













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

03_green_assembly_line_IO [12]

PLC tags

	Name	Data type	Address	Comment
	green_assembly_base_clamp	Bool	%Q0.5	-
	green_assembly_lid_clamp	Bool	%Q0.6	-
	green_assembly_move_X	Bool	%Q0.7	0 = gripper is above lid , 1= gripper is above base
	green_assembly_move_Z	Bool	%Q1.0	0 = gripper is up , 1= gripper is down
	green_assembly_grab	Bool	%Q1.1	-
	green_assembly_clamp_up	Bool	%Q1.2	Raise the base clamp to allow the final product to exit the assembly line
	green_assembly_base_in	Bool	%I1.2	The base is positioned at the edge of the base clamp
	green_assembly_lid_in	Bool	%I1.3	The lid is positioned at the edge of the lid clamp
	green_assembly_done	Bool	%I1.4	Final product exited the assembly line
	green_assembly_X_limit	Bool	%I1.5	Becomes 1 when the arm is fully extended along the X axis
	green_assembly_Z_limit	Bool	%I1.6	Becomes 1 when the arm is fully extended along the Z axis
	green_assembled_count	Int	%QW52	-