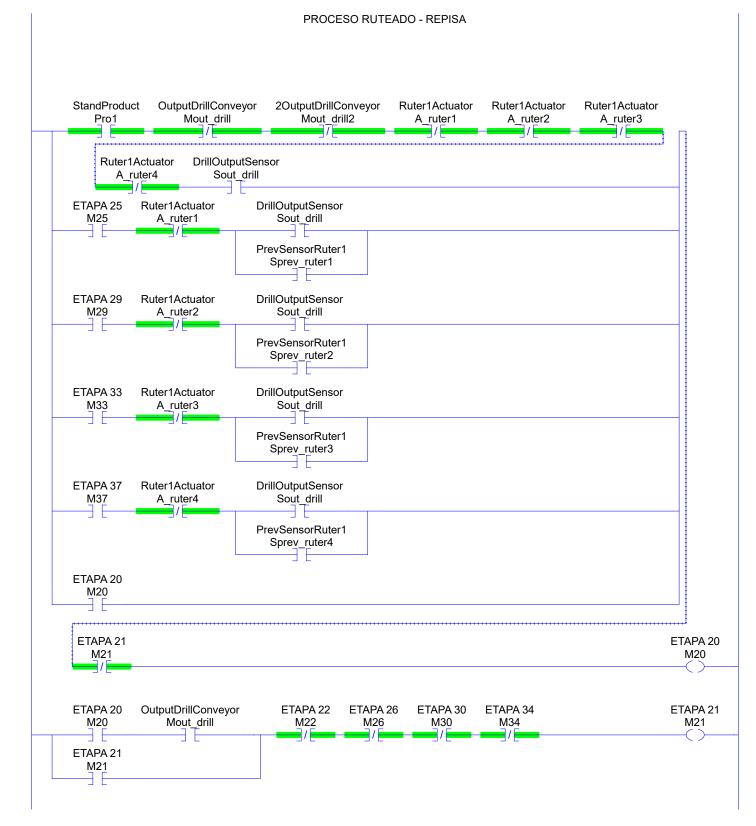


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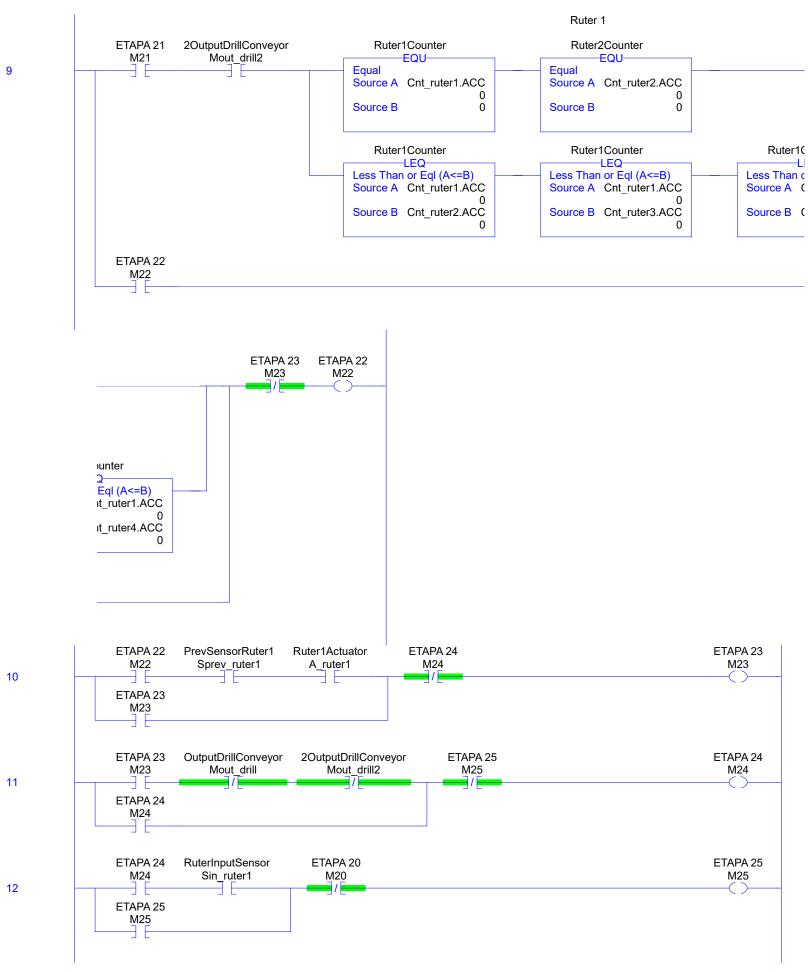


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Total number of rungs in routine: 139 C:\Users\LucasTheKitten\Downloads\Programa PLC Fisico2.ACD



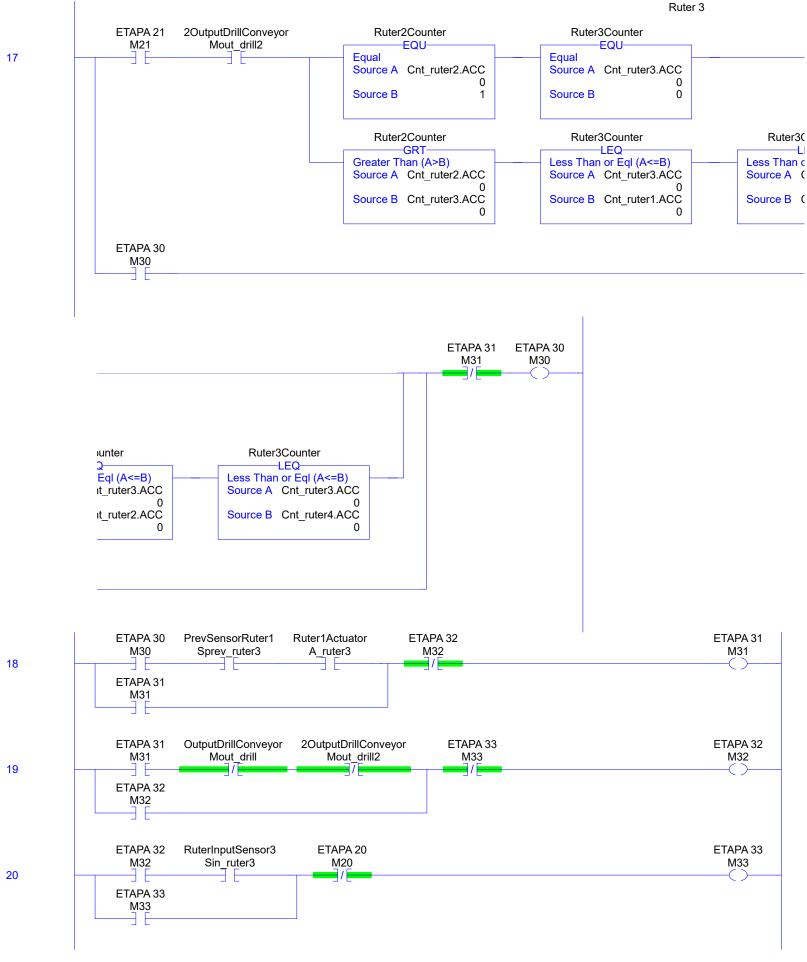
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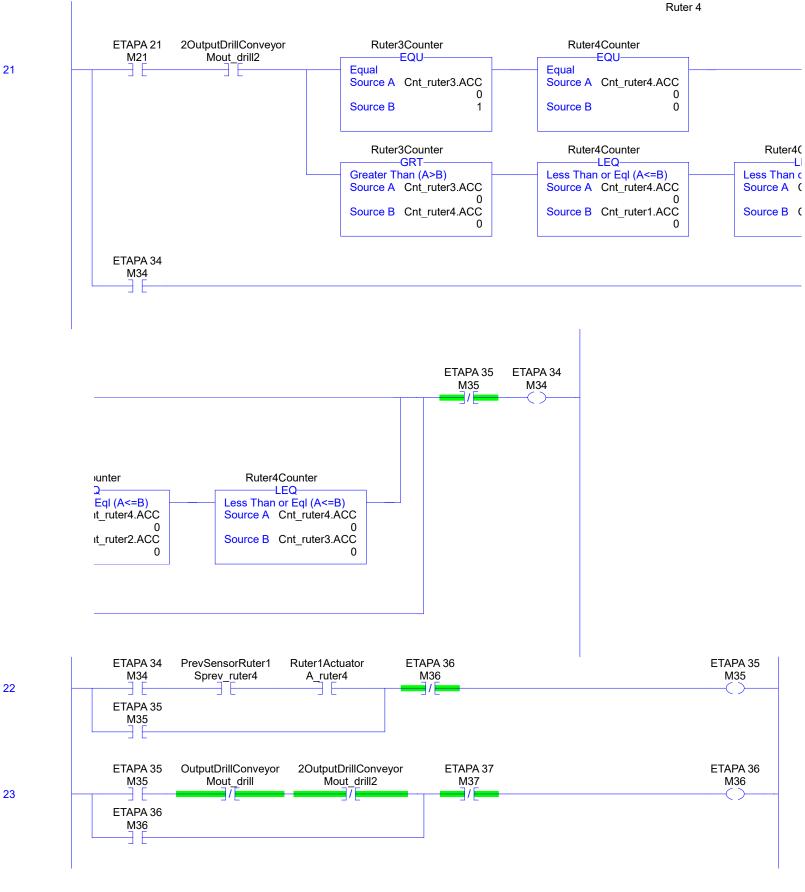
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Ruter 2 ETAPA 21 2OutputDrillConveyor Ruter1Counter Ruter2Counter . Mout_drill2 M21 -EQU -EQU-13 Equal Equal Source A Cnt_ruter1.ACC Source A Cnt_ruter2.ACC Source B Source B 1 0 Ruter1Counter Ruter2Counter Ruter20 -GRT -LEQ -11 Less Than c Greater Than (A>B) Less Than or Eql (A<=B) Source A Cnt_ruter1.ACC Source A Cnt_ruter2.ACC Source A (Source B Cnt_ruter2.ACC Source B Cnt_ruter1.ACC Source B (ETAPA 26 M26 ETAPA 27 ETAPA 26 M27 M26 Ruter2Counter ounter -LEQ-Eql (A<=B) Less Than or Eql (A<=B) ıt_ruter2.ACC Source A Cnt_ruter2.ACC ıt ruter3.ACC Source B Cnt ruter4.ACC 0 ETAPA 27 ETAPA 26 PrevSensorRuter1 Ruter1Actuator ETAPA 28 Sprev_ruter2 A_ruter2 M28 M27 M26 14 ETAPA 27 M27 ETAPA 27 OutputDrillConveyor 2OutputDrillConveyor ETAPA 29 ETAPA 28 Mout drill Mout drill2 M29 M28 M27 15 ETAPA 28 M28 ETAPA 28 RuterInputSensor2 ETAPA 20 ETAPA 29 M28 Sin ruter2 M20 M29 16 ETAPA 29 M29

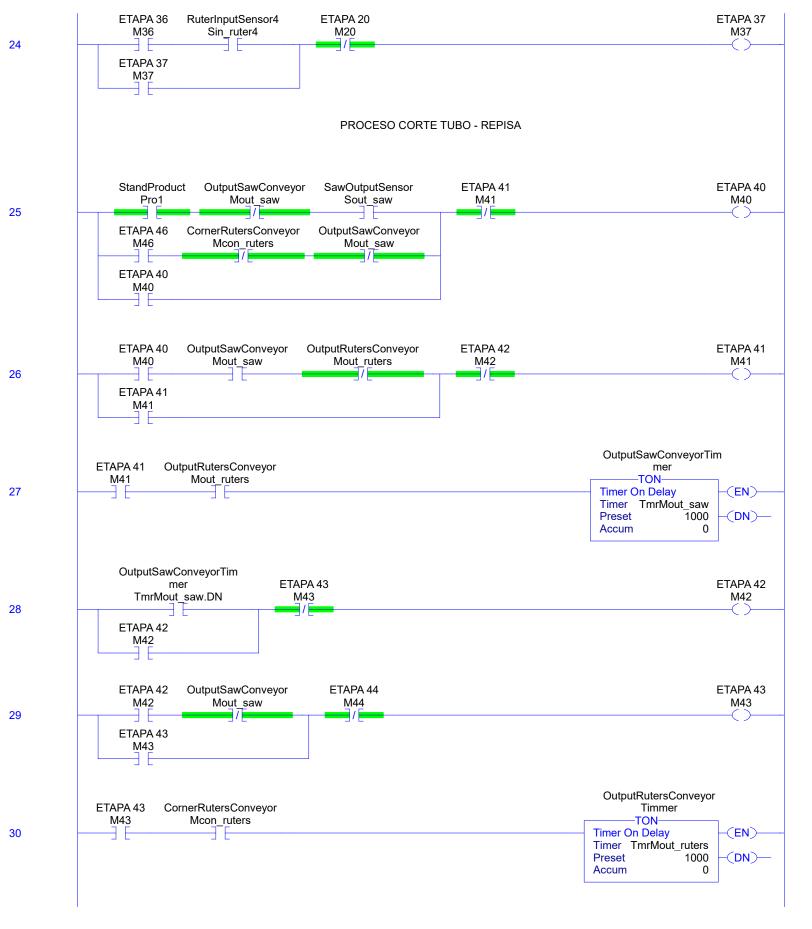
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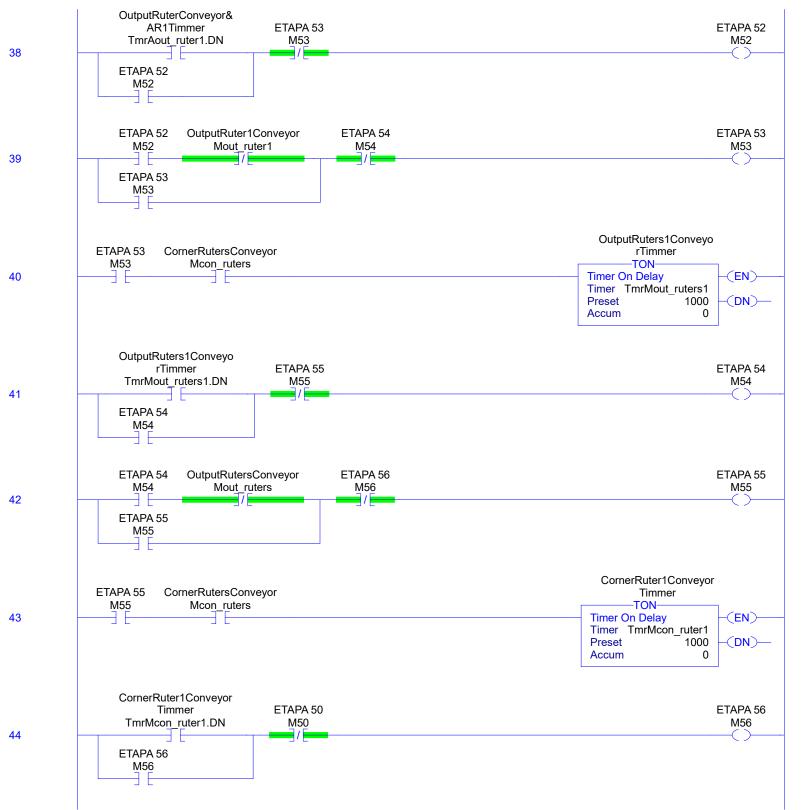


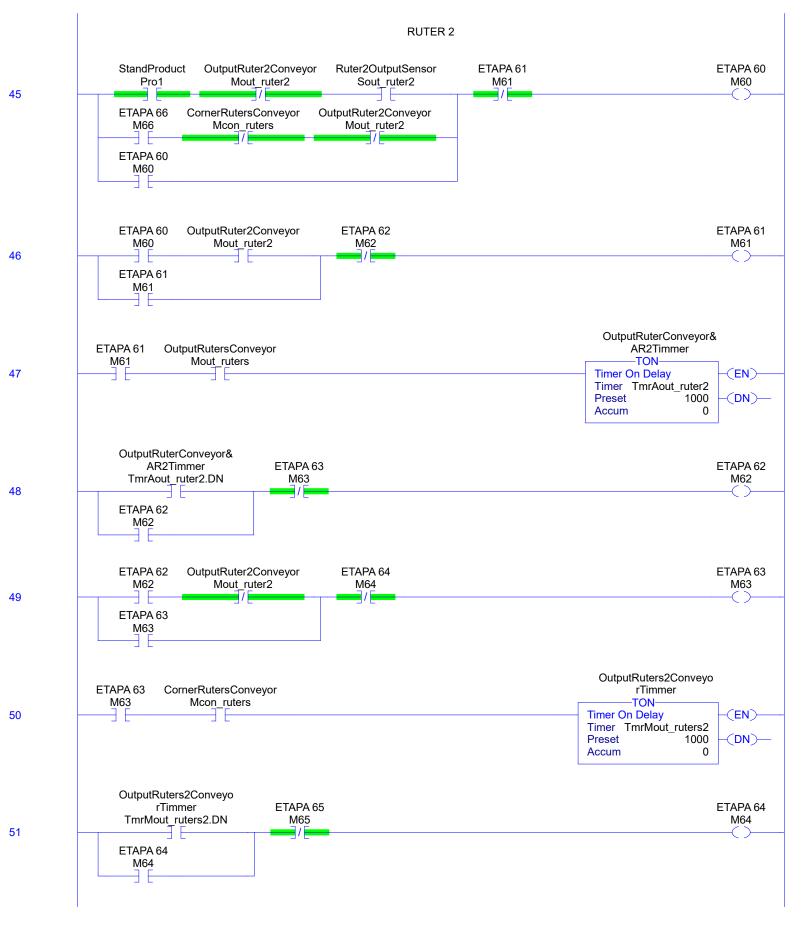
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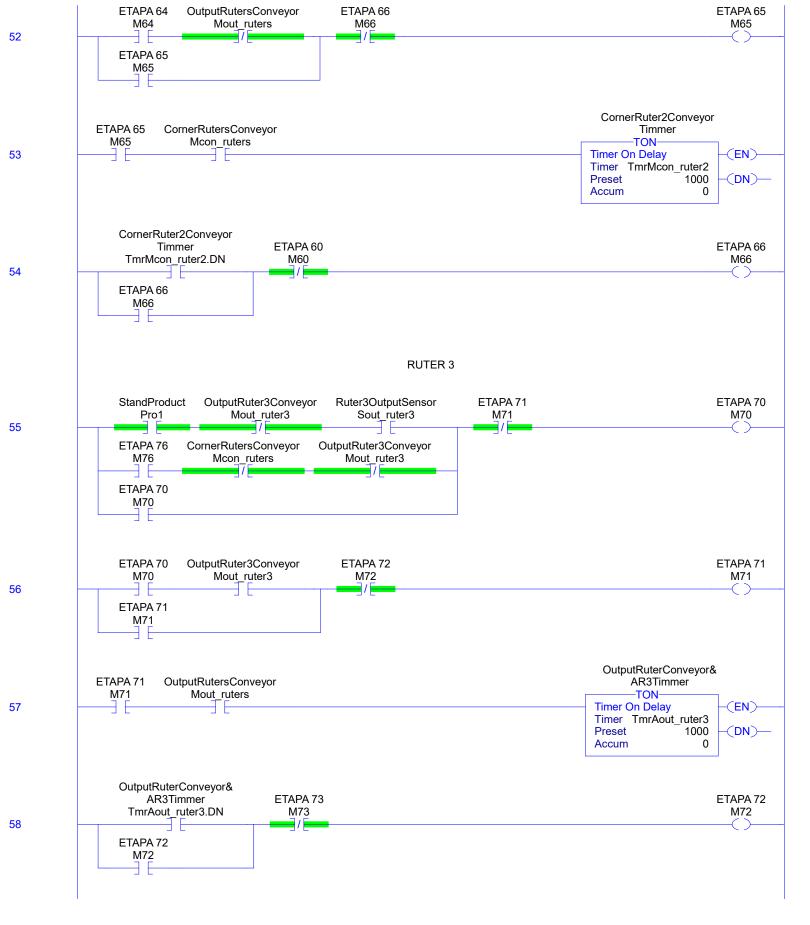
Total number of rungs in routine: 139 C:\Users\LucasTheKitten\Downloads\Programa PLC Fisico2.ACD OutputRutersConveyor ETAPA 45 ETAPA 44 Timmer M44 TmrMout ruters.DN M45 31 ETAPA 44 M44 ETAPA 44 OutputRutersConveyor ETAPA 46 ETAPA 45 M44 Mout_ruters M46 M45 32 ETAPA 45 M45 CornerRuterConveyor ETAPA 45 InputCeldaConveyor Timmer M45 Min_celda TON-33 Timer On Delay $\langle \mathsf{EN} \rangle$ Timer TmrMcon ruter Preset 1000 (DN) Accum 0 CornerRuterConveyor Timmer ETAPA 40 ETAPA 46 TmrMcon_ruter.DN M40 M46 34 ETAPA 46 M46 SALIDA PROCESO RUTEADO - REPISA **RUTER 1** ETAPA 50 StandProduct OutputRuter1Conveyor Ruter1OutputSensor ETAPA 51 Pro1 Mout_ruter1 Sout_ruter1 M51 M50 35 ETAPA 56 CornerRutersConveyor OutputRuter1Conveyor M56 Mcon ruters Mout ruter1 **-** / | ETAPA 50 M50 ETAPA 51 ETAPA 50 OutputRuter1Conveyor ETAPA 52 M52 M50 Mout_ruter1 M51 36 ETAPA 51 M51 OutputRuterConveyor& AR1Timmer ETAPA 51 OutputRutersConveyor M51 Mout ruters -TON-37 Timer On Delay (EN)Timer TmrAout ruter1 1000 (DN) Preset Accum 0

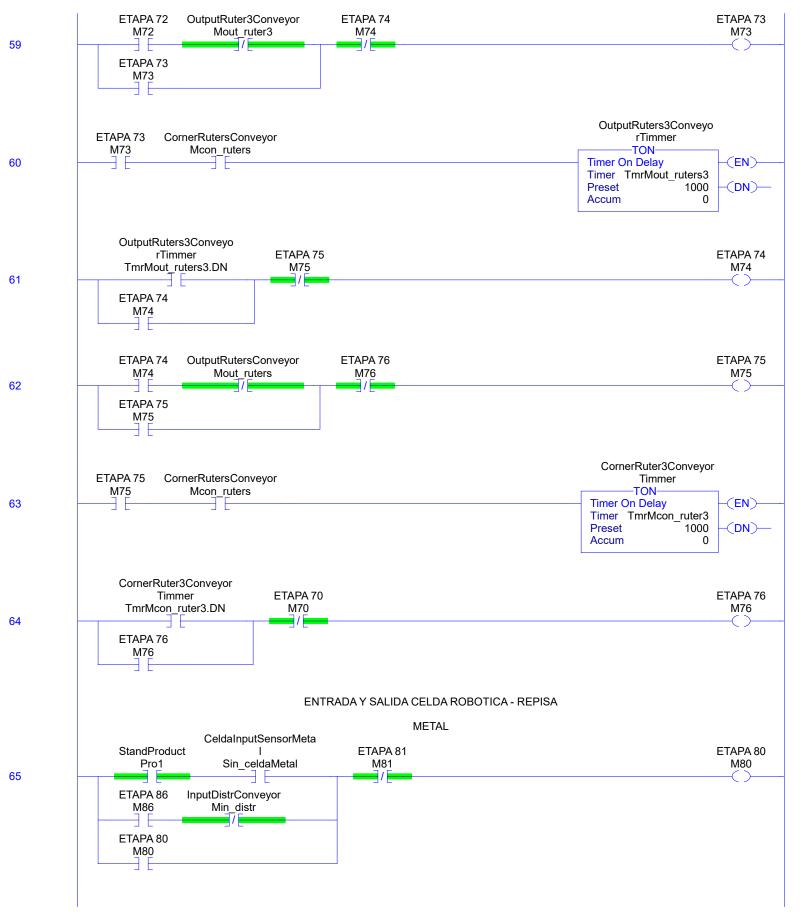




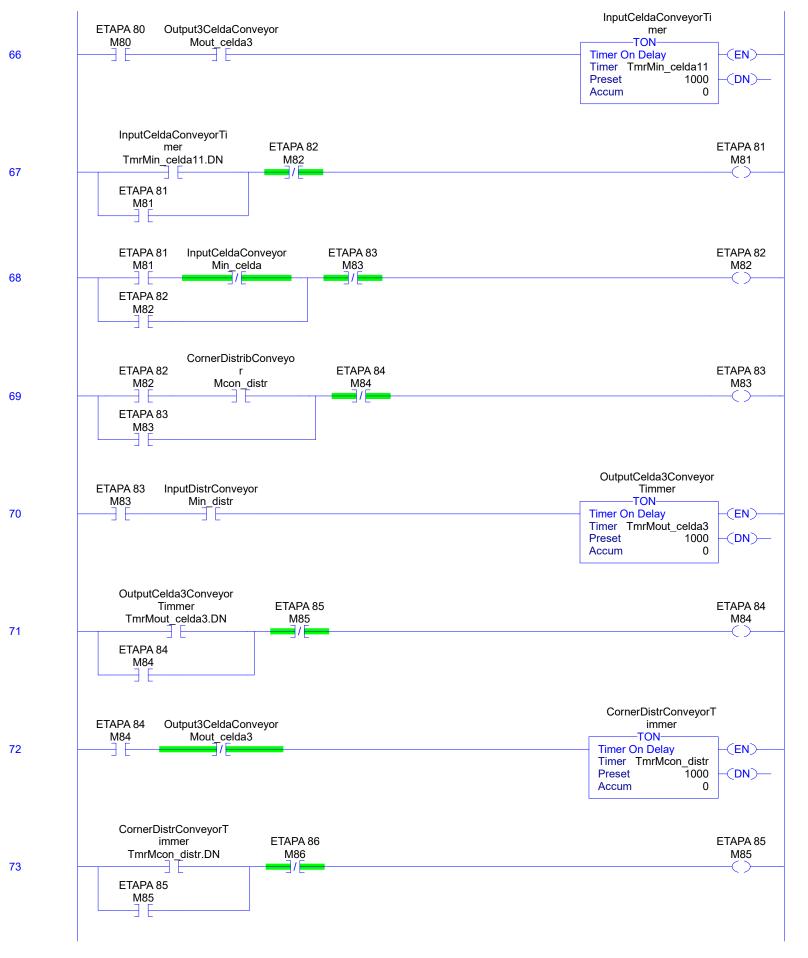
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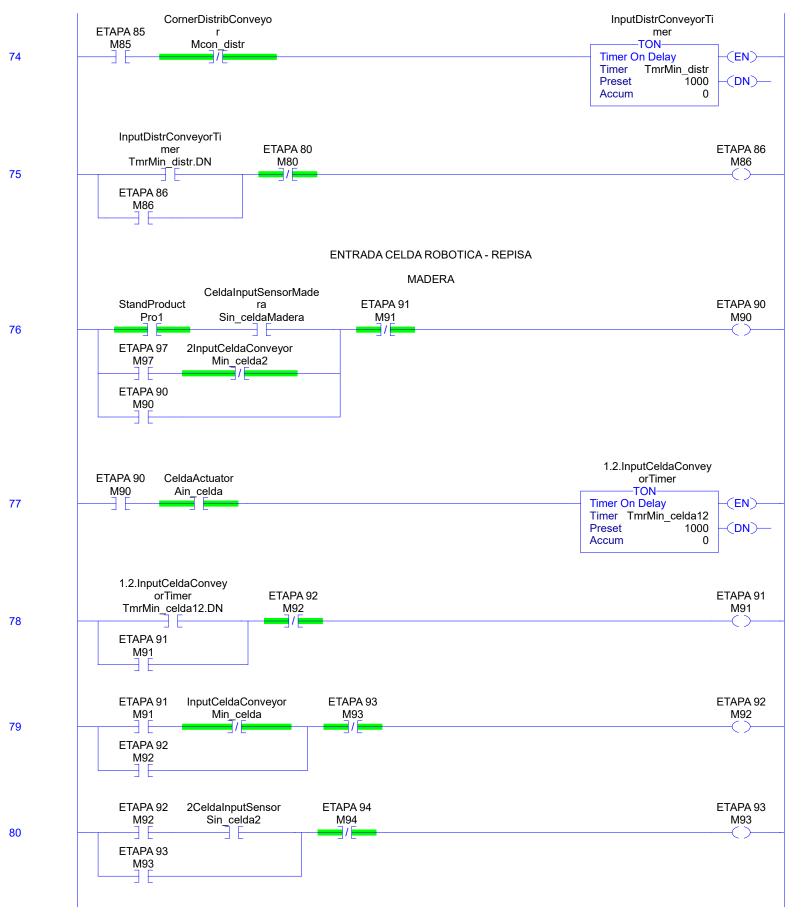


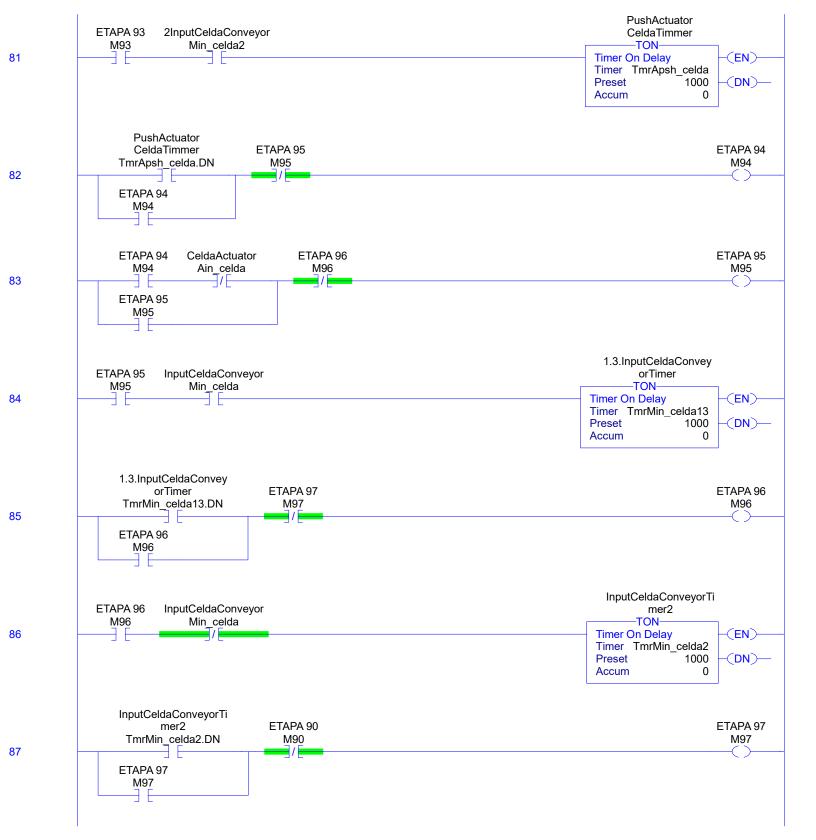


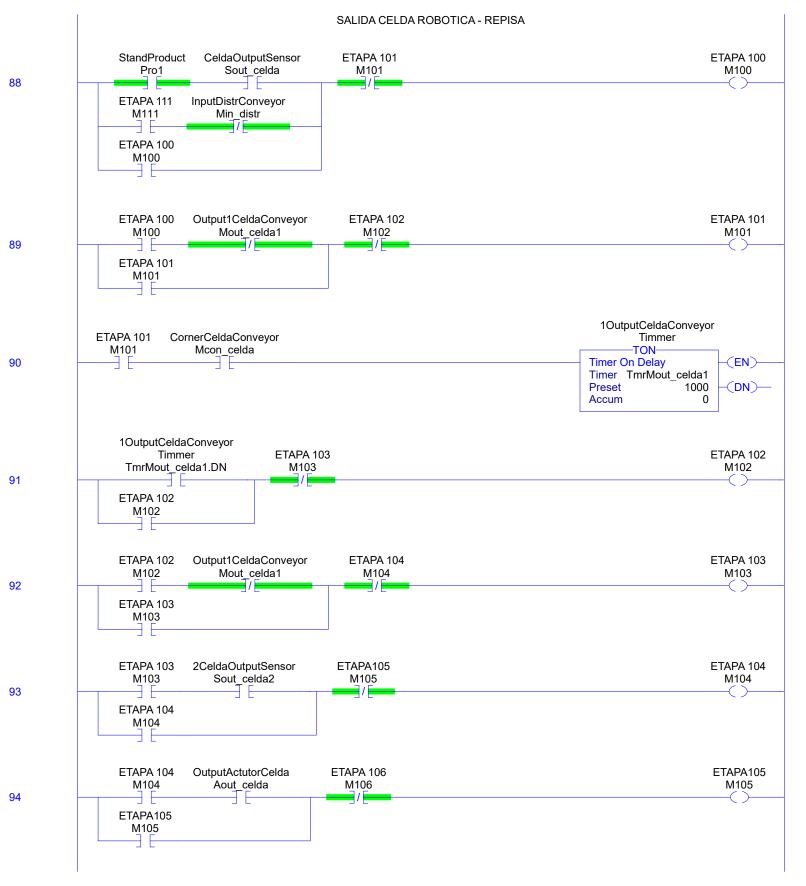
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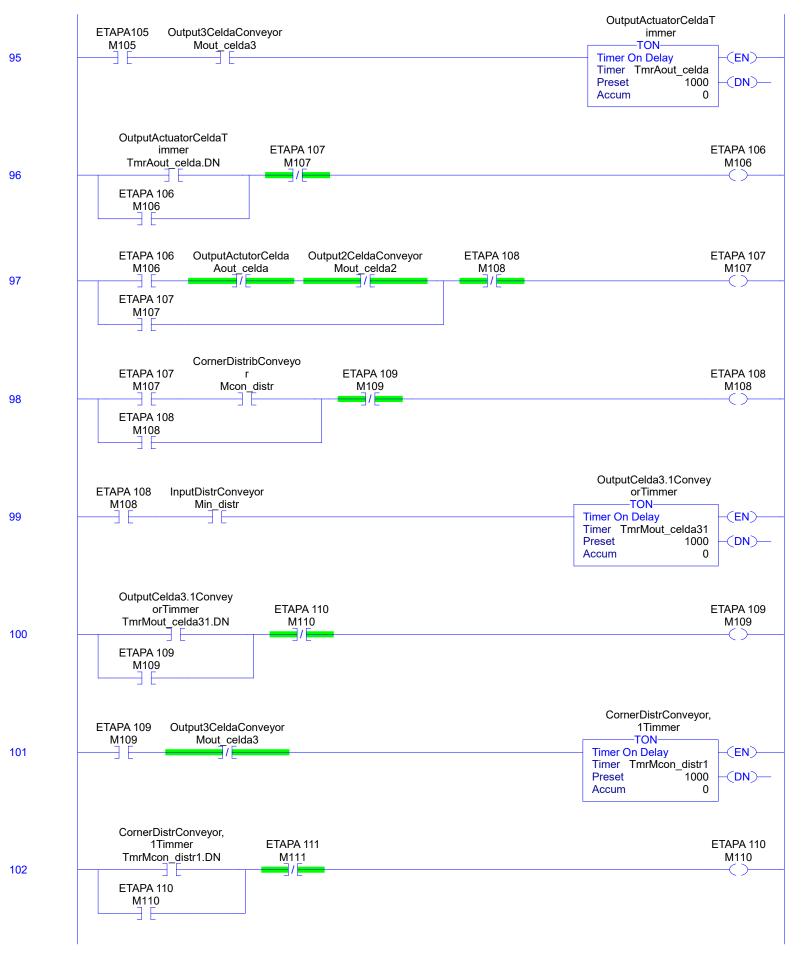


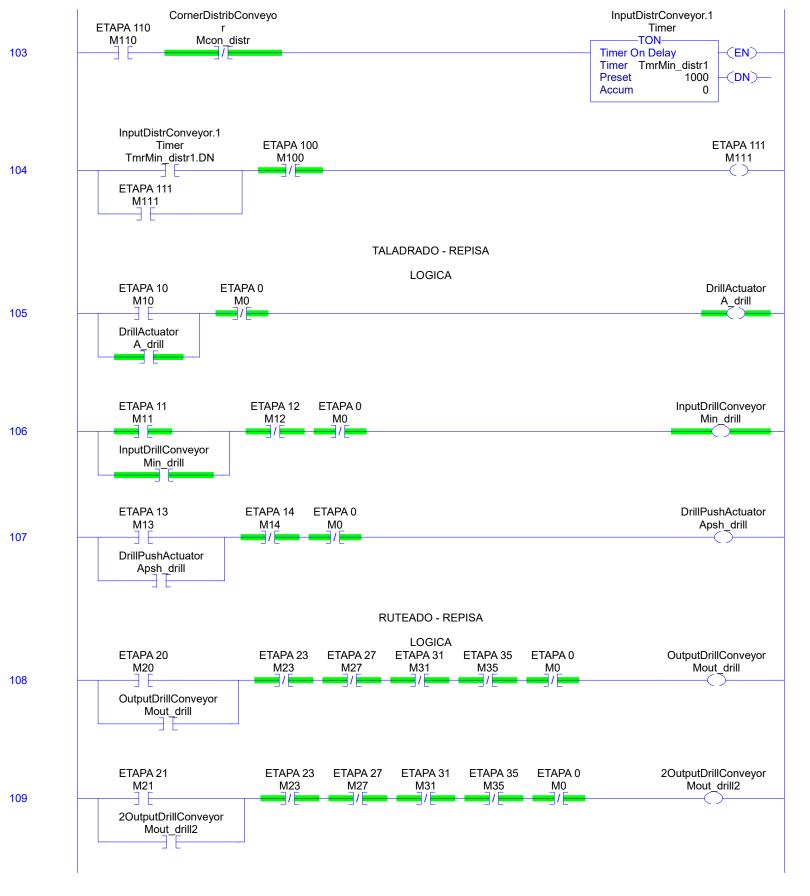
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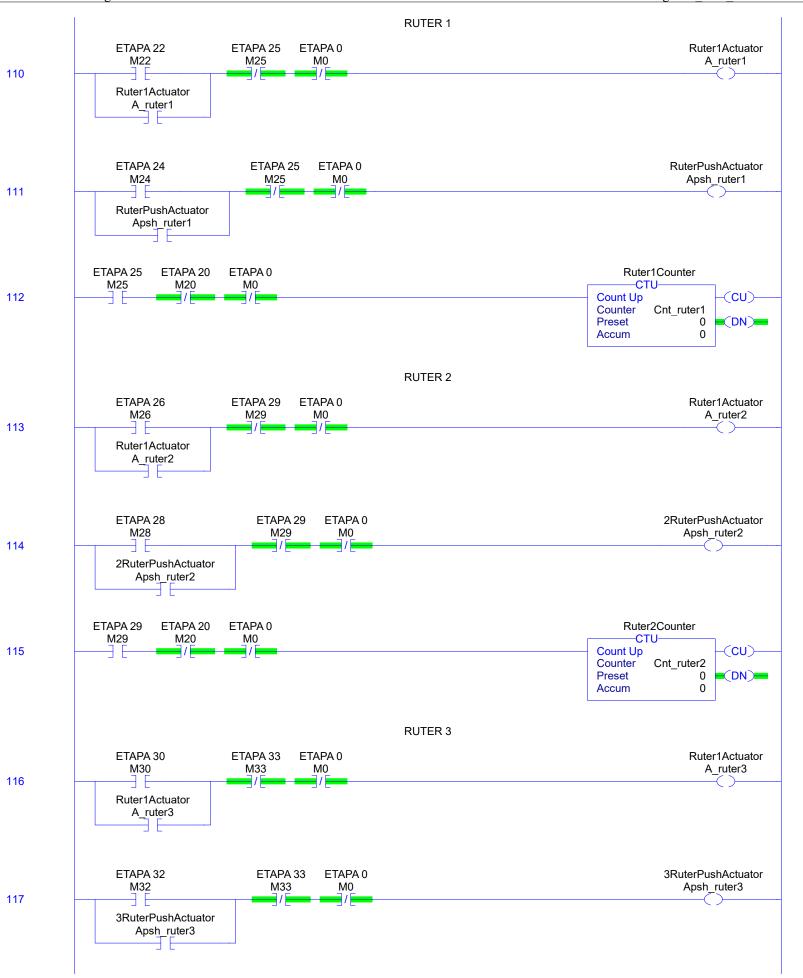


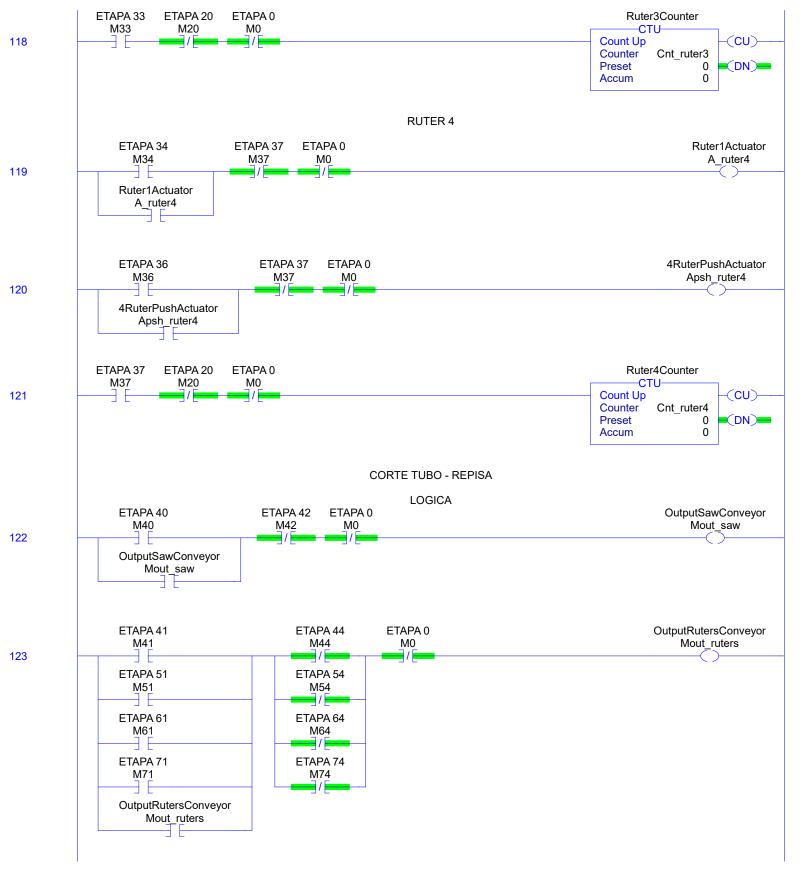


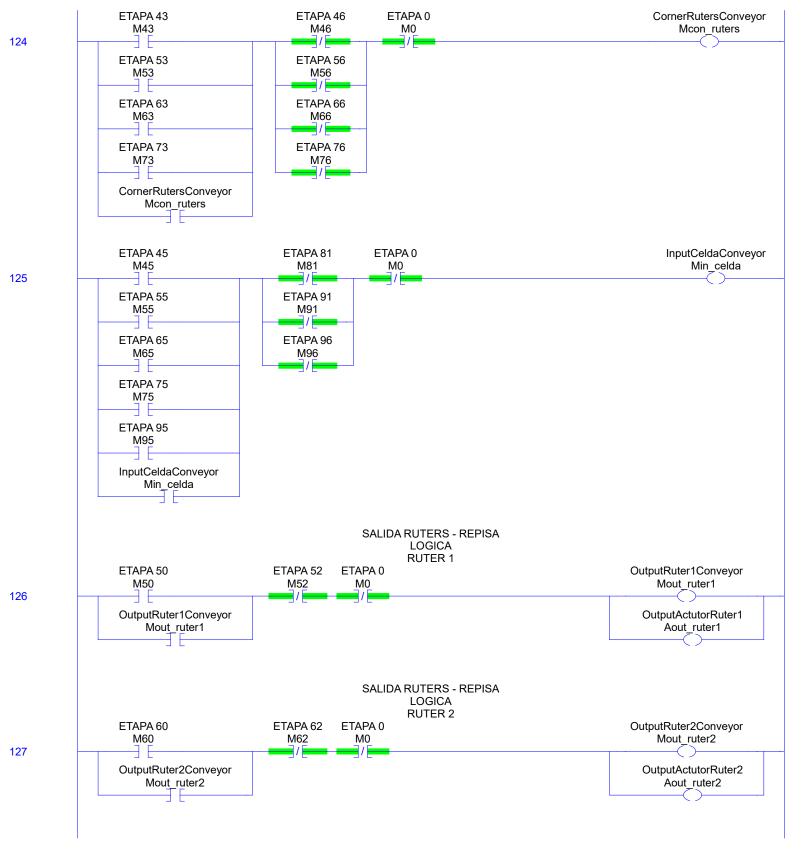


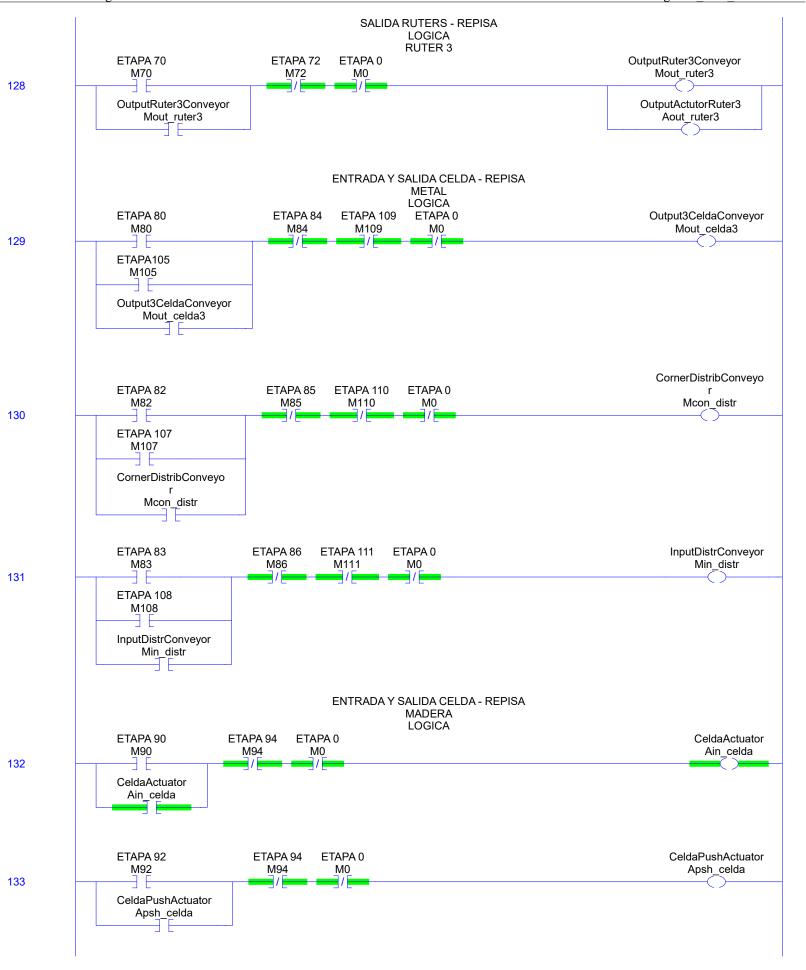












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