



























Default tag table [54]

PLC tags

| PLC tags | | | | | | | | | |
|----------------------------------------------------------------------------------------------------|-----------|---------|--------|------------------------------|----------------------------|-------------------------------|-------------|----------|--|
| Name | Data type | Address | Retain | Access-ible from HMI/O PC UA | Writa-ble from HMI/O PC UA | Visi-ble in HMI engi-neer-ing | Supervision | Comment | |
|  System_Byte | Byte | %MB1 | False | True | True | True | | | |
|  FirstScan | Bool | %M1.0 | False | True | True | True | | | |
|  DiagStatusUpdate | Bool | %M1.1 | False | True | True | True | | | |
|  AlwaysTRUE | Bool | %M1.2 | False | True | True | True | | | |
|  AlwaysFALSE | Bool | %M1.3 | False | True | True | True | | | |
|  s1 | Bool | %I0.0 | False | True | True | True | | | |
|  s2 | Bool | %I0.1 | False | True | True | True | | | |
|  s5_up | Bool | %I0.2 | False | True | True | True | | | |
|  s6_down | Bool | %I0.3 | False | True | True | True | | | |
|  s7_L | Bool | %I0.4 | False | True | True | True | | | |
|  s8_R | Bool | %I0.5 | False | True | True | True | | | |
|  m1 | Bool | %Q0.0 | False | True | True | True | | | |
|  m2a_mov_up | Bool | %Q0.1 | False | True | True | True | | mov_up | |
|  m2b_mov_down | Bool | %Q0.2 | False | True | True | True | | mov_down | |
|  m3a_mov_L | Bool | %Q0.3 | False | True | True | True | | | |
|  m3b_mov_R | Bool | %Q0.4 | False | True | True | True | | | |
|  EM | Bool | %Q0.5 | False | True | True | True | | | |
|  state1 | Bool | %M10.0 | False | True | True | True | | | |
|  state2 | Bool | %M10.1 | False | True | True | True | | | |
|  state3 | Bool | %M10.2 | False | True | True | True | | | |
|  state4 | Bool | %M10.3 | False | True | True | True | | | |
|  state5 | Bool | %M10.4 | False | True | True | True | | | |
|  state6 | Bool | %M10.5 | False | True | True | True | | | |
|  state7 | Bool | %M10.6 | False | True | True | True | | | |
|  state8 | Bool | %M10.7 | False | True | True | True | | | |
|  state9 | Bool | %M11.0 | False | True | True | True | | | |

Main [OB1]

Main Properties

General

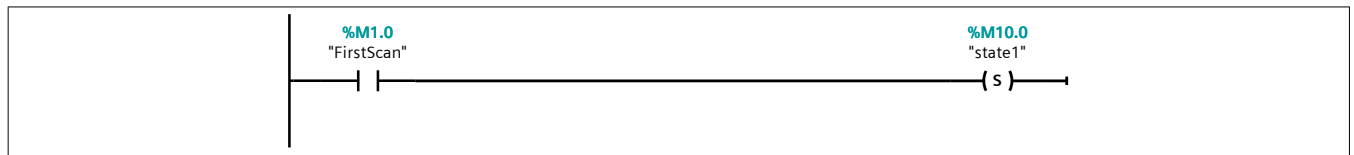
| | | | | | |
|-----------------|------|------------------|-----------|-------------|----|
| Name | Main | Number | 1 | Type | OB |
| Language | LAD | Numbering | Automatic | | |

Information

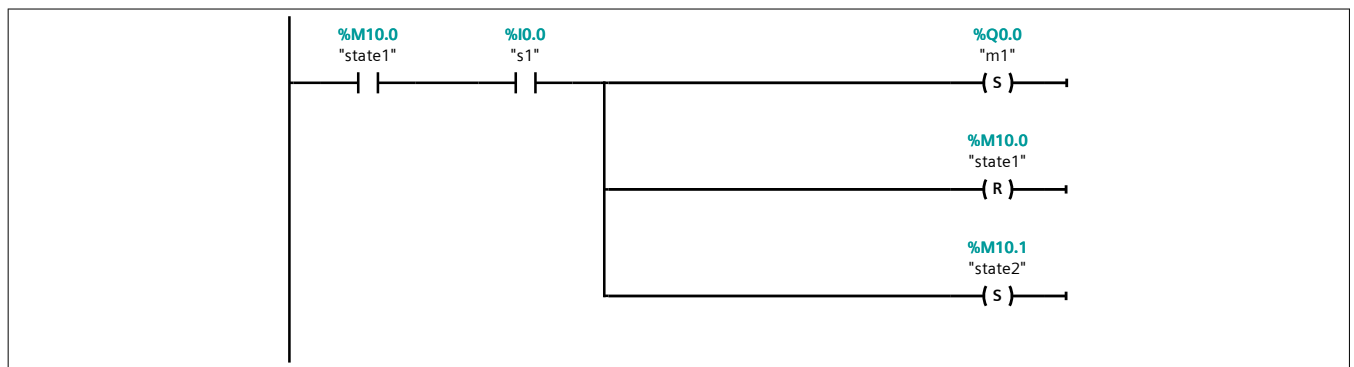
| | | | | | |
|---------------|------------------------------|----------------|-----|------------------------|--|
| Title | "Main Program Sweep (Cycle)" | Author | | Comment | |
| Family | | Version | 0.1 | User-defined ID | |

| Name | Data type | Default value | Supervision | Comment |
|--------------|-----------|---------------|-------------|---------------------------------------|
| ▼ Input | | | | |
| Initial_Call | Bool | | | Initial call of this OB |
| Remanence | Bool | | | =True, if remanent data are available |
| Temp | | | | |
| Constant | | | | |

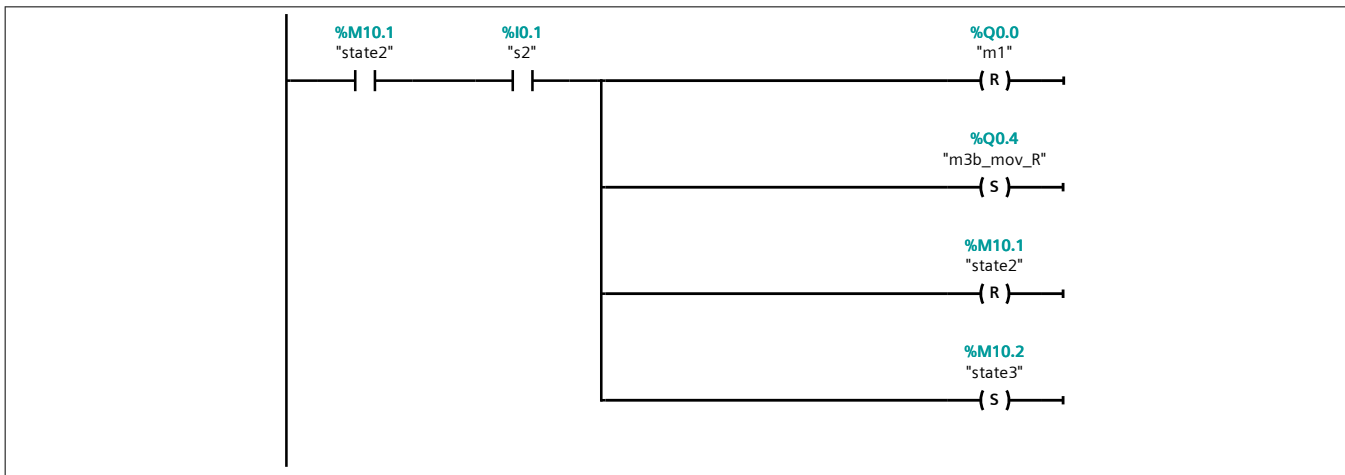
Network 1:



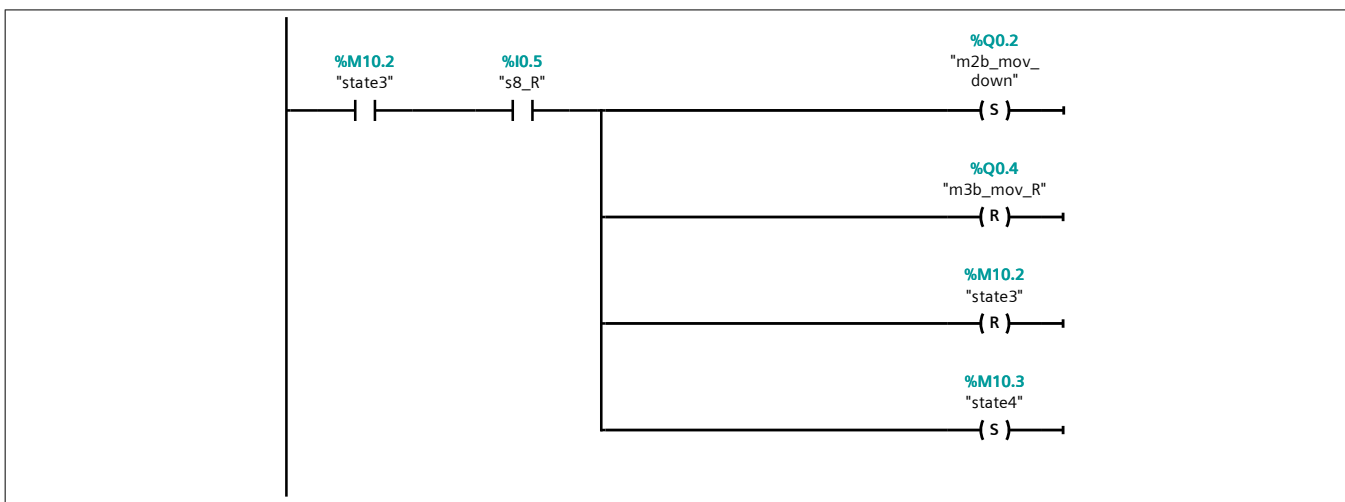
Network 2: conveyer on



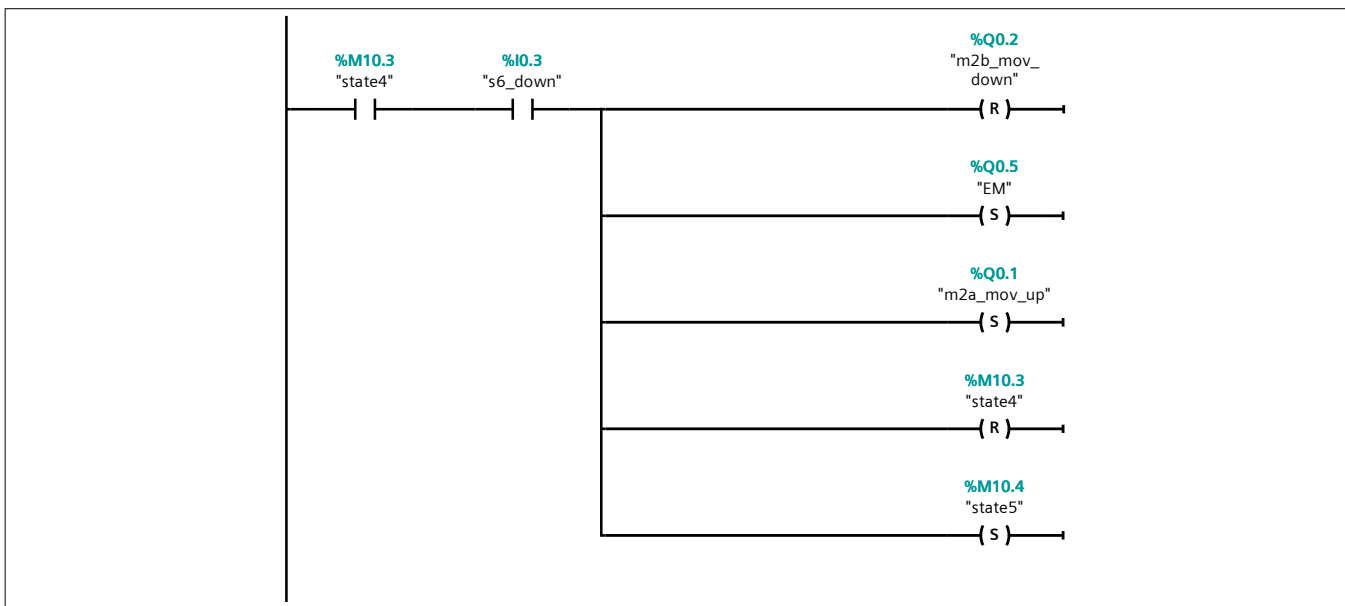
Network 3: move to Right



