

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:

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Problem SP6-13 Erbia Can Tipper/Rotator Control

Additional internal memory:

Tag Address

Run M5.0 BOOL On while station running

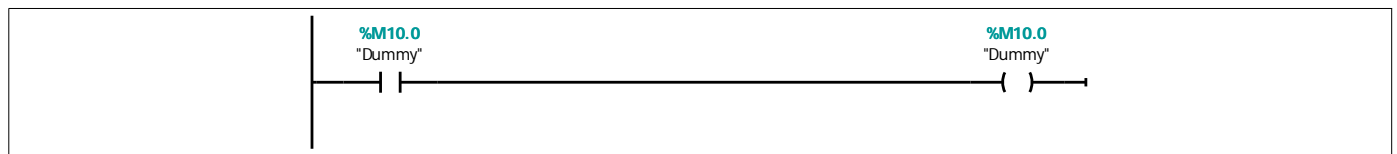
Int_Reset M5.1 BOOL Internal reset

Step_1 to Step_9 M0.1 to M1.1 BOOL Step-in-progress bits

Retract_Tmr DB1 TON_SFB Times CYL_4 retract

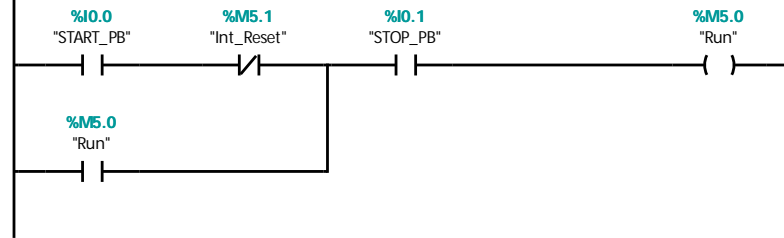
Blend_Tic DB3 TON_SFB Tic timer for blend retentive timer

Blend_Ctr DB6 CTU_SFB Counter for blend retentive timer

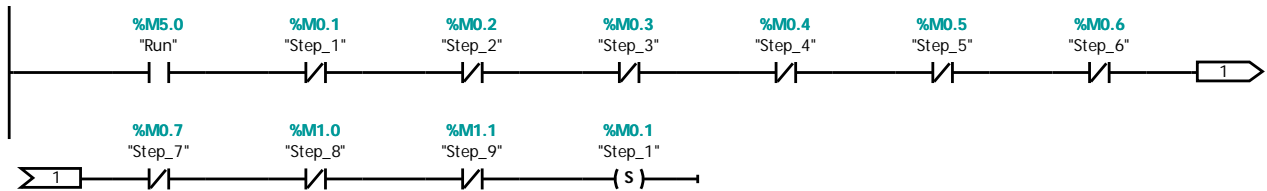


Network 2: Start/stop

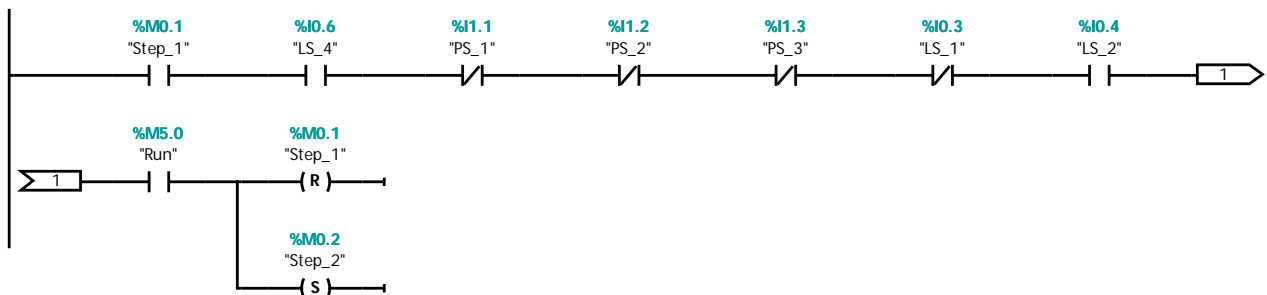
During reset prevent start



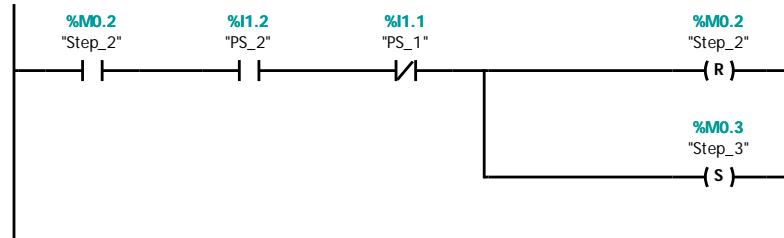
Network 3: Initial start



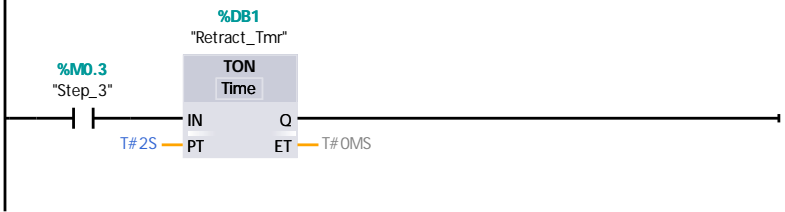
Network 4: Step 1 Wait for can



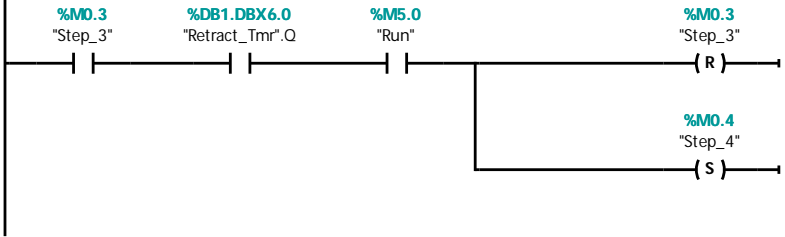
Network 5: Step 2 Push can into tipper.



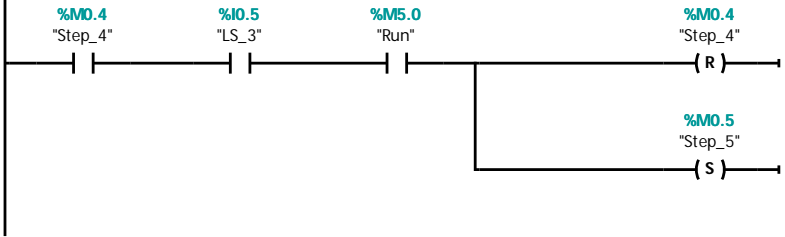
Network 6: Retract timer



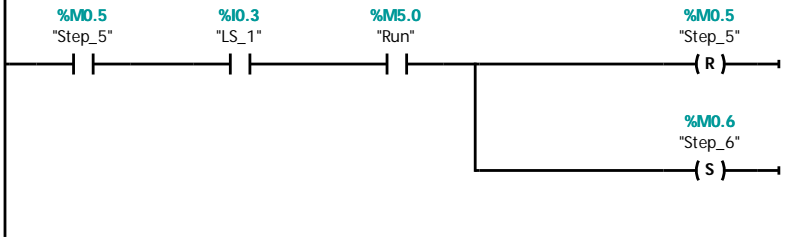
Network 7: Step 3 Wait for CYL_4 to retract



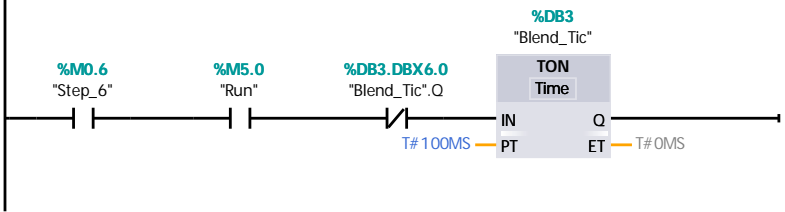
Network 8: Step 4 Clamp can



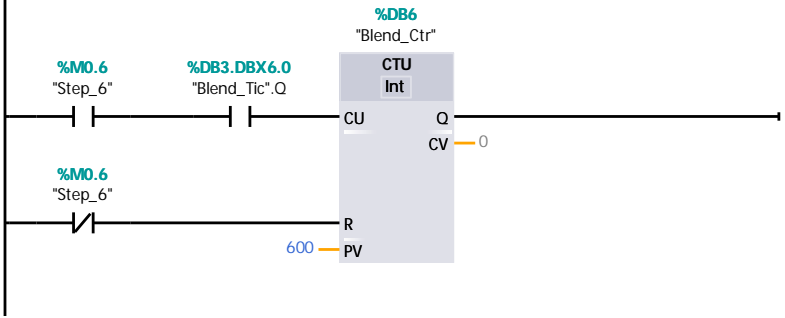
Network 9: Step 5 Tip rotator



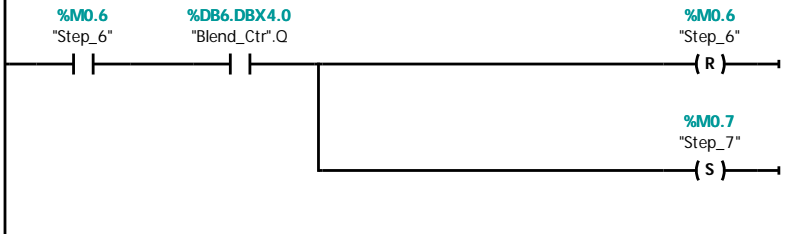
Network 10: Blend tic for retentive timer



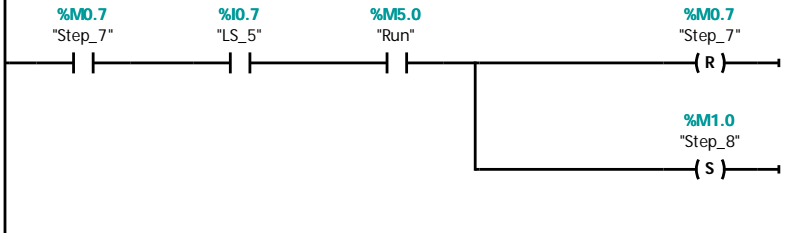
Network 11: Counter for retentive blend timer



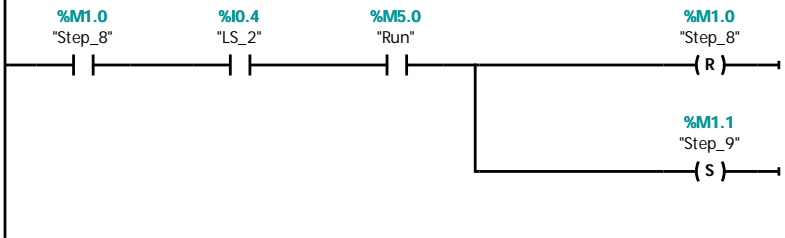
Network 12: Step 6 Blend



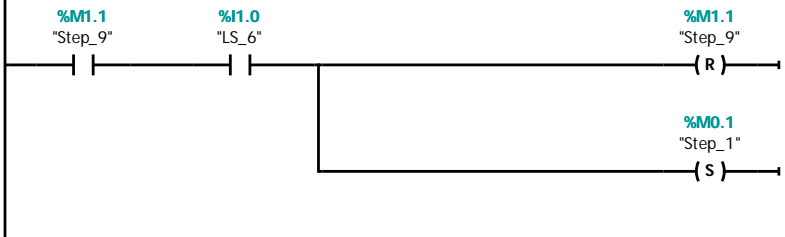
Network 13: Step 7 Untip



Network 14: Step 8 Unclamp

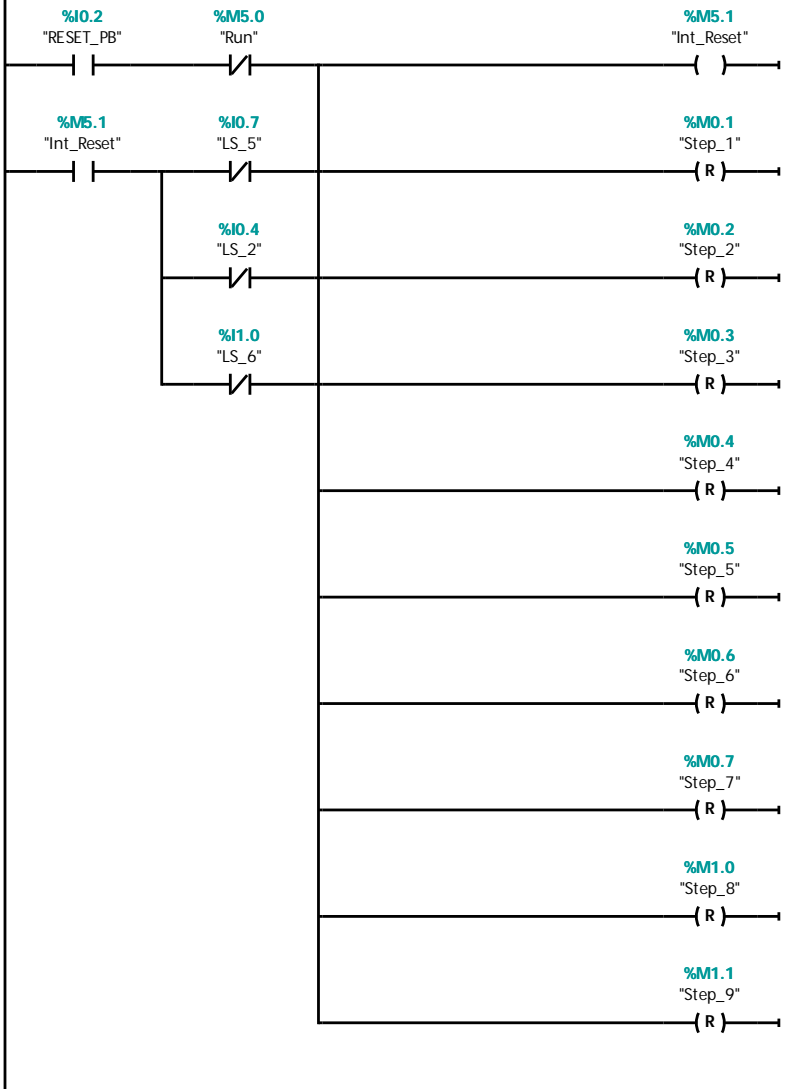


Network 15: Step 9 - Push out



Network 16: Reset

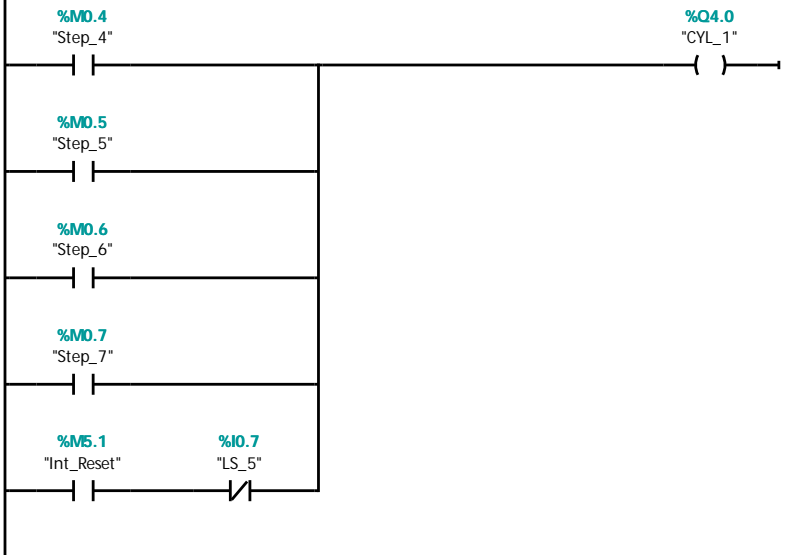
Keep internal reset on until can unclamped, vertical and out of station.



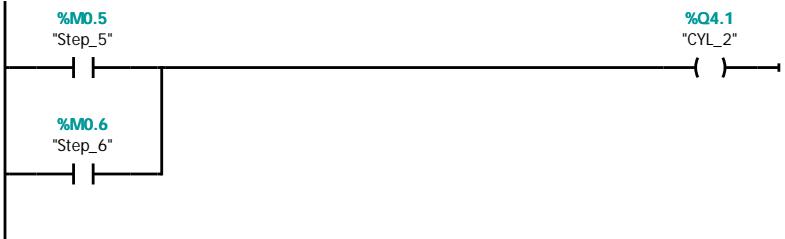
Network 17: Physical Outputs

Gate cylinder controls. Cannot turn off CYL_1 to CYL_3 when paused.

On reset, do not unclamp until vertical.

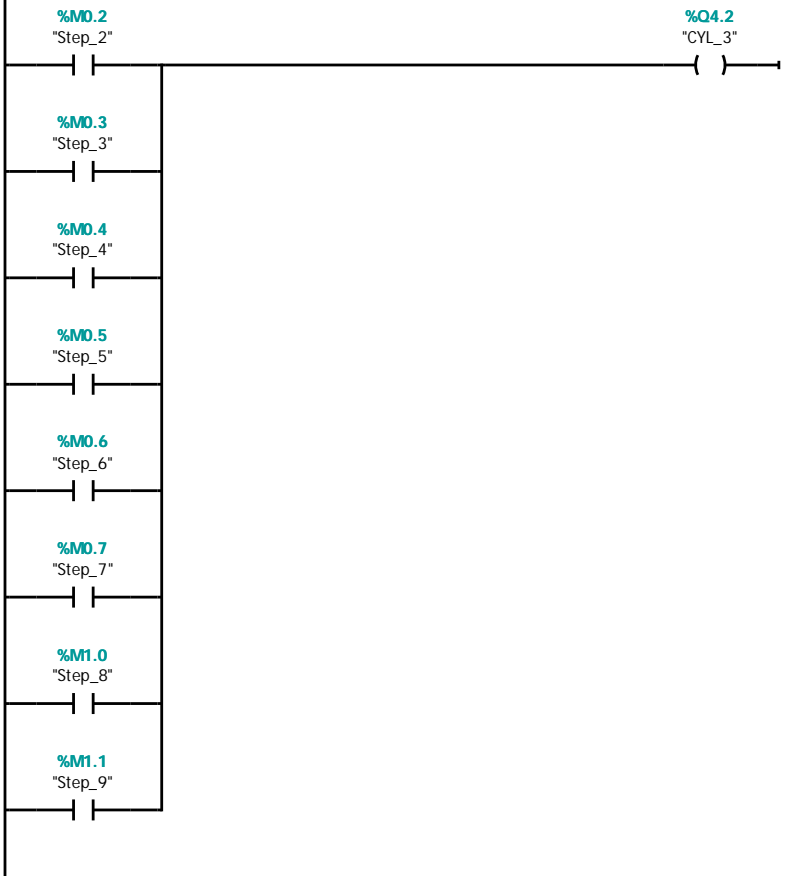


Network 18: CYL_2 control



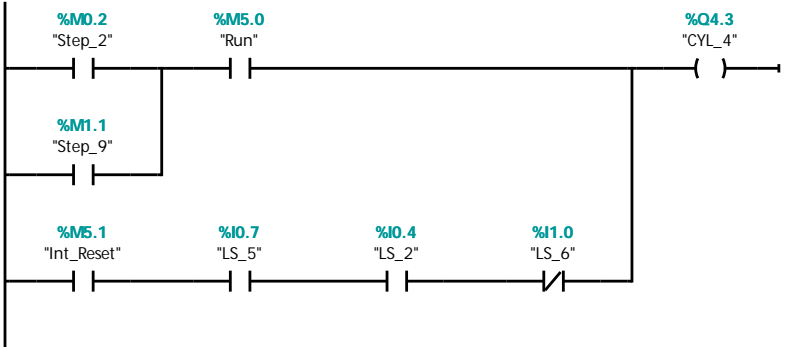
Network 19: CYL_3 control

Retract on reset



Network 20: CYL_4 control

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



Network 21: Rotator motor control

Retract on reset

