

A

Automation Production Station Code

Project			
Name:	Automation Production Station Code	Creation time:	6/11/2025 5:40:46 AM
Last change	7/12/2025 4:43:55 AM	Author:	DUNNA ANANDA SIDHVLAS
Last modified by:	MTC-MECH-05	Version:	
Comment:	The automation production station is the core of a mechatronic system where actual assembly or manufacturing tasks are performed automatically. It typically integrates actuators, sensors, robotic arms or pneumatic devices, and is controlled by a PLC or microcontroller. This station executes critical functions like assembling components, inserting parts, or performing pick-and-place operations. It demonstrates the seamless interaction between mechanical systems, electronics, and software, embodying the essence of industrial automation. By simulating real-world production environments, the station is essential for training students and professionals in efficient, accurate, and high-speed automated manufacturing processes.		

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Operating system			
Name		Description	
Operating system		Microsoft Windows 11 Pro	
Version of the operating system		6.3.9600.0	
Operating system service pack			
Version of the Internet Explorer		11.1.22621.0	
Computer name		MTC-NITW-MECH-0	
User name		MTC-NITW-MECH-0\MTCH-MECH-05	
Installation path of the TIA Portal		C:\Program Files\Siemens\Automation\Portal V16	

C

Components			
Name	Version	Release	
TIA Portal Project Server V16 - TIA Portal Project Server Single SetupPackage V16.0 (MUSERVERV16)	V16.0	V16.00.00.00_31.02.00.01	
TIA Administrator - AWB Licensing Module V1.0 + SP2 (TIAADMIN)	V1.0 + SP2	V01.00.02.00_01.10.00.01	
TIA Administrator - AWB Software Management V1.0 + SP2 (TIAADMIN)	V1.0 + SP2	V01.00.02.00_01.10.00.01	
TIA Administrator - TIA UMC Agent Configurator Module V1.0 + SP2 (TIAADMIN)	V1.0 + SP2	V01.00.02.00_01.10.00.01	
TIA Administrator - TIA Administrator V1.0 SP2 (TIAADMIN)	V1.0 + SP2	V01.00.02.00_01.10.00.01	
Siemens Totally Integrated Automation Portal V16 - HM All Editions Single SetupPackage V16.0 (TIAP16)	V16.0	V16.00.00.00_31.02.00.01	
Siemens Totally Integrated Automation Portal V16 - HM NoBasic Single SetupPackage V16.0 (TIAP16)	V16.0	V16.00.00.00_31.02.00.01	
Siemens Totally Integrated Automation Portal V16 - Hardware Support Base Package 0 V16.0 (TIAP16)	V16.0	V16.00.00.00_27.01.00.01	
Siemens Totally Integrated Automation Portal V16 - Multiuser Client Single SetupPackage V16.0 (TIAP16)	V16.0	V16.00.00.00_31.02.00.01	

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A	Siemens Totally Integrated Automation Portal V16 - Version Control Interface SetupPackage V16.0 (TIAP16)	V16.0	V16.00.00.00_31.02.00.01
	Siemens Totally Integrated Automation Portal V16 - STEP 7 Safety Single SetupPackage V16.0 (TIAP16)	V16.0	V16.00.00.00_31.02.00.01
	Siemens Totally Integrated Automation Portal V16 - STEP 7 Single SetupPackage V16.0 (TIAP16)	V16.0	V16.00.00.00_31.02.00.01
B	Siemens Totally Integrated Automation Portal V16 - Hardware Support Base Package 02 V16.0 (TIAP16)	V16.0	V16.00.00.00_27.01.00.01
	Siemens Totally Integrated Automation Portal V16 - Hardware Support Base Package 03 V16.0 (TIAP16)	V16.0	V16.00.00.00_27.01.00.01
	Siemens Totally Integrated Automation Portal V16 - Hardware Support Base Package 04 V16.0 (TIAP16)	V16.0	V16.00.00.00_27.01.00.01
	Siemens Totally Integrated Automation Portal V16 - Support Base Package TO-01 V16.0 (TIAP16)	V16.0	V16.00.00.00_27.01.00.01
C	Siemens Totally Integrated Automation Portal V16 - Support Base Package TO-02 V16.0 (TIAP16)	V16.0	V16.00.00.00_27.01.00.01
	Siemens Totally Integrated Automation Portal V16 - Hardware Support Base Package WCF-01 V16.0 (TIAP16)	V16.0	V16.00.00.00_27.01.00.01
	Siemens Totally Integrated Automation Portal V16 - TIACOMPCHECK Single SetupPackage V16.0 (TIAP16)	V16.0	V16.00.00.00_31.02.00.01
	Siemens Totally Integrated Automation Portal V16 - Simatic Single SetupPackage V16.0 (TIAP16)	V16.0	V16.00.00.00_31.02.00.01
D	Siemens Totally Integrated Automation Portal V16 - WinCC Single SetupPackage V16.0 (TIAP16)	V16.0	V16.00.00.00_31.02.00.01
	Siemens Totally Integrated Automation Portal V16 - Openness SetupPackage V16.0 (TIAP16)	V16.0	V16.00.00.00_31.02.00.01
	Siemens Totally Integrated Automation Portal V16 - WinCC Transfer Mandatory Single SetupPackage V16.0 (TIAP16)	V16.0	V16.00.00.00_31.02.00.01
	User Management Component - UserManagementComponentx64 V2.7 (UMC64)	V2.7	V02.07.00.00_04.06.00.07
	WinCC Runtime Advanced V16.0 - HMIRTM Tagging Package 01 Single SetupPackage V16.0 (HMIRTM_V11)	V16.0	V16.00.00.00_31.02.00.01
E	Siemens Totally Integrated Automation Portal V16 - Simatic Single SetupPackage 32 Bit V16.0 (TIAP16)	V16.0	V16.00.00.00_31.02.00.01
	Siemens Totally Integrated Automation Portal V16 - WinCC Single SetupPackage 32 Bit V16.0 (TIAP16)	V16.0	V16.00.00.00_31.02.00.01
	SIMATIC HMI License Manager Panel Plugin (x64)	16.0.0.0	V16.00.00.00_31.02.00.01

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A	SIMATIC WinCC Runtime Advanced Driver (x64)	16.0.0.0	V16.00.00.00_31.02.00.01
	ETWEventCollector	16.0.0.0	V16.00.00.00_31.02.00.01
	SIMATIC NCM FWL 64	5.6.0.3	K5.6.0.3_1.1.0.2
	NCM GPRS 64	01.02.00.00	V1.2.0.0_2.1.0.1
	SIMATIC Device Drivers	9.2	09.02.04.00_01.04.00.05
	TelemetryConnector	1.0.2.57	V01.00.02.57_01.00.00.01
	Automation Software Updater	02.05.0000	V02.05.00.00_01.03.00.02
	SIEMENS OPC	3.9	03.09.10.00_01.04.00.08
	SIMATIC HMI ProSave	16.0.0.0	V16.00.00.00_31.02.00.01
	SIMATIC HMI Symbol Library	16.0.0.0	V16.00.00.00_31.02.00.01
	SIMATIC HMI Touch Input	16.0.0.0	V16.00.00.00_31.02.00.01
	SIMATIC Device Drivers WoW	29.2	29.02.04.00_01.04.00.05
	SIMATIC Event Database	5.6	05.06.02.00_01.01.00.01
	SeCon	2.6	V02.06.01.00_01.08.00.01
	WinCC Runtime Advanced Simulator	16.0.0.0	V16.00.00.00_31.02.00.01

Products

	Name	Version	Release
C	TIA Portal Project Server	V16.0	V16.00.00.00_31.02.00.01
	TIA Administrator	V1.0	01.00.02.00_01.10.00.01
	SIMATIC STEP 7 Prof - STEP 7 Safety - WinCC Adv	V16.0	V16.00.00.00_31.02.00.01
	User Management Component	V2.7	V02.07.00.00_00.00.00.00
	SIMATIC WinCC Runtime Advanced Simulation	V16.0	V16.00.00.00_31.02.00.01
	Automation License Manager	V6.0 + SP5 + Upd1	06.00.05.01_02.01.00.05
	SIMATIC ProSave	V16.0	V16.00.00.00_31.02.00.01
	S7-PCT	V3.5 + SP1	K3.5.1.0_1.19.0.1

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Automation Production Station Code

PLC_1 [CPU 1214C DC/DC/DC]

PLC_1			
General\Project information			
Name	PLC_1	Author	MTC-MECH-05
Comment		Slot	1
Rack	0		
General\Catalog information			
Short designation	CPU 1214C DC/DC/DC	Description	Work memory 75 KB; 24VDC power supply with DI14 x 24VDC SINK/SOURCE, DQ10 x 24VDC and AI2 on board; 6 high-speed counters and 4 pulse outputs on board; signal board expands on-board I/O; up to 3 communication modules for serial communication; up to 8 signal modules for I/O expansion; PROFINET interface for programming, HMI and PLC-to-PLC communication
Article number	6ES7 214-1AG40-0XB0	Firmware version	V4.0
General\Identification & Maintenance			
Plant designation		Location identifier	
Installation date	2025-06-11 05:41:27.236	Additional information	
Connection resources			
PG communication:	1	OP communication:	1
S7 basic communication:	0	S7 communication:	0
Maximum number of S7 connection resources:	38		
PROFINET interface [X1]\General			
Name	PROFINET interface_1	Author	MTC-MECH-05
Comment			
PROFINET interface [X1]\General\Project information			
Name	DI 14/DQ 10_1	Comment	
Name	AI 2_1	Comment	
PROFINET interface [X1]\Ethernet addresses\Interface networked with			
Subnet:	PN/IE_1		
PROFINET interface [X1]\Ethernet addresses\IP protocol			
IP configuration	Set IP address in the project	IP address:	192.168.0.1
Subnet mask:	255.255.255.0	Use router	False
PROFINET interface [X1]\Ethernet addresses\PROFINET			
PROFINET device name is set directly at the device	False	Generate PROFINET device name automatically	True
PROFINET device name:	plc_1	Converted name:	plcxb1d0ed
Device number:	0		

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PROFINET interface [X1]\Time synchronization			
Enable time synchronization via NTP server	Enable time synchronization via NTP server		IP addresses
Server 1	0.0.0.0	Server 2	0.0.0.0
Server 3	0.0.0.0	Server 4	0.0.0.0
Update interval	10sec		
PROFINET interface [X1]\Digital inputs\Channel0			
Channel address	I0.0	Input filters	6.4 millisec
Enable pulse catch	0		
PROFINET interface [X1]\Digital inputs\Channel0\			
Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49152
Event name:	0	Hardware interrupt:	0
Rising edge0	Rising edge0		
PROFINET interface [X1]\Digital inputs\Channel0\			
Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49280
Event name:	0	Hardware interrupt:	0
Falling edge0	Falling edge0		
PROFINET interface [X1]\Digital inputs\Channel1			
Channel address	I0.1	Input filters	6.4 millisec
Enable pulse catch	0		
PROFINET interface [X1]\Digital inputs\Channel1\			
Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49153
Event name:	0	Hardware interrupt:	0
Rising edge1	Rising edge1		
PROFINET interface [X1]\Digital inputs\Channel1\			
Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49281
Event name:	0	Hardware interrupt:	0
Falling edge1	Falling edge1		
PROFINET interface [X1]\Digital inputs\Channel2			
Channel address	I0.2	Input filters	6.4 millisec
Enable pulse catch	0		
PROFINET interface [X1]\Digital inputs\Channel2\			
Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49154
Event name:	0	Hardware interrupt:	0
Rising edge2	Rising edge2		
PROFINET interface [X1]\Digital inputs\Channel2\			
Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49282
Event name:	0	Hardware interrupt:	0
Falling edge2	Falling edge2		
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A	PROFINET interface [X1]\Digital inputs\Channel3			
	Channel address	I0.3	Input filters	6.4 millisec
B	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49155
	Event name:	0	Hardware interrupt:	0
C	Rising edge3	Rising edge3		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49283
	Event name:	0	Hardware interrupt:	0
D	Falling edge3	Falling edge3		
	PROFINET interface [X1]\Digital inputs\Channel4			
	Channel address	I0.4	Input filters	6.4 millisec
	Enable pulse catch	0		
E	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49156
	Event name:	0	Hardware interrupt:	0
	Rising edge4	Rising edge4		
F	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49284
	Event name:	0	Hardware interrupt:	0
	Falling edge4	Falling edge4		
D	PROFINET interface [X1]\Digital inputs\Channel5			
	Channel address	I0.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel5\			
E	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49157
	Event name:	0	Hardware interrupt:	0
	Rising edge5	Rising edge5		
	PROFINET interface [X1]\Digital inputs\Channel5\			
F	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49285
	Event name:	0	Hardware interrupt:	0
	Falling edge5	Falling edge5		
	PROFINET interface [X1]\Digital inputs\Channel6			
G	Channel address	I0.6	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel6\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49158
H	Event name:	0	Hardware interrupt:	0
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A	Rising edge6	Rising edge6		
	PROFINET interface [X1]\Digital inputs\Channel6\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49286
	Event name:	0	Hardware inter-rupt:	0
	Falling edge6	Falling edge6		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Channel address	I0.7	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel7\			
B	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49159
	Event name:	0	Hardware inter-rupt:	0
	Rising edge7	Rising edge7		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49287
	Event name:	0	Hardware inter-rupt:	0
	Falling edge7	Falling edge7		
	PROFINET interface [X1]\Digital inputs\Channel8\			
C	Channel address	I1.0	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel8\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49160
	Event name:	0	Hardware inter-rupt:	0
	Rising edge8	Rising edge8		
	PROFINET interface [X1]\Digital inputs\Channel8\			
D	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49288
	Event name:	0	Hardware inter-rupt:	0
	Falling edge8	Falling edge8		
	PROFINET interface [X1]\Digital inputs\Channel9\			
	Channel address	I1.1	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel9\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49161
	Event name:	0	Hardware inter-rupt:	0
	Rising edge9	Rising edge9		
	PROFINET interface [X1]\Digital inputs\Channel9\			
E	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49289
	Event name:	0	Hardware inter-rupt:	0
	Falling edge9	Falling edge9		
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A	PROFINET interface [X1]\Digital inputs\Channel10			
	Channel address	I1.2	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49162
	Event name:	0	Hardware interrupt:	0
	Rising edge10	Rising edge10		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49290
	Event name:	0	Hardware interrupt:	0
B	Falling edge10	Falling edge10		
	PROFINET interface [X1]\Digital inputs\Channel11			
	Channel address	I1.3	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49163
	Event name:	0	Hardware interrupt:	0
	Rising edge11	Rising edge11		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49291
C	Event name:	0	Hardware interrupt:	0
	Falling edge11	Falling edge11		
	PROFINET interface [X1]\Digital inputs\Channel12			
	Channel address	I1.4	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel13			
	Channel address	I1.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Analog inputs\Noise reduction			
	Integration time	50 Hz (20 ms)		
D	PROFINET interface [X1]\Analog inputs\Channel0			
	Channel address	IW64	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Analog inputs\Channel1			
	Channel address	IW66	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Digital outputs			
	Reaction to CPU STOP	Use substitute value		
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A	PROFINET interface [X1]\Digital outputs\Channel0					
	Channel address	Q0.0	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel1					
	Channel address	Q0.1	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel2					
	Channel address	Q0.2	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel3					
	Channel address	Q0.3	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel4					
	Channel address	Q0.4	Substitute a value of 1 on a change from RUN to STOP.	0		
B	PROFINET interface [X1]\Digital outputs\Channel5					
	Channel address	Q0.5	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel6					
	Channel address	Q0.6	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel7					
	Channel address	Q0.7	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel8					
	Channel address	Q1.0	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel9					
	Channel address	Q1.1	Substitute a value of 1 on a change from RUN to STOP.	0		
C	PROFINET interface [X1]\Operating mode					
	IO controller	True	IO system			
	Device number	0	IO device	False		
	PROFINET interface [X1]\I/O addresses\Input addresses					
	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Input addresses					
	Start address	64	End address	67		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Output addresses					
D	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Output addresses					
	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
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A	PROFINET interface [X1]\Advanced options\Interface options				
	Support device replacement without exchangeable medium	True	Use IEC V2.2 LLDP mode	True	
B	Keep-Alive connection monitoring:	30s			
	PROFINET interface [X1]\Advanced options\Real time settings\IO communication				
C	Send clock:	1.000ms			
	PROFINET interface [X1]\Advanced options\Real time settings\Real time options				
D	Calculated bandwidth for cyclic IO data:	0.000ms	Calculated bandwidth for cyclic IO data:	0.000%	
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\General				
E	Name	Port_1	Author	MTC-MECH-05	
	Comment				
F	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Local port:				
	Local port:	PLC_1\PROFINET interface_1 [X1]\Port_1 [X1 P1]	Medium:	Copper	
G	Cable name:	---			
					
H	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Partner port:				
	Monitoring of partner port is not possible	Partner port:	Any partner		
I	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Activate				
	Activate this port for use	True			
J	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Connection				
	Transmission rate / duplex:	Automatic	Monitor	False	
K	Enable autonegotiation	True			
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Boundaries				
L	End of detection of accessible devices	False	End of topology discovery	False	
	End of the sync domain	False			
M	High speed counters (HSC)\HSC1\General\Enable				
	Enable this high speed counter	0	Enable this high speed counter	0	
N	Enable this high speed counter	0	Enable this high speed counter	0	
	Enable this high speed counter	0	Enable this high speed counter	0	
O	High speed counters (HSC)\HSC1\General\Project information				
	Name	HSC_1	Comment		
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	Name	HSC_3	Comment	
	Name	HSC_4	Comment	
	Name	HSC_5	Comment	
	Name	HSC_6	Comment	
	High speed counters (HSC)\HSC1\I/O addresses\Input addresses			
B	Start address	1000.0	End address	1003.7
	Start address	1004.0	End address	1007.7
	Organization block	0	Start address	1008.0
	End address	1011.7	Organization block	0
	Process image	0	Start address	1012.0
	End address	1015.7	Organization block	0
	Process image	0	Start address	1016.0
	End address	1019.7	Organization block	0
	Process image	0	Start address	1020.0
	End address	1023.7	Organization block	0
C	Process image	0	Organization block	0
	Process image	0	Process image	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Enable			
	Enable this pulse generator	0	Enable this pulse generator	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Project information			
	Name	Pulse_1	Comment	
	Name	Pulse_2	Comment	
	Pulse generators (PTO/PWM)\PTO1/PWM1\I/O addresses\Output addresses			
	Start address	1000.0	End address	1001.7
	Start address	1002.0	End address	1003.7
D	Organization block	0	Organization block	0
	Process image	0	Process image	0
	Startup			
	Startup after POWER ON	Warm restart - mode before POWER OFF	Comparison preset to actual configuration	Startup CPU even if mismatch
	Configuration time	60000ms	OBs should be interruptible	1
	Cycle			
	Cycle monitoring time	150ms		
	Enable minimum cycle time for cyclic OBs	0	Minimum cycle time	1ms
	Communication load			
	Cycle load due to communication	20%		
E	System and clock memory\System memory bits			
	Enable the use of system memory byte	1	Address of system memory byte (MBx)	1
	First cycle	%M1.0 (FirstScan)	Diagnostic status changed	%M1.1 (DiagStatusUpdate)
	Always 1 (high)	%M1.2 (AlwaysTRUE)	Always 0 (low)	%M1.3 (AlwaysFALSE)
F	Owner	Project name Automation Production Station Code		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
	Designed By	Location		
	Checked By	Description 1st	Description 2nd	Language en-US
	Approved By	1st View	Version	Sheet 2 - 8

A	System and clock memory\Clock memory bits					
	Enable the use of clock memory byte	1	Address of clock memory byte (MBx)			
	10 Hz clock	%M0.0 (Clock_10Hz)	5 Hz clock			
	2.5 Hz clock	%M0.2 (Clock_2.5Hz)	2 Hz clock			
	1.25 Hz clock	%M0.4 (Clock_1.25Hz)	1 Hz clock			
	0.625 Hz clock	%M0.6 (Clock_0.625Hz)	0.5 Hz clock			
B	Web server\General					
	Activate web server on this module	False	Permit access only with HTTPS			
	Web server\Automatic update					
	Enable automatic update	True	Update interval			
C	Web server\User interface languages					
	Assign project language		User interface languages			
	English (United States)		German			
	English (United States)		English			
	English (United States)		French			
	English (United States)		Spanish			
	English (United States)		Italian			
	English (United States)		Chinese (simplified)			
D	Web server\User management					
	User name		User rights			
	Everybody					
E	Web server\User-defined web pages					
	Application name	HTML source path	Default HTML page	Files with dynamic content	Web DB number	Fragment DB number
			index.htm	.htm;.html	333	334
F	User interface languages					
	Assign project language		User interface languages			
	English (United States)		German			
	English (United States)		English			
	English (United States)		French			
	English (United States)		Spanish			
	English (United States)		Italian			
	English (United States)		Chinese (simplified)			
	Time of day\Local time					
	Time zone	(UTC +01:00) Berlin, Bern, Brussels, Rome, Stockholm, Vienna				
	Time of day\Daylight saving time					
	Activate daylight saving time	1	Difference between standard and daylight saving time			
			60mins			
	Time of day\Daylight saving time\Start of daylight saving time					
	Starting week of the month:	Last	Sunday			
	of	March	at 01:00 a.m.			
	Time of day\Daylight saving time\Start of standard time					
	Last		Sunday			
	of	October	at 02:00 a.m.			
	Protection & Security					
	Level of protection	No protection				
	Owner	Project name	Automation Production Station Code	Date	7/12/2025	
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
	Designed By	Location				
	Checked By	Description 1st	Description 2nd	Language	en-US	
	Approved By	1st View		Version	Sheet 2 - 9	

A

Protection & Security\Connection mechanisms

Permit access with True
 PUT/GET communication from remote partner

Overview of addresses\Overview of addresses\Overview of addresses

Inputs	True	Outputs	True
Address gaps	False	Slot	True

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 2 - 10

A	Type	I	Addr. from	0	Addr. to	1
	Module	DI 14/DQ 10_1	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 1		
	Type	O	Addr. from	0	Addr. to	1
	Module	DI 14/DQ 10_1	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
B	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 1		
	Type	I	Addr. from	64	Addr. to	67
	Module	AI 2_1	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 2		
C	Type	I	Addr. from	1000	Addr. to	1003
	Module	HSC_1	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 16		
	Type	I	Addr. from	1004	Addr. to	1007
	Module	HSC_2	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
D	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 17		
	Type	I	Addr. from	1008	Addr. to	1011
	Module	HSC_3	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 18		
E	Type	I	Addr. from	1012	Addr. to	1015
	Module	HSC_4	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 19		
	Type	I	Addr. from	1016	Addr. to	1019
	Module	HSC_5	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
F	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 20		
	Type	I	Addr. from	1020	Addr. to	1023
	Module	HSC_6	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location		
Checked By	Description 1st		
Approved By	Description 2nd	Language en-US	Version Sheet 2 - 11
	1st View		

A	Rack	0	Slot	1 21	Addr. to	1001
	Type	O	Addr. from	1000	Device name	PLC_1 [CPU 1214C DC/DC/DC]
B	Module	Pulse_1	PIP	Automatic update	Master / IO system	-
	Device num- ber	-	Size	2 Bytes	Addr. to	1003
C	Rack	0	Slot	1 32	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Type	O	Addr. from	1002	Master / IO system	-
D	Module	Pulse_2	PIP	Automatic update	Addr. to	1005
	Device num- ber	-	Size	2 Bytes	Device name	PLC_1 [CPU 1214C DC/DC/DC]
E	Rack	0	Slot	1 33	Master / IO system	-
	Type	O	Addr. from	1004	Addr. to	1007
F	Module	Pulse_3	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Device num- ber	-	Size	2 Bytes	Master / IO system	-
G	Rack	0	Slot	1 34	Addr. to	1006
	Type	O	Addr. from	1006	Device name	PLC_1 [CPU 1214C DC/DC/DC]
H	Module	Pulse_4	PIP	Automatic update	Master / IO system	-
	Device num- ber	-	Size	2 Bytes	Rack	0
I	Rack	0	Slot	1 35	Master / IO system	-
	Type	O	Addr. from	1007	Device name	PLC_1 [CPU 1214C DC/DC/DC]

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location		
Checked By	Description 1st		
Approved By	Description 2nd	Language en-US	Version Sheet 2 - 12

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks

AUTO 1 [FC1]

AUTO 1 Properties

General

Name	AUTO 1	Number	1
Type	FC	Language	LAD

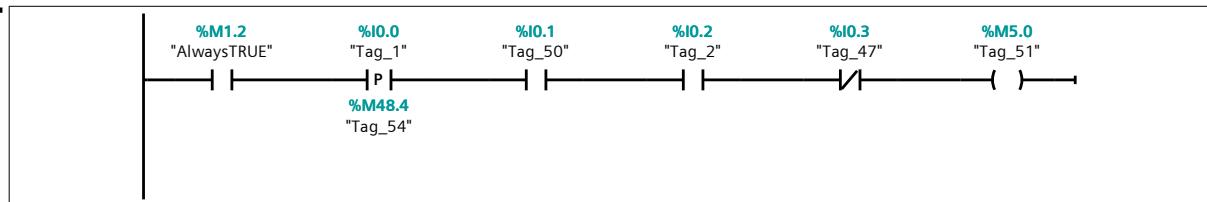
Numbering Automatic

Information

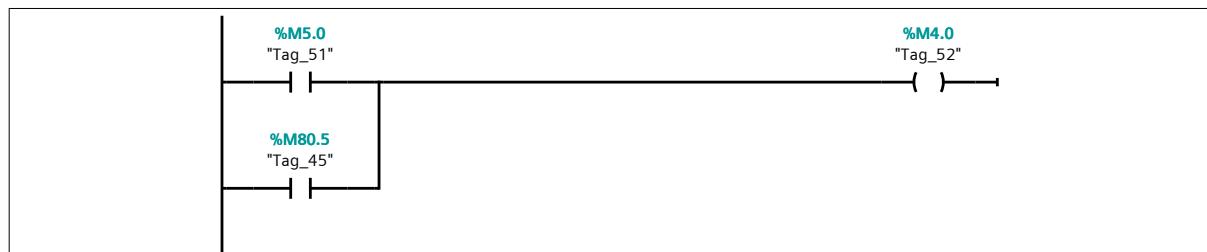
Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
AUTO 1	Void		

Network 1: START STOP LOGIC FOR MANUAL

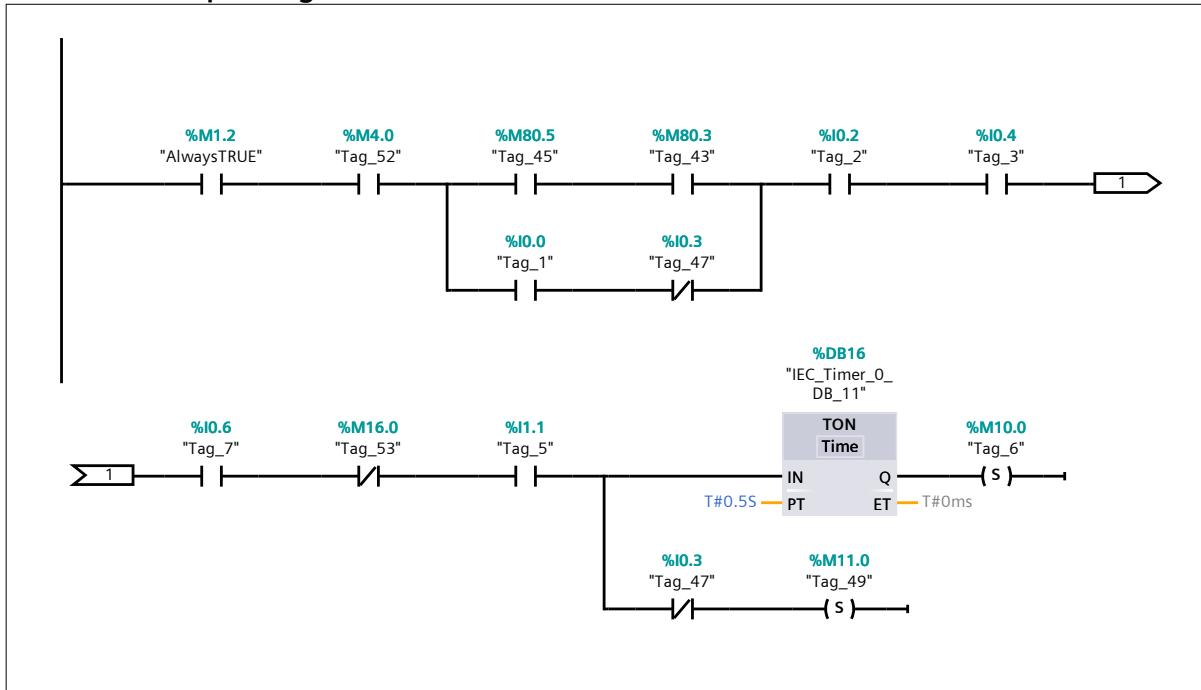


Network 2: START STOP CONTROL FOR BOTH AUTO & MANUAL



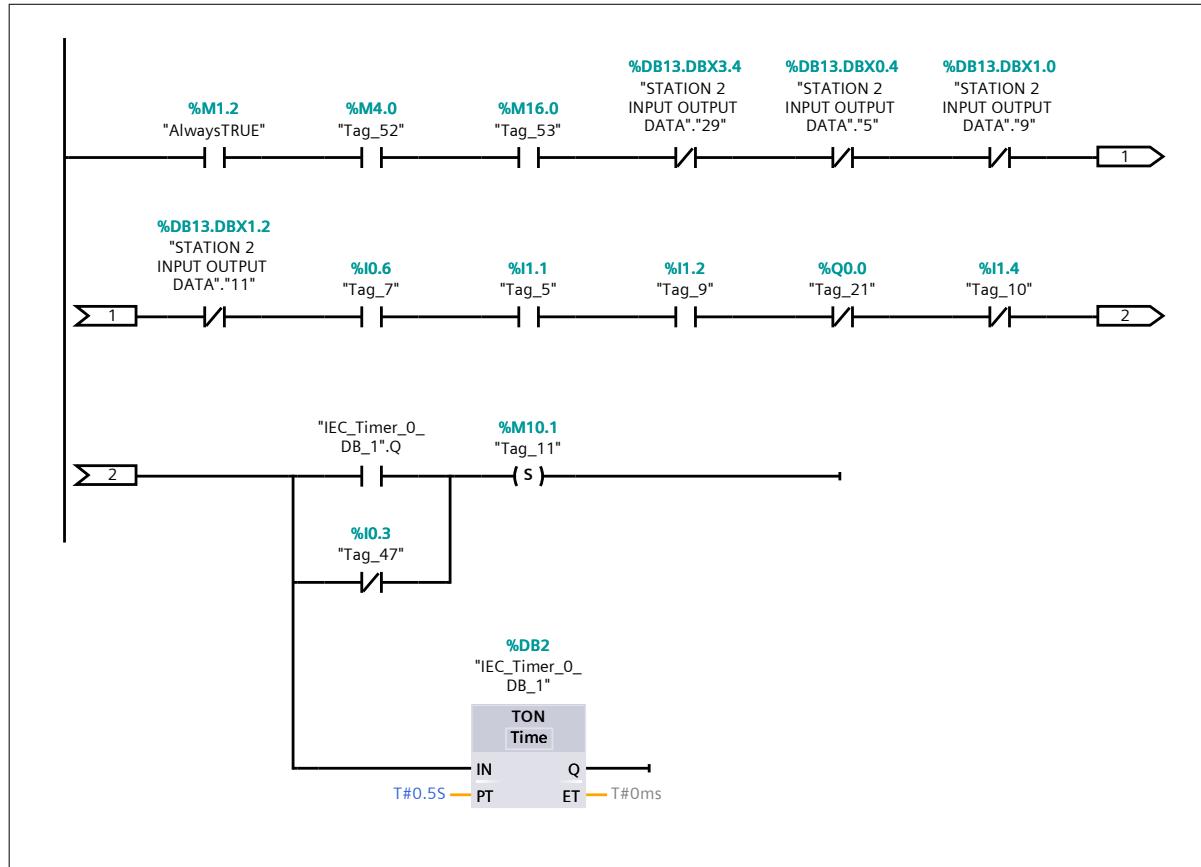
Network 3: dispensing extend

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
Designed By	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Checked By	Location			
Approved By	Description 1st	Description 2nd	Language	en-US
			Version	Sheet 3 - 1

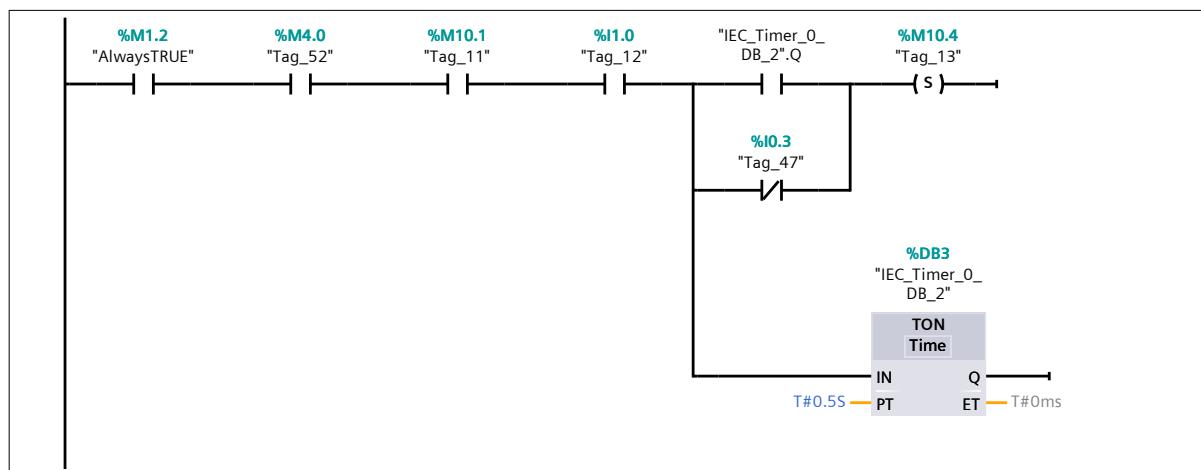
Network 3: dispensing extend**Network 5: RPP FOR PICKING BOTTLE (RPP DOWN)**

Owner	Project name	Automation Production Station Code	Date	7/12/2025			
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code					
Location							
Designed By	Description 1st						
Checked By	Description 2nd	Language	en-US				
Approved By	1st View	Version		Sheet 3 - 2			

Network 5: RPP FOR PICKING BOTTLE (RPP DOWN)

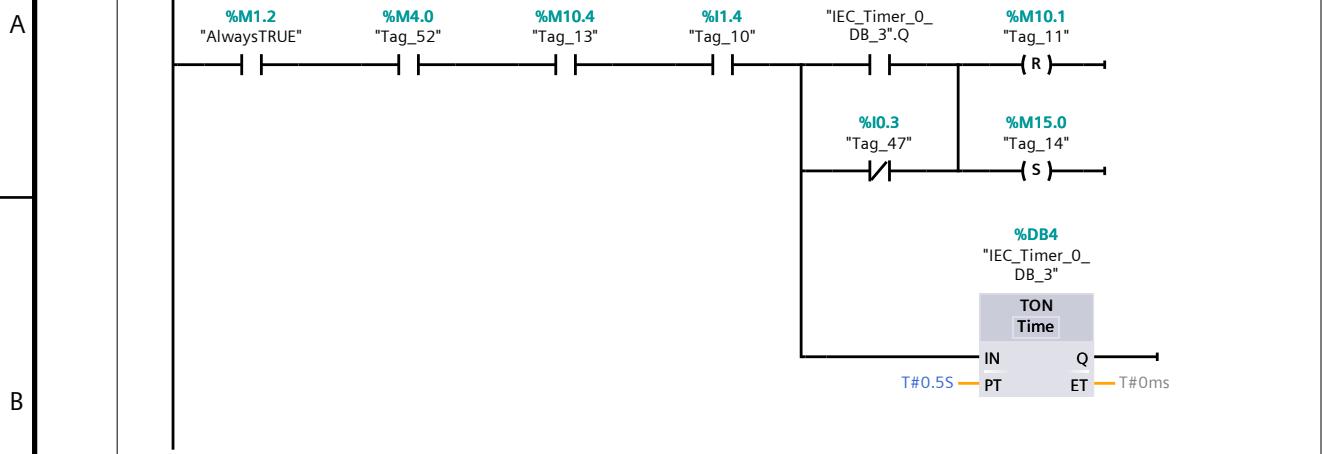
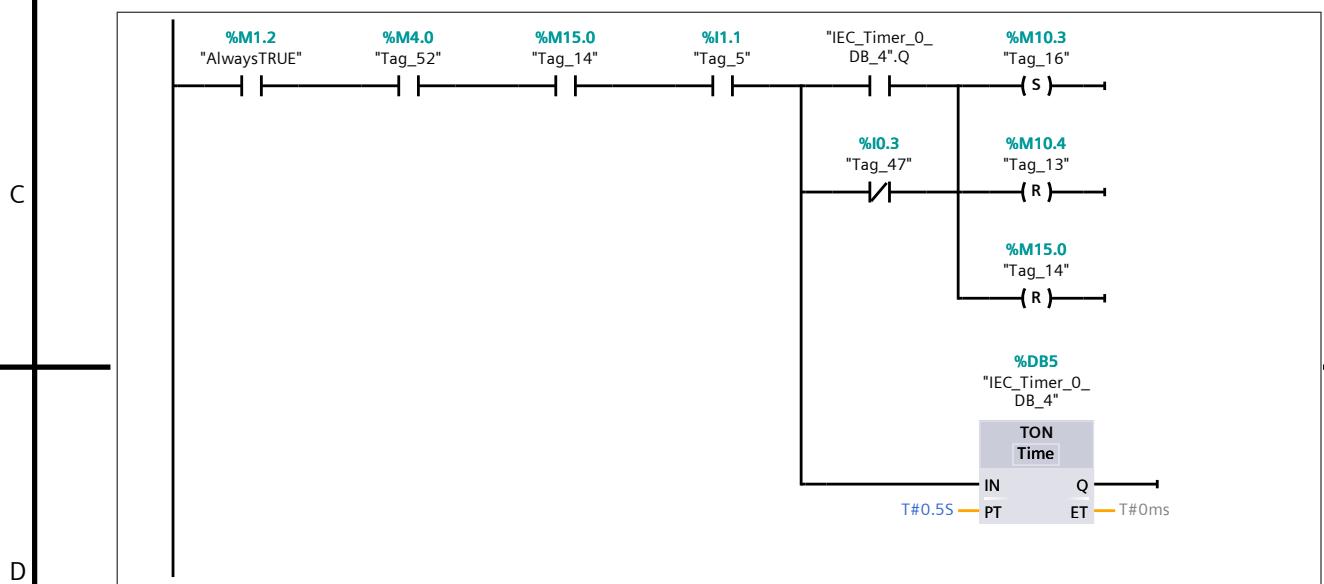


Network 6: GRIPPER CLOSE

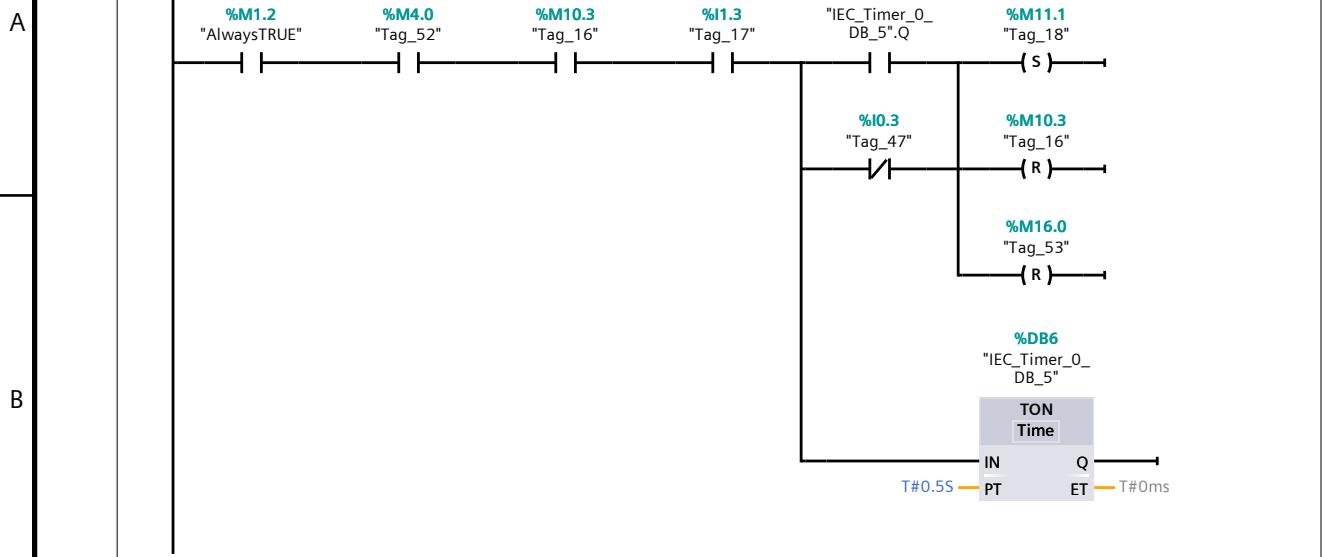
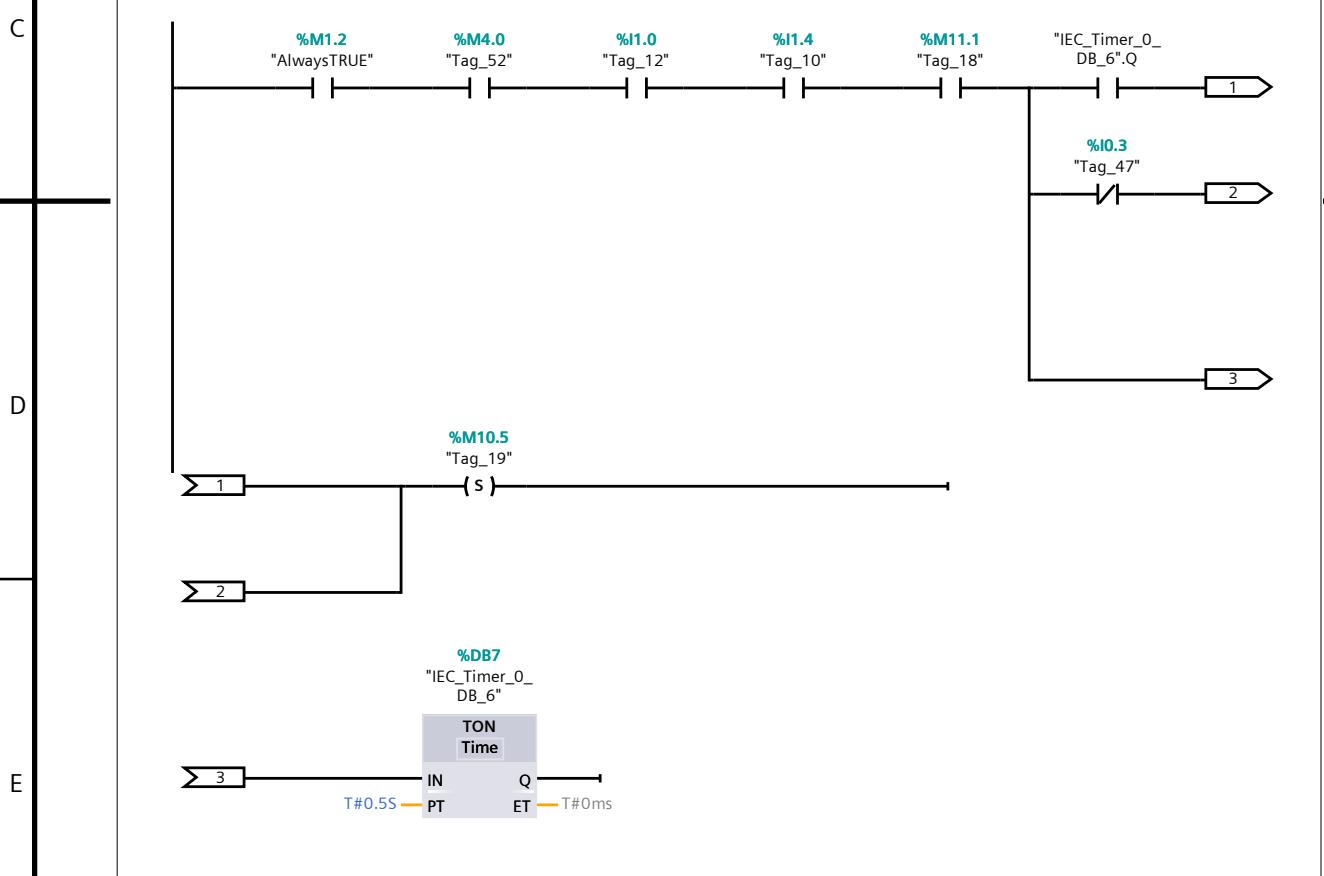


Network 7: RPP UP

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 3 - 3

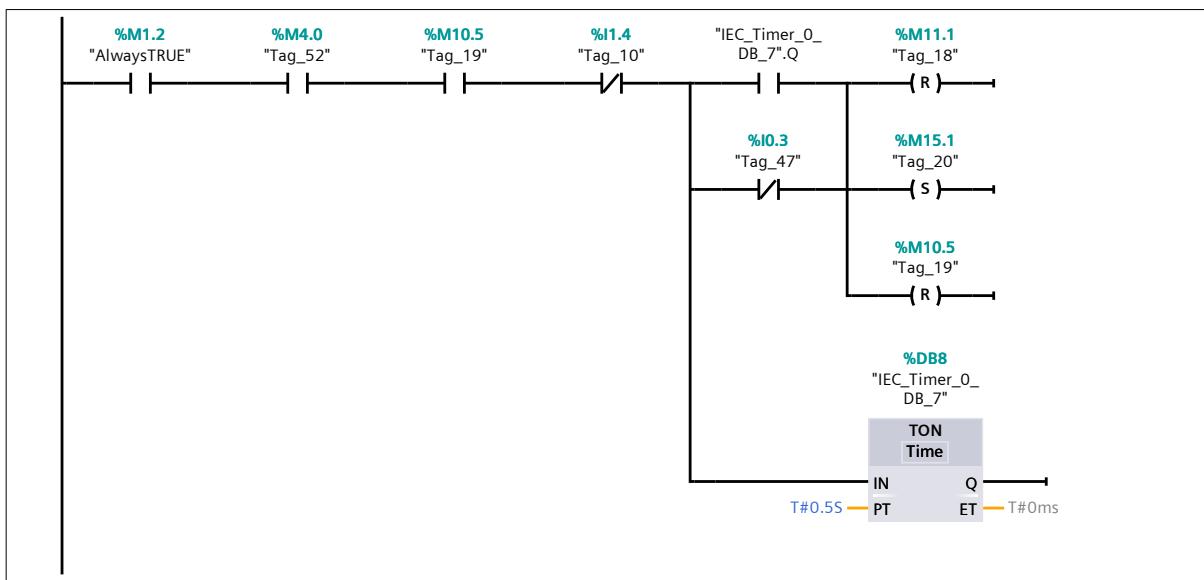
**Network 8: RPP ROTATE CCW****Network 9: RPP DOWN**

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 3 - 4

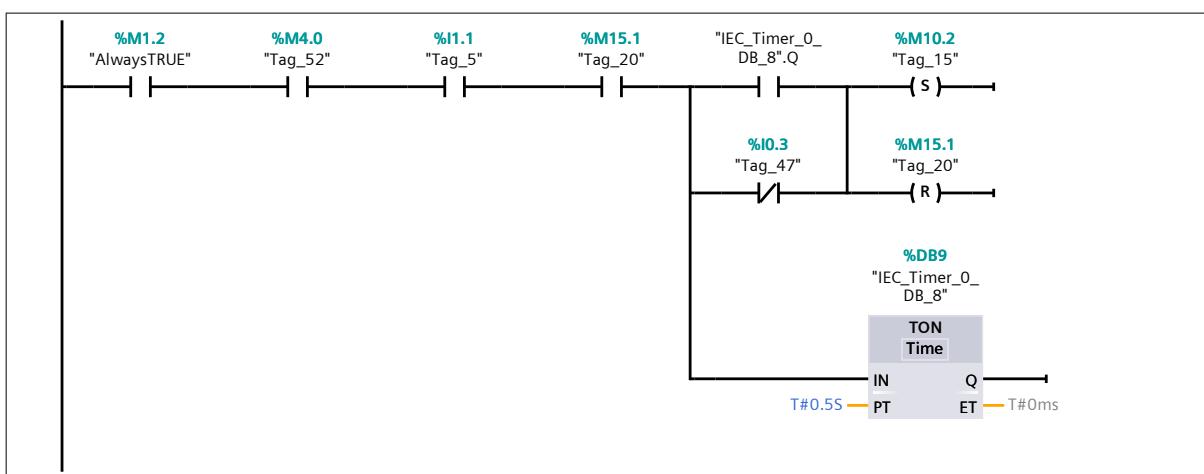
**Network 10: GRIPPER OPEN****Network 10: GRIPPER OPEN**

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Location			
Designed By	Description 1st		
Checked By	Description 2nd	Language en-US	
Approved By	1st View	Version	Sheet 3 - 5

A Network 11: RPP UP

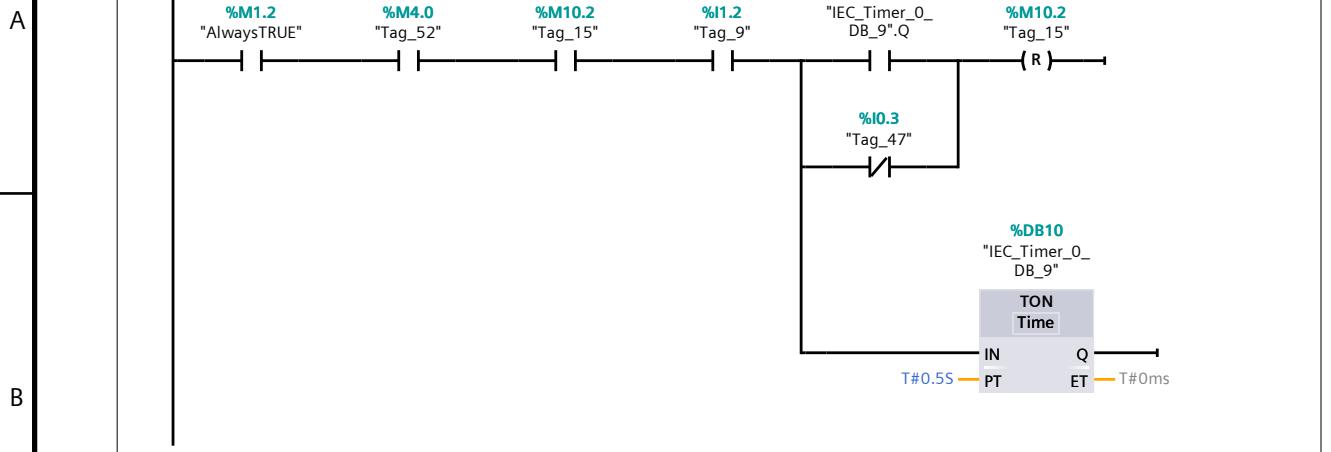


B Network 12: RPP ROTATE CW



C Network 13: RPP HOME

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language		
Approved By	1st View	Version	Sheet 3 - 6	



Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	
	1st View	Version		Sheet 3 - 7

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks

OUTPUT CALL 1 [FC2]

OUTPUT CALL 1 Properties

General

Name	OUTPUT CALL 1	Number	2
Type	FC	Language	LAD

Numbering

Information

Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
OUTPUT CALL 1	Void		

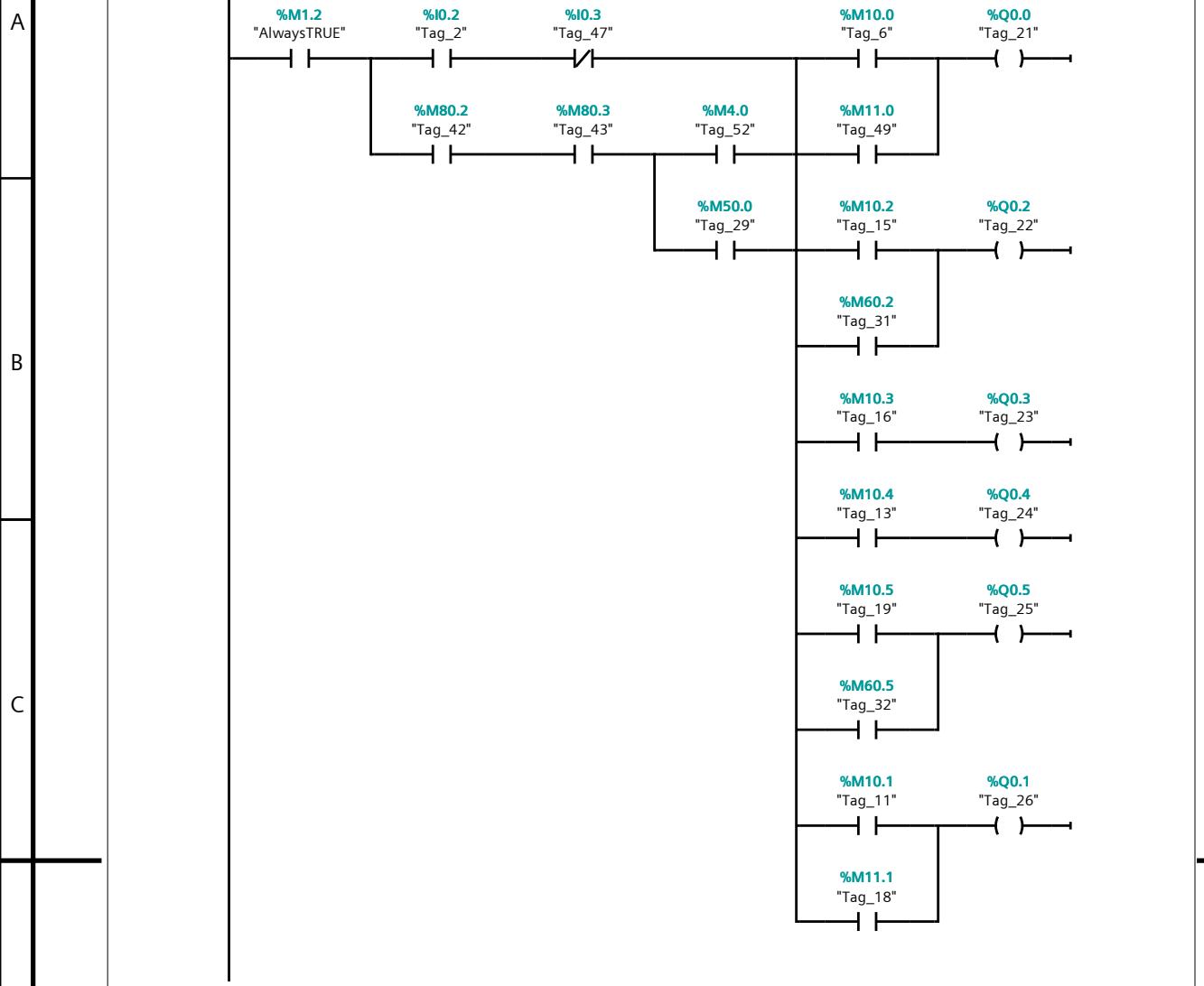
Network 1: OUTPUT CALL

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 4 - 1



A			
B			
C			
D			
E			
F	<p>Owner</p> <p>Operator</p> <p>Designed By</p> <p>Checked By</p> <p>Approved By</p>	<p>Project name Automation Production Station Code</p> <p>Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</p> <p>Location</p> <p>Description 1st</p> <p>Description 2nd</p> <p>1st View</p>	<p>Date 7/12/2025</p> <p>Language en-US</p> <p>Version</p> <p>Sheet 4 - 2</p>

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks

ESTOP LOGIC 1 [FC3]

ESTOP LOGIC 1 Properties

General

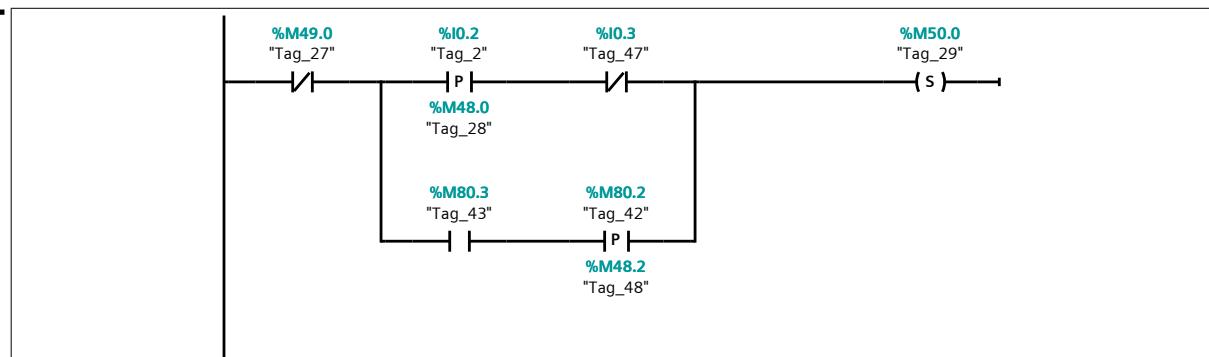
Name	ESTOP LOGIC 1	Number	3
Type	FC	Language	LAD
Numbering			Automatic

Information

Title	Author
Comment	Family
Version	User-defined ID

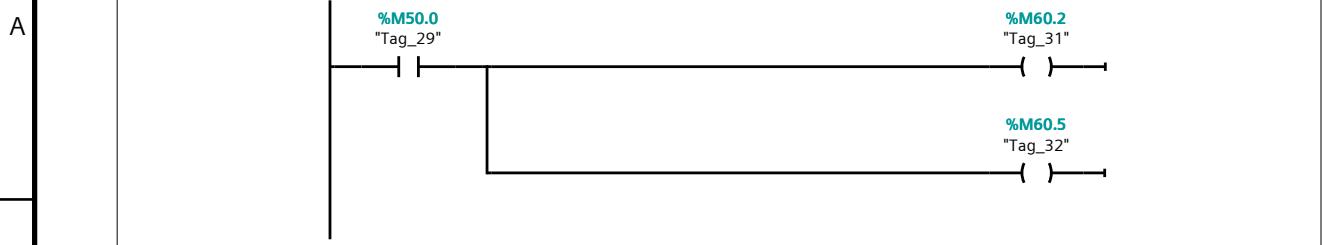
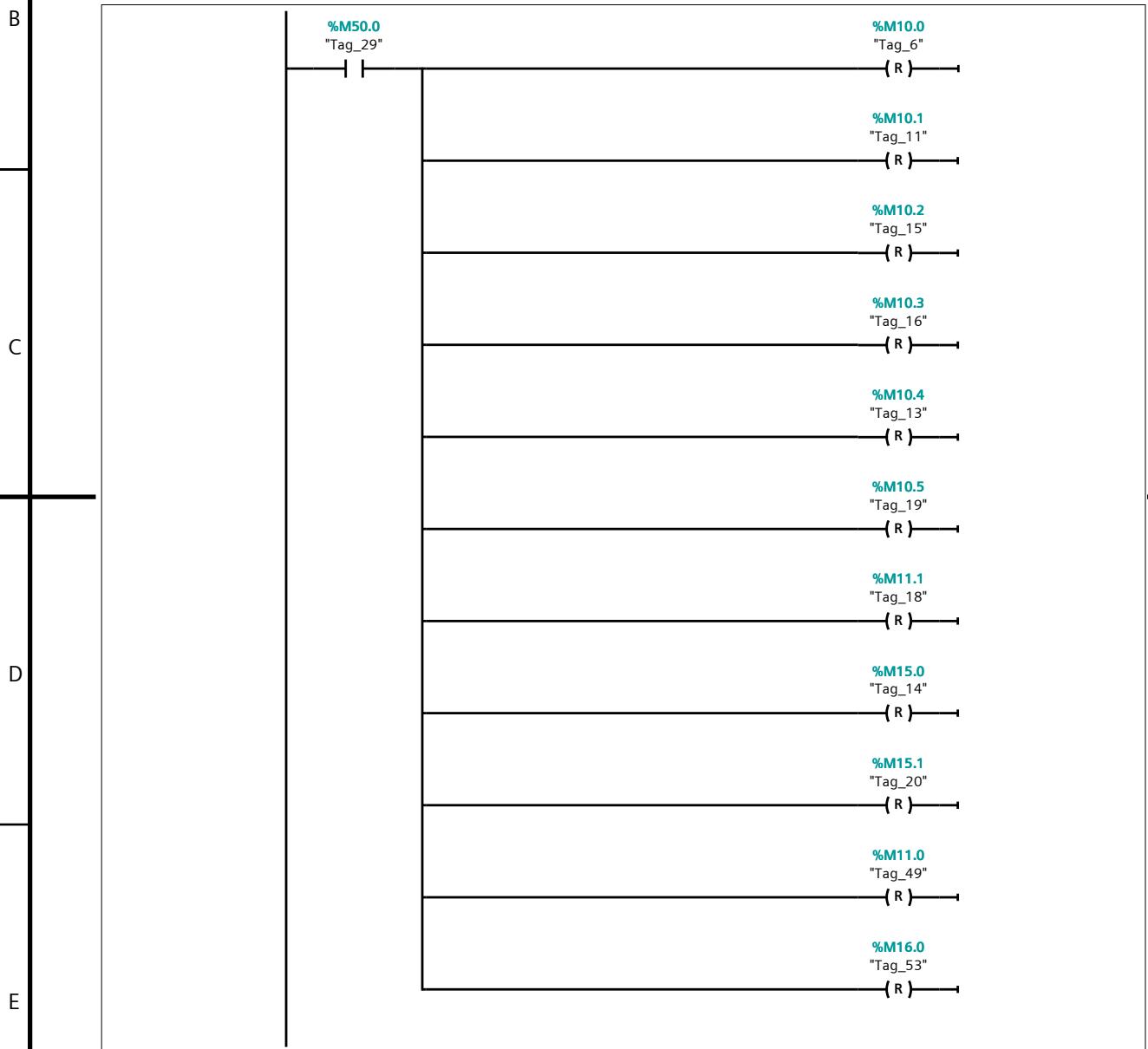
Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
ESTOP LOGIC 1	Void		

Network 1: ESTOP HOMING POSITION LOGIC



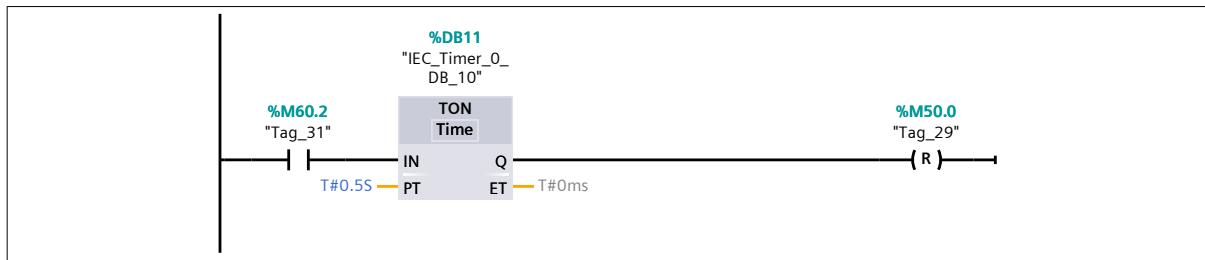
Network 2: OUTPUT CALL FOR HOMING

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 5 - 1

**Network 3: MEMORY RESET**

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	
	1st View	Version		Sheet 5 - 2

Network 4: ESTOP LOGIC RESET



B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 5 - 3

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks

DATA BLOCK MOVE [FC4]

DATA BLOCK MOVE Properties

General

Name	DATA BLOCK MOVE	Number	4
Type	FC	Language	LAD

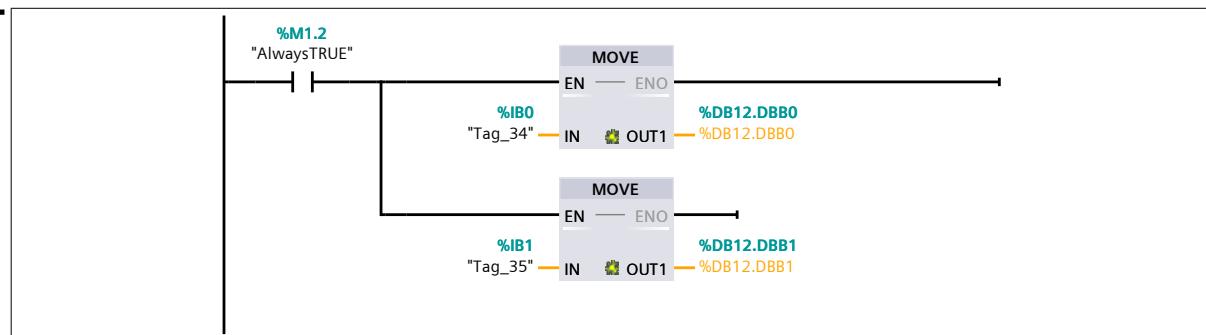
Numbering

Information

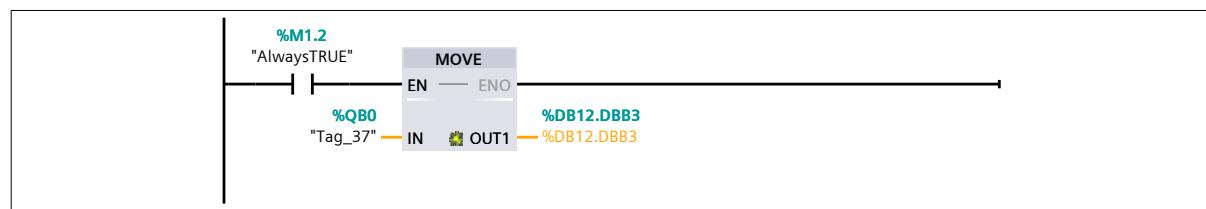
Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
DATA BLOCK MOVE	Void		

Network 1:

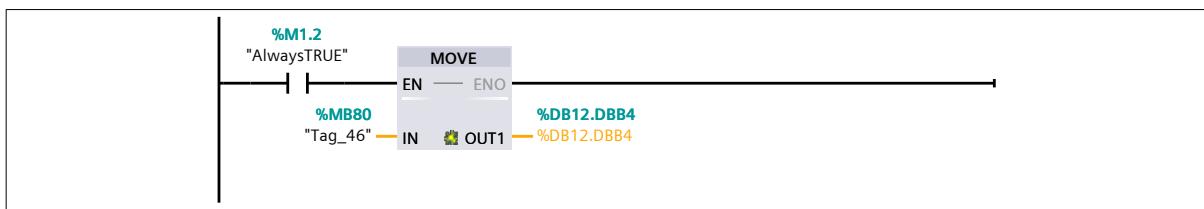


Network 2:



Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 2nd			
Approved By	Language		en-US	
	Version			Sheet 6 - 1

Network 3: PUT VALUE FOR START STOP LOGIC



B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 6 - 2

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks

COM 1 [FC5]

COM 1 Properties

General

Name	COM 1	Number	5
Type	FC	Language	LAD

Numbering Automatic

Information

Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
COM 1	Void		

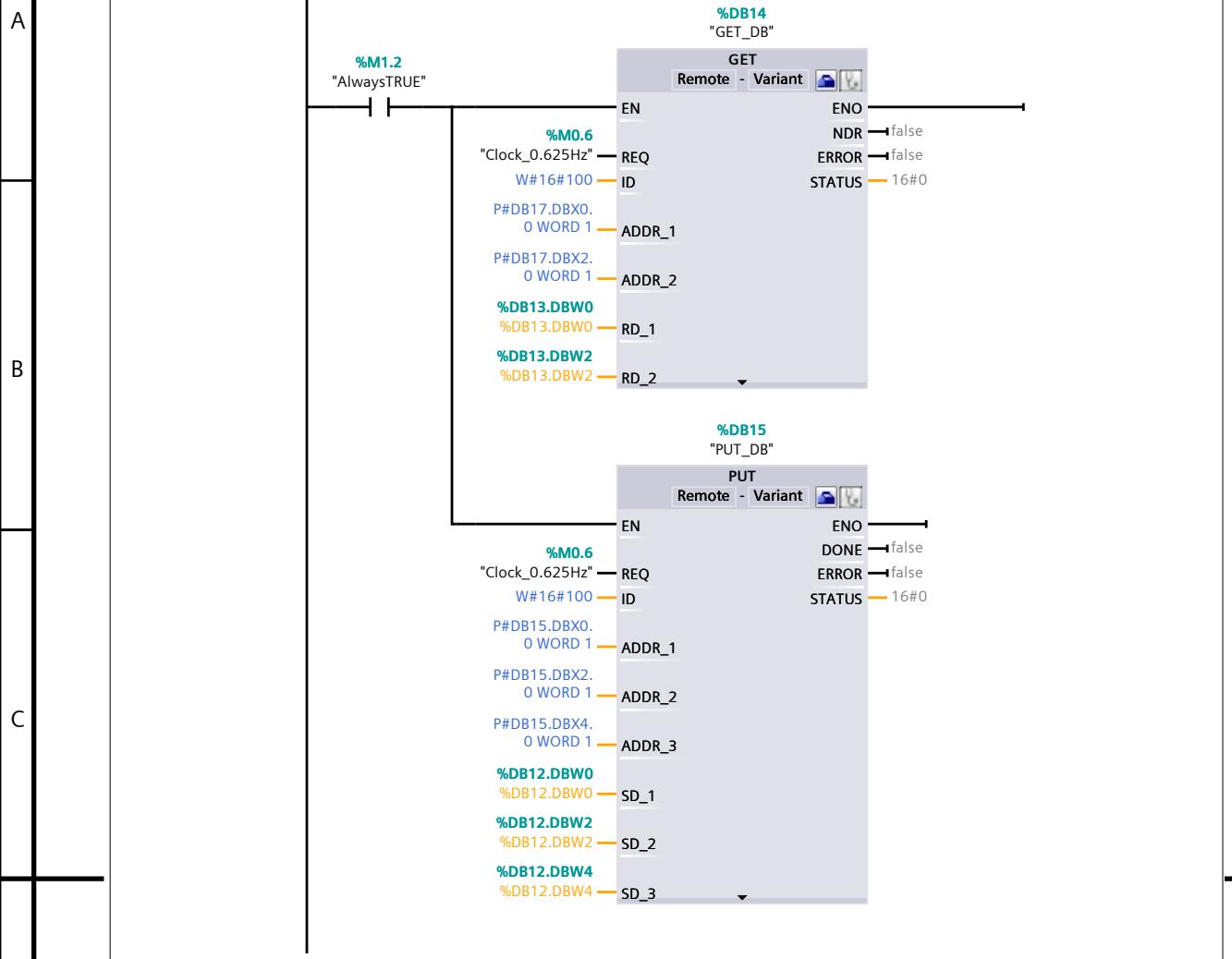
Network 1: FROM STATION 2

D

E

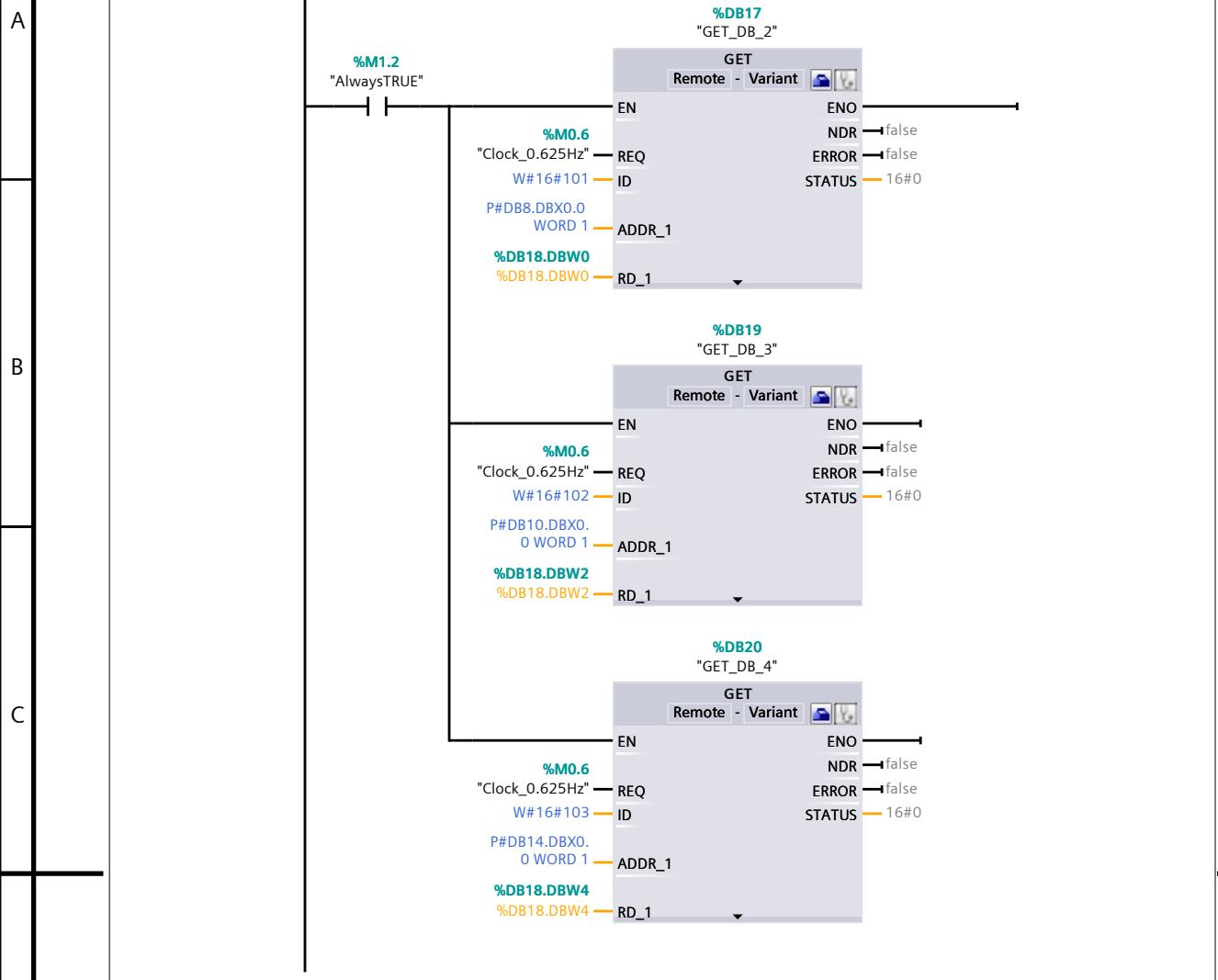
F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 7 - 1



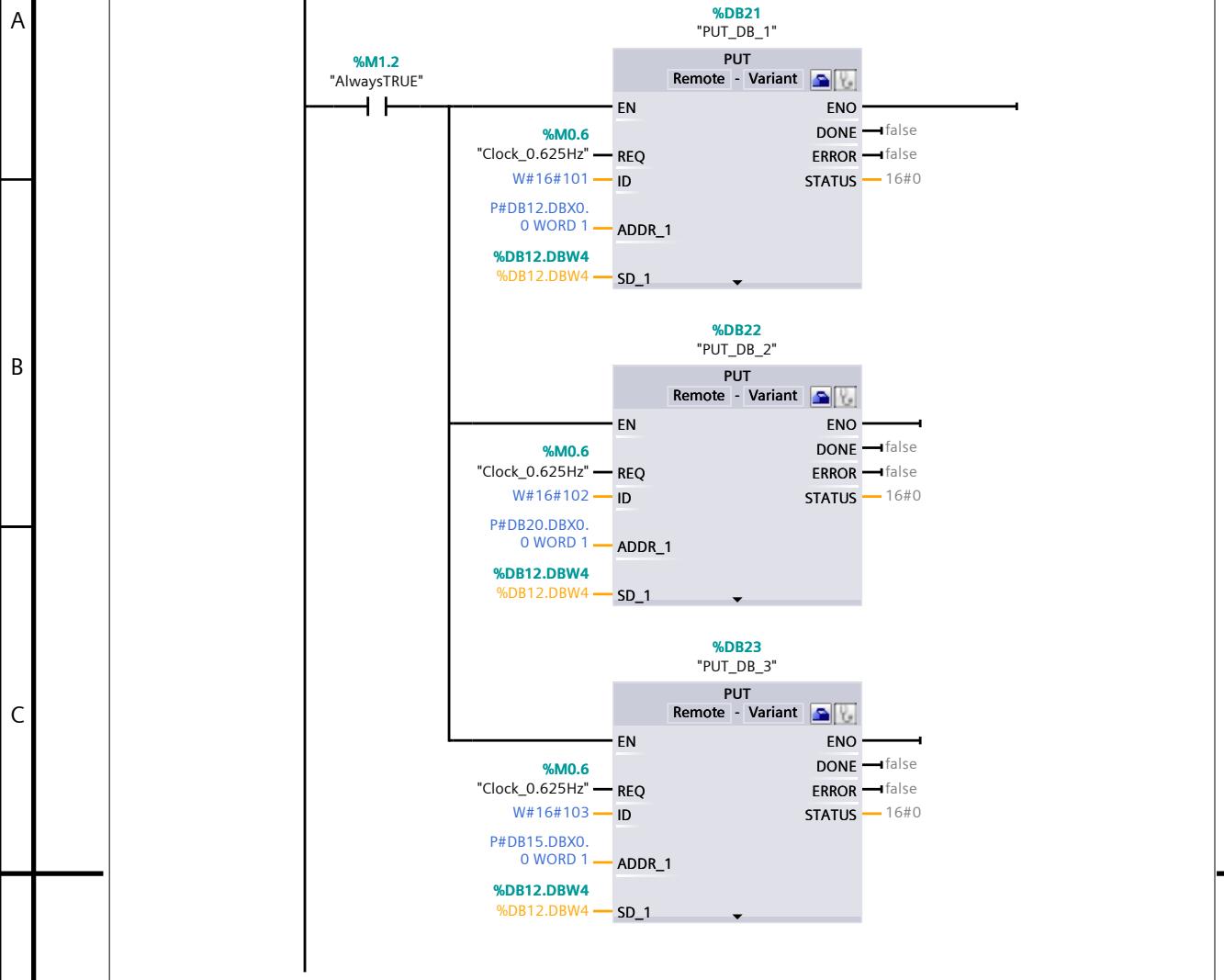
Network 2: GET FROM 3,4,5

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 7 - 2



