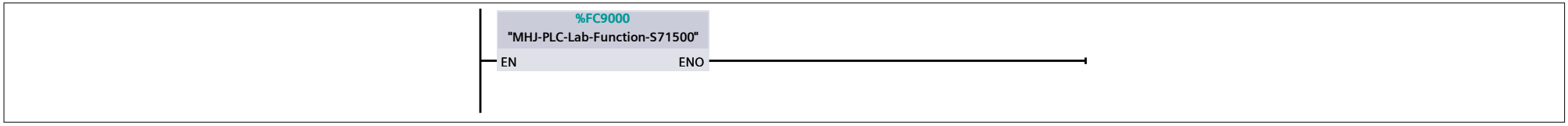
PICK&PLACE / PLC_1 [CPU 1511-1 PN] / Program blocks

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**	**Supervision**	**Comment**
Input				
Initial_Call	Bool			Initial call of this OB
Remanence	Bool			=True, if remanent data are available
Temp				
Constant				

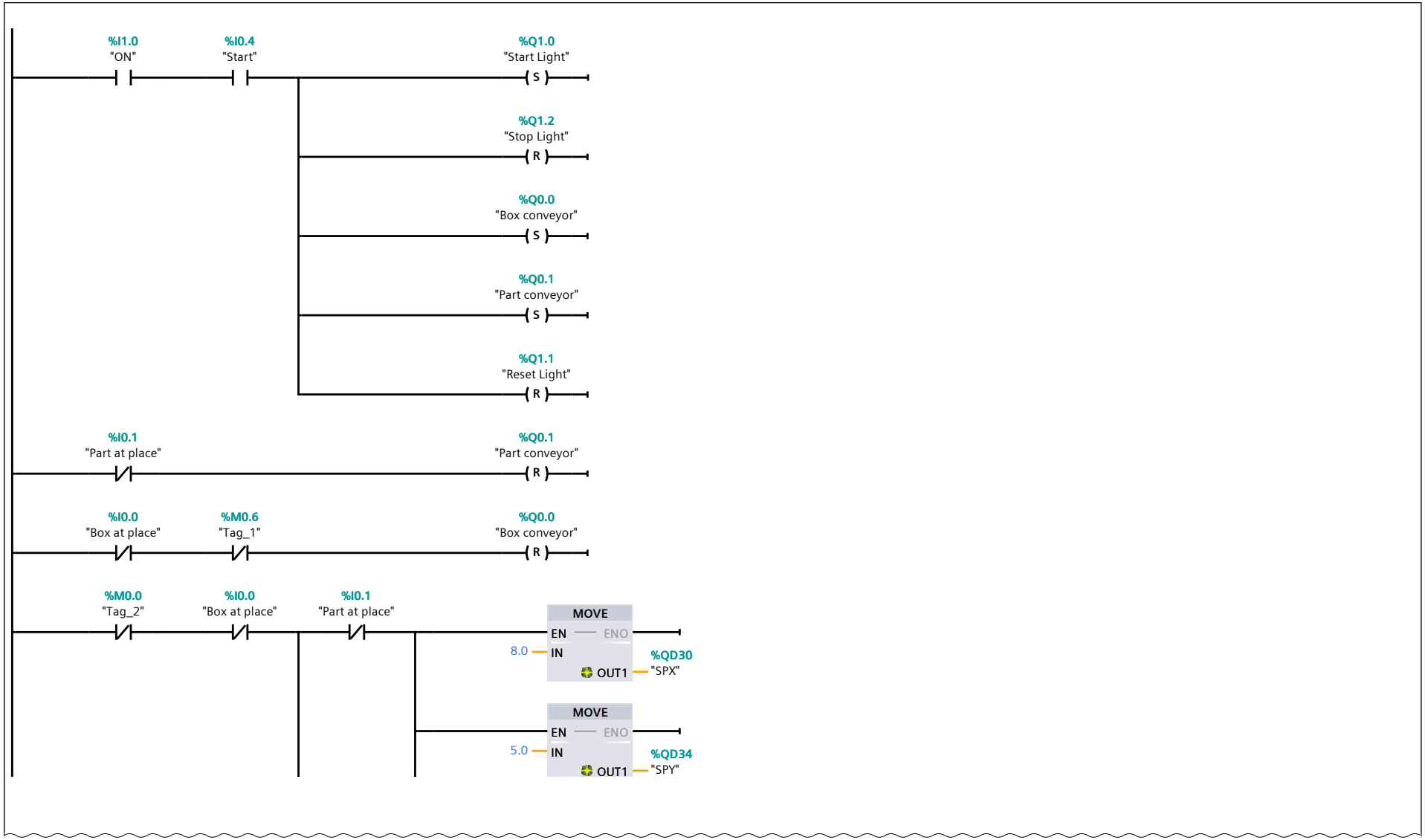
Network 1:



Symbol	Address	Type	Comment

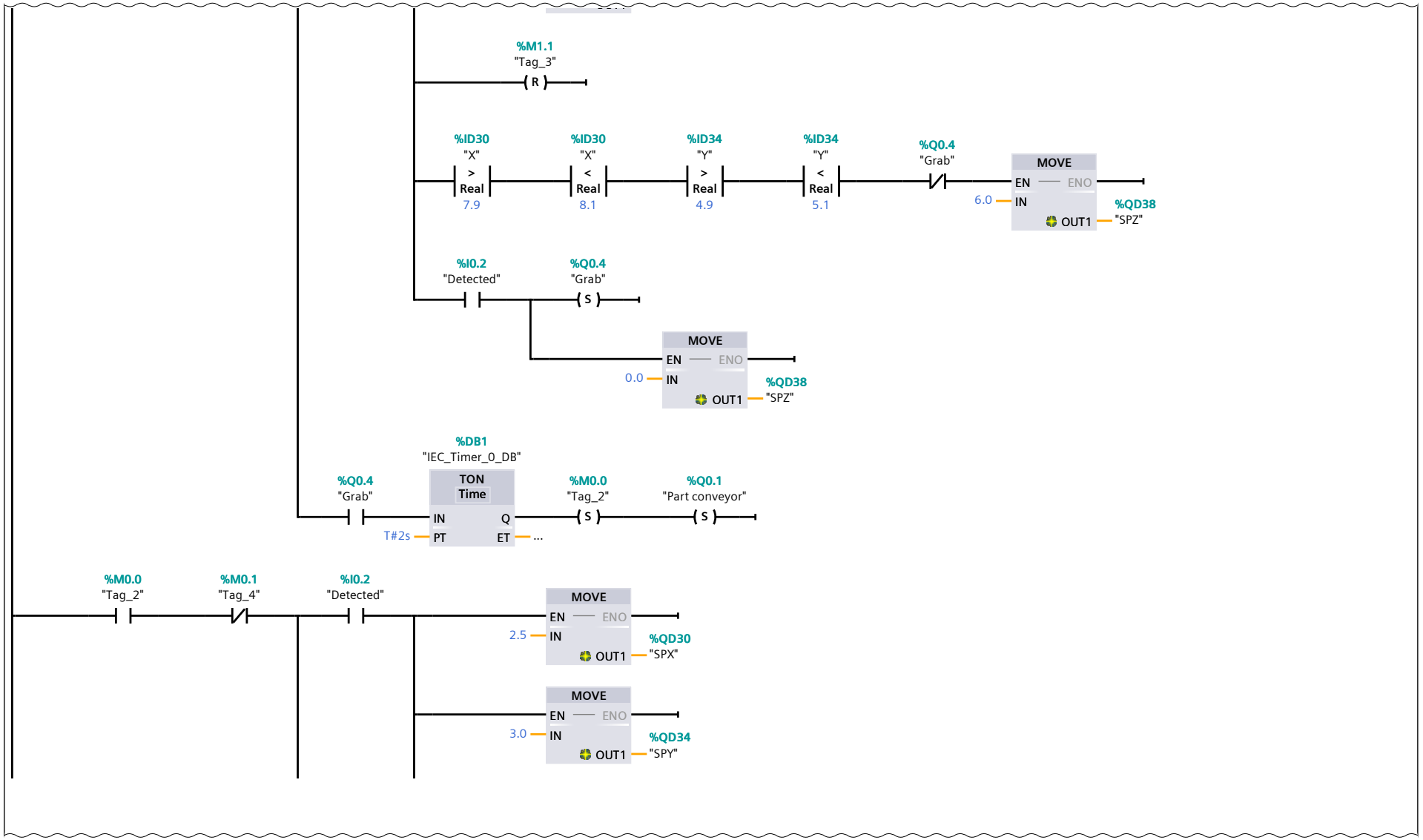
Network 2:

Network 2: (1.1 / 10.1)



Network 2: (2.1 / 10.1)

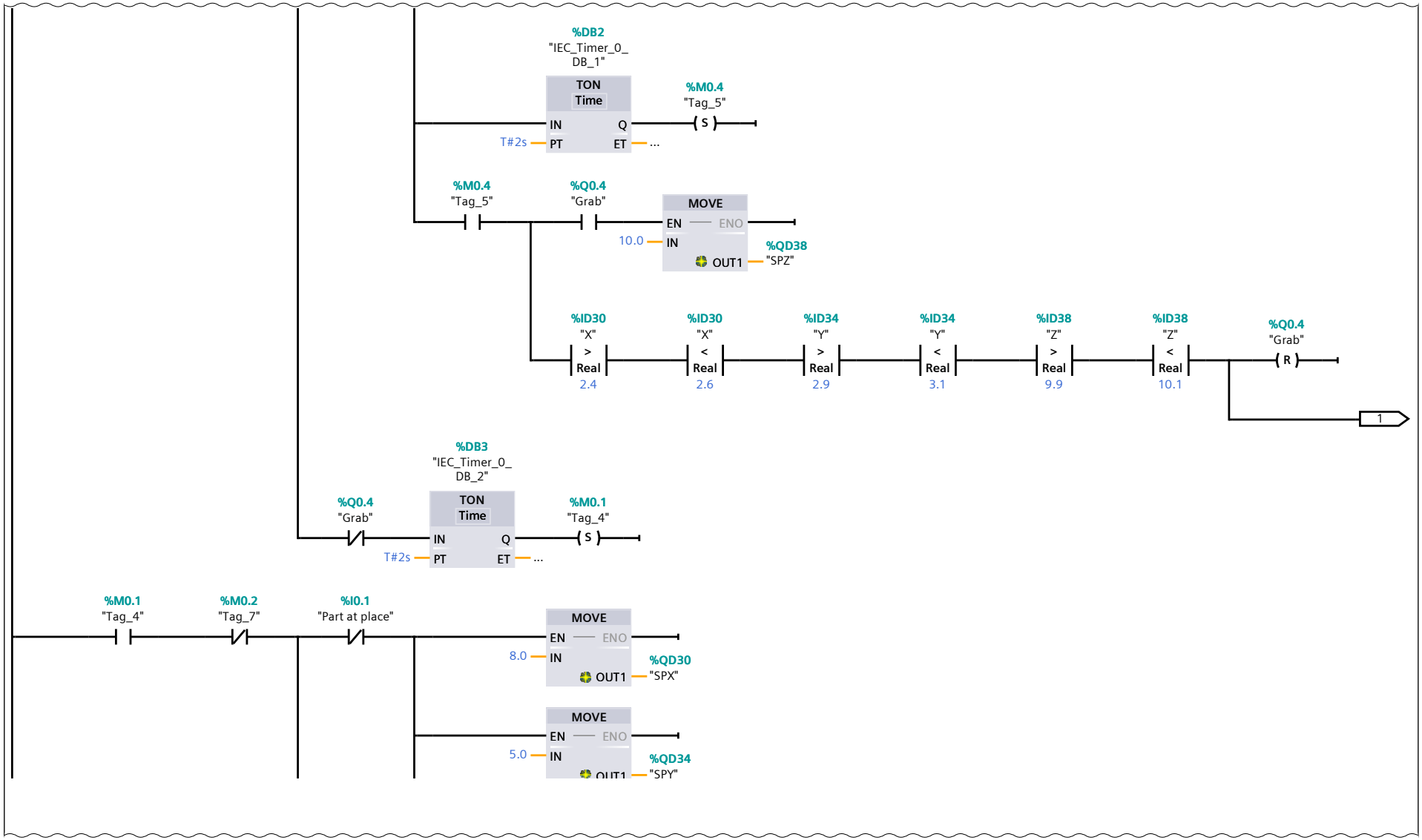
1.1 (Page1 - 2)



3.1 (Page1 - 4)

Network 2: (3.1 / 10.1)

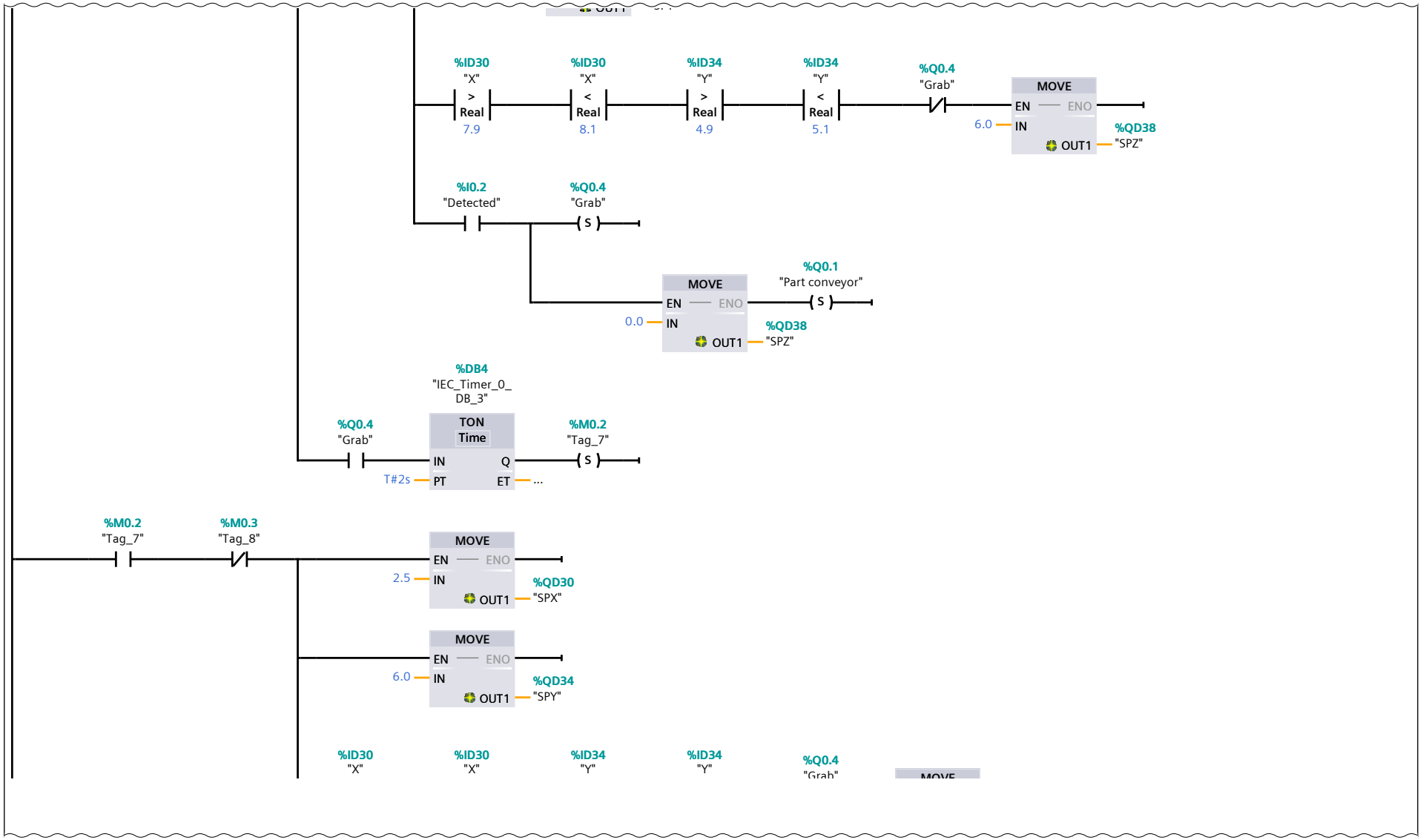
2.1 (Page1 - 3)



4.1 (Page1 - 5)

Network 2: (4.1 / 10.1)

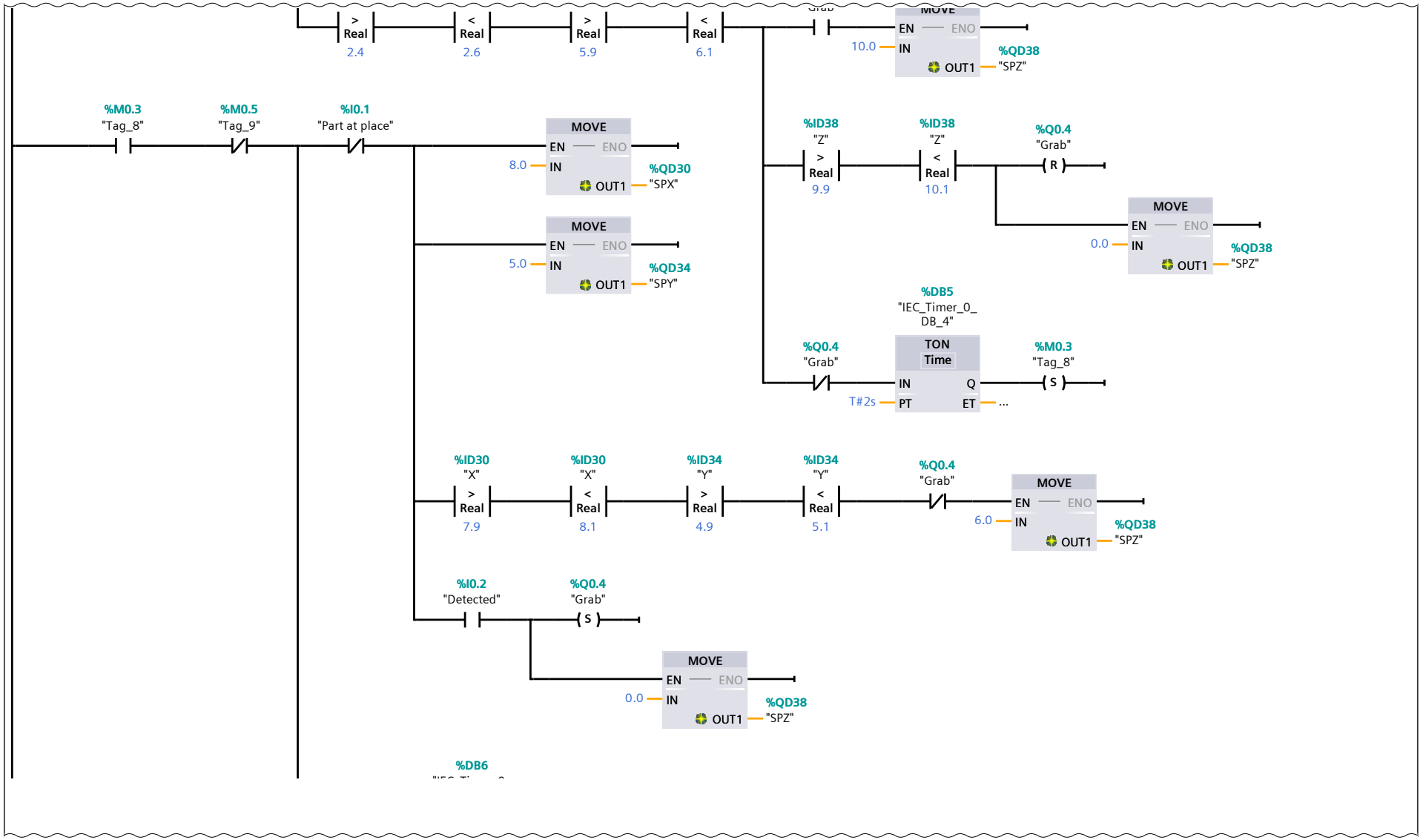
3.1 (Page1 - 4)



5.1 (Page1 - 6)

Network 2: (5.1 / 10.1)

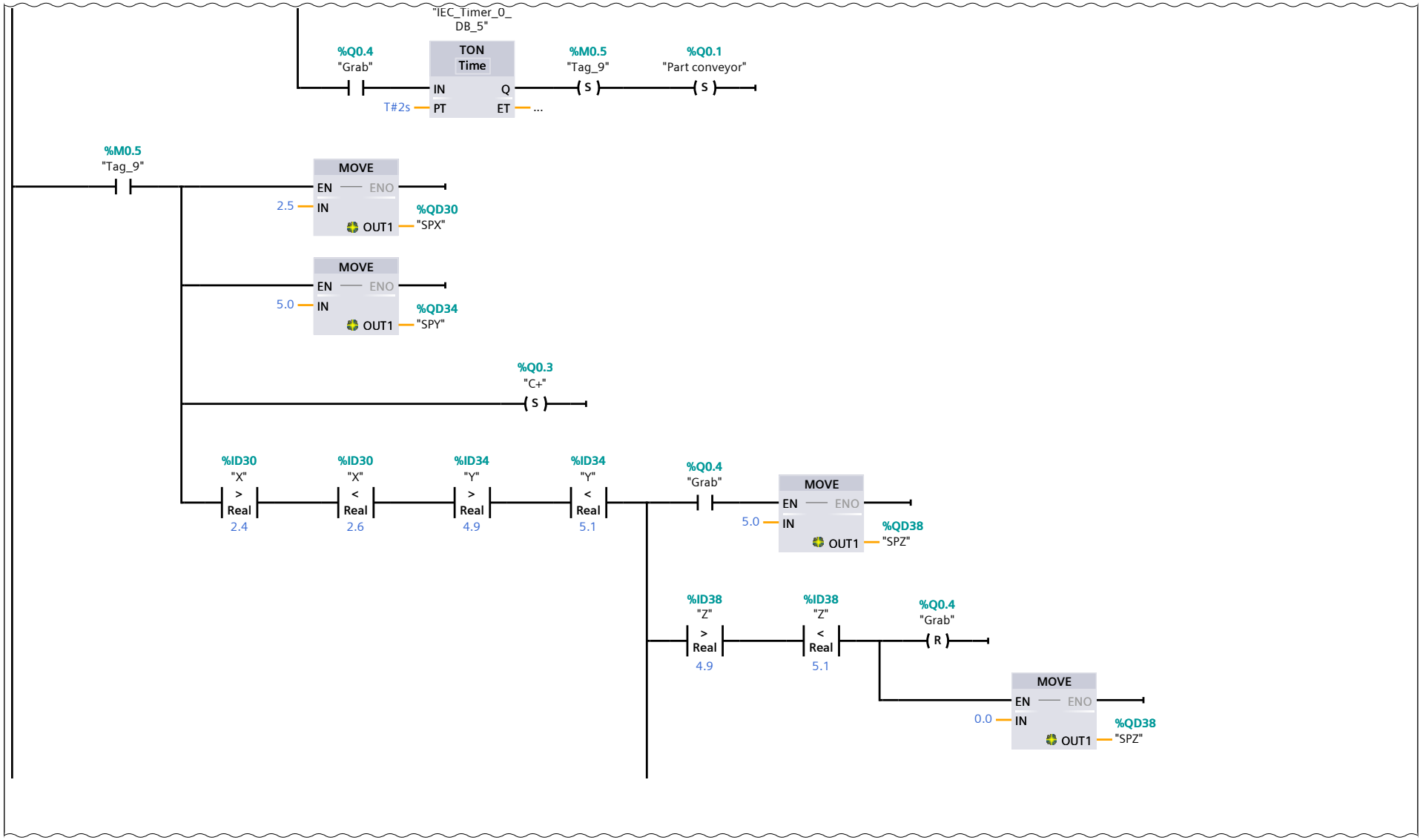
4.1 (Page1 - 5)



6.1 (Page1 - 7)

Network 2: (6.1 / 10.1)

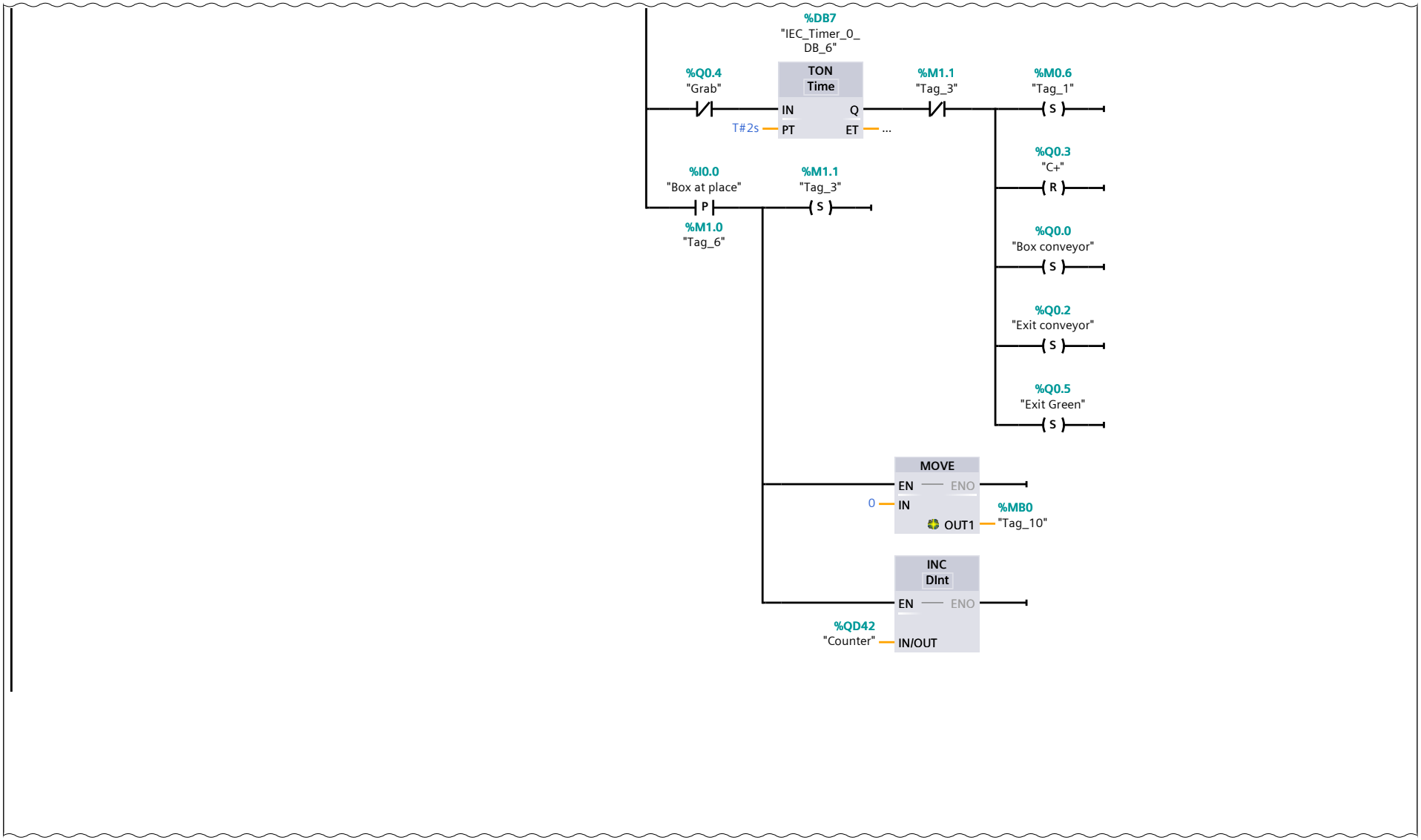
5.1 (Page1 - 6)



7.1 (Page1 - 8)

Network 2: (7.1 / 10.1)

6.1 (Page1 - 7)



8.1 (Page1 - 9)

Network 2: (8.1 / 10.1)

7.1 (Page1 - 8)

9.1 (Page1 - 10)

Network 2: (9.1 / 10.1)

8.1 (Page1 - 9)

10.1 (Page1 - 11)

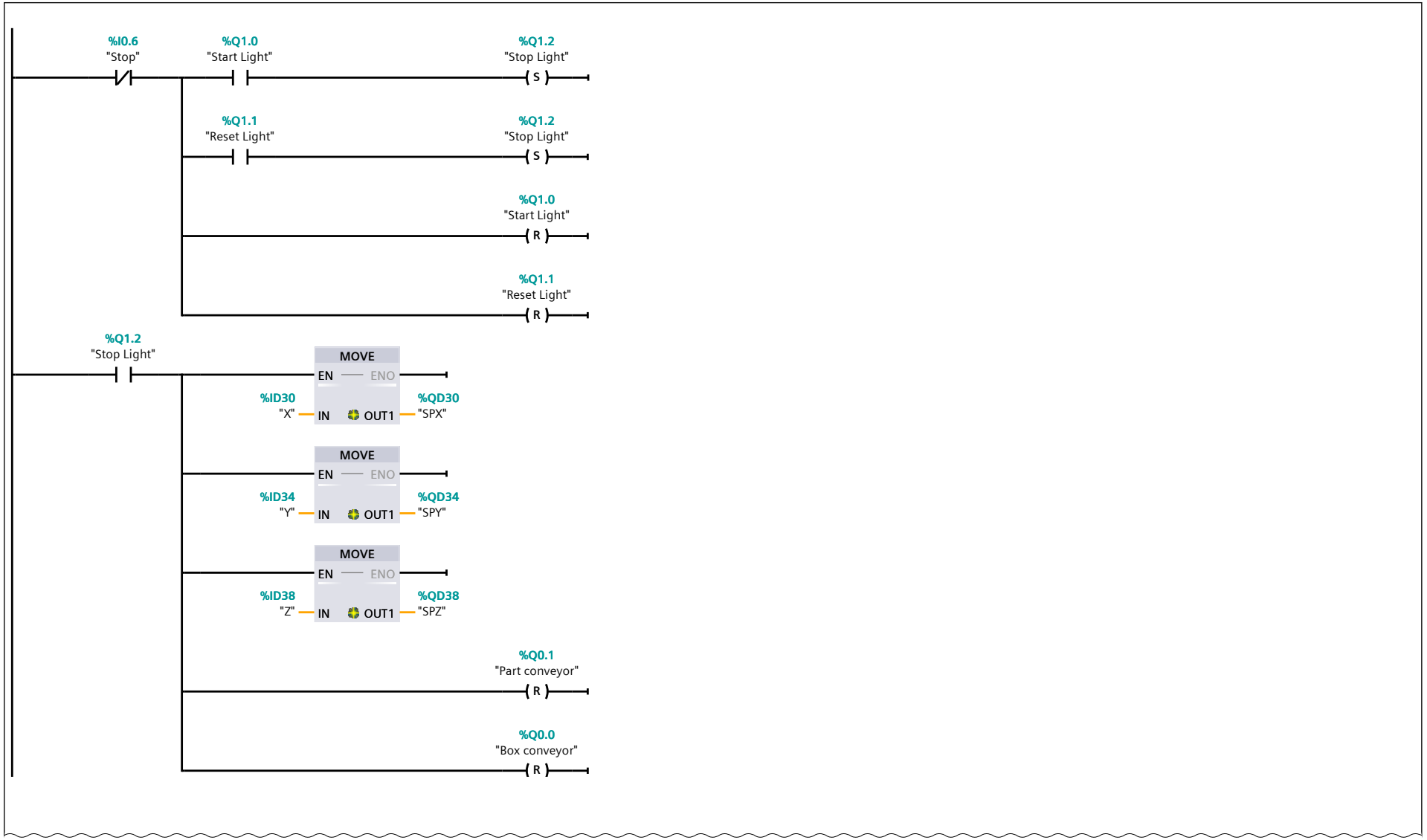
Network 2: (10.1 / 10.1)

9.1 (Page1 - 10)

Symbol	Address	Type	Comment
"Box at place"	%I0.0	Bool	
"Box conveyor"	%Q0.0	Bool	
"C+"	%Q0.3	Bool	
"Counter"	%QD42	DInt	
"Detected"	%I0.2	Bool	
"Exit conveyor"	%Q0.2	Bool	
"Exit Green"	%Q0.5	Bool	
"Grab"	%Q0.4	Bool	
"ON"	%I1.0	Bool	
"Part at place"	%I0.1	Bool	
"Part conveyor"	%Q0.1	Bool	
"Reset Light"	%Q1.1	Bool	
"SPX"	%QD30	Real	
"SPY"	%QD34	Real	
"SPZ"	%QD38	Real	
"Start Light"	%Q1.0	Bool	
"Start"	%I0.4	Bool	
"Stop Light"	%Q1.2	Bool	
"Tag_1"	%M0.6	Bool	
"Tag_2"	%M0.0	Bool	
"Tag_3"	%M1.1	Bool	
"Tag_4"	%M0.1	Bool	
"Tag_5"	%M0.4	Bool	
"Tag_6"	%M1.0	Bool	
"Tag_7"	%M0.2	Bool	
"Tag_8"	%M0.3	Bool	
"Tag_9"	%M0.5	Bool	
"Tag_10"	%MB0	Byte	
"X"	%ID30	DWord	
"Y"	%ID34	Real	
"Z"	%ID38	Real	

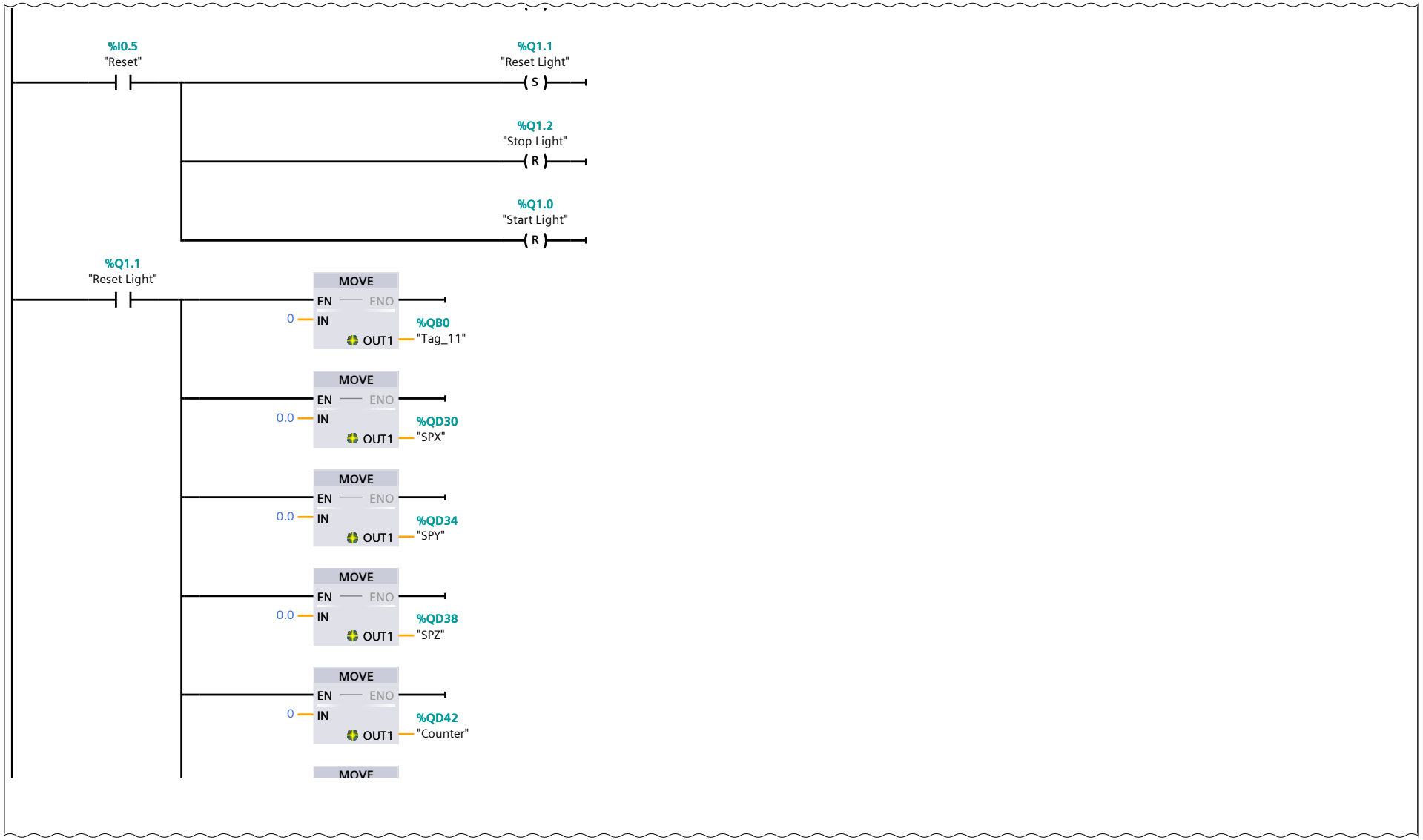
Network 3:

Network 3: (1.1 / 3.1)



Network 3: (2.1 / 3.1)

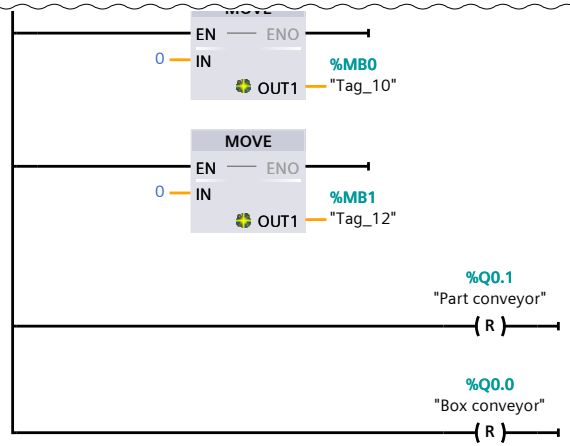
1.1 (Page1 - 13)



3.1 (Page1 - 15)

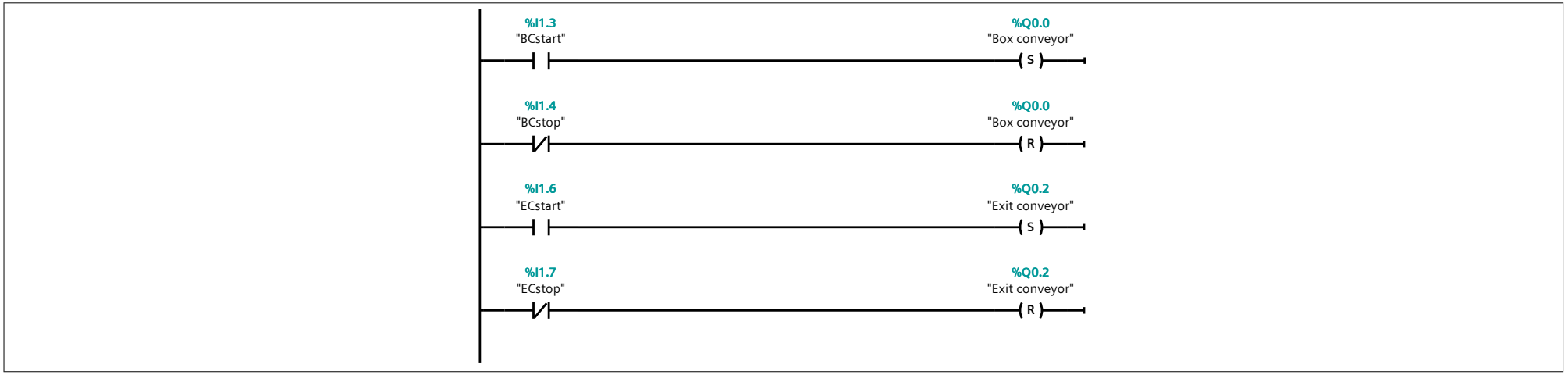
Network 3: (3.1 / 3.1)

2.1 (Page1 - 14)



Symbol	Address	Type	Comment
"Box conveyor"	%Q0.0	Bool	
"Counter"	%QD42	DInt	
"Part conveyor"	%Q0.1	Bool	
"Reset Light"	%Q1.1	Bool	
"Reset"	%I0.5	Bool	
"SPX"	%QD30	Real	
"SPY"	%QD34	Real	
"SPZ"	%QD38	Real	
"Start Light"	%Q1.0	Bool	
"Stop Light"	%Q1.2	Bool	
"Stop"	%I0.6	Bool	
"Tag_10"	%MB0	Byte	
"Tag_11"	%QB0	Byte	
"Tag_12"	%MB1	Byte	
"X"	%ID30	DWord	
"Y"	%ID34	Real	
"Z"	%ID38	Real	

Network 4:



Symbol	Address	Type	Comment
"BCstart"	%I1.3	Bool	
"BCstop"	%I1.4	Bool	
"Box conveyor"	%Q0.0	Bool	
"ECstart"	%I1.6	Bool	
"ECstop"	%I1.7	Bool	
"Exit conveyor"	%Q0.2	Bool	