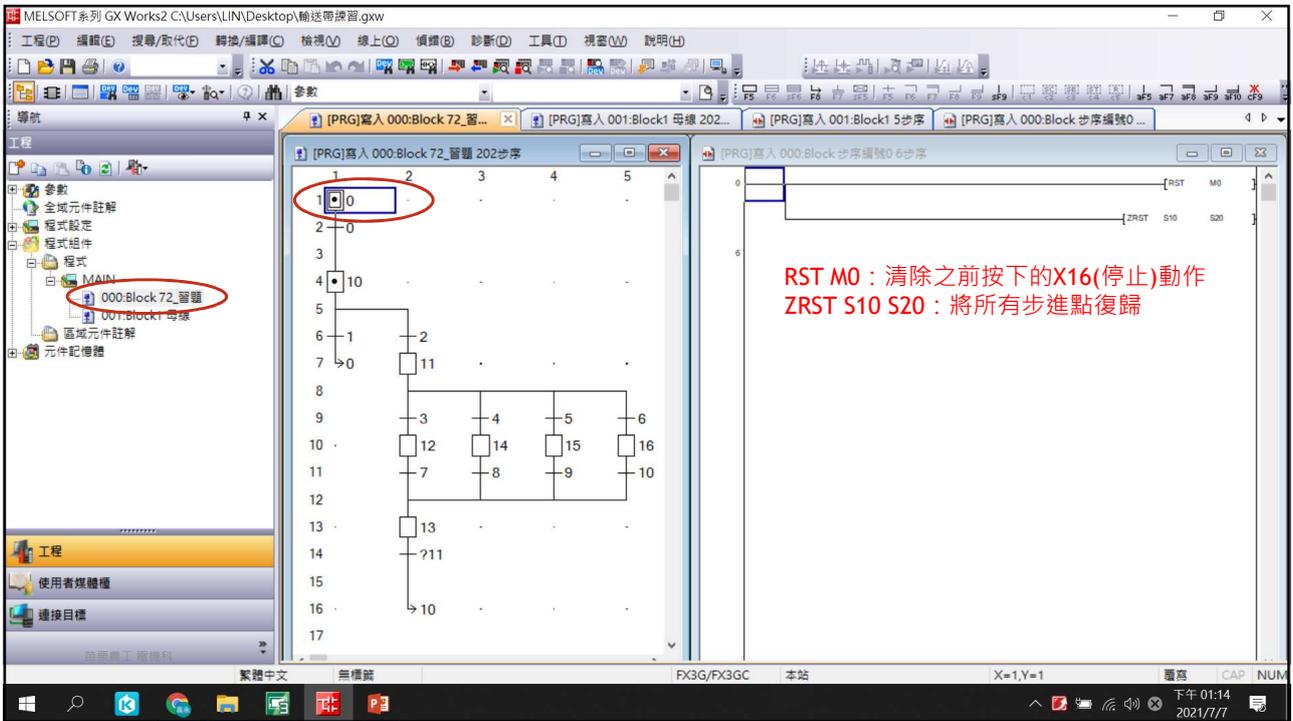
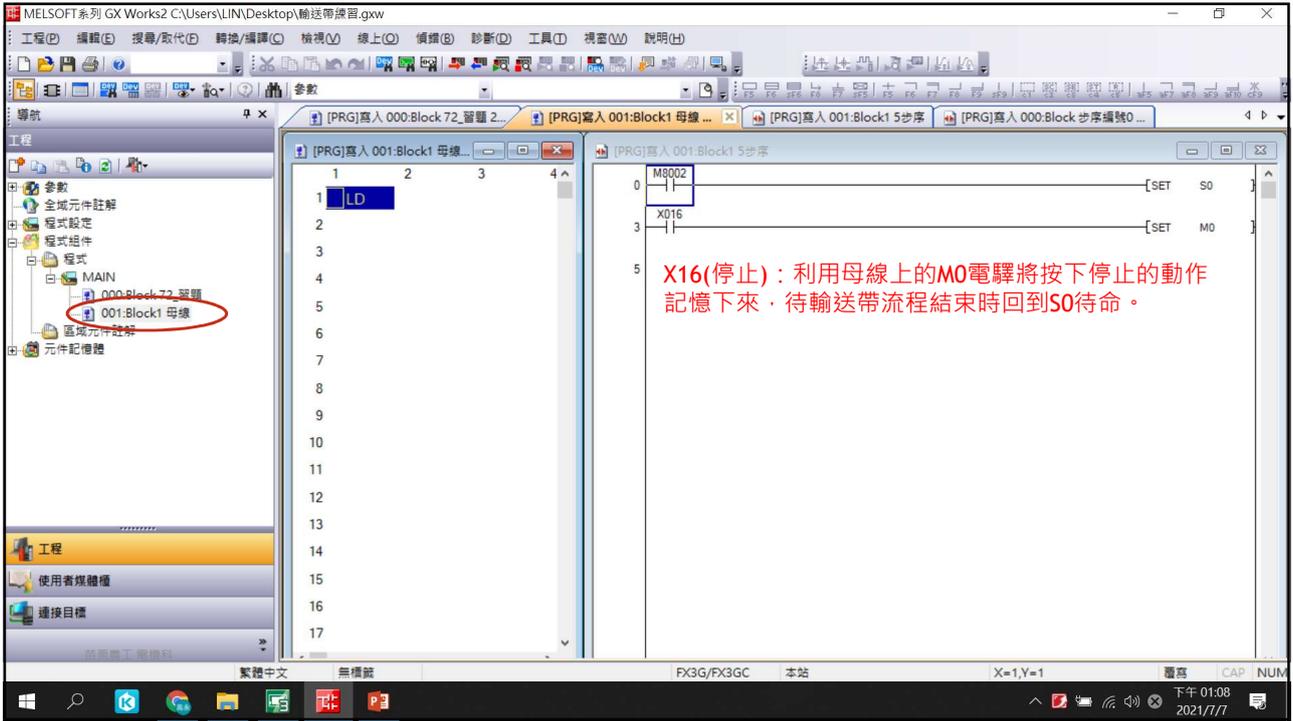


利用人機介面控制輸送帶 運轉及物件判斷實習

苗栗農工 電機科

PLC程式編輯

苗栗農工 電機科



X 15(啟動)：動作時換行條件成立·進入步進點S10

進入步進點S10時·輸送帶(Y2)運轉·但輸送帶運轉超過8秒鐘·定位點(X0)沒有偵測到物件則回S0待命。

MELSOFT系列 GX Works2 C:\Users\LIN\Desktop\輸送帶排管.gxw

工程 編輯 搜尋/取代 轉換/編譯 檢視 線上 偵錯 診斷 工具 視窗 說明

導航 [PRG]寫入 000:Block 72_管... [PRG]寫入 001:Block1 母線 203... [PRG]寫入 001:Block1 5步序 [PRG]寫入 000:Block 步序編號1...

[PRG]寫入 000:Block 72_管 203步序

1 0
2 0
3
4 10
5
6 1
7 0
8
9 3 4 5 6
10 12 14 15 16
11 7 8 9 10
12
13 13
14
15
16
17 10

[PRG]寫入 000:Block 步序編號10 34步序

0 T0
1
2
3 T14
4
5
6
7
8
9
10
11
12
13
14
15
16
17
18
19
20
21 T10
22 T10 T11
23 T11 T12
24 T12 T13
25 T13 T14
26
27
28
29
30
31
32
33
34

此範圍為提供給GOT輸送帶上物件移動的跑馬燈用
使用內部繼電器而不占用輸出接點

繁體中文 無標籤 FX3G/FX3GC 本站 X=1,Y=4 圖畫 CAP NUM 下午 01:36 2021/7/7

MELSOFT系列 GX Works2 C:\Users\LIN\Desktop\輸送帶排管.gxw

工程 編輯 搜尋/取代 轉換/編譯 檢視 線上 偵錯 診斷 工具 視窗 說明

導航 [PRG]寫入 000:Block 72_管... [PRG]寫入 001:Block1 母線 203... [PRG]寫入 001:Block1 5步序 [PRG]寫入 000:Block 步序編號1...

[PRG]寫入 000:Block 72_管 203步序

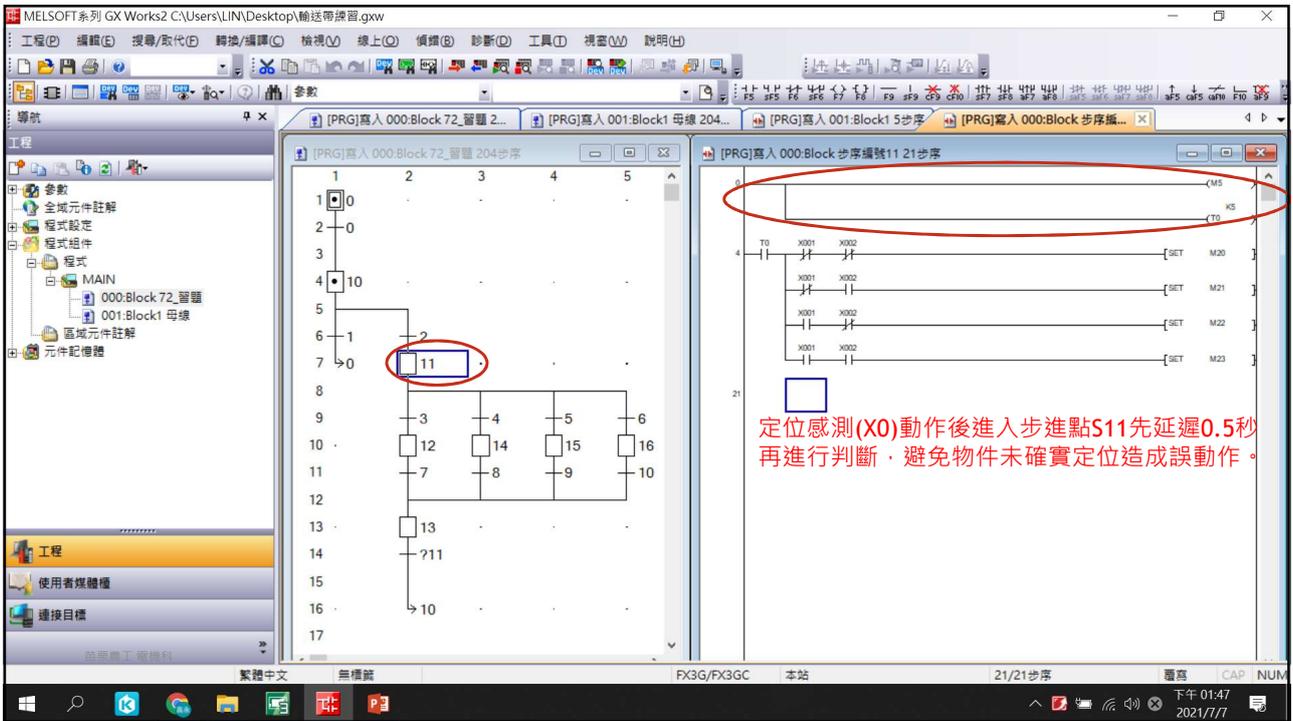
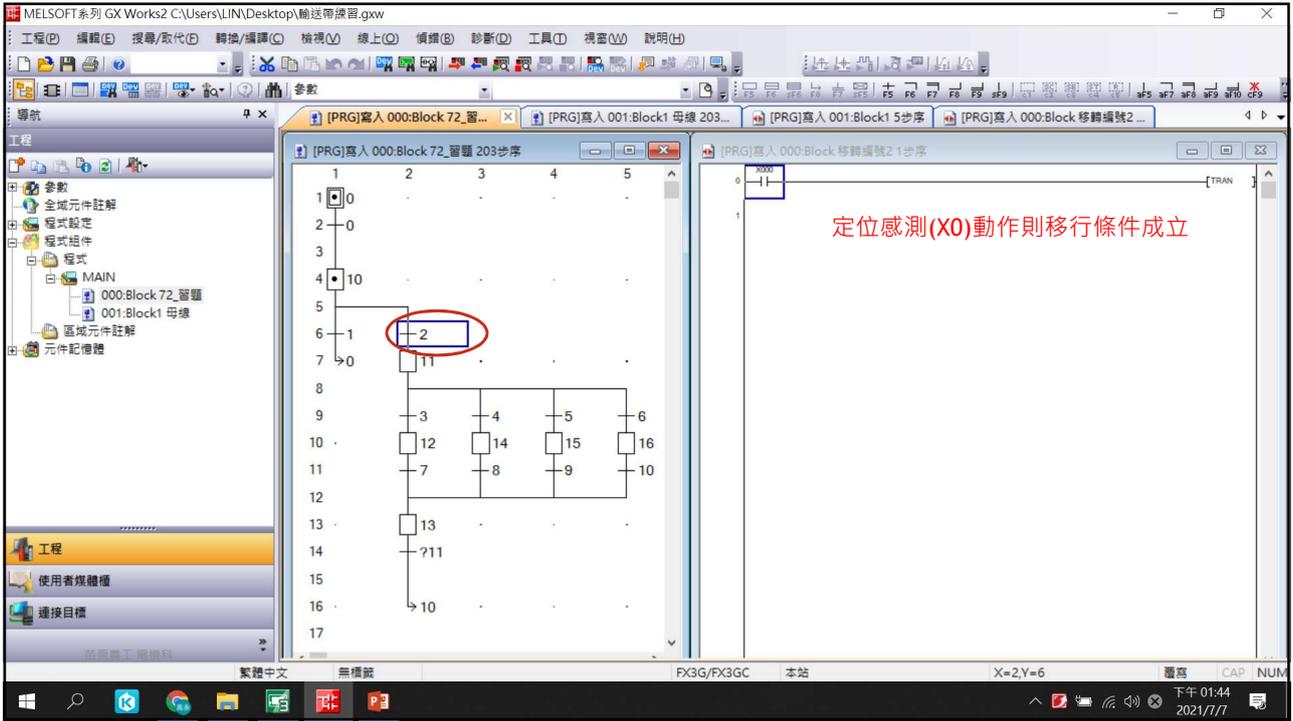
1 0
2 0
3
4 10
5
6 1
7 0
8
9 3 4 5 6
10 12 14 15 16
11 7 8 9 10
12
13 13
14
15
16
17 10

[PRG]寫入 000:Block 步序編號1 2步序

0 [TRAN]
1
2

任何時刻觸發停止鈕(X16)則M0 SET。或輸
送帶上超過8秒沒有偵測到物件，則跳回S0
待命。

繁體中文 無標籤 FX3G/FX3GC 本站 X=1,Y=6 圖畫 CAP NUM 下午 01:41 2021/7/7



[PRG]寫入 000:Block 72_管體 204 步序

[PRG]寫入 000:Block 步序編號11 21步序

X1、X2為顏色及材質感測，共有4種組合。將偵測結果記憶到M20-M23，依題目需求作輸出。

[PRG]寫入 000:Block 72_管體 204 步序

[PRG]寫入 000:Block 移轉編號3 1步序

判斷結果若為M20動作，則進到S12步進點

MELSOFT系列 GX Works2 C:\Users\LIN\Desktop\輸送帶排習.gxw

工程編輯 搜尋/取代 轉換/編譯 檢視 線上 偵錯 診斷 工具 視窗 說明

參數

導航

工程

參數
全域元件註解
程式設定
程式組件
MAIN
000:Block 72_管帶
001:Block1 母線
區域元件註解
元件記憶體

工程
使用者媒體檔
連接目標

高麗農工 電腦科

繁體中文 無標籤 FX3G/FX3GC 本站 X=2,Y=10 圖區 CAP NUM

下午 01:56 2021/7/7

[PRG]寫入 000:Block 72_管帶 204步序

[PRG]寫入 000:Block 步序編號1...

Y10
K50
T5

Y10動作5秒(人機介面上亮白色燈5秒)

1 2 3 4 5
1 0
2 0
3
4 10
5
6
7 1
8
9
10 12 14 15 16
11 7 8 9 10
12
13
14
15
16
17

MELSOFT系列 GX Works2 C:\Users\LIN\Desktop\輸送帶排習.gxw

工程編輯 搜尋/取代 轉換/編譯 檢視 線上 偵錯 診斷 工具 視窗 說明

參數

導航

工程

參數
全域元件註解
程式設定
程式組件
MAIN
000:Block 72_管帶
001:Block1 母線
區域元件註解
元件記憶體

工程
使用者媒體檔
連接目標

高麗農工 電腦科

繁體中文 無標籤 FX3G/FX3GC 本站 X=2,Y=11 圖區 CAP NUM

下午 01:56 2021/7/7

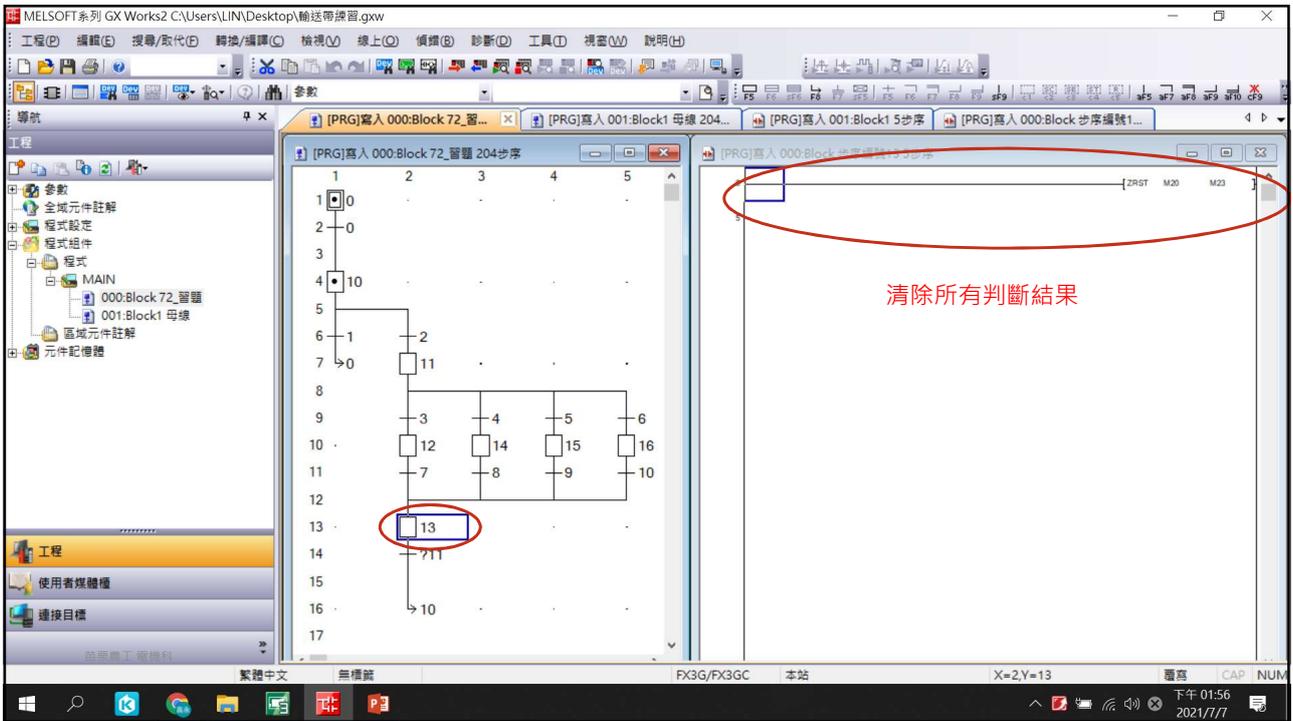
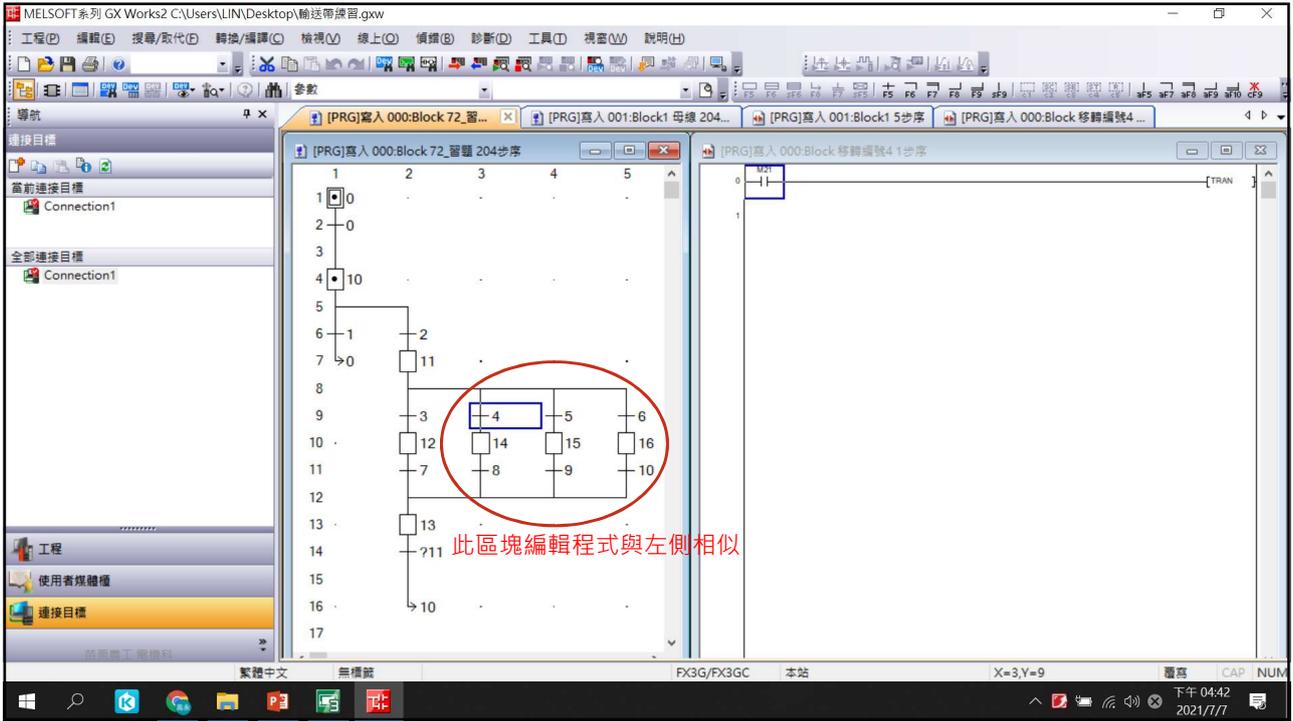
[PRG]寫入 000:Block 72_管帶 204步序

[PRG]寫入 000:Block 移轉編號7 1步序

T5

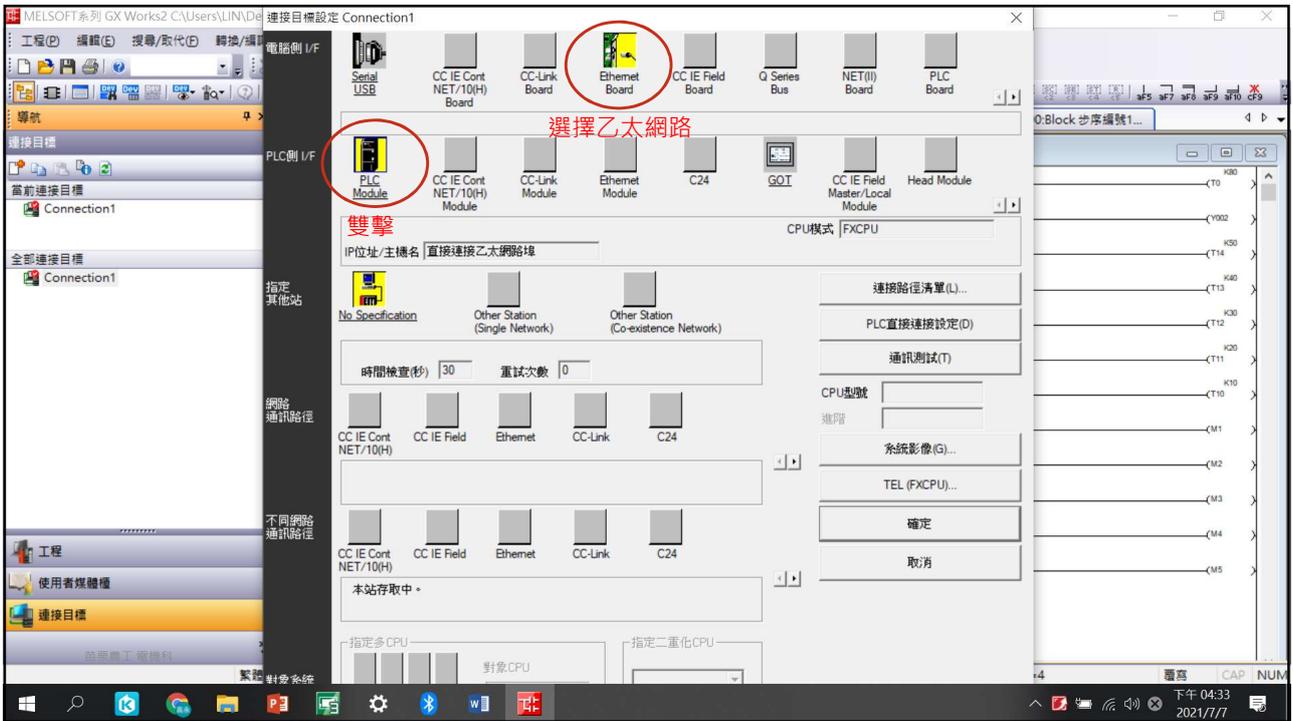
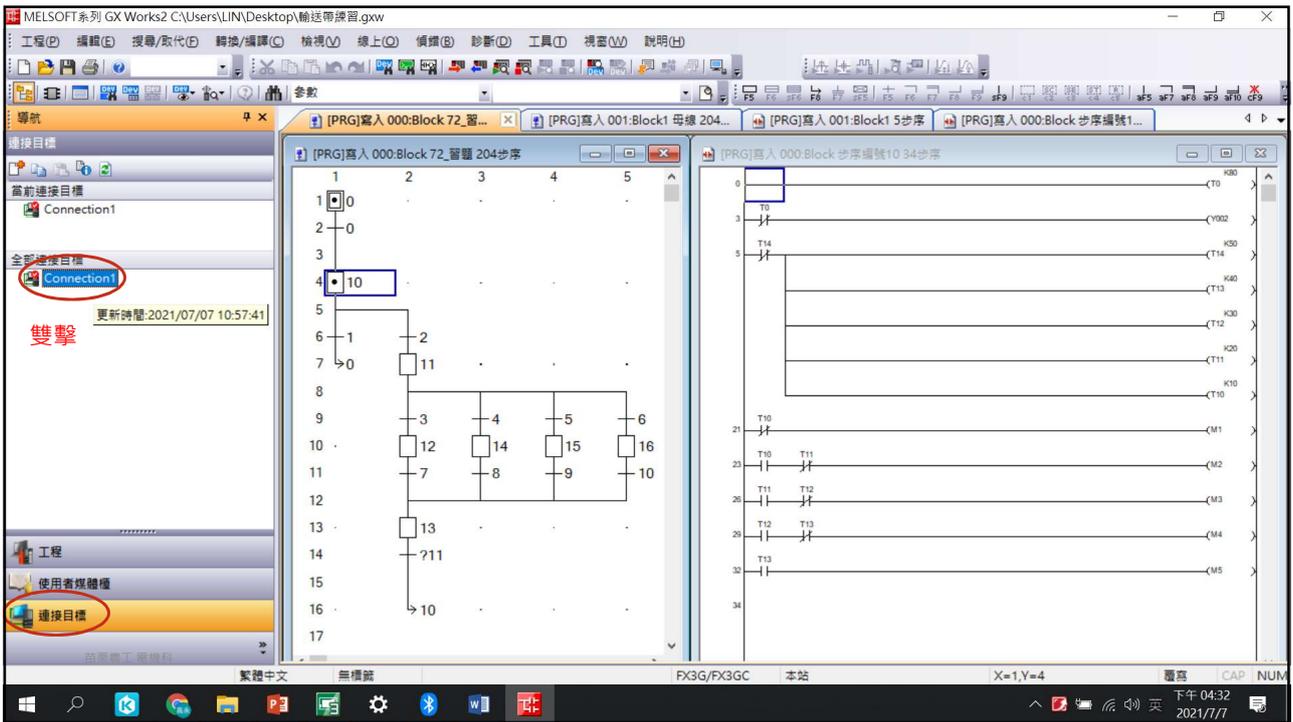
T5動作·移行條件成立

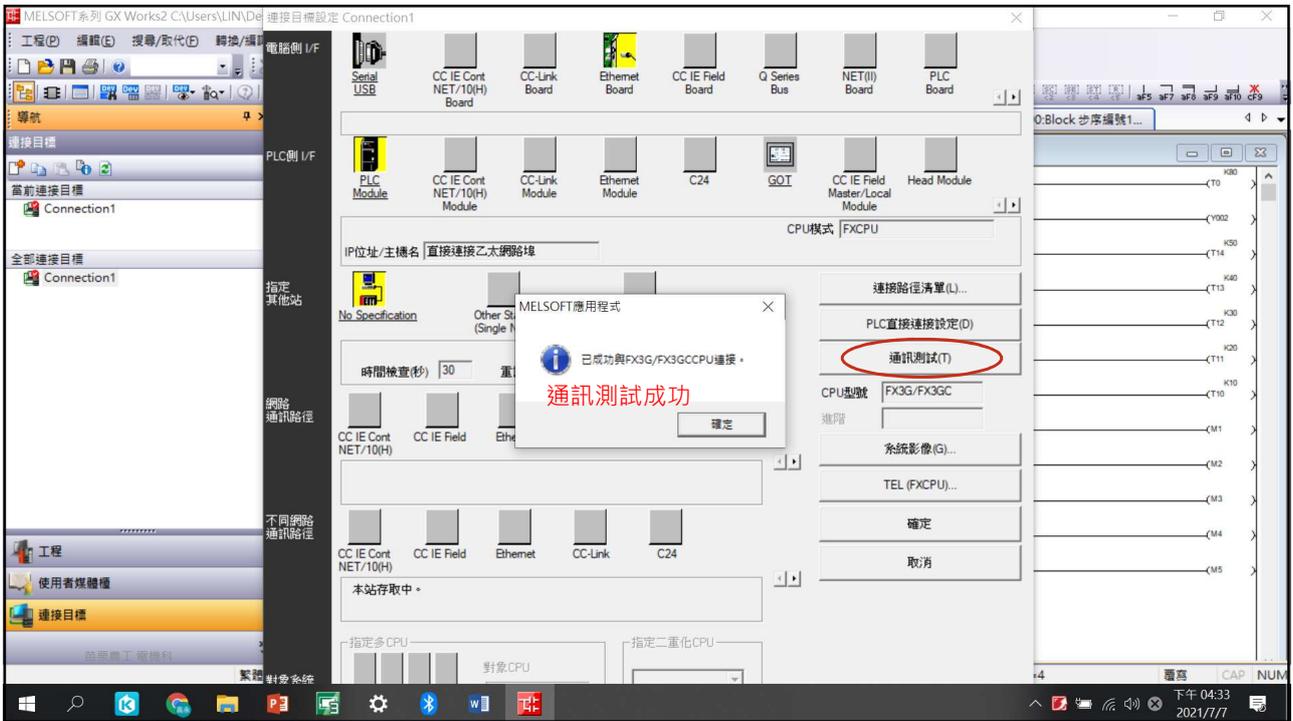
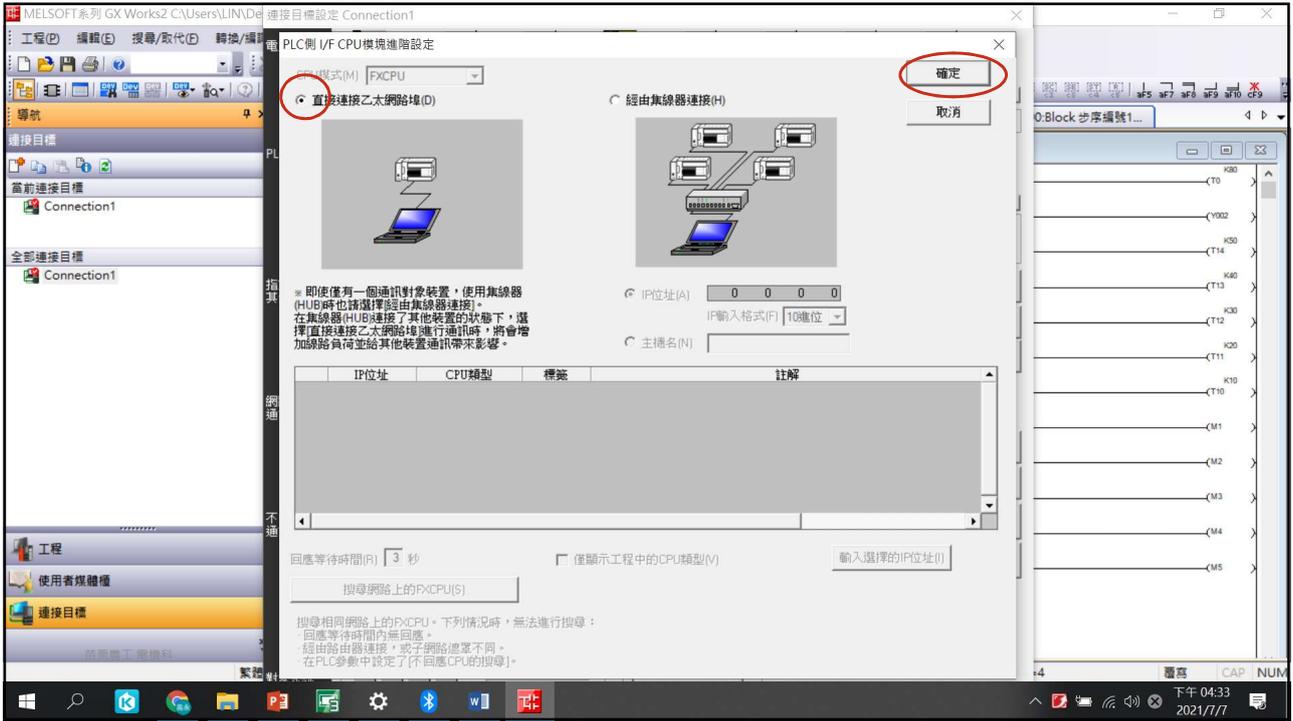
1 2 3 4 5
1 0
2 0
3
4 10
5
6
7 1
8
9
10 12 14 15 16
11 7 8 9 10
12
13
14
15
16
17

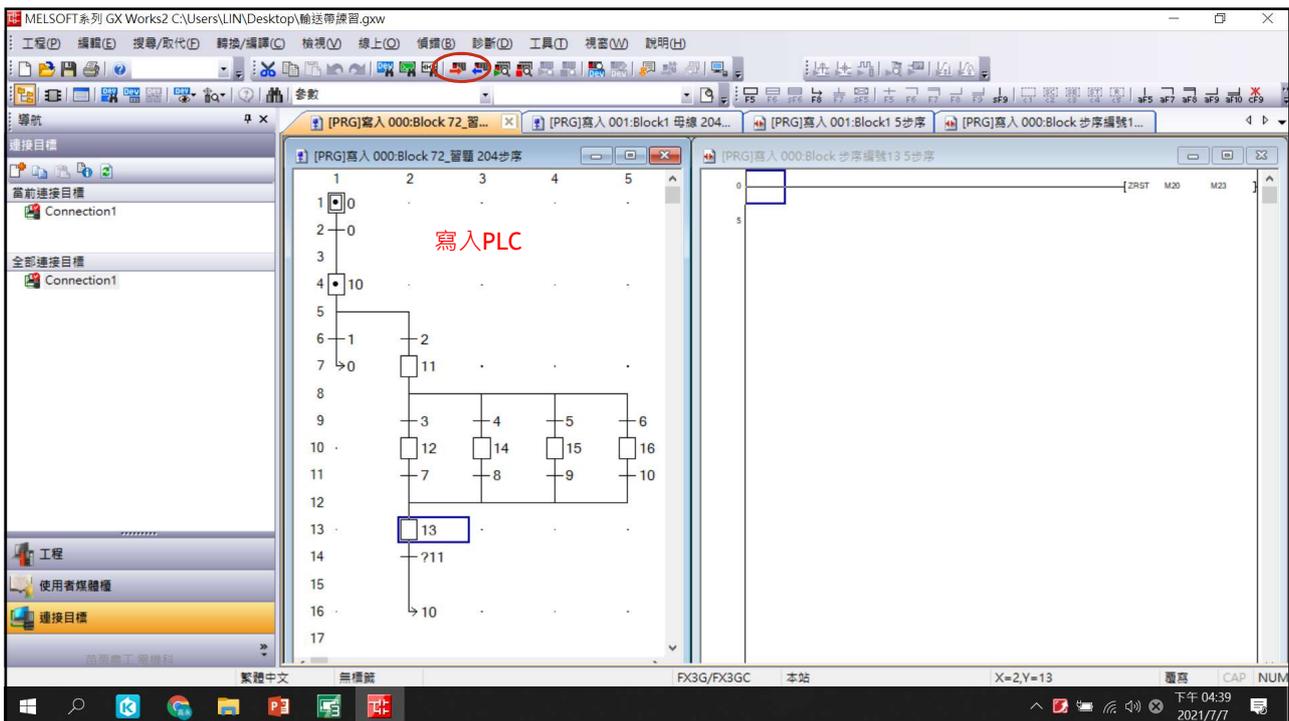


The screenshot shows the MELSOFT GX Works2 interface. On the left is the project tree with 'MAIN' and '000:Block 72_管壁' selected. The main window displays a ladder logic diagram for '000:Block 72_管壁 204步序'. Step 10 is circled in red, showing a normally open contact labeled '11' leading to a coil labeled '10'. To the right, a parameter window is open, with a red oval around a field. Red text in the center of the parameter window reads '直接回到步進點S10重複循環'. The status bar at the bottom shows 'FX3G/FX3GC' and the date '2021/7/7'.

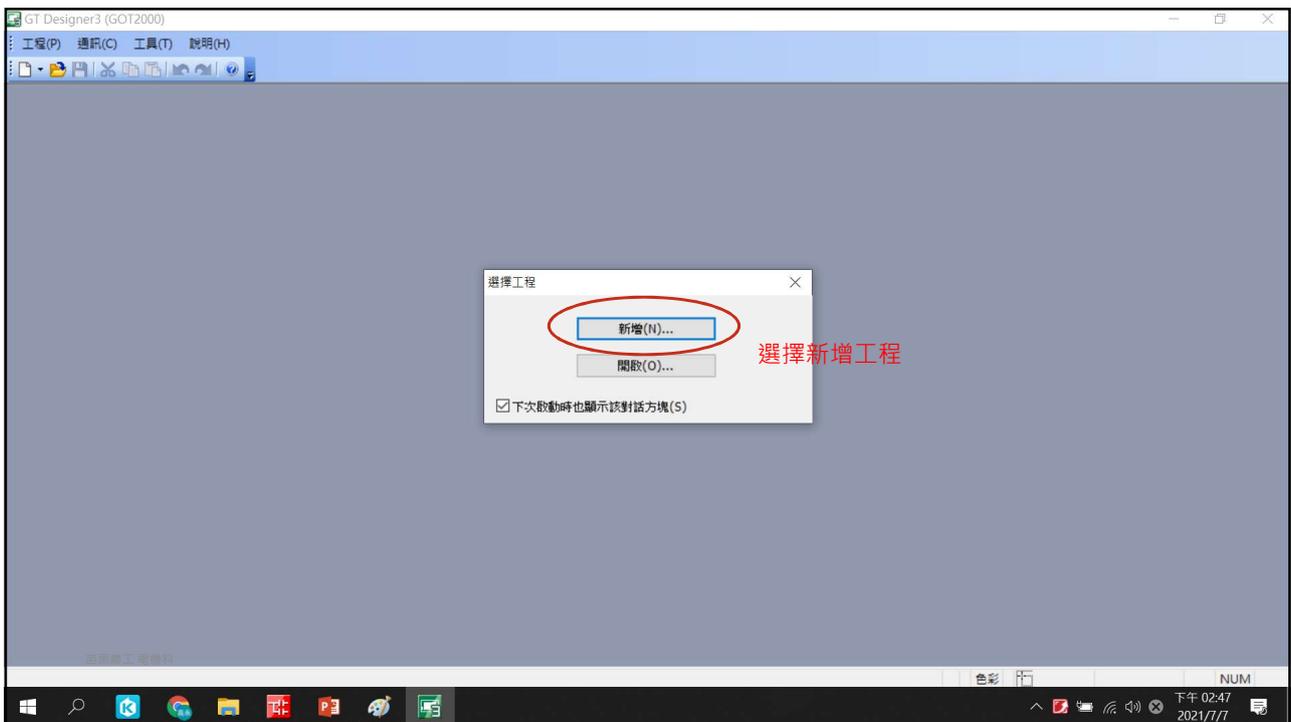
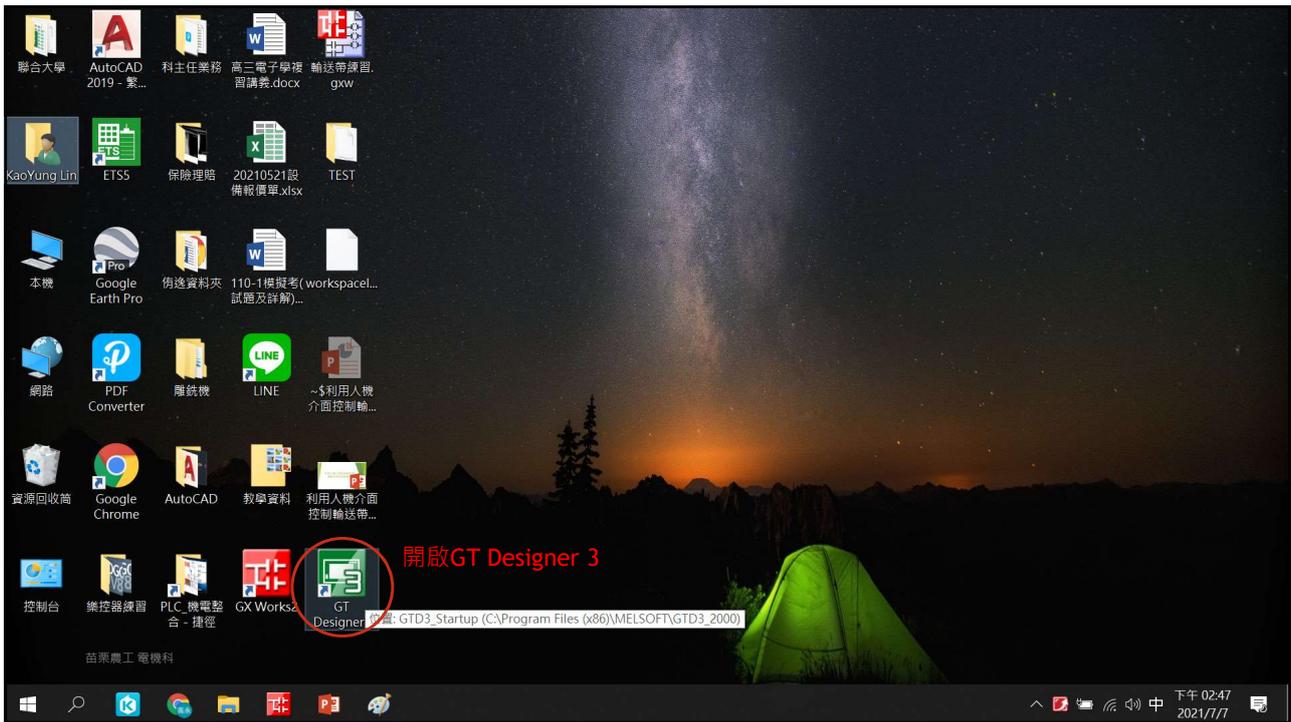
PLC程式傳輸

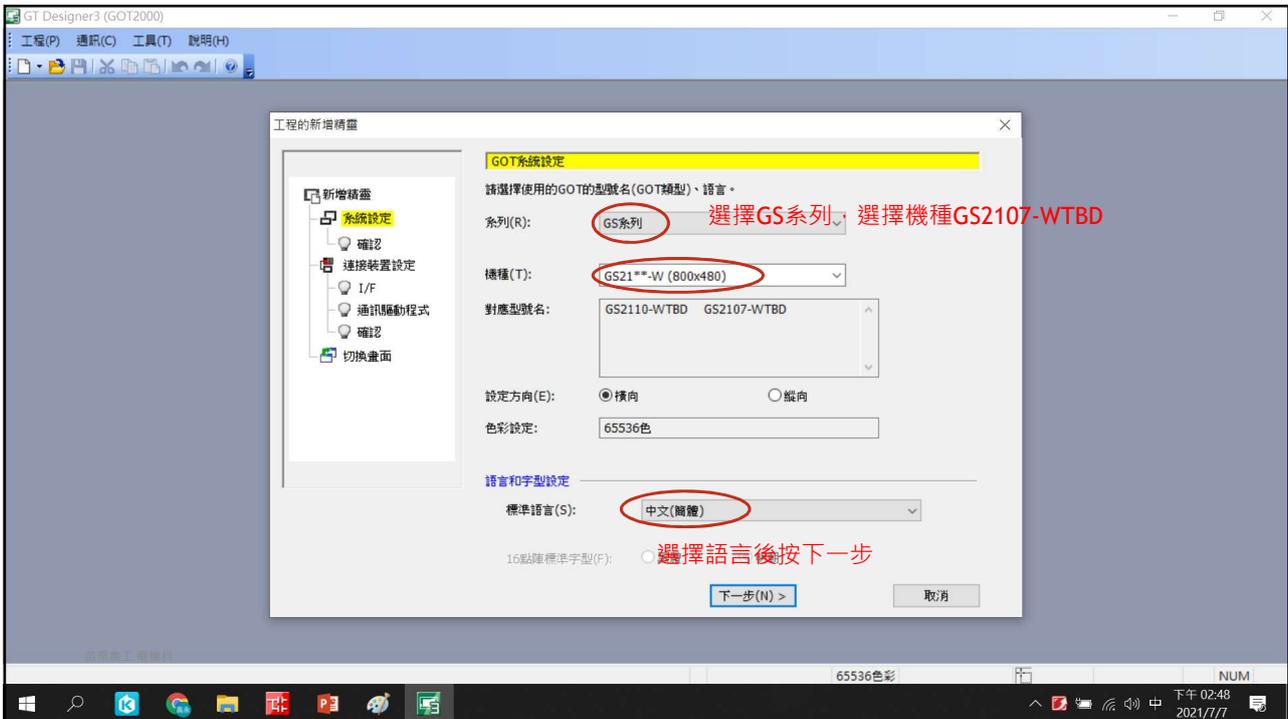
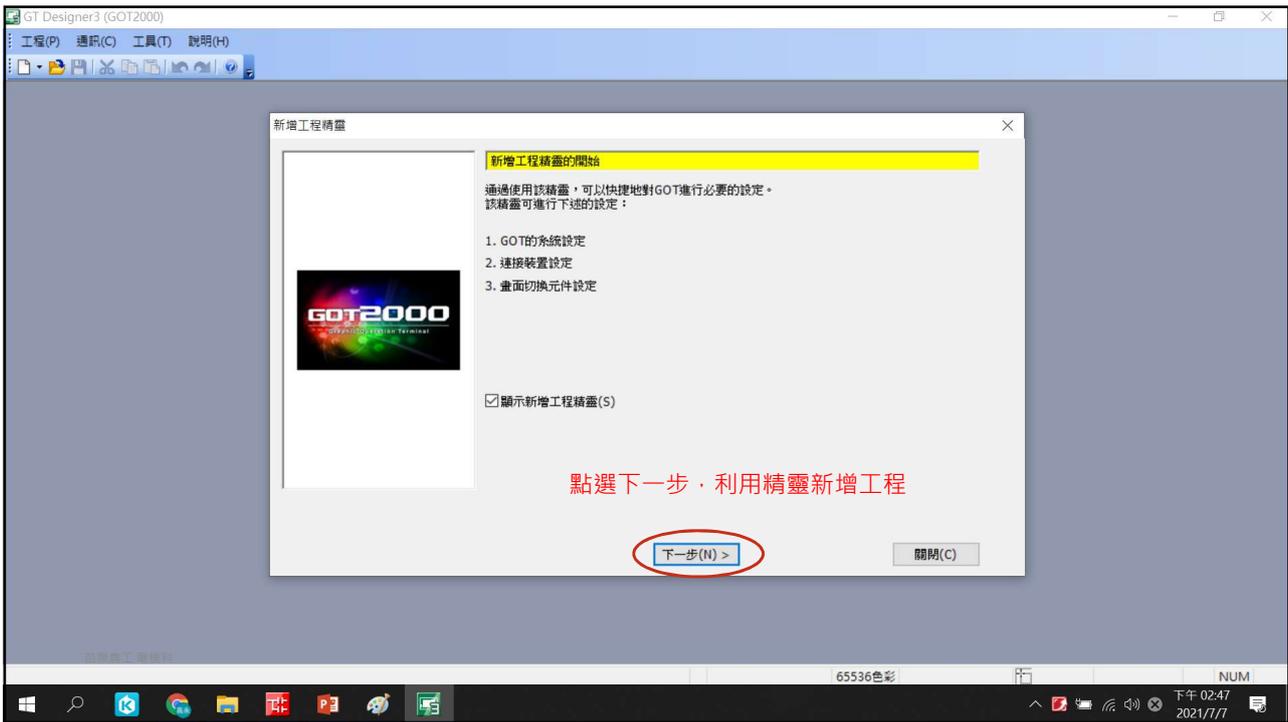


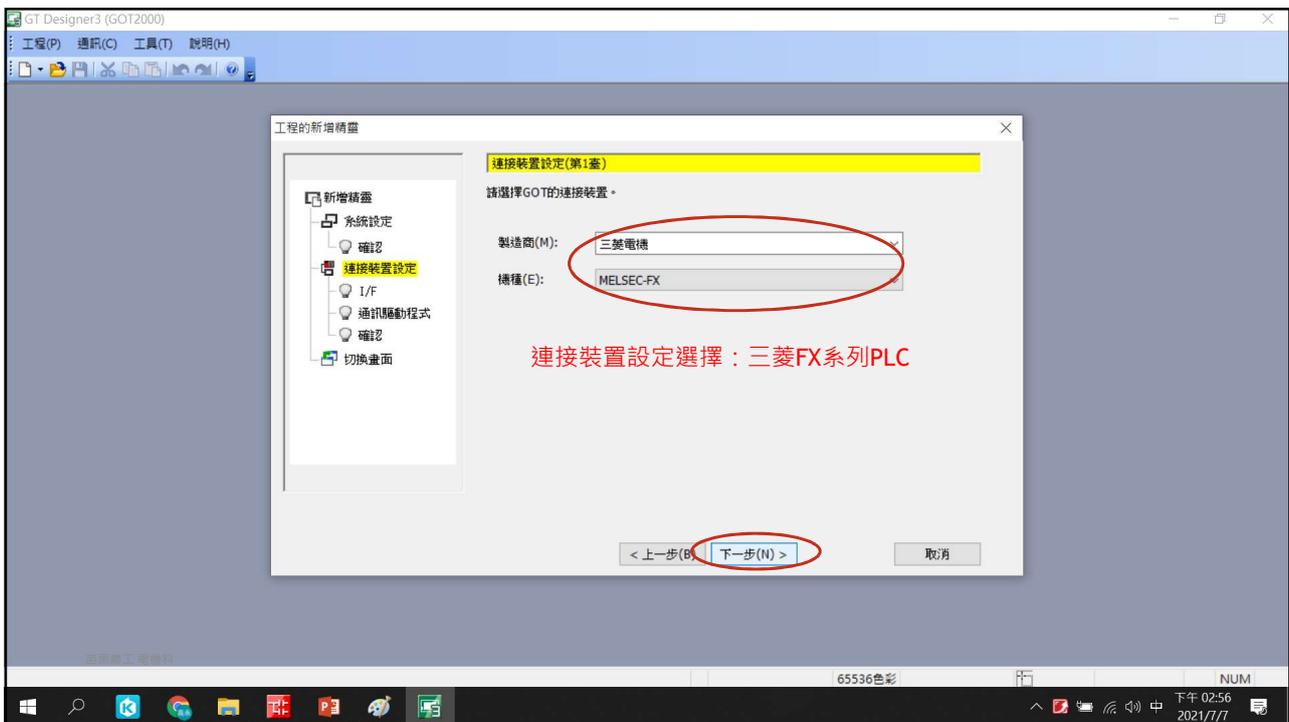
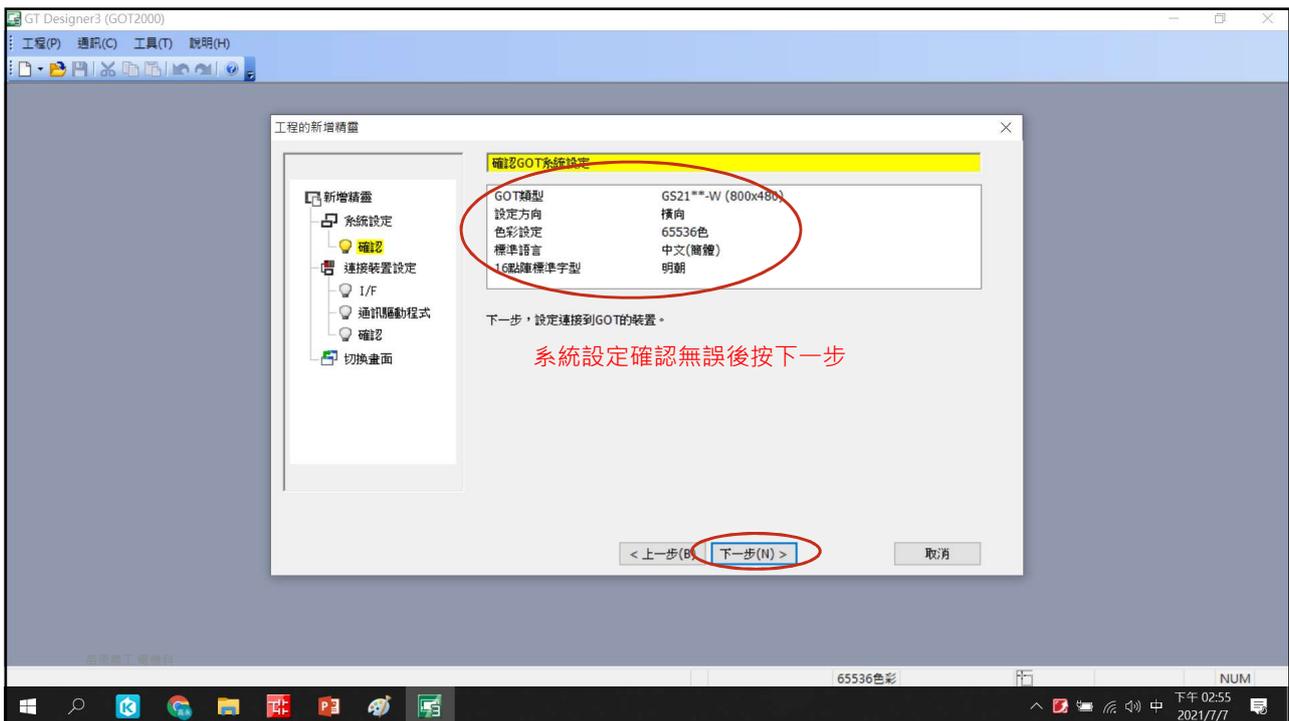


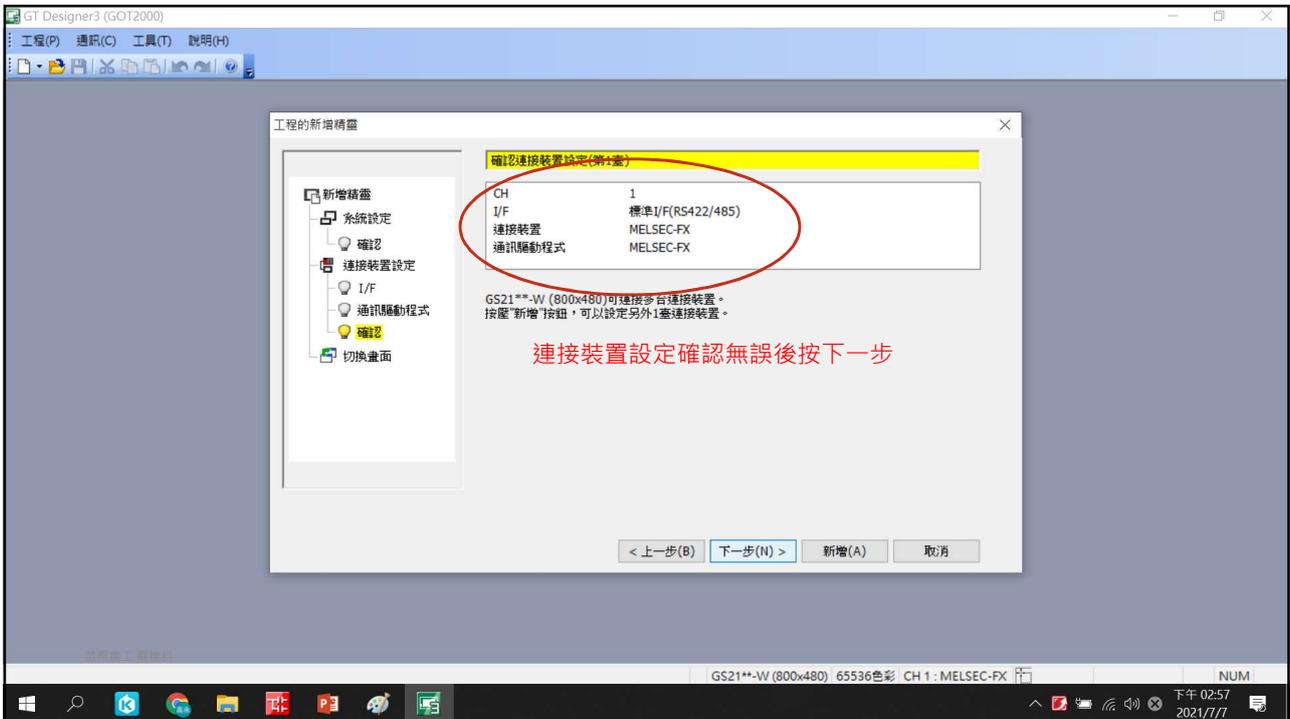
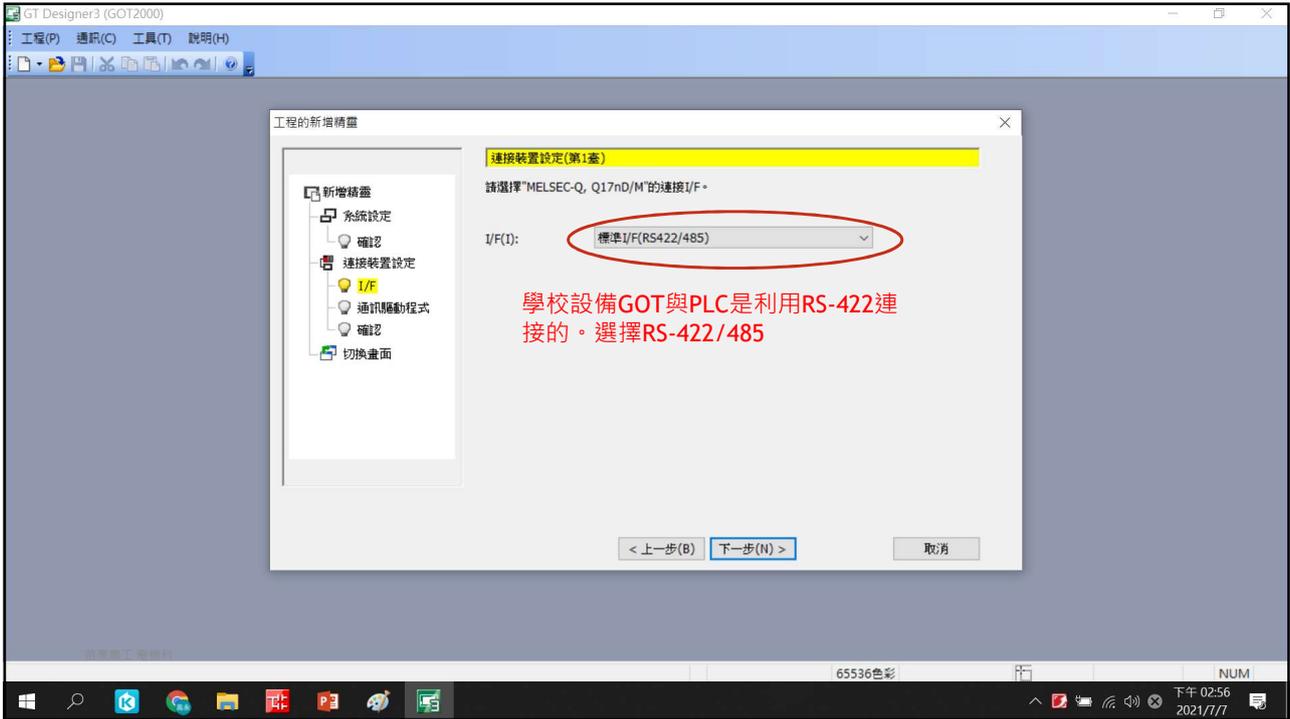


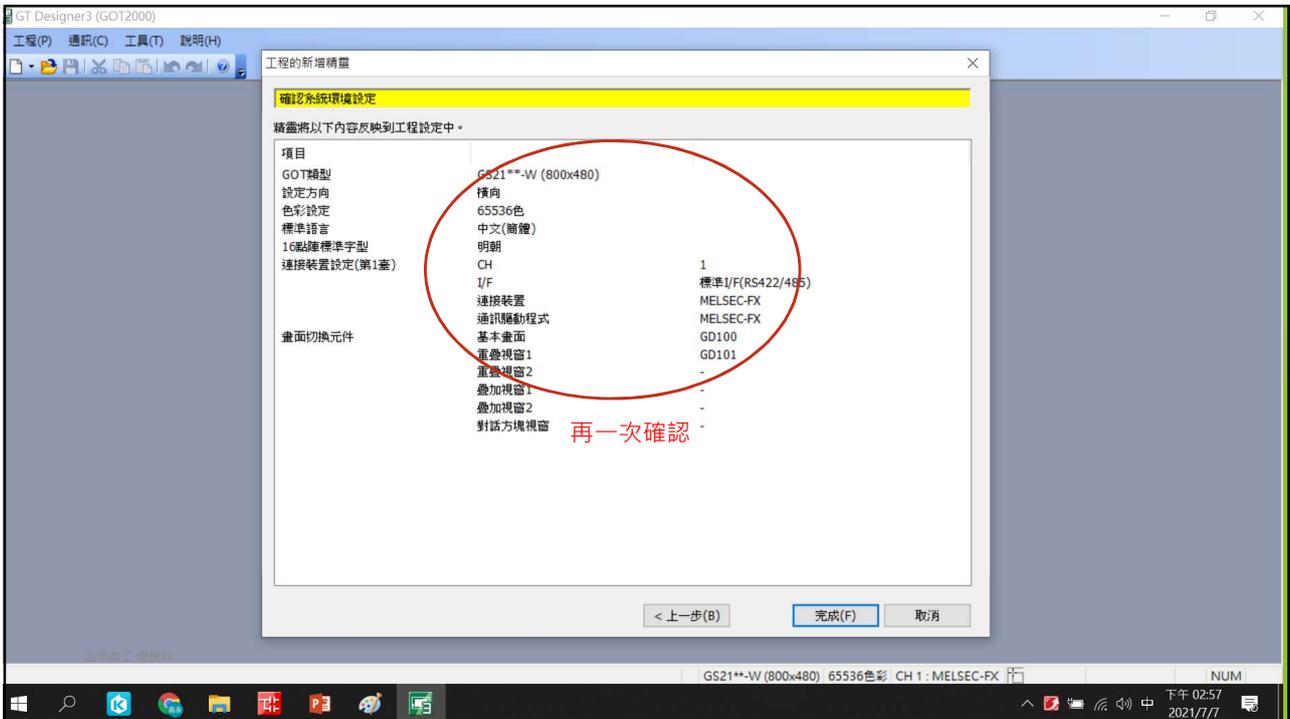
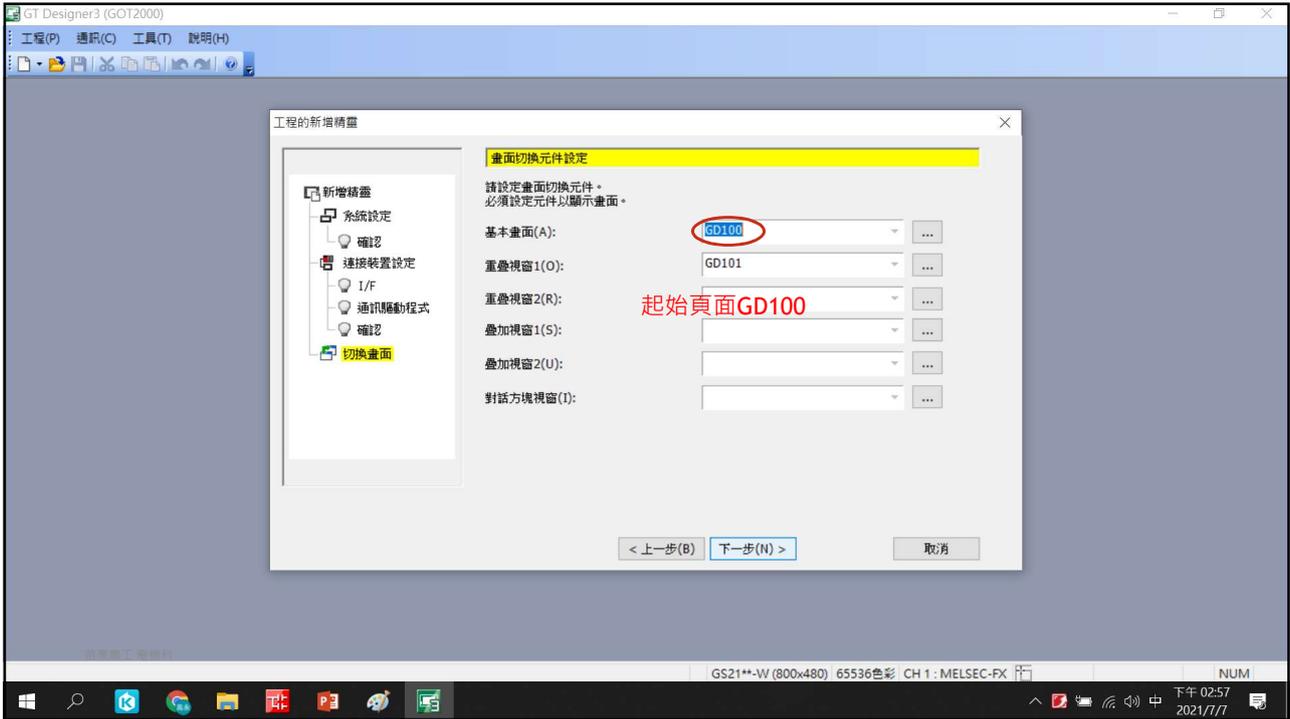
GOT程式編輯

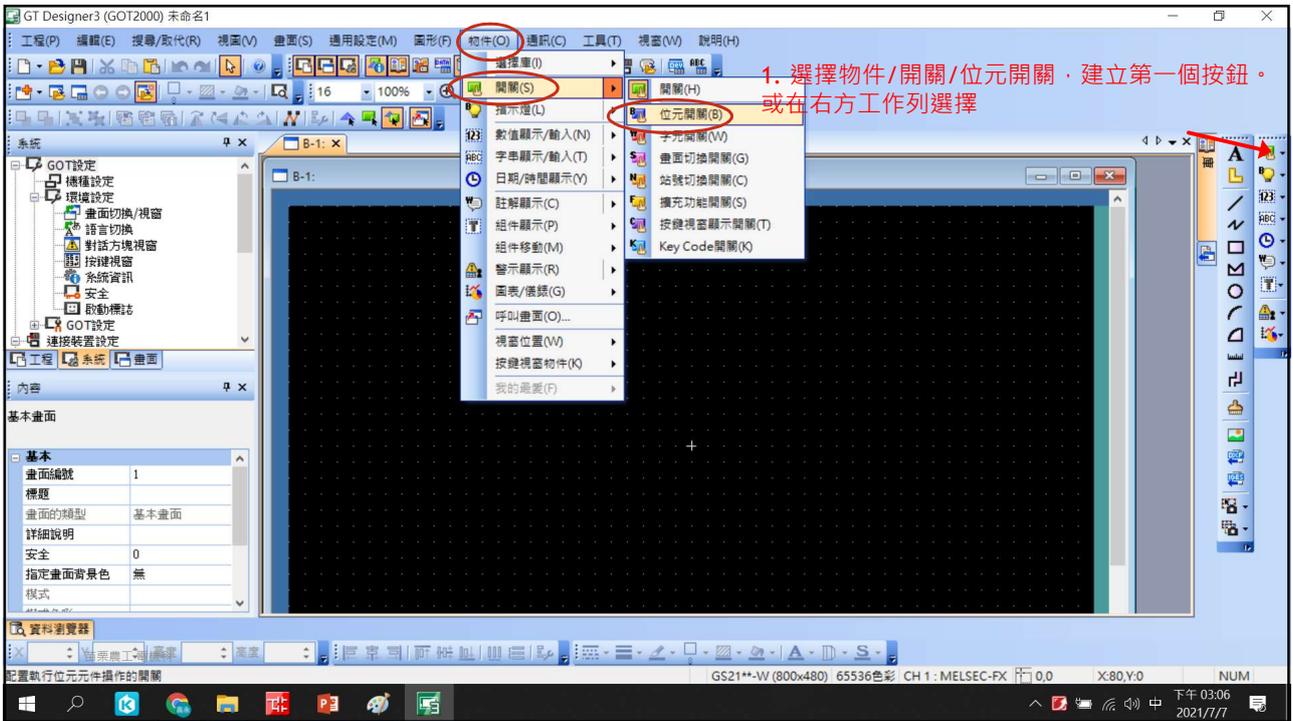
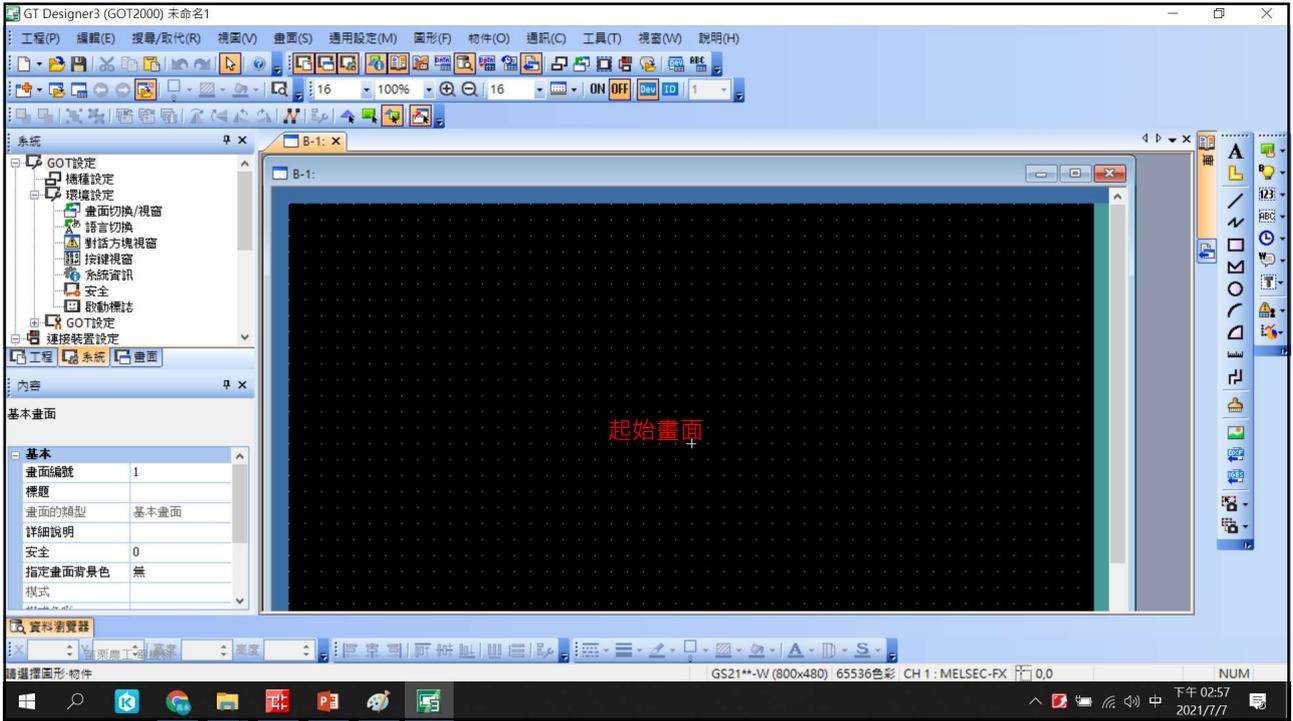


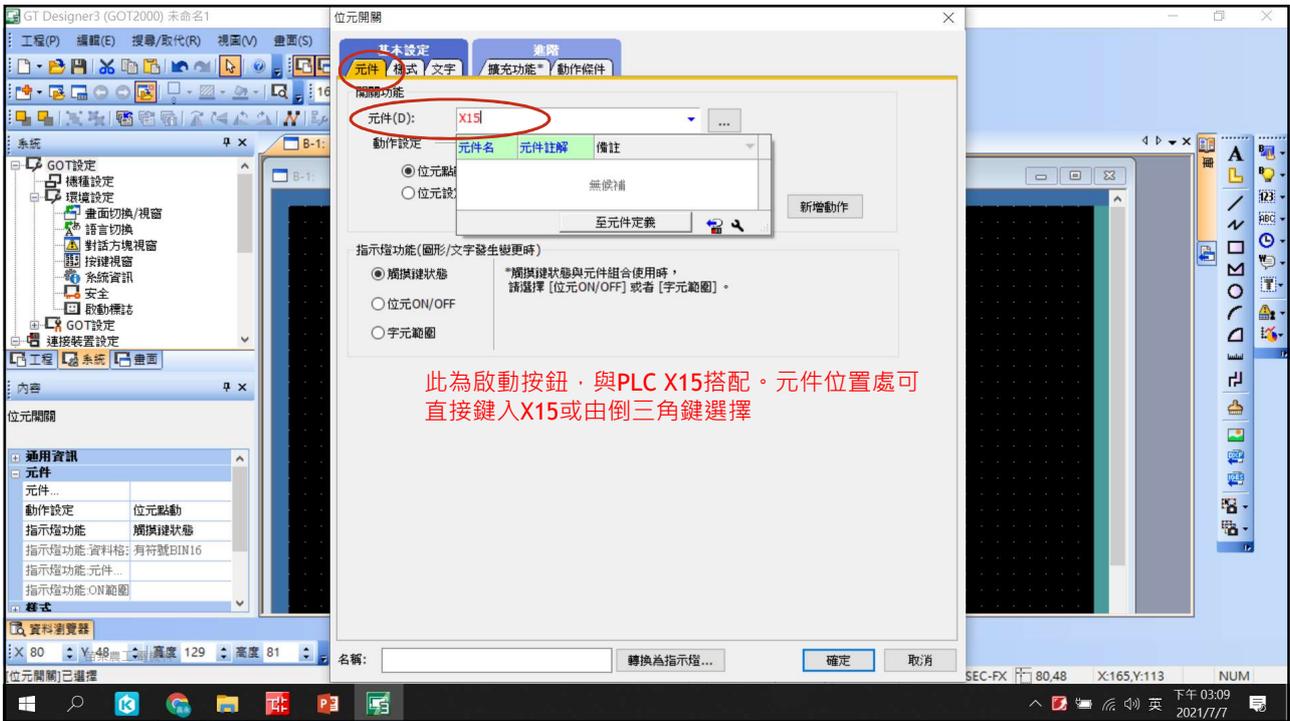
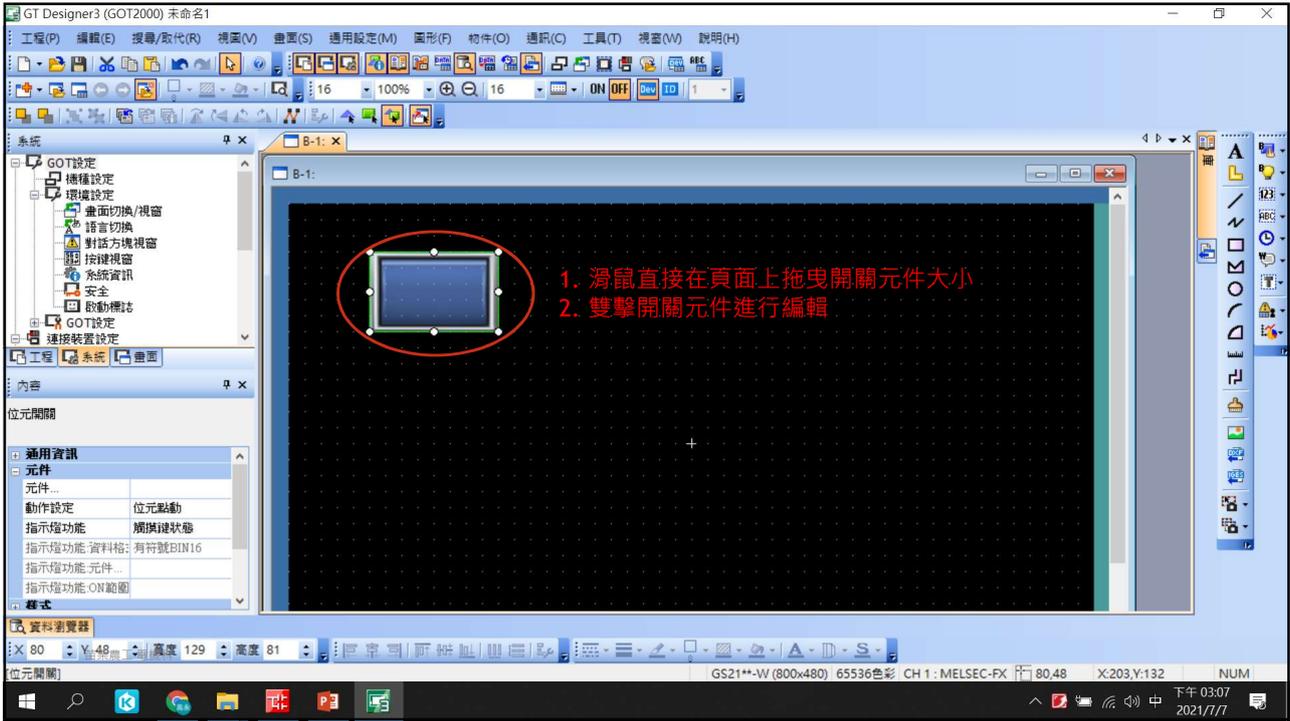


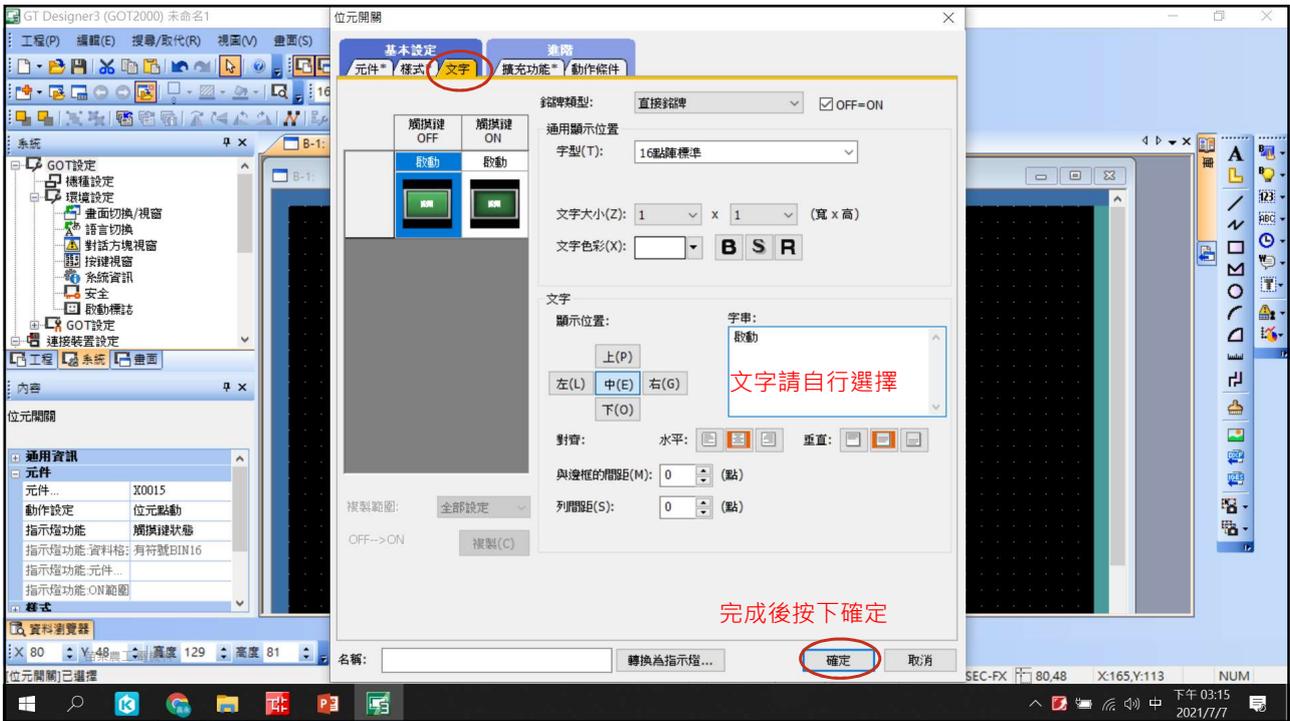
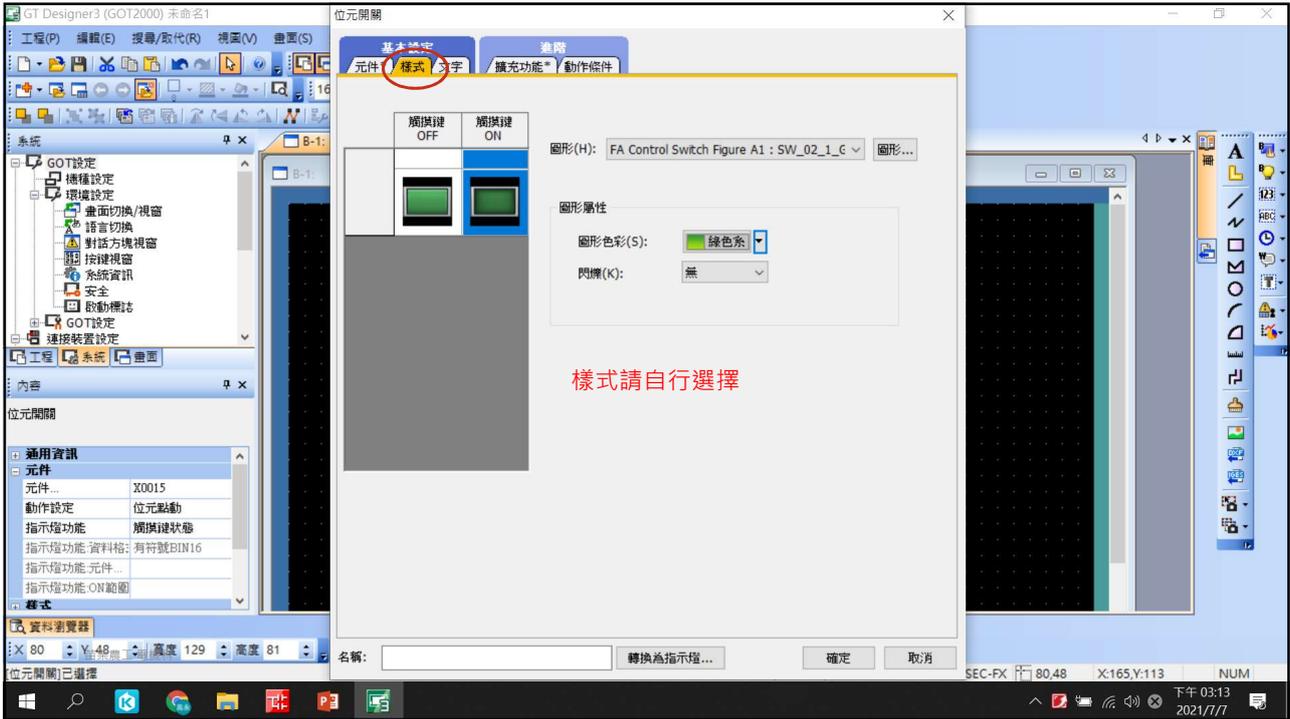


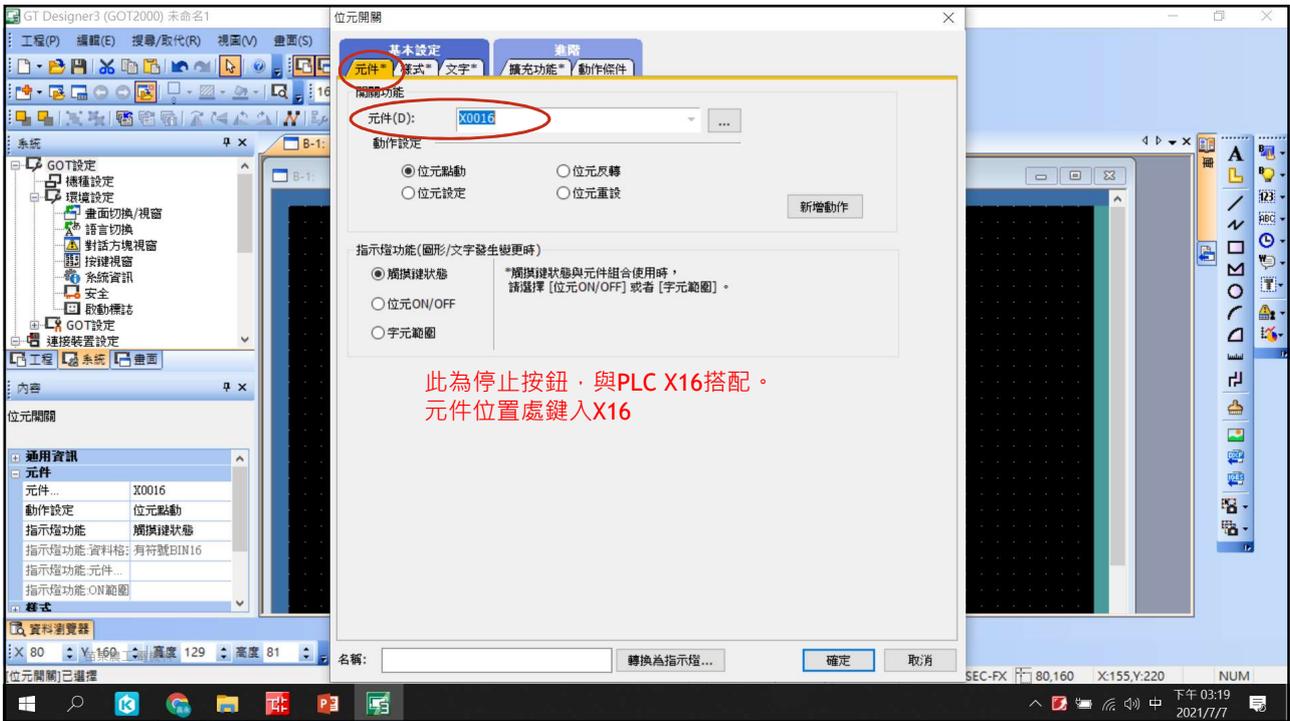
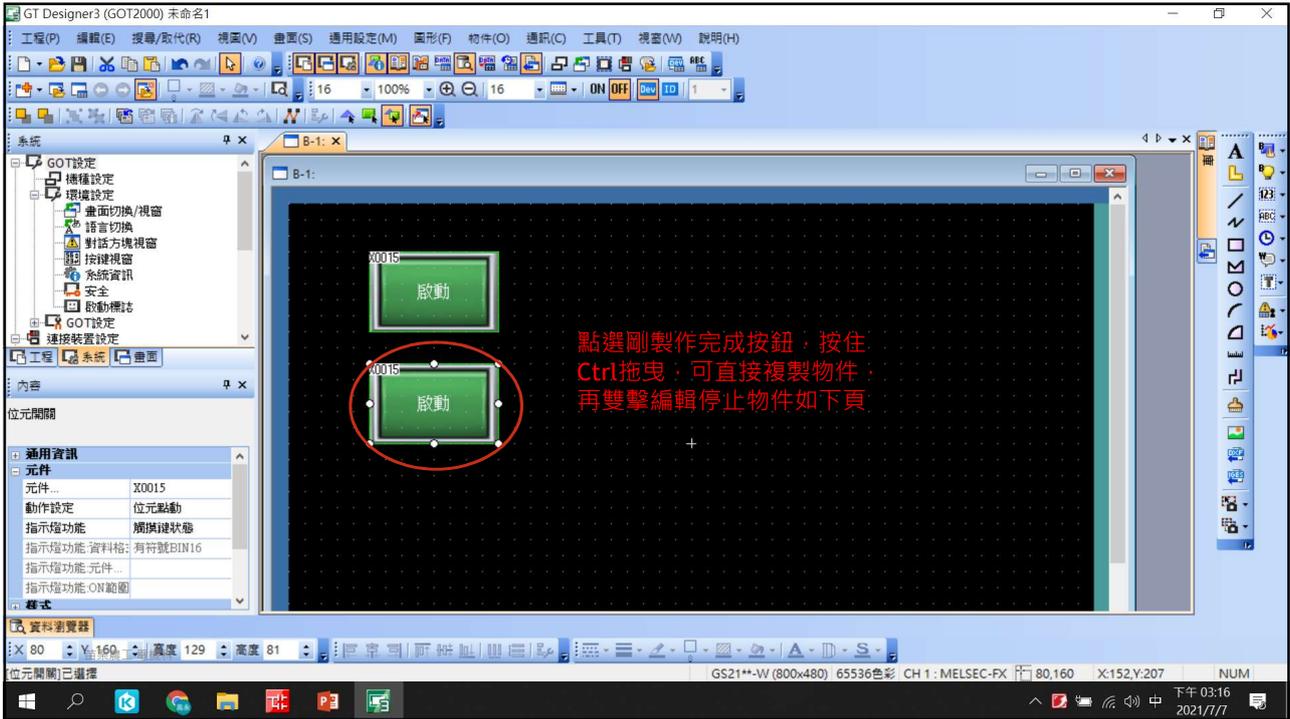


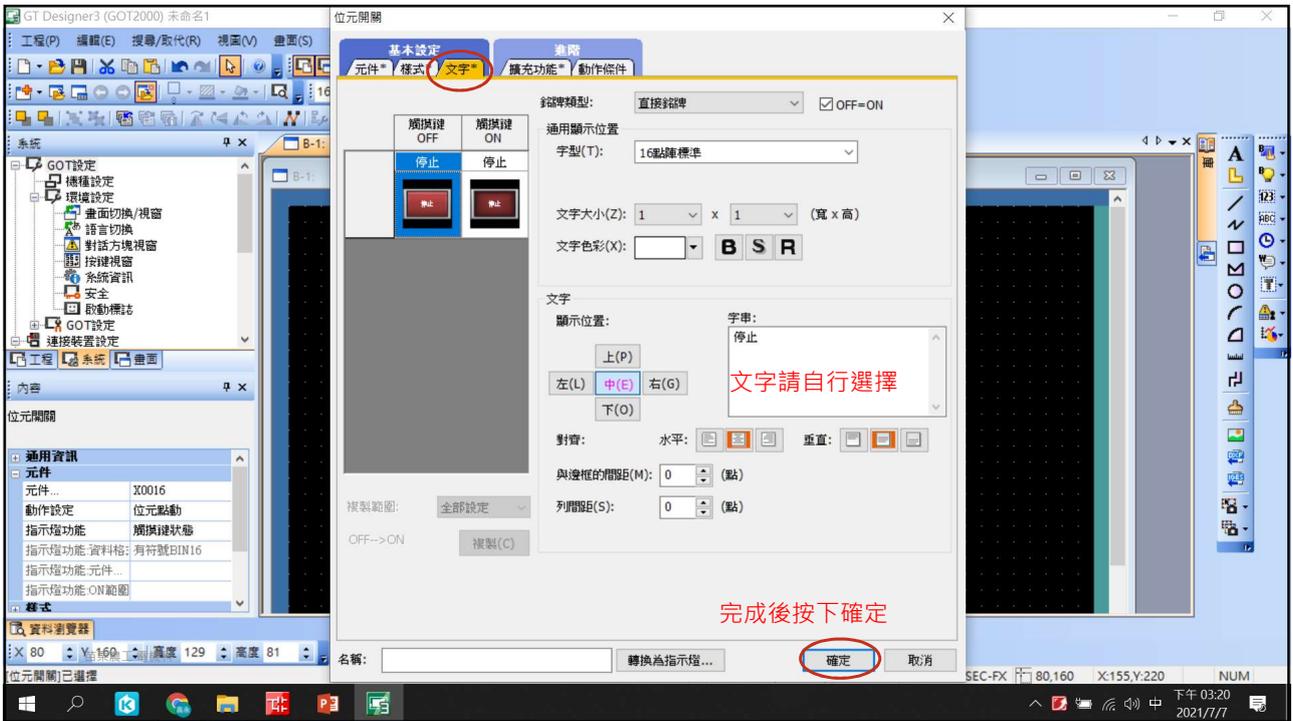
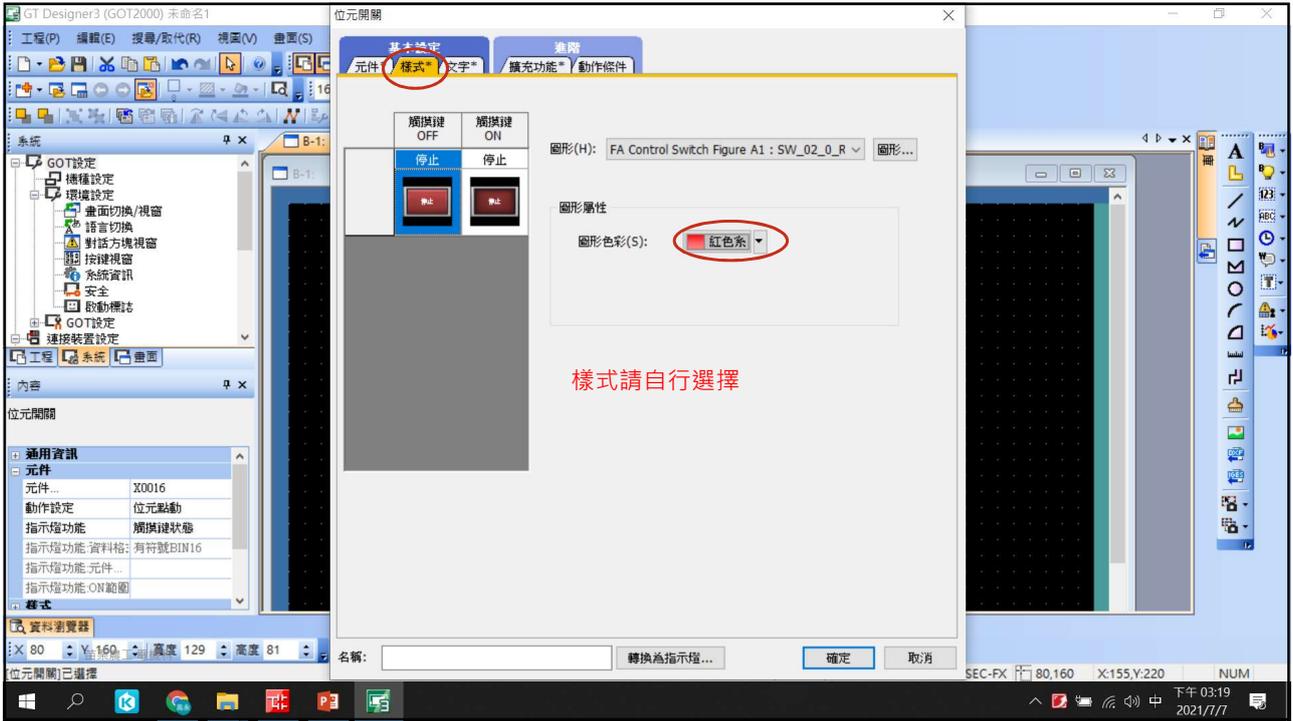


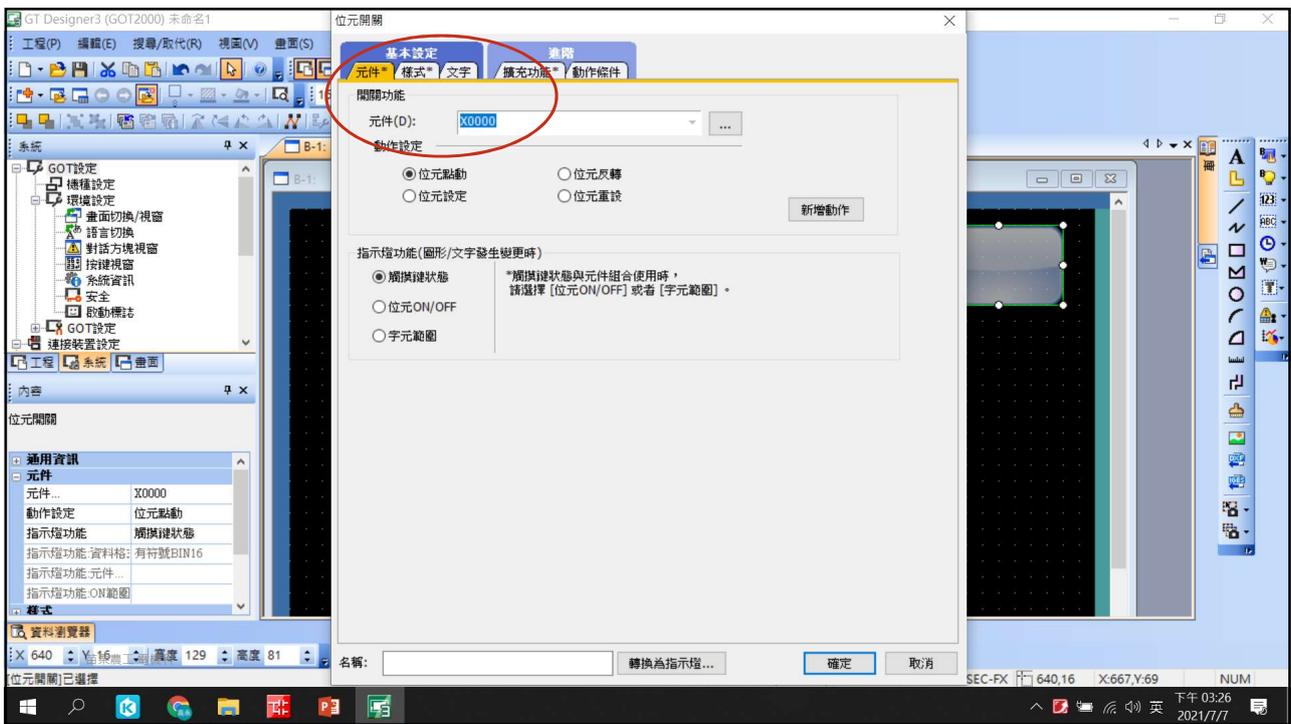
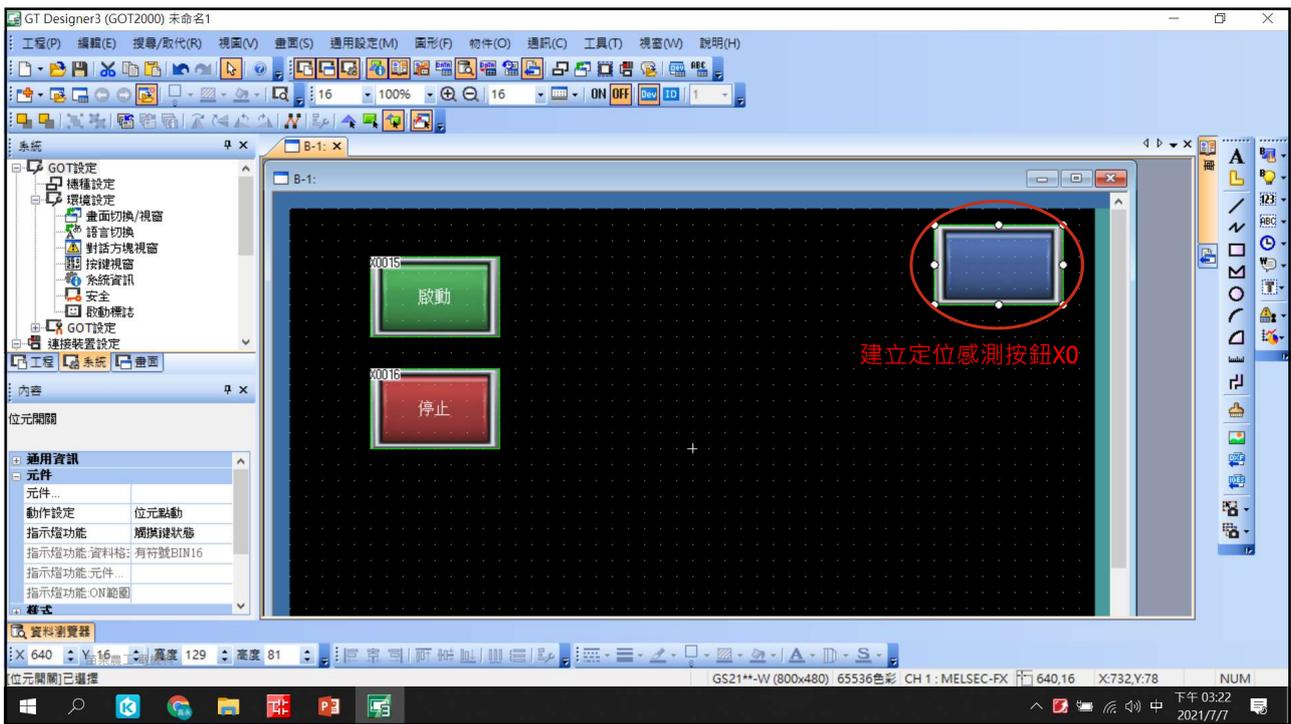


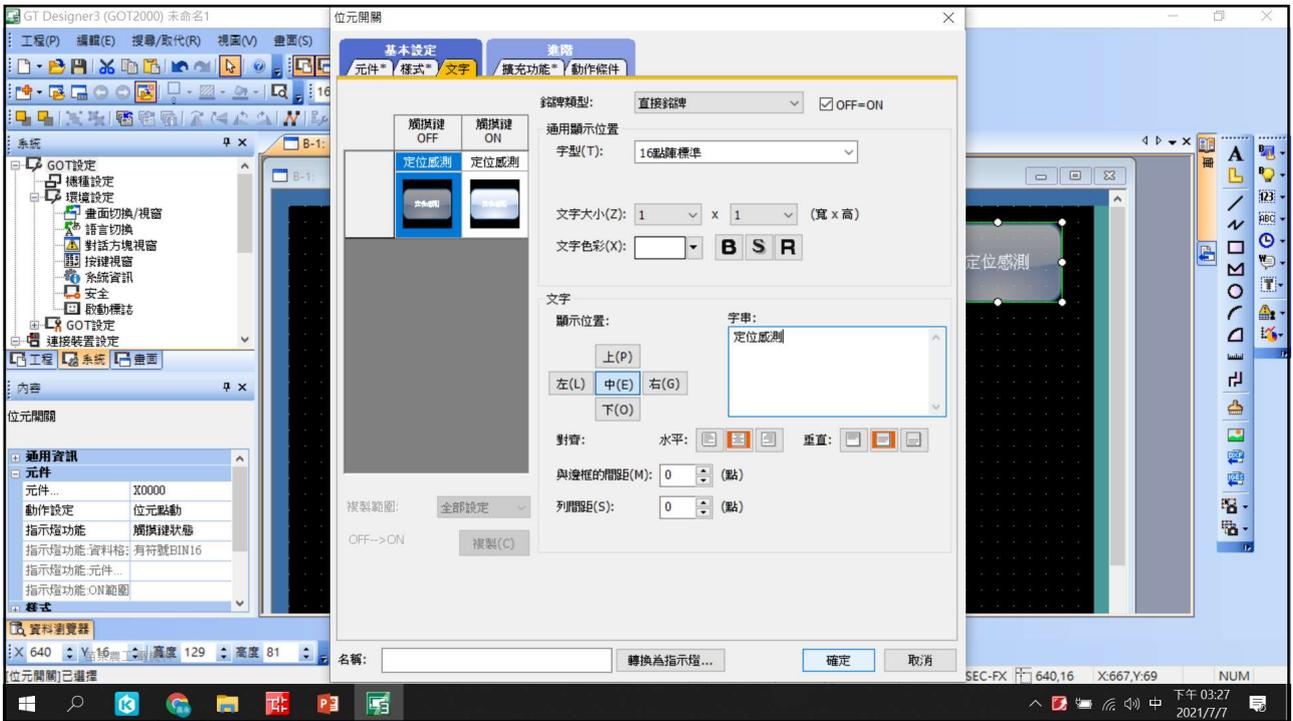
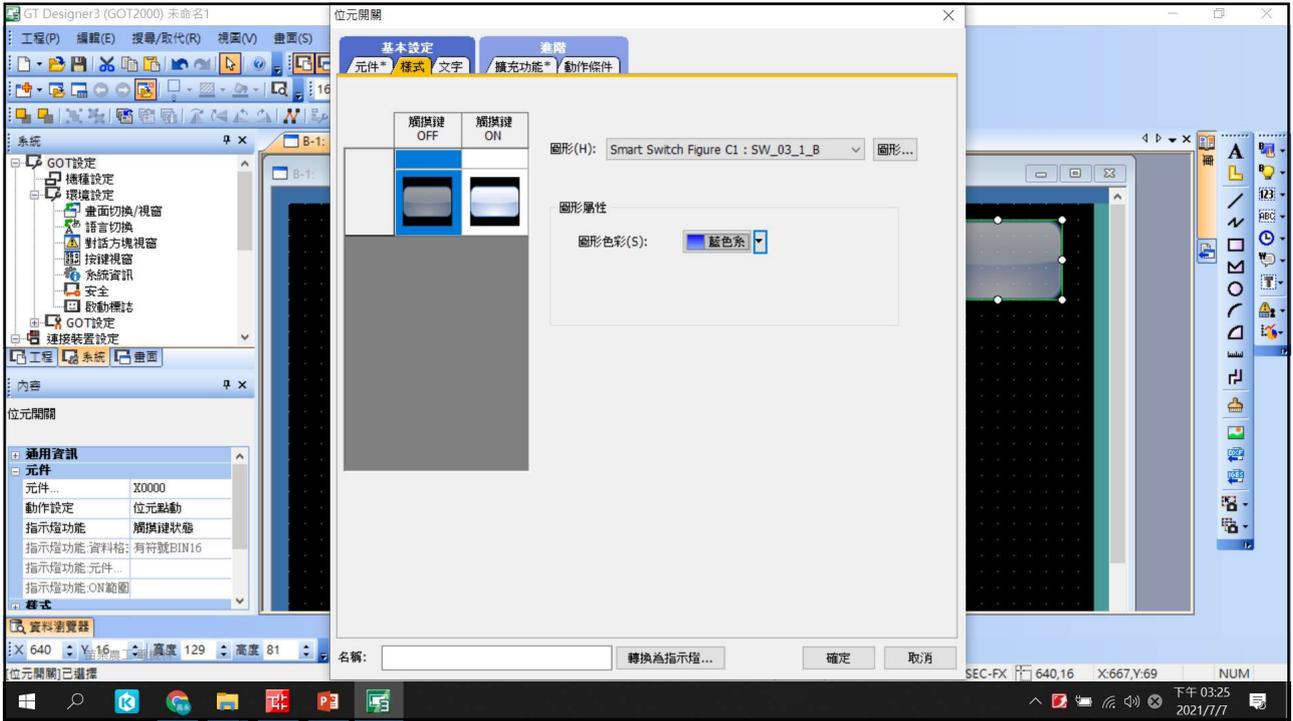


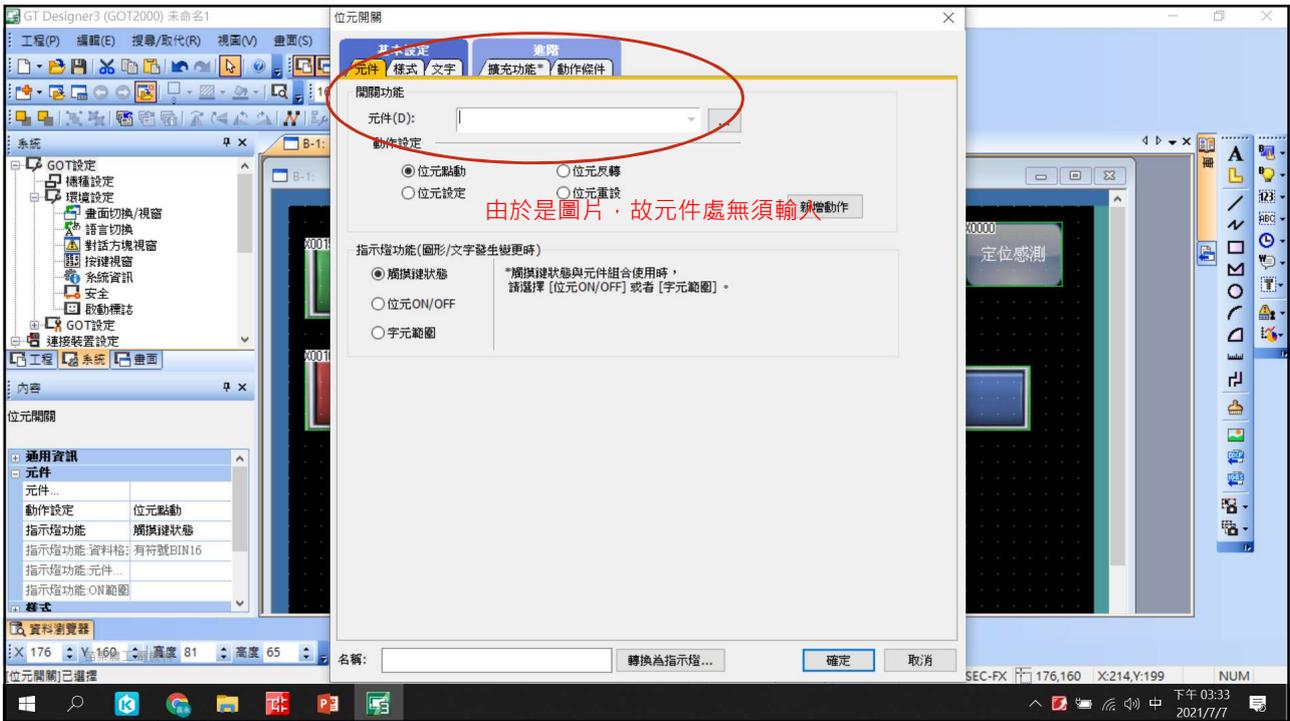
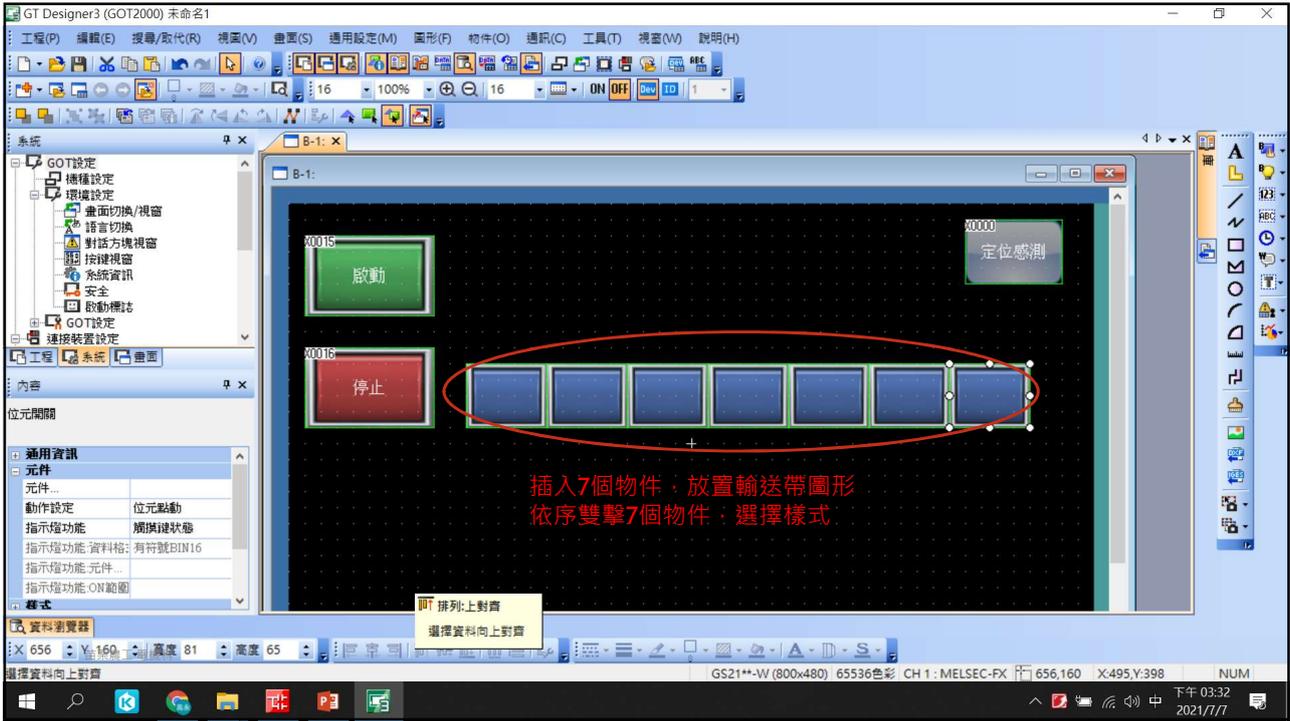


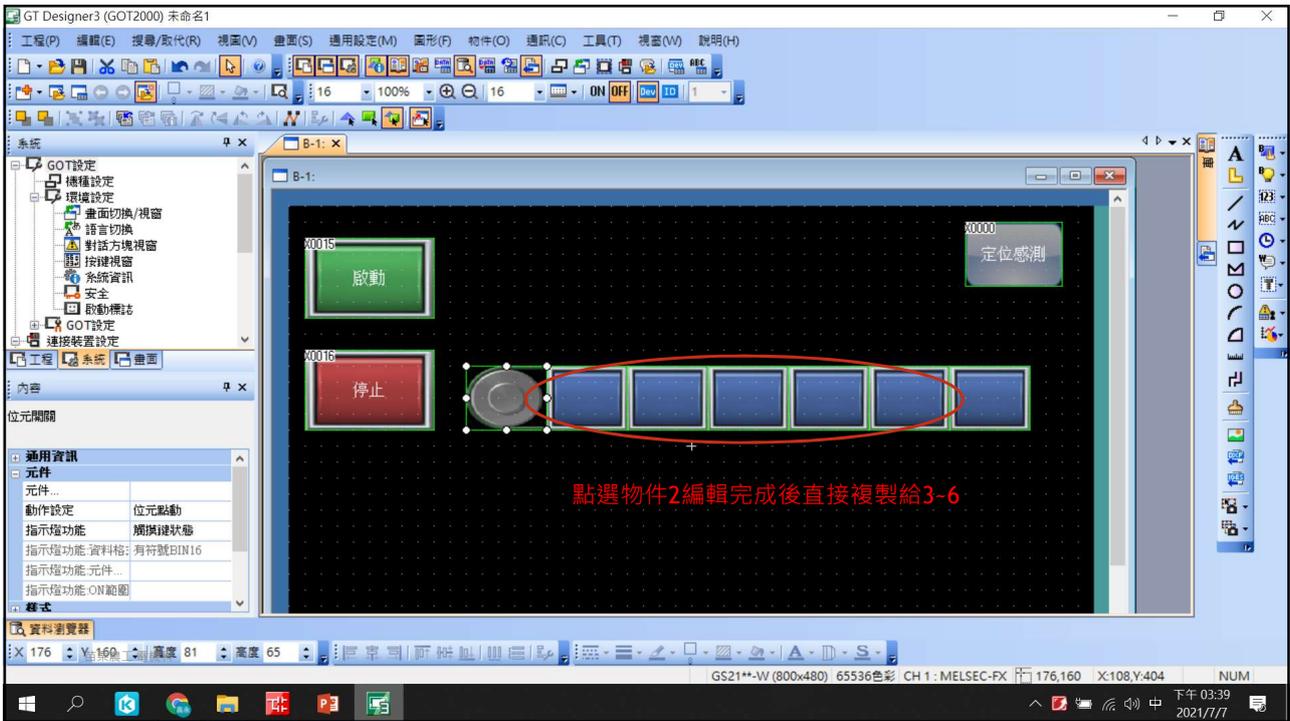
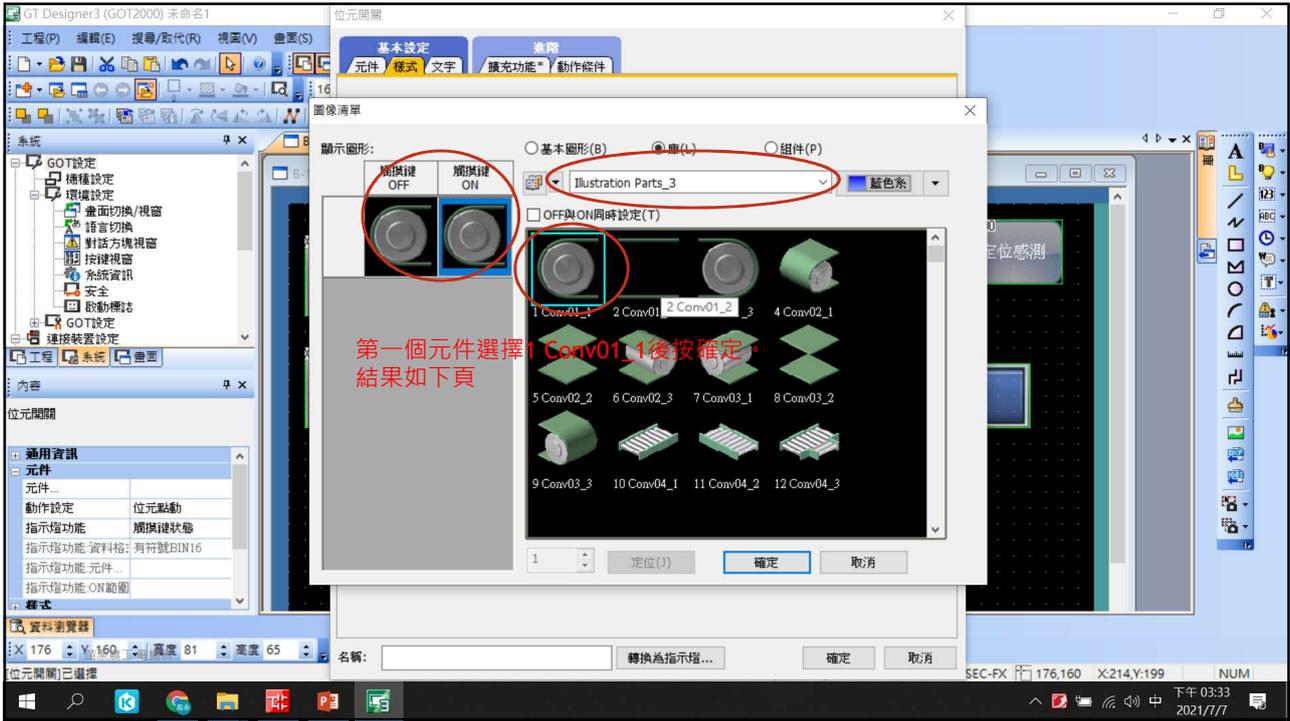


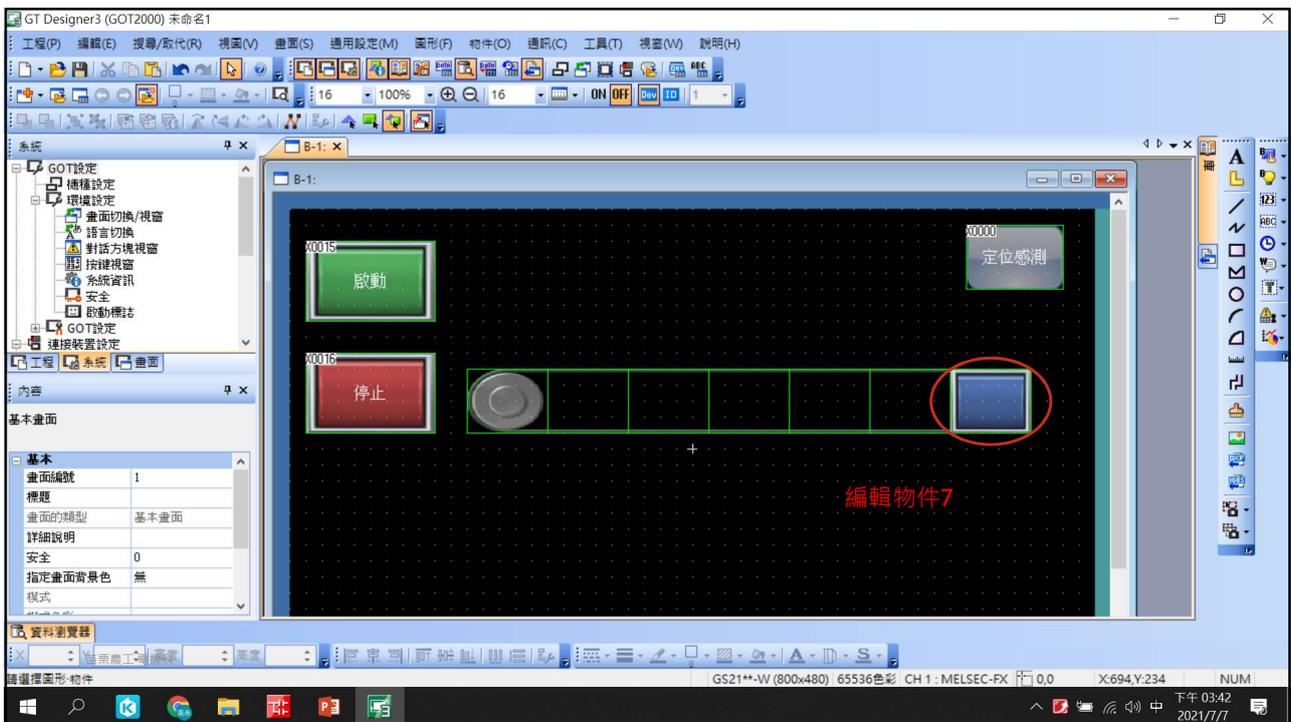
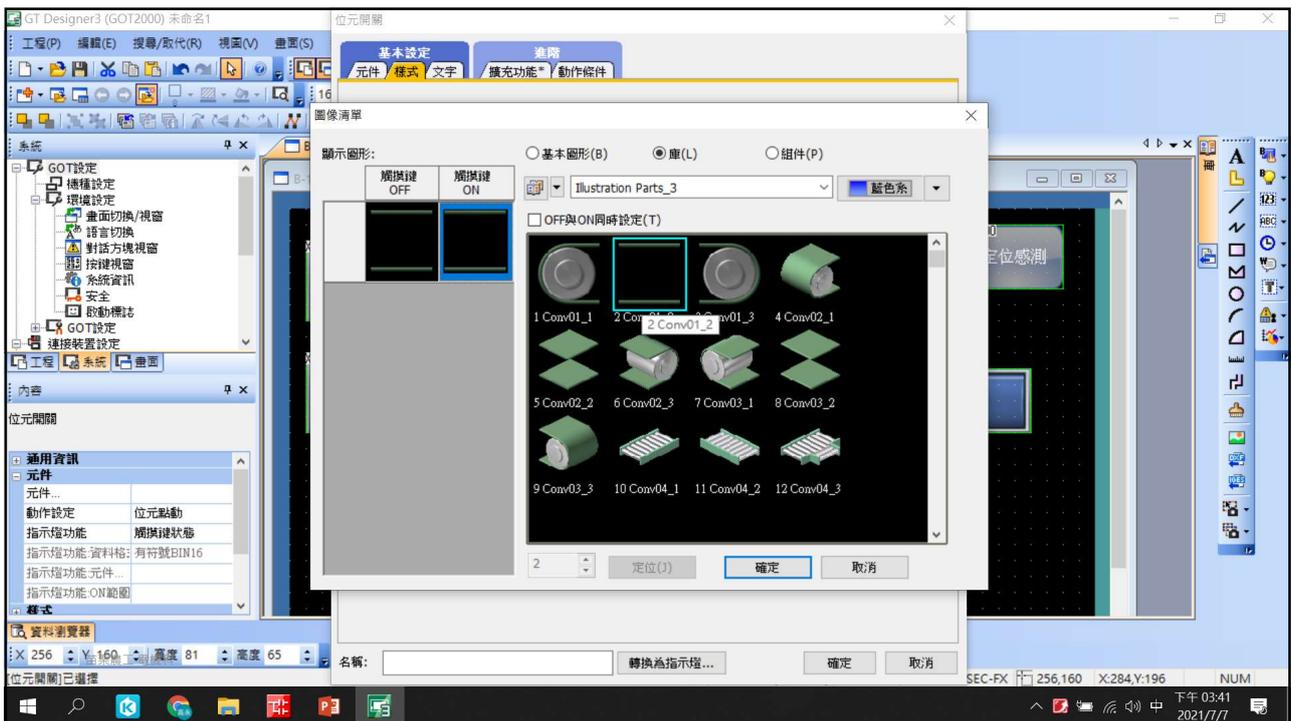


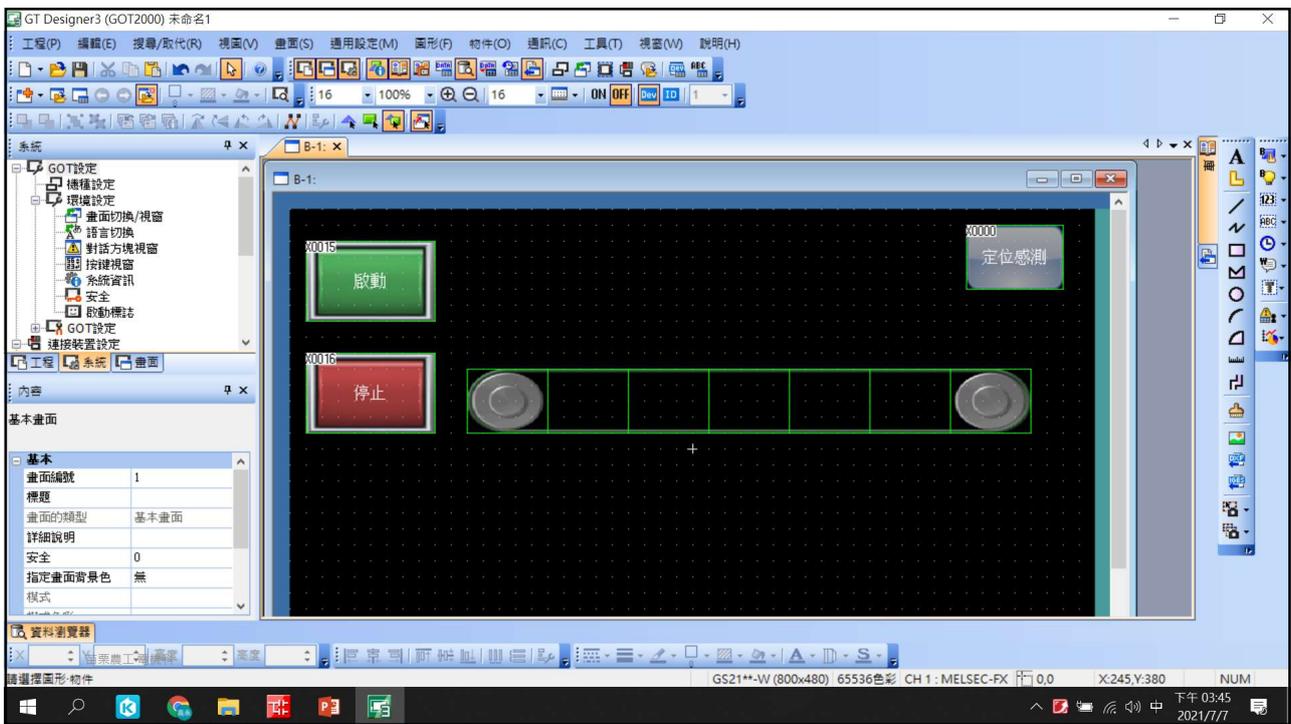
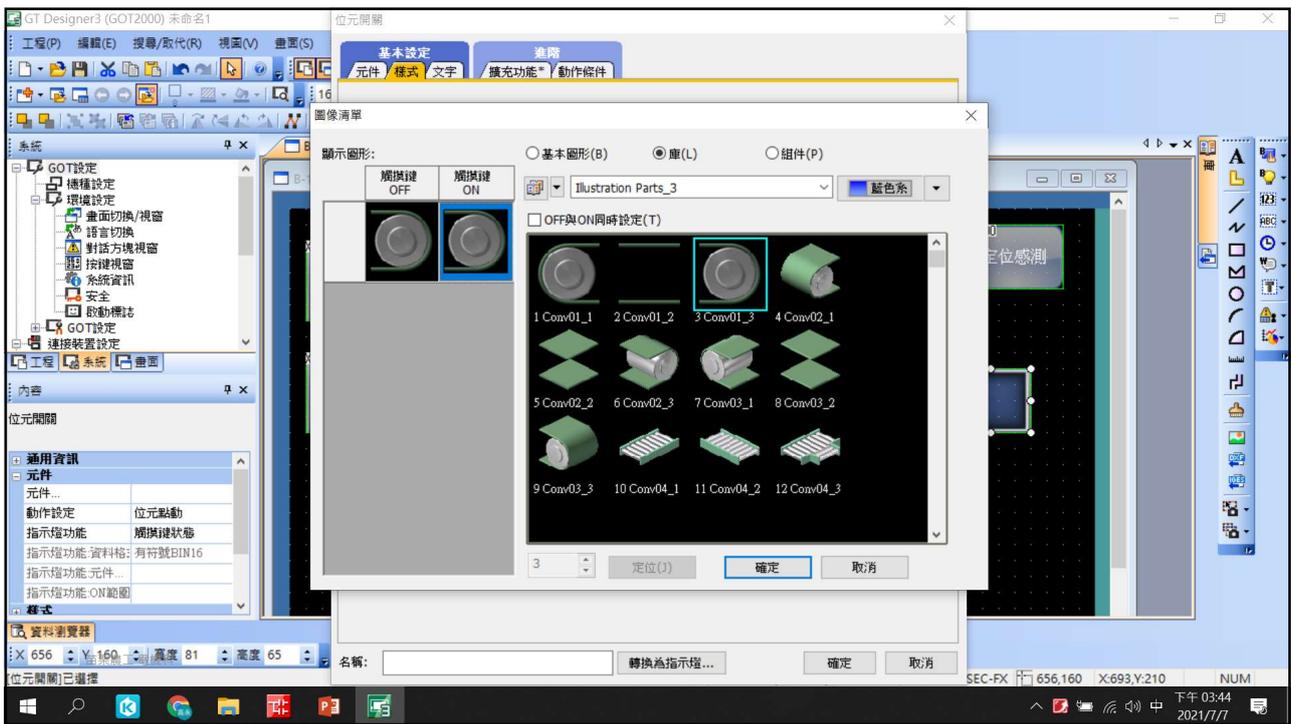


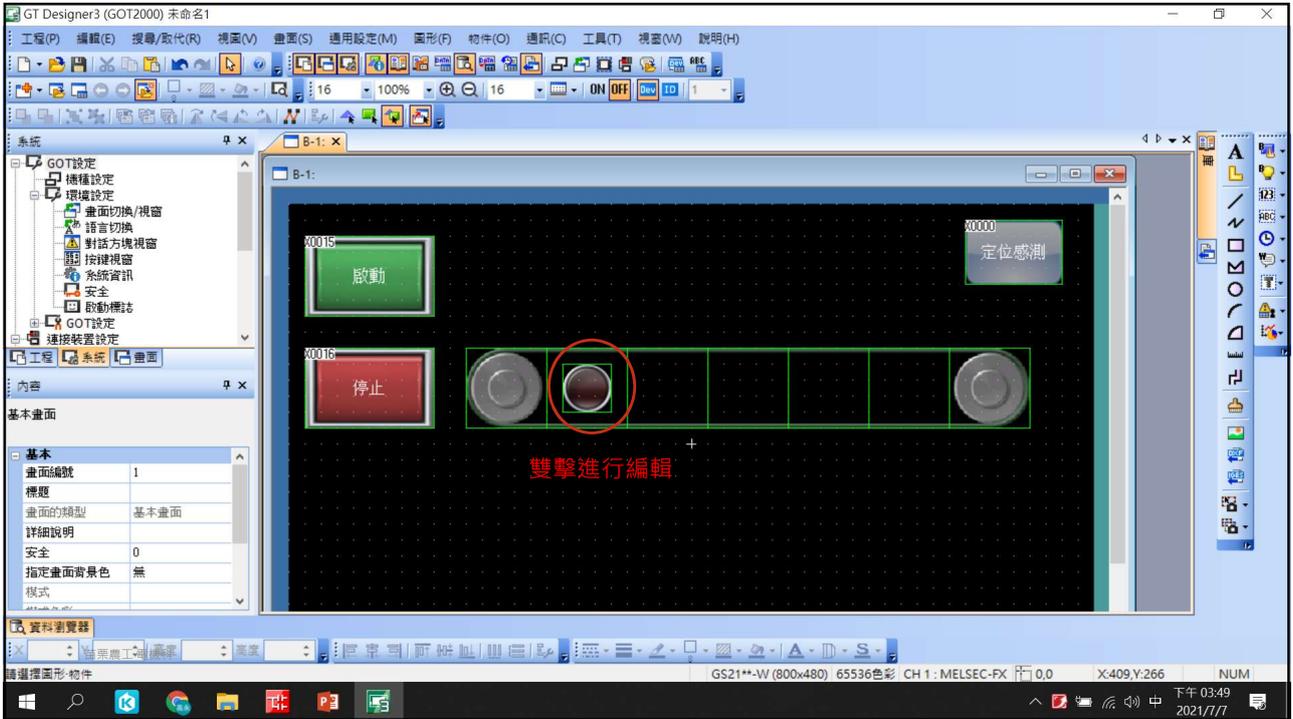
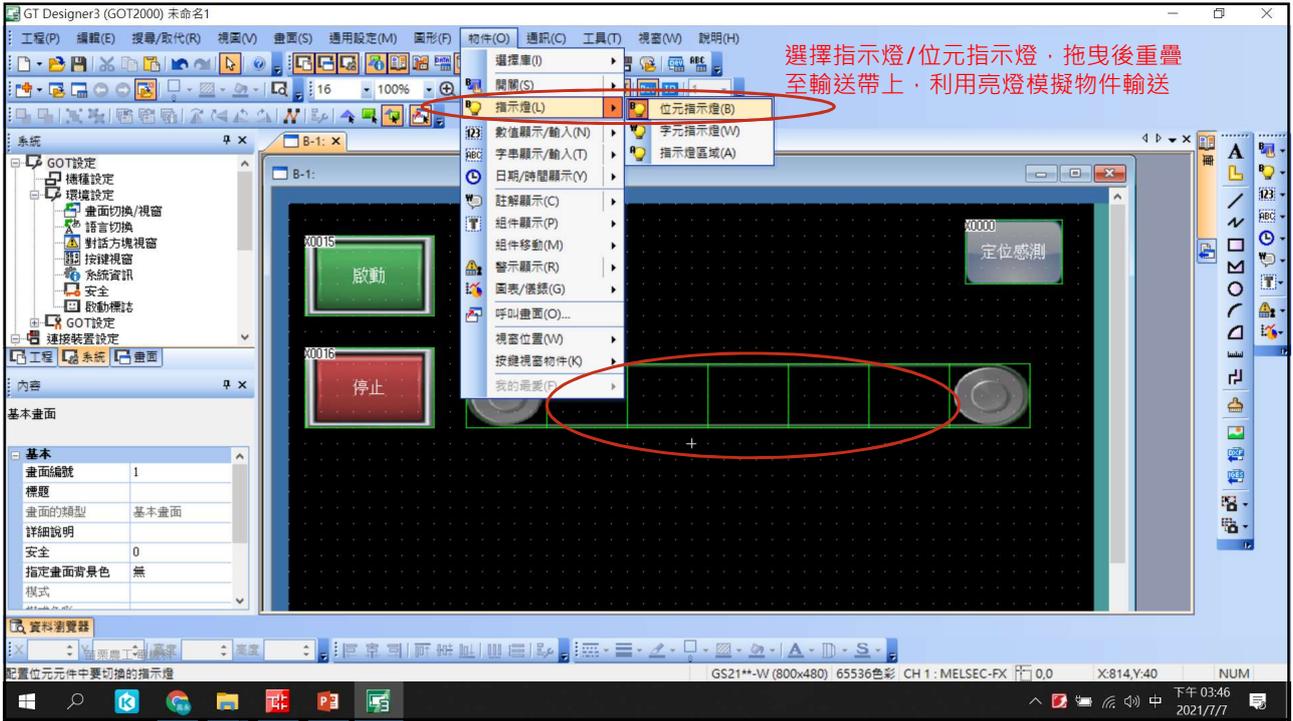




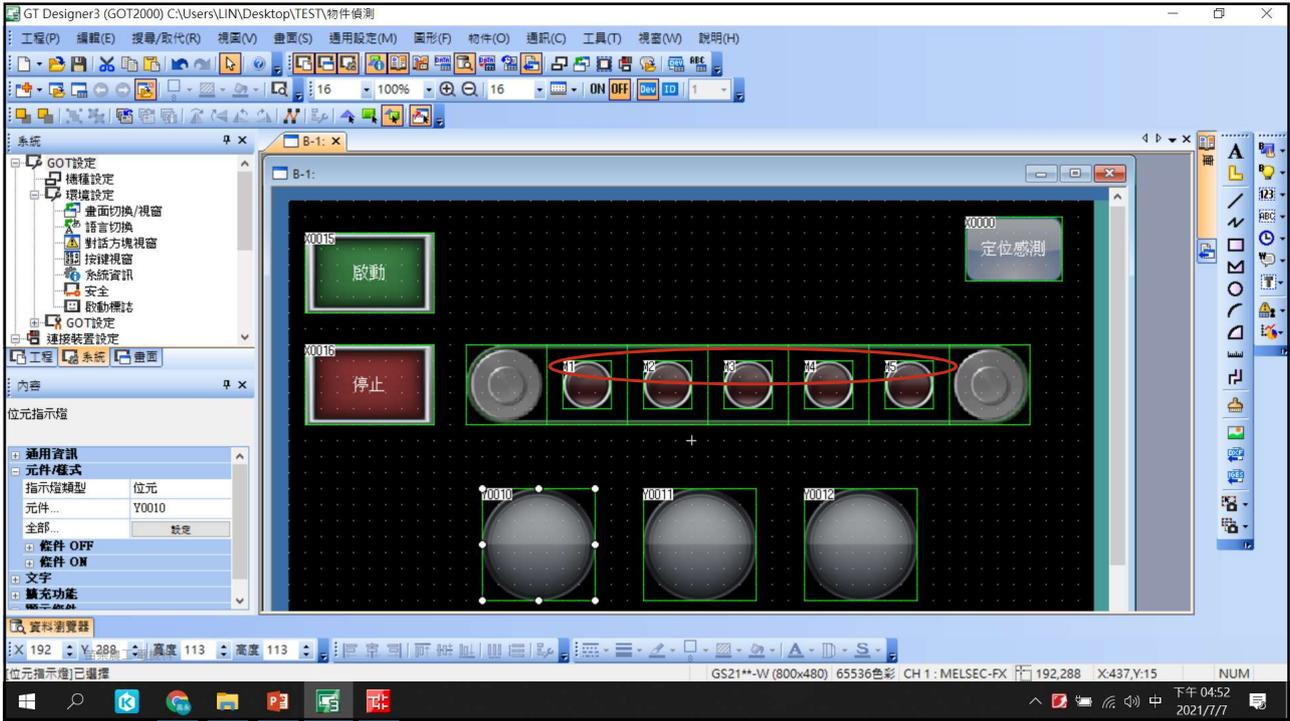


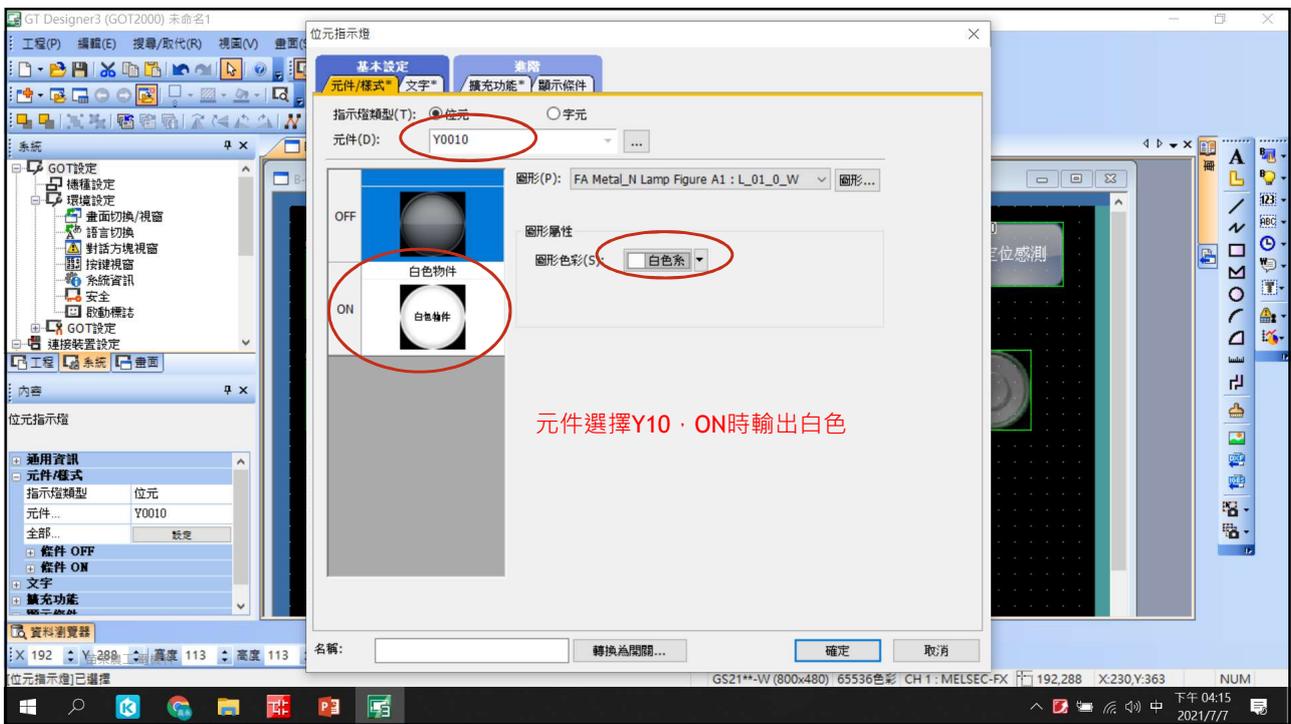
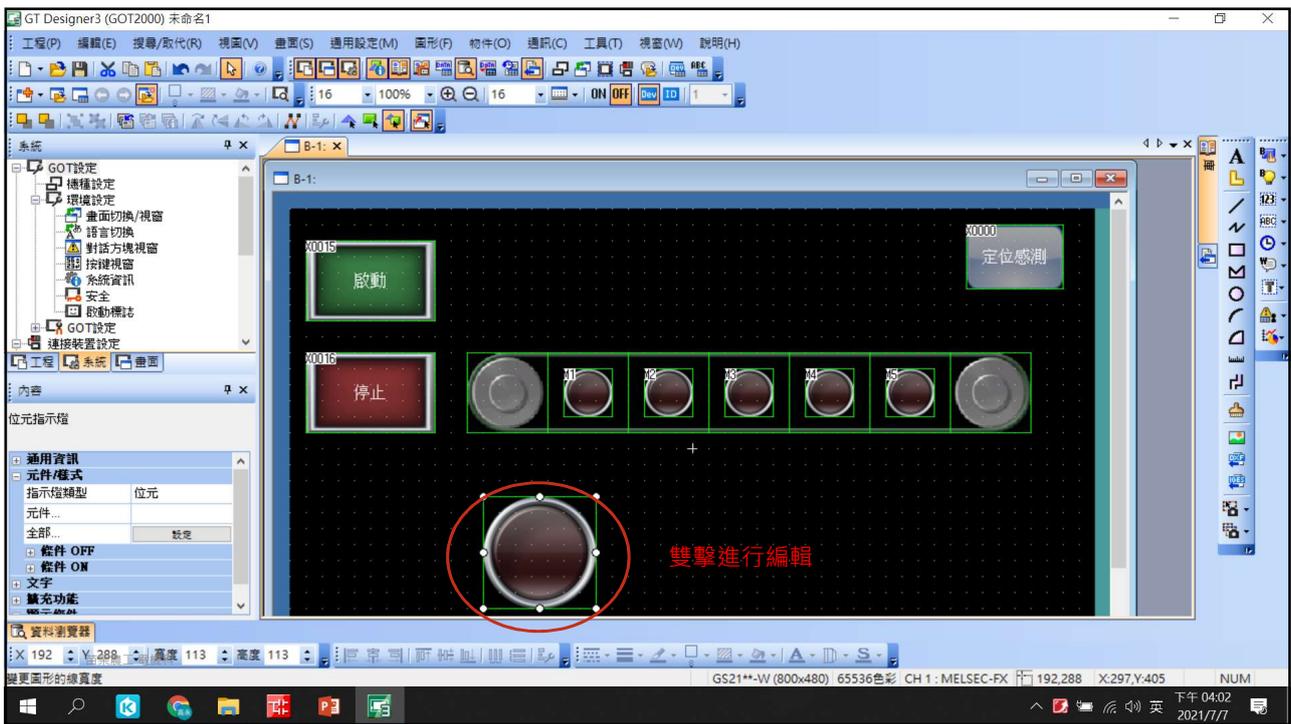


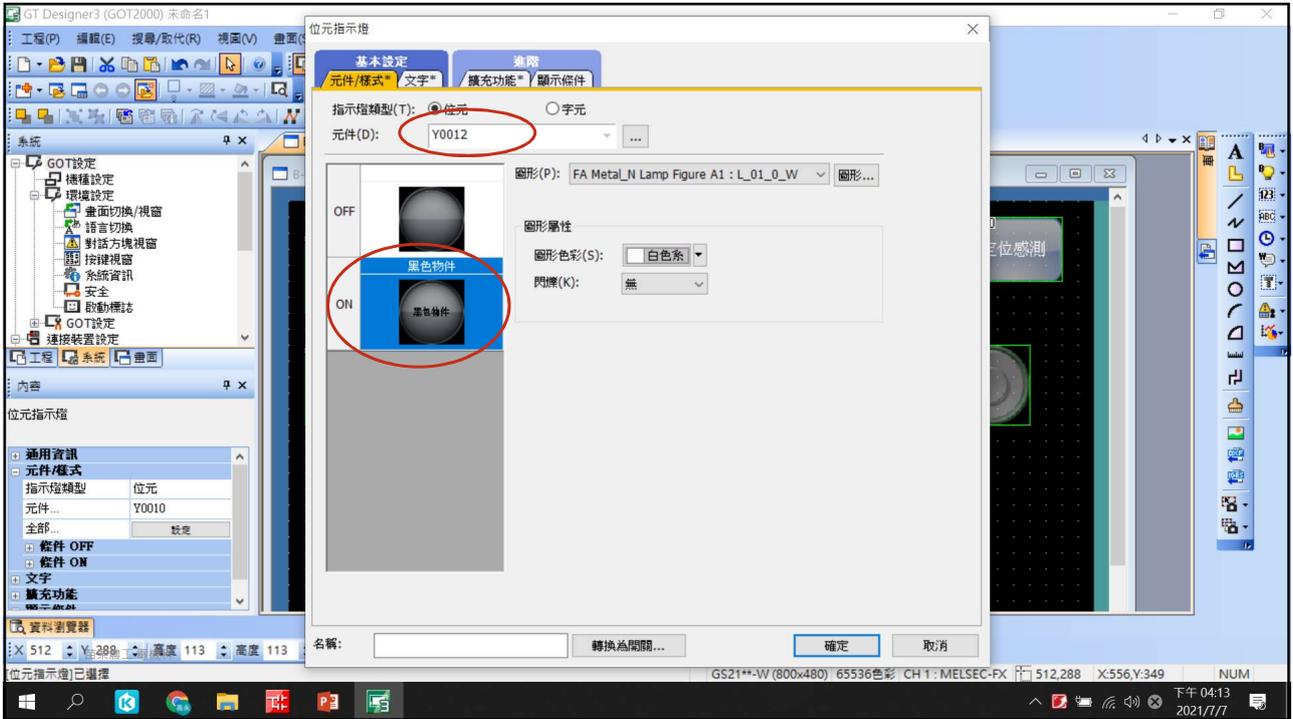
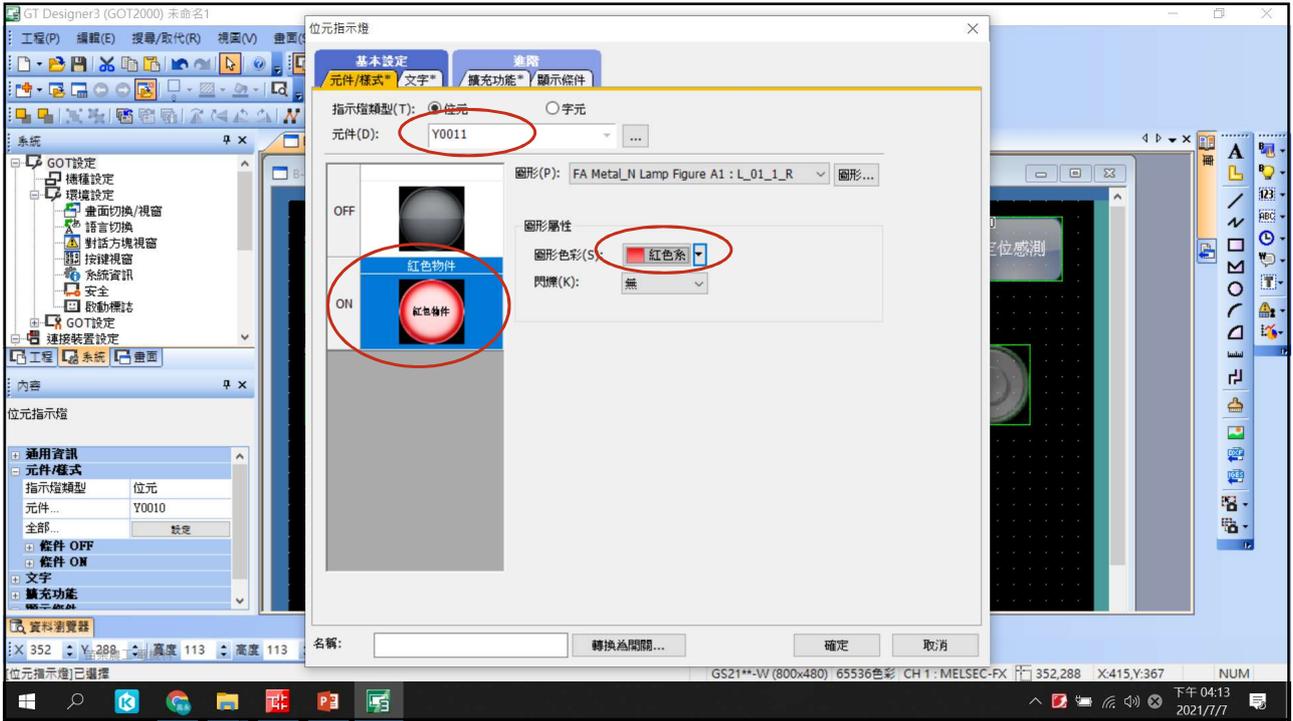


