














IA_Project / PLC_1 [CPU 1511-1 PN] / PLC tags

01_sorting_line_IO [13]

PLC tags

	Name	Data type	Address	Comment
	sorting_emitter_belt	Bool	%Q0.0	Conveyor belt beneath the raw material emitter
	sorting_color_sensor	Int	%IW10	Color detection sensor 1 = blue , 4 = green , 7 = gray
	sorting_arm1_turn	Bool	%Q0.2	When activated, turn the first sorting arm by about 45 degrees
	sorting_arm2_turn	Bool	%Q0.3	When activated, turn the second sorting arm by about 45 degrees
	sorting_green_sensor	Bool	%I0.1	The green raw material left the sorting line
	sorting_blue_sensor	Bool	%I0.2	The blue raw material left the sorting line
	sorting_stop_blade	Bool	%Q0.1	Moving the stop blade up to make sure the raw material cannot enter the sorting line
	sorting_in_sensor	Bool	%I0.3	Raw material entered the line
	sorting_out_sensor	Bool	%I0.4	Raw material is about to go under the color detection sensor, now the next raw material is allowed to proceed
	sorting_gray_sensor	Bool	%I0.5	The gray raw material left the sorting line
	sorting_blue_count	Int	%QW10	Number of blue raw materials sorted
	sorting_green_count	Int	%QW12	Number of green raw materials sorted
	sorting_gray_count	Int	%QW14	Number of gray raw materials sorted