PLC I/O layout

	high rack (HR)			ECC-2250	
FischerTechnik name	var name	type	Codesys port		0
switch horizonal	sHorizontal	IN	IX0.0	1	
light-barrier inside	lbin	IN	IX0.1	2	
ight-barrier outside	lbOut	IN	IX0.2	3	
switch vertical	sVertical	IN	IX0.3	4	
switch cantilever front	sCFront	IN	IX0.4	5	
witch cantilever back	sCBack	IN	IX0.5	6	
notor conveyor belt forward	mCbForward	OUT	QX0.0	·	
notor conveyor belt lorward	mCbBackward	OUT	QX0.1		
notor conveyor best backward notor horizontal towards conveyor belt	mHorizontalLeft	OUT	QX0.2		
motor horizontal towards rack	mHorizontalRight	OUT	QX0.3		
motor vertical axis upward	mVerticalDown	OUT	QX0.4		
motor vertical axis downward	mVerticalUp	OUT	QX0.5		
motor cantilever forward	mCForward	OUT	QX0.6		
motor cantilever backward	mCBackward	OUT	QX0.7		
v	acuum gripper (VG)			ECC-2250	
FischerTechnik name	var name	type	Codesys port		0
switch vertical	sVertical	IN	IX0.6	7	
switch horizontal	sHorizontal	IN	IX0.7	8	
witch 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	IX1.2	12	
encoder horizontal impuls 1	enchorizontal2	IN	IX1.3	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		
motor vertical down	mVerticalDown	OUT	QX1.1		1
motor horizontal backwards	mHorizontalBackward	OUT	QX1.2		1
motor horizontal forward	mHorizontalForward	OUT	QX1.3		1
notor rotation clockwise	mRotationClockwise	OUT	QX1.4		1
motor rotation counterclockwise	mRotationCClockwise	OUT	QX1.5		1
compressor	compressor	OUT	QX1.5 QX1.6		1
valve vacuum	valve	OUT	QX1.6 QX1.7		1
	furnance (FU)			ECC DIO	
FischerTechnik name	var name	type	Codesys port		0
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	IbConveyorBelt	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	sEurnanceSliderInside	IN	IX300.5	6	
switch furnance slider outside	sFurnanceSliderOutside	IN	IX300.5	7	
	sSuckerPosEF	IN	IX300.6	8	
switch sucker (pos firing furnance)				9	
light barrier furnance	IbFurnance	IN	IX301.0	9	
motor rotating assembly clockwise	mRaClockwise	OUT	QX40.0		
motor rotating assembly counter clockwise	mRaCClockwise	OUT	QX40.1		
motor conveyor belt forward	mConveyorBeltForward	OUT	QX40.2		
motor saw	mSaw	OUT	QX40.3		
		OUT OUT	QX40.3 QX40.4		
motor furnance slider in	mSaw mFurnanceSliderIn				
motor furnance slider in motor furnance slider out	mSaw mFurnanceSliderIn mFurnanceSliderOut	OUT	QX40.4 QX40.5		
motor furnance slider in motor furnance slider out motor sucker to furnance	mSaw mFurnanceSliderIn mFurnanceSliderOut mSuckertoFurnance	OUT OUT OUT	QX40.4 QX40.5 QX40.6		
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to rotating assembly	mSaw mFurnanceSliderIn mFurnanceSliderOut mSuckertoFurnance mSuckertoRa	OUT OUT OUT OUT	QX40.4 QX40.5		
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to rotating assembly light furnance	mSaw mFurnanceSliderIn mFurnanceSliderOut mSuckertoFurnance mSuckertoRa lightFurnance	OUT OUT OUT OUT OUT	QX40.4 QX40.5 QX40.6 QX40.7	analog	ş?
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to rotating assembly light furnance compressor	mSaw mFurnanceSliderIn mFurnanceSliderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor	OUT OUT OUT OUT OUT OUT	QX40.4 QX40.5 QX40.6 QX40.7	analog	3 ?
