

Main_Program [OB1]

Main_Program Properties

General

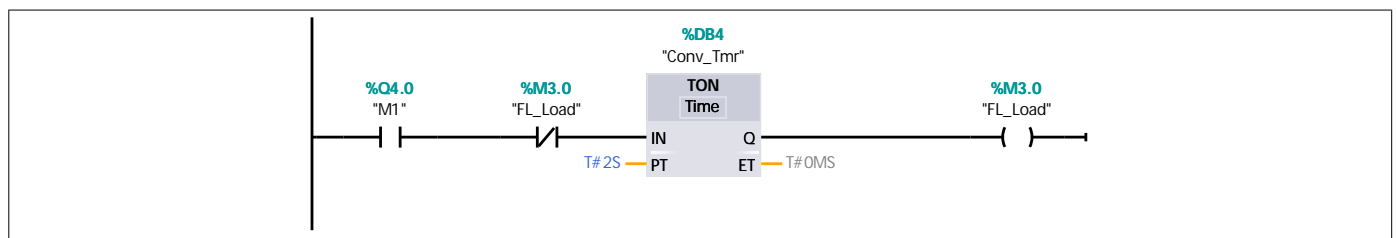
Name	Main_Program	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

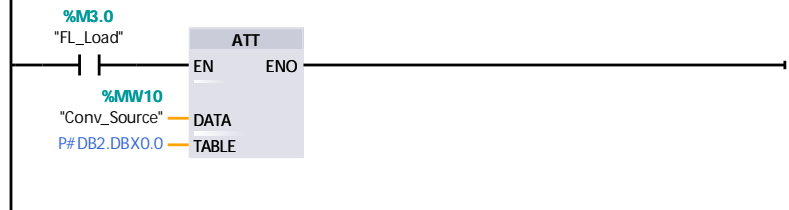
Title	"Main Program Sweep (Cycle)"	Author		Comment	Example 8.2 Part Tracking and Unstacking. Also includes code to generate parts. Copyright (c) 2013 Dogwood Valley Press, LLC
Family		Version	0.1	User-defined ID	

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	
Temp1	Bool	
Temp2	Bool	
Constant		

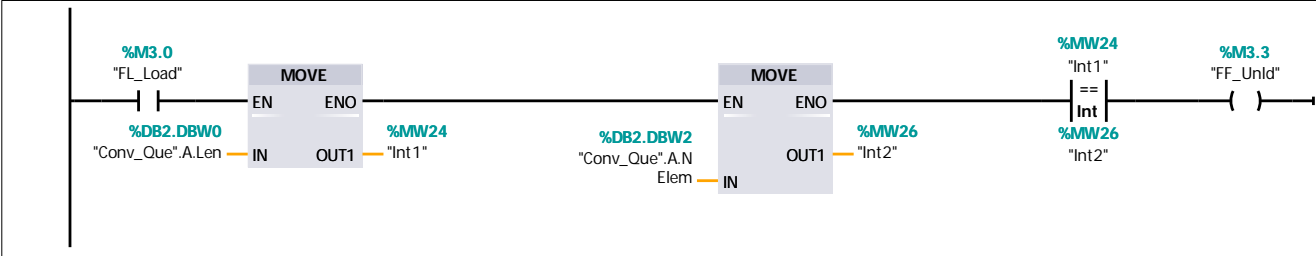
Network 1: Generate FIFO Load Pulse



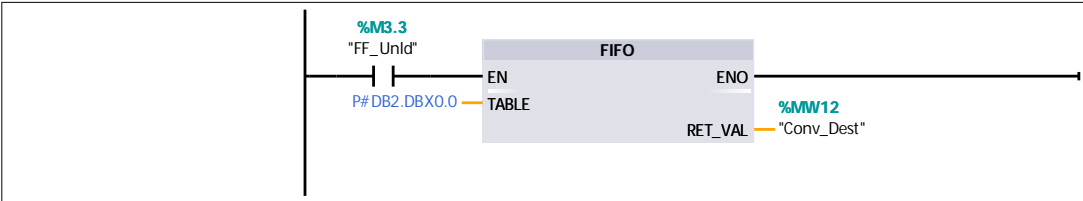
Network 2: Load FIFO representing conveyor.



Network 3: Detect when conveyor FIFO full so last number unloaded

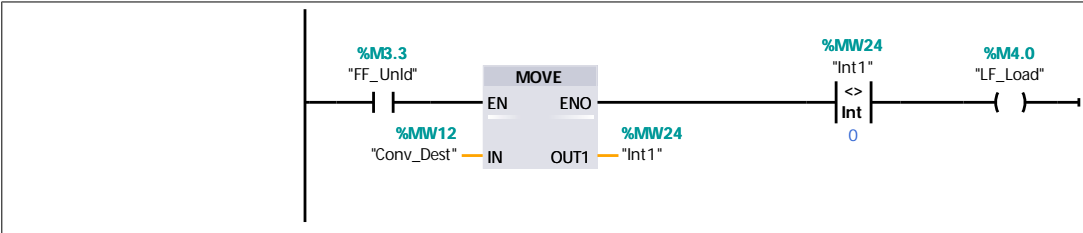


Network 4: Unload conveyor FIFO

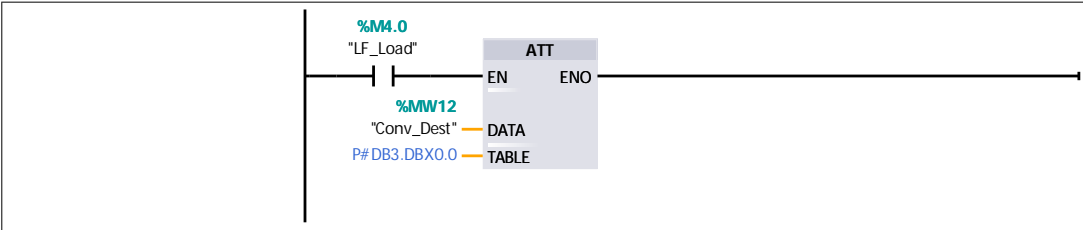


Network 5: Check part number unloaded from FIFO.

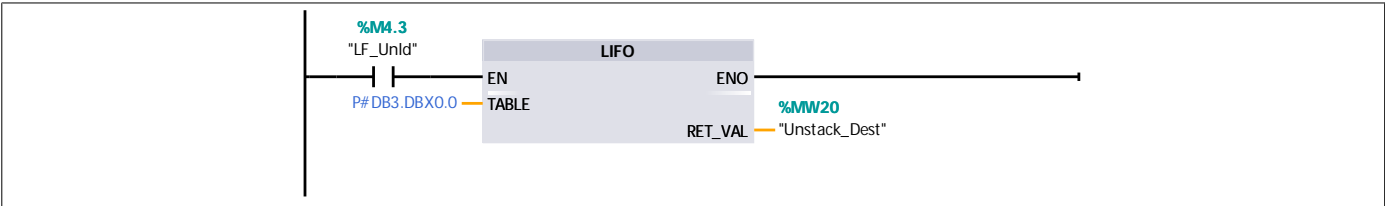
If non-zero, generate LIFO load pulse.



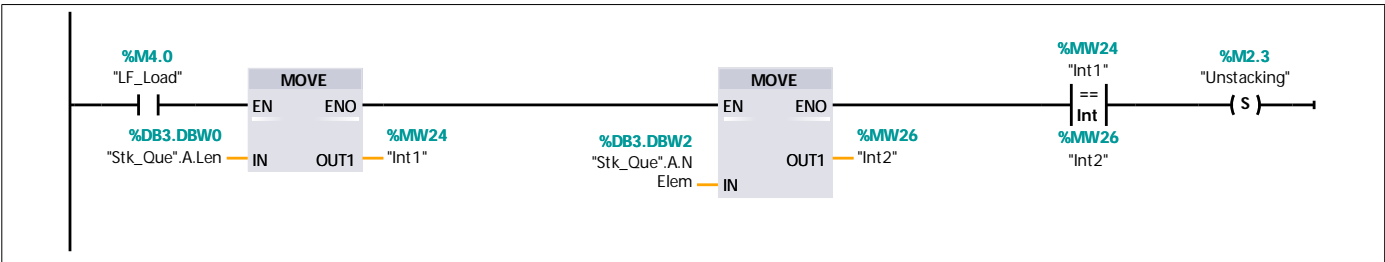
Network 6: Load stack LIFO



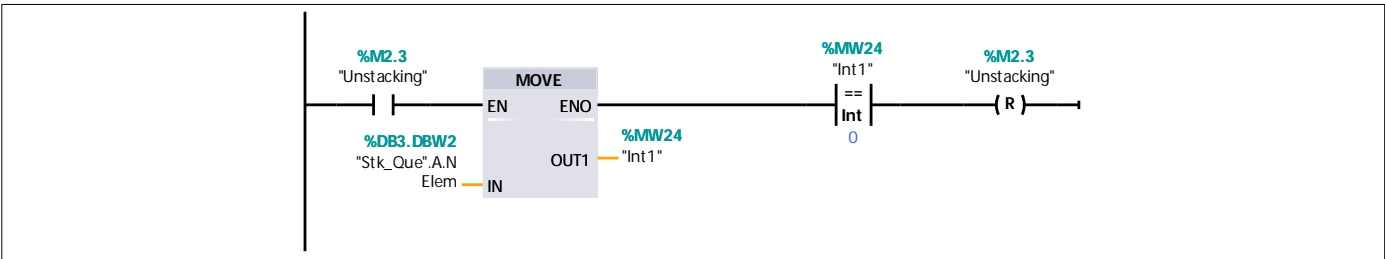
Network 7: Unload stack LIFO



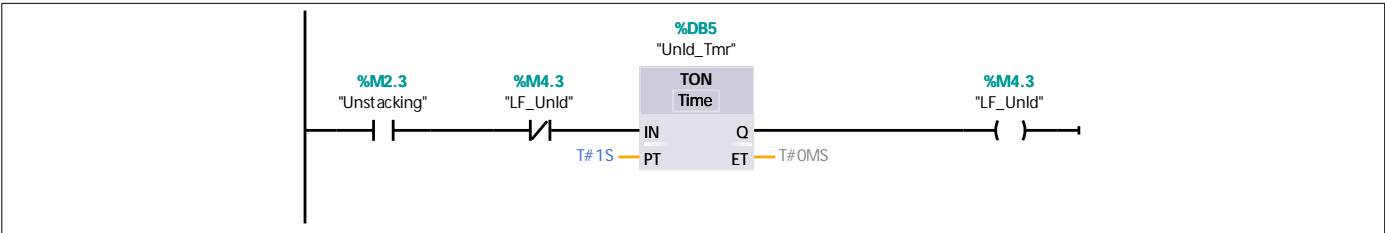
Network 8: When stack is full, start unstacking



Network 9: Finish unstacking when stack empty

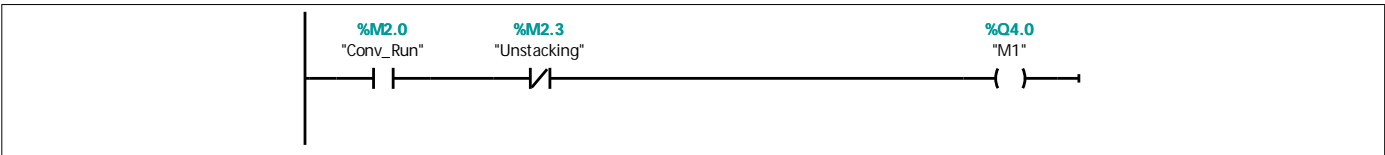


Network 10: Generate LIFO unload pulse



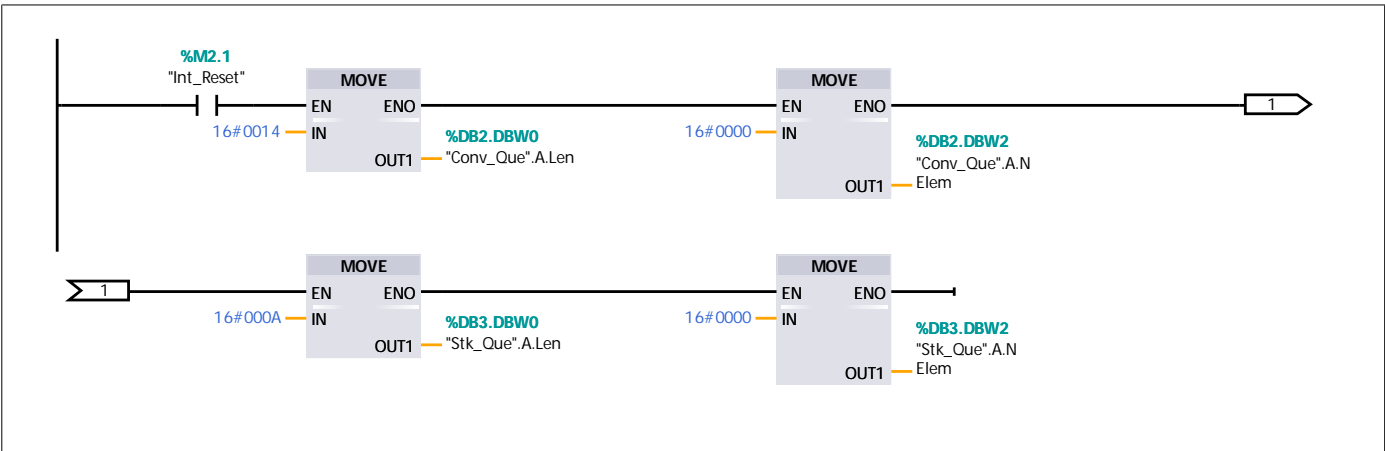
Network 11: Conveyor motor control.

Do not run when unstacking.

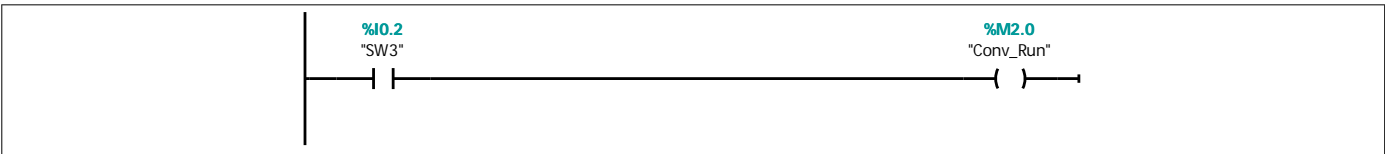


Network 12: Initialization of tables

Reset of FIFO and LIFO

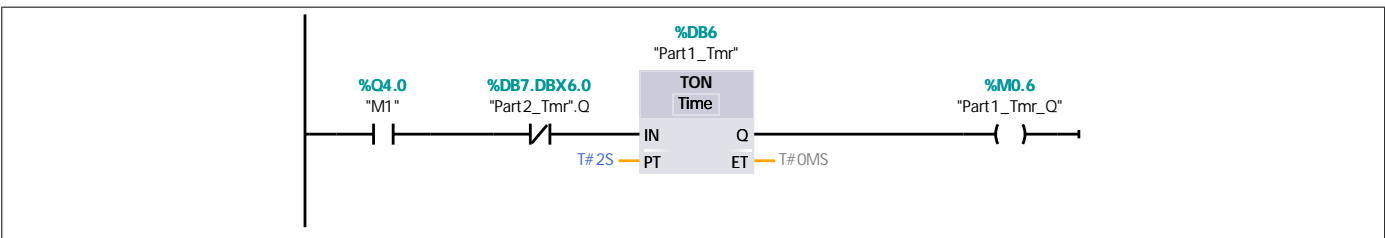


Network 13: Mimic run with SW3

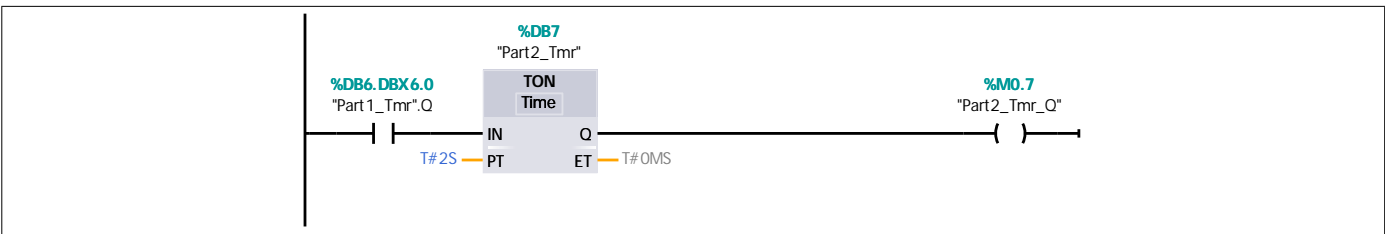


Network 14: Generate part numbers to place on conveyor.

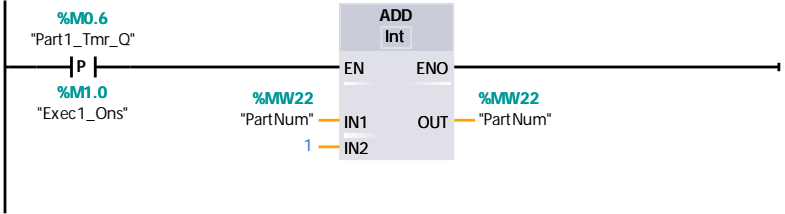
Increment number every 4 seconds. Every other execution of FLoad is a zero part number.



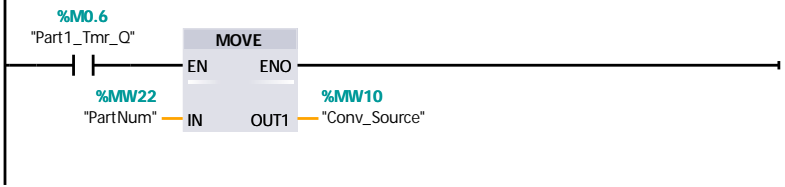
Network 15:



Network 16:



Network 17:



Network 18:

