

OB1 - <offline>

"Cycle Execution"

Name:

Author:

Time stamp Code:

Lengths (block/logic/data):

Family:

Version: 0.1

Block version: 2

01/15/2023 10:52:50 PM

02/15/1996 04:51:12 PM

01332 01160 00020

Name	Data Type	Address	Comment
TEMP		0.0	
OB1_EV_CLASS	Byte	0.0	Bits 0-3 = 1 (Coming event), Bits 4-7 = 1 (Event class 1)
OB1_SCAN_1	Byte	1.0	1 (Cold restart scan 1 of OB 1), 3 (Scan 2-n of OB 1)
OB1_PRIORITY	Byte	2.0	Priority of OB Execution
OB1_OB_NUMBR	Byte	3.0	1 (Organization block 1, OB1)
OB1_RESERVED_1	Byte	4.0	Reserved for system
OB1_RESERVED_2	Byte	5.0	Reserved for system
OB1_PREV_CYCLE	Int	6.0	Cycle time of previous OB1 scan (milliseconds)
OB1_MIN_CYCLE	Int	8.0	Minimum cycle time of OB1 (milliseconds)
OB1_MAX_CYCLE	Int	10.0	Maximum cycle time of OB1 (milliseconds)
OB1_DATE_TIME	Date_And_Time	12.0	Date and time OB1 started

Block: OB1 "Main Program Sweep (Cycle)"

Network: 1

AN

FP

JCN

L

T

j1: NOP

"Stop"

M

j1

QB

MB

0

I1.4

0.1

20

0

Network: 2

A

FP

JCN

L

T

j2: NOP

"Start"

M

j2

MB

QB

0

I1.3

0.2

20

0

Network: 3

A

O

S

AN

R

"Start"

"Reset"

M

"Stop"

M

I1.3

I1.5

0.0

I1.4

0.0

Network: 4

reset counter 1

```
A(
O    "LeftEntry"    I1.0
FN   M      0.3
O    "RightEntry"   I0.7
FN   M      0.4
)
A(
L    MW      12
L    10
==I
)
R    C      1
```

Network: 5

reset counter 0

```
A    "Entry"        I0.0
FP   M      7.3
A(
L    MW      10
L    10
==I
)
R    C      0
```

Network: 6

```
A    M      0.0
A    "Start"        I1.3
A    M      0.0
S    "Conv1"        Q0.0
```

Network: 7

counter 0

```
A    "S1"           I0.1
FP   M      0.5
CU   C      0

L    C      0
T    MW      10
```

Network: 8

counter 0 & set & right

```
A(
L    MW      10
L    1
==I
)
A    "S1"           I0.1
S    M      5.0

A(
L    MW      10
L    2
==I
)
A    "S1"           I0.1
S    M      5.1

A(
L    MW      10
```

```
L      3
==I
)
A      "S1"      IO.1
S      M          5.2
```

```
A(
L      MW      10
L      4
==I
)
A      "S1"      IO.1
S      M          5.3
```

```
A(
L      MW      10
L      5
==I
)
A      "S1"      IO.1
S      M          5.4
```

```
A(
L      MW      10
L      6
==I
)
A      "S1"      IO.1
S      M          5.5
```

```
A(
L      MW      10
L      7
==I
)
A      "S1"      IO.1
S      M          5.6
```

```
A(
L      MW      10
L      8
==I
)
A      "S1"      IO.1
S      M          5.7
```

```
A(
L      MW      10
L      9
==I
)
A      "S1"      IO.1
S      M          50.0
```

```
A(
L      MW      10
L      10
==I
)
A      "S1"      IO.1
S      M          50.1
```

Network: 9

counter 0 & reset & left

A(
L MW 10
L 1
==I
)
A "S1" I0.1
A "S2" I0.2
R M 5.0

A(
L MW 10
L 2
==I
)
A "S1" I0.1
A "S2" I0.2
R M 5.1

A(
L MW 10
L 3
==I
)
A "S1" I0.1
A "S2" I0.2
R M 5.2

A(
L MW 10
L 4
==I
)
A "S1" I0.1
A "S2" I0.2
R M 5.3

A(
L MW 10
L 5
==I
)
A "S1" I0.1
A "S2" I0.2
R M 5.4

A(
L MW 10
L 6
==I
)
A "S1" I0.1
A "S2" I0.2
R M 5.5

A(
L MW 10
L 7
==I
)
A "S1" I0.1
A "S2" I0.2
R M 5.6

```
A(
L      MW      10
L      8
==I
)
A      "S1"      I0.1
A      "S2"      I0.2
R      M      5.7
```

```
A(
L      MW      10
L      9
==I
)
A      "S1"      I0.1
A      "S2"      I0.2
R      M      50.0
```

```
A(
L      MW      10
L      10
==I
)
A      "S1"      I0.1
A      "S2"      I0.2
R      M      50.1
```

Network: 10 counter 1

```
A      "TurntableEntry" I0.3
FN     M      0.6
CU     C      1

L      C      1
T      MW      12
```

Network: 11

```
A      M      0.0
A      "Entry"      I0.0
FP     M      0.7
AN     "TurnTable"  Q0.4
S      "Conv2"      Q0.1
```

```
//
A      M      0.0
A      "TurntableEntry" I0.3
FP     M      7.1
A(
//
O      "Front"      I0.6
FP     M      7.3
//
O      "Back"      I1.6
FN     M      7.4

)
R      "Conv2"      Q0.1
R      "Conv1"      Q0.0
```

Network: 12

```
//
A      M      0.0
A      "TurntableEntry" I0.3
FP     M      7.0
A      "LoadPosition"  I0.4
S      "LoadLeft"      Q0.2
```

```

A      M      0.0
//    O      "Front"
//    FN     M      7.4
      A      "Back"      I1.6
      FN     M      7.5

      R      "LoadLeft"      Q0.2
//    S      "TurnTable"

//
//
//    A      M      0.0
//    O      "Front"
//    FN     M      7.4
      A      "Back"      I1.6
      FN     M      15.2

//    R      "LoadLeft"
      S      "TurnTable"      Q0.4
```

Network: 13

```

A      M      0.0
A      "UnloadPosition"  I0.5
A      "TurnTable"      Q0.4
AN     M      5.0
A(
  L     MW     12
  L     1
==I
)

S      "LoadLeft"      Q0.2

A      M      0.0
A      "UnloadPosition"  I0.5
A      "TurnTable"      Q0.4
AN     M      5.1
A(
  L     MW     12
  L     2
==I
)

S      "LoadLeft"      Q0.2

A      M      0.0
A      "UnloadPosition"  I0.5
A      "TurnTable"      Q0.4
AN     M      5.2
A(
  L     MW     12
  L     3
==I
)

S      "LoadLeft"      Q0.2

A      M      0.0
A      "UnloadPosition"  I0.5
A      "TurnTable"      Q0.4
AN     M      5.3
A(
  L     MW     12
  L     4
==I
```

```
)

S      "LoadLeft"      Q0.2


A      M      0.0
A      "UnloadPosition" I0.5
A      "TurnTable"     Q0.4
AN     M      5.4
A(
L      MW     12
L      5
==I
)

S      "LoadLeft"      Q0.2


A      M      0.0
A      "UnloadPosition" I0.5
A      "TurnTable"     Q0.4
AN     M      5.5
A(
L      MW     12
L      6
==I
)

S      "LoadLeft"      Q0.2


A      M      0.0
A      "UnloadPosition" I0.5
A      "TurnTable"     Q0.4
AN     M      5.6
A(
L      MW     12
L      7
==I
)

S      "LoadLeft"      Q0.2


A      M      0.0
A      "UnloadPosition" I0.5
A      "TurnTable"     Q0.4
AN     M      5.7
A(
L      MW     12
L      8
==I
)

S      "LoadLeft"      Q0.2


A      M      0.0
A      "UnloadPosition" I0.5
A      "TurnTable"     Q0.4
AN     M      50.0
A(
L      MW     12
L      9
==I
)

S      "LoadLeft"      Q0.2


A      M      0.0
A      "UnloadPosition" I0.5
A      "TurnTable"     Q0.4
AN     M      50.1
A(
```

```
L      MW      12
L      10
==I
)

S      "LoadLeft"      Q0.2
```

Network: 14

```
A      M      0.0
A      "LeftEntry"      I1.0
S      "LeftConv"      Q0.5
```

```
A      M      0.0
A      "LeftEntry"      I1.0
FN     M      16.0
R      "LoadLeft"      Q0.2
//     R      "TurnTable"
```

```
//     A      M      0.0
//     A      "LeftEntry"      I1.0
//     FN     M      16.1
//     R      "LoadLeft"
//     R      "TurnTable"      Q0.4
```

Network: 15

```
A      M      0.0
A      "LeftExit"      I1.2
FN     M      1.5
R      "LeftConv"      Q0.5
```

Network: 16

```
A      M      0.0
A      "UnloadPosition"      I0.5
A      "TurnTable"      Q0.4
A      M      5.0
A(
L      MW      12
L      1
==I
)
S      "Right"      Q0.3
```

```
A      M      0.0
A      "UnloadPosition"      I0.5
A      "TurnTable"      Q0.4
A      M      5.1
A(
L      MW      12
L      2
==I
)
S      "Right"      Q0.3
```

```
A      M      0.0
A      "UnloadPosition"      I0.5
A      "TurnTable"      Q0.4
A      M      5.2
```



```

A(
L      MW      12
L      3
==I
)
S      "Right"          Q0.3

