

Main Program [OB1]

Main Program Properties

General

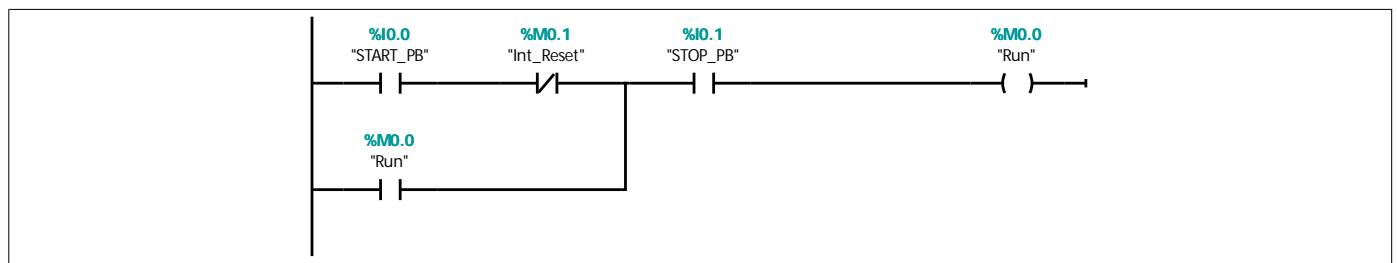
Name	Main Program	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

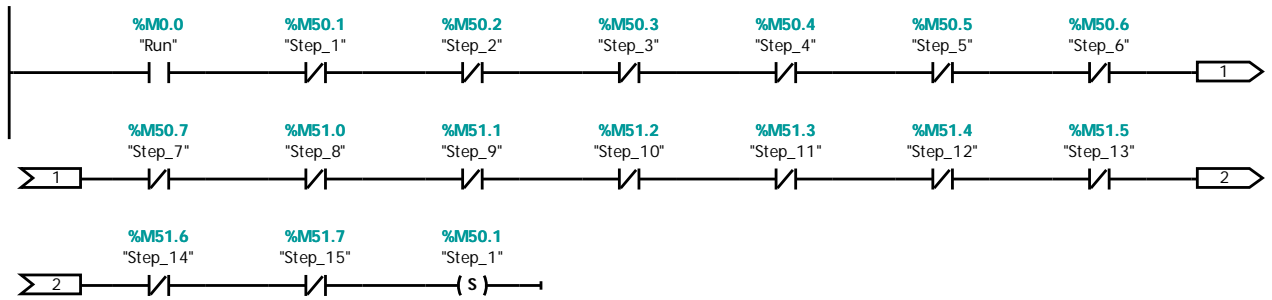
Title	"Main Program Sweep (Cycle)"	Author		Comment	Example 6.5 - Engine Inverter with parallel steps Copyright (c) 2013 Dogwood Valley Press, LLC
Family		Version	0.1	User-defined ID	

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		

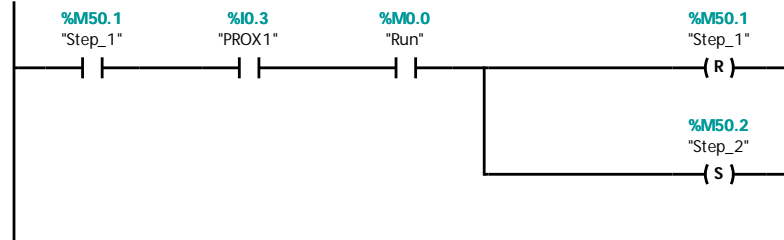
Network 1: Overall start/stop/pause



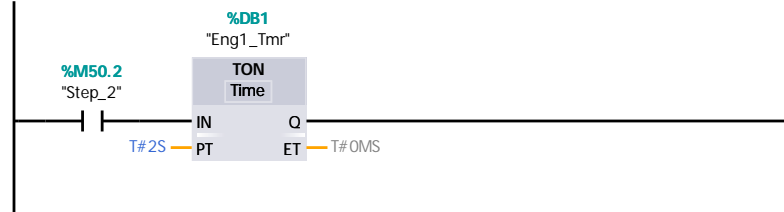
Network 2: Generate transition out of initial step



Network 3: Step 1 - Wait for pallet.

