














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

05_blue_CNC_line_IO [13]

PLC tags

	Name	Data type	Address	Comment
	blue_CNC_base_loaded	Bool	%I2.1	Raw material is loaded into the CNC machine for base production
	blue_CNC_base_produced	Bool	%I2.2	-
	blue_CNC_in_sensor	Bool	%I2.3	The blue raw material is at the edge of the pusher
	blue_CNC_lid_loaded	Bool	%I2.4	Raw material is loaded into the CNC machine for lid production
	blue_CNC_lid_produced	Bool	%I2.5	-
	blue_CNC_pusher_limit	Bool	%I2.6	Becomes 1 when the pusher is fully extended
	blue_CNC_base_start	Bool	%Q1.7	Start signal of the CNC responsible for producing blue bases
	blue_CNC_lid_start	Bool	%Q2.0	Start signal of the CNC responsible for producing blue lids
	blue_CNC_pusher	Bool	%Q2.1	-
	blue_CNC_base_count	Int	%QW20	Number of blue bases produced as of right now
	blue_CNC_lid_count	Int	%QW22	Number of blue lids produced as of right now
	blue_CNC_base_belt	Bool	%Q3.0	Input conveyor of the CNC that produces bases
	blue_CNC_lid_belt	Bool	%Q3.1	Input conveyor of the CNC that produces lids