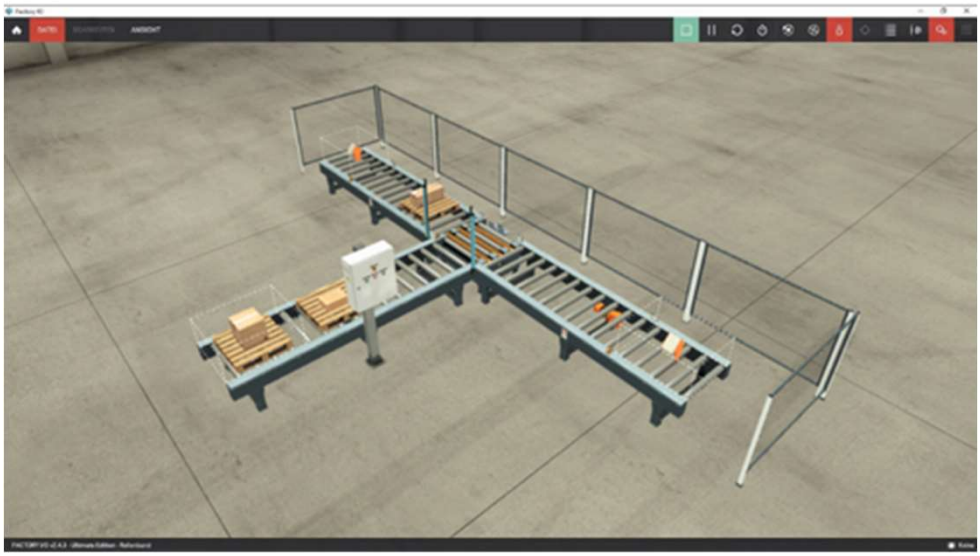
Selmo

- **Model Sorter**



Factory IO

- **Functional Description**

Automatically generated packages are placed on the entry conveyor and are transported to the height sensors. Depending on the assignment of the sensors (pallet, low and high), it is decided whether the package is a small or a large one. The Transfer Conveyer is then switched on and transports the package to the Pallet Sensor. Due to the earlier decision, in the case of the small package, the right transport conveyor is started and in the case of the large package, the left transport conveyor is started. Accordingly, the package is transported to the right corner to the Remover.

In/Output assignment

The in- and outputs of the model are assigned as follows (the designation input or output refers to the connected controller):

Input Nr.	**Name**	**Factory IO –Variable name**		**Specification**
1	S1	I_Start	:BOOL;	//S1 Start
2	S2	I_Stop	:BOOL;	//S2 Stop
3	S3	I_Estop	:BOOL;	//S3 Emergency stop
4	B1	I_Pallet_Present	:BOOL;	//B1 Pallet present
5	B2	I_Pallet_Sensor	:BOOL;	//B2 Pallet sensor
6	B3	I_Low_Sensor	:BOOL;	//B3 Low sensor
7	B4	I_High_Sensor	:BOOL;	//B4 High sensor
8	B5	I_Part_on_Transferunit	:BOOL;	//B5 Part on Transferunit
9	B6	I_Left_Entry	:BOOL;	//B6 left Entry Part present
10	B7	I_Left_Exit	:BOOL;	//B7 left Exit Part present
11	B8	I_Right_Entry	:BOOL;	//B8 right Entry Part present
12	B9	I_Right_Exit	:BOOL;	//B9 right Exit Part present

Output Nr.	**Name**	**Factory IO –Variable name**		**Specification**
1	O1	O_Conveyor_Entry_ON	:BOOL;	//M1 Conveyor entry ON
2	O2	O_Conveyor_Transfer_forw_ON	:BOOL;	//M2 Transferunit for. ON
3	O3	O_Conveyor_Transfer_backw_ON	:BOOL;	//M3 Transferunit back. ON
4	O4	O_Conveyor_Transfer_left_ON	:BOOL;	//M4 Transferunit left ON
5	O5	O_Conveyor_Transfer_right_ON	:BOOL;	//M5 Transferunit right ON
6	O6	O_Conveyor_left_ON	:BOOL;	//M6 Conveyor left ON
7	O7	O_Conveyor_right_ON	:BOOL;	//M7 Conveyor right ON
8	O8	O_Start_LED	:BOOL;	//L1 Start LED
9	O9	O_Stop_LED	:BOOL;	//L2 Stop LED