ECELabFinalProject / PLC_1 [CPU 314C-2 DP] / Program blocks

Box to Palletizer [FB12]

Box to Palletizer Properties								
General								
Name	Box to Palletizer	Number	12	Type	FB	Language	LAD	
Numbering	Automatic							
Information								
Title		Author		Comment		Family		
Version	0.1	User-defined ID						
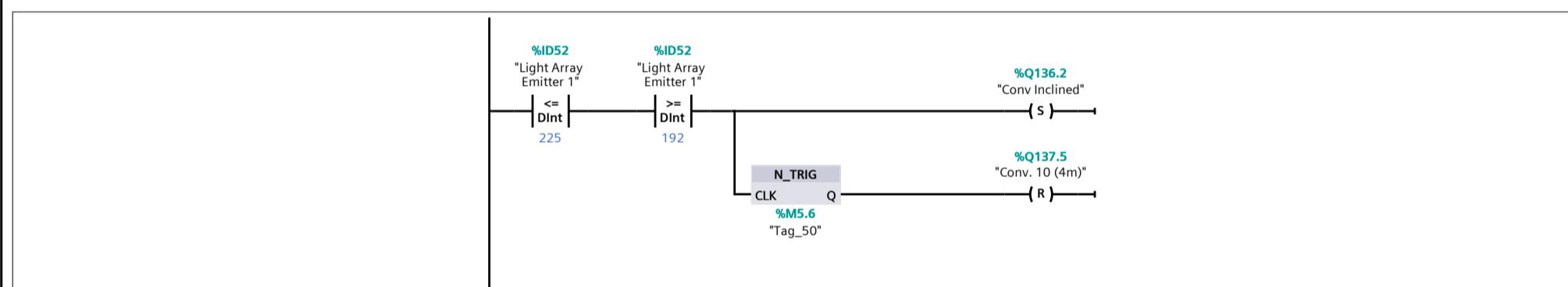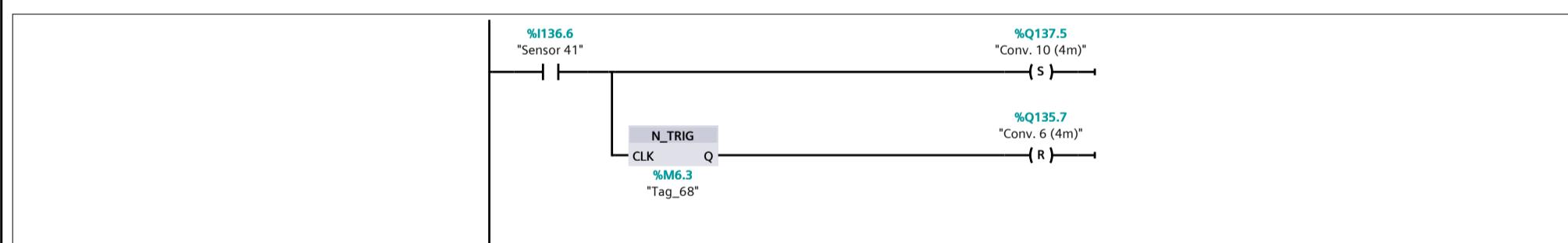
Box to Palletizer									
Name	Data type	Offset	Default value	Accessible from HMI/OPC UA/Web API	Writ-able from HMI/ OPC UA/W eb API	Visible in HMI engi-neering	Setpoint	Supervi-sion	Comment
Input									
Output									
InOut									
Static									
▼ Temp									
Constant LAE	Int	0.0							
Constant									
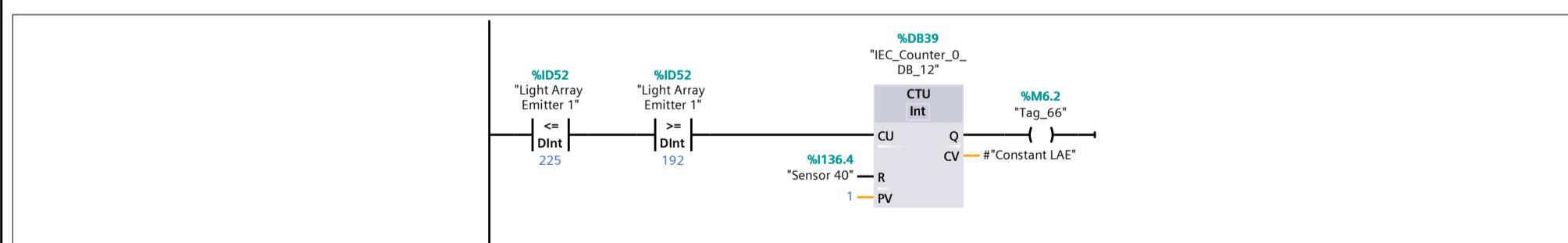
Network 1:
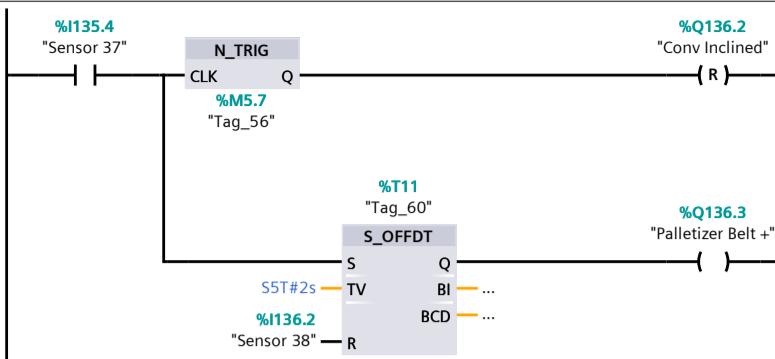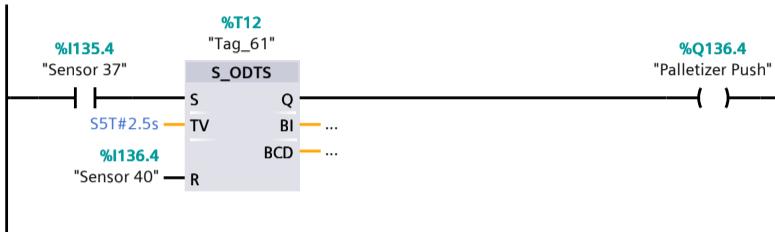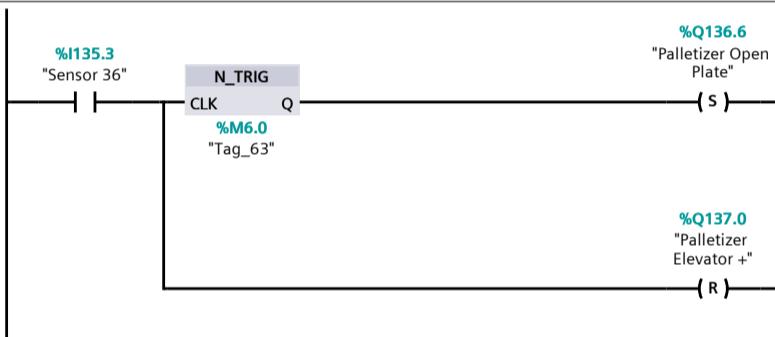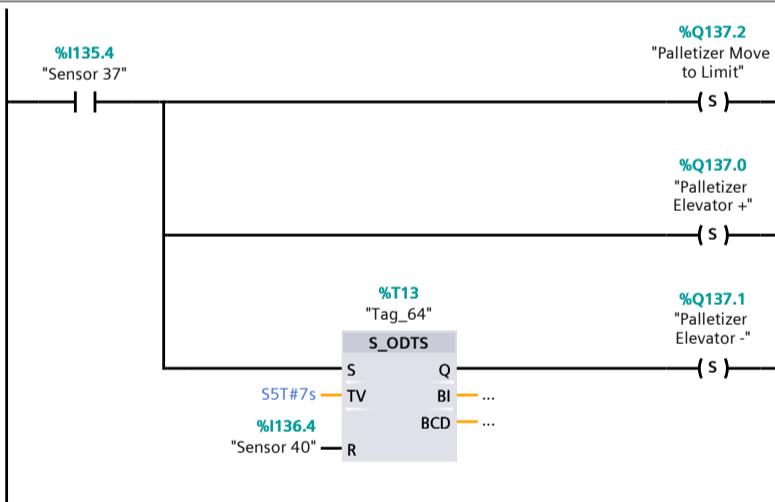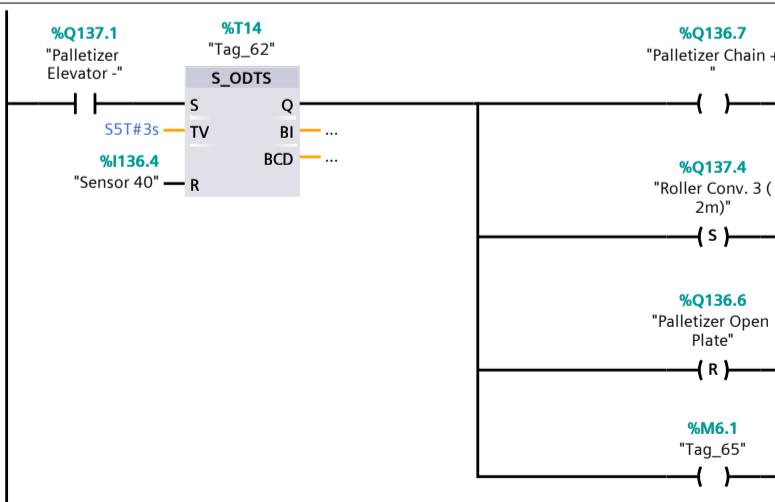
Network 2:

Network 3:

Network 4:

%I135.4
"Sensor 37"

N_TRIG
CLK   Q

%Q136.2
"Conv Inclined"
(R)

%M5.7
"Tag_56"

%T11
"Tag_60"

S_OFFDT
S   Q

%Q136.3
"Palletizer Belt +"
( )

S5T#2s — TV   BI — ...
BCD — ...

%I136.2
"Sensor 38" — R

Network 5:

%I135.4
"Sensor 37"

%T12
"Tag_61"

S_ODTS
S   Q

%Q136.4
"Palletizer Push"
( )

S5T#2.5s — TV   BI — ...
BCD — ...

%I136.4
"Sensor 40" — R

Network 6:

%I135.3
"Sensor 36"

N_TRIG
CLK   Q

%Q136.6
"Palletizer Open
Plate"
(S)

%M6.0
"Tag_63"

%Q137.0
"Palletizer
Elevator +"
(R)

Network 7:

%I135.4
"Sensor 37"

%Q137.2
"Palletizer Move
to Limit"
(S)

%Q137.0
"Palletizer
Elevator +"
(S)

%T13
"Tag_64"

S_ODTS
S   Q

%Q137.1
"Palletizer
Elevator -"
(S)

S5T#7s — TV   BI — ...
BCD — ...

%I136.4
"Sensor 40" — R

Network 8:

%Q137.1
"Palletizer
Elevator -"

%T14
"Tag_62"

S_ODTS
S   Q

%Q136.7
"Palletizer Chain +
"
( )

S5T#3s — TV   BI — ...
BCD — ...

%I136.4
"Sensor 40" — R

%Q137.4
"Roller Conv. 3 (
2m)"
(S)

%Q136.6
"Palletizer Open
Plate"
(R)

%M6.1
"Tag_65"
( )

Network 9:

%I136.4
"Sensor 40"
%Q137.1
"Palletizer
Elevator -"
—| |———(R)—

Network 10:

%I136.1
"Palletizer
Elevator Front
Limit"
%Q137.3
"Roller Conv. 2 (
4m)"
—|/|———( )—

%M6.1
"Tag_65"
%Q136.7
"Palletizer Chain +
"
—| |——( )—