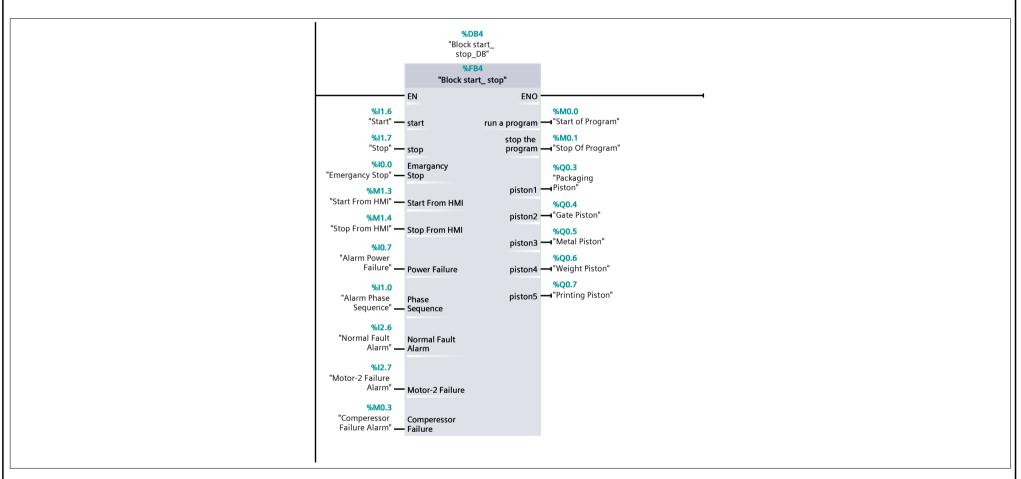
# Graduation\_Project / PLC\_1 [CPU 313C-2 DP] / Program blocks

## Main [OB1]

Main Properties							
General							
Name	Main	Number	1	Туре	ОВ	Language	LAD
Numbering	Manual						
Information							
Title	"Main Program Sweep (Cy-cle)"	Author		Comment		Family	
Version	0.1	User-defined ID					

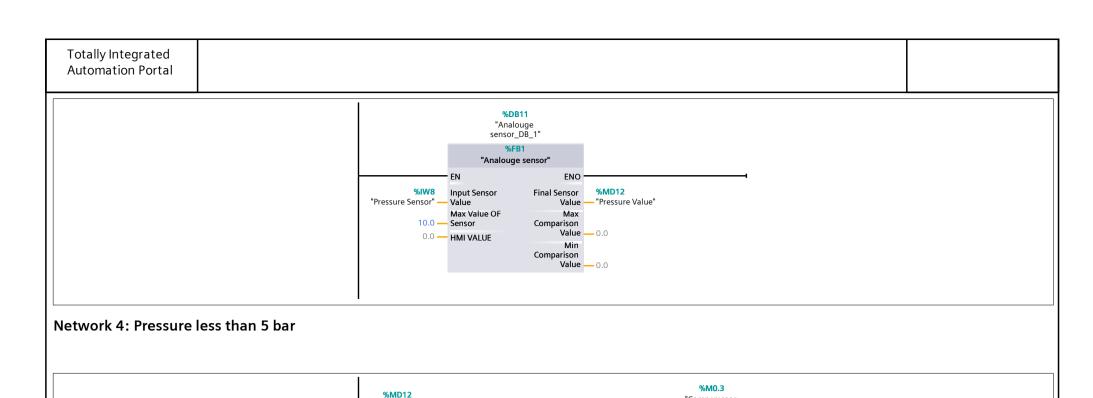
Main				
Name	Data type	Offset	Default value	Comment
<b>▼</b> Temp				
OB1_EV_CLASS	Byte	0.0		Bits 0-3 = 1 (Coming event), Bits 4-7 = 1 (Event class 1)
OB1_SCAN_1	Byte	1.0		1 (Cold restart scan 1 of OB 1), 3 (Scan 2-n of OB 1)
OB1_PRIORITY	Byte	2.0		Priority of OB Execution
OB1_OB_NUMBR	Byte	3.0		1 (Organization 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:



## **Network 2: Motor With VFD-Drive**

## Network 3:



"Comperessor Failure Alarm"

"Pressure Value"

## Network 5:

```
%DB5
                            "packaging_DB"
                               %FB8
                             "packaging"
                   EN
                                              ENO
         %M0.0 Start of
"Start of Program" — Program
                                                     "Packaging
→ Piston"
         %M0.1
                  Stop of
                                             Piston
"Stop Of Program" — Program
                                                      %M0.2
                                                      "STOP Motor for
          %10.1
                                        Stop Motor —Packaging"
      "PHOTO Photo Pi
SENSOR1" — Sensor
                   Photo Proximity
          %I2.1
"pusher_1_front" — Front Sensor
          %11.1
 "Pusher_1_Back" — Back Sensor
```

## Network 6:

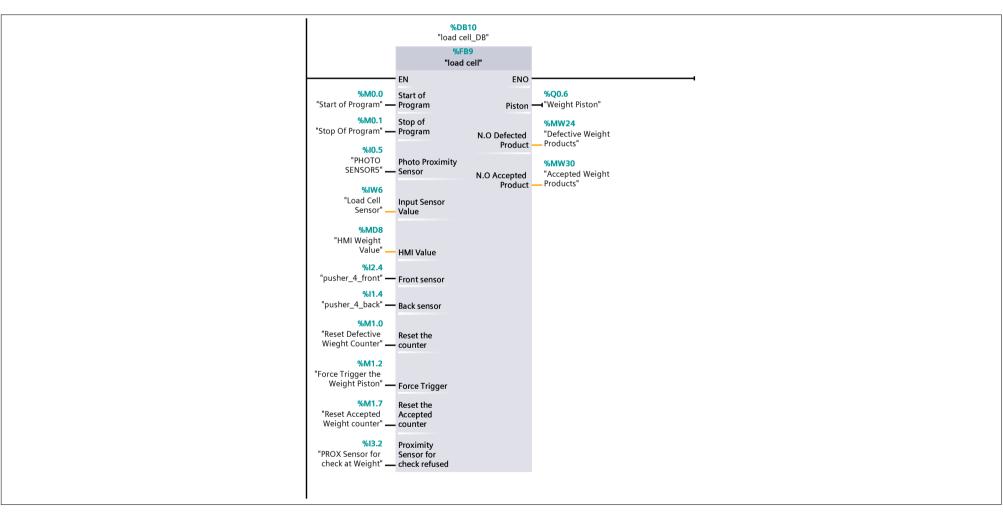
```
"Gate_DB"
                                          "Gate"
                                                                      %Q0.4

→ "Gate Piston"
             %M0.0
                        Start of
"Start of Program" –
                        Program
                                                           Piston -
%M0.1
"Stop Of Program" — Stop of Program
                                                                       %MW20
                                                  N.O Defected
Product
                                                                       "Defective Gate
- Products"
             %10.2
         "PHOTO Photo Proximity Sensor 1
           "РНОТО
                                                                        %MW26
                                                  N.O Accepted
Product —
                                                                       "Accepted Gate
- Products"
              %10.3
         "PHOTO
SENSOR3" _
                        Photo Proximity
– Sensor 2
 "pusher_2_front" — Front Sensor
             %I1.2
 "pusher_2_back" — Back Sensor
             %M0.6
                        Reset the
Refused
 "Reset Defective
Gate Counter" _
                        counter
            %M1.5 Reset the Accepted
 "Reset Accepted gate counter" — counter
"PROX Sensor for check at gate" — Proximity Sensor for check refused
```

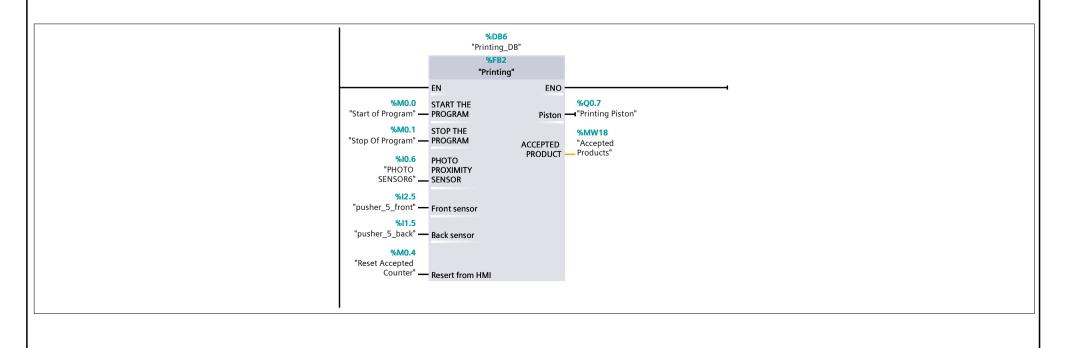
## Network 7:

Totally Integrated **Automation Portal** %DB2 "Detect Metal Level\_DB" %FB3 "Detect Metal Level" EN ENO %M0.0 Start of %Q0.5 "Start of Program" — Program Piston → "Metal Piston" Stop of - Program %M0.1 "Stop Of Program" -"Defective Metal Products" N.O Defected Product "РНОТО Photo Proximity - Sensor %MW28 SENSOR4" N.O Accepted "Accepted Metal Products" Input Sensor Value "METAL SENSOR" -%MD4 "HMI Metal Value" -HMI Value %12.3 "pusher\_3\_front" — Front sensor "pusher\_3\_back" — Back sensor %M1.1 "Force Trigger the Metal Piston" = Force Trigger %M0.7 "Reset Defective Metal Counter" — counter Reset the %M1.6 "Reset Accepted Accepted Metal counter" -%I3.1 Proximity
PROX Sensor for check at Metal" — check refused "PROX Sensor for

#### Network 8:



## Network 9:



|--|

### Network 10:

```
%I3.0

"PROX Sensor for check at gate"

%I3.1

"PROX Sensor for check at Metal"

"PROX Sensor for check at Weight"

"Summer of the content of
```

#### Network 11:

