

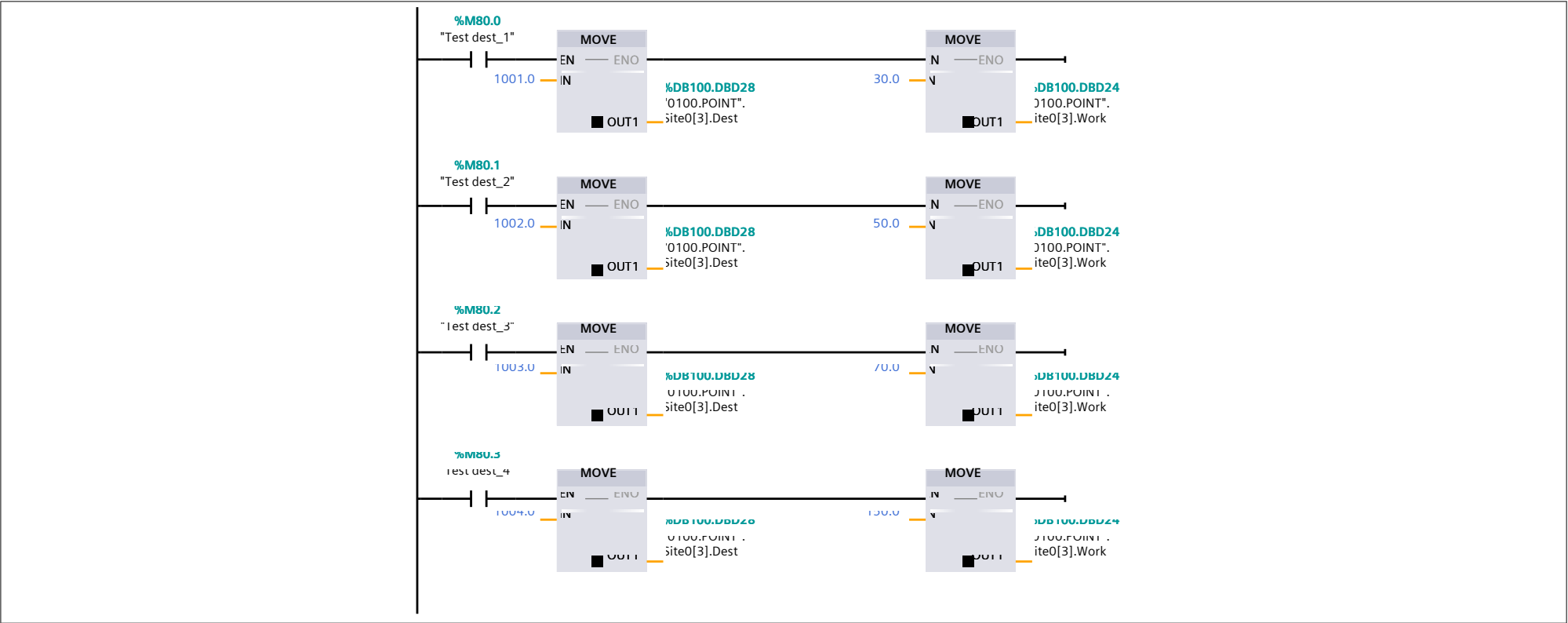
AI_detailchecker&classification_230614 / PLC_1 [CPU 1215C AC/DC/Rly] / Program blocks / 2.FC_program

FC102_Classification [FC102]

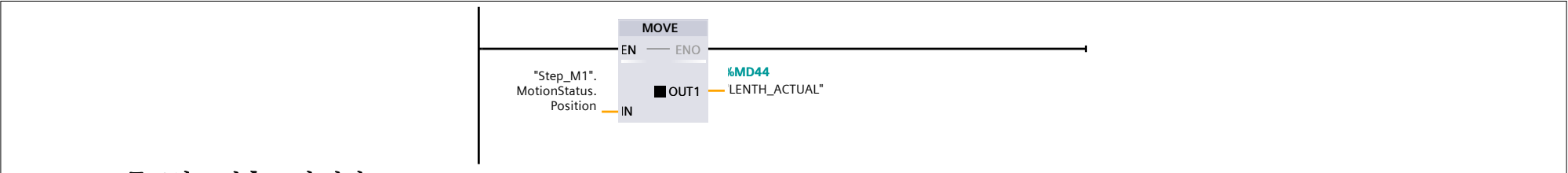
| FC102_Classification Properties | | | | | | | |
|---------------------------------|----------------------|-----------------|-----|---------|----|----------|-----|
| General | | | | | | | |
| Name | FC102_Classification | Number | 102 | Type | FC | Language | LAD |
| Numbering | Manual | | | | | | |
| 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

