

Escena13_ST

```
1|      10|      20|      30|      40|      50|      60|      70|      80|      90|     100|     110|
1  R_TRIG_0 (CLK := start);
2  if em_stop and stop and not reseteo and R_TRIG_0.Q then
3      start_light:=1;
4      stop_light:=0;
5      reset_light:=0;
6      %M50:=0;
7  end_if;
8
9  if not stop and not auto then
10     entry_conveyor:=0;
11     start_light:=0;
12     stop_light:=1;
13 end_if;
14 (*-----modo automático*)
15 if start_light and em_stop and auto then
16
17     if R_TRIG_0.Q then
18         feeder_conveyor:=1;
19         aux_cont:=0;
20     end_if;
21     R_TRIG_1 (CLK := at_entry);
22     if R_TRIG_1.Q then
23         entry_conveyor:=1;
24     end_if;
25     F_TRIG_1 (CLK := at_entry);
26     if F_TRIG_1.Q then
27         feeder_conveyor:=0;
28     end_if;
29
30     if high_box then
31         grande:=1;
32     end_if;
33     if low_box then
34         peque:=1;
35     end_if;
36
37     R_TRIG_2 (CLK := at_turn_entry);
38     if R_TRIG_2.Q then
39         load:=1;
40     end_if;
41     F_TRIG_2 (CLK := at_turn_entry);
42     if F_TRIG_2.Q then
43         entry_conveyor:=0;
44     end_if;
45
46     F_TRIG_3 (CLK := at_back);
47     if F_TRIG_3.Q and not at_unload_position then
48         load:=0;
49     end_if;
50
51     if (grande or peque) and F_TRIG_3.Q then
52         turn:=1;
53     end_if;
54 (*-----caja grande*)
55     R_TRIG_3 (CLK := at_unload_position);
56     if R_TRIG_3.Q and grande and peque then
57         unload:=1;
58     end_if;
59
60     R_TRIG_4 (CLK := at_right_entry);
61     if R_TRIG_4.Q and grande and peque then
62         right_conveyor:=1;
63     end_if;
64     F_TRIG_4 (CLK := at_right_entry);
65     if F_TRIG_4.Q and grande and peque then
66         unload:=0;
67         turn:=0;
68         grande:=0;
69         peque:=0;
70     end_if;
71
72     F_TRIG_6 (CLK := at_right_exit);
73     if F_TRIG_6.Q then
74         right_conveyor:=0;
75     end_if;
76 (*-----caja pequeña*)
77     R_TRIG_5 (CLK := at_unload_position);
78     if R_TRIG_5.Q and peque and not grande then
79         load:=1;
80     end_if;
81
82     R_TRIG_6 (CLK := at_left_entry);
83     if R_TRIG_6.Q and peque and not grande then
84         left_conveyor:=1;
85     end_if;
86     F_TRIG_5 (CLK := at_left_entry);
87     if F_TRIG_5.Q and peque and not grande then
88         load:=0;
89         turn:=0;
90         peque:=0;
91     end_if;
92
93     F_TRIG_7 (CLK := at_left_exit);
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1|      10|      20|      30|      40|      50|      60|      70|      80|      90|     100|     110|
94          if F_TRIG_7.Q then
95              left_conveyor:=0;
96          end_if;
97
98          R_TRIG_7 (CLK := at_left_exit);
99          R_TRIG_8 (CLK := at_right_exit);
100         F_TRIG_8 (CLK := at_left_exit);
101         F_TRIG_9 (CLK := at_right_exit);
102
103
104
105
106
107         if (R_TRIG_7.Q or R_TRIG_8.Q) then
108             feeder_conveyor:=1;
109
110         end_if;
111         if (F_TRIG_8.Q or F_TRIG_9.Q) and cont>3 and %M50 then
112             feeder_conveyor:=0;
113             entry_conveyor:=0;
114             turn:=0;
115             start_light:=0;
116             reset_light:=1;
117             load:=0;
118             right_conveyor:=0;
119             left_conveyor:=0;
120         end_if;
121
122
123
124
125     end_if;
126
127
128
129
130     (*-----Reseteo*)
131
132     R_TRIG_9 (CLK := reseteo);
133     if r_trig_9.q then
134         %M51:=0;
135     end_if;
136     if (R_TRIG_9.Q and not start_light) or not em_stop then
137         feeder_conveyor:=0;
138         entry_conveyor:=0;
139         turn:=0;
140         start_light:=0;
141         reset_light:=1;
142         load:=0;
143         right_conveyor:=0;
144         left_conveyor:=0;
145         aux_cont:=1;
146     end_if;
147
148     if %M51 and %s6 then
149         reset_light:=1;
150     end_if;
151     if %M51 and not %s6 then
152         reset_light:=0;
153     end_if;
154
155     F_TRIG_0 (CLK := stop);
156     if F_TRIG_0.Q then
157         stop_light:=1;
158         %M50:=1;
159     end_if;
160
161     F_TRIG_10 (CLK := em_stop);
162     if F_TRIG_10.Q then
163         %M51:=1;
164     end_if;
165
166
167
168     (*-----modo manual*)
169     if start_light and em_stop and manual then
170
171         if R_TRIG_0.Q then
172             feeder_conveyor:=1;
173             aux_cont:=0;
174         end_if;
175
176         R_TRIG_10 (CLK := at_entry);
177         if R_TRIG_10.Q then
178             entry_conveyor:=1;
179         end_if;
180
181         F_TRIG_11 (CLK := at_entry);
182         if F_TRIG_11.Q then
183             feeder_conveyor:=0;
184         end_if;
185
186         if high_box then
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1|      10|      20|      30|      40|      50|      60|      70|      80|      90|      100|      110|
187         grande:=1;
188     end_if;
189     if low_box then
190         peque:=1;
191     end_if;
192
193     R_TRIG_11 (CLK := at_turn_entry);
194     if R_TRIG_11.Q then
195         load:=1;
196     end_if;
197
198     F_TRIG_12 (CLK := at_turn_entry);
199     if F_TRIG_12.Q then
200         entry_conveyor:=0;
201     end_if;
202
203     F_TRIG_13 (CLK := at_back);
204     if F_TRIG_13.Q and not at_unload_position then
205         load:=0;
206     end_if;
207
208     if (grande or peque) and F_TRIG_3.Q then
209         turn:=1;
210     end_if;
211     (*-----caja grande*)
212
213     R_TRIG_12 (CLK := at_unload_position);
214     if R_TRIG_12.Q and grande and peque then
215         unload:=1;
216     end_if;
217
218     R_TRIG_13 (CLK := at_right_entry);
219     if R_TRIG_13.Q and grande and peque then
220         right_conveyor:=1;
221     end_if;
222
223     F_TRIG_14 (CLK := at_right_entry);
224     if F_TRIG_14.Q and grande and peque then
225         unload:=0;
226         turn:=0;
227         grande:=0;
228         peque:=0;
229     end_if;
230
231     F_TRIG_15 (CLK := at_right_exit);
232     if F_TRIG_15.Q then
233         right_conveyor:=0;
234         start_light:=0;
235         aux_cont:=1;
236     end_if;
237     (*-----caja pequeña*)
238
239     R_TRIG_14 (CLK := at_unload_position);
240     if R_TRIG_14.Q and peque and not grande then
241         load:=1;
242     end_if;
243
244     R_TRIG_15 (CLK := at_left_entry);
245     if R_TRIG_15.Q and peque and not grande then
246         left_conveyor:=1;
247     end_if;
248
249     F_TRIG_16 (CLK := at_left_entry);
250     if F_TRIG_16.Q and peque and not grande then
251         load:=0;
252         turn:=0;
253         peque:=0;
254     end_if;
255
256     F_TRIG_17 (CLK := at_left_exit);
257     if F_TRIG_17.Q then
258         left_conveyor:=0;
259         start_light:=0;
260     end_if;
261
262 end_if;
263
264
265
266
267
268
269 CTU_0 (CU := at_entry,
270        R := aux_cont,
271        CV => cont);

```