|--|

height_sorting / PLC_1 [CPU 1211C DC/DC/DC] / Program blocks

Main [OB1]

Main Properties	Main Properties							
General								
Name	Main	Number	1	Туре	ОВ	Language	LAD	
Numbering	Automatic							
Information								
		Author		Comment		Family		
	cle)"							
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:

```
"MHJ-PLC-Lab-Function-S71200"
— EN ENO
```

Network 2:

start/ stop

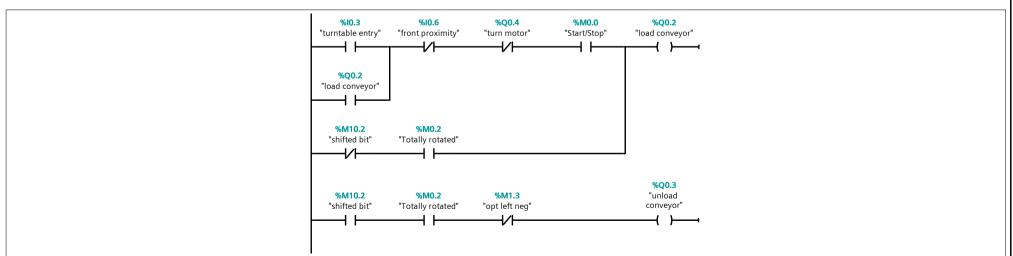
```
%I1.3 %I1.5 %M0.0 "Start/Stop" "Start/Stop"
```

Network 3:

feeder and entry conveyor

Network 4:

loading and unloading



Network 5:

twisting palette

Totally Integrated **Automation Portal** %I0.6 "front proximity" %M1.1
"opt right neg" %M1.3 "opt left neg" %M0.0 "Start/Stop" %Q0.4 "turn motor" -1/1-%Q0.4 "turn motor" %DB1 "Timer1" TON %Q0.4 %M0.2 Time "turn motor" "Totally rotated" **←** }-T#2s — **PT** ET — T#0ms Network 6: shifting process %I0.0 "optical entry" SHL Byte %MB10 %MB10 "Tag_1" -- "Storage Byte" "Storage Byte" — IN OUT · Network 7: box type **%I0.1** "opt low box" %I0.2 "opt high box" %M10.0 "decision bit" **-(** s **)**--%M10.0 "opt high box" "decision bit" -(R)-Network 8: right conveyor **%M0.6**"opt end right conv neg" %Q0.6 "right conveyor" %M10.2 %M0.0 %10.5 "back proximity" "shifted bit" "Start/Stop" **%Q0.6**"right conveyor" **%M1.6** "right box memory" %M0.0 "Start/Stop" Network 9: left conveyor %M0.7 "opt end left conv neg" %10.6 %M10.2 %M0.0 %Q0.5 "front proximity" "left coveyor" "shifted bit" "Start/Stop" -1/1- \leftarrow %Q0.5 "left coveyor" "left box memory" "Start/Stop" Network 10: conveyor end

Totally Integrated **Automation Portal %M0.6**"opt end right conv neg" **%I1.1**"opt end right" H۱F **%M0.4** "Tag_4" **%M0.7** "opt end left conv neg" %I1.2 "opt end left" H۱ **%M0.5** "Tag_6" **%I0.7**"opt right entry" **%M1.1**"opt right neg" 4 n F **%M1.0** "Tag_5" %M1.3 "opt left neg" **%I1.0**"opt left entry" H۱۲ **%M1.2** "Tag_7" Network 11: counting boxes **%DB2**"C1" CTU Int %I0.0 "optical entry" - CU %M1.4 **%I1.4** %QD30 "Tag_2" "reset button" — R 1000 — PV Network 12: box memory **%DB3**"C2" **%M1.6** "right box memory" CTU **%I0.7**"opt right entry" Int %M1.5 **cv** — 0 %M0.6 "Tag_3" "opt end right conv neg" — R **%DB4**"C3" CTU Int **%l1.0** "opt left entry" %M2.0 "left box memory" \dashv P \vdash - CU **cv** — 0 %M1.7 %M0.7
"opt end left conv neg" — R "Tag_8"