Totally Integrated
Automation Portal

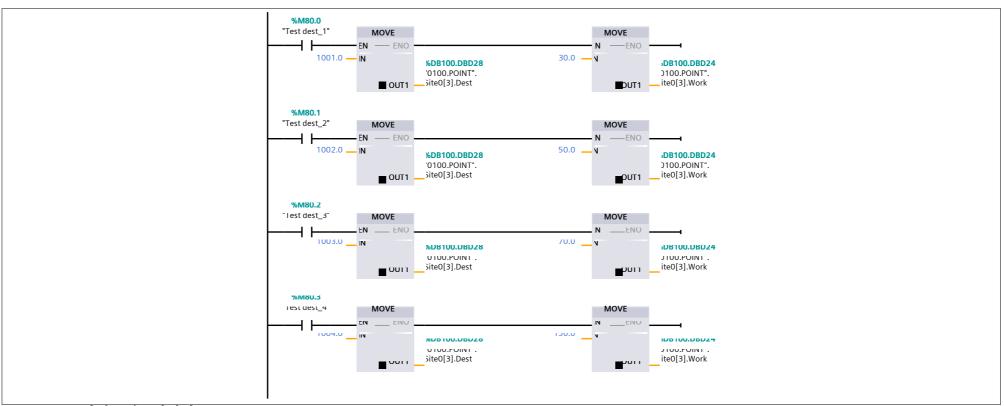
Al_detailchecker&classification_230614 / PLC_1 [CPU 1215C AC/DC/Rly] / Program blocks / 2.FC_program

FC102_Classification [FC102]

FC102_Classification Properties								
General								
Name	FC102_Classification	Number	102	Туре	FC	Language	LAD	
Numbering	Manual							
Information								
Title		Author		Comment		Family		
Version	0.1	User-defined ID						

FC102_Classification							
Name	Data type	Default value	Comment				
Input							
Output							
InOut							
Temp							
Constant							
▼ Return							
FC102_Classification	Void						

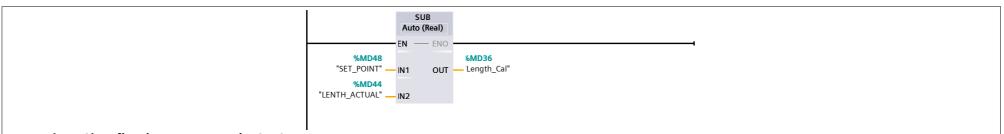
Network 1: test dest



Network 2: 현재스텝모터위치

Network 3: 목표치 도달후 모터 정지

셋 포인트에 도착



Network 4: Classfication Data ON Site03-04

```
Totally Integrated
  Automation Portal
                                                                                                                                                          "DB102.DBX0.7"

"0102.
magazine_DB".
MG01.MG.
DATA_ON1
                                                                              %DB100.DBD28
"0100.POINT".
Site0[3].Dest
                                                                                                                                                                -( )-
                                                                                 Real
                                                                                   0.0
                                                                                                                                                           %DB102.DBX1.1
                                                                                                                                                           "0102.
magazine_DB".
MG01.MG.
DATA_ON2
                                                                              %DB100.DBD36
                                                                              "0100.POINT".
Site0[4].Dest
                                                                                - Real
                                                                                                                                                                Network 5:
                                                                                                   %DB162
"TIMER12"
                                                                                                      TON
Time
                                                                                  %10.0
                                                                              "Step1_HOME"
                                                                                                            Q
                                                                                                           ET — 「#0ms
Network 6:
                                                                                                                                       %DB102.DBX1.1
"0102.
magazine_DB".
MG01.MG.
DATA_ON2
                                                                                                                    %DB102.DBX0.7
                                                                                                                        "0102.
                                                                                                                    magazine_DB".
MG01.MG.
DATA_ON1
                                                                                                                                                              %M31.0
                                                                                                      %I1.4
                                                                               "TIMER12".Q
                                                                                                   "Object_ON"
                                                                                                                                                             "Go_Okay"
Network 7: Classfication Auto Start [step0]
                                                                                                              %MB32
                                                                       %M100.0
                                                                                           %M31.0
                                                                                                                                 %M100.0
                                                                                                                                                                        %M32.0
                                                                                                                                                    %M32.1
                                                                                                               "busy"
                                                                                                                                                                      "Move_RDY"
                                                                        "Auto"
                                                                                          "Go_Okay"
                                                                                                                                  "Auto"
                                                                                                                                                    "Coil_on"
                                                                                                               ==
Byte
                                                                                                                                                                          -( )-
                                                                     %M32.0
"Move_RDY"
Network 8: Classfication Auto [step1] coil ON
                                                                                                                       %M100.0 "Auto"
                                                                                                                                          %M32.1 "Coil_on"
                                                              %M32.0
                                                                                 %M32.0
                                                                                                    %M32.3
                                                                                                  "Go Storage"
                                                            "Move_RDY"
                                                                               "Move_RDY"
                                                                                                                                             -( )-
                                                                                                                                                             %DB161
"TIMER11"
                                                              %M32.1
                                                              "Coil_on"
                                                                                                                                                               TON
lime
                                                                                                                                                                      Q -
                                                                                                                                                                      ET __#0ms
Network 9: set point on
                                                                                %M100.0
                                                                                  "Auto"
                                                                                                  MOVE
                                                                                   +
                                                                                                  EN --- ENO
                                                                                                                  %MD48
                                                                                %DB100.DBD32
                                                                                                       ■OUT1 — SET_POINT"
                                                                                 "0100.POINT".
Site0[4].Work __
                                                                               %MD48
"SET_POINT"
                                                                                                                                                              %M80.5 "check1"
                                                                                                                                                                ⊣ }——
                                                                                   0.0
```

