

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: SP6-3

Problem SP6-3 Parts Transfer Station Control

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Additional internal memory:

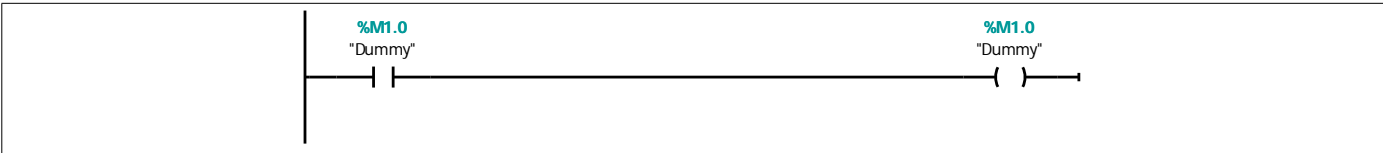
Tag Address

Run M3.1 BOOL On while station running

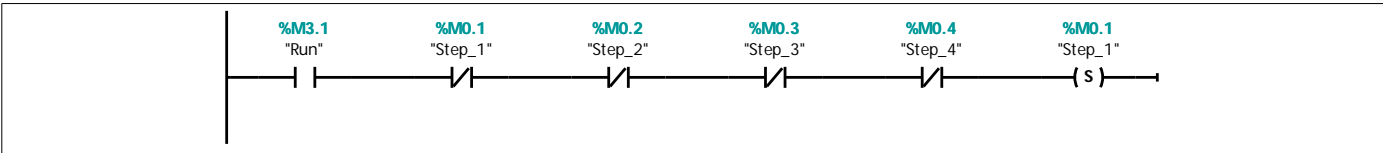
Step_1 to Step_4 M0.1 to M0.4 BOOL Step-in-progress bits

Motor1_Tmr DB1 TON_SFB Times rotation of table

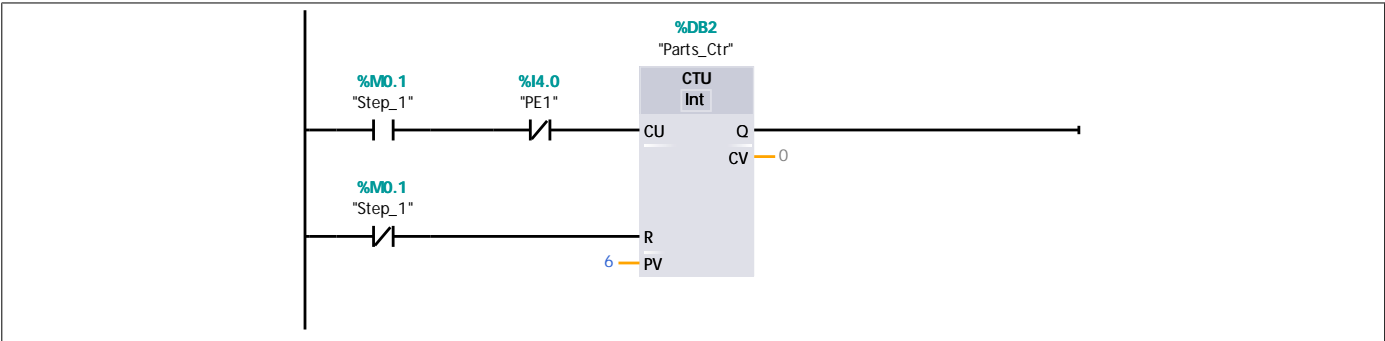
Parts_Ctr DB2 CTU_SFB Counts parts going to table



