

250311_2_Njegovec_dipl / PLC_1 [CPU 1513-1 PN] / Program blocks / Sekvence

Okretni_stol_sekvenca [FB3]

Okretni_stol_sekvenca Properties					
General					
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Language	LAD	Numbering	Automatic		
Information					
Title		Author		Comment	
Family		Version	0.1	User-defined ID	

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Default value			
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Visible in HMI engineering			
Visible in HMI engineering			
Setpoint			
Setpoint			
Supervision			
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Supervision		Supervision	
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Comment			
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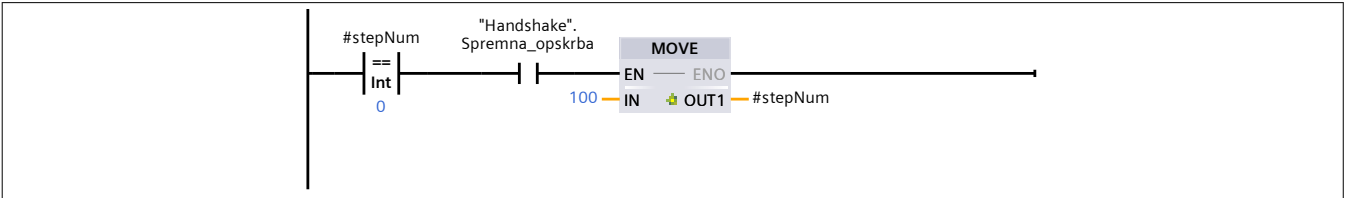
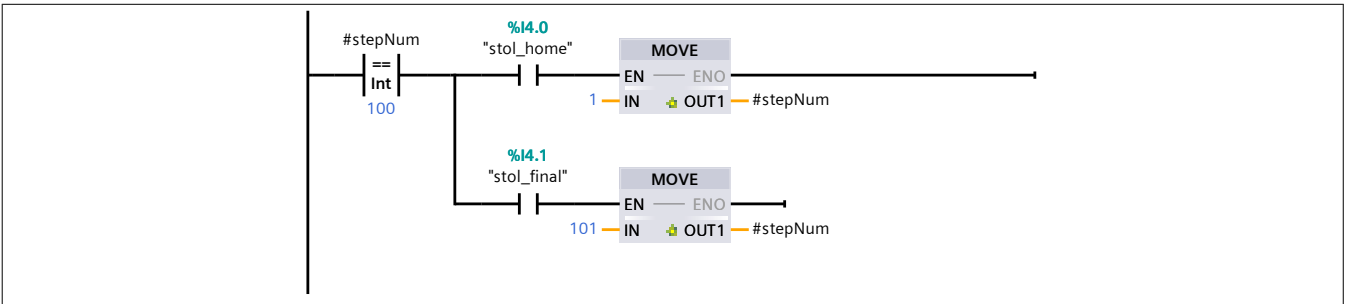
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Comment			
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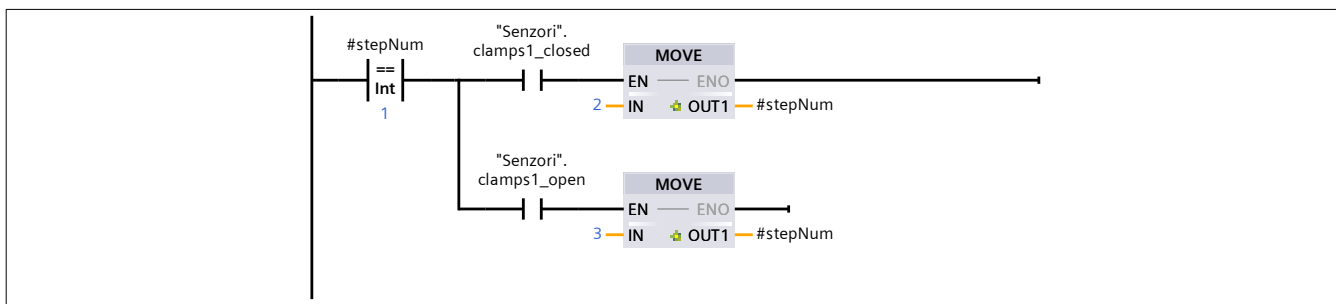
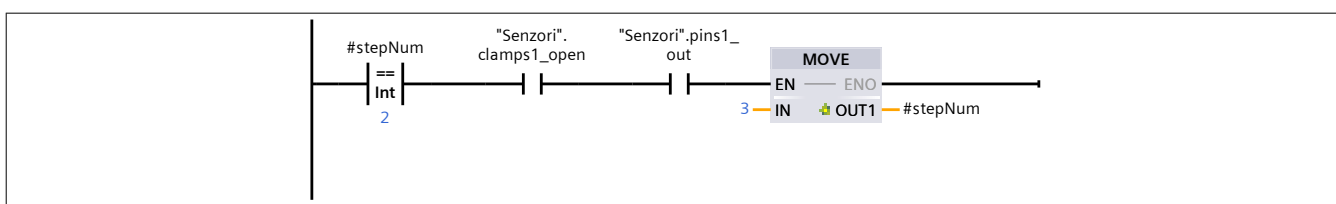
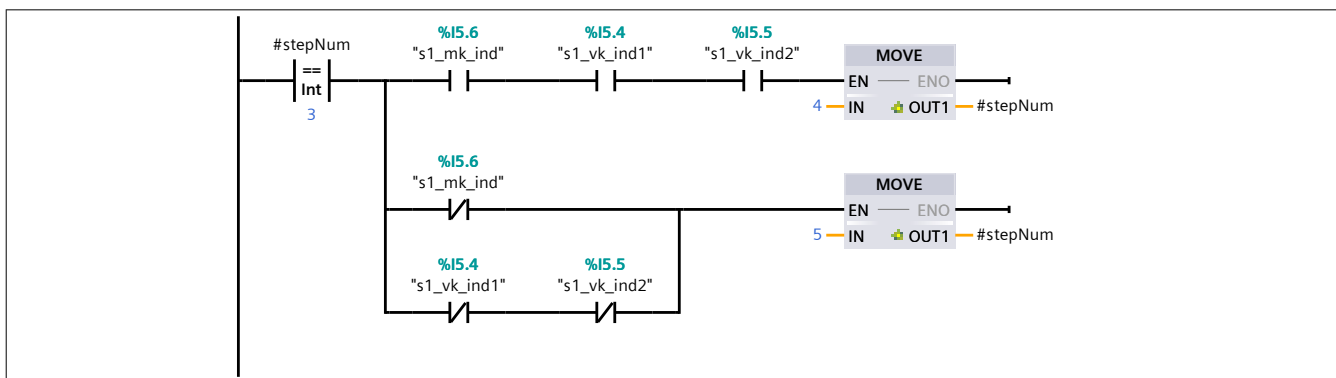
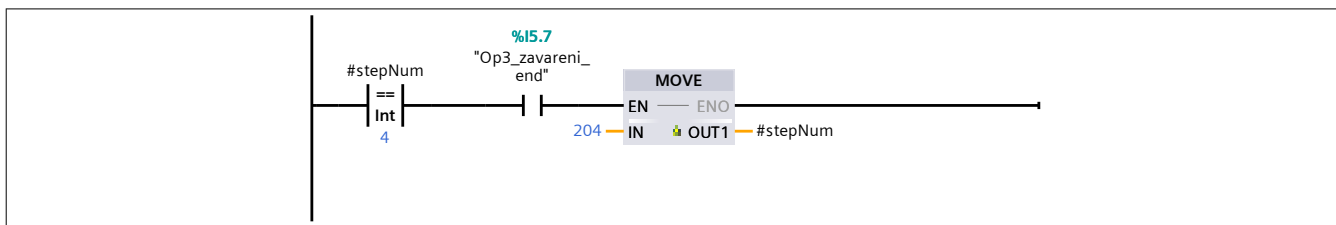
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Setpoint		
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Supervision		Supervision
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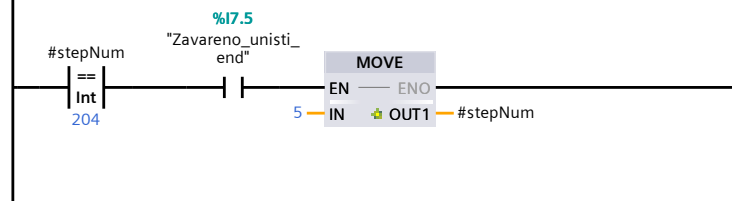
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Totally Integrated Automation Portal			
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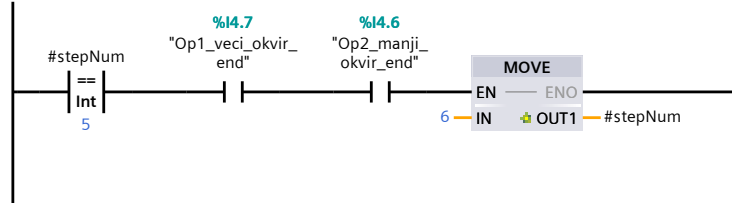
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Setpoint		
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Supervision		
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Supervision		Supervision
Comment		
Comment		
Network 1: Inicijalizacija sekvence		
		
