

OB1 - <offline>

"Main Program"

Name:
Author:

Time stamp Code:
Interface:
Lengths (block/logic/data):

Family:
Version: 0.1
Block version: 2
12/05/2015 07:43:41 PM
03/29/2003 05:35:22 PM
00860 00684 00028

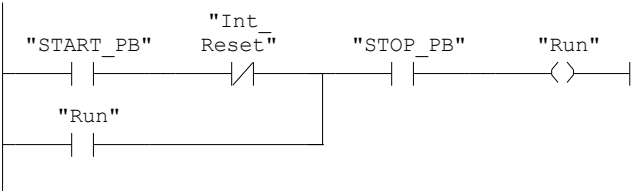
Name	Data Type	Address	Comment
TEMP		0.0	
OB1_EV_CLASS	Byte	0.0	Bits 0-3 = 1 (Coming event), Bits 4-7 = 1 (Event class 1)
OB1_SCAN_1	Byte	1.0	1 (Cold restart scan 1 of OB 1), 3 (Scan 2-n of OB 1)
OB1_PRIORITY	Byte	2.0	Priority of OB Execution
OB1_OB_NUMBR	Byte	3.0	1 (Organization block 1, OB1)
OB1_RESERVED_1	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 6.4 - Engine Inverter

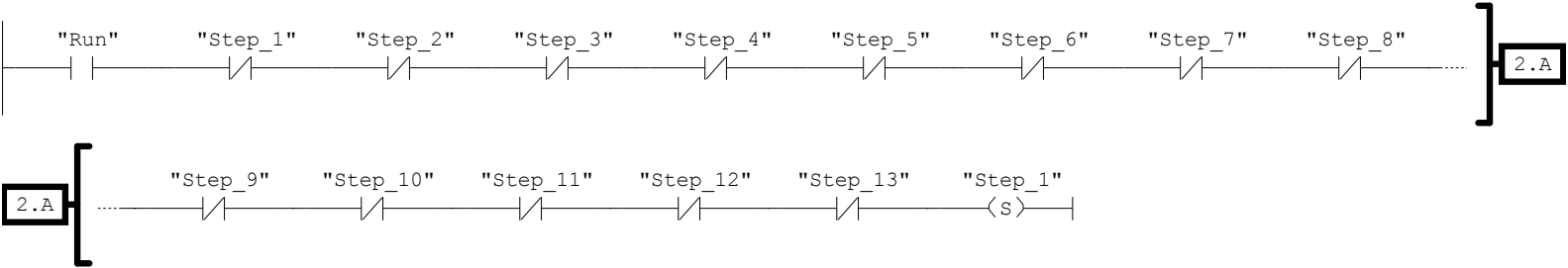
Copyright (c) 2011 Dogwood Valley Press, LLC

Network: 1Overall start/stop/pause



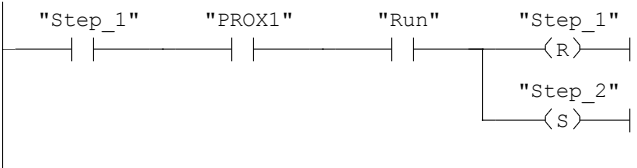
Network: 2

Generate transition out of initial step



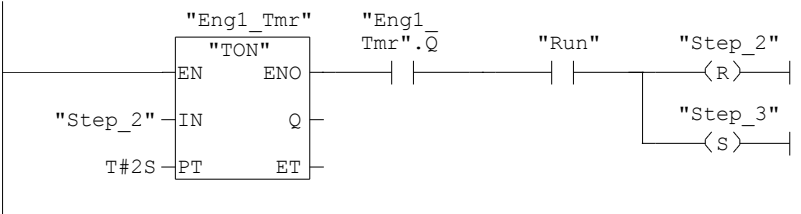
Network: 3

Step 1 - Wait for pallet.