```

```

A      M      0.0
A      "UnloadPosition" I0.5
A      "TurnTable"      Q0.4
A      M      5.3
A(
L      MW      12
L      4
==I
)
S      "Right"          Q0.3

```

```

A      M      0.0
A      "UnloadPosition" I0.5
A      "TurnTable"      Q0.4
A      M      5.4
A(
L      MW      12
L      5
==I
)
S      "Right"          Q0.3

```

```

A      M      0.0
A      "UnloadPosition" I0.5
A      "TurnTable"      Q0.4
A      M      5.5
A(
L      MW      12
L      6
==I
)
S      "Right"          Q0.3

```

```

A      M      0.0
A      "UnloadPosition" I0.5
A      "TurnTable"      Q0.4
A      M      5.6
A(
L      MW      12
L      7
==I
)
S      "Right"          Q0.3

```

```

A      M      0.0
A      "UnloadPosition" I0.5
A      "TurnTable"      Q0.4
A      M      5.7
A(
L      MW      12
L      8
==I
)
S      "Right"          Q0.3

```

```

A      M      0.0
A      "UnloadPosition" I0.5
A      "TurnTable"      Q0.4
A      M      50.0
A(
L      MW      12
L      9
==I

```

```
)
S      "Right"          Q0.3

A      M      0.0
A      "UnloadPosition" I0.5
A      "TurnTable"     Q0.4
A      M      50.1
A(
L      MW      12
L      10
==I
)
S      "Right"          Q0.3
```

Network: 17

```
A      M      0.0
A      "RightEntry"     I0.7
S      "RightConv"      Q0.6
```

```
A      M      0.0
A      "RightEntry"     I0.7
FN     M      1.6
R      "Right"          Q0.3
//     R      "TurnTable"
```

```
//     A      M      0.0
//     A      "RightEntry" I0.7
//     FN     M      15.3
//     R      "Right"          Q0.4
//     R      "TurnTable"
```

Network: 18

```
//     A      M      0.0
//     A      "LoadPosition" I0.4
//     FP     M      1.7
//     A(
//
//     O      "RightConv"      Q0.6
//     O      "LeftConv"       Q0.5
//
//     )
//     S      "Conv1"          Q0.0
//     S      "Conv2"          Q0.1
```

Network: 19

```
A      M      0.0
A      "RightExit"      I1.1
FN     M      2.0
R      "RightConv"      Q0.6
```

Network: 20

```
A      M      0.0
AN     "Stop"           I1.4
R      C      0
R      C      1
```

Network: 21

```
//      A      M      0.0
//      A      "TurntableEntry"
//      FP      M      15.0
//      A(
//      O      "Back"
//      FN      M      15.1
//      O      "Front"
//      FP      M      15.2
//      )
//      R      "Conv1"
//      R      "Conv2"
```

Network: 22 to stop

```
      AN      "Stop"      I1.4
      R      "Conv1"      Q0.0
      R      "Conv2"      Q0.1
      R      "LoadLeft"   Q0.2
      R      "Right"      Q0.3
//  R      "TurnTable"
      R      "LeftConv"   Q0.5
      R      "RightConv"  Q0.6
```

```
//  AN      "Stop"
//  A(
//  O      "LoadPosition"
//  O      "UnloadPosition"
//  )
//  A(
//  ON      "LoadLeft"
//  ON      "Right"
//  )
//  A(
//  ON      "RightEntry"
//  ON      "LeftEntry"
//  )
//  AN      "TurnTable"
//  R      "TurnTable"
```

```
//  AN      "Stop"
//  R      "TurnTable"
```

Network: 23 to reset

```
A      "Reset"      I1.5
R      "Conv1"      Q0.0
R      "Conv2"      Q0.1
R      "LoadLeft"   Q0.2
R      "Right"      Q0.3
R      "TurnTable"  Q0.4
R      "LeftConv"   Q0.5
R      "RightConv"  Q0.6
R      C      0
R      C      1
```

```
A      "Reset"      I1.5
JCN    j3
L      0
T      MD      0
j3:    NOP      0
```

j5:

A"Reset" I1.5
JCN j5
L 0
T MD 4
NOP 0

j6:

A"Reset" I1.5
JCN j6
L 0
T MD 8
NOP 0

j7:

A"Reset" I1.5
JCN j7
L 0
T MD 20
NOP 0

j10:

A"Reset" I1.5
JCN j10
L 0
T MD 50
NOP 0

Network: 24

// AN "Stop"
// FP M 6.2
// JCN j4
// L 0
// T QB 0
// NOP 0