

Main_Program [OB1]

Main_Program Properties

General

Name	Main_Program	Number	1	Type	OB
Language	LAD	Numbering	Manual		

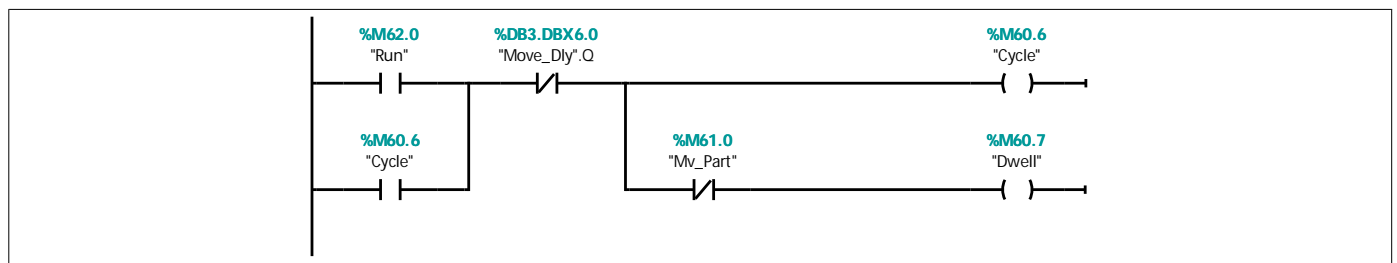
Information

Title	"Main Program Sweep (Cycle)"	Author		Comment	Example 8.1 Defect Tracking Copyright (c) 2013 Dogwood Valley Press, LLC
Family		Version	0.1	User-defined ID	

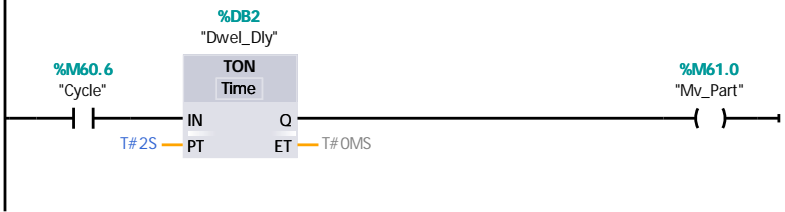
Name	Data type	Default value
▼ Temp		
OB1_EV_CLASS	Byte	
OB1_SCAN_1	Byte	
OB1_PRIORITY	Byte	
OB1_OB_NUMBR	Byte	
OB1_RESERVED_1	Byte	
OB1_RESERVED_2	Byte	
OB1_PREV_CYCLE	Int	
OB1_MIN_CYCLE	Int	
OB1_MAX_CYCLE	Int	
OB1_DATE_TIME	Date_And_Time	
Temp1	Bool	
Temp2	Bool	
Constant		

Network 1: Dwell and Part Move

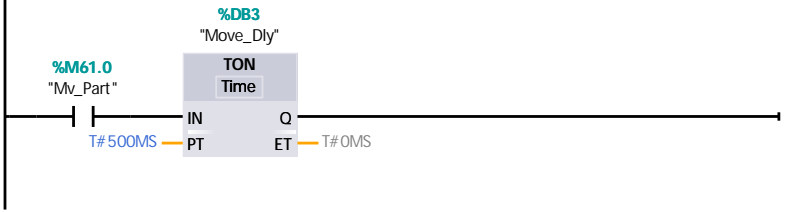
Generate part dwell and part move indications. If Run turns off, finish cycle.



Network 2: Dwell Delay timer

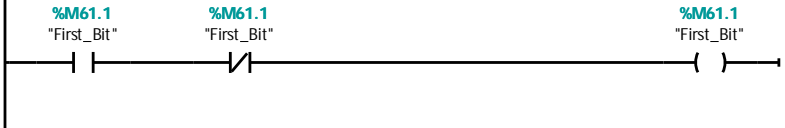


Network 3: Move delay timer

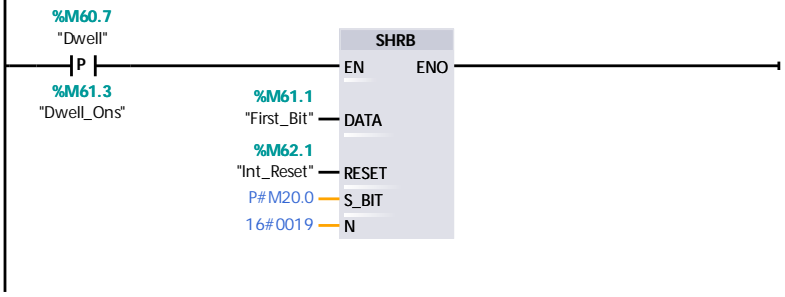


Network 4: Shift defect indications left one position

Always shift in a zero.

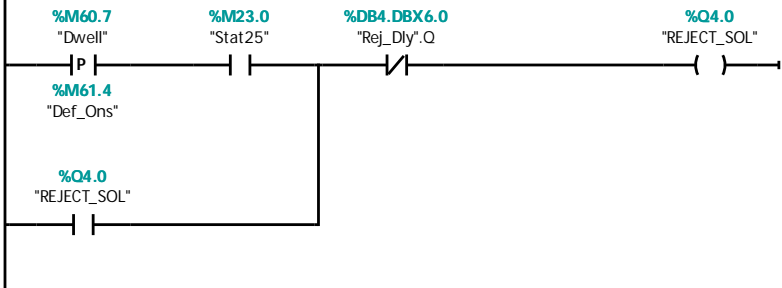


Network 5: Shift register control

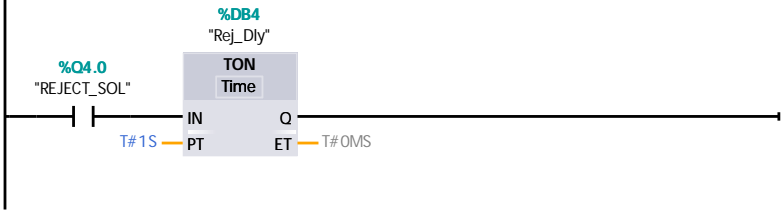


Network 6: Reject solenoid control

If defective at station 25, hold solenoid for 1 second to kick it off

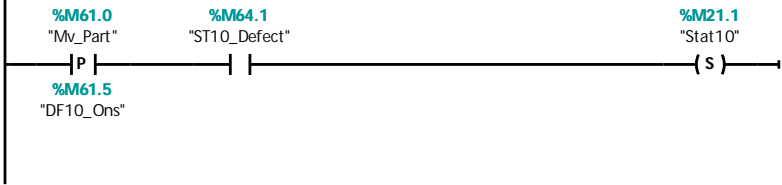


Network 7: Reject solenoid timer



Network 8: Station 10 defect indication

Set station 10 defect on rising edge of when part is moved



Network 9: Use SW3 for Run

