

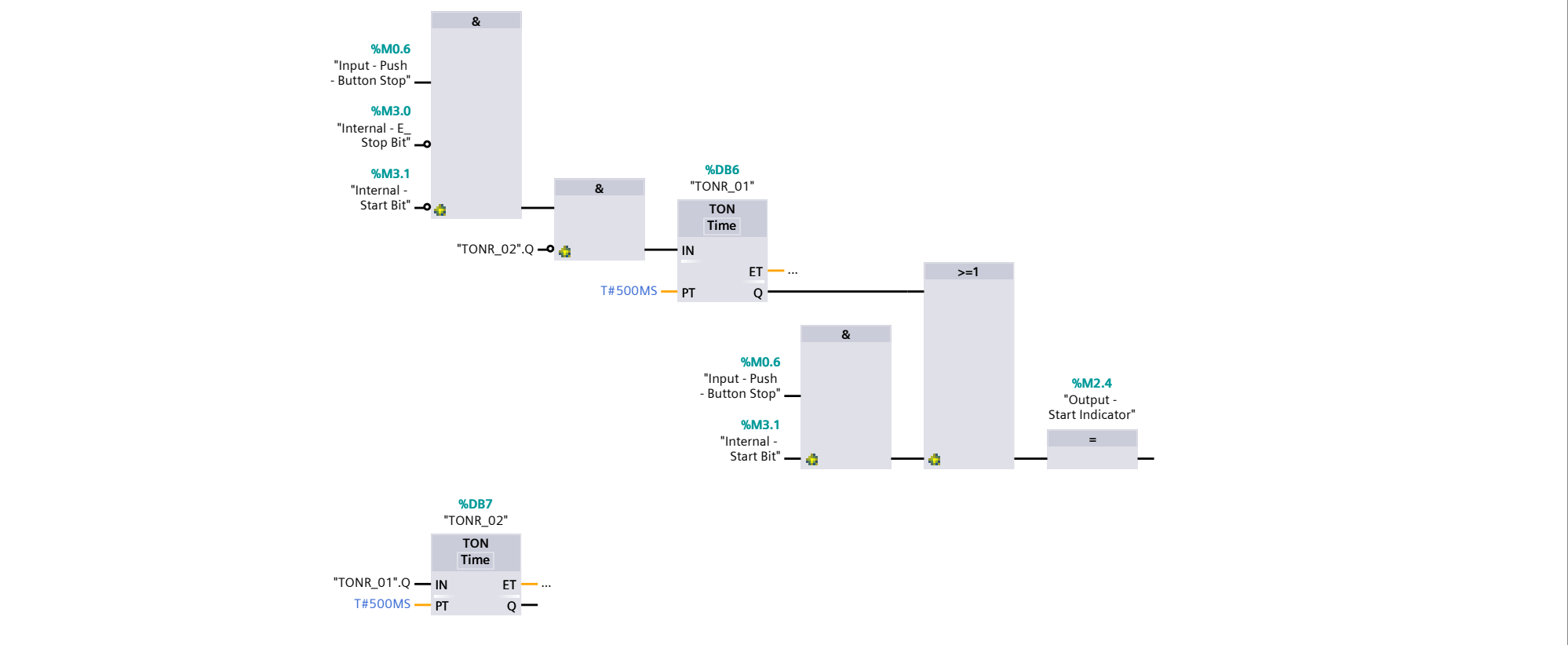
FrontPanel\_Lights [OB126]

FrontPanel_Lights Properties							
General							
Name	FrontPanel_Lights	Number	126	Type	OB	Language	FBD
Numbering	Automatic						
Information							
Title	"Main Program Sweep (Cycle)"	Author		Comment	FrontPanel_Light_Routine Function Block Language	Family	
Version	0.1	User-defined ID					

Name	Data type	Default value	Comment
▼ Input			
Initial_Call	Bool		Initial call of this OB
Remanence	Bool		=True, if remanent data are available
Temp			
Constant			

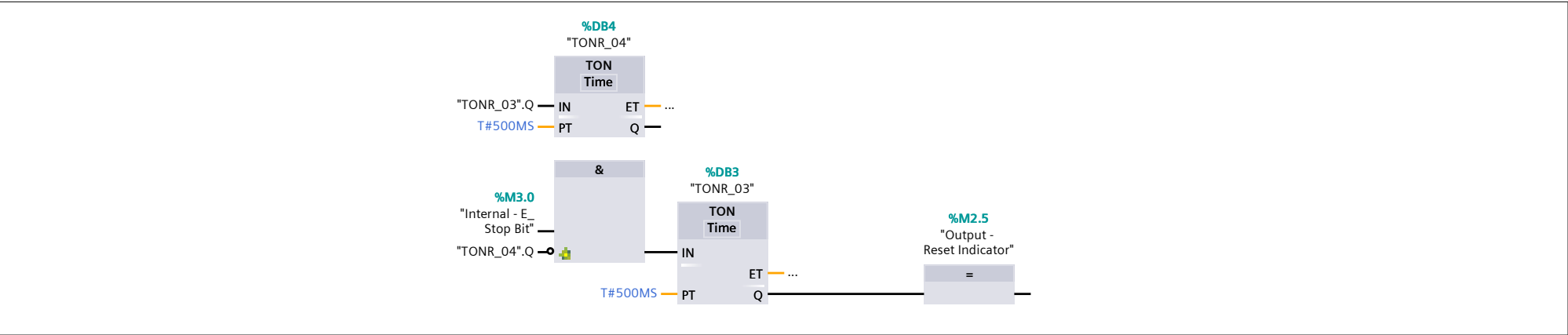
Network 1: Panel - Start Button Indicator

When Stop button is on, Stop Bit and Start Bit is not enabled. It will start blinking which require operator to press the start button. The light will turn solid.



Network 2: Panel - Reset Indicator

The reset button indicator will blink if stop bit is latched.



Totally Integrated Automation Portal

### Input\_Mapping [OB123]

Input\_Mapping Properties

General

Name	Input_Mapping	Number	123	Type	OB	Language	LAD
Numbering	Automatic						

Information

Title	"Main Program Sweep (Cycle)"	Author		Comment	Input_Mapping_Routine	Family	
Version	0.1	User-defined ID					

Name	Data type	Default value	Comment
▼ Input			
Initial_Call	Bool		Initial call of this OB
Remanence	Bool		=True, if remanent data are available
Temp			
Constant			

#### Network 1: Workpiece Enter Conveyor #1

%I0.0  
"Workpiece Enter Conveyor #1"

%M0.0  
"Input - Sensor Conveyor #1 Start"

#### Network 2: Workpiece in Middle of Conveyor #1

%I0.1  
"Wrokpiece in Middle of Conveyor #1"

%M0.1  
"Input - Sensor Conveyor #1 Stopper"

#### Network 3: No Workpiece at End of Conveyor #1

%I0.2  
"No Workpiece at End of Conveyor #1"

%M0.2  
"Input - Sensor Conveyor #1 End"

#### Network 4: Distance Sensor

%I0.3  
"Distance Sensor"

%M0.3  
"Input - Sensor Conveyor #1 Distance Sensor"

#### Network 5: Workpiece Enter Conveyor #2

%I0.4  
"Workpiece Enter Conveyor #2"

%M0.4  
"Input - Sensor Conveyor #2 Enter"

#### Network 6: Push-Button Start

%I0.5  
"Push-Button Start"

%M0.5  
"Input - Push - Button Start"

