

IA_Project / PLC_1 [CPU 1511-1 PN] / Program blocks / 01 sorting line

sorting_line [FB2]

sorting_line Properties

General

Name	sorting_line	Number	2	Type	FB
Language	LAD	Numbering	Automatic		

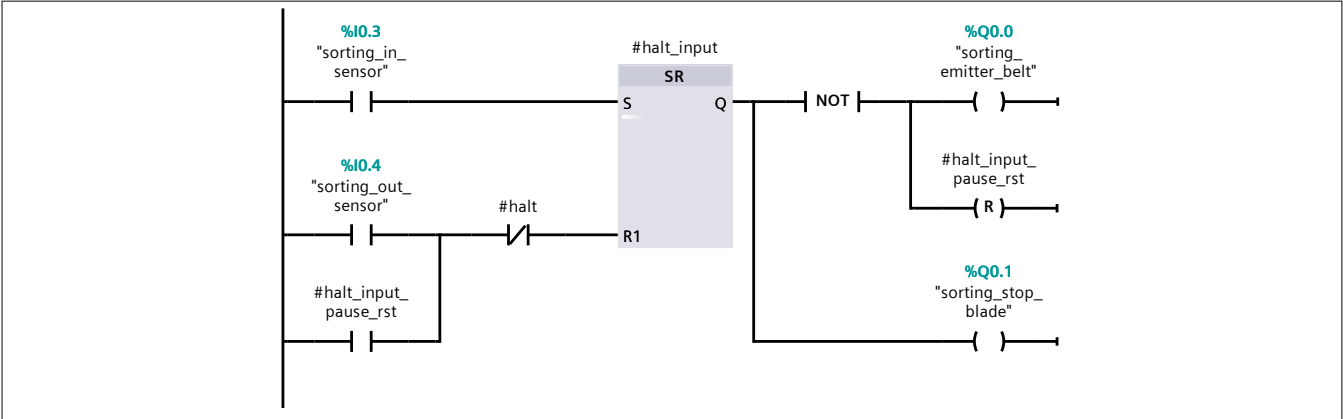
Information

Title		Author		Comment	
Family		Version	0.1	User-defined ID	

sorting_line

Name	Data type	Default value
▼ Input		
RST	Bool	false
halt	Bool	false
▼ Output		
green_count	Int	0
blue_count	Int	0
gray_count	Int	0
InOut		
▼ Static		
halt_input	Bool	false
halt_input_pause_rst	Bool	false
M1	Bool	false
blue_in_line	Bool	false
green_in_line	Bool	false
gray_in_line	Bool	false
blue_counter	CTU_INT	
green_counter	CTU_INT	
gray_counter	CTU_INT	
Temp		
Constant		

Network 1: Conveyor belt beneath the raw material emitter

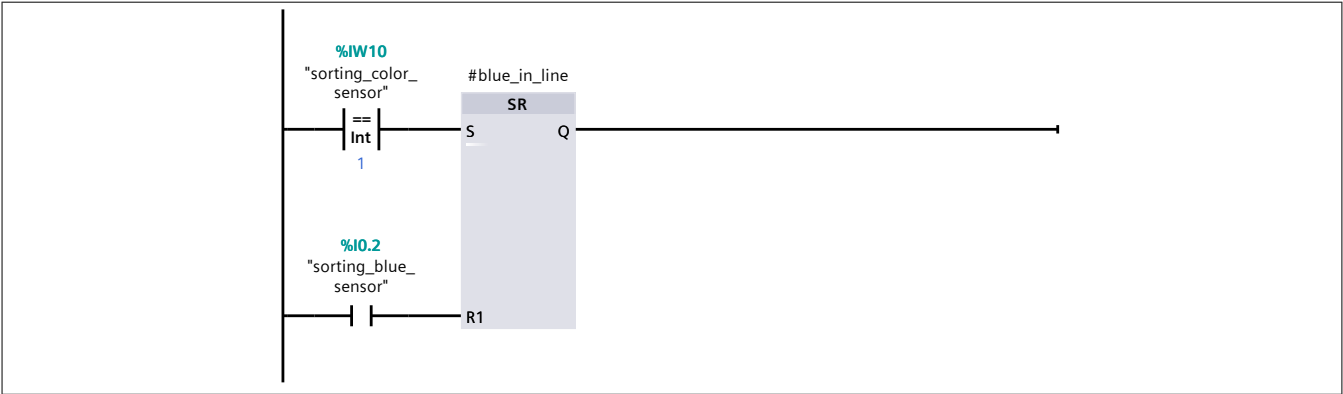


Network 2: to stop raw material input temporarily



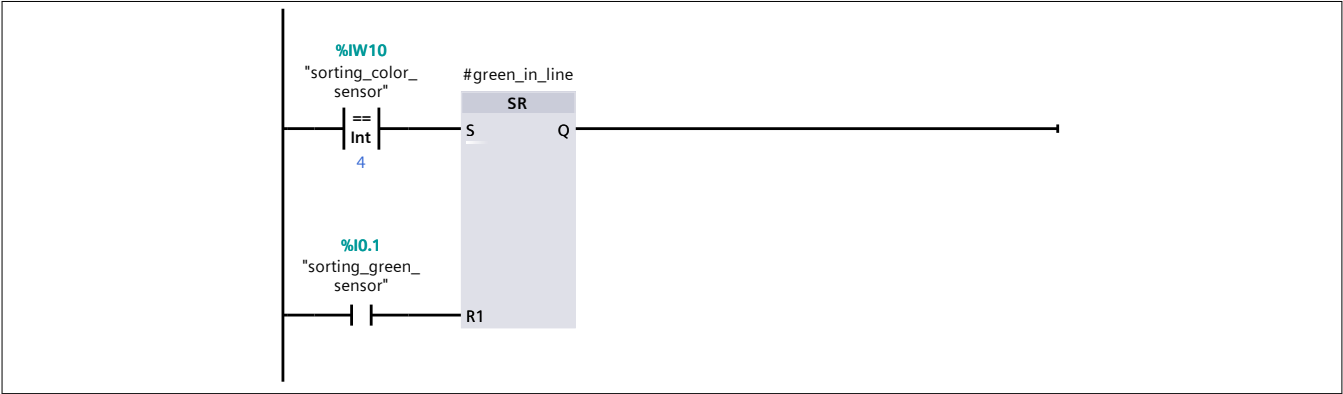
Network 3:

blue -> 1



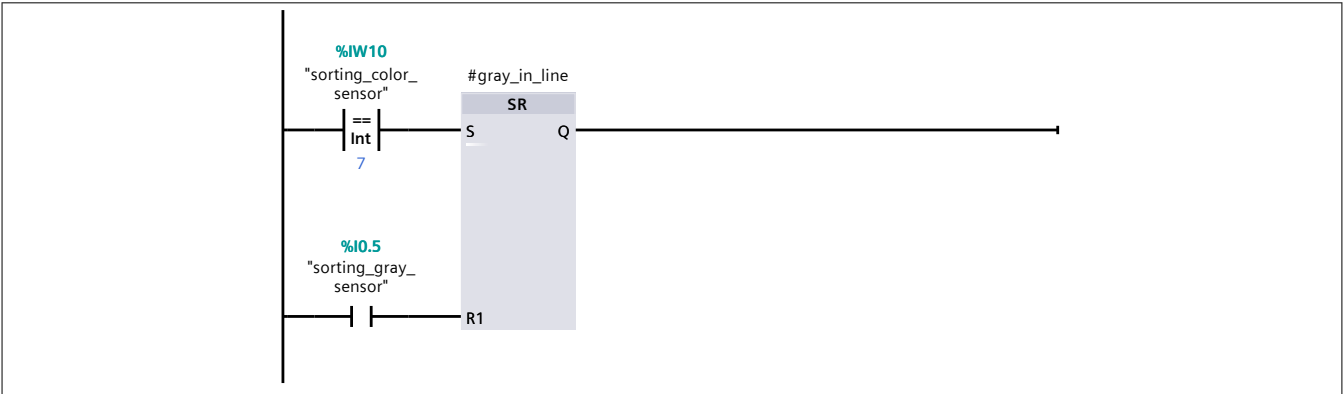
Network 4:

green -> 4



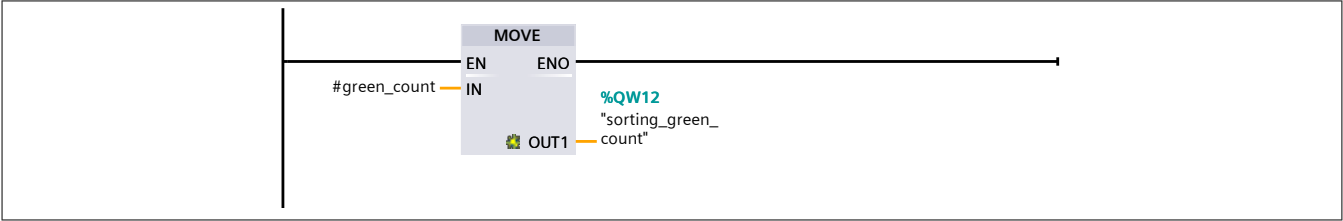
Network 5:

gray -> 7

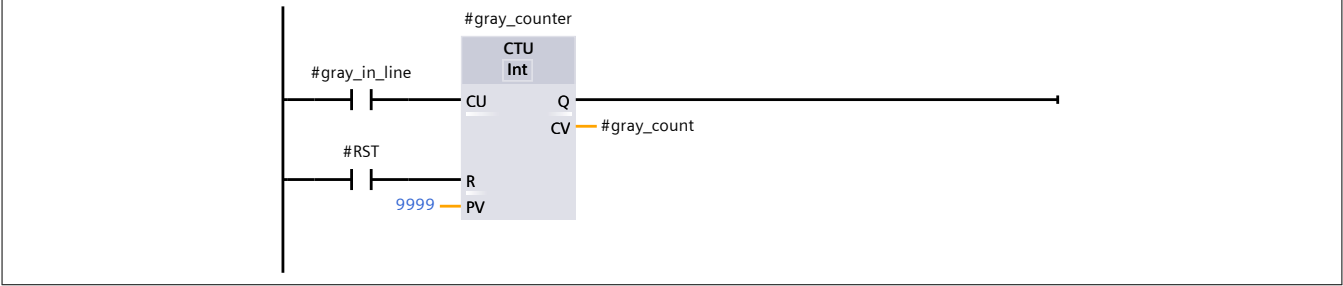


Totally Integrated Automation Portal		
Network 6:		
<div><div></div><div><div>#gray_in_line</div><div><div>%Q0.2 "sorting_arm1_turn"</div></div></div></div>		
Network 7:		
<div><div></div><div><div>#green_in_line</div><div><div>%Q0.3 "sorting_arm2_turn"</div></div></div></div>		
Network 8:		
<div><div></div><div><div><div>#blue_in_line</div><div>#RST</div></div><div><div>#blue_counter</div><div>CTU Int</div><div><div>CU</div><div>R</div></div><div><div>Q</div><div>CV</div></div><div><div>9999</div><div>PV</div></div><div><div>#blue_count</div></div></div></div></div>		
Network 9:		
<div><div></div><div><div><div>#blue_count</div></div><div><div>MOVE</div><div><div>EN</div><div>ENO</div></div><div><div>IN</div><div>OUT1</div></div><div><div>%QW10 "sorting_blue_count"</div></div></div></div></div>		
Network 10:		
<div><div></div><div><div><div>#green_in_line</div><div>#RST</div></div><div><div>#green_counter</div><div>CTU Int</div><div><div>CU</div><div>R</div></div><div><div>Q</div><div>CV</div></div><div><div>9999</div><div>PV</div></div><div><div>#green_count</div></div></div></div></div>		

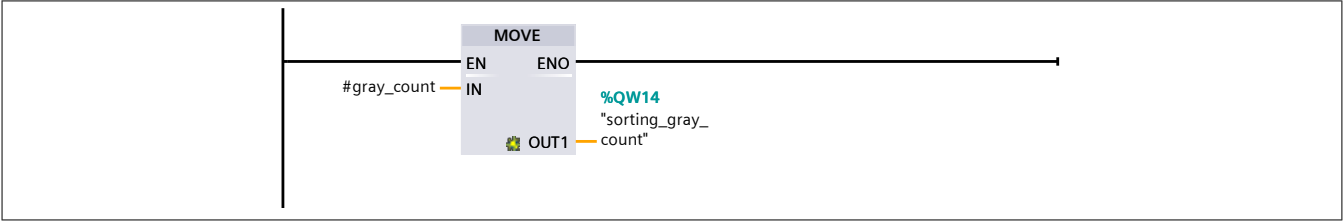
Network 11:



Network 12:



Network 13:



Network 14:

