Controladores Lógicos Programáveis

Técnico em Automação Industrial

INSTITUTO FEDERAL
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Câmpus Salto

Método de programação por Maximização de contatos

Cadeia estacionária ou passo a passo

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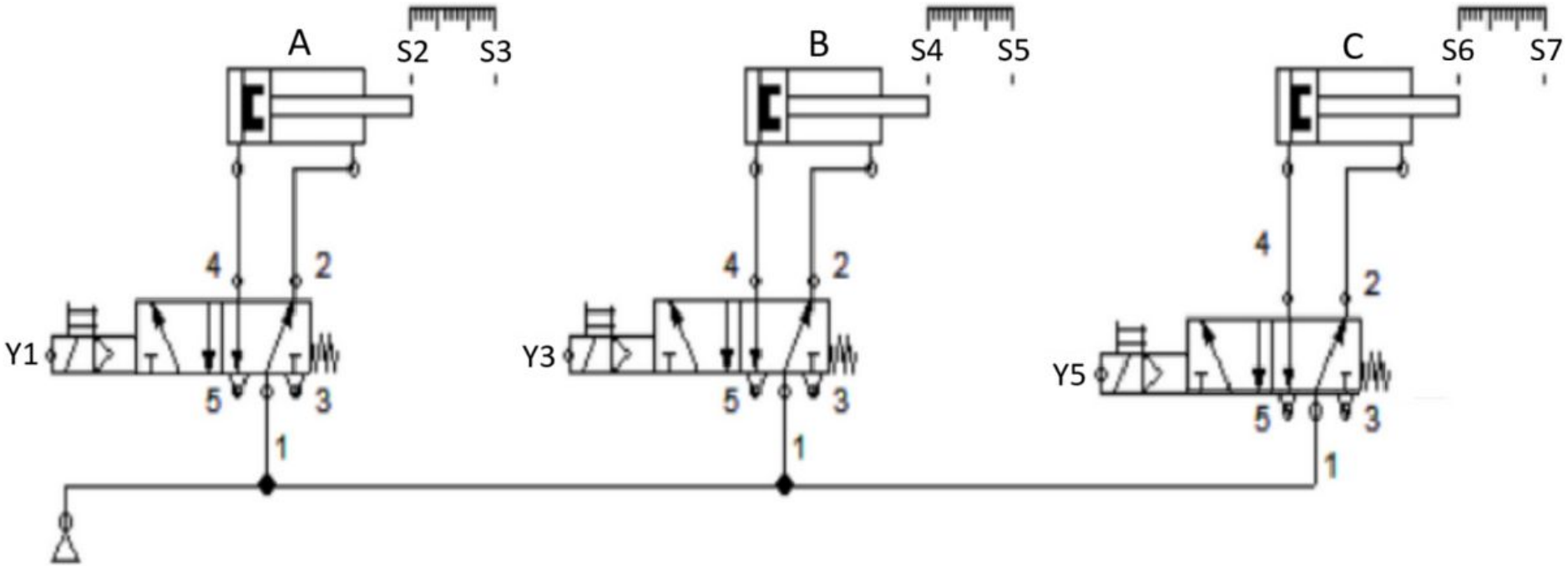
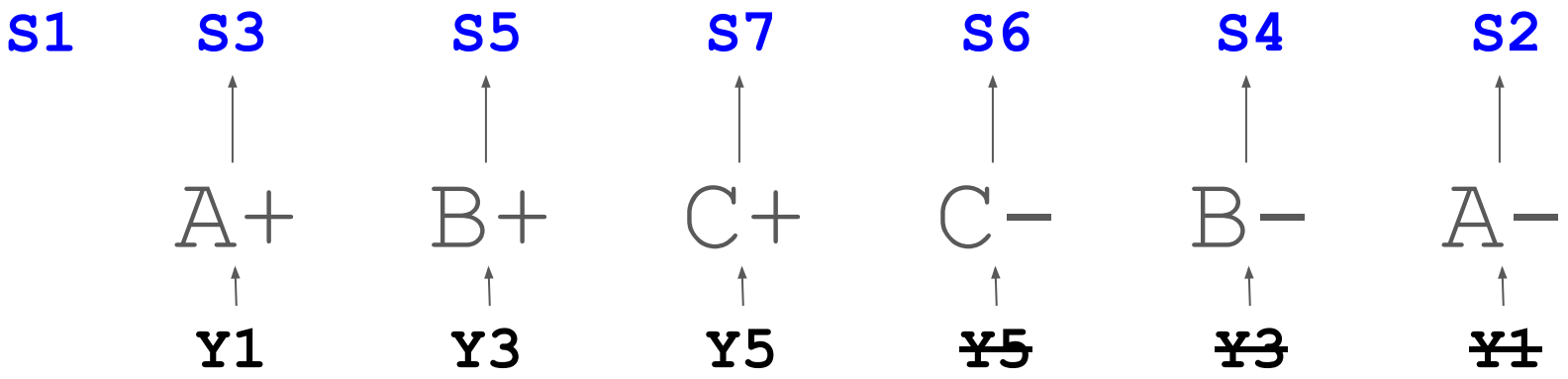
Circuito



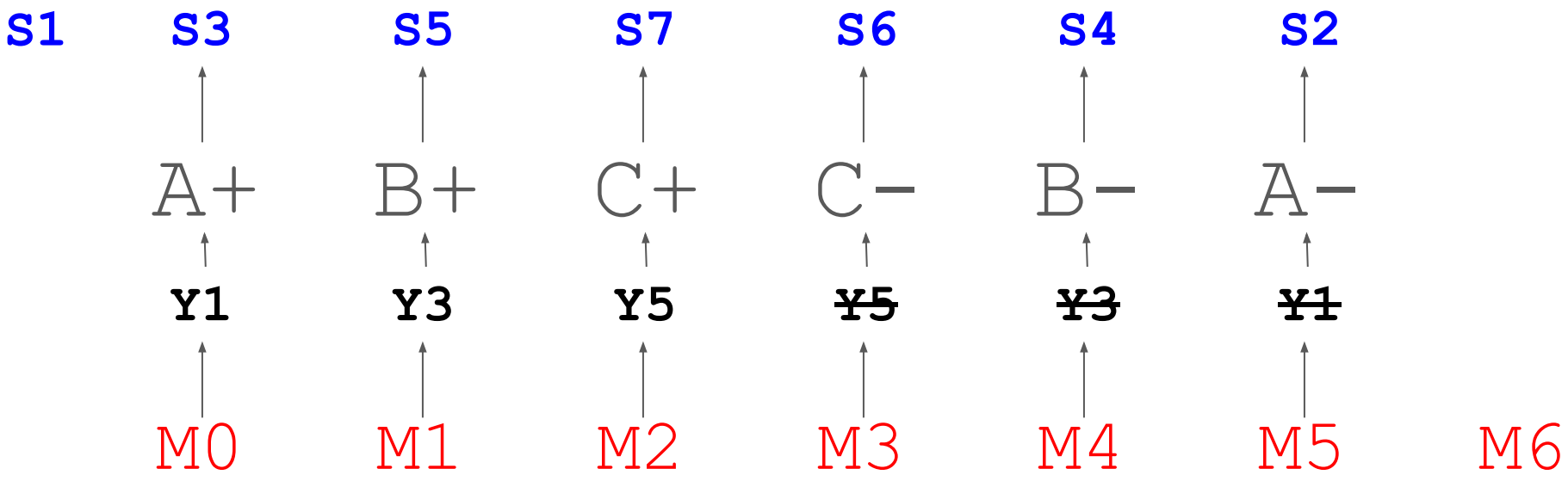
Passo 0: Sequência de acionamento

A+ B+ C+ C- B- A-

Passo 1: **Atuadores** e **Fins de Curso**



Passo 2: Para cada movimento, uma memória, +1



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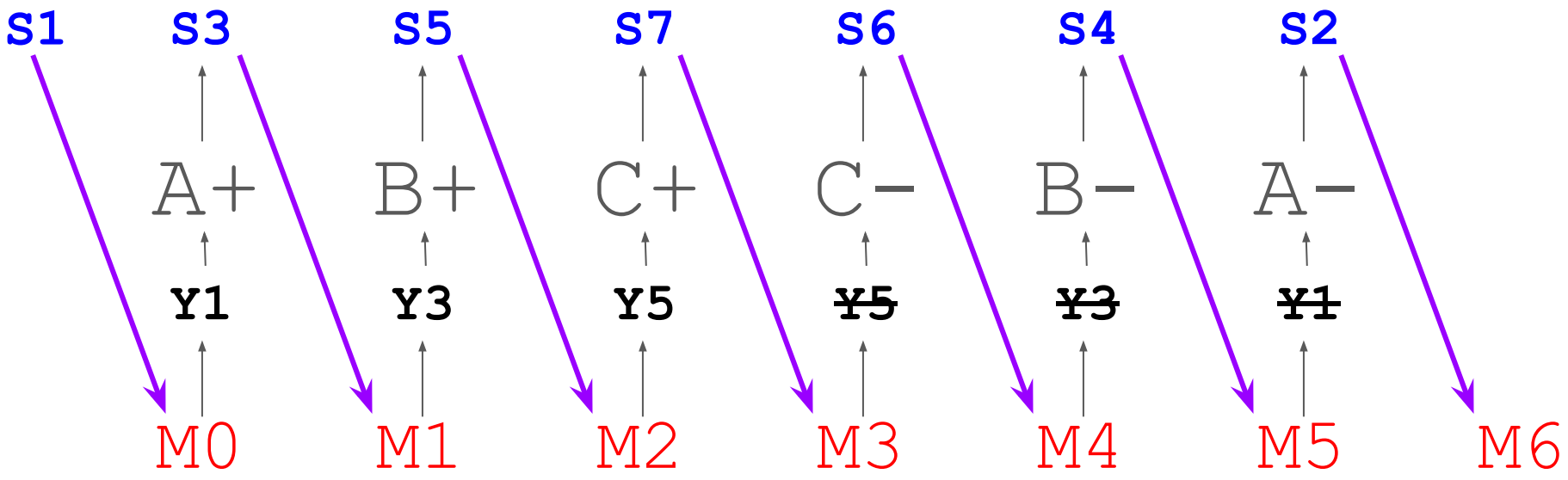
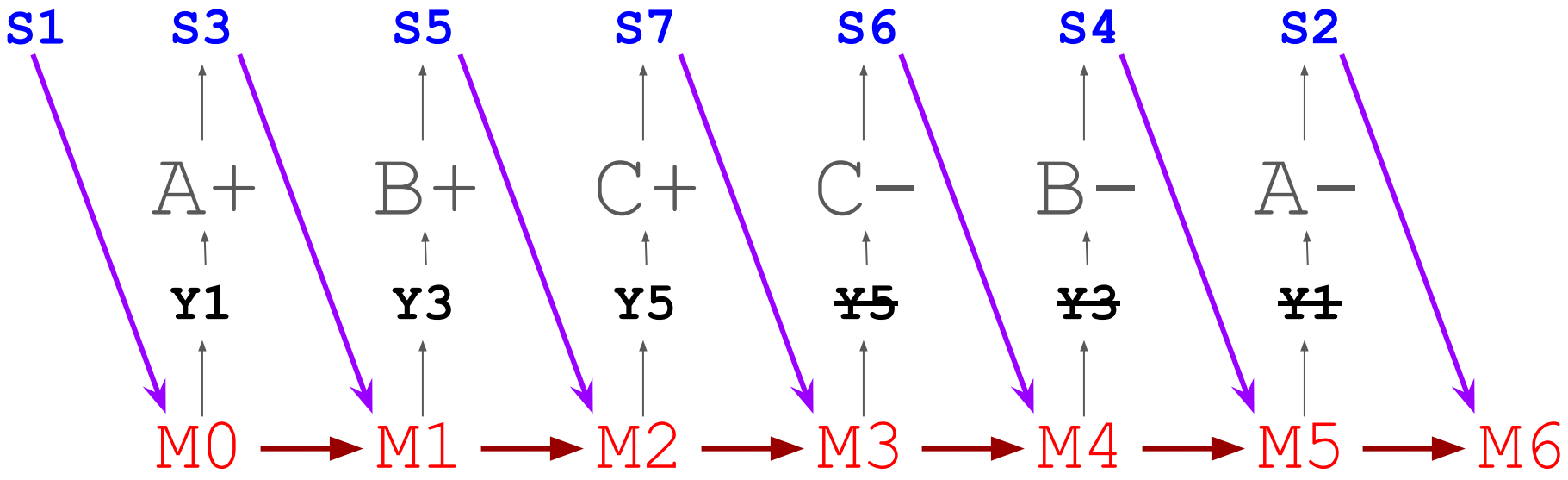
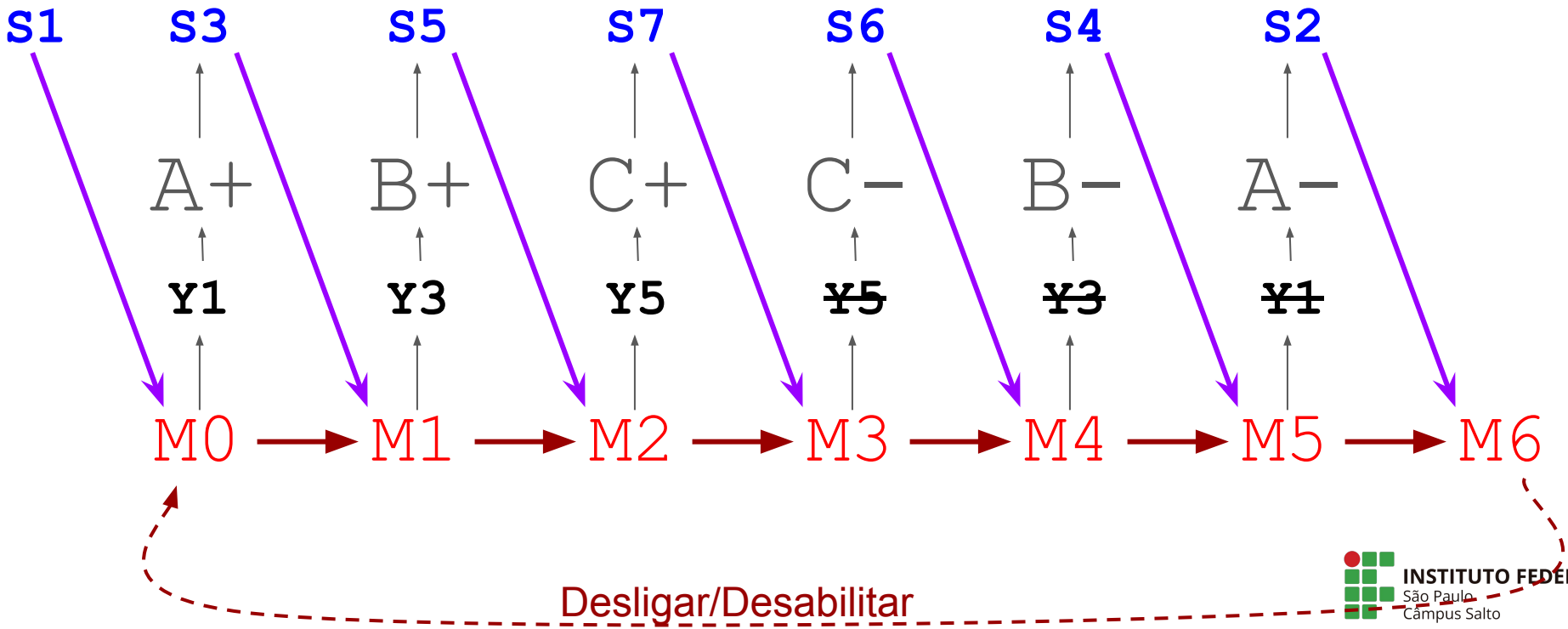
Passo 3: Acionamento das memórias



Passo 4: Habilitação das Memórias



Passo 5: Desabilitação das Memórias



Programação no PLC

Linguagem Ladder

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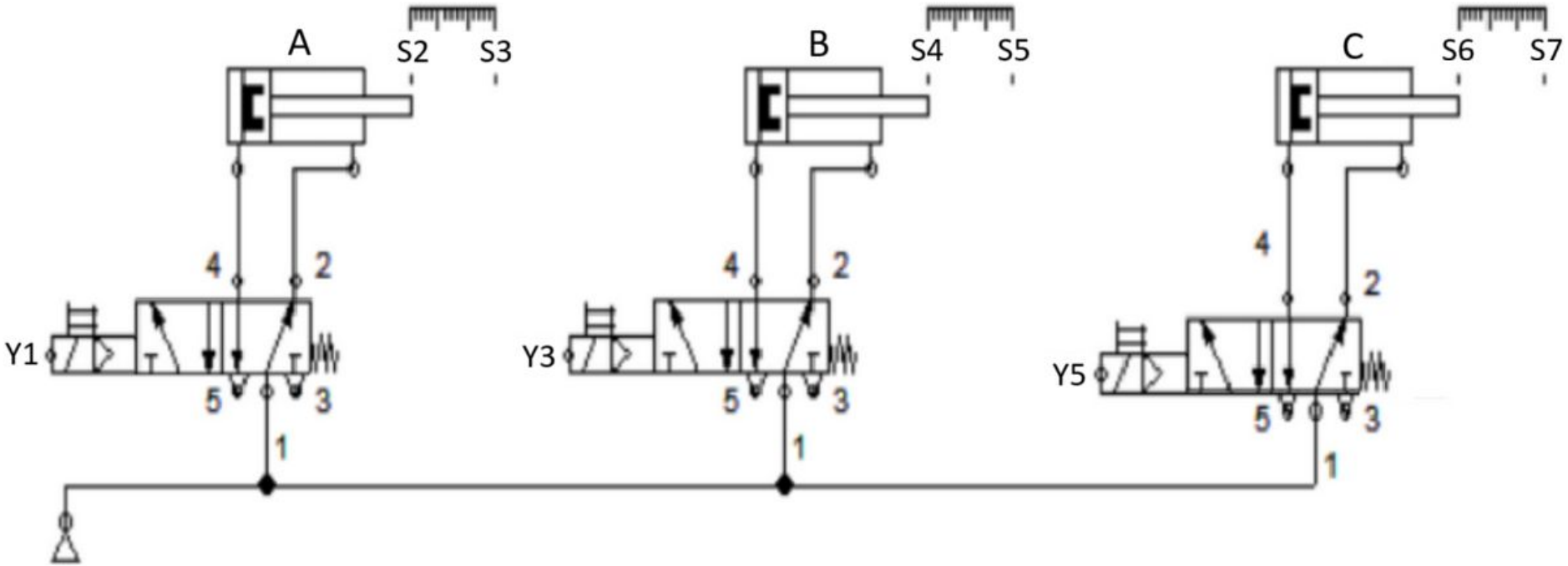

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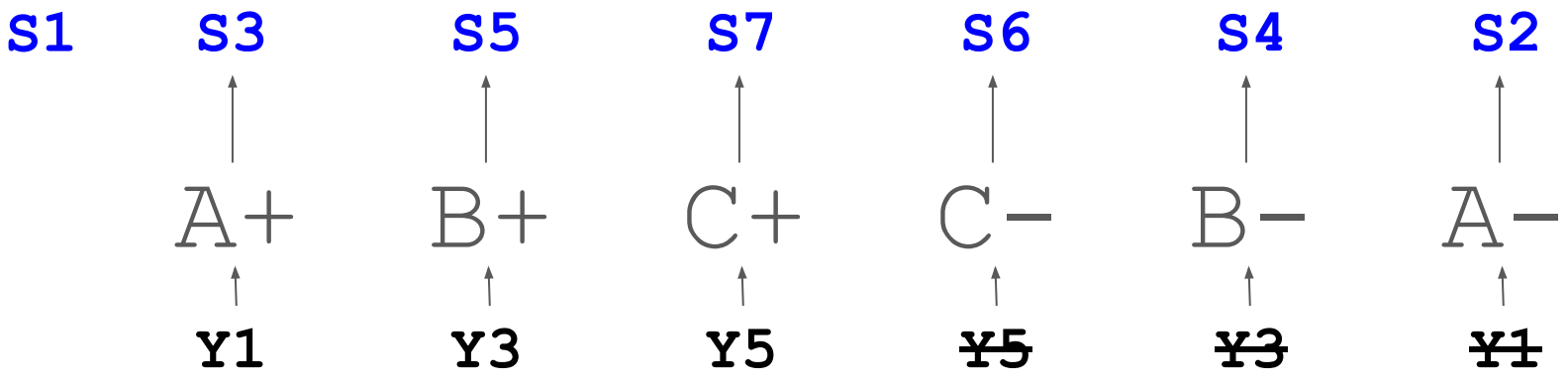
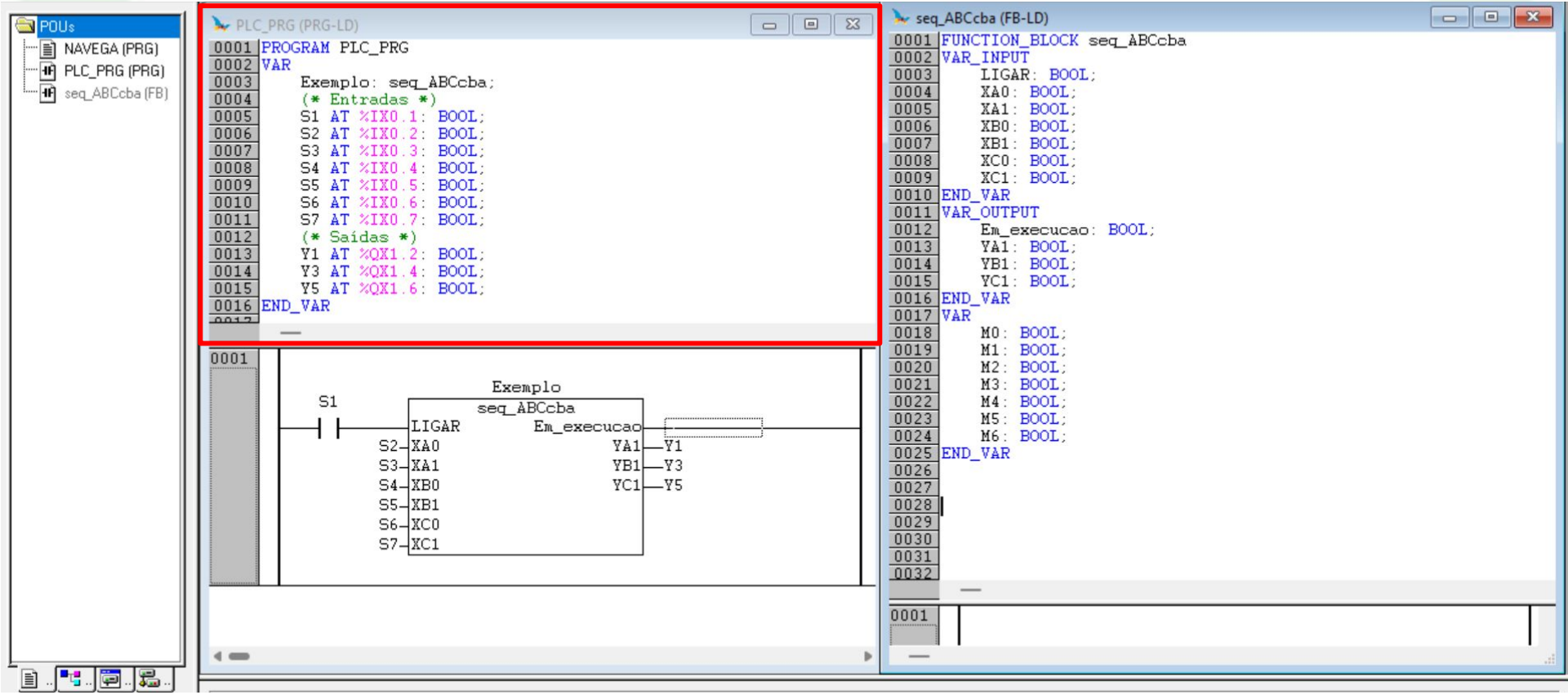
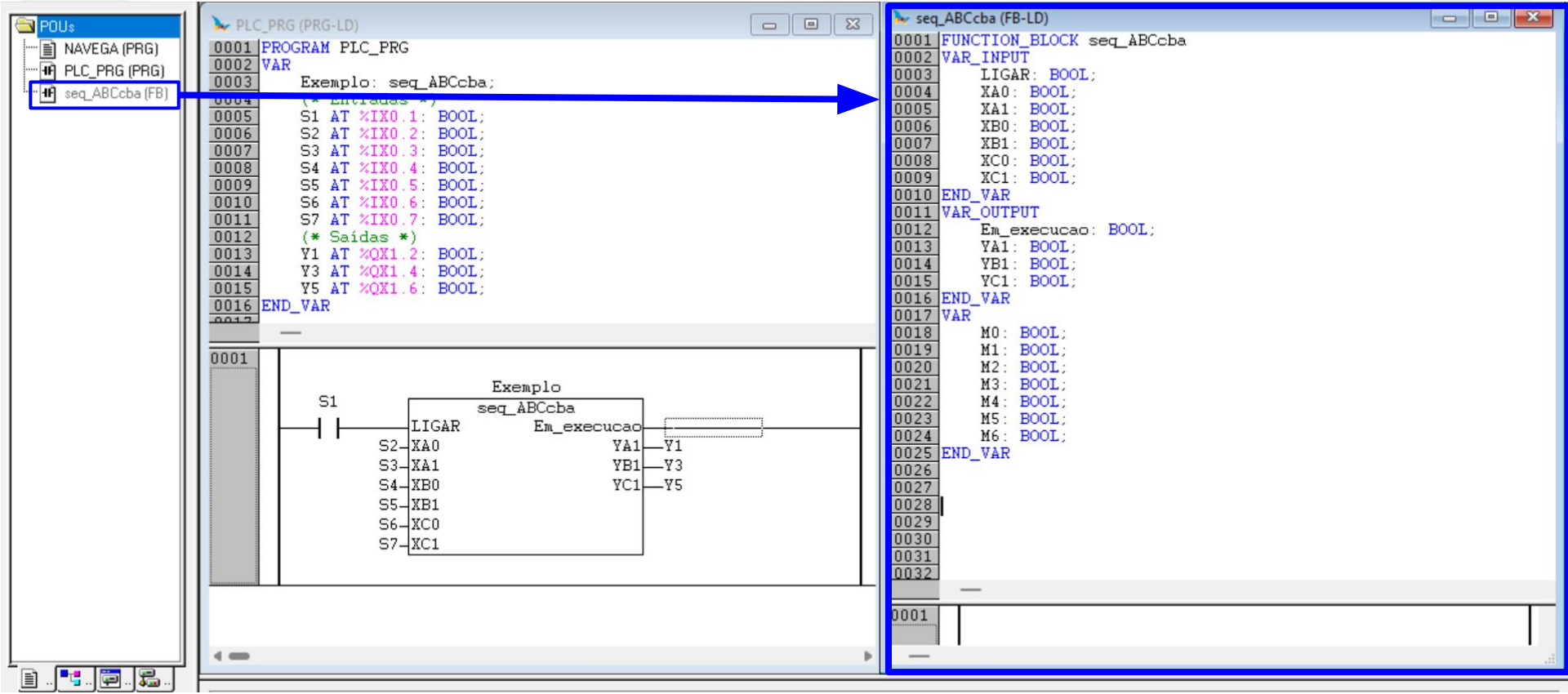


Declaração de Entradas(Fins de curso) e Saídas(Atuadores)

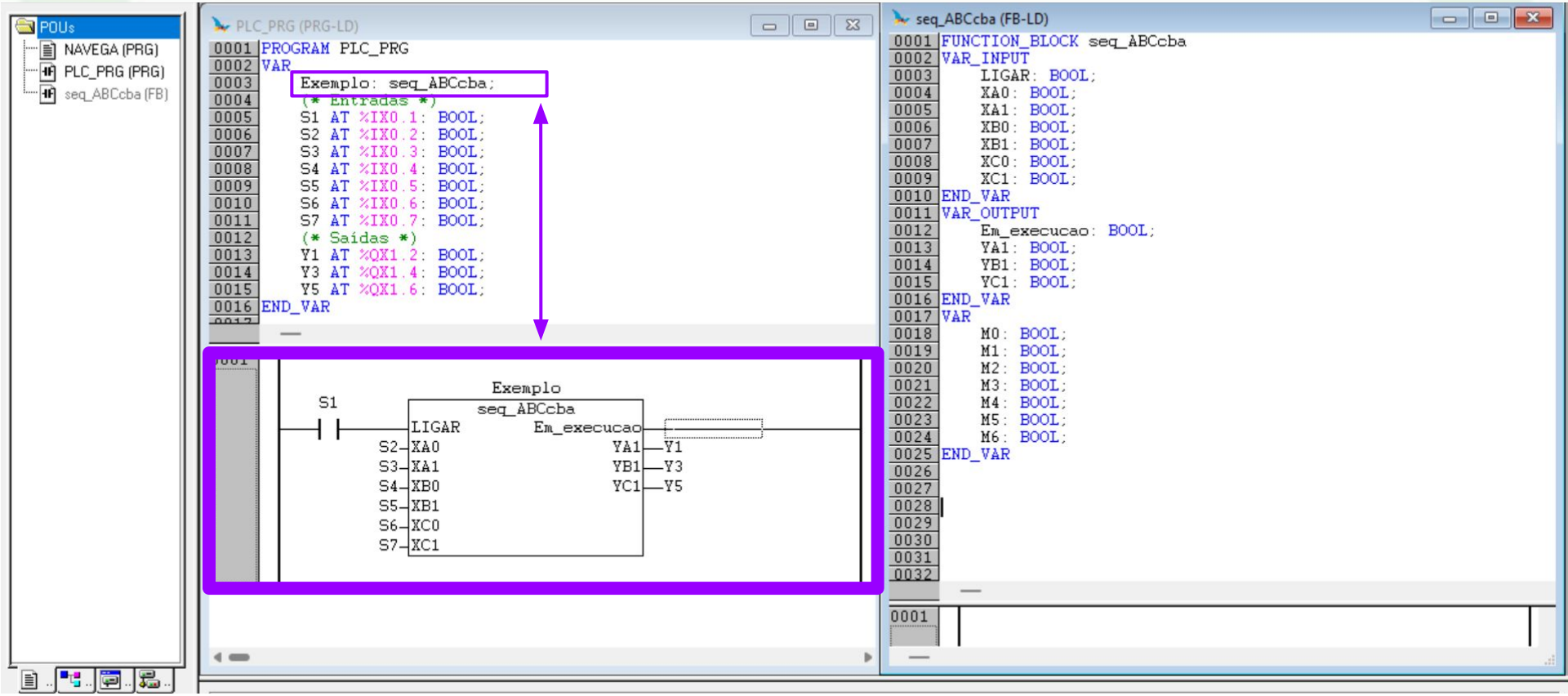
de acordo com o diagrama



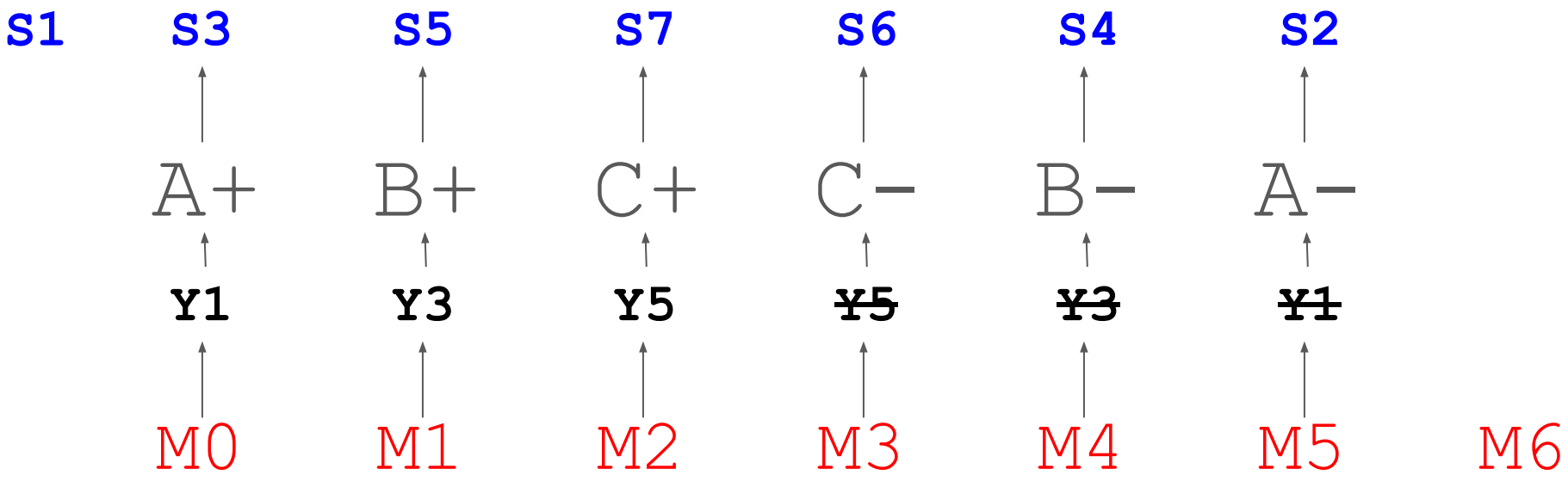
Declaração de interface do Bloco Funcional da Sequência



Inserir → Bloco Funcional… → FB def. pelo usuário



Passo 2: Para cada movimento, uma memória, +1



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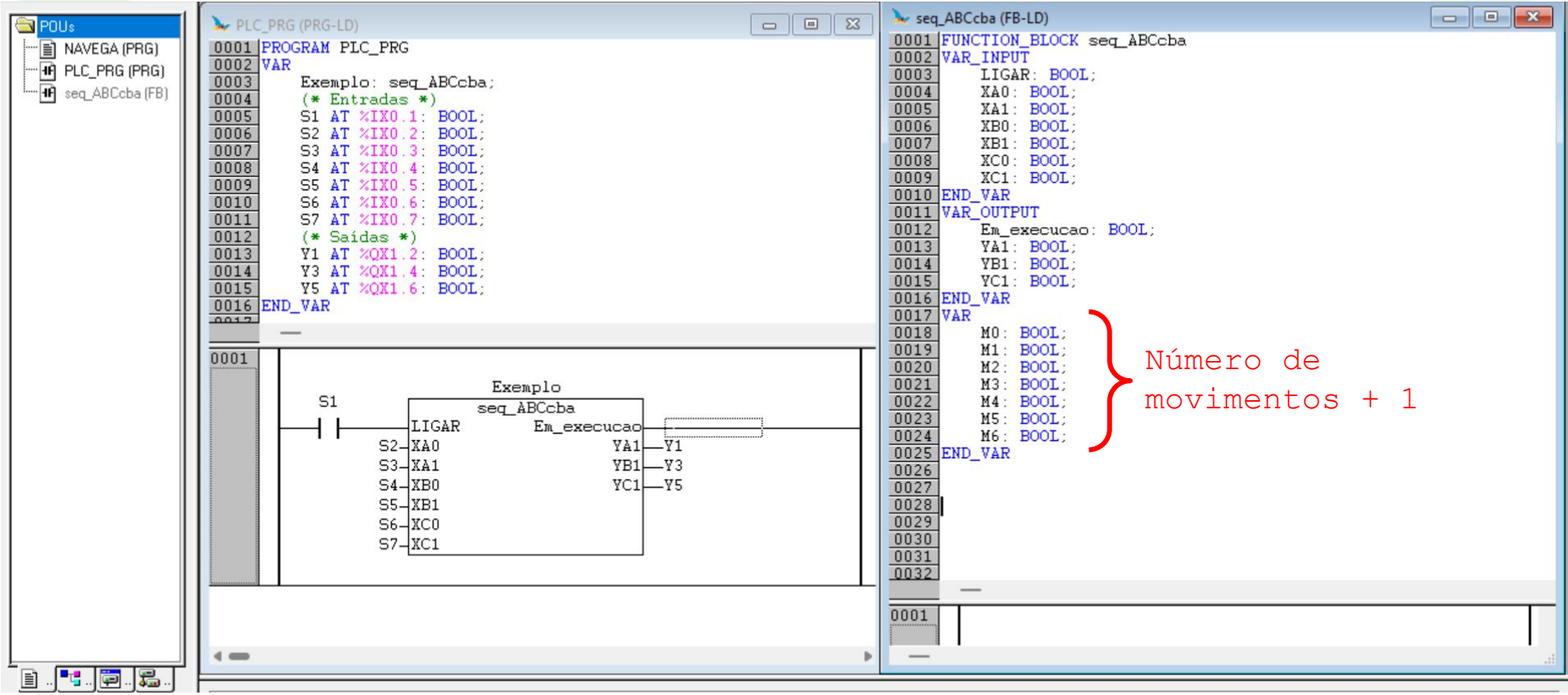
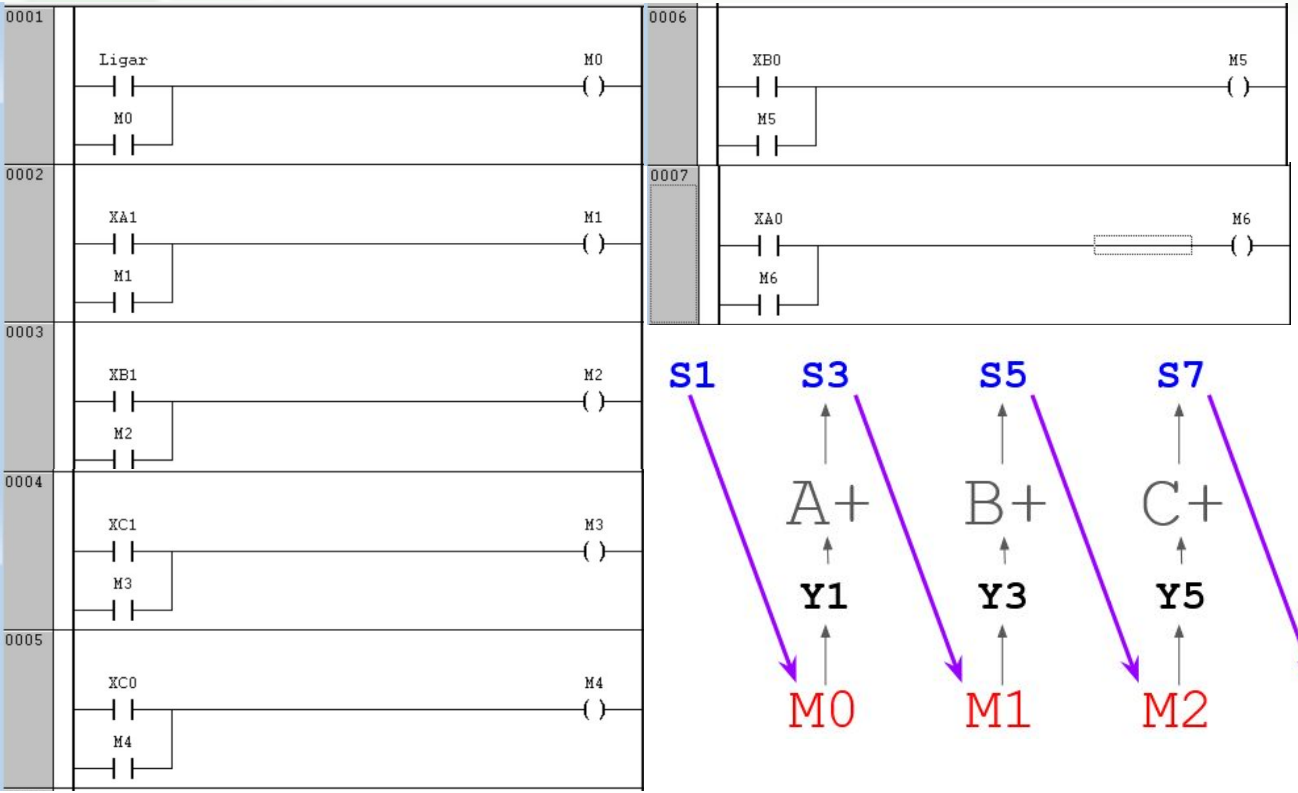
Passo 2: Para cada movimento, uma memória, +1



Passo 3: Acionamento das memórias



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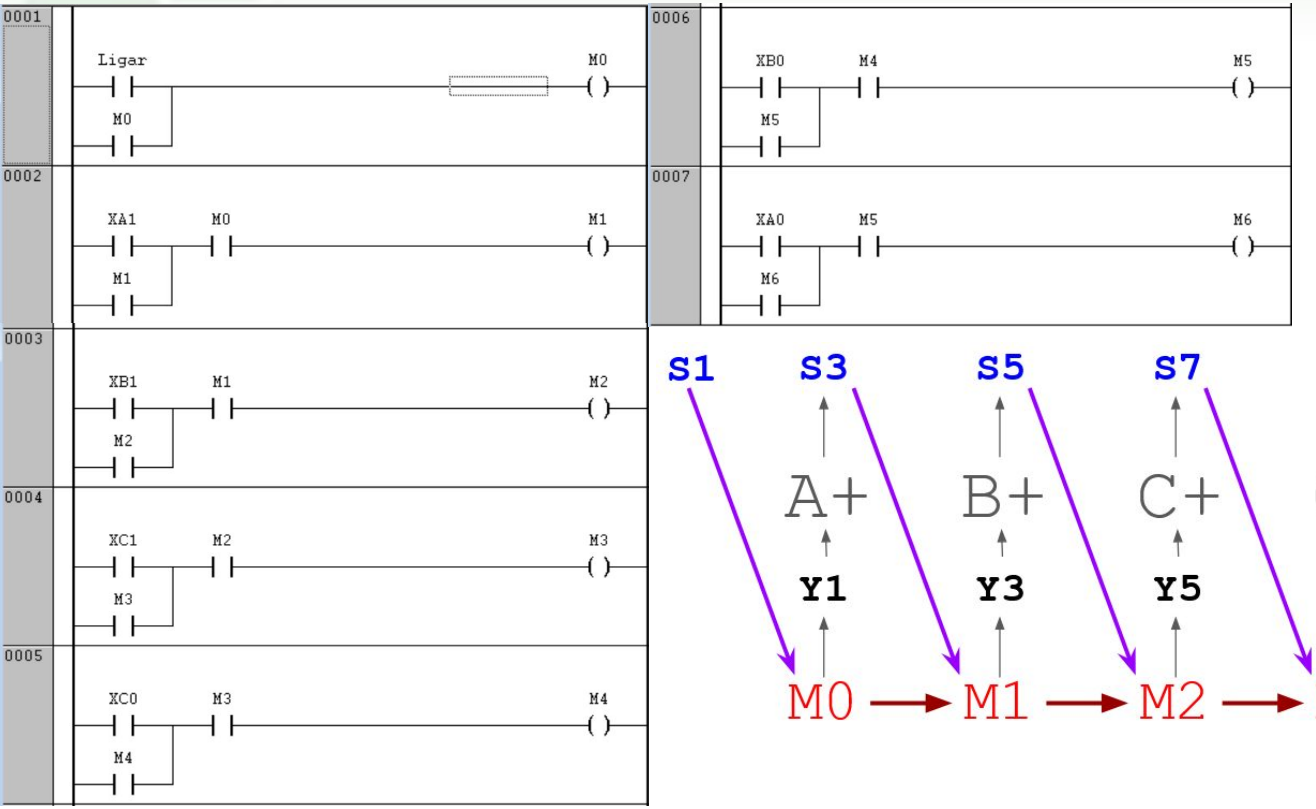
Passo 4: Habilitação das Memórias



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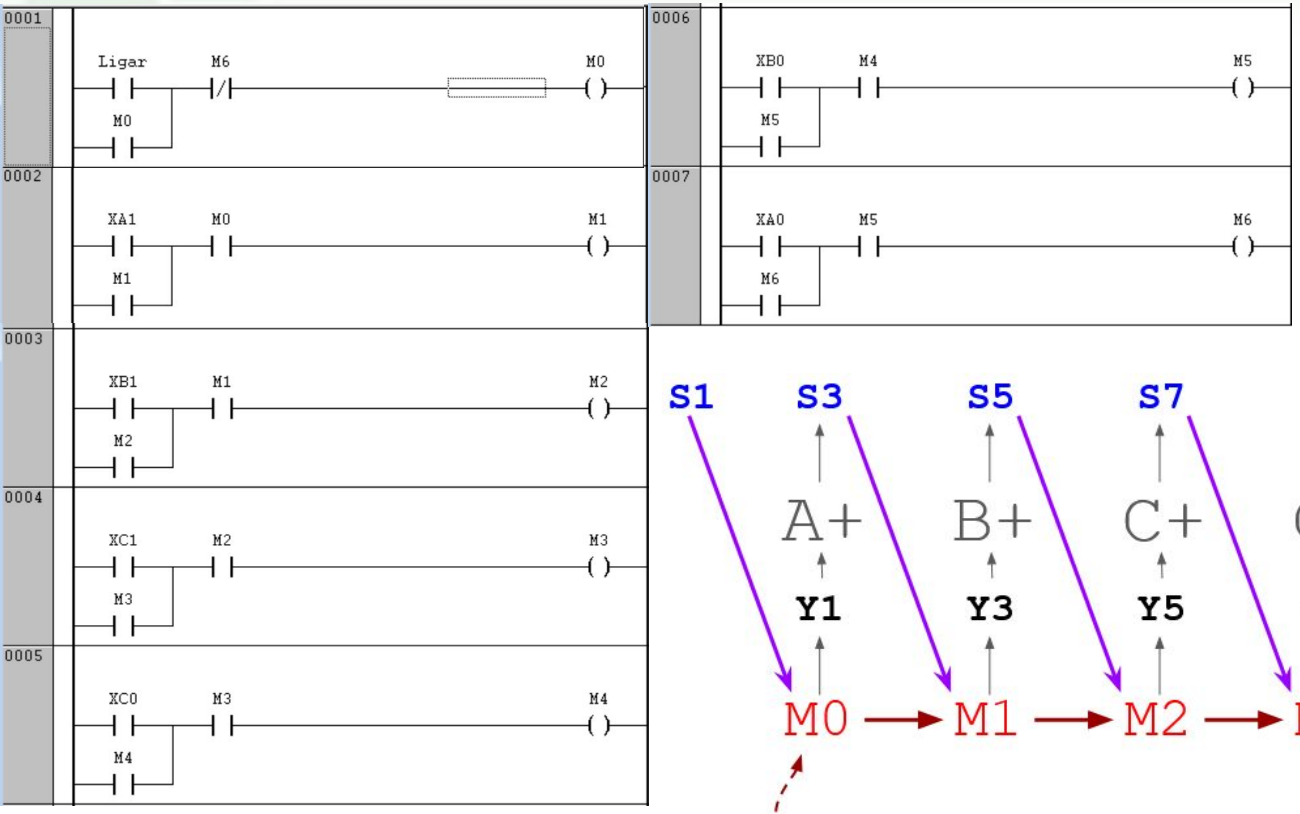
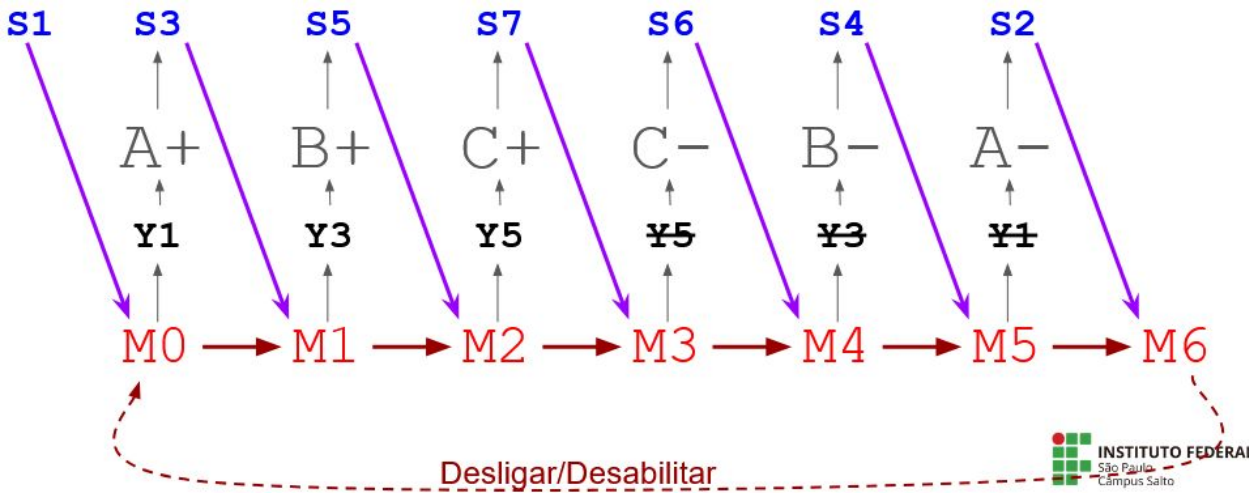
Passo 5: Desabilitação das Memórias





