ally Integrated	
Automation Portal	

# Centro de Maquinados / PLC\_1 [CPU 1214C AC/DC/Rly] / Program blocks

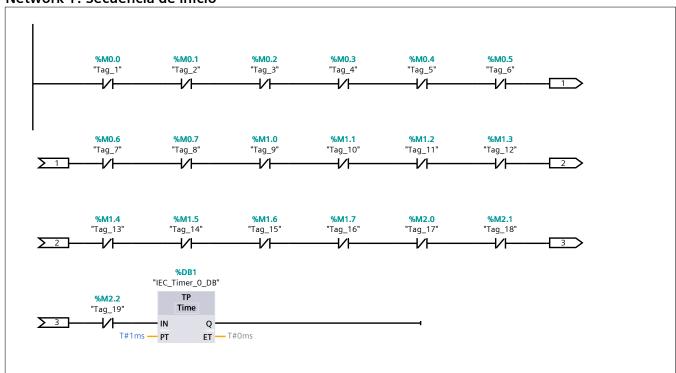
## Main [OB1]

Main Properties							
General							
Name	Main	Number	1	Туре	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: Secuencia de inicio

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Network 2: Encendido y Apagado Botón 1

## Totally Integrated **Automation Portal %Q8.1** "IBotón 1" %19.4 "Botón Verde" SR %19.5 "Botón Amarillo" +Network 3: Tiempo 1: Cambio banda 1 %DB12 "Tiempo cdc 1" TP %M0.6 Time "Tag\_7" ET — T#0ms Network 4: Tiempo 2: Movimiento del pistón %DR2 "Tiempo Movimiento del pistón" TP %M0.7 "Tag\_8" Time T#1s — PT ET — T#0ms Network 5: Tiempo 3: Movimiento hasta el taladrado %DB3 "Tiempo llegada maquinado 1" %M1.0 Time "Tag\_9" - IN Q-T#0.675s — PT ET — T#0ms Network 6: Tiempo 4: Taladrado %DB5 "Tiempo taladrado" %M1.2 "Tag\_11" Q· T#2s — PT ET — T#0ms



Time

Q-

ET — T#0ms

- IN

T#40ms — PT

"Tag\_12"

Network 8: Tiempo 6: Taladrado 2

```
**MB7
"Tiempo taladrado 2"

**M1.4
"Tag_13"

T#4s | IN | Q |

T#4s | TF | Time
```

Network 9: Tiempo 7: Fresado

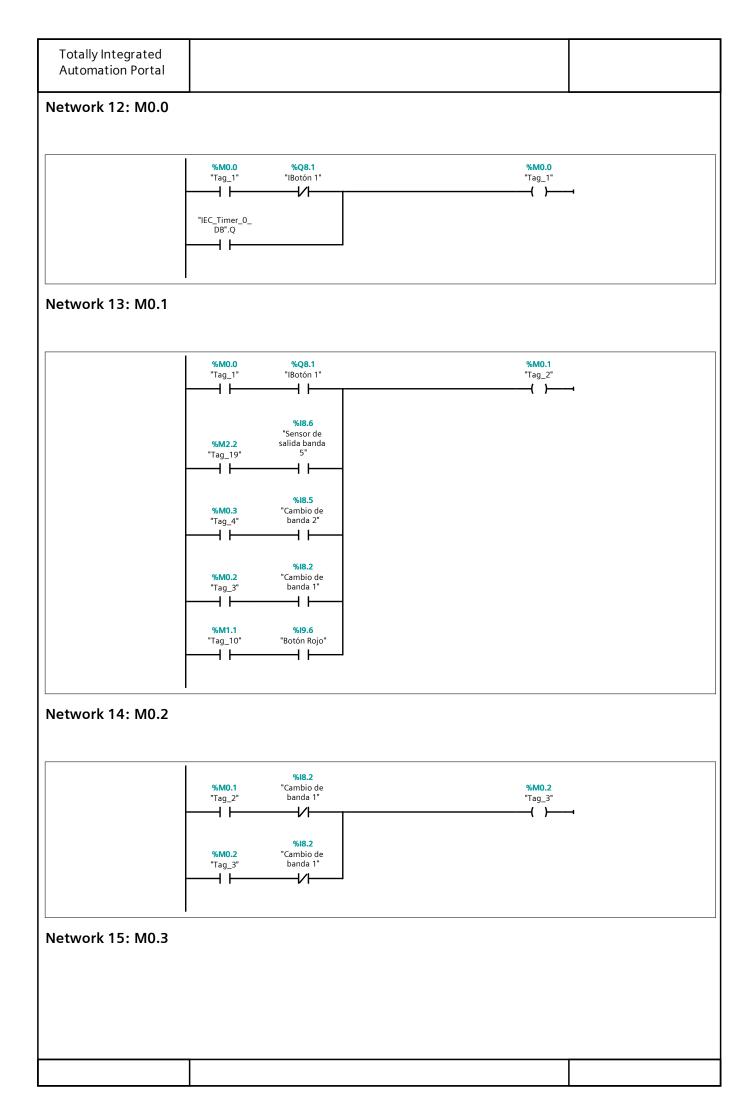
Network 10: Tiempo 8: Llegada banda 5

Network 11: Tiempo 9: Movimiento pistón 2

```
%DB9
"Pistón 2"

%M2.0
"Tag_17"
Time

IN Q
PT ET T#0ms
```



### Totally Integrated **Automation Portal** %18.5 %18.2 "Cambio de banda 1" %M0.1 "Cambio de %M0.3 "Tag\_2" banda 2" "Tag\_4" <del>1</del>/|-4 F %18.5 "Cambio de banda 2" %M0.3 "Tag\_4" Network 16: M0.4 %18.2 %18.5 **%M0.4** "Tag\_5" **%M0.1** "Tag\_2" "Cambio de banda 1" "Cambio de banda 2" 1 F ( )-%18.0 "Sensor de **%M0.4** "Tag\_5" Entrada Banda 2" **Network 17: M0.5** %18.0 "Sensor de Entrada Banda 2" %M0.4 %M0.5 "Tag\_5" "Tag\_6" <del>(</del> )-%18.1 **%M0.5** "Tag\_6" "Sensor Salida Banda 2" 4 F **%DB4**"retardo del sensor 2" %18.1 "Sensor Salida Banda 2" TP Q· T#0.001s — PT ET — T#0ms Network 18: M.06

#### Totally Integrated **Automation Portal** %18.1 %M0.5 "Sensor Salida %M0.6 "Tag\_6" Banda 2" "Tag\_7" %M0.6 "Tag\_7" "Tiempo cdc 1".Q $\dashv$ $\vdash$ %DB11 "Retardo del cdc" %M0.6 "Tag\_7" "Tiempo cdc 1".Q Time 4 F <del>1</del>/|-- IN Q T#0.001s — PT ET — T#0ms Network 19: M0.7 "Tiempo Movimiento del pistón".Q %M0.7 %M0.7 "Tag\_8" "Tag\_8" %DB13 "retraso al pistón" "Tiempo Movimiento del %M0.7 pistón".Q Time "Tag\_8" · IN Q· T#0.001s — PT ET — T#0ms %M0.6 "Tag\_7" "Tiempo cdc 1".Q <del>-</del>1/1-Network 20: M1.0 "Tiempo Movimiento del pistón".Q %M0.7 %M1.0 "Tag\_8" "Tag\_9" <del>1</del>/} "Tiempo llegada maquinado 1". Q %M1.0 "Tag\_9" 1 F 1 F %DB14 "retraso llegada maquinado 1" "Tiempo llegada maquinado 1". Q %M1.0 "Tag\_9" Time **+** + - IN Q T#0.001s — PT ET -T#0ms Network 21: M1.1

#### Totally Integrated **Automation Portal** "Tiempo llegada maquinado 1". Q %18.3 %M1.0 "Sensor %M1.1 "Tag\_9" Maquinado 3" "Tag\_10" **~** }-%M1.1 %19.6 "Tag\_10" "Botón Rojo" <del>-</del>1/1-Network 22: M1.2 "Tiempo llegada maquinado 1". %18.3 "Sensor %M1.2 %M1.0 Maquinado 3" "Tag\_9" Q "Tag\_11" +<del>(</del> )-"Tiempo taladrado".Q %M1.2 "Tag\_11" ++%DB15 "Retraso al taladrado" "Tiempo taladrado".Q %M1.2 "Tag\_11" +IN Q T#0.001s — PT ET — T#0ms Network 23: M1.3 "Tiempo taladrado".Q %M1.3 %M1.2 "Tag\_11" "Tag\_12" $\dashv$ $\vdash$ %M1.3 "Tag\_12" "Tiempo 5mm".Q <del>|</del> | |-%DB16 "retraso a los 5mm" %M1.3 Time "Tag\_12" "Tiempo 5mm".Q · IN Q· T#0.001s — PT ET — T#0ms **Network 24: M1.4**

#### Totally Integrated **Automation Portal %M1.3** "Tag\_12" **%M1.4** "Tag\_13" "Tiempo 5mm".Q +<del>/</del>/} <del>(</del> )-**%M1.4** "Tag\_13" "Tiempo taladrado 2".Q +**-**| |-%DB17 "retraso taladrado 2" "Tiempo taladrado 2".Q %M1.4 "Tag\_13" Time +- IN Q T#0.001s — PT ET — T#0ms **Network 25: M1.5** "Tiempo taladrado 2".Q **%M1.4** "Tag\_13" **%M1.5** "Tag\_14" <del>1</del>/} +( )-

```
"Tag_13" taladrado 2".Q "Tag_14"

%M1.5

%M8.4

"Sensor

"Tag_14" Maquinado 4"

%DB18

"retraso
maquinado 4"

The Maquinado 4"

The Maquinado 4"

The Time

Note the Magninado A To The M
```

Network 26: M1.6

```
%I8.4
                   "Sensor
Maquinado 4"
%M1.5
                                                                                         %M1.6
"Tag_14"
                                                                                        "Tag_15"
                        <del>-</del>|/|
                                                                                          ( )-
  +
%M1.6
"Tag_15"
                    "Fresado".Q
  <del>|</del> | |
                        <del>|</del> | |-
                                             %DB19
                                        "retraso fresado"
%M1.6
"Tag_15"
                    "Fresado".Q
                                                      Q
                          T#0.001s — PT
                                                     ET — T#0ms
```

Network 27: M1.7

#### Totally Integrated **Automation Portal %M1.6** "Tag\_15" **%M1.7** "Tag\_16" "Fresado".Q +<del>-</del>1/1-( )-**%M1.7** "Tag\_16" "Tiempo llegada banda 5".Q $\dashv$ $\vdash$ **%DB20** "retraso llegada banda 5" "Tiempo llegada banda 5".Q %M1.7 "Tag\_16" Time <del>/</del>/|-4 F - IN Q T#0.001s — PT ET — T#0ms Network 28: M2.0

```
%M1.7
"Tag_16"
                   "Tiempo llegada
banda 5".Q
                                                                                                 %M2.0
"Tag_17"
  +
                                                                                                   ( )-
%M2.0
"Tag_17"
                      "Pistón 2".Q
  <del>|</del> | |
                          <del>|</del> | |
                                                 %DB21
                                           "retraso piston 2"
                                                   TP
%M2.0
"Tag_17"
                      "Pistón 2".Q
                                                  Time
                                                          ET — T#0ms
                             T#0.001s — PT
```

Network 29: M2.1

```
%M2.0
                                                                                         %M2.1
  "Tag_17"
                      "Pistón 2".Q
                                                                                        "Tag_18"
                          <del>//</del>|
                         %18.6
                     "Sensor de
salida banda
5"
  %M2.1
"Tag_18"
    4 F
                        %DB22
   %18.6
                    "retraso ultimo"
 "Sensor de
salida banda
5"
                         TP
                         Time
                    · IN
                                 Q
         T#0.1s — PT
                                ET — T#0ms
```

Network 30: M2.2

# Totally Integrated Automation Portal **%18.6**"Sensor de salida banda 5" **%M2.1** "Tag\_18" **%M2.2** "Tag\_19" <del>|</del> | | **-(** )-%18.6 "Sensor de salida banda 5" **%M2.2** "Tag\_19" Network 31: Salidas definidas

Totally Integrated **Automation Portal** Network 31: Salidas definidas (1.1 / 2.1) **%M0.2** "Tag\_3" %Q8.3 "Motor cambio 1" **~** }-4 + %M0.7 "Tag\_8" **%M0.3** "Tag\_4" **%Q9.0**"Motor cambio 2" 4 F %M2.0 "Tag\_17" <del>|</del> | | **%M0.4** "Tag\_5" %Q9.3 "Semáforo Verde" 1 H <del>(</del> )-%M0.5 %Q8.2 "Tag\_6" "Avance banda 2"  $\dashv$   $\vdash$ **%M0.6** "Tag\_7" +**%M1.1** "Tag\_10" %Q9.2 "Semáforo Rojo" 4 F ( )-**%Q8.5**"Maquinado banda 3" %M1.2 "Tag\_11" ┨┞ **⊣** )– **%M1.4** "Tag\_13" 4 F **%M1.0** "Tag\_9" %Q8.4 "Avance banda 3" **(** )-%M1.3 "Tag\_12" 4 F %M1.5 "Tag\_14" +%M0.6 "Tag\_7" +%M0.7 "Tag\_8" %M1.5 "Tag 14" %Q8.6 "Δyance handa 4"

2.1 (Page1 - 12)

```
Totally Integrated
   Automation Portal
Network 31: Salidas definidas (2.1 / 2.1)
                                                                        1.1 ( Page1 - 11)
                                                                                        Availce pallua +
                       ΗH
                                                                                              %M1.7
"Tag_16"
                       \dashv \vdash
                                                                                          %Q8.7
"Maquinado
banda 4"
                     %M1.6
"Tag_15"
                        + +
                                                                                              ( )-
                     %M2.0
"Tag_17"
                                                                                             %Q9.1
                                                                                        "Avance banda 5"
                       \dashv \vdash
                                                                                              ⊣ )—
                     %M1.7
"Tag_16"
                       \dashv \vdash
                     %M2.1
"Tag_18"
                        \dashv \vdash
```