## Network 7: Push-Button Stop



## Network 8: Switch-Auto/Manual



## Network 9: Push-Button Reset



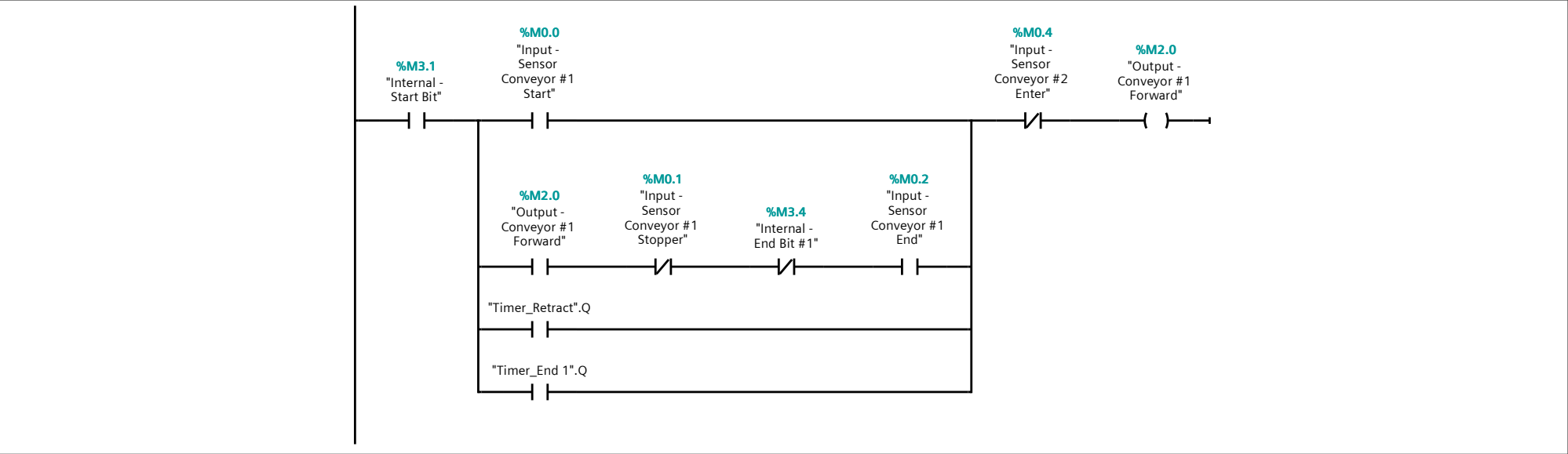
Main [OB1]

Main Properties							
General							
Name	Main	Number	1	Type	OB	Language	LAD
Numbering	Automatic						
Information							
Title	"Main Program Sweep (Cycle)"	Author		Comment	Separating Station Hangsihak Sin -- Dalton Miyabara	Family	
Version	0.1	User-defined ID					

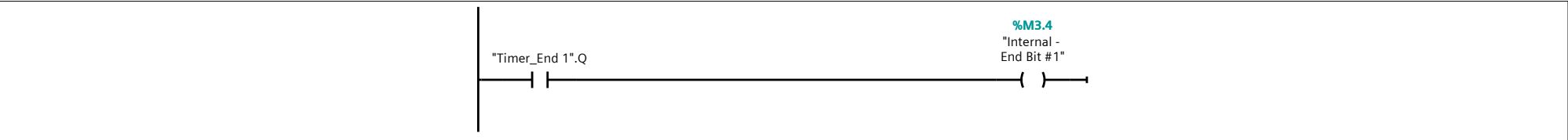
Name	Data type	Default value	Comment
▼ Input			
Initial_Call	Bool		Initial call of this OB
Remanence	Bool		=True, if remanent data are available
Temp			
Constant			

Network 1: Conveyor #1 Belt Motor

Conveyor #1 Forward Direction. It will move if workpiece enter conveyor, after scanned, passed conveyor #1 or #2 end sensor

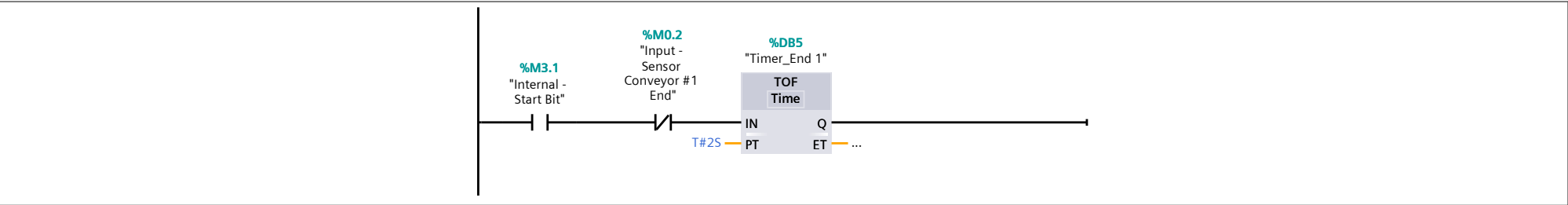


Network 2: Conveyor #2 Internal End Bit



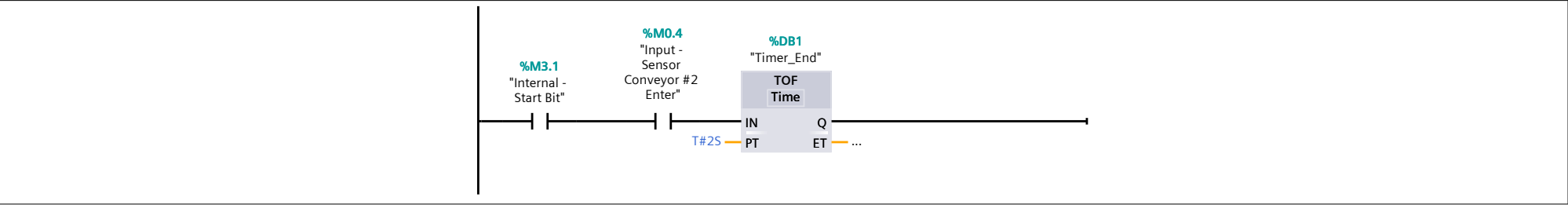
Network 3: Conveyor #2 Timer

Allow conveyor #2 to run for an additional 2 seconds after Workpiece has passed the diffuse sensor



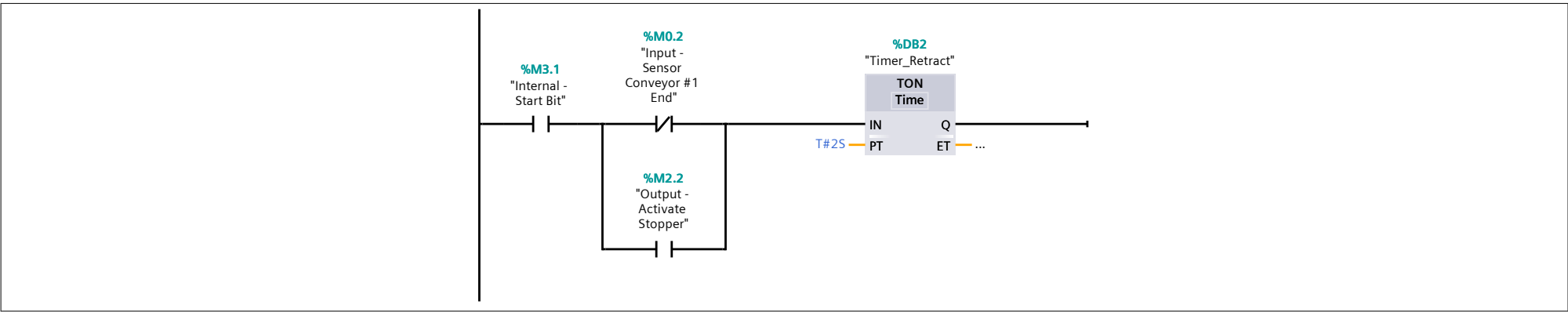
Network 4: Conveyor #1 Timer

Allow conveyor #1 to run for an additional 2 seconds after Workpiece has passed the diffuse sensor



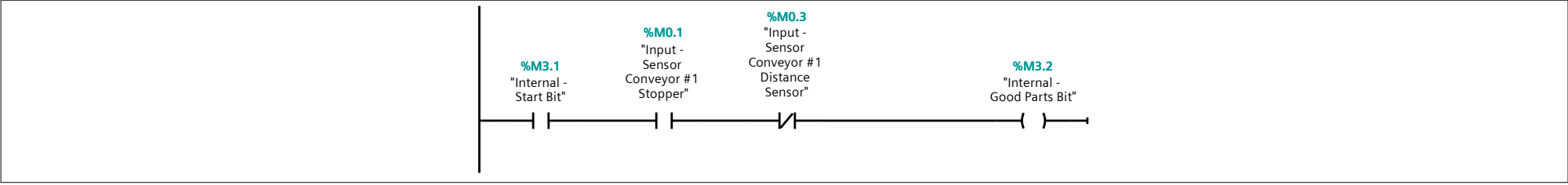
Network 5: Retract Stopper Motor

Allow Motor to move after it has been scan/measure by diffuse and distance sensor



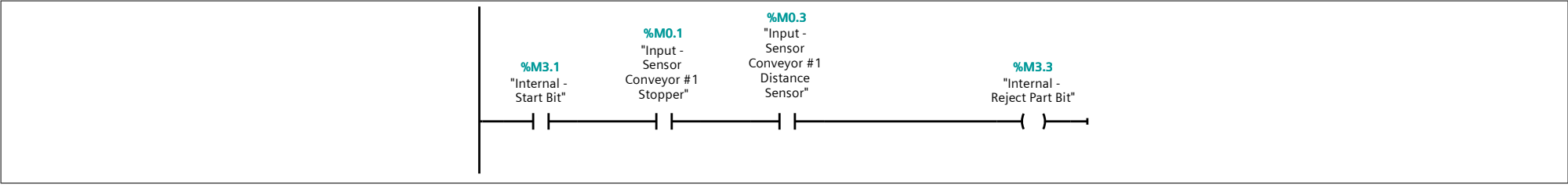
## Network 6: Good Parts Bit

Open Top Workpiece



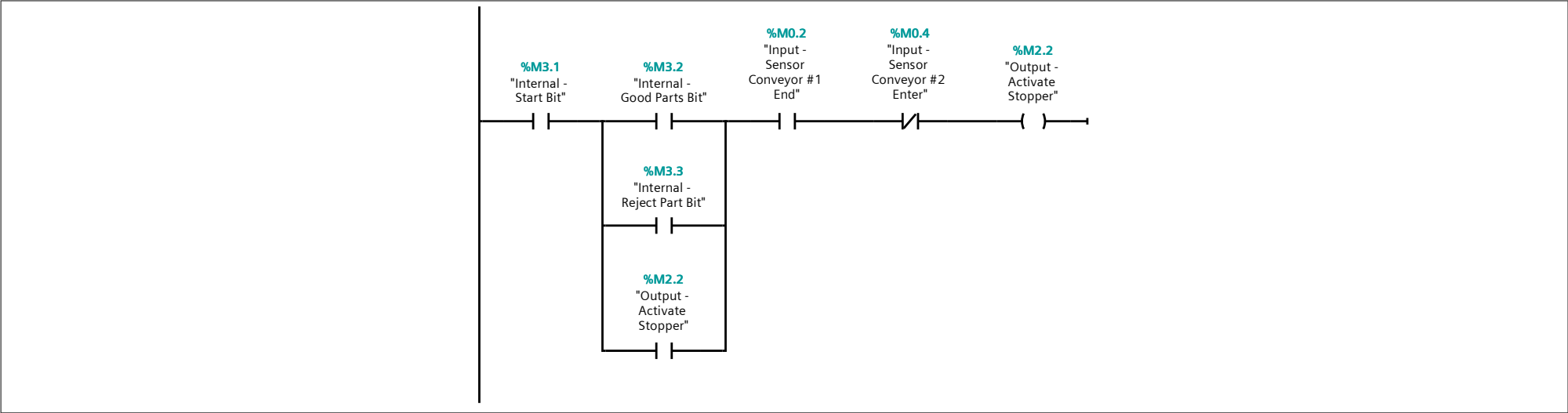
## Network 7: Reject Parts Bit

## Closed Top Workpiece



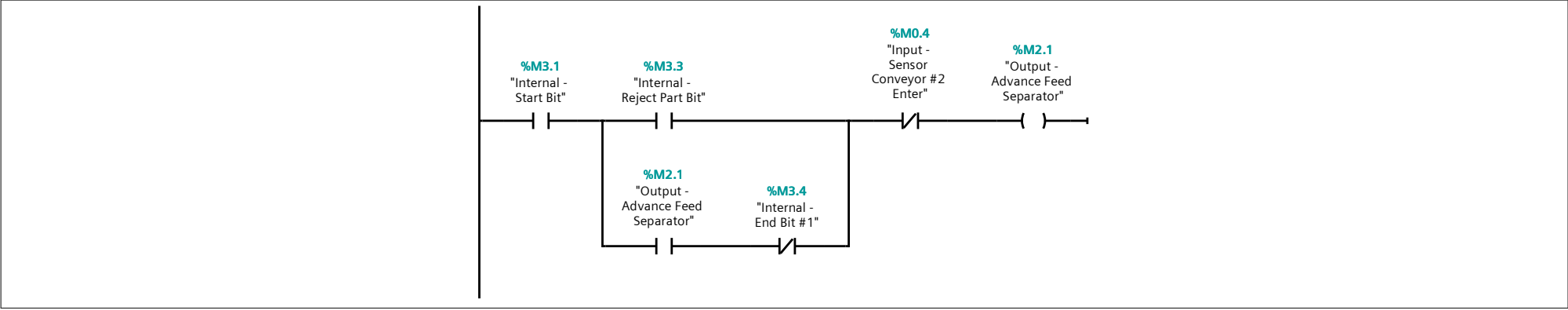
## Network 8: Activate Stopper

Activate Stopper for either conditions (Reject/Good Parts)



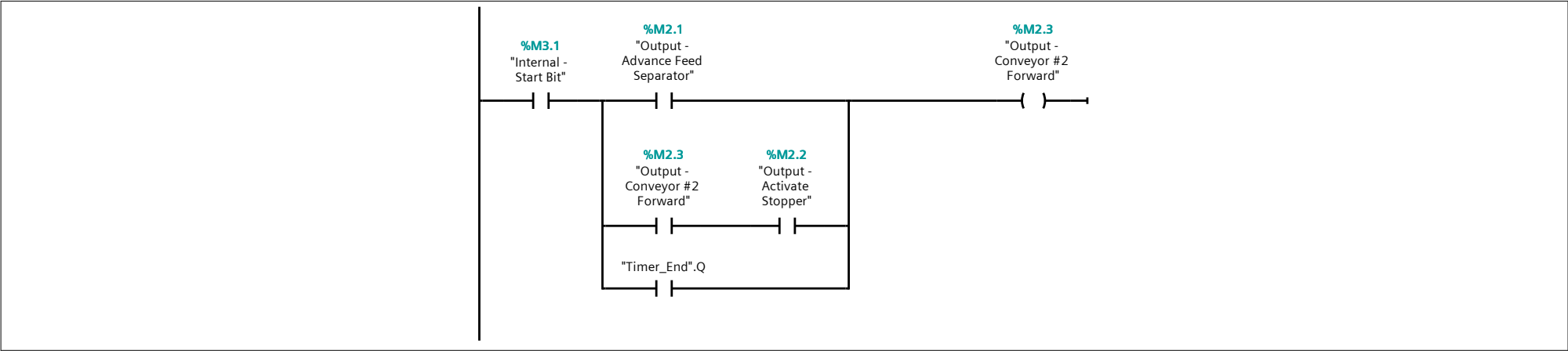
## Network 9: Advance Feed Separator

Only Advance Feed Separator if it is a Reject Parts



## Network 10: Conveyor #2 Belt Motor

Conveyor #2 Forward Direction



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Output\_Mapping [OB124]

Output\_Mapping Properties

General

Name	Output_Mapping	Number	124	Type	OB	Language	LAD
Numbering	Automatic						

Information

Title	"Main Program Sweep (Cycle)"	Author		Comment	Output_Mapping_Routine	Family	
Version	0.1	User-defined ID					

Name	Data type	Default value	Comment
▼ Input			
Initial_Call	Bool		Initial call of this OB
Remanence	Bool		=True, if remanent data are available
Temp			
Constant			

Network 1: Conveyor #1 Forward

%M2.0

"Output - Conveyor #1 Forward"

%Q0.0

"Conveyor #1 Forward"

Network 2: Advance Feed Separator

%M2.1

"Output - Advance Feed Separator"

%Q0.1

"Advance Feed Separator"

Network 3: Activate Stopper

%M2.2

"Output - Activate Stopper"

%Q0.2

"Activate Stopper"

Network 4:

%M2.3

"Output - Conveyor #2 Forward"

%Q0.3

"Conveyor #2 Forward"

Network 5: Panel Start Indicator

%M2.4

"Output - Start Indicator"

%Q0.4

"Panel Start Indicator"

Network 6: Panel Reset Indicator

%M2.5

"Output - Reset Indicator"

%Q0.5

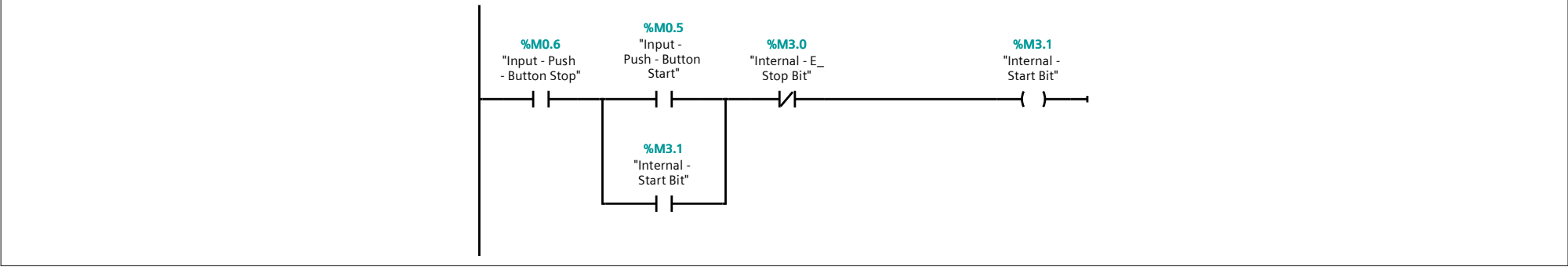
"Panel Reset Indicator"

Start\_Mode [OB125]

Start_Mode Properties							
General							
Name	Start_Mode	Number	125	Type	OB	Language	LAD
Numbering	Automatic						
Information							
Title	"Main Program Sweep (Cycle)"	Author		Comment	Start Mode Routine	Family	
Version	0.1	User-defined ID					

Name	Data type	Default value	Comment
▼ Input			
Initial_Call	Bool		Initial call of this OB
Remanence	Bool		=True, if remanent data are available
Temp			
Constant			

Network 1: Start/Stop Circuit



Network 2: Stop button Pressed during operation



Network 3: Reset latching bit

Key must be in Manual mode, Reset is pressed to reset the bit

