














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

04_green_boxing_line_IO [13]

PLC tags

	Name	Data type	Address	Comment
	green_boxing_box_in	Bool	%I3.4	-
	green_boxing_product_in	Bool	%I3.5	-
	green_boxing_box_belt	Bool	%Q3.2	-
	green_boxing_clamp	Bool	%Q3.3	Clamp the final product in place
	green_boxing_stop_blade	Bool	%Q3.4	Raise the stop blade to prevent the box from moving too far forward
	green_boxing_grab	Bool	%Q3.5	-
	green_boxing_move_X	Int	%QW24	Move the 3-axis arm along the X axis
	green_boxing_move_Y	Int	%QW26	Move the 3-axis arm along the Y axis
	green_boxing_move_Z	Int	%QW28	Move the 3-axis arm along the Z axis
	green_boxing_X_position	Int	%IW12	Position of the 3-axis arm along the X axis
	green_boxing_Y_position	Int	%IW14	Position of the 3-axis arm along the Y axis
	green_boxing_Z_position	Int	%IW16	Position of the 3-axis arm along the Z axis
	green_boxing_box_count	Int	%QW30	Total boxes produced (each contains 3 final products)