Totally Integ Automation	rated Portal						
AI_detail	checker&classific	cation_230614 /	PLC_1 [CPU 1	1215C AC	/DC/Rly] / Pro	gram blocks	
Main [OB1							
Main Propertie General Name Numbering	Main Automatic	Number 1		Туре	ОВ	Language	LAD
nformation Fitle Version	"Main Program Sweep (Cycle)"	Author User-defined ID		Comment		Family	
/lain lame		Data type	Default value		Comment		
▼ Input Initial_Ca Remaner Temp		Bool Bool			Initial call of this =True, if remand	s OB ent data are available	
Constant							
letwork 1: /	Allways ON/OFF						
		%M0.0 "Allways_Off"			%M0.1 "Allways_On" 	.	
					"Allways_Off" (R)	-	
Network 2:	clock 메모리 확인						
		%M1.0 %l "Clock_10Hz" "Cloc	M1.1 %M1.2 :k_5Hz" "Clock_2.5Hz"	%M1.3 "Clock_2Hz"	%N "Pulse	/12.0 _Check" { } —— -	
			M1.5 %M1.6 k_1Hz" "Clock_0.625Hz"	%M1.7 "Clock_0.5Hz"	иот		
Network 3:	Move_object	l					
			C100 Magazine" ENO			.	
%FC101 "FC101_Checker_Conveyor"							
			ENO ENO ENO ENO				
Network 4:	Move_data						
			AoveZon" ENO			-	
Network 5: Auto && Manual							

Totally Integrated Automation Portal **%DB101.DBX2.1**"0101.CV_DB".
CV[1].CV.AUTO_
RUN **%M100.0** "Auto" **%DB101.DBX50.1**"0101.CV_DB".
CV[2].CV.AUTO_
RUN -()---- **%M100.1** "Manual" **%M100.0** "Auto" \prec \succ **%UB1U1.UBX2.4**"U1U1.CV_UB".
CV[1].CV.CV_
Manu **%M1UU.1** Ivianuai **—**()—— **70ม เบา.บธ.วบ.4** บาบา.Cv_บธ . CV[2].CV.CV_ Manu ()—— **Network 6: WINDOW %M600.1** "WS_OP01" **%M700.1** "WIN_OP01" **→** → **%M600.2** "WS_OP02" **%M700.2** "WIN_OP02" **-()**-**-**| |-