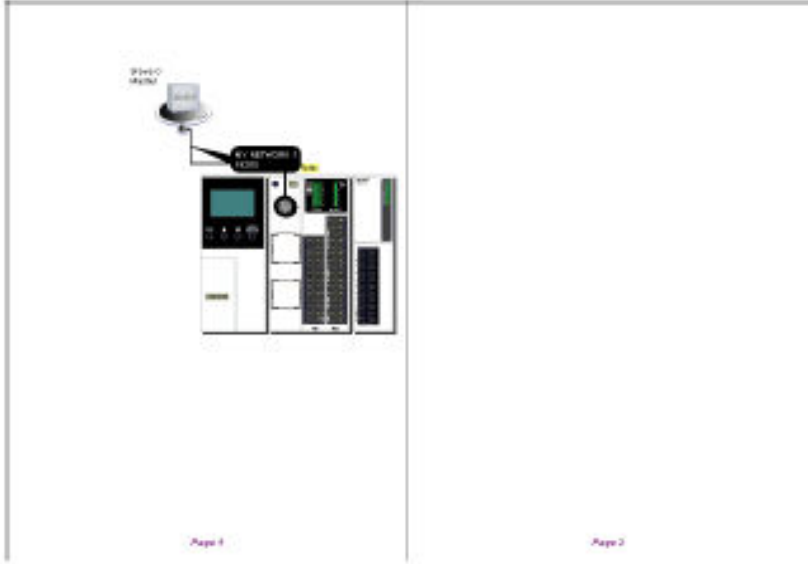
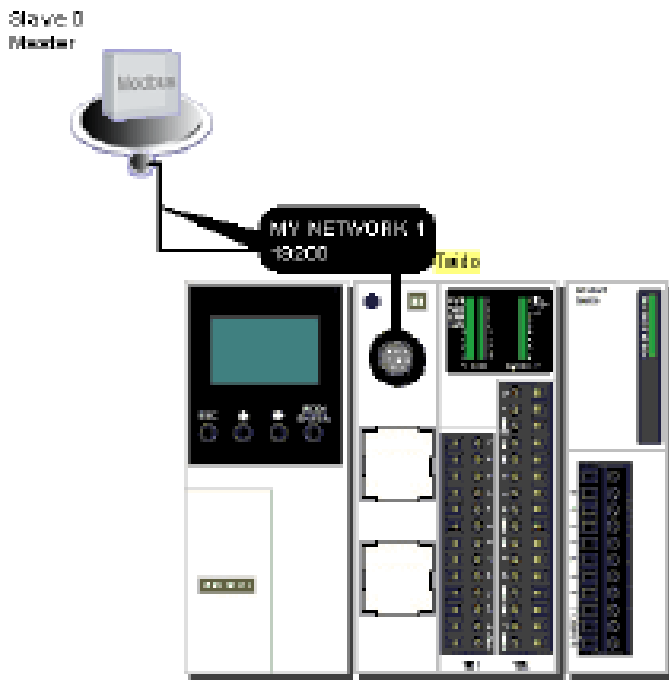


**LAMPIRAN A**  
**PROGRAM PLC**





## Properties

Network MY NETWORK 1 :

### Parameters

---

Type : Modbus  
Address : 1  
Baudrate : 19200  
Data Bits : 8 (RTU)  
Parity : none  
Stop Bit : 1  
Response Timeout: (x 100ms) : 10  
Time between frames (ms) : 10

### Element

---

Name	Type	Ad dr es s Ma st er
Slave 0	Modbus	

## Bill of material

Family	Reference number	Quantity
Twido	TWDLMDAZ00RT	1
Twido	TWDD08TT	1
Twido	TWDXCP00M	1
Modbus elements	Generic Modbus element	1

## Memory objects configuration

### Timer configuration (%TM)

Used	%TM	Symbol	Type	Adjustable	Time Base	Preset
Yes	%TM0		TON	Yes	100 ms	17
Yes	%TM1	TIMER_TESTING	TON	Yes	1 s	3
Yes	%TM2	TIMER_BOR	TP	Yes	1 s	5
Yes	%TM3		TP	Yes	100 ms	8
Yes	%TM4		TON	Yes	10 ms	50
Yes	%TM5	TIMER_SORTING	TP	Yes	100 ms	2
Yes	%TM6		TP	Yes	10 ms	110
Yes	%TM7		TON	Yes	100 ms	25
Yes	%TM8		TP	Yes	100 ms	5
Yes	%TM9		TP	Yes	100 ms	15