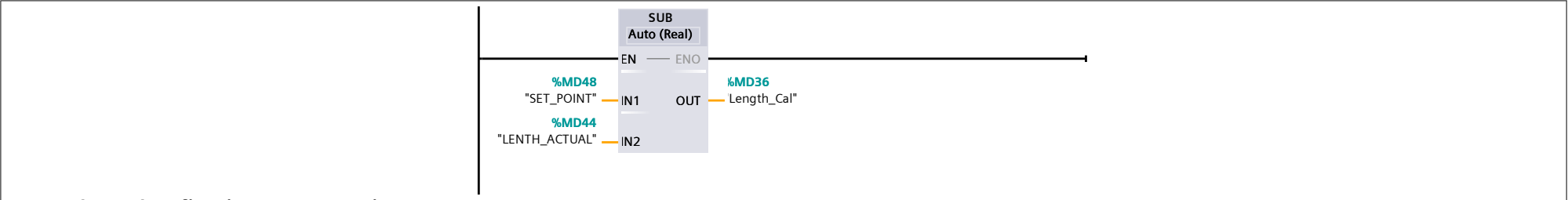


Network 2: 현재스텝모터위치

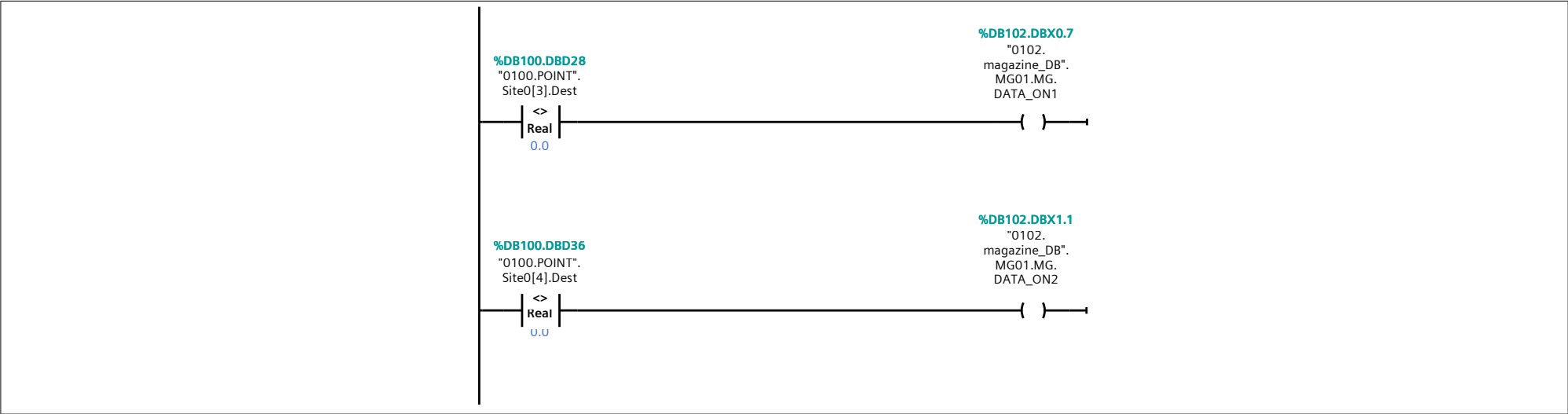


Network 3: 목표치 도달후 모터 정지

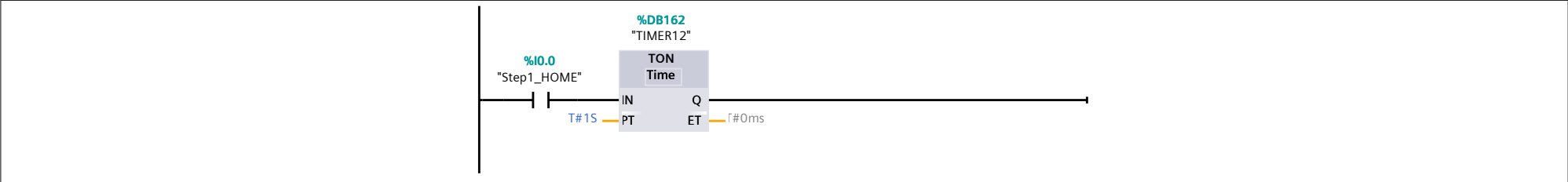
셋 포인트에 도착



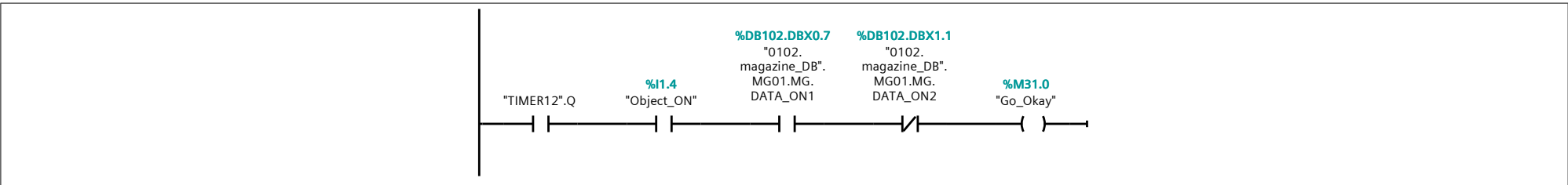
Network 4: Classification Data ON Site03-04



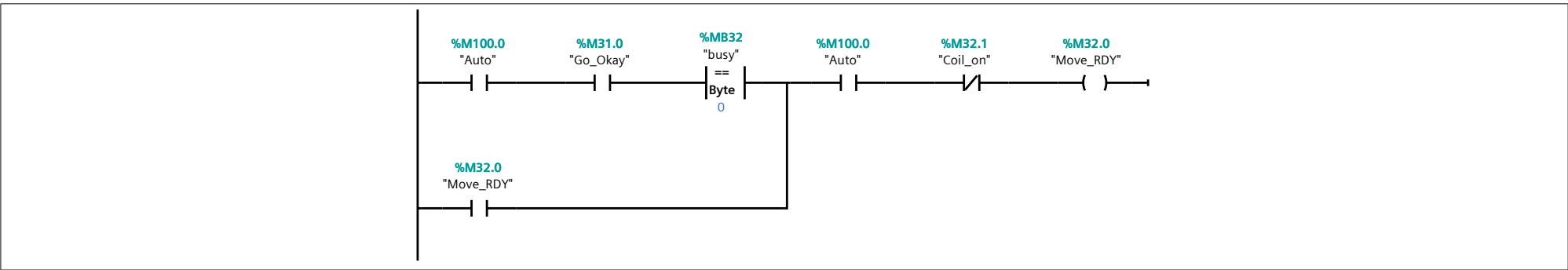
Network 5:



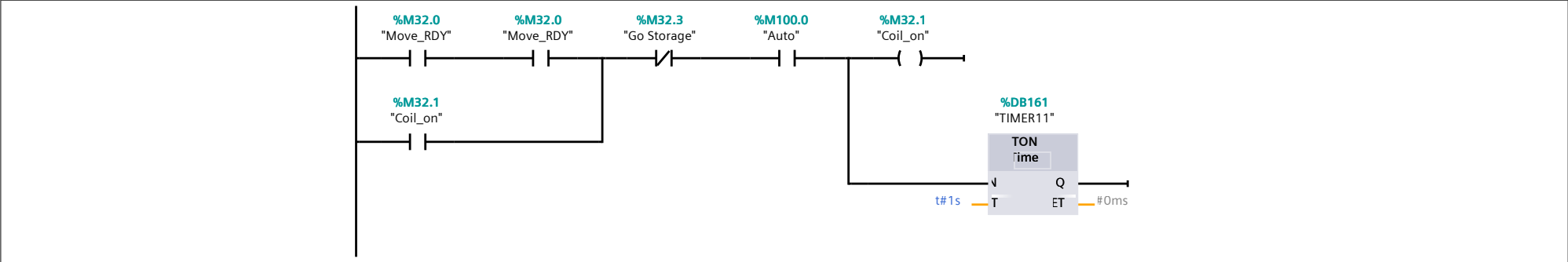
Network 6:



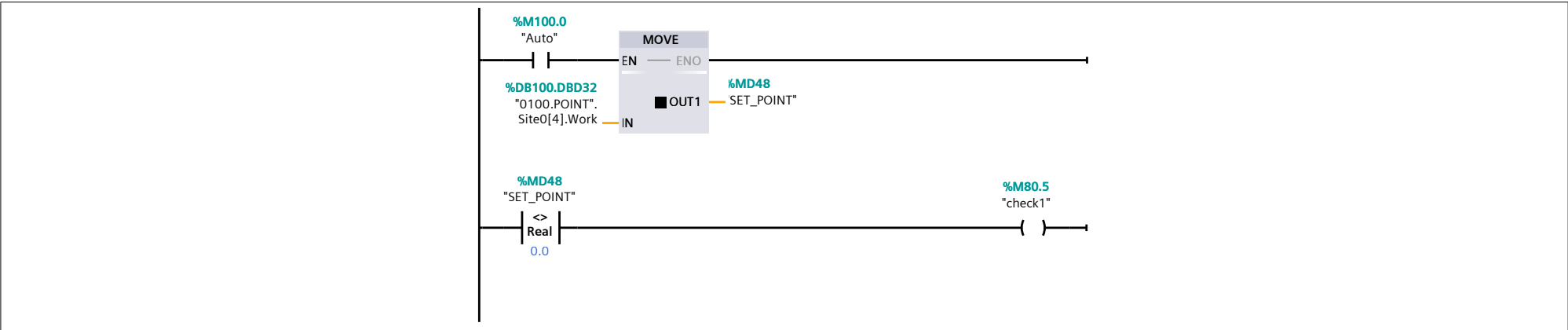
Network 7: Classification Auto Start [step0]



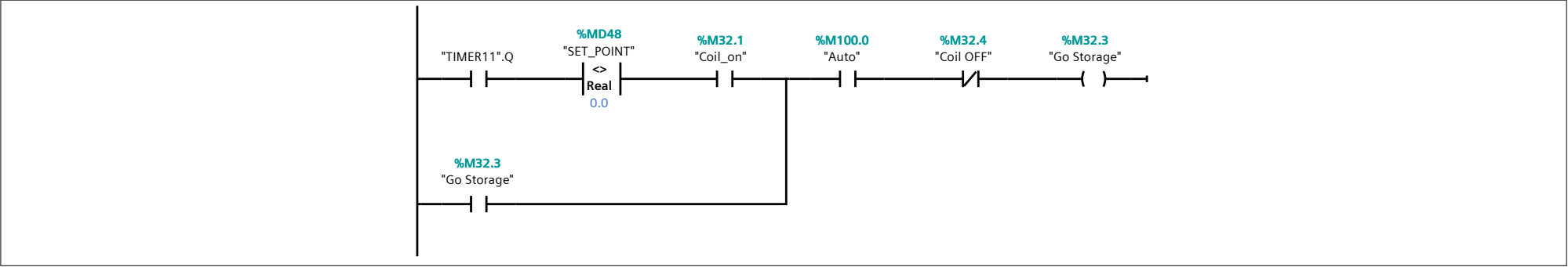
Network 8: Classification Auto [step1] coil ON



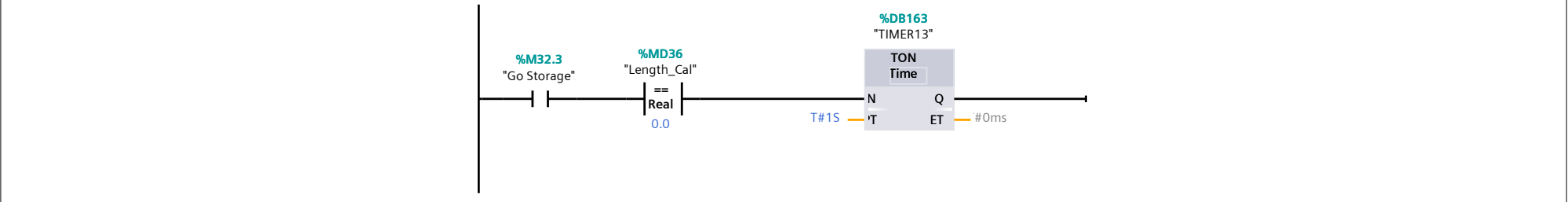
Network 9: set point on



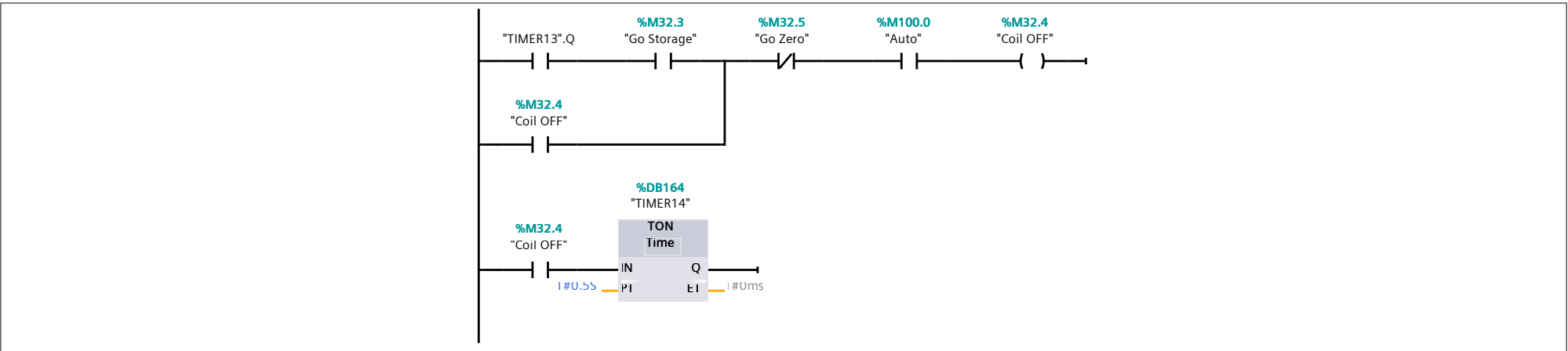
Network 10: Classification Auto [step2] Go Storage



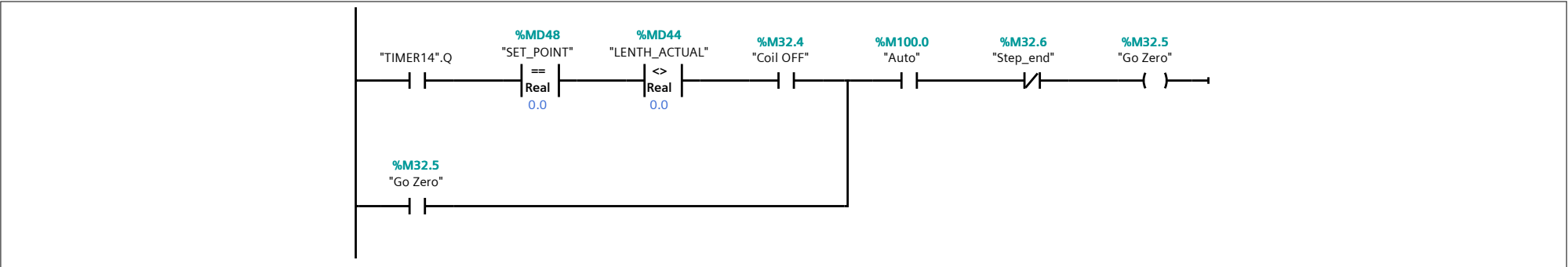
Network 11:



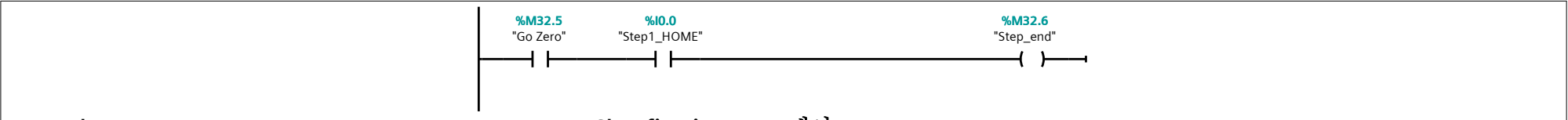
Network 12: Classification Auto [step3] Coil OFF



Network 13: Classification Auto [step4] Go Zero

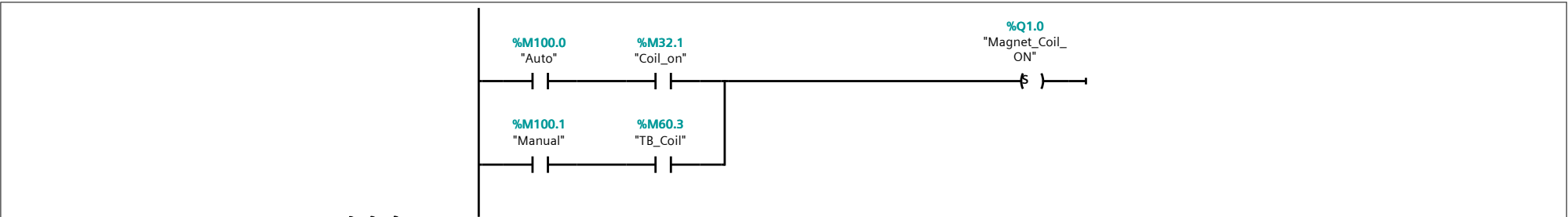


Network 14: Classification Auto [step5] Step end

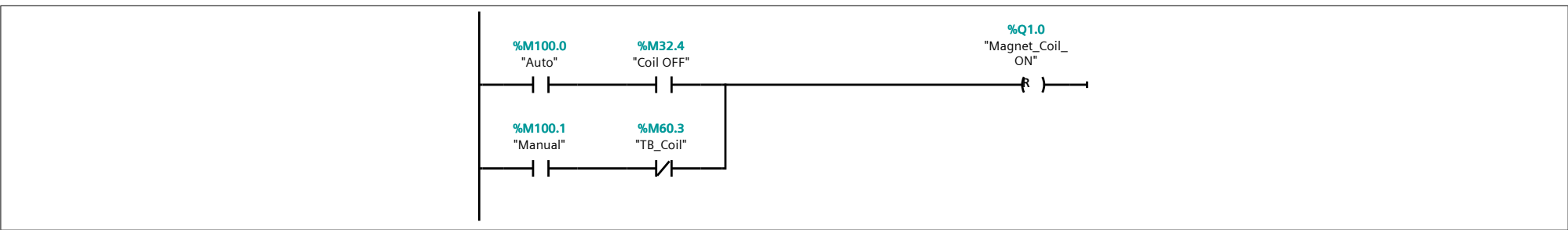


Network 15: -----Classification Auto 제어-----

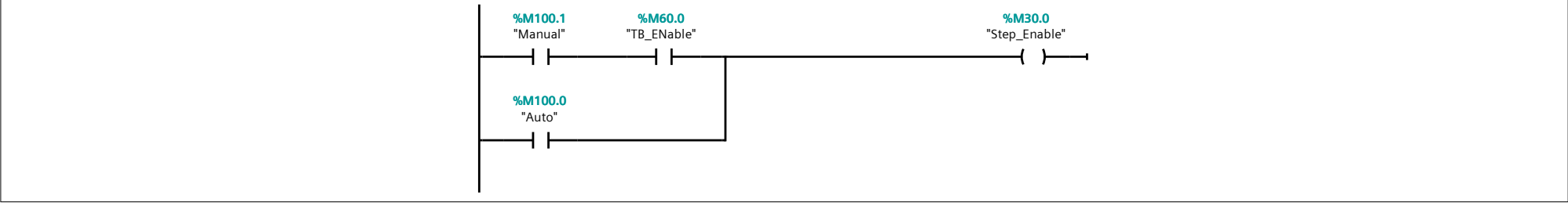
Network 16: Classification Auto 전자석 ON



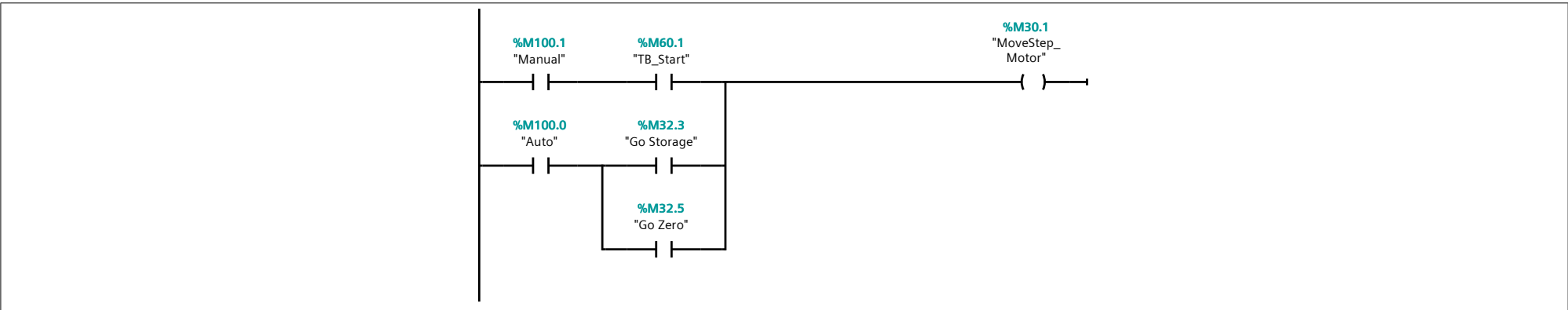
Network 17: Classification Auto 전자석 OFF



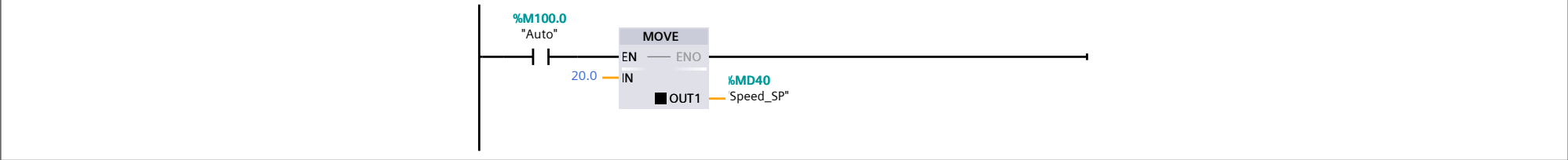
Network 18: 모터 사용가능 신호 >>>>>>> [Network08]스텝모터 파워



Network 19: 모터 구동 신호 >>>>>>>>>[Network09]스텝모터 구동



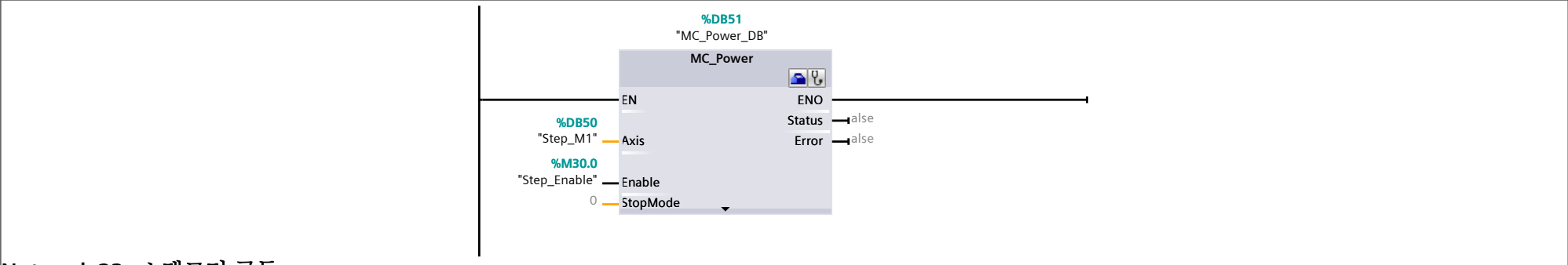
Network 20: 모터 속도



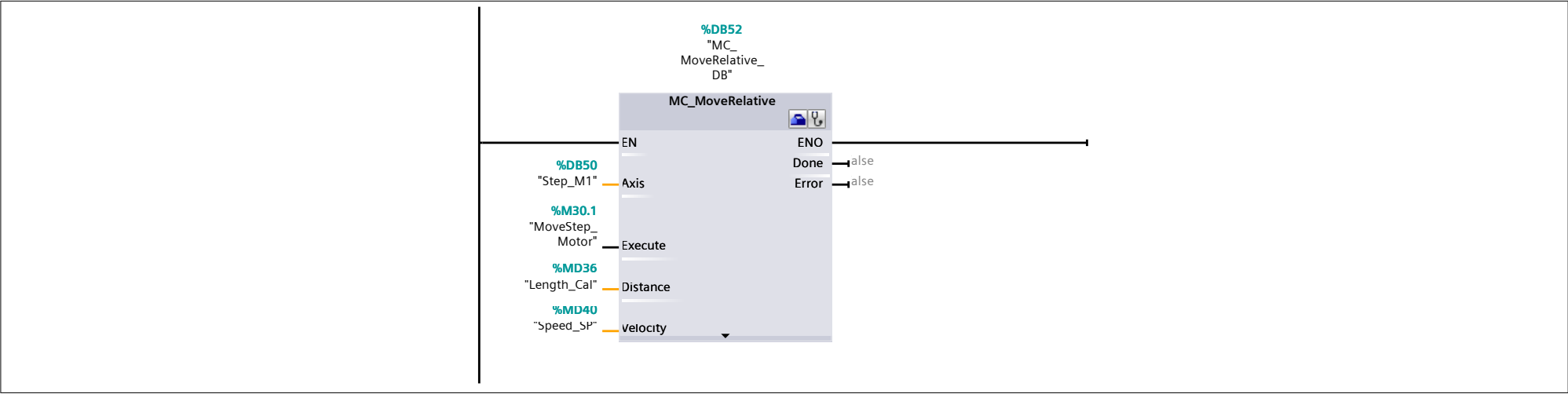
Network 21: 모터 홈 구동 신호



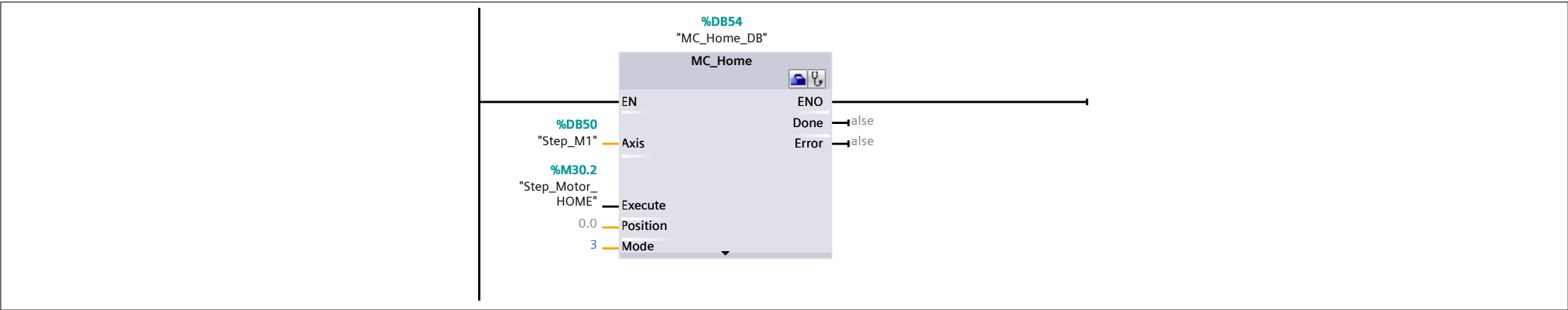
Network 22: 스텝모터 파워



Network 23: 스텝모터 구동



Network 24: Home 구동



Network 25:

