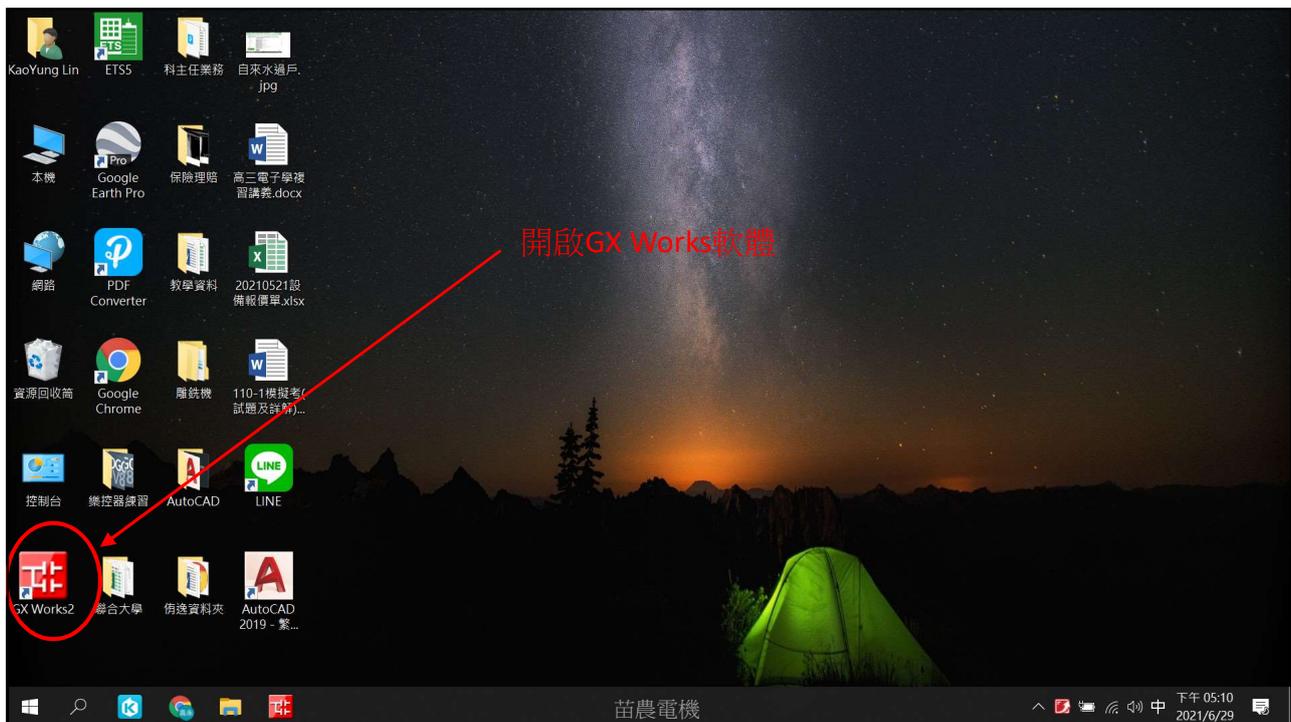
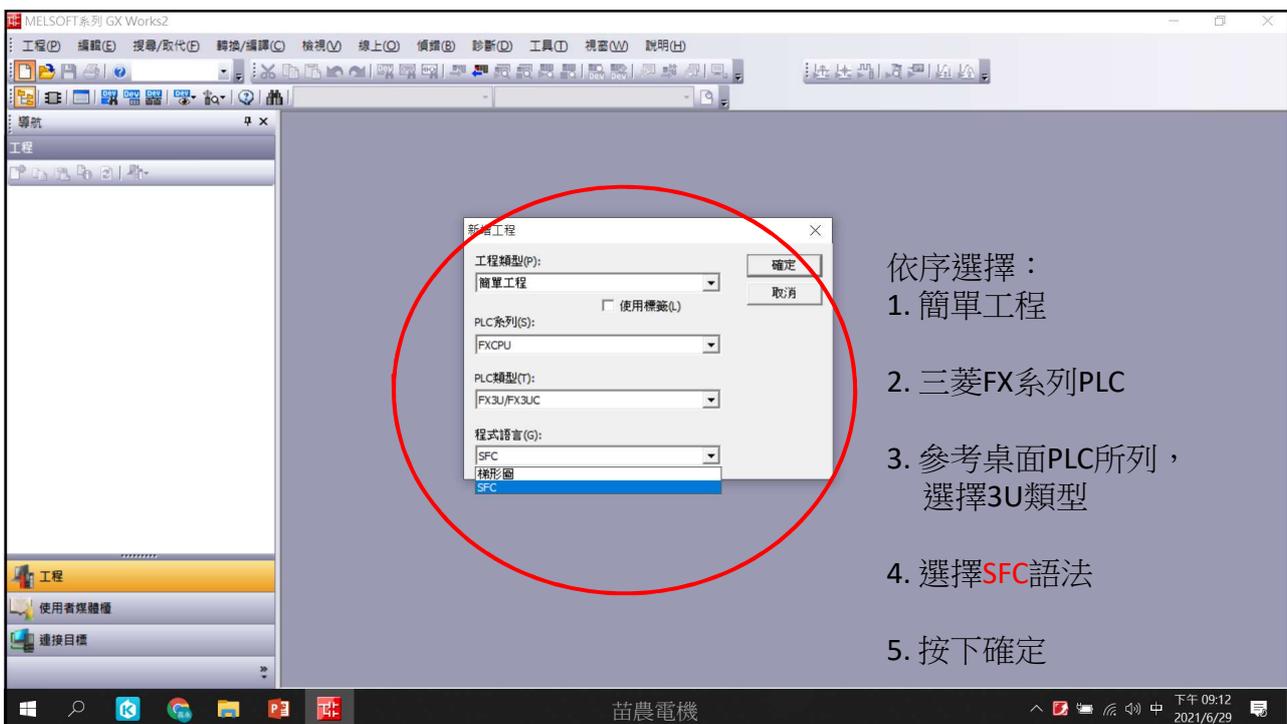
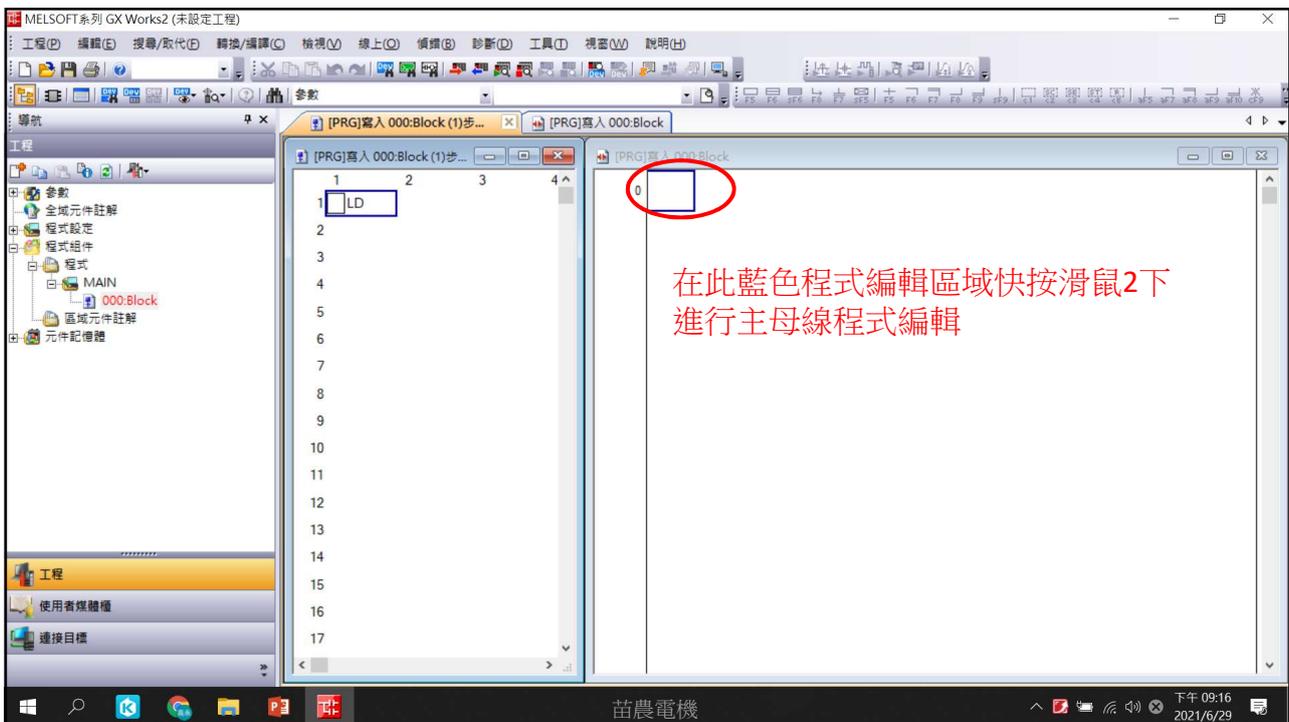
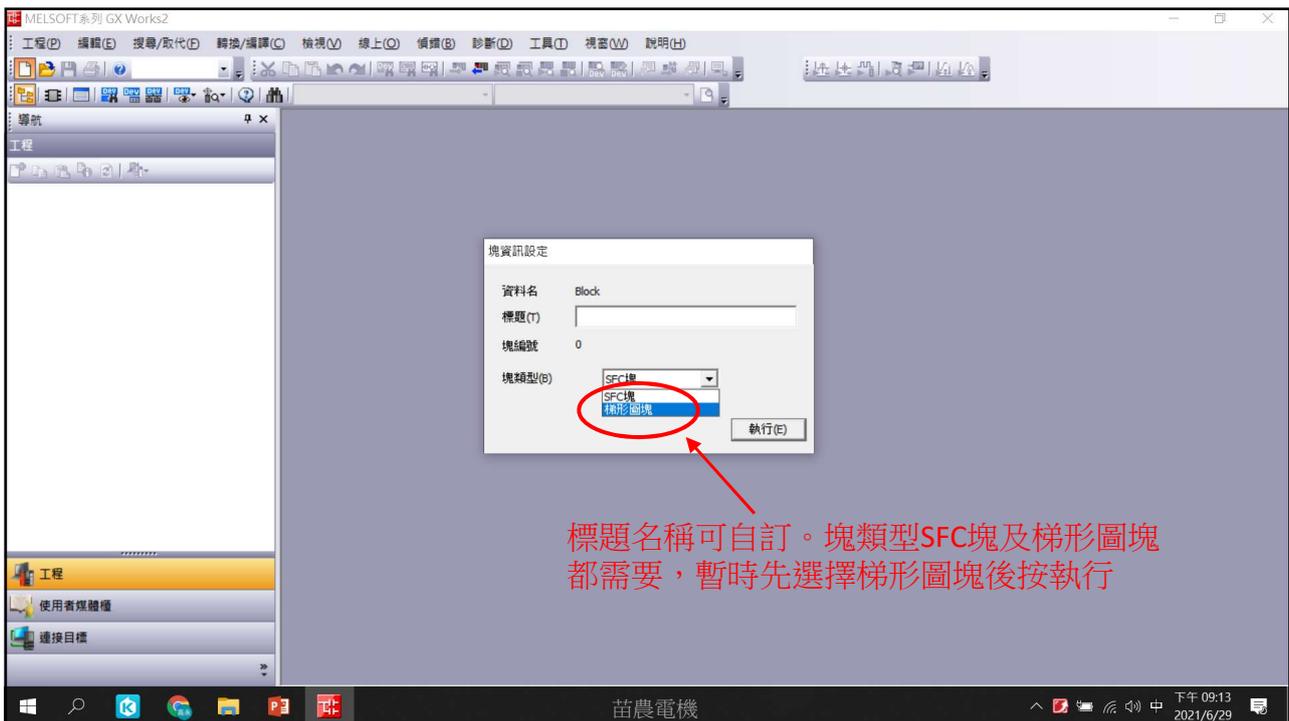


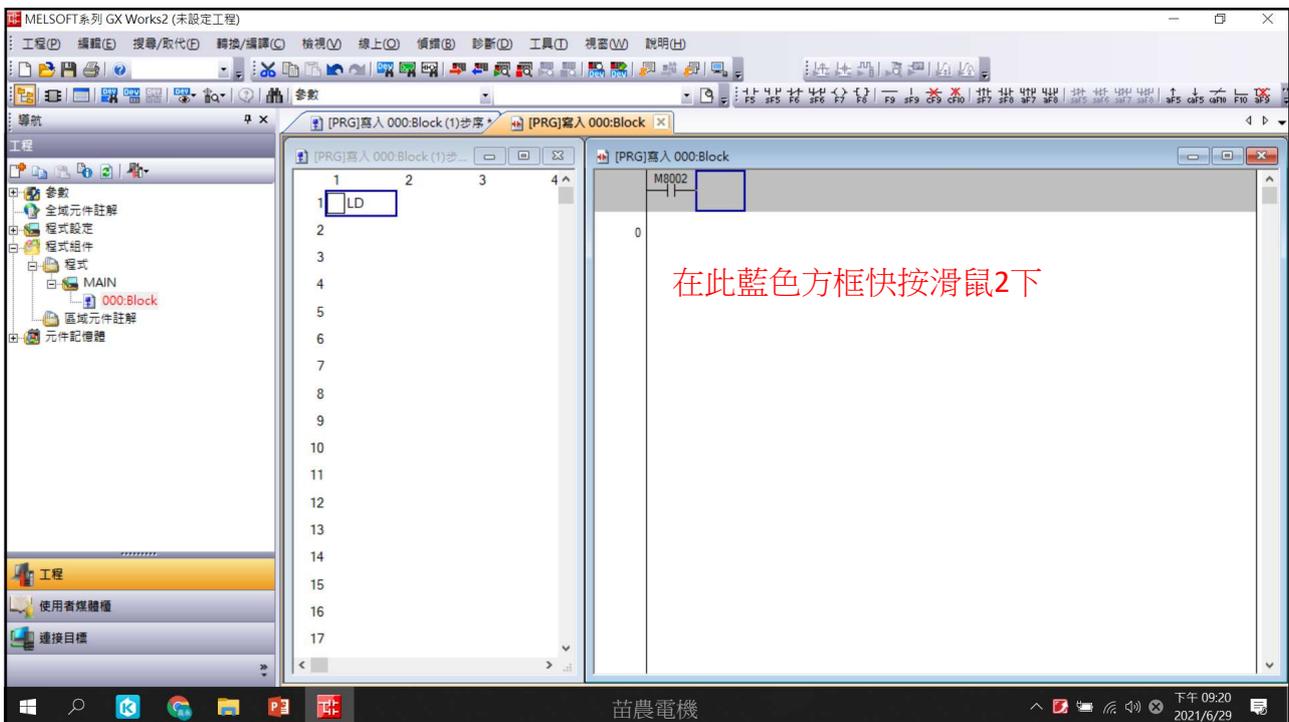
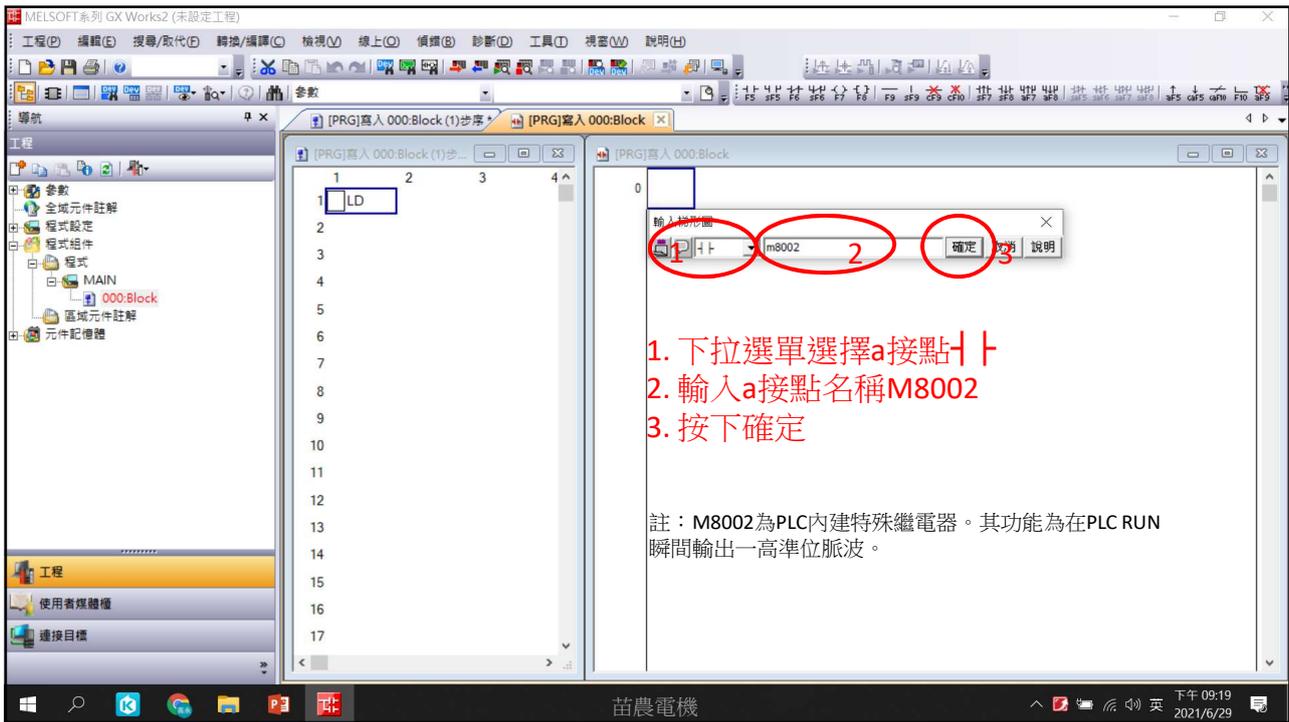
利用SFC語法完成下列功能

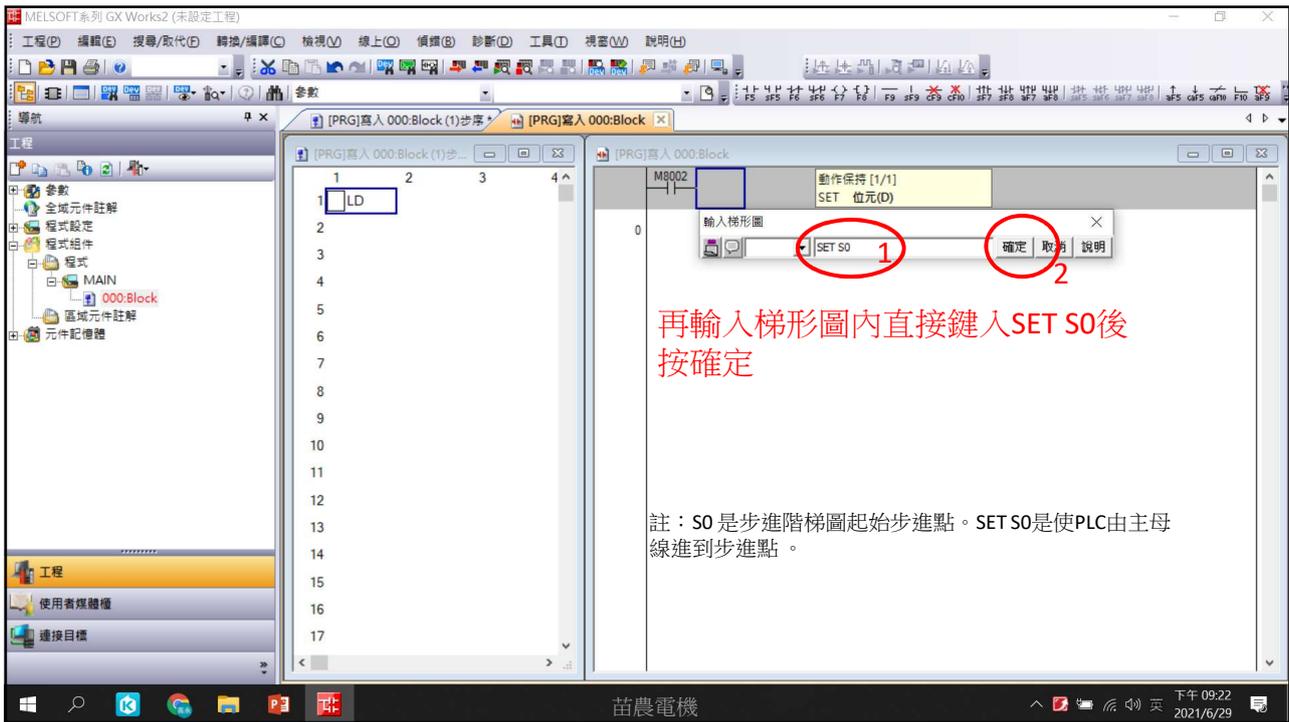
按下啟動，輸送帶動作1秒後停0.5秒，反覆執行。
直到按下停止時，輸送帶停止動作。





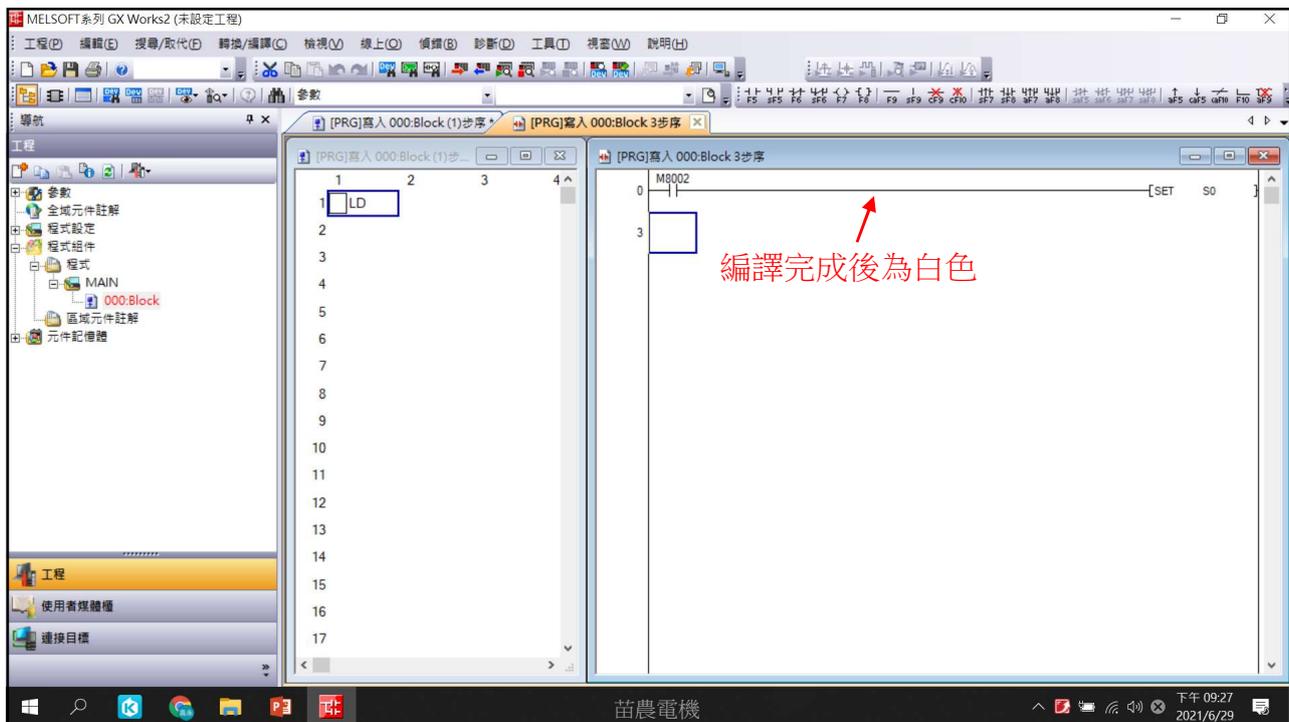
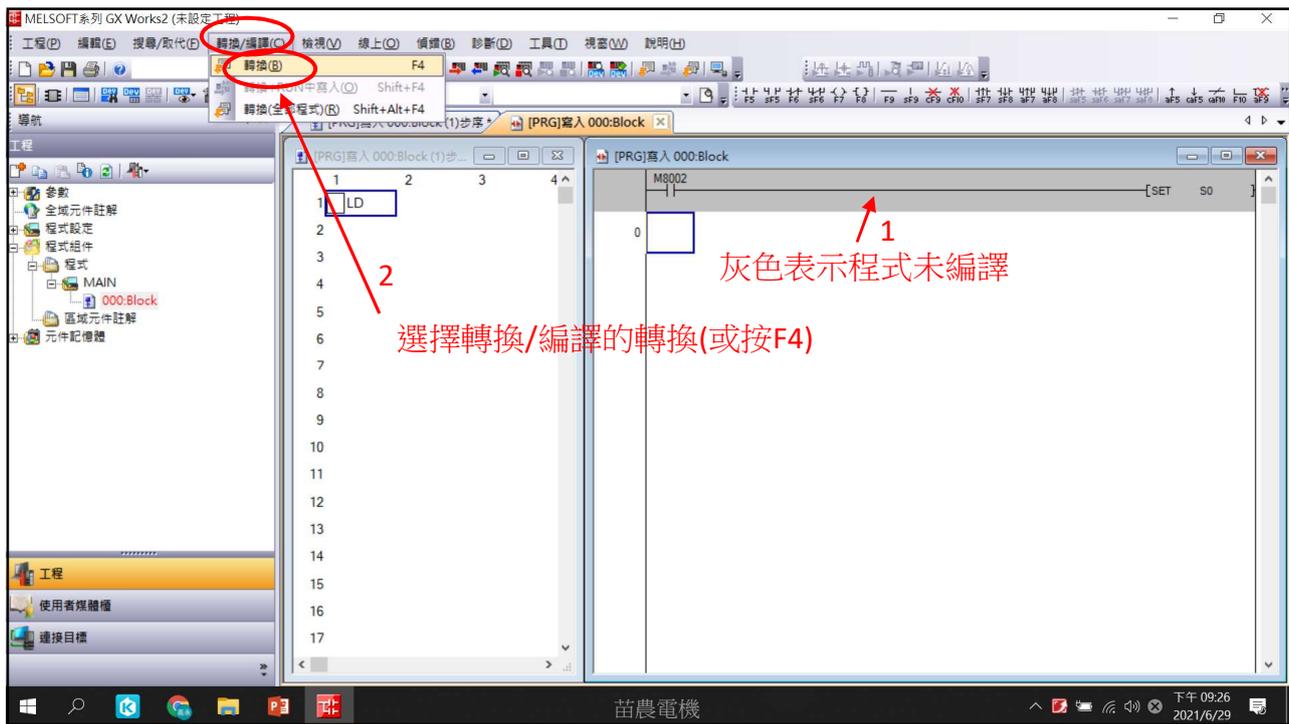


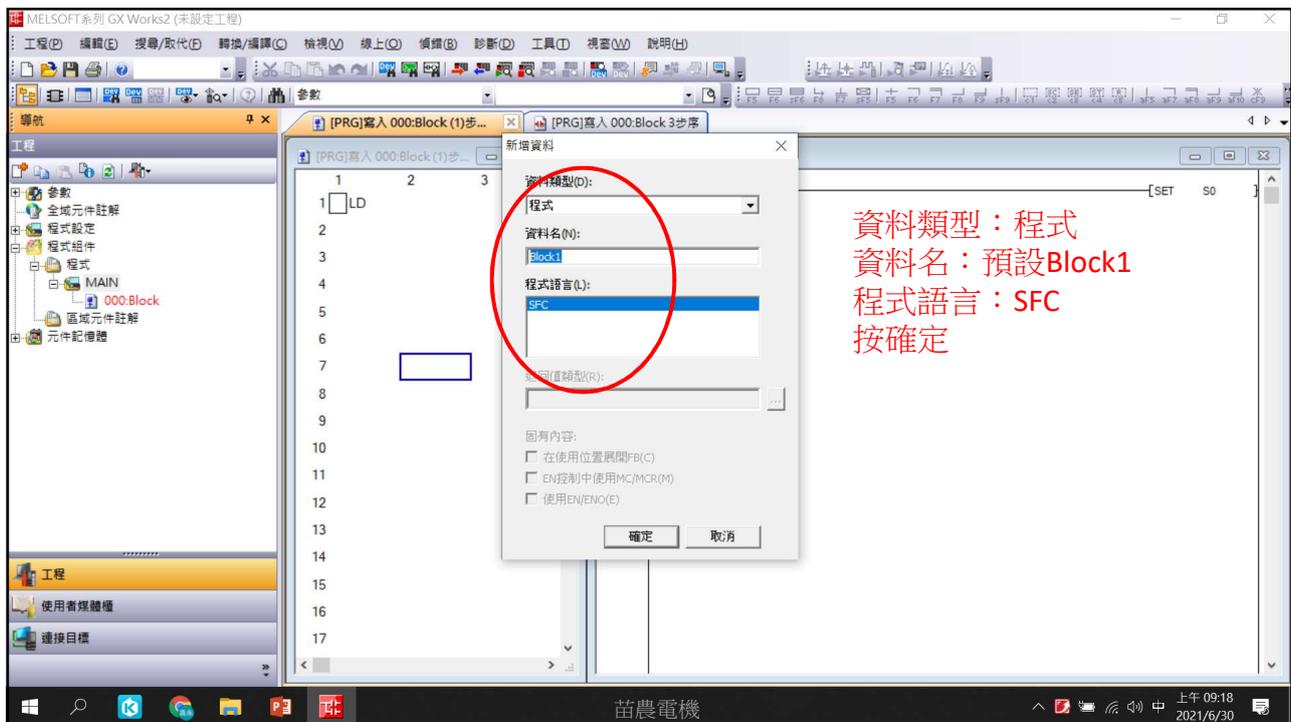
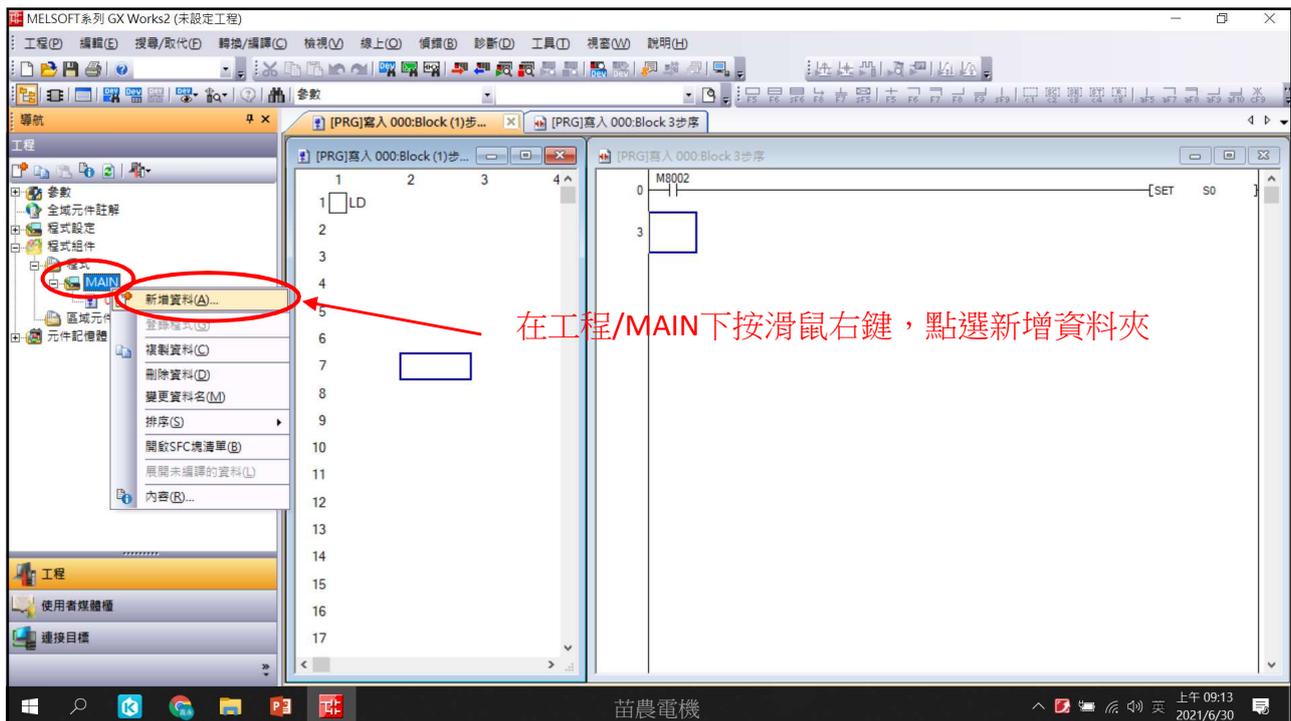


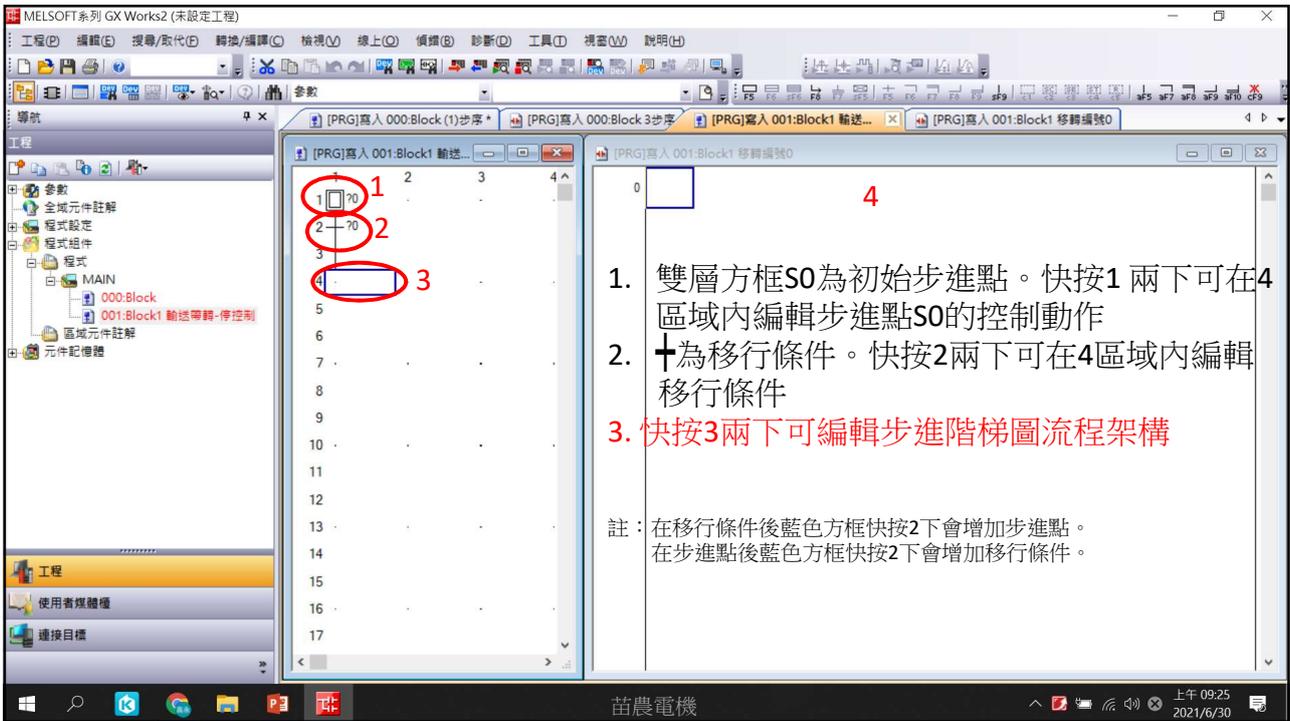
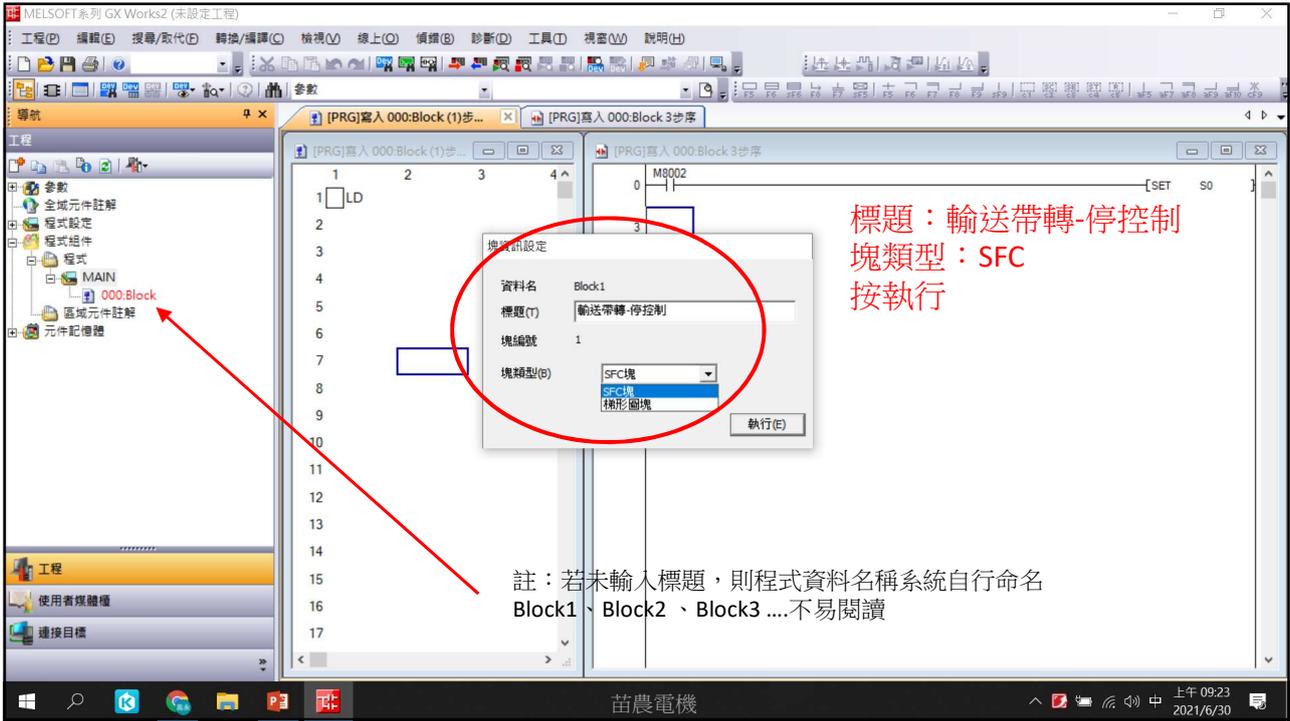


