

Escena13_ST

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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 pequе 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         if (R_TRIG_7.Q or R_TRIG_8.Q) then
107             feeder_conveyor:=1;
108
109         end_if;
110         if (F_TRIG_8.Q or F_TRIG_9.Q) and cont>3 and %M50 then
111             feeder_conveyor:=0;
112             entry_conveyor:=0;
113             turn:=0;
114             start_light:=0;
115             reset_light:=1;
116             load:=0;
117             right_conveyor:=0;
118             left_conveyor:=0;
119         end_if;
120
121
122
123
124
125
126     end_if;
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);
```