

OB1 - <offline>

"Main_Program"

Name:	Family:
Author:	Version: 0.1
	Block version: 2
Time stamp Code:	06/26/2011 07:45:58 PM
Interface:	02/15/1996 04:51:12 PM
Lengths (block/logic/data):	01852 01654 00030

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

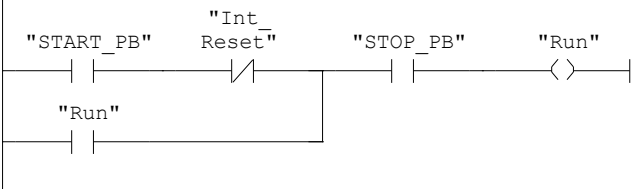
Block: OB1 "Main Program Sweep (Cycle)"

Example 9.1 Engine Inverter with counter-based sequencer

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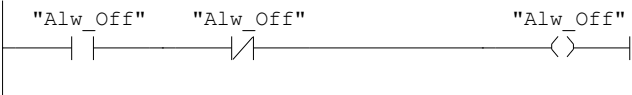
Network: 1

Start/stop/pause. Start prevented if reset in progress.



Network: 2

Always Off Logic



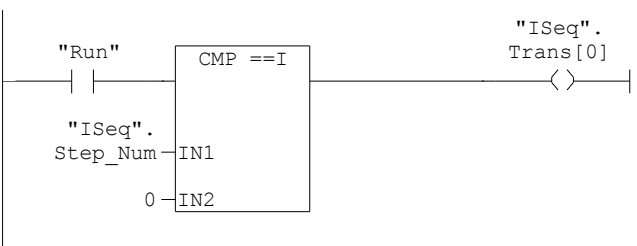
Network: 3

Always On Logic



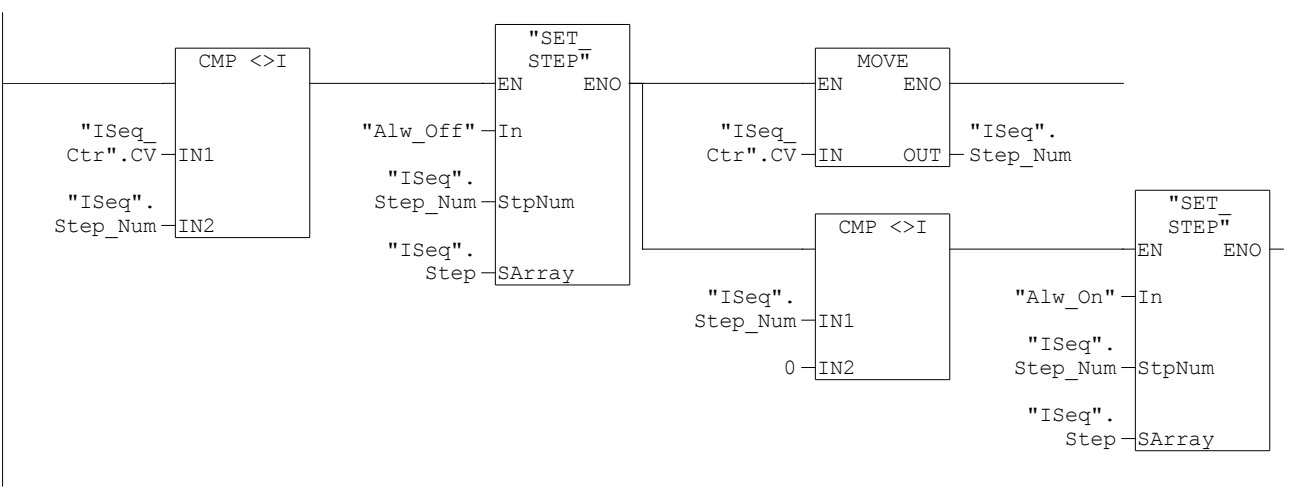
Network: 4

First Start - transition out of initial step to step 1.



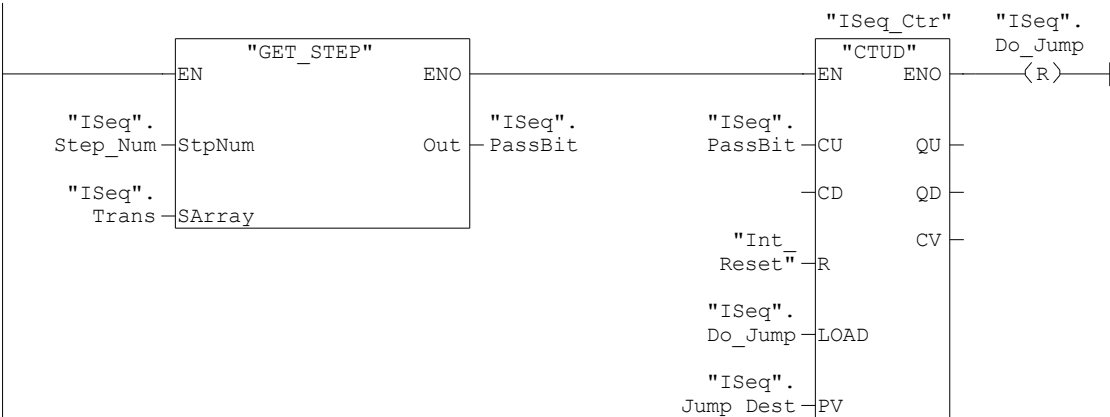
Network: 5

Change step-in-progress bit when step changes.



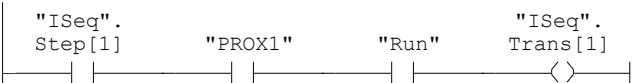
Network: 6

Increment to next step when step-done bit set. Also handle jumps.



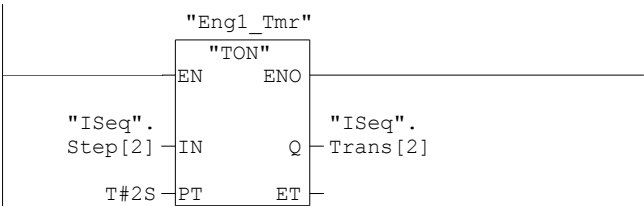
Network: 7

Step 1 - Wait for pallet.



