

PLC I/O layout

high rack (HR)				ECC-2250		
FischerTechnik name	var name	type	Codesys port	I	O	
switch horizontal	sHorizontal	IN	IX0.0	1		
light-barrier inside	lbin	IN	IX0.1	2		
light-barrier outside	lbOut	IN	IX0.2	3		
switch vertical	sVertical	IN	IX0.3	4		
switch cantilever front	sCFront	IN	IX0.4	5		
switch cantilever back	sCBack	IN	IX0.5	6		
motor conveyor belt forward	mCbForward	OUT	QX0.0		1	
motor conveyor belt backward	mCbBackward	OUT	QX0.1		2	
motor horizontal towards conveyor belt	mHorizontalLeft	OUT	QX0.2		3	
motor horizontal towards rack	mHorizontalRight	OUT	QX0.3		4	
motor vertical axis upward	mVerticalDown	OUT	QX0.4		5	
motor vertical axis downward	mVerticalUp	OUT	QX0.5		6	
motor cantilever forward	mCForward	OUT	QX0.6		7	
motor cantilever backward	mCBackward	OUT	QX0.7		8	

vacuum gripper (VG)				ECC-2250		
FischerTechnik name	var name	type	Codesys port	I	O	
switch vertical	sVertical	IN	IX0.6	7		
switch horizontal	sHorizontal	IN	IX0.7	8		
switch rotation	sRotation	IN	IX1.0	9		
encoder vertical impuls 1	encVertical1	IN	IX1.1	10		
encoder vertical impuls 2	encVertical2	IN	IX1.2	11		
encoder horizontal impuls 1	encHorizontal1	IN	IX1.3	12		
encoder horizontal impuls 2	encHorizontal2	IN	IX1.4	13		
encoder rotation impuls 1	encRotation1	IN	IX1.5	14		
encoder rotation impuls 2	encRotation2	IN	IX1.6	15		
motor vertical up	mVerticalUp	OUT	QX1.0		9	
motor vertical down	mVerticalDown	OUT	QX1.1		10	
motor horizontal backwards	mHorizontalBackward	OUT	QX1.2		11	
motor horizontal forward	mHorizontalForward	OUT	QX1.3		12	
motor rotation clockwise	mRotationClockwise	OUT	QX1.4		13	
motor rotation counterclockwise	mRotationCClockwise	OUT	QX1.5		14	
compressor	compressor	OUT	QX1.6		15	
valve vacuum	valve	OUT	QX1.7		16	

furnance (FU)				ECC DIO		
FischerTechnik name	var name	type	Codesys port	I	O	
switch rotating assembly (pos sucker)	sRaPosSucker	IN	IX300.0	1		
switch rotating assembly (pos conveyor belt)	sRaPosConveyorBelt	IN	IX300.1	2		
light barrier conveyor belt	lbConveyorBelt	IN	IX300.2	3		
switch rotating assembly (pos saw)	sRaPosSaw	IN	IX300.3	4		
switch sucker (pos rotating assembly)	sSuckerPosRa	IN	IX300.4	5		
switch furnance slider inside	sFurnanceSliderInside	IN	IX300.5	6		
switch furnance slider outside	sFurnanceSliderOutside	IN	IX300.6	7		
switch sucker (pos firing furnance)	sSuckerPosFF	IN	IX300.7	8		
light barrier furnance	lbFurnance	IN	IX301.0	9		
motor rotating assembly clockwise	mRaClockwise	OUT	QX40.0		1	
motor rotating assembly counter clockwise	mRaCClockwise	OUT	QX40.1		2	
motor conveyor belt forward	mConveyorBeltForward	OUT	QX40.2		3	
motor saw	mSaw	OUT	QX40.3		4	
motor furnance slider in	mFurnanceSliderIn	OUT	QX40.4		5	
motor furnance slider out	mFurnanceSliderOut	OUT	QX40.5		6	
motor sucker to furnance	mSuckertoFurnance	OUT	QX40.6		7	
motor sucker to rotating assembly	mSuckertoRa	OUT	QX40.7		8	
light furnance	lightFurnance	OUT			analog?	
compressor	compressor	OUT	QX41.0		9	
valve vacuum	valveVacuum	OUT	QX41.1		10	
valve lowering	valveLowering	OUT	QX41.2		11	
valve furnance door	valveFurnanceDoor	OUT	QX41.3		12	
valve slider	valveSlider	OUT	QX41.4		13	

sorting line (SL)				ECC DIO		
FischerTechnik name	var name	type	Codesys port	I	O	
impuls feeler	iFeeler	IN	IX301.1	10		
light barrier entry	lbEntry	IN	IX301.2	11		
light barrier after color sensor	lbAfterColorSensor	IN	IX301.3	12		
color sensor	colorSensor	IN		Analog		
light barrier white	lbWhite	IN	IX301.5	14		
light barrier red	lbRed	IN	IX301.6	15		
light barrier blue	lbBlue	IN	IX301.7	16		
motor conveyor belt	mConveyorBelt	OUT	QX41.5		14	
compressor	compressor	OUT	QX41.6		15	
valve first ejection (white)	valveFirstEject	OUT	QX41.7		16	
valve second ejection (red)	valveSecEject	OUT	QX41.7		16	
valve third ejection (blue)	valveThirdEject	OUT	QX41.7		16	

switch				ECC-2250		
FischerTechnik name	var name	type	Codesys port	I	O	
hardware switch	hwSwitch	IN	IX1.7	16		

global var lists

HR high rack
VG vacuum gripper
FU Furnance
SL sorting line