

Main [OB1]

Main Properties

General

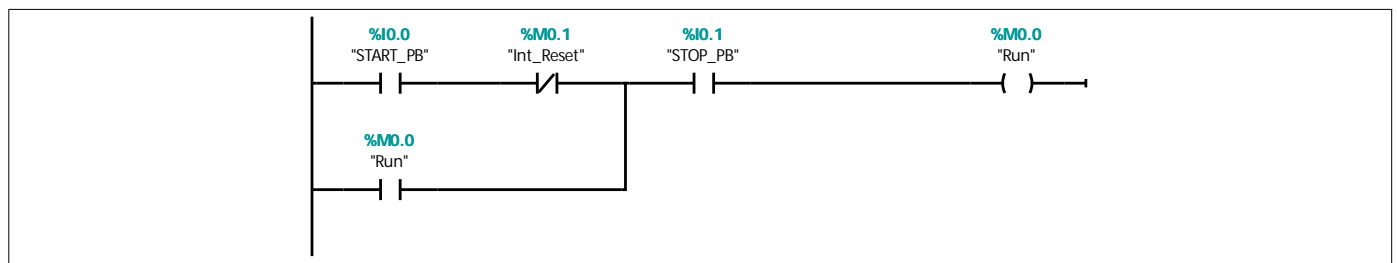
Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

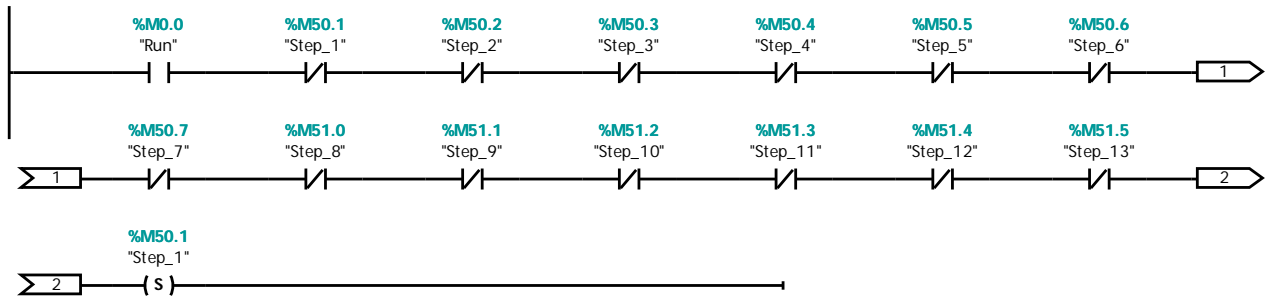
Title	"Main Program Sweep (Cycle)"	Author		Comment	Example 6.4 - Engine Inverter Copyright (c) 2022 Dogwood Valley Press, LLC
Family		Version	0.1	User-defined ID	

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	
Temp1	Bool	
Temp2	Bool	
Constant		

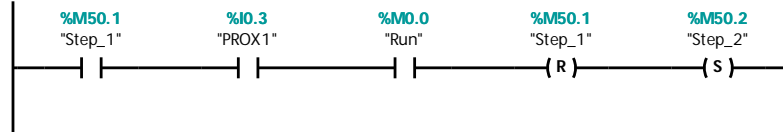
Network 1: Overall start/stop/pause



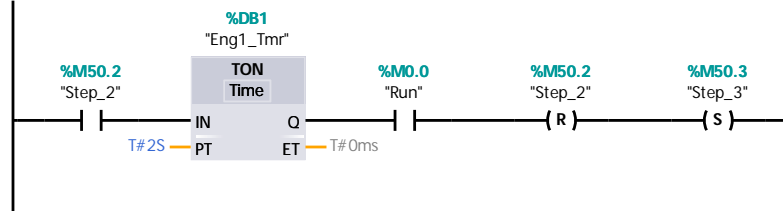
Network 2: Generate transition out of initial step



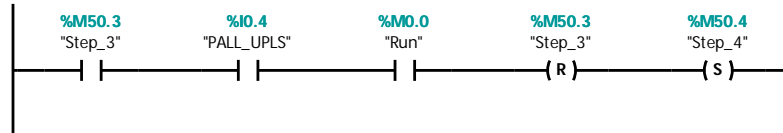
Network 3: Step 1 - Wait for pallet.