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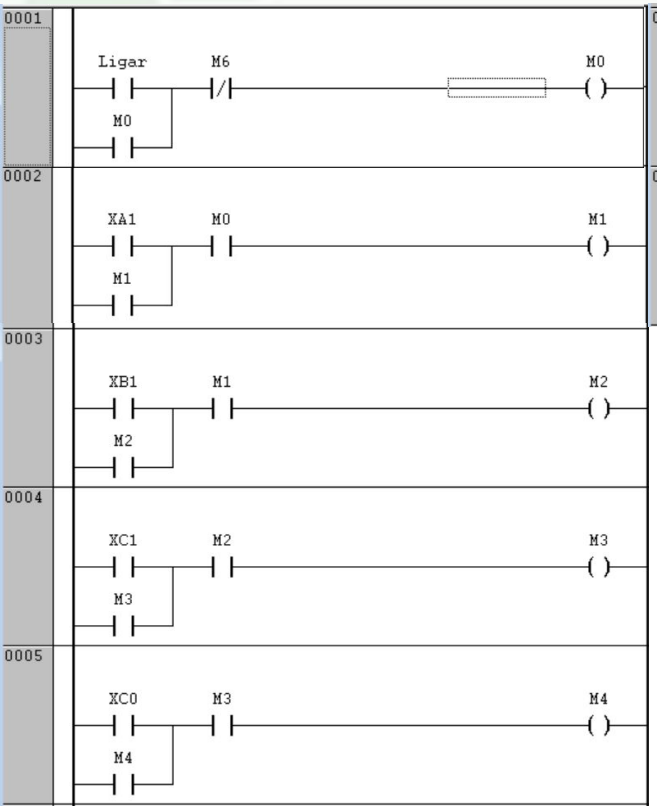
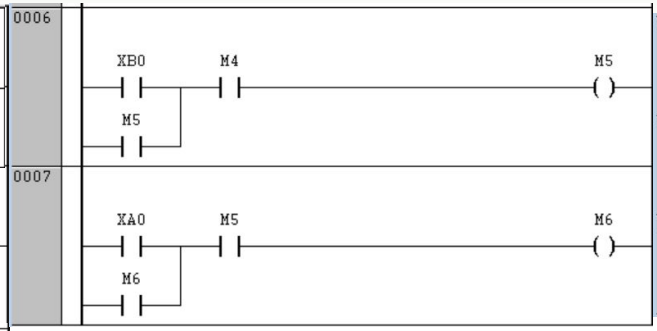
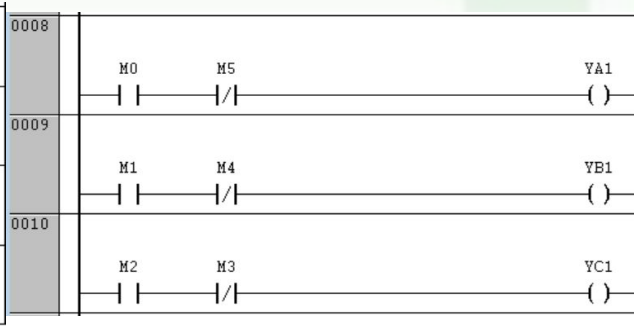
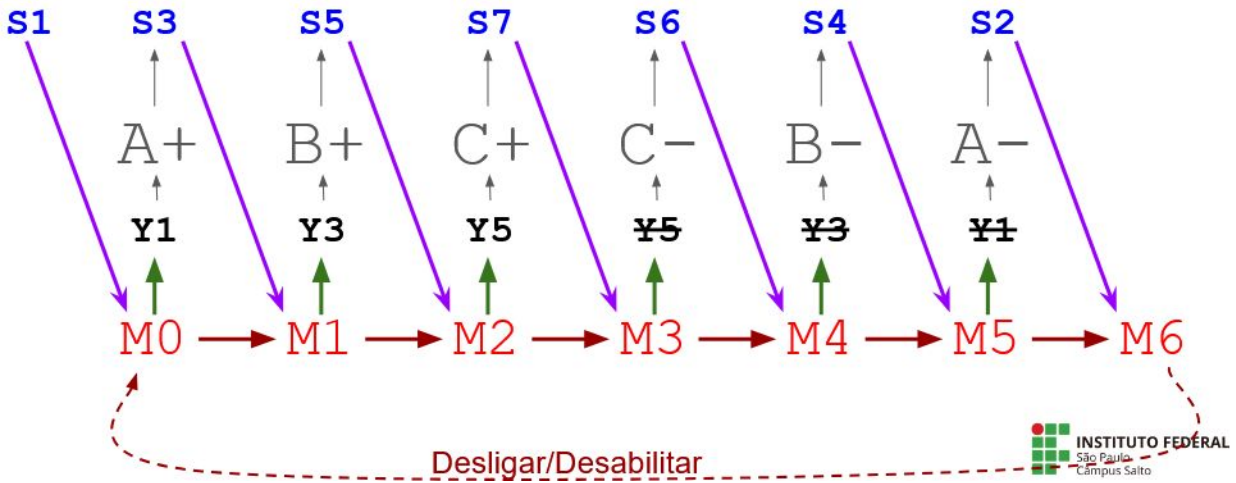
Passo 6: **Acionamento** de Saídas









Exercícios

Aplicar o método de Maximização de contatos, para produzir as seguintes sequências de acionamento:

1) A+ C+ C- B+ A- B-

2) A+ A- B+ B- C+ C-

3) A+ C+ [A- B+] B- C-

4) C+ B+ B- A+ C- B+ B- A-

Obs.: [A- B+]: Movimentos simultâneos