motor saw motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to rotating assembly light furnance compressor valve vacuum	mSaw mFurnanceSliderIn mFurnanceSliderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum	OUT OUT OUT OUT OUT OUT OUT	OX40.4 OX40.5 OX40.6 OX40.7 OX41.0 OX41.1	analog	;? 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to rotating assembly light furnance compressor	mSaw mFurnanceSliderIn mFurnanceSliderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor	OUT OUT OUT OUT OUT OUT	QX40.4 QX40.5 QX40.6 QX40.7	analog	;? 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance light furnance light furnance compressor valve vacuum valve lowering	mSaw mFurnanceSliderIn mFurnanceSliderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum	OUT OUT OUT OUT OUT OUT OUT	OX40.4 OX40.5 OX40.6 OX40.7 OX41.0 OX41.1	analog	g? 1 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to rotating assembly light furnance compressor valve vacuum	mSaw mFurnanceSliderIn mFurnanceSliderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering	OUT OUT OUT OUT OUT OUT OUT	QX40.4 QX40.5 QX40.6 QX40.7 QX41.0 QX41.1 QX41.2	analog	3? 1 1 1 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance motor sucker to rotating assembly light furnance compressor valve vacuum valve lowering valve furnance door valve slider	mSaw mFurnanceSilderIn mFurnanceSilderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering valveFurnanceDoor valveSilder sorting line(SL)	OUT	OX40.4 OX40.5 OX40.6 OX40.7 OX41.0 OX41.1 OX41.2 OX41.3 OX41.4	ECC DIO	3? 1 1 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance ight furnance compressor valve vacuum valve lowering valve furnance door valve slider FischerTechnik name	mSaw mFurnanceSiderIn mFurnanceSiderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacum valveLowering valveFurnanceDoor valveSider sorting line (SL) var name	OUT	0X40.4 0X40.5 0X40.6 0X40.7 0X41.0 0X41.1 0X41.2 0X41.3 0X41.4	ECC DIO	;? 1 1 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance motor sucker to rotating assembly light furnance compressor valve vacuum valve lowering valve furnance door valve slider FischerTechnik name impuls feeler	mSaw mFurnanceSliderIn mFurnanceSliderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering valveFurnanceDoor valveSlider sorting line (SL) var name iFeeler	OUT	0X40.4 0X40.5 0X40.6 0X40.7 0X41.0 0X41.1 0X41.2 0X41.3 0X41.4 Codesys port IX301.1	ECC DIO	3? 1 1 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance motor sucker to rotating assembly ight furnance compressor valve vacuum valve lowering valve furnance door valve slider FischerTechnik name mpuls feeler ight barrier entry	mSaw mFurnanceSiderIn mFurnanceSiderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering valveFurnanceDoor valveSider sorting line (SL) var name iFeeler lbEntry	OUT	0X40.4 0X40.5 0X40.6 0X40.6 0X40.7 0X41.0 0X41.1 0X41.2 0X41.3 0X41.4 Codesys port IX301.1 IX301.2	ECC DIO I 10 11	3? 1 1 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance ight furnance compressor valve lowering valve lowering valve lowering valve slider FischerTechnik name mpuls feeler ight barrier after color sensor	mSaw mFurnanceSliderIn mFurnanceSliderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering valveFurnanceDoor valveSlider sorting line (SL) var name iFeeler lbEntry lbAfterColorSensor	OUT	0X40.4 0X40.5 0X40.6 0X40.7 0X41.0 0X41.1 0X41.2 0X41.3 0X41.4 Codesys port IX301.1	ECCDIO 1 10 11 12	3? 1 1 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance ight furnance compressor valve lowering valve lowering valve lowering valve slider FischerTechnik name mpuls feeler ight barrier after color sensor	mSaw mFurnanceSiderIn mFurnanceSiderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering valveFurnanceDoor valveSider sorting line (SL) var name iFeeler lbEntry	OUT	0X40.4 0X40.5 0X40.6 0X40.6 0X40.7 0X41.0 0X41.1 0X41.2 0X41.3 0X41.4 Codesys port IX301.1 IX301.2	ECC DIO I 10 11	3? 1 1 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance motor sucker to furnance compressor valve lowering valve lowering valve lowering valve furnance door valve slider FischerTechnik name mpuls feeler ight barrier entry ight barrier after color sensor color sensor	mSaw mFurnanceSliderIn mFurnanceSliderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering valveFurnanceDoor valveSlider sorting line (SL) var name iFeeler lbEntry lbAfterColorSensor	OUT	0X40.4 0X40.5 0X40.6 0X40.6 0X40.7 0X41.0 0X41.1 0X41.2 0X41.3 0X41.4 Codesys port IX301.1 IX301.2	ECCDIO 1 10 11 12	3? 1 1 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance ight furnance compressor valve vacuum valve lowering valve furnance door valve slider FischerTechnik name impuls feeler light barrier entry light barrier after color sensor color sensor light barrier white	mSaw mFurnanceSilderIn mFurnanceSilderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering valveFurnanceDoor valveSilder sorting line(SL) var name iFeeler lbEntry lbAfterColorSensor colorSensor	OUT	0X40.4 0X40.5 0X40.6 0X40.6 0X41.0 0X41.1 0X41.2 0X41.3 0X41.4 Codesys port 1X301.1 1X301.2 1X301.3	ECC DIO 1 10 11 12 Analog	3? 1 1 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance compressor valve vacuum valve lowering valve furnance door valve slider FischerTechnik name mpuls feeler ight barrier entry ight barrier white	mSaw mFurnanceSliderIn mFurnanceSliderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering valveFurnanceDoor valveSlider sorting line (SL) var name iFeeler lbEntry lbAfterColorSensor colorSensor lbWhite lbRed	OUT	0X40.4 0X40.5 0X40.6 0X40.6 0X40.7 0X41.0 0X41.1 0X41.2 0X41.3 0X41.4 Codesys port 1X301.1 1X301.2 1X301.3	ECCDIO 1 10 11 12 Analog 14 15	3? 1 1 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance motor sucker to furnance light furnance compressor valve vacuum valve lowering valve furnance door valve slider FischerTechnik name impuls feeler light barrier after color sensor color sensor light barrier white light barrier white light barrier white light barrier blue	mSaw mFurnanceSiderIn mFurnanceSiderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering valveFurnanceDoor valveSider sorting line(SL) var name iFeeler lbEntry lbAfterColorSensor colorSensor lbWhite lbRed lbBlue	OUT	OX40.4 OX40.5 OX40.6 OX40.6 OX40.7 OX41.0 OX41.1 OX41.2 OX41.3 OX41.4 Codesys port IX301.1 IX301.5 IX301.5 IX301.6 IX301.7	ECC DIO 1 10 11 12 Analog 14	1 1 1 1 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance ight furnance compressor valve lowering valve lowering valve lowering valve slider FischerTechnik name mpuls feeler ight barrier entry ight barrier after color sensor color sensor ight barrier white ight barrier white ight barrier blue motor conveyor belt	mSaw mFurnanceSliderIn mFurnanceSliderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering valveFurnanceDoor valveSlider sorting line (SL) iFeeler lbEntry lbAfterColorSensor colorSensor colorSensor lbWhite lbBlue mConveyorBet	OUT	Codesys port IX301.1 IX301.5 IX301.6 IX301.7 CX41.5	ECCDIO 1 10 11 12 Analog 14 15	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance motor sucker to furnance compressor valve lowering valve lowering valve lowering valve slider FischerTechnik name mpuls feeler ight barrier entry ight barrier after color sensor color sensor ight barrier white ight barrier white ight barrier de ight barrier blue motor conveyor bet compressor	mSaw mFurnanceSiderIn mFurnanceSiderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacum valveLowering valveFurnanceDoor valveSider sorting line (SL) var name iFeeler lbEntry lbAfterColorSensor colorSensor lbWhite lbRed lbBlue mConveyorBelt compressor	OUT	0X40.4 0X40.5 0X40.6 0X40.6 0X41.0 0X41.1 0X41.2 0X41.3 0X41.4 Codesys port 1X301.1 1X301.2 1X301.3 1X301.5 1X301.6 1X301.7 0X41.5 0X41.6	ECCDIO 1 10 11 12 Analog 14 15	3? 11 11 11 10
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance ight furnance compressor valve lowering valve lowering valve furnance door valve slider FischerTechnik name mpuls feeler ight barrier entry ight barrier after color sensor color sensor ight barrier white ight barrier white ight barrier blue motor conveyor belt compressor valve first ejection (white)	mSaw mFurnanceSiderIn mFurnanceSiderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering valveFurnanceDoor valveSider sorting line (SL) var name iFeeler lbEntry lbAfterColorSensor colorSensor lbWhite lbRed lbBlue mConveyorBelt compressor valveFirstEject	OUT	Cx40.4 Cx40.5 Cx40.6 Cx40.6 Cx40.7 Cx41.0 Cx41.1 Cx41.2 Cx41.3 Cx41.4 Codesys port IX301.1 IX301.2 IX301.3 IX301.5 IX301.6 IX301.7 Cx41.5 Cx41.6 Cx41.6 Cx41.7	ECCDIO 1 10 11 12 Analog 14 15	11 11 11 10 0