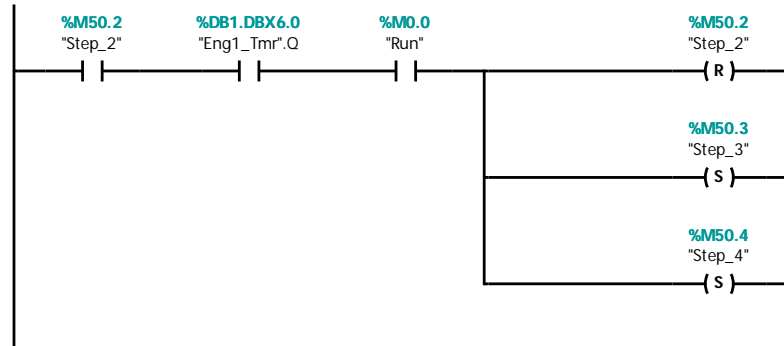


Network 4: Step 2 - Timer

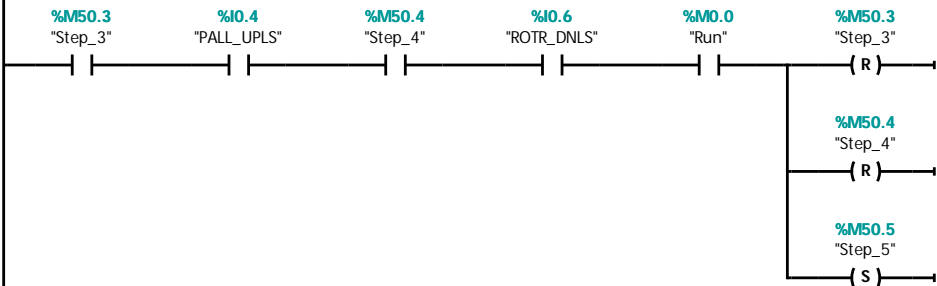


Network 5: Step 2 - Move to hook 2

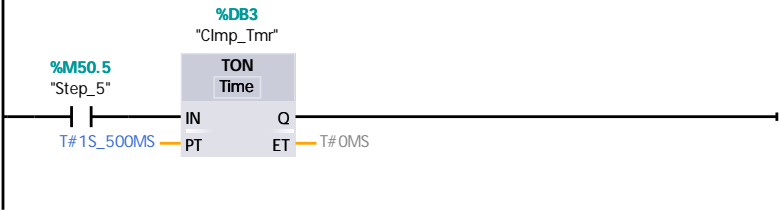
Transition to steps 3 & 4 after hook open for 2 sec



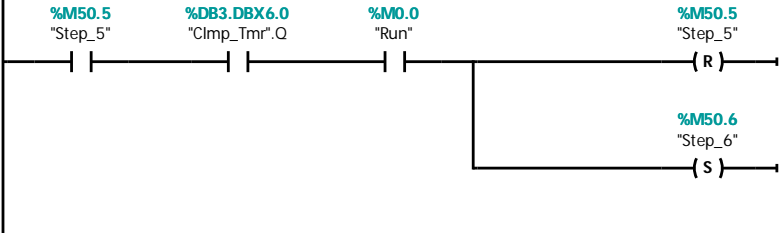
Network 6: Step 3 & 4 - Wait for pallet raised & rotator lowered



