Sorting line_Project / PLC_1 [CPU 1211C DC/DC/DC] / Program blocks

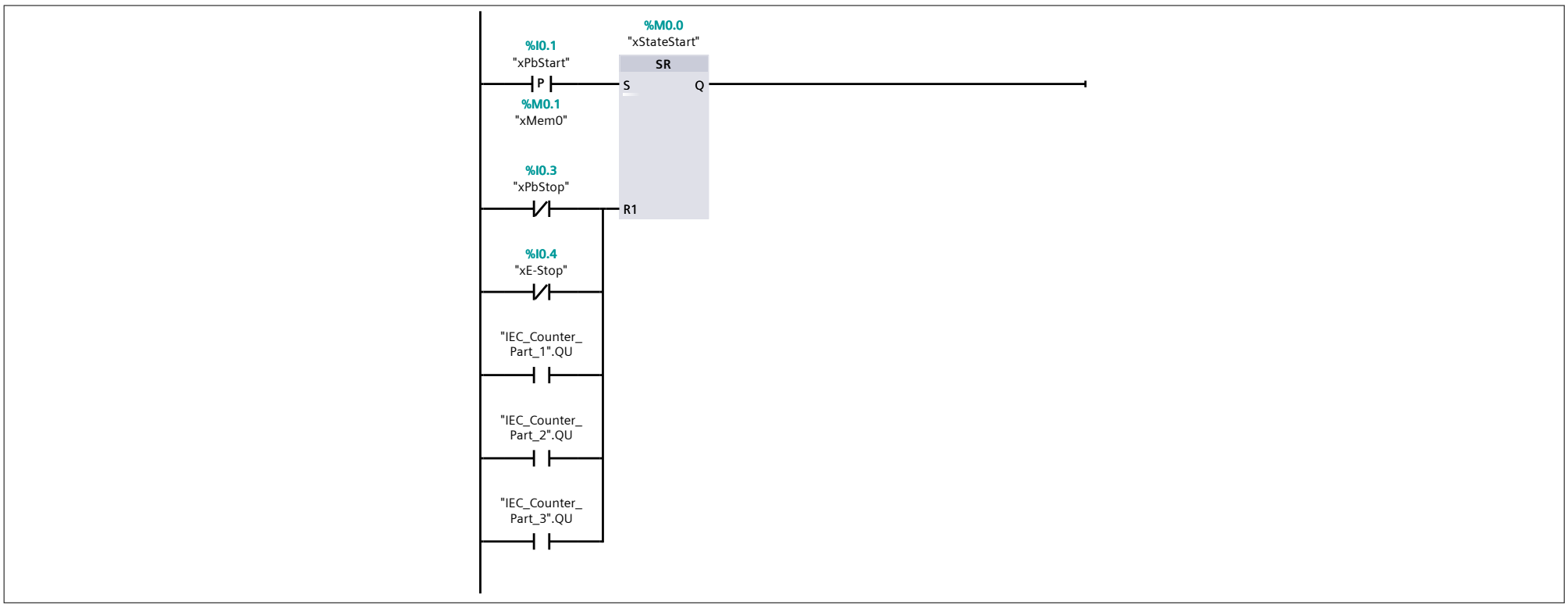
Main [OB1]

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			

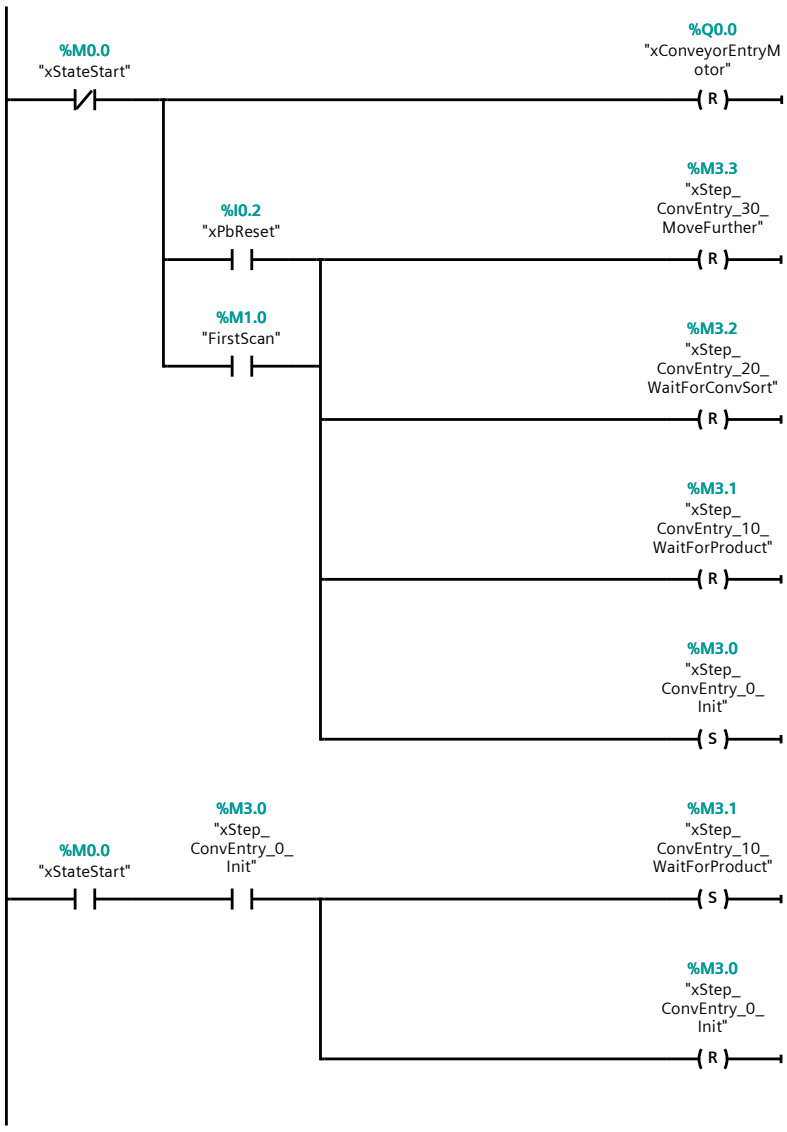
Network 1: Start/Stop system

Start/Stop system



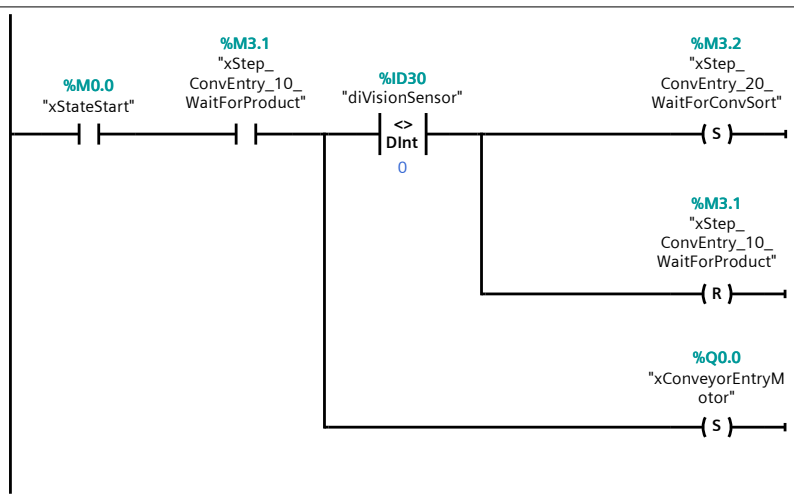
Network 2: Input conveyor initialization

Input conveyor initialization



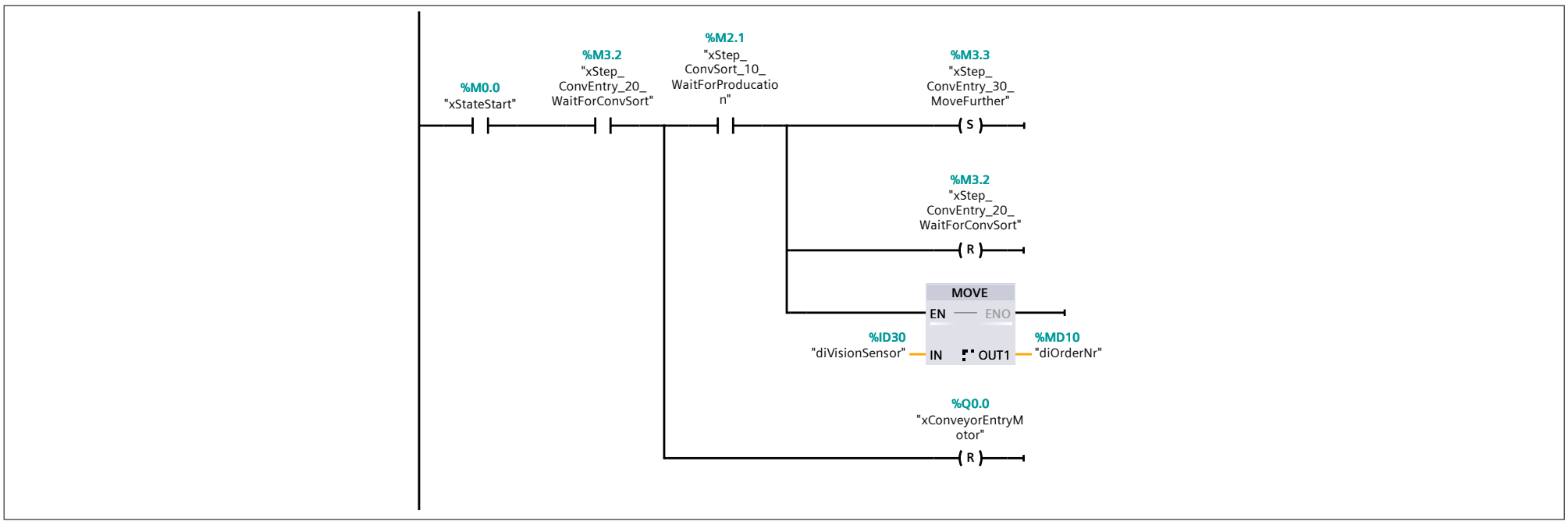
Network 3: Input conveyor Step 10 Waiting for product

Input conveyor Step 10 Waiting for product



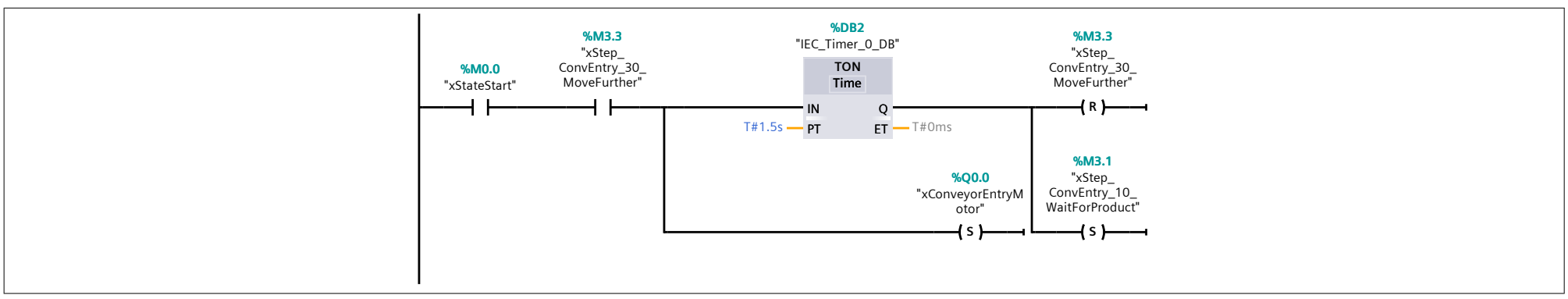
Network 4: Input conveyor Step 20 Waiting for sorting conveyor

Input conveyor Step 20 Waiting for sorting conveyor



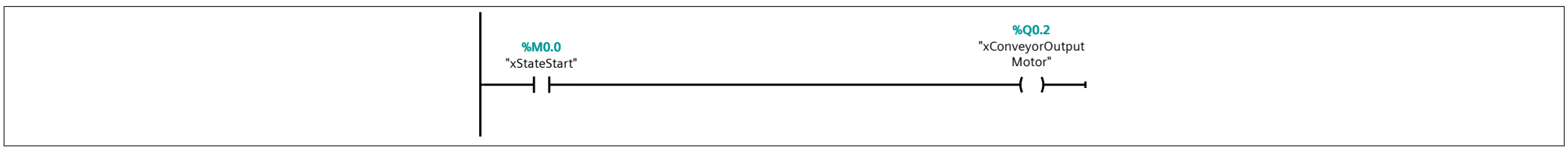
Network 5: Input conveyor Step 30 Move product to the next conveyo

Input conveyor Step 30 Move product to the next conveyor



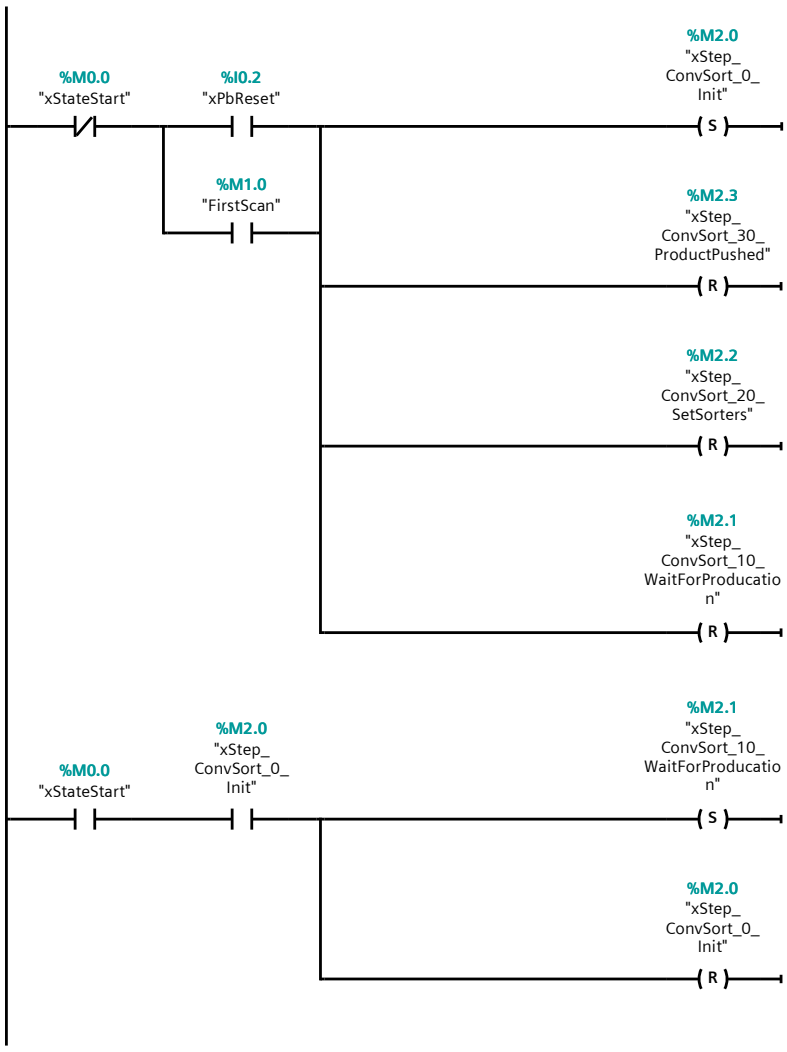
Network 6: Activating the output conveyor

Activating the output conveyor



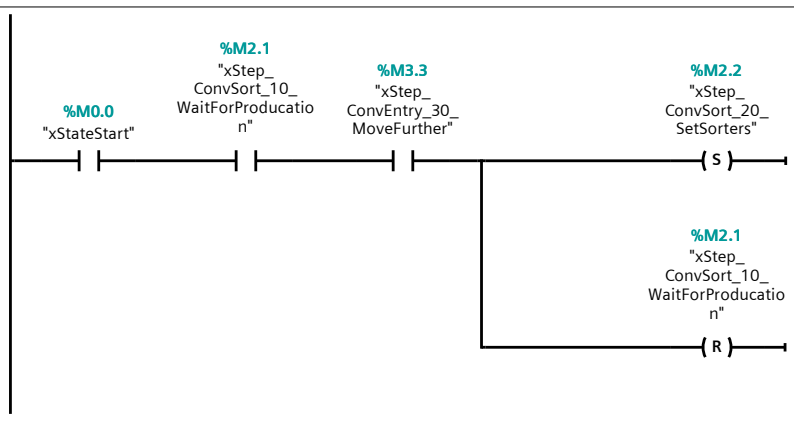
Network 7: Sorting conveyor assembly Step 0 Initialization

Sorting conveyor assembly Step 0 Initialization



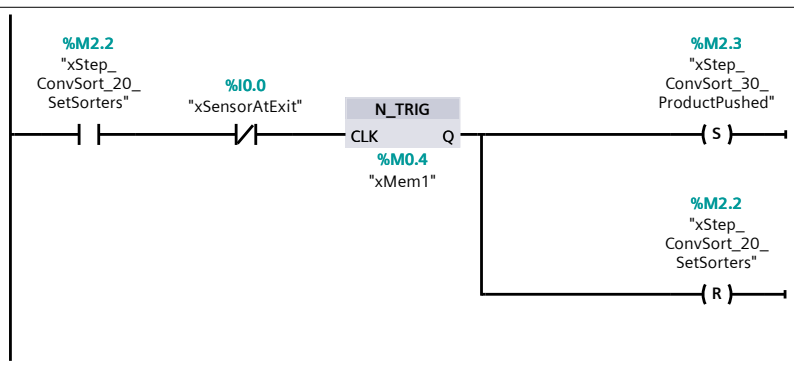
Network 8: Sorting conveyor assembly Step 10 Waiting for the input conveyor to provide the product

Sorting conveyor assembly Step 10 Waiting for the input conveyor to provide the product



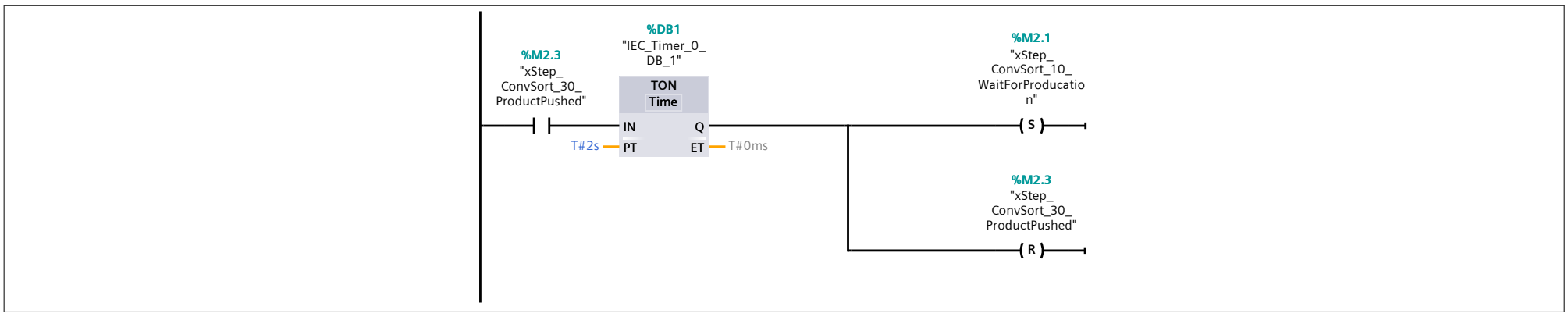
Network 9: Sorting conveyor assembly Step 20 Setting the sorters

Sorting conveyor assembly Step 20 Setting the sorters



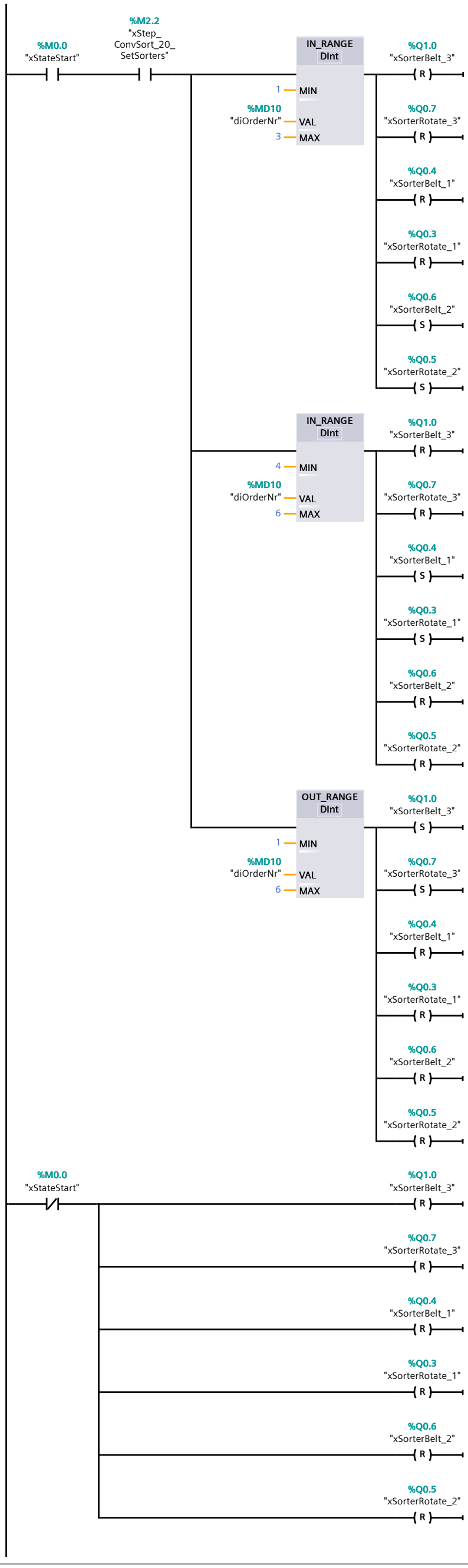
Network 10: Sorting conveyor assembly Step 30 Timer after pushing the product off

Sorting conveyor assembly Step 30 Timer after pushing the product off



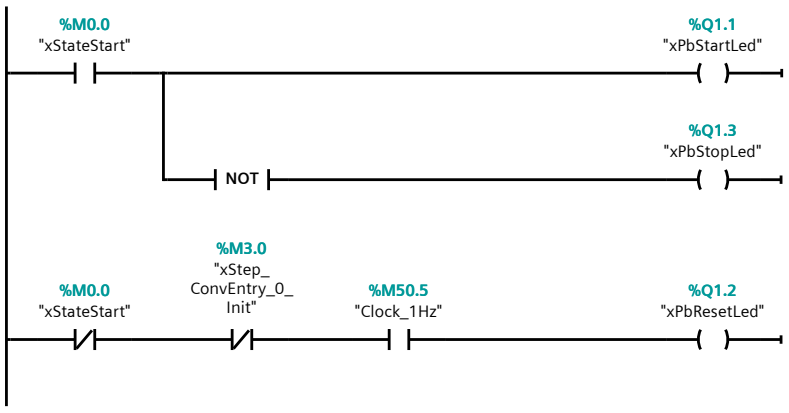
Network 11: Checking if the elements fall within the given range

checking if the elements fall within the given range

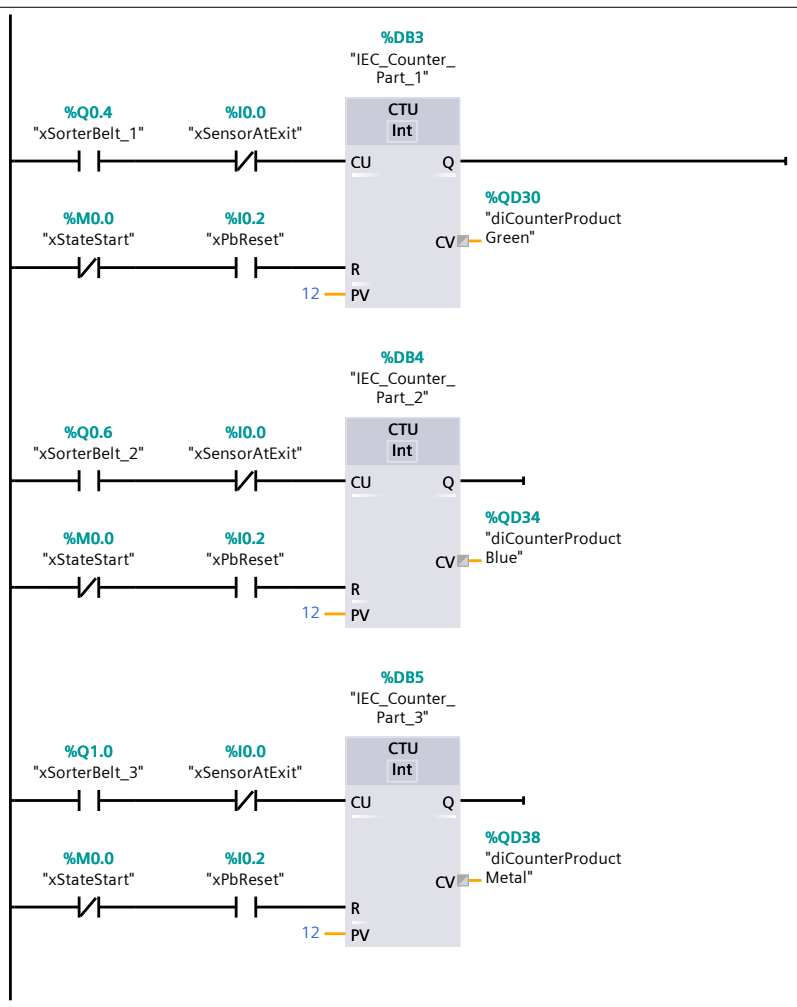


Network 12: Push buton's LEDs

Push buton's LEDs



Network 13:



Network 14: FIO communication