

Centro de Maquinados / PLC_1 [CPU 1214C AC/DC/Rly] / Program blocks

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Automatic		

Information

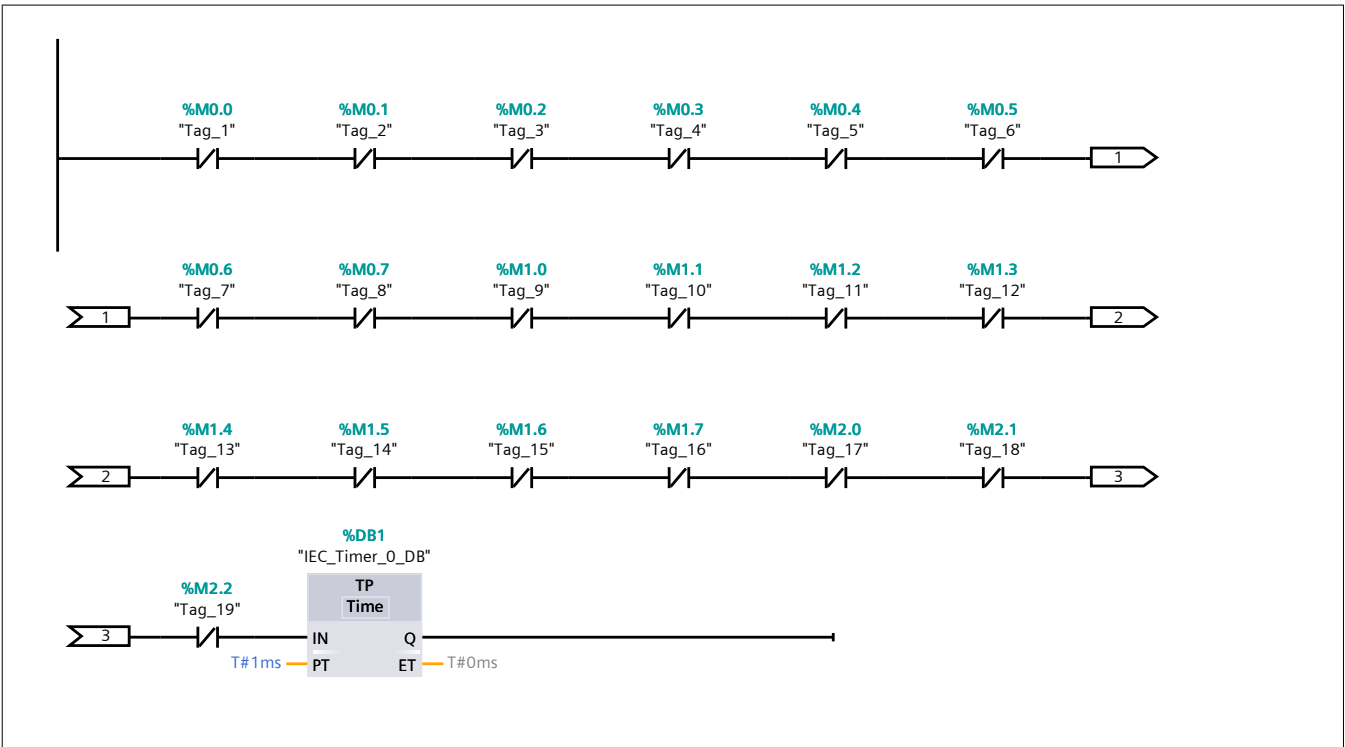
Title	"Main Program Sweep (Cycle)"	Author		Comment	
Family		Version	0.1	User-defined ID	

Main

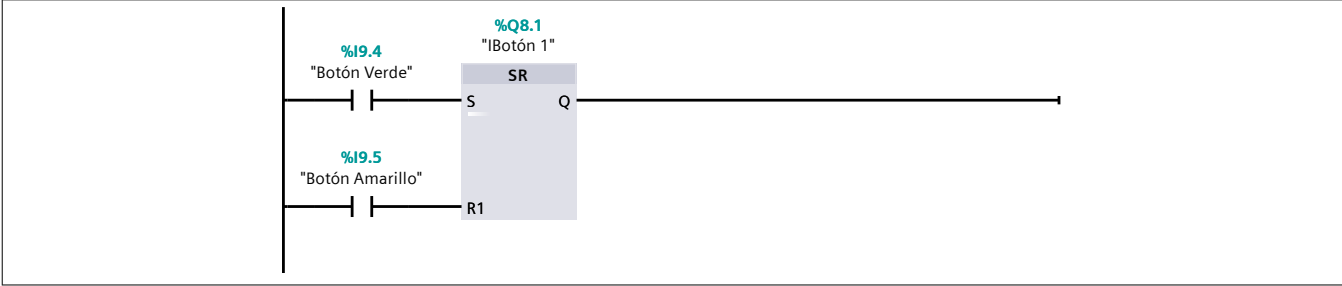
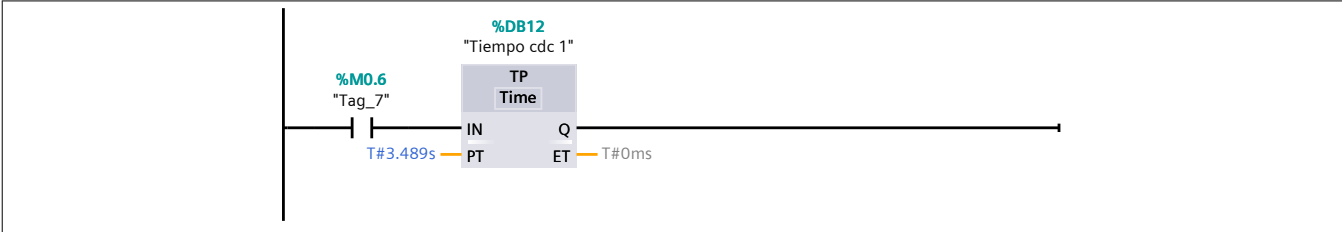
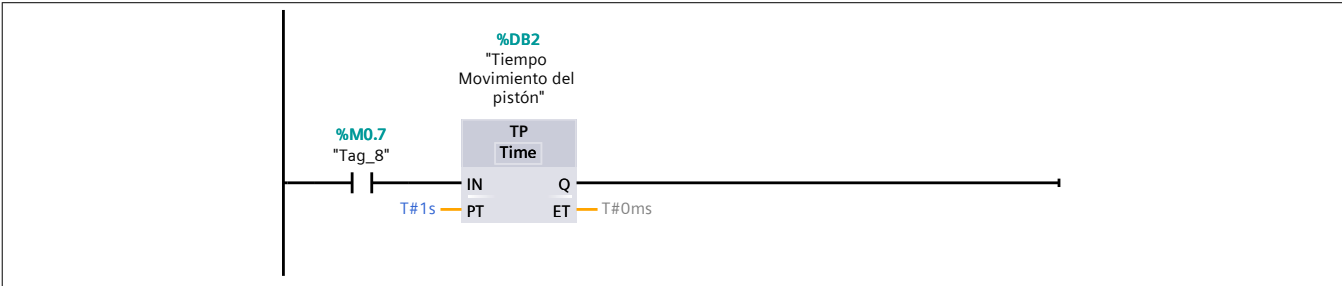
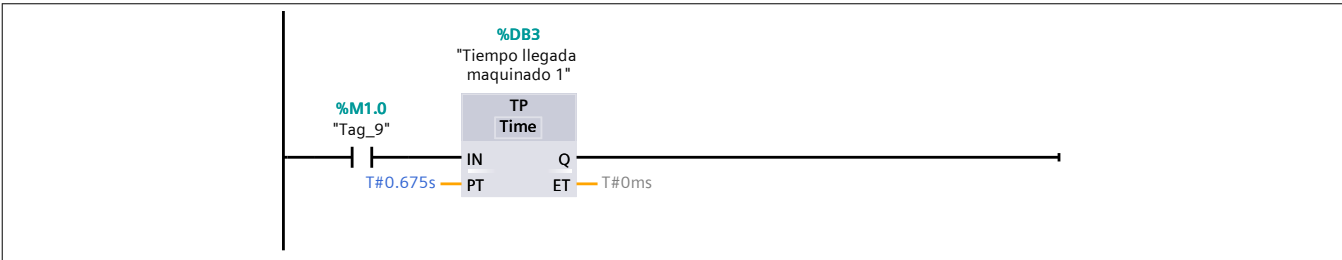
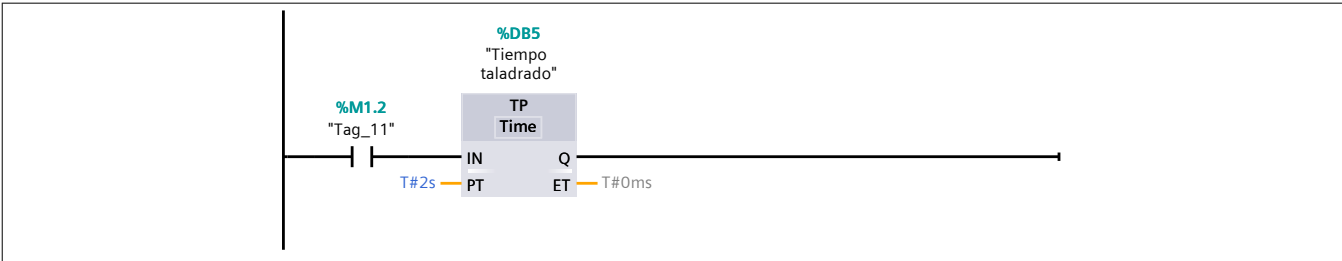
Name	Data type	Default value	Comment
▼ Input			
Initial_Call	Bool		Initial call of this OB
Remanence	Bool		=True, if remanent data are available
Temp			
Constant			

Network 1: Secuencia de inicio

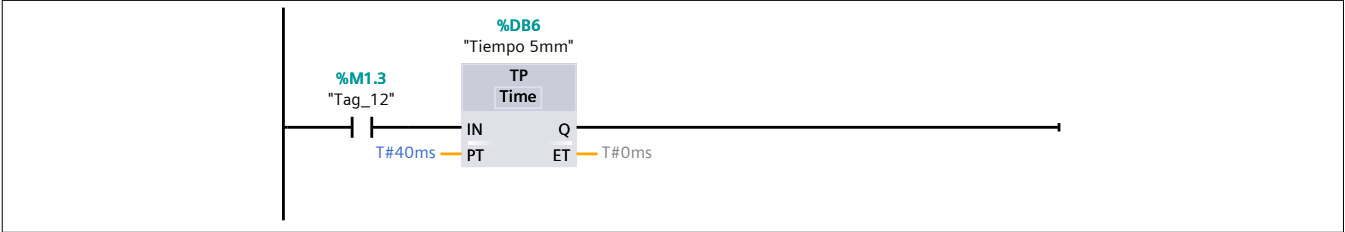
Network 1: Secuencia de inicio



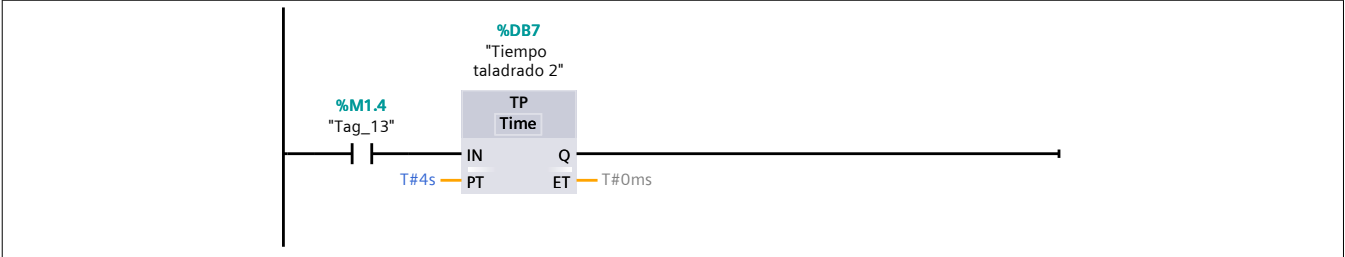
Network 2: Encendido y Apagado Botón 1

Totally Integrated Automation Portal		
		
Network 3: Tiempo 1: Cambio banda 1		
		
Network 4: Tiempo 2: Movimiento del pistón		
		
Network 5: Tiempo 3: Movimiento hasta el taladrado		
		
Network 6: Tiempo 4: Taladrado		
		

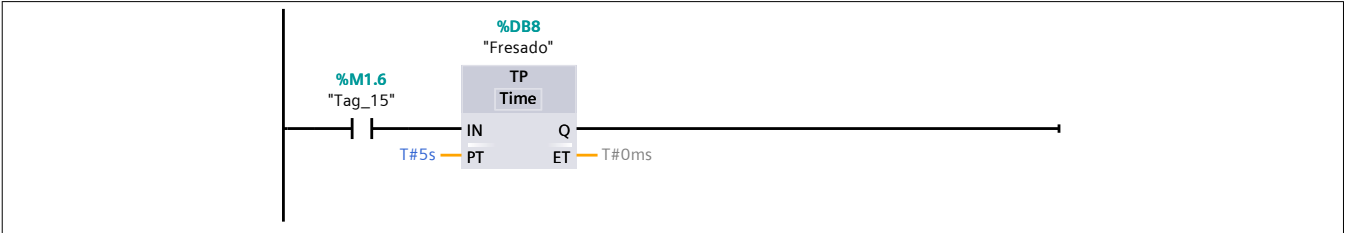
Network 7: Tiempo 5: Movimiento 5mm



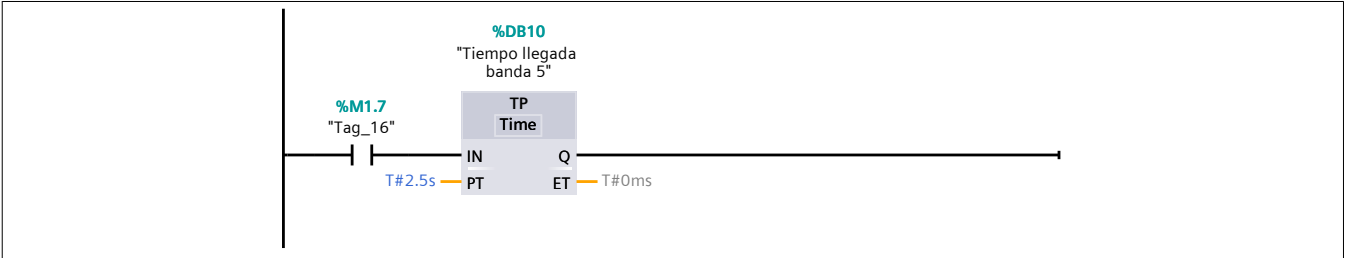
Network 8: Tiempo 6: Taladrado 2



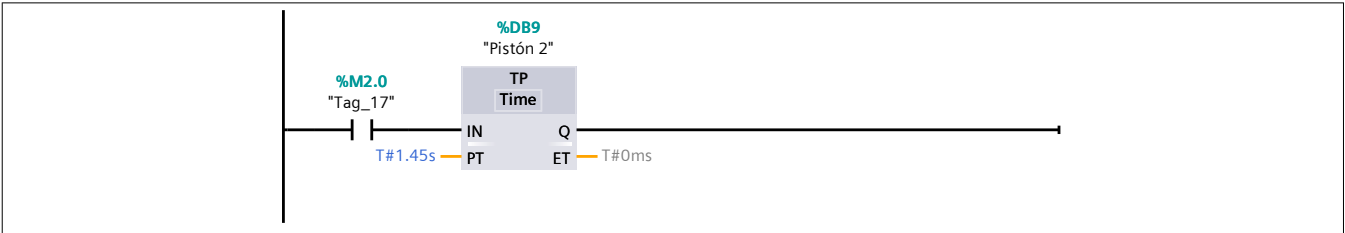
Network 9: Tiempo 7: Fresado



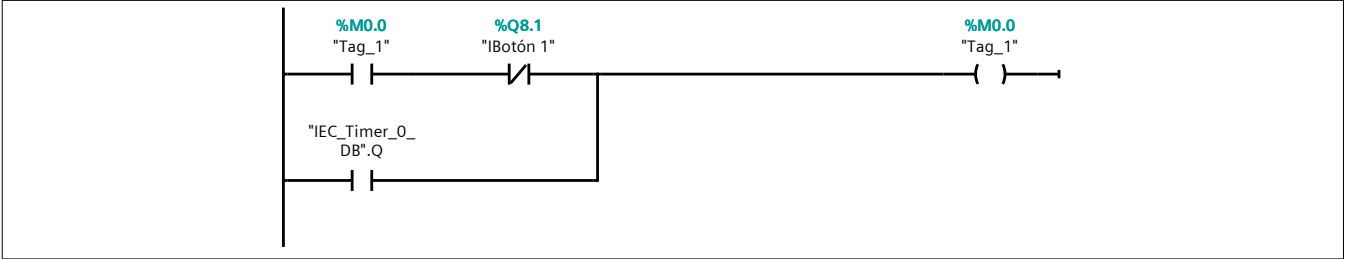
Network 10: Tiempo 8: Llegada banda 5



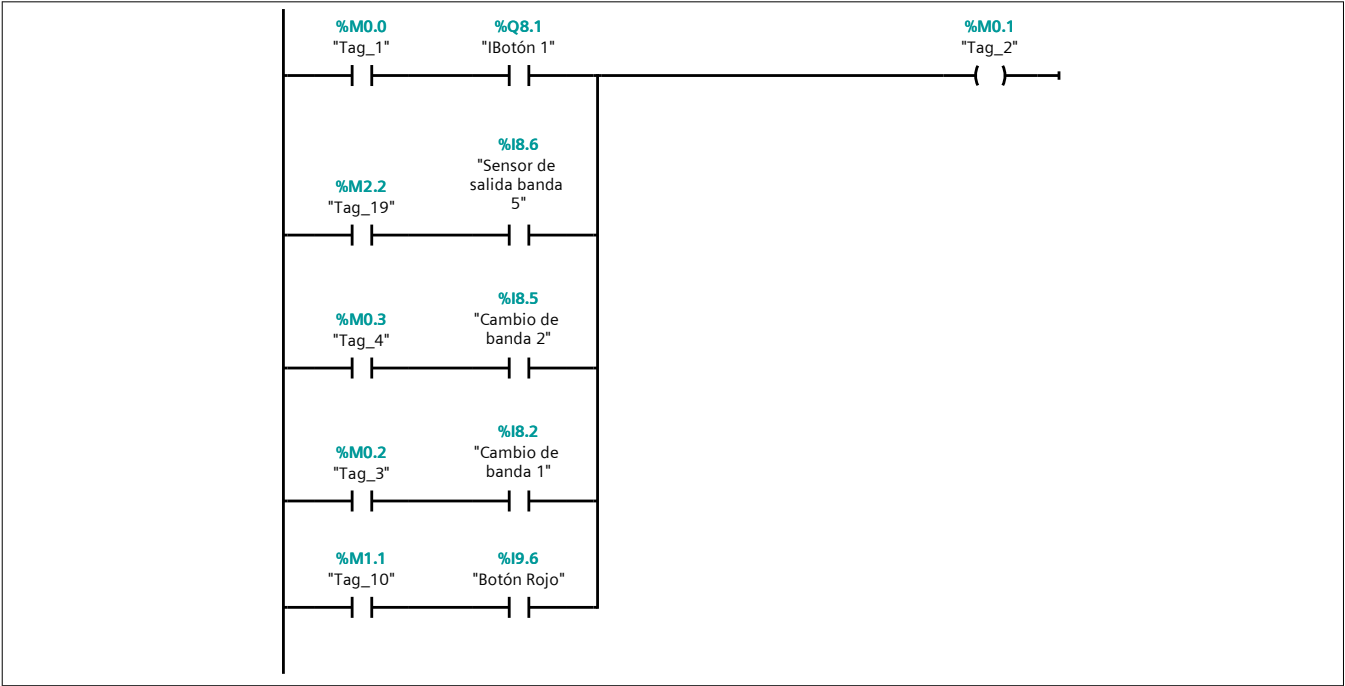
Network 11: Tiempo 9: Movimiento pistón 2



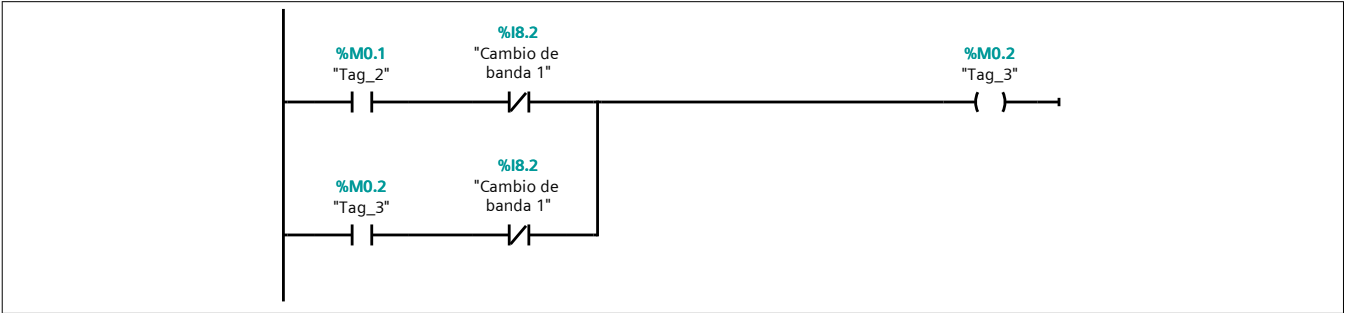
Network 12: M0.0



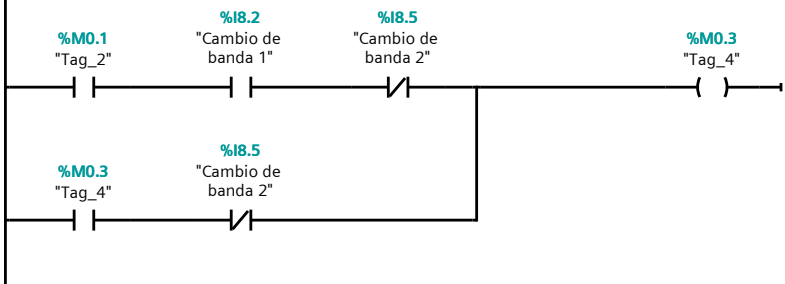
Network 13: M0.1



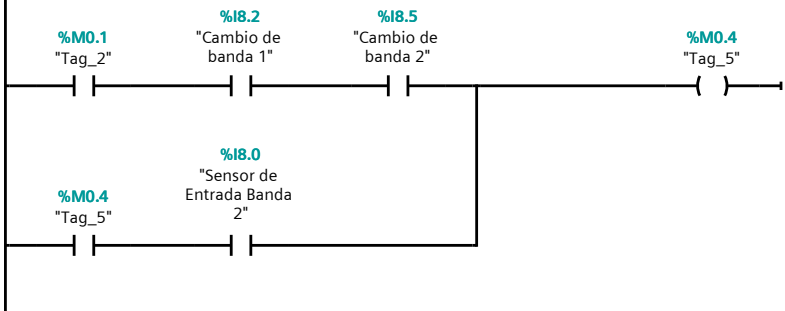
Network 14: M0.2



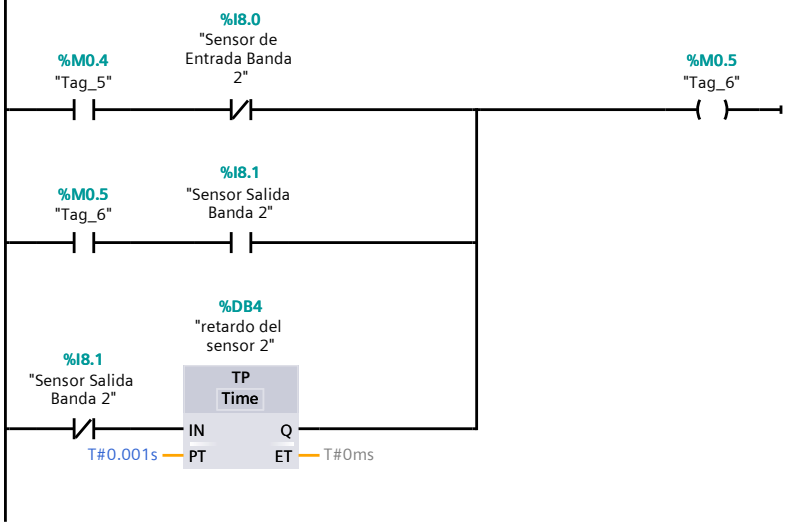
Network 15: M0.3



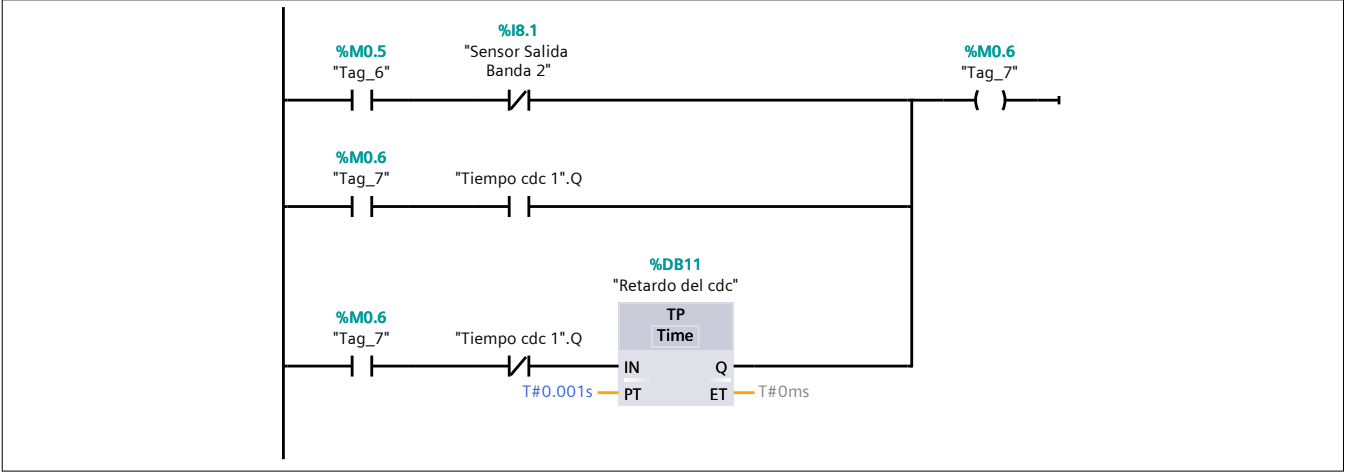
Network 16: M0.4



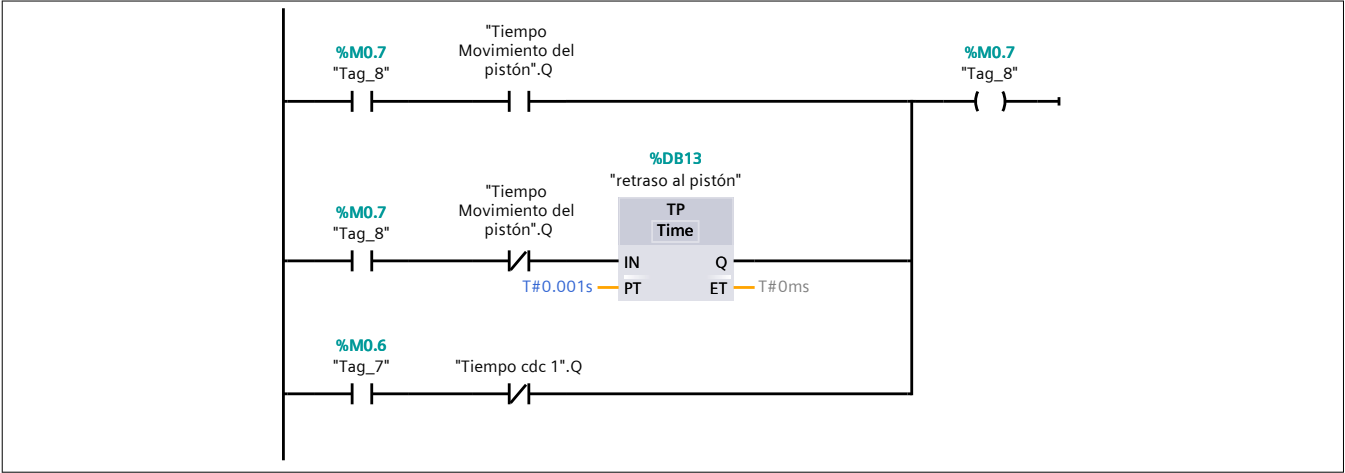
Network 17: M0.5



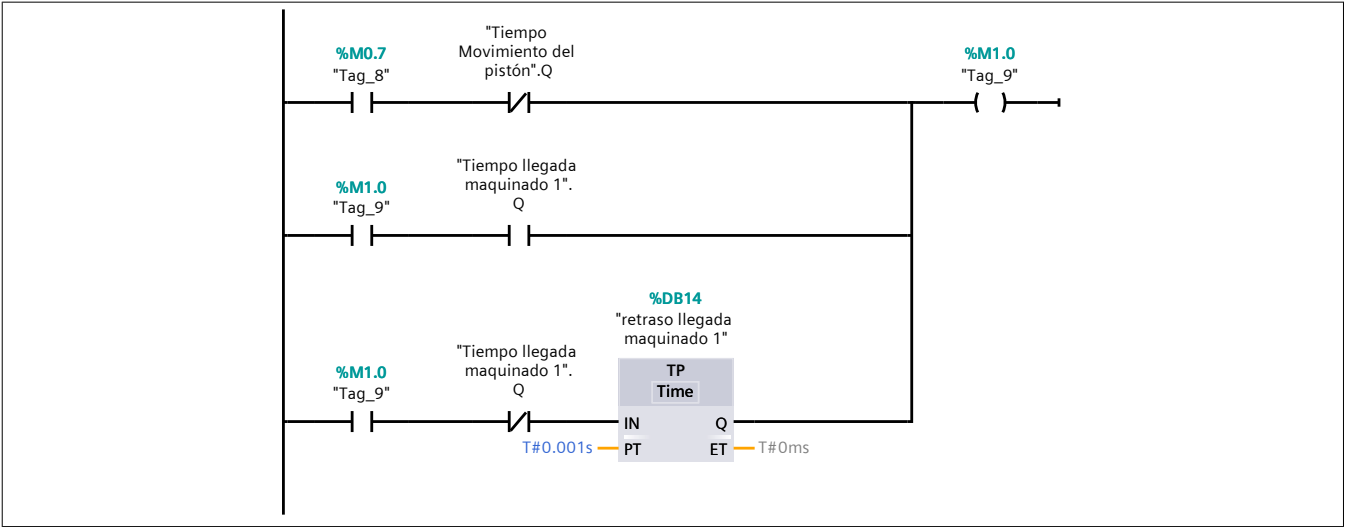
Network 18: M.06



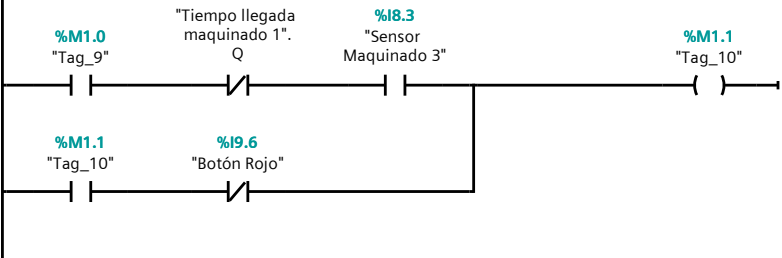
Network 19: M0.7



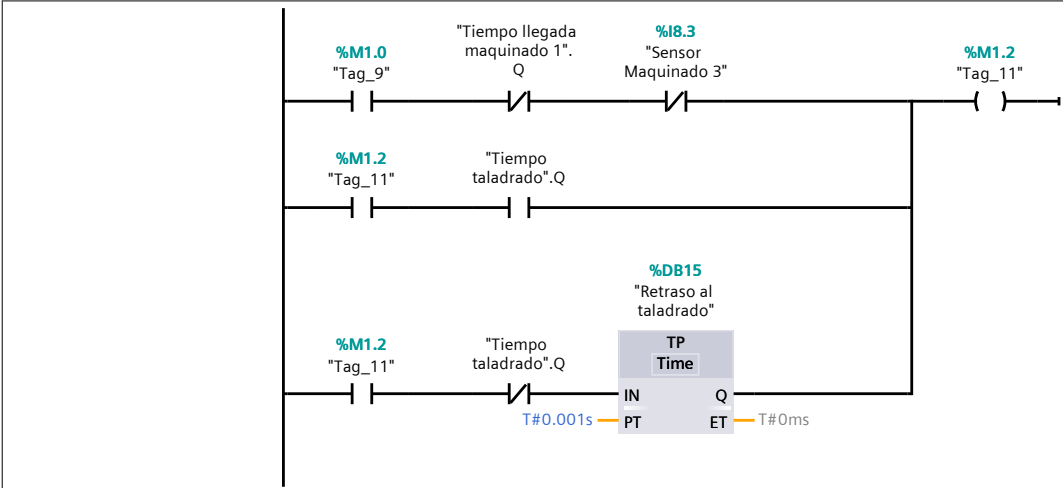
Network 20: M1.0



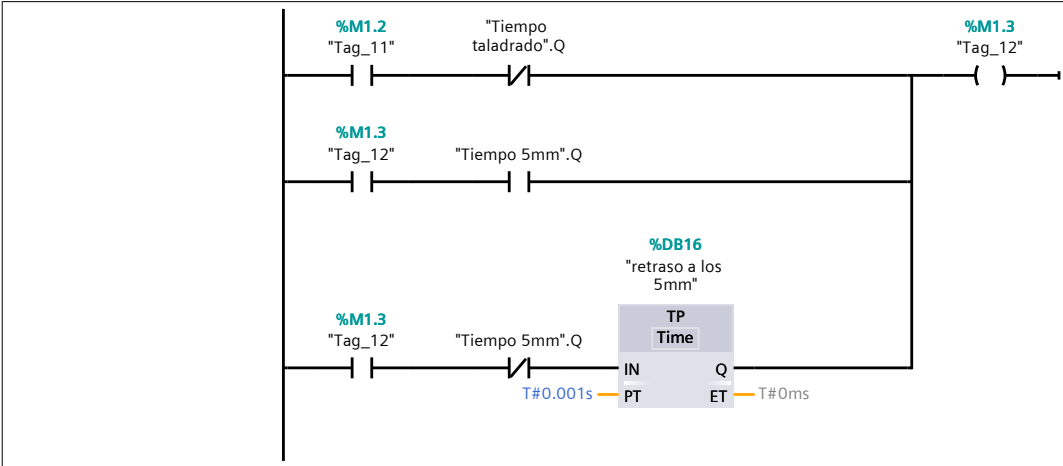
Network 21: M1.1



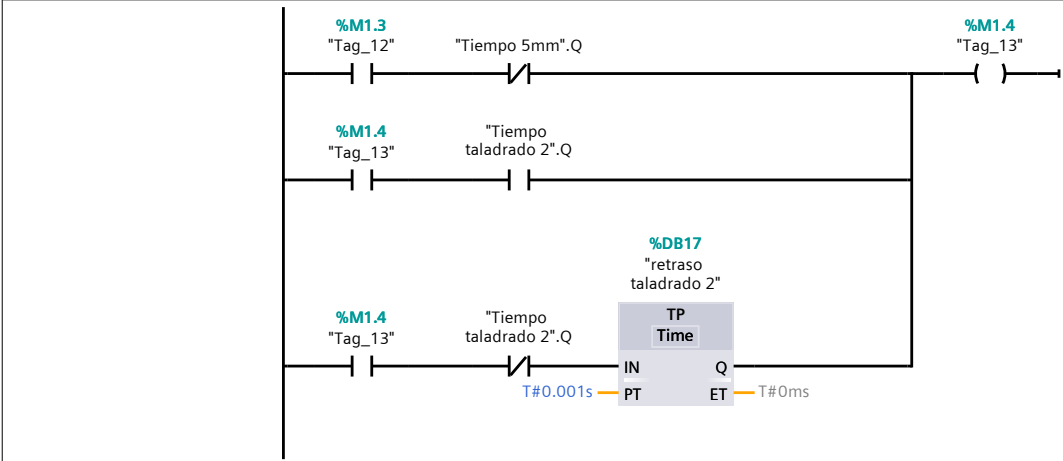
Network 22: M1.2



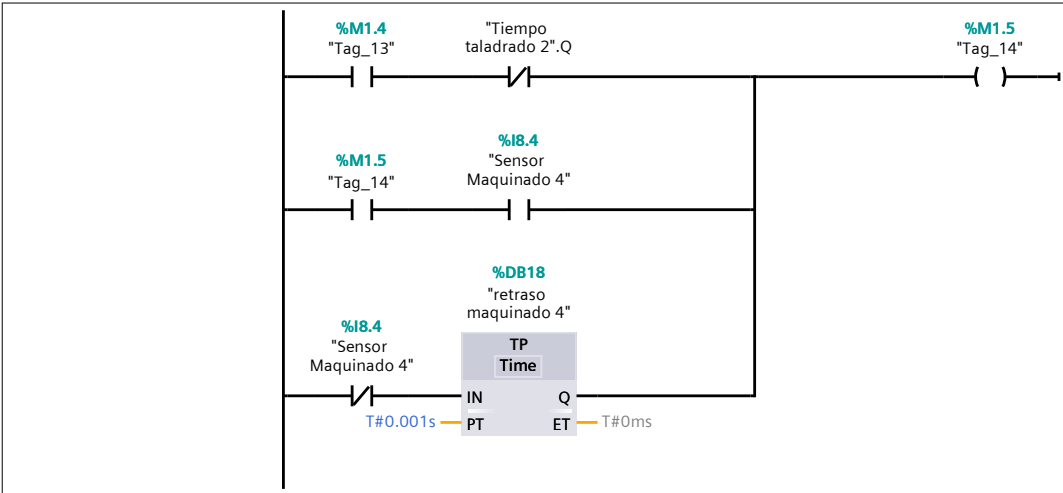
Network 23: M1.3



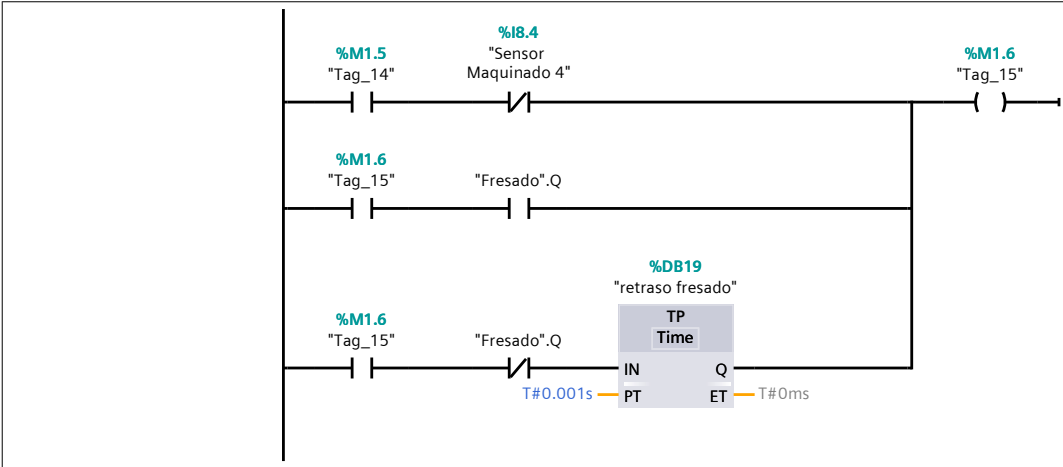
Network 24: M1.4



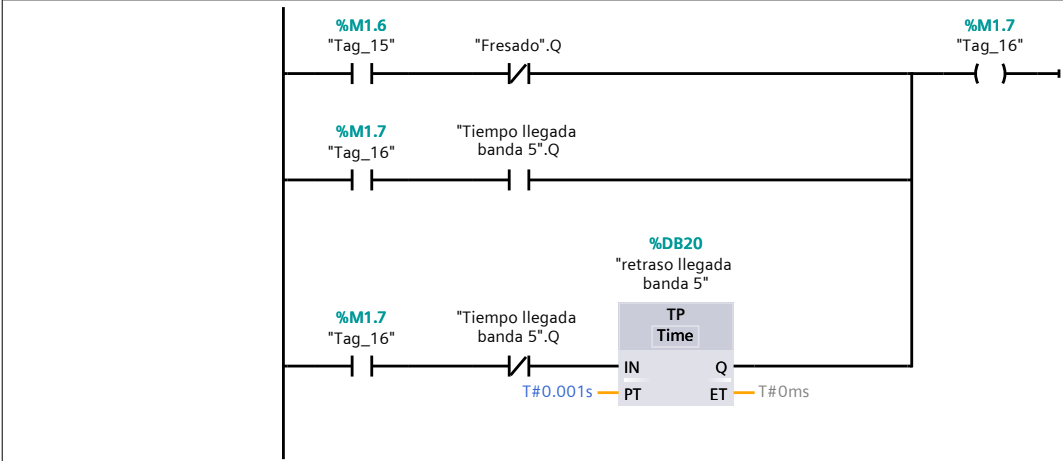
Network 25: M1.5



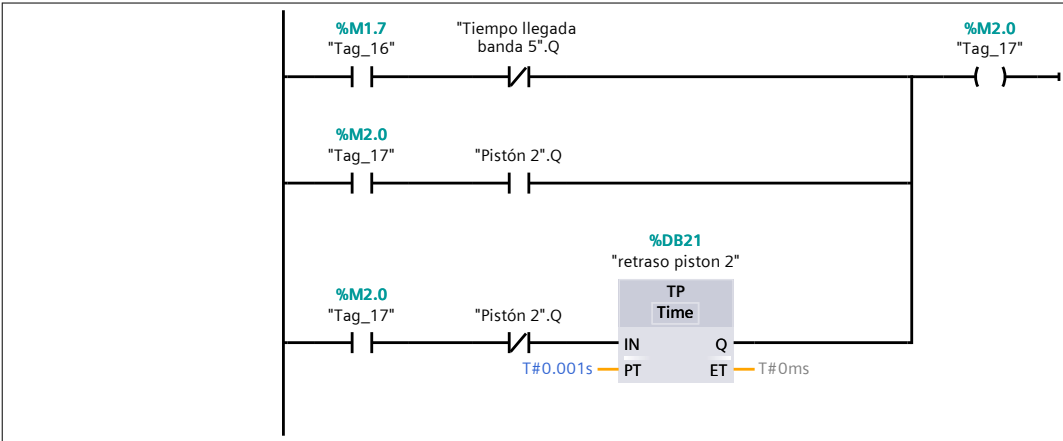
Network 26: M1.6



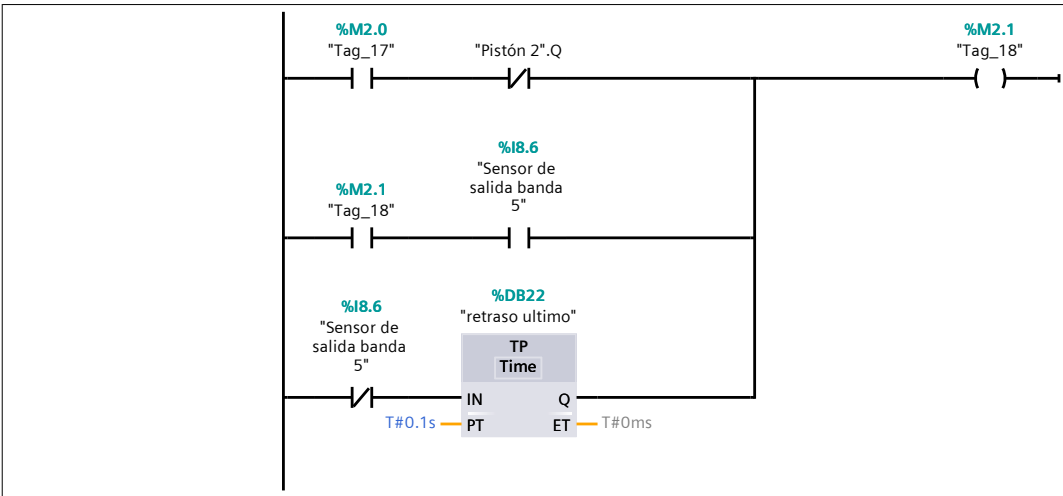
Network 27: M1.7



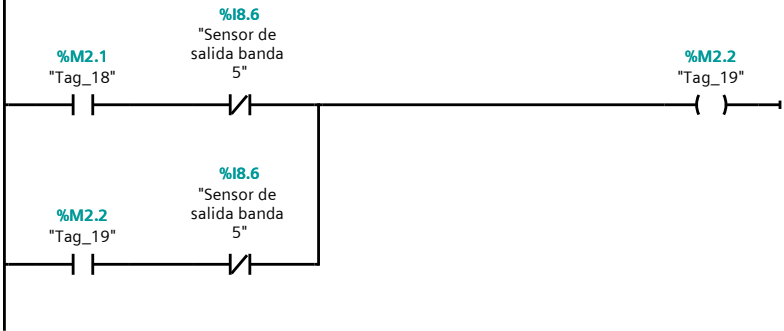
Network 28: M2.0



Network 29: M2.1

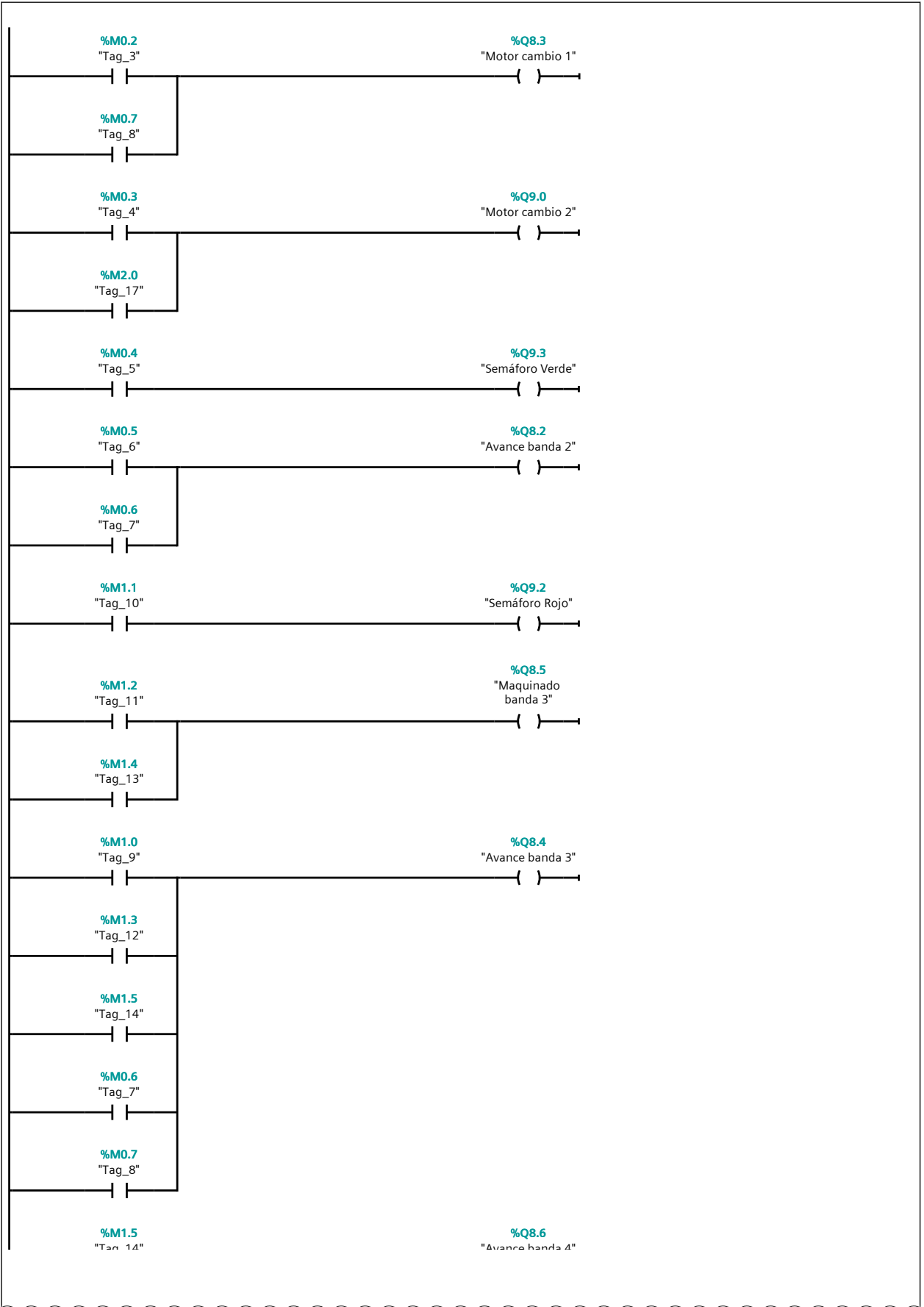


Network 30: M2.2



Network 31: Salidas definidas

Network 31: Salidas definidas (1.1 / 2.1)



Network 31: Salidas definidas (2.1 / 2.1)

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