

Anexo A: **Datos Globales y de Diagnóstico**

En las siguientes tablas se indicarán los datos globales definidos en cada una de las líneas y las posiciones de diagnóstico dentro de cada uno de los PLC's concentradores de las líneas.

A.1 LÍNEAS SAMOVI

En esta línea hay dos PLC's y entre ellos no intercambian datos globales.

A.1.1 Posiciones de memoria en el PLC concentrador (enfardadora)

		SAMOVI	
DB125	inPALET1	PLC Enfardadora A (PIERI)	
STRING1[10]	DB125.DBX0.0		
STRING2[12]	DB125.DBX12.0		
STRING3[12]	DB125.DBX26.0		
INT1	DB125.DBW40		
INT2	DB125.DBW42	Numero programa enfardado	DB10.DBW20 INT
INT3	DB125.DBW44		
INT4	DB125.DBW46		
INT5	DB125.DBW48		
INT6	DB125.DBW50		
INT7	DB125.DBW52		
INT8	DB125.DBW54		
INT9	DB125.DBW56		
INT10	DB125.DBW58		
DINT1	DB125.DBD60		
DINT2	DB125.DBD64		
DINT3	DB125.DBD68		
BOOL1	DB125.DBX72.0	ENFARD - Ciclo AUTO (Marcha) - Verde	A125.1
BOOL2	DB125.DBX72.1	ENFARD - ALARMA (1) - Rojo	A125.0
BOOL3	DB125.DBX72.2	ENFARD - Standby (1) - Amarillo	A125.2
BOOL4	DB125.DBX72.3		
BOOL5	DB125.DBX72.4		
BOOL6	DB125.DBX72.5		
BOOL7	DB125.DBX72.6		
BOOL8	DB125.DBX72.7		

A.1.2 Posiciones de memoria en el PLC Samovi (transporte)

OMRON PLC Transporte (Omron)			
D00018	Código DUN producto L1	7 Words	
D00048	Código DUN producto L2	7 Words	
D00078	Código DUN producto L3	7 Words	
D00108	Código DUN producto L4	7 Words	
D00138	Código DUN producto L5	7 Words	
D00168	Código DUN producto L6	7 Words	
D00620	Estado Robot 1 L1 y L2	1 Word	
D00621	Estado Robot 2 L3 y L4	1 Word	
D00622	Estado Robot 3 L5 Y L6	1 Word	
303.00	Linea 1 en marcha	Bit	
303.01	Linea 2 en marcha	Bit	
303.02	Linea 3 en marcha	Bit	
303.03	Linea 4 en marcha	Bit	
303.04	Linea 5 en marcha	Bit	
303.05	Linea 6 en marcha	Bit	
438.00	Linea 1 parada	Bit	
438.01	Linea 2 parada	Bit	
438.02	Linea 3 parada	Bit	
438.03	Linea 4 parada	Bit	
438.04	Linea 5 parada	Bit	
438.05	Linea 6 parada	Bit	
438.06	Linea 7 parada	Bit	
50.01	Paro emergencia general	Bit	
50.02	Paro emergencia L1	Bit	
50.03	Paro emergencia L2	Bit	
50.04	Paro emergencia L3	Bit	
50.05	Paro emergencia L4	Bit	
50.06	Paro emergencia L5	Bit	
50.07	Paro emergencia L6	Bit	

A.2 L3NEA MALETAS 1

A.2.1 Datos globales intercambiados ente los PLC's

GD - [MPI(1) (Datos globales) -- inMALETAS1]				
Tabla GD Edici3n Insertar Sistema de destino Ver Ventana Ayuda				
	Identificador GD	inPieri\ PIERI 13806	inOCME CONFIG\ CPU 315-2 DP	
1	GD 1.1.1	DB5.DBW0	>DB101.DBW100	
2	GD 1.1.2	DB5.DBW2	>DB101.DBW102	
3	GD 1.1.3	DB5.DBW4	>DB101.DBW106	
4	GD 1.1.4	DB5.DBW6	>DB101.DBW110	
5	GD 1.1.5	DB5.DBW8	>DB101.DBW112	
6	GD 1.1.6	DB15.DBB6	>DB15.DBB6	
7	GD 1.2.1	>DB15.DBB1	DB15.DBB1	
8	GD 1.2.2	>DB15.DBB2	DB15.DBB2	
9	GD 2.1.1	DB15.DBB7	>DB15.DBB7	
10	GD 2.1.2	DB125.DBD78	>DB73.DBD20	
11	GD 2.1.3	DB125.DBD82	>DB73.DBD24	
12	GD 2.1.4	DB125.DBW122	>DB9.DBW80	
13	GD 2.1.5	DB125.DBW124	>DB9.DBW82	
14	GD 3.1.1	DB125.DBW126	>DB9.DBW84	
15	GD 3.1.2	DB125.DBW128	>DB9.DBW86	
16	GD 3.1.3	DB125.DBW130	>DB9.DBW88	
17	GD 3.1.4	DB125.DBX148.0	>A2.3	
18	GD 3.1.5	DB125.DBX150.0	>M220.0	
19	GD 3.1.6	DB125.DBX150.1	>A2.0	
20	GD 3.1.7	DB125.DBX150.2	>A2.2	
21	GD 4.1.1	DB125.DBX150.4	>M27.0	
22	GD 4.1.2	DB125.DBX150.5	>M28.0	
23	GD 4.1.3	DB125.DBX150.6	>M29.0	
24	GD 4.1.4	DB125.DBW116	>DB9.DBW8	
25	GD			
26	GD			

A.2.2 Posiciones de memoria en el PLC concentrador (enfardadora)

MALETAS 1			
inPALET1	PLC Enfardadora A (PIERI)		
DB125.DBX0.0			
DB125.DBX12.0			
DB125.DBX26.0			
DB125.DBW40			
DB125.DBW42	Numero programa enfardado	DB10.DBW20	INT
DB125.DBW44			
DB125.DBW46			
DB125.DBW48			
DB125.DBW50			
DB125.DBW52			
DB125.DBW54			
DB125.DBW56			
DB125.DBW58			
DB125.DBD60	Código SAP producto enfardado	DB5.DBD6	
DB125.DBD64			
DB125.DBD68			
DB125.DBX72.0	ENFARD - Ciclo AUTO (Marcha) - Verde	A125.1	
DB125.DBX72.1	ENFARD - ALARMA (1) - Rojo	A125.0	
DB125.DBX72.2	ENFARD - Standby (1) - Amarillo	A125.2	
DB125.DBX72.3	ROBOT1 - Ciclo AUTO (Marcha)	DBX148.0	
DB125.DBX72.4	ROBOT1 - ALARMA (1)	DBX150.1	
DB125.DBX72.5	ROBOT1 - Standby	No hay	
DB125.DBX72.6			
DB125.DBX72.7			
DB125.DBX73.0			
DB125.DBX73.1	TRANSP - Ciclo OK (1)	Varios	
DB125.DBX73.2	TRANSP - Alarma	No hay	
DB125.DBX73.3	TRANSP - Standby	No hay	
DB125.DBX73.4			
DB125.DBX73.5			
DB125.DBX73.6			
DB125.DBX73.7			

DB125		MALETAS 1		
inPALET2		PLC ROBOT		
STRING1[10]	DB125.DBX78.0	Código de FP en curso	DB73.DBD20	8 Carac.
STRING2[12]	DB125.DBX88.0			
STRING3[12]	DB125.DBX102.0			
INT1	DB125.DBW116	PID Albatros asociado al FP	DB73.DBW8	
INT2	DB125.DBW118			
INT3	DB125.DBW120			
INT4	DB125.DBW122	Estado paletizador	DB9.DBW80	16=OK
INT5	DB125.DBW124	Estado transp. descarga	DB9.DBW82	16=OK
INT6	DB125.DBW126			
INT7	DB125.DBW128	Estado alimentador paletas	DB9.DBW86	16=OK
INT8	DB125.DBW130	Estado ROBOT	DB9.DBW88	16=OK
INT9	DB125.DBW132			
INT10	DB125.DBW134			
DINT1	DB125.DBD136			
DINT2	DB125.DBD140			
DINT3	DB125.DBD144			
BOOL1	DB125.DBX148.0	Ciclo en AUTO (Marcha)	A2.3	
BOOL2	DB125.DBX148.1			
BOOL3	DB125.DBX148.2			
BOOL4	DB125.DBX148.3			
BOOL5	DB125.DBX148.4			
BOOL6	DB125.DBX148.5			
BOOL7	DB125.DBX148.6			
BOOL8	DB125.DBX148.7			
BOOL9	DB125.DBX149.0			
BOOL10	DB125.DBX149.1			
BOOL11	DB125.DBX149.2			
BOOL12	DB125.DBX149.3			
BOOL13	DB125.DBX149.4			
BOOL14	DB125.DBX149.5			
BOOL15	DB125.DBX149.6			
BOOL16	DB125.DBX149.7			
BOOL17	DB125.DBX150.0	Alarma emergencia	M220.0	
BOOL18	DB125.DBX150.1	Alarma en línea paletizado	A2.0	
BOOL19	DB125.DBX150.2	Alarma falta producto	A2.2	
BOOL20	DB125.DBX150.3			
BOOL21	DB125.DBX150.4	Alarma en zona paletización	M27.0	
BOOL22	DB125.DBX150.5	Alarma en zona transporte	M28.0	
BOOL23	DB125.DBX150.6	Alarma en robot paletizador	M29.0	
BOOL24	DB125.DBX150.7			

A.3 LÍNEA MALETAS 2

A.3.1 Datos globales intercambiados entre los PLC's

	Identificador GD	inPieri\ CPU 313C	inRobot\ CPU 315-2 DP	inTransp\ CPU 315F-2 DP
1	GD 1.1.1	DB125.DBD78	>DB9.DBD20	
2	GD 1.1.2	DB125.DBW116	>DB9.DBW4	
3	GD 1.1.3	DB125.DBW122	>DB20.DBW80	
4	GD 1.1.4	DB125.DBW124	>DB20.DBW82	
5	GD 1.1.5	DB125.DBX148.0	>A2.0	
6	GD 1.1.6	DB125.DBX148.1	>A2.2	
7	GD 2.1.1	DB125.DBX150.0	>A1.0	
8	GD 2.1.2	DB125.DBX150.1	>A1.5	
9	GD 2.1.3	DB125.DBX150.2	>A2.1	
10	GD 2.1.4	DB125.DBX150.5	>M28.0	
11	GD 2.1.5	DB125.DBX150.6	>M29.0	
12	GD 3.1.1	DB125.DBW208		>DB50.DBW30
13	GD 3.1.2	DB125.DBX224.0		>DB11.DBX0.1
14	GD 3.1.3	DB125.DBX224.1		>DB12.DBX0.1
15	GD 3.1.4	DB125.DBX224.2		>DB13.DBX0.1
16	GD 3.1.5	DB125.DBX224.3		>DB14.DBX0.1
17	GD 3.1.6	DB125.DBX224.4		>DB15.DBX0.1
18	GD 3.1.7	DB125.DBX224.5		>DB16.DBX0.1
19	GD 4.1.1	DB125.DBX224.6		>DB17.DBX0.1
20	GD 4.1.2	DB125.DBX226.0		>DB100.DBX8.2
21	GD 4.1.3	DB125.DBX226.1		>DB100.DBX8.3
22	GD 4.1.4	DB125.DBX226.2		>DB100.DBX8.4
23	GD 4.1.5	DB125.DBX226.3		>DB100.DBX8.5
24	GD 4.1.6	DB125.DBX226.4		>DB100.DBX8.6
25	GD 4.1.7	DB125.DBX226.5		>DB100.DBX8.7
26	GD 4.1.8	DB125.DBX226.6		>DB100.DBX9.0
27	GD 5.1.1		>DB100.DBW2	MW202
28	GD 5.1.2		>DB100.DBW4	MW204
29	GD 5.1.3		>DB100.DBW30	MW216
30	GD 5.1.4		>DB100.DBW32	MW218
31	GD 5.1.5		>DB100.DBW44	MW220
32	GD 5.1.6		>DB100.DBW48	MW224
33	GD 6.1.1		>DB100.DBW48	MW250

A.3.2 Posiciones de memoria en el PLC concentrador (enfardadora)

DB125.DB125		MALETAS 2	
inPALET1		PLC CONCENTRADOR - Enfardadora (PIERI)	
DB125.DBX0.0			
DB125.DBX12.0			
DB125.DBX26.0			
DB125.DBW40			
DB125.DBW42	Numero programa enfardado	DB10.DBW26	INT
DB125.DBW44			
DB125.DBW46			
DB125.DBW48			
DB125.DBW50			
DB125.DBW52			
DB125.DBW54			
DB125.DBW56			
DB125.DBW58			
DB125.DBD60			
DB125.DBD64			
DB125.DBD68			
DB125.DBX72.0	ENFARD - Ciclo AUTO (Marcha)	A8.1	
DB125.DBX72.1	ENFARD - ALARMA (1)	A8.0 + A8.2	
DB125.DBX72.2			
DB125.DBX72.3	ROBOT1 - Ciclo AUTO (Marcha)	DB125.DBX148.0	
DB125.DBX72.4	ROBOT1 - ALARMA (1)	Varios	
DB125.DBX72.5			
DB125.DBX72.6			
DB125.DBX72.7			
DB125.DBX73.0			
DB125.DBX73.1	TRANSP - Ciclo OK (1)	DBW208	
DB125.DBX73.2	TRANSP - Alarma en Transporte	Varios	
DB125.DBX73.3			
DB125.DBX73.4			
DB125.DBX73.5			
DB125.DBX73.6			
DB125.DBX73.7			
DB125.DBX74.0	Alarma en Emergencia	A8.0	
DB125.DBX74.1	Alarma Puera Abierta en Enfardadora	A8.2	
DB125.DBX74.2			
DB125.DBX74.3			
DB125.DBX74.4			
DB125.DBX74.5			
DB125.DBX74.6			
DB125.DBX74.7			

MALETAS 2			
inPALET2	PLC1 - Robot (Ocme 2)		
DB125.DBX78.0	Código de FP en curso	DB9.DBD20	8 Carac.
DB125.DBX88.0			
DB125.DBX102.0			
DB125.DBW116	PID Albatros asociado al FP	DB9.DBW4	
DB125.DBW118			
DB125.DBW120			
DB125.DBW122	Estado paletizador	DB20.DBW80	16=OK
DB125.DBW124	Estado transp. descarga	DB20.DBW82	16=OK
DB125.DBW126			
DB125.DBW128			
DB125.DBW130			
DB125.DBW132			
DB125.DBW134			
DB125.DBD136			
DB125.DBD140			
DB125.DBD144			
DB125.DBX148.0	Ciclo en AUTO (Marcha)	A2.0	
DB125.DBX148.1	Transportadores parados	A2.2	
DB125.DBX148.2			
DB125.DBX148.3			
DB125.DBX148.4			
DB125.DBX148.5			
DB125.DBX148.6			
DB125.DBX148.7			
DB125.DBX149.0			
DB125.DBX149.1			
DB125.DBX149.2			
DB125.DBX149.3			
DB125.DBX149.4			
DB125.DBX149.5			
DB125.DBX149.6			
DB125.DBX149.7			
DB125.DBX150.0			
DB125.DBX150.1	Alarma en sistema	A1.5	
DB125.DBX150.2	Alarma falta producto	A2.1	
DB125.DBX150.3			
DB125.DBX150.4			
DB125.DBX150.5	Alarma en zona transporte	M28.0	
DB125.DBX150.6	Alarma en robot paletizador	M29.0	
DB125.DBX150.7			

MALETAS 2			
inPALET3	PLC2 -Scalextric		
DB125.DBX152.0			
DB125.DBX164.0			
DB125.DBX178.0			
DB125.DBW192			
DB125.DBW194			
DB125.DBW196			
DB125.DBW198			
DB125.DBW200			
DB125.DBW202			
DB125.DBW204			
DB125.DBW206			
DB125.DBW208	Estado Transporte (0=Marcha, <>Incidencia)	DB50.DBW30	
DB125.DBW210			
DB125.DBD212			
DB125.DBD216			
DB125.DBD190			
DB125.DBX224.0	Zona A en (1) Auto / (0) Manual	DB11.DBX0.1	
DB125.DBX224.1	Zona B en (1) Auto / (0) Manual	DB12.DBX0.1	
DB125.DBX224.2	Zona C en (1) Auto / (0) Manual	DB13.DBX0.1	
DB125.DBX224.3	Zona D en (1) Auto / (0) Manual	DB14.DBX0.1	
DB125.DBX224.4	Zona E en (1) Auto / (0) Manual	DB15.DBX0.1	
DB125.DBX224.5	Zona F en (1) Auto / (C) Manual	DB16.DBX0.1	
DB125.DBX224.6	Zona G en (1) Auto / (0) Manual	DB17.DBX0.1	
DB125.DBX224.7			
DB125.DBX225.0			
DB125.DBX225.1			
DB125.DBX225.2			
DB125.DBX225.3			
DB125.DBX225.4			
DB125.DBX225.5			
DB125.DBX225.6			
DB125.DBX225.7			
DB125.DBX226.0	Seta activa en zona de carga	DB100.DBX8.2	
DB125.DBX226.1	Seta activa en zona elevador	DB100.DBX8.3	
DB125.DBX226.2	Seta activa en zona transp pared	DB100.DBX8.4	
DB125.DBX226.3	Seta activa en zona transp salida	DB100.DBX8.5	
DB125.DBX226.4	Seta activa en zona transp PIERI	DB100.DBX8.6	
DB125.DBX226.5	Seta activa en zona sist 2 enfardado	DB100.DBX8.7	
DB125.DBX226.6	Seta activa en zona linea cajas	DB100.DBX9.0	
DB125.DBX226.7			

A.4 LÍNEAS FANUC 1 Y 2

A.4.1 Datos globales intercambiados entre los PLC's

	Identificador GD	L1_Pieri\ CPU 314 IFM	Robot\ CPU 314C-2 DP	Cajas1\ CPU 314C-2 PtP
1	GD	DB125.DBW128	>DB50.DBW30	
2	GD	DB125.DBW130	>DB60.DBW30	
3	GD	DB125.DBD136	>DB11.DBW30	
4	GD	DB125.DBD140	>DB21.DBD50	
5	GD	DB125.DBX148.1	>M1.6	
6	GD	DB125.DBX148.2	>M1.4	
7	GD	DB125.DBX148.7	>M40.2	
8	GD	DB125.DBX149.0	>M40.6	
9	GD	DB125.DBX150.0	>E113.0	
10	GD	DB125.DBX150.1	>E105.3	
11	GD	DB125.DBX151.2	>M120.1	
12	GD	DB125.DBX151.3	>M120.0	
13	GD	DB125.DBX151.4	>DB1.DBX1.5	
14	GD	DB125.DBX151.5	>DB1.DBX7.1	
15	GD	DB125.DBW198		>MW70
16	GD	DB125.DBW204		>DB50.DBW30
17	GD	DB125.DBW206		>DB60.DBW30
18	GD			

A.4.2 Posiciones de memoria en el PLC concentrador (enfardadora)

En estas líneas existen dos PLC's concentradores, siendo las posiciones de memoria iguales en ambos:

inPALET1	PLC Enfardadora L1 (PIER1)		
DB125.DBX0.0			
DB125.DBX12.0			
DB125.DBX26.0			
DB125.DBW40			
DB125.DBW42	Numero programa enfardado	DB10.DBW26	INT
DB125.DBW44			
DB125.DBW46			
DB125.DBW48			
DB125.DBW50			
DB125.DBW52			
DB125.DBW54			
DB125.DBW56			
DB125.DBW58			
DB125.DBD60			
DB125.DBD64			
DB125.DBD68			
DB125.DBX72.0	ENFARD - Ciclo AUTO (Marcha)	A8.1	
DB125.DBX72.1	ENFARD - ALARMA (1)	A8.0 ó A8.2	
DB125.DBX72.2	ENFARD -	No hay	
DB125.DBX72.3	ROBOT1 - Ciclo MARCHA	DBW130	
DB125.DBX72.4	ROBOT1 -		
DB125.DBX72.5	ROBOT1 -		
DB125.DBX72.6	ROBOT2 - Ciclo MARCHA	DBW128	
DB125.DBX72.7	ROBOT2 -		
DB125.DBX73.0	ROBOT2 -		
DB125.DBX73.1	TRANSP - Todo OK		
DB125.DBX73.2	TRANSP - Alarma		
DB125.DBX73.3	TRANSP -		
DB125.DBX73.4			
DB125.DBX73.5			
DB125.DBX73.6			
DB125.DBX73.7			
DB125.DBX74.0	Máquina en emergencia	A8.0	
DB125.DBX74.1	Alarma apertura puerta	A8.2	
DB125.DBX74.2			
DB125.DBX74.3			
DB125.DBX74.4			
DB125.DBX74.5			
DB125.DBX74.6			
DB125.DBX74.7			

FANUC 1 Y 2			
inPALET2	PLC Robot		
DB125.DBX76.0			
DB125.DBX88.0			
DB125.DBX102.0			
DB125.DBW116			
DB125.DBW118			
DB125.DBW120			
DB125.DBW122			
DB125.DBW124			
DB125.DBW126			
DB125.DBW128	Estado ROBOT L2 (0=Marcha, <>Incidencia)	DB50.DBW30	
DB125.DBW130	Estado ROBOT L1 (0=Marcha, <>Incidencia)	DB60.DBW30	
DB125.DBW132			
DB125.DBW134			
DB125.DBD136	Código SAP producto actual L2	DB11.DBD50	DBB
DB125.DBD140	Código SAP producto actual L1	DB21.DBD50	DBB
DB125.DBD144			
DB125.DBX148.0			
DB125.DBX148.1	L1 sin servicio	M1.6	
DB125.DBX148.2	L2 sin servicio	M1.4	
DB125.DBX148.3			
DB125.DBX148.4			
DB125.DBX148.5			
DB125.DBX148.6			
DB125.DBX148.7	Etiquetadora L1 en marcha (1), espera (0)	M40.2	
DB125.DBX149.0	Etiquetadora L2 en marcha (1), espera (0)	M40.6	
DB125.DBX149.1			
DB125.DBX149.2			
DB125.DBX149.3			
DB125.DBX149.4			
DB125.DBX149.5			
DB125.DBX149.6			
DB125.DBX149.7			
DB125.DBX150.0	Alarma fallo servo L1	E113.0	
DB125.DBX150.1	Alarma fallo servo L2	E105.3	
DB125.DBX150.2			
DB125.DBX150.3			
DB125.DBX150.4			
DB125.DBX150.5			
DB125.DBX150.6			
DB125.DBX150.7			
DB125.DBX151.0			
DB125.DBX151.1			
DB125.DBX151.2	Alarma térmico alimentador cartón L1	M120.1	
DB125.DBX151.3	Alarma térmico alimentador cartón L2	M120.0	
DB125.DBX151.4	Error etiquetadora L1	DB1.DBX1.5	
DB125.DBX151.5	Error etiquetadora L2	DB1.DBX7.1	
DB125.DBX151.6			
DB125.DBX151.7			

FANUC			
inPALET3	PLC Cajas 1		
DB125.DBX152.0			
DB125.DBX164.0			
DB125.DBX178.0			
DB125.DBW192			
DB125.DBW194			
DB125.DBW196			
DB125.DBW198	Atasco en túnel HDL (=1)	MW70	
DB125.DBW200			
DB125.DBW202			
DB125.DBW204	Estado Transporte Cajas (0=Marcha, <>Incidencia)	DB50.DBW30	
DB125.DBW206	Estado Transporte Cajas HDL (0=Marcha, <>Incidencia)	DB60.DBW30	
DB125.DBW208			
DB125.DBW210			

A.5 L NEAS EMMETTI A Y B

En estas l neas la rutina de cableado de posiciones de memoria dentro de los PLC's concentradores es la FC130, manteni ndose el DB125 como DB de datos.

A.5.1 Datos globales intercambiados entre los PLC's

	Identificador GD	inPieri_A\ CPU 314C 2 DP	inPAL_A\ CPU 314C 2 DP	inPieri_B\ CPU 314C 2 DP	inPAL_B\ CPU 314C 2 DP	inMagPal\ CPU 313C 2 DP
1	GD 1.1.1	DB125.DBD98	>DB100.DBD12			
2	GD 1.1.2	DB125.DBD136	>DB22.DBD0			
3	GD 1.1.3	DB125.DBX148.0	>A0.0			
4	GD 1.1.4	DB125.DBX148.1	>A0.1			
5	GD 1.1.5	DB125.DBX148.2	>A0.2			
6	GD 1.1.6	DB125.DBX150.0	>A0.3			
7	GD 2.1.1	DB125.DBX150.1	>A0.4			
8	GD 3.1.1			DB125.DBD98	>DB100.DBD12	
9	GD 3.1.2			DB125.DBD136	>DB22.DBD0	
10	GD 3.1.3			DB125.DBX148.0	>A0.0	
11	GD 3.1.4			DB125.DBX148.1	>A0.1	
12	GD 3.1.5			DB125.DBX148.2	>A0.2	
13	GD 3.1.6			DB125.DBX150.0	>A0.3	
14	GD 4.1.1			DB125.DBX150.1	>A0.4	
15	GD 5.1.1			DB125.DEX224.0		>A0.0
16	GD 5.1.2			DB125.DEX224.1		>A0.1
17	GD 5.1.3			DB125.DEX224.2		>A0.2
18	GD 5.1.4			DB125.DEX226.0		>A0.3
19	GD 5.1.5			DB125.DEX226.1		>A0.4
20	GD					
21	GD					

A.5.2 Posiciones de memoria en el PLC concentrador (enfardadora A)

EMMETTI A			
inPALET1	PLC Enfardadora A (PIER1)		
DB125.DBX0.0			
DB125.DBX12.0			
DB125.DBX26.0			
DB125.DBW40			
DB125.DBW42	Numero programas enfardado	DB10.DBW22	INT
DB125.DBW44			
DB125.DBW46			
DB125.DBW48			
DB125.DBW50			
DB125.DBW52			
DB125.DBW54			
DB125.DBW56			
DB125.DBW58			
DB125.DBD60			
DB125.DBD64			
DB125.DBD68			
DB125.DBX72.0	ENFARD - Ciclo AUTO (Marcha)	A124.5	
DB125.DBX72.1	ENFARD - ALARMA (1)	A124.4 ó A124.6	
DB125.DBX72.2	ENFARD - Standby (1)	No Hay	
DB125.DBX72.3	PAL A - Ciclo AUTO (Marcha)	NO DBX148.0	
DB125.DBX72.4	PAL A - Alarma	DBX150.0	
DB125.DBX72.5	PAL A - Standby	No Hay	
DB125.DBX72.6			
DB125.DBX72.7			
DB125.DBX73.0			
DB125.DBX73.1			
DB125.DBX73.2			
DB125.DBX73.3			
DB125.DBX73.4			
DB125.DBX73.5			
DB125.DBX73.6			
DB125.DBX73.7			
DB125.DBX74.0	Máquina en emergencia	A124.4	
DB125.DBX74.1	Alarma apertura puerta	A124.6	
DB125.DBX74.2			
DB125.DBX74.3			
DB125.DBX74.4			

	EMMETTI A	
inPALET2	PLC Paletizador A	
DB125.DBX76.0		
DB125.DBX98.0	Código de FTP en curso	DB100DBW12
DB125.DBX102.0		
DB125.DBW116		
DB125.DBW118		
DB125.DBW120		
DB125.DBW122		
DB125.DBW124		
DB125.DBW126		
DB125.DBW128		
DB125.DBW130		
DB125.DBW132		
DB125.DBW134		
DB125.DBD136	Estado alimentador palet madre (0=OK, <>Incidencia)	DB22.DBD0
DB125.DBX137.0	Alarma en alimentador de palet	
DB125.DBD144		
DB125.DBX148.0	Paletizador Parado	A0.0
DB125.DBX148.1	Paletizador en manual	A0.1
DB125.DBX148.2	Paletizador en automático (marcha)	A0.2
DB125.DBX148.3	Negado de Paletizador en automático (Marcha = 0)	
DB125.DBX148.4		
DB125.DBX148.5		
DB125.DBX148.6		
DB125.DBX148.7		
DB125.DBX149.0		
DB125.DBX149.1		
DB125.DBX149.2		
DB125.DBX149.3		
DB125.DBX149.4		
DB125.DBX149.5		
DB125.DBX149.6		
DB125.DBX149.7		
DB125.DBX150.0	Relé de emergencia activado	A0.3
DB125.DBX150.1	Alarma en paletizador	A0.4
DB125.DBX150.2		
DB125.DBX150.3		
DB125.DBX150.4		

A.5.3 Posiciones de memoria en el PLC concentrador (enfardadora B)

EMMETTI B			
inPALET1	PLC Enfardadora B (PIER1)		
DB125.DBX0.0			
DB125.DBX12.0			
DB125.DBX26.0			
DB125.DBW40			
DB125.DBW42	Numero programa enfardado	DB10.CBW22	INT
DB125.DBW44			
DB125.DBW46			
DB125.DBW48			
DB125.DBW50			
DB125.DBW52			
DB125.DBW54			
DB125.DBW56			
DB125.DBW58			
DB125.DBD60			
DB125.DBD64			
DB125.DBD68			
DB125.DBX72.0	ENFARD - Ciclo AUTO (Marcha)	A124.5	
DB125.DBX72.1	ENFARD - ALARMA (1)	A124.4 ó A124.6	
DB125.DBX72.2	ENFARD - Standby (1)	No Hay	
DB125.DBX72.3	PAL B - Ciclo AUTO (Marcha)	NO DBX148.0	
DB125.DBX72.4	PAL B - Alarma	DBX150.0	
DB125.DBX72.5	PAL B - Standby	No Hay	
DB125.DBX72.6			
DB125.DBX72.7			
DB125.DBX73.0			
DB125.DBX73.1	ALIMENT - Ciclo Marcha	DBX148.2	
DB125.DBX73.2	ALIMENT - Alarma	150.0 ó 150.1	
DB125.DBX73.3	ALIMENT - Standby	No Hay	
DB125.DBX73.4			
DB125.DBX73.5			
DB125.DBX73.6			
DB125.DBX73.7			
DB125.DBX74.0	Máquina en emergencia	A124.4	
DB125.DBX74.1	Alarma apertura puerta	A124.6	
DB125.DBX74.2			
DB125.DBX74.3			

EMMETTI B		
inPALET2	PLC Paletizador B	
DB125.DBX76.0		
DB125.DBX98.0	Código de FTP en curso	DB100DBW12
DB125.DBX102.0		
DB125.DBW116		
DB125.DBW118		
DB125.DBW120		
DB125.DBW122		
DB125.DBW124		
DB125.DBW126		
DB125.DBW128		
DB125.DBW130		
DB125.DBW132		
DB125.DBW134		
DB125.DBD136	Estado alimentador palet madre (0=OK, <>Incidencia)	DB22.DBD0
DB125.DBX137.0	Alarma en alimentador de palet	
DB125.DBD140		
DB125.DBX148.0	Paletizador Parado	A0.0
DB125.DBX148.1	Paletizador en manual	A0.1
DB125.DBX148.2	Paletizador en automático (marcha)	A0.2
DB125.DBX148.3		
DB125.DBX148.4		
DB125.DBX148.5		
DB125.DBX148.6		
DB125.DBX148.7		
DB125.DBX149.0		
DB125.DBX149.1		
DB125.DBX149.2		
DB125.DBX149.3		
DB125.DBX149.4		
DB125.DBX149.5		
DB125.DBX149.6		
DB125.DBX149.7		
DB125.DBX150.0	Relé de emergencia activado	A0.3
DB125.DBX150.1	Alarma en paletizador	A0.4
DB125.DBX150.2		
DB125.DBX150.3		

EMMETTI B			
inPALET3	PLC Alimentador Cartón (MAG PAL)		
DB125.DBX152.0			
DB125.DBX164.0			
DB125.DBX178.0			
DB125.DBW192			
DB125.DBW194			
DB125.DBW196			
DB125.DBW198			
DB125.DBW200			
DB125.DBW202			
DB125.DBW204			
DB125.DBW206			
DB125.DBW208			
DB125.DBW210			
DB125.DBD212			
DB125.DBD216			
DB125.DBD190			
DB125.DBX224.0	Alimentador Parado	A0.0	
DB125.DBX224.1	Alimentador en manual	A0.1	
DB125.DBX224.2	Alimentador en automático (marcha)	A0.2	
DB125.DBX224.3			
DB125.DBX224.4			
DB125.DBX224.5			
DB125.DBX224.6			
DB125.DBX224.7			
DB125.DBX225.0			
DB125.DBX225.1			
DB125.DBX225.2			
DB125.DBX225.3			
DB125.DBX225.4			
DB125.DBX225.5			
DB125.DBX225.6			
DB125.DBX225.7			
DB125.DBX226.0	Relé de emergencia activado	A0.3	
DB125.DBX226.1	Alarma en alimentador de cartón	A0.4	
DB125.DBX226.2			
DB125.DBX226.3			