Totally Integ Automation								
Automat	ed Warehouse Tr	abajo_V1	6 / PLC	_1 [CPU 121	1C DC/DC/	DC] / Bloques de	programa	
Main [OB1]							
Main Duaniada	J.,							
Main Propiedad General	aes							
Nombre	Main	Número	1		Tipo	ОВ	Idioma	KOP
Numeración	Automático	Numero	ı ı		Про	Ob	lulollia	KOI
Información	ratomatico							
Título	"Main Program Sweep (Cycle)"	Autor			Comentario		Familia	
Versión	0.1	ID personaliz do	za-					,
Main								
Nombre		Tipo de o	datos	Valor predet.		Comentario		
✓ Input		•		•		-		
Initial_Ca		Bool				Initial call of this OB		
Remaner		Bool				=True, if remanent data ar	e available	
Temp								
Constant								
Segmento 1	:		%FC9 "MHJ-PLC-Lab-Fu					
		-	EN .	ENO				
Segmento 2	:							

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Segmento 2: (1.1 / 3.1)

```
%l11.1 "Start"
                          %l11.3
"Tag_9"
                                                                                         %M10.0 "inicio"
                                                                                         %Q10.7
"Tag_32"
%M10.0 "inicio"
                                                                                          √ )——
%M10.0 "inicio"
                                                                                         %Q11.1
"Tag_33"
%I11.3
"Tag_9"
                                                                                        %M200.0 "E1"
                                                                                      -( RESET_BF )--
                                                                                            10
                                                                                       %M401.1
"seguridad"
                                                                                       %M402.2
"antirrebote"
                                                                                           _( R )____
%M10.0 "inicio"
                        %M200.3 "E4"
                                                                                        %M200.0 "E1"
                         %M30.0 "Tag_26"
                         %M60.1
"Tag_27"
                          %I11.1
                                                                                                                    2.1 ( Página1 - 3)
```

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gmento 2: (2.1 / 3.1)							I	
				1.1 (Página1	- 2)	 		
	"Start"							
%M10.0 "inicio"	%I10.1 "At Load"		%M200.1 "E2" —(S)———					
			%M200.0 "E1" ——(R)———					
%M10.0 "inicio"	%110.2 "At Left"		%M200.2 "E3" — (S)——					
%M10.0 "inicio"	%I11.0 %M44 "MovingZ" "segur N // %M400.0 "Tag_10"	idad"	%M200.3 "E4" —{ S }——					
%M10.0 "inicio"	%M200.3 "E4"		%M200.1 "E2" ——(R)———					
	%l1 "At Mi).3 ddle"	%M200.4 "E5" (S)———					
%M10.0 "inicio"	%M403.0 %M2 ("Tag_20" "E5	5" "MovingZ"	%I10.7 "MovingX"	%M402.2 "antirrebote"	%M200.5 "E6" (S)			
%M10.0 "inicio"	%M200.4 TO Tim "E5" IN T#15 — PT	er_O_DB"	%M403.0 "Tag_20"					
	~~~~~	~~~~~	~~~~	3.1 ( Página1	- 4)	 ~~~~~	~~~~	~~~~

ento 2: (3.1 / 3.1	)					
	····	~··~··		2.1 ( Página1 - 3)	~~~~	 
<b>%M10.0</b> "inicio"	<b>%M200.5</b> "E6"	% <b>I10.4</b> "At Right"	%M200.6 "E7" ( S }			
			%M200.2 "E3" ———( R )———1			
			%M402.2 "antirrebote"			
<b>%M10.0</b> "inicio"	%M200.6 "E7"	%I11.0 "MovingZ" N   %M400.4	%M200.7 "E9" ———{ S }———			
		"regreso derecho"	%M200.5 "E6" 			
%M10.0 "inicio"	<b>%M200.7</b> "E9"	%I10.3 "At Middle"	%M201.0 "E10" { S }			

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Segmento 3:	
	l

Sogmente 3: (1 1 / 2 1)				
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## Segmento 3: (1.1 / 2.1)

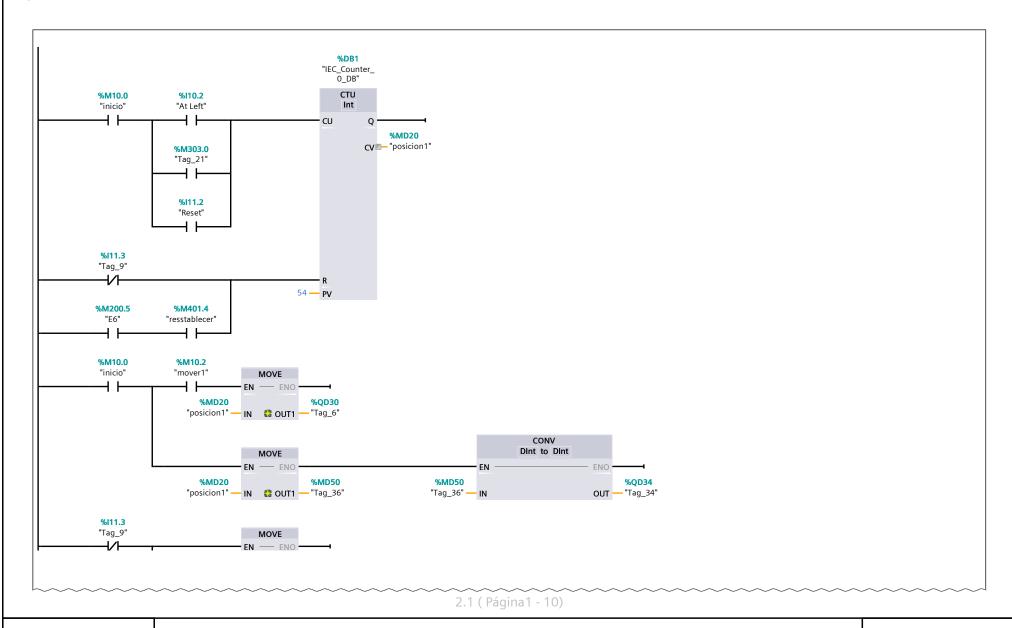
```
%M200.0 "E1"
                                                                      %Q10.0 "Tag_7"
                                                                      %Q10.1 "Tag_8"
                                                                      %M200.1 "E2"
                  %M401.1
"seguridad"
                                                                    %Q10.2
"Forsk Left"
                                                                      %M200.2 "E3"
                                                                      %Q10.4
"Lift"
                                                                      %M200.4 "E5"
                                                                      %M10.2
                                                                     "mover1"
                                                                       →
%M200.5 "E6"
                                                                   %Q10.3
"Forks Right"
                                                                      →
                                                                    %M401.1
"seguridad"
                                                                      _( s )____
                  %l10.7
"MovingX"
                                                                    %M401.1
"seguridad"
%M10.0
 "inicio"
                   N | %M401.2 "Tag_12"
                                                                      _( R )____
%M201.0
                                                                     %M10.6
 "E10"
                                                                    "Regresar1"
                                                                                          2.1 ( Página1 - 7)
```

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gmento 3: (2.1 / 2.1)		<b>_</b>
<u> </u>	1.1 ( Página1 - 6)	~~~~~~~~ ₁
%M10.6 "Regresar1"	%M200.0 "E1"  ( RESET_BF )→ 10	
	%M402.2 "antirrebote"	
	<b>%M30.2</b> "Tag_28"	
%MD20 "posicion1" "Tag_21"	%M401.4 "resstablecer"	
%M401.4 "resstablecer"		

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Segmento 4:	

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## Segmento 4: (1.1 / 2.1)



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egmento 4: (2.1 / 2.1)	1.1 ( Página1 - 9)	
%M10.6 "Regresar1"	55—IN %QD30	
%M401.4 "resstablecer"	"IEC_Timer_0_ DB_1"  "M200.5	

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Segmento 5:				
			1	
	1			