

## 2026-03-16 FanEnd+Blower+ThermalBreak\_V16 / PLC\_1 [CPU 1215C DC/DC/DC] / Program blocks

### Main Steps [FC1]

#### Main Steps Properties

##### General

Name	Main Steps	Number	1	Type	FC	Language	LAD
Numbering	Automatic						

##### Information

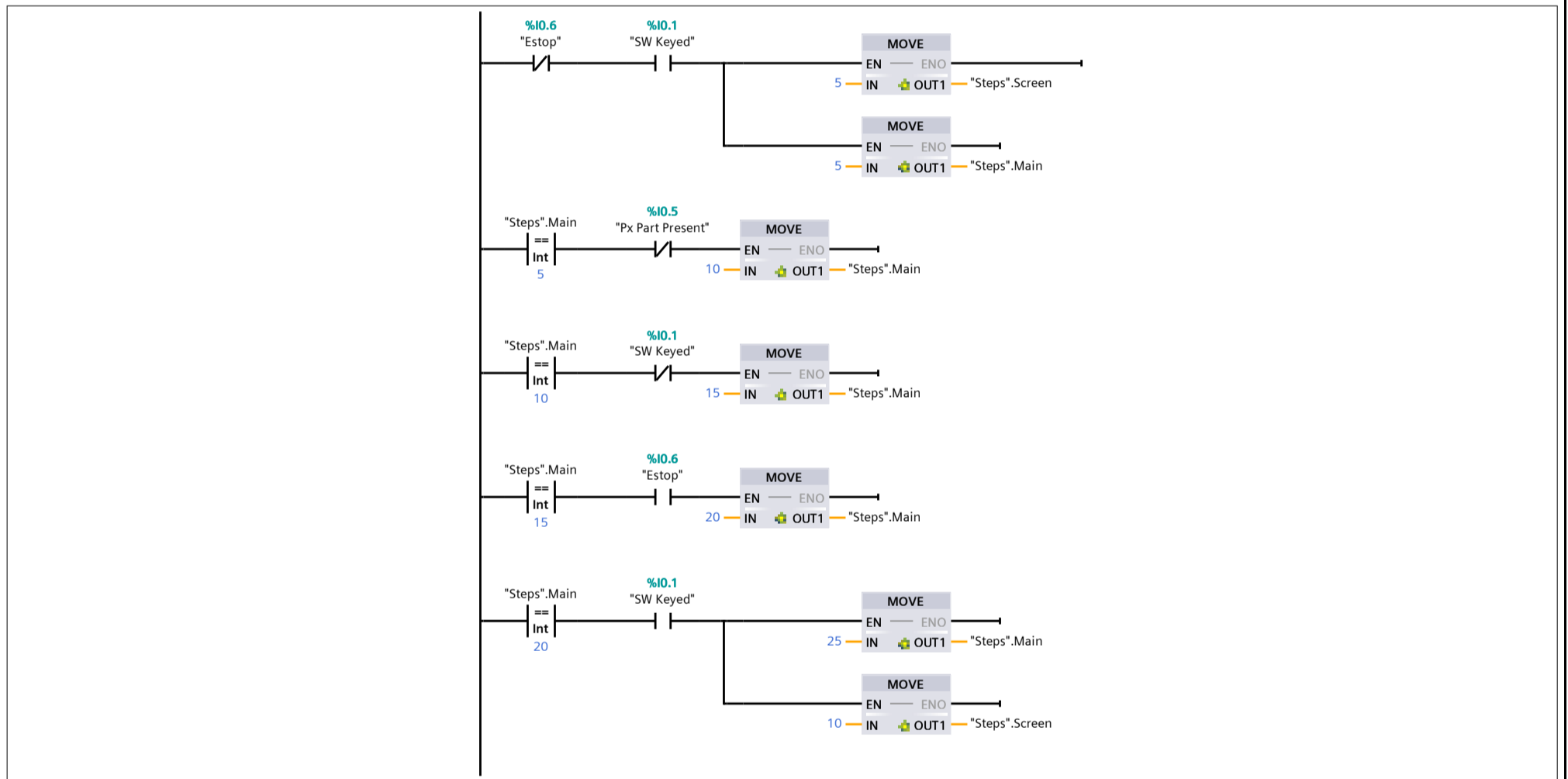
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

