














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

08_storage_system_IO [13]

PLC tags

	Name	Data type	Address	Comment
	storage_fork_left_limit	Bool	%I4.0	Becomes 1 when fork reaches full left extension
	storage_fork_middle_limit	Bool	%I4.1	Becomes 1 when the fork is exactly at the center position
	storage_fork_right_limit	Bool	%I4.2	Becomes 1 when fork reaches full right extension
	storage_X_moving	Bool	%I4.3	Becomes 1 while moving along the floor (X-axis); otherwise, 0
	storage_Z_moving	Bool	%I4.4	Becomes 1 while moving up or down (Z-axis); otherwise, 0
	storage_fork_lift	Bool	%Q4.2	-
	storage_fork_move_left	Bool	%Q4.3	-
	storage_fork_move_right	Bool	%Q4.4	-
	storage_loading_belt	Bool	%Q4.5	-
	storage_fork_position	Int	%QW40	1 to 54 = Valid storage positions; other values (except 0) = Home position
	storage_box_in	Bool	%I4.5	The box is ready to be lifted
	storage_stored_boxes_count	Int	%QW42	The total number of boxes in the storage as of right now
	storage_stored_products_count	Int	%QW44	The total number of products in the storage as of right now