

Totally Integrated Automation Portal		
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WORKS fINALwith tags / PLC\_1 [CPU 1214C DC/DC/DC] / Program blocks

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB	Language	LAD
Numbering	automatic						

Information

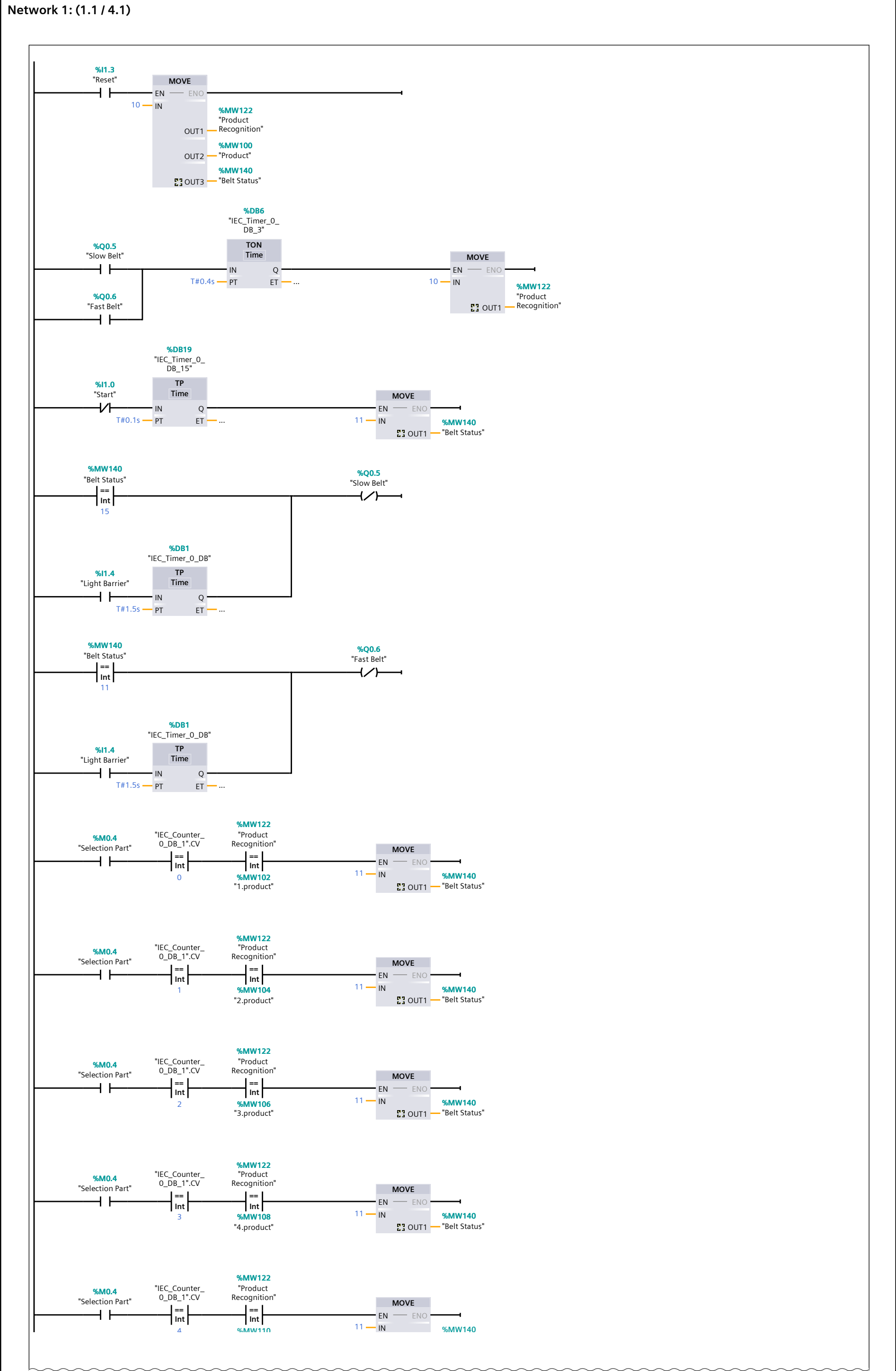
Title	"Main Program Sweep (Cycle)"	Author		Comment		Family	
Version	0.1	User-defined ID					

Main

Name	Data type	Default value	Comment
▼ Input			
Initial_Call	Bool		Initial call of this OB
Remanence	Bool		=True, if remanent data are available
Temp			
Constant			

Network 1:

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1.1 ( Page1 - 2)

Network 1: (2.1 / 4.1)

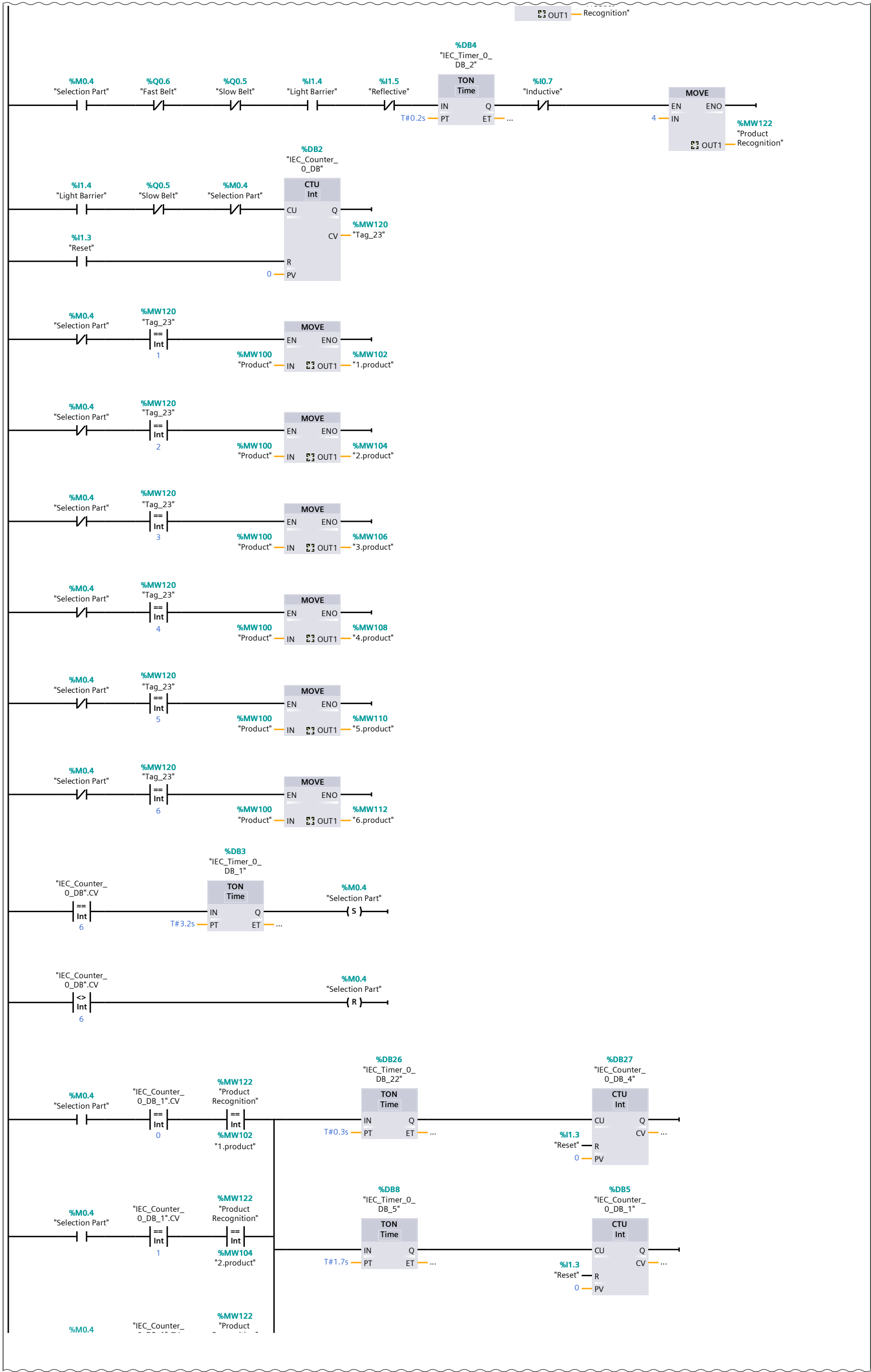
The diagram illustrates a control system for product recognition and belt status. It consists of several rungs of a ladder logic network. Each rung starts with a common input '%M0.4' labeled 'Selection Part'. The logic branches into six main paths, each corresponding to a different product type (1 to 6). Each path uses a combination of normally open and normally closed contacts, including counters ('IEC\_Counter\_0\_DB\_1'.CV) and timers ('IEC\_Timer\_0\_DB\_17' to 'IEC\_Timer\_0\_DB\_21'). The outputs are labeled '%MW122' (Product Recognition) and '%MW140' (Belt Status). The logic also includes a 'MOVE' instruction to transfer data between memory words. The diagram is titled '1.1 ( Page1 - 2)' and 'Network 1: (2.1 / 4.1)'. The logic is as follows:

- Rung 1:** '%M0.4' (NO) - '>= Int 5' (NO) - '%MW122' (NO) - '>= Int 11' (NO) - 'MOVE' (EN) - '%MW140' (OUT1).
- Rung 2:** '%M0.4' (NO) - '<> Int 10' (NO) - '>= Int 0' (NO) - '%MW122' (NO) - '<> Int 10' (NO) - 'TON Time' (IN) - 'T#0.4s' (PT) - 'Q' (ET) - 'MOVE' (EN) - '%MW140' (OUT1).
- Rung 3:** '%M0.4' (NO) - '<> Int 10' (NO) - '>= Int 1' (NO) - '%MW122' (NO) - '<> Int 10' (NO) - 'TON Time' (IN) - 'T#0.4s' (PT) - 'Q' (ET) - 'MOVE' (EN) - '%MW140' (OUT1).
- Rung 4:** '%M0.4' (NO) - '<> Int 10' (NO) - '>= Int 2' (NO) - '%MW122' (NO) - '<> Int 10' (NO) - 'TON Time' (IN) - 'T#0.4s' (PT) - 'Q' (ET) - 'MOVE' (EN) - '%MW140' (OUT1).
- Rung 5:** '%M0.4' (NO) - '<> Int 10' (NO) - '>= Int 3' (NO) - '%MW122' (NO) - '<> Int 10' (NO) - 'TON Time' (IN) - 'T#0.4s' (PT) - 'Q' (ET) - 'MOVE' (EN) - '%MW140' (OUT1).
- Rung 6:** '%M0.4' (NO) - '<> Int 10' (NO) - '>= Int 4' (NO) - '%MW122' (NO) - '<> Int 10' (NO) - 'TON Time' (IN) - 'T#0.4s' (PT) - 'Q' (ET) - 'MOVE' (EN) - '%MW140' (OUT1).
- Rung 7:** '%M0.4' (NO) - '<> Int 10' (NO) - '>= Int 5' (NO) - '%MW122' (NO) - '<> Int 10' (NO) - 'TON Time' (IN) - 'T#0.4s' (PT) - 'Q' (ET) - 'MOVE' (EN) - '%MW140' (OUT1).
- Rung 8:** '%Q0.5' (NO) - '%Q0.6' (NO) - '%I1.5' (NO) - '%I0.7' (NO) - '%I1.4' (NO) - 'MOVE' (EN) - '%MW100' (OUT1).
- Rung 9:** '%Q0.5' (NO) - '%Q0.6' (NO) - '%I1.5' (NO) - '%I0.7' (NO) - '%I1.4' (NO) - 'MOVE' (EN) - '%MW100' (OUT1).
- Rung 10:** '%Q0.5' (NO) - '%Q0.6' (NO) - '%I1.4' (NO) - '%I0.7' (NO) - '%I1.5' (NO) - 'MOVE' (EN) - '%MW100' (OUT1).
- Rung 11:** '%M0.4' (NO) - '%Q0.5' (NO) - '%Q0.6' (NO) - '%I1.4' (NO) - '%I1.5' (NO) - '%I0.7' (NO) - 'MOVE' (EN) - '%MW122' (OUT1).
- Rung 12:** '%M0.4' (NO) - '%Q0.6' (NO) - '%Q0.5' (NO) - '%I1.4' (NO) - '%I1.5' (NO) - '%I0.7' (NO) - 'MOVE' (EN) - '%MW122' (OUT1).

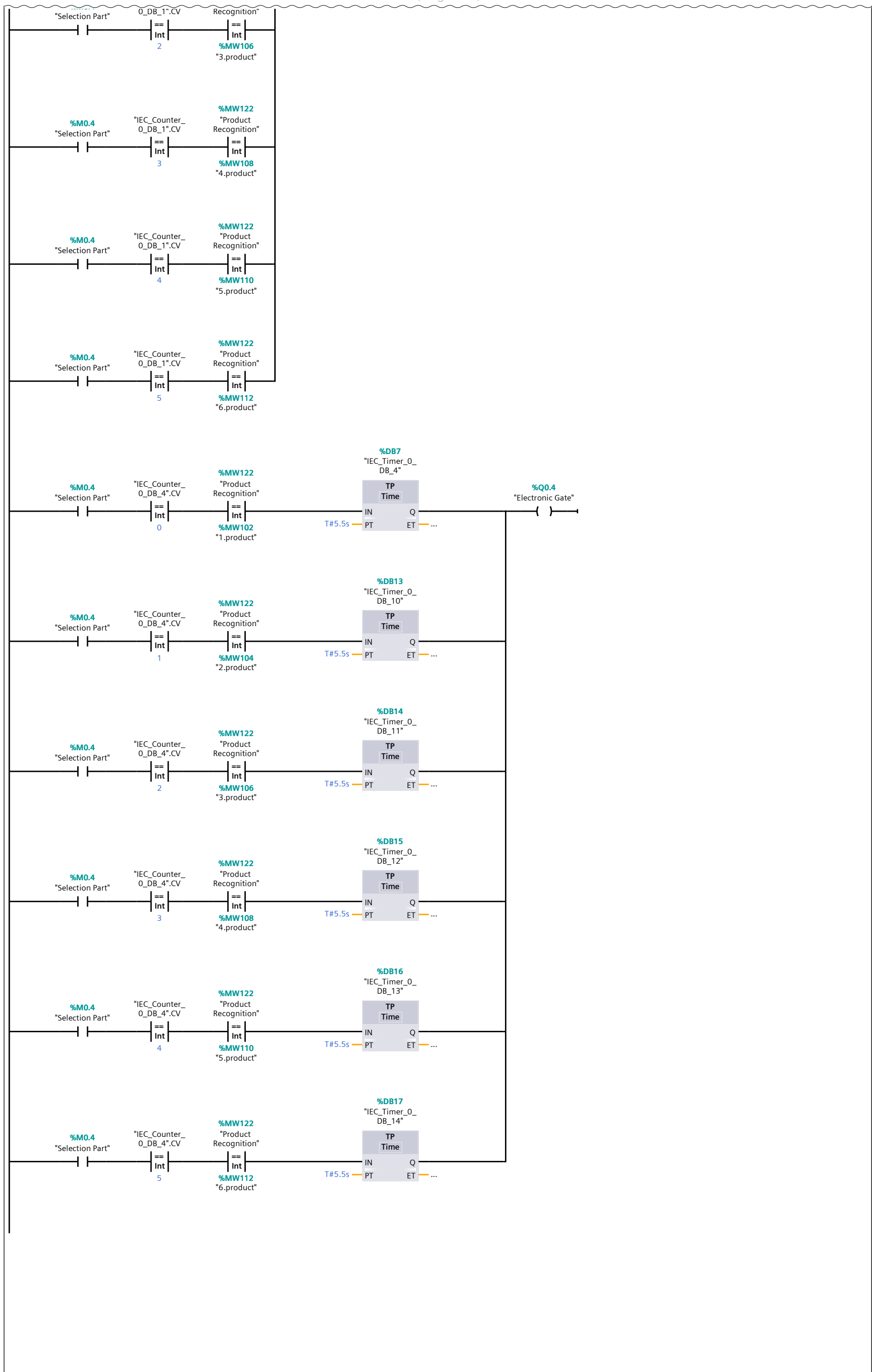
3.1 ( Page1 - 4)

**Network 1: (3.1 / 4.1)**

2.1 ( Page1 - 3)



4.1 ( Page1 - 5)

[illegible]

Totally Integrated Automation Portal				
Symbol	Address	Type	Comment	
"1.product"	%MW102	Int		
"2.product"	%MW104	Int		
"3.product"	%MW106	Int		
"4.product"	%MW108	Int		
"5.product"	%MW110	Int		
"6.product"	%MW112	Int		
"Belt Status"	%MW140	Int		
"Electronic Gate"	%Q0.4	Bool		
"Fast Belt"	%Q0.6	Bool		
"IEC_Counter_0_DB".CV		Int		
"IEC_Counter_0_DB_1".CV		Int		
"IEC_Counter_0_DB_4".CV		Int		
"Inductive"	%I0.7	Bool		
"Light Barrier"	%I1.4	Bool		
"Product Recognition"	%MW122	Int		
"Product"	%MW100	Int	Metal	
"Reflective"	%I1.5	Bool		
"Reset"	%I1.3	Bool		
"Selection Part"	%M0.4	Bool		
"Slow Belt"	%Q0.5	Bool		
"Start"	%I1.0	Bool		
"Tag_23"	%MW120	Int		
Network 2:				
<div><div></div><div></div></div>				
Symbol	Address	Type	Comment	
Network 3:				

