

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	Example 21.2 Marking Defective Parts Copyright (c) 2013, Dogwood Valley Press, LLC
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:



Mark_Def [FB1]

Mark_Def Properties

General

Name	Mark_Def	Number	1	Type	FB
Language	SCL	Numbering	Manual		

Information

Title		Author		Comment	
Family		Version	0.1	User-defined ID	

Name	Data type	Default value
Input		
Output		
InOut		
▼ Static		
P_Seal	Bool	false
S_Done	Bool	false
St_Delay	TON	
Pls_Tmr	TON	
Temp		
Constant		

```
0001 (* Example 12.2 Marking defective parts *)
0002
0003 (* Copyright 2013 Dogwood Valley Press *)
0004
0005 IF NOT #P_Seal THEN
0006     IF ( ("PDEFECT" AND (NOT "PROX5")) AND (NOT #S_Done) ) THEN
0007         #P_Seal := TRUE;
0008     END_IF;
0009 ELSE
0010     IF #S_Done THEN #P_Seal := FALSE;
0011     END_IF;
0012 END_IF;
0013 #St_Delay(IN:=#P_Seal, PT:=T#5.5s);
0014 "SPRAY" := #St_Delay.Q;
0015 #Pls_Tmr(IN:="SPRAY", PT:=T#1s);
0016 #S_Done := #Pls_Tmr.Q;
```