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  Automation Portal
Network 10: Classfication Auto [step2] Go Storage
                                                                              %MD48
                                                                                              %M32.1
                                                                                                              %M100.0
                                                                                                                               %M32.4
                                                                                                                                                %M32.3
                                                                            "SET_POINT"
                                                           "TIMER11".Q
                                                                                              "Coil_on"
                                                                                                               "Auto"
                                                                                                                              "Coil OFF"
                                                                                                                                              "Go Storage"
                                                                              <>
Real
                                                                                                \dashv \vdash
                                                                                                                                  <del>-</del>1/1-
                                                                                                                                                  0.0
                                                             %M32.3
                                                           "Go Storage"
Network 11:
                                                                                                                      %DB163
"TIMER13"
                                                                                                                        TON
Time
                                                                                      %MD36
                                                                      %M32.3
                                                                                    "Length_Cal"
                                                                    "Go Storage"
                                                                                                                             ET -- #0ms
Network 12: Classfication Auto [step3] Coil OFF
                                                                                    %M32.3
"Go Storage
                                                                                                                                       %M32.4 "Coil OFF"
                                                                                                       %M32.5
                                                                                                                       %M100.0
                                                                    "TIMER13".Q
                                                                                                      "Go Zero"
                                                                                                                        "Auto"
                                                                     %M32.4 "Coil OFF"
                                                                                     %DB164
"TIMER14"
                                                                                       TON
                                                                      %M32.4
                                                                     "Coil OFF"
                                                                                             Q
                                                                            1#0.55 ___PI
                                                                                             EI ___ #Ums
Network 13: Classfication Auto [step4] Go Zero
                                                                    %MD48
"SET_POINT"
                                                                                  %MD44
"LENTH_ACTUAL"
                                                                                                      %M32.4 "Coil OFF"
                                                                                                                      %M100.0 "Auto"
                                                                                                                                      %M32.6 "Step_end"
                                                                                                                                                       %M32.5
                                                    "TIMER14".Q
                                                                                                                                                       "Go Zero"
                                                                                       | <>
                                                                       Real
                                                                                       Real
                                                     %M32.5
                                                     "Go Zero"
Network 14: Classfication Auto [step5] Step end
                                                                                    %I0.0
"Step1_HOME"
                                                                                                                                        %M32.6
                                                                     "Go Zero"
                                                                                                                                       "Step_end"
Network 15: -
Network 16: Classfication Auto 전자석 ON
                                                                                                                                     %Q1.0
"Magnet_Coil_
ON"
                                                                                      %M32.1 "Coil_on"
                                                                     %M100.0
                                                                     %M100.1
                                                                                      %M60.3
Network 17: Classfication Auto 전자석 OFF
```

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  Automation Portal
                                                                                                                     %Q1.0
                                                                         %M32.4 "Coil OFF"
                                                                                                                  "Magnet_Coil_
ON"
                                                           %M100.0
                                                            "Auto"
                                                             +
                                                                                                                      -|₹ }-
                                                            %M100.1
                                                                          %M60.3
                                                           "Manual"
                                                                          "TB_Coil"
Network 18: 모터 사용가능 신호 >>>>> [Network08]스탭모터 파워
                                                           %M100.1 "Manual"
                                                                        %M60.0
"TB_ENable"
                                                                                                                    %M30.0
                                                                                                                  "Step_Enable"
                                                           %M100.0 "Auto"
Network 19: 모터 구동 신호 >>>>>>[Network09]스탭모터 구동
                                                                                                                   %M30.1
"MoveStep_
Motor"
                                                                         %M60.1 "TB_Start"
                                                            %M100.1
                                                             +
                                                                            4 F
                                                                                                                      %M100.0
                                                                          %M32.3
                                                                        "Go Storage"
                                                                          %M32.5
                                                                          "Go Zero"
Network 20: 모터 속도
                                                           %M100.0
                                                            "Auto"
                                                                           MD40

Speed_SP"
Network 21: 모터 홈 구동 신호
                                                                                                                    %M30.2
                                                                                                                  "Step_Motor_
HOME"
                                                           %M100.1
                                                                          %M60.2
                                                           "Manual"
                                                                         "TB_Home"
                                                                                      "Step1_HOME"
Network 22: 스탭모터 파워
                                                                              %DB51
"MC_Power_DB"
                                                                                MC_Power
                                                                                           Status — alse
                                                                %DB50
                                                              "Step_M1" __
                                                                                            Error —alse
                                                            "Step_Enable" — Enable
                                                                   O ___ StopMode
Network 23: 스탭모터 구동
```

