FC3 - <offline>

"Table Station"

Nombre: **Familia:**
Autor: **Versión:** 0.1
Versión del bloque: 2
Hora y fecha Código: 22/08/2022 15:22:18
Interface: 18/08/2022 10:00:20
Longitud (bloque / código / datos): 00446 00302 00000

Nombre	Tipo de datos	Dirección	Comentario
IN		0.0	
OUT		0.0	
IN_OUT		0.0	
TEMP		0.0	
RETURN		0.0	
RET_VAL		0.0	

Bloque: FC3 TURN TABLE MANAGEMENT

Segm.: 1

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////////////////////////////////////////////////////////////////////////////////////////////////
//************************** TURN TABLE FINITE STATE MACHINE (FSM) ******************************//
////////////////////////////////////////////////////////////////////////////////////////////////

// If Systeme is Active => Enter into the State machine
      U     "systemActive"                      M10.0
      SPBN  _020

      L     "turnTableState"                    MW24

      SPL   _021

      SPA   CERO
      SPA   ONE
      SPA   TWO
      SPA   THRE
      SPA   FOUR
      SPA   FIVE
      SPA   SIX

_021: SPA   OUT


//********* RESET ALL THE TABLE OUTPUTS *************//
CERO: R     "Var System Outputs".load           DB2.DBX0.2
      R     "Var System Outputs".unLoad         DB2.DBX0.3
      R     "Var System Outputs".turnTable      DB2.DBX0.4

// If Turn Table => New State
      U     "Var System Inputs".turnTableEntry  DB1.DBX0.7
      FP    "OnsLoadAct"                        M255.3
      O
      U     "Var System Inputs".turnTableEntry  DB1.DBX0.7
      U     "Var System Inputs".loadPosition    DB1.DBX1.1        -- "NC"
      FP    "OnsReLoadBox"                      M254.7
      SPBN  _022
      L     1
      T     "turnTableState"                    MW24
_022: NOP   0
      SPA   END


//********* SET LOAD BOX INTO TURN TABLE *************//
ONE:  S     "Var System Outputs".load           DB2.DBX0.2

// If box at front sensor => New State
      U     "Var System Inputs".atFront         DB1.DBX1.2
      SPBN  _023
      L     2
      T     "turnTableState"                    MW24
_023: NOP   0
      SPA   END
```

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//********* RESET LOAD, SET TURN TABLE AND BOX PATH SELECTION *************//
TWO:  R     "Var System Outputs".load           DB2.DBX0.2
      S     "Var System Outputs".turnTable      DB2.DBX0.4

// If large box detected and at unload position => New State
      U     "largeBox"                          M20.2
      SPBN  _024
      L     3
      T     "turnTableState"                    MW24
_024: NOP   0

// If Not large box detected and at unload position => New State
      UN    "largeBox"                          M20.2
      SPBN  _025
      L     5
      T     "turnTableState"                    MW24
_025: NOP   0
      SPA   END


//********* LARGE BOX PATH (LEFT CONVEYOR)******************//
THRE: U     "Var System Inputs".unLoadPosition  DB1.DBX1.0
      SPBN  _026
      L     4
      T     "turnTableState"                    MW24
_026: NOP   0
      SPA   END


//********* SMALL BOX LEAVING PATH (RIGHT CONVEYOR)******************//
FOUR: S     "Var System Outputs".load           DB2.DBX0.2

// If negative edge sensor left entry => State 0
      U     "Var System Inputs".leftEntry       DB1.DBX1.4
      FN    "OnsLeftLeaving"                    M255.0
      SPBN  _027
      L     0
      T     "turnTableState"                    MW24
_027: NOP   0
      SPA   END

//********* SMALL BOX LEAVING PATH (RIGHT CONVEYOR)******************//
FIVE: U     "Var System Inputs".unLoadPosition  DB1.DBX1.0
      SPBN  _028
      L     6
      T     "turnTableState"                    MW24
_028: NOP   0
      SPA   END


//********* SMALL BOX LEAVING PATH (RIGHT CONVEYOR)******************//
SIX:  S     "Var System Outputs".unLoad         DB2.DBX0.3

// If negative edge sensor right entry => State 0
      U     "Var System Inputs".rightEntry      DB1.DBX1.3
      FN    "OnsRightLeaving"                   M254.6
      SPBN  _029
      L     0
      T     "turnTableState"                    MW24
_029: NOP   0
      SPA   END

//********* VALUE OUT OF RANGE *************//
OUT:  L     0
      T     "turnTableState"                    MW24
      SPA   END


//********* IF JUMP TO END LOOP OUT *************//
END:  BEA

_020: NOP   0
```