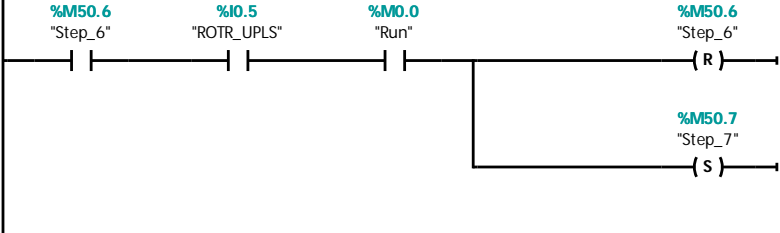
Network 7: Step 5 - Timer



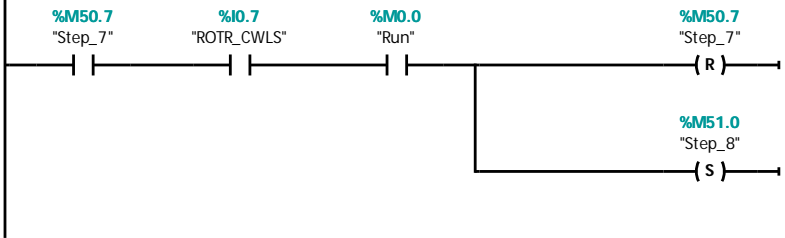
Network 8: Step 5 - Clamp engine



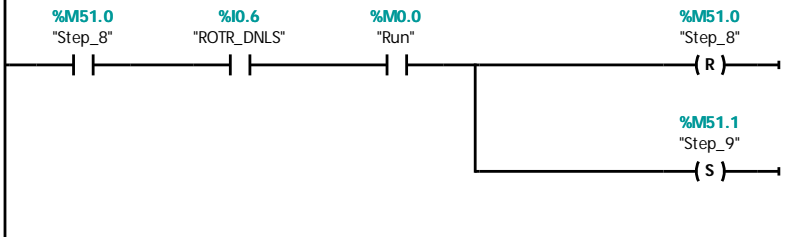
Network 9: Step 6 - Raise rotator



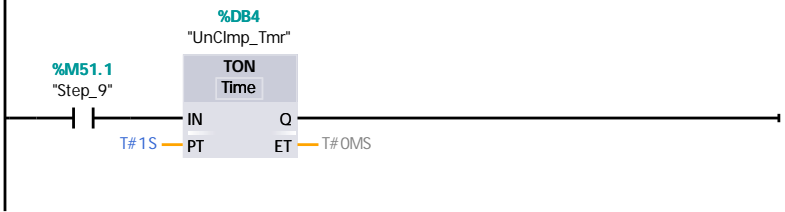
Network 10: Step 7 - Rotate clockwise



Network 11: Step 8 - Lower rotator

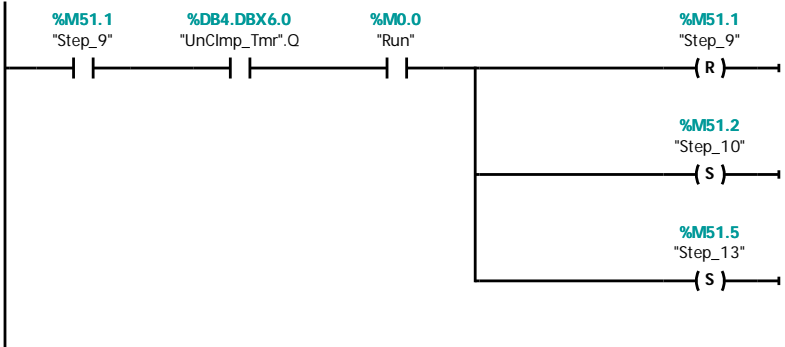


Network 12: Step 9 - Timer

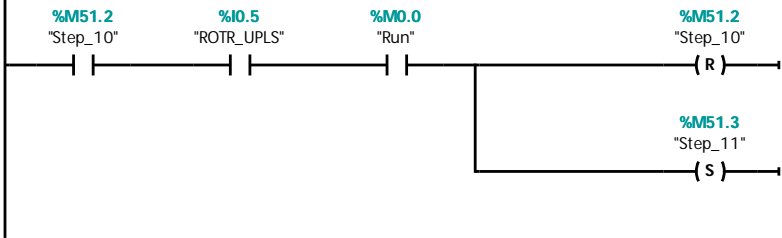


Network 13: Step 9 - Unclamp timer

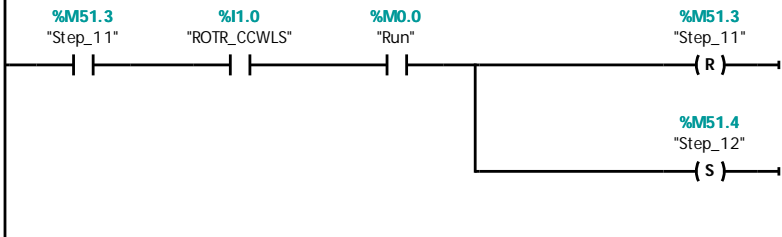
Transition to steps 10 and 13 after 1 sec



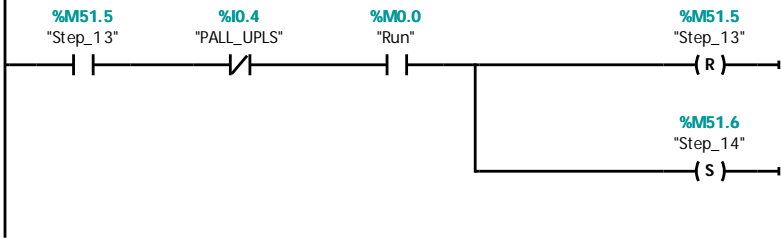
Network 14: Step 10 - Raise rotator



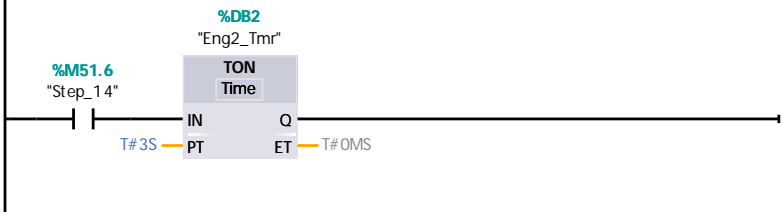
Network 15: Step 11 - Rotate CCW



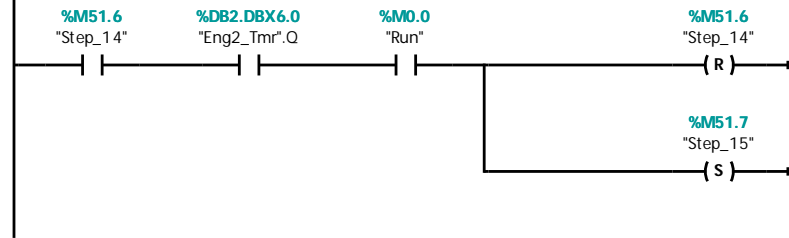
Network 16: Step 13 - Drop Engine



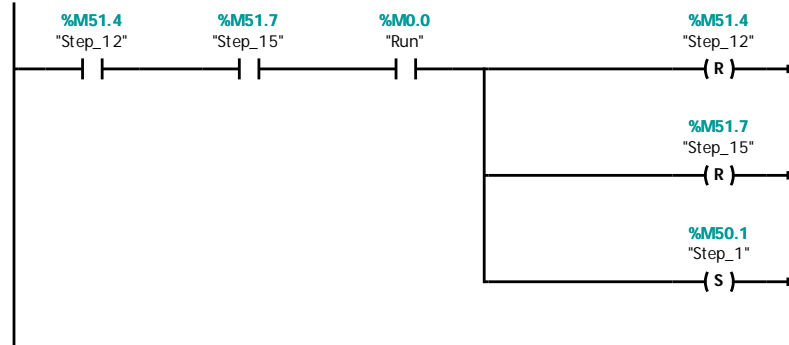
Network 17: Step 14 - Move out pallet



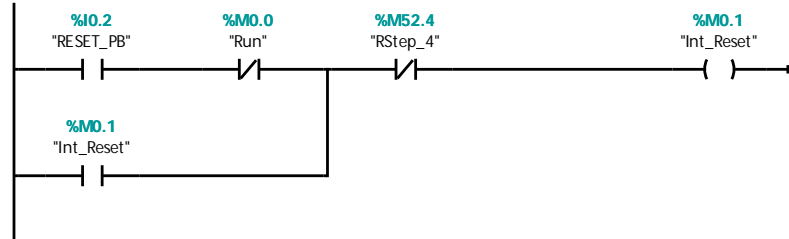
Network 18:



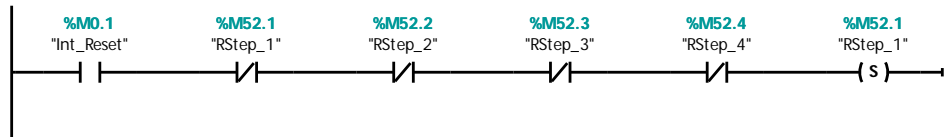
Network 19: Steps 12 & 15 - Wait for both to be active before starting over



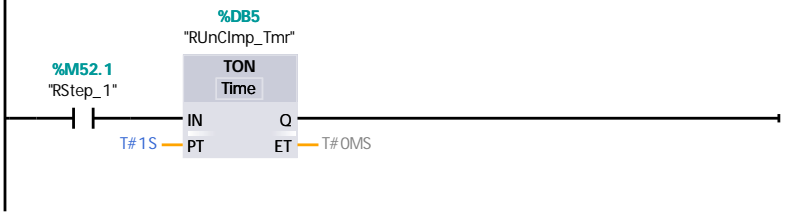
Network 20: Start/stop for reset operation



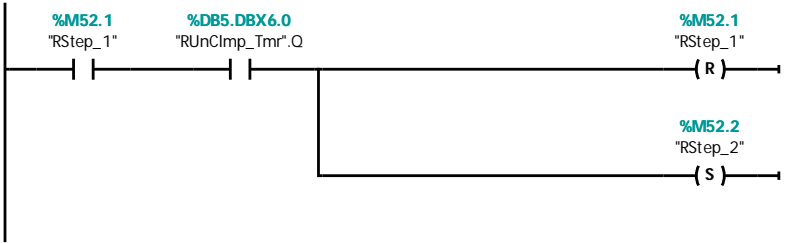
Network 21: First press of reset pb starts reset



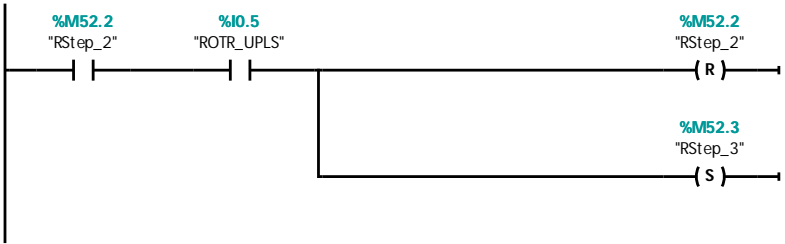
Network 22: Reset step 1 - Timer



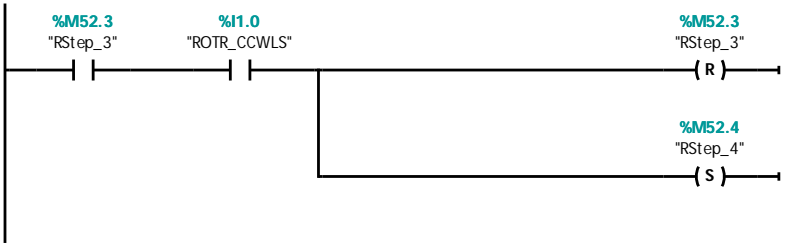
Network 23: Reset step 1 - Delay to unclamp



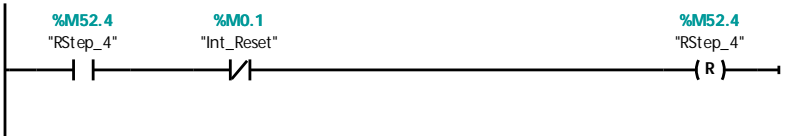
Network 24: Reset step 2 - Raise mechanism



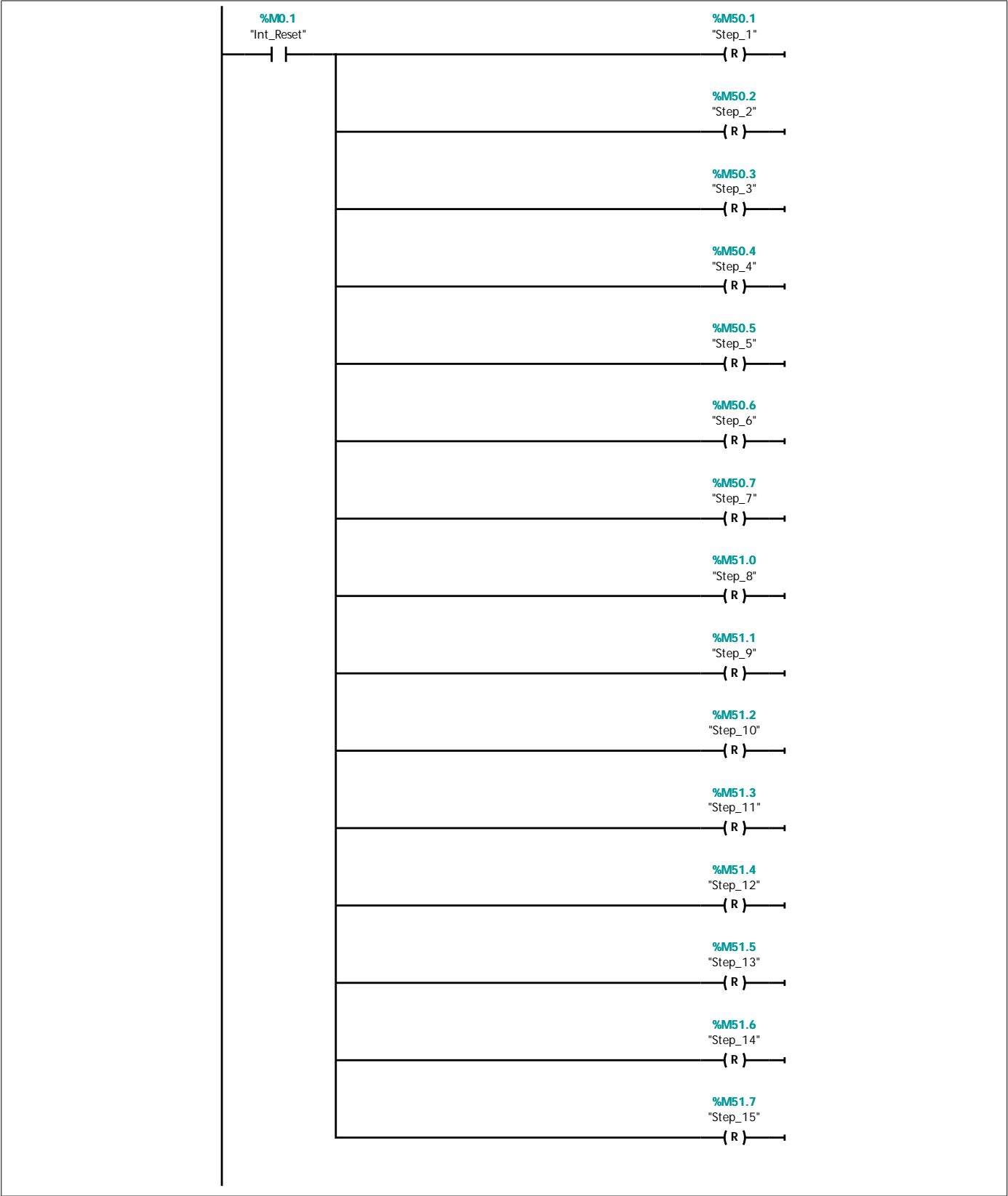
Network 25: Reset step 3 - Rotate CCW



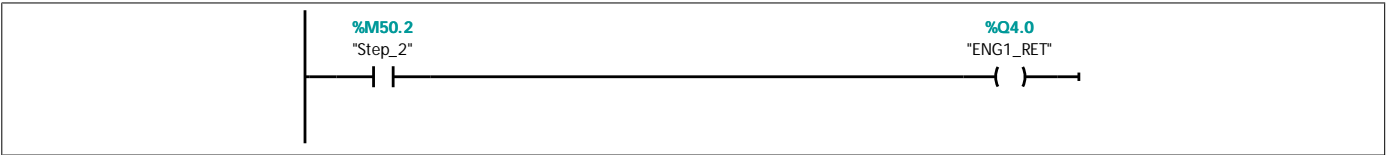
Network 26: Reset step 4 - Unlatch internal reset



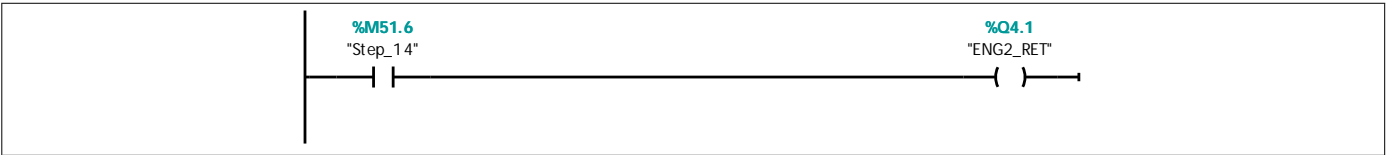
Network 27: Reset steps of main operation



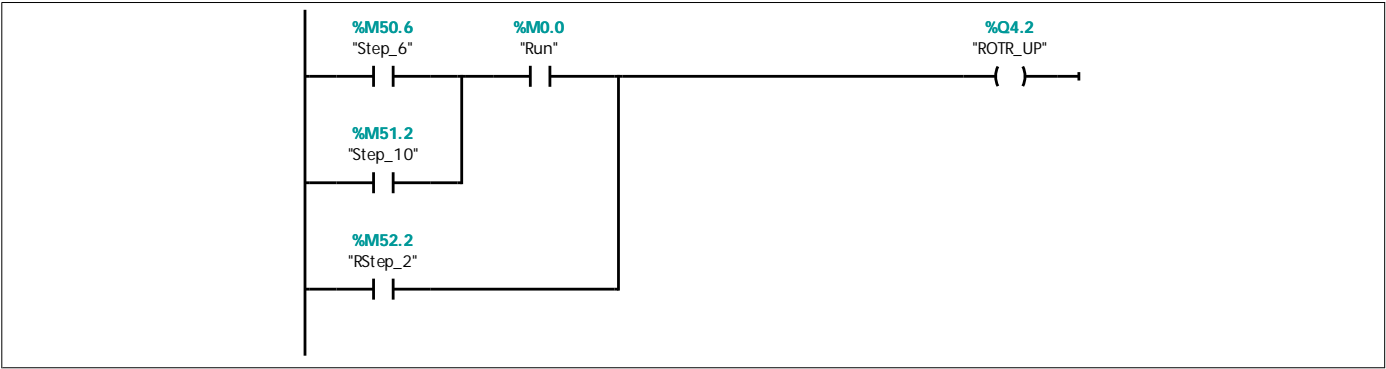
Network 28: Engaging hooks control



Network 29:



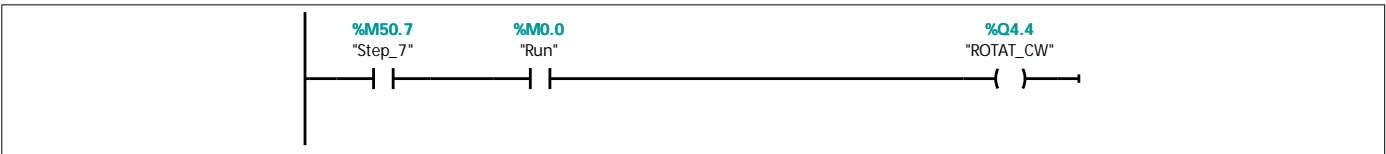
Network 30: Rotating mechanism up/down control



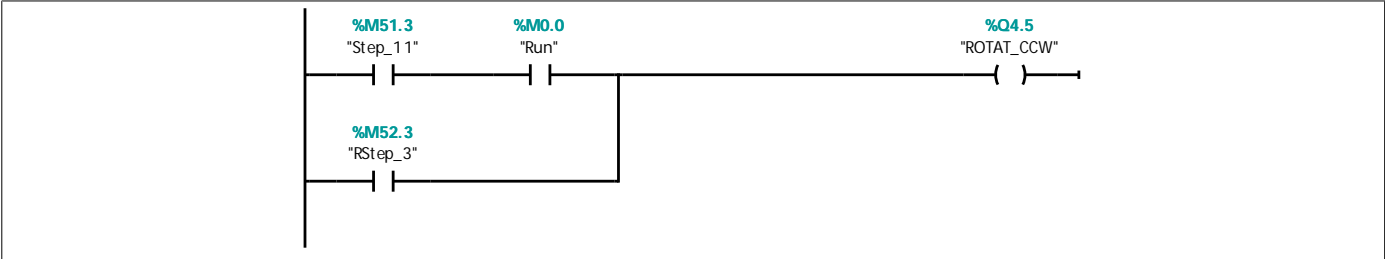
Network 31:



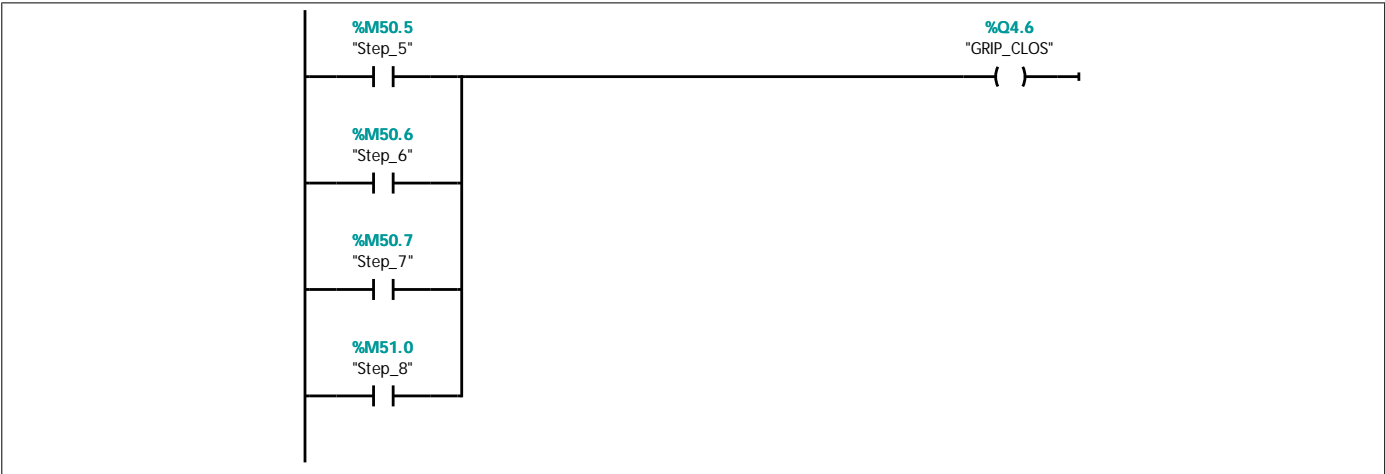
Network 32: Rotation control



Network 33:



Network 34: Gripper control



Network 35: Pallet up control

