

Totally Integrated Automation Portal

Color Baised Sorting Station Factory IO / 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:

%FC9000

"MHJ-PLC-Lab-Function-S71200"

EN

ENO

Network 2:

%I0.1

"Start"

%I0.3

"Stop"

%I0.2

"Reset"

%M0.0

"SR_1"

SR

S

R1

Q

%Q0.0

"Entry_Conveyer"

%Q0.2

"Exit_Conveyer"

%M0.1

"mains"

Network 3: Station 1

Sorting Blue Part Base

%M0.1

"mains"

%ID30

"Vision_Sensor"

%M0.2

"SR_2"

SR

%M0.1

"mains"

%M0.5

"Exit_memory"

S

R1

Q

%Q0.3

"Sorter_1_Turn"

%Q0.4

"Sorter_1_Belt"

Network 4: Station 2

Sorting Green Top Part

%M0.1

"mains"

%ID30

"Vision_Sensor"

%M0.3

"SR_3"

SR

%M0.1

"mains"

%M0.5

"Exit_memory"

S

R1

Q

%Q0.5

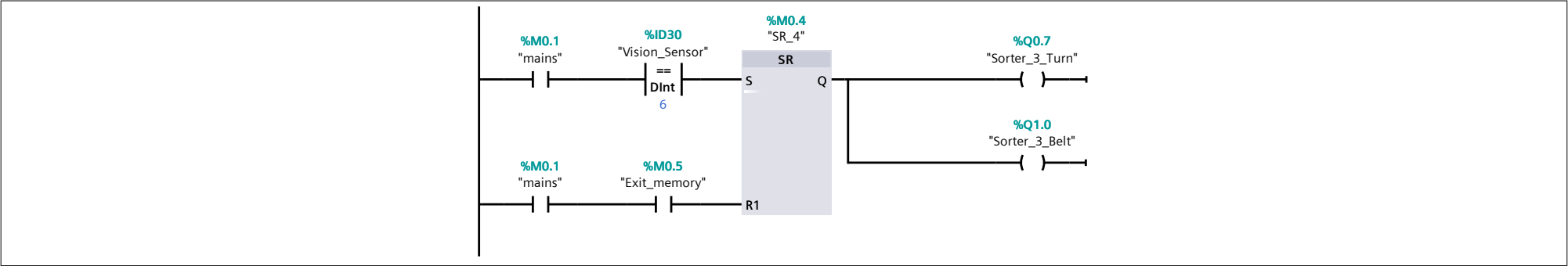
"Sorter_2_Turn"

%Q0.6

"Sorter_2_Belt"

Network 5: Station 1

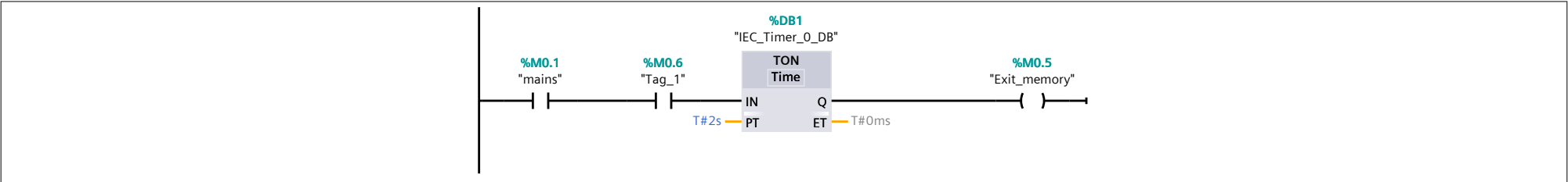
Sorting Gren Part Base Part



Network 6:



Network 7:



Network 8:

