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Design Of Controller For Inspection Packaging And Storage

P.SATYANARAYANA MURTHY

EMAIL:- parcha.satyam@gmail.com

UNDER THE ESTEEM GUIDENCE OF

DR.B.SUDHEER PREM KUMAR

PROFESSOR OF JNTU COLLEGE OF ENGINEERING & TECHNOLOGY

Abstract:- This paper presents the design of controller for inspection and packaging using programmable logic controller. This will automate the process of inspection and packaging without any human intervention. This Is a Programming Project with plc for Inspection Packing and Automated Storage of Any Manufactured Component with Ladder logic. Traditional Inspection Packaging and Automatic Storage Requires Lot of Human Intervention Money and Safety Will be The Main Problem. To Overcome This Problem We Have Introduced Programmable Logic Controller. Most Of The Companies Are Using Microcontroller Based Automation. The Main Problem Of Using Microcontroller We Can Do Fixed Operations. We Can't Rewrite and Edit the Program. To Avoid This We Will Use Programmable Logic Controller. Uses Less Human Intervention. We Can Increase The Safety Measure. Profitable For Mass Production.The simulation can be done using step-7 software and simulation Through FACTORY I/O.

Keywords:- programmable logic controller, automation, Ladder logic.etc

Introduction:- Automation is used in various control systems for operating equipment such as machinery and process in factories with minimal or reduced human intervention. Prior to Programmable Logic Controllers (PLC), many control tasks were solved with contactor or relay controls . This is often referred to as hardwired control. Circuit diagrams had to be designed, electrical components specified and installed. Electricians would then wire the components necessary to perform a specific task. If an error was made the wires had to be reconnected correctly. A change in function or system expansion required extensive component changes and rewiring. With the improvement in the field of VLSI, Programmable Logic Controllers were developed. Thus nowadays, the same, as well as more complex tasks can be done with a Programmable Logic Controller. Wiring between devices and relay contacts is done in the Programmable Logic Controller program. Hard-wiring, though still required to connect field devices, is less intensive. Modifying the application and correcting errors are easier to handle. It is easier to create and change a program in a Programmable Logic Controller than it is to wire and rewire a circuit. A Programmable Logic Controller can be programmed in the following five languages (a) Ladder diagram (LAD)-Ladder logic uses graphic symbols similar to relay schematic circuit diagrams. (b) Functional block diagram (FBD)-The Function Block Diagram is a graphical language which can describe the function between input variables and output variables. (c) Statement list (STL)-Statement list is a programming language using mnemonic abbreviations of Boolean logic operations. Programmable Logic Controllers (PLCs) are used in commercial and industrial applications.(d) Instructions list- There are other methods to program PLCs. One of the earliest techniques involved mnemonic instructions. These instructions can be derived directly from the ladder logic diagrams and entered into the PLC. through a simple programming terminal. Programmable Logic Controllers consist of input modules or points, a Central Processing Unit (CPU), and output modules or points . An input accepts a variety of digital or analog signals from various field devices (sensors) and converts them into a logic signal that can be used by the CPU. The CPU makes decisions and executes control instructions based on program instructions in memory. Output modules

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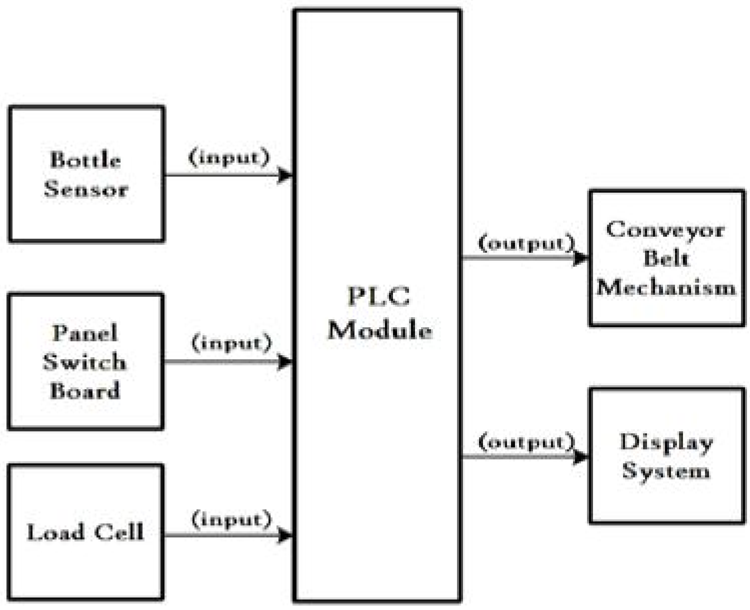
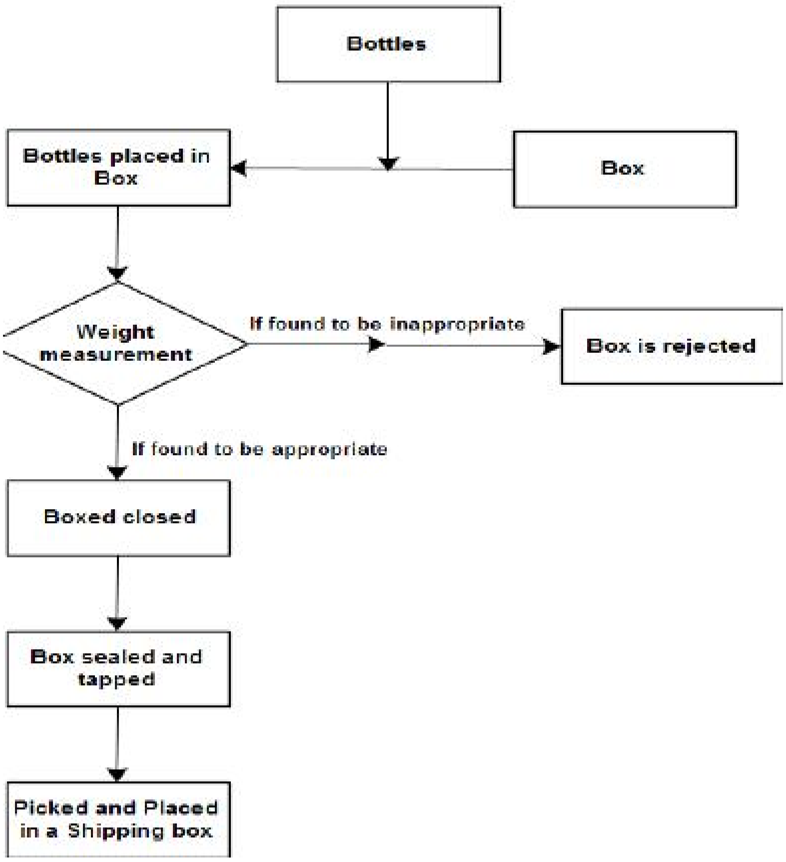
convert control instructions from the CPU into a digital or analog signal that can be used to control various field devices (actuators). A programming device is used to input the desired instructions. These instructions determine what the PLC will do for a specific input.

Block diagram:-



The above Block diagram shows that Bottle sensor panel switch board and Load cells are internally connected the outputs are conveyor belt Mechanism and Display system shows how does the controllers are actually connected. Generally the sensors that we will use are inductive sensors and switches that we will use are limit switches and mostly pushbuttons.

Flow diagram:-



The above diagram show the flow of steps that we follow in the procedure first the bottles will be placed in a box then it will goes to the weight measurement if found to be inappropriate the box will be rejected or if the box weight found appropriate the box will be closed then the box will be sealed and tapped then picked and placed in a shipping box then it will go to the storage.

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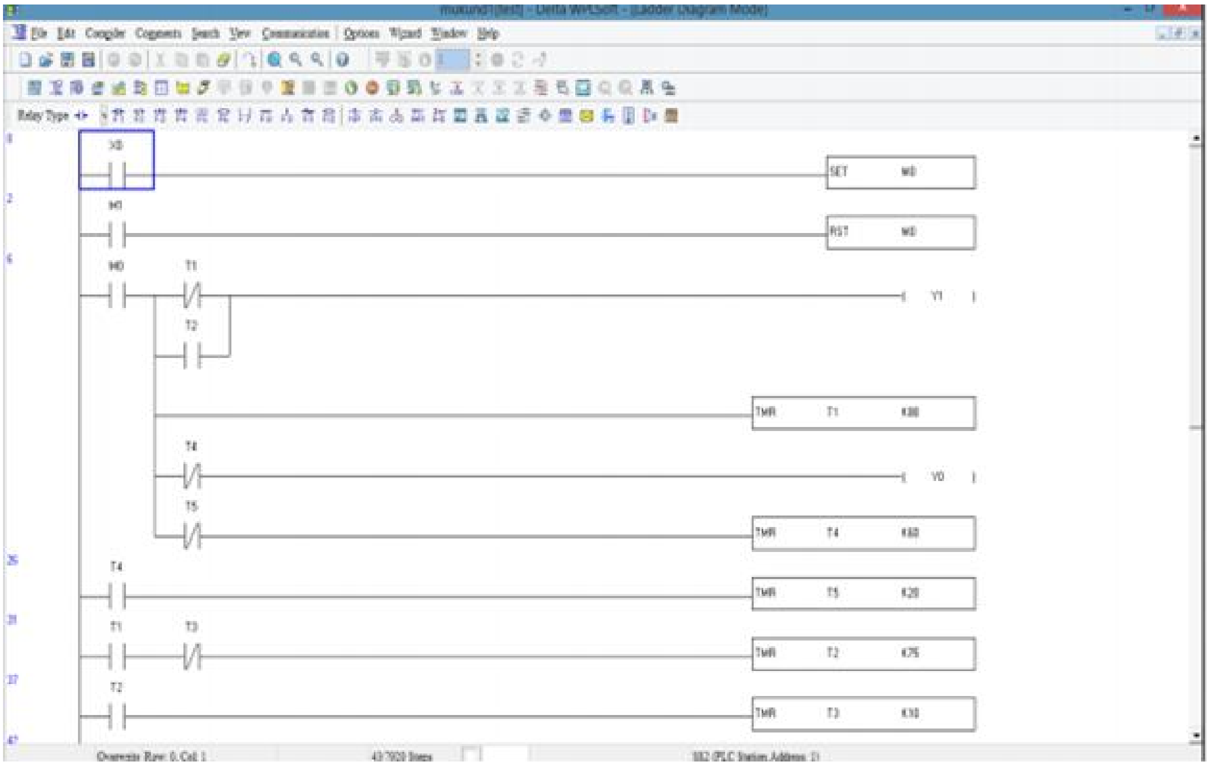
Simulation model:-



Progress till date:-

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Some piece of the rationale actualized in the program is clarified ahead.

D. Conveyor prepared to begin. System appeared in figure 4 characterizes the rationale to check for blast transport prepared to begin condition. Memory bit M50.0 is doled out to Boom deficiency bit. There are many flaw condition, for example, pull harmony initiated deficiency, zero speed switch flaw, belt influence switch issue, blast over-burden deficiency, blast forward/turn around on input flaw, blast break utmost switch issue. Assuming any of these issues emerge the blast issue bit will be set to 1, as the contact relegated to M50.0 is a regularly shut contact this will bring about opening the contact.

Therefore in such a case blast isn't prepared to begin. Thus rationale 1 at DBX1.2 implies the belt influence switch is initiated, this will break the contact. Then again if the belt influence switch is to be by passed, I 24.3 is set to 1. This will build up a contact and the blast will be prepared to begin which means M50.1 will be equivalent to 1.

E. Blast forward/turn around start memory bit. When the blast is prepared to begin that is, M50.1 is set, the blast transport can be begun in either nearby or manual mode delineates the stepping stool rationale for the equivalent. Local mode: I 16.5 will be set when nearby mode is chosen. I 24.0 is an information showing forward start order from the push button in nearby mode. T1 is a clock, it gives rationale 1 at its yield after a predefined measure of time once it gets a 1 at its information and in this case 1 sec is the clock esteem. Once the clock passes M 55.1and M50.2 will be set furthermore, these memory bits can be additionally utilized in the program. Manual mode: I 16.3 will be equivalent to 1 if manual mode is chosen. At the point when the blast transport works a forward way it implies it is stacking the material. I 15.2 is an contribution for choosing stacking mode. The blast transport can either be worked from the control work area or the human machine interface. I 12.4 is a contribution from control work area and DBX0.0 is a piece which turned out to be 1 when forward start order is given from the human machine interface. When this association is set up memory bits M55.1 and M 50.3 will be set, these memory bits can be additionally utilized in the program. shows the rationale for the blast transport to work forward way otherwise called the stacking mode. A comparative rationale can be composed for running the blast transport backward heading to work it in recovering mode.

F. Blast brake discharge.

System appeared in figure 6 characterizes the rationale to check for transport brake discharge condition. Previously beginning the blast transport brake ought to be discharged. For forward or invert bearing, the blast transport can be begun in neighbourhood or manual mode. Memory bits M50.2, M50.3 are allocated to blast neighbourhood and manual start bits for forward heading otherwise called stacking mode. Memory bits M50.5, M50.6 are relegated for conveyor neighbourhood and manual beginning bits for turn around heading .On the off chance that any of these mode is chosen to work blast transport in forward/invert heading, the regularly open contact will be shut. T3 is a clock; it gives rationale 1 at its yield after a predefined measure of time in the clock esteem once it gets a 1 at its info and for this situation 10 sec is the clock esteem once the clock slips by blast transport brake discharge bit, Q 5.2 will be set.

