

In the Present work, the application of the PLC in the production line was studied from the point of view of industrial engineering and the program was written by ladder diagram (LAD) method. This study was done in a ceramic factory of the state company of class and ceramic in Ramadi. It was exactly on the Kiln entrance of ceramic tiles, for a reused PLC system where the tiles pieces enter the Kiln in compiled arranged rows in order to guarantee the heat distribution.