

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

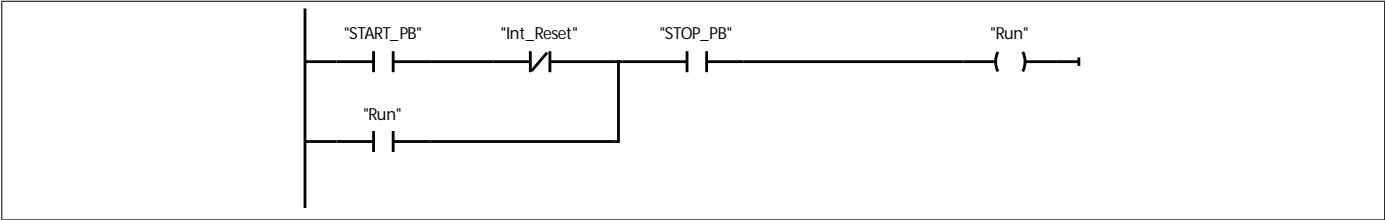
Information

Title	"Main Program Sweep (Cycle)"	Author		Comment	Example 9.2 Engine Inverter with counter-based sequencer Copyright (c) 2022 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		

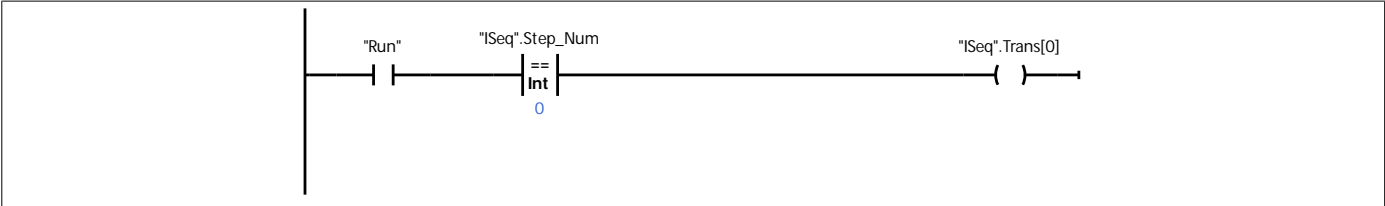
Network 1: Start/stop/pause.

Start prevented if reset in progress.

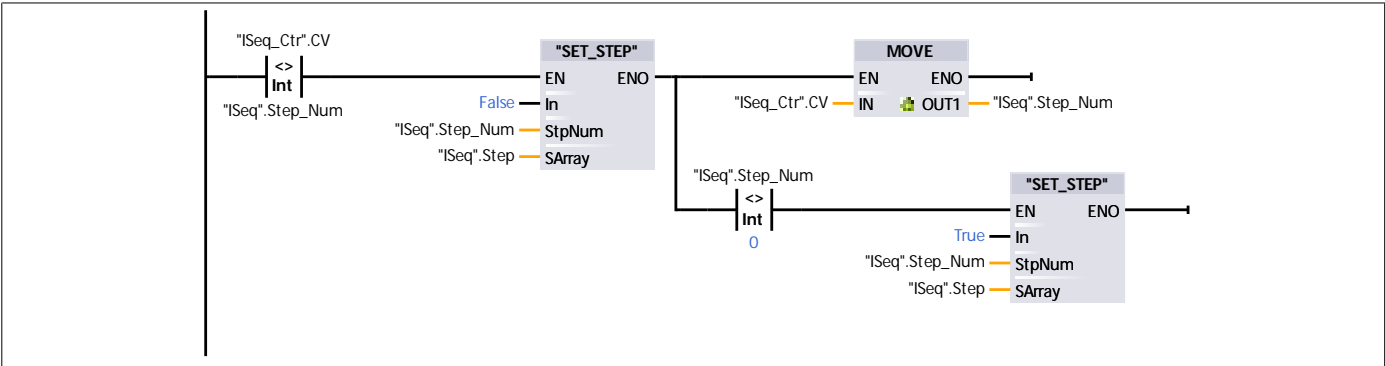


Network 2: First Start

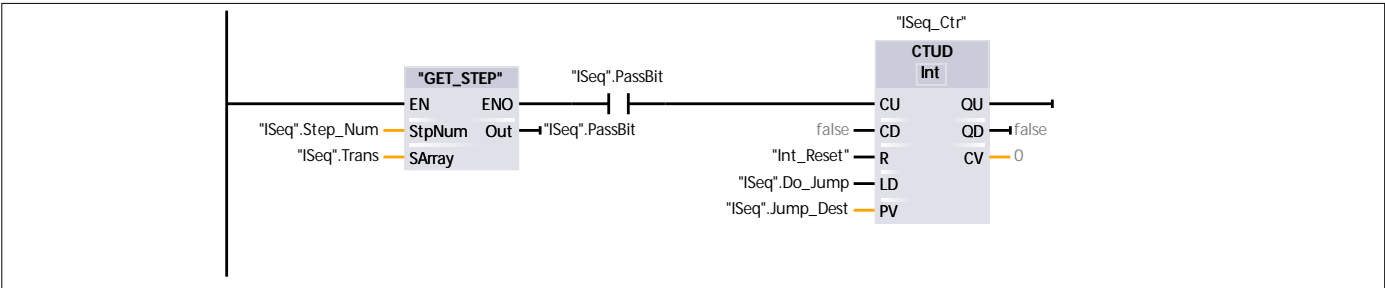
Transition out of initial step to step 1.



Network 3: Change step-in-progress bit when step changes.

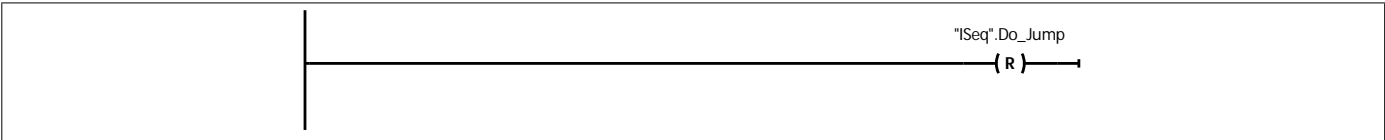


Network 4: Increment to next step when step-done bit set. Also handle jumps

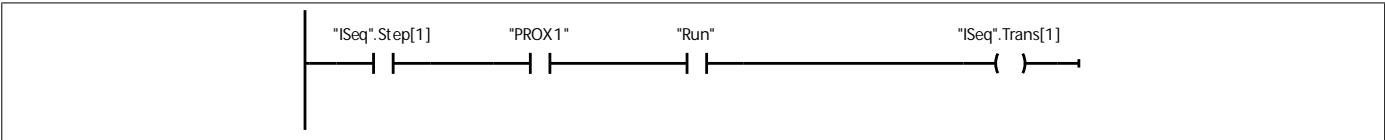


Network 5:

Always reset Jump



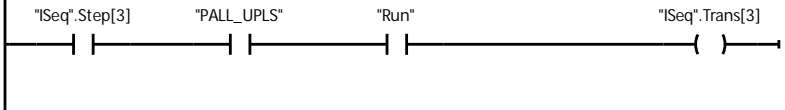
Network 6: Step 1 - Wait for pallet.



