Main

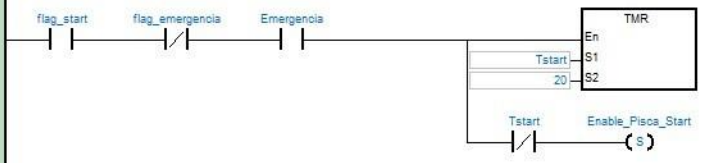
Declaration Type	Identifiers	Address	Type	Initial Value	Identifier Comment
VAR	MStart	M0	BOOL	FALSE	
VAR	flag_stop	M1	BOOL	N/A	
VAR	BtnEmergencia	M12	BOOL	N/A	
VAR	Parada_Manual	M15	BOOL	N/A	
VAR	TiraCaixa	M16	BOOL	N/A	
VAR	TirandoCaixa	M17	BOOL	N/A	
VAR	VoltaInicio2	M18	BOOL	N/A	
VAR	flag_sobrecarga	M2	BOOL	N/A	
VAR	ParadaInversao	M25	BOOL	N/A	
VAR	TemCaixa	M26	BOOL	N/A	
VAR	PegouFita	M27	BOOL	N/A	
VAR	EmRepouso	M28	BOOL	N/A	
VAR	Posicionado	M29	BOOL	N/A	
VAR	Preparado	M3	BOOL	N/A	
VAR	Embalando	M32	BOOL	N/A	
VAR	MoveX	M33	BOOL	N/A	
VAR	Mpos0	M34	BOOL	N/A	
VAR	Mpos1	M35	BOOL	N/A	
VAR	Mpos2	M36	BOOL	N/A	
VAR	ColocaFita	M37	BOOL	N/A	
VAR	VoltaInicio	M38	BOOL	N/A	
VAR	AuxTiraCaixa	M39	BOOL	N/A	
VAR	flag_sensor	M4	BOOL	N/A	
VAR	flag_emergencia	M40	BOOL	N/A	
VAR	flag_start	M41	BOOL	N/A	
VAR	Enable_Pisca_Start	M42	BOOL	N/A	
VAR	AuxCMD2	M5	BOOL	N/A	
VAR	AuxStart	M6	BOOL	N/A	
VAR	AuxCMD1	M7	BOOL	N/A	
VAR	TimerCM2	M8	BOOL	N/A	
VAR	Timer_Start	T0	TIMER	0	
VAR	Timer_Inverte1	T1	TIMER	N/A	
VAR	TimerCMD3	T10	TIMER	N/A	
VAR	TimerCMD4	T11	TIMER	N/A	
VAR	TimerPosicionado	T12	TIMER	N/A	
VAR	TimerColocaFita	T13	TIMER	N/A	
VAR	TimerTiraCaixa	T14	TIMER	N/A	
VAR	TimerColocaFita2	T15	TIMER	N/A	
VAR	Tstart	T16	TIMER	N/A	
VAR	Timer_PiscaStart_1	T17	TIMER	N/A	
VAR	Timer_PiscaStart_2	T18	TIMER	N/A	
VAR	TimerCMD0	T19	TIMER	N/A	
VAR	Timer_Inverte2	T2	TIMER	N/A	
VAR	TimerHome	T20	TIMER	N/A	
VAR	AuxTimerCMD2	T21	TIMER	N/A	
VAR	AuxTimerCMD1	T22	TIMER	N/A	
VAR	TimerCMD5	T23	TIMER	N/A	
VAR	TimerCMD6	T24	TIMER	N/A	
VAR	TimerHome2	T25	TIMER	N/A	
VAR	debug	T26	TIMER	N/A	
VAR	Timer_troca1	T3	TIMER	N/A	
VAR	Timer_troca2	T4	TIMER	N/A	
VAR	TimerSen2	T5	TIMER	N/A	
VAR	TimerSen3	T6	TIMER	N/A	
VAR	Timer_servo1	T7	TIMER	N/A	
VAR	TimerCMD	T8	TIMER	N/A	
VAR	TimerCMD2	T9	TIMER	N/A	

Network 1

Acionamento do botao START

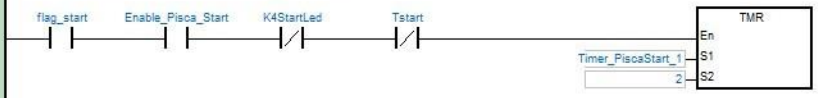
Network 2

Temporizacao de 2 segundos para ligar



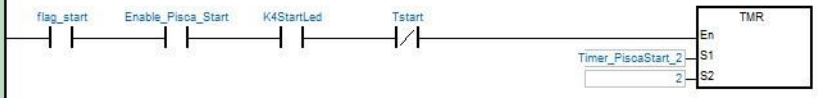
Network 3

Pisca luz de partida durante a ativação do sistema 1



Network 4

Pisca luz de partida durante a ativação do sistema 2



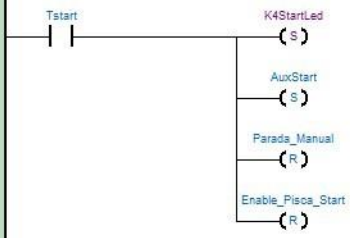
Network 5

Pisca luz de partida durante a ativação do sistema 3

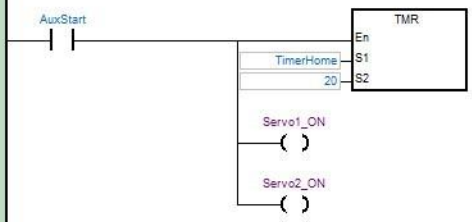
Main

Network 6

Acionamento da luz de partida após 2 segundos



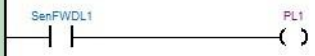
Network 7



Network 8

Ligar servo Motores

Network 9



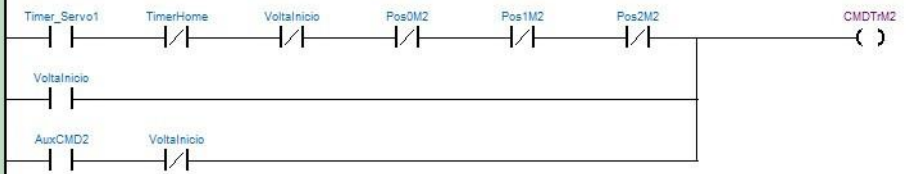
Network 10

Network 11

Network 12

Network 13

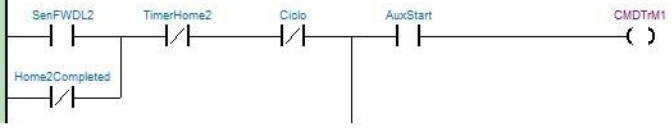
Home inicial do servo motor do eixo Y