#### Main Steps

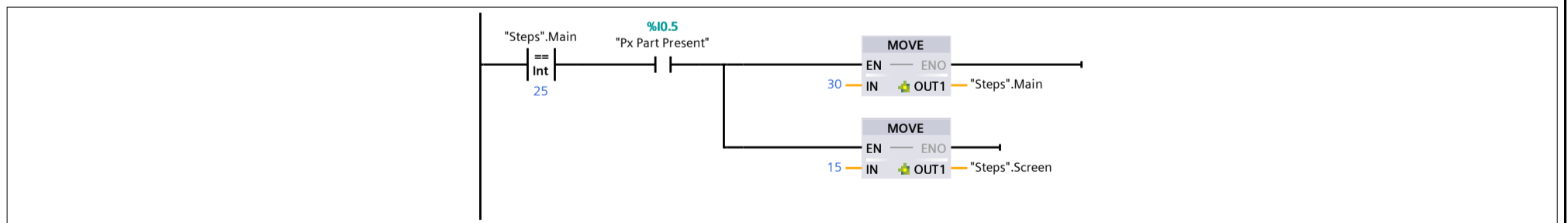
Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
Return			
Main Steps	Void		

#### Network 1: estop pressed & rest procedure

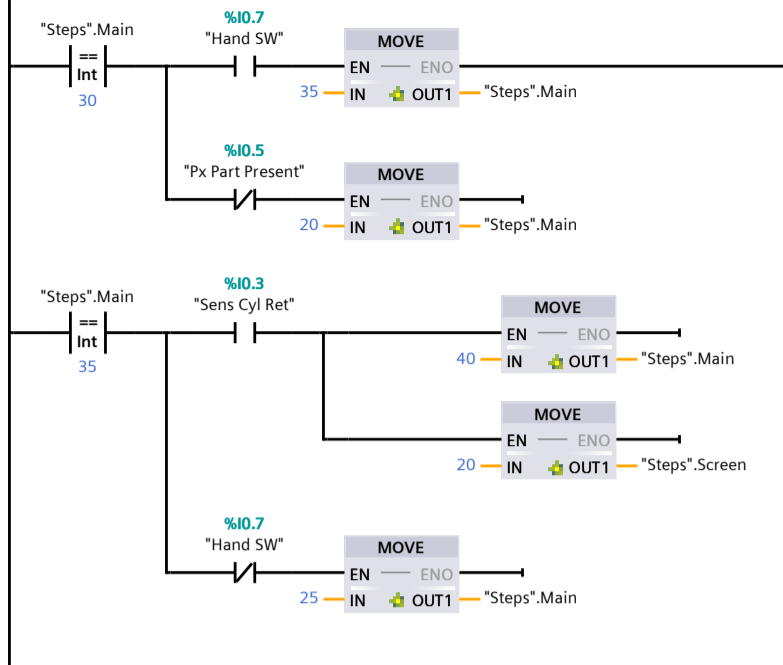
after pressing estop, screen shows reset procedure



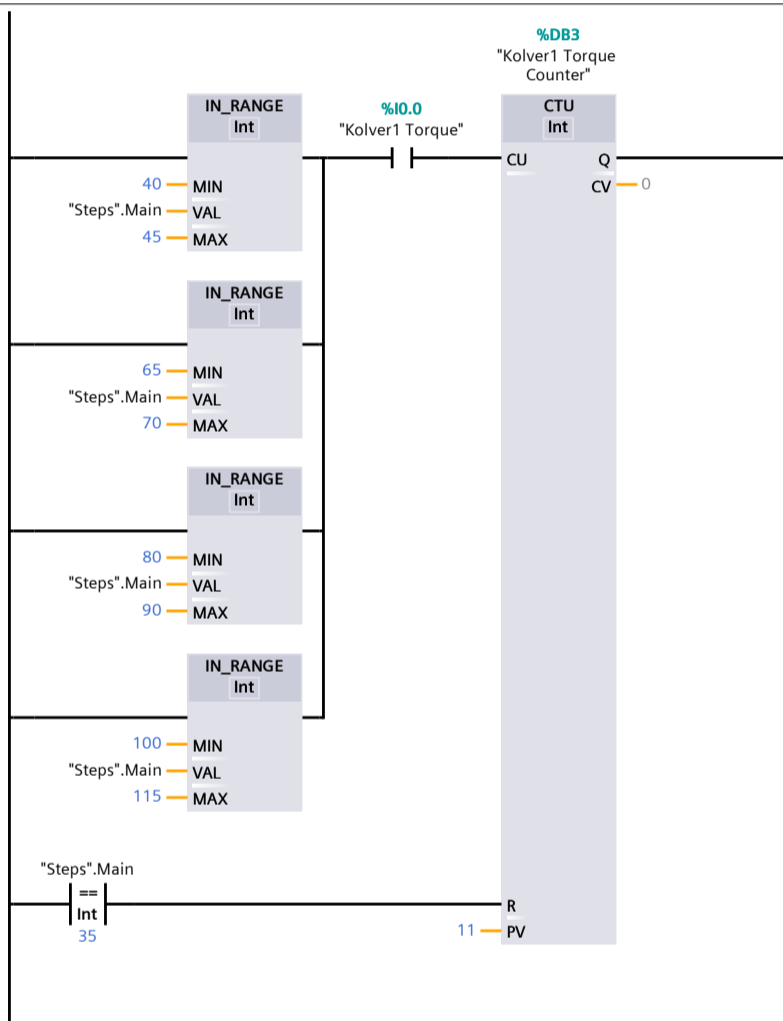
#### Network 2: start: set fanend into fixture



