



















Sorting / PLC_1 [CPU 314C-2 PN/DP]

PLC tags

	Name	Data type	Address	Retain	Access- ible from HMI/O PC UA	Writa- ble from HMI/O PC UA	Visi- ble in HMI engi- neer- ing	Supervision	Comment
	Raise Stopper	Bool	%I0.2		True	True	True		
	Magazin Level	Bool	%I0.3		True	True	True		
	Start of Belt	Bool	%I1.3		True	True	True		
	End of belt	Bool	%I1.4		True	True	True		
	Start Button	Bool	%I2.2		True	True	True		
	Reset	Bool	%I3.1		True	True	True		
	Lower Stopper	Bool	%Q0.0		True	True	True		
	Sort	Bool	%Q0.2		True	True	True		
	Forward	Bool	%Q1.0		True	True	True		
	Backward	Bool	%Q1.1		True	True	True		
	Inching Mode	Bool	%Q1.2		True	True	True		
	Start Done	Bool	%M1.0		True	True	True		
	Reached stopper	Bool	%M1.1		True	True	True		
	Loaded	Bool	%M1.2		True	True	True		
	Flipflop	Bool	%M1.3		True	True	True		
	Flip Flop 2	Bool	%M1.4		True	True	True		
	flip flop 3	Bool	%M1.5		True	True	True		
	sort start	Bool	%M1.6		True	True	True		