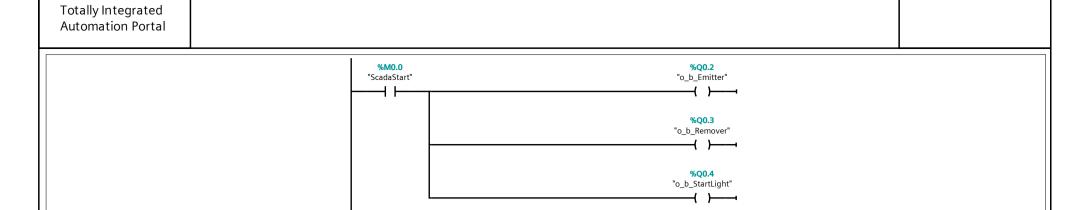
Totally Integ Automation						
PalletCon Main [OB1		PU 1215C AC/D0	C/Rly] / Program bloc	:ks		
Main Properties	;					
General Name	Main	Number 123	Туре	ОВ	Language	LAD
Numbering	Automatic	125	11.3100			
Information Title	"Main Program Sweep (Cy-	Author	Comment		Family	
Version	cle)"	User-defined ID				
Main	0.1	oser defined is				
Name		Data type	Default value	Comment		
<b>▼</b> Input						
Initial_Cal		Bool Bool		Initial call of this OB =True, if remanent of		
Remanen Temp	Le	BUUI		= rrue, il remanent (	aata are avallable	
Constant						
Network 1:						
Communication block for factory io						
			9000 Function-S71200"			
		— EN	ENO			
Network 2:						
		%FC1				
		"X1" — EN ENO —				
Network 3:		<u>.</u>				
M0.1 sets the conveyor to 0 v in Network 4						
		%M0.4 "PalletCount Reached"	%IO.1 %MO.2 "i_b_stopPB" "ScadaStop"	%M0.1 "Tag_4" 		
Network 4:						
start amd stop	button always on factory io					
		%I0.0	%M0.1	%M0.0		
		"i_b_StartPB" 	"Tag_4"	"ScadaStart" <b>( )</b> ——		
		%МО.О				
		"ScadaStart"				
NI_4		•				
Network 5:						
set conveyor to	0 Ov when stop is pressed					
		l				
		<b>%M0.1</b> "Tag_4"	MOVE			
		0.0	EN — ENO — MQD9	-		
			"o_real_Buffer — Conveyor"			
			%QD5 "o_real_Entry			
			"o_real_Entry — Conveyor"			

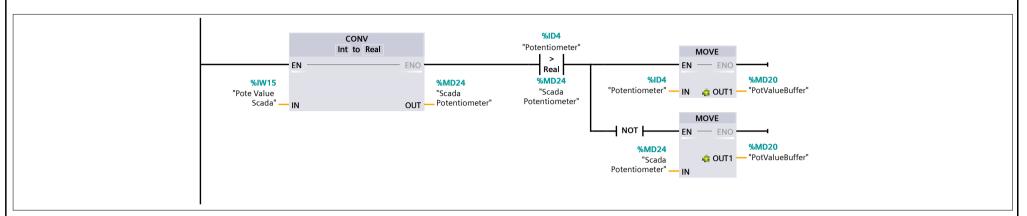
# Network 6:

start emitter , remover and start light



#### Network 7:

compare value from potentiometer and from scada



### Network 8:

scale the potentiometer value and store it in memory

```
NORM_X
Dint to Real
                           SCALE_X
  %M0.0
"ScadaStart"
                         Real to DInt
                EN -
                                                                                     EN
          0.0 — MIN
                                                                               0.0 — MIN
                                                %MD10
                                                                                                                      %MD15
                                                - "Tag_3"
                                                                                                                     "Tag_2"
      %MD20
                                         OUT -
                                                                                                              OUT
                                                                            %MD10
"PotValueBuffer" — VALUE
                                                                            "Tag_3" — VALUE
         10.0 MAX
                                                                              10.0 ─ MAX
```

### Network 9:

use the memory value and move them to conveyor ( REAL value ) , move DINT value into Digital Display

```
%M0.0
"ScadaStart"
             MOVE
                                                          MOVE
              EN - ENO
                                                           EN - ENO
                                                  %MD10
     %MD15
                          %QD9
                                                                       %QD1
     "Tag_2" — IN
                                                  "Tag_3" — IN
                                                                        "o_dint_Speed
                           "o_real_Buffer
                          Conveyor"
                                                          d OUT1 — Display"
                          %QD5
                           "o_real_Entry
```

#### Network 10:

## Network 11:

Count and Display Pallet

```
**MO.4

**L.b_Sensor**

CU

**MO.1

**Tag_4**

**MW30

**Tag_1**

**PoliciCount
Reached*

**QD13

**o_dint_Pallet
Display**

**Display**
```