
































Sorting machine / General / PLC_1 [CPU 1214C DC/DC/DC]

PLC tags

	Name	Data type	Address	Retain	Access- ible from HMI/O PC UA/We b API	Writa- ble from HMI/O PC UA/We b API	Visible in HMI engi- neer- ing	Supervision	Comment
	Alarm_triggered	Bool	%M10.0	False	True	True	True		Alarm triggered
	Warning_triggered	Bool	%M10.1	False	True	True	True		Without machine Stop
	Error_triggered	Bool	%M10.2	False	True	True	True		With machine Stop
	Acknowledge_triggered	Bool	%M10.3	False	True	True	True		Acknowledge button is triggered
	Startup_Acknowledge	Bool	%M10.4	False	True	True	True		Acknowledge is needed When the system is starting up
	S1	Bool	%I8.0	False	True	True	True		machine start
	S2	Bool	%I8.1	False	True	True	True		machine stop
	S3	Bool	%I8.2	False	True	True	True		Emergency Stop
	H1	Bool	%Q8.0	False	True	True	True		start button light
	H2	Bool	%Q8.1	False	True	True	True		stop button light
	S4	Bool	%I2.0	False	True	True	True		Emergency Stop
	M1	Bool	%Q2.0	False	True	True	True		Conveyor entry motor
	SL1	Bool	%I3.0	False	True	True	True		left entry
	SL2	Bool	%I3.1	False	True	True	True		right entry
	SL3	Bool	%I3.2	False	True	True	True		Pallet sensor
	SL4	Bool	%I3.3	False	True	True	True		Low sensor
	SL5	Bool	%I3.4	False	True	True	True		High sensor
	SQ1	Bool	%I3.5	False	True	True	True		Loaded sensor
	M2 left	Bool	%Q3.0	False	True	True	True		Transfer motor left
	M2 right	Bool	%Q3.1	False	True	True	True		Transfer motor Right
	M3 load	Bool	%Q3.2	False	True	True	True		load motor forward
	M3 unload	Bool	%Q3.3	False	True	True	True		load motor backward
	S5	Bool	%I4.0	False	True	True	True		left Emergency Stop
	S6	Bool	%I4.1	False	True	True	True		right Emergency Stop
	SL6	Bool	%I4.2	False	True	True	True		Left exit
	SL7	Bool	%I4.3	False	True	True	True		Right exit
	M4	Bool	%Q4.0	False	True	True	True		Left Conveyor exit motor
	M5	Bool	%Q4.1	False	True	True	True		Right Conveyor exit motor
	H3	Bool	%Q8.2	False	True	True	True		Stack Light (Red) - Error
	H4	Bool	%Q8.3	False	True	True	True		Stack Light (Yellow) - Warning
	H5	Bool	%Q8.4	False	True	True	True		Stack Light (Green) - machine Run