Conveyor system (version 1)

Structure of the PLC program

OB100 „Start-up block"

…
…
…
…
…

OB100 is executed once only when you change the status of the PLC from STOP to RUN!

OB1 „main program block"

Call FC1 „Grafcet G1"
…
…

Call FC2 „Grafcet G10"
…
…
…
…
…

Call FC3 „Actions"
…
…

OB1 is executed cyclically!

FC1 „Grafcet G1"

…
…
…
…
…

FC2 „Grafcet G10"

…
…
…
…
…

FC3 „Actions"

…
…
…
…
…
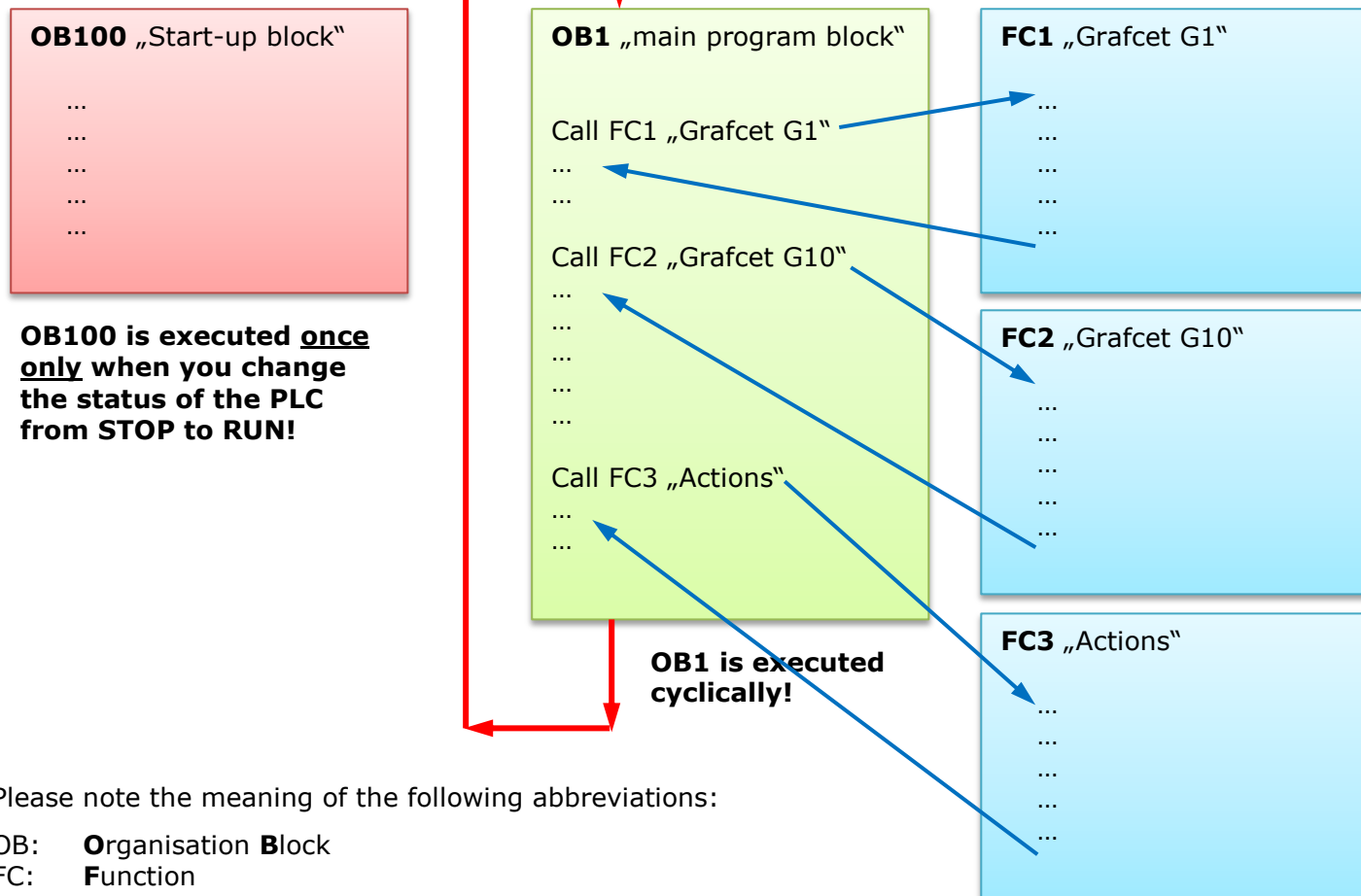
Please note the meaning of the following abbreviations:

OB: **O**rganisation **B**lock
FC: **F**unction