Network 2: Automatika aktivna		
		
Network 3: KORACI: 1 - stol u početnoj poziciji, 101 - stol u okrenutoj poziciji		
Network 4: S0 - Početak sekvence		
		
Network 5: S100 - Pozicija okretnog stola		
		

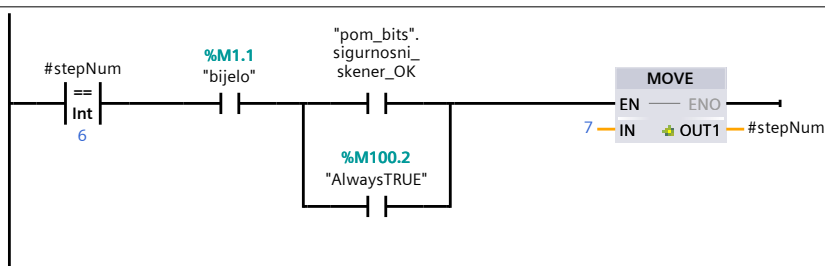
Network 6: S1 - Status stezaljki**Network 7: S2 - Čekanje da se izvuku pinovi i otvore stezaljke****Network 8: S3 - Provjera prisutnosti radnih komada na okretnom stolu****Network 9: S4 - čekanje da čovjek odnese zavarene komade****Network 10: S204 - Uklanjanje zavarenih predmeta**



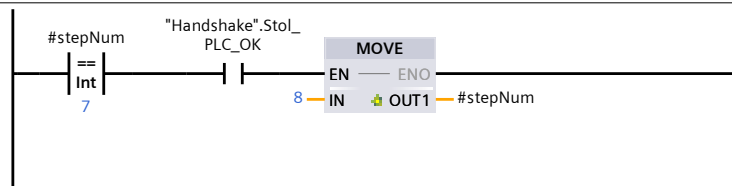
Network 11: S5 - Čekanje da čovjek opskrbi stol radnim komadima



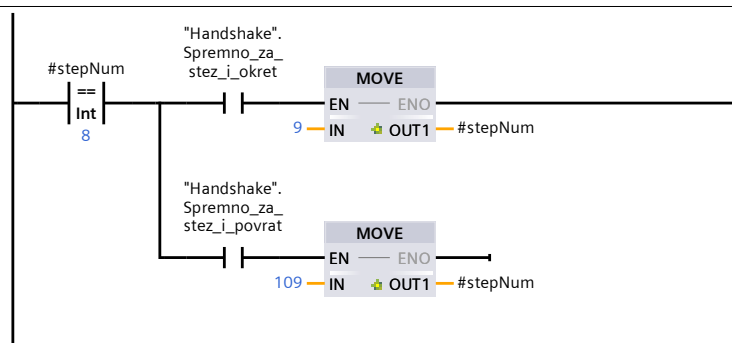
Network 12: S6 - Potvrda safetyja



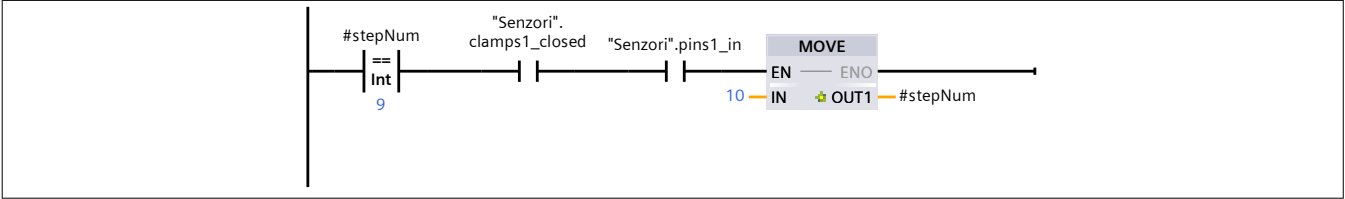
Network 13: S7 - Slanje handshake signala PLC-u



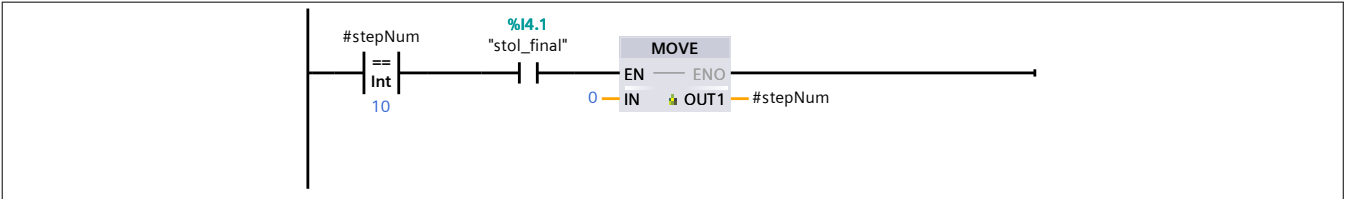
Network 14: S8 - Spremno za stezanje radnih komada



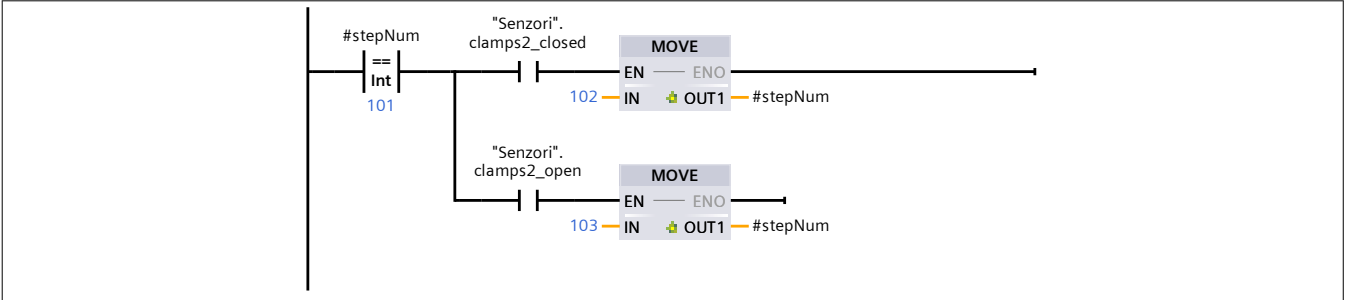
Network 15: S9 - stezanje radnih komada i uvlačenje pinova



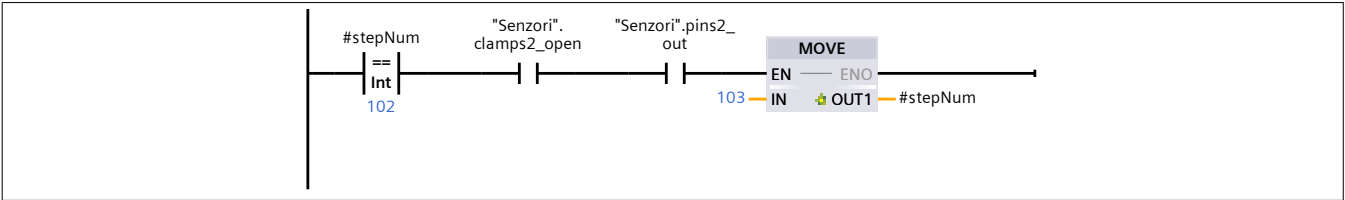
Network 16: S10 - Okret stola



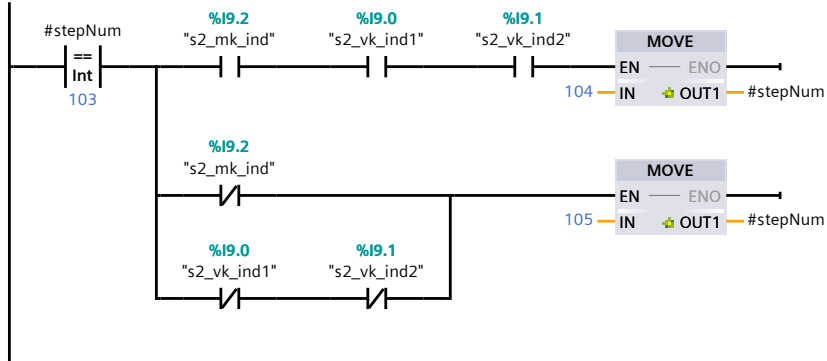
Network 17: S101 - Status stezaljki



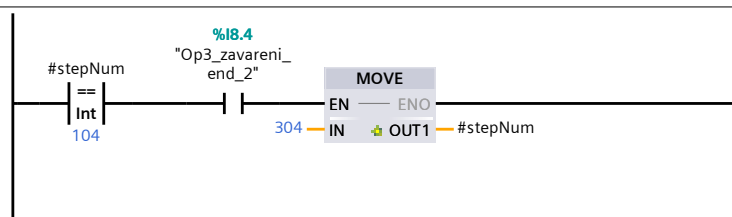
Network 18: S102 - Čekanje da se pinovi izvuku i otvore stezaljke



