

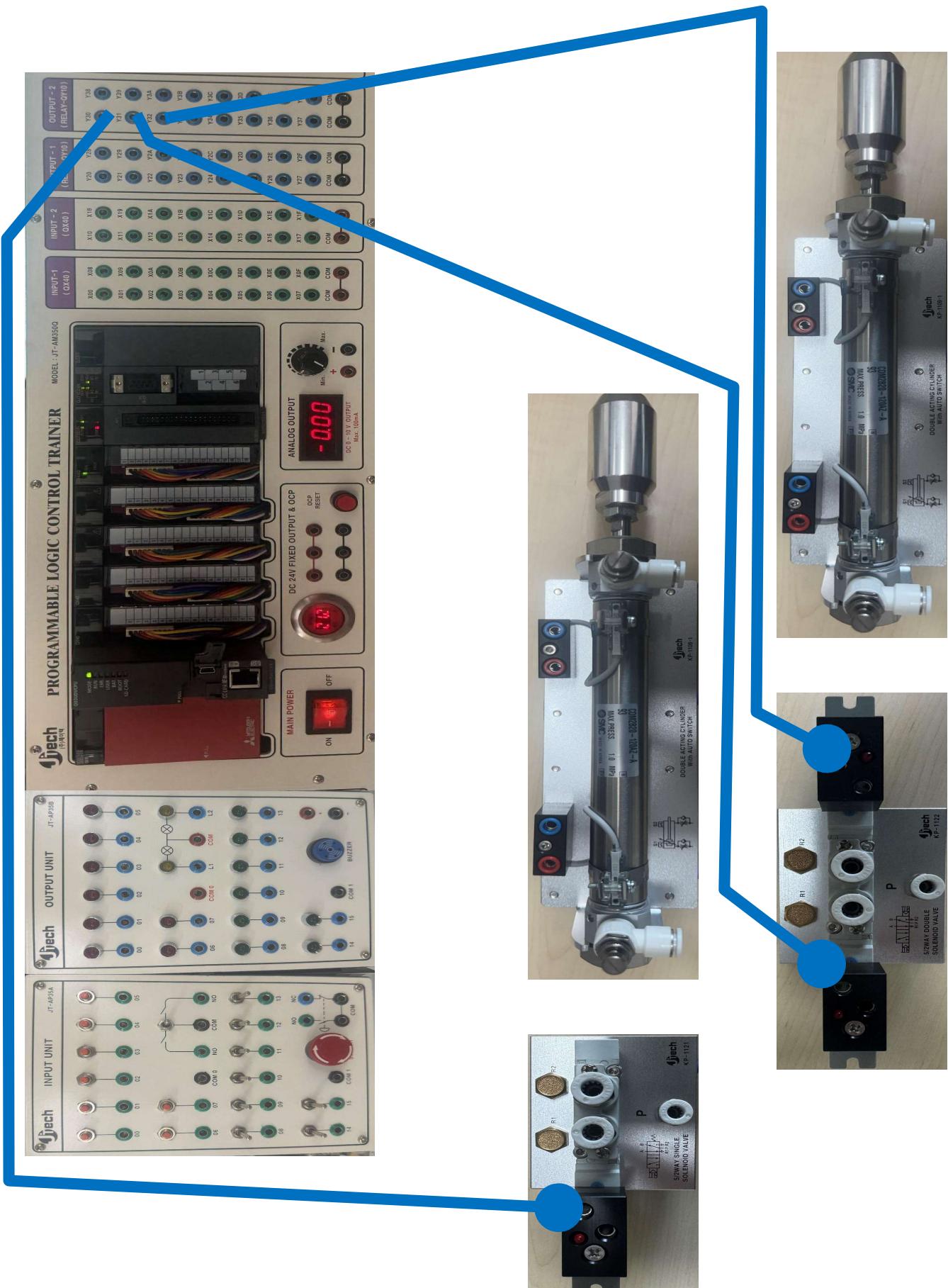
2025.



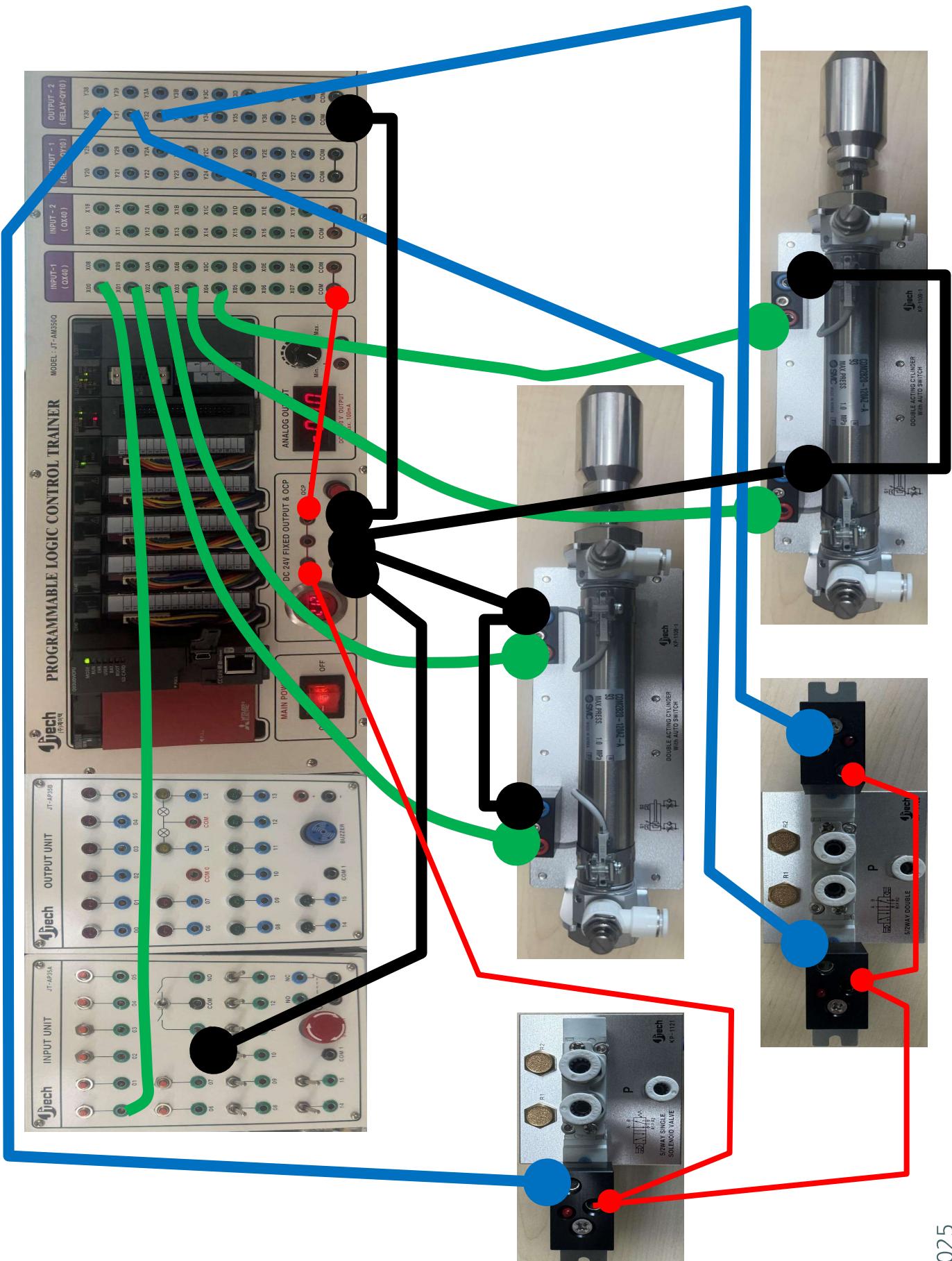
2025.



2025.



2025.



2025.

2025.



