

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: SP6-14

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Problem SP6-14 Pick-and-Place Machine Control

Additional internal memory:

Tag Address

Run M5.0 BOOL On while station running

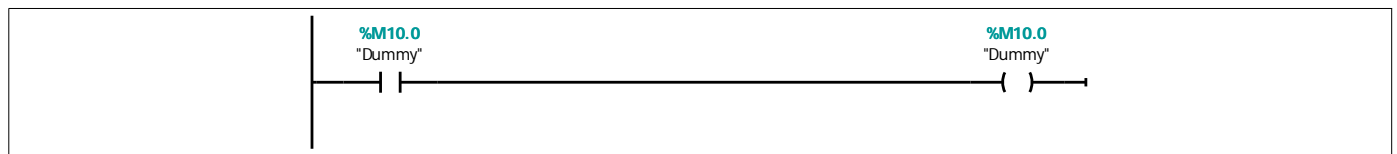
Int_Reset M5.1 BOOL Internal reset

Step_1 to Step_10 M0.1 to M1.2 BOOL Step-in-progress bits

Clamp_Tmr DB1 TON_SFB Times clamping

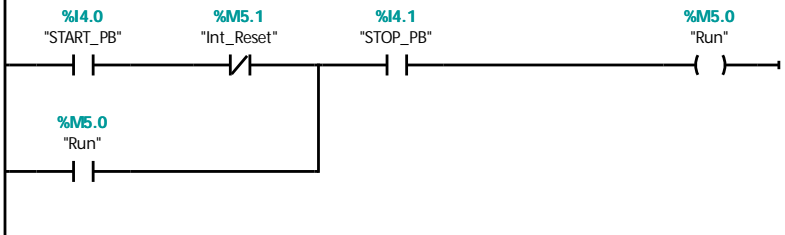
Unclamp_Tmr DB3 TON_SFB Times unclamp

Reset_Tmr DB4 TON_SFB Times unclamp during reset



Network 2: Start/stop

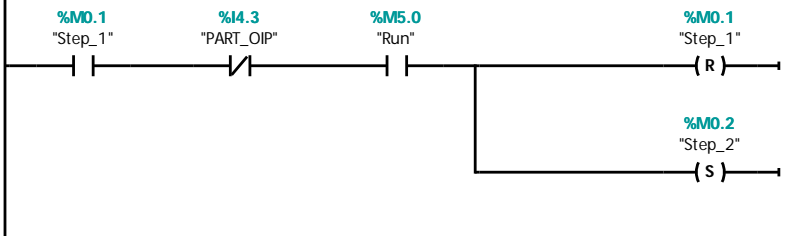
During reset prevent start



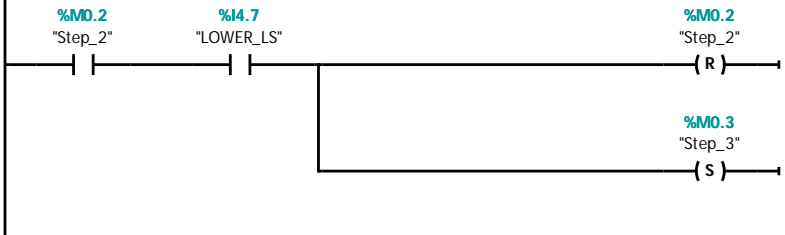
Network 3: Initial start



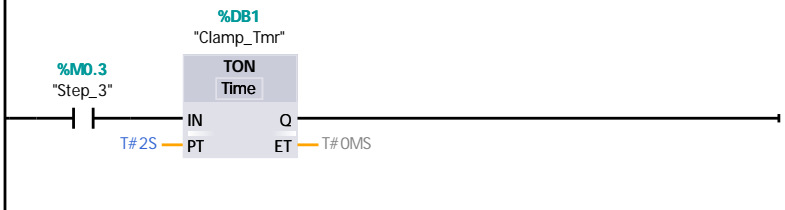
Network 4: Step 1 Wait for part ready.



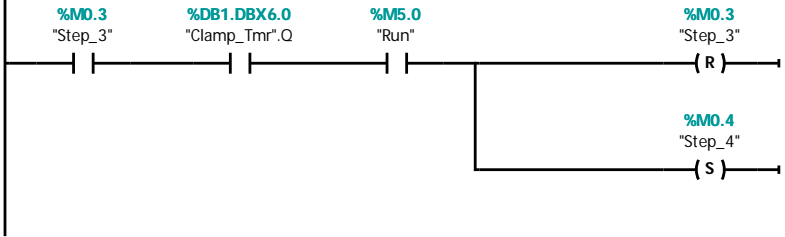
Network 5: Step 2 Lower to left table



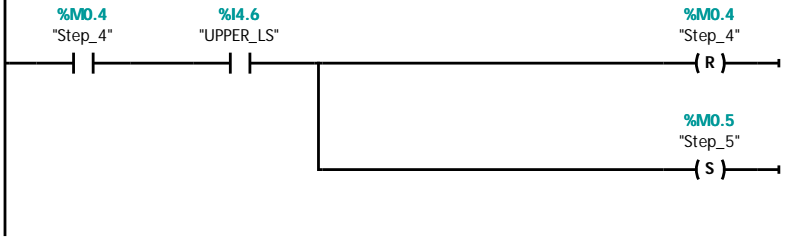
Network 6: Clamp timer



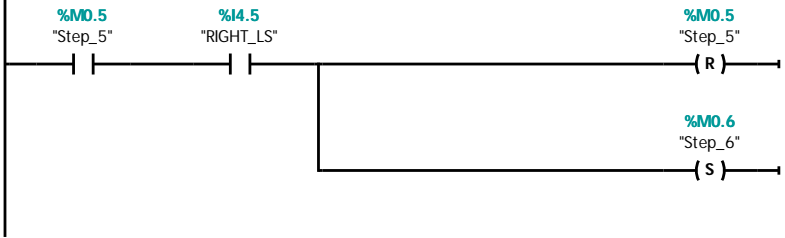
Network 7: Step 3 Clamp part



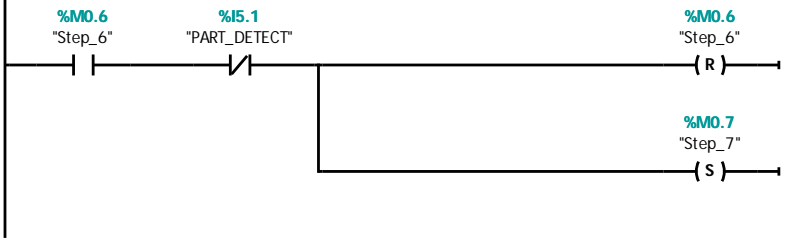
Network 8: Step 4 Raise to home



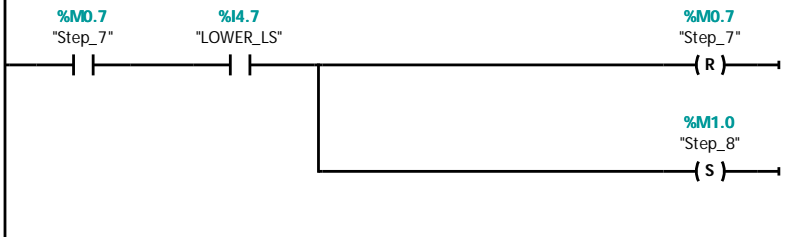
Network 9: Step 5 Move to right



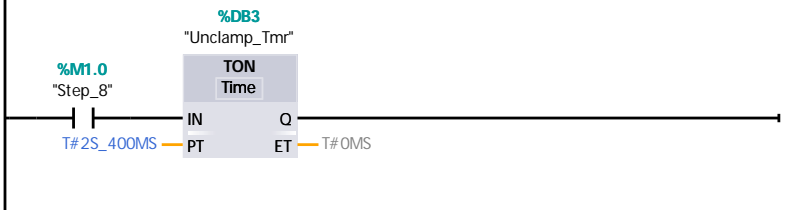
Network 10: Step 6 Wait for part removed



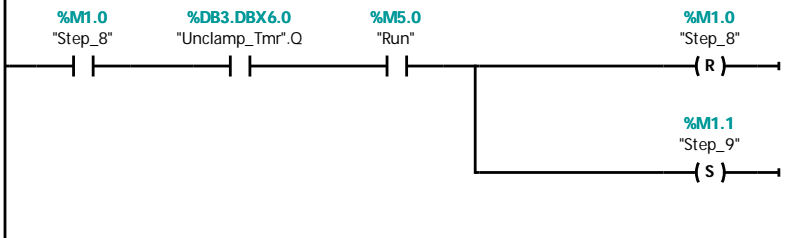
Network 11: Step 7 Lower to right table



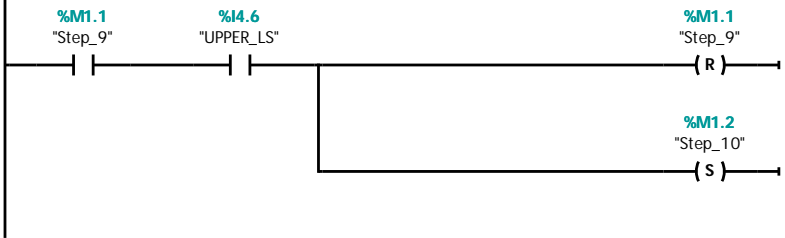
Network 12: Unclamp timer



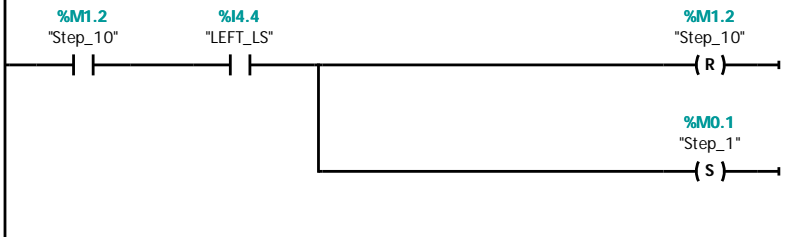
Network 13: Step 8 Unclamp



Network 14: Step 9 Raise

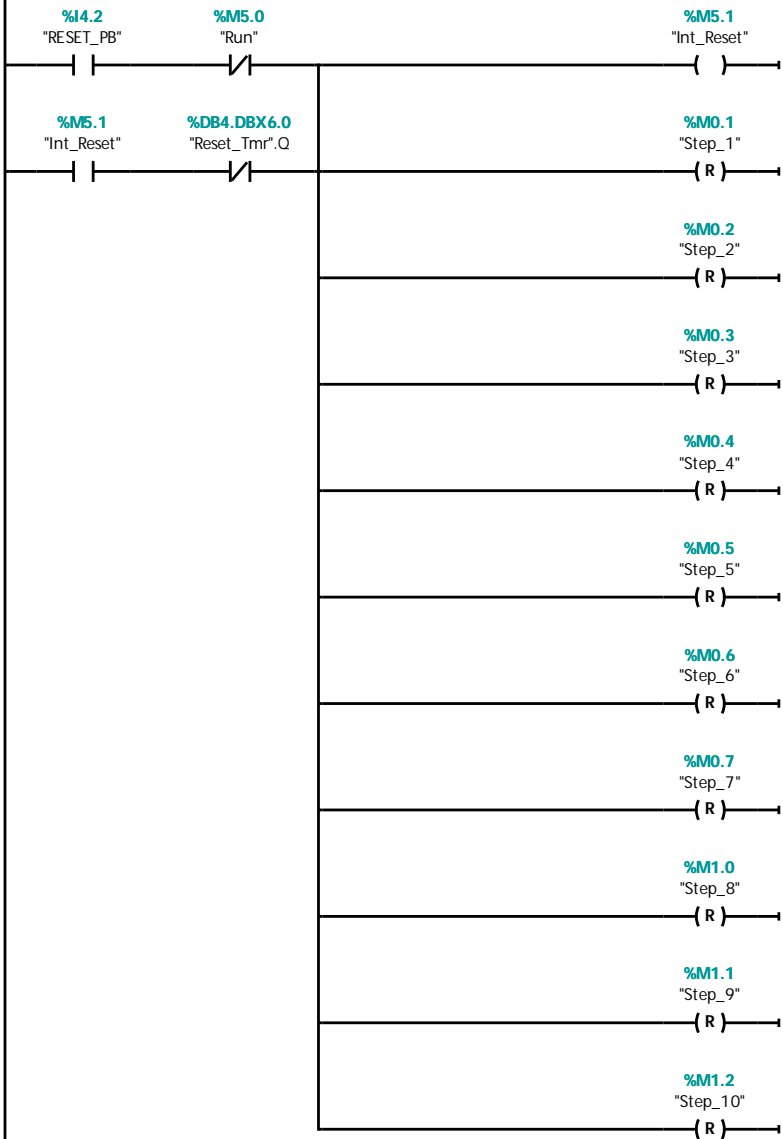


Network 15: Step 10 Move to left

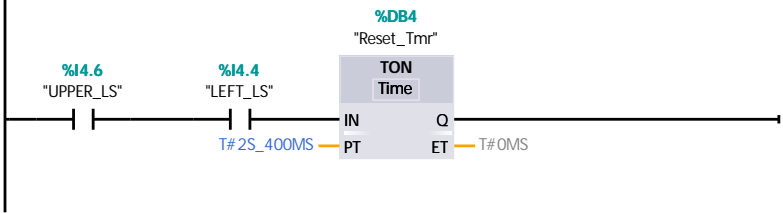


Network 16: Reset

Keep internal reset on while cylinders are not retracted.

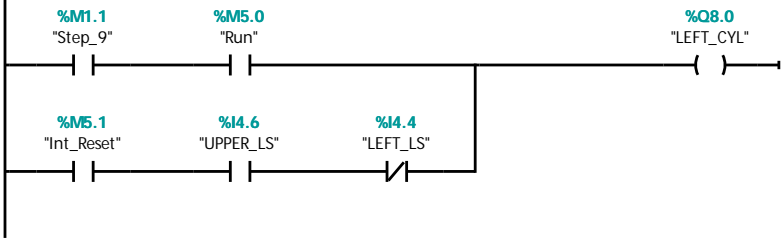


Network 17: Reset timer

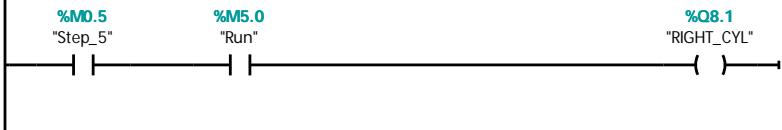


Network 18: Left cylinder control

When reset, do not move until fully up.

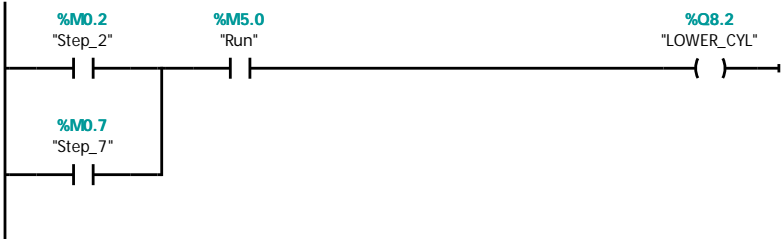


Network 19: Right cylinder control

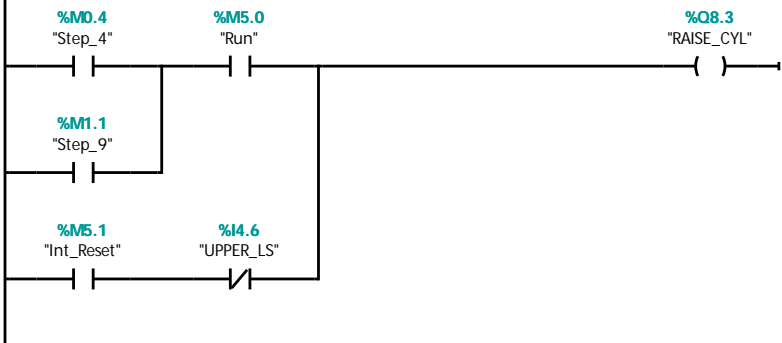


Network 20: Lowering cylinder control

Retract on reset



Network 21: Raise cylinder control



Network 22: Clamp cylinder control

Maintain clamp while moving home during reset.

