

Totally Integrated Automation Portal

### PalletConveyor / PLC\_2 [CPU 1215C AC/DC/Rly] / Program blocks

#### Main [OB123]

Main Properties

General

Name	Main	Number	123	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:

Communication block for factory io

%FC9000

"MHJ-PLC-Lab-Function-S71200"

EN

ENO

#### Network 2:

%FC1

"X1"

EN

ENO

#### Network 3:

M0.1 sets the conveyor to 0 v in Network 4

%M0.4

"PalletCount Reached"

%I0.1

"i\_b\_StopPB"

%M0.2

"ScadaStop"

%M0.1

"Tag\_4"

#### Network 4:

start amd stop button  
stop button is always on factory io

%I0.0

"i\_b\_StartPB"

%M0.1

"Tag\_4"

%M0.0

"ScadaStart"

#### Network 5:

set conveyor to 0v when stop is pressed

%M0.1

"Tag\_4"

MOVE

0.0

IN

OUT1

OUT2

%QD9

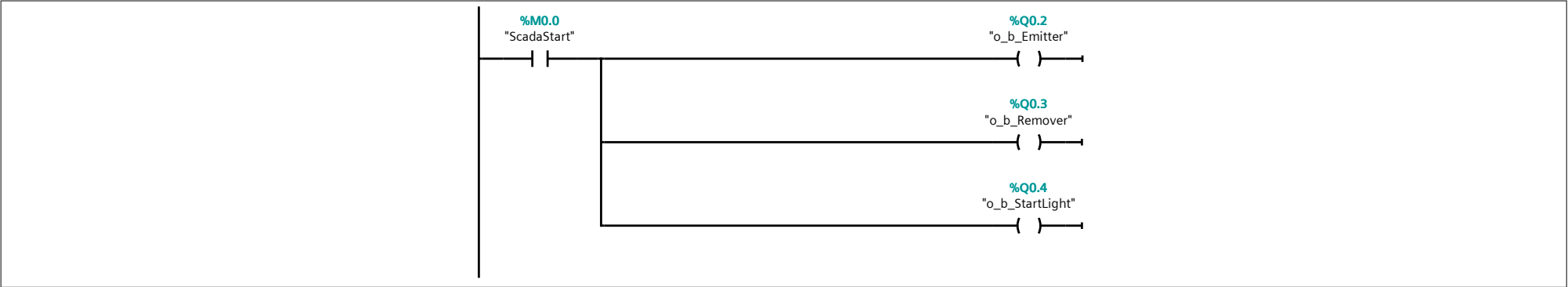
"o\_real\_Buffer Conveyor"

%QD5

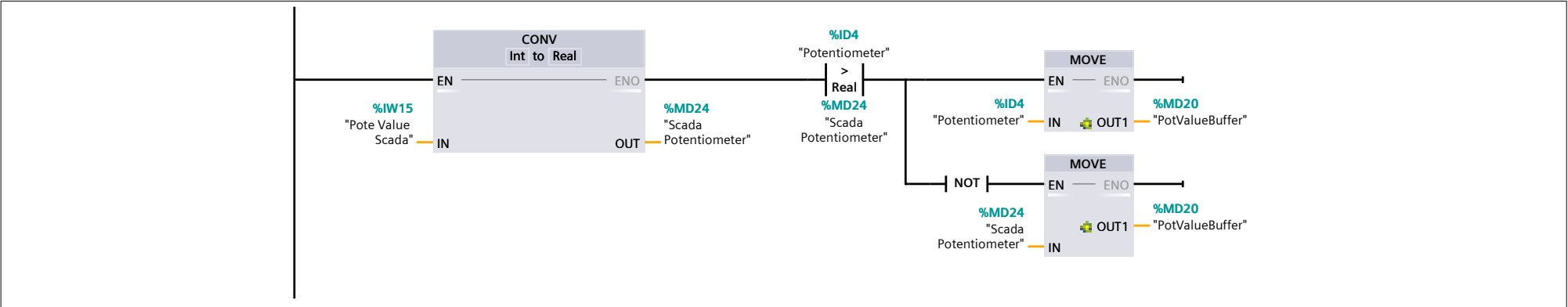
"o\_real\_Entry Conveyor"

#### Network 6:

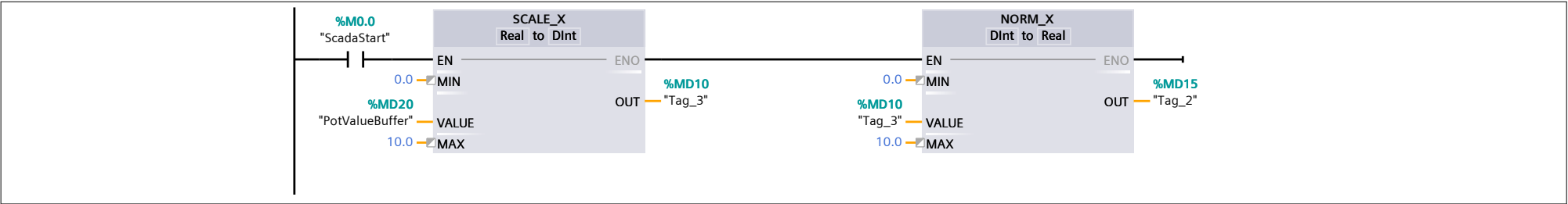
start emitter , remover and start light



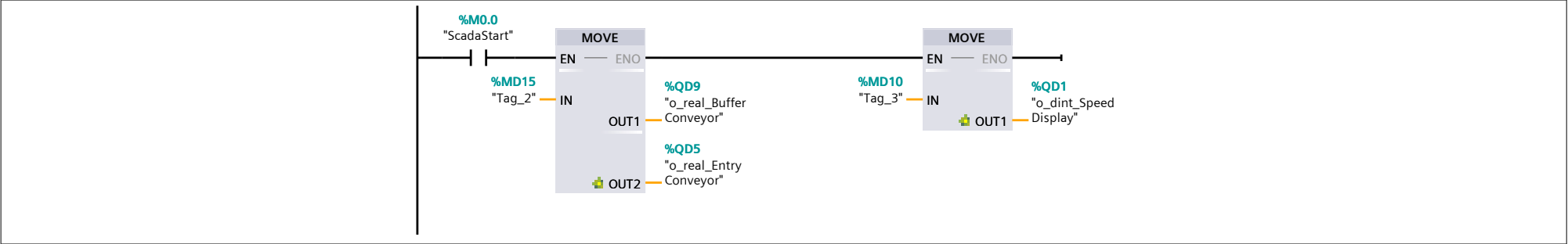
Network 7:  
compare value from potentiometer and from scada



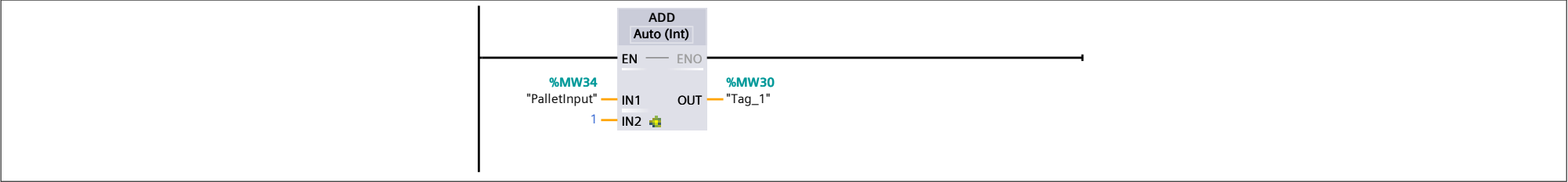
Network 8:  
scale the potentiometer value and store it in memory



Network 9:  
use the memory value and move them to conveyor ( REAL value ) , move DINT value into Digital Display



Network 10:



Network 11:  
Count and Display Pallet

