

Totally Integrated Automation Portal

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

Information

Title	"Main Program Sweep (Cycle)"	Author		Comment	Example 21.2 Marking Defective Parts  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:

%DB1

"Mark\_Def\_DB"

%FB1

"Mark\_Def"

EN

ENO

## Mark\_Def [FB1]

### Mark\_Def Properties

#### General

<b>Name</b>	Mark_Def	<b>Number</b>	1	<b>Type</b>	FB
<b>Language</b>	SCL	<b>Numbering</b>	Manual		

#### Information

<b>Title</b>		<b>Author</b>		<b>Comment</b>	
<b>Family</b>		<b>Version</b>	0.1	<b>User-defined ID</b>	

Name	Data type	Default value
Input		
Output		
InOut		
▼ Static		
P_Seal	Bool	false
S_Done	Bool	false
St_Delay	TON_TIME	
Pls_Tmr	TON_TIME	
Temp		
Constant		

```

0001  (* Example 12.2 Marking defective parts *)
0002
0003  (* Copyright 2022 Dogwood Valley Press *)
0004
0005  IF NOT #P_Seal THEN
0006      IF ( ("PDEFECT" AND (NOT "PROX5")) AND (NOT #S_Done) ) THEN
0007          #P_Seal := TRUE;
0008      END_IF;
0009  ELSE
0010      IF #S_Done THEN #P_Seal := FALSE;
0011      END_IF;
0012  END_IF;
0013  #St_Delay(IN:=#P_Seal, PT:=T#5.5s);
0014  "SPRAY" := #St_Delay.Q;
0015  #Pls_Tmr(IN:="SPRAY", PT:=T#1s);
0016  #S_Done := #Pls_Tmr.Q;

```