

## Main [OB1]

## Main Properties

## General

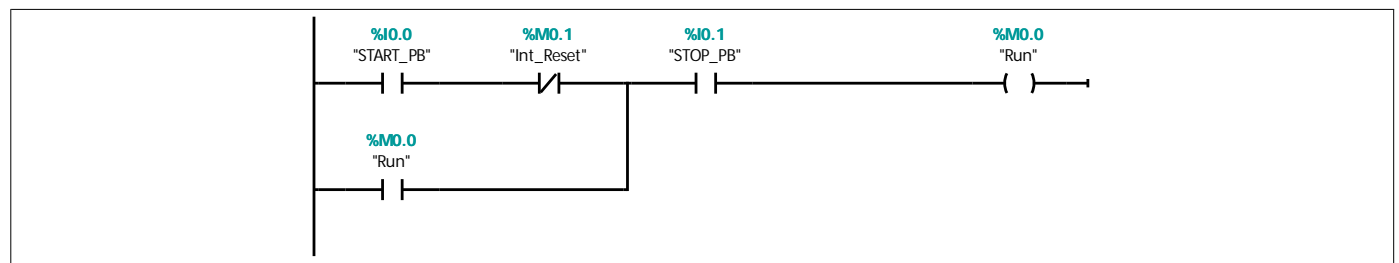
Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Manual		

## Information

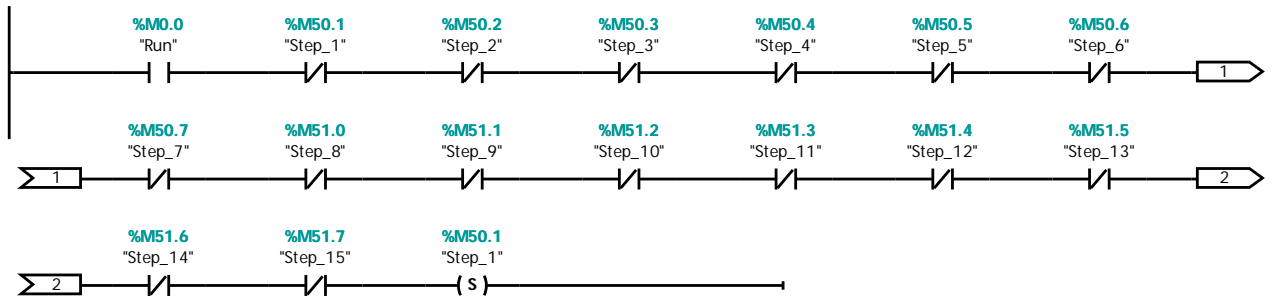
Title	"Main Program Sweep (Cycle)"	Author		Comment	Example 6.5 - Engine Inverter with parallel steps  Copyright (c) 2022 Dogwood Valley Press, LLC
Family		Version	0.1	User-defined ID	

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		

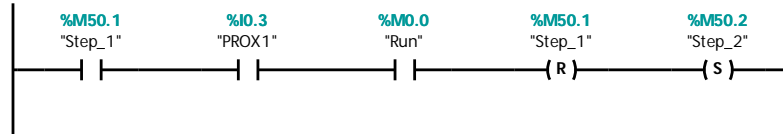
## Network 1: Overall start/stop/pause



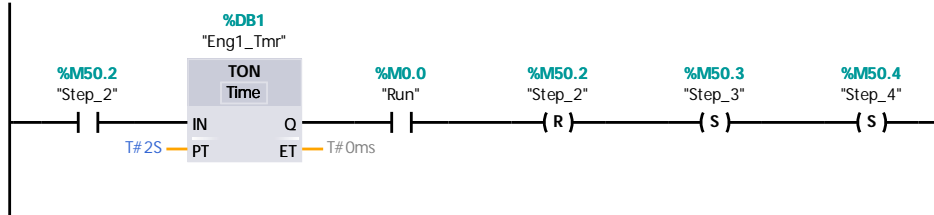
## Network 2: Generate transition out of initial step



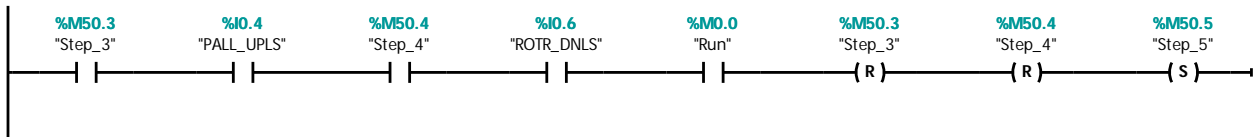
### Network 3: Step 1 - Wait for pallet.



