| Totally Inte | egrated on Portal | | | | | | | |
|-------------------|-------------------------------------|------------------|----------------------|--------------|---------------------|------------------------|-----|--|
| TEST1_ | V16 / PLC_1 [CF | PU 1215C DC/D | C/DC] / 程序均 | t | | | | |
| Main [OB | 1] | | | | | | | |
| Main 属性 常规 | | | | | | | | |
| 名称 编号 | Main 自动 | 编号 | 1 | 类型 | ОВ | 语言 | LAD | |
| 信息 | | o (Cy- 作者 | | 注释 | | 系列 | | |
| 版本 | "Main Program Sweep cle)" 0.1 | 用户自定义ID | | Z-1T | | | | |
| Main | 0.1 | 州广日足又10 | | | | | | |
| 名称 | | 数据类型 | 默认值 | | 注释 | | | |
| ▼ Input Initial_0 | Call | Bool | | | Initial call of thi | s OB | | |
| Reman | | Bool | | | | ent data are available | | |
| Temp Constant | | | | | | | | |
| 网络1: | | | | | | | | |
| | | | | | | | | |
| | | %1 | DB41 | | | | | |
| | | | 轴_DB" FB2 | | | | | |
| | | — EN | ENO | | | - | | |
| | | | | | | | | |
| 网络 2: | | | | | | | | |
| | | | | | | | | |
| | | %l "D1 | DB56 袖_DB" | | | | | |
| | | | FB7 | | | | | |
| | | — EN | ENO | | | -1 | | |
| | | | | | | | | |
| 网络 3: | | | | | | | | |
| | | | | | | | | |
| | | % "01: | DB53 轴_DB" | | | | | |
| | | | FB4 | | | | | |
| | | — EN | ENO - | | | - | | |
| | | <u> </u> | | | | | | |
| 网络 4: | | | | | | | | |
| | | | | | | | | |
| | | | DB50 a_DB_1" | | | | | |
| | | | FB3 | | | | | |
| | | — EN | ENO | | | 4 | | |
| | | l | | | | | | |
| 网络 5: | | | | | | | | |
| | | | | | | | | |
| | | "X2: | DB54 轴_DB" | | | | | |
| | | % | FB5 | | | | | |
| | | — EN | ENO | | | - | | |
| | | l | | | | | | |
| 网络 6: | | | | | | | | |
| | | | | | | | | |
| | | "Q2: | DB55 轴_DB" | | | | | |
| | | | FB6 | | | | | |
| | | EN | ENO - | | | - | | |
| | | l | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

网络7:启动状态处理

```
%M13.0
"FLAG_QIDONG_
KEEP"
%DB44.DBX0.0
   "G".启动
                   SR
    "T1".Q
    \dashvP\vdash
 %M13.2
"RISE_T1_1"
                    %M13.1
"FLAG_RUN"
   "T1".Q
                   SR
     ⊣ P ⊢
   %M13.3
  "RISE_T1_2"
%DB44.DBX0.1
"G".停止
     \dashv \vdash
                      %DB52
"T1"
   %M13.0
"FLAG_QIDONG_
KEEP"
                       TON
                      Time
                            Q-
                   - IN
          T#5S — PT
                             ET — T#0ms
```

网络8:停止状态处理

网络9:红灯

网络 10:绿灯

网络 11: 黄灯

```
*M13.0

*FLAG_QIDONG_ *M0.5

KEEP* "Clock_1Hz" "三色灯-紅"

*DB44.DBX0.2 *M0.7

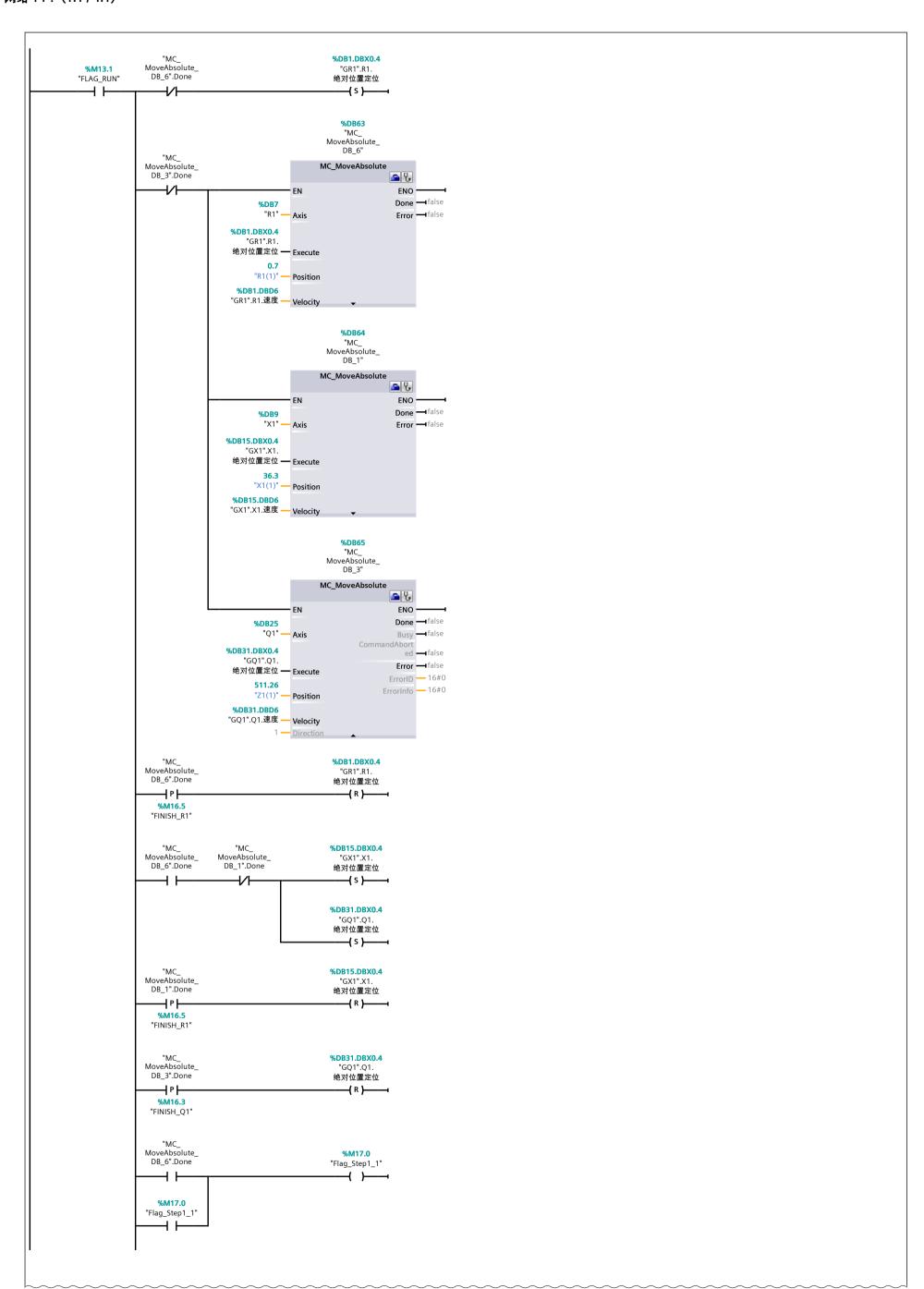
"G"急停 "Clock_0.5Hz"
```

网络 12:夹爪

网络 13:吸盘

网络 14:

网络 14: (1.1 / 4.1)



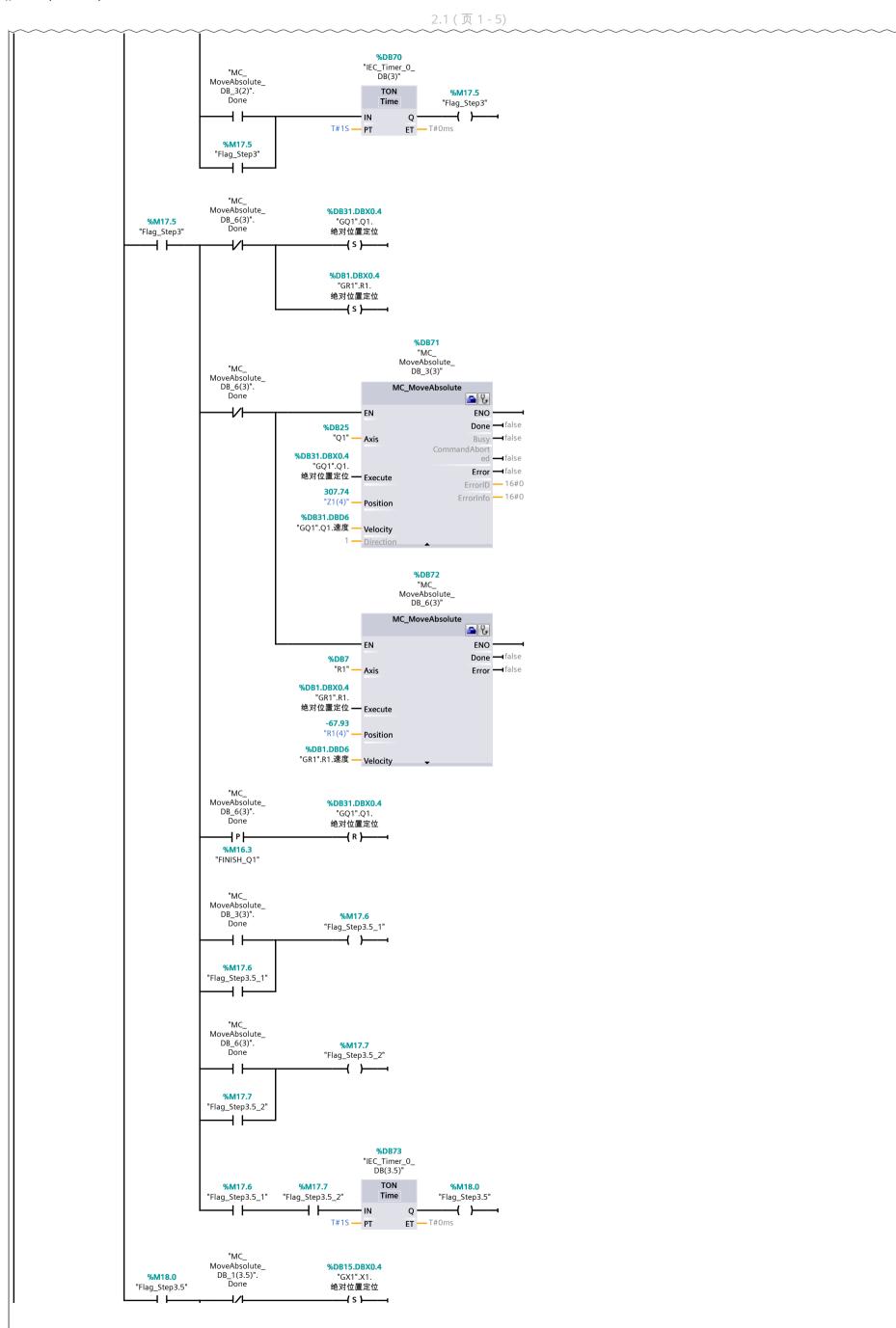
2.1 (页 1 - 5)

Totally Integrated **Automation Portal** 网络 14: (2.1 / 4.1) 1.1 (页 1 - 4) "MC_ MoveAbsolute_ %M17.1 DB_1".Done "Flag_Step1_2" **⊣** ⊢ %M17.1 "Flag_Step1_2" \dashv \vdash "MC_ MoveAbsolute_ DB_3".Done %M17.2 "Flag_Step1_3" %M17.2 "Flag_Step1_3" \dashv \vdash %DB66 "IEC_Timer_0_DB" TON %M17.0 %M17.1 %M17.2 %M17.3 "Flag_Step1_1" "Flag_Step1_3" Time "Flag_Step1" "Flag_Step1_2" \dashv \vdash \dashv \vdash **→** → - IN Q -T#1S — PT ET — T#0ms "MC_ MoveAbsolute_ DB_3(1)". **%DB31.DBX0.4** "GQ1".Q1. %M17.3 "Flag_Step1" 绝对位置定位 ٦H **-(** s **)**-%DB67 "MC_ MoveAbsolute_ "MC_ MoveAbsolute_ DB_3(1)". Done DB_3(1)" MC_MoveAbsolute **-**//⊢ ENO -- EN **Done →**false %DB25 "Q1" — Busy —false Axis CommandAbort ed —false %DB31.DBX0.4 Error → false 绝对位置定位 — Execute ErrorID — 16#0 864.06 ErrorInfo — 16#0 "Z1(2)" — Position %DB31.DBD6 "GQ1".Q1.速度 — Velocity 1 — Directi "MC_ MoveAbsolute_ DB_3(1)". Done %DB31.DBX0.4 "GQ1".Q1. 绝对位置定位 —(R)— Ⅎℙℍ %M16.3 "FINISH_Q1" %DB68 "MC_ MoveAbsolute_ DB_3(1)". Done TON %M17.4 Time "Flag_Step2" \dashv \vdash - IN Q -**→ →** %M17.4 "Flag_Step2" "MC_ MoveAbsolute_ DB_3(2)". %DB31.DBX0.4 %M17.4 "Flag_Step2" 绝对位置定位 **-(** s **)**-%DB69 "MC_ MoveAbsolute_ DB_3(2)" "MC_ Db_عرــ,
MC_MoveAbsolute MoveAbsolute_ DB_3(2)". ENO -**Done →**false %DB25 "Q1" — Axis Busy —false CommandAbort ed —false %DB31.DBX0.4 "GQ1".Q1. Error —false 绝对位置定位 — Execute ErrorID — 16#0 307.74 ErrorInfo — 16#0 "Z1(3)" <mark>-</mark> Position %DB31.DBD6 "GQ1".Q1.速度 — Velocity 1 — Direction "MC_ MoveAbsolute_ DB_3(2)". Done %DB31.DBX0.4 绝对位置定位 **–(** R **)**– %M16.3 "FINISH_Q1"

Totally Integrated Automation Portal

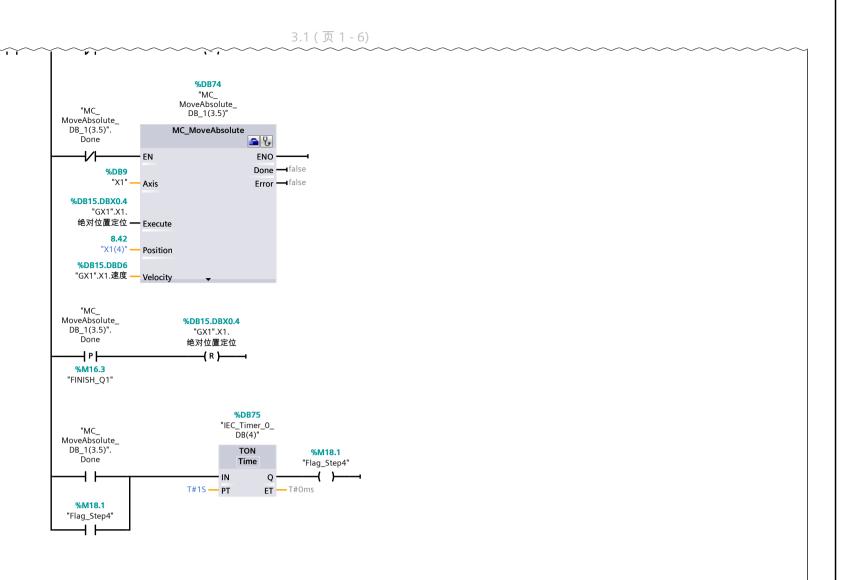
网络 14: (3.1 / 4.1)

2.1 (页 1 - 5)

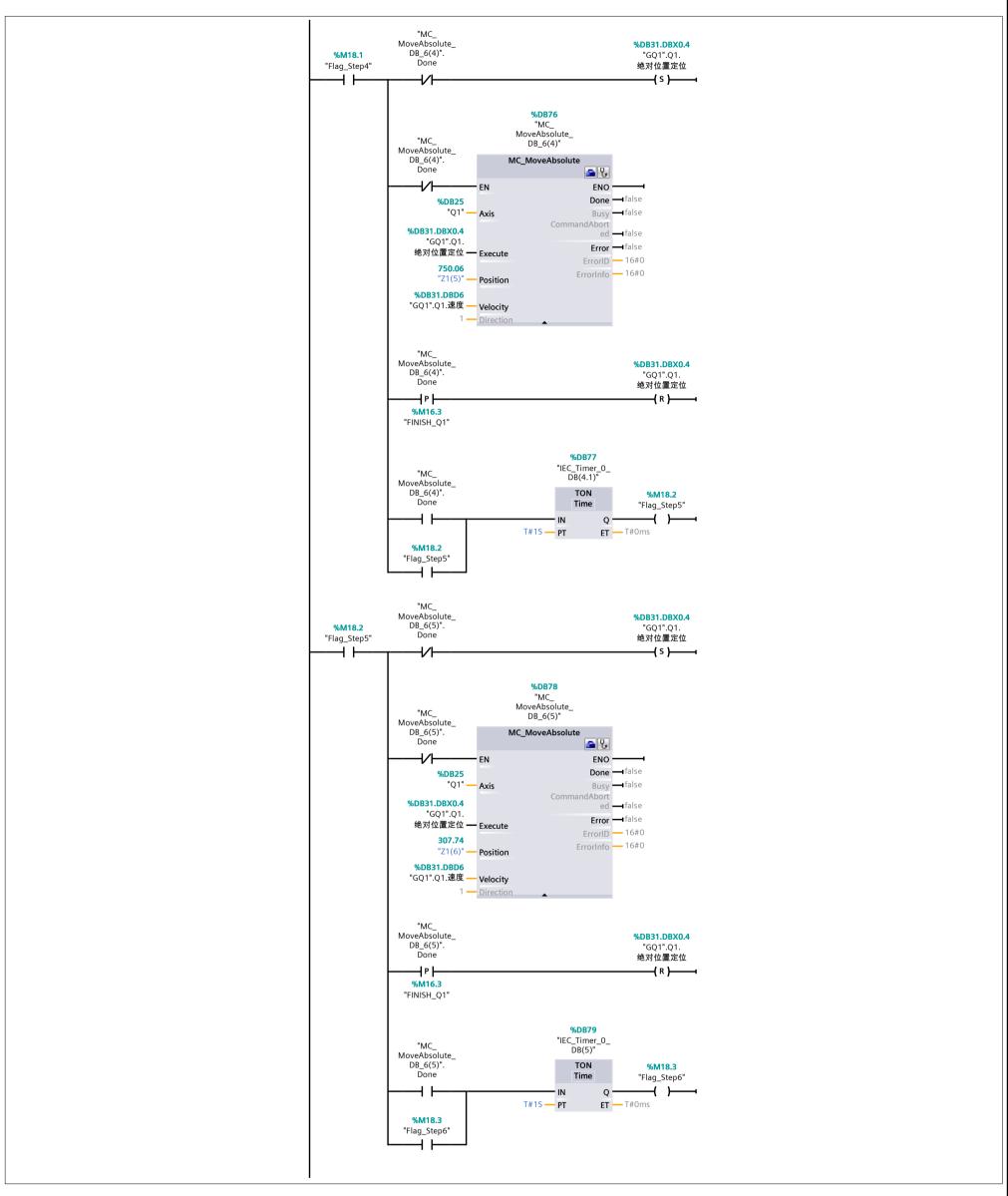


|--|

网络 14: (4.1 / 4.1)

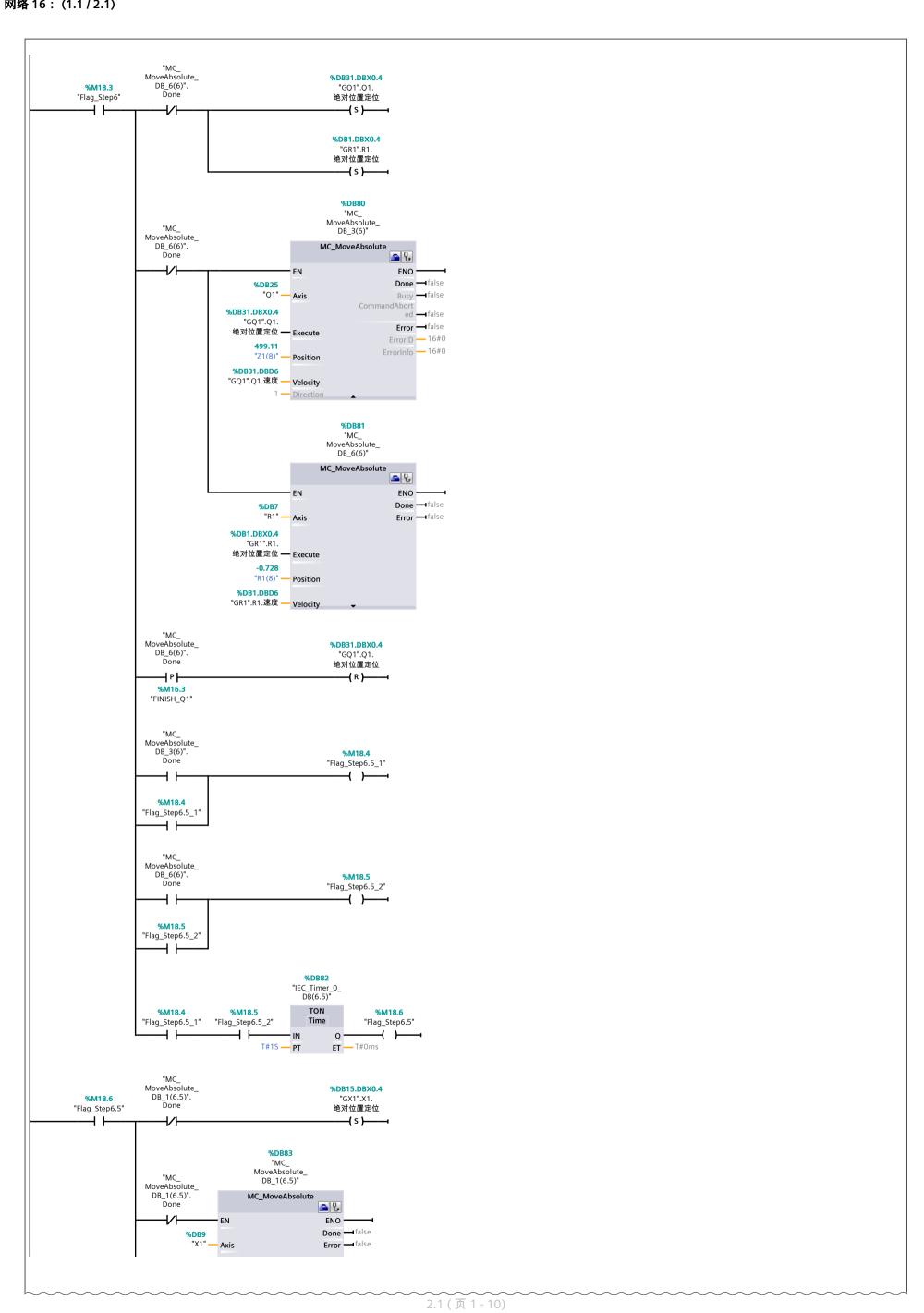


网络 15:



网络 16:

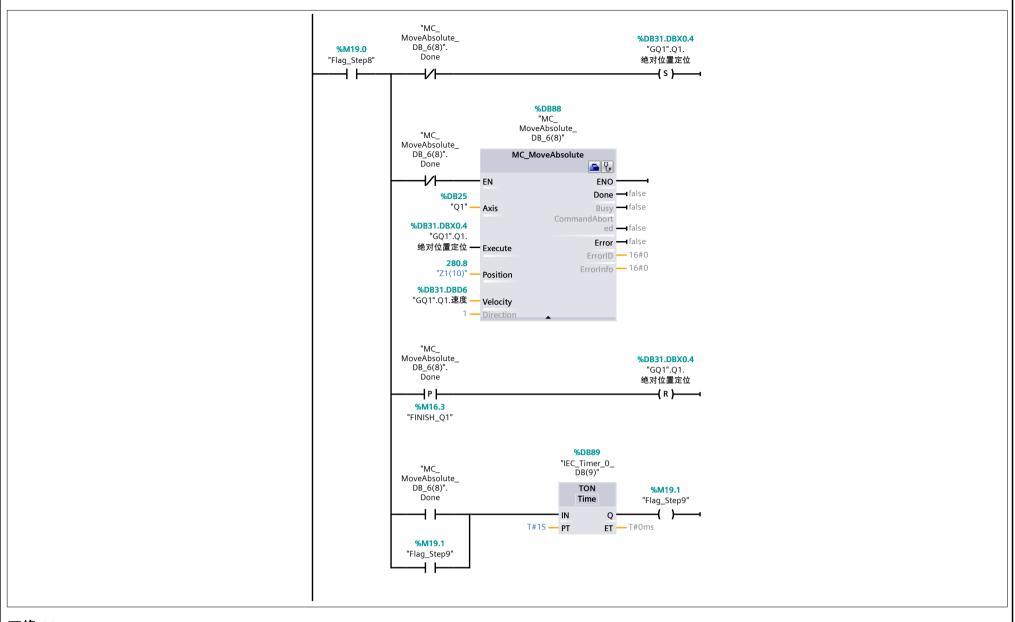
网络 16: (1.1 / 2.1)



Totally Integrated **Automation Portal** 网络 16: (2.1 / 2.1) 1.1 (页 1 - 9) %DB15.DBX0.4 "GX1".X1. 绝对位置定位 — Execute -7.66 "X1(8)" — Position %DB15.DBD6 "GX1".X1.速度 — Velocity "MC_ MoveAbsolute_ DB_1(6.5)". Done %DB15.DBX0.4 "GX1".X1. 绝对位置定位 —(R)— "FINISH_Q1" %DB84 "IEC_Timer_0_ DB(7)" "MC_ MoveAbsolute_ DB_1(6.5)". Done TON **%M18.7** "Flag_Step7" Time **T#1S** — **PT** ET — T#0ms %M18.7 "Flag_Step7" \dashv \vdash "MC_ MoveAbsolute_ DB_6(7)". Done %DB31.DBX0.4 "GQ1".Q1. 绝对位置定位 %M18.7 "Flag_Step7" **_(** s **)**___ %DB85

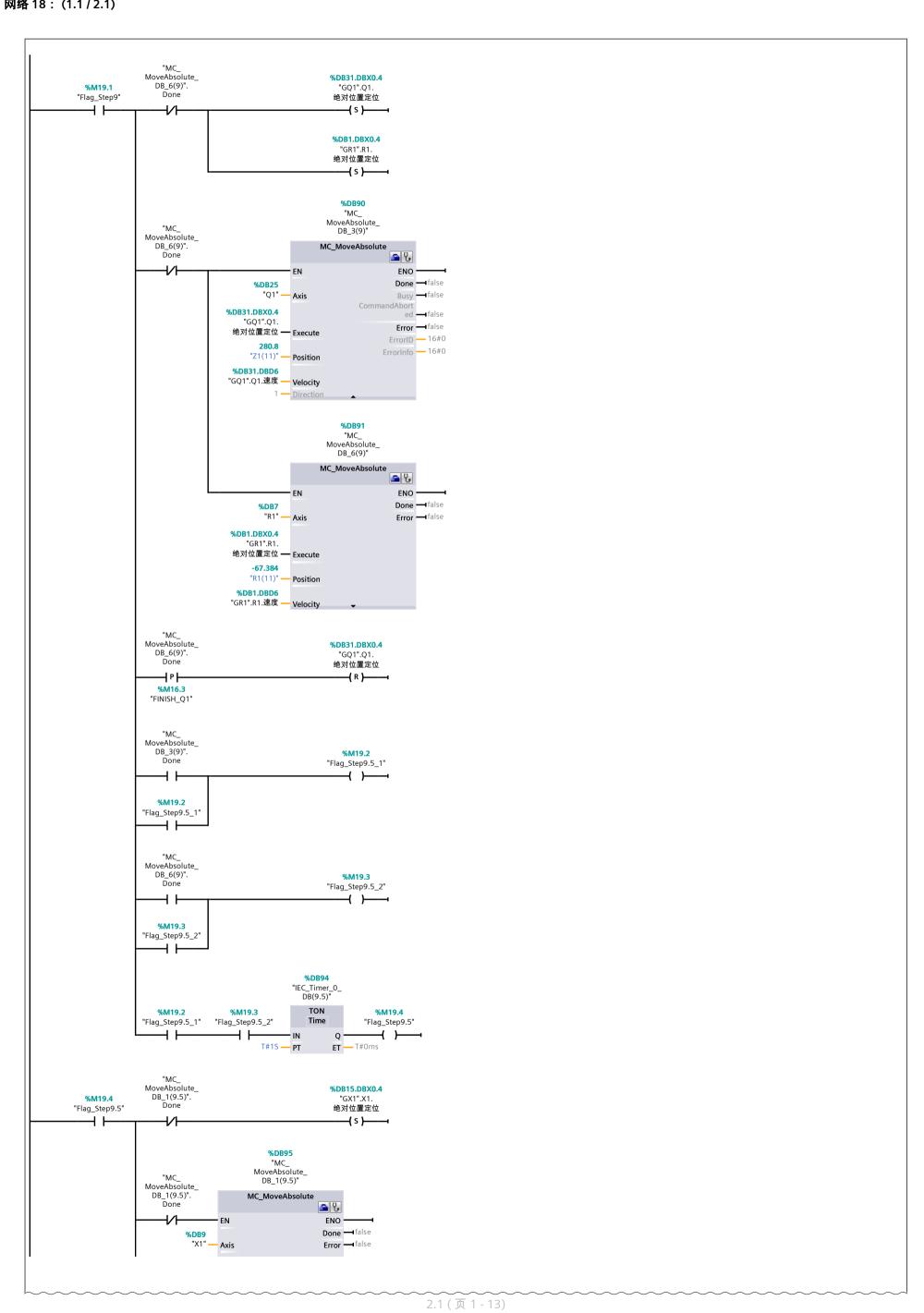
"MC_
MoveAbsolute_
DB_6(7)" "MC_ MoveAbsolute_ DB_6(7)". MC_MoveAbsolute - EN ENO -**Done →** false %DB25 "Q1" — Axis Busy **→**false CommandAbort ed —false %DB31.DBX0.4 Error — false 绝对位置定位 — Execute ErrorID — 16#0 813.48 ErrorInfo — 16#0 "Z1(9)" — Position %DB31.DBD6 "GQ1".Q1.速度 — Velocity 1 — Direction "MC_ MoveAbsolute_ %DB31.DBX0.4 DB_6(7)". Done "GQ1".Q1. 绝对位置定位 \dashv P \vdash —(R)— %M16.3 "FINISH_Q1" **%DB87**"IEC_Timer_0_
DB(8)" "MC_ MoveAbsolute_ TON DB_6(7)". Done %M19.0 Time "Flag_Step8" T#1S — IN Q — T#0ms \dashv \vdash **→** → %M19.0 "Flag_Step8" \dashv \vdash

网络 17:



网络 18:

网络 18: (1.1 / 2.1)



| Totally Integrated Automation Portal | | |
|---|--|--|
| 网络 18: (2.1 / 2.1) | | |
| | 1.1(页 1 - 12) **DB15.DBX0.4 "GX1".X1. 绝对位置定位 — Execute 9.52 "X1(11)" — Position **DB15.DBD6 "GX1".X1.速度 — Velocity ▼ | |
| | "MC_ MoveAbsolute_ | |
| | "MC_ | |
| | | |
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网络 19:

```
"MC_
MoveAbsolute_
DB_6(10)".
Done
                                                                                %DB31.DBX0.4
                                                                                 "GQ1".Q1.
绝对位置定位
  %M19.5
"Flag_Step10"
                                                      %DB97
                                                 "MC_
MoveAbsolute_
                  "MC_
MoveAbsolute_
DB_6(10)".
Done
                                                    DB_6(10)"
                                                          <u>-</u> ₽
                                        - EN
                                                                     ENO -
                                                                     Done →false
                             %DB25
                                                                     Busy — false
                                "Q1" — Axis
                                                          CommandAbort
ed →false
                     %DB31.DBX0.4 "GQ1".Q1.
                                                                    Error → false
                        绝对位置定位 — Execute
                                                                  ErrorID — 16#0
                             600.0
                                                                 ErrorInfo — 16#0
                           "Z1(12)" — Position
                       %DB31.DBD6
                      "GQ1".Q1.速度 — Velocity
                                  1 — Direction
                  "MC_
MoveAbsolute_
DB_6(10)".
Done
                                                                                %DB31.DBX0.4
                                                                                 "GQ1".Q1.
绝对位置定位
                        \dashvP\vdash
                                                                                    --( ℝ )--
                       %M16.3
                    "FINISH_Q1"
                                                                %DB98
                                                            "IEC_Timer_0_
DB(11)"
                  "MC_
MoveAbsolute_
DB_6(10)".
Done
                                                             TON
                                                                                   %M19.6
                                                                                 "Flag_Step11"
                                                   T#1S — PT ET — T#0ms
                       %M19.6
                    "Flag_Step11"
```

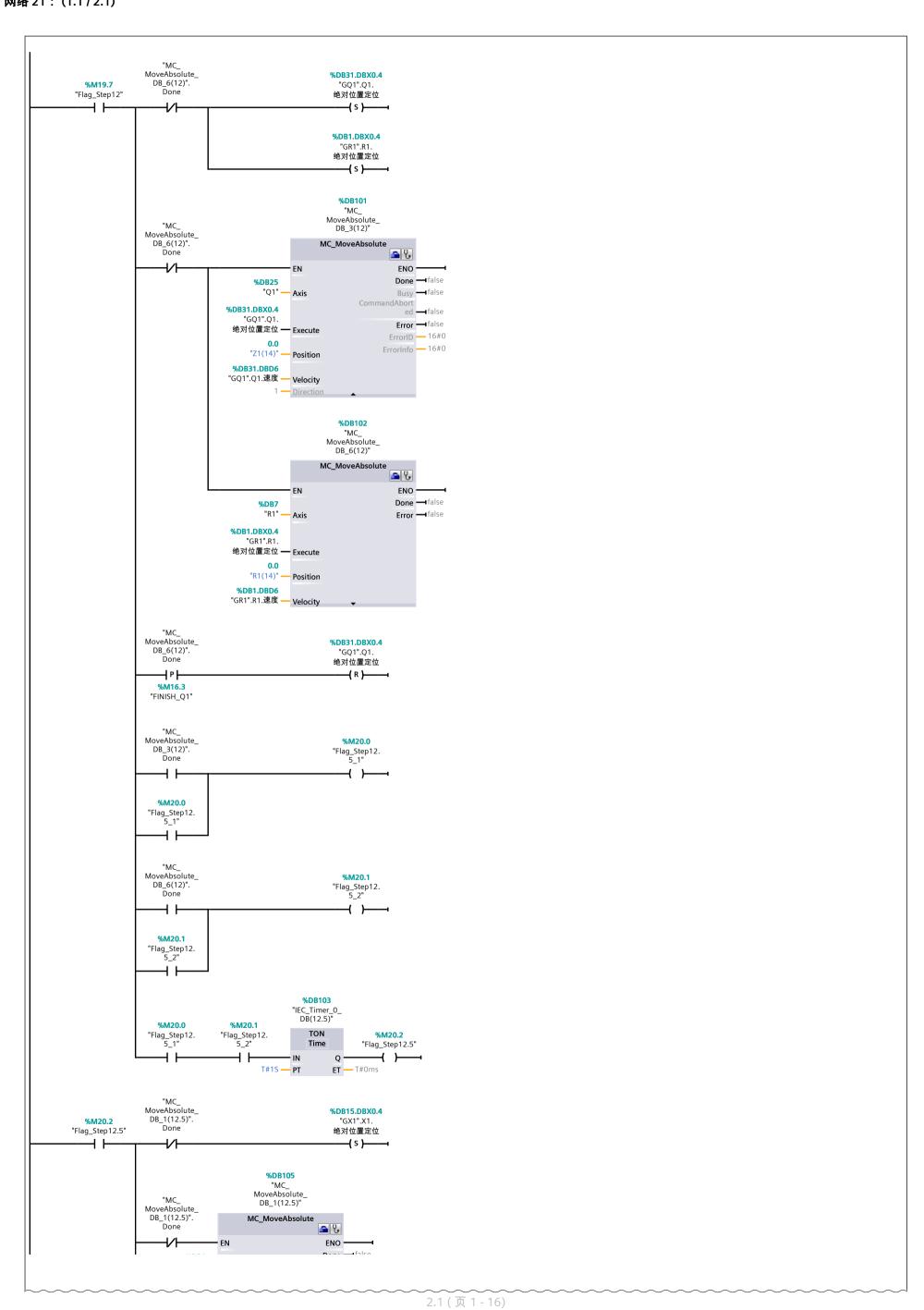
网络 20:

```
"MC_
MoveAbsolute_
DB_6(11)".
Done
                                                                             %DB31.DBX0.4
                                                                              "GQ1".Q1.
绝对位置定位
  %M19.6
"Flag_Step11"
                                               %DB99

"MC_
MoveAbsolute_
DB_6(11)"
                       "MC_
                  MoveAbsolute_
DB_6(11)".
                                              MC_MoveAbsolute
                       Done
                                                                  ENO -
                                      - EN
                                                                 Done →false
                            %DB25
                                                                  Busy — false
                              "Q1" — Axis
                                                        CommandAbort
ed —false
                     %DB31.DBX0.4 "GQ1".Q1.
                                                               Error → false
                       绝对位置定位 — Execute
                                                               ErrorID — 16#0
                             280.8
                                                              ErrorInfo — 16#0
                           "Z1(13)" —
                                      Position
                      %DB31.DBD6
                     "GQ1".Q1.速度 — Velocity
                                 1 — Direction
                  "MC_
MoveAbsolute_
DB_6(11)".
Done
                                                                             %DB31.DBX0.4
                                                                              绝对位置定位
                      %M16.3
                    "FINISH_Q1"
                                                         %DB100
"IEC_Timer_0_
DB(12)"
                 "MC_
MoveAbsolute_
DB_6(11)".
Done
                                                          TON
                                                                               %M19.7
                                                          Time - IN Q -
                                                                             "Flag_Step12"
                                                                               \longrightarrow
                                                 T#1S — PT ET — T#0ms
                    %M19.7
                   "Flag_Step12"
```

网络 21:

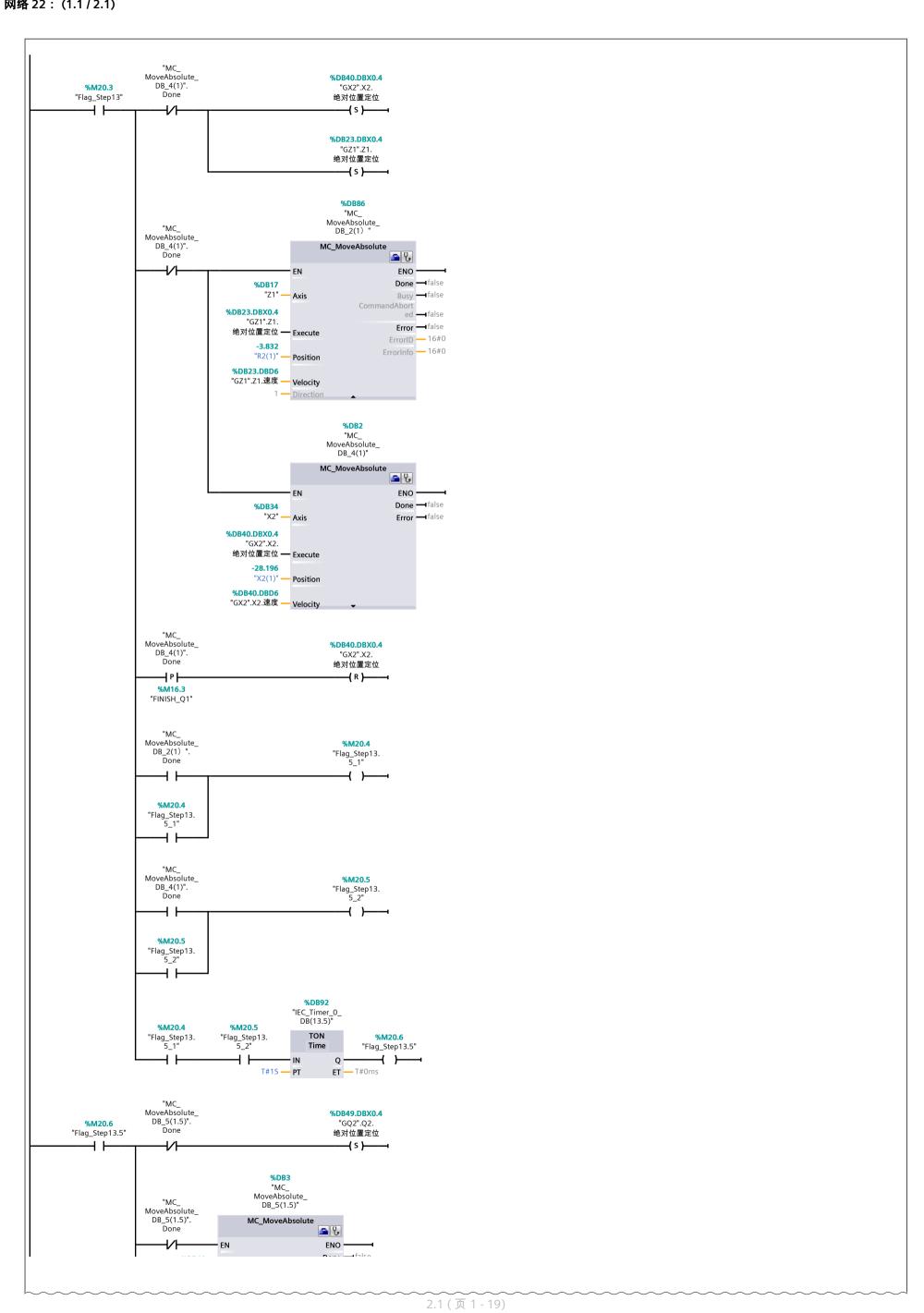
网络 21: (1.1 / 2.1)



| 网络 21: (2.1 / 2.1) | • | | | | | |
|--------------------|-----------------|--|--|--|--|--|
| 700000 | 1.1 (页 1 - 15) | | | | | |
| | NDB9 | | | | | |
| | "MC_ | | | | | |
| | | | | | | |
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| Totally Integrated Automation Portal | |
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| 网络 22 : | |
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网络 22: (1.1 / 2.1)



Totally Integrated **Automation Portal** 网络 22: (2.1 / 2.1) 1.1 (页 1 - 18) Done Tidise %DB42 "Q2" — Axis Error —false **%DB49.DBX0.4** "GQ2".Q2. 绝对位置定位 — Execute **436.47**"Z2(1)" — Position **%DB49.DBD6** "GQ2".Q2.速度 — Velocity "MC_ MoveAbsolute_ DB_5(1.5)". Done **%DB49.DBX0.4** "GQ2".Q2. 绝对位置定位 \dashv P \vdash —(R)— **%M16.3** "FINISH_Q1" **%DB93**"IEC_Timer_O_
DB(14)" "MC_ MoveAbsolute_ DB_5(1.5)". Done TON %M20.7 "Flag_Step14" Time "Flag_
IN Q
T#15 PT ET T#0ms **%M20.7**"Flag_Step14"

网络 23:

```
"MC_
MoveAbsolute_
DB_5(2)".
Done
                                                                          %DB49.DBX0.4
  %M20.7
                                                                            "GQ2".Q2.
"Flag_Step14"
                                                                           绝对位置定位
                                                  %DB4
                                              "MC_
MoveAbsolute_
                 "MC_
MoveAbsolute_
DB_5(2)".
Done
                                                DB_5(2)"
                                                     $ €
                                     - EN
                                                                ENO -
                                                               Done → false
                           %DB42
                                                               Busy — false
                             "Q2" — Axis
                                                     CommandAbort
ed →false
                    %DB49.DBX0.4 "GQ2".Q2.
                                                              Error — false
                      绝对位置定位 — Execute
                                                             ErrorID — 16#0
                                                            ErrorInfo — 16#0
                          "Z2(2)" — Position
                     %DB49.DBD6
                     "GQ2".Q2.速度 — Velocity
                               1 — Direction
                      "MC_
                 MoveAbsolute_
DB_5(2)".
Done
                                                                          %DB49.DBX0.4
                                                                           "GQ2".Q2.
绝对位置定位
                      \dashvP\vdash
                                                                              -( R )-
                     %M16.3
                   "FINISH_Q1"
                                                           %DB5
                                                        "IEC_Timer_0_
DB(15)"
                 "MC_
MoveAbsolute_
DB_5(2)".
Done
                                                        TON
                                                                            %M21.0
                                                                          "Flag_Step15"
                                               %M21.0
                  "Flag_Step15"
```

网络 24:

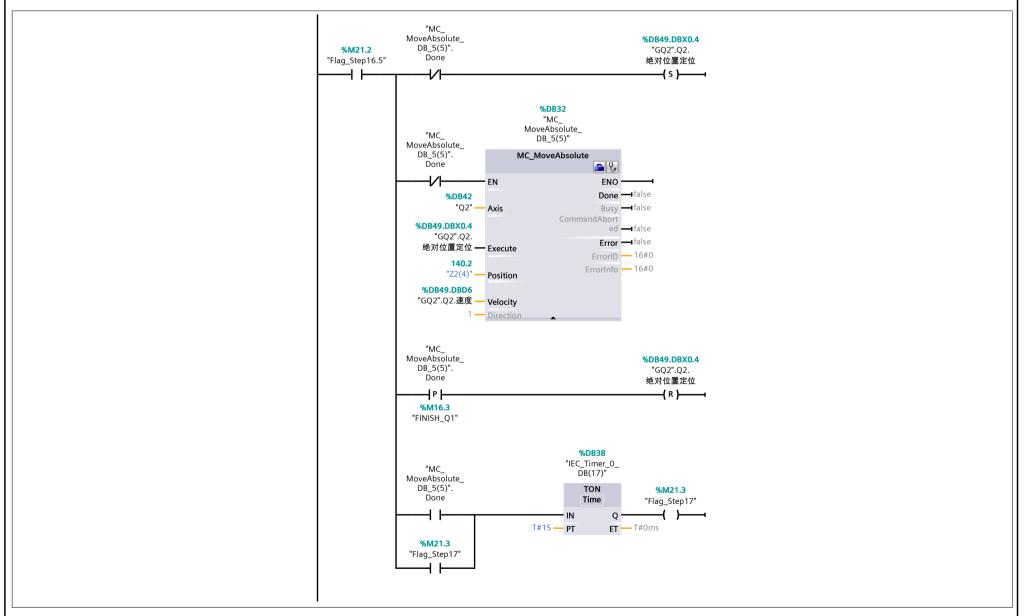
```
"MC_
MoveAbsolute_
DB_2(3)".
Done
                                                                          %DB23.DBX0.4
                                                                           "GZ1".Z1.
绝对位置定位
  %M21.0
"Flag_Step15"
                                             %DB6

"MC_
MoveAbsolute_
DB_2(3)"
                      "MC_
                 MoveAbsolute_
DB_2(3)".
                                            MC_MoveAbsolute
                      Done
                                                                ENO -
                                     - EN
                                                               Done → false
                          %DB17
                                                               Busy — false
                             "Z1" — Axis
                                                     CommandAbort ed —false
                    %DB23.DBX0.4
                         "GZ1".Z1.
                                                            Error —false
                      绝对位置定位 — Execute
                                                            ErrorID — 16#0
                           69.412
                                                            ErrorInfo — 16#0
                           "R2(3)" — Position
                     %DB23.DBD6
                     "GZ1".Z1.速度 — Velocity
                                1 — Direction
                 "MC_
MoveAbsolute_
DB_2(3)".
Done
                                                                          %DB23.DBX0.4
                                                                           --
绝对位置定位
                     %M16.3
                   "FINISH_Q1"
                                                       %DB13
"IEC_Timer_0_
DB(16)"
                "MC_
MoveAbsolute_
DB_2(3)".
Done
                                                        TON
                                                                            %M21.1
                                                       Time Q -
                                                                          "Flag_Step16"
                                                                           \longrightarrow
                                               T#1S — PT ET — T#0ms
                    %M21.1
                  "Flag_Step16"
```

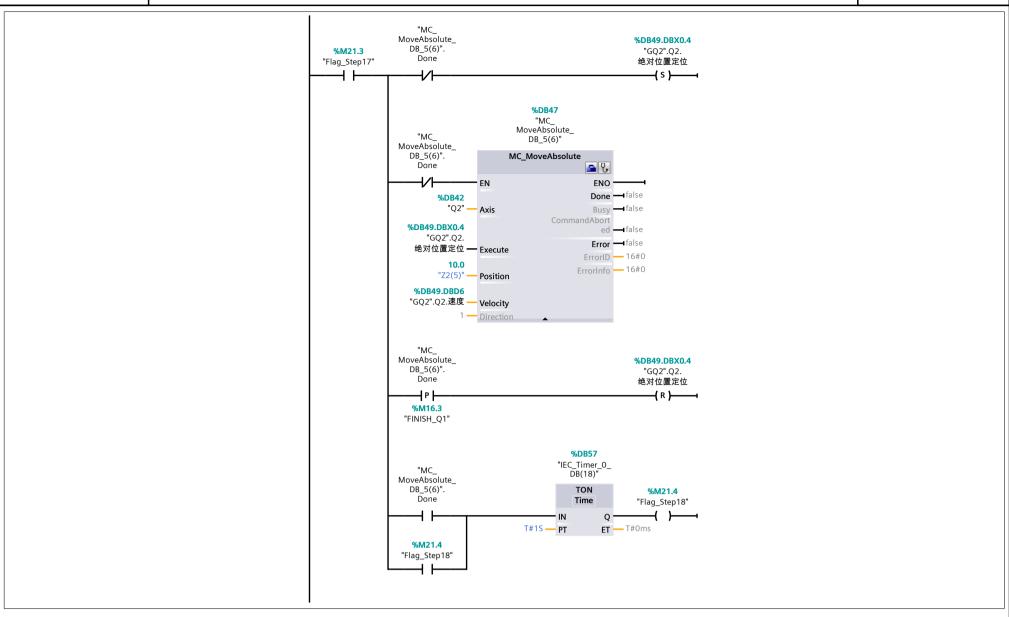
网络 25:

```
"MC_
MoveAbsolute_
DB_4(4.5)".
Done
                                                                                      %DB40.DBX0.4
  %M21.1
                                                                                         "GX2".X2.
                                                                                       绝对位置定位
"Flag_Step16"
                                                                                            -( s )-
                                                          %DB21
                                                     "MC_
MoveAbsolute_
DB_4(4.5)"
                    "MC_
MoveAbsolute_
DB_4(4.5)".
Done
                                                    MC_MoveAbsolute
                                                                          ENO -
                                           - EN
                                                                          Done → false
                                                                          Busy — false
                                           Axis
                       %DB40.DBX0.4
                             "GX2".X2.
                                                                         Error → false
                         绝对位置定位 — Execute
                                                                        ErrorID — 16#0
                               -47.48
"X2(4)" — Position
                                                                      ErrorInfo — 16#0
                         %DB40.DBD6
                         "GX2".X2.速度 — Velocity
                    "MC_
MoveAbsolute_
DB_4(4.5)".
Done
                                                                                       %DB40.DBX0.4
                                                                                       "GX2".X2.
绝对位置定位
                          \dashvP\vdash
                      %M16.3
"FINISH_Q1"
                                                                    %DB29
                                                                 "IEC_Timer_0_
DB(16.5)"
                    "MC_
MoveAbsolute_
DB_4(4.5)".
Done
                                                                                          %M21.2
                                                                                      "Flag_Step16.5"
                                                       T#1S — PT
                                                                        ET — T#0ms
                        %M21.2
                    "Flag_Step16.5"
```

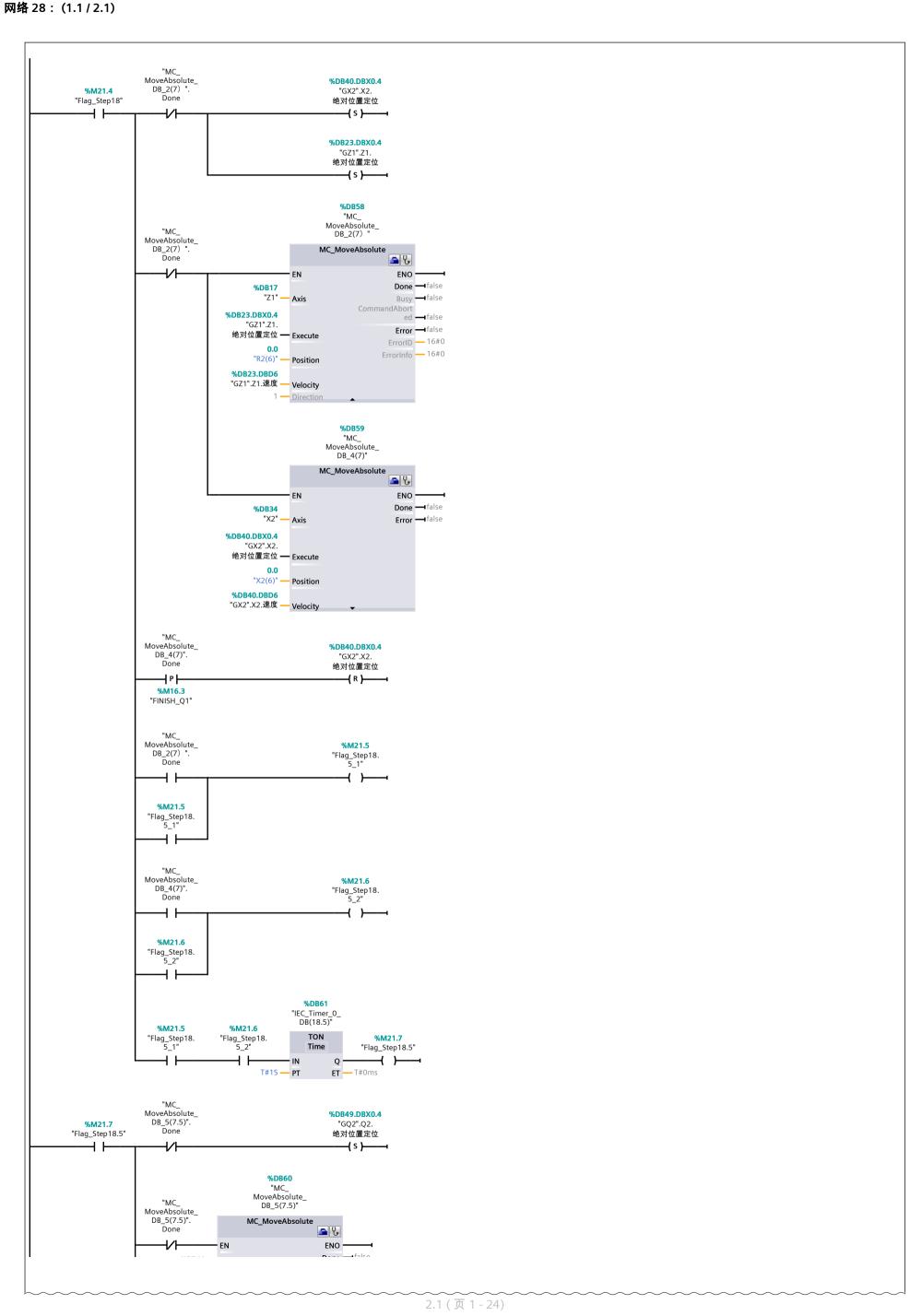
网络 26:



网络 27:



网络 28:



Totally Integrated **Automation Portal** 网络 28: (2.1 / 2.1) 1.1 (页 1 - 23) Done Tidise %DB42 "Q2" — Axis Error —false **%DB49.DBX0.4** "GQ2".Q2. 绝对位置定位 — Execute 0.0 "Z2(6)" — Position **%DB49.DBD6** "GQ2".Q2.速度 — Velocity "MC_ MoveAbsolute_ DB_5(7.5)". Done **%DB49.DBX0.4** "GQ2".Q2. 绝对位置定位 \dashv P \vdash —(R)— **%M16.3** "FINISH_Q1" **%DB62**"IEC_Timer_O_
DB(19)" "MC_ MoveAbsolute_ DB_5(7.5)". Done **%M22.0**"Flag_Step19"

网络 29:

