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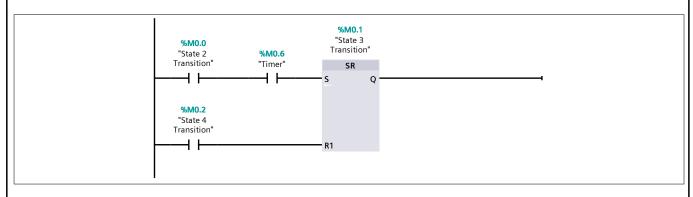
Sorting / PLC_1 [CPU 314C-2 PN/DP] / Program blocks

Main [OB1]

Main Properties									
General									
Name	Main	Number	1	Туре	OB				
Language	LAD	Numbering	Manual						
Information									
Title	"Main Program Sweep (Cycle)"	Author		Comment					
Family		Version	0.1	User-defined ID					

Main								
Name	Data type	Offset	Default value	Super- vision	Comment			
▼ Temp								
OB1_EV_CLASS	Byte	0.0			Bits 0-3 = 1 (Coming event), Bits 4-7 = 1 (Event class 1)			
OB1_SCAN_1	Byte	1.0			1 (Cold restart scan 1 of OB 1), 3 (Scan 2-n of OB 1)			
OB1_PRIORITY	Byte	2.0			Priority of OB Execution			
OB1_OB_NUMBR	Byte	3.0			1 (Organization block 1, OB1)			
OB1_RESERVED_1	Byte	4.0			Reserved for system			
OB1_RESERVED_2	Byte	5.0			Reserved for system			
OB1_PREV_CYCLE	Int	6.0			Cycle time of previous OB1 scan (milliseconds)			
OB1_MIN_CYCLE	Int	8.0			Minimum cycle time of OB1 (milliseconds)			
OB1_MAX_CYCLE	Int	10.0			Maximum cycle time of OB1 (milliseconds)			
OB1_DATE_TIME	Date_And_Ti me	12.0			Date and time OB1 started			
Constant								

Network 2: State2 -> State3



Network 3:

Totally Integrated **Automation Portal** %DB5 "IEC_Timer_0_ DB_4" **%M0.0** "State 2 TP %M0.6 Transition" "Timer" P_TRIG | | | T#1.5s — **PT** %M1.0 ET -"Trig Mem" %M0.1 "State 3 Transition" %M0.2 "State 4 Transition" Network 4: State3 -> State4 %M0.2 %M0.1 "State 3 Transition" "State 4 Transition" **%M0.6** "Timer" SR 4 F 4 F Q · %M0.3 "State 5 Transition" Network 5: State4 -> State5 %M0.3 "State 5 Transition" %M0.2 "State 4 %M0.6 Transition" "Timer" SR | | | Q %M0.4 "State 6 Transition" **H** F R1 Network 6: State5 -> State6

Totally Integrated **Automation Portal** %M0.4 "State 6 Transition" %M0.3 %10.2 "State 5 Transition" "Raise Stopper (B3)" %M0.7 "Timer 2" SR | | | 4 F Q %M0.5 "State 1 Transition" **4** F Network 7: %DB4 "IEC_Timer_0_ DB_3" %M0.3 %10.2 TP "State 5 Transition" "Raise Stopper (B3)" %M0.7 Time "Timer 2" **-(**)-**H** F - IN Q · T#1s — PT ET --- ... Network 8: %M0.5 "State 1 Transition" %M0.4 **%I1.4** "State 6 "Right Limit Transition" Sensor (IR)" SR Q %M0.0 "State 2 Transition" **H** F · R1 Network 9: Lower Stopper (M1) %M0.0 %M0.3 %Q0.0 "State 5 Transition" "Lower Stopper (M1)" "State 2 Transition" ()-**Network 10: Forward (QR)**

Totally Integrated **Automation Portal** %M0.0 "State 2 Transition" **%Q1.0**"Forward (OR)" ()-%M0.1 "State 3 Transition" %M0.4 "State 6 Transition" **H** F Network 11: Sort (M2) %M0.2 "State 4 Transition" %Q0.2 "Sort (M2)" ()-Network 1: State 1-> State2 %M0.0 "State 2 Transition" %I1.3 "Left Limit Sensor (IL)" %10.3 **%I2.2**"Start" "Magazine Level (B4)" SR 4 F 4 F 1 Q %M0.1 "State 3 Transition"