2025.

## 스위치 (X0) 를 누르면

디바이스	동작
SM400	상시] ON
SM401	상시] OFF
SM402	Run $\frac{A}{B}$ 1 scan ON
SM403	Run $\frac{B}{A}$ 1 scan OFF
SM409	0.01s clock
SM410	0.1s clock
SM411	0.2s clock
SM412	1s clock
SM413	2s clock

실린더A 후진, 실린더B 후진 (A-B-)  
 실린더A 가 앞으로 움직이게 하시오. (A+)  
 실린더B 가 앞으로 움직이게 하시오.(B+)  
 A+ A-  
 A+ B+ B- A-

PLC 시작하면, 초기화 A- B-  
 X0 누르면(누를때마다) A+ B+ B- A-

스위치 (X0) 를 누르면  
실린더A 후진, 실린더B 후진 (A-B-)

Y30 - OFF  
Y32 - OFF

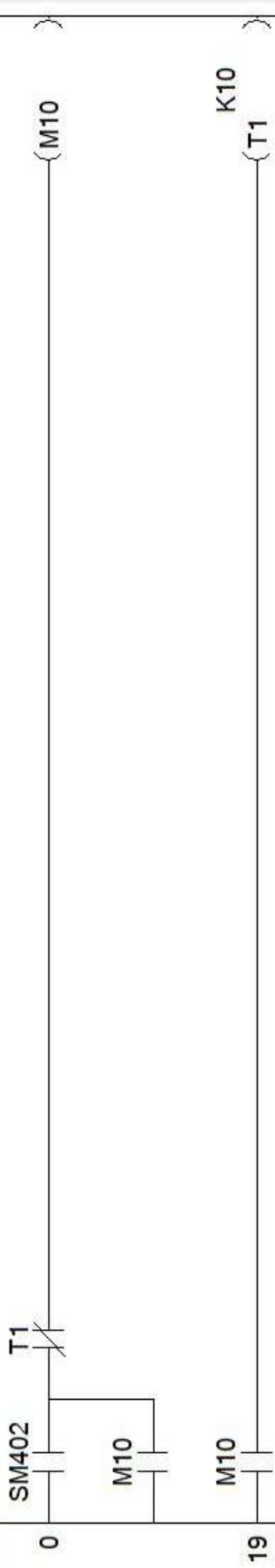
이래를 수록

디바이스	동작
SM400 — —	ON OFF
SM401 — —	ON OFF
SM412 — —	ON OFF
	0.5s 0.5s 0.5s 0.5s 0.5s 0.5s 0.5s
SM400	상시] ON
SM401	상시] OFF
SM402	Run $\frac{1}{7}$ 1 scan ON
SM403	Run $\frac{1}{7}$ 1 scan OFF
SM409	0.01s clock
SM410	0.1s clock
SM411	0.2s clock
SM412	1s clock
SM413	2s clock

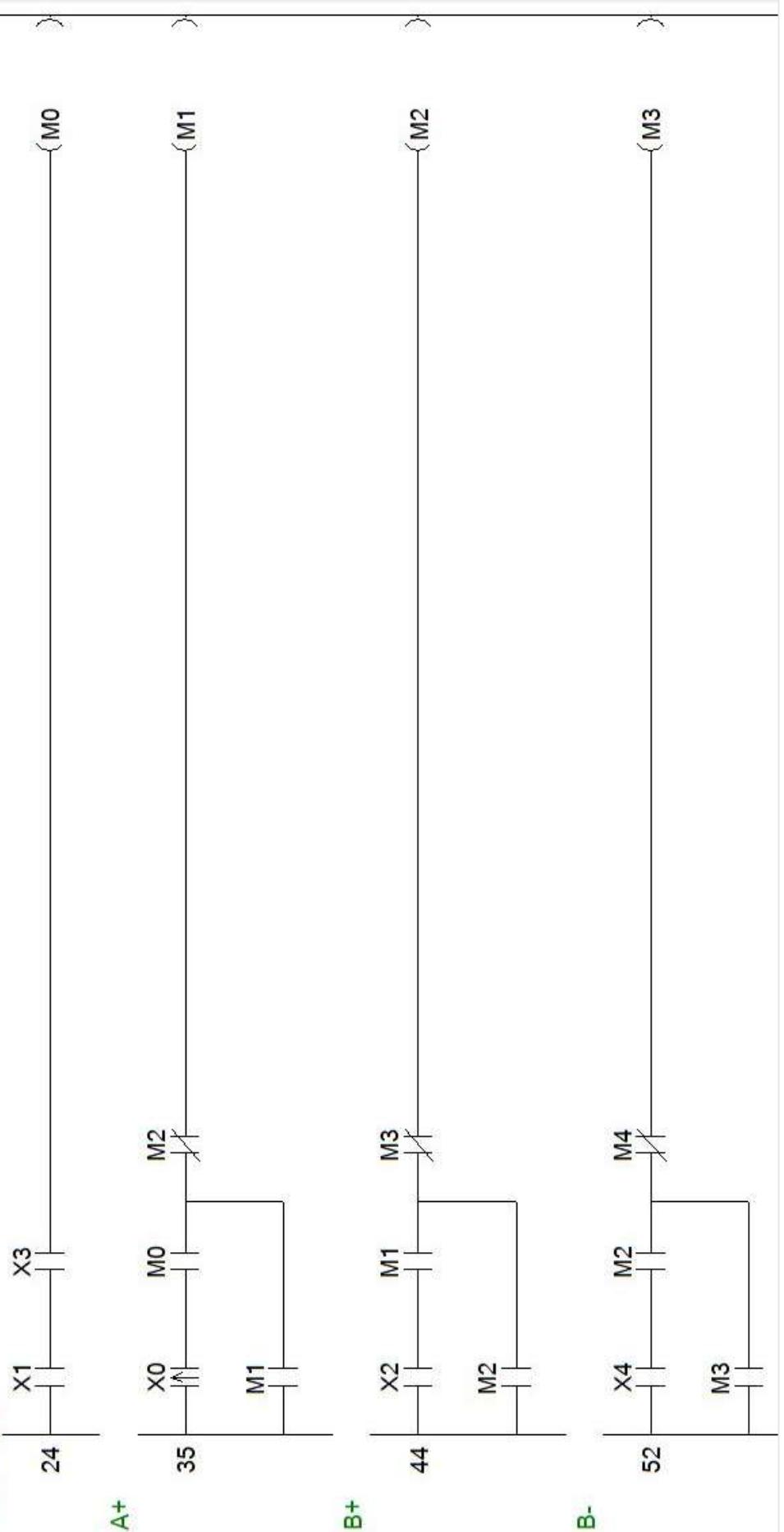
양승 실린더 초기화 포함  
 $A+B+B-A-$

## 초기화

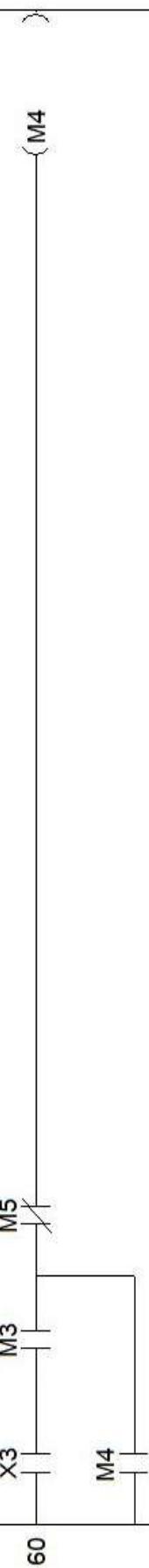
원상타이머 이용



작업준비완료



A-

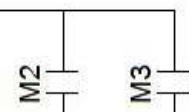


END

출력 A+



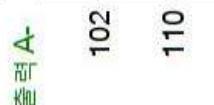
75



출력 B+



93



110

출력 B-