Gluing device

Structure of the PLC program

OB100 „Start-up block"

…
…
…
…
…

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

OB1 „main program block"

Call FC1 „Grafcet"
…
…

Call FC2 „Actions"
…
…
…
…
…
…
…
…
…
…

OB1 is executed cyclically!

FC1 „Grafcet"

…
…
…
…
…

FC2 „Actions"

…
…
…
…
…

DB2 „Gluing time value"

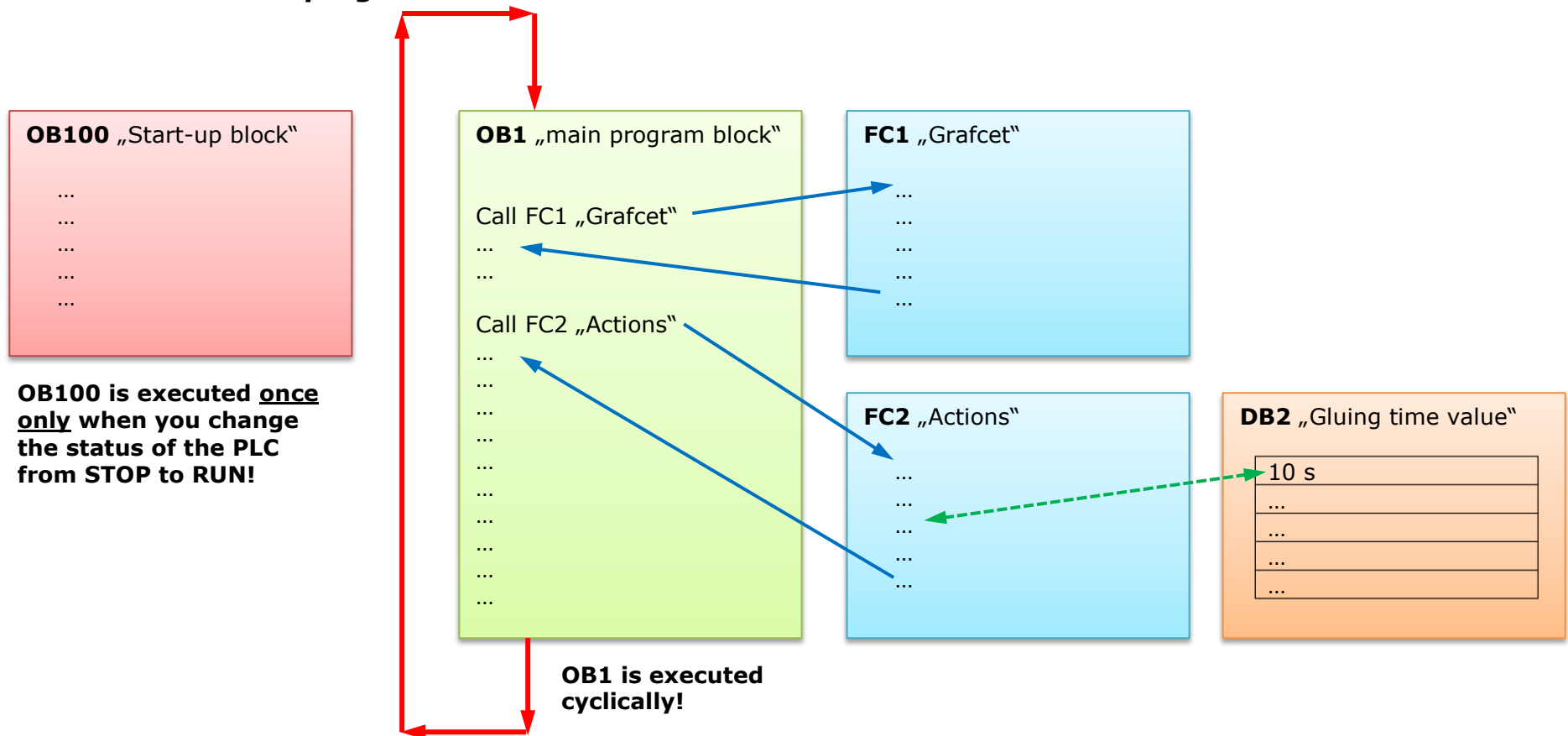| 10 s |
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| … |
| … |
| … |
| … |

Please note the meaning of the following abbreviations:

OB: **O**rganisation **B**lock
FC: **F**unction
DB: **D**ata **B**lock