




























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

PLC tags

	Name	Data type	Address	Retain	Access- ible from HMI/O PC UA/Web API	Writ- able from HMI/O PC UA/Web API	Visible in HMI engi- neer- ing	Supervision			Comment
	S1_Start	Bool	%I0.0	False	True	True	True				NO
	S2_Stop	Bool	%I0.1	False	True	True	True				NO
	B1_FeederRetracted	Bool	%I0.2	False	True	True	True				
	B2_FeederExtended	Bool	%I0.3	False	True	True	True				
	B4_MetalSensor	Bool	%I0.4	False	True	True	True				
	B5_ColorSensor_Is- White	Bool	%I0.6	False	True	True	True				
	B6_AtConveyorEnd	Bool	%I0.7	False	True	True	True				
	B3_PusherRetracted	Bool	%I0.5	False	True	True	True				
	B8_ArmOverTruck	Bool	%I1.0	False	True	True	True				
	B7_ArmOverConvey- or	Bool	%I1.1	False	True	True	True				
	B9_ArmsDown	Bool	%I1.2	False	True	True	True				
	B10_WhiteTruckAc- tive	Bool	%I1.3	False	True	True	True				
	P1_LightGreen	Bool	%Q0.0	False	True	True	True				
	P2_LightYellow	Bool	%Q0.1	False	True	True	True				
	Y1A_FeederExtend	Bool	%Q0.3	False	True	True	True				
	Y1B_FeederRetract	Bool	%Q0.2	False	True	True	True				
	M1_ConveyorMove	Bool	%Q0.4	False	True	True	True				
	Y2_PusherExtend	Bool	%Q0.5	False	True	True	True				
	Y6_ArmFromTruck- ToConveyor	Bool	%Q0.6	False	True	True	True				
	Y4_LowerArm	Bool	%Q0.7	False	True	True	True				
	Y5_GripperPressur- eOn	Bool	%Q1.0	False	True	True	True				
	Y3_EnableBlackTruck	Bool	%Q1.1	False	True	True	True				
	M_Start_Last- State_Negative	Bool	%M11.1	False	True	True	True				
	M_Running	Bool	%M11.3	False	True	True	True				
	M_Push	Bool	%M11.4	False	True	True	True				
	M_Start_One- Shot_Negative	Bool	%M11.2	False	True	True	True				
	M_MetalSensor_Last- State_Positive	Bool	%M11.5	False	True	True	True				