

Main [OB1]

Main Properties

General

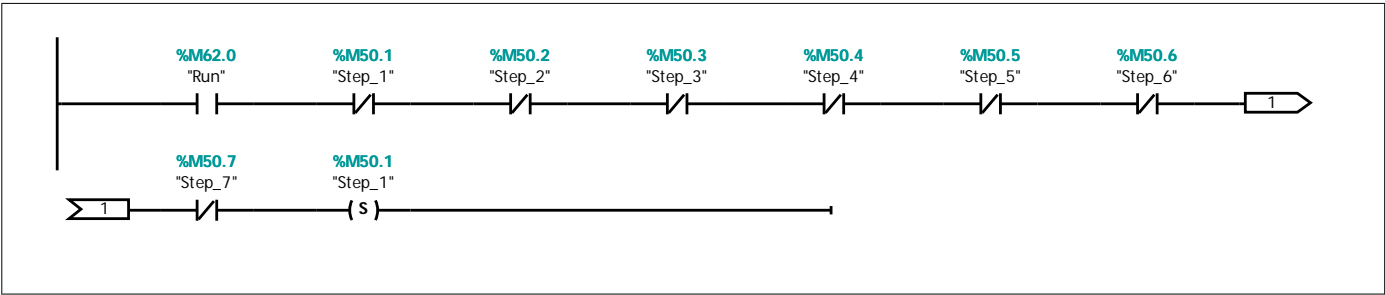
Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

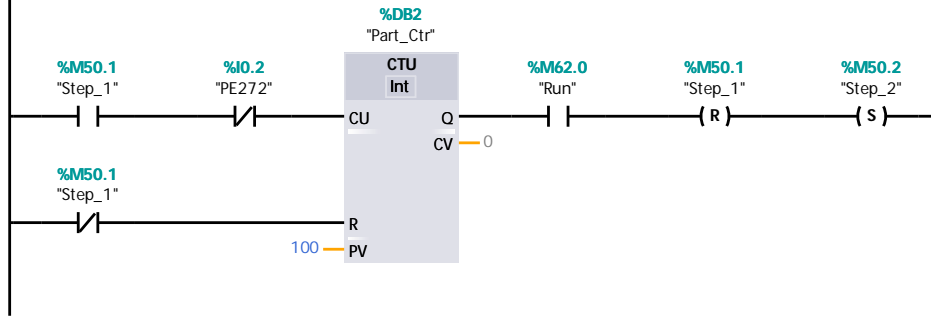
Title	"Main Program Sweep (Cycle)"	Author		Comment	Example 6.3 - Parts Tub Loader Copyright (c) 2023 Dogwood Valley Press, LLC
Family		Version	0.1	User-defined ID	

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 transition out of initial step



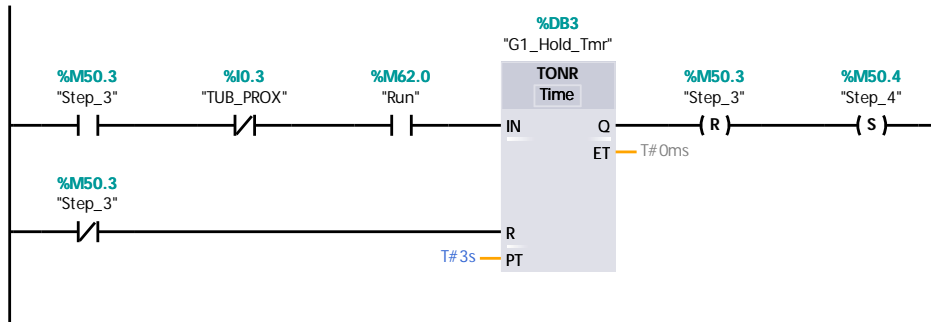
Network 2: Part Counter



Network 3: Step 2 - Open Gate 1



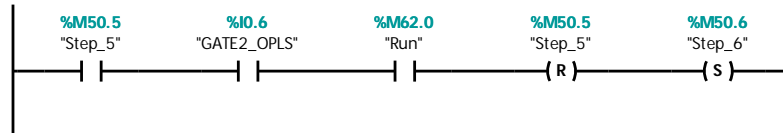
Network 4: Step 3 - Hold gate 1 open for 3 secs after tub passes



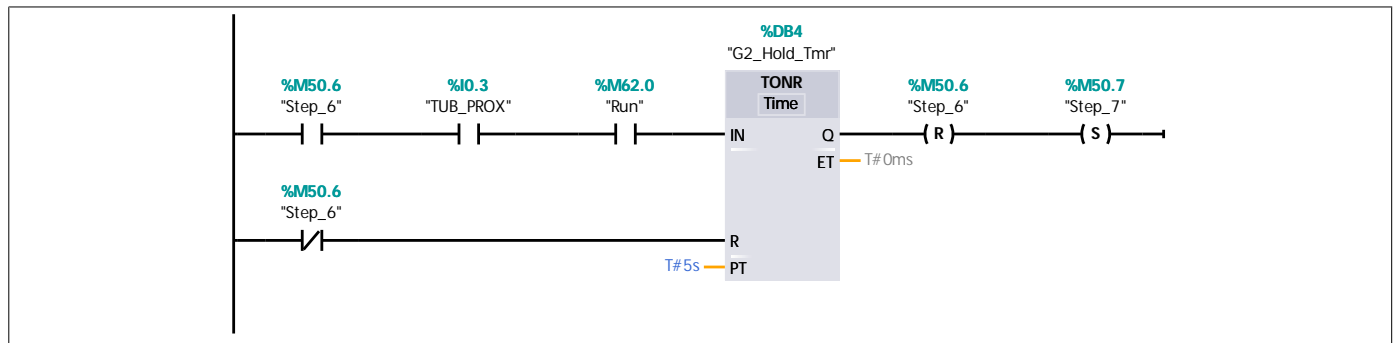
Network 5: Step 4 - Close Gate 1



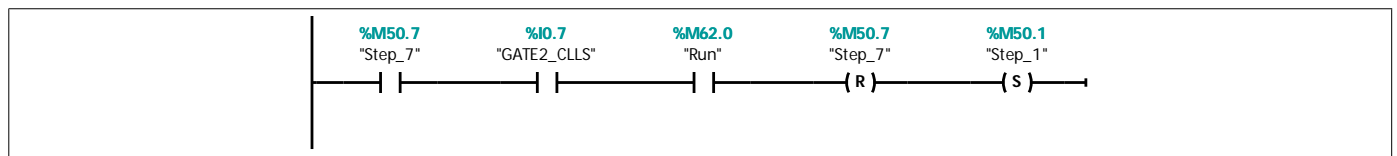
Network 6: Step 5 - Open Gate 2



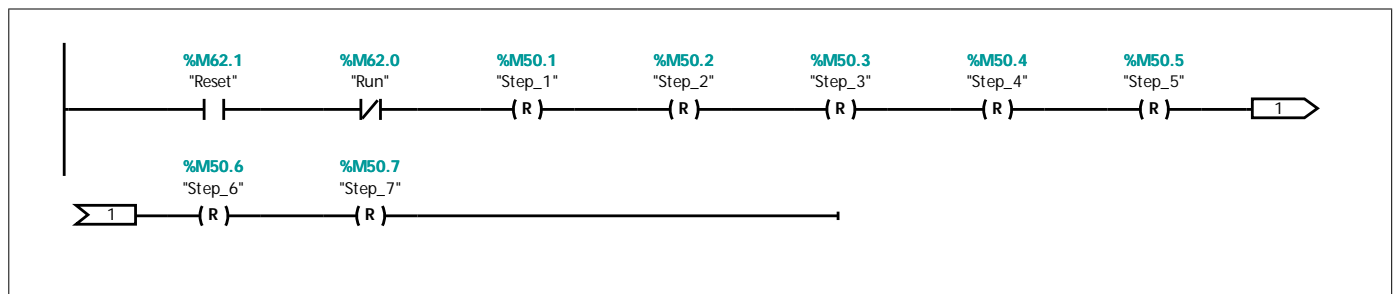
Network 7: Step 6 - Hold gate 2 open for 5 secs after tub passes.



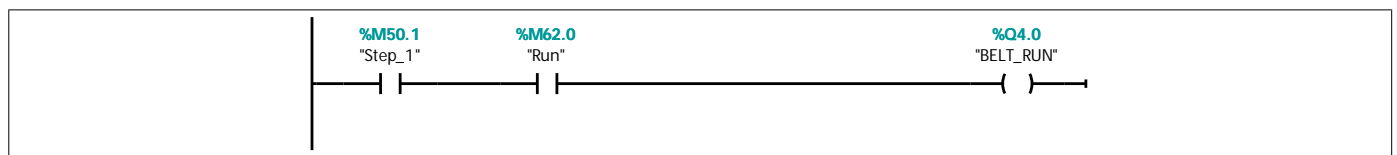
Network 8: Step 7 - Close Gate 2



Network 9: Reset steps



Network 10: Belt conveyor control



Network 11: Roll conveyor control



Network 12: Gate 1 cylinder control



Network 13: Gate 2 cylinder control



Network 14: Tub permissive control

