Misc_Cyl_Assembly_rev3 / PLC_1 [CPU 1215C DC/DC/DC] / Program blocks

Primary_Operation [FB2]

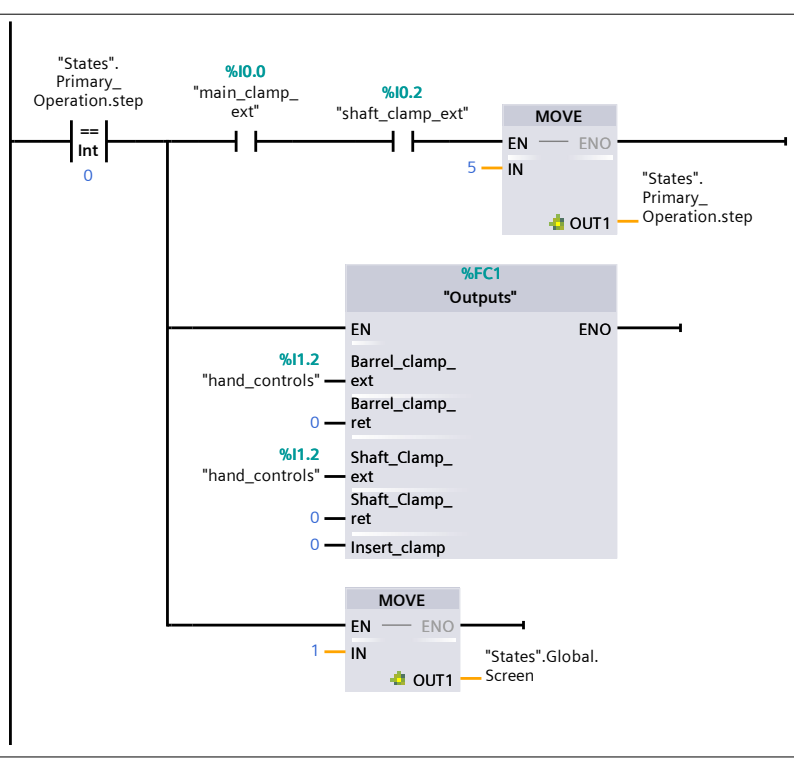
Primary_Operation Properties							
General							
Name	Primary_Operation	**Number**	2	**Type**	FB	**Language**	LAD
Numbering	Automatic						
Information							
Title		**Author**		**Comment**		**Family**	
Version	0.1	**User-defined ID**					

Primary_Operation

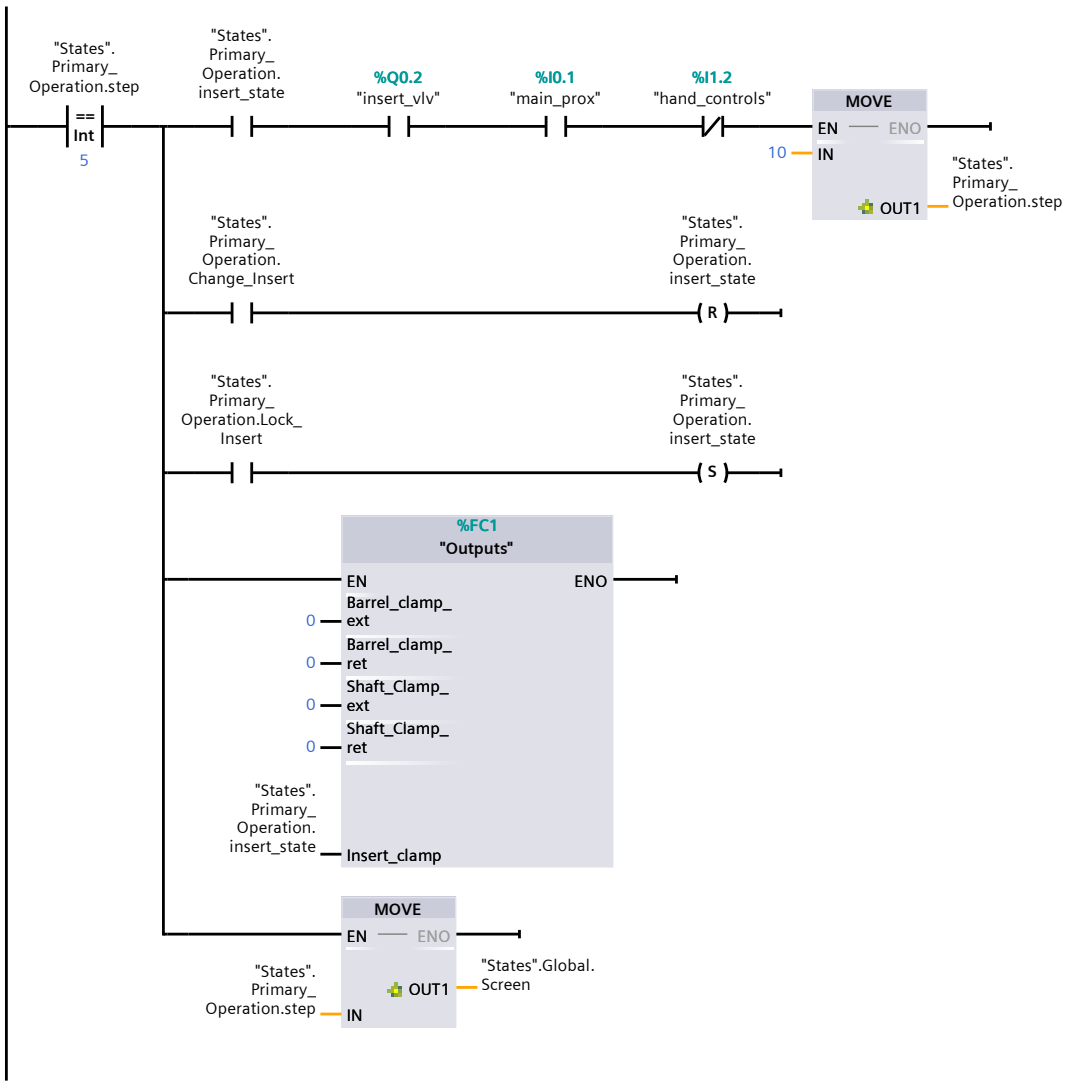
Name	Data type	Default value	Retain	Accessible from HMI/OPC UA/Web API	Writable from HMI/OPC UA/Web API	Visible in HMI engineering	Setpoint	Supervision	Comment
Input									
Output									
InOut									
▼ Static									
▼ Timers	Struct		Non-retain	True	True	True	False		
▼ Main_timeout	IEC_TIMER		Non-retain	True	True	True	False		
PT	Time	T#0ms	Non-retain	True	True	True	False		
ET	Time	T#0ms	Non-retain	True	False	True	False		
IN	Bool	false	Non-retain	True	True	True	False		
Q	Bool	false	Non-retain	True	False	True	False		
▼ Barrel_ID	IEC_TIMER		Non-retain	True	True	True	True		
PT	Time	T#0ms	Non-retain	True	True	True	False		
ET	Time	T#0ms	Non-retain	True	False	True	False		
IN	Bool	false	Non-retain	True	True	True	False		
Q	Bool	false	Non-retain	True	False	True	False		
▼ Shaft_ID	IEC_TIMER		Non-retain	True	True	True	True		
PT	Time	T#0ms	Non-retain	True	True	True	False		
ET	Time	T#0ms	Non-retain	True	False	True	False		
IN	Bool	false	Non-retain	True	True	True	False		
Q	Bool	false	Non-retain	True	False	True	False		
▼ Shaft_timeout	IEC_TIMER		Non-retain	True	True	True	True		
PT	Time	T#0ms	Non-retain	True	True	True	False		
ET	Time	T#0ms	Non-retain	True	False	True	False		
IN	Bool	false	Non-retain	True	True	True	False		
Q	Bool	false	Non-retain	True	False	True	False		
▼ Temp									
clamp_state	Bool								
Constant									

Network 1: 000: Home Cylinders

Home Cylinders



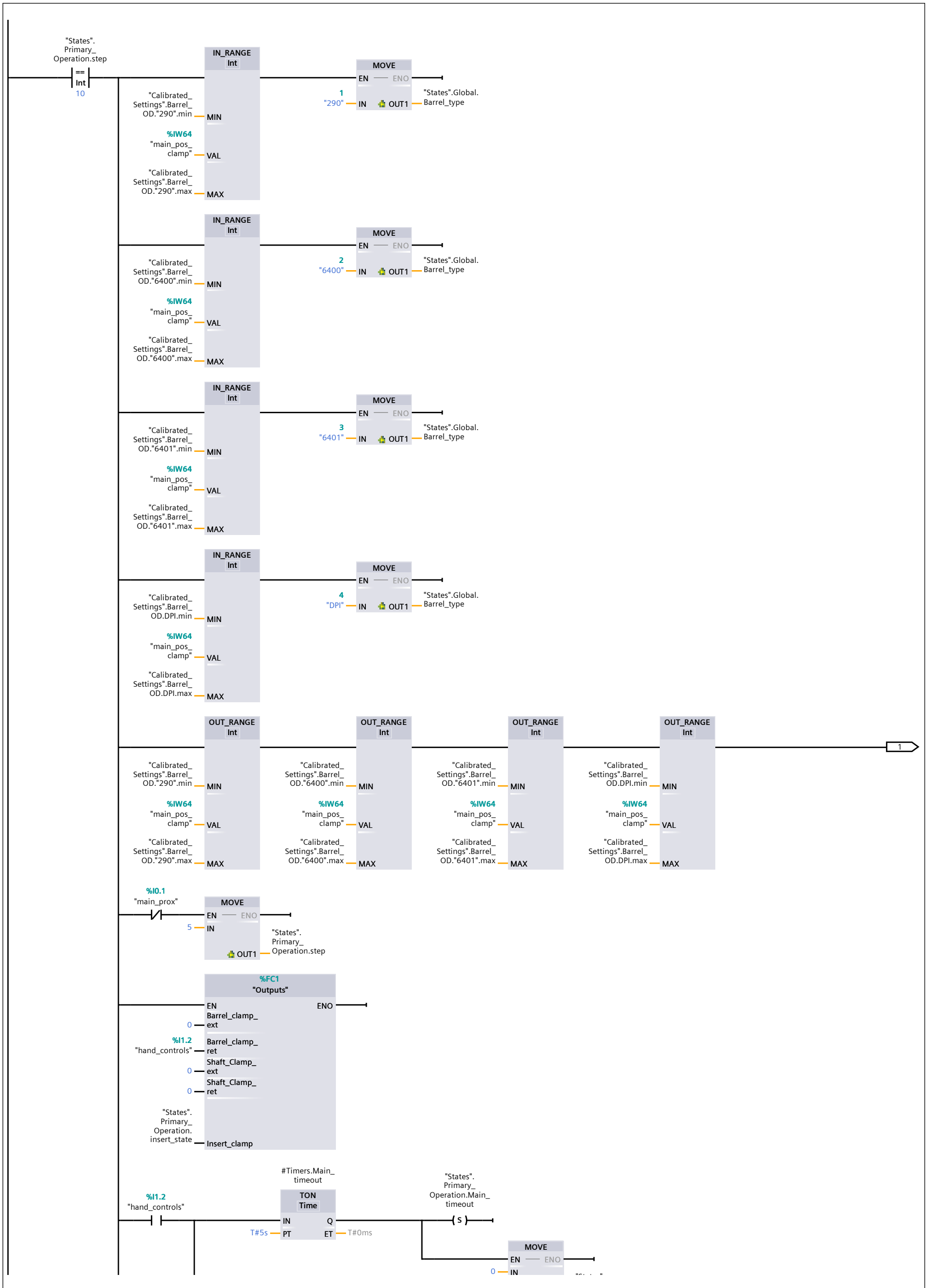
Network 2: 005: Load Main



Network 3: 010: Clamp Main and Barrel OD

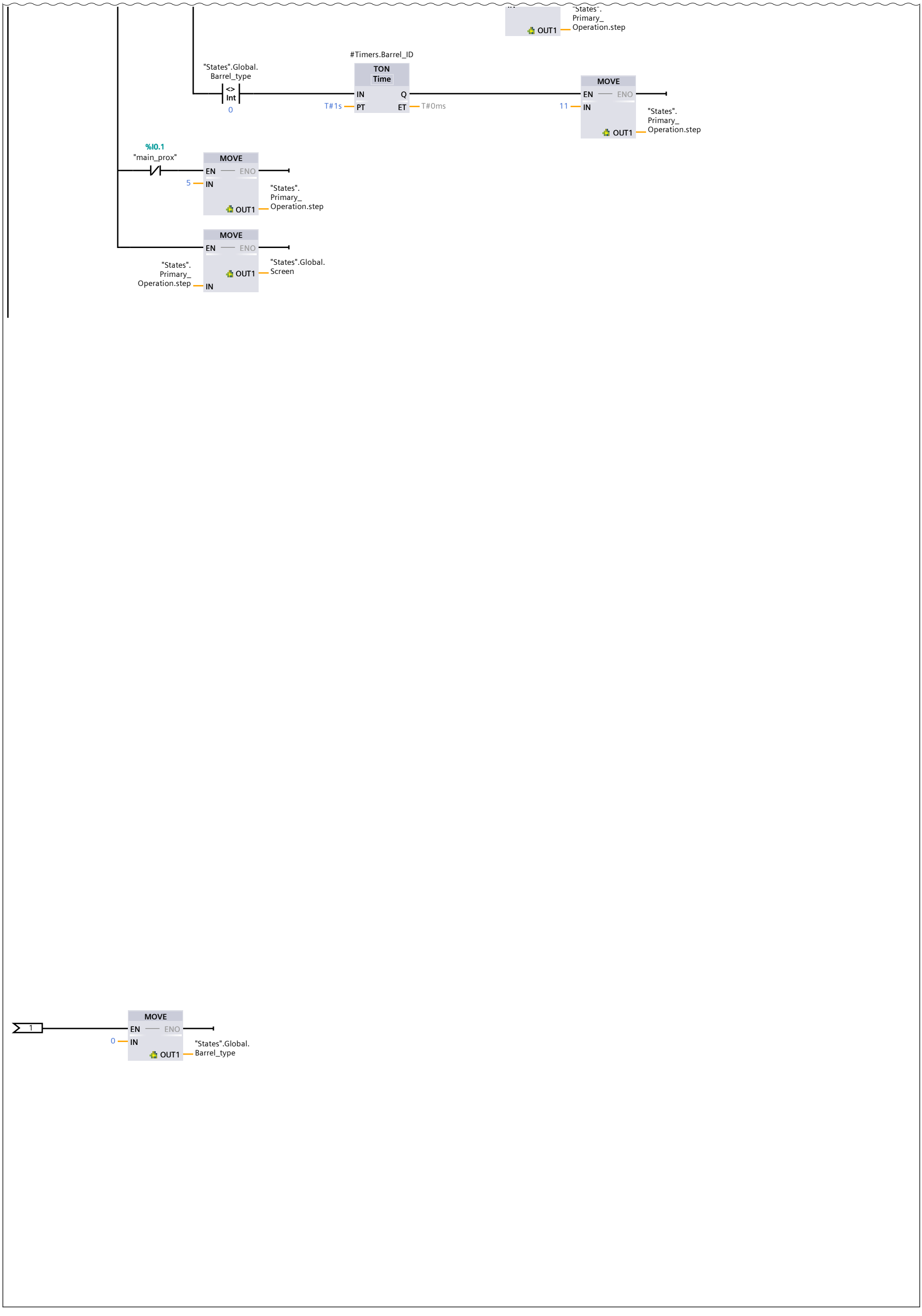
set barrel modle by measuring position of closed clamp

Network 3: 010: Clamp Main and Barrel OD (1.1 / 2.1)

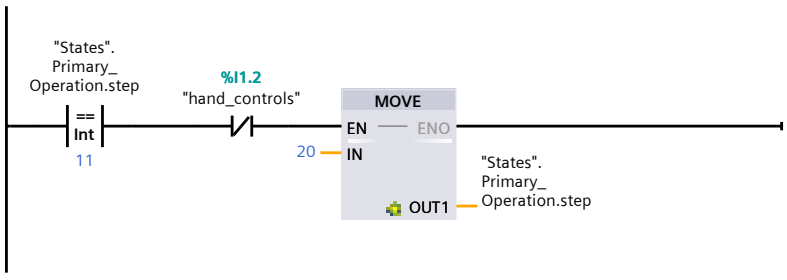


Network 3: 010: Clamp Main and Barrel OD (2.1 / 2.1)

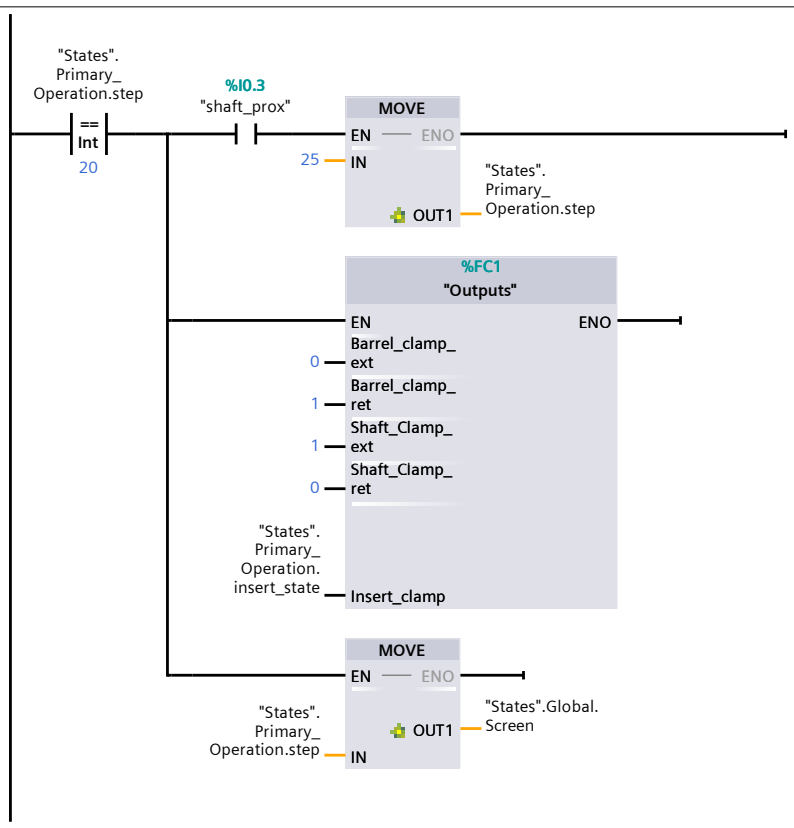
1.1 (Page1 - 3)



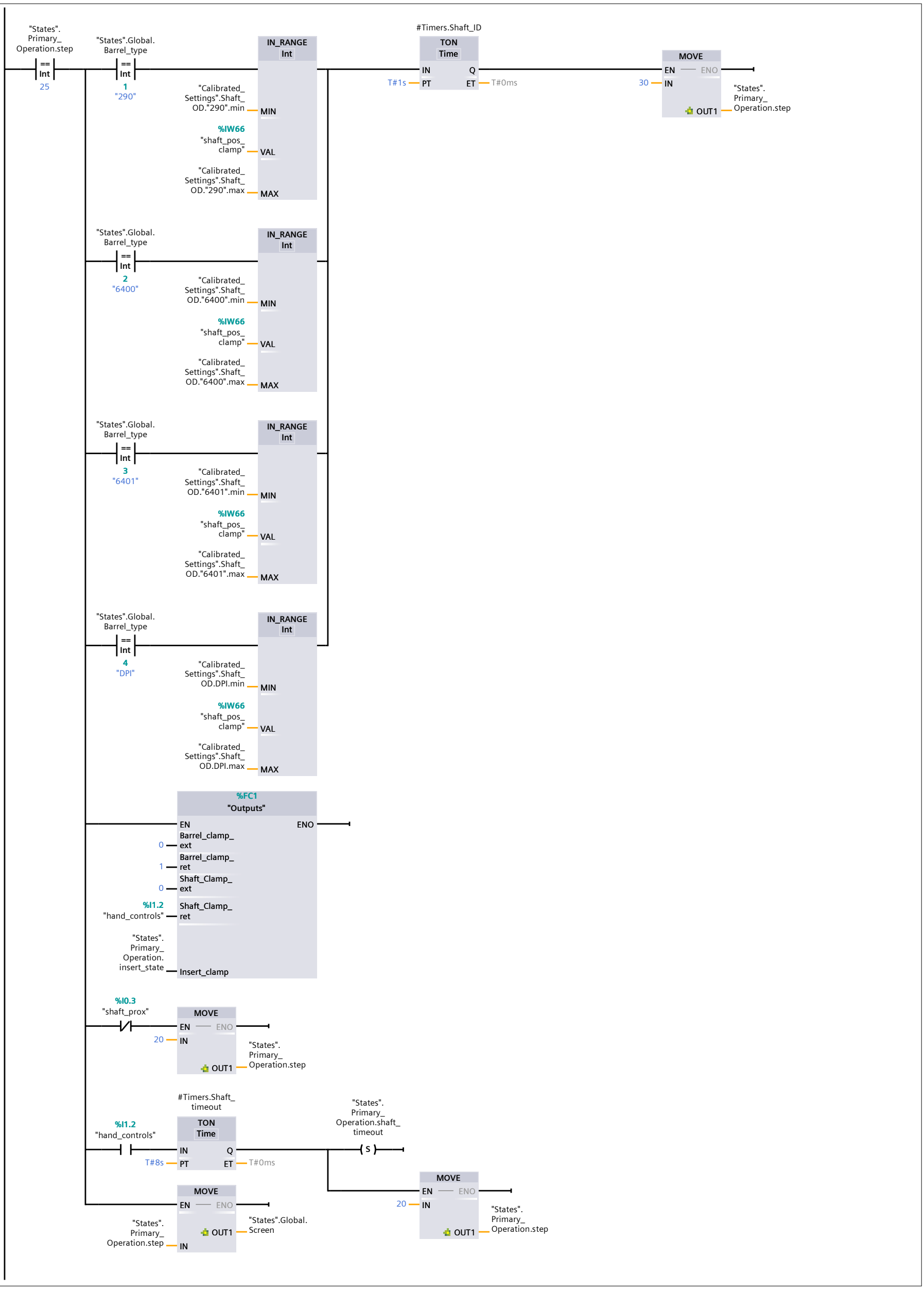
Network 4: 011: release hand controls



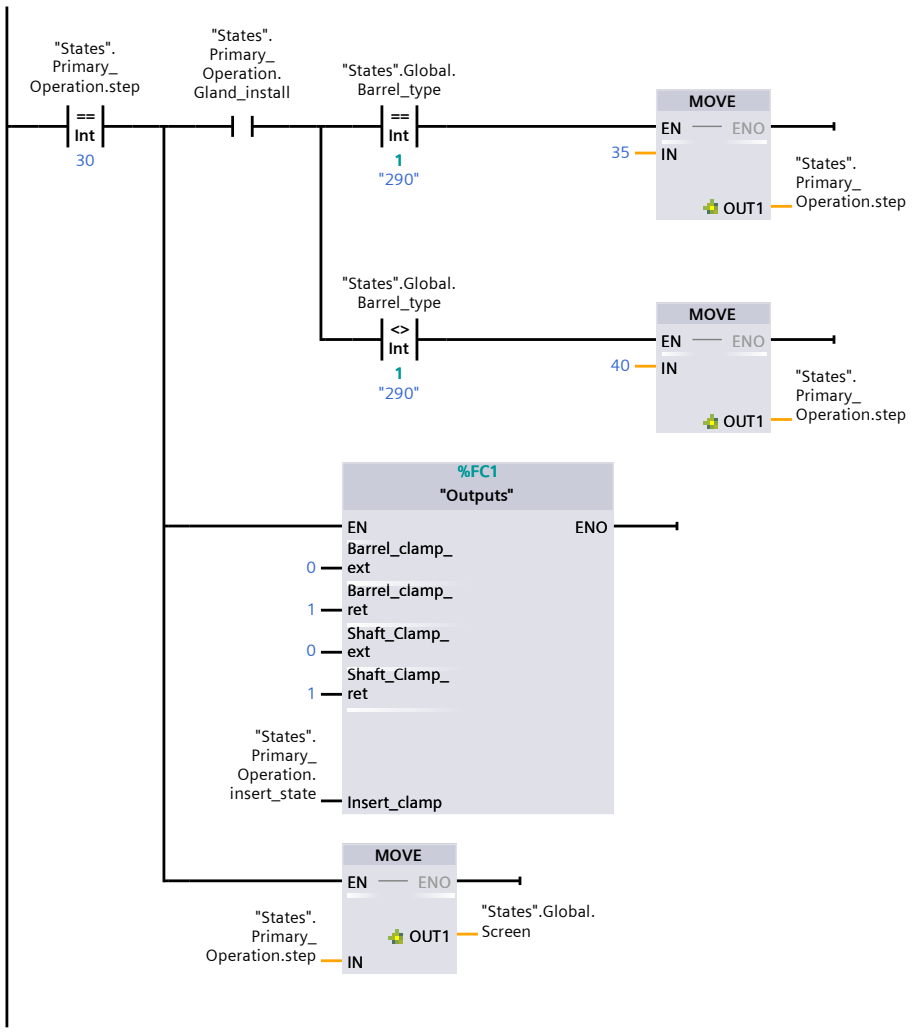
Network 5: 020: load shaft



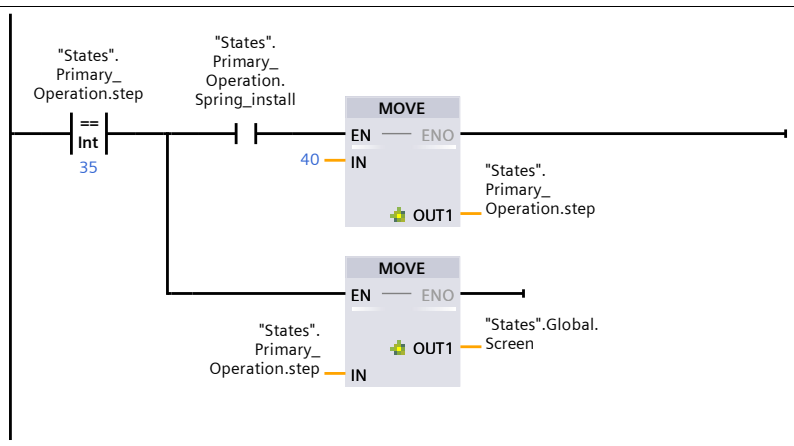
Network 6: 025: clamp shaft



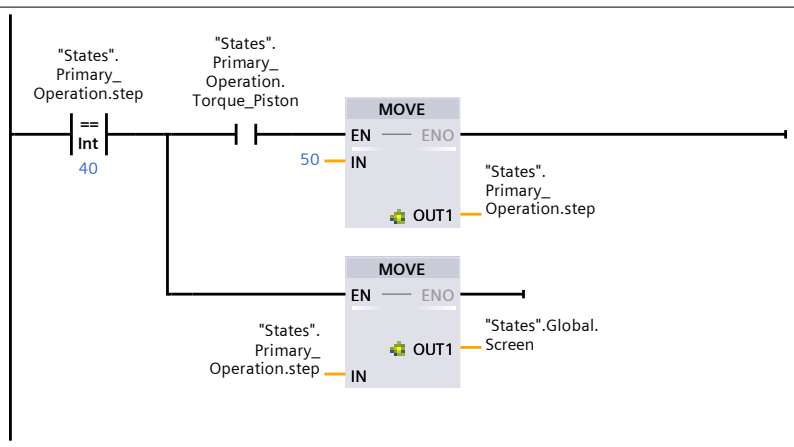
Network 7: 030: Install gland assembly



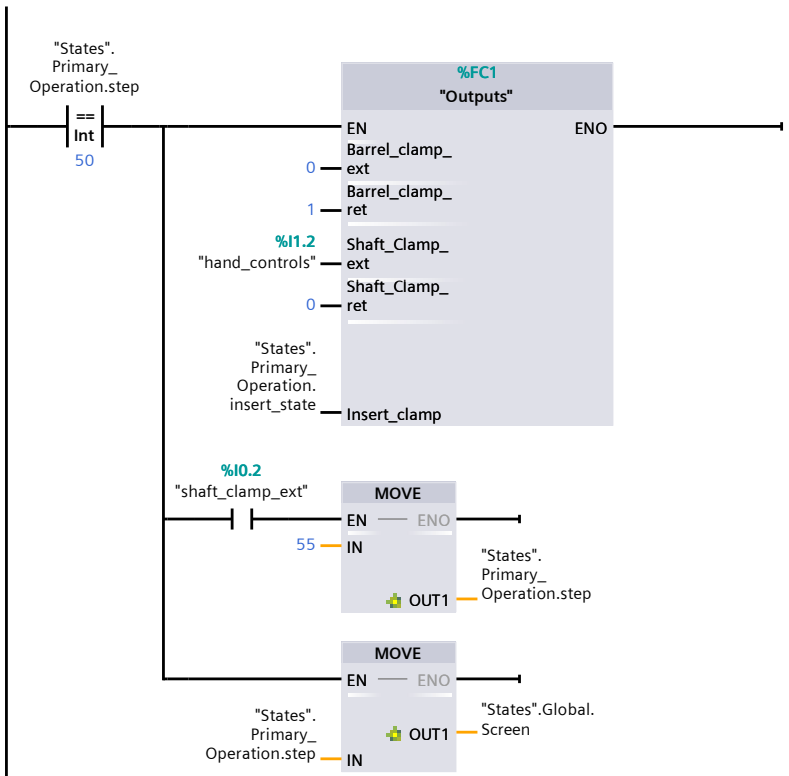
Network 8: 035: spring install (290 ONLY)



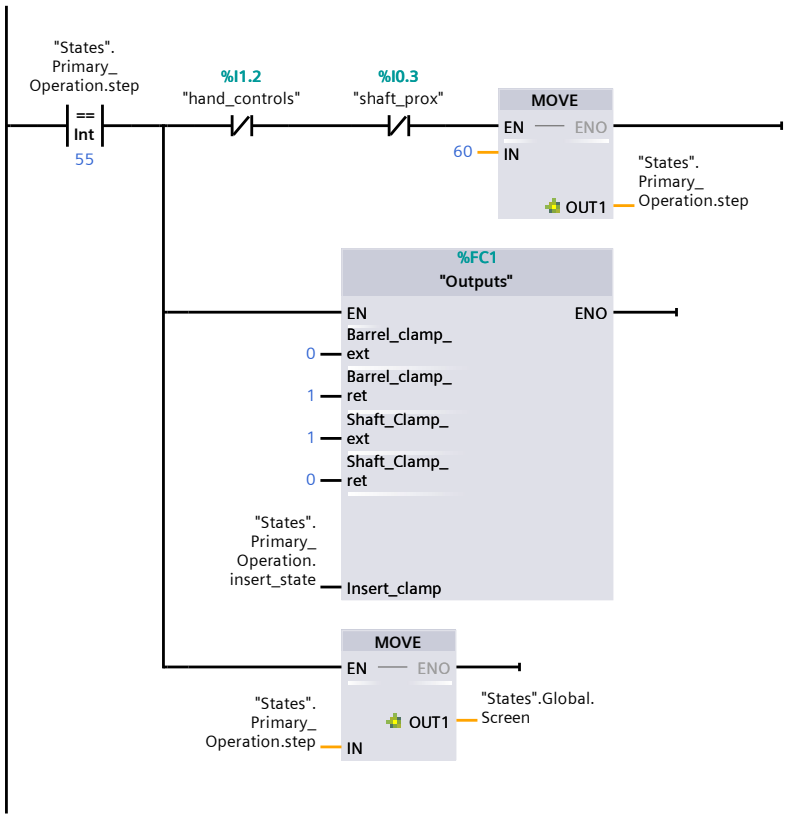
Network 9: 040: Piston Install



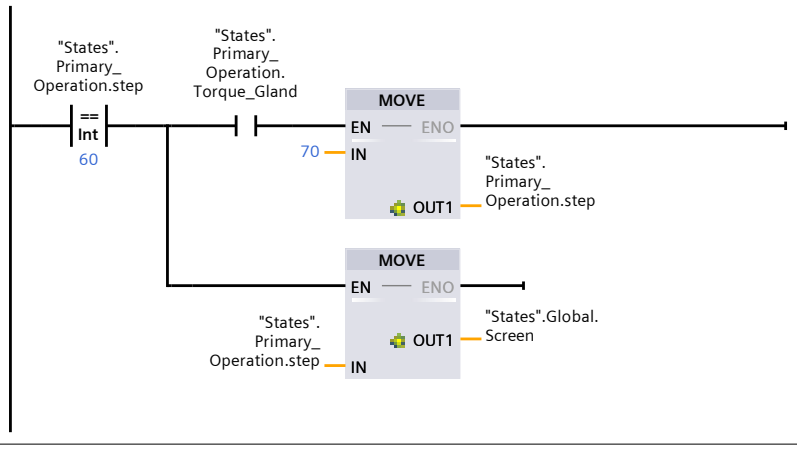
Network 10: 050: Unlock shaft



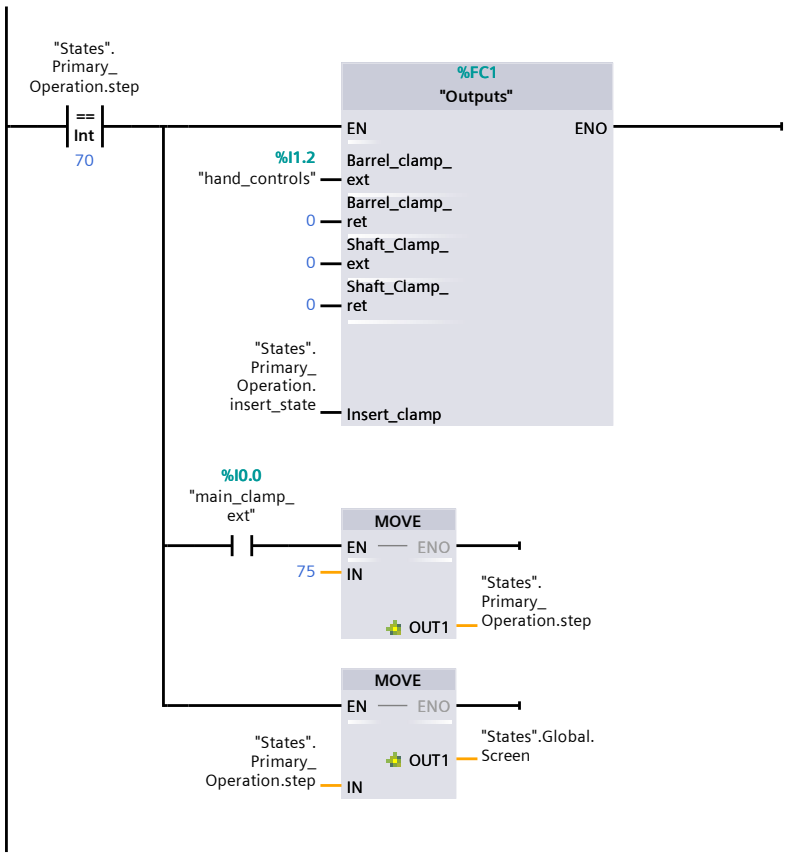
Network 11: 055: remove shaft