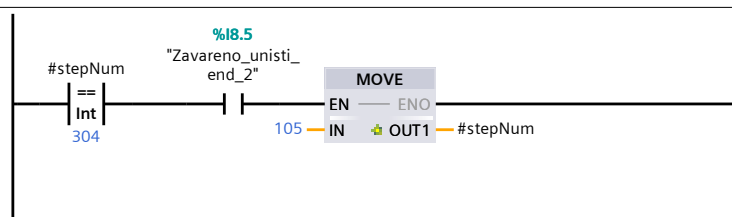
Network 19: S103 - Provjera prisutnosti radnih komada na okretnom stolu



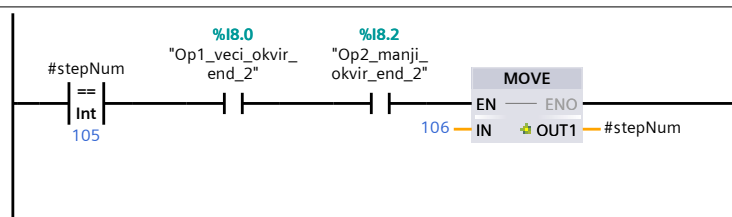
Network 20: S104 - čekanje da čovjek odnese zavarene komade



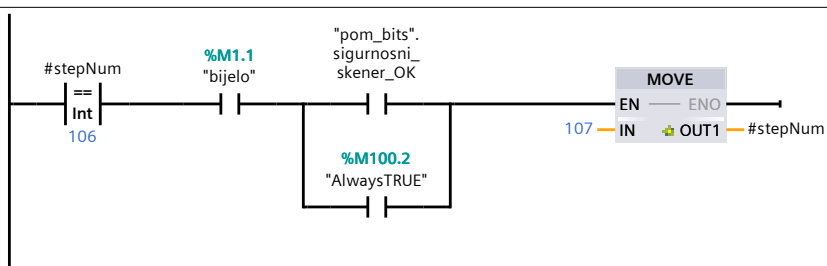
Network 21: S104 - čekanje da čovjek odnese zavarene komade



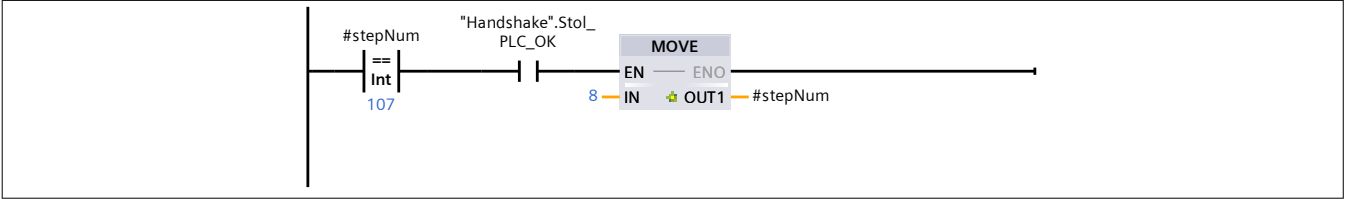
Network 22: S105 - Čekanje da čovjek opskrbi stol radnim komadima



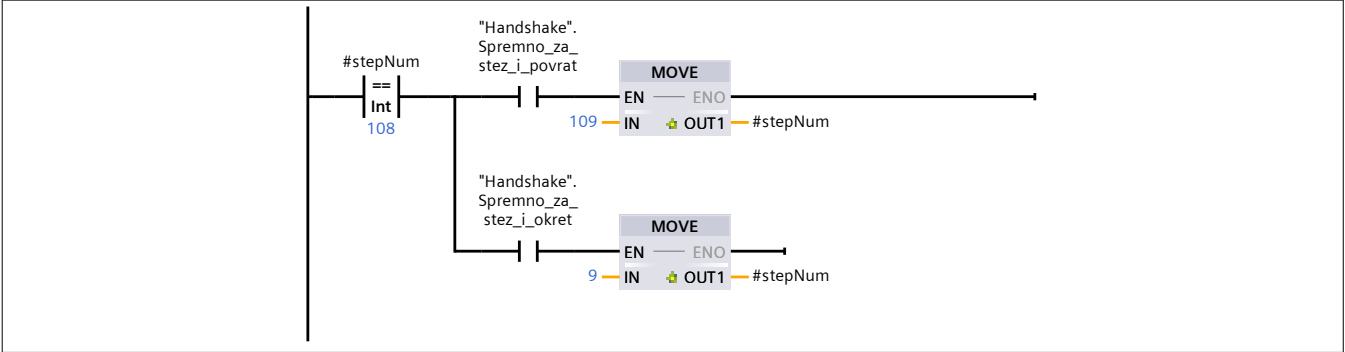
Network 23: S106 - Potvrda safetyja



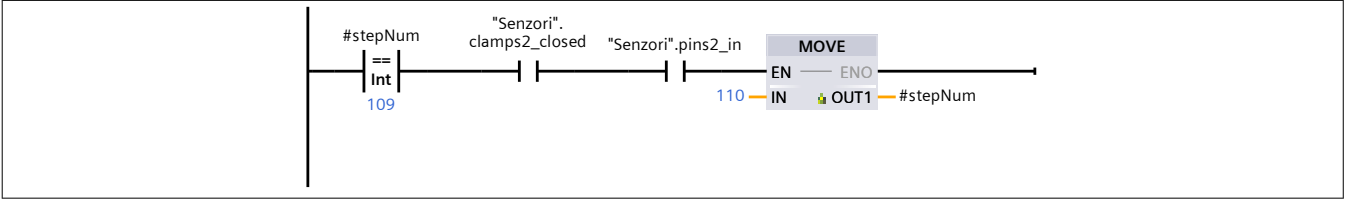
Network 24: S107 - Slanje handshake signala PLC-u



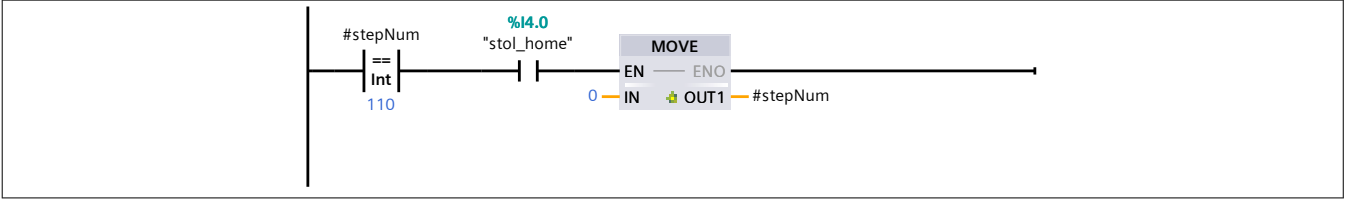
Network 25: S108 - spremno za stezanje radnih komada



Network 26: S109 - stezanje radnih komada i uvlačenje pinova

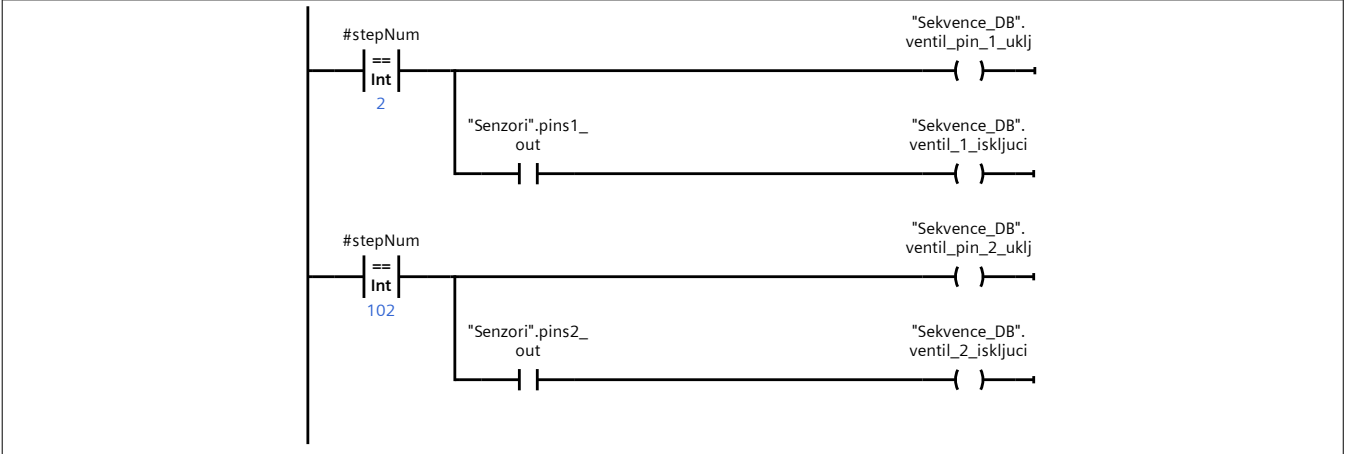


Network 27: S110 - Okret stola



Network 28: RADNJE

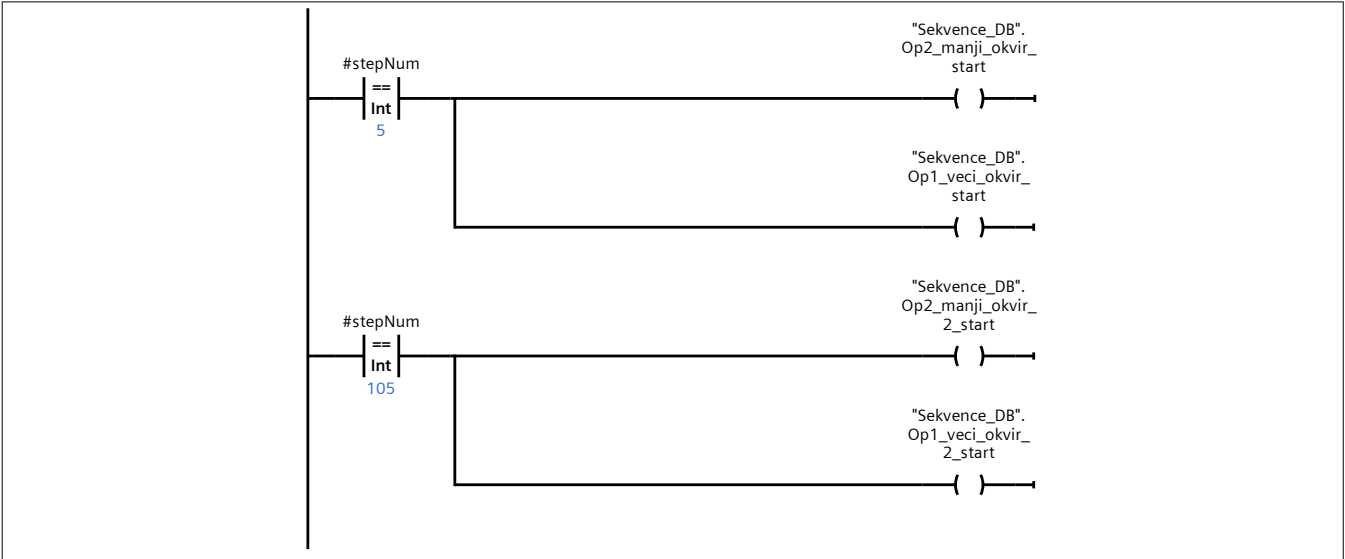
Network 29: Otvori stezaljke



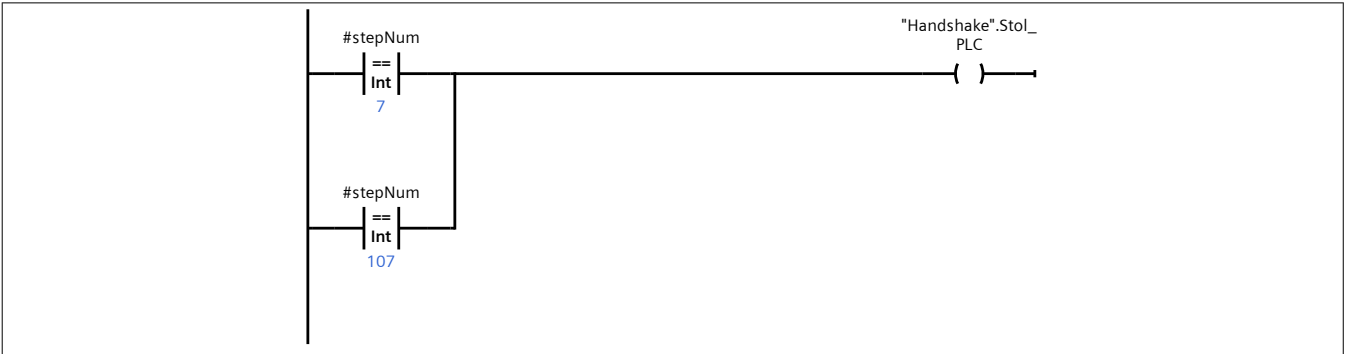
Network 30: Čovjek nosi zavarene komade sa stola



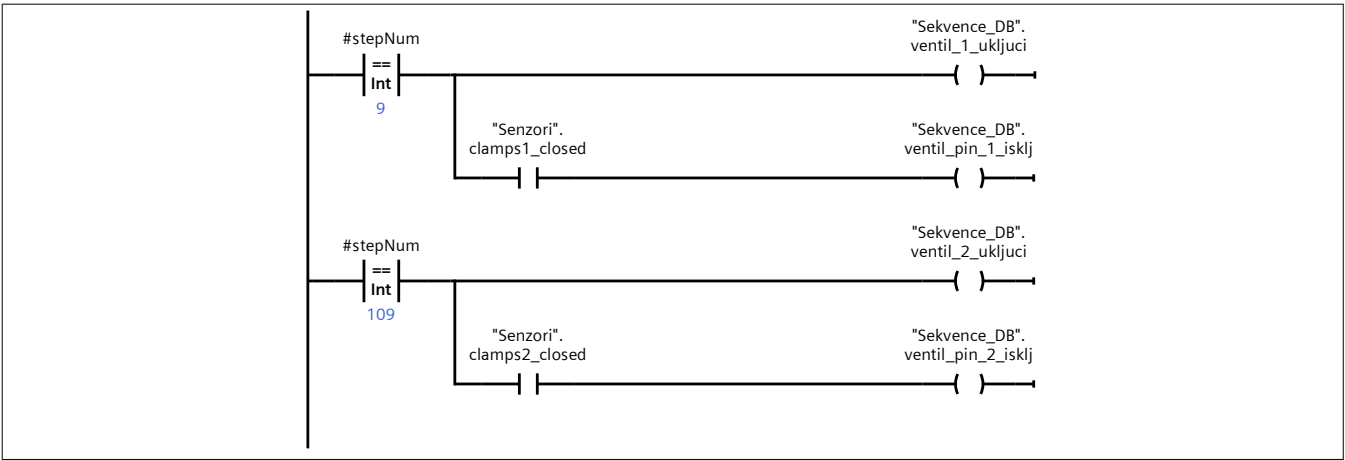
Network 31: Čovjek nosi nezavarene komade na stol



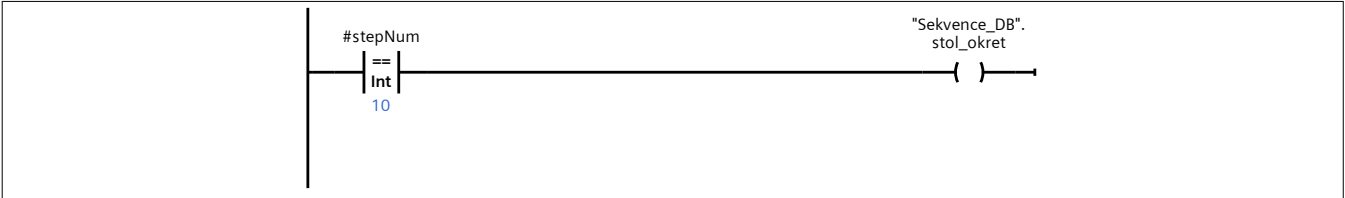
Network 32: Opskrba stola završena



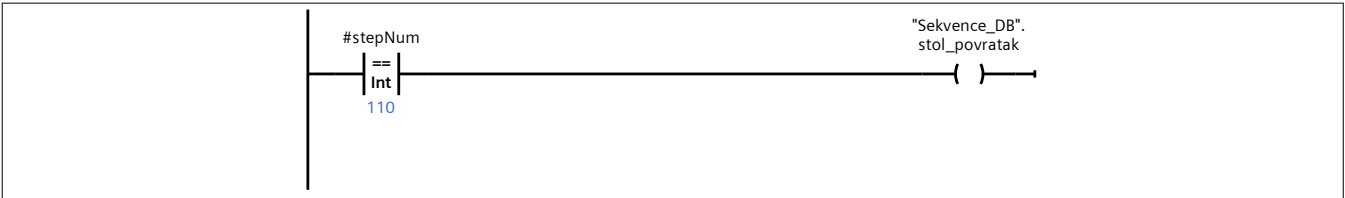
Network 33: Stezanje radnih komada



Network 34: Okretanje stola HOME -> FINAL



Network 35: Okretanje stola FINAL -> HOME



Network 36: Uklanjanje zavarenih komada

Totally Integrated Automation Portal		
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Network 37: Kraj		
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