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance ight furnance compressor valve lowering valve lowering valve furnance door valve slider FischerTechnik name mpuls feeler ight barrier entry ight barrier after color sensor color sensor ight barrier white ight barrier white ight barrier blue motor conveyor belt compressor valve first ejection (white)	mSaw mFurnanceSiderIn mFurnanceSiderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering valveFurnanceDoor valveSider sorting line (SL) var name iFeeler lbEntry lbAfterColorSensor colorSensor lbWhite lbBlue mConveyorBelt compressor valveFirstEject valveSecEject	OUT	0X40.4 0X40.5 0X40.6 0X40.6 0X41.0 0X41.1 0X41.2 0X41.3 0X41.4 Codesys port 1X301.1 1X301.2 1X301.3 1X301.5 1X301.6 1X301.7 0X41.5 0X41.6	ECCDIO 1 10 11 12 Analog 14 15	11 11 11 10 0
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance ight furnance compressor valve lowering valve lowering valve furnance door valve slider FischerTechnik name mpuls feeler ight barrier entry ight barrier after color sensor color sensor ight barrier white ight barrier white ight barrier blue motor conveyor bet compressor valve first ejection (white) valve scond of survave or survave first out	mSaw mFurnanceSiderIn mFurnanceSiderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering valveFurnanceDoor valveSider sorting line (SL) var name iFeeler lbEntry lbAfterColorSensor colorSensor lbWhite lbRed lbBlue mConveyorBelt compressor valveFirstEject	OUT	Cx40.4 Cx40.5 Cx40.6 Cx40.6 Cx40.7 Cx41.0 Cx41.1 Cx41.2 Cx41.3 Cx41.4 Codesys port IX301.1 IX301.2 IX301.3 IX301.5 IX301.6 IX301.7 Cx41.5 Cx41.6 Cx41.6 Cx41.7	ECCDIO 1 10 11 12 Analog 14 15	1 1 1 1 1 0
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance ight furnance compressor valve lowering valve lowering valve furnance door valve slider FischerTechnik name mpuls feeler ight barrier entry ight barrier after color sensor color sensor ight barrier white ight barrier white ight barrier blue motor conveyor bet compressor valve first ejection (white) valve scond of survave or survave first out	mSaw mFurnanceSiderIn mFurnanceSiderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering valveFurnanceDoor valveSider sorting line (SL) var name iFeeler lbEntry lbAfterColorSensor colorSensor lbWhite lbBlue mConveyorBelt compressor valveFirstEject valveSecEject	OUT	Codesys port IX301.1 IX301.5 IX301.6 IX301.7 CX41.6 CX41.7	ECCDIO 1 10 11 12 Analog 14 15	3? 1 1 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance ight furnance compressor valve lowering valve lowering valve furnance door valve slider FischerTechnik name mpuls feeler ight barrier entry ight barrier after color sensor color sensor ight barrier white ight barrier red ight barrier red ight barrier white ight barrier sub ight barrier sie ight	mSaw mFurnanceSiderIn mFurnanceSiderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveAacuum valveLowering valveFurnanceDoor valveSider sorting line (SL) var name i Feeler lbEntry lbAfterColorSensor colorSensor lbWhite lbRed lbBlue mConveyorBelt compressor valveFirstEject valveSecEject valveSecEject valveFirdEject	OUT	Codesys port IX301.1 IX301.2 IX301.3 IX301.5 IX301.7 CX41.6 CX41.7	ECC DIO I 10 11 12 Analog 14 15 16	1 1 1 1 1 1 1 1 1 1
motor furnance slider in motor furnance slider out motor sucker to furnance motor sucker to furnance ight furnance compressor valve lowering valve lowering valve furnance door valve slider FischerTechnik name mpuls feeler ight barrier entry ight barrier after color sensor color sensor ight barrier white ight barrier white ight barrier blue motor conveyor bet compressor valve first ejection (white) valve scond of survave or survave first out	mSaw mFurnanceSiderIn mFurnanceSiderOut mSuckertoFurnance mSuckertoRa lightFurnance compressor valveVacuum valveLowering valveFurnanceDoor valveSilder sorting line (SL) var name iFeeler lbEntry lbAfterColorSensor colorSensor lbWhite lbRed lbBlue mConveyorBelt compressor valveFirstEject valveSeEject valveThirdEject	OUT	Codesys port IX301.1 IX301.5 IX301.6 IX301.7 CX41.6 CX41.7	ECC DIO I 10 11 12 Analog 14 15 16	1 1 1 1 1 0

global var lists
HR high rack
VG vacuum gripper
FU Furnance
SL sorting line