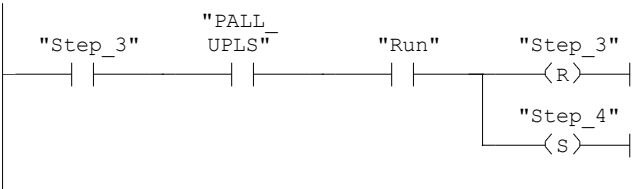
Network: 4

Step 2 - Move to hook 2



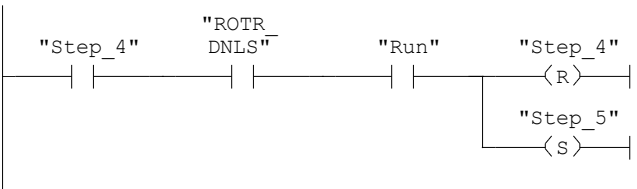
Network: 5

Step 3 - Raise pallet



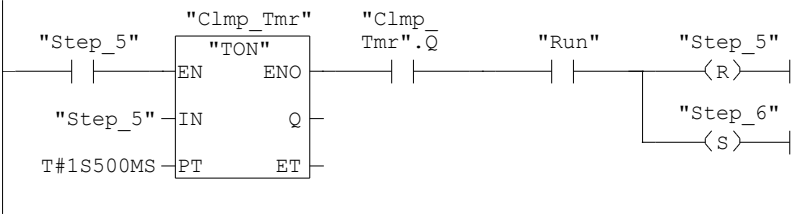
Network: 6

Step 4 - Lower rotator



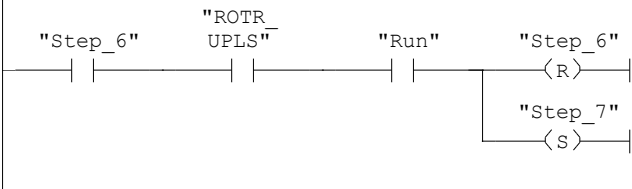
Network: 7

Step 5 - Clamp engine



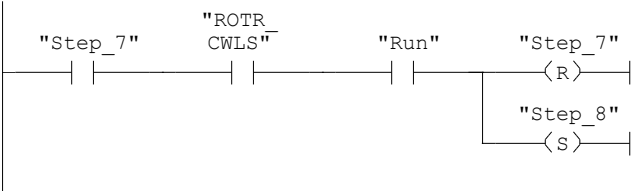
Network: 8

Step 6 - Raise rotator



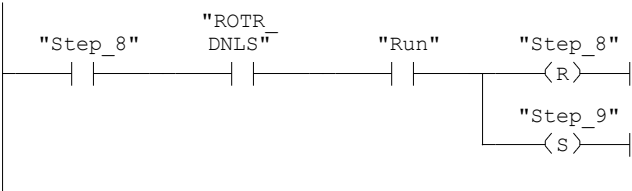
Network: 9

Step 7 - Rotate clockwise



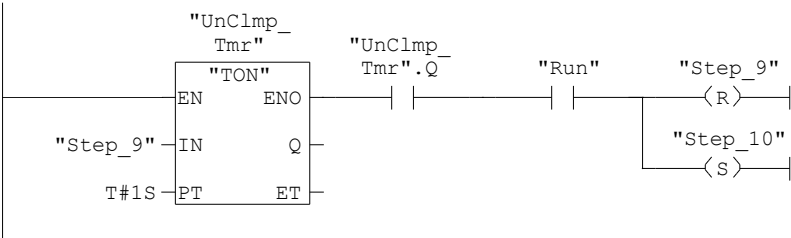
Network: 10

Step 8 - Lower rotator



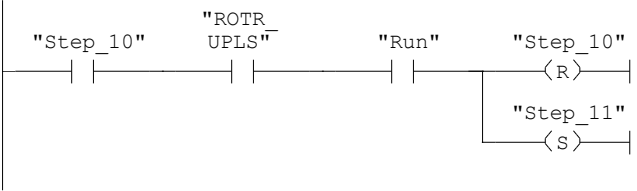
Network: 11

Step 9 - Unclamp timer



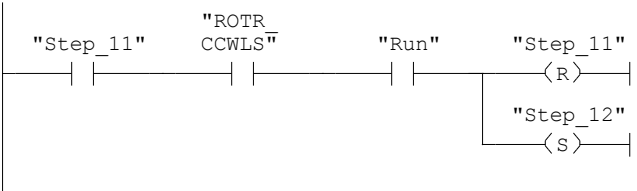
Network: 12

Step 10 - Raise rotator



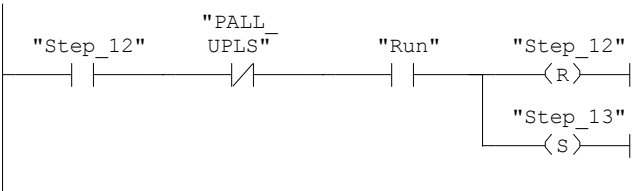
Network: 13

Step 11 - Rotate CCW



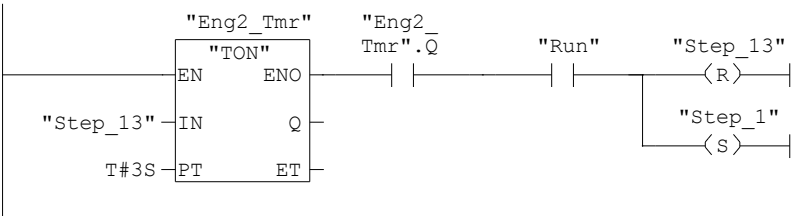
Network: 14

Step 12 - Drop Engine



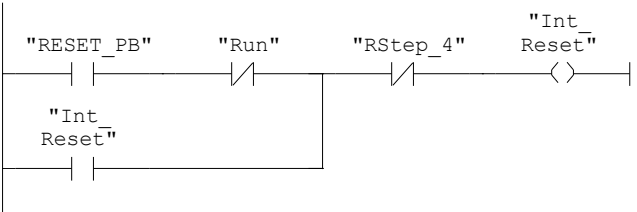
Network: 15

Step 13 - Move out pallet

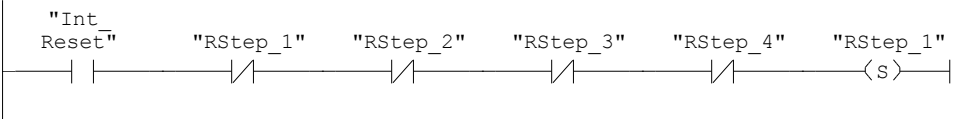


Network: 16

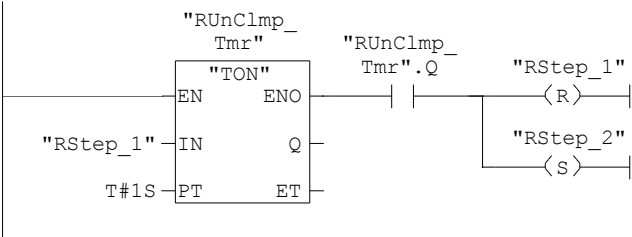
Start/stop for reset operation



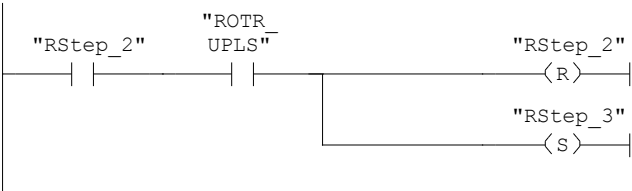
Network: 17 First press of reset pb starts reset



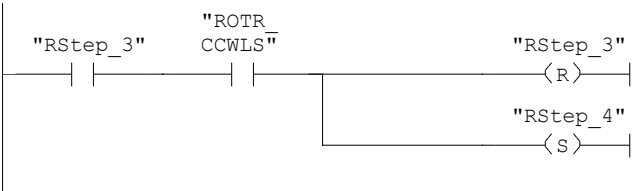
Network: 18 Reset step 1 - Delay to unclamp



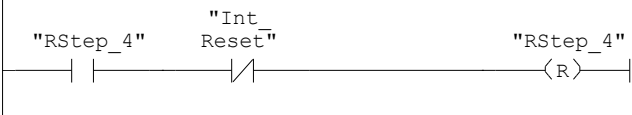
Network: 19 Reset step 2 - Raise mechanism