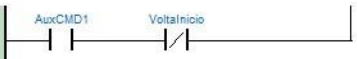
Network 14

Network 15

Home inicial do servo motor do eixo X

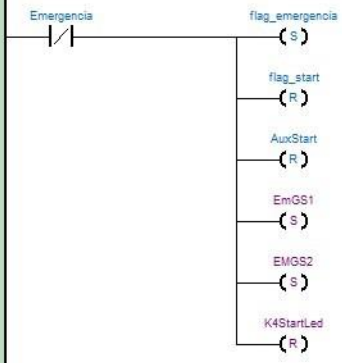


Main



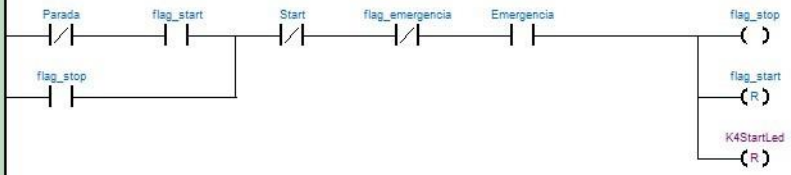
Network 16

Acionamento do boao de emergencia



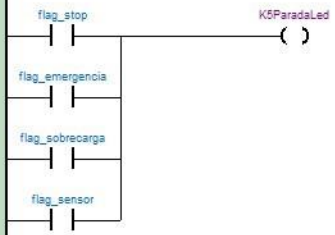
Network 17

Acionamento do botao de STOP



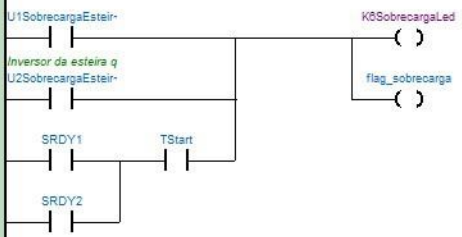
Network 18

Aciona luz de parada



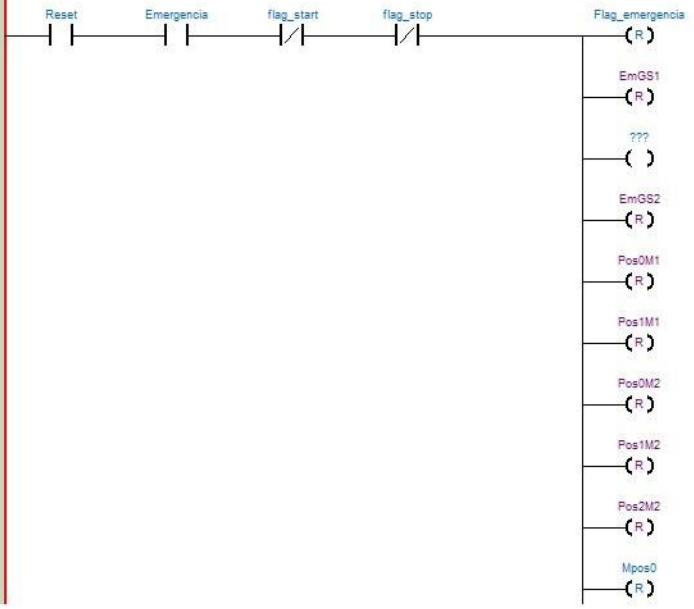
Network 19

Aciona luz de sobrecarga de motor e ativa flag indicador de sobrecarga

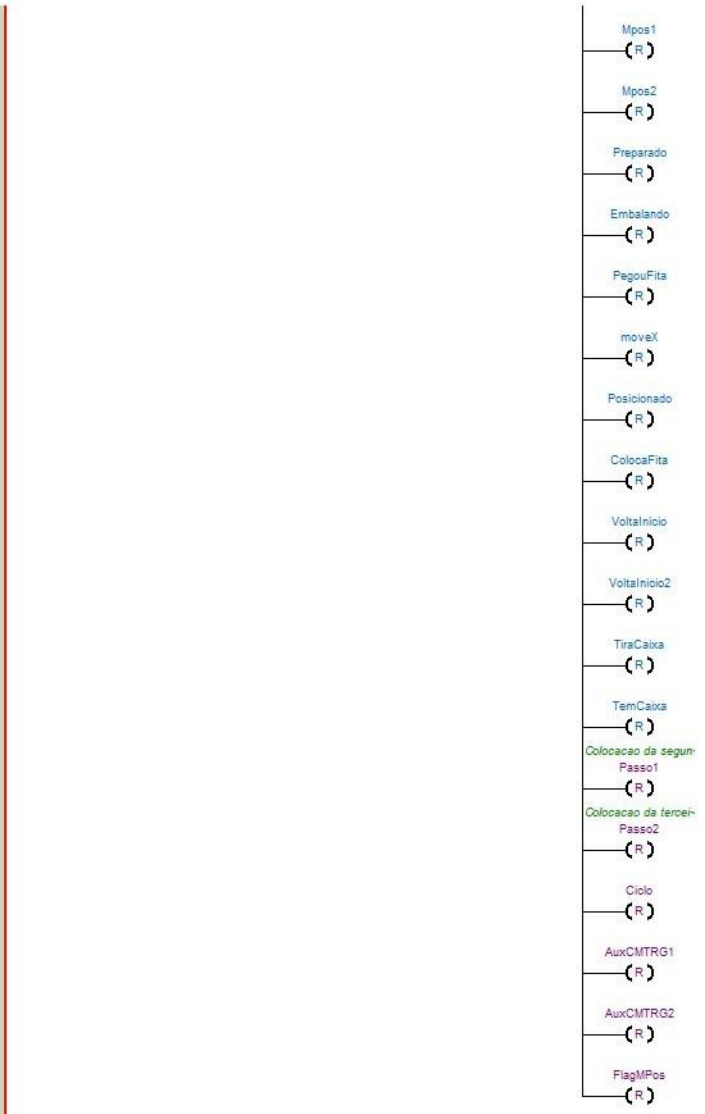


Network 20

Reset

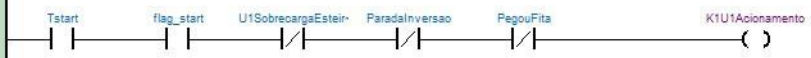


Main



Network 21

Esteira superior



Network 22

so pode haver inversão se o servo não estiver na ação de pegar fita - implementar

Network 23

Network 24

Sentido Inverso da esteira superior - FIM

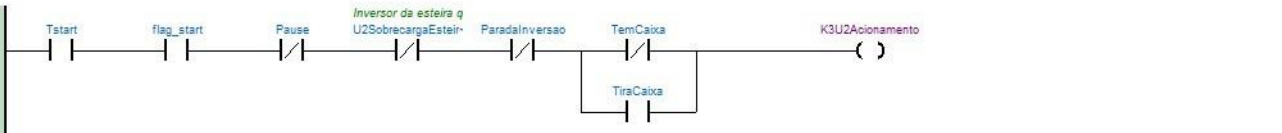
Network 25

Network 26

Network 27

*Esteira inferior *falta realizar a ação de movimentar a esteria apos a embalagem de caixas*

Main



Network 28 EMBALAGEM:

Temporizador sensor lado esquerdo

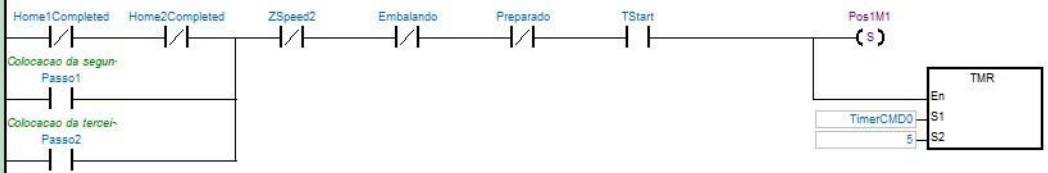
Network 29

Temporizador sensor lado direito

Network 30

Verificação de caixa na esteira inferior

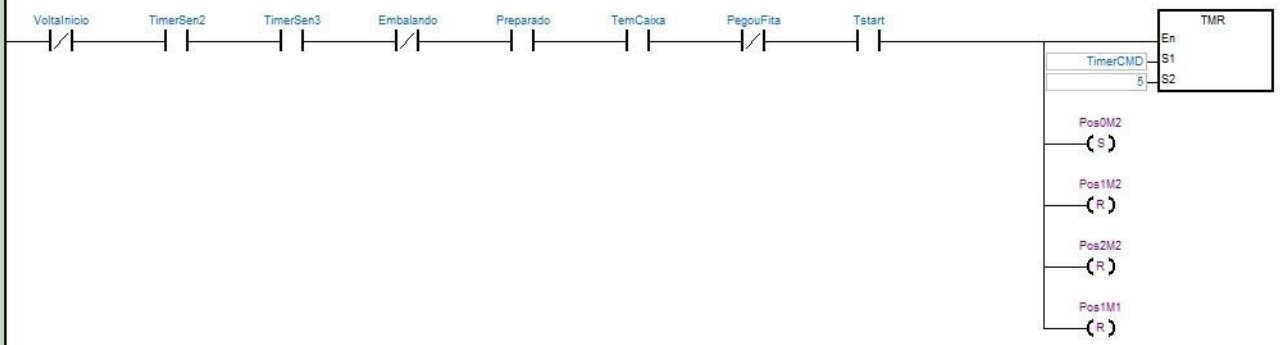
Network 31



Network 32

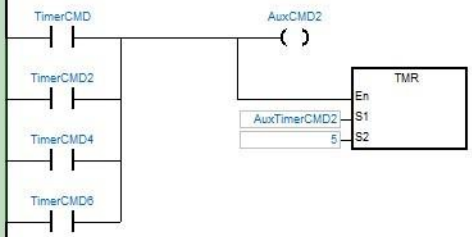
Network 33

Controle do servo motor eixo Y - inicio - Pega Fita

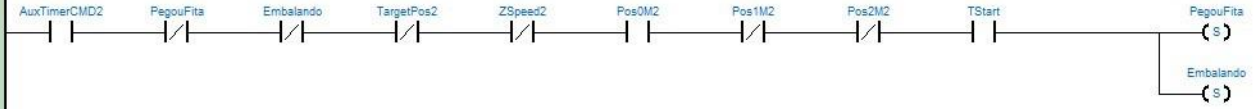


Network 34

Pegou a fita



Network 35



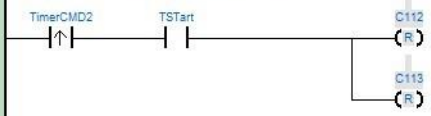
Network 36

Main

Network 37

Network 38

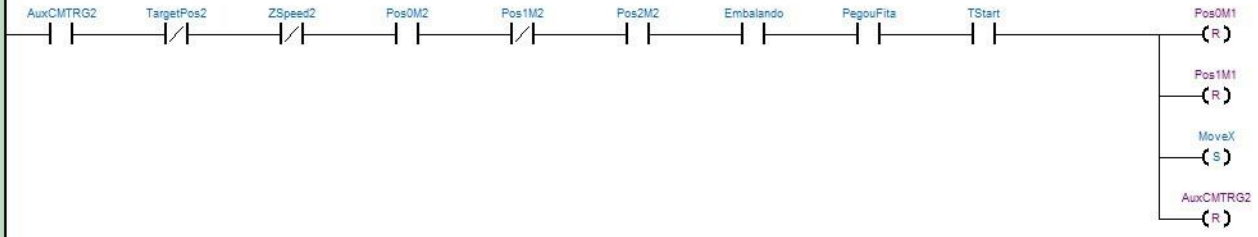
Pevou as fitas e reseta os contadores



Network 39

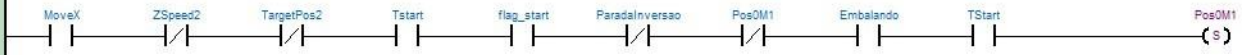
Network 40

Recua para a posição inicial



Network 41

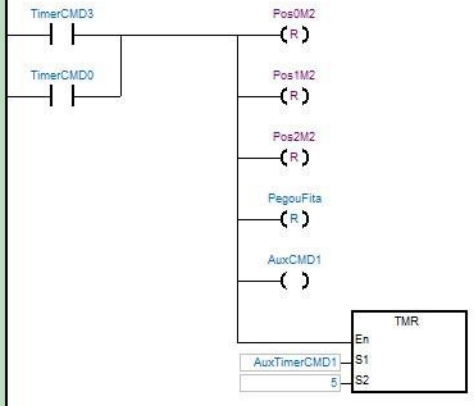
Controle do servo motor eixo X - Inicio - posição para embalagem



Network 42

Controle do servo motor eixo X - Inicio - posição para embalagem

Network 43



Network 44

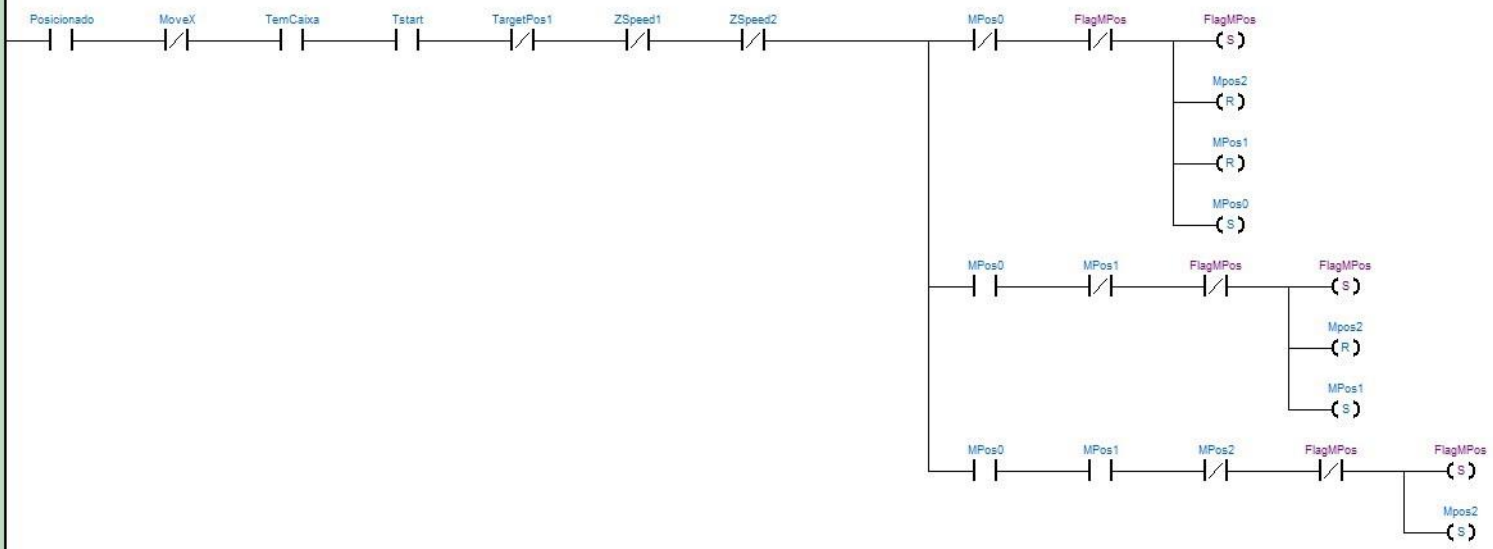
Network 45

Posicionado

Network 46

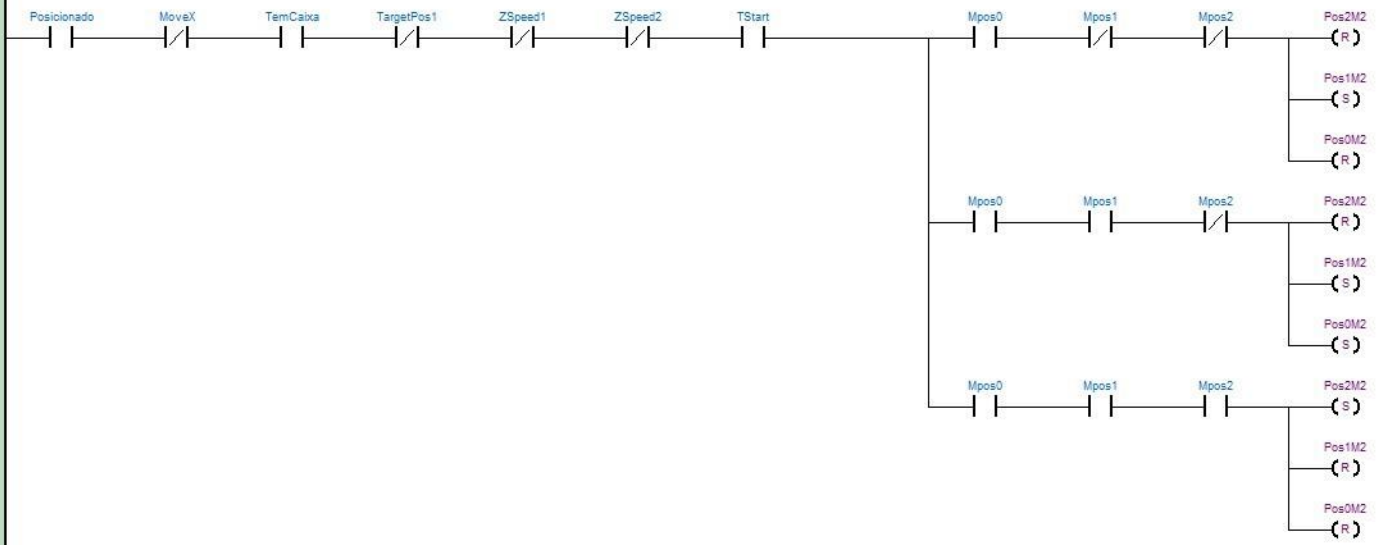
Main

Contagem de posicionamento de fitas na caixa

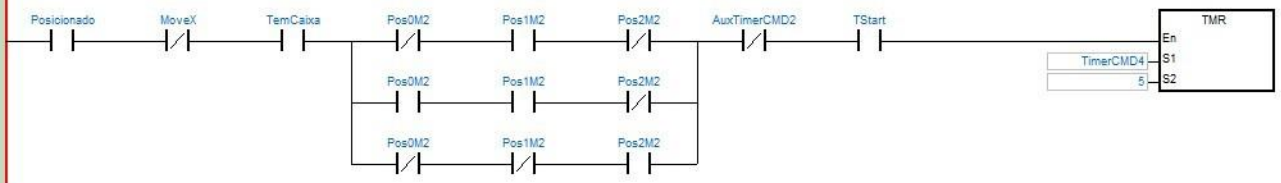


Network 47

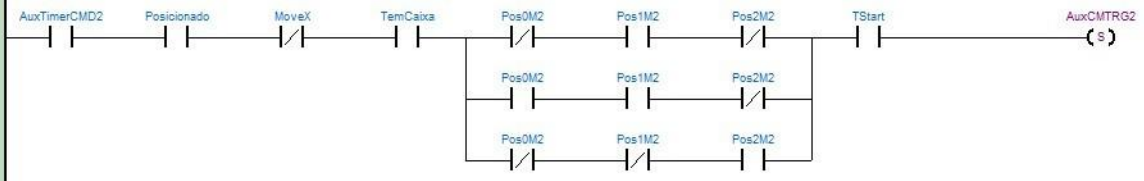
Coloca as fitas na caixa na posição 1



Network 48

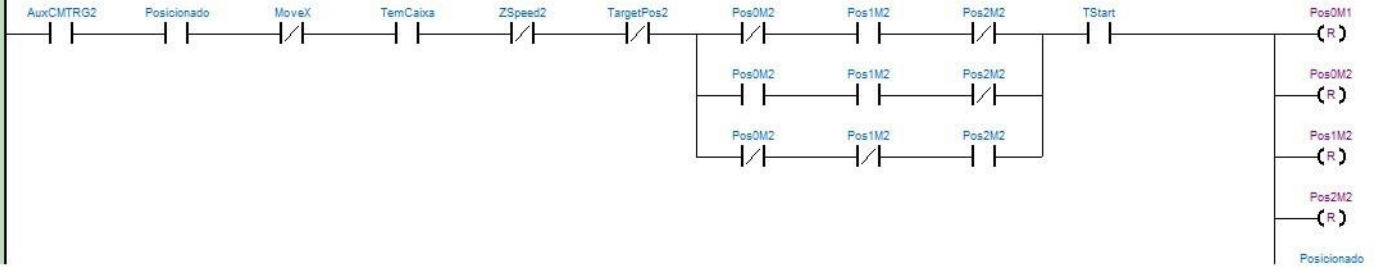


Network 49

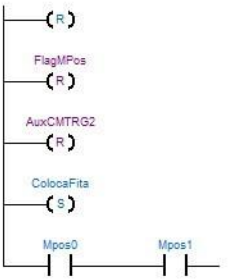


Network 50

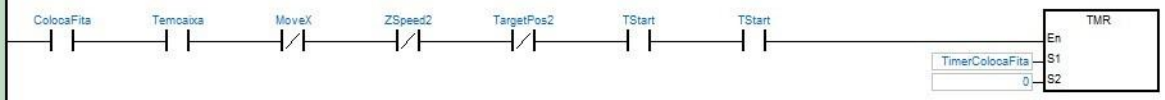
Recua para a posição inicial



Main

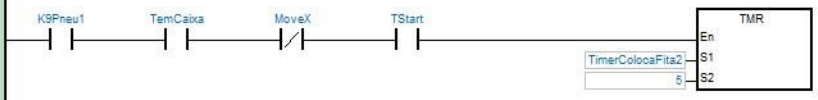


Network 51



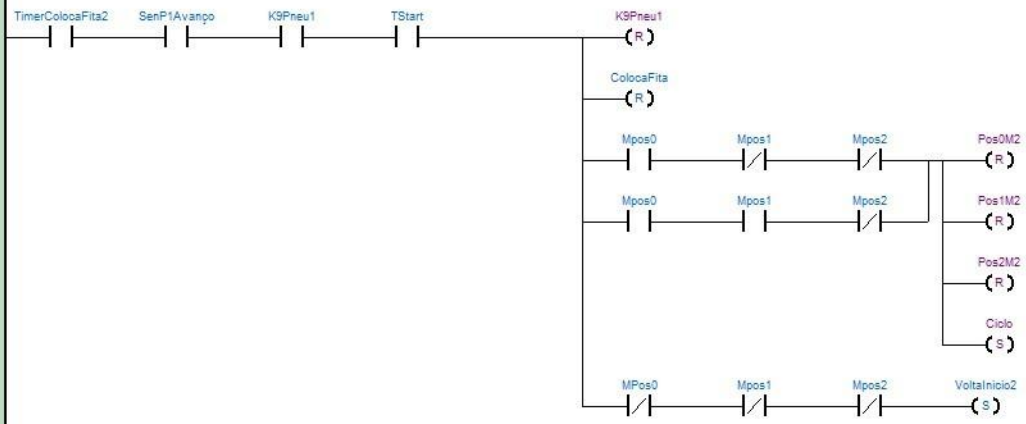
Network 52

Network 53

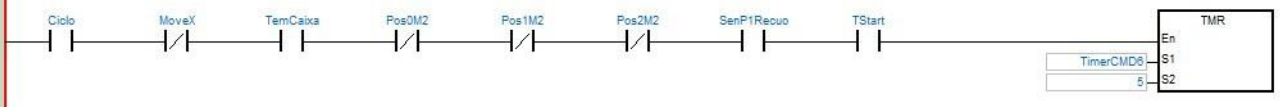


Network 54

Fim da embalagem

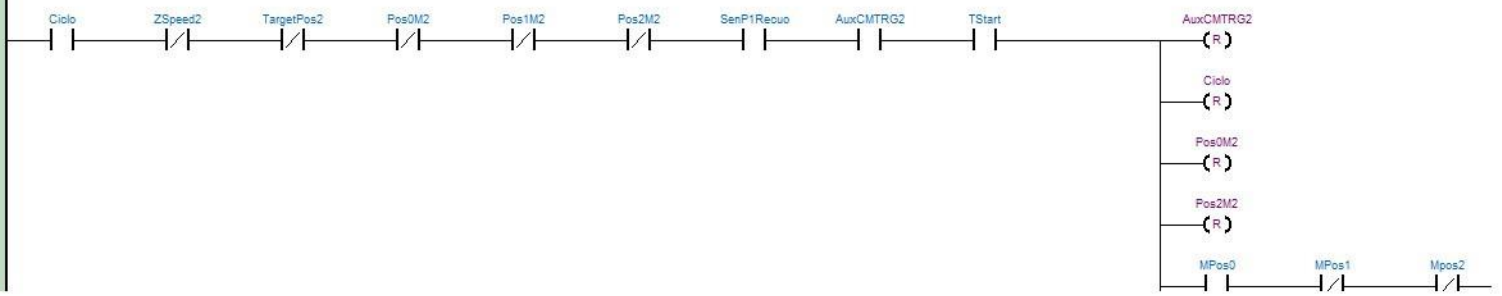


Network 55

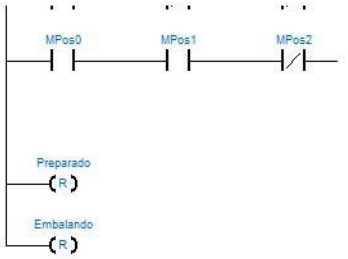


Network 56

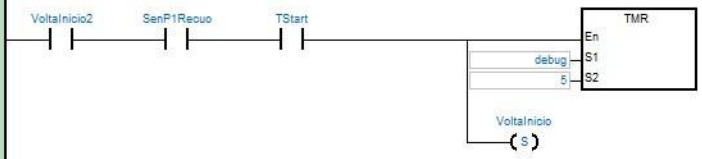
Network 57



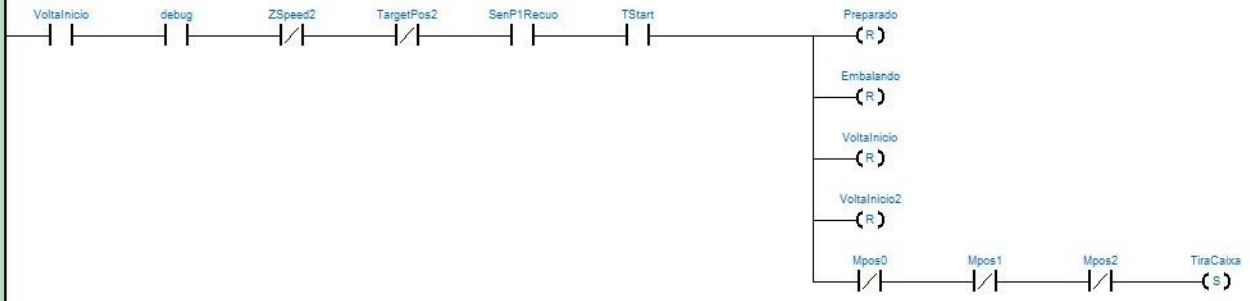
Main

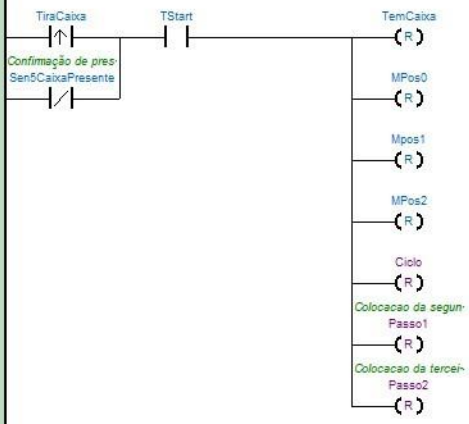


Network 58



Network 59



Network 60

Network 61