### Counter configuration (%C)

Used	%C	Symbol	Adjustable	Preset
Yes	%C0		Yes	0
Yes	%C1		Yes	5

### Register configuration (%R)

### Drum configuration (%DR)

### Scheduler block configuration (%SCH)

### Fast counters configuration (%FC)

### Very fast counters configuration (%VFC)

### Memory words (%MD)

### Memory words (%MW)

Used	%MW	Symbol	Allocated
Yes	%Mw2		Yes
Yes	%Mw3		Yes
Yes	%Mw4		Yes
Yes	%Mw5		Yes
Yes	%Mw6		Yes
Yes	%Mw7		Yes
Yes	%Mw8		Yes
Yes	%Mw9		Yes
Yes	%Mw10		Yes
Yes	%Mw11		Yes

### Memory words (%MF)

**Memory bits (%M)**

---

<b>Used</b>	<b>%M</b>	<b>Symbol</b>	<b>Allocated</b>
Yes	M0		Yes
Yes	M1		Yes
Yes	M2		Yes
Yes	M3		Yes
Yes	M4		Yes
Yes	M5		Yes
Yes	M6		Yes
Yes	M7		Yes
Yes	M8		Yes
Yes	M9		Yes
Yes	M10		Yes
Yes	M11		Yes
Yes	M13		Yes
Yes	M14		Yes
Yes	M15	ON_SCADA	Yes
Yes	M16	OFF__SCADA	Yes
Yes	M17	LAMPU_SCADA	Yes
Yes	M22	PROXIMITY_METAL_SCADA	Yes
Yes	M23		Yes
Yes	M24	PROXIMITY_DRILLING_MODULE_SCADA	Yes
Yes	M25	PROXIMITY_TESTING_SCADA	Yes
Yes	M41		Yes
Yes	M101	MATERIAL_1_SCADA	Yes
Yes	M102	MATERIAL_3_SCADA	Yes

**PID configuration (PID)**

---

**Constant configuration (%kD)**

---

**Constant configuration (%kW)**

---

**Constant configuration (%kF)**

---

**PLS/PWM configuration (%PLS/%PWM)**

---

**Configuration of external objects Comm**

---

**Configuration of external objects Drive**

---

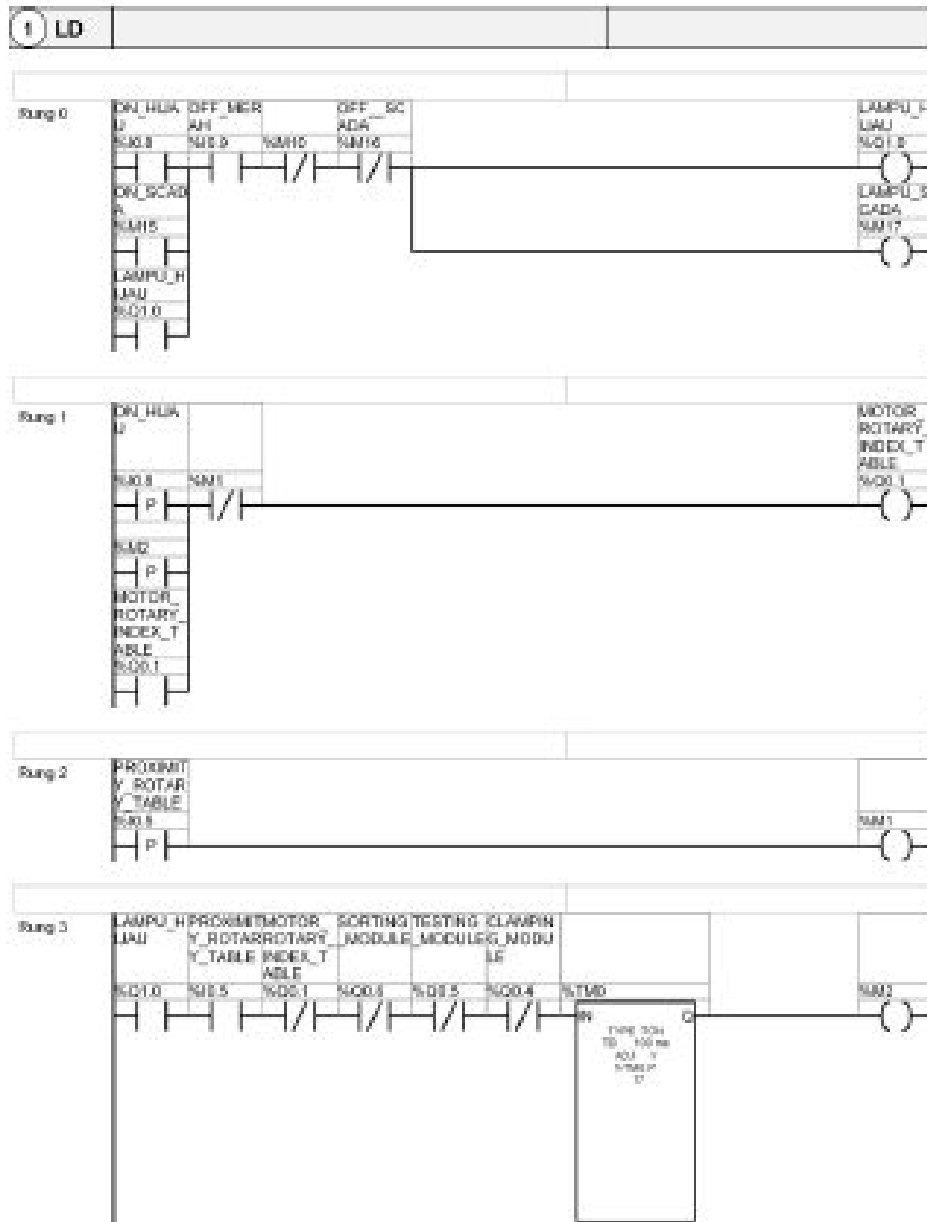
**Configuration of external objects Tesys**

---

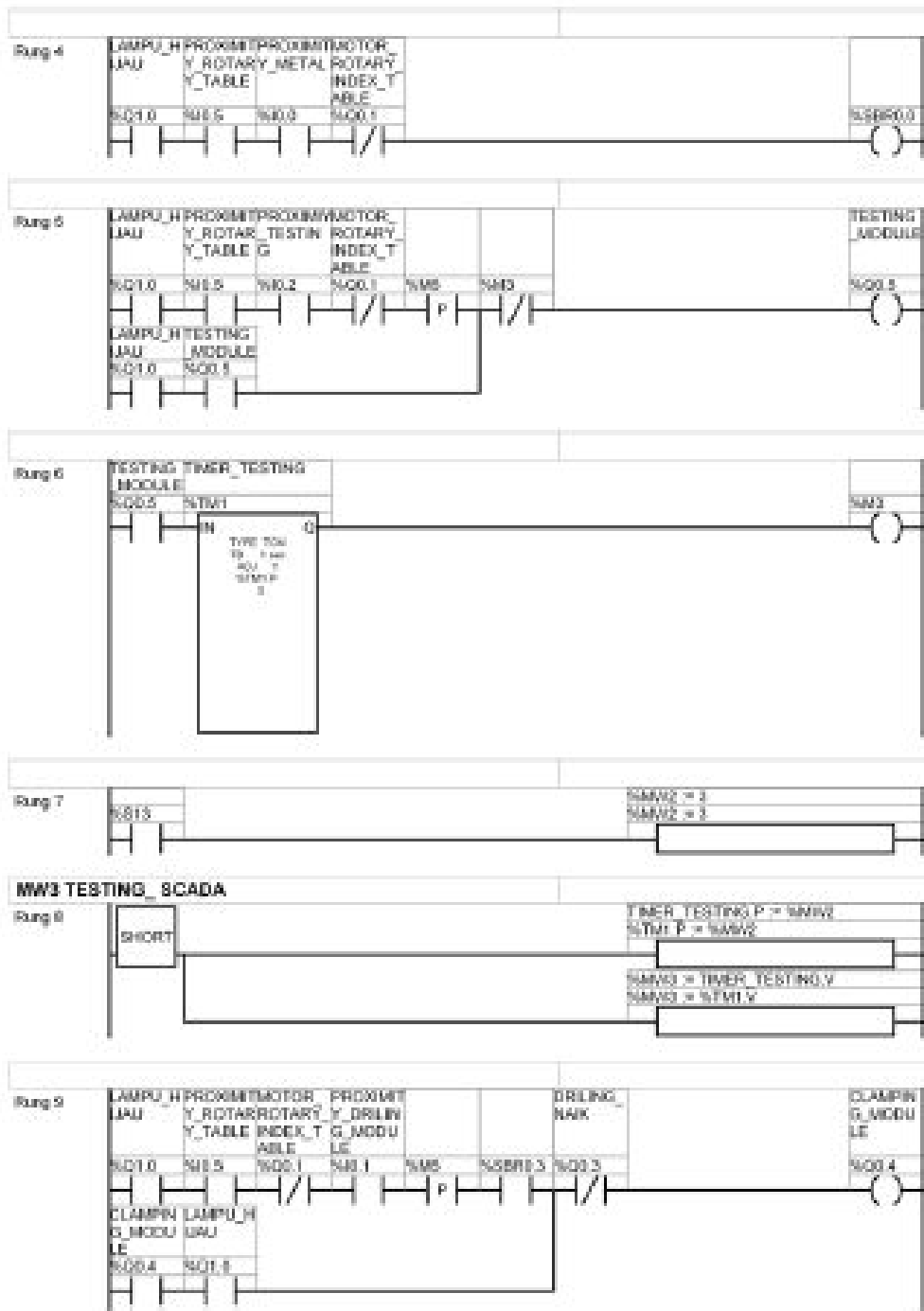
**Configuration of external objects Advantys OTB**

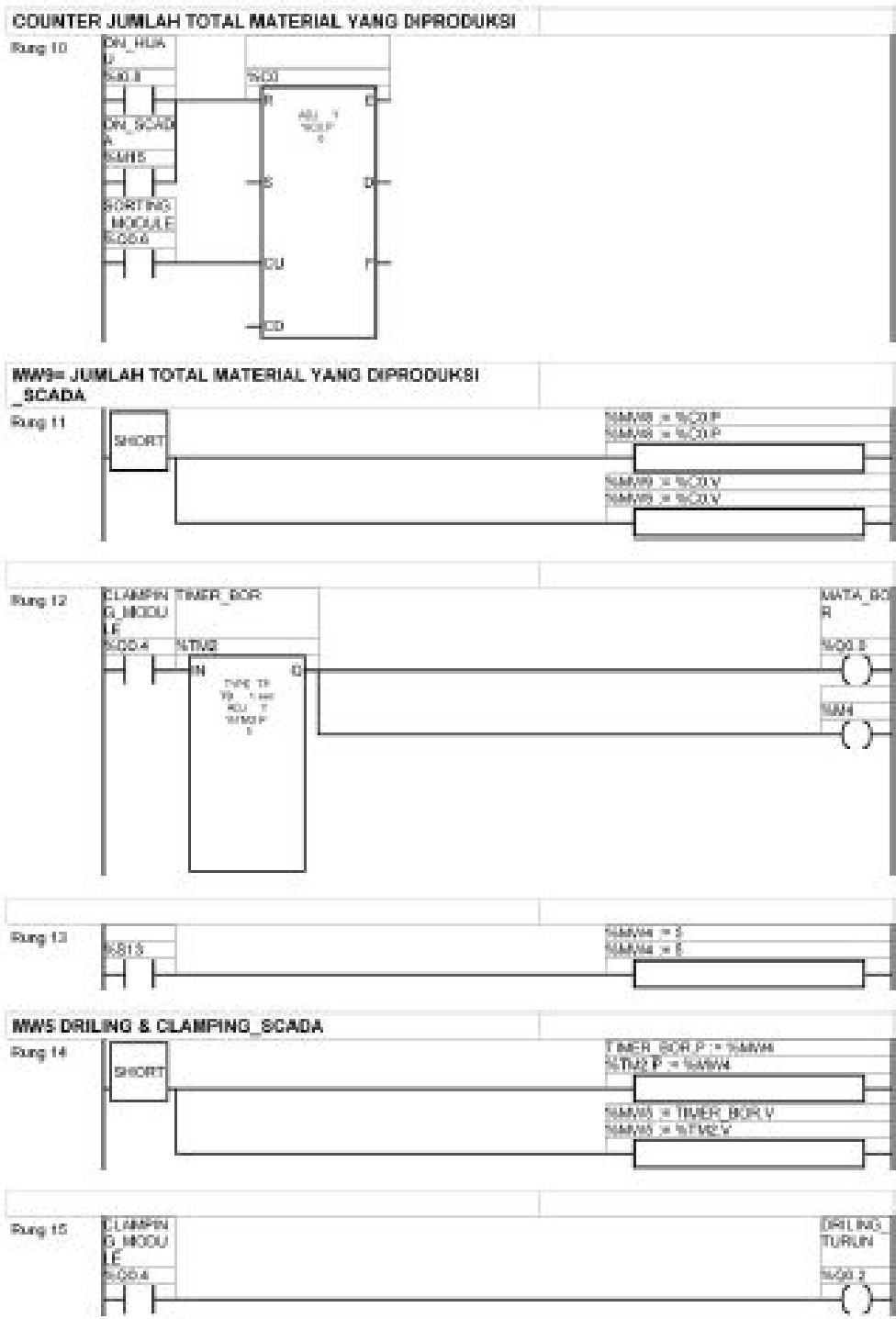
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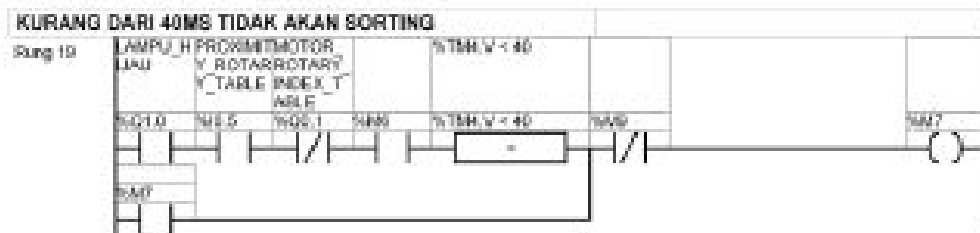
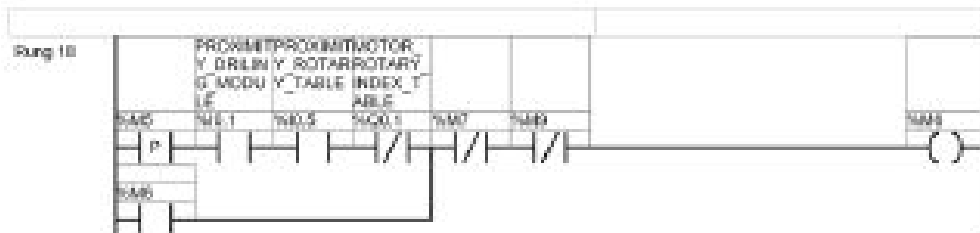
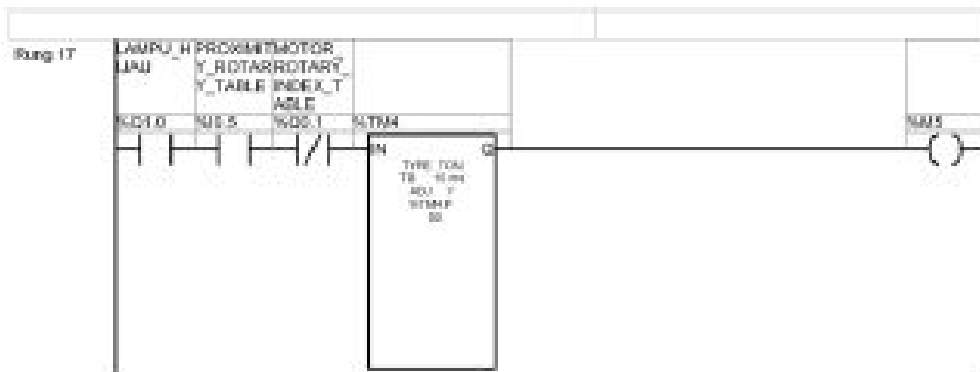
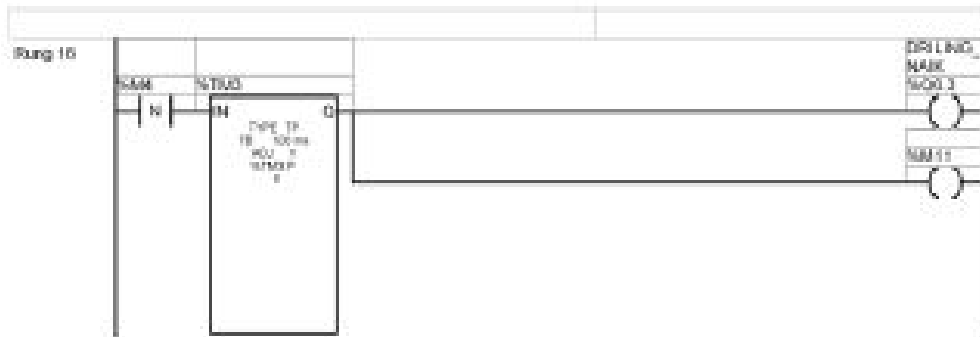
## Program lists and diagrams

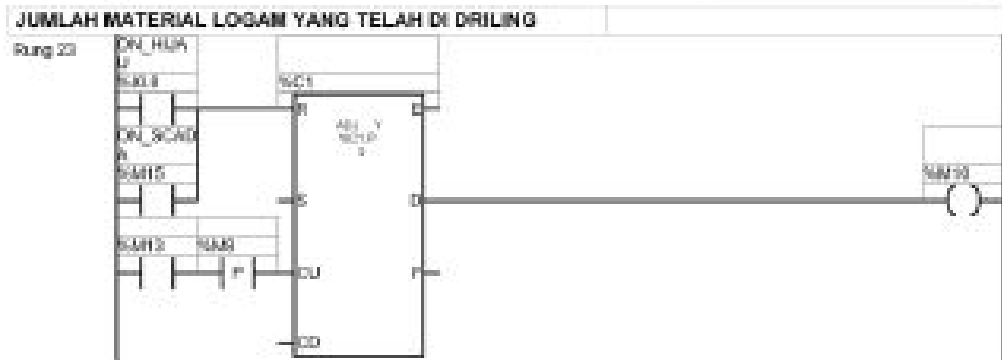
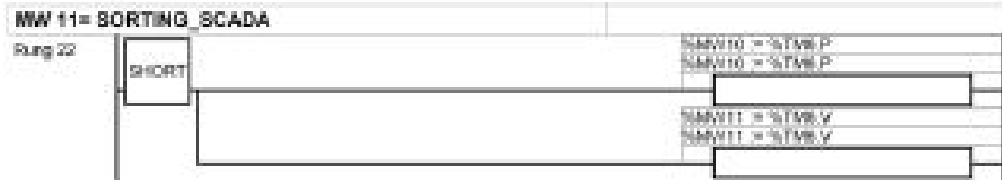
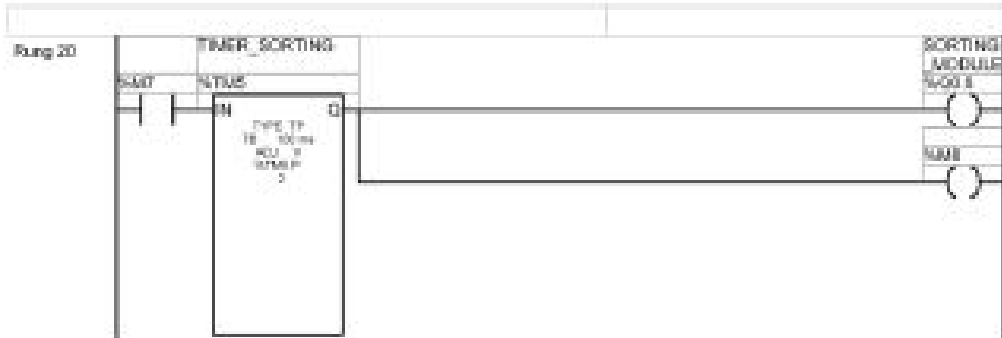




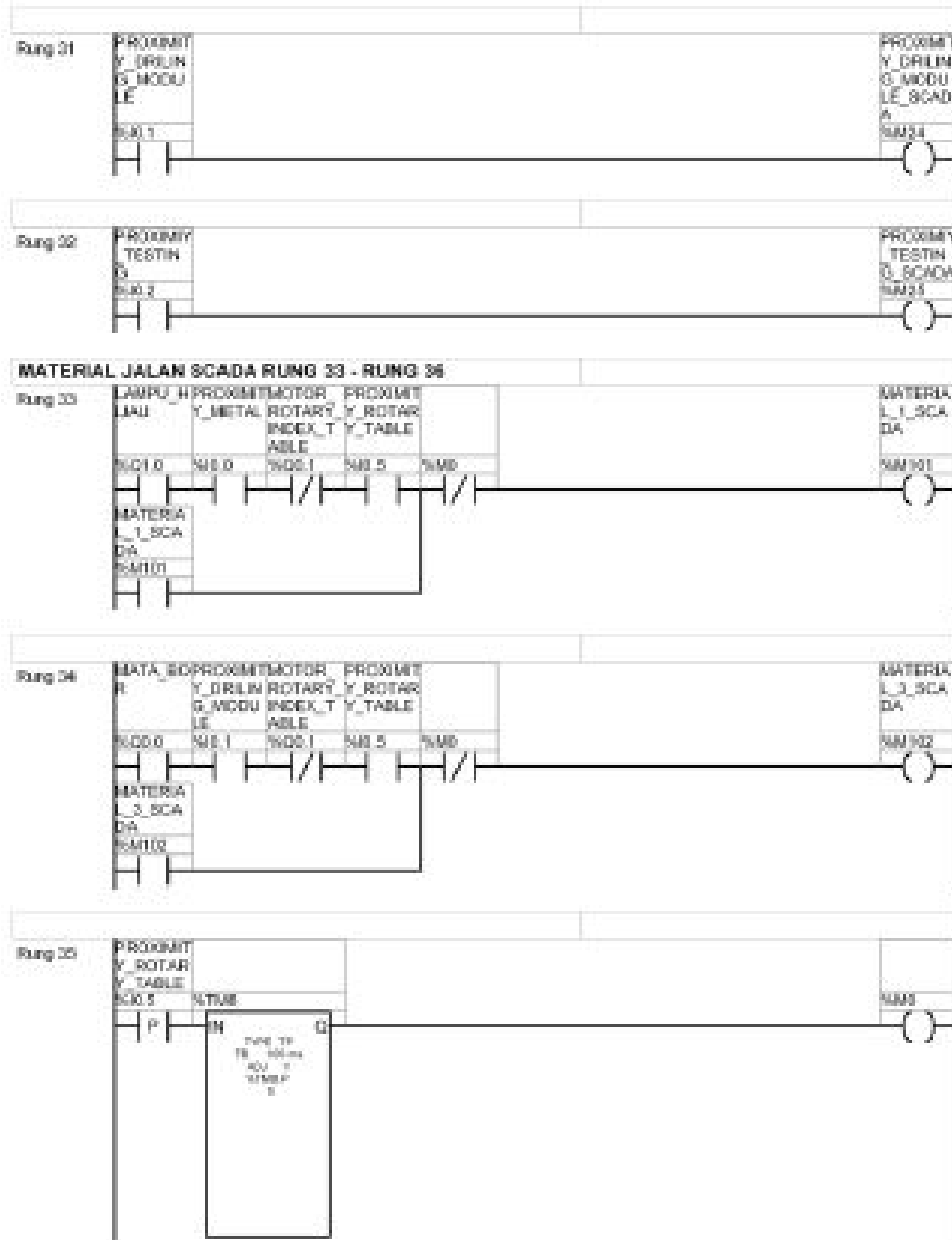














## Symbols

Used	Address	Symbol	Comment
Yes	%Q0.4	CLAMPING_MODULE	
Yes	%Q0.3	DRILLING_NAIK	
Yes	%Q0.2	DRILLING_TURUN	
Yes	%Q1.0	LAMPU_HIJAU	
Yes	%M17	LAMPU_SCADA	
Yes	%Q0.0	MATA_BOR	
Yes	%M101	MATERIAL_1_SCADA	
Yes	%M102	MATERIAL_3_SCADA	
Yes	%Q0.1	MOTOR_ROTARY_INDEX_TABLE	
Yes	%I0.9	OFF_MERAH	
Yes	%M16	OFF_SCADA	
Yes	%I0.8	ON_HIJAU	
Yes	%M15	ON_SCADA	
Yes	%I0.1	PROXIMITY_DRILLING_MODULE	
Yes	%M24	PROXIMITY_DRILLING_MODULE_SCADA	
Yes	%I0.0	PROXIMITY_METAL	
Yes	%M22	PROXIMITY_METAL_SCADA	
Yes	%I0.5	PROXIMITY_ROTARY_TABLE	
Yes	%I0.2	PROXIMITY_TESTING	
Yes	%M25	PROXIMITY_TESTING_SCADA	
Yes	%Q0.6	SORTING_MODULE	
Yes	%Q0.5	TESTING_MODULE	
Yes	%TM2	TIMER_BOR	
Yes	%TM5	TIMER_SORTING	
Yes	%TM1	TIMER_TESTING	

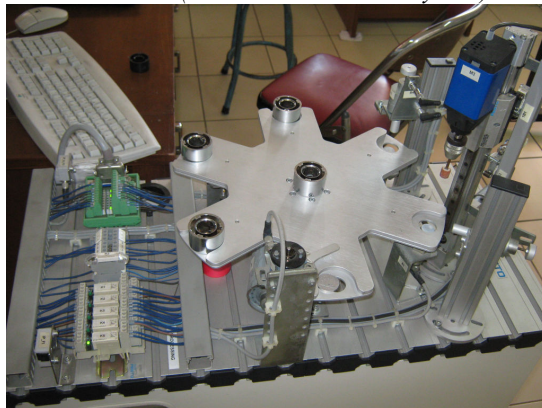


**LAMPIRAN B**  
**FOTO PERALATAN YANG DIGUNAKAN**

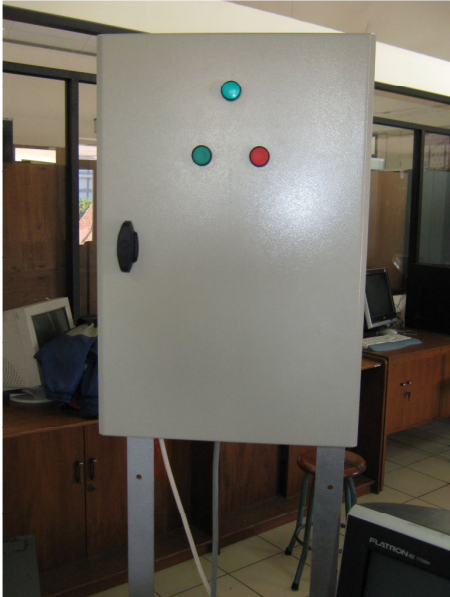
Alat yang digunakan



*Plant MPS (Modular Production System)*



Panel tampak luar



PLC Twido



PLC Twido



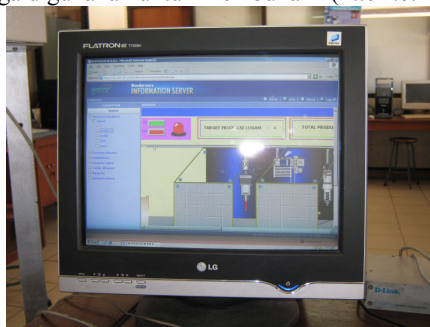
PC pertama digunakan untuk Twidosuite dan InTouch



PC kedua digunakan untuk *Web Server*



PC ketiga digunakan untuk membuka *IE(Internet Explorer)*



*Switch Ethernet*