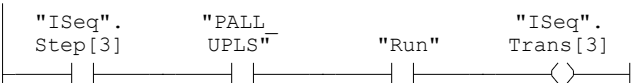
Network: 8

Step 2 - Move to hook 2



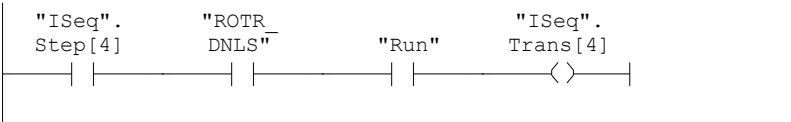
Network: 9

Step 3 - Raise pallet



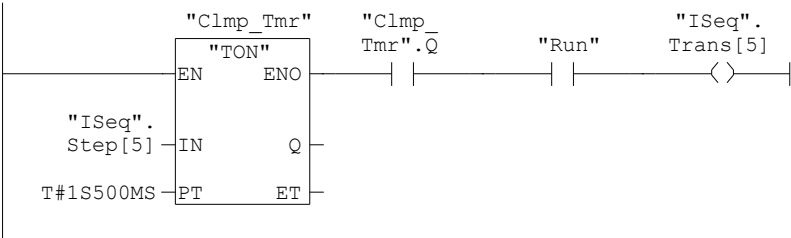
Network: 10

Step 4 - Lower rotator



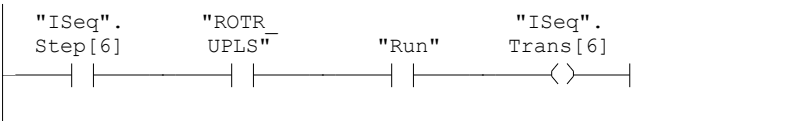
Network: 11

Step 5 - Clamp engine



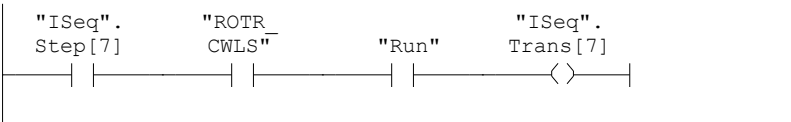
Network: 12

Step 6 - Raise rotator



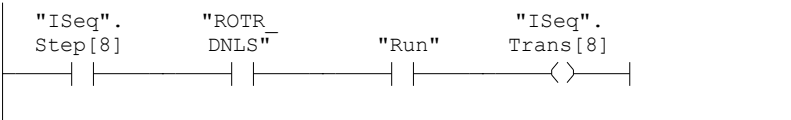
Network: 13

Step 7 - Rotate CW



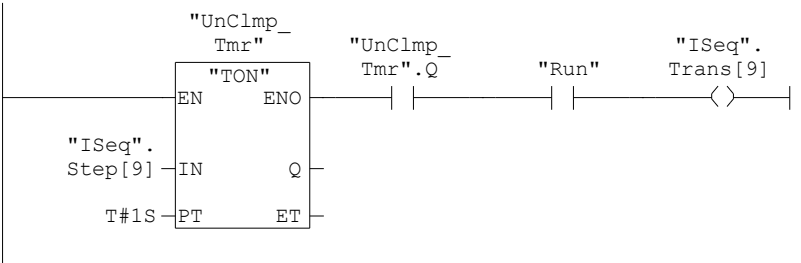
Network: 14

Step 8 - Lower rotator



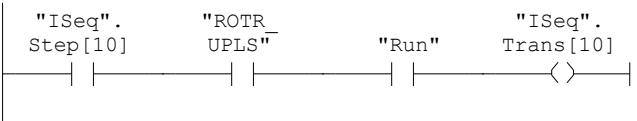
Network: 15

Step 9 - Unclamp engine.



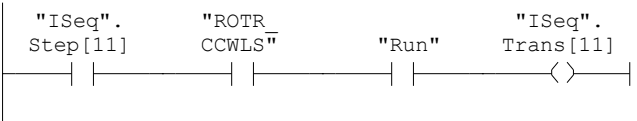
Network: 16

Step 10 - Raise rotator.



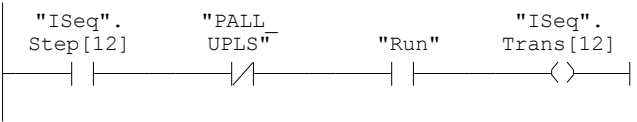
Network: 17

Step 11 - Rotate CW



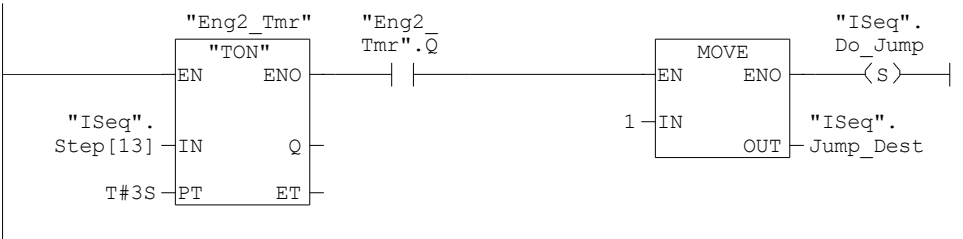
Network: 18

Step 12 - Drop engine.



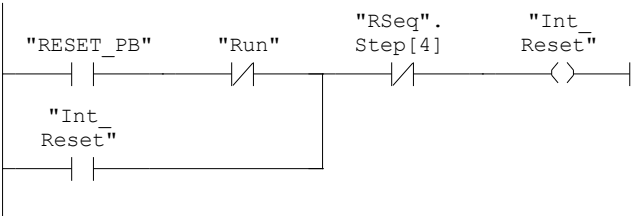
Network: 19

Step 13 - Move out pallet, then jump to step 1



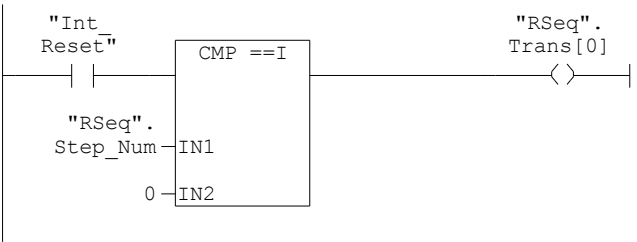
Network: 20

Start/stop for reset operation. Reset pb starts, reset step 4 stops it.



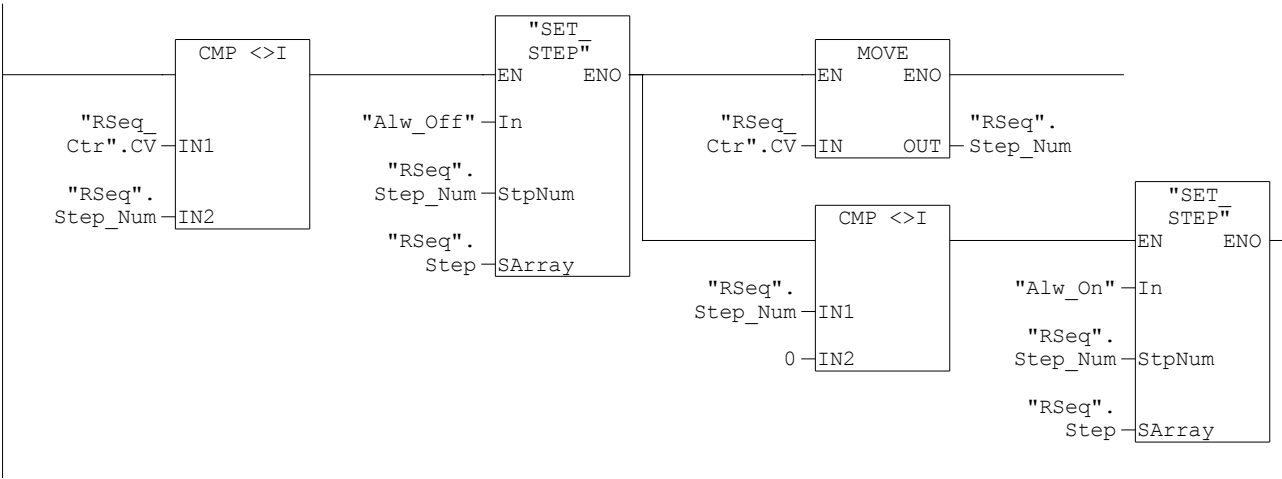
Network: 21

First press of reset pb starts reset



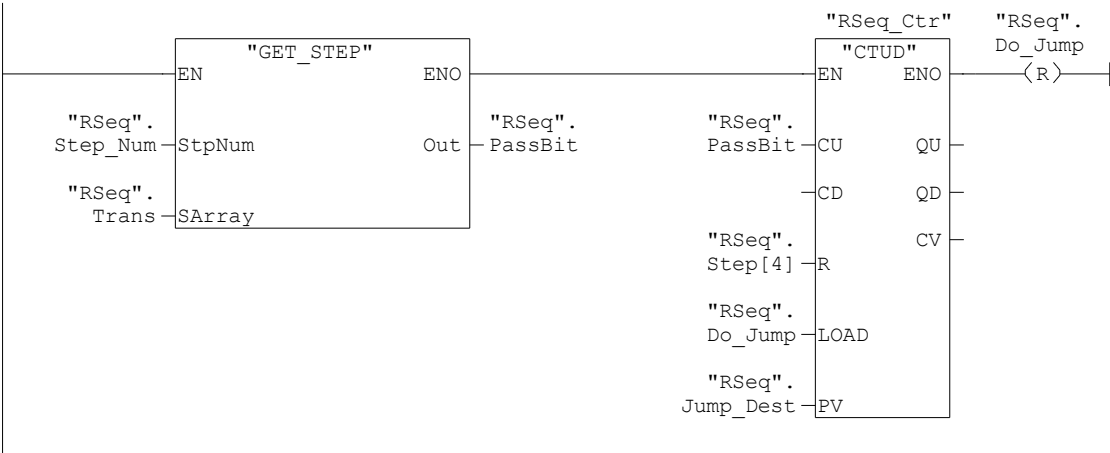
Network: 22

Change reset step-in-progress bit when step changes.



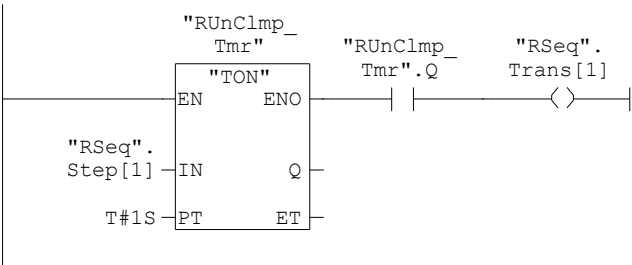
Network: 23

Increment to next step when step-done bit set.



