

OB1 - <offline>

"Cycle Execution"

Name:

Author:

Time stamp Code:

Interface:

Lengths (block/logic/data):

Family:

Version: 0.1

Block version: 2

06/26/2011 07:43:30 PM

03/29/2003 05:35:22 PM

00522 00362 00032

Name	Data Type	Address	Comment
TEMP		0.0	
OB1_EV_CLASS	Byte	0.0	Bits 0-3 = 1 (Coming event), Bits 4-7 = 1 (Event class 1)
OB1_SCAN_1	Byte	1.0	1 (Cold restart scan 1 of OB 1), 3 (Scan 2-n of OB 1)
OB1_PRIORITY	Byte	2.0	Priority of OB Execution
OB1_OB_NUMBR	Byte	3.0	1 (Organization block 1, OB1)
OB1_RESERVED_1	Byte	4.0	Reserved for system
OB1_RESERVED_2	Byte	5.0	Reserved for system
OB1_PREV_CYCLE	Int	6.0	Cycle time of previous OB1 scan (milliseconds)
OB1_MIN_CYCLE	Int	8.0	Minimum cycle time of OB1 (milliseconds)
OB1_MAX_CYCLE	Int	10.0	Maximum cycle time of OB1 (milliseconds)
OB1_DATE_TIME	Date_And_Time	12.0	Date and time OB1 started
Temp1	Bool	20.0	Temp bool 1
Temp2	Bool	20.1	Temps bool 2

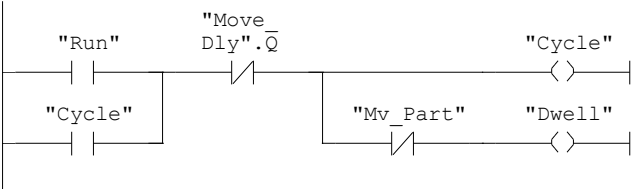
Block: OB1 "Main Program Sweep (Cycle)"

Example 8.1 Defect Tracking

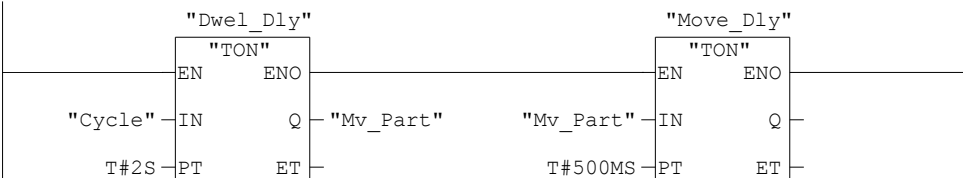
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Network: 1

Generate part dwell and part move indications. If Run turns off, finish cycle.

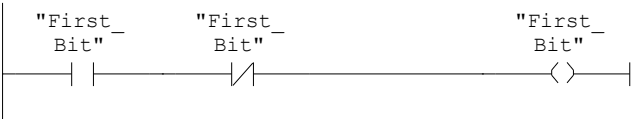


Network: 2

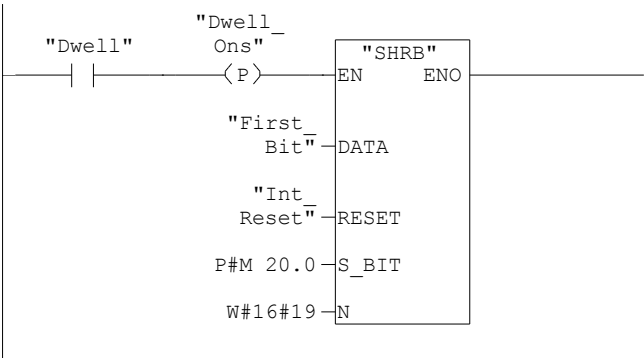


Network: 3

Shift defect indications left one position. Always shift in a zero.

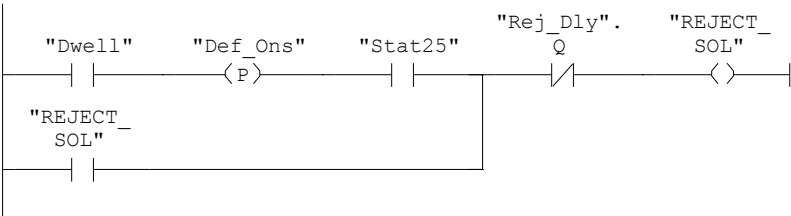


Network: 4



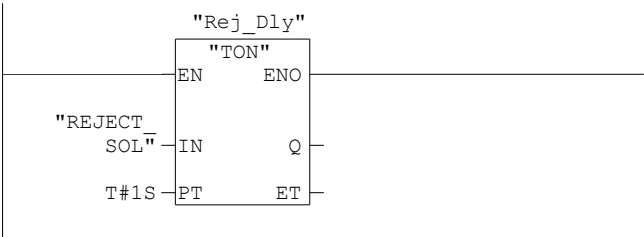
Network: 5

If defective at station 25, hold solenoid for 1 second to kick it off

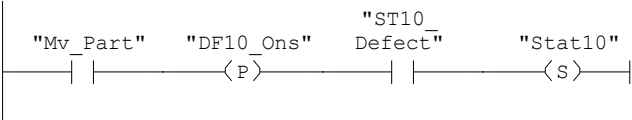


Network: 6

Times reject solenoid



Network: 7
Set station 10 defect on rising edge of when part is moved



Network: 8
Use SW3 for Run

