WORKS fİNALwith tags / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks

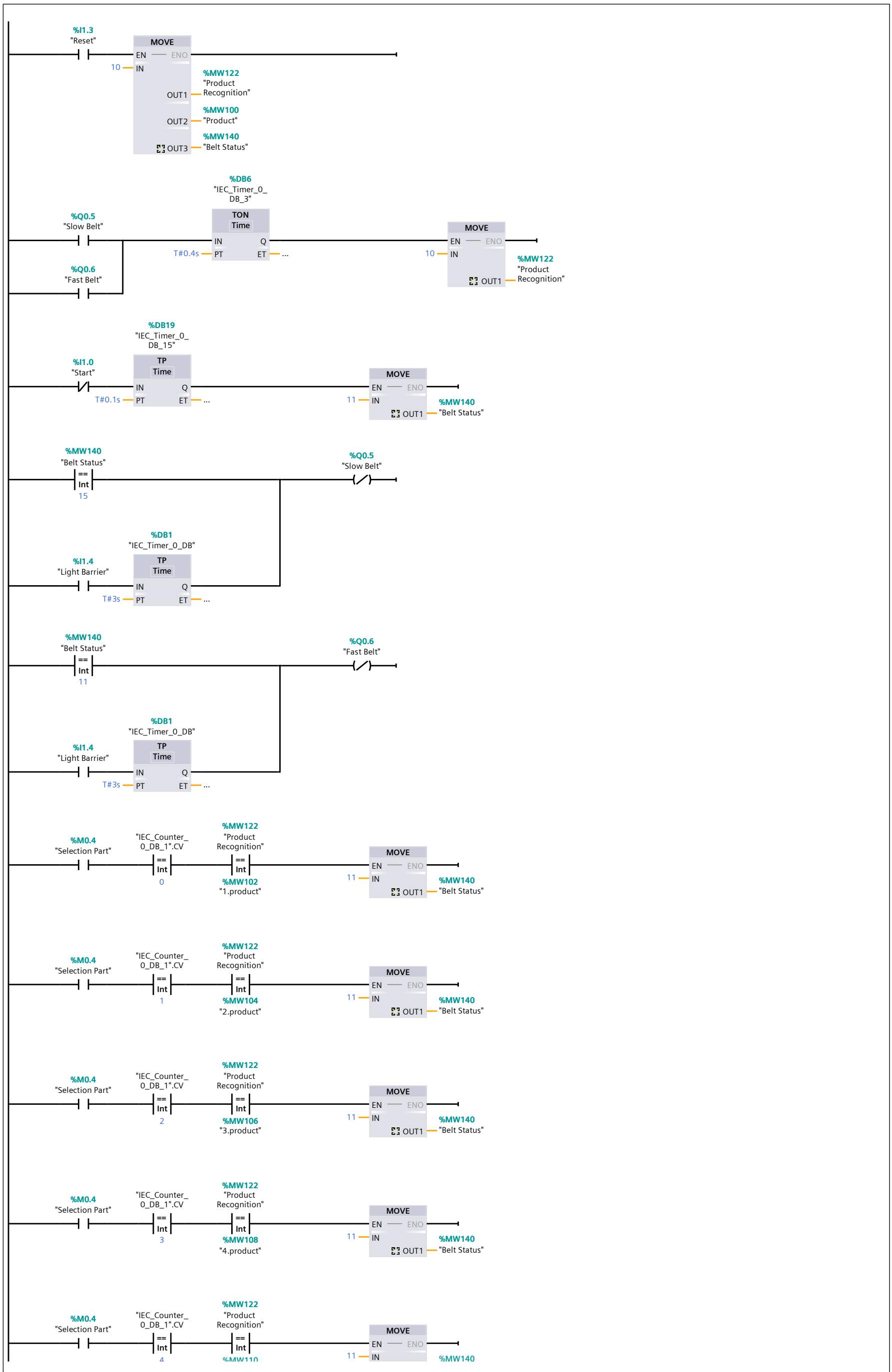
Main [OB1]

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			

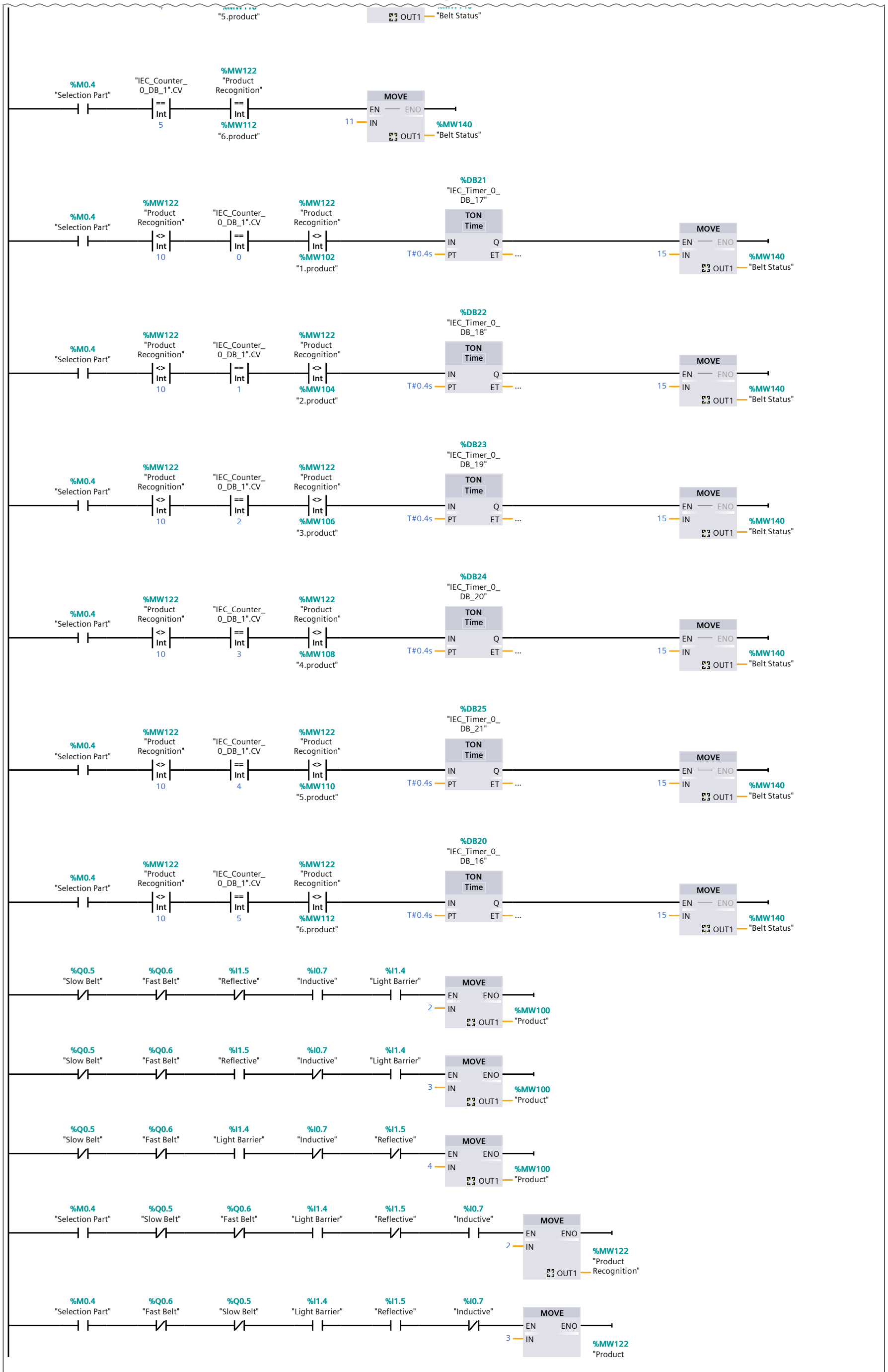
Network 1:

Network 1: (1.1 / 4.1)



Network 1: (2.1 / 4.1)

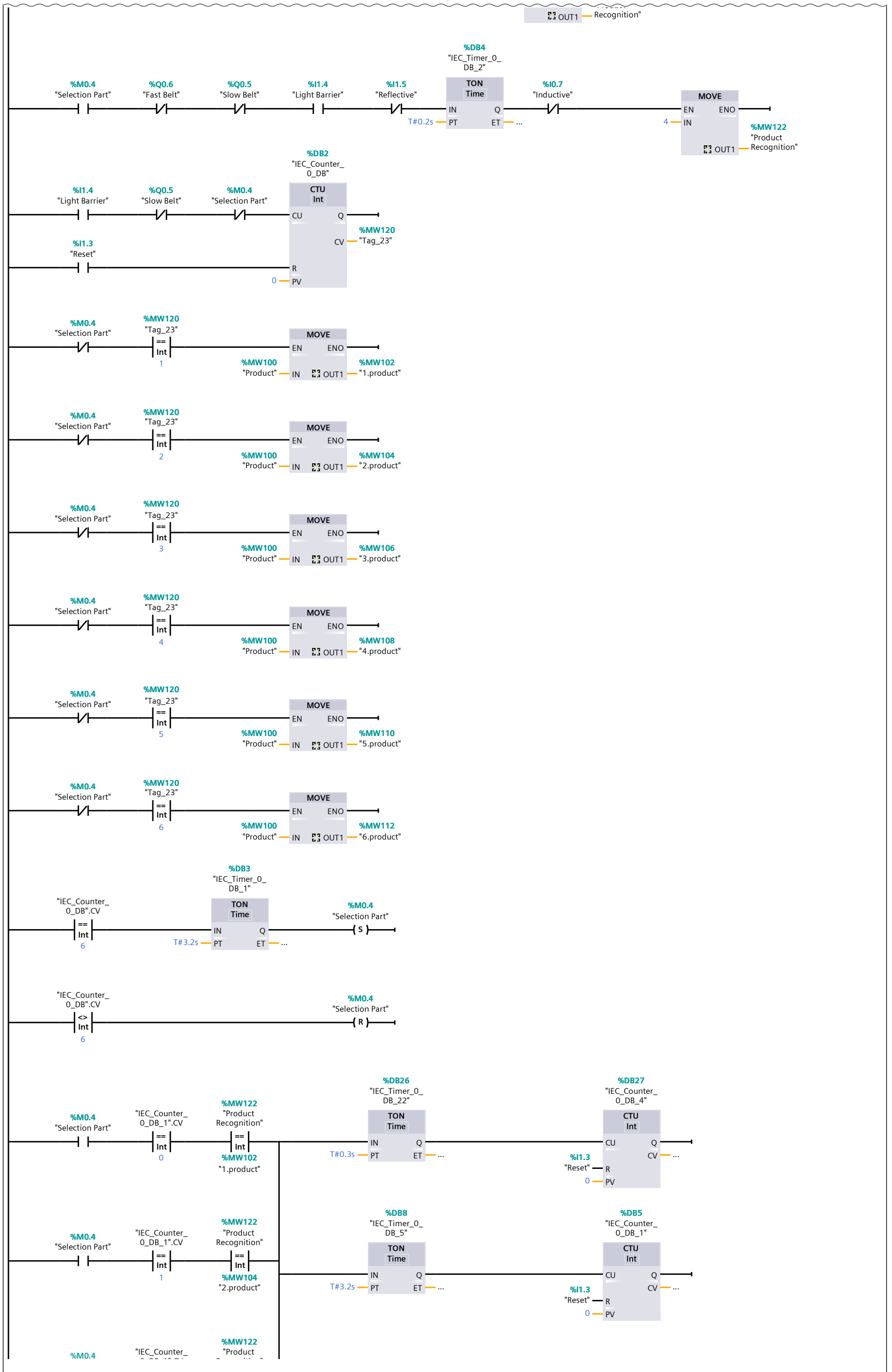
1.1 (Page1 - 2)



3.1 (Page1 - 4)

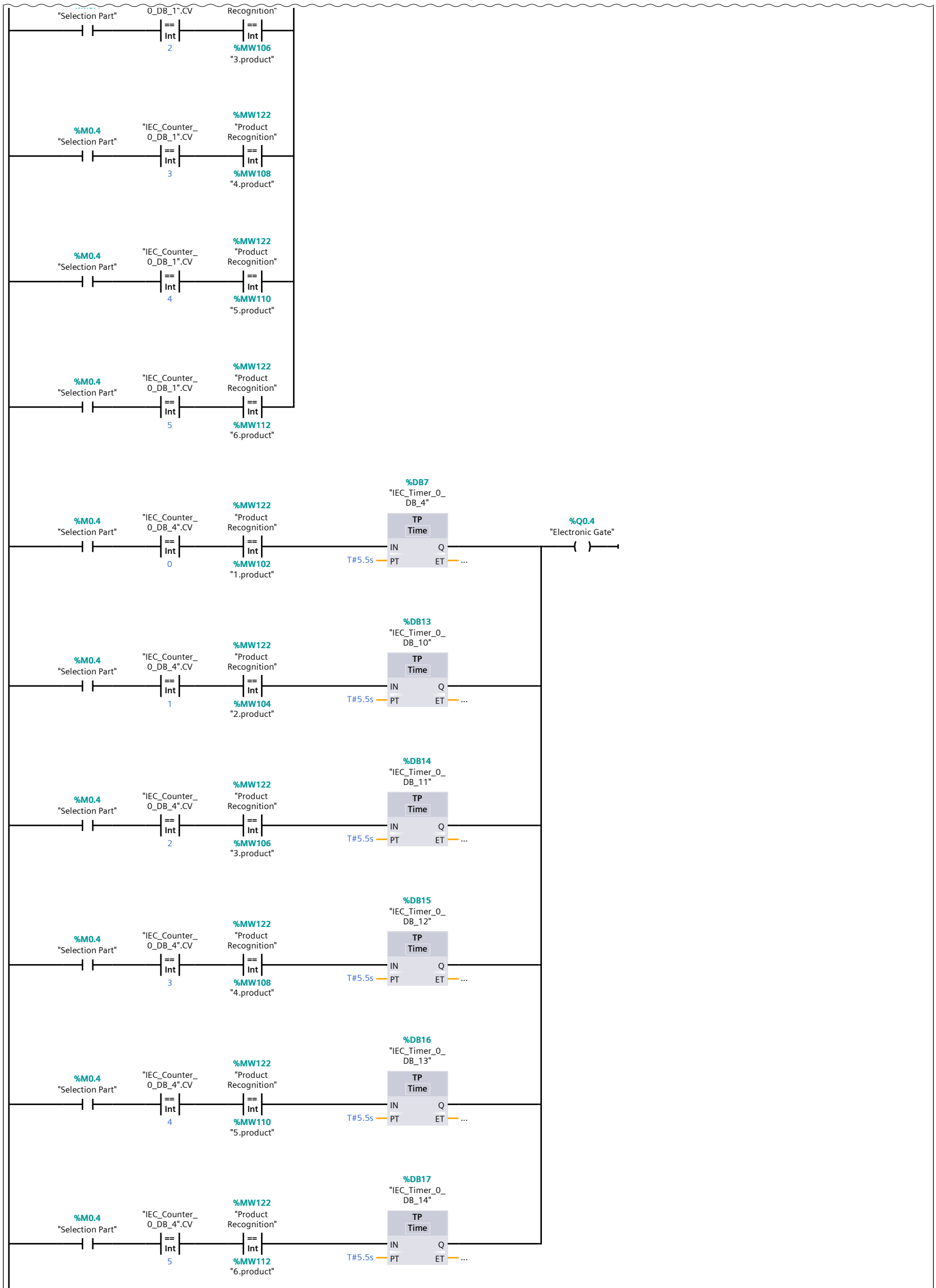
Network 1: (3.1 / 4.1)

2.1 (Page1 - 3)



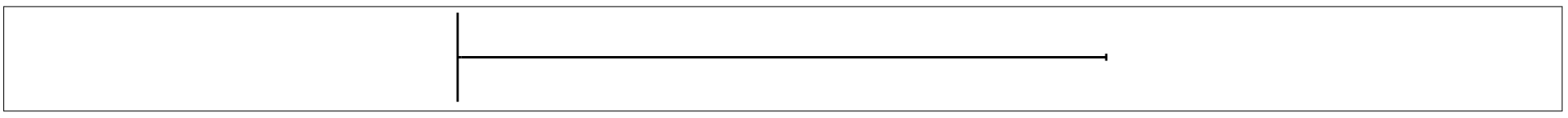
4.1 (Page1 - 5)

Network 1: (4.1 / 4.1)



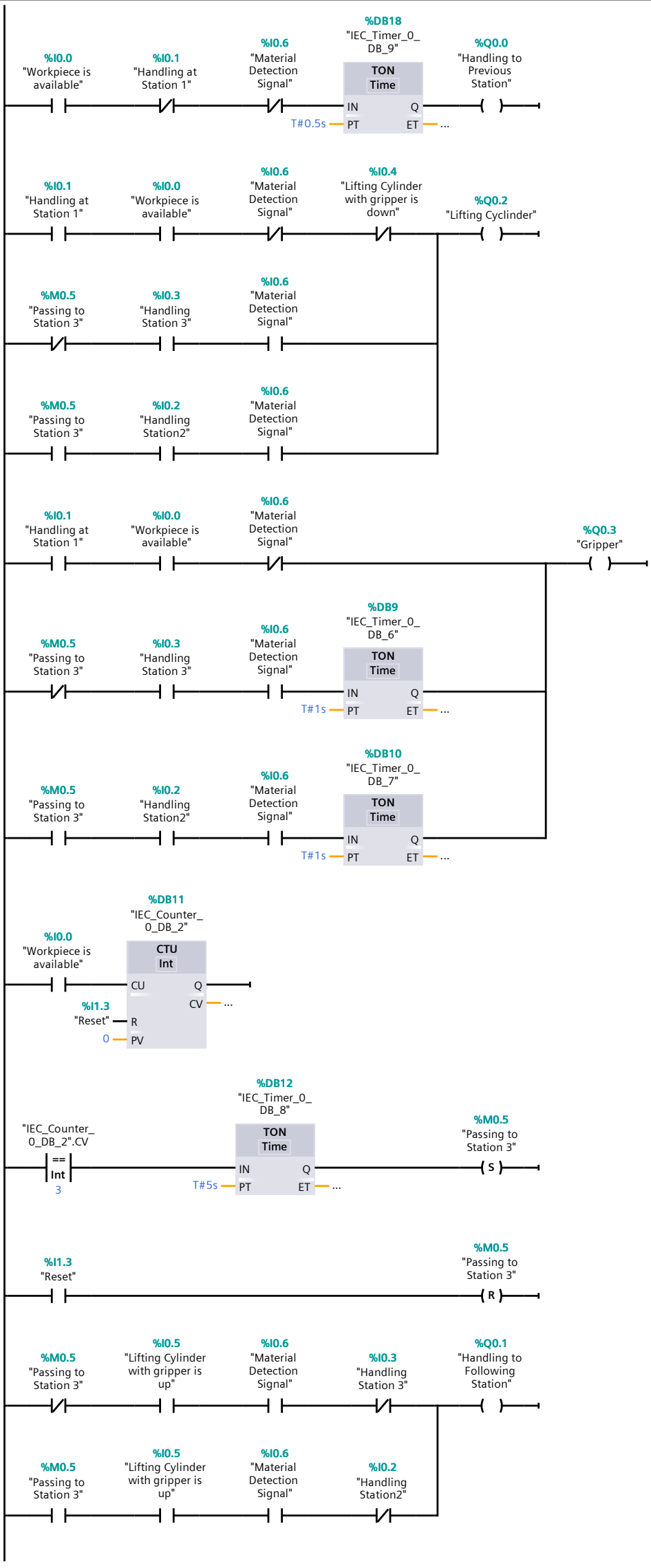
Symbol	Address	Type	Comment
"1.product"	%MW102	Int	
"2.product"	%MW104	Int	
"3.product"	%MW106	Int	
"4.product"	%MW108	Int	
"5.product"	%MW110	Int	
"6.product"	%MW112	Int	
"Belt Status"	%MW140	Int	
"Electronic Gate"	%Q0.4	Bool	
"Fast Belt"	%Q0.6	Bool	
"IEC_Counter_0_DB".CV		Int	
"IEC_Counter_0_DB_1".CV		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:



Symbol	Address	Type	Comment

Network 3:



Symbol	Address	Type	Comment
"Gripper"	%Q0.3	Bool	
"Handling at Station 1"	%I0.1	Bool	
"Handling Station2"	%I0.2	Bool	
"Handling Station 3"	%I0.3	Bool	
"Handling to Following Station"	%Q0.1	Bool	
"Handling to Previous Station"	%Q0.0	Bool	
"IEC_Counter_0_DB_2".CV		Int	
"Lifting Cyclinder"	%Q0.2	Bool	
"Lifting Cylinder with gripper is down"	%I0.4	Bool	
"Lifting Cylinder with gripper is up"	%I0.5	Bool	
"Material Detection Signal"	%I0.6	Bool	
"Passing to Station 3"	%M0.5	Bool	
"Reset"	%I1.3	Bool	
"Workpiece is available"	%I0.0	Bool	