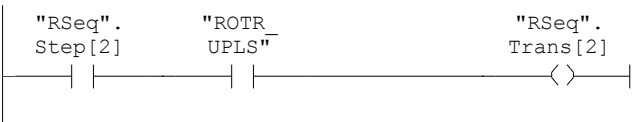
Network: 24

Reset step 1 - Unclamp.



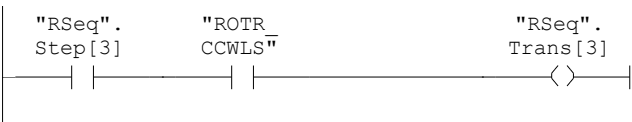
Network: 25

Reset step 2 - Raise mechanism.



Network: 26

Reset step 3 - Rotate CCW.



Network: 27

Engaging hooks control

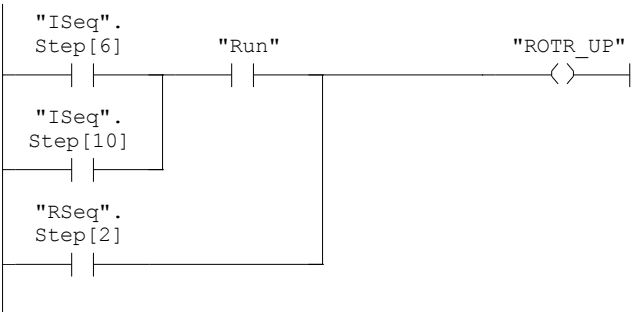


Network: 28

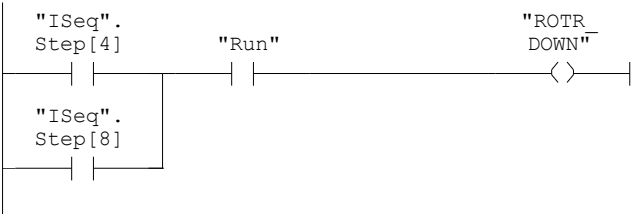


Network: 29

Rotating mechanism up/down control.

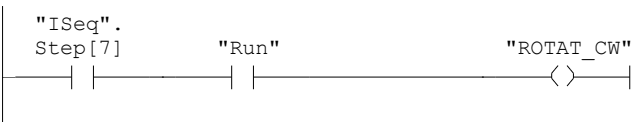


Network: 30

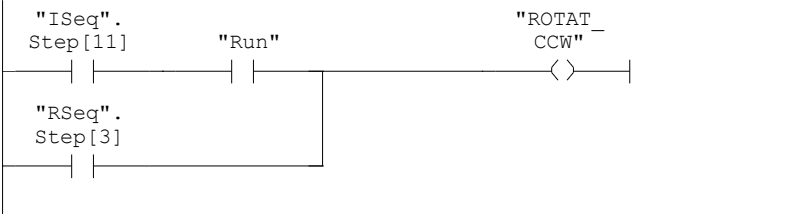


Network: 31

Rotation Control

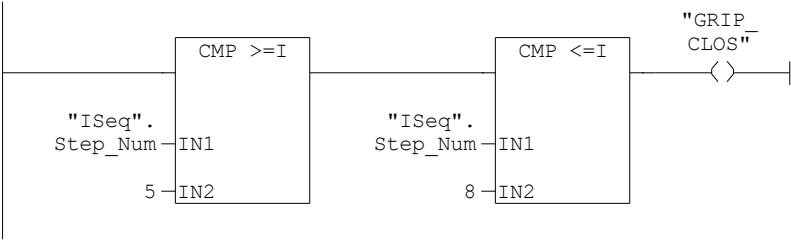


Network: 32



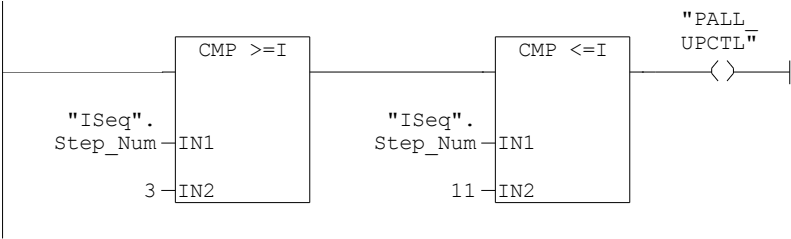
Network: 33

Gripper Control



Network: 34

Pallet Up Control



Network: 35

