

OB1 - <offline>

"Cycle Execution"

Name:

Author:

Time stamp Code:

Interface:

Lengths (block/logic/data):

Family:

Version: 0.1

Block version: 2

12/28/2015 05:29:41 PM

03/29/2003 05:35:22 PM

01142 00954 00042

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

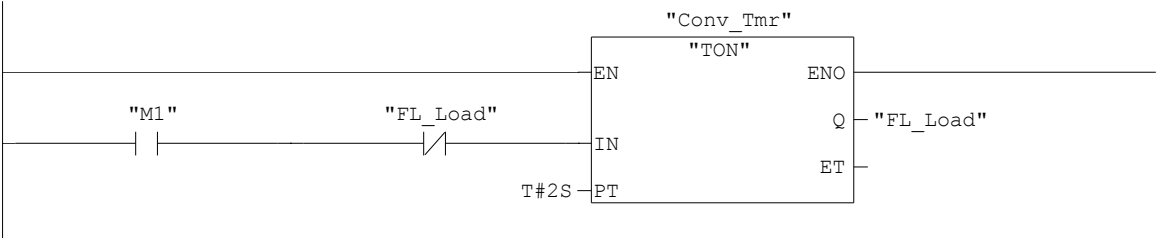
Block: OB1    "Main Program Sweep (Cycle)"

Example 8.3 Modified part tracking and stacking

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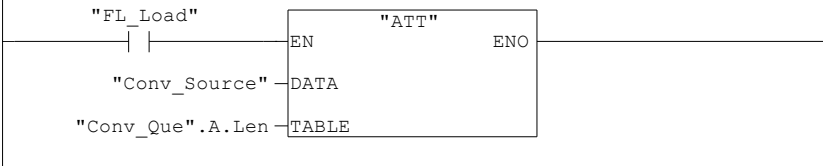
Network: 1

Generate FIFO Load Pulse



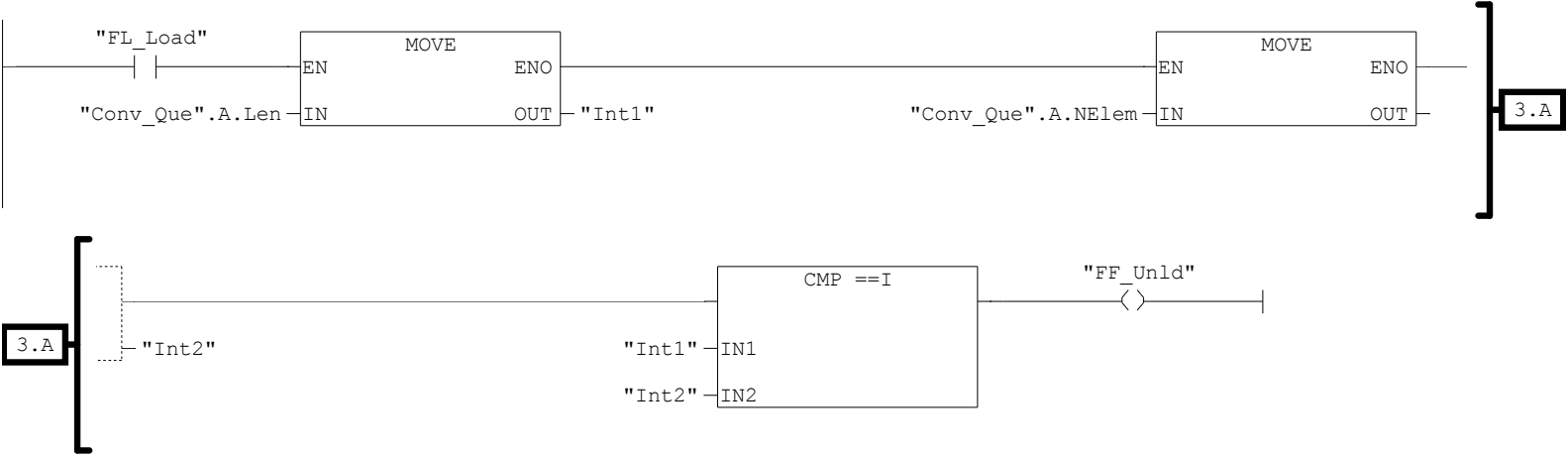
Network: 2

Load FIFO representing conveyor.



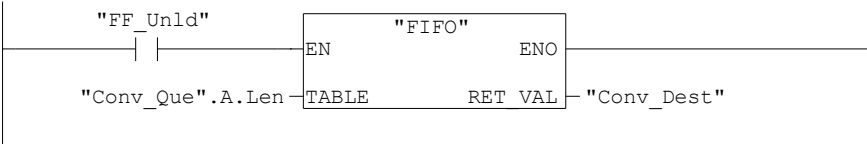
Network: 3

Detect when conveyor FIFO full so last number unloaded



Network: 4

Unload conveyor FIFO



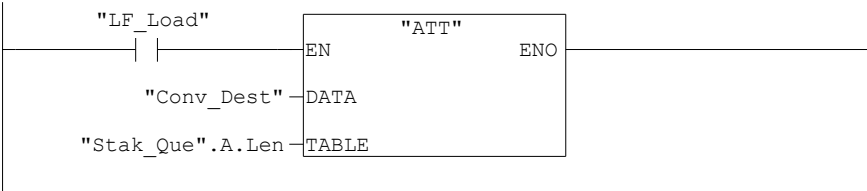
Network: 5

Check part number unloaded from FIFO. If non-zero, generate LIFO load pulse.



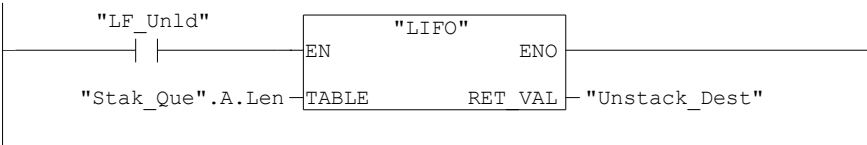
Network: 6

Load stack LIFO



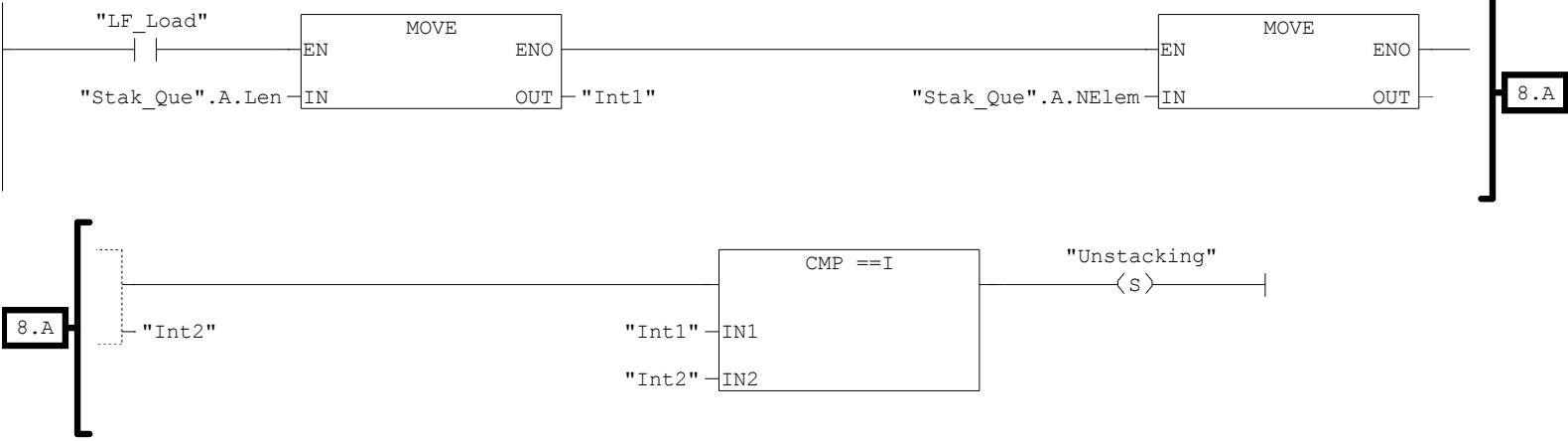
