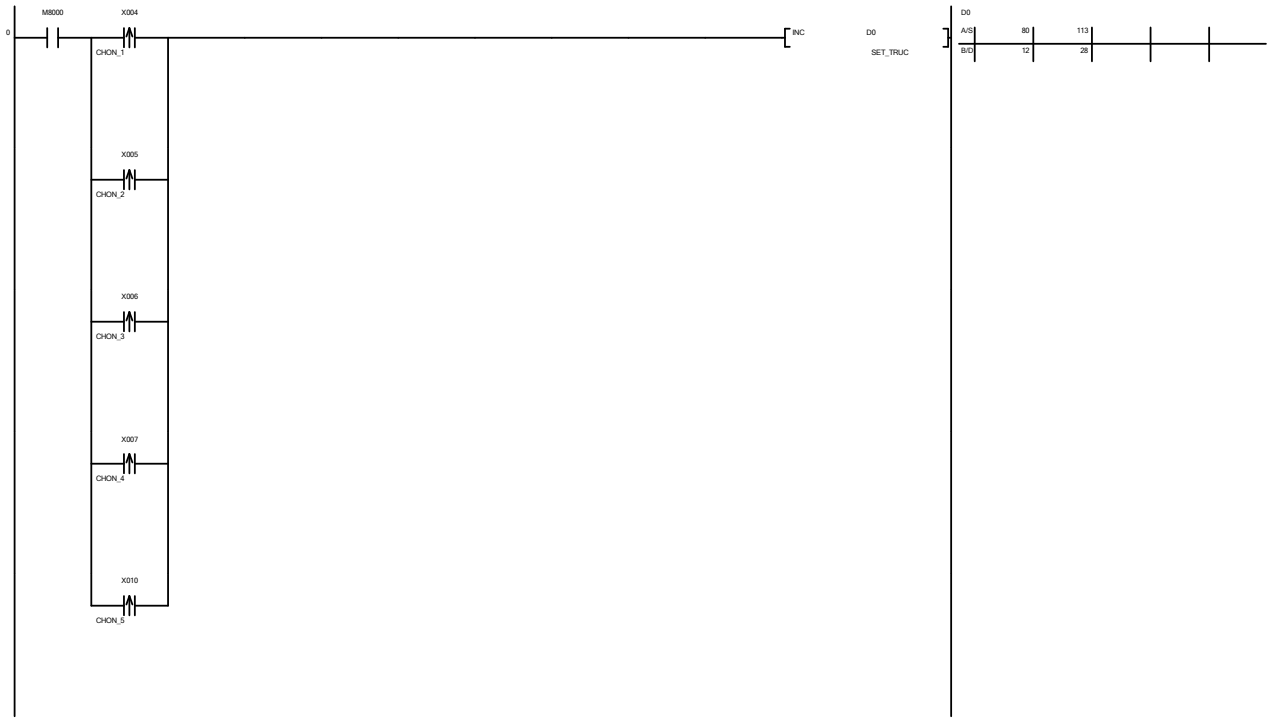
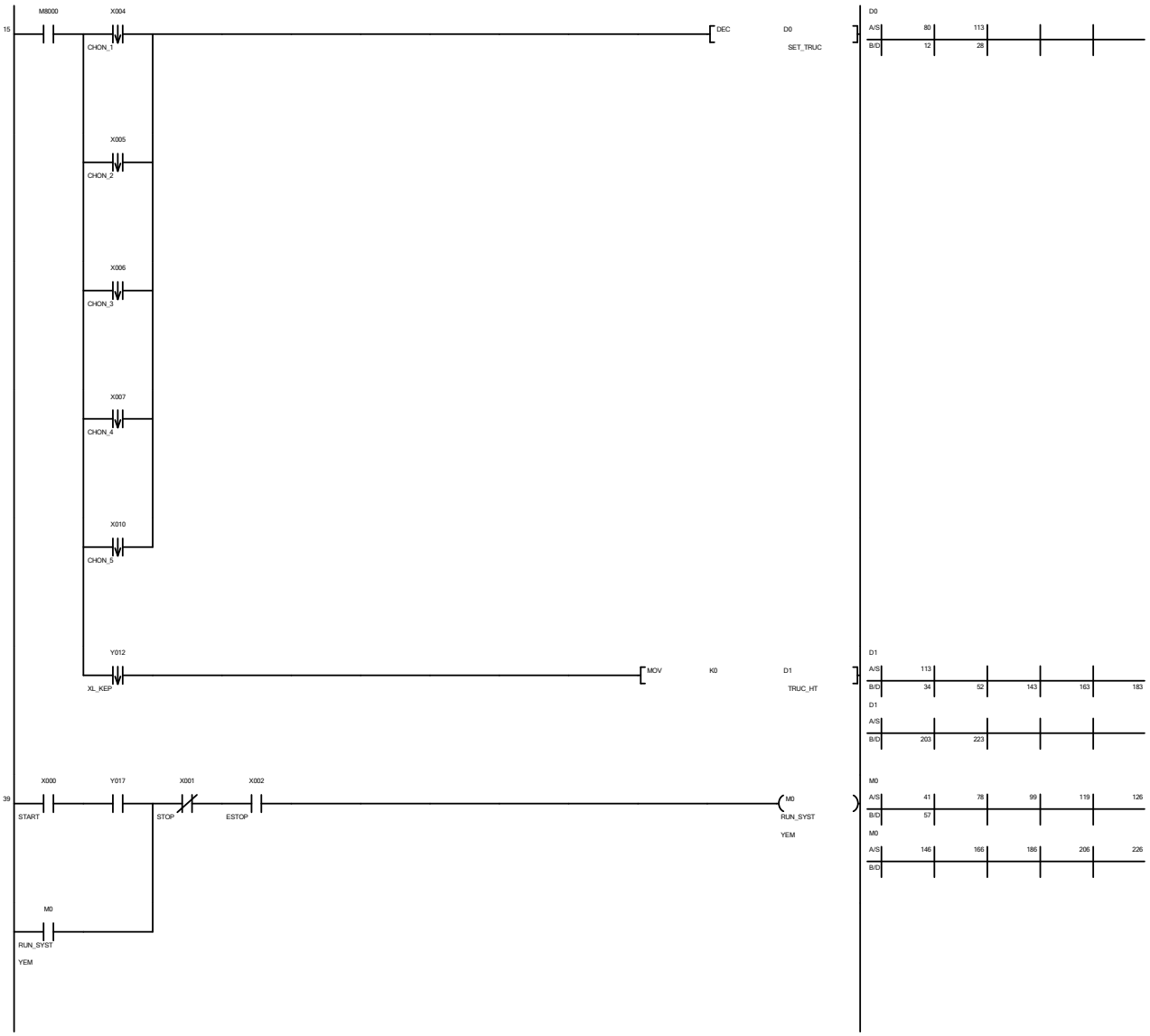
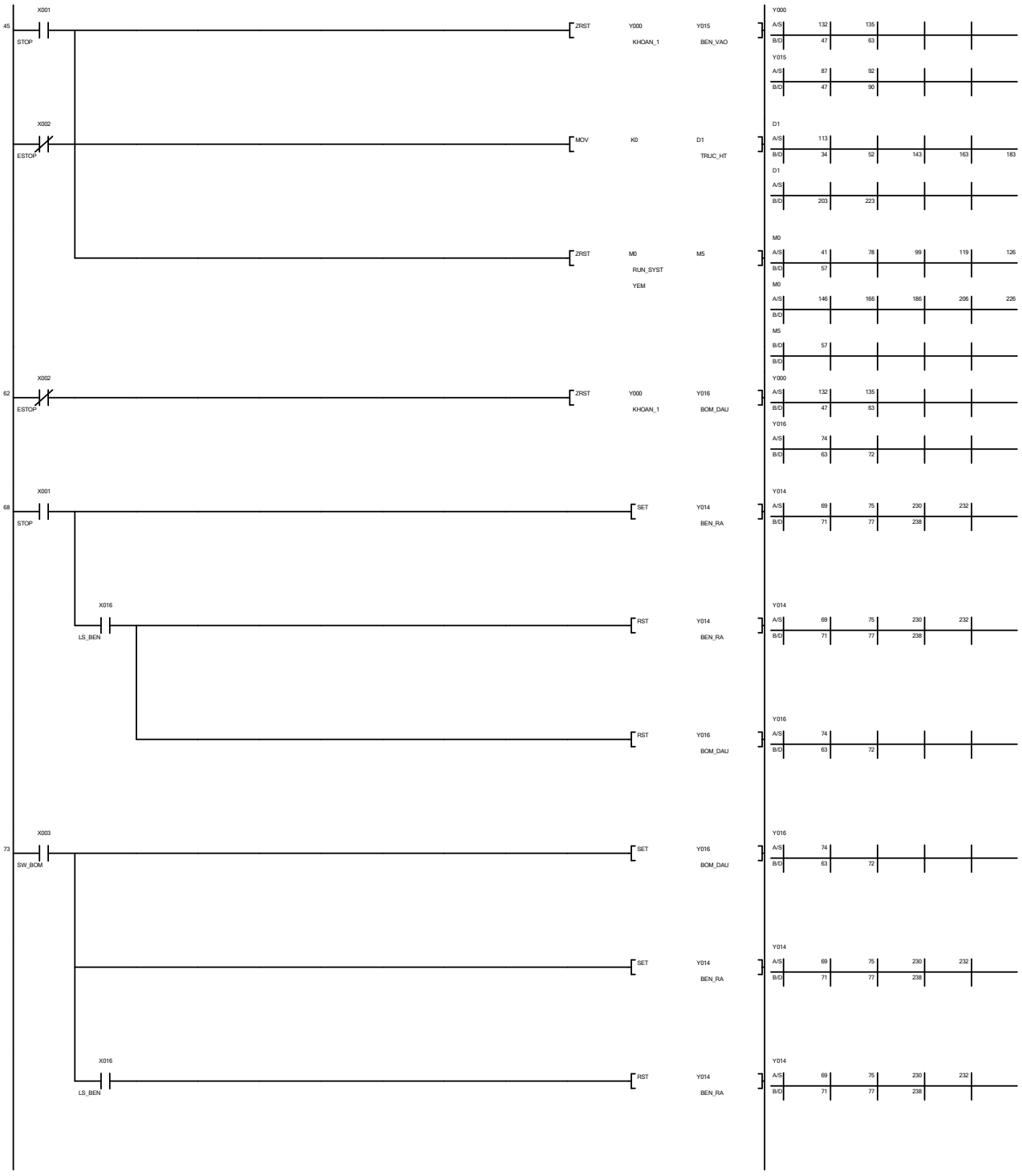
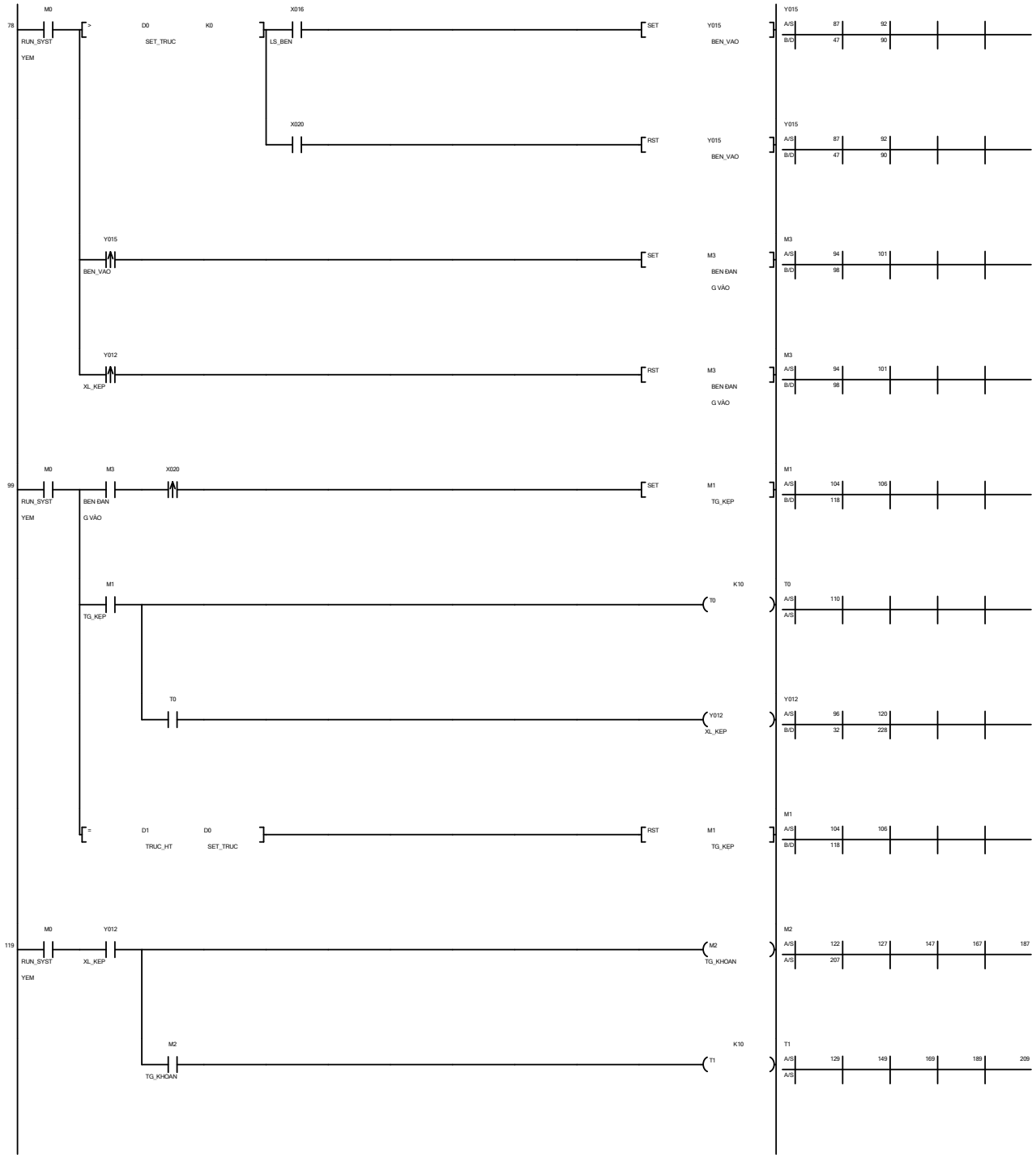
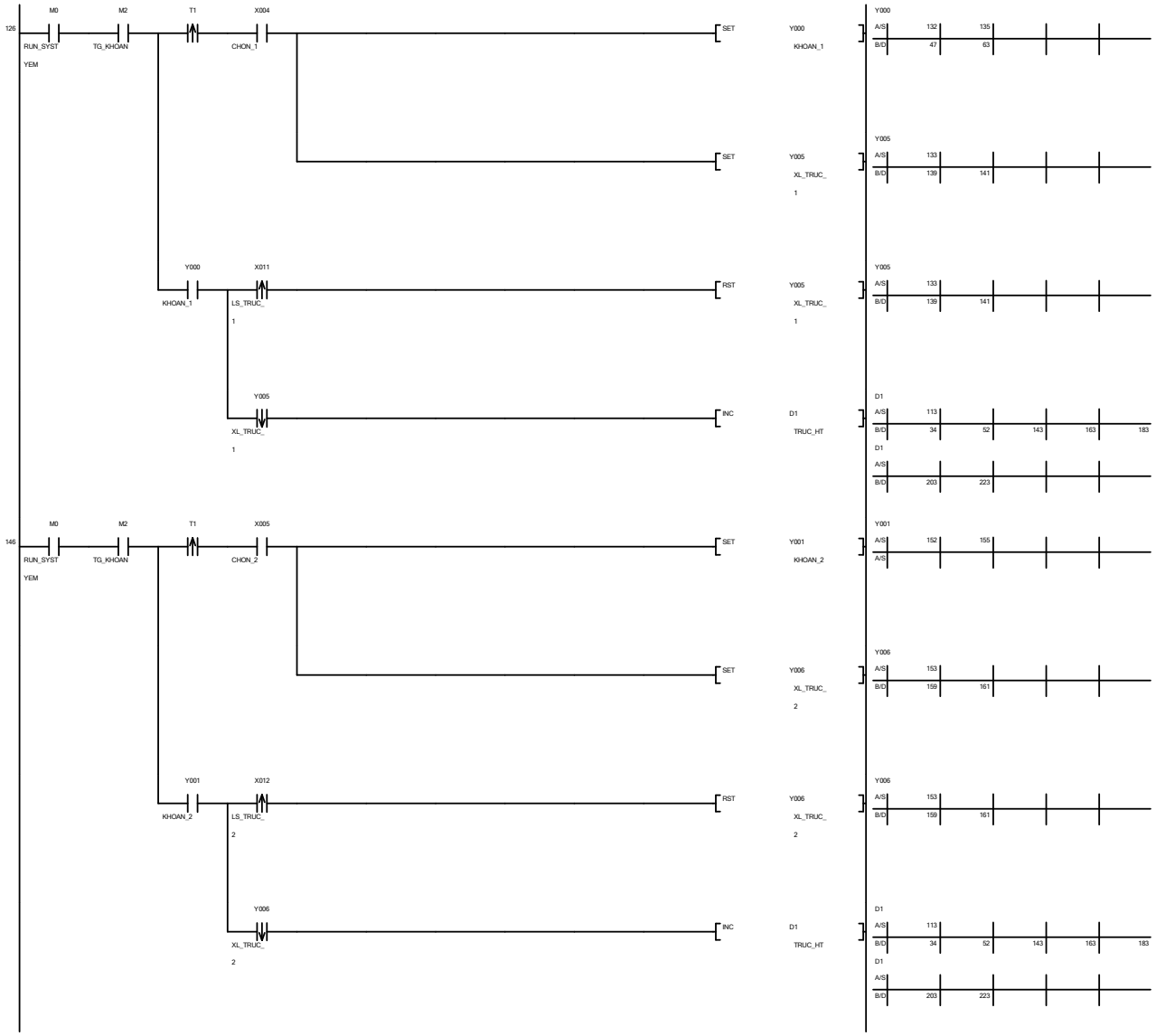
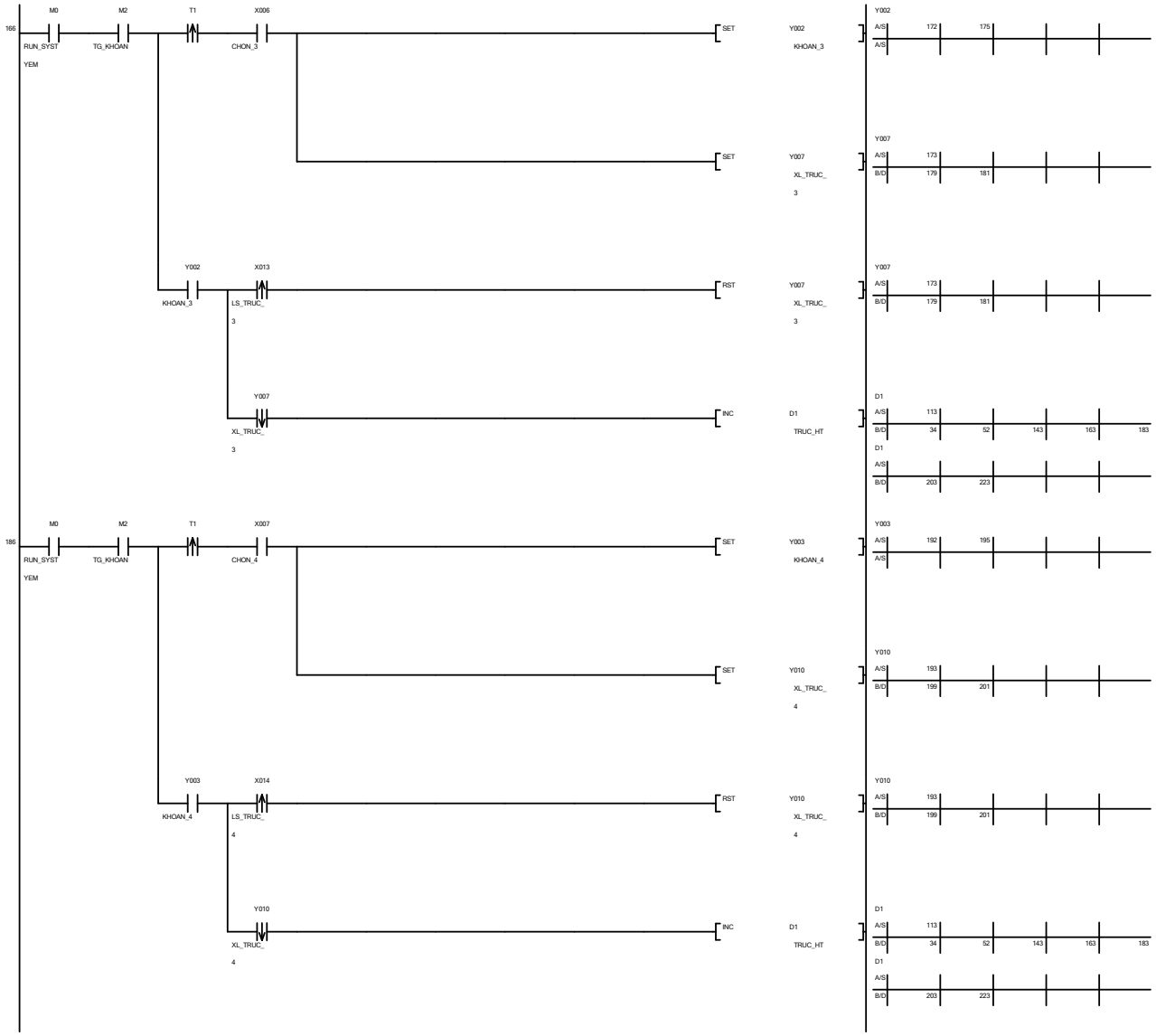

0
M8000
X004
CHON_1
X005
CHON_2
X006
CHON_3
X007
CHON_4
X010
CHON_5
INC
D0
SET_TRUC
D0
A/S
80
113
B/D
12
28

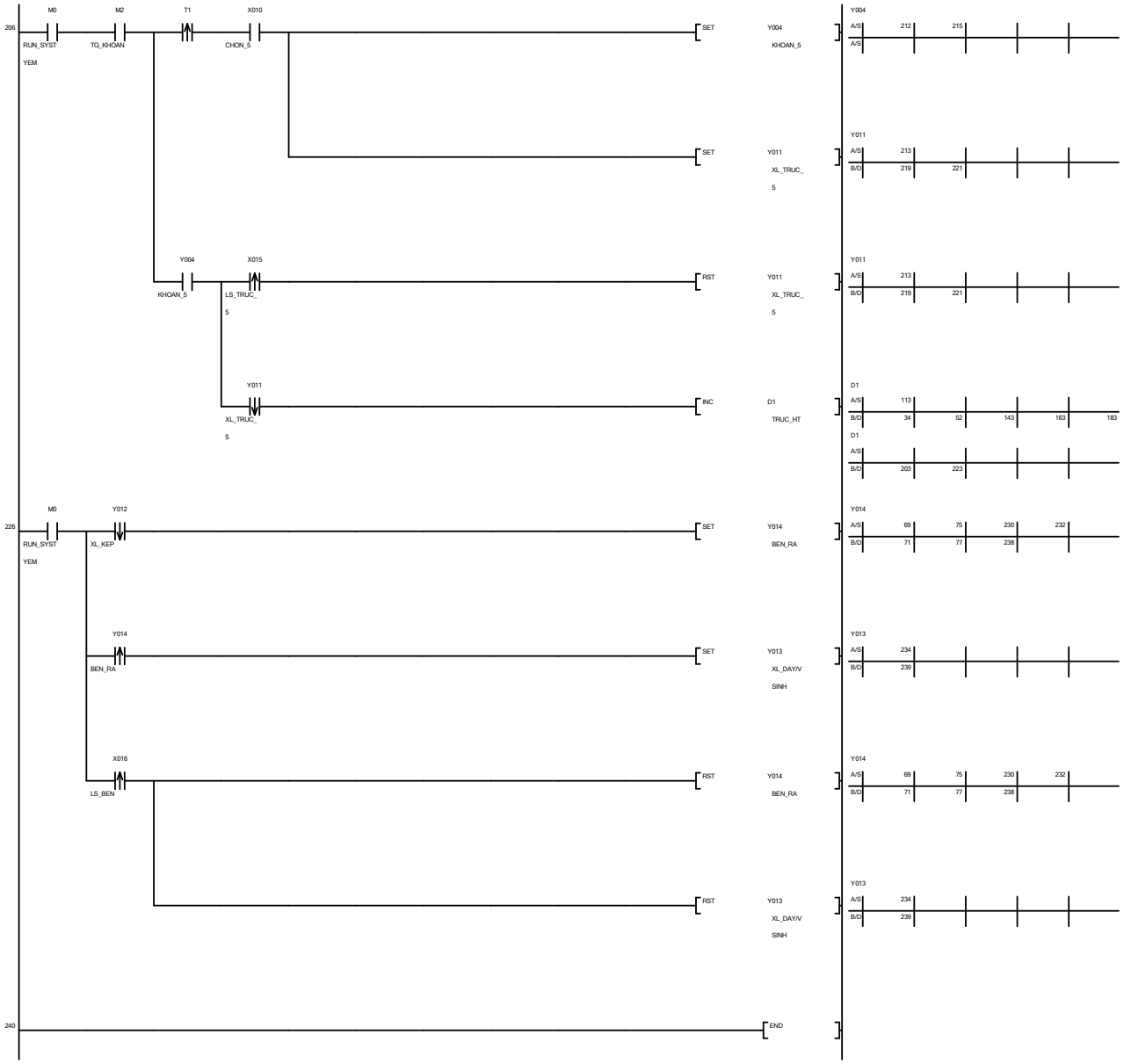

15
M8000
X004
CHON_1
X005
CHON_2
X006
CHON_3
X007
CHON_4
X010
CHON_5
DEC
D0
SET_TRUC
Y012
XL_KEP
MOV
K0
D1
TRUC_HT
39
X000
START
Y017
X001
STOP
X002
ESTOP
M0
RUN_SYST
YEM
M0
RUN_SYST
YEM
D0
A/S
B/D
80
113
12
28
D1
A/S
B/D
113
34
52
143
163
183
D1
A/S
B/D
203
223
M0
A/S
B/D
41
78
99
119
126
57
M0
A/S
B/D
146
166
186
206
226


45
X001
STOP
ZRST
Y000
KHOAN_1
Y015
BEN_VAO
X002
ESTOP
MOV
K0
D1
TRUC_HT
ZRST
M0
RUN_SYST
YEM
M5
62
X002
ESTOP
ZRST
Y000
KHOAN_1
Y016
BOM_DAU
68
X001
STOP
SET
Y014
BEN_RA
X016
LS_BEN
RST
Y014
BEN_RA
RST
Y016
BOM_DAU
73
X003
SW_BOM
SET
Y016
BOM_DAU
SET
Y014
BEN_RA
X016
LS_BEN
RST
Y014
BEN_RA


78
M0
RUN_SYST
YEM
>
D0
SET_TRUC
K0
X016
LS_BEN
SET
Y015
BEN_VAO
X020
RST
Y015
BEN_VAO
Y015
BEN_VAO
SET
M3
BEN ĐAN
G VÀO
Y012
XL_KEP
RST
M3
BEN ĐAN
G VÀO
99
M0
RUN_SYST
YEM
M3
BEN ĐAN
G VÀO
X020
SET
M1
TG_KEP
M1
TG_KEP
K10
T0
T0
Y012
XL_KEP
=
D1
TRUC_HT
D0
SET_TRUC
RST
M1
TG_KEP
119
M0
RUN_SYST
YEM
Y012
XL_KEP
M2
TG_KHOAN
M2
TG_KHOAN
K10
T1
A/S
B/D
87
47
92
90
94
98
101
104
118
106
110
96
32
120
228
122
207
127
147
167
187
129
149
169
189
209


126
M0
RUN_SYST
YEM
M2
TG_KHOAN
T1
X004
CHON_1
SET
Y000
KHOAN_1
SET
Y005
XL_TRUC_
1
Y000
KHOAN_1
X011
LS_TRUC_
1
RST
Y005
XL_TRUC_
1
Y005
XL_TRUC_
1
INC
D1
TRUC_HT
A/S
B/D
132
135
47
63
133
139
141
113
34
52
143
163
183
203
223
146
M0
RUN_SYST
YEM
M2
TG_KHOAN
T1
X005
CHON_2
SET
Y001
KHOAN_2
SET
Y006
XL_TRUC_
2
Y001
KHOAN_2
X012
LS_TRUC_
2
RST
Y006
XL_TRUC_
2
Y006
XL_TRUC_
2
INC
D1
TRUC_HT
152
155
153
159
161


166
M0
RUN_SYST
YEM
M2
TG_KHOAN
T1
X006
CHON_3
SET
Y002
KHOAN_3
Y007
XL_TRUC_
3
Y002
KHOAN_3
X013
LS_TRUC_
3
RST
Y007
XL_TRUC_
3
Y007
XL_TRUC_
3
INC
D1
TRUC_HT
A/S
B/D
172
175
173
179
181
113
34
52
143
163
183
203
223
186
M0
RUN_SYST
YEM
M2
TG_KHOAN
T1
X007
CHON_4
SET
Y003
KHOAN_4
Y010
XL_TRUC_
4
Y003
KHOAN_4
X014
LS_TRUC_
4
RST
Y010
XL_TRUC_
4
Y010
XL_TRUC_
4
INC
D1
TRUC_HT
192
195
193
199
201


206
M0
RUN_SYST
YEM
M2
TG_KHOAN
T1
X010
CHON_5
SET
Y004
KHOAN_5
Y004
A/S 212 215
A/S
SET
Y011
XL_TRUC_
5
Y011
A/S 213
B/D 219 221
Y004
KHOAN_5
X015
LS_TRUC_
5
RST
Y011
XL_TRUC_
5
Y011
A/S 213
B/D 219 221
Y011
XL_TRUC_
5
INC
D1
TRUC_HT
D1
A/S 113
B/D 34 52 143 163 183
D1
A/S
B/D 203 223
226
M0
RUN_SYST
YEM
Y012
XL_KEP
SET
Y014
BEN_RA
Y014
A/S 69 75 230 232
B/D 71 77 238
Y014
BEN_RA
SET
Y013
XL_DAY/V
SINH
Y013
A/S 234
B/D 239
X016
LS_BEN
RST
Y014
BEN_RA
Y014
A/S 69 75 230 232
B/D 71 77 238
RST
Y013
XL_DAY/V
SINH
Y013
A/S 234
B/D 239
240
END

Device Comment 8/8/2025
Data Name : COMMENT

Device Name	Comment
M0	RUN_SYSTYEM
M1	TG_KEP
M2	TG_KHOAN
M3	BEN ĐANG VÀO
X000	START
X001	STOP
X002	ESTOP
X003	SW_BOM
X004	CHON_1
X005	CHON_2
X006	CHON_3
X007	CHON_4
X010	CHON_5
X011	LS_TRUC_1
X012	LS_TRUC_2
X013	LS_TRUC_3
X014	LS_TRUC_4
X015	LS_TRUC_5
X016	LS_BEN
X017	LS_WORK
Y000	KHOAN_1
Y001	KHOAN_2
Y002	KHOAN_3
Y003	KHOAN_4
Y004	KHOAN_5
Y005	XL_TRUC_1
Y006	XL_TRUC_2
Y007	XL_TRUC_3
Y010	XL_TRUC_4
Y011	XL_TRUC_5
Y012	XL_KEP
Y013	XL_DAY/VSINH
Y014	BEN_RA
Y015	BEN_VAO
Y016	BOM_DAU
D0	SET_TRUC
D1	TRUC_HT

Position	Device	Setting Value
(107)	T0	K10
(123)	T1	K10

Data Name : Device List

Find In:(Entire project)
Find What:Used Device (Contact & Coil)
Print Range:Whole Range

*:in use (times): the number of coil uses

Device	Contact	Coil	Parameter	Comment
M0	*	*(2)		RUN_SYSTYEM
M1	*	*(3)		TG_KẸP
M2	*	*(2)		TG_KHOAN
M3	*	*(3)		BEN ĐANG VÀO
Y000	*	*(3)		KHOAN_1
Y001	*	*(3)		KHOAN_2
Y002	*	*(3)		KHOAN_3
Y003	*	*(3)		KHOAN_4
Y004	*	*(3)		KHOAN_5
Y005	*	*(4)		XL_TRUC_1
Y006	*	*(4)		XL_TRUC_2
Y007	*	*(4)		XL_TRUC_3
Y010	*	*(4)		XL_TRUC_4
Y011	*	*(4)		XL_TRUC_5
Y012	*	*(3)		XL_KEP
Y014	*	*(8)		BEN_RA
Y015	*	*(4)		BEN_VAO
D0	*	*(2)		SET_TRUC
D1	*	*(7)		TRUC_HT
T0	*	*(1)		
T1	*	*(1)		

[Line Statement List]

Step	Line Statement
0	CHON TRUC
15	BO CHON TRUC
39	ON SYSTEM
45	STOP SYSTEM
73	CONTROL PUMP
78	BEN VÀO
99	KEP PHÔI
119	KHOAN
126	KHOAN 1
146	KHOAN 2
166	KHOAN 3
186	KHOAN 4
206	KHOAN 5