Network: 20 Reset step 3 - Rotate CCW

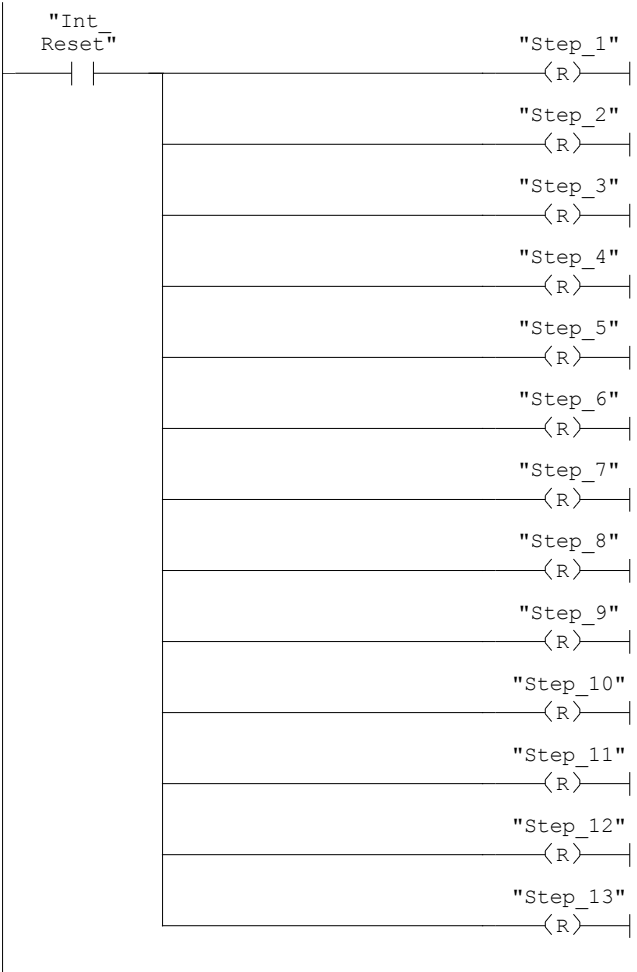


Network: 21 Reset step 4 - Unlatch internal reset



Network: 22

Reset steps of main operation



Network: 23

Engaging hooks control

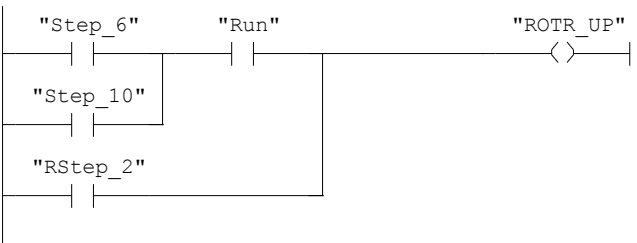


Network: 24

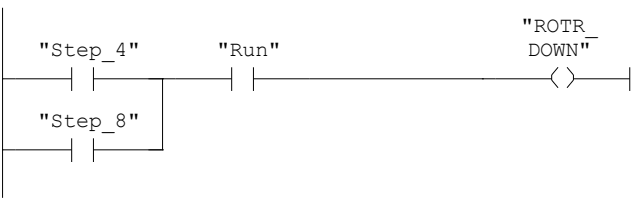


Network: 25

Rotating mechanism up/down control

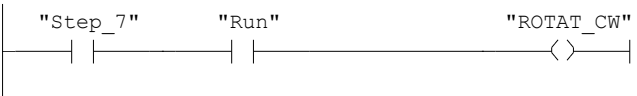


Network: 26

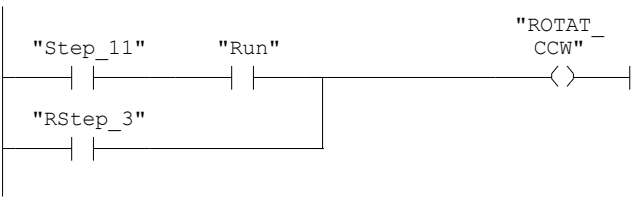


Network: 27

Rotation control

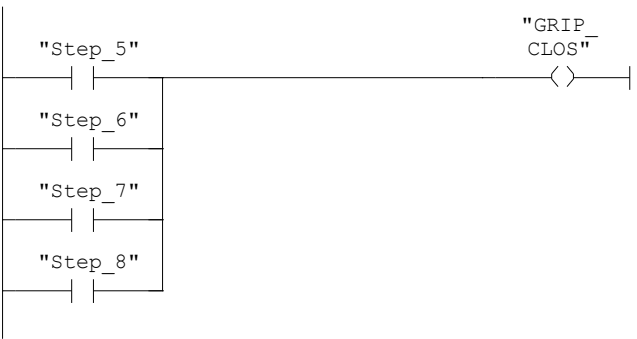


Network: 28



Network: 29

Gripper control



Network: 30

Pallet up control