Network: 7

Unload stack LIFO



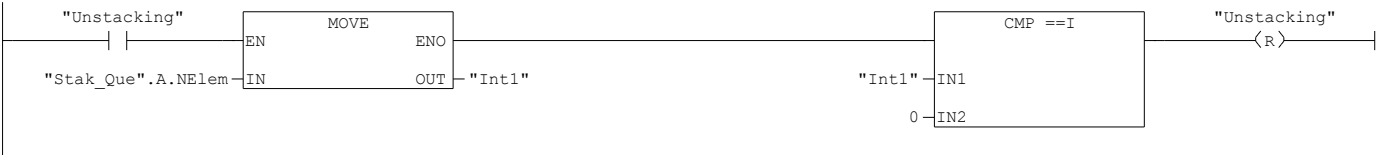
Network: 8

When stack is full, start unstacking



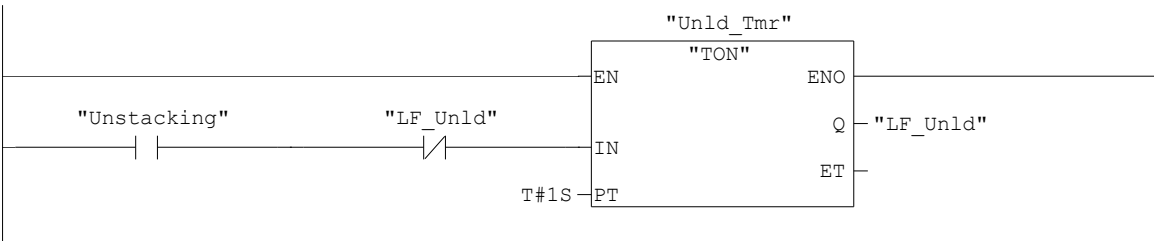
Network: 9

Finish unstacking when stack empty



Network: 10

Generate LIFO unload pulse



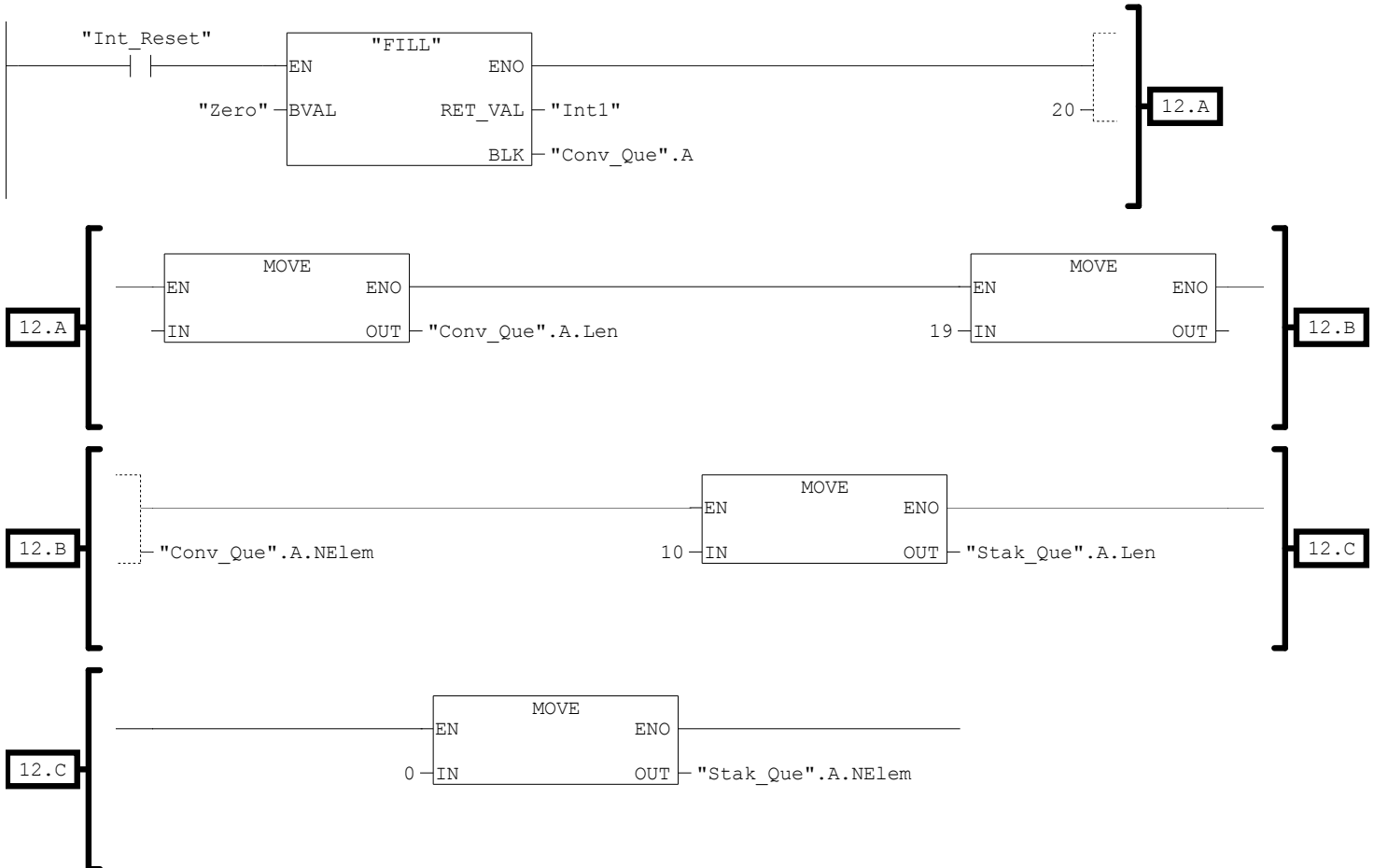
Network: 11

Conveyor motor control. Do not run when unstacking.



Network: 12

## Reset of FIFO and LIFO



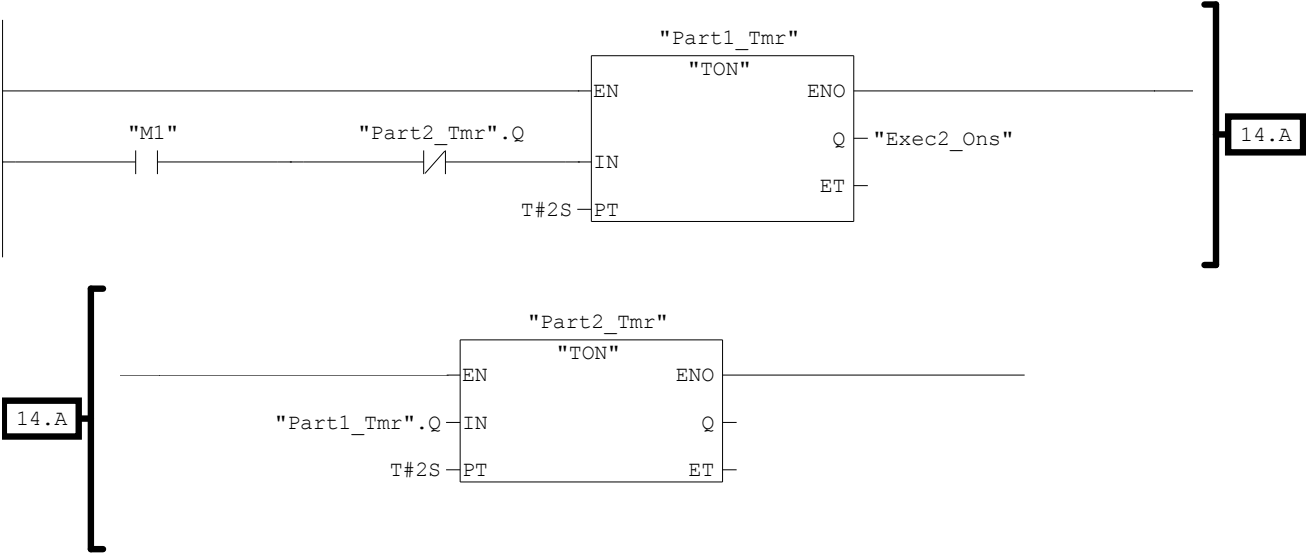
Network: 13

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Mimic run with SW3
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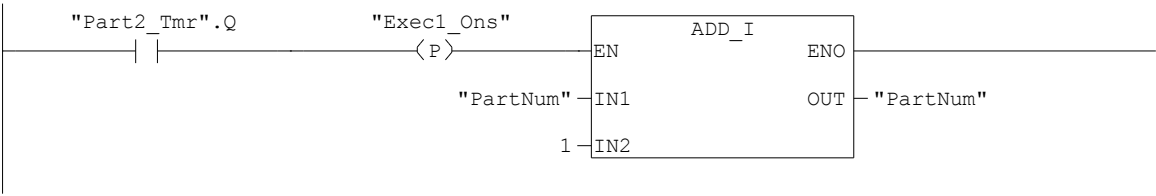


Network: 14

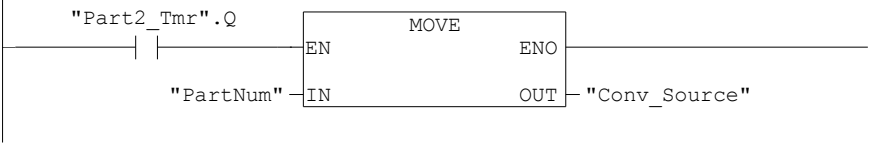
Generate part numbers to place on conveyor. Increment number every 4 seconds.



Network: 15



Network: 16



Network: 17

