

Totally Integrated Automation Portal

FactoryIO\_Template\_S7-1200\_V15\_V16 / PLC\_1 [CPU 1211C 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:

%FC9000

"MHJ-PLC-Lab-Function-S71200"

EN

ENO

Network 2: System Start

%M10.0

"HMI\_Start\_But"

%M10.1

"HMI\_Stop\_But"

%M10.2

"System Start Mem"

SR

S

R1

Q

Network 3: Görüntü Senörü Değerini kaydetme

Sensor Value 1 ise Cisim Mavi.  
4 ise cisim yeşil.  
Hiçbirşey görmüyorsa 0 değeri üretecek.

%M10.2

"System Start Mem"

%IW30

"wColorSensor"

Int

1

%IW30

"wColorSensor"

Int

4

MOVE

EN

ENO

IN

OUT1

%MW12

"Color\_Mem"

Network 4: KOnveyörler çalışma

%M10.2

"System Start Mem"

%MW12

"Color\_Mem"

Int

0

%MW12

"Color\_Mem"

Int

0

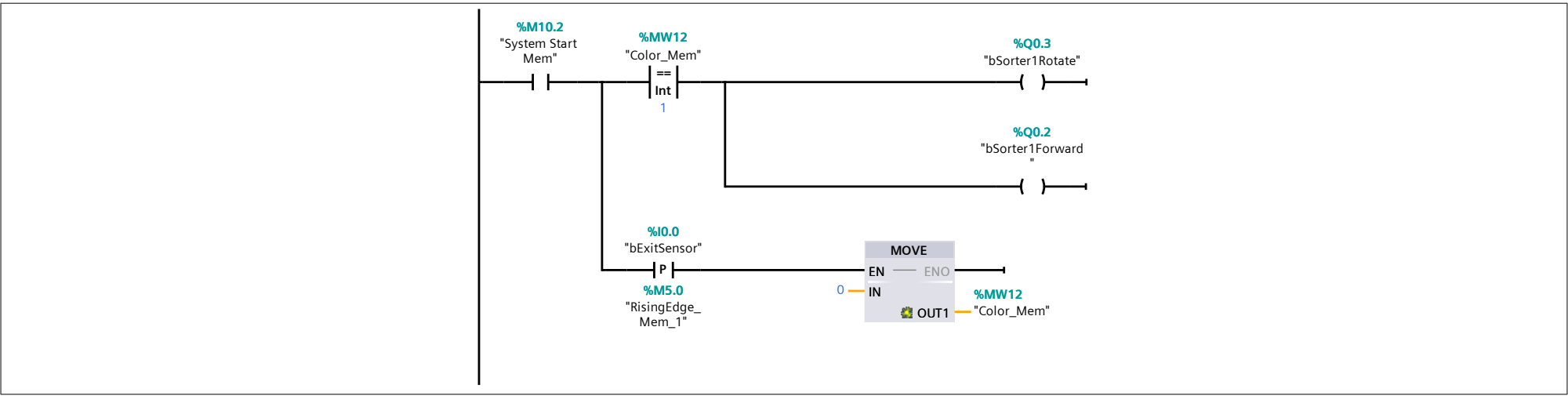
%Q0.0

"bConveyor1"

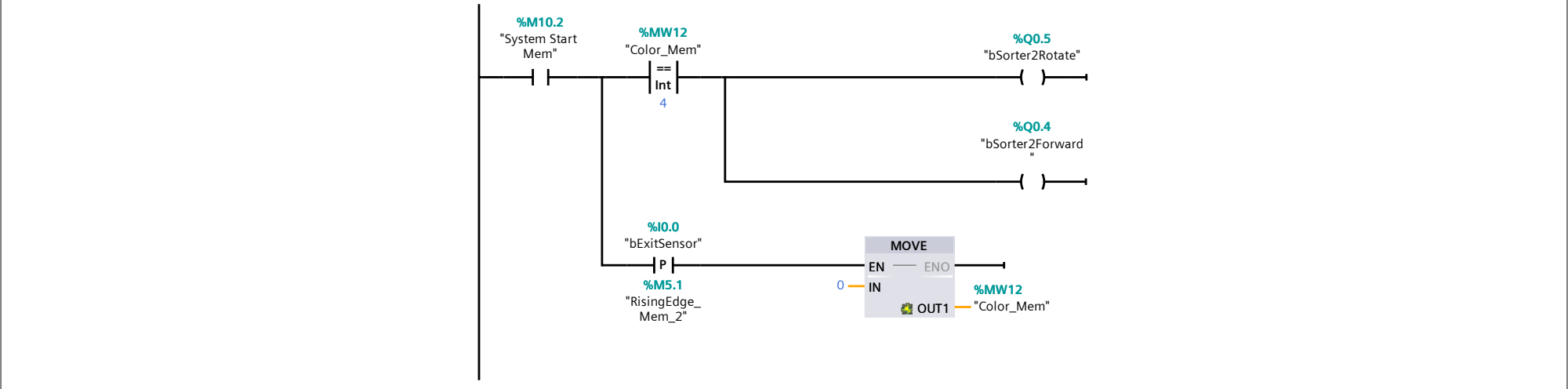
%Q0.1

"bConveyor2"

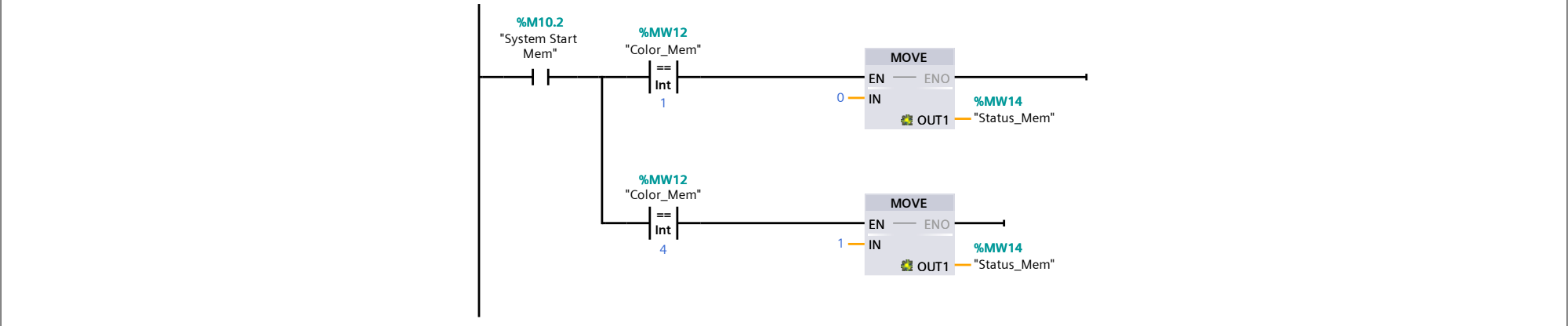
Network 5: Mavi ürün geldi Ayırıcı 1 çalışması



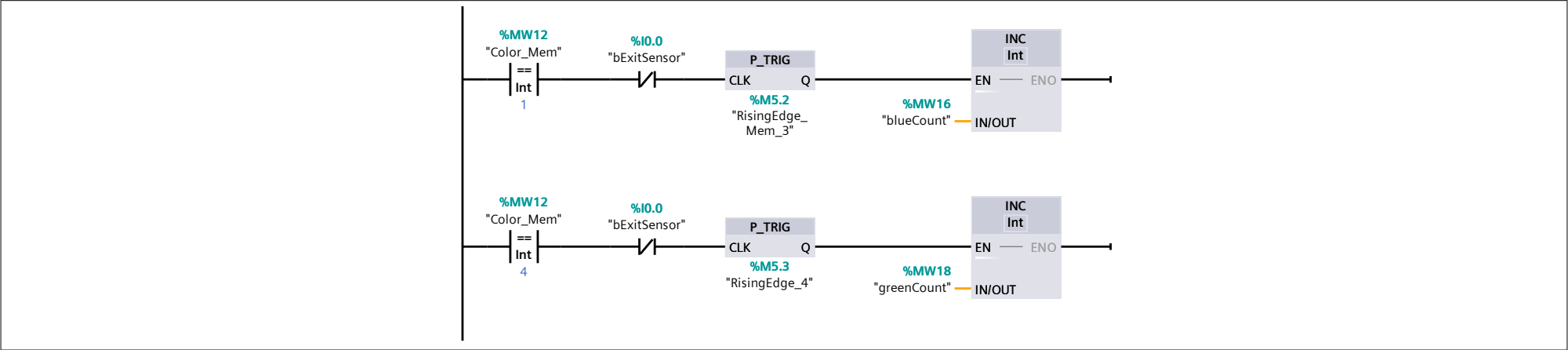
**Network 6: Çıkış sensörü gördükten sonra görünümü memoriyi sıfırlıcaz**



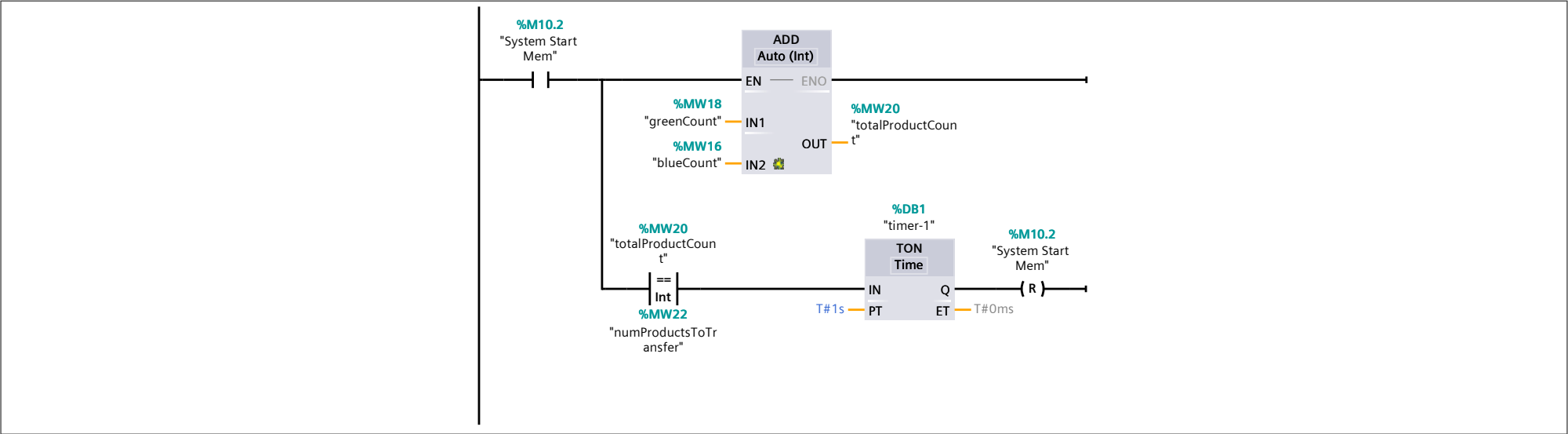
## Network 7: HMI DURUM BİLGİSİ



**Network 8: Transfer olan mavi ve yeşil ürünü sayma**



**Network 9: Transfer olacak toplam ürün sayısını hesaplama ve çalışmayı durdurma**



Network 10: Sistemi Resettle