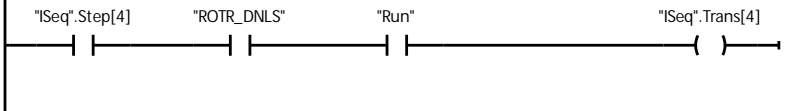
Network 7: Step 2 - Move to hook 2



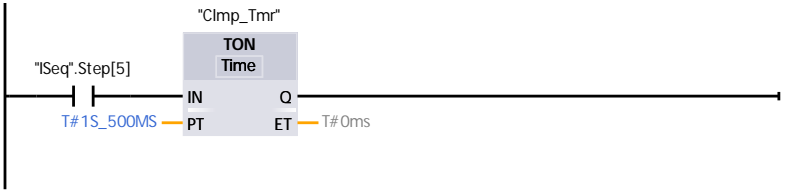
Network 8: Step 3 - Raise pallet



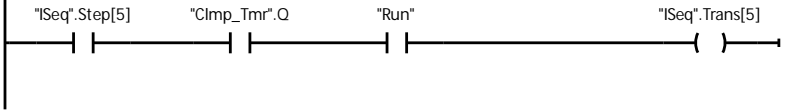
Network 9: Step 4 - Lower rotator



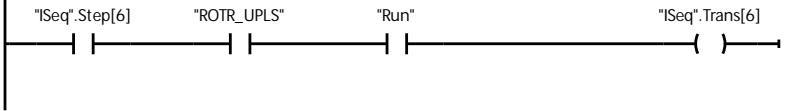
Network 10: Step 5 - Timer



Network 11: Step 5 - Clamp

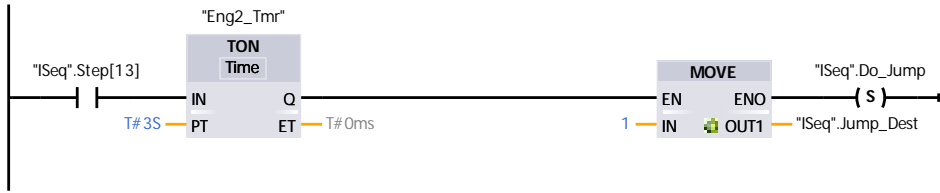


Network 12: Step 6 - Raise rotator



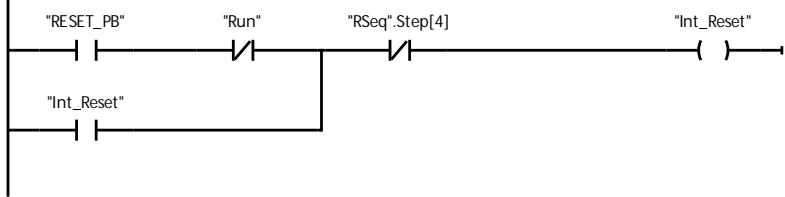
Network 13: Step 7 - Rotate CW

Totally Integrated Automation Portal		
Network 14: Step 8 - Lower rotator		
Network 15: Step 9 - Unclamp engine.		
Network 16: Step 10 - Raise rotator.		
Network 17: Step 11 - Rotate CW		
Network 18: Step 12 - Drop engine.		
Network 19: Step 13 - Timer to move out pallet, then jump to step 1		

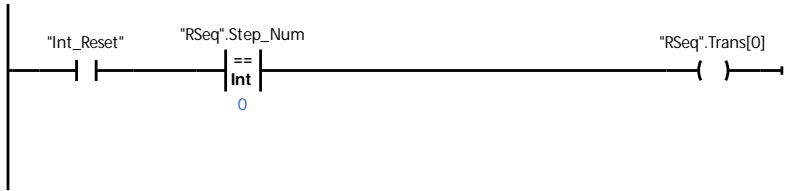


Network 20: Start/stop for reset operation.

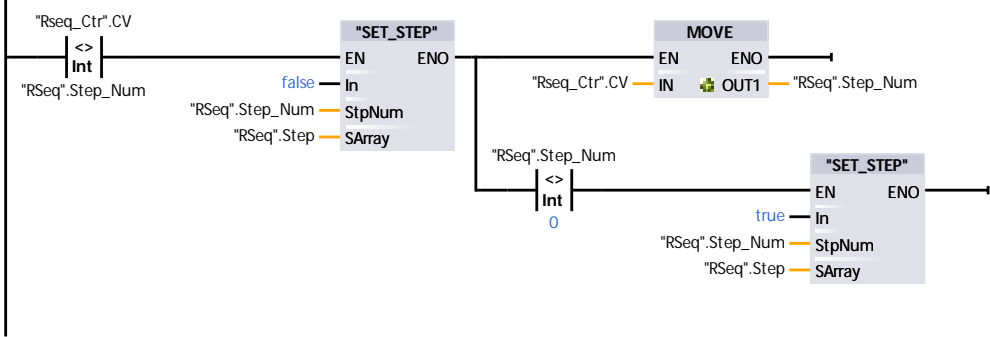
Reset pb starts, reset step 4 stops it.



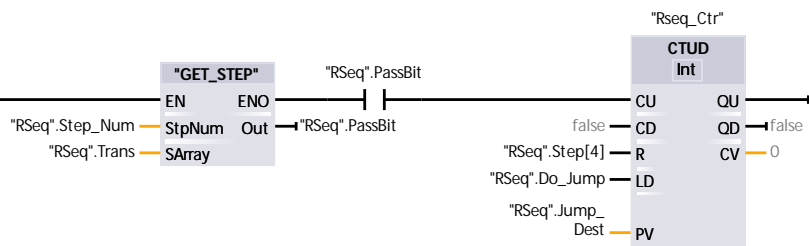
Network 21: First press of reset pb starts reset



Network 22: Change reset step-in-progress bit when step changes.

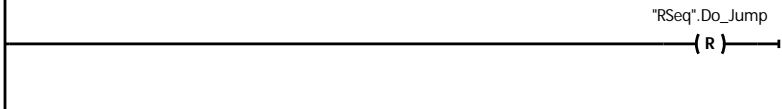


Network 23: Reset increment to next step when step-done bit set.



Network 24:

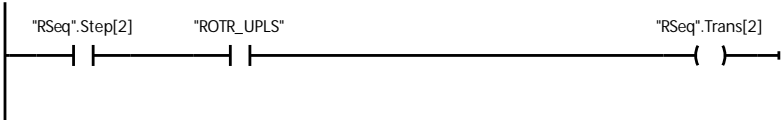
Always reset jump bit



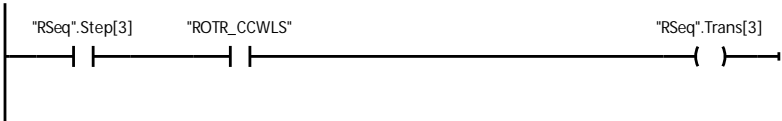
Network 25: Reset step 1 - Unclamp.



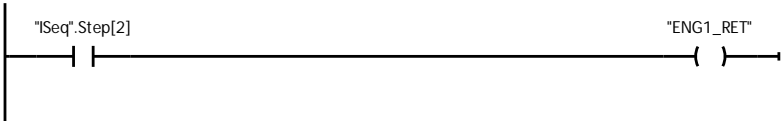
Network 26: Reset step 2 - Raise mechanism.



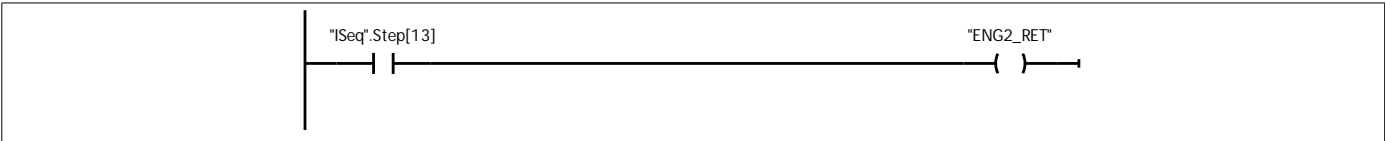
Network 27: Reset step 3 - Rotate CCW.



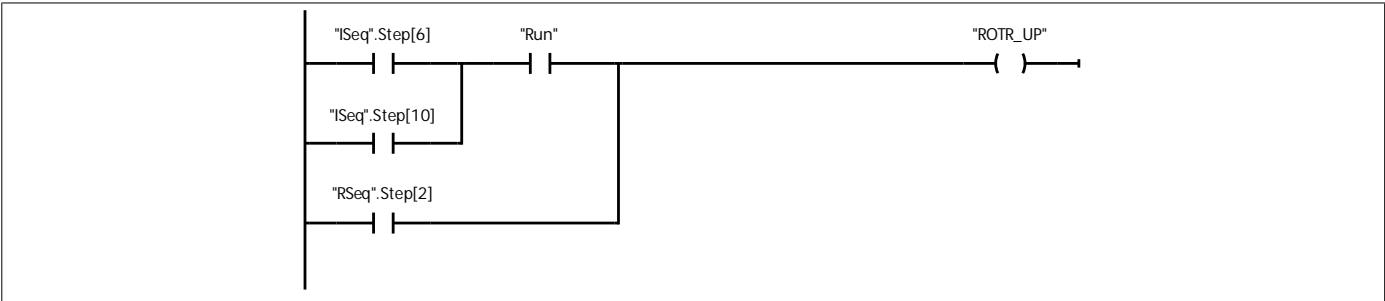
Network 28: Engaging hooks control



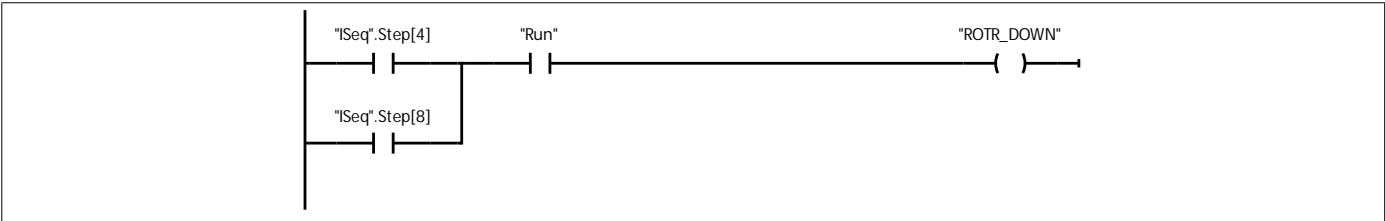
Network 29:



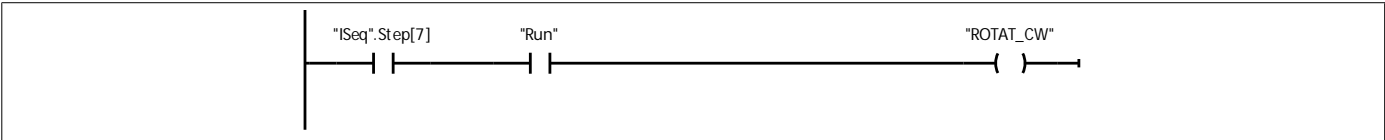
Network 30: Rotating mechanism up/down control.



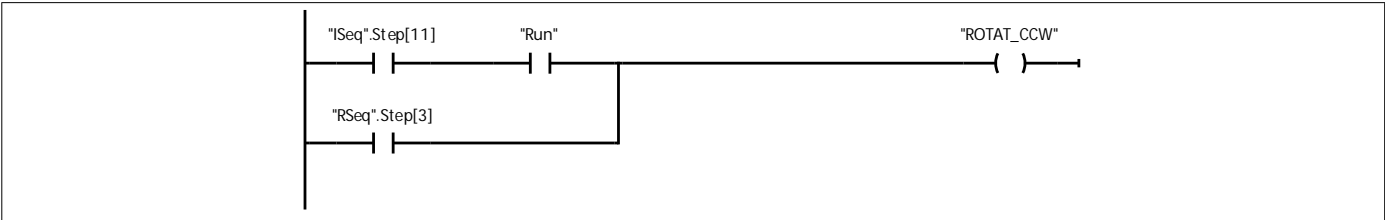
Network 31:



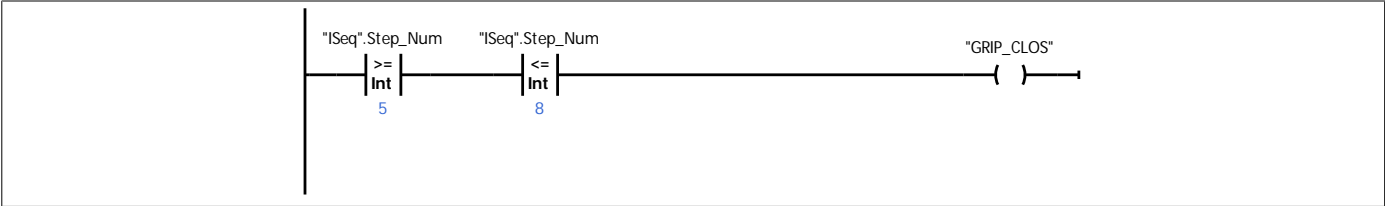
Network 32: Rotation Control



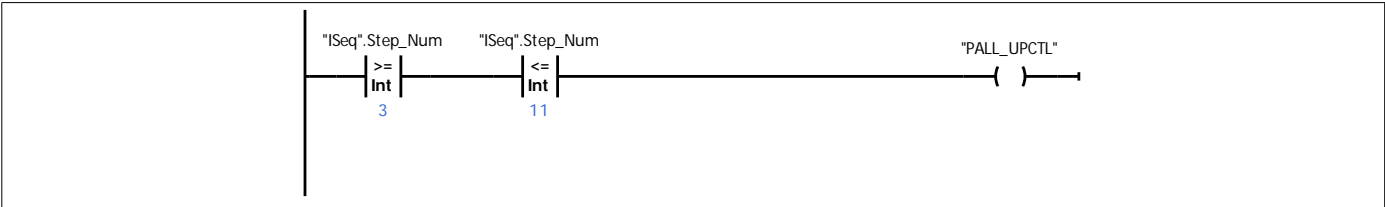
Network 33:



Network 34: Gripper Control



Network 35: Pallet Up Control



Network 36: Call simulation