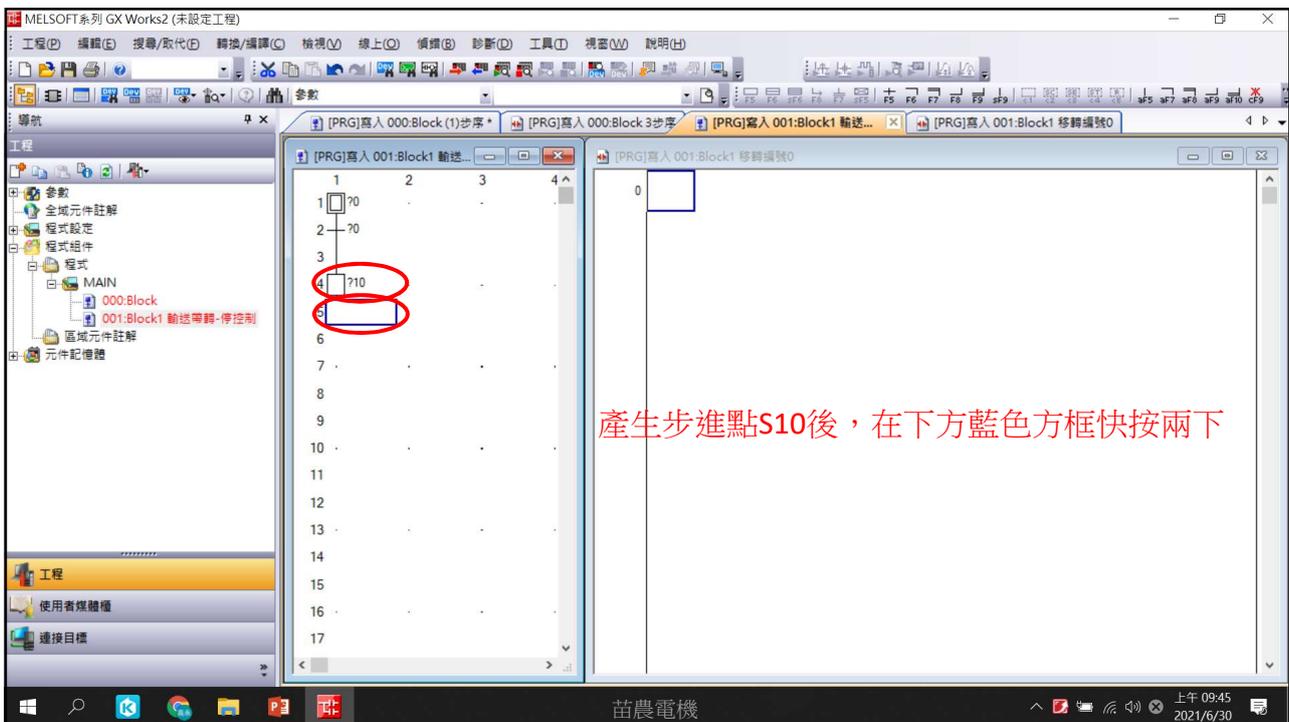
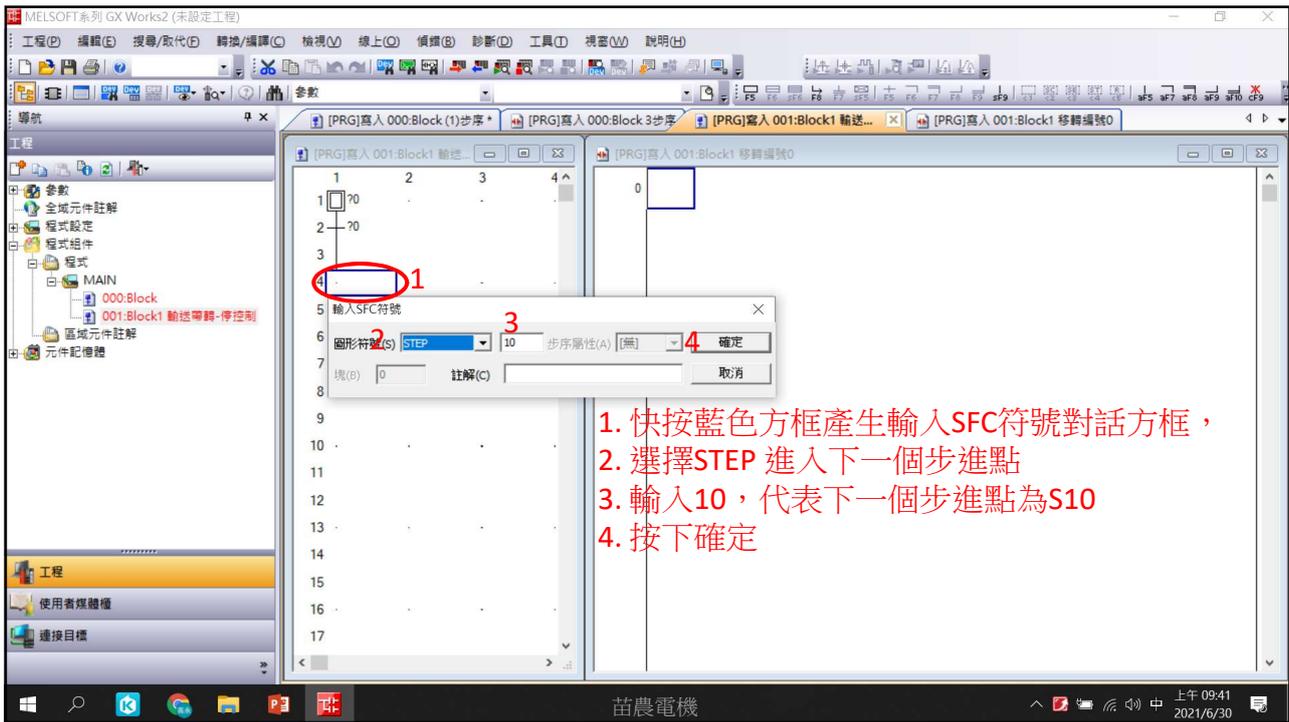
步進點編號及功能

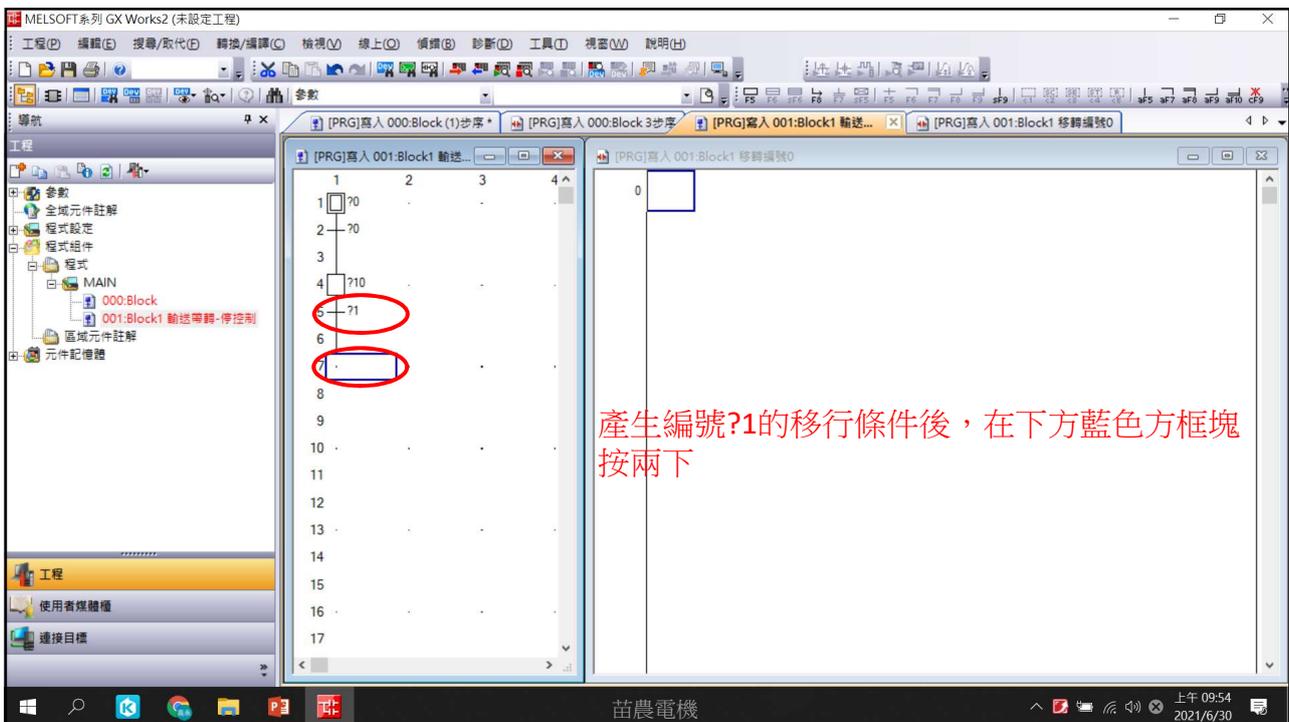
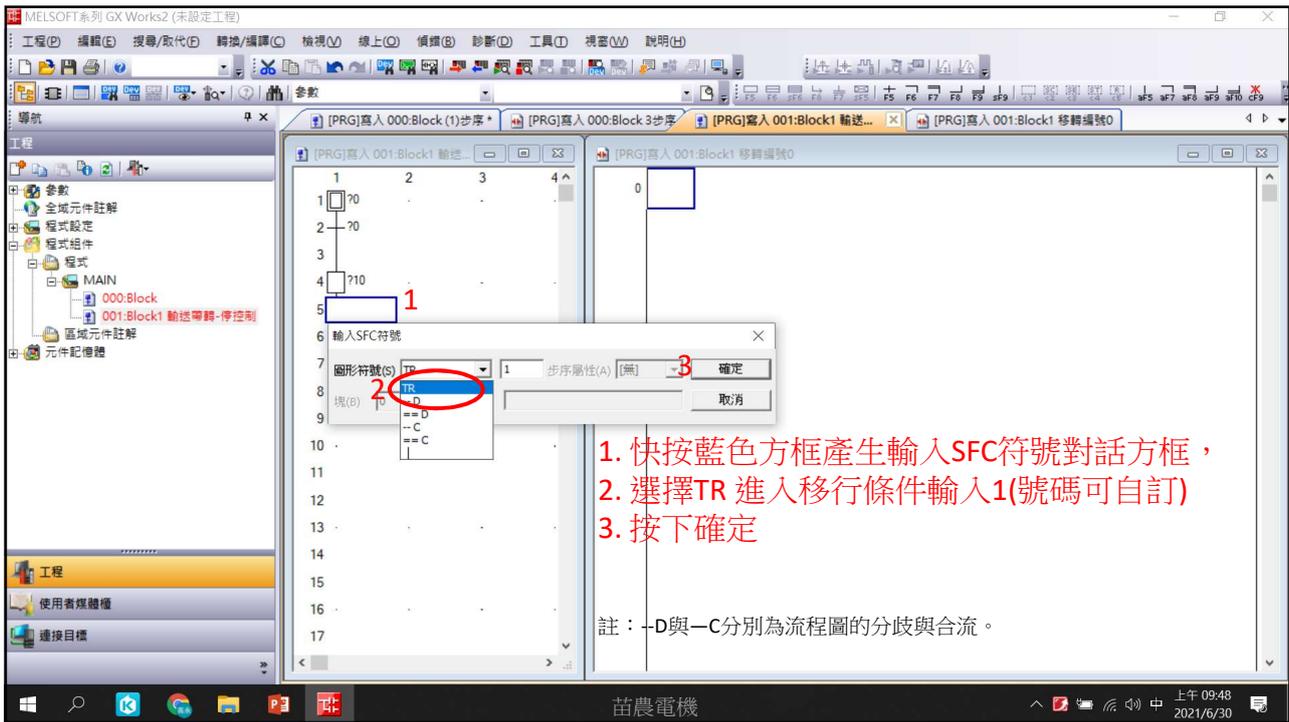
- 1. 初始狀態用：S0~S9
- 2. 原點復歸用：S10~S19
- 3. 一般用：S20~S499
- 4. 停電保持用：S500~S899
- 5. 警報用：S900~S999

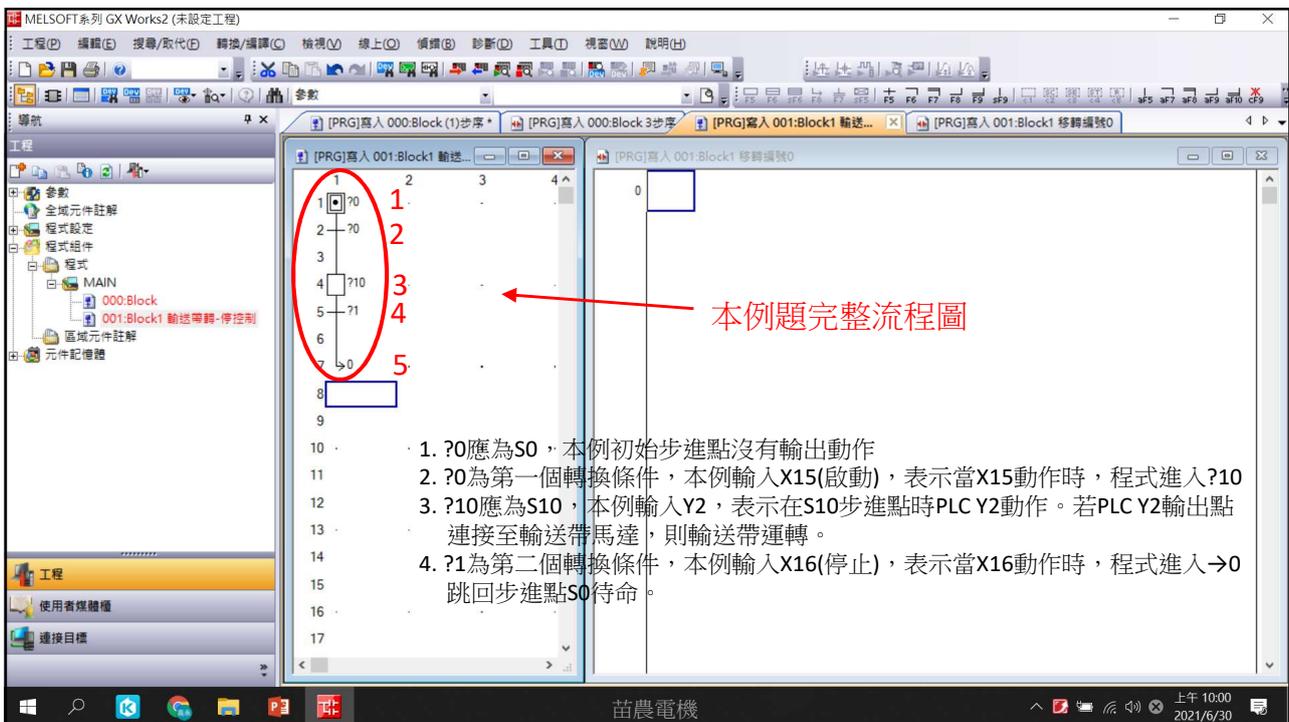
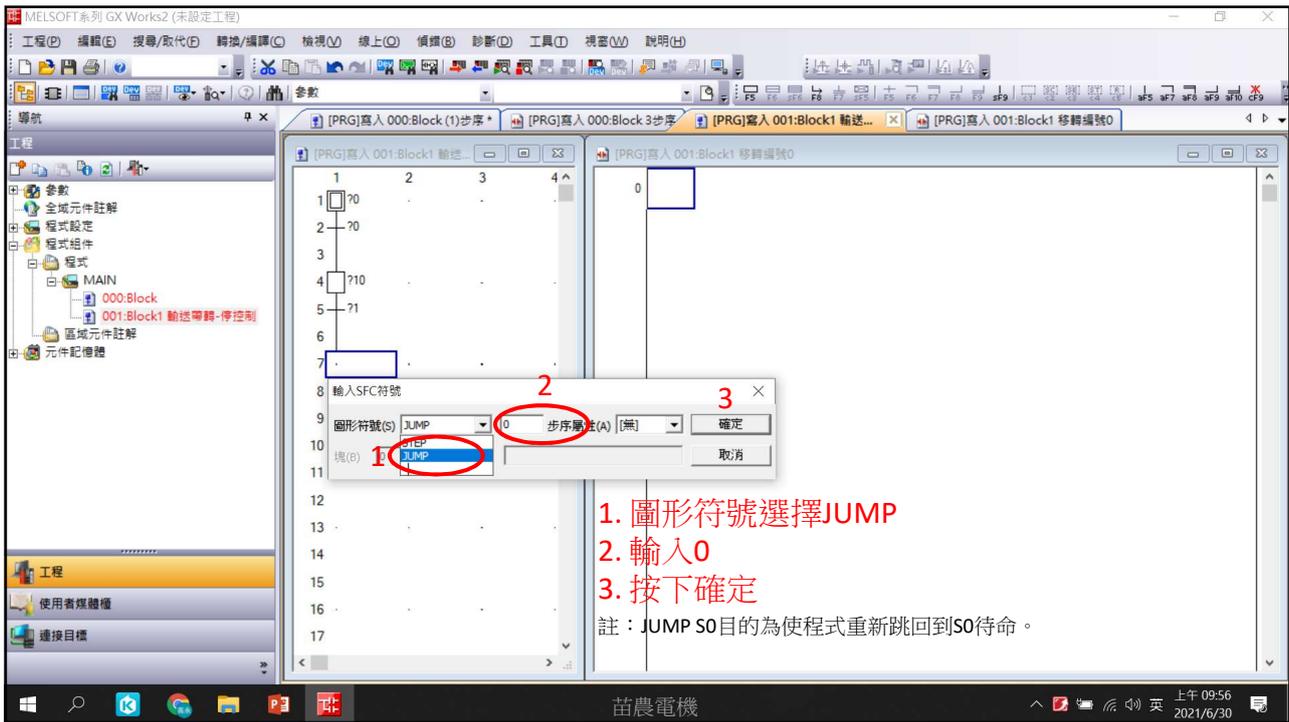












- 準備編輯各步進點內控制動作及各移行條件程式

苗農電機

1. 藍色方框在S0時在2. 快按2下即可進行步進S0的程式編輯

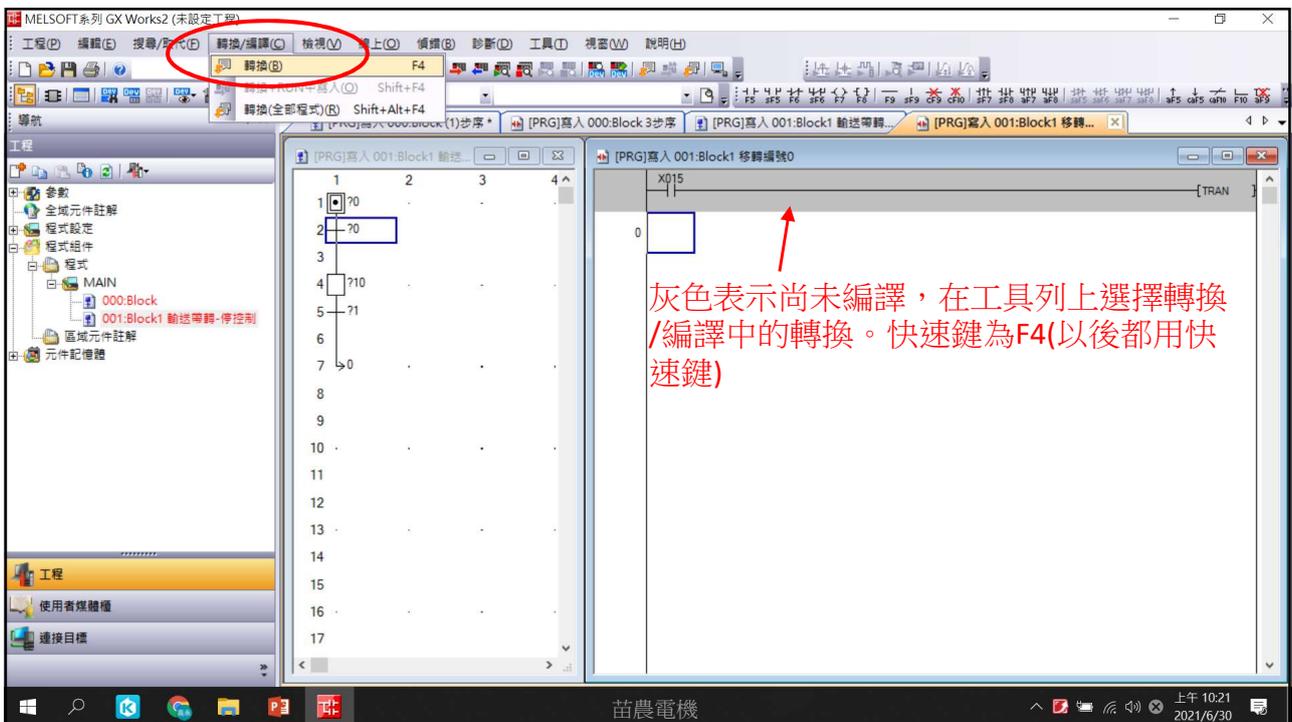
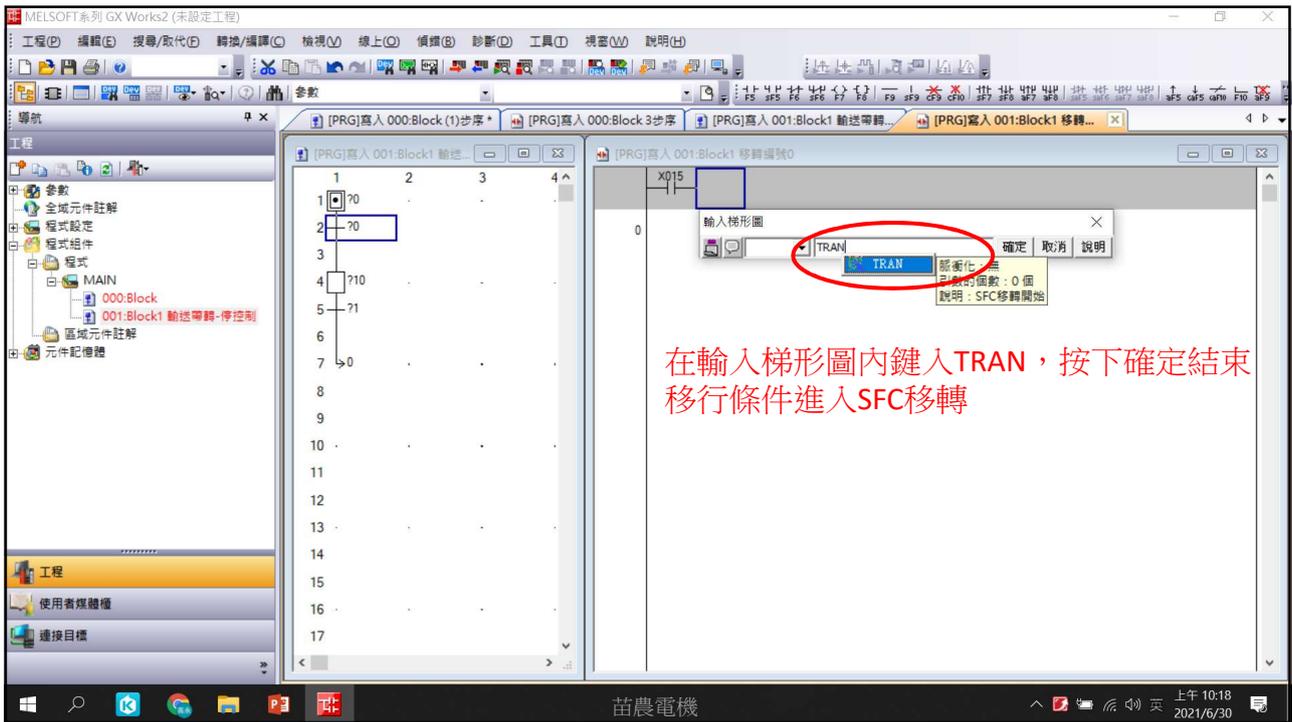
本例題S0為輸送帶停止，故無需輸入程式選擇取消

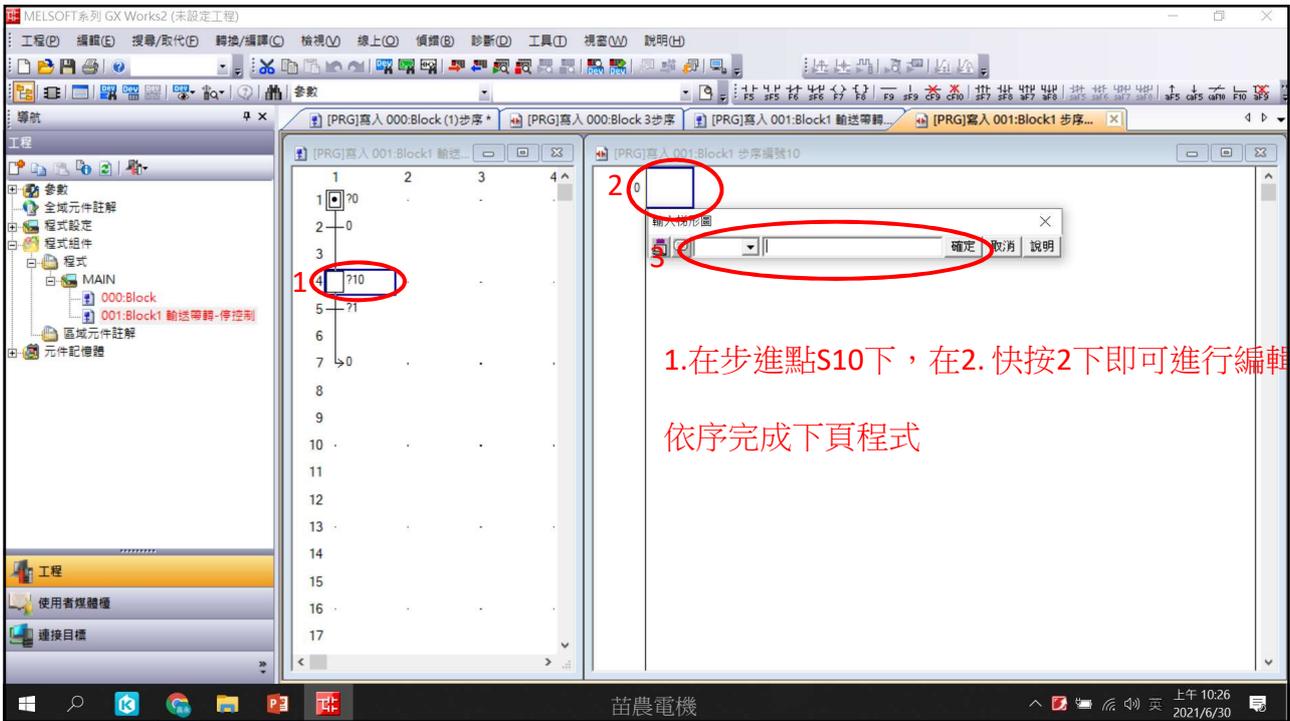
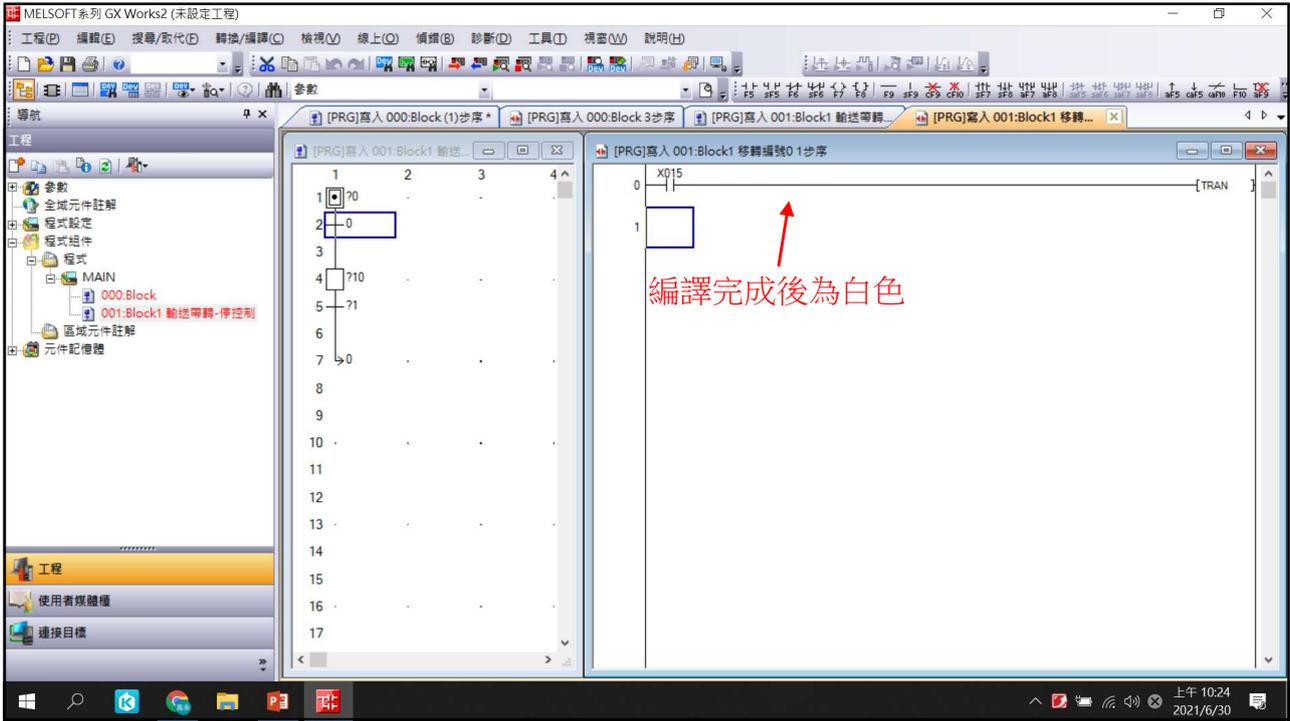
苗農電機

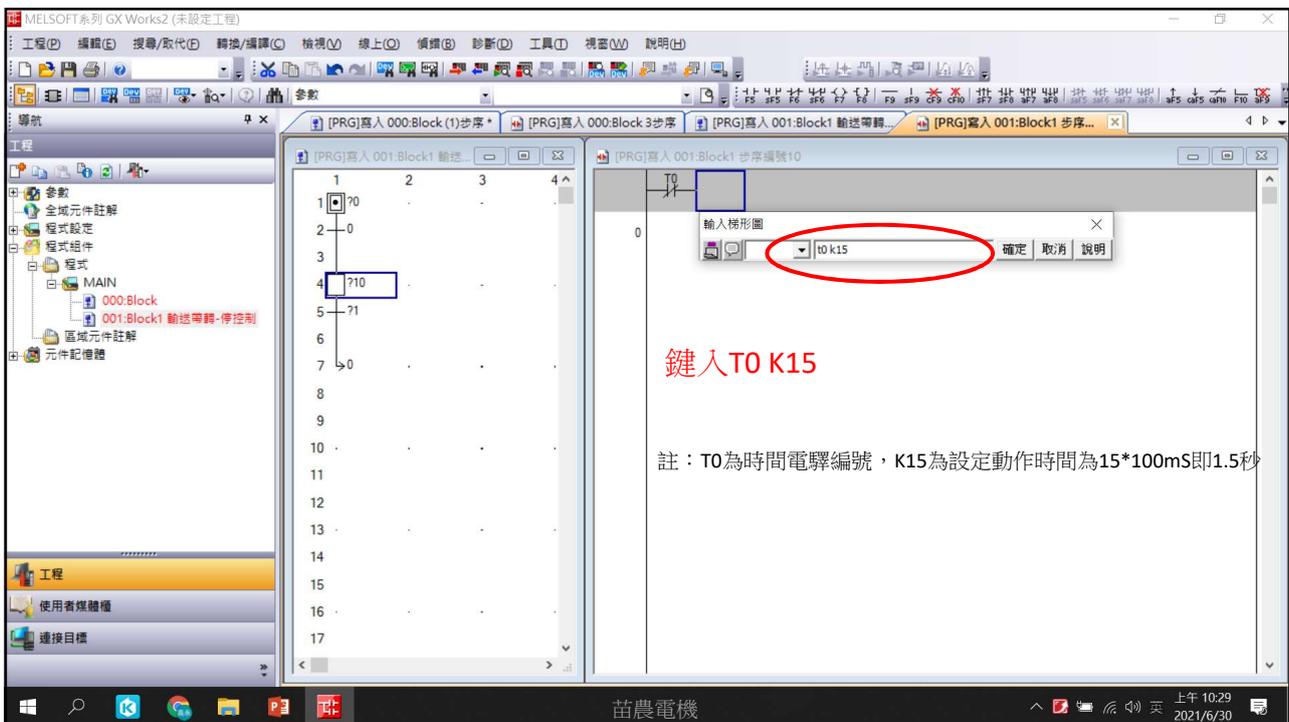
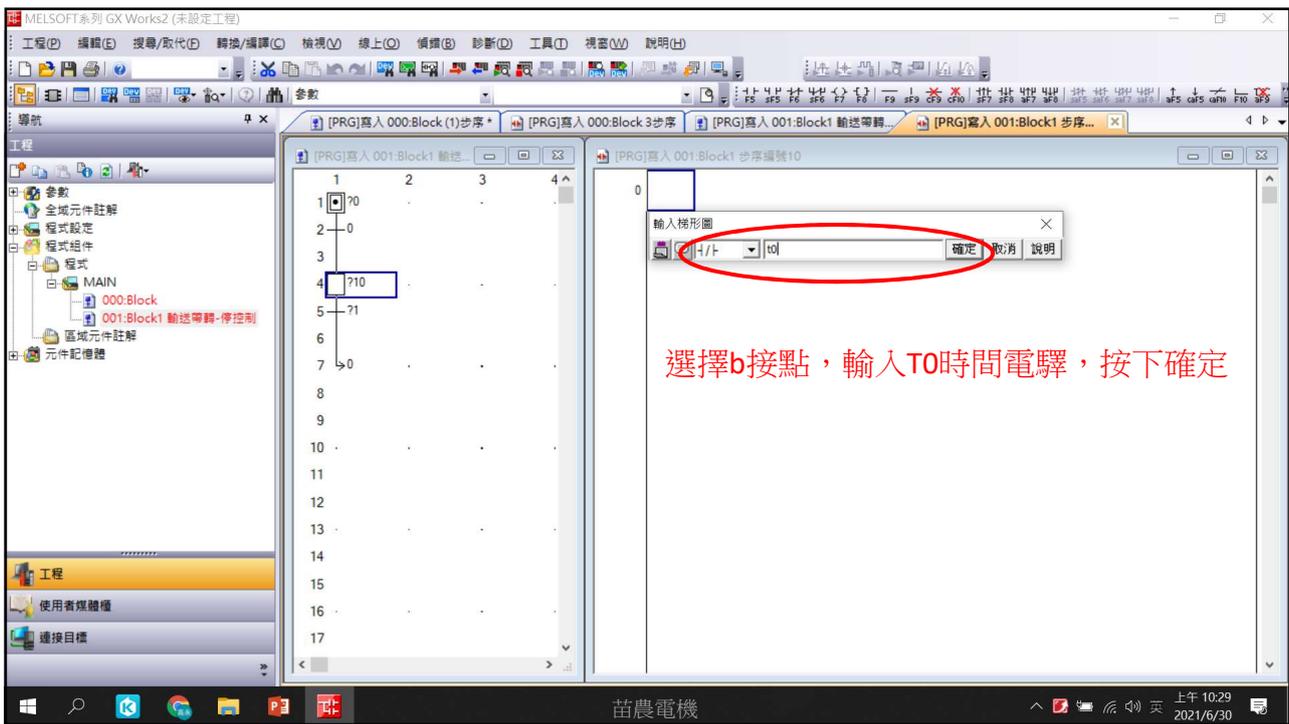
上午 10:07
2021/6/30

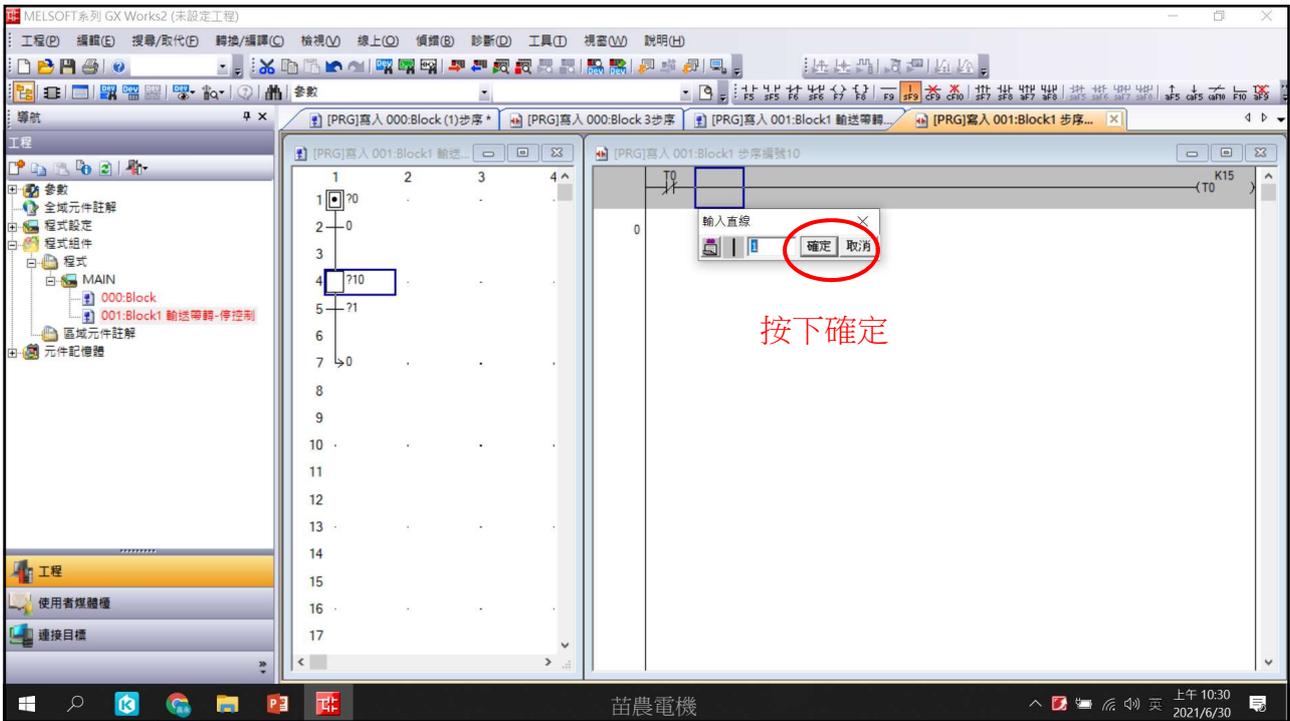
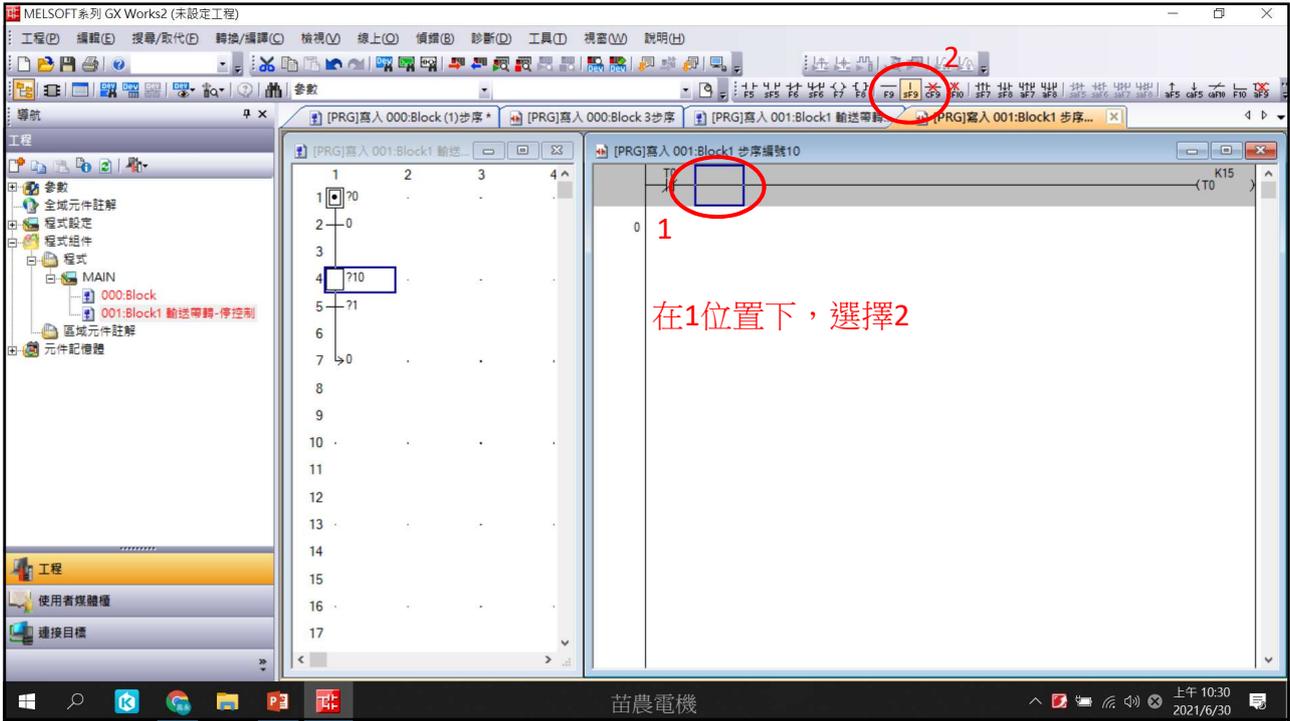
1. 在編號?0移行條件下，在2. 快按2下即可進行編輯
輸入梯形圖內選擇a接點，鍵入X15，按下確定

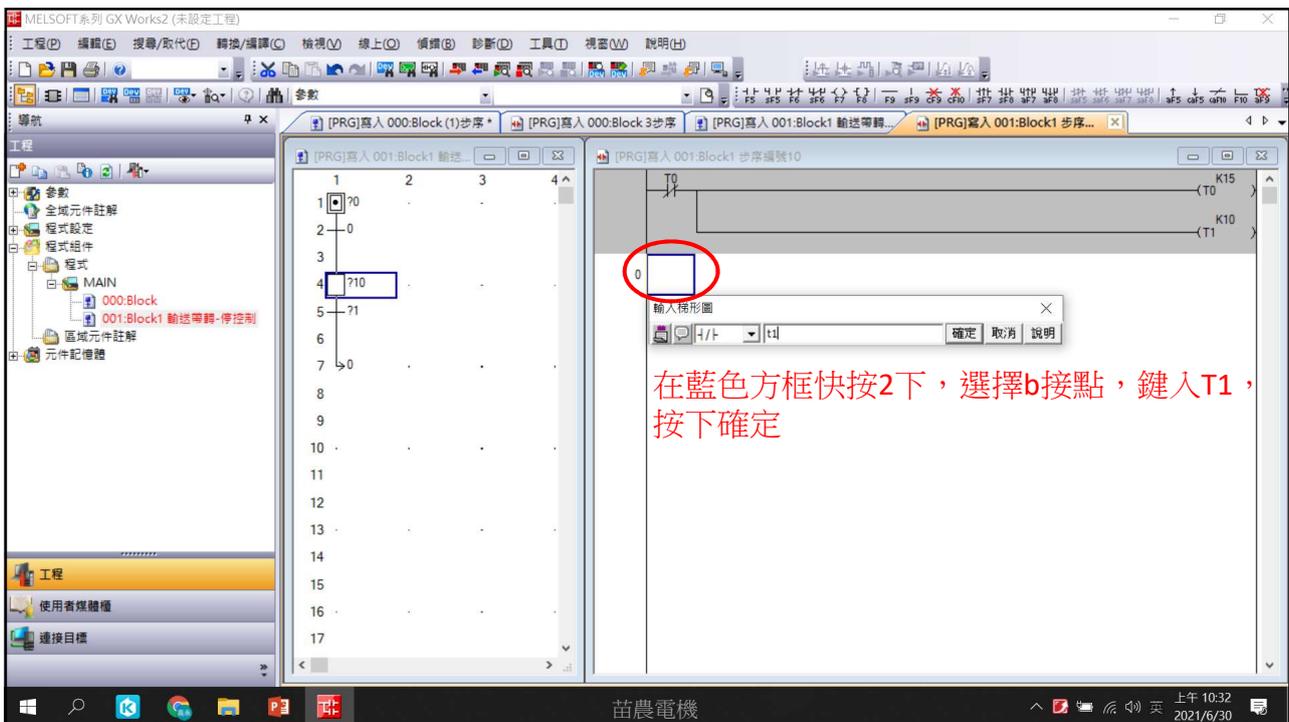
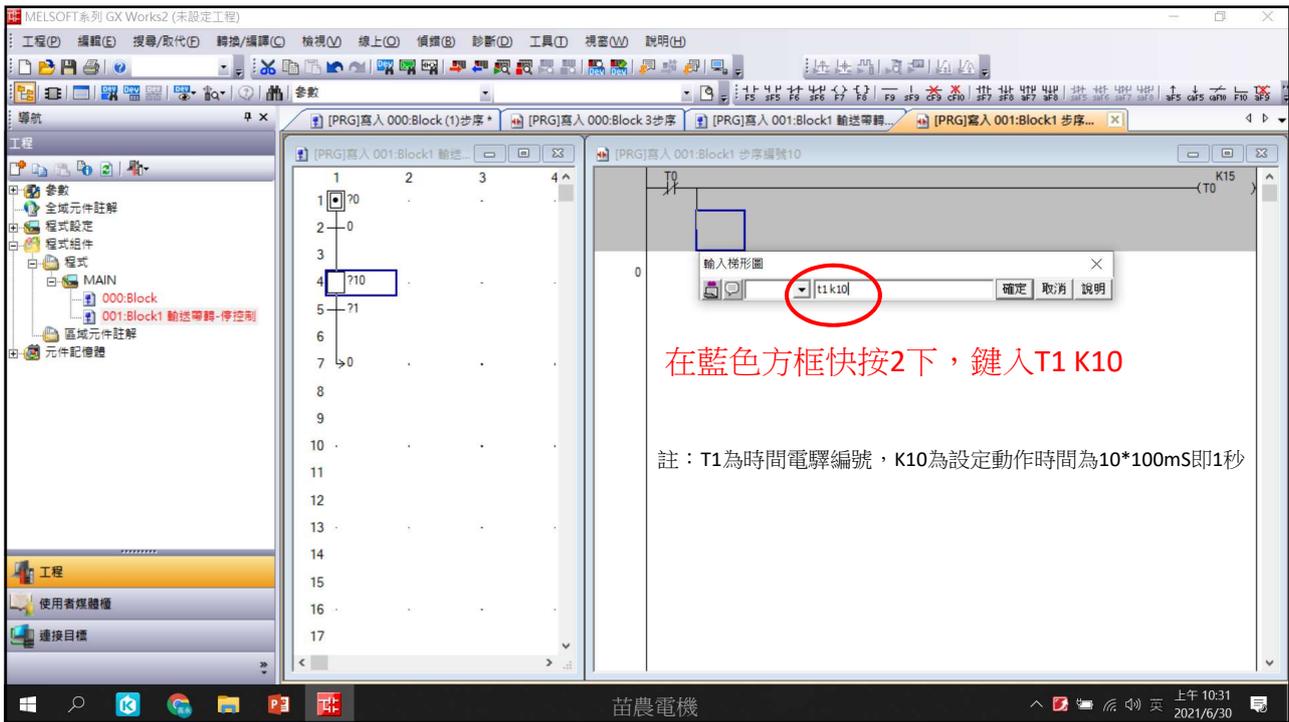
產生X15接點後在藍色方框快按2下進行下一步驟編輯

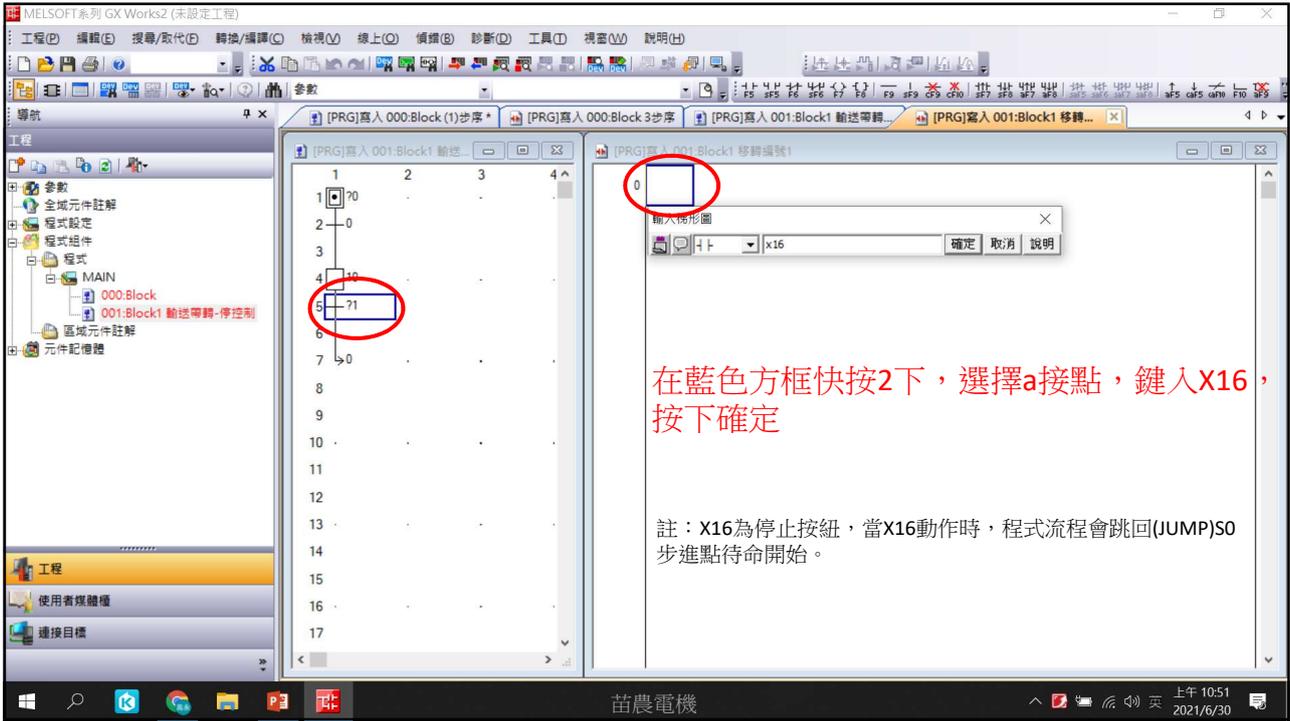








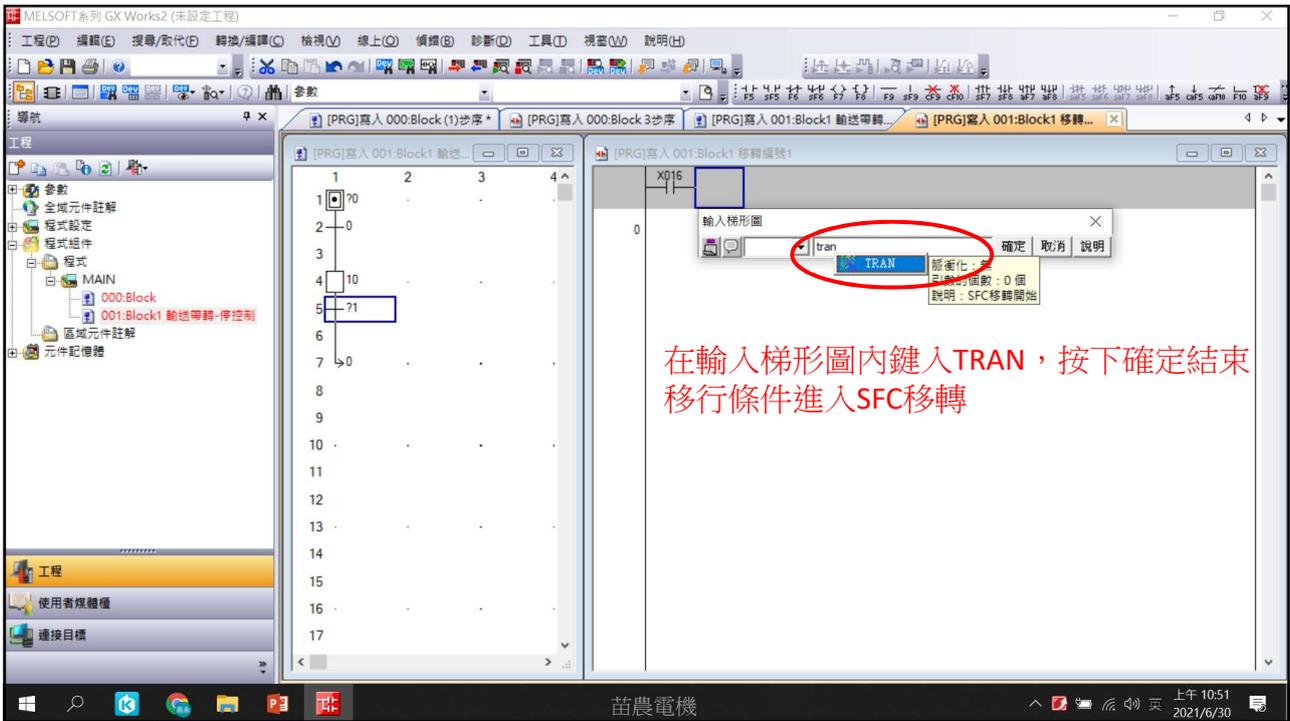




The screenshot shows the MELSOFT GX Works2 interface. On the left, a project tree shows the 'MAIN' folder containing '000:Block' and '001:Block1 輸送帶轉-停控制'. The main window displays a ladder logic diagram with steps 1 through 17. Step 5 is highlighted with a blue box and contains a coil labeled '71'. A dialog box titled '輸入梯形圖' (Enter Ladder Diagram) is open, showing a search for 'X16'. The search results list 'X16' as a stop button. A red circle highlights the 'X16' entry in the search results.

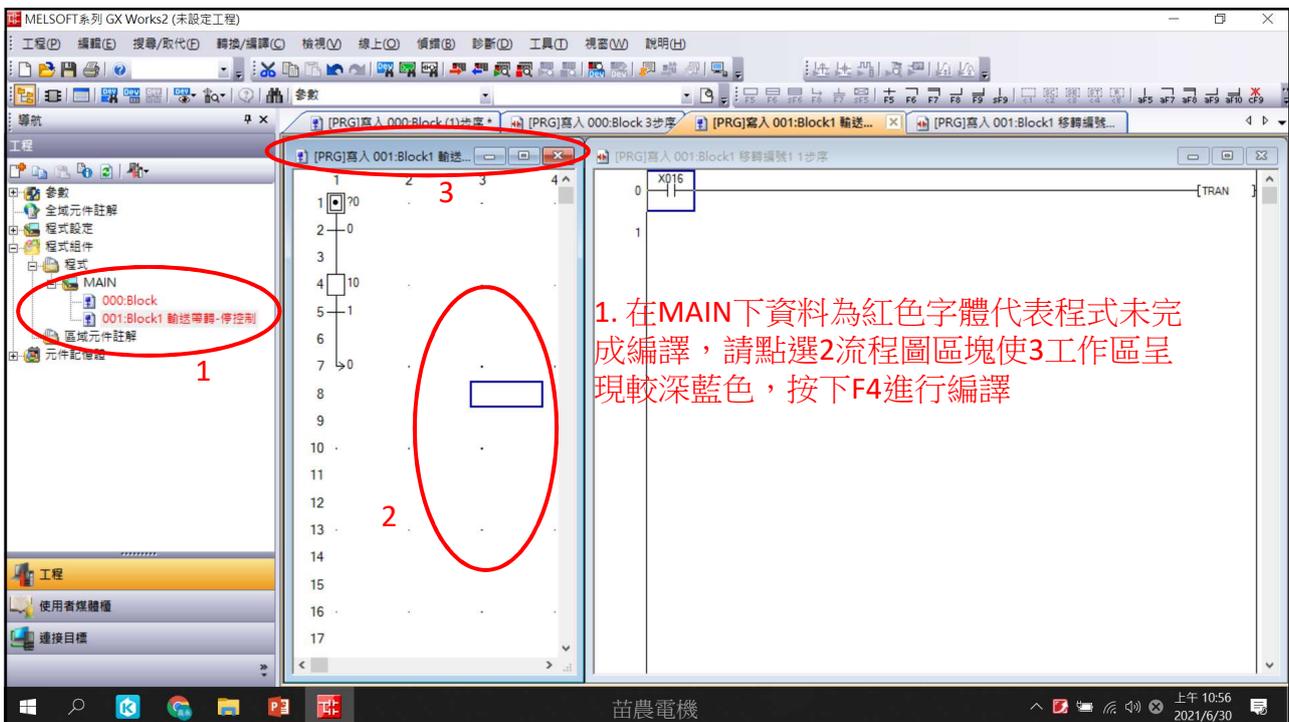
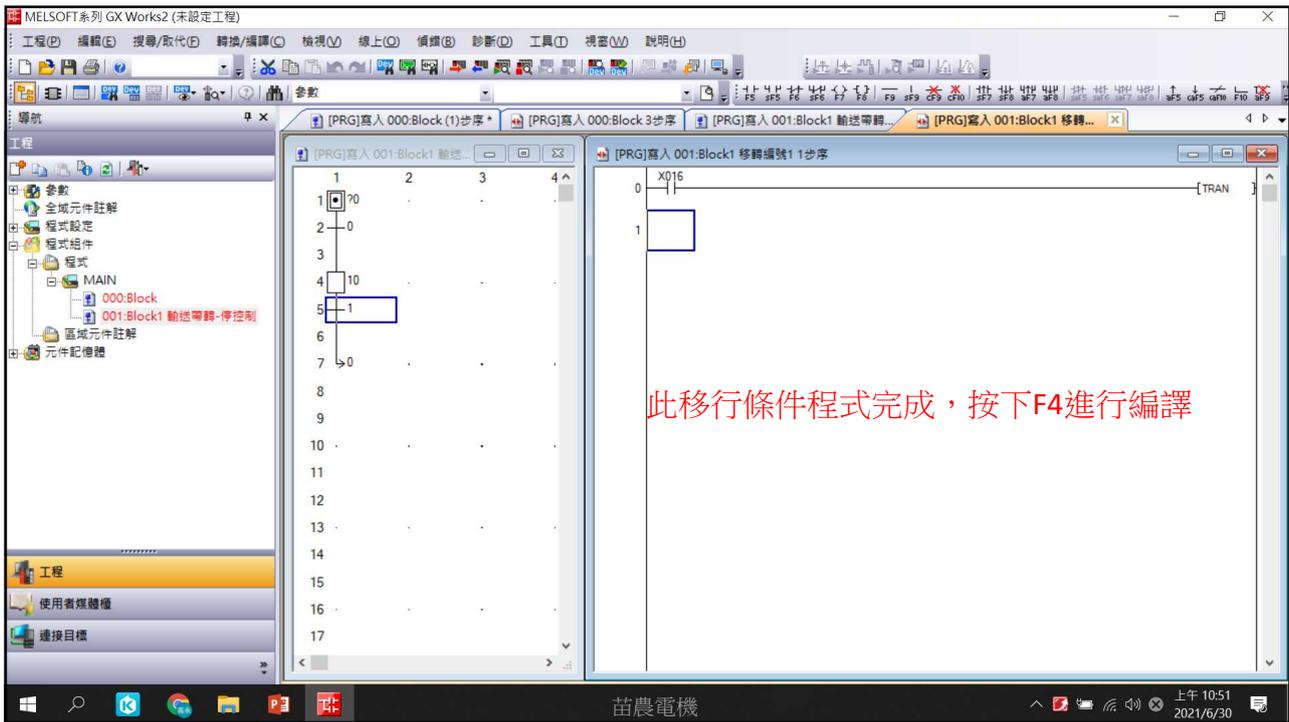
在藍色方框快按2下，選擇a接點，鍵入X16，按下確定

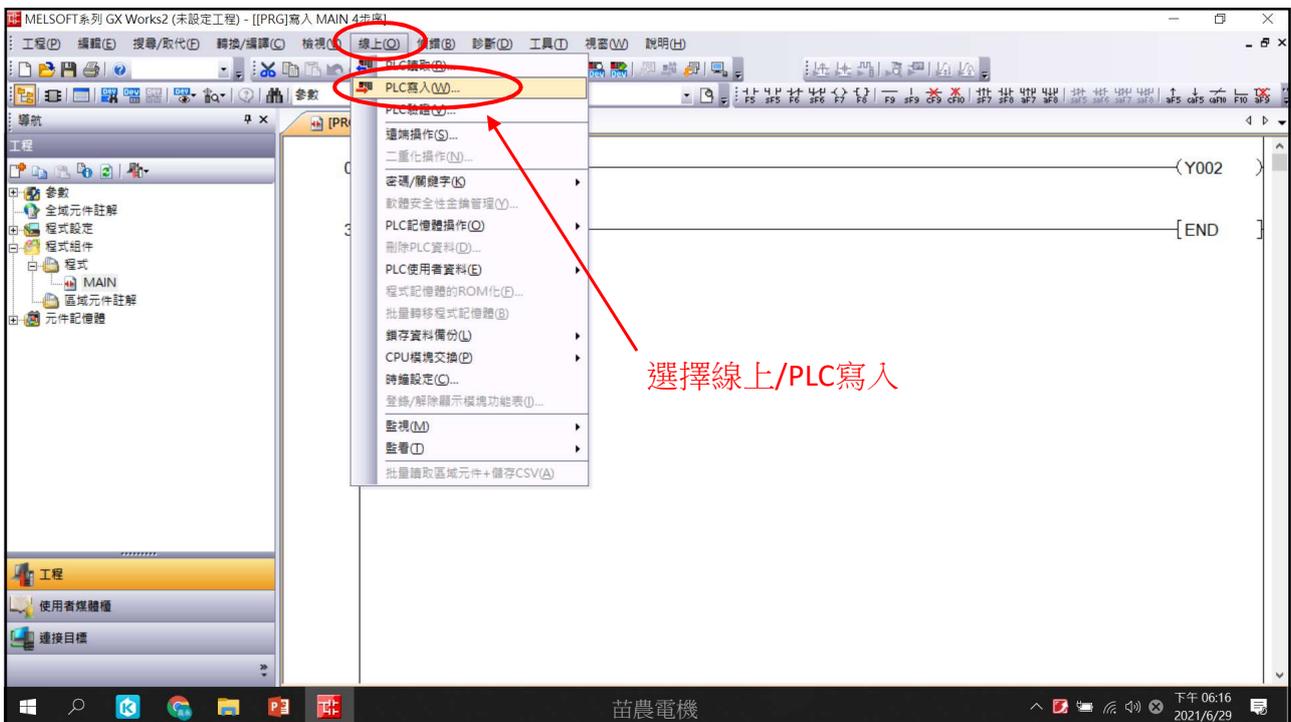
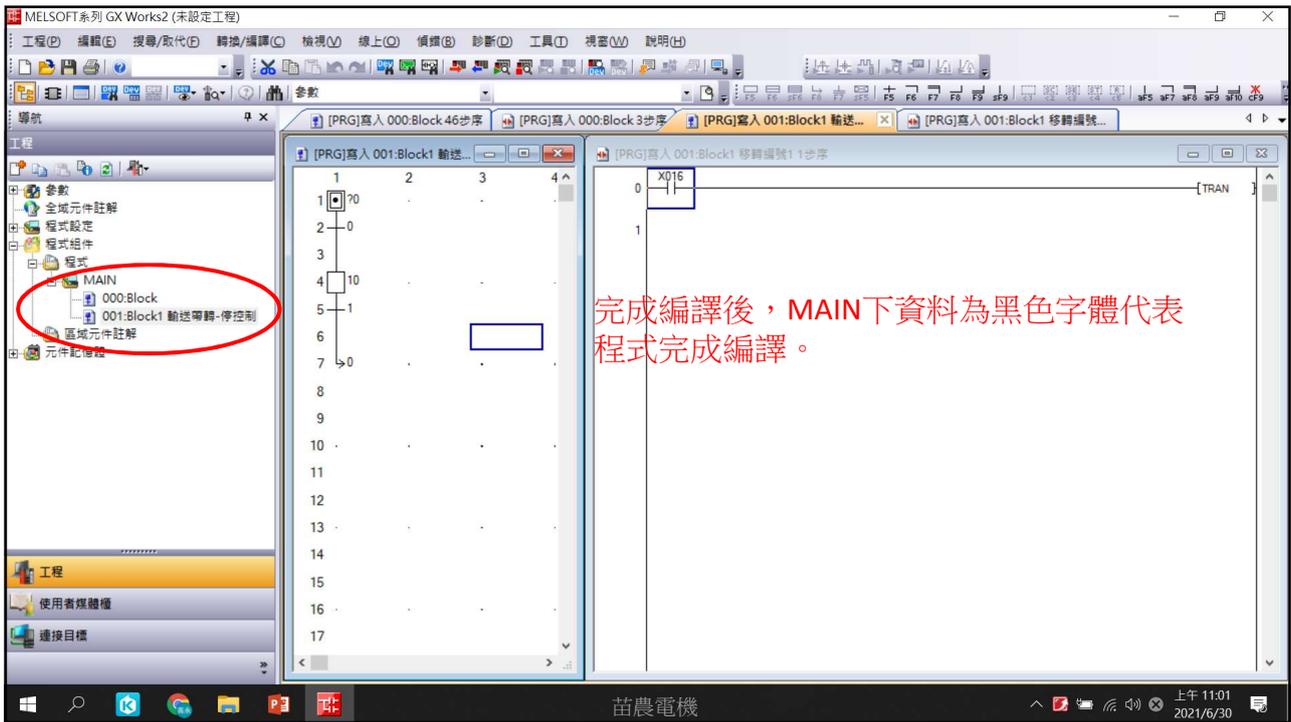
註：X16為停止按鈕，當X16動作時，程式流程會跳回(JUMP)S0步進點待命開始。

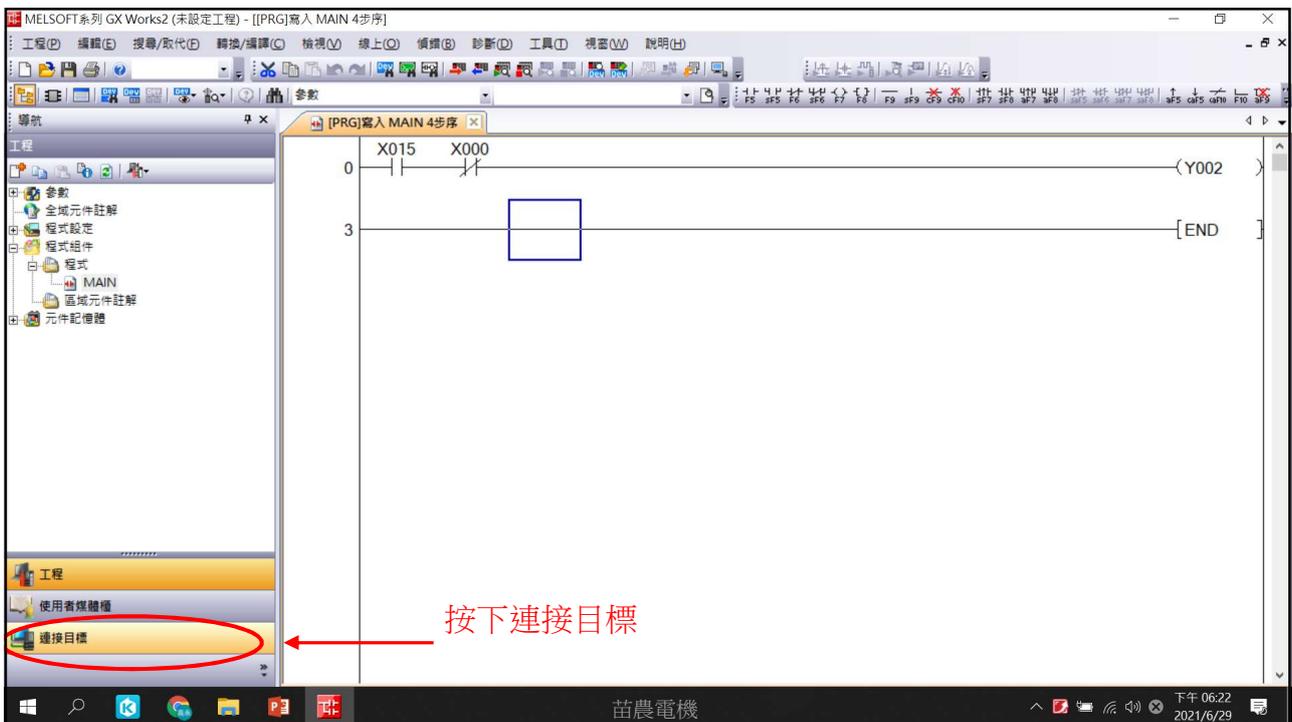
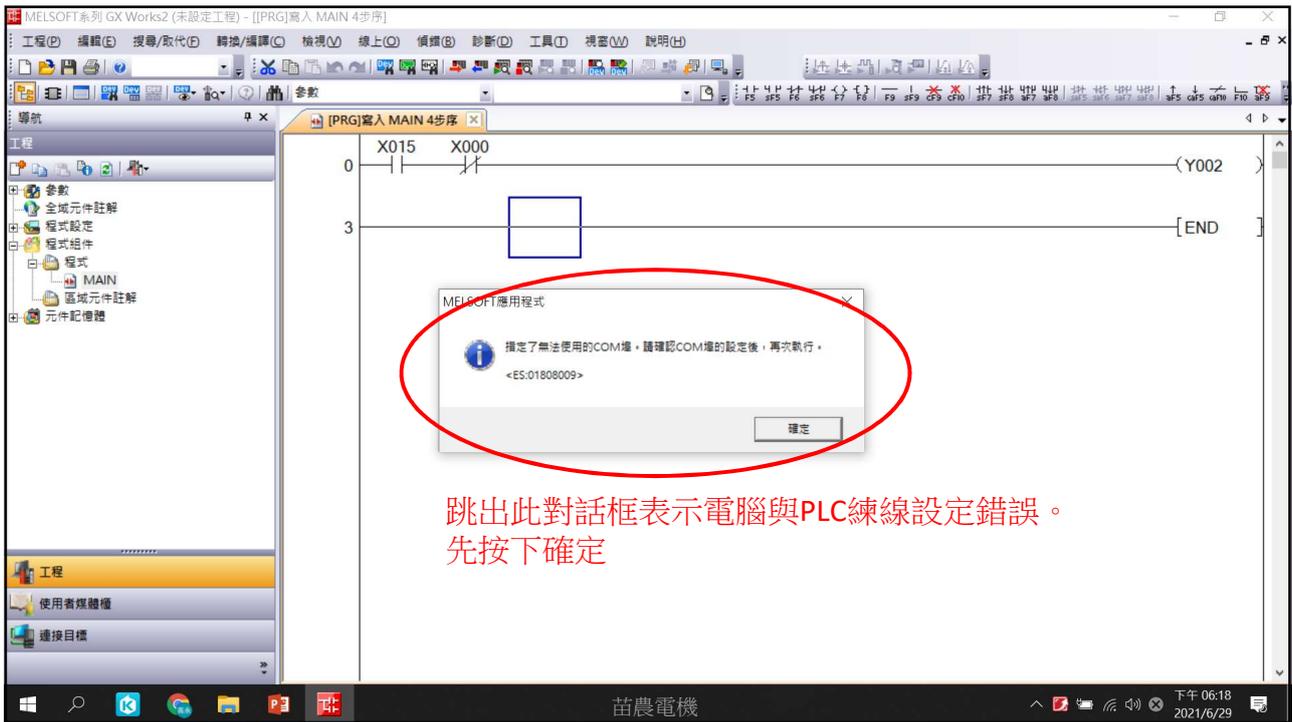


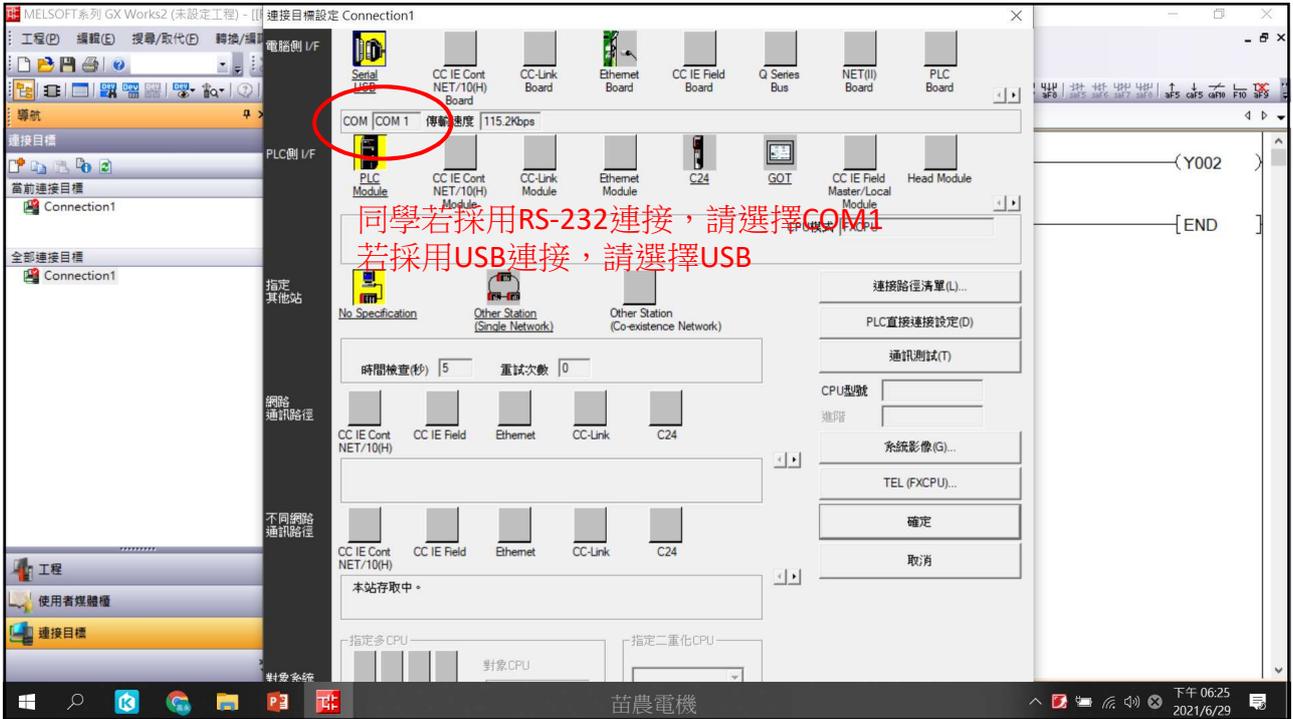
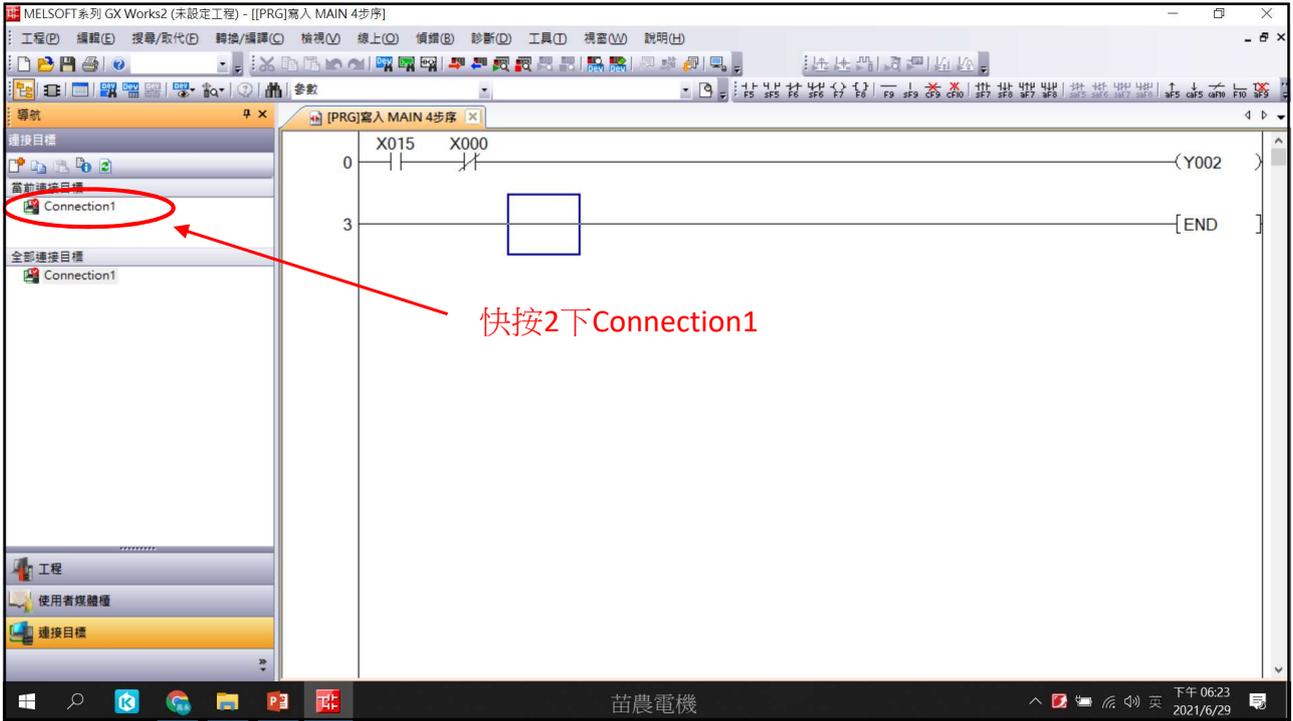
This screenshot shows the same software interface as the previous one. The ladder logic diagram now shows a transition labeled 'X16' between steps 4 and 5. The '輸入梯形圖' dialog box is still open, but the search results now show 'TRAN' as a transition. A red circle highlights the 'TRAN' entry in the search results.

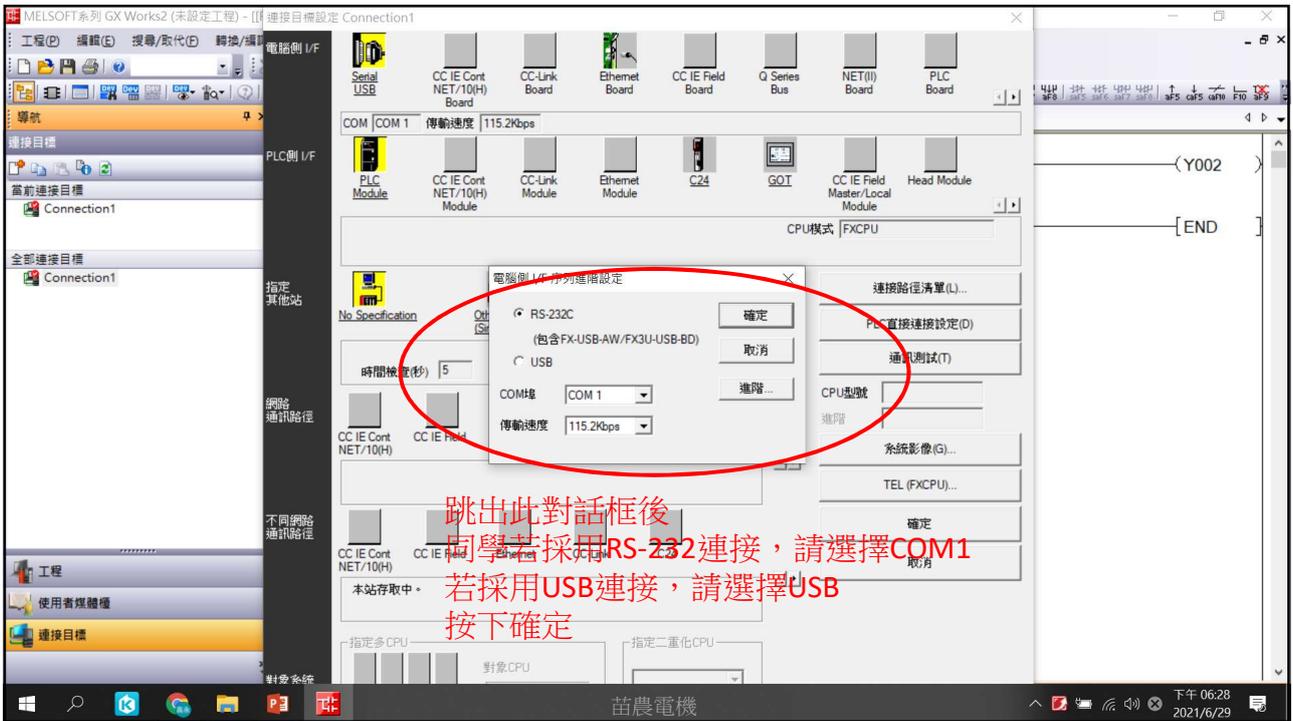
在輸入梯形圖內鍵入TRAN，按下確定結束移行條件進入SFC移轉

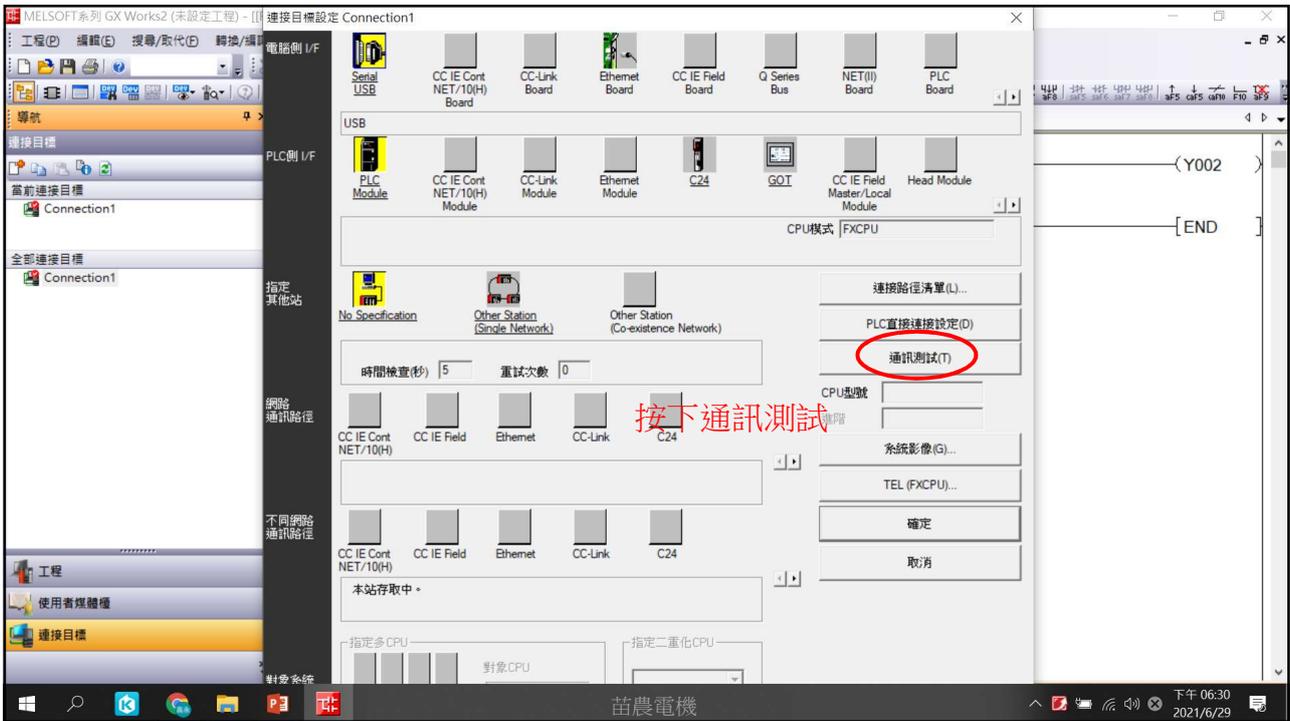
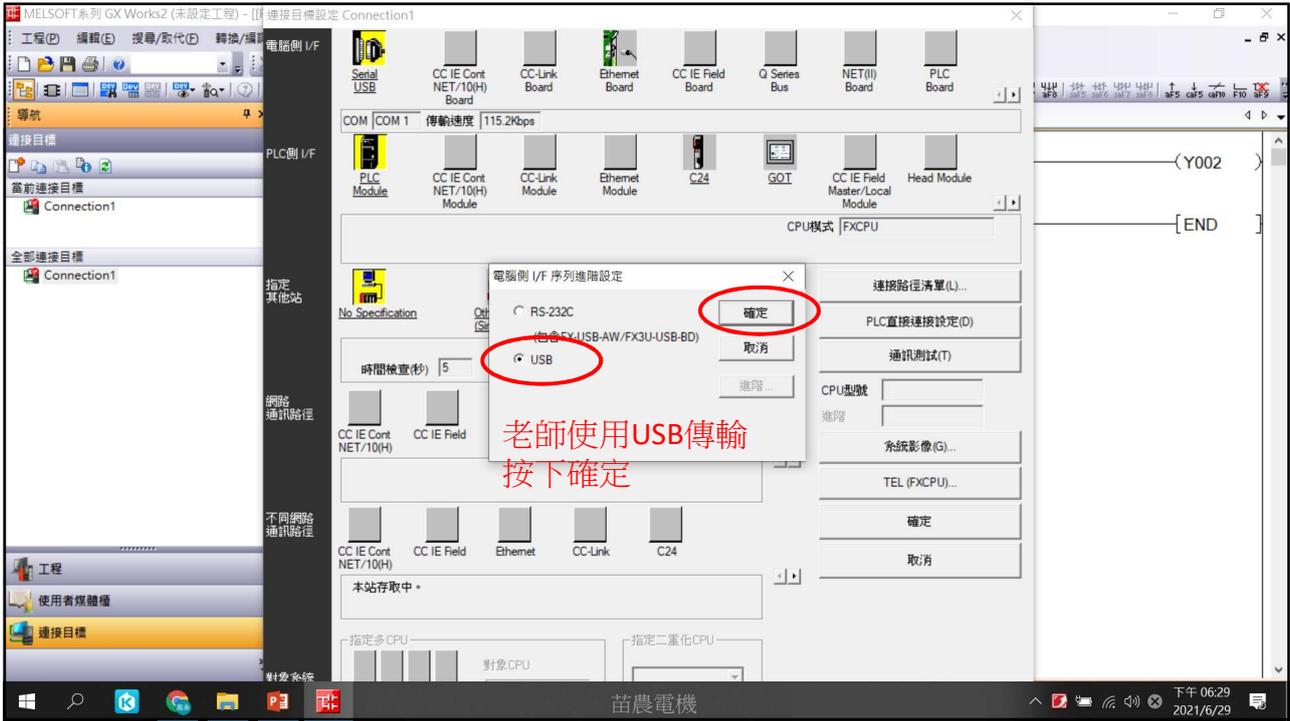


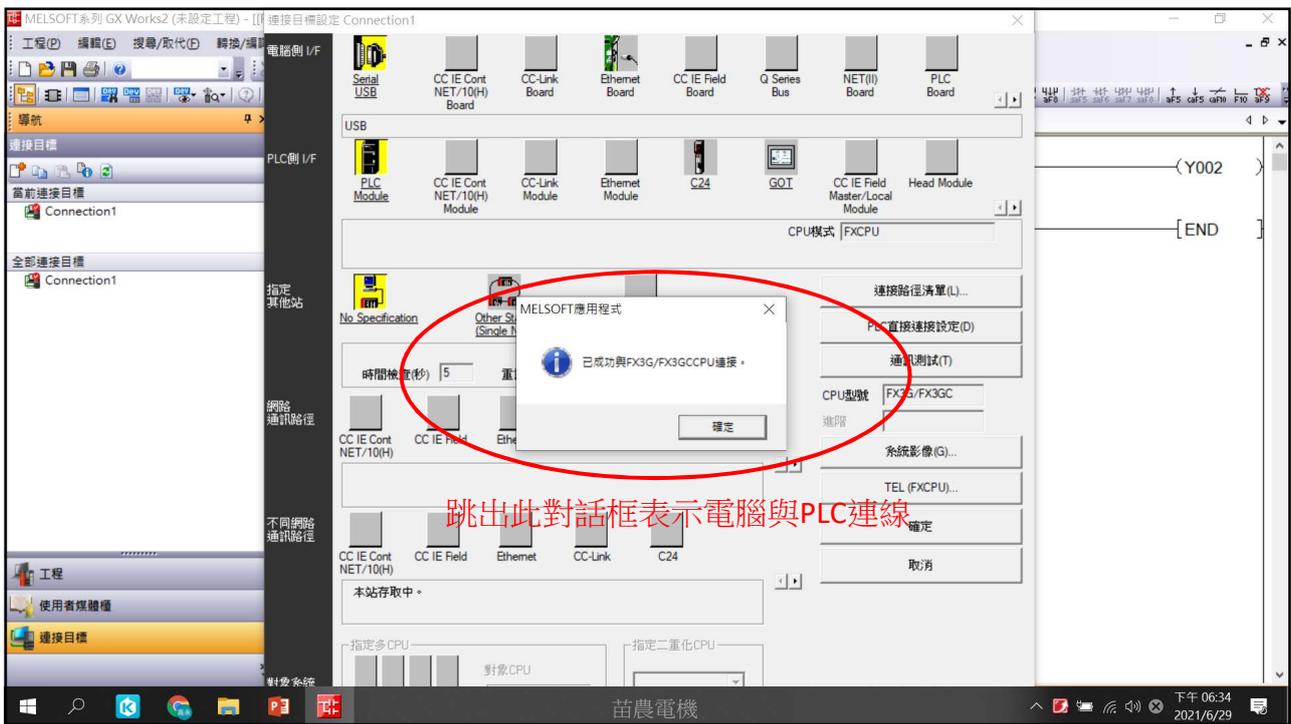








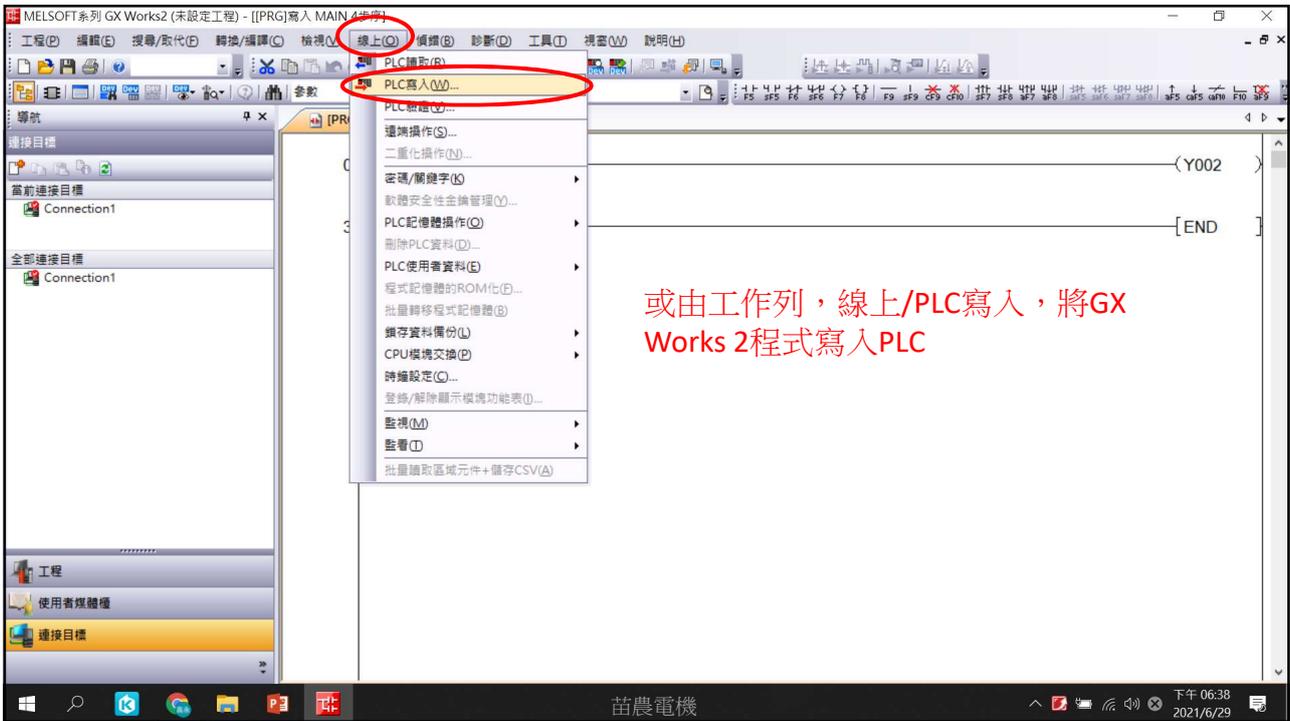
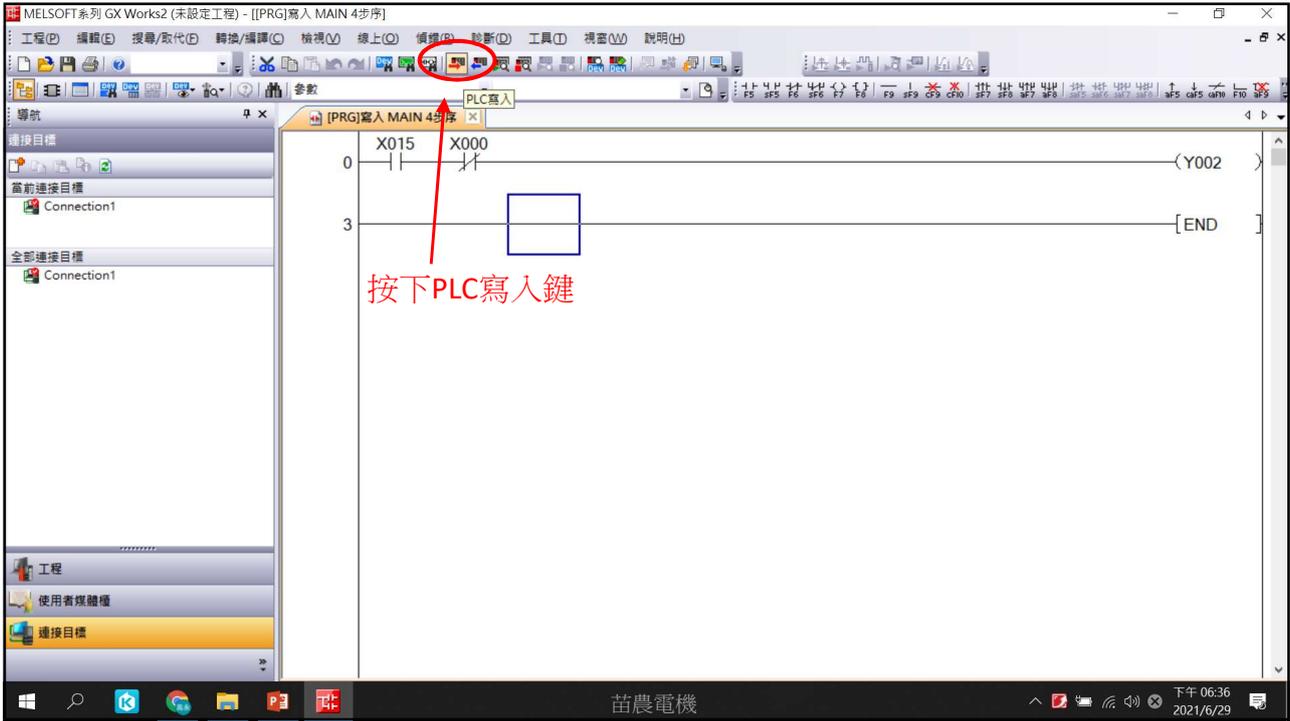


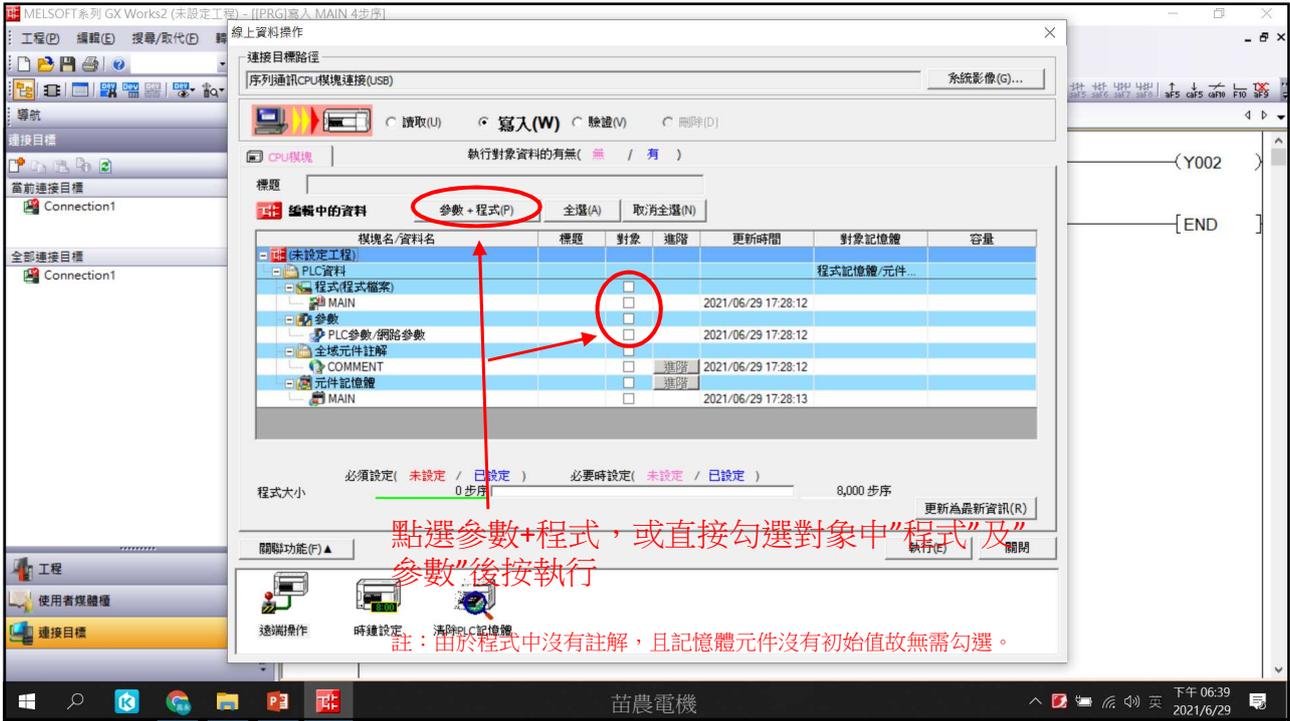


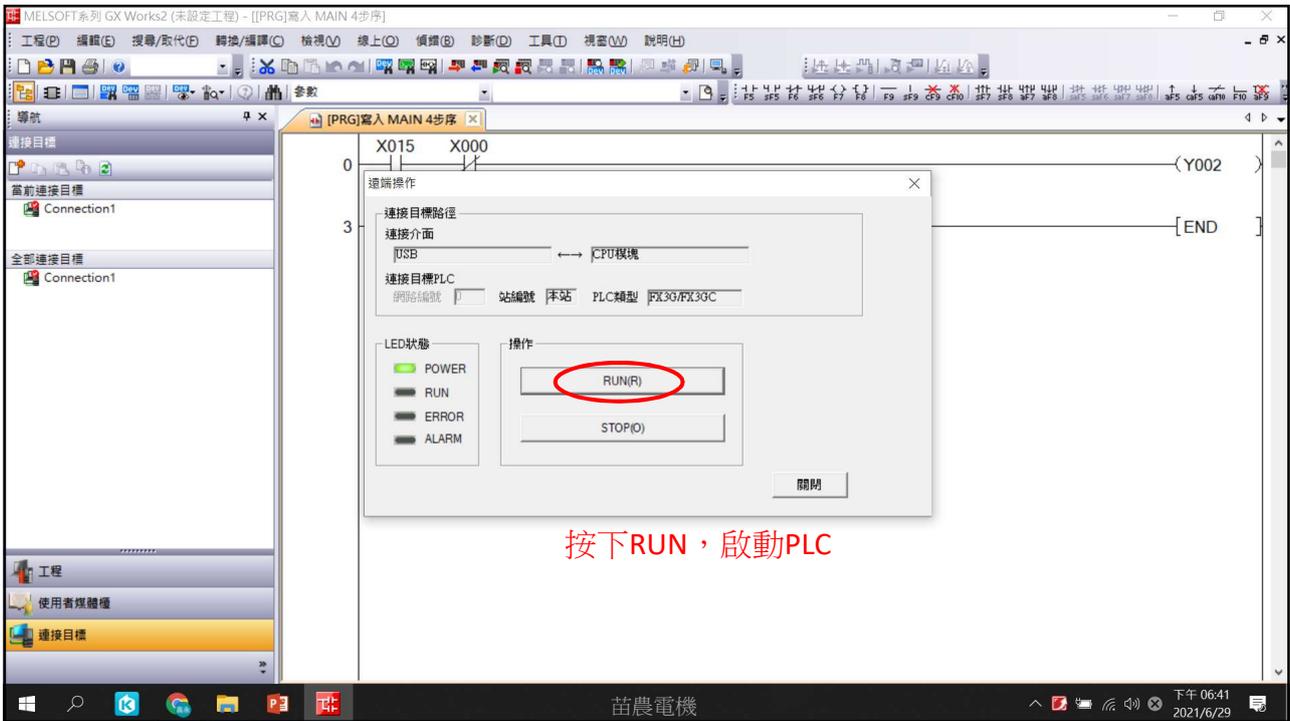
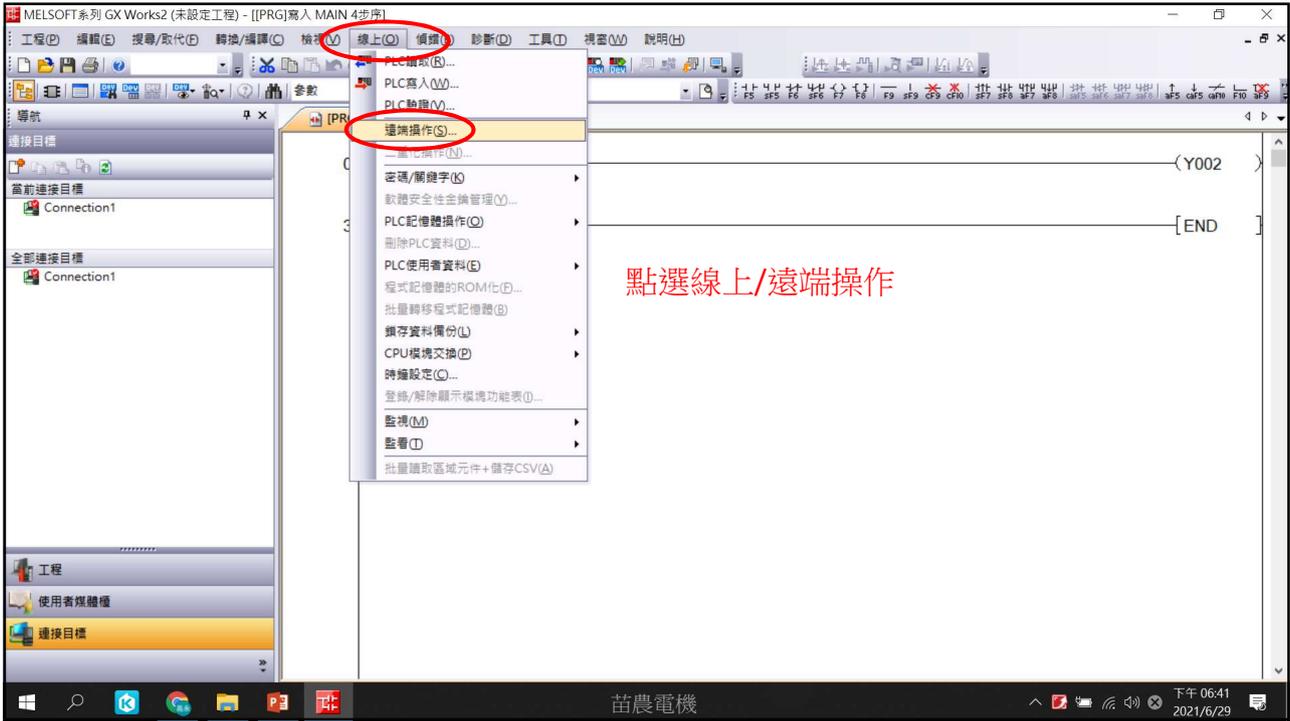
跳出此對話框表示電腦與PLC連線

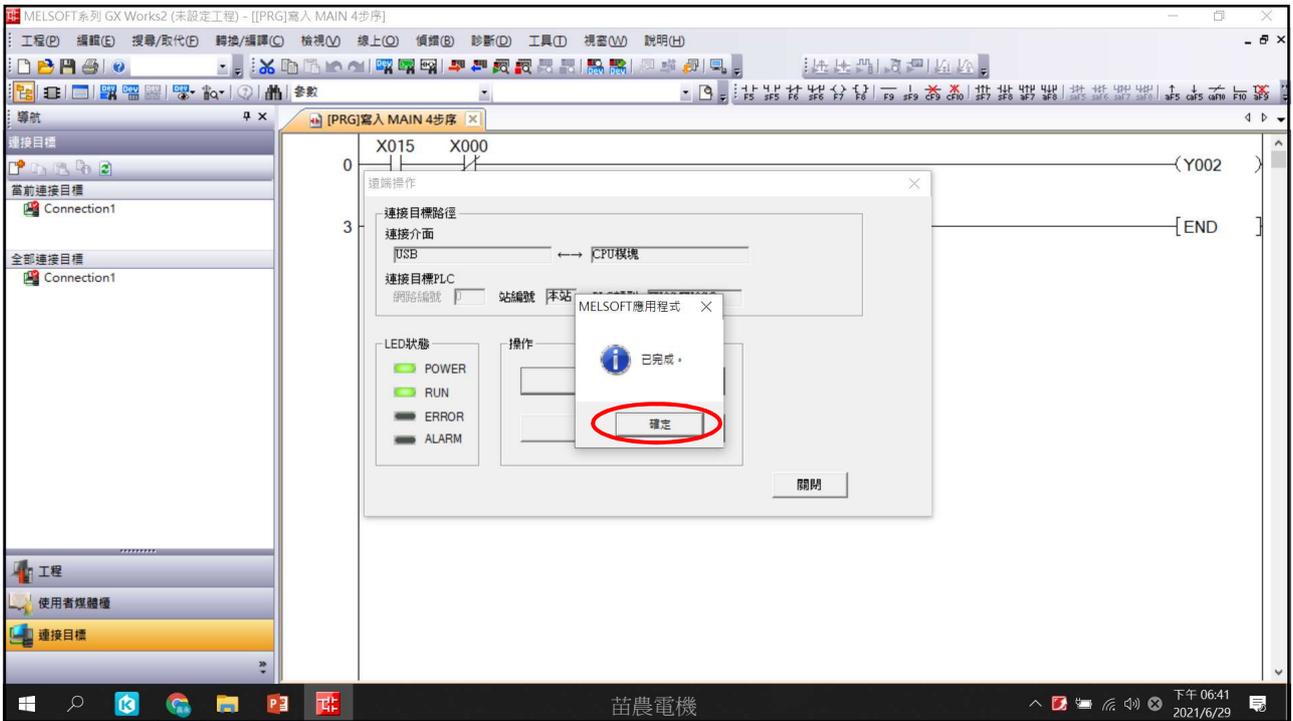
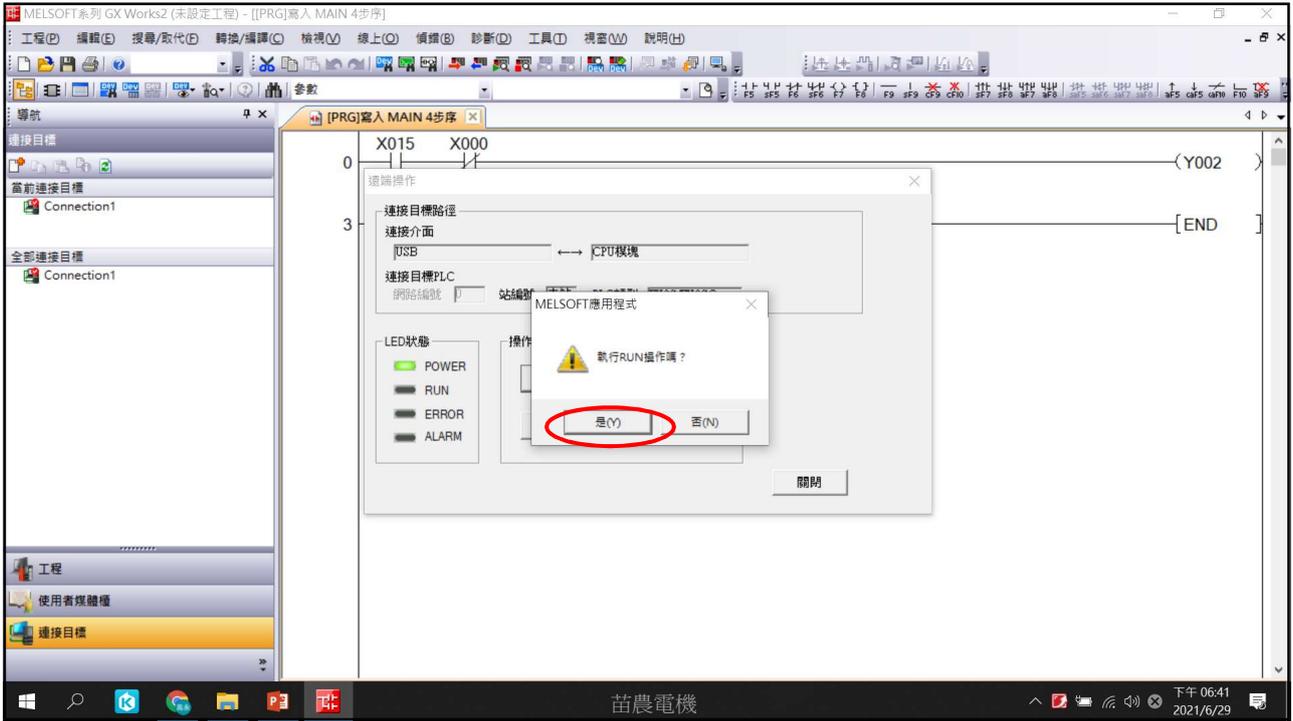


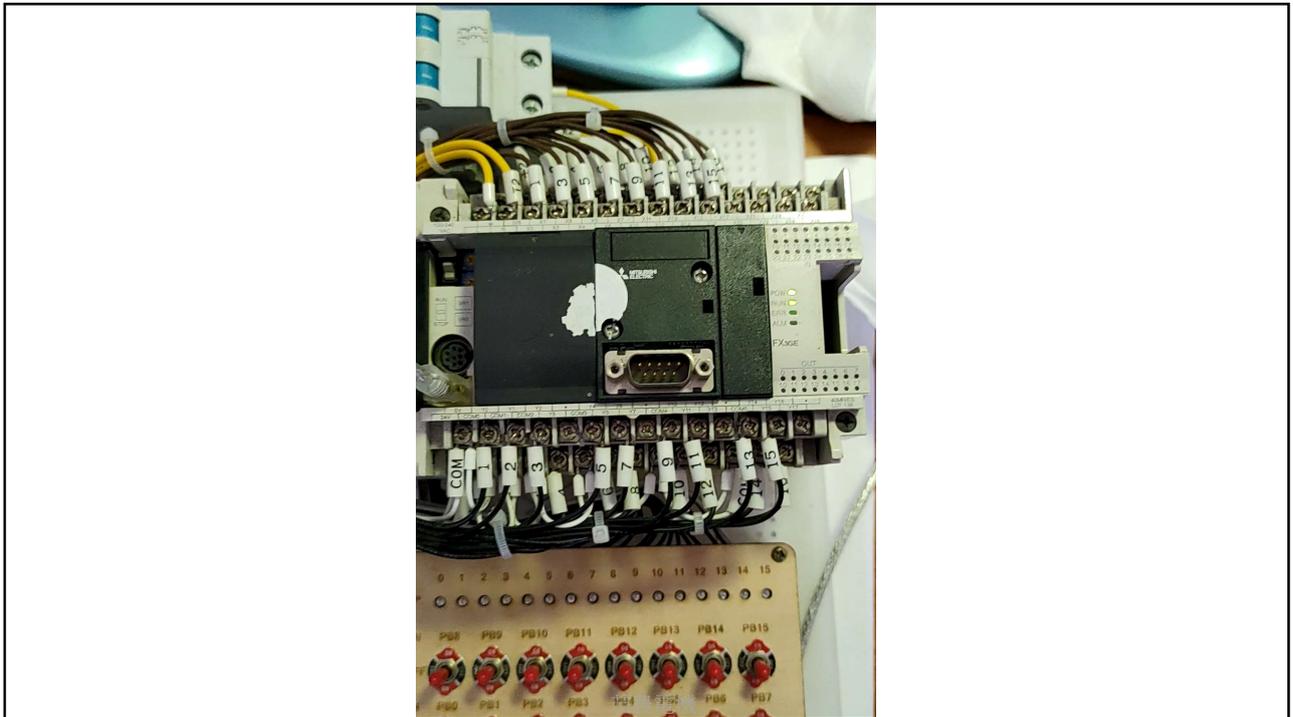
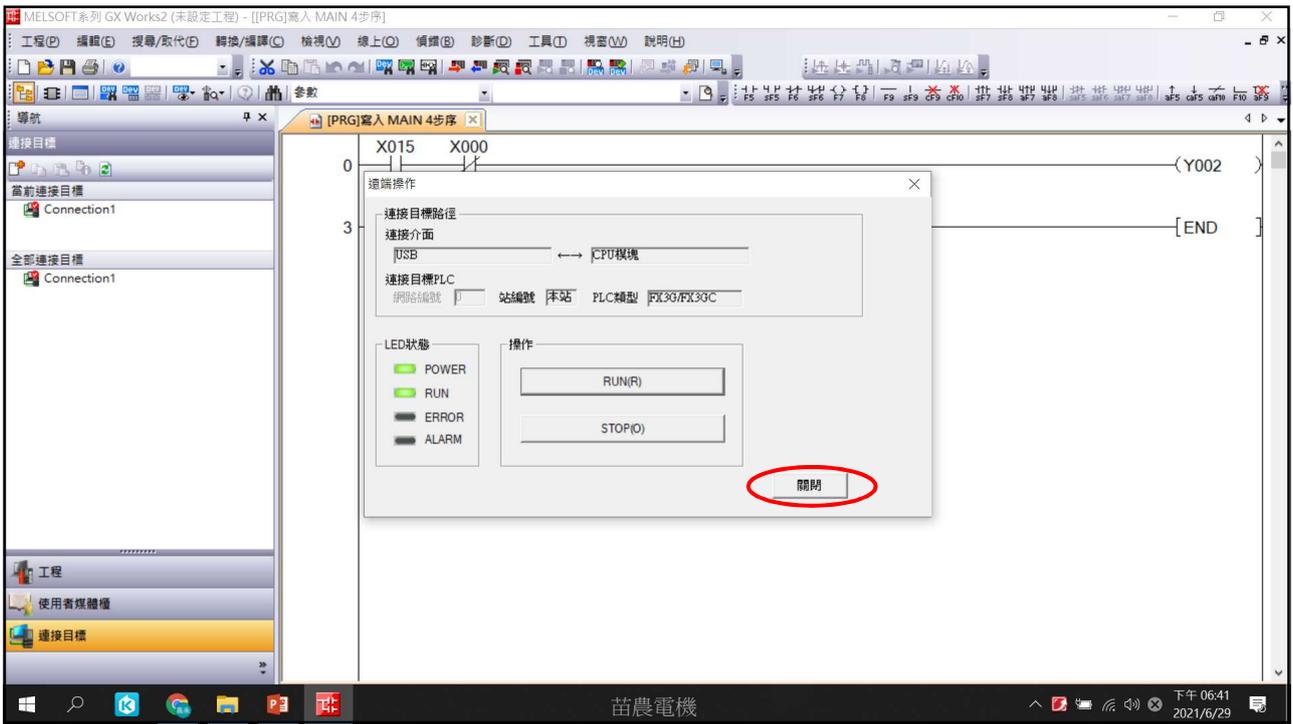
按下2次確定鍵











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苗農電機