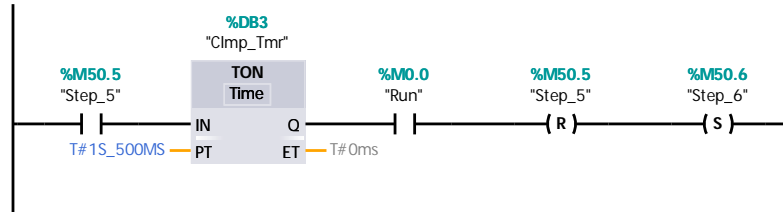
### Network 4: Step 2 - Move to hook 2



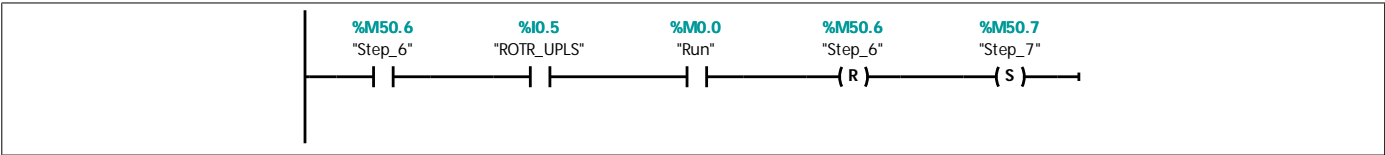
### Network 5: Step 3 & 4 - Wait for pallet raised & rotator lowered



