press piece



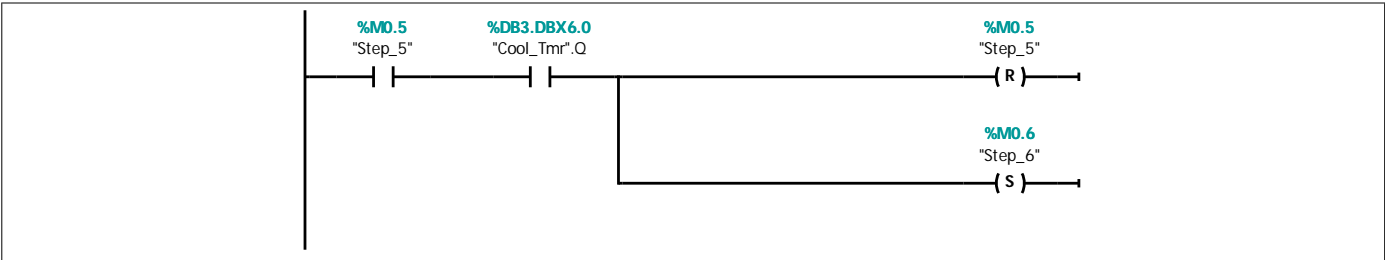
Network 8: Step 4 Raise press



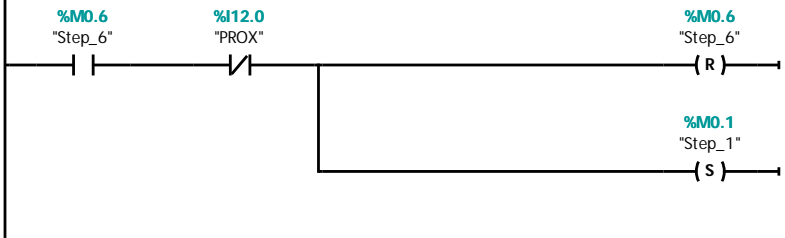
Network 9: Cool timer



Network 10: Step 5 Cool down

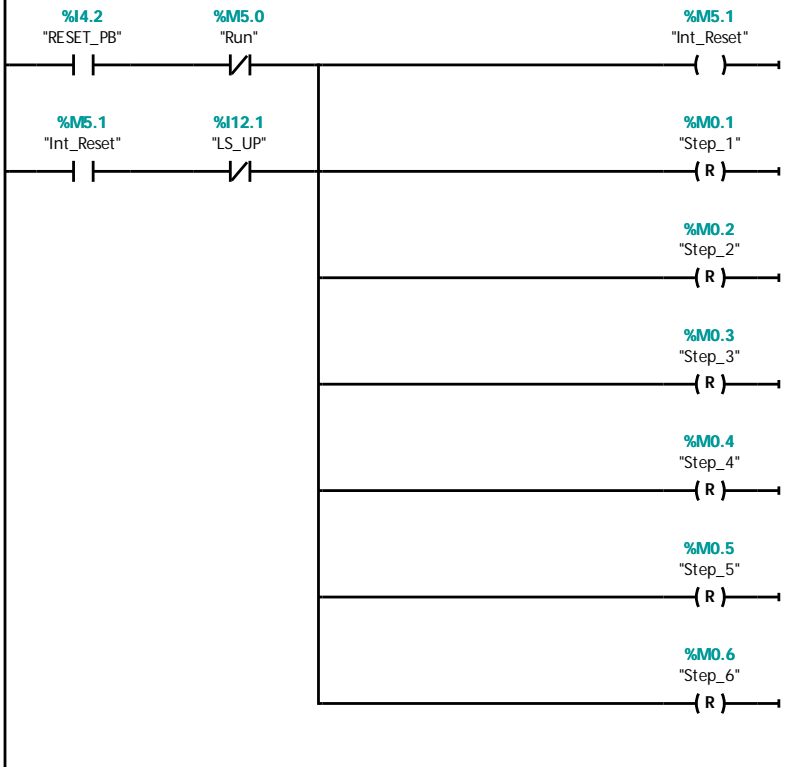


Network 11: Step 6 Move out piece



**Network 12: Reset**

Keep internal reset on while raising press.

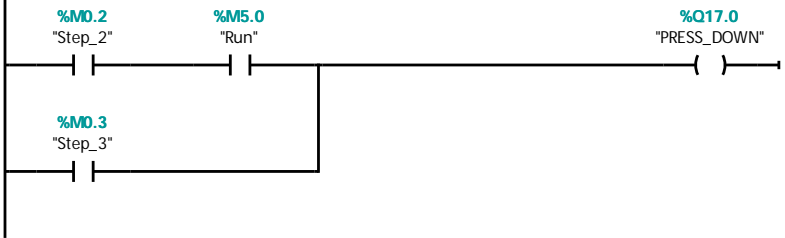


**Network 13: Infeed conveyor motor control, on to run conveyor motor**



**Network 14: Press cylinder control, on to lower press**

Can not pause in Step 3



**Network 15: On to open valve that directs steam into die**

Can not turn off when paused.

