

Powder Soap Filling Process application

Powder Soap Filling Process application will help you in understanding **Timer instructions of STEP7 program.**

The application simulates a powder soap filling process; you will design PLC program to control the powder soap filling process using timer instruction as shown in figure (fig.1, fig.2).

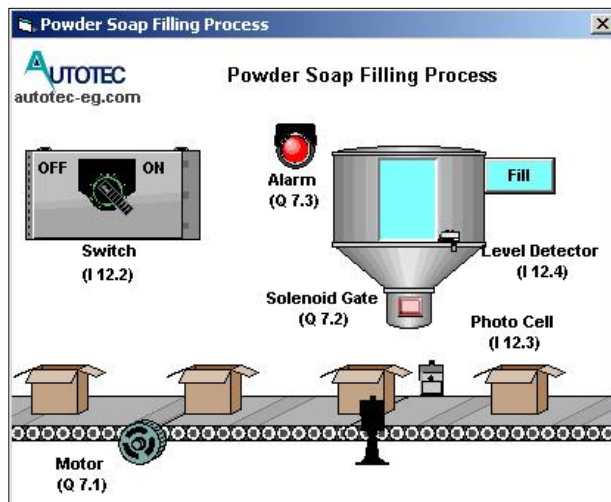


Fig.1

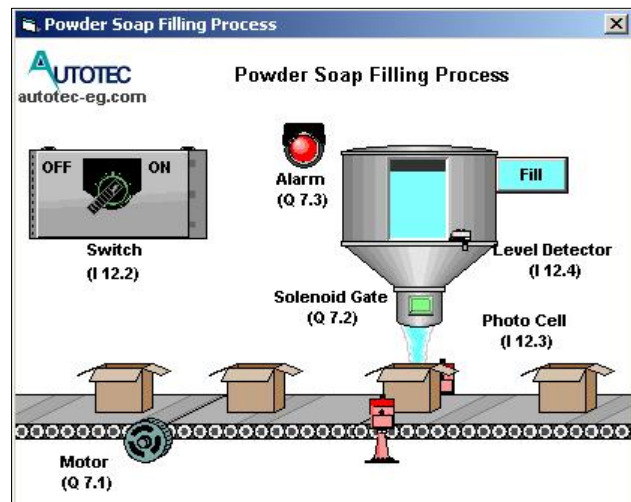


Fig.2

Description:

Upon switching the system to on the following sequence should happen:

- The conveyor should start to move.
- The conveyor should stop when the box cuts the photo cell beam.
- The gate should open for 5 seconds to fill the box with soap.
- The conveyor should move again until another box cuts the photo cell beam and so on.
- At any time if the soap level goes below the level detector the alarm should operate and the conveyor should stop until you fill the soap container using "Fill" Button shown in the above figures.