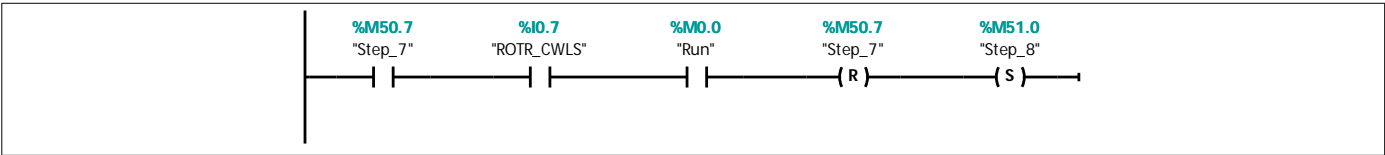
### Network 6: Step 5 - Clamp engine



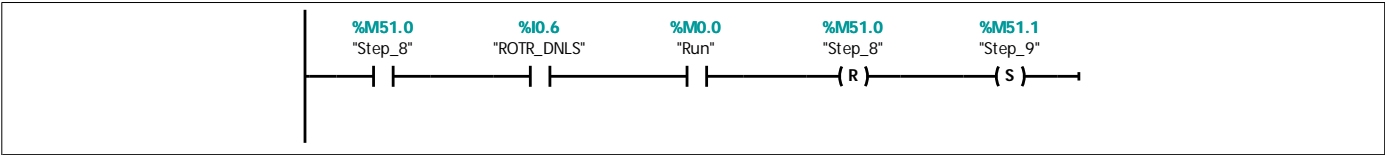
Network 7: Step 6 - Raise rotator



Network 8: Step 7 - Rotate clockwise

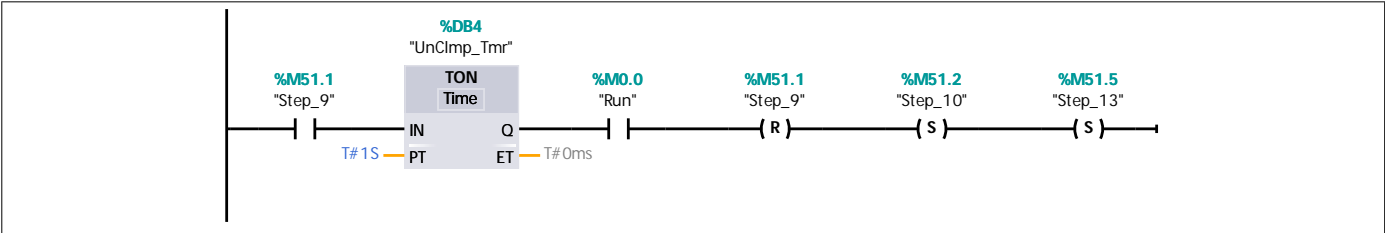


Network 9: Step 8 - Lower rotator

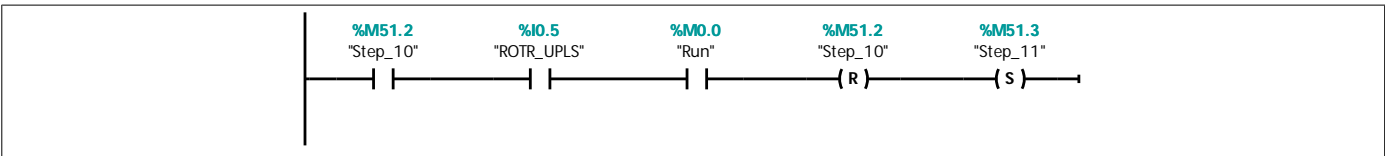


Network 10: Step 9 - Unclamp

Transition to steps 10 and 13 after 1 sec



Network 11: Step 10 - Raise rotator



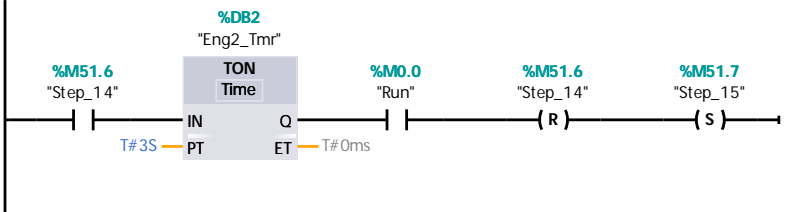
Network 12: Step 11 - Rotate CCW



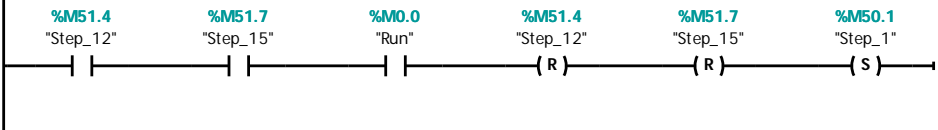
**Network 13: Step 13 - Drop Engine**



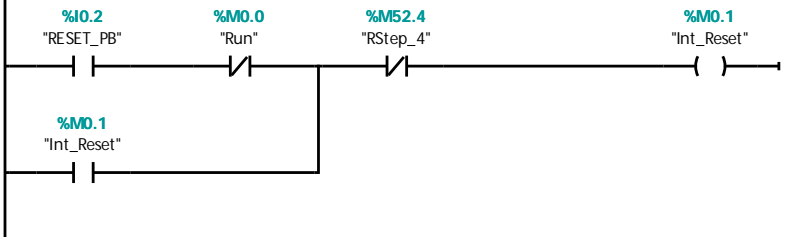
**Network 14: Step 14 - Move out pallet**



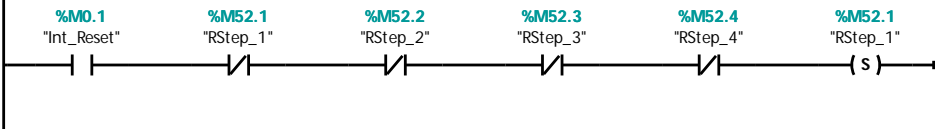
**Network 15: Steps 12 & 15 - Wait for both to be active before starting over**



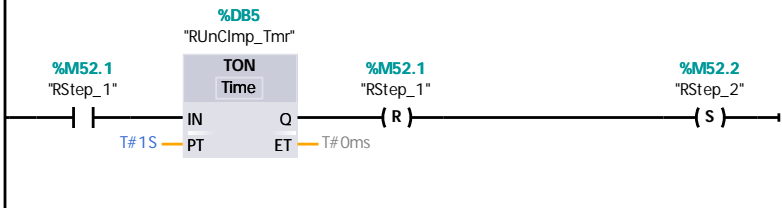
**Network 16: Start/stop for reset operation**



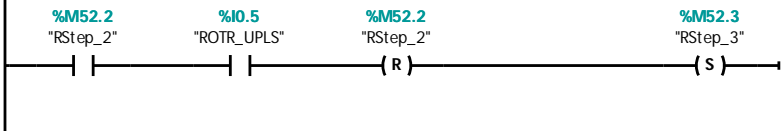
**Network 17: First press of reset pb starts reset**



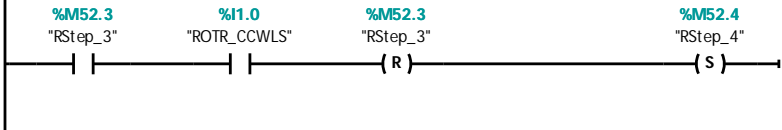
**Network 18: Reset step 1 - Delay to unclamp**



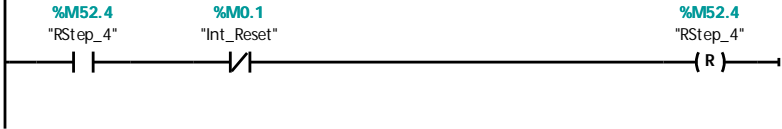
**Network 19: Reset step 2 - Raise mechanism**



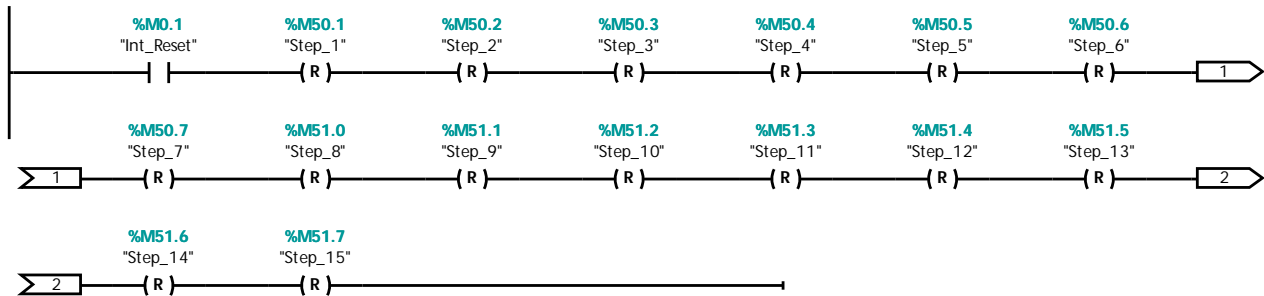
**Network 20: Reset step 3 - Rotate CCW**



**Network 21: Reset step 4 - Unlatch internal reset**



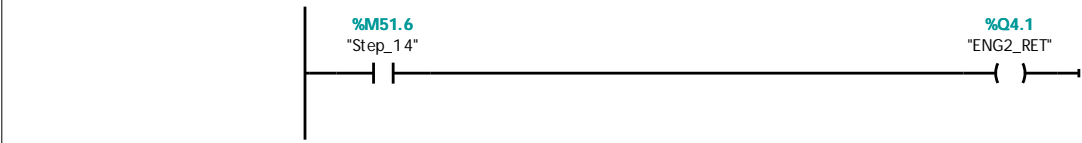
**Network 22: Reset steps of main operation**



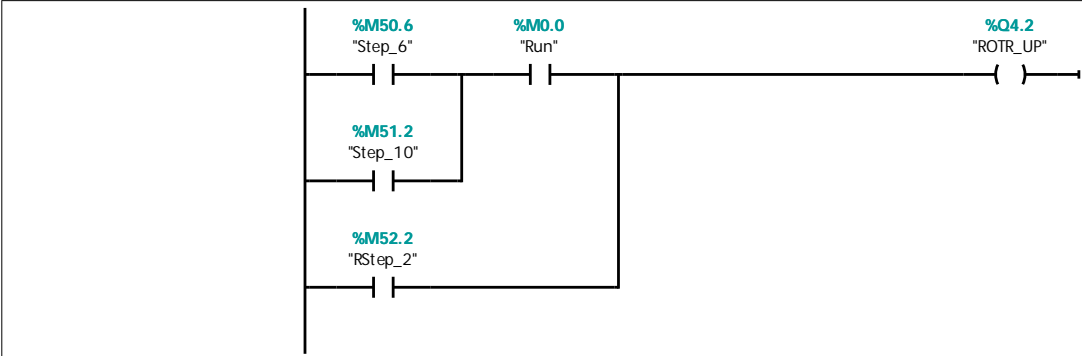
Network 23: Engaging hooks control



Network 24:



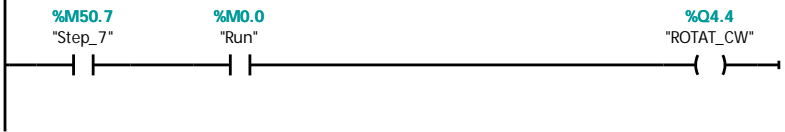
Network 25: Rotating mechanism up/down control



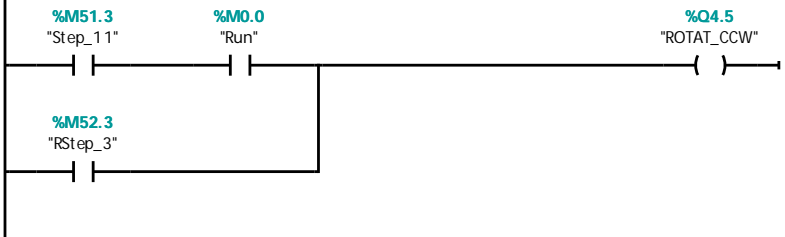
Network 26:



Network 27: Rotation control



Network 28:



Network 29: Gripper control



Network 30: Pallet up control