G. Blast transport forward/turn around start direction.

The rationale was to create neighbourhood and manual beginning memory bits, presently these memory bits are utilized in to really turn over the engines of transport prepared to begin memory bit from is additionally utilized in this rationale. When M50.1 is 1 what's more, either manual or neighbourhood mode is chosen the clock 6 gets an info and it begins the clock with a clock estimation of 5 seconds. The clock T4 and T5 are characterized for alarm. Alarm is a significant piece of any material taking care of plant; its capacity is to caution all the labourers in the region that the machine is going to start. Its fundamental design is to guarantee human security. The alarm rings for a term indicated in clocks T4 and T5. Later the brake discharge criticism is checked, if the brakes are discharged the info I 24.7 is rationale 1. Further transport switch start direction is checked, if it is set the association isn't built up. This is since the blast transport can't be worked in the forward and switch course at the same time. T9 is a clock for blast transport invert start direction. On getting a transport switch start order it is checked for 10 seconds, and the blast transport forward bearing engine on activity is prematurely ended just if the transport switch start information exists for 10 seconds. In the event that there is no invert start order an association is set up and the yield bit Q 5.0 ends up 1. This is the genuine yield bit which will work the engines in the field. M52.0 is a memory bit used to sidestep all the conditions. It is for the most part utilized for testing reason.

End This paper displays the computerization of Boom transport of a Stacker cum Reclaimer machine utilizing programmable rationale controller. PLC today are progressing as far as ability pertinence. The program is written in stepping stool language utilizing SIEMENS Step-7 programming. SIEMENS S7-300 arrangement programmable controller is utilized. The wiring and establishment strategy are additionally improved in light of the fact that the PLC information and yield gadgets are appointed with explicit locations, and subsequently it further streamlines investigating. PLC models might be recommended contingent upon the need and particulars of various forms. Some PLC is currently online while a few as of now have the document move convention (FTP) coordinated and email applications also. The program for transport activity in forward and switch mode is actualized and tried.

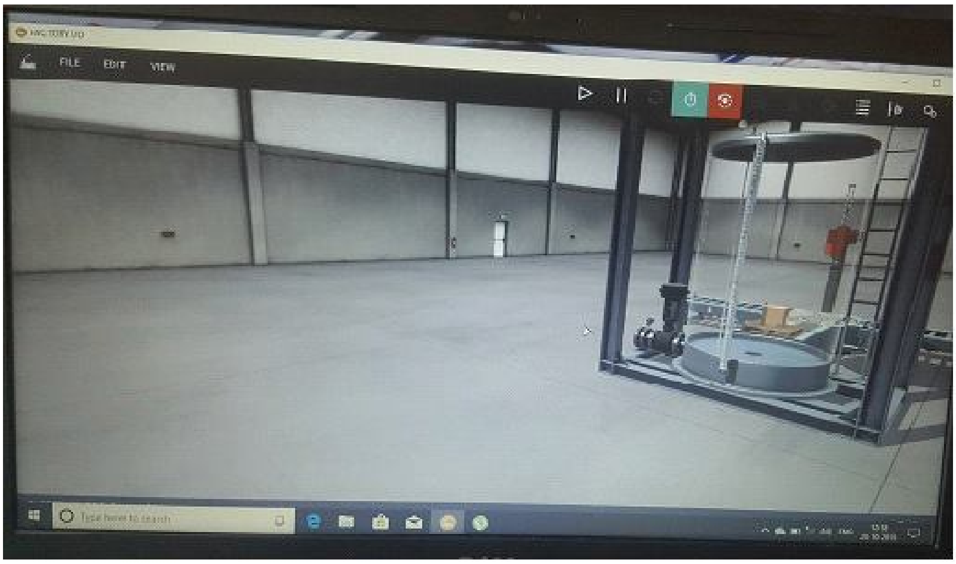
PROGRAMMING FEATURES OF FACTORY I/O:-

FACTORY I/O is a 3D factory simulation for learning automation technologies. Designed to be easy to use, it allows to quickly build a virtual factory using a selection of common industrial parts. FACTORY I/O also includes many scenes inspired by typical industrial applications, ranging from beginner to advanced difficulty levels.

The most common scenario is to use FACTORY I/O as a PLC training platform since PLC are the most common controllers found in industrial applications. However, it can also be used with microcontrollers, SoftPLC, Modbus, among many other technologies.

SIMULATION THROUGH FACTORY I/O:-

By using Factory I/O we can create simulation of the above model which is represented below.



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