

1	O	"Auto_mode"	%M0.0
2	A	#Large_box	
3	=	#Lbox_passed	
4	JC	LBOX	
5			
6	O	"Auto_mode"	%M0.0
7	A	#Small_box	
8	=	#Sbox_passed	
9	JC	SBOX	
10			
11	LBOX:	CALL RESET_TIMER	
12		IEC_TIMER	
13		TIMER := "timerA_DB"	%DB1
14			
15		CALL TP , "timerA_DB"	%DB1
16		Time	
17		IN := #Lbox_passed	
18		PT := T#5s	T#5s
19		Q := "Motor1"	%Q0.0
20		ET :=	
21			
22		BE	
23			
24	SBOX:	CALL RESET_TIMER	
25		IEC_TIMER	
26		TIMER := "timerB_DB"	%DB2
27			
28		CALL TP , "timerB_DB"	%DB2
29		Time	
30		IN := #Lbox_passed	
31		PT := T#5s	T#5s
32		Q := "Motor1"	%Q0.0
33		ET :=	
34			
35		CALL RESET_TIMER	
36		IEC_TIMER	
37		TIMER := "timerC_DB"	%DB3
38			
39		CALL TON , "timerC_DB"	%DB3
40		Time	
41		IN := #Lbox_passed	
42		PT := T#5s	T#5s
43		Q := "valve_motor"	%M0.1
44		ET :=	
45			
46	O	"valve_motor"	%M0.1
47	=	"Solenoid_valve"	%Q0.1
48			
49		CALL RESET_TIMER	
50		IEC_TIMER	
51		TIMER := "timerD_DB"	%DB4
52			
53		CALL TP , "timerD_DB"	%DB4
54		Time	
55		IN := "Solenoid_valve"	%Q0.1
56		PT := T#5s	T#5s
57		Q := "Motor2"	%Q0.2
58		ET :=	
59			
60		BE	

Statement List Programming Plcs

RJ Shavelson



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