

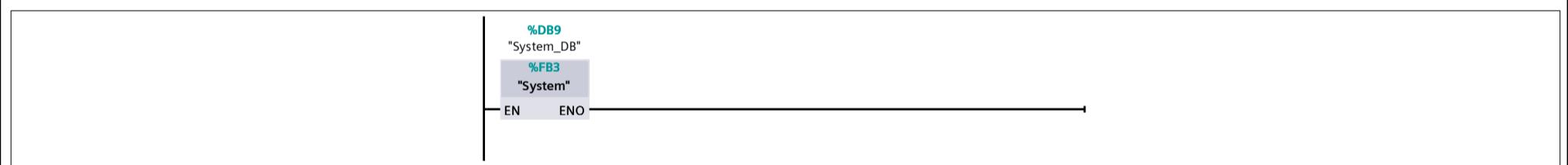
Totally Integrated Automation Portal		
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ECELabFinalProject / PLC_1 [CPU 314C-2 DP] / Program blocks

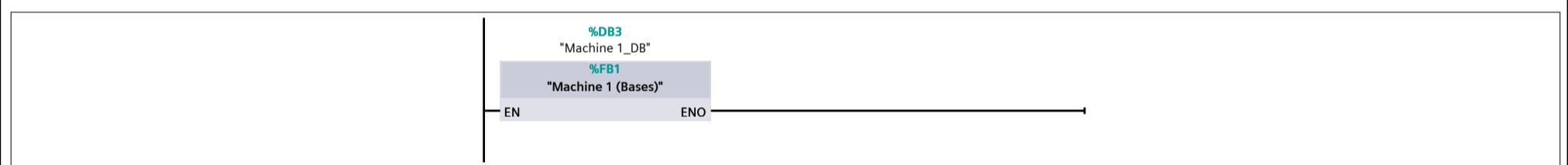
Main [OB1]

Main Properties						
General						
Name	Main	Number	1	Type	OB	Language LAD
Numbering	Manual					
Information						
Title	"Main Program Sweep (Cycle)"	Author		Comment		Family
Version	0.1	User-defined ID				
Main						
Name	Data type	Offset	Default value	Comment		
▼ Temp						
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		
Constant						

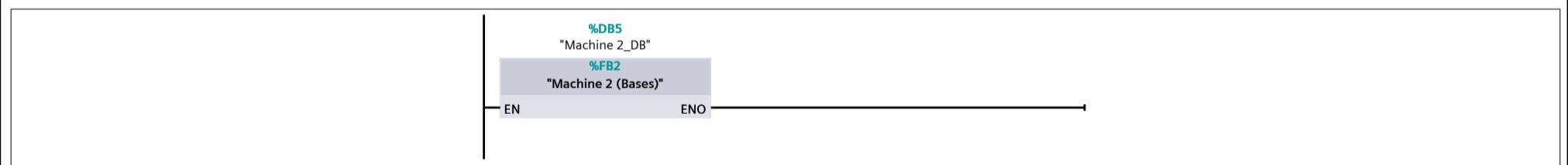
Network 1: System Start/Stop/E-Stop/Reset



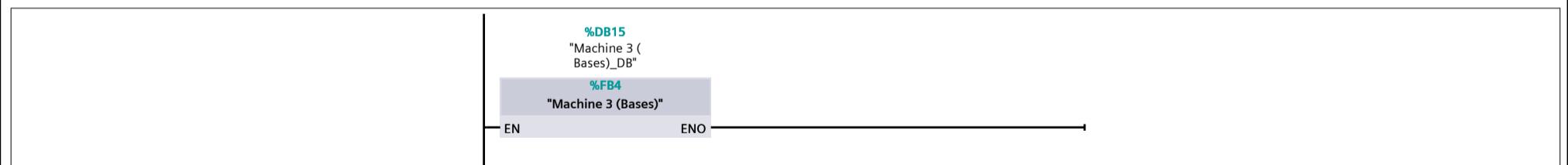
Network 2: Machine 1 (Bases)



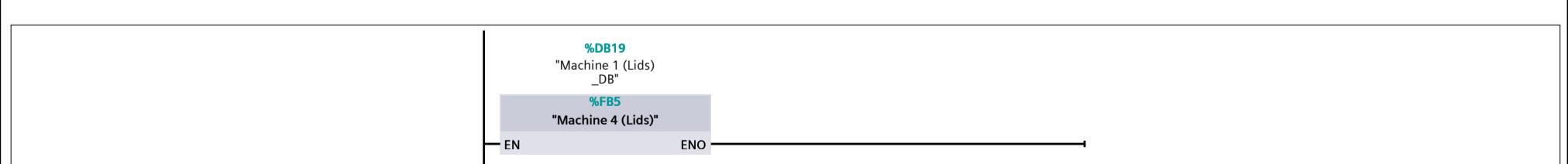
Network 3: Machine 2 (Bases)



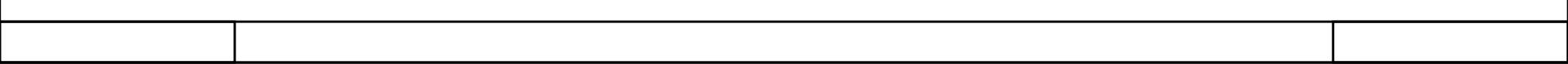
Network 4: Machine 3 (Bases)

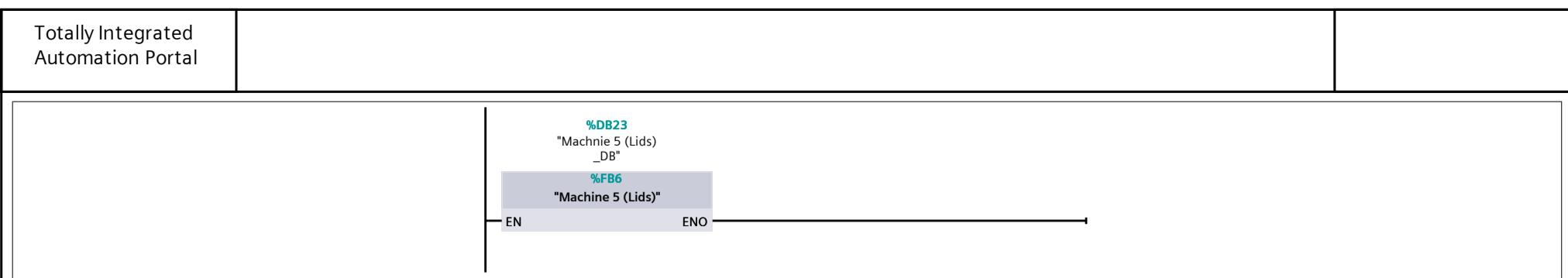


Network 5: Machine 4 (Lids)

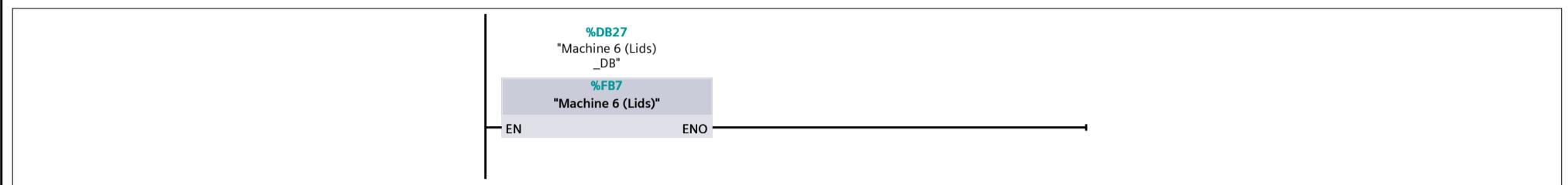


Network 6: Machine 5 (Lids)

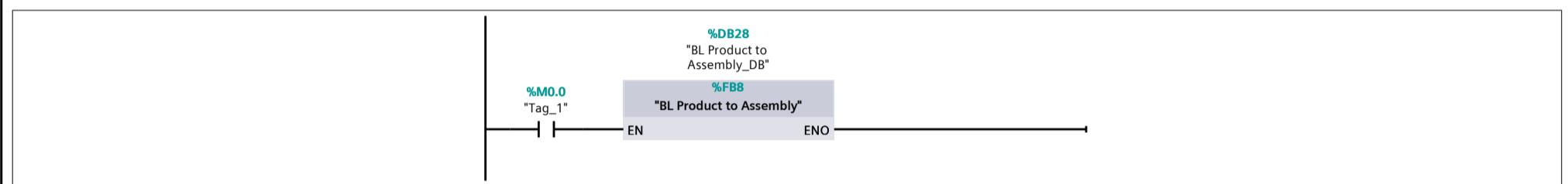




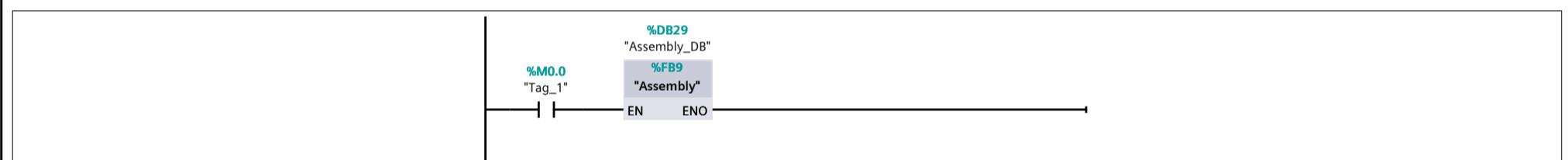
Network 7: Machine 6 (Lids)



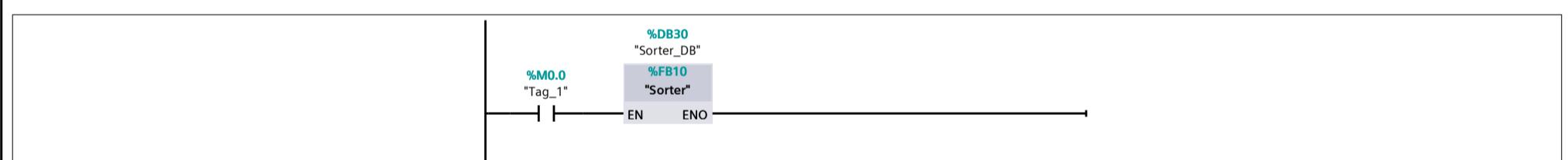
Network 8: BL Product to Assembly



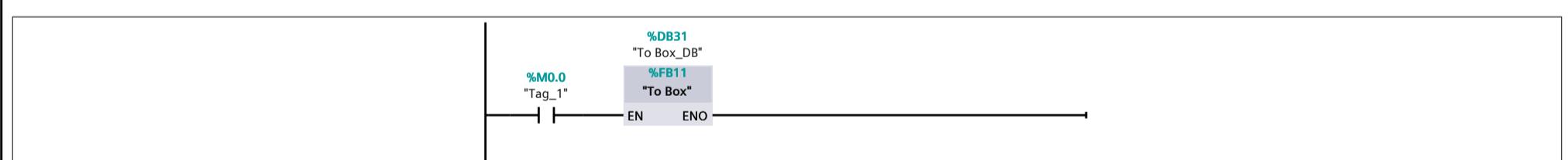
Network 9: Assembly



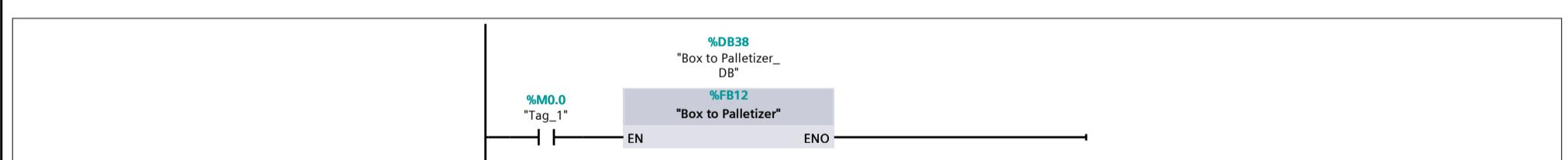
Network 10: Sorter



Network 11: To Box



Network 12:



Network 13:

