

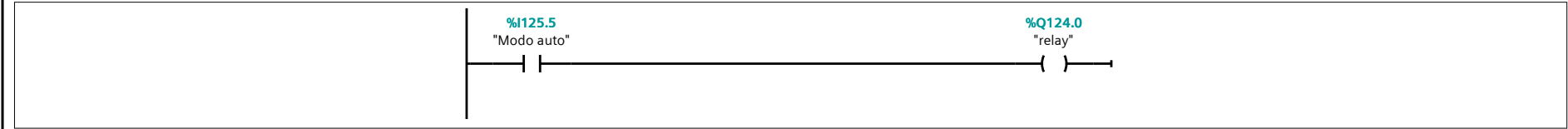
Selecao\_peca\_V131907 / PLC\_1 [CPU 314C-2 PN/DP] / Program blocks

Seleção de Peças 2 [OB1]

Seleção de Peças 2 Properties							
General							
Name	Seleção de Peças 2	Number	1	Type	OB	Language	LAD
Numbering	manual						
Information							
Title	"Main Program Sweep (Cycle)"	Author		Comment		Family	
Version	0.1	User-defined ID					

Seleção de Peças 2				
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				

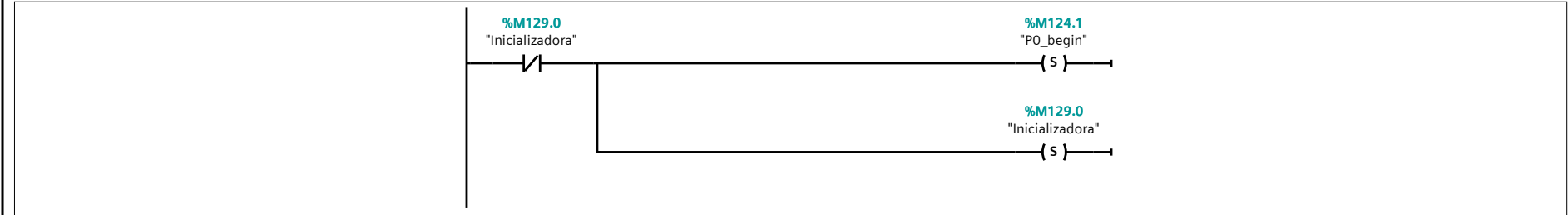
Network 1: Segurança



Symbol	Address	Type	Comment
"Modo auto"	%I125.5	Bool	
"relay"	%Q124.0	Bool	

Network 2: Inicializar

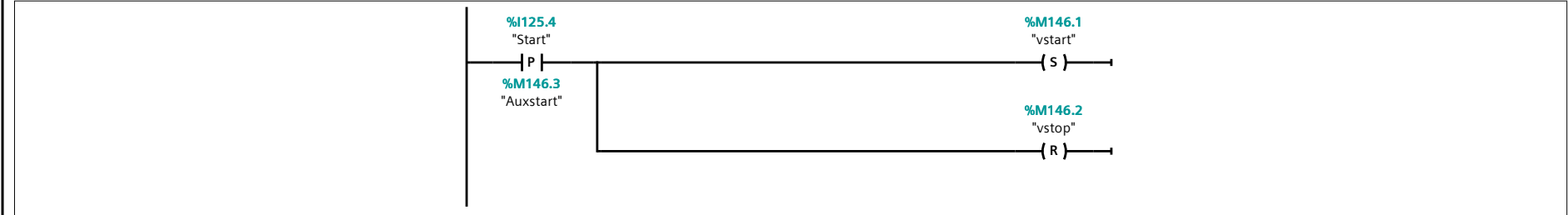
Distribui Ficha inicial em P0\_begin



Symbol	Address	Type	Comment
"Inicializadora"	%M129.0	Bool	
"P0_begin"	%M124.1	Bool	LUGAR

Network 3: Iniciar Start

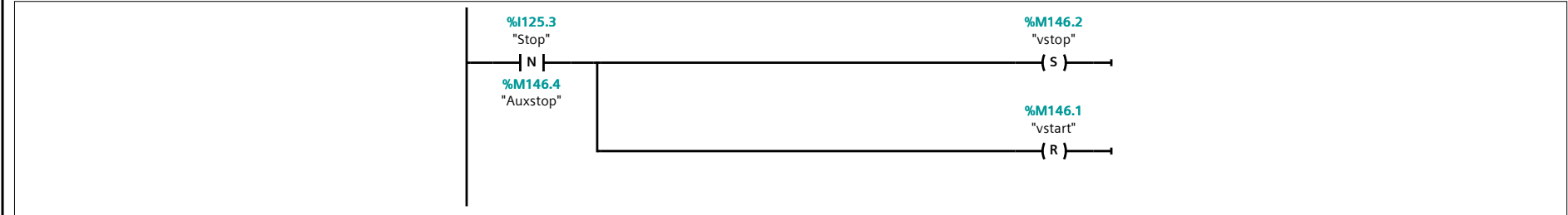
Rever



Symbol	Address	Type	Comment
"Auxstart"	%M146.3	Bool	
"Start"	%I125.4	Bool	
"vstart"	%M146.1	Bool	VARIAVEIS
"vstop"	%M146.2	Bool	

Network 4: Inicializar Stop

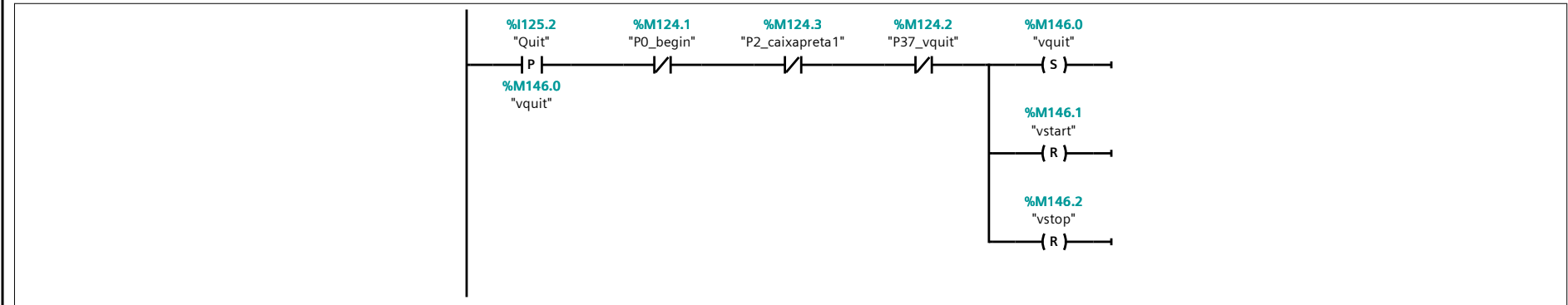
Rever



Symbol	Address	Type	Comment
"Auxstop"	%M146.4	Bool	
"Stop"	%I125.3	Bool	
"vstart"	%M146.1	Bool	VARIAVEIS
"vstop"	%M146.2	Bool	

Network 5: Iniciliazar Quit

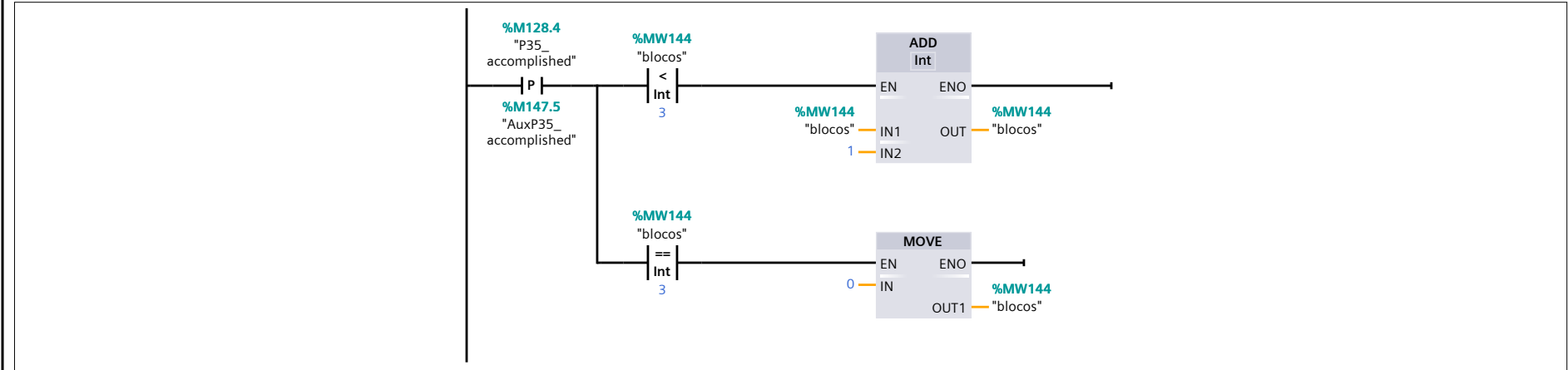
Rever



Symbol	Address	Type	Comment
"PO_begin"	%M124.1	Bool	LUGAR
"P2_caixapreta1"	%M124.3	Bool	LUGAR
"P37_vquit"	%M124.2	Bool	LUGAR
"Quit"	%I125.2	Bool	
"vquit"	%M146.0	Bool	VARIAVEIS
"vstart"	%M146.1	Bool	VARIAVEIS
"vstop"	%M146.2	Bool	

Network 6: mudar contador de blocos (teste de desenvolvedor)

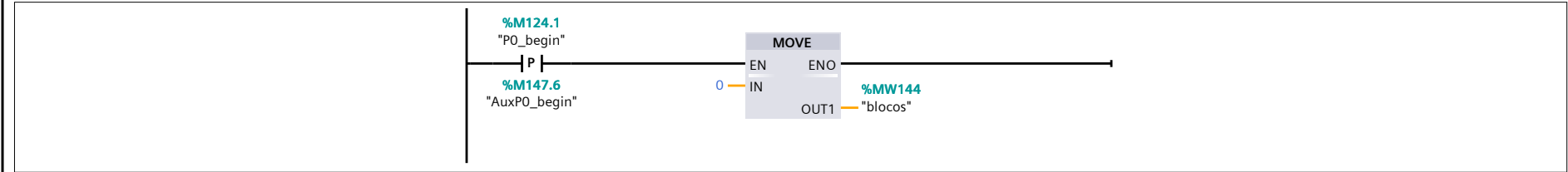
Conta de 0 a 2 quando aperta o botao branco



Symbol	Address	Type	Comment
"AuxP35_accomplished"	%M147.5	Bool	
"blocos"	%MW144	Int	VARIAVEIS
"P35_accomplished"	%M128.4	Bool	LUGAR

Network 7: Resetablocos

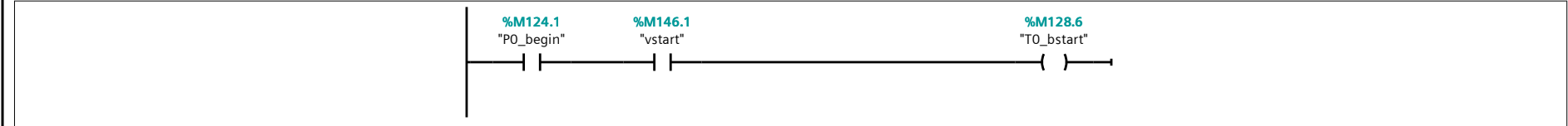
Pode dar problema!!!



Symbol	Address	Type	Comment
"AuxPO_begin"	%M147.6	Bool	
"blocos"	%MW144	Int	VARIAVEIS
"PO_begin"	%M124.1	Bool	LUGAR

Network 8: Lugares (Condicao de disparo)

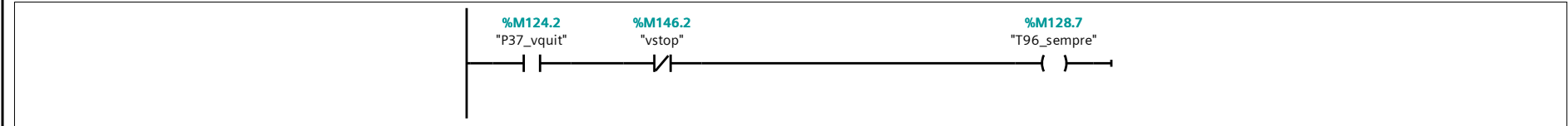
t0



Symbol	Address	Type	Comment
"PO_begin"	%M124.1	Bool	LUGAR
"T0_bstart"	%M128.6	Bool	TRANSICAO
"vstart"	%M146.1	Bool	VARIAVEIS

Network 9: TRANSICAO

t96



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Symbol	Address	Type	Comment
"P37_vquit"	%M124.2	Bool	LUGAR
"T96_sempre"	%M128.7	Bool	TRANSICAO
"vstop"	%M146.2	Bool	

Network 10: TRANSICAO

t3

%M124.3  
"P2\_caixapreta1"

%I1.1  
"Smag2F"

%I0.6  
"Smag1F"

%M146.2  
"vstop"

%M129.5  
"T3"

Symbol	Address	Type	Comment
"P2_caixapreta1"	%M124.3	Bool	LUGAR
"Smag1F"	%I0.6	Bool	
"Smag2F"	%I1.1	Bool	
"T3"	%M129.5	Bool	TRANSICAO
"vstop"	%M146.2	Bool	

Network 11: TRANSICAO

t8

%M124.5  
"P4\_caixapreta2"

%M146.2  
"vstop"

%M130.2  
"T8"

Symbol	Address	Type	Comment
"P4_caixapreta2"	%M124.5	Bool	LUGAR
"T8"	%M130.2	Bool	TRANSICAO
"vstop"	%M146.2	Bool	

Network 12: t94 - cuidado tempo

t94 - cuidado tempo

%M124.7  
"P6\_esteiraesq-  
Esteira2^~  
Esteira1v"

%M146.2  
"vstop"

%DB1  
"IEC\_Timer\_0\_DB"

TON  
Time

IN

Q

ET ...

12000  
"esteiraesquerda"

PT

%M129.2  
"T94\_  
tempoesteira"

Symbol	Address	Type	Comment
"esteiraesquerda"	12000	Time	
"P6_esteiraesq-Esteira2^~Esteira1v"	%M124.7	Bool	LUGAR
"T94_tempoesteira"	%M129.2	Bool	TRANSICAO
"vstop"	%M146.2	Bool	

Network 13: TRANSICAO

t20

%M125.1  
"P8\_  
esteiraparada"

%M146.0  
"vquit"

%M146.2  
"vstop"

%M129.1  
"T20\_notvquit"

Symbol	Address	Type	Comment
"P8_esteiraparada"	%M125.1	Bool	LUGAR
"T20_notvquit"	%M129.1	Bool	TRANSICAO
"vquit"	%M146.0	Bool	VARIAVEIS
"vstop"	%M146.2	Bool	

Network 14: TRANSICAO

t21 - Precisa do Fim de Curso de um dos dois Metal ou plast

%M155.3  
"P10\_feijoadada"

%MW144  
"blocos"

==  
Int  
2

%MW144  
"blocos"

<  
Int  
2

%I1.2  
"FCMag2"

%M146.2  
"vstop"

%M131.7  
"T21"

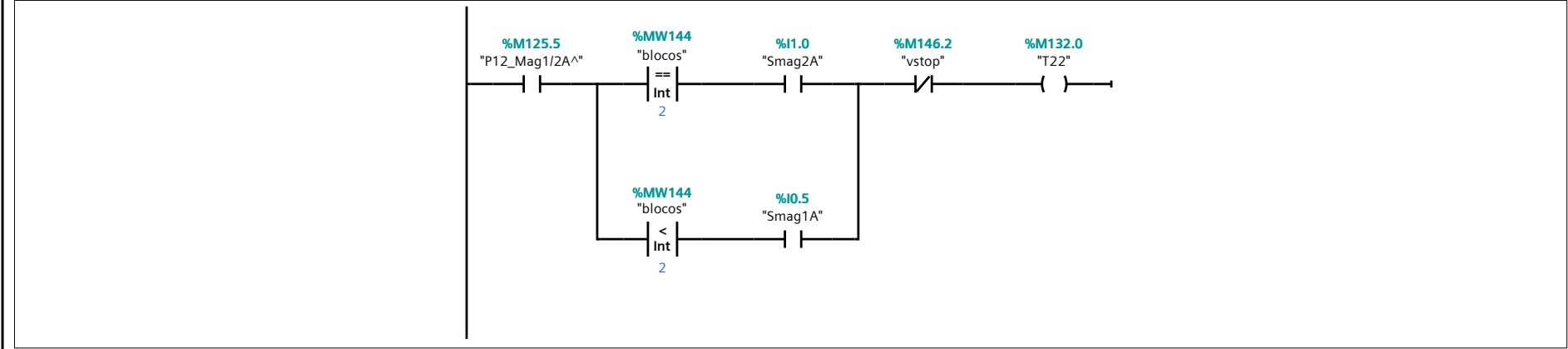
%I0.7  
"FCMag1"

Symbol	Address	Type	Comment
"blocos"	%MW144	Int	VARIAVEIS
"FCMag1"	%I0.7	Bool	
"FCMag2"	%I1.2	Bool	

Symbol	Address	Type	Comment
"P10_feijoadada"	%M155.3	Bool	LUGAR
"T21"	%M131.7	Bool	TRANSICAO
"vstop"	%M146.2	Bool	

Network 15: TRANSICAO

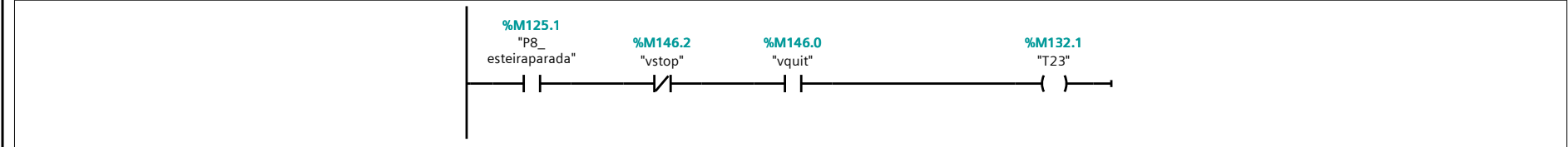
t22



Symbol	Address	Type	Comment
"blocos"	%MW144	Int	VARIAVEIS
"P12_Mag1/2A^"	%M125.5	Bool	LUGAR
"Smag1A"	%I0.5	Bool	
"Smag2A"	%I1.0	Bool	
"T22"	%M132.0	Bool	TRANSICAO
"vstop"	%M146.2	Bool	

Network 16: TRANSICAO

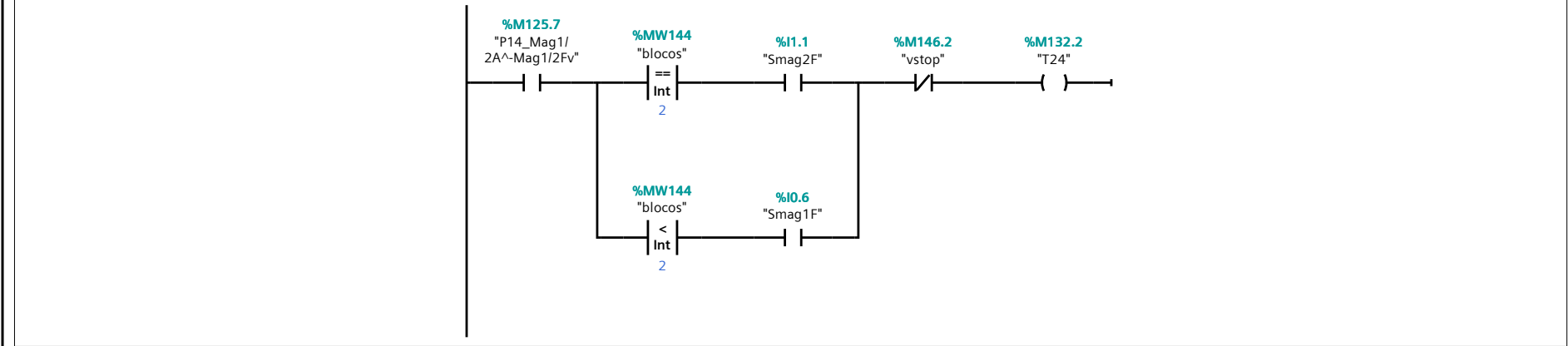
t23



Symbol	Address	Type	Comment
"P8_esteiraparada"	%M125.1	Bool	LUGAR
"T23"	%M132.1	Bool	TRANSICAO
"vquit"	%M146.0	Bool	VARIAVEIS
"vstop"	%M146.2	Bool	

Network 17: TRANSICAO

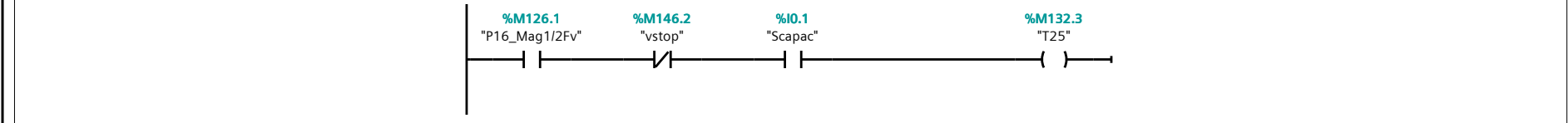
t24



Symbol	Address	Type	Comment
"blocos"	%MW144	Int	VARIAVEIS
"P14_Mag1/2A^Mag1/2Fv"	%M125.7	Bool	LUGAR
"Smag1F"	%I0.6	Bool	
"Smag2F"	%I1.1	Bool	
"T24"	%M132.2	Bool	TRANSICAO
"vstop"	%M146.2	Bool	

Network 18: TRANSICAO

t25



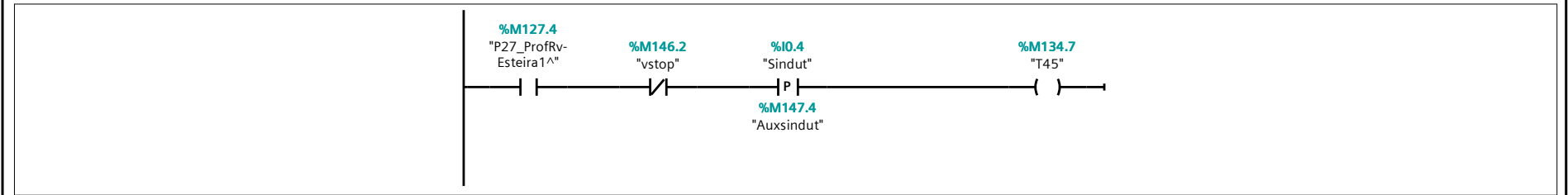
Symbol	Address	Type	Comment
"P16_Mag1/2Fv"	%M126.1	Bool	LUGAR
"Scapac"	%I0.1	Bool	
"T25"	%M132.3	Bool	TRANSICAO
"vstop"	%M146.2	Bool	

Network 19: t26 - cuidado tempo

t26 - cuidado tempo



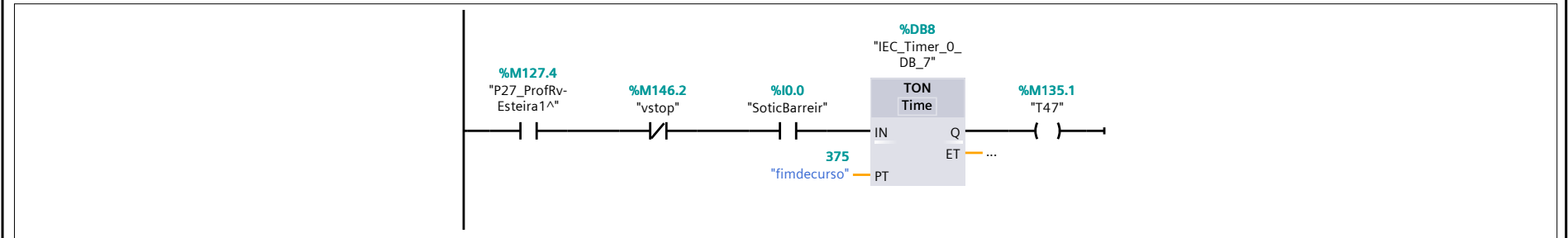




Symbol	Address	Type	Comment
"Auxsindut"	%M147.4	Bool	
"P27_ProfRv-Esteira1^"	%M127.4	Bool	LUGAR
"Sindut"	%I0.4	Bool	
"T45"	%M134.7	Bool	TRANSICAO
"vstop"	%M146.2	Bool	

Network 30: t47 - rever tempo

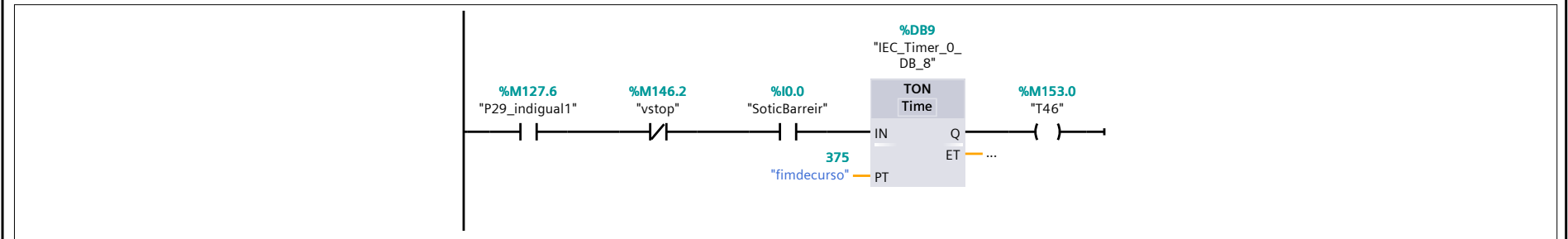
t47 - rever tempo



Symbol	Address	Type	Comment
"fimdecurso"	375	Time	
"P27_ProfRv-Esteira1^"	%M127.4	Bool	LUGAR
"SoticBarreir"	%I0.0	Bool	
"T47"	%M135.1	Bool	TRANSICAO
"vstop"	%M146.2	Bool	

Network 31: t46 - rever tempo

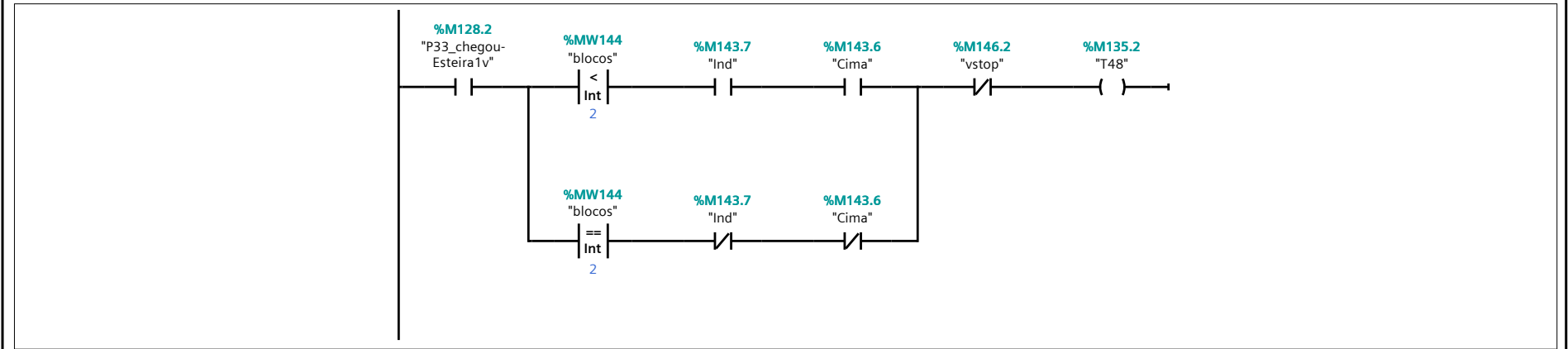
t46 - rever tempo



Symbol	Address	Type	Comment
"fimdecurso"	375	Time	
"P29_indigual1"	%M127.6	Bool	LUGAR
"SoticBarreir"	%I0.0	Bool	
"T46"	%M153.0	Bool	TRANSICAO
"vstop"	%M146.2	Bool	

Network 32: TRANSICAO

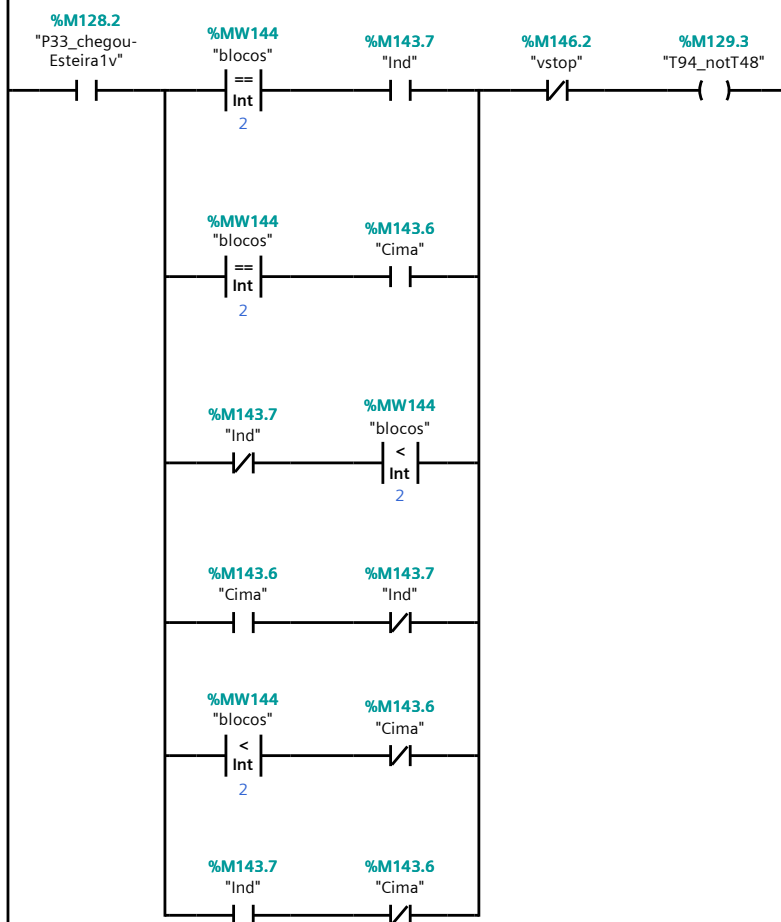
t48



Symbol	Address	Type	Comment
"blocos"	%MW144	Int	VARIAVEIS
"Cima"	%M143.6	Bool	VARIAVEIS
"Ind"	%M143.7	Bool	VARIAVEIS
"P33_chegou-Esteira1v"	%M128.2	Bool	LUGAR
"T48"	%M135.2	Bool	TRANSICAO
"vstop"	%M146.2	Bool	

Network 33: TRANSICAO

t94\_not48 - REVER!!!!



Symbol	Address	Type	Comment
"blocos"	%MW144	Int	VARIABLES
"Cima"	%M143.6	Bool	VARIABLES
"Ind"	%M143.7	Bool	VARIABLES
"P33_chegou-Esteira1v"	%M128.2	Bool	LUGAR
"T94_notT48"	%M129.3	Bool	TRANSICAO
"vstop"	%M146.2	Bool	

## Network 34: TRANSICAO

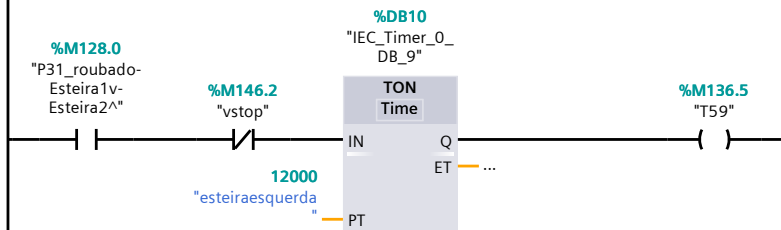
t60 - rever trailing edge



Symbol	Address	Type	Comment
"Auxlaser"	%M147.2	Bool	
"P35_accomplished"	%M128.4	Bool	LUGAR
"SoticBarreir"	%I0.0	Bool	
"T60"	%M136.6	Bool	TRANSICAO
"vstop"	%M146.2	Bool	

## Network 35: t59 - rever tempo

t59 - rever tempo



Symbol	Address	Type	Comment
"esteiraesquerda"	12000	Time	
"P31_roubado-Esteira1v-Esteira2^"	%M128.0	Bool	LUGAR
"T59"	%M136.5	Bool	TRANSICAO
"vstop"	%M146.2	Bool	

## Network 36: t58 - rever tempo

t58 - rever tempo







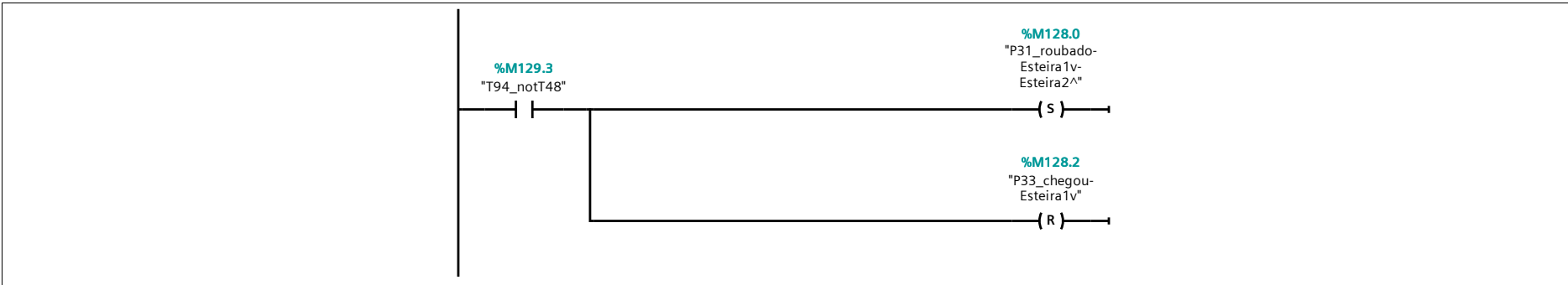






## Network 61: LUGAR

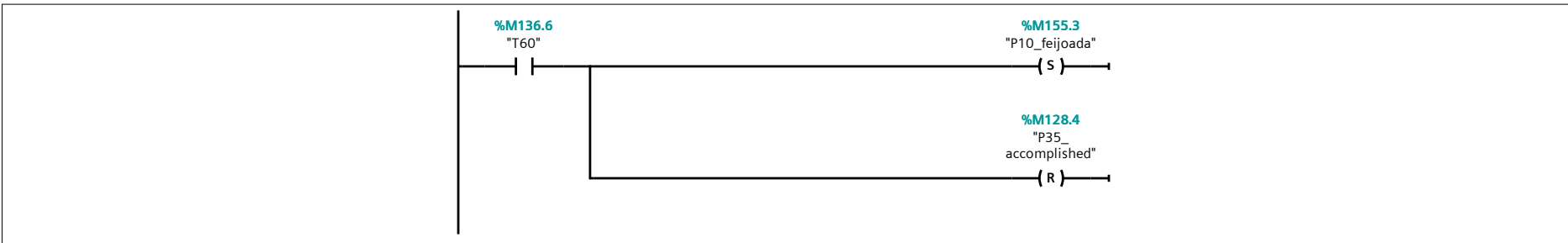
t94\_notT48



Symbol	Address	Type	Comment
"P31_roubado-Esteira1v-Esteira2^"	%M128.0	Bool	LUGAR
"P33_chegou-Esteira1v"	%M128.2	Bool	LUGAR
"T94_notT48"	%M129.3	Bool	TRANSICAO

## Network 62: LUGAR

t60



Symbol	Address	Type	Comment
"P10_feijoada"	%M155.3	Bool	LUGAR
"P35_accomplished"	%M128.4	Bool	LUGAR
"T60"	%M136.6	Bool	TRANSICAO

## Network 63: QUIT

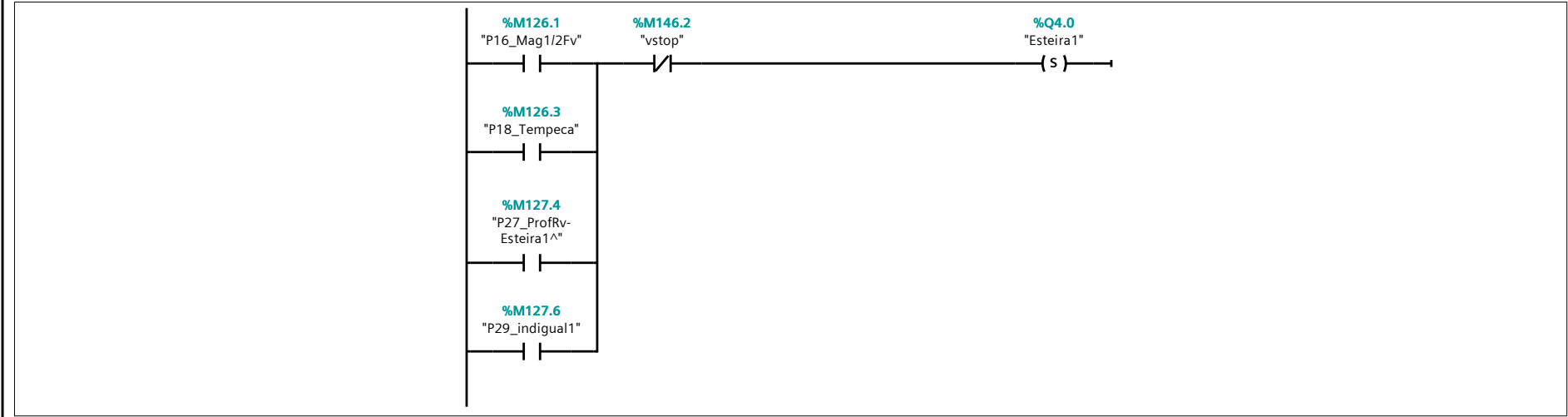
QUIT - PODE DAR PROBLEMA!!!



Symbol	Address	Type	Comment
"P25_estendido-ProfEv-ProfR^"	%M127.2	Bool	LUGAR
"P27_ProfRv-Esteira1^"	%M127.4	Bool	LUGAR
"P29_indigual1"	%M127.6	Bool	LUGAR
"P31_roubado-Esteira1v-Esteira2^"	%M128.0	Bool	LUGAR
"P33_chegou-Esteira1v"	%M128.2	Bool	LUGAR
"P35_accomplished"	%M128.4	Bool	LUGAR
"P37_vquit"	%M124.2	Bool	LUGAR
"vquit"	%M146.0	Bool	VARIAVEIS

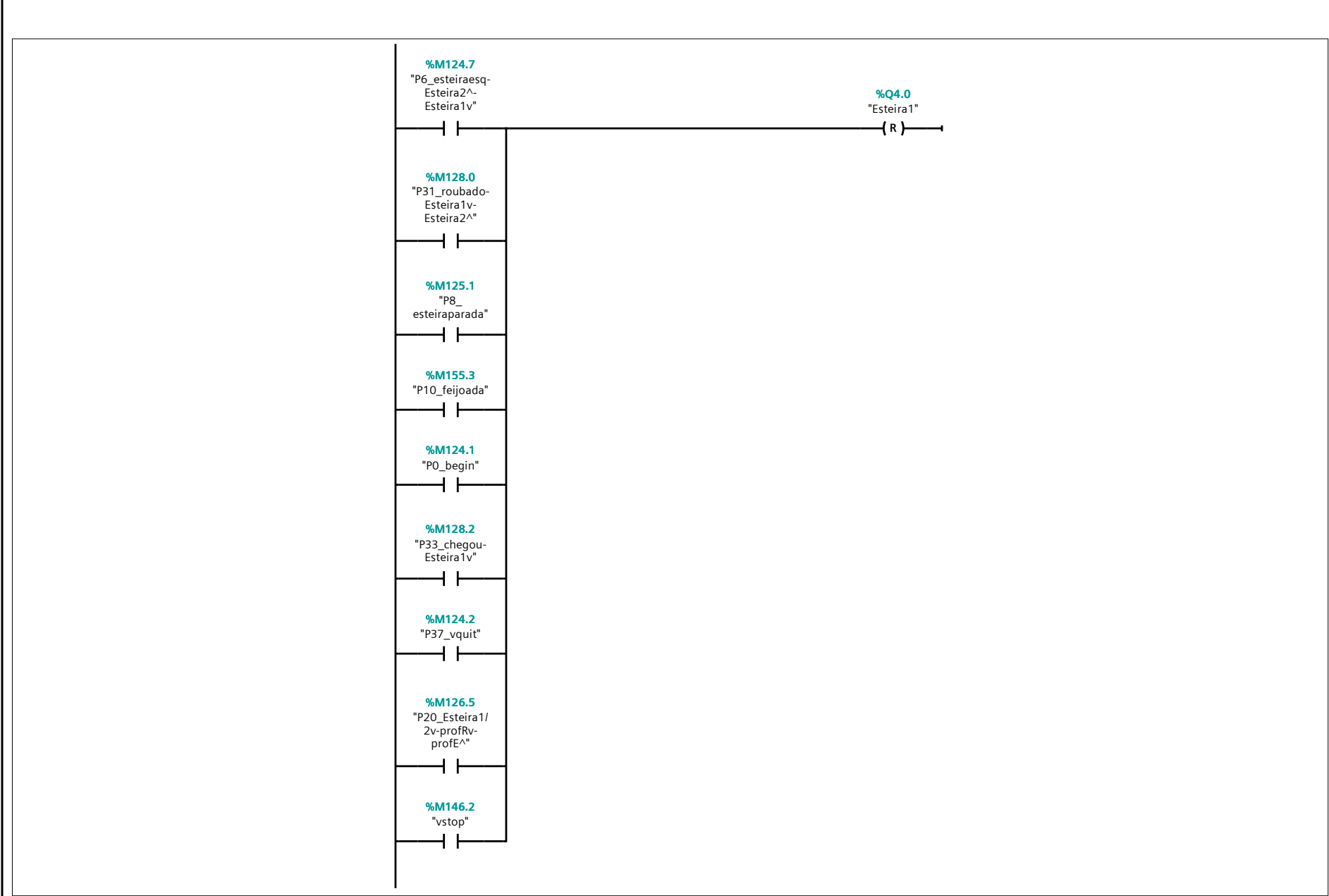
Network 64: Ações (Onde cada coisa acontece) Esteira1

Esteira1



Symbol	Address	Type	Comment
"Esteira1"	%Q4.0	Bool	SAÍDA
"P16_Mag1/2Fv"	%M126.1	Bool	LUGAR
"P18_Tempeca"	%M126.3	Bool	LUGAR
"P27_ProfRv-Esteira1^"	%M127.4	Bool	LUGAR
"P29_indigual1"	%M127.6	Bool	LUGAR
"vstop"	%M146.2	Bool	

Network 65: SAÍDA



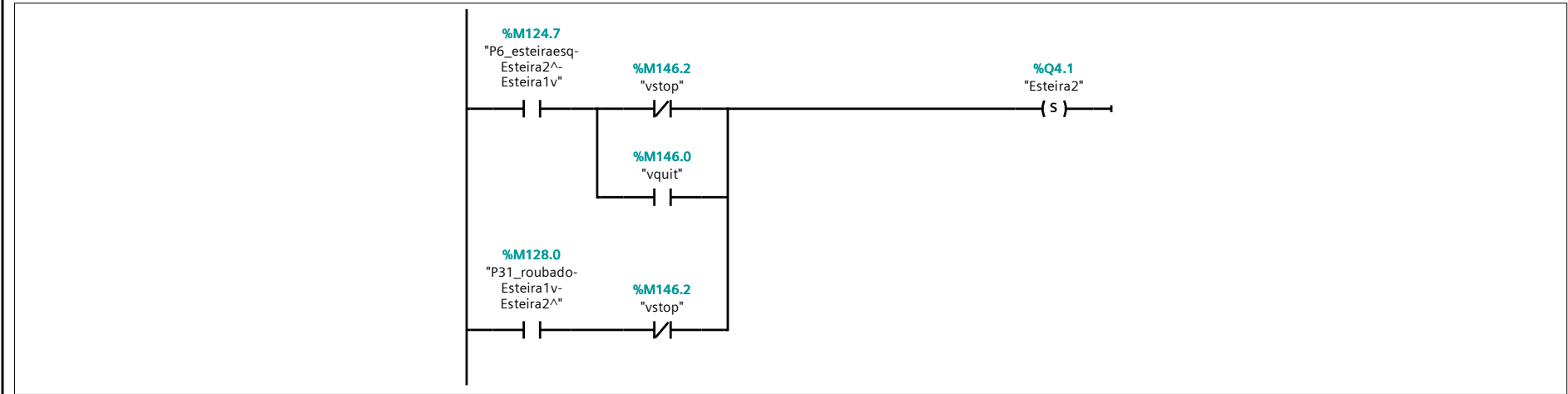
Symbol	Address	Type	Comment
"Esteira1"	%Q4.0	Bool	SAÍDA
"P0_begin"	%M124.1	Bool	LUGAR
"P6_esteiraesq-Esteira2^-Esteira1v"	%M124.7	Bool	LUGAR
"P8_esteiraparada"	%M125.1	Bool	LUGAR
"P10_feijoadada"	%M155.3	Bool	LUGAR
"P20_Esteira1/2v-profRv-profE^"	%M126.5	Bool	LUGAR
"P31_roubado-Esteira1v-Esteira2^"	%M128.0	Bool	LUGAR
"P33_chegou-Esteira1v"	%M128.2	Bool	LUGAR
"P37_vquit"	%M124.2	Bool	LUGAR



Symbol	Address	Type	Comment
"vstop"	%M146.2	Bool	

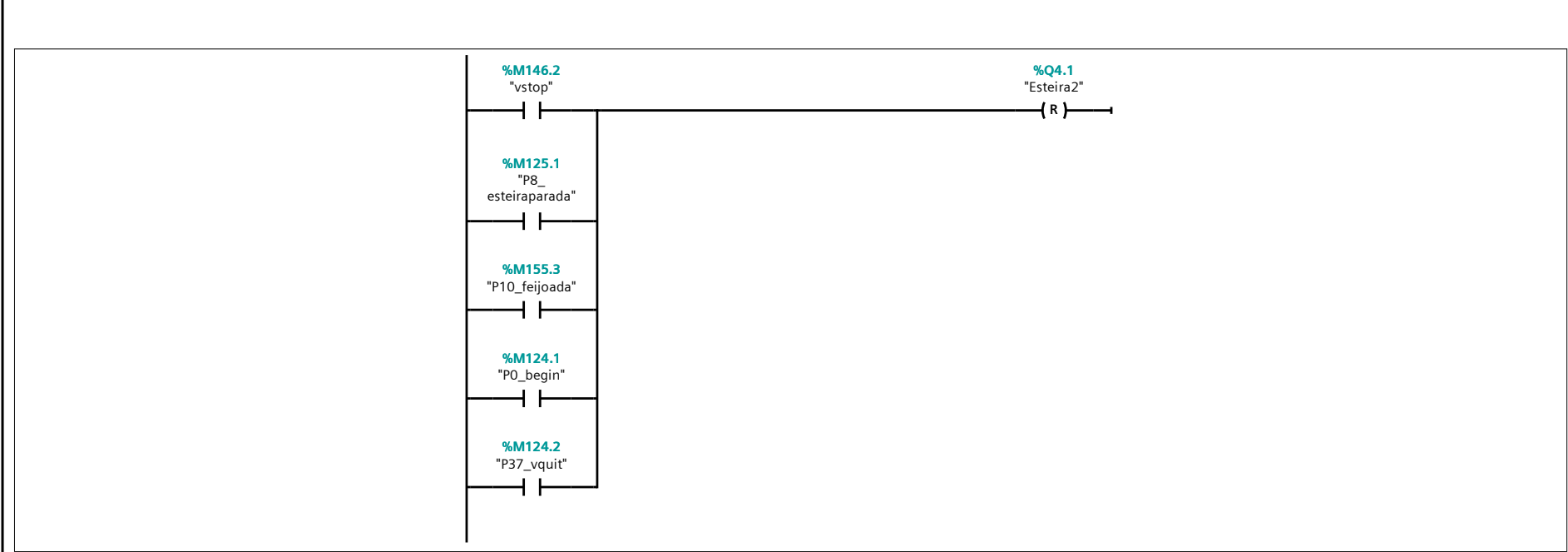
Network 66: Ações (Onde cada coisa acontece) Esteira2

Esteira2



Symbol	Address	Type	Comment
"Esteira2"	%Q4.1	Bool	SAÍDA
"P6_esteiraesq-Esteira2^-Es-teira1v"	%M124.7	Bool	LUGAR
"P31_roubado-Esteira1v-Esteira2^"	%M128.0	Bool	LUGAR
"vquit"	%M146.0	Bool	VARIAVEIS
"vstop"	%M146.2	Bool	

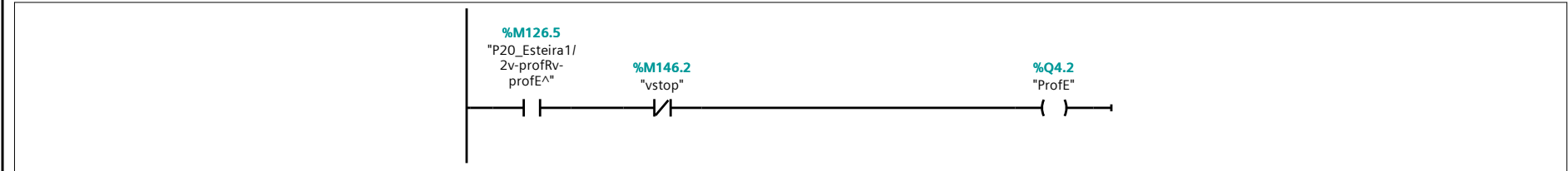
Network 67: SAÍDA



Symbol	Address	Type	Comment
"Esteira2"	%Q4.1	Bool	SAÍDA
"P0_begin"	%M124.1	Bool	LUGAR
"P8_esteiraparada"	%M125.1	Bool	LUGAR
"P10_feijoadada"	%M155.3	Bool	LUGAR
"P37_vquit"	%M124.2	Bool	LUGAR
"vstop"	%M146.2	Bool	

Network 68: Ações (Onde cada coisa acontece) ProfE

ProfE



Symbol	Address	Type	Comment
"P20_Esteira1/2v-profRv-profE^"	%M126.5	Bool	LUGAR
"ProfE"	%Q4.2	Bool	SAÍDA
"vstop"	%M146.2	Bool	

Network 69: SAÍDA

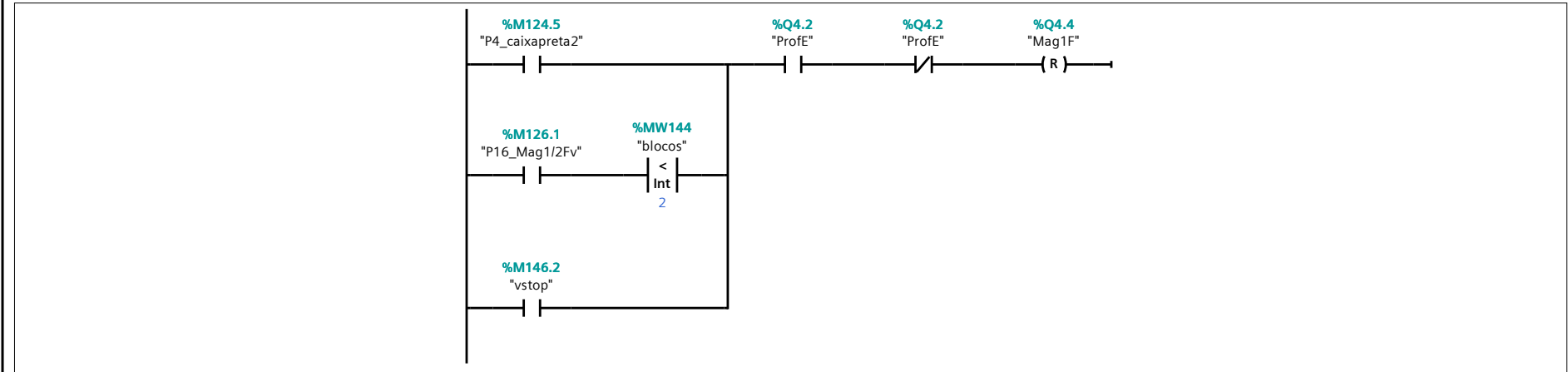
VAl dar merda vai.... vai dar merda vai dar merda... vai dar merda



Symbol	Address	Type	Comment
"P14_Mag1/2A^~Mag1/2Fv"	%M125.7	Bool	LUGAR
"vstop"	%M146.2	Bool	

Network 73: SAÍDA

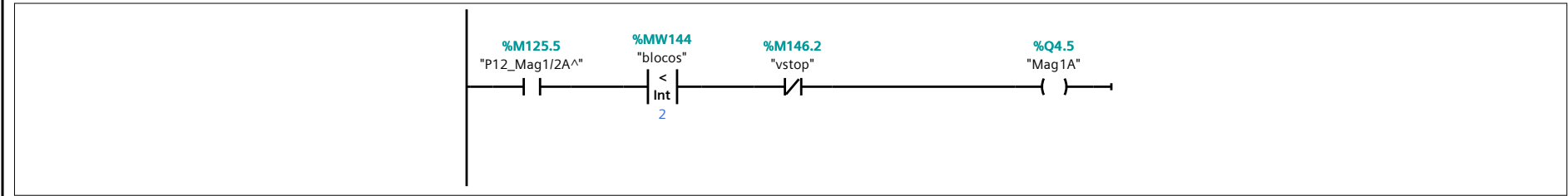
Comentado (Ignorar)



Symbol	Address	Type	Comment
"blocos"	%MW144	Int	VARIAVEIS
"Mag1F"	%Q4.4	Bool	SAÍDA
"P4_caixapreta2"	%M124.5	Bool	LUGAR
"P16_Mag1/2Fv"	%M126.1	Bool	LUGAR
"ProfE"	%Q4.2	Bool	SAÍDA
"vstop"	%M146.2	Bool	

Network 74: Ações (Onde cada coisa acontece)

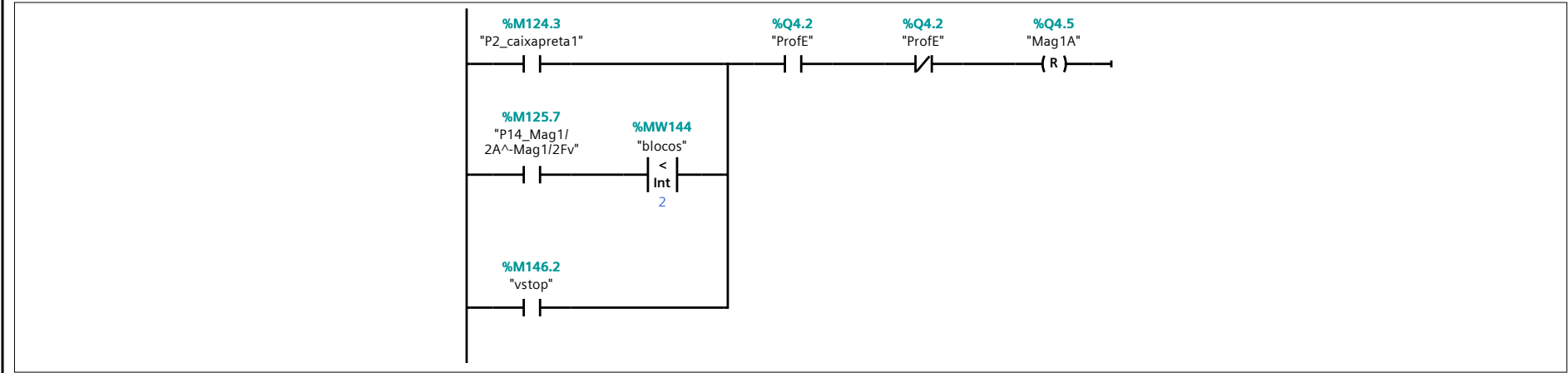
Mag1A



Symbol	Address	Type	Comment
"blocos"	%MW144	Int	VARIAVEIS
"Mag1A"	%Q4.5	Bool	SAÍDA
"P12_Mag1/2A^"	%M125.5	Bool	LUGAR
"vstop"	%M146.2	Bool	

Network 75: SAÍDA

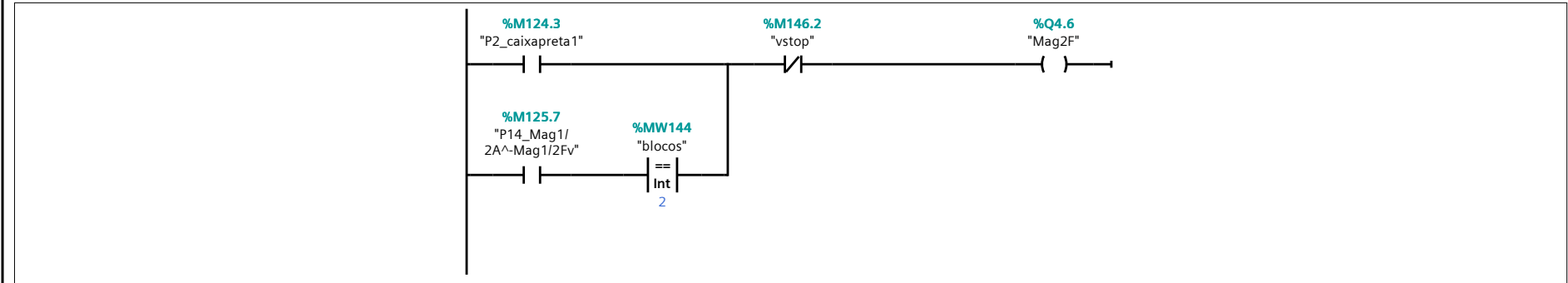
Comentado (Ignorar)



Symbol	Address	Type	Comment
"blocos"	%MW144	Int	VARIAVEIS
"Mag1A"	%Q4.5	Bool	SAÍDA
"P2_caixapreta1"	%M124.3	Bool	LUGAR
"P14_Mag1/2A^~Mag1/2Fv"	%M125.7	Bool	LUGAR
"ProfE"	%Q4.2	Bool	SAÍDA
"vstop"	%M146.2	Bool	

Network 76: Ações (Onde cada coisa acontece)

Mag2F



Symbol	Address	Type	Comment
"blocos"	%MW144	Int	VARIAVEIS
"Mag2F"	%Q4.6	Bool	SAÍDA



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Symbol	Address	Type	Comment
"P0_begin"	%M124.1	Bool	LUGAR
"P21_P20stop"	%M126.6	Bool	LUGAR
"Verde"	%Q124.4	Bool	SAÍDA
"vstop"	%M146.2	Bool	

Network 81: Ações (Onde cada coisa acontece)

Vermelho

%M146.2  
"vstop"

%M124.1  
"P0\_begin"

%Q124.5  
"Vermelho"

Symbol	Address	Type	Comment
"P0_begin"	%M124.1	Bool	LUGAR
"Vermelho"	%Q124.5	Bool	SAÍDA
"vstop"	%M146.2	Bool	

Network 82: Ações (Onde cada coisa acontece)

Azul

%M124.1  
"P0\_begin"

%M124.2  
"P37\_vquit"

%M124.3  
"P2\_caixapreta1"

%Q124.6  
"Azul"

Symbol	Address	Type	Comment
"Azul"	%Q124.6	Bool	SAÍDA
"P0_begin"	%M124.1	Bool	LUGAR
"P2_caixapreta1"	%M124.3	Bool	LUGAR
"P37_vquit"	%M124.2	Bool	LUGAR

Network 83: Ações (Onde cada coisa acontece)

vquit

%M124.1  
"P0\_begin"

%M147.6  
"AuxP0\_begin"

%M146.0  
"vquit"

Symbol	Address	Type	Comment
"AuxP0_begin"	%M147.6	Bool	
"P0_begin"	%M124.1	Bool	LUGAR
"vquit"	%M146.0	Bool	VARIAVEIS

Network 84: Ações (Onde cada coisa acontece)

Cima

%M127.0  
"P23\_Cimaigual1"

%M147.6  
"AuxP0\_begin"

%M143.6  
"Cima"

Symbol	Address	Type	Comment
"AuxP0_begin"	%M147.6	Bool	
"Cima"	%M143.6	Bool	VARIAVEIS
"P23_Cimaigual1"	%M127.0	Bool	LUGAR

Network 85: VARIAVEIS

%M155.3  
"P10\_feijoadada"

%M147.7  
"AuxP10\_feijoadada"

%M124.5  
"P4\_caixapreta2"

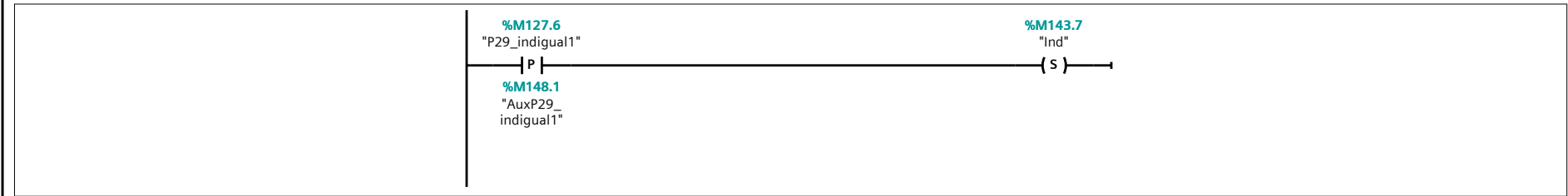
%M148.0  
"AuxP4\_caixapreta2"

%M143.6  
"Cima"

Symbol	Address	Type	Comment
"AuxP4_caixapreta2"	%M148.0	Bool	
"AuxP10_feijoadada"	%M147.7	Bool	
"Cima"	%M143.6	Bool	VARIAVEIS
"P4_caixapreta2"	%M124.5	Bool	LUGAR
"P10_feijoadada"	%M155.3	Bool	LUGAR

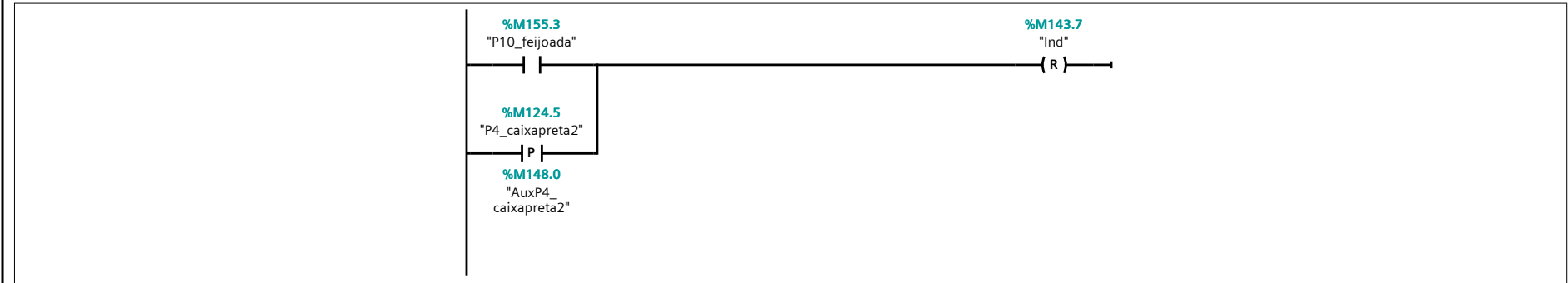
Network 86: Ações (Onde cada coisa acontece)

Ind



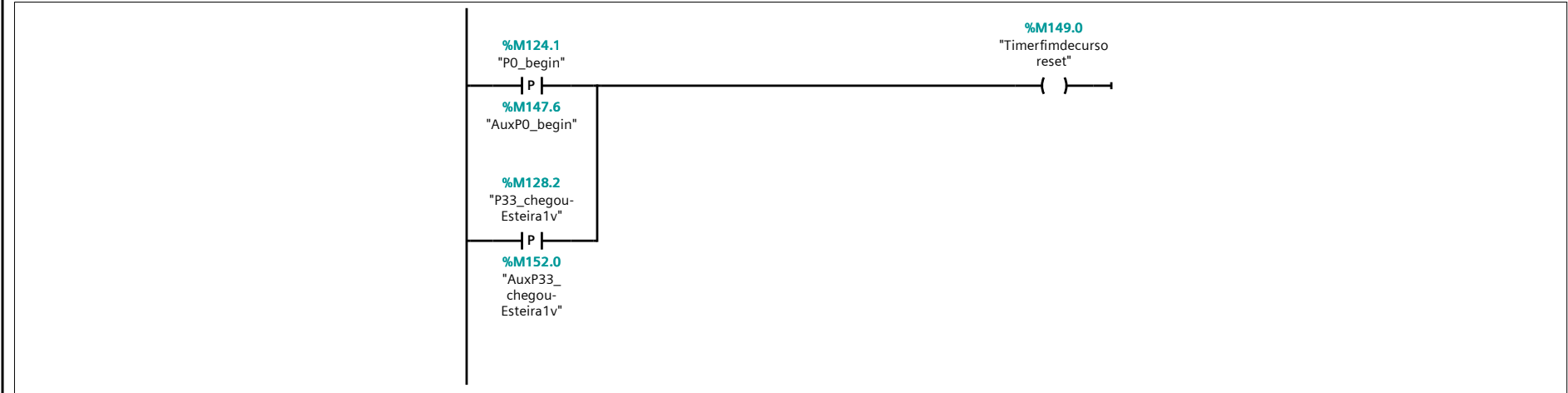
Symbol	Address	Type	Comment
"AuxP29_indigual1"	%M148.1	Bool	
"Ind"	%M143.7	Bool	VARIAVEIS
"P29_indigual1"	%M127.6	Bool	LUGAR

Network 87: VARIAVEIS



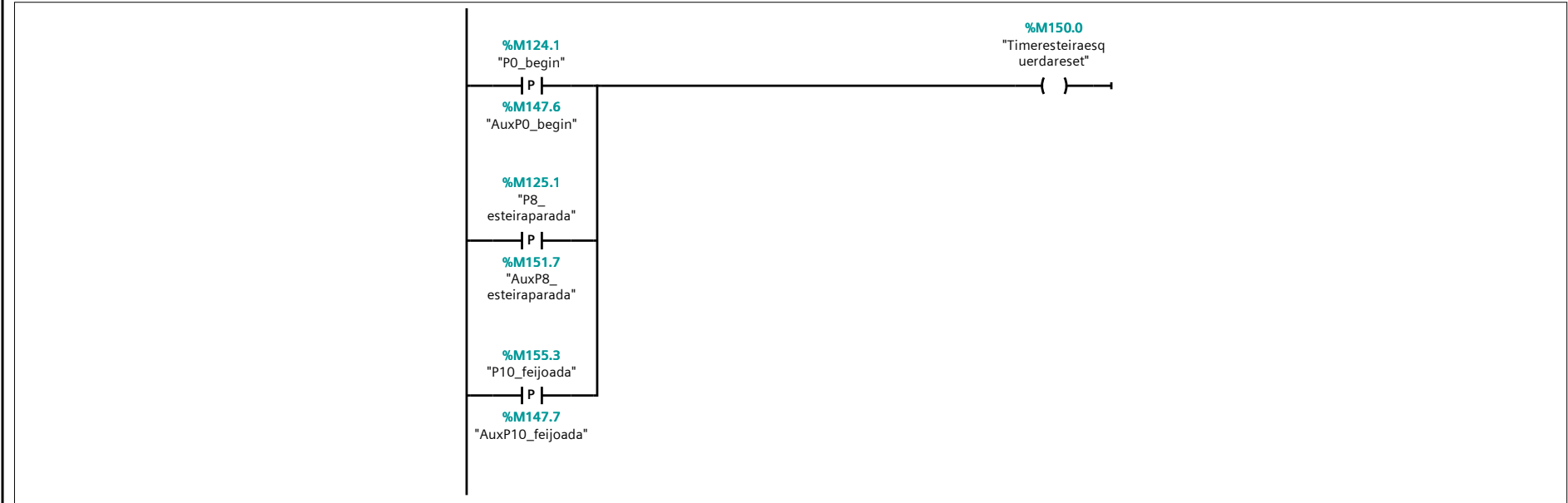
Symbol	Address	Type	Comment
"AuxP4_caixapreta2"	%M148.0	Bool	
"Ind"	%M143.7	Bool	VARIAVEIS
"P4_caixapreta2"	%M124.5	Bool	LUGAR
"P10_feijoadas"	%M155.3	Bool	LUGAR

Network 88: "Timerfimdecursoreset" VER SE PRECISA SER P reset



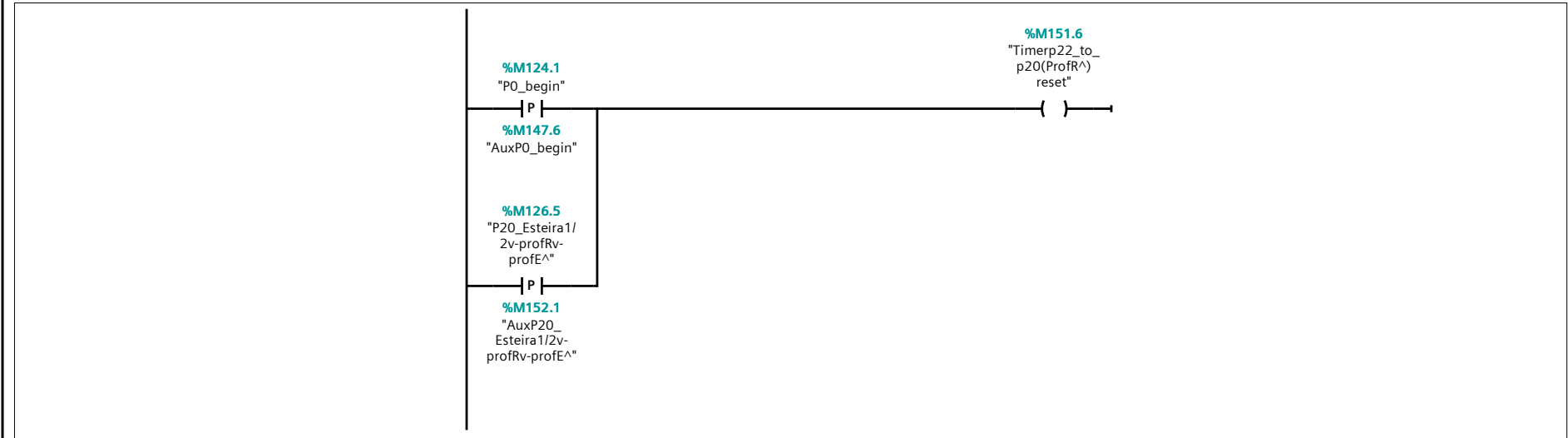
Symbol	Address	Type	Comment
"AuxP0_begin"	%M147.6	Bool	
"AuxP33_chegou-Esteira1v"	%M152.0	Bool	
"P0_begin"	%M124.1	Bool	LUGAR
"P33_chegou-Esteira1v"	%M128.2	Bool	LUGAR
"Timerfimdecursoreset"	%M149.0	Bool	

Network 89: esteiraesq reset



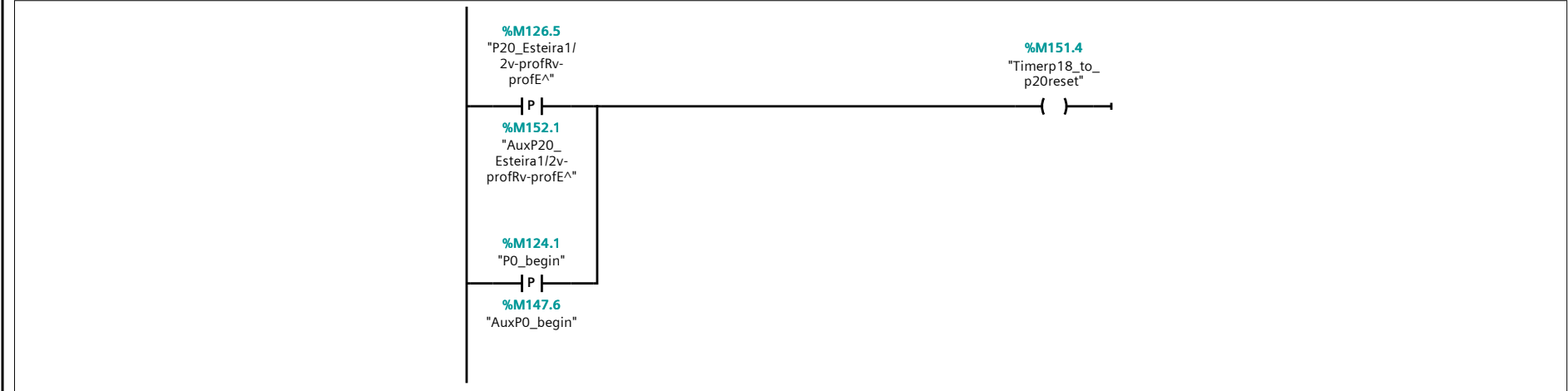
Symbol	Address	Type	Comment
"AuxP0_begin"	%M147.6	Bool	
"AuxP8_esteiraparada"	%M151.7	Bool	
"AuxP10_feijoadas"	%M147.7	Bool	
"P0_begin"	%M124.1	Bool	LUGAR
"P8_esteiraparada"	%M125.1	Bool	LUGAR
"P10_feijoadas"	%M155.3	Bool	LUGAR
"Timeresteiraesquerdareset"	%M150.0	Bool	

Network 90: p22\_to\_p20 reset



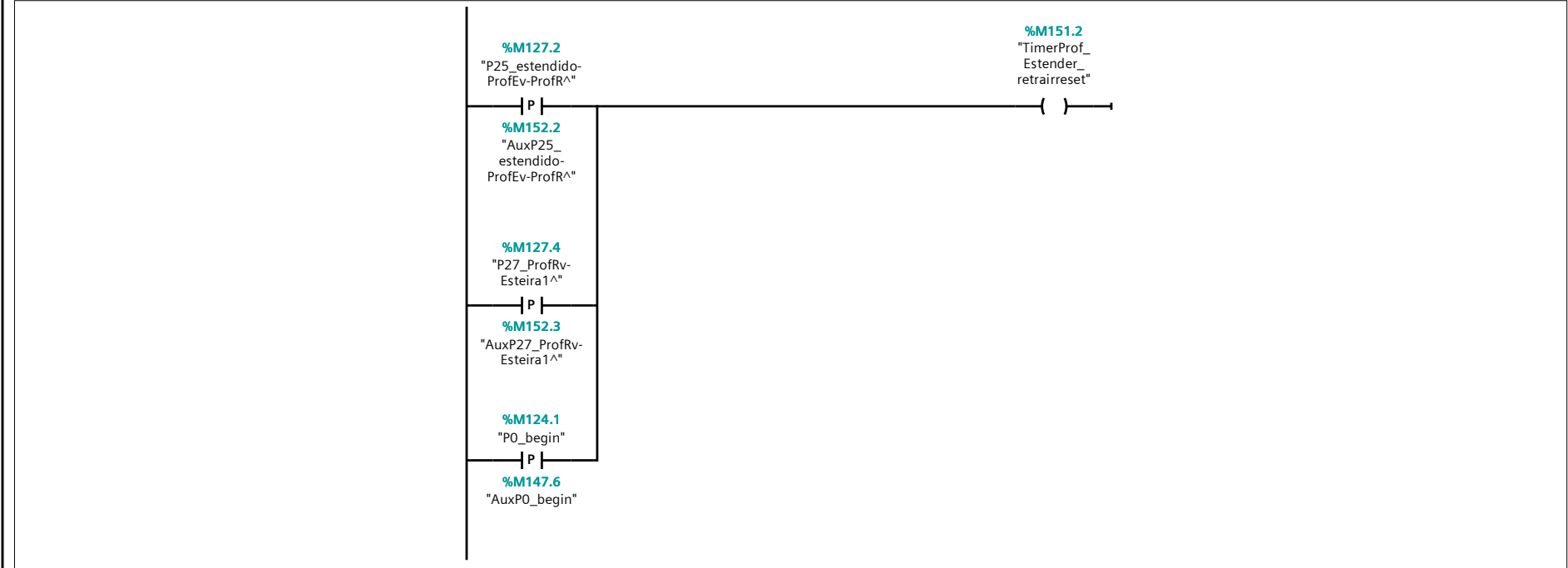
Symbol	Address	Type	Comment
"AuxP0_begin"	%M147.6	Bool	
"AuxP20_Esteira1/2v-profRv-profE^"	%M152.1	Bool	
"P0_begin"	%M124.1	Bool	LUGAR
"P20_Esteira1/2v-profRv-profE^"	%M126.5	Bool	LUGAR
"Timerp22_to_p20(ProfR^)reset"	%M151.6	Bool	

Network 91: p18\_t0\_p20



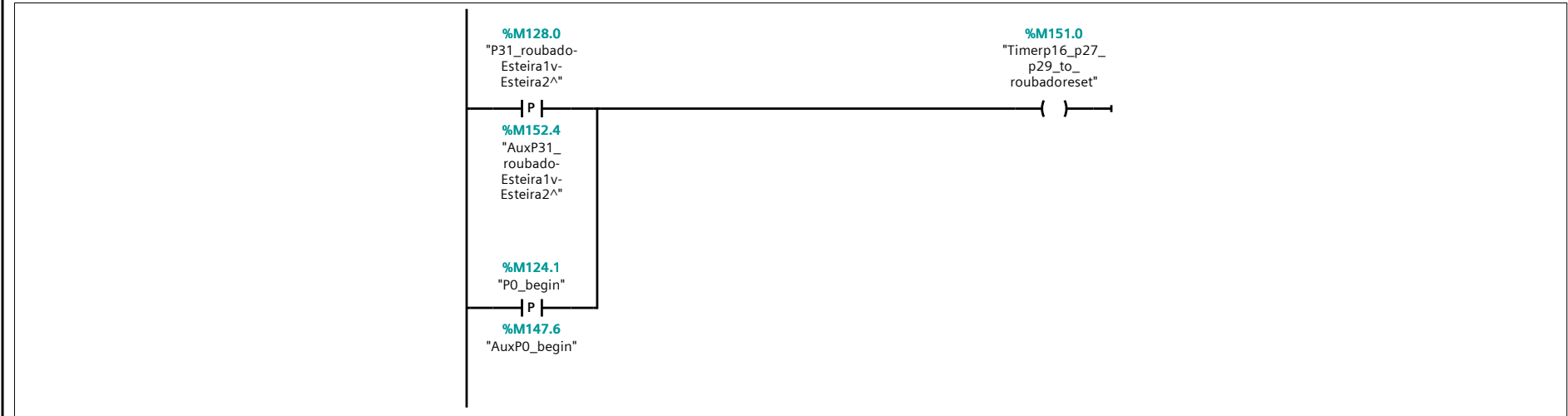
Symbol	Address	Type	Comment
"AuxP0_begin"	%M147.6	Bool	
"AuxP20_Esteira1/2v-profRv-profE^"	%M152.1	Bool	
"P0_begin"	%M124.1	Bool	LUGAR
"P20_Esteira1/2v-profRv-profE^"	%M126.5	Bool	LUGAR
"Timerp18_to_p20reset"	%M151.4	Bool	

Network 92: Profest reset



Symbol	Address	Type	Comment
"AuxP0_begin"	%M147.6	Bool	
"AuxP25_estendido-ProfEv-ProfR^"	%M152.2	Bool	
"AuxP27_ProfRv-Esteira1^"	%M152.3	Bool	
"P0_begin"	%M124.1	Bool	LUGAR
"P25_estendido-ProfEv-ProfR^"	%M127.2	Bool	LUGAR
"P27_ProfRv-Esteira1^"	%M127.4	Bool	LUGAR
"TimerProf_Estender_retrairreset"	%M151.2	Bool	

Network 93: Timerp16\_p27\_p29\_to\_roubadoreset



Symbol	Address	Type	Comment
"AuxP0_begin"	%M147.6	Bool	
"AuxP31_roubado-Esteira1v-Esteira2^"	%M152.4	Bool	
"P0_begin"	%M124.1	Bool	LUGAR
"P31_roubado-Esteira1v-Esteira2^"	%M128.0	Bool	LUGAR
"Timerp16_p27_p29_to_roubadoreset"	%M151.0	Bool	