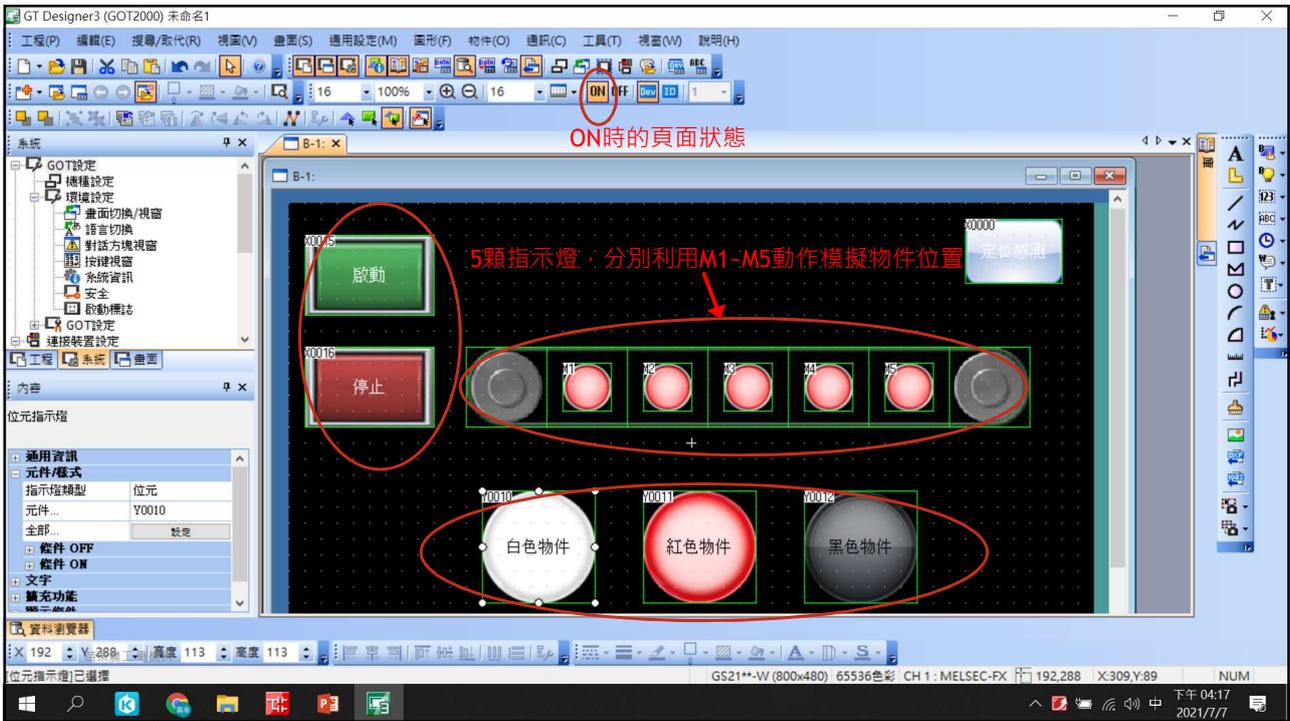
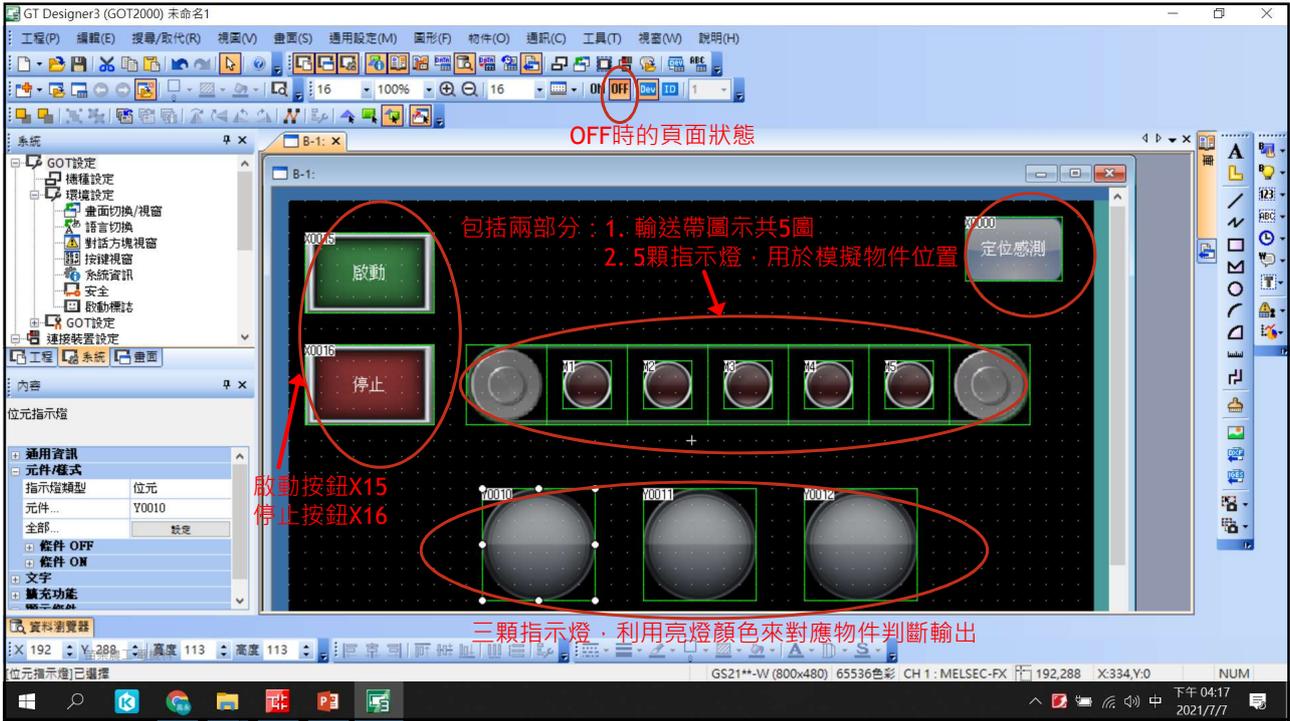


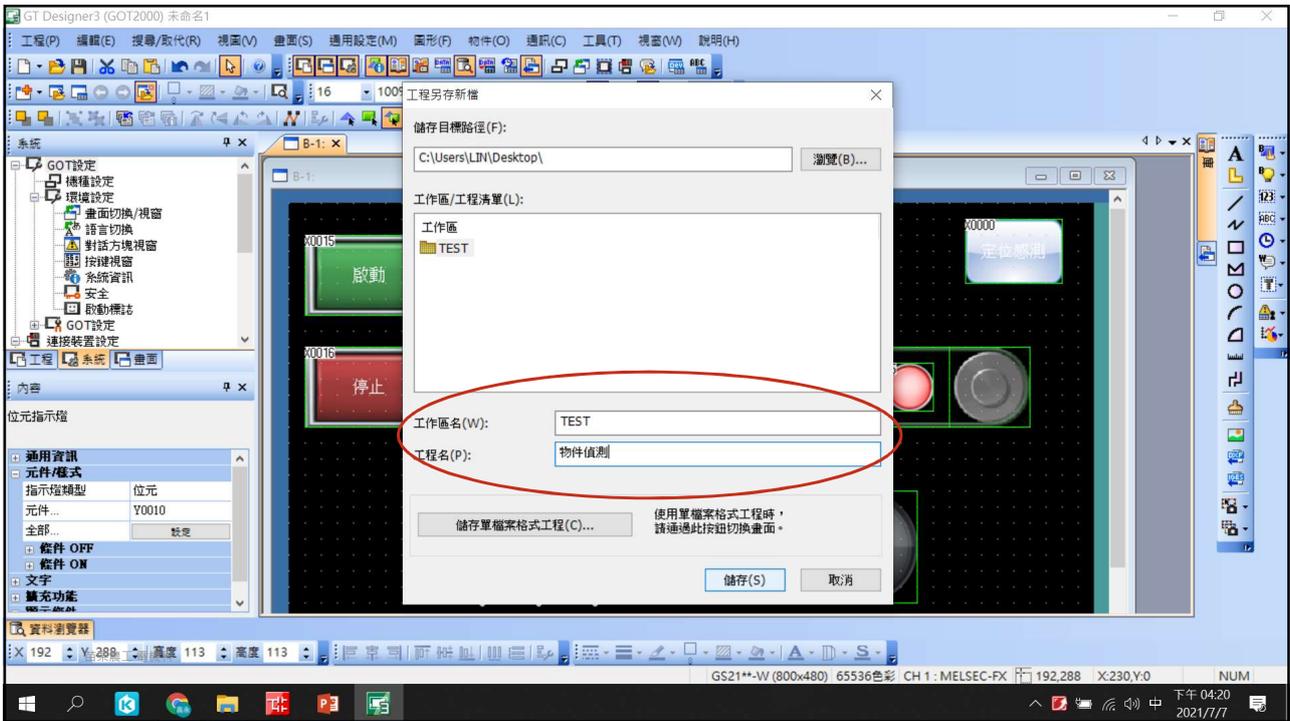
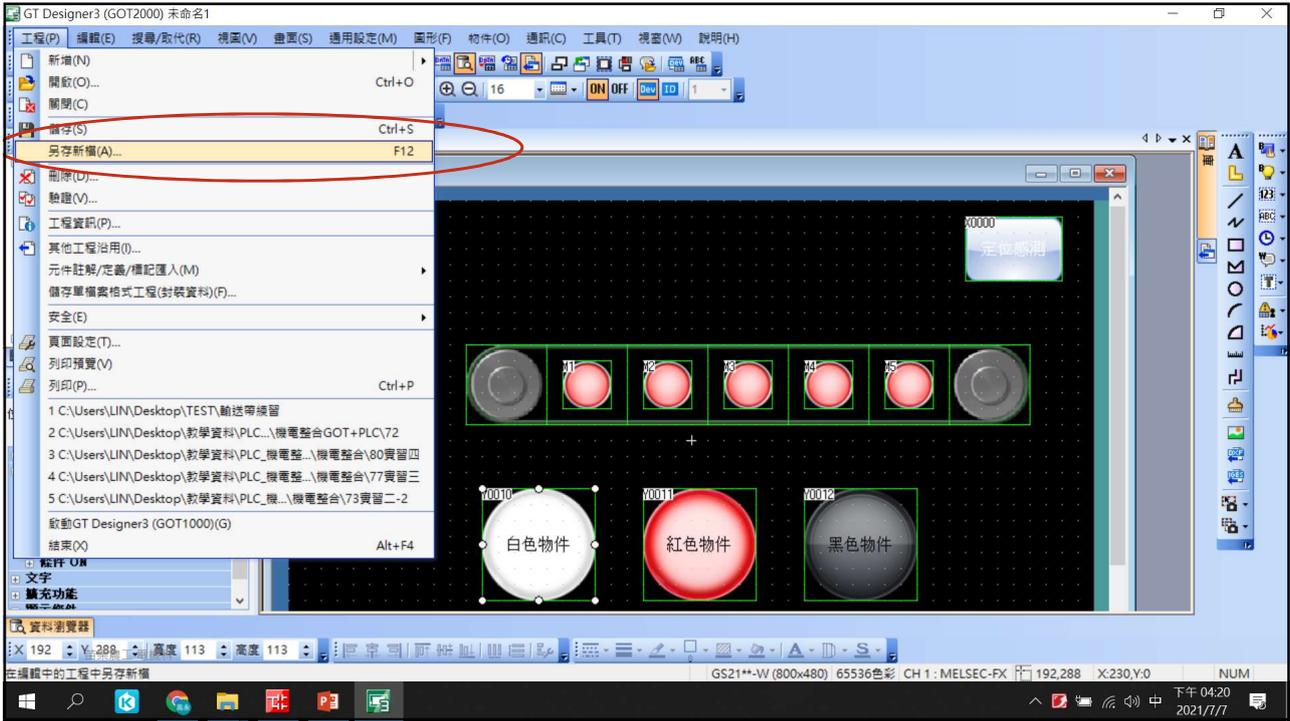


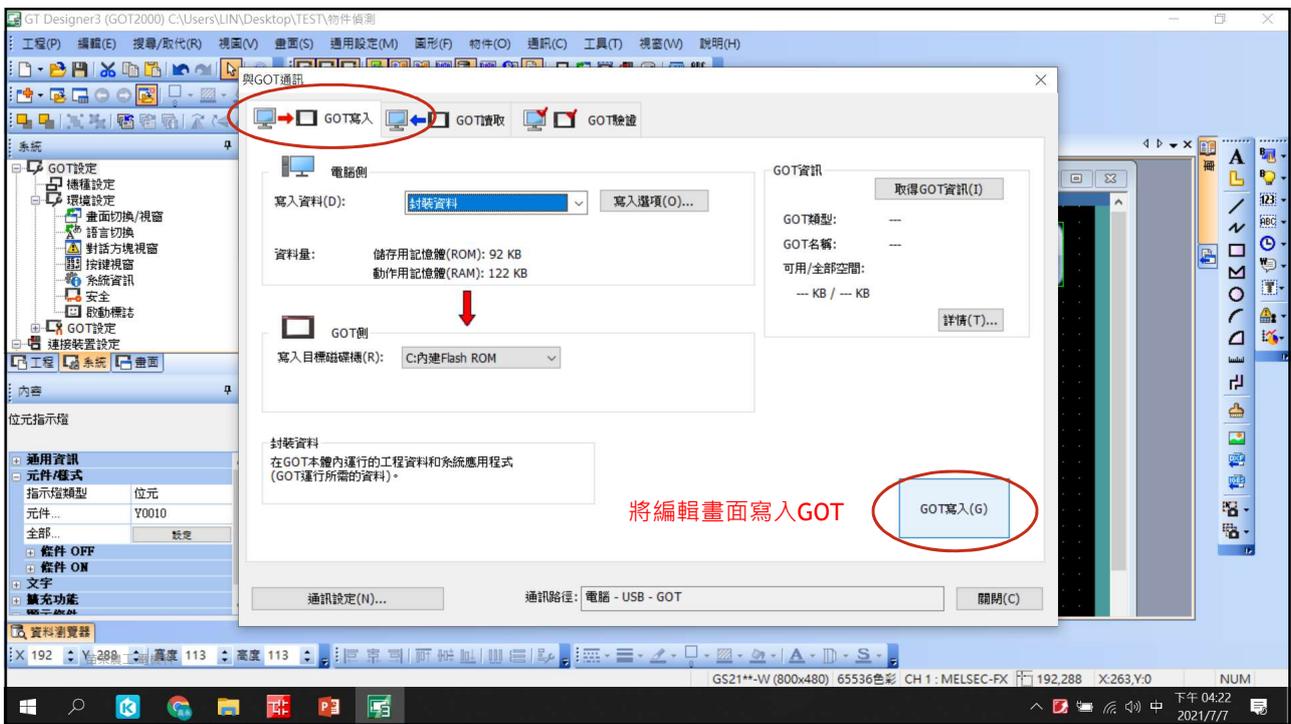


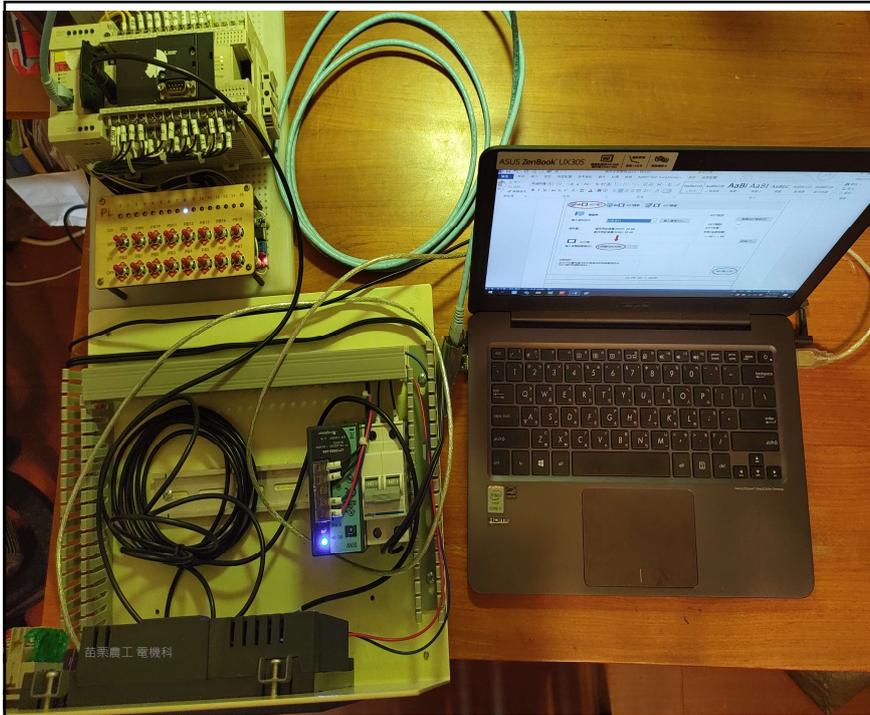
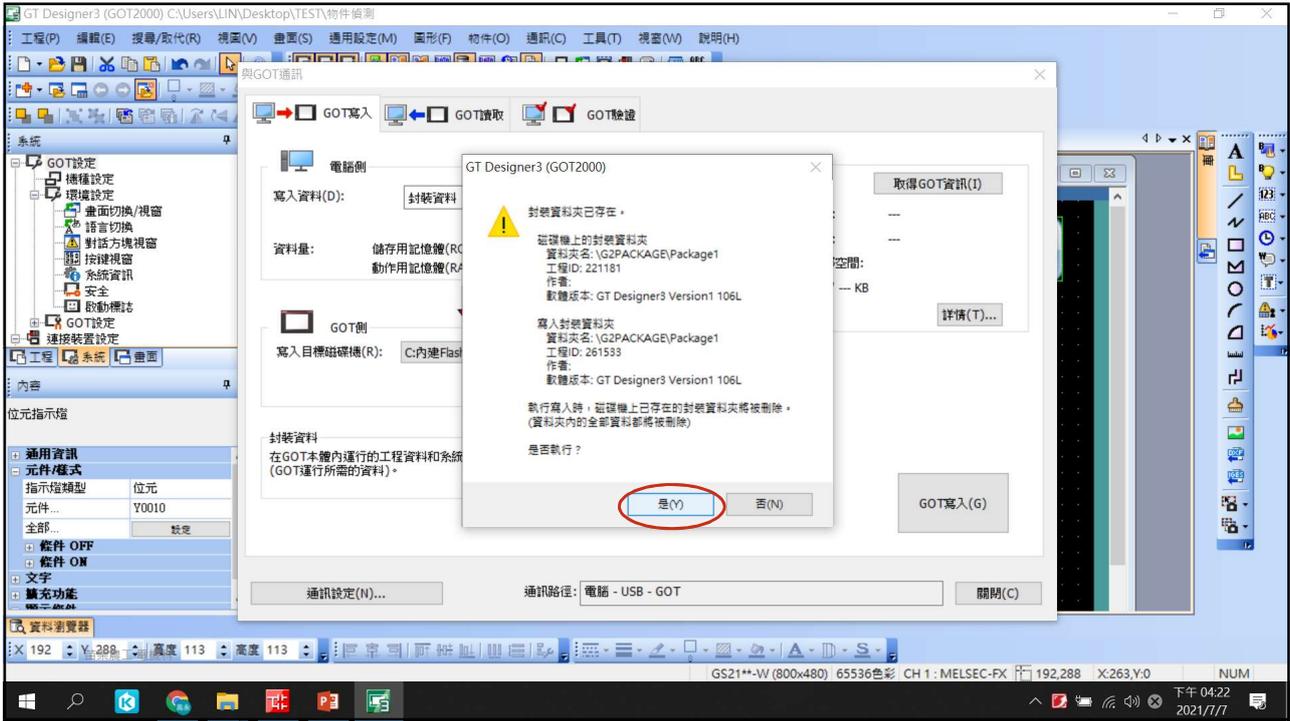












PC透過USB與GOT
連接

PC透過乙太網路
與PLC連接

PLC與GOT之間則
透過RS-422傳輸



苗栗農工電機科