Project / PLC_2 [CPU 319-3 PN/DP]

PLC tags

	Name	Data type	Address	Retain	Accessible from HMI/OPC UA	Writable from HMI/OPC UA	Visible in HMI engineering	Supervision	Comment
	lid_detection	Bool	%I0.0		True	True	True		
	stop_beginning_lid_sensor	Bool	%I0.1		True	True	True		
	start_LID_feeding_convyer	Bool	%I0.2		True	True	True		
	LID_detected_grip	Bool	%I0.3		True	True	True		
	stop_LID_Feeding	Bool	%I0.4		True	True	True		
	LID_machining_entrance_sensor	Bool	%I0.5		True	True	True		
	base_Raw_counter_start	Bool	%I0.6		True	True	True		
	stop_base_begininning_convyr	Bool	%I0.7		True	True	True		
	base_gripper_detected	Bool	%I1.0		True	True	True		
	start_base_raw_feeding	Bool	%I1.1		True	True	True		
	stop_base_raw_feeding	Bool	%I1.2		True	True	True		
	stop_base_machining_convyr	Bool	%I1.3		True	True	True		
	lid_start_button	Bool	%I1.4		True	True	True		
	lid_stop_button	Bool	%I1.5		True	True	True		
	lid_emergency_button	Bool	%I1.6		True	True	True		
	base_start_button	Bool	%I1.7		True	True	True		
	base_stop_button	Bool	%I2.0		True	True	True		
	base_emergency	Bool	%I2.1		True	True	True		
	Lid_beginning_conveyr	Bool	%Q0.0		True	True	True		
	lid_feeding_conveyr	Bool	%Q0.1		True	True	True		
	Lid_pickup_x_axis	Bool	%Q0.3		True	True	True		
	lid_pickup_z_axis	Bool	%Q0.4		True	True	True		
	lid_sucction_gripper	Bool	%Q0.5		True	True	True		
	base_beginning_conveyr	Bool	%Q0.6		True	True	True		
	lid-machinning_conveyr	Bool	%Q0.2		True	True	True		
	base_raw_feeding_conveyr	Bool	%Q0.7		True	True	True		
	base_to_machinning_conveyr	Bool	%Q1.0		True	True	True		
	base_pickup_x_axis	Bool	%Q1.1		True	True	True		
	base_pickup_z_axis	Bool	%Q1.2		True	True	True		
	base_sucction_gripper	Bool	%Q1.3		True	True	True		
	base_start_button_1_light	Bool	%Q1.4		True	True	True		
	base_stop_button_1_light	Bool	%Q1.5		True	True	True		
	lid_start_light	Bool	%Q1.6		True	True	True		
	lid_stop_button_1_light	Bool	%Q1.7		True	True	True		
	base_raw_material	Bool	%Q2.0		True	True	True		
	lid_raw_emit	Bool	%Q2.1		True	True	True		
	state_of_start_base	Bool	%M0.0		True	True	True		
	state_of_start_LID	Bool	%M0.1		True	True	True		
	state_of_lid	Bool	%M0.2		True	True	True		
	dummy	Bool	%M0.3		True	True	True		
	To_emit_lid	Bool	%M0.4		True	True	True		
	item_ready_to_picked	Bool	%M0.5		True	True	True		
	movin_lid_z_mem	Bool	%M0.6		True	True	True		
	LID_moving_z_sensor	Bool	%I2.4		True	True	True		
	LID_moving_x_sensor	Bool	%I2.5		True	True	True		
	dummy(1)	Bool	%M0.7		True	True	True		
	dummy(2)	Bool	%M1.0		True	True	True		
	lid_belt_convyer_excess	Bool	%Q2.2		True	True	True		
	push_excess_blue_lid	Bool	%Q2.3		True	True	True		
	push_excess_green_lid	Bool	%Q2.4		True	True	True		
	Blue_vision_lid	Bool	%I2.6		True	True	True		
	green_vision_lid	Bool	%I2.7		True	True	True		
	front_blue_push_lid	Bool	%I3.0		True	True	True		
	back_blue_push_lid	Bool	%I3.1		True	True	True		
	front_green_push_lid	Bool	%I3.2		True	True	True		
	back_green_push_lid	Bool	%I3.3		True	True	True		
	into_cnc_lid_sensor	Bool	%I3.4		True	True	True		

	Name	Data type	Address	Retain	Accessible from HMI/OPC UA	Writable from HMI/OPC UA	Visible in HMI engineering	Supervision	Comment
	CNC_lid_empty	Bool	%M1.1		True	True	True		
	ONE_OBJECT_IN	Bool	%Q2.5		True	True	True		
	KEEP_DISTANCE	Bool	%Q2.6		True	True	True		
	ARE_WE_THERE_YET_BLUE_lid	Bool	%M1.2		True	True	True		
	ARE_WE_THERE_YET_GREEN_lid	Bool	%M1.3		True	True	True		
	LID_COUNTER_RESET_BUTTON_BLUE	Bool	%I3.5		True	True	True		
	TO_STORAGE_BLUE_CONVYER_lid	Bool	%Q2.7		True	True	True		
	TO_STORAGE_GREEN_CONVYER_lid	Bool	%Q3.0		True	True	True		
	TO_STORAGE_BLUE_SENSOR_lid	Bool	%I3.6		True	True	True		
	TO_STORAGE_GREEN_SENSOR_lid	Bool	%I3.7		True	True	True		
	LID_COUNTER_RESET_BUTTON_GREEN	Bool	%I4.0		True	True	True		
	GREEN_LID_PUSHER_SORTING(FRONT LIMIT)	Bool	%I4.1		True	True	True		
	GREEN_LID_PUSHER_SORTING(BACK LIMITT)	Bool	%I4.2		True	True	True		
	BLUE_LID_PUSHER_SORTING(FRONT LIMIT)	Bool	%I4.3		True	True	True		
	BLUE_LID_PUSHER_SORTING(BACK LIMIT)	Bool	%I4.4		True	True	True		
	BEGIN_SORTING_STATION_LIDS	Bool	%I4.5		True	True	True		
	BLUE_LID_VISION_SORTING	Bool	%I4.6		True	True	True		
	GREEN_LID_VISION_SORTING	Bool	%I4.7		True	True	True		
	SORTING_CONVYER_LID	Bool	%Q3.1		True	True	True		
	GREEN_LID_PUSHER_SORTING	Bool	%Q3.2		True	True	True		
	BLUE_LID_PUSHER_SORTING	Bool	%Q3.3		True	True	True		
	CNC_base_empty	Bool	%M2.5		True	True	True		
	to_emit_base	Bool	%M1.5		True	True	True		
	base_into_cnc	Bool	%I5.0		True	True	True		
	BASE_MOVE_X_SENSOR	Bool	%I5.1		True	True	True		
	BASE_MOVE_Z_SENSOR	Bool	%I5.2		True	True	True		
	DUMMY1	Bool	%M1.6		True	True	True		
	DUMMY2	Bool	%M1.7		True	True	True		
	DUMMY3	Bool	%M2.0		True	True	True		
	DUMMY4	Bool	%M2.1		True	True	True		
	DUMMY5	Bool	%M2.2		True	True	True		
	BASE_RAW_EXESS_CONV	Bool	%Q3.4		True	True	True		
	Are_we_there_base_raw_blue	Bool	%M2.3		True	True	True		
	Are_we_there_base_raw_green	Bool	%M2.4		True	True	True		
	base_raw_blue_exes_vision	Bool	%I5.3		True	True	True		
	base_raw_green_exes_vision	Bool	%I5.4		True	True	True		
	to_blue_base_raw_storage_sensor	Bool	%I5.5		True	True	True		
	to_green_base_raw_storage_sensor	Bool	%I5.6		True	True	True		
	push_ex_green_base raw(front)	Bool	%I5.7		True	True	True		
	push_ex_green_base raw (back)	Bool	%I6.0		True	True	True		
	pusher blue base raw (front)	Bool	%I6.1		True	True	True		
	pusher blue base raw (back)	Bool	%I6.2		True	True	True		
	MachineCenter1_lid_start	Bool	%Q3.5		True	True	True		
	MachineCenter1_lid_produceLids	Bool	%Q3.6		True	True	True		
	push_excess_blue_base	Bool	%Q3.7		True	True	True		
	push_excess_green_base	Bool	%Q4.0		True	True	True		
	base_COUNTER_RESET_BUTTON_BLUE	Bool	%I6.3		True	True	True		
	base_COUNTER_RESET_BUTTON_GREEN	Bool	%I6.4		True	True	True		
	base_raw_excess_blue	Bool	%Q4.1		True	True	True		
	base_raw_excess_green	Bool	%Q4.2		True	True	True		
	base_vision_raw_execess_sensor_green	Bool	%I6.5		True	True	True		
	base_vision_raw_execess_sensor_blue	Bool	%I6.6		True	True	True		
	MachineCenter2_base_start	Bool	%Q4.3		True	True	True		
	is_base_exsist	Bool	%M1.4		True	True	True		
	Stop_blade4	Bool	%Q4.4		True	True	True		

	Name	Data type	Address	Retain	Accessible from HMI/OPC UA	Writable from HMI/OPC UA	Visible in HMI engineering	Supervision	Comment
	Stop_blade5	Bool	%Q4.5		True	True	True		
	MACHINE1_BUSY	Bool	%I6.7		True	True	True		
	BEGIN_SORTING_STATION_BASE_SENSOR	Bool	%I7.0		True	True	True		
	BEGIN_SORTING_STATION_BASE_1	Bool	%Q4.6		True	True	True		
	BEGIN_SORTING_STATION_BASE_2	Bool	%Q4.7		True	True	True		
	BEGIN_SORTING_STATION_BASE_3	Bool	%Q5.0		True	True	True		
	Green_base_sorting_vision	Bool	%I7.1		True	True	True		
	Blue_base_sorting_vision	Bool	%I7.2		True	True	True		
	Pusher_green_base (Front Limit)	Bool	%I7.3		True	True	True		
	Pusher_green_base (Back Limit)	Bool	%I7.4		True	True	True		
	Pusher_blue_base (Front Limit)	Bool	%I7.5		True	True	True		
	Pusher_blue_base (Back Limit)	Bool	%I7.6		True	True	True		
	Pusher_blue_base_sorter	Bool	%Q5.2		True	True	True		
	Pusher_green_base_sorter	Bool	%Q5.1		True	True	True		
	Conv_sorting_set_base	Bool	%M2.6		True	True	True		
	BEGIN_SORTING_STATION_BASE_4	Bool	%Q5.3		True	True	True		
	Conv_sorting_set_lid	Bool	%M2.7		True	True	True		
	Emit_set_lid	Bool	%M3.0		True	True	True		
	Emit_set_base	Bool	%M3.1		True	True	True		
	Blue count	Int	%MW4		True	True	True		
	excess blue lid raw led light	Bool	%Q5.4		True	True	True		
	excess green lid raw led light	Bool	%Q5.5		True	True	True		
	excess blue base raw led light	Bool	%Q5.6		True	True	True		
	excess green base raw led light	Bool	%Q5.7		True	True	True		
	blue lid sorting light	Bool	%Q6.0		True	True	True		
	green lid sorting light	Bool	%Q6.1		True	True	True		
	blue base sorting light	Bool	%Q6.2		True	True	True		
	green base sorting light	Bool	%Q6.3		True	True	True		
	Assembly green lid start	Bool	%I8.0		True	True	True		
	Assembly blue lid start	Bool	%I8.1		True	True	True		
	Assembly green base start	Bool	%I8.2		True	True	True		
	Assembly blue base start	Bool	%I8.3		True	True	True		
	G_lid in place	Bool	%I8.4		True	True	True		
	G_base in place	Bool	%I8.5		True	True	True		
	G_lid_clamped	Bool	%I8.6		True	True	True		
	G_base_clamped	Bool	%I8.7		True	True	True		
	G_part_leaving	Bool	%I9.0		True	True	True		
	G_item_detect	Bool	%I9.1		True	True	True		
	B_lid in place	Bool	%I9.2		True	True	True		
	B_base in place	Bool	%I9.3		True	True	True		
	B_lid_clamped	Bool	%I9.4		True	True	True		
	B_base_clamped	Bool	%I9.5		True	True	True		
	B_part_leaving	Bool	%I9.6		True	True	True		
	B_item_detect	Bool	%I9.7		True	True	True		
	G_Negative_Trig_1	Bool	%M4.0		True	True	True		
	G_Negative_Trig_2	Bool	%M4.1		True	True	True		
	G_Negative_Trig_3	Bool	%M4.2		True	True	True		
	move_green_lid_conv	Bool	%M4.3		True	True	True		
	move_green_base_conv	Bool	%M4.4		True	True	True		
	move_blue_lid_conv	Bool	%M4.5		True	True	True		
	move_blue_base_conv	Bool	%M4.6		True	True	True		
	B_Negative_Trig_1	Bool	%M4.7		True	True	True		
	B_Negative_Trig_2	Bool	%M5.0		True	True	True		
	B_Negative_Trig_3	Bool	%M5.1		True	True	True		
	G_Detected_Memory	Bool	%M5.2		True	True	True		
	G_Reset	Bool	%M5.3		True	True	True		
	B_Detected_Memory	Bool	%M5.4		True	True	True		
	B_Reset	Bool	%M5.5		True	True	True		

	Name	Data type	Address	Retain	Accessible from HMI/OPC UA	Writable from HMI/OPC UA	Visible in HMI engineering	Supervision	Comment
	G_Timer_1	Timer	%T0		True	True	True		
	G_Timer_2	Timer	%T1		True	True	True		
	G_Timer_3	Timer	%T2		True	True	True		
	B_Timer_1	Timer	%T3		True	True	True		
	B_Timer_2	Timer	%T4		True	True	True		
	B_Timer_3	Timer	%T5		True	True	True		
	Green_Lid_conv_timer	Timer	%T6		True	True	True		
	Blue_Lid_conv_timer	Timer	%T7		True	True	True		
	Green_Base_conv_timer	Timer	%T8		True	True	True		
	Blue_Base_conv_timer	Timer	%T9		True	True	True		
	G_lids_conv_1	Bool	%Q7.0		True	True	True		
	G_lids_conv_2	Bool	%Q7.1		True	True	True		
	G_lids_conv_3	Bool	%Q7.2		True	True	True		
	G_lids_conv_4	Bool	%Q7.3		True	True	True		
	G_lids_conv_5	Bool	%Q7.4		True	True	True		
	G_lids_conv_6	Bool	%Q7.5		True	True	True		
	G_lids_conv_7	Bool	%Q7.6		True	True	True		
	G_lids_conv_8	Bool	%Q7.7		True	True	True		
	B_lids_conv_1	Bool	%Q8.0		True	True	True		
	B_lids_conv_2	Bool	%Q8.1		True	True	True		
	B_lids_conv_3	Bool	%Q8.2		True	True	True		
	B_lids_conv_4	Bool	%Q8.3		True	True	True		
	G_base_conv_1	Bool	%Q8.4		True	True	True		
	G_base_conv_2	Bool	%Q8.5		True	True	True		
	G_base_conv_3	Bool	%Q8.6		True	True	True		
	G_base_conv_4	Bool	%Q8.7		True	True	True		
	G_base_conv_5	Bool	%Q9.0		True	True	True		
	G_base_conv_6	Bool	%Q9.1		True	True	True		
	B_base_conv_1	Bool	%Q9.2		True	True	True		
	B_base_conv_2	Bool	%Q9.3		True	True	True		
	B_base_conv_3	Bool	%Q9.4		True	True	True		
	B_base_conv_4	Bool	%Q9.5		True	True	True		
	G_clamp_lid	Bool	%Q9.6		True	True	True		
	G_clamp_base	Bool	%Q9.7		True	True	True		
	G_move Z	Bool	%Q10.0		True	True	True		
	G_grab	Bool	%Q10.1		True	True	True		
	G_move X	Bool	%Q10.2		True	True	True		
	G_pos.Raise_bases	Bool	%Q10.3		True	True	True		
	B_clamp_lid	Bool	%Q10.4		True	True	True		
	B_clamp_base	Bool	%Q10.5		True	True	True		
	B_move Z	Bool	%Q10.6		True	True	True		
	B_grab	Bool	%Q10.7		True	True	True		
	B_move X	Bool	%Q11.0		True	True	True		
	B_pos.Raise_bases	Bool	%Q11.1		True	True	True		
	CCC1	Bool	%I10.0		True	True	True		
	CCC2	Bool	%I10.1		True	True	True		
	Tag_1	Bool	%M5.6		True	True	True		
	Tag_2	Bool	%M5.7		True	True	True		
	Tag_3	Bool	%M6.0		True	True	True		
	Tag_4	Bool	%M6.1		True	True	True		
	Tag_5	Bool	%M6.2		True	True	True		
	Tag_6	Bool	%M6.3		True	True	True		
	Tag_7	Bool	%M6.4		True	True	True		
	Tag_8	Bool	%M6.5		True	True	True		
	Tag_9	Bool	%M6.6		True	True	True		