














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

02_green_CNC_line_IO [13]

PLC tags

	Name	Data type	Address	Comment
	green_CNC_in_sensor	Bool	%I0.6	The green raw material is at the edge of the pusher
	green_CNC_pusher_limit	Bool	%I0.7	Becomes 1 when the pusher is fully extended
	green_CNC_pusher	Bool	%Q0.4	-
	green_CNC_base_produced	Bool	%I1.1	-
	green_CNC_lid_produced	Bool	%I1.0	-
	green_CNC_base_count	Int	%QW16	Number of green bases produced as of right now
	green_CNC_lid_count	Int	%QW18	Number of green lids produced as of right now
	green_CNC_lid_start	Bool	%Q1.3	Start signal of the CNC responsible for producing green lids
	green_CNC_base_start	Bool	%Q1.4	Start signal of the CNC responsible for producing green bases
	green_CNC_base_loaded	Bool	%I1.7	Raw material is loaded into the CNC machine for base production
	green_CNC_lid_loaded	Bool	%I2.0	Raw material is loaded into the CNC machine for lid production
	green_CNC_base_belt	Bool	%Q1.5	Input conveyor of the CNC that produces bases
	green_CNC_lid_belt	Bool	%Q1.6	Input conveyor of the CNC that produces lids