

FACTORY IO- Sorting of Boxes(1) / PLC_1 [CPU 1212C AC/DC/Rly] / Program blocks

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	automatic		

Information

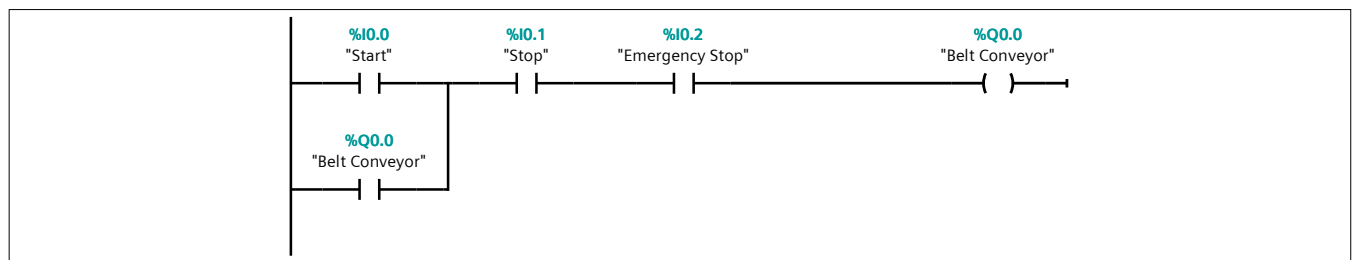
Title	NFI Siemens Course Exercise: Sorting of Boxes	Author	Rajvir	Comment	
Family	NFI	Version	0.1	User-defined ID	

Main

Name	Data type	Default value	Comment
▼ Input			
Initial_Call	Bool		Initial call of this OB
Remanence	Bool		=True, if remanent data are available
Temp			
Constant			

Network 1: Latching & Unlatching of conveyor Q0.0 from Start I0.0 and Stop I0.1

6. Use Emergency I0.2 to stop the conveyor Q0.0

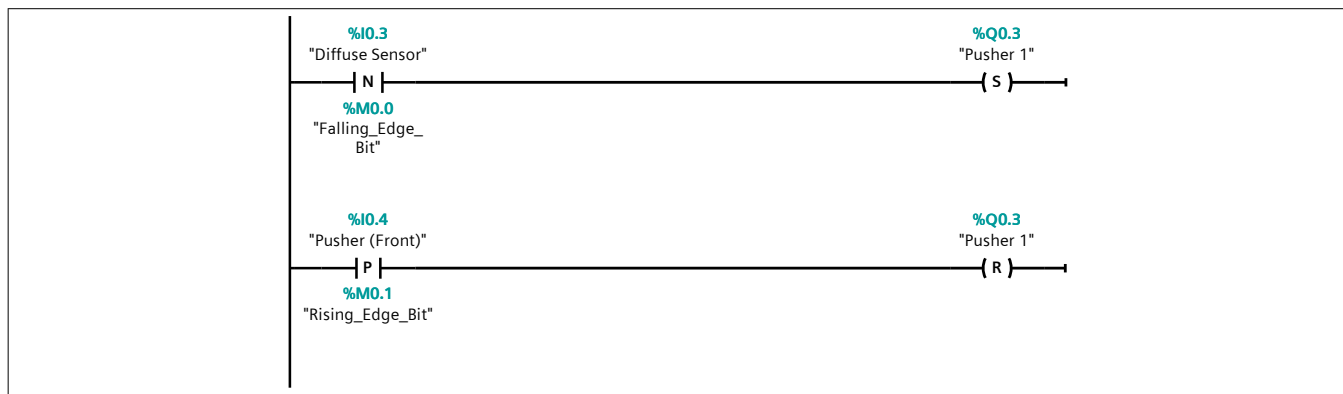


Symbol	Address	Type	Comment
"Belt Conveyor"	%Q0.0	Bool	
"Emergency Stop"	%I0.2	Bool	
"Start"	%I0.0	Bool	Toggle Button
"Stop"	%I0.1	Bool	

Network 2: Sense bigger box via Diffuse sensor I0.3 and Drag bigger boxes using Pusher Q0.3

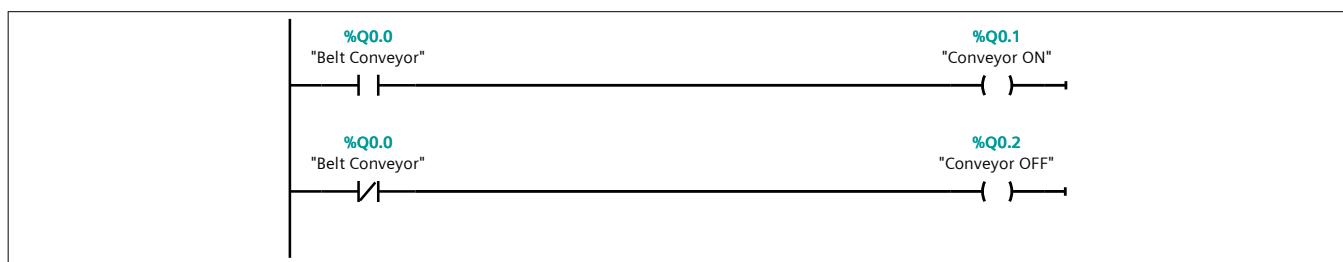
4. Sense and control Pusher Q0.3 using Pusher front I0.4 and back limit I0.5





Symbol	Address	Type	Comment
"Diffuse Sensor"	%I0.3	Bool	
"Falling_Edge_Bit"	%M0.0	Bool	
"Pusher 1"	%Q0.3	Bool	
"Pusher (Front)"	%I0.4	Bool	
"Rising_Edge_Bit"	%M0.1	Bool	

Network 3: 5. Indicate the Start & Stop operation of Conveyor via Indicators Q0.1 and Q0.2



Symbol	Address	Type	Comment
"Belt Conveyor"	%Q0.0	Bool	
"Conveyor OFF"	%Q0.2	Bool	
"Conveyor ON"	%Q0.1	Bool	

