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WintonWasher_Recycler / PLC_1 [CPU 315-2 PN/DP] / Program blocks

DB_WintonWasher [DB1]

DB_WintonWasl	DB_WintonWasher Properties											
General												
Name	DB_WintonWasher	Number	1	Туре	DB	Language	DB					
Numbering	Manual											
Information												
Title		Author		Comment		Family						
Version	0.1	User-defined ID										
	·			-								

tle Author ersion 0.1 User-defined ID					Comment						
_WintonWasher me	Data type	Offset	Start value	Retain		able from HMI/ OPC	HMI engi- neering		Supervi- sion	Comment	
- Input						UA					
Input											
ESTOP Pressed	Bool	0.0	false	True	True	True		False			
Ix Doors are Closed	Bool	0.1	false	True	True	True		False			
Ix Prestop Ext PX	Bool	0.2	false	True	True	True		False			
Ix Prestop Ret PX	Bool	0.3	false	True	True	True		False			
Ix Endstop Ext PX	Bool	0.4	false	True	True	True		False			
Ix Endstop Ret PX	Bool	0.5	false false	True	True	True True		False False			
Ix Punch Ext PX Ix Punch Ret PX	Bool Bool	0.8	false	True True	True True	True		False			
Ix Washer Present PX	Bool	1.0	false	True	True	True		False			
Ix Left Clamp Ext PX	Bool	1.1	false	True	True	True		False			
Ix Left Clamp Ret PX	Bool	1.2	false	True	True	True		False			
Ix Right Clamp Ext PX	Bool	1.3	false	True	True	True		False			
Ix Right Clamp Ret PX	Bool	1.4	false	True	True	True		False			
Ix Left Shear Ext PX	Bool	1.5	false	True	True	True		False			
Ix Left Shear Ret PX	Bool	1.6	false	True	True	True		False			
Backup Washer Present PX	Bool	1.7	false	True	True	True		False			
Ix Gripper Ext PX	Bool	2.0	false	True	True	True		False			
Ix Gripper Ret PX	Bool	2.1	false	True	True	True		False			
Ix Lat Ext PX	Bool	2.2	false	True	True	True	True	False			
Ix Lat Ret PX	Bool	2.3	false	True	True	True	True	False			
Ix T2 Ext PX	Bool	2.4	false	True	True	True	True	False			
Ix T2 Ret PX	Bool	2.5	false	True	True	True	True	False			
Ix T1 Ext PX	Bool	2.6	false	True	True	True	True	False			
Ix T1 Ret PX	Bool	2.7	false	True	True	True	True	False			
Ix Sense Part Ready PE	Bool	3.0	false	True	True	True	True	False			
Ix Right Shear Ext PX	Bool	3.1	false	True	True	True	True	False			
Ix Right Shear Ret PX	Bool	3.2	false	True	True	True	True	False			
Ix Cycle Start PB	Bool	3.3	false	True	True	True	True	False			
▼ Output											
Qx Shear Cyl Ret	Bool	4.0	false	True	True	True	True	False			
Qx Shear Cyl Ext	Bool	4.1	false	True	True	True	True	False			
Qx Prestop Cyl Ret	Bool	4.2	false	True	True	True	True	False			
Qx Prestop Cyl Ext	Bool	4.3	false	True	True	True	True	False			
Qx Endstop Cyl Ret	Bool	4.4	false	True	True	True	True	False			
Qx Endstop Cyl Ext	Bool	4.5	false	True	True	True	True	False			
Qx Clamp Cyl Ret	Bool	4.6	false	True	True	True	True	False			
Qx Clamp Cyl Ext	Bool	4.7	false	True	True	True		False			
Qx Punch Cyl Ret	Bool	5.0	false	True	True	True		False			
Qx Punch Cyl Ext	Bool	5.1	false	True	True	True		False			
Qx Gripper Cyl Ret	Bool	5.2	false	True	True	True		False			
Qx Gripper Cyl Ext	Bool	5.3	false	True	True	True		False			
Qx Lat Cyl Ret	Bool	5.4	false	True	True	True		False			
Qx Lat Cyl Ext	Bool	5.5	false	True	True	True		False			
Qx T2 Cyl Ret	Bool	5.6	false	True	True	True		False			
Qx T2 Cyl Ext	Bool	5.7	false	True	True	True		False			
Qx T1 Cyl Ret	Bool	6.0	false	True	True	True		False			
Qx T1 Cyl Ext	Bool	6.1	false	True	True	True		False			
Qx Cycle Start PL	Bool Bool	6.2 6.3	false false	True True	True True	True True		False False			
Qx Feeder OFF	Bool	6.4	false	True	True	True		False			
Qx Overhead Light ON Qx Fan ON	Bool	6.5	false	True	True	True		False			
Qx Fan ON Qx Auxiliary Lights ON	Bool	6.6	false	True	True	True		False			
InOut	DOOI	0.0	Turse	Tiue	Tiue	iiue	Tiue	1 4136			
✓ Static											
	D I	0.0	f - 1	-	T	—	T	E_ I			
Master Reset	Bool	8.0	false	True	True	True		False			
Pause	Bool	8.1	false	True	True	True		False			
▼ Auto	Struct	10.0		True	True	True		False			
Shear Cyl Ret	Bool	10.0	false	True	True	True		False			
Shear Cyl Ext	Bool	10.1	false	True	True	True		False			
Prestop Cyl Ret	Bool	10.2	false	True	True	True	True	False			

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ne	Data type	Offset	Start value	Retain	Accessi- ble from HMI/OPC UA	able	Visible in HMI engi- neering	Setpoint	Supervi- sion	Comment
Prestop Cyl Ext	Bool	10.3	false	True	True	True	True	False		
Endstop Cyl Ret	Bool	10.4	false	True	True	True	True	False		
Endstop Cyl Ext	Bool	10.5	false	True	True	True	True	False		
Clamp Cyl Ret	Bool	10.6	false	True	True	True		False		
Clamp Cyl Ext	Bool	10.7	false	True	True	True		False		
· · ·	Bool	11.0	false	True	True	True		False		
Punch Cyl Ret										
Punch Cyl Ext	Bool	11.1	false	True	True	True		False		
Gripper Cyl Ret	Bool	11.2	false	True	True	True	True	False		
Gripper Cyl Ext	Bool	11.3	false	True	True	True	True	False		
Lat Cyl Ret	Bool	11.4	false	True	True	True	True	False		
Lat Cyl Ext	Bool	11.5	false	True	True	True	True	False		
T2 Cyl Ret	Bool	11.6	false	True	True	True		False		
T2 Cyl Ext	Bool	11.7	false	True	True	True		False		
· · · · · · · · · · · · · · · · · · ·										
T1 Cyl Ret	Bool	12.0	false	True	True	True		False		
T1 Cyl Ext	Bool	12.1	false	True	True	True		False		
Cycle Start PL	Bool	12.2	false	True	True	True	True	False		
Feeder OFF	Bool	12.3	false	True	True	True	True	False		
▼ Manual	Struct	14.0		True	True	True	True	False		
	Dool	14.0	false	Truc	Truc	Truc	Truc	Tales.		
Shear Cyl Ret	Bool	14.0	false	True	True	True		False		
Shear Cyl Ext	Bool	14.1	false	True	True	True		False		
Prestop Cyl Ret	Bool	14.2	false	True	True	True		False		
Prestop Cyl Ext	Bool	14.3	false	True	True	True	True	False		
Endstop Cyl Ret	Bool	14.4	false	True	True	True	True	False		
Endstop Cyl Ext	Bool	14.5	false	True	True	True	True	False		
Clamp Cyl Ret	Bool	14.6	false	True	True	True		False		
Clamp Cyl Ext	Bool	14.7	false	True	True	True		False		
					_					
Punch Cyl Ret	Bool	15.0	false	True	True	True		False		
Punch Cyl Ext	Bool	15.1	false	True	True	True		False		
Gripper Cyl Ret	Bool	15.2	false	True	True	True	True	False		
Gripper Cyl Ext	Bool	15.3	false	True	True	True	True	False		
Lat Cyl Ret	Bool	15.4	false	True	True	True	True	False		
Lat Cyl Ext	Bool	15.5	false	True	True	True	True	False		
T2 Cyl Ret	Bool	15.6	false	True	True	True		False		
-	Bool	15.7	false			True		False		
T2 Cyl Ext				True	True					
T1 Cyl Ret	Bool	16.0	false	True	True	True		False		
T1 Cyl Ext	Bool	16.1	false	True	True	True		False		
Cycle Start PL	Bool	16.2	false	True	True	True	True	False		
Feeder OFF	Bool	16.3	false	True	True	True	True	False		
Light ON	Bool	16.4	false	True	True	True	True	False		
Fan ON	Bool	16.5	false	True	True	True		False		
▼ Step	Struct	18.0		True	True	True		False		
·										
Idle	Bool	18.0	false	True	True	True		False		
Sense Part Ready	Bool	18.1	false	True	True	True		False		
Activate Prestop	Bool	18.2	false	True	True	True	True	False		
Pick and Place Retract Endstop	Bool	18.3	false	True	True	True	True	False		
Pick and Place Extend Lat Cyl	Bool	18.4	false	True	True	True	True	False		
Pick and Place Extend Clamp	Bool	18.5	false	True	True	True	True	False		
Pick and Place Extend Gripper	Bool	18.6	false	True	True	True	True	False		
Pick and Place Retract Lat Cyl		18.7	false	True	True	True		False		
Pick and Place Retract Gripper	Bool	19.0	false	True	True	True		False		
Pick and Place Extend Endstop	Bool	19.1	false	True	True	True		False		
Check for Washer	Bool	19.2	false	True	True	True		False		
Open Path to Head Bin	Bool	19.3	false	True	True	True		False		
Remove Head	Bool	19.4	false	True	True	True		False		
Open Path to Washer Bin	Bool	19.5	false	True	True	True	True	False		
Retract Shears	Bool	19.6	false	True	True	True	True	False		
Punch Out Washer	Bool	19.7	false	True	True	True		False		
Retract Punch	Bool	20.0	false	True	True	True		False		
Open Path to Body Bin	Bool	20.1	false	True	True	True		False		
Drop Part	Bool	20.2	false	True	True	True		False		
Transition1_OK	Bool	22.0	false	True	True	True		False		
Transition2_OK	Bool	22.1	false	True	True	True	True	False		
Okay_toDelay1	Bool	22.2	false	True	True	True	True	False		
No_Parts_Error	Bool	22.3	false	True	True	True	True	False		
Enable PL Blink	Bool	22.4	false	True	True	True		False		
Enable Overhead Blink	Bool	22.5	false	True	True	True		False		
	Bool	22.6	false			True		False		
Start_Delay_OffVibrate	Bool	22.6		True	True					Almana and an
Stop_Vibrate		1///	false	True	True	⊥rue	True	False	1	timer output variable to stop

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ame	Data type	Offset	Start value	Retain	Accessi- ble from HMI/OPC UA	able	Visible in HMI engi- neering	Setpoint	Supervi- sion	Comment
Washer_NotPresent	Bool	23.0	false	True	True	True	True	False		
Bin_Overflow	Bool	23.1	false	True	True	True	True	False		
Cyl_Jam	Bool	23.2	false	True	True	True	True	False		
▼ ClearPart	Struct	24.0		True	True	True	True	False		
Retract Shears	Bool	24.0	false	True	True	True	True	False		
Retract Punch	Bool	24.1	false	True	True	True	True	False		
Extend Gripper	Bool	24.2	false	True	True	True	True	False		
Retract Endstop	Bool	24.3	false	True	True	True	True	False		
Extend Prestop	Bool	24.4	false	True	True	True	True	False		
Retract Lateral	Bool	24.5	false	True	True	True	True	False		
Retract Clamp	Bool	24.6	false	True	True	True	True	False		
Reset Cyls for Idle	Bool	24.7	false	True	True	True	True	False		
Start _Timeout	Bool	26.0	false	True	True	True	True	False		
Start_PreExt_Jam	Bool	26.1	false	True	True	True	True	False		
Start_PreRet_Jam	Bool	26.2	false	True	True	True	True	False		
Start_EndExt_Jam	Bool	26.3	false	True	True	True	True	False		
Start_EndRet_Jam	Bool	26.4	false	True	True	True	True	False		
Start_GrpExt_Jam	Bool	26.5	false	True	True	True	True	False		
Start_GrpRet_Jam	Bool	26.6	false	True	True	True	True	False		
Start_LatExt_Jam	Bool	26.7	false	True	True	True	True	False		
Start_LatRet_Jam	Bool	27.0	false	True	True	True	True	False		
Start_ShrExt_Jam	Bool	27.1	false	True	True	True	True	False		
Start_ShrRet_Jam	Bool	27.2	false	True	True	True	True	False		
Start_PunExt_Jam	Bool	27.3	false	True	True	True	True	False		
Start_PunRet_Jam	Bool	27.4	false	True	True	True	True	False		
Start_T1Ext_Jam	Bool	27.5	false	True	True	True	True	False		
Start_T1Ret_Jam	Bool	27.6	false	True	True	True	True	False		
Start_T2Ext_Jam	Bool	27.7	false	True	True	True	True	False		
Start_T2Ret_Jam	Bool	28.0	false	True	True	True	True	False		
Start_ClmpExt_Jam	Bool	28.1	false	True	True	True	True	False		
Start_ClmpRet_Jam	Bool	28.2	false	True	True	True	True	False		