SIMATIC 300\CPU 315\...\FC72 - <offline>

FC72 - <offline>

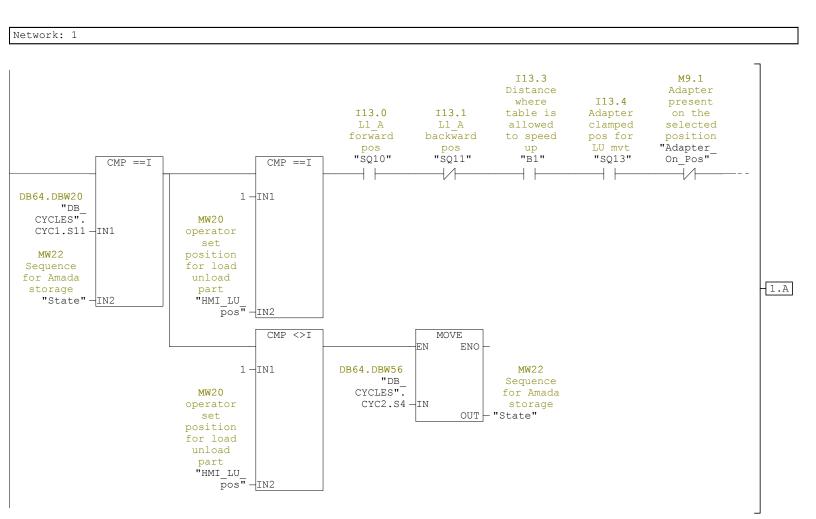
"FC_MAN_LOAD"

SIMATIC

Name: Family: Author: Version: 0.1 | Block version: 2 | Time stamp Code: | 11/21/2022 | 04:35:12 | PM | Interface: | 11/07/2022 | 08:54:22 | AM | Lengths (block/logic/data): | 00744 | 00606 | 00002

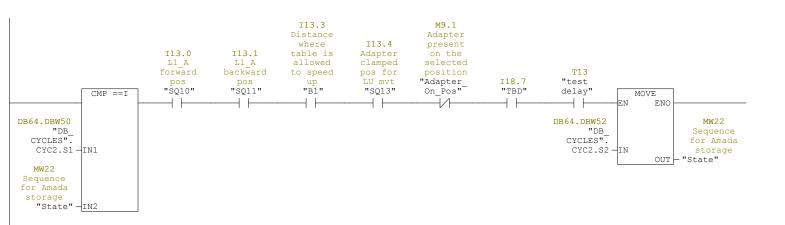
Name	Data Type	Address	Comment
IN		0.0	
OUT		0.0	
IN_OUT		0.0	
TEMP		0.0	
RETURN		0.0	
RET_VAL		0.0	

Block: FC72



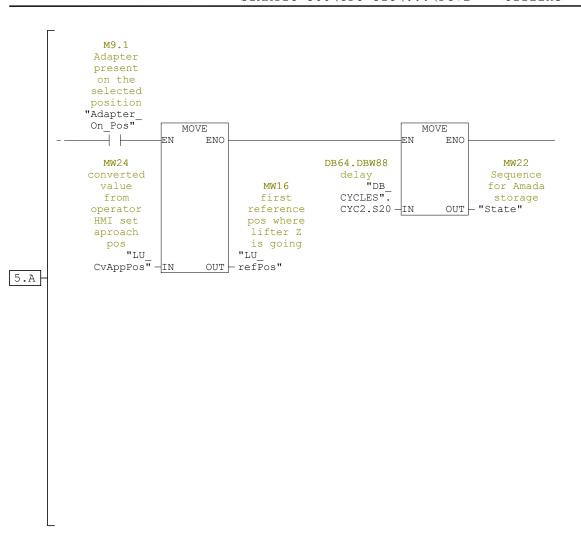
```
M105.0
                            I17.2
                                         I14.3
             adapter 1
                             L2
                                           L2
               back
                          adapter 1
                                       adapter 1
                           middle
                                                       I18.7
              sensor
                                          down
                            "SQ20"
                                                       "TBD"
            "SQ42_mem"
                                         "SQ19"
                                                                    MOVE
                                                                 EΝ
                                                                        ENO
                                                    DB64.DBW50
                                                                                 MW22
                                                       "DB_
CYCLES".
                                                                                Sequence
                                                                               for Amada
                                                        CYC2.S1 -IN
                                                                                storage
                                                                        OUT - "State"
1.A
```

Network: 2

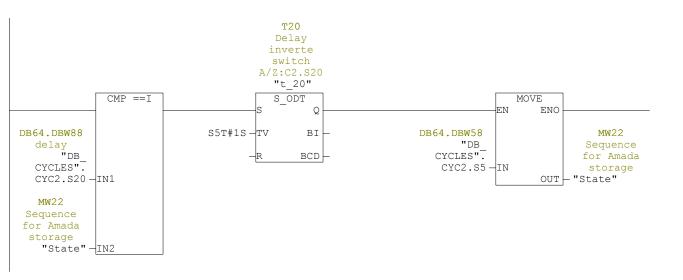


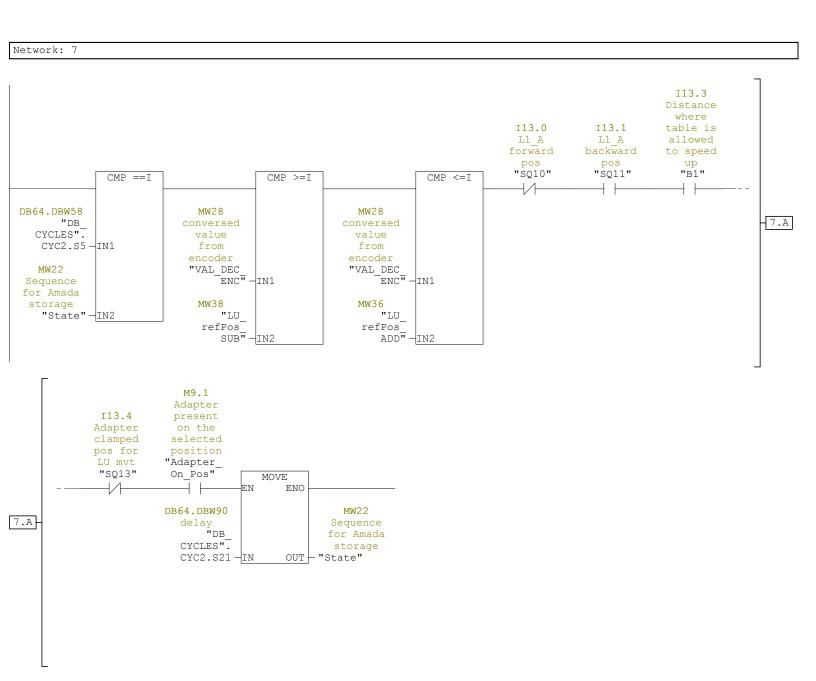
Network: 3 lift 2 down - adapter 1 allowed to mov back - for adapter 1 load I13.3 M9.1 Distance Adapter where I13.4 present on the selected position I13.0 I13.1 table is Adapter clamped 124.0 L1_A backward I24.1 L1_A forward allowed pos for LU mvt 1/1PlateDo 1/1Plate_U LKD LKD to speed "Adapter_ On_Pos" pos pos up "B1" wn LKD "SQ10" "SQ11" "SQ13" "SQ37" "SQ38" CMP ==I MOVE -1/1-+++++ \vdash $+\vdash$ ΕN ENO DB64.DBW52 "DB_ CYCLES". DB64.DBW54 "DB_ CYCLES". Sequence for Amada storage "State" CYC2.S2 -IN1 CYC2.S3 OUT MW22 Sequence for Amada storage "State" -IN2 Network: 4 I13.3 M9.1 Distance Adapter I13.4 where present I13.0 I13.1 table is Adapter on the L1 A L1 A allowed clamped selected I24.0 I24.1 1/1Plate_U pos for 1/1PlateDo forward backward position to speed "Adapter_ pos pos up LU mvt wn LKD LKD LKD "SQ10" "sQ11" "B1" "SQ13" On Pos" "SQ37" "SQ38" CMP ==I +4.A DB64.DBW54 "DB CYCLES". CYC2.S3-IN1 MW22 Sequence for Amada storage "State" -IN2 I17.2 I14.3 L2 L2 adapter 1 adapter 1 middle down "SQ20" "SQ19" MOVE ΕN ENO 4.A DB64.DBW56 MW22 "DB Sequence CYCLES". for Amada CYC2.S4 -IN storage OUT "State"

Network: 5 I13.3 Distance I13.4 where I13.0 I13.1 table is Adapter L1 A L1 A allowed clamped forward backwardto speed pos for LU mvt "SQ13" pos pos up "B1" "SQ10" "SQ11" CMP ==I CMP <>I 1-IN1 DB64.DBW56 "DB_ CYCLES". MW20 CYC2.S4 -IN1 operator set MW22 position for load Sequence for Amada unload storage part "State" -IN2 "HMI LU pos"-IN2 5.A M105.0 adapter 1 back sensor "SQ42_mem" CMP ==I 1 -IN1 MW20 operator set position for load unload part "HMI LU pos"-IN2

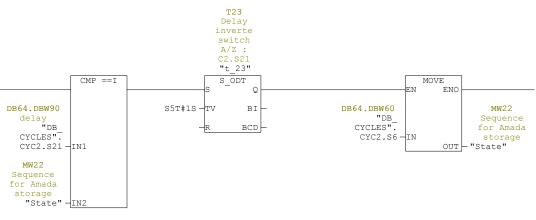


Network: 6 Delay inverte switch A/Z









MW22 Sequence for Amada storage "State"

SIMATIC 300\CPU 315\...\FC72 - <offline> Network: 9 I13.3 M9.1 Distance Adapter I13.4 where present I13.0 I13.1 table is Adapter on the DB69.DBX18 L1 A .0 "DB_HMI L1_A allowed selected clamped forward backward to speed pos for position INTERF". "Adapter_ On_Pos" pos up LU mvt "SQ10" "SQ11" "B1" "SQ13" IN_OUT[1] CMP ==I MOVE ΕN ENO 110 -IN DB64.DBW60 "DB_ CYCLES". CYC2.S6 -IN1 MW22 9.A Sequence for Amada OUT storage DB69.DBX18 "State" -IN2 .0 "DB_HMI_ INTERF". IN_OUT[1] MOVE \dashv \vdash ΕN ENO -999 IN OUT MOVE ENO DB64.DBW92 MW16 MW22 delay "DB_ Sequence first reference for Amada CYCLES". CYC2.S22-IN pos where storage OUT - "State" lifter Z is going 9.A "LU_ _ j refPos"

Network: 10 Delay inverte switch A/Z