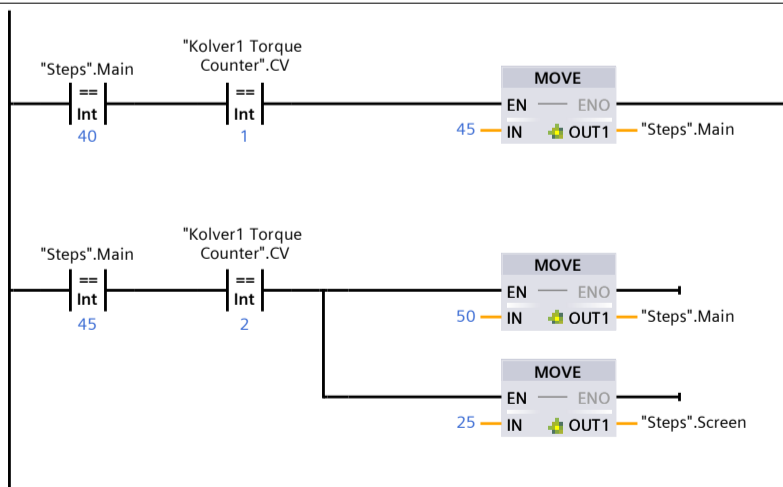
#### Network 3: activate hand switches to clamp part



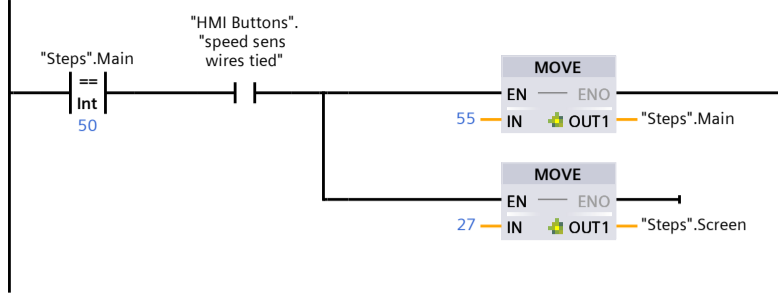
**Network 4:**



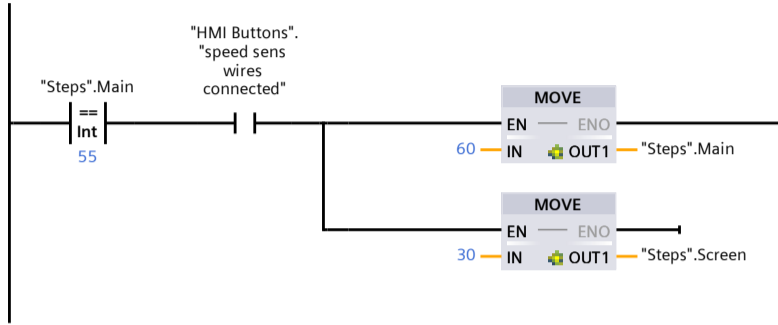
**Network 5: set blower assembly and speed sensor, tighten screws**



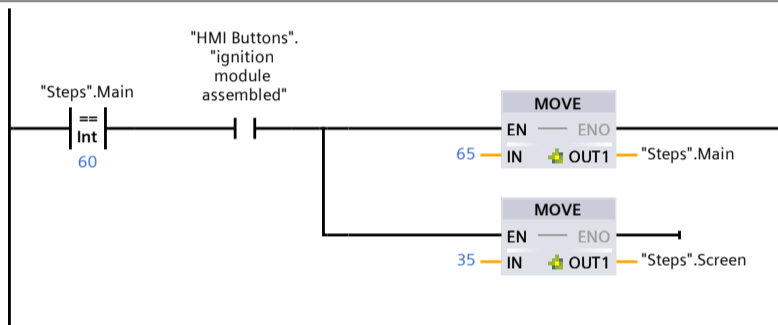
**Network 6: secure speed sensor cables with cable tie**



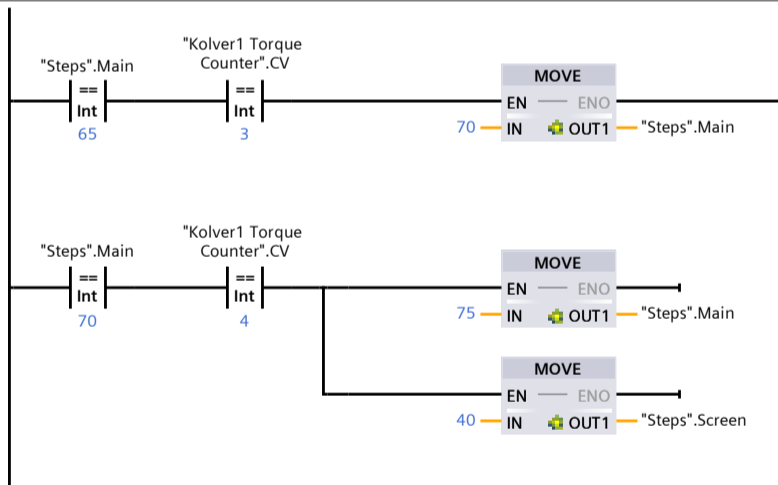
Network 7: connect speed sensor wires to connector