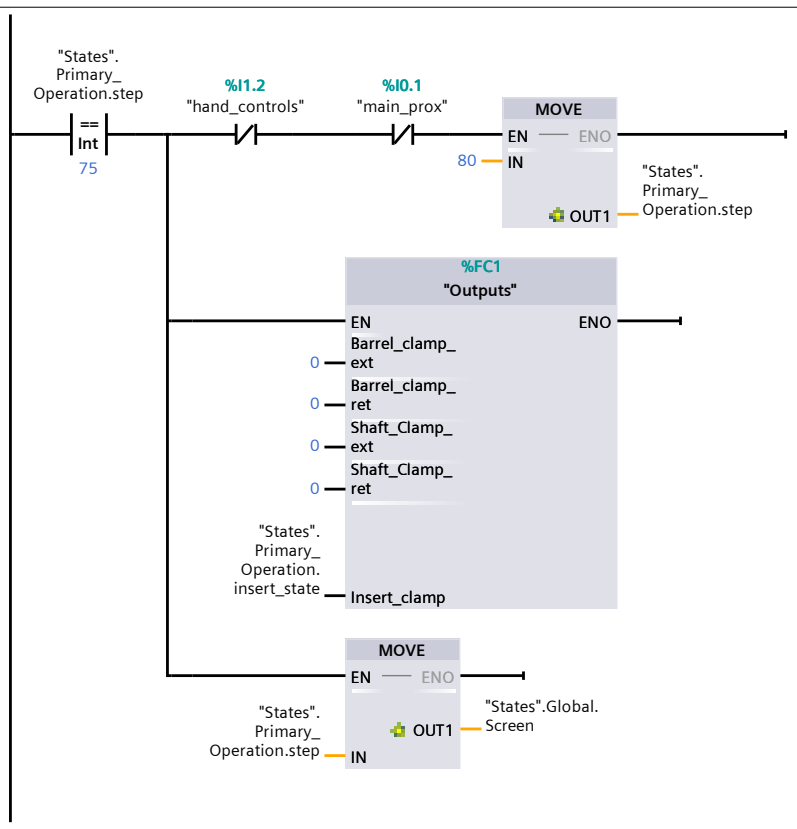
Network 12: 060: install and torque piston-shaft assembly into barrel



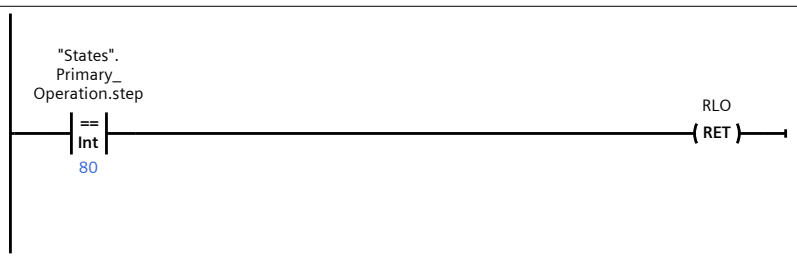
Network 13: 070: unlock main



Network 14: 075: remove assembly



Network 15: 080: END



Network 16: