

Develop the program with block logic (BDF) with the Zelio Soft V2 software, using the SR3B101FU PLC

## Practice blocks

### System description:

The function of this mechanism is to move and place in a short distance the sacks of sugar, which are stacked in a pyramidal shape from the transport van to the hold of the site.

### Functional description of the control:

The system consists of upward and downward movement, left and right, start and stop; as well as the detection of the bags at the beginning and end of the band.

The IZQ-DER system is operated by a motor that drives the mechanism after its advance or reversal.

The UP-DW system is operated by a motor that drives the mechanism after its advance or reverse gear.

The START-STOP system manipulates the conveyor belt feed only in the forward direction.

When reaching the count of 10 bags, the system goes into forced stop so that the mechanical parts have a recess, the count of a bag is fulfilled if and only if it is counted at the beginning and end of the band.

Pressing the B3 button on the Zelio should display the current bag count.



LF	Left alignment.	11
RG	Right alignment.	12
UP	Elevation.	13
DW	Down.	14
IN	Start.	B1
ST	Stop.	B2
YES	Home Sensor	IB
S2	Sensor Final	IC