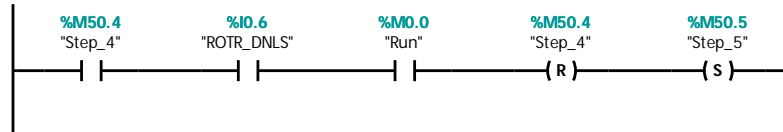
Network 4: Step 2 - - Move to hook 2



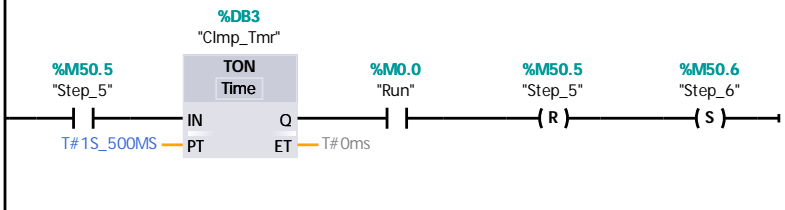
Network 5: Step 3 - Raise pallet



Network 6: Step 4 - Lower rotator



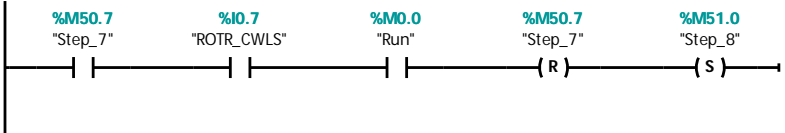
Network 7: Step 5 - Clamp engine



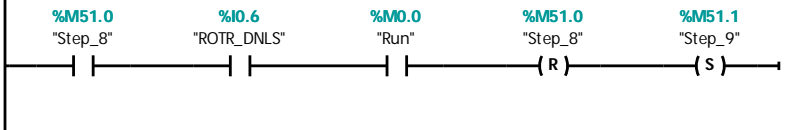
Network 8: Step 6 - Raise rotator



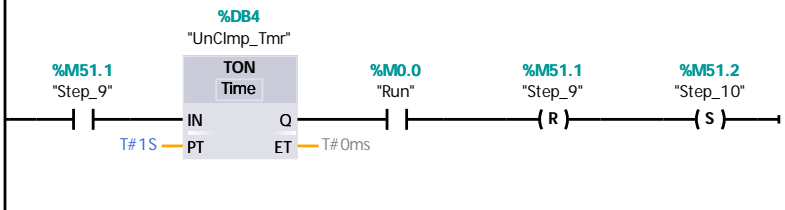
Network 9: Step 7 - Rotate clockwise



Network 10: Step 8 - Lower rotator



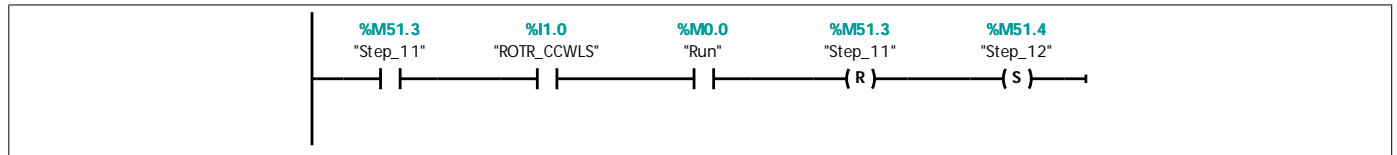
Network 11: Step 9 - Unclamp



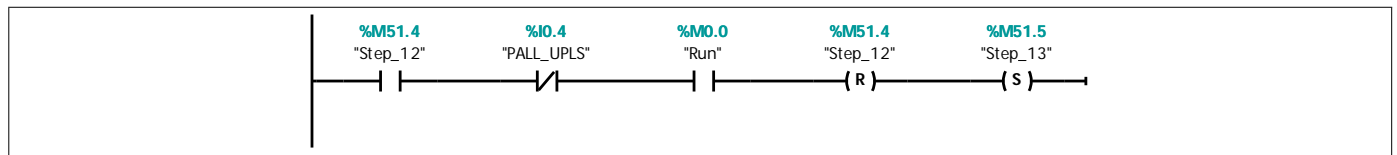
Network 12: Step 10 - Raise rotator



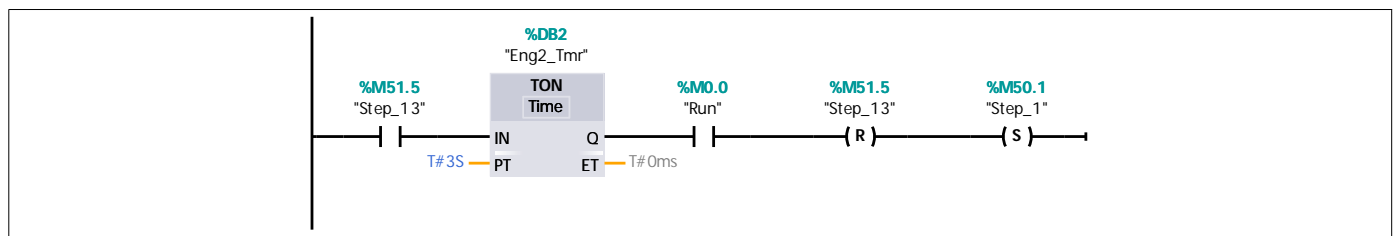
Network 13: Step 11 - Rotate CCW



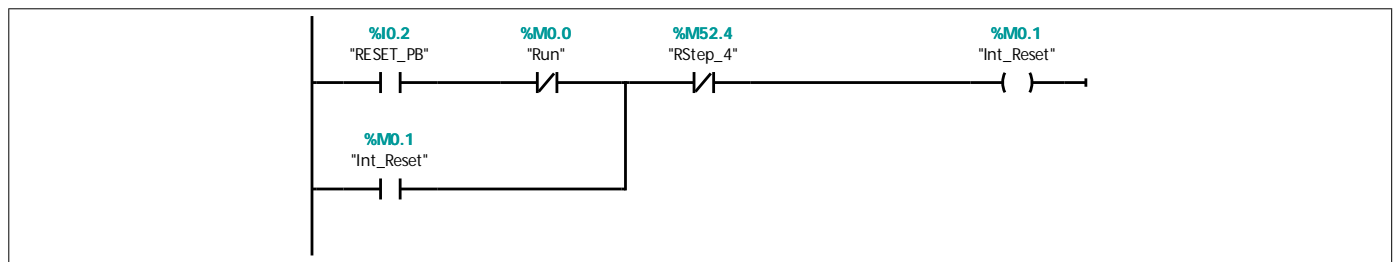
Network 14: Step 12 - Drop Engine



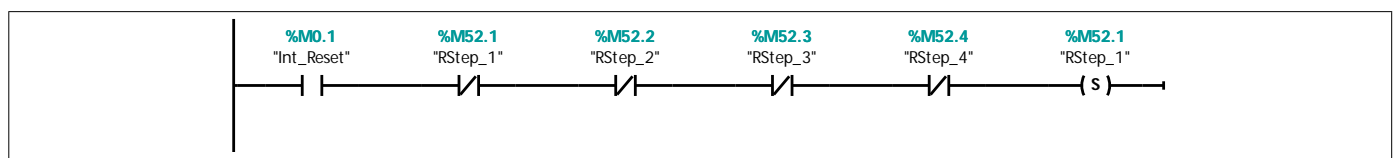
Network 15: Step 13 - Move out pallet



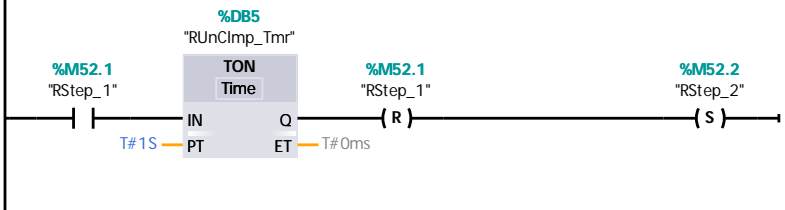
Network 16: Start/stop for reset operation



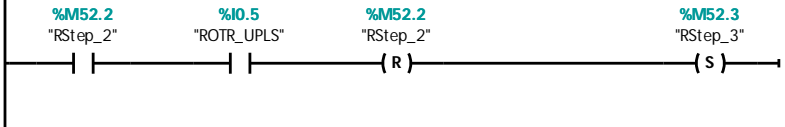
Network 17: First press of reset pb starts reset



Network 18: Reset step 1 - Delay to unclamp



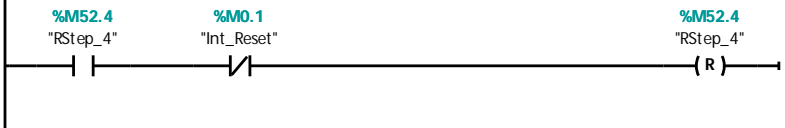
Network 19: Reset step 2 - Raise mechanism