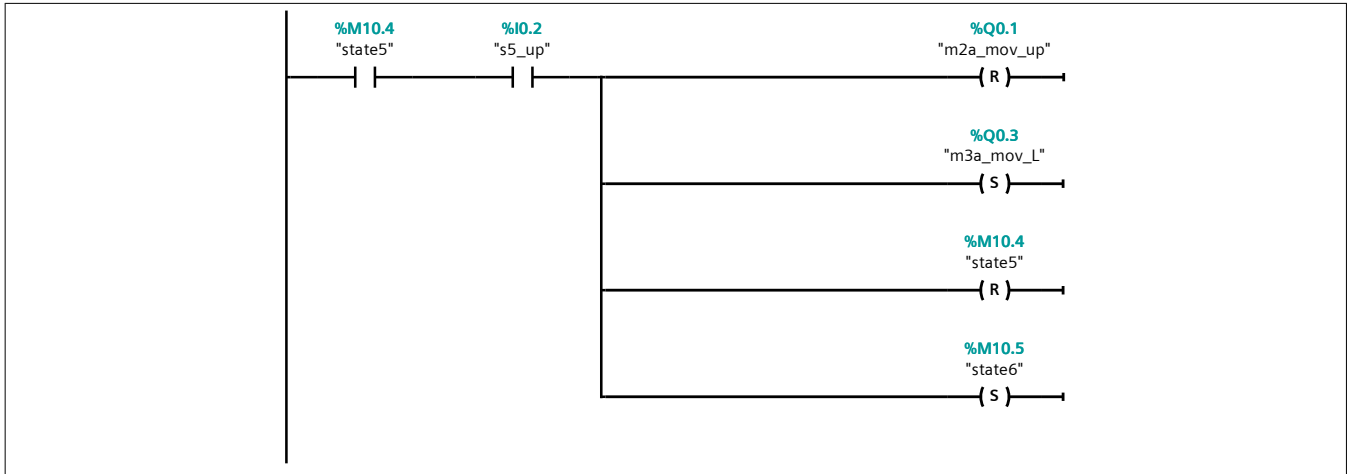
Network 4: move down



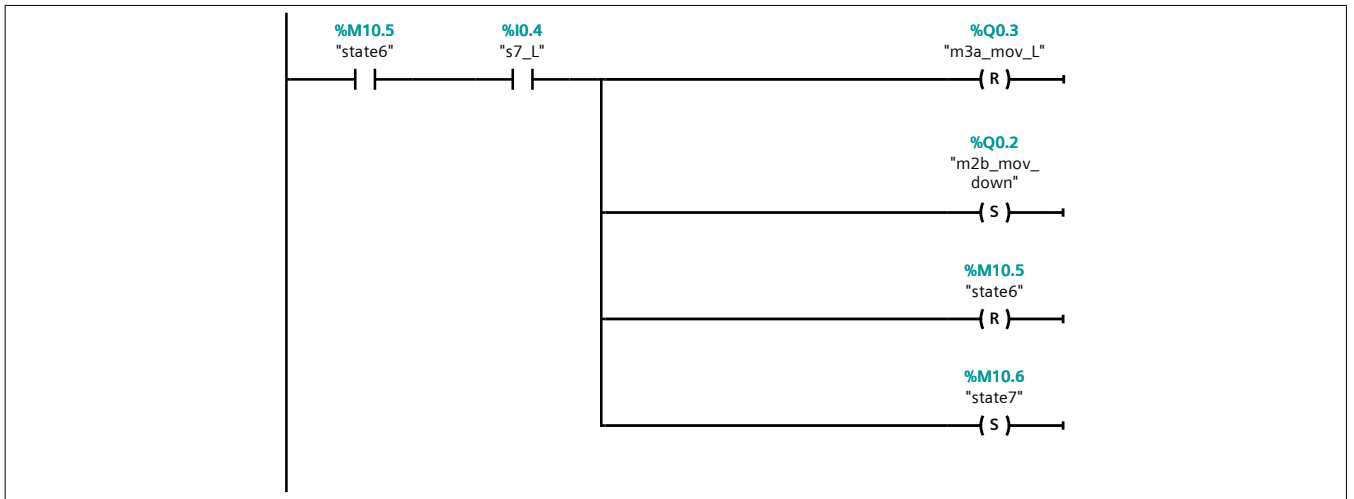
Network 5: move up and EM on



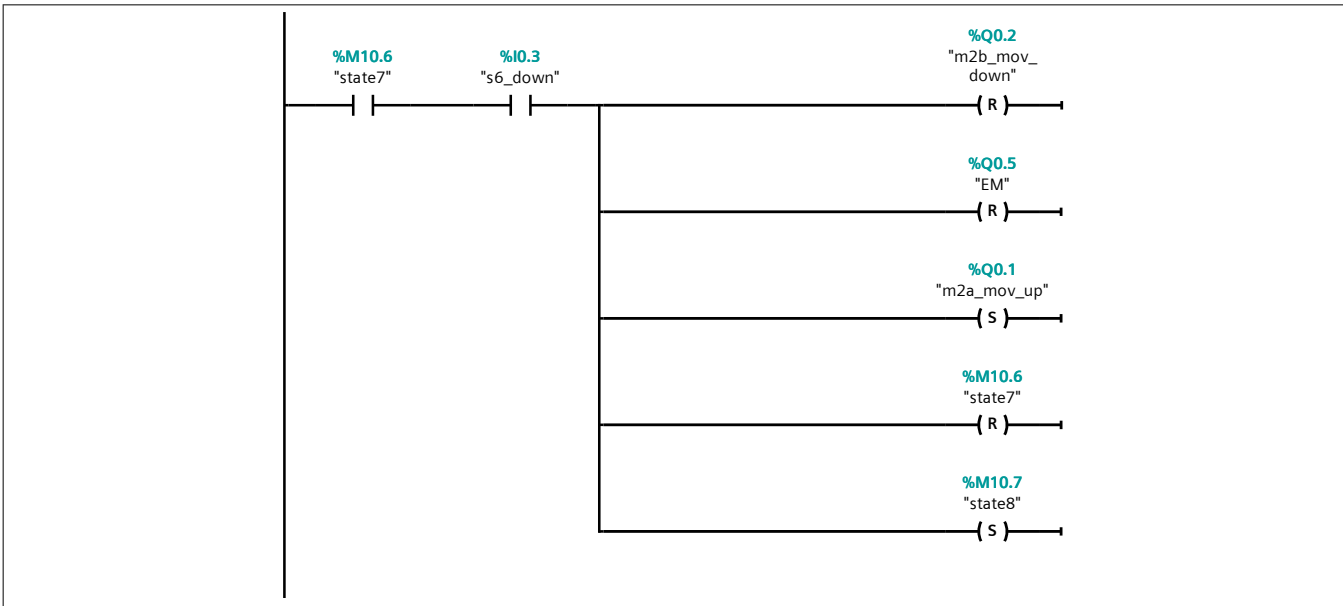
Network 6: mov_up



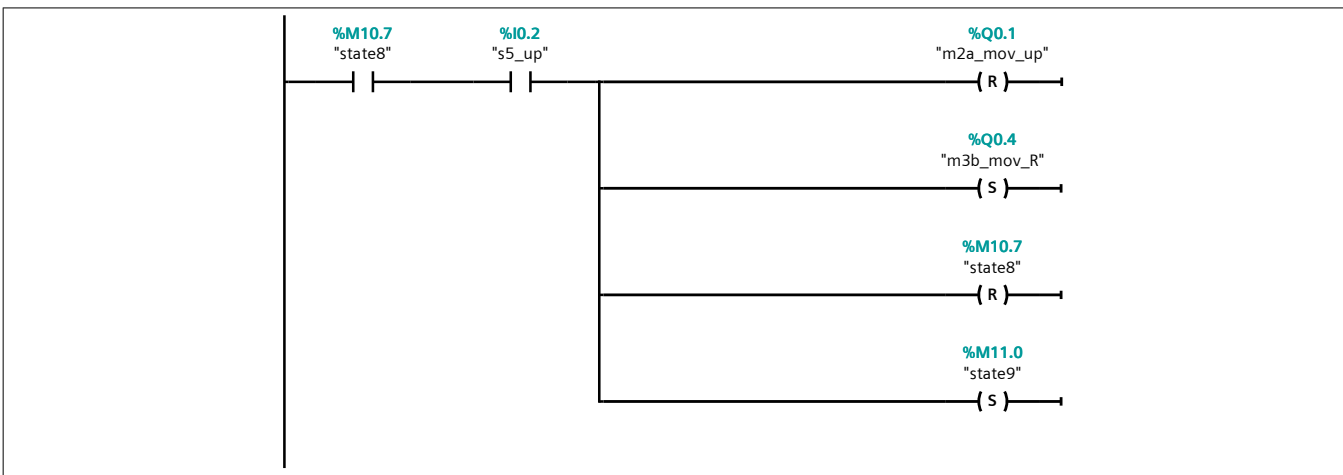
Network 7:



Network 8: mov_down



Network 9: mov_up



Network 10:

