conveyor-push-sort / PLC_1 [CPU 1214C AC/DC/Rly] / Program blocks

FC_Conveyor [FC1]

FC_Conveyor Properties					
General					
Name	FC_Conveyor	**Number**	1	**Type**	FC
Language	LAD	**Numbering**	Automatic		
Information					
Title		**Author**		**Comment**	
Family		**Version**	0.1	**User-defined ID**	

FC_Conveyor			
Name	**Data type**	**Default value**	**Comment**
Input			
Output			
InOut			
▼ Temp			
i	Int		
err	Int		
▼ CurrentTime	DTL		
YEAR	UInt		
MONTH	USInt		
DAY	USInt		
WEEKDAY	USInt		
HOUR	USInt		
MINUTE	USInt		
SECOND	USInt		
NANOSECOND	UDInt		
Constant			
▼ Return			
FC_Conveyor	Void		

Network 1:

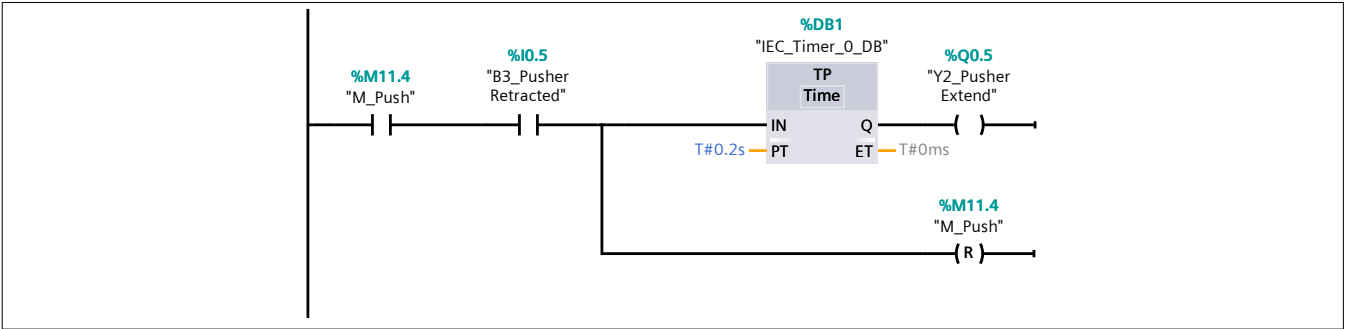Track items

```
0001 IF "DB_ItemTracking".UntrackedItems > 0 THEN
0002     FOR #i := 0 TO 5 DO
0003         IF NOT "DB_ItemTracking".ItemList[#i].Active THEN
0004             "DB_ItemTracking".ItemList[#i].Active := TRUE;
0005             "DB_ItemTracking".UntrackedItems := "DB_ItemTracking".UntrackedI-
     tems - 1;
0006         END_IF;
0007
0008         // If more items remain untracked, continue filling slots
0009         IF "DB_ItemTracking".UntrackedItems = 0 THEN
0010             EXIT;
0011         END_IF;
0012     END_FOR;
0013 END_IF;
0014
```

Network 2:

Push items that approach pusher based on travel time

```
0001 #err := RD_SYS_T("DB_ItemTracking".CurrentTime);
0002
0003 "DB_ItemTracking".DeltaTime := T_DIFF(IN1:="DB_ItemTracking".Current-
     Time,IN2:="DB_ItemTracking".PrevScanTime);
0004 "DB_ItemTracking".PrevScanTime := "DB_ItemTracking".CurrentTime;
0005
0006 IF "M1_ConveyorMove" THEN
0007     FOR #i := 0 TO 5 DO
0008         IF "DB_ItemTracking".ItemList[#i].Active THEN
0009
0010             "DB_ItemTracking".ItemList[#i].AccumulatedTime :=
0011             "DB_ItemTracking".ItemList[#i].AccumulatedTime + "DB_ItemTrack-
     ing".DeltaTime;
0012
0013             IF "DB_ItemTracking".ItemList[#i].AccumulatedTime >= "DB_Item-
     Tracking".ThresholdTime THEN
0014                 "M_Push" := TRUE;
0015                 "DB_ItemTracking".ItemList[#i].Active := FALSE;
0016                 "DB_ItemTracking".ItemList[#i].AccumulatedTime := T#0s;
0017             END_IF;
0018         END_IF;
0019     END_FOR;
0020 END_IF;
0021
```

Network 3:

Network 4: