

PLC tags

	Name	Data type	Address	Retain	Accessi- ble from HMI/OPC UA/Web API	Writable from HMI/OPC UA/Web API	Visible in HMI engi- neering	Supervision	Comment
	Start_Button	Bool	%I16.0	False	True	True	True		
	Stop_Button	Bool	%I16.1	False	True	True	True		
	E_Stop	Bool	%I16.2	False	True	True	True		
	Door_Interlock	Bool	%I16.3	False	True	True	True		
	Counter_Reset_Button	Bool	%I16.4	False	True	True	True		
	Pusher_0_Rear_Limit	Bool	%I16.5	False	True	True	True		Back Limit For Large Boxes
	Pusher_1_Rear_Limit	Bool	%I16.6	False	True	True	True		Back Limit For Medium Boxes
	Large_Sensor	Bool	%I17.0	False	True	True	True		Large Box detection for pusher 0
	Med_Small_Sensor	Bool	%I17.1	False	True	True	True		Detection sensor for pusher 1 small medium boxes
	Palletise_Box_Count_Sensor	Bool	%I17.2	False	True	True	True		Counter sensor for palletise Boxes
	Box_Loaded_Sensor	Bool	%I17.3	False	True	True	True		Box detected on scales
	Large_Count_Sensor	Bool	%I17.4	False	True	True	True		Sensor to detect large box sum
	Small_Count_Sensor	Bool	%I17.5	False	True	True	True		Sensor to detect small box sum
	Medium_Count_Sensor	Bool	%I17.6	False	True	True	True		Sensor to detect Medium box sum
	Alarm_Siren	Bool	%Q16.0	False	True	True	True		
	Start_Light	Bool	%Q16.1	False	True	True	True		
	Stop_Light	Bool	%Q16.2	False	True	True	True		
	Stack_Green_0	Bool	%Q16.3	False	True	True	True		
	Stack_Yellow_0	Bool	%Q16.4	False	True	True	True		
	Stack_Red_0	Bool	%Q16.5	False	True	True	True		
	Pusher_0	Bool	%Q16.6	False	True	True	True		
	Pusher_1	Bool	%Q16.7	False	True	True	True		
	Conveyor_1	Bool	%Q17.0	False	True	True	True		6m Main Converyor
	Conveyor_2	Bool	%Q17.1	False	True	True	True		4M Large Box Conveyor 4m (0)
	Conveyor_3	Bool	%Q17.2	False	True	True	True		4M Small/Med Conveyor 4m(1)
	Conveyor_4	Bool	%Q17.3	False	True	True	True		2M Conveyor 0
	Conveyor_5	Bool	%Q17.4	False	True	True	True		Curved Conveyor
	Conveyor_6	Bool	%Q17.5	False	True	True	True		Pallet box conveyor
	Conveyor_7	Bool	%Q17.6	False	True	True	True		2M Conveyor 1 (Small Boxes)
	Conveyor_8	Bool	%Q17.7	False	True	True	True		2M Conveyor 2 (Medium Boxes)
	Conveyor_9	Bool	%Q18.0	False	True	True	True		Spur Conveyor Left
	Conveyor_10	Bool	%Q18.1	False	True	True	True		Spur Conveyor Right
	Sorter_Run	Bool	%Q18.2	False	True	True	True		Pop Up Sorter Run
	Sorter_Left	Bool	%Q18.3	False	True	True	True		
	Sorter_Right	Bool	%Q18.4	False	True	True	True		
	System_Start_FLG0	Bool	%M100.0	False	True	True	True		System is ready to operate
	Start_HMI	Bool	%M100.1	False	True	True	True		
	Stop_HMI	Bool	%M100.2	False	True	True	True		
	Reset_HMI	Bool	%M100.3	False	True	True	True		
	Estop_HMI	Bool	%M100.4	False	True	True	True		
	Box_Loaded_FLG	Bool	%M100.5	False	True	True	True		
	Scale_Control_FLG	Bool	%M100.6	False	True	True	True		
	Alarms	Int	%MW300	False	True	True	True		Alarm Word
	Alarm_0	Bool	%M300.0	False	True	True	True		
	Alarm_1	Bool	%M300.1	False	True	True	True		
	Alarm_2	Bool	%M300.2	False	True	True	True		
	Alarm_3	Bool	%M300.3	False	True	True	True		
	Alarm_4	Bool	%M300.4	False	True	True	True		
	Alarm_5	Bool	%M300.5	False	True	True	True		
	Alarm_6	Bool	%M300.6	False	True	True	True		
	Alarm_7	Bool	%M300.7	False	True	True	True		
	Alarm_8	Bool	%M301.0	False	True	True	True		
	Alarm_9	Bool	%M301.1	False	True	True	True		
	Alarm_10	Bool	%M301.2	False	True	True	True		
	Alarm_11	Bool	%M301.3	False	True	True	True		
	Alarm_12	Bool	%M301.4	False	True	True	True		