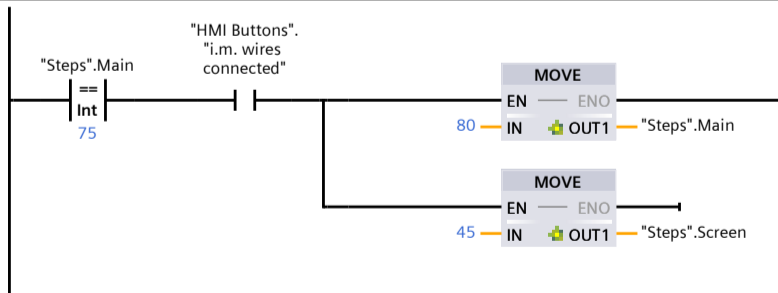
Network 8: assemble ignition module



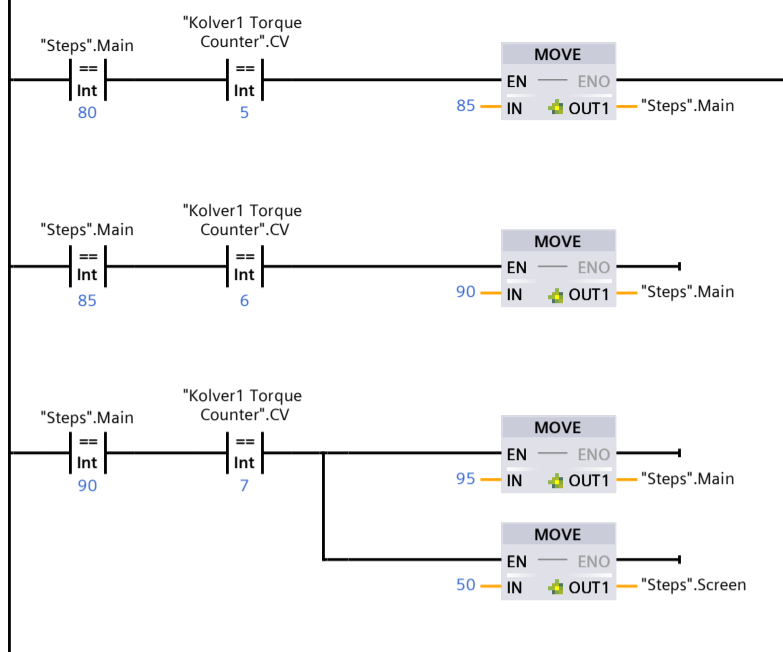
Network 9: ignition module screws



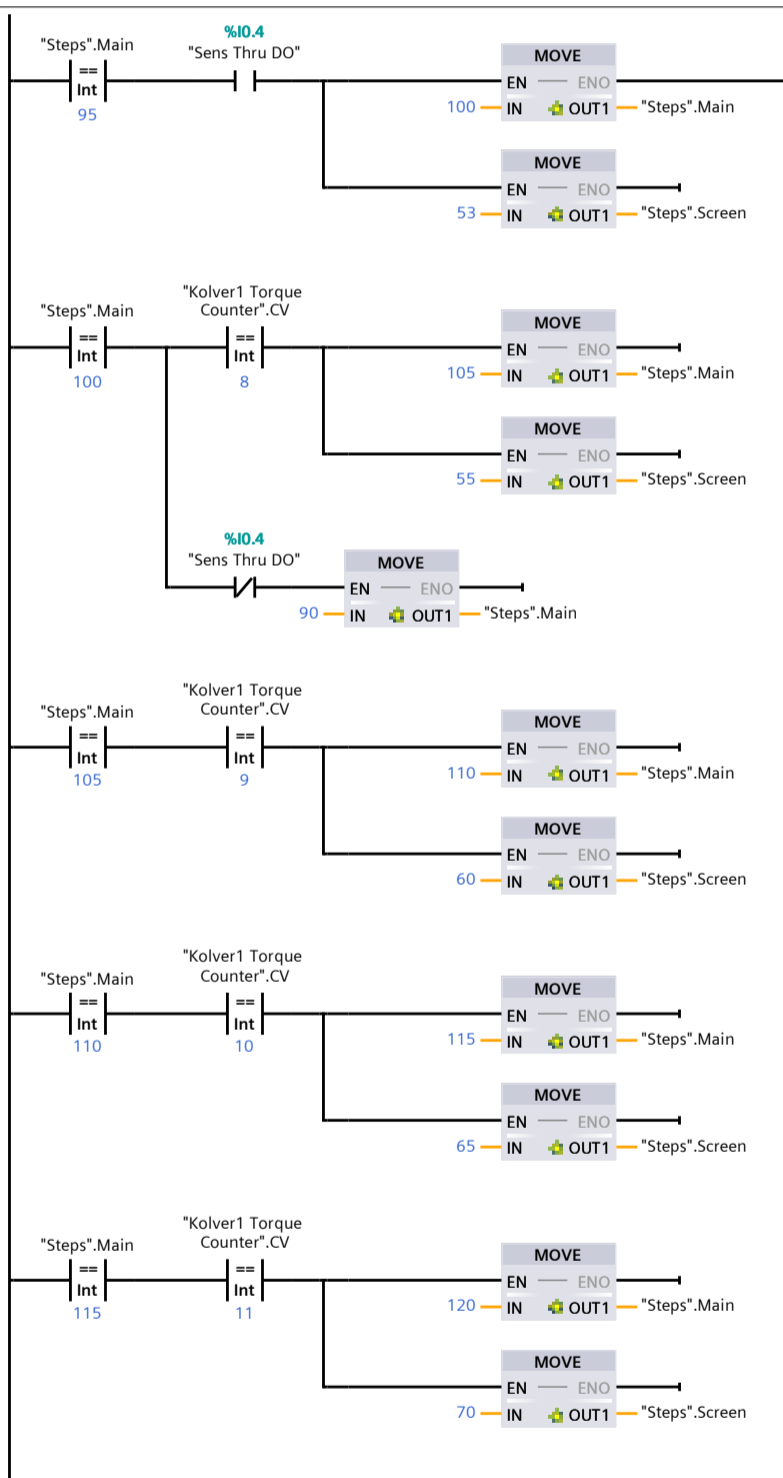
Network 10: connect diffuser to ignition module and set to assembly



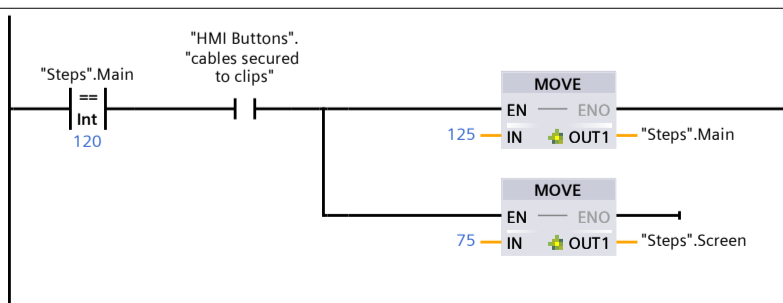
Network 11: tighten diffuser cone screws



Network 12: set thermal break spacer and tighten screws



Network 13: secure cables to clips



### Network 14: remove assembly from fixture