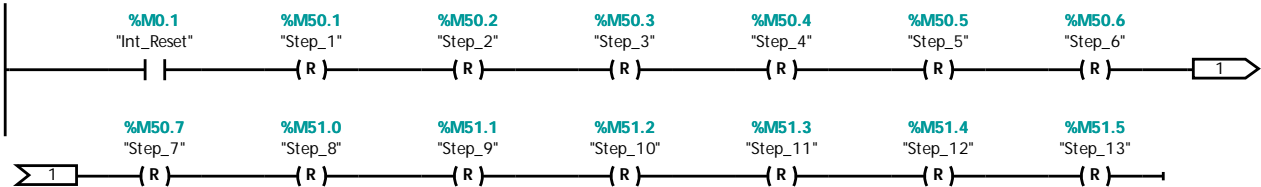
Network 20: Reset step 3 - Rotate CCW



Network 21: Reset step 4 - Unlatch internal reset



Network 22: Reset steps of main operation



Network 23: Engaging hooks control

%M50.2
"Step_2"

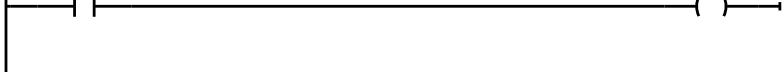
%Q4.0
"ENG1_RET"



Network 24:

%M51.5
"Step_13"

%Q4.1
"ENG2_RET"



Network 25: Rotating mechanism up/down control

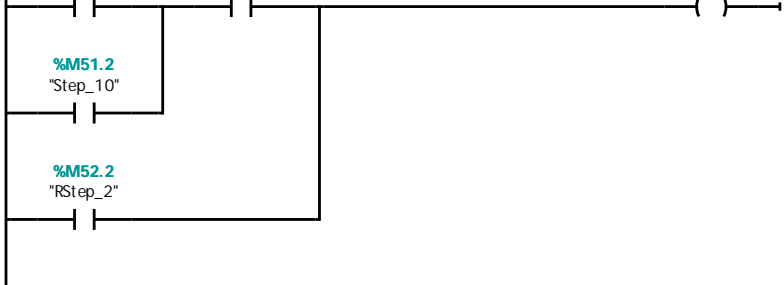
%M50.6
"Step_6"

%M0.0
"Run"

%Q4.2
"ROTR_UP"

%M51.2
"Step_10"

%M52.2
"RStep_2"



Network 26:

%M50.4
"Step_4"

%M0.0
"Run"

%Q4.3
"ROTR_DOWN"

%M51.0
"Step_8"

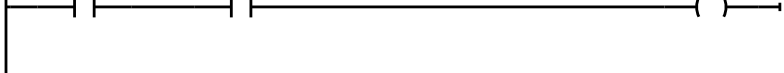


Network 27: Rotation control

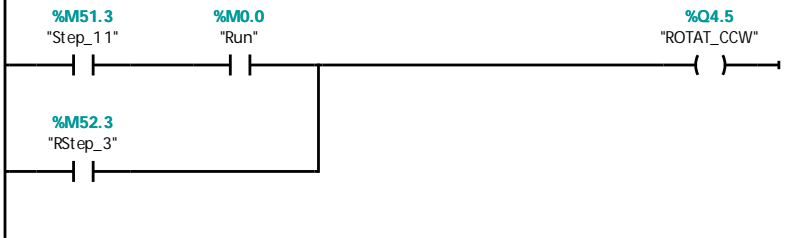
%M50.7
"Step_7"

%M0.0
"Run"

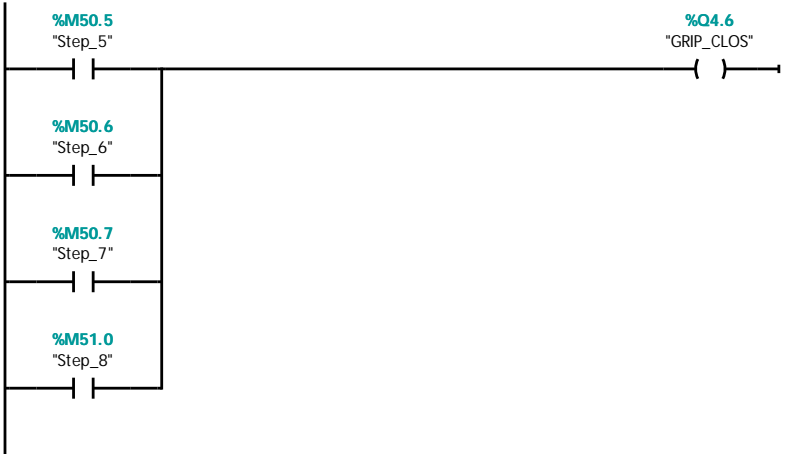
%Q4.4
"ROTAT_CW"



Network 28:



Network 29: Gripper control



Network 30: Pallet up control

