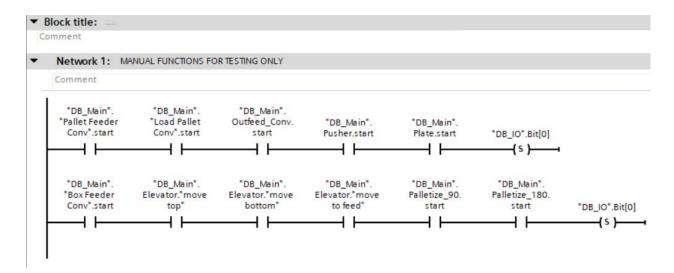
## **4.2 The Ladder Logic Diagram of a Palletizing Process in industrial automation**

nment			
Network 1:			
Comment			
%FC900	0		
"MHJ-PLC-Lab-Func	tion-\$71500"		
EN	ENO		
Network 2:			
Comment			
%DB1			
"DB_Main"			
%FB1 "FB_Main"			
EN ENO			ı
20. P			
ock title: "Main Pro	gram Sween (Cycle)		
nment	gium streep (ejele)		
iment			
Network 1:			
Network 1:			
Network 1: Comment %1.5 *FACTORY I/O (	%1.4	%1.3	"DB_IO".
Network 1: Comment %11.5 *FACTORY I/O ( Running)*	"Auto"	Emergency stop*	"System Ready"
Network 1: Comment %1.5 *FACTORY I/O (			
Network 1: Comment %11.5 *FACTORY I/O ( Running)*	"Auto"	Emergency stop*	"System Ready"
Network 1: Comment %11.5 *FACTORY I/O ( Running)*	"Auto"	Emergency stop*	"System Ready"
Network 1: Comment "FACTORY I/O ( Running)"	"Auto"	Emergency stop*	"System Ready"
Network 1: Comment "FACTORY I/O ( Running)"	"Auto"	Emergency stop*	"System Ready"
Network 1: Comment *FACTORY I/O ( Running)*	"Auto" .	Emergency stop*	"System Ready" ( ) "DB_IO".
Network 1: Comment %11.5 "FACTORY I/O ( Running)" Network 2: Comment	*Auto* *	Emergency stop*	"System Ready" ( ) "DB_IO". "System
Network 1: Comment %11.5 "FACTORY I/O ( Running)" Network 2: Comment	"Auto" "	Emergency stop*	"System Ready" () "DB_IO". "System Running"
Network 1: Comment %11.5 "FACTORY I/O ( Running)" Network 2: Comment	*Auto* *	Emergency stop*	"System Ready" () "DB_IO". "System Running"
Network 1: Comment %11.5 *FACTORY I/O ( Running)* I Network 2: Comment %11.0 *Start*	"Auto" "	Emergency stop*	"System Ready" () "DB_IO". "System Running"
Network 1: Comment %11.5 "FACTORY I/O ( Running)" Network 2: Comment %11.0 "Start" DB_IO". "System	"Auto" "	Emergency stop*	"System Ready" () "DB_IO". "System Running"
Network 1: Comment %11.5 "FACTORY I/O ( Running)" I Network 2: Comment %11.0 *Start" I DB IO".	"Auto" "	Emergency stop*	"System Ready" () "DB_IO". "System Running"

•



Comment				
	#Pusher	r		
	%FB3			
	"FB_Pusher_	Plate"		
	EN	ENO -		
"DB_10".			%Q1.0	
"System		forward -	"Push"	
Running*	machine ready	counter	0	
%10.4				
"Pusher limit" - Network 3:	— photoeye			
"Pusher limit" –				
"Pusher limit" - Network 3:	#Plate	2		
"Pusher limit" - Network 3:				
*Pusher limit* – Network 3:	#Plate %FB3			
*Pusher limit* – Network 3: Comment *DB_IO*.Bit[15]	#Plate %FB3 "FB_Pusher	_Plate" ENO	%Q1.3	
*Pusher limit* – Network 3: Comment *DB_IO*.Bit[15] *DB_IO*. *System	#Plate %FB3 "FB_Pusher — EN	_Plate" ENO		
*Pusher limit* – Network 3: Comment *DB_IO*.Bit[15] *DB_IO*. *System	#Plate %FB3 "FB_Pusher	_Plate" ENO	%Q1.3 —∎*Open plate*	
*Pusher limit* – Network 3: Comment *DB_IO*.Bit[15] *DB_IO*. *System	#Plate %FB3 "FB_Pusher, — EN — machine ready	_Plate" ENO forward	%Q1.3 —∎*Open plate*	

