B R PLC References

B&R PLC References

Contents

Comments

Simon a quick list of the PLC input and outputs.
On the B&R plc you have 8 green led's (inputs) and directly underneath these you have 8 yellow led's (outputs).
There is a little white button on the PLC that you can press"1" ,when this is pressed a yellow led on the left hand side goes "2" out and a yellow one on the right "3"comes on.
When the left one"2" is ON you monitoring inputs X1 – X8 (left to right) on the green led's and outputs Y1 – Y8 on the yellow led's.
When the right one "3" is ON you monitoring inputs X9 – X16 (left to right) on the green led's and outputs Y9 – Y16 on the yellow led's.
So if the right yellow led is on and the third from left green led is on this input X11.
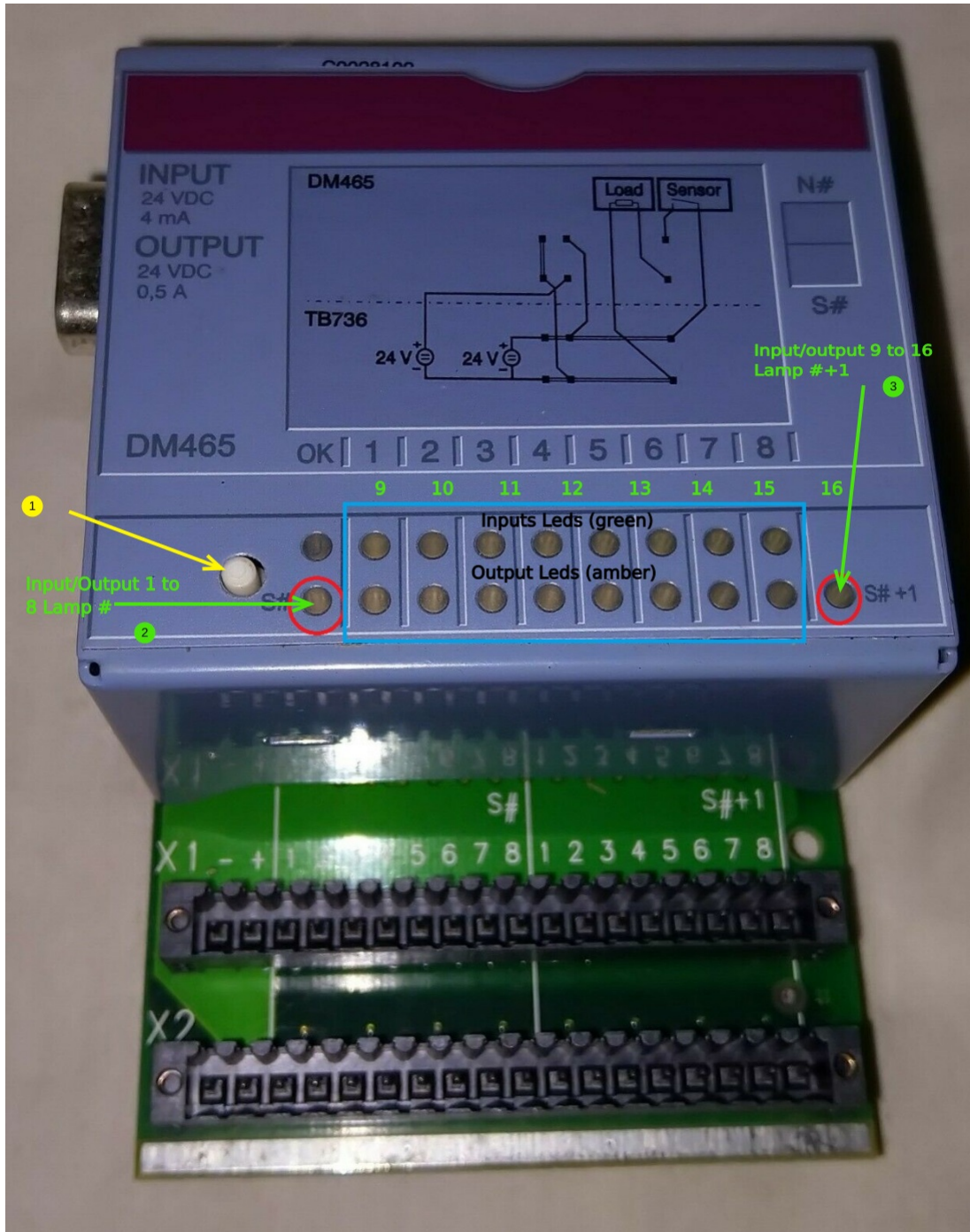
Here is a list of the I/O to help.

16 DIGITAL INPUTS			
Slot Number:			
Input No	Description:	Wire No>	Variable Name: (OLD WIRE NO>)
1	EMERGENCY STOP	X1	EM_STOP (wire 37)
2	BAR AT DOG 1 (MH)	X2	BAR1
3	BAR AT DOG 2	X3	BAR2
4	BAR AT DOG 3	X4	BAR3
5	BAR AT DOG 4	X5	BAR4
6	BAR AT DOG 5	X6	BAR5
7	BAR AT DOG 6	X7	BAR6
8	BAR AT SENSOR READY TO LIFT BAR INTO SAW	X8	BARSAW (wire 5)
9	BAR IN SAW (OUTPUT FROM SAW) RTA no.2 on I/O	X9	SAWLOADED (WIRE 26) y38
10	MOTOR CRANK FWD	X10	FORWARD_MOT
11	MOTOR CRANK AT HOME	X11	HOME_MOT
12	TABLE UP INPUT	X12	TABLE_UP
13	TABLE DOWN INPUTB	X13	TABLE_DWN
14	TABLE IN INPUT	X14	TABLE_IN
15	TABLE OUT INPUT	X15	TABLE_OUT
16	MATERIAL IN SAW INPUT	X16	? (WIRE 7)

16 DIGITAL OUTPUTS			
Slot Number:			
Output No.	Description	Wire No>	Variable Name: (OLD WIRE NO)
1	MOTOR GO FWD RELAY	Y1	MOTFWD
2	N/A	Y2	N/A
3	BAR 1 DOG VALVE	Y3	OUT_BAR1
4	BAR 2 VALVE	Y4	OUT_BAR2
5	BAR 3 VALVE	Y5	OUT_BAR3
6	BAR 4 VALVE	Y6	OUT_BAR4
7	BAR 5 VALVE	Y7	OUT_BAR5
8	BAR 6 VALVE	Y8	OUT_BAR6
9	OUTPUT TO MH (READY) RT_ACCEPCT	Y9	MHOUT (WIRE 21)
10	TABLE UP/DOWN VALVE	Y10	TABLEUD (WIRE 8)
11	TABLE IN/OUT VALVE	Y11	TABLEIO (WIRE 9)
12	LAMP 1 (24V LED MAYBE)	Y12	LAMP1
13	LAMP 2	Y13	LAMP2
14	LAMP 3	Y14	LAMP3
15	LAMP 4	Y15	LAMP4
16	OUTPUT TO SAW (BEEN LOADED)	Y16	BAR_IN_SAW (WIRE 36)

Another useful feature are the 4 lamps if the Lamps are wired in correctly "+ve goes to the gold leg of the led lamp".

There is 4 led lamps on the outside of the transfer table box ,here is the faults that they report depending on status of the 4 lamps.

Internal PCC Variable:	Description / Operation:
FAULT1	EMERGENCY STOP
FAULT2	NA
FAULT3	MOTOR CRANK NOT HOME
FAULT4	MOTOR CRANK NOT OUT
FAULT5	SAW LOADER NOT DOWN
FAULT6	SAW LOADER NOT UP
FAULT7	SAW LOADER NOT IN
FAULT8	SAW LOADER NOT OUT
FAULT9	TBA
FAULT10	TBA
FAULT11	TBA
FAULT12	TBA
FAULT13	TBA
FAULT14	TBA
FAULT15	SAW NOT READY TO ACCEPT

LAMP1	LAMP2	LAMP3	LAMP4	FAULT NUMBER
OFF	OFF	OFF	OFF	0
ON	OFF	OFF	OFF	1
OFF	ON	OFF	OFF	2
ON	ON	OFF	OFF	3
OFF	OFF	ON	OFF	4
ON	OFF	ON	OFF	5
OFF	ON	ON	OFF	6
ON	ON	ON	OFF	7
OFF	OFF	OFF	ON	8
ON	OFF	OFF	ON	9
OFF	ON	OFF	ON	10
ON	ON	OFF	ON	11
OFF	OFF	ON	ON	12
ON	OFF	ON	ON	13
OFF	ON	ON	ON	14