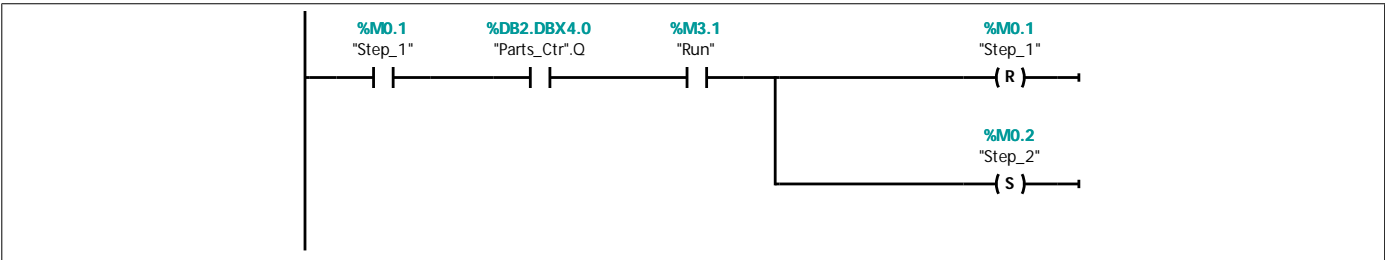
Network 2: Initial start



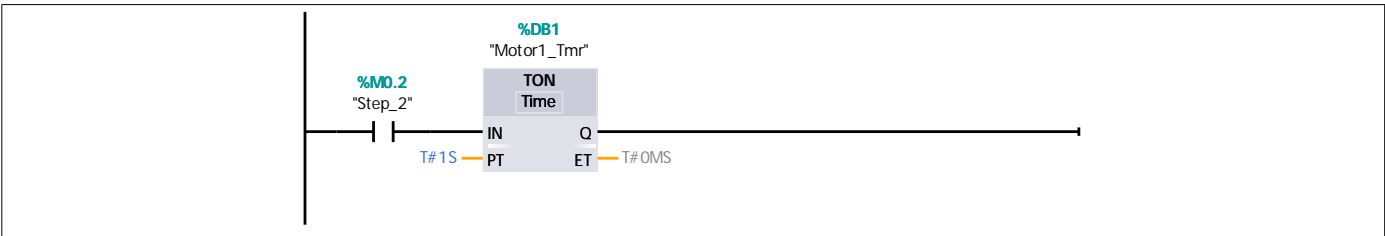
Network 3: Part Counter



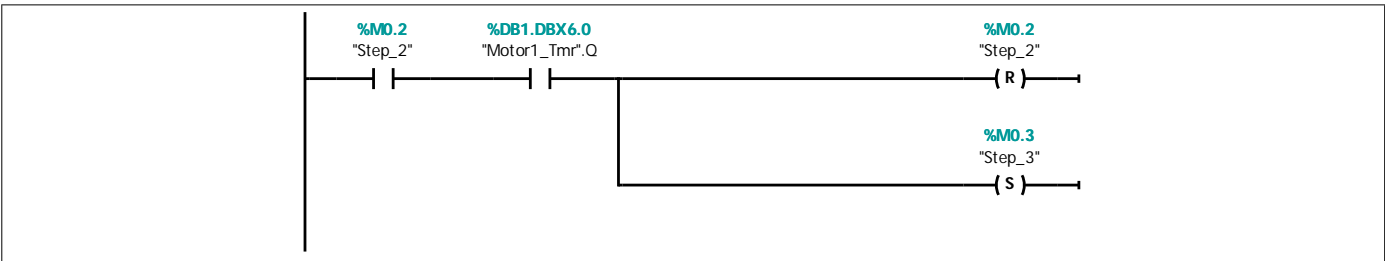
Network 4: Step 1 Count parts



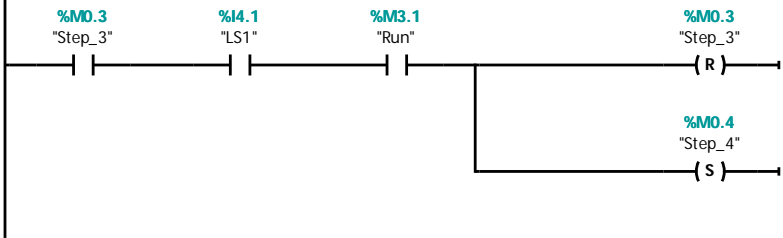
Network 5: Rotate Table timer



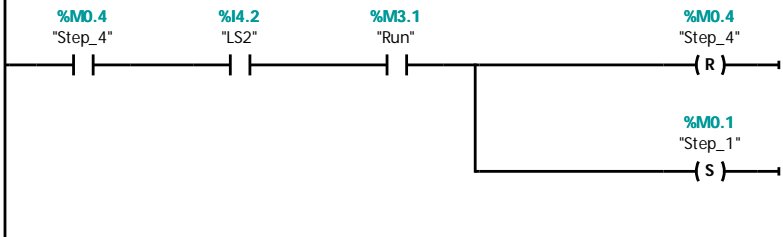
Network 6: Step 2 Rotate Table



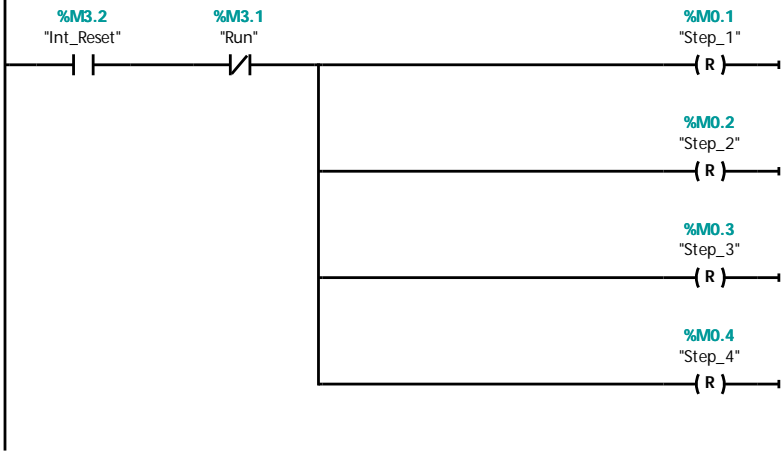
Network 7: Step 3 Extend Ram



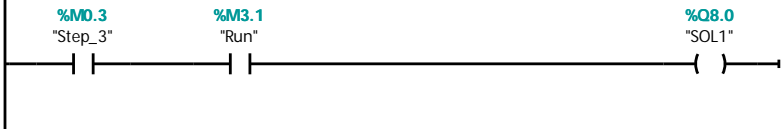
Network 8: Step 4 Retract Ram



Network 9: Reset



Network 10: Pneumatic ram extension solenoid control, on to extend ram



Network 11: Turntable motor control, on to turn turntable

%M0.2
"Step_2"

%Q8.1
"MOTOR1"



Network 12: Belt conveyor motor control, on to run conveyor

%M0.1
"Step_1"

%M3.1
"Run"

%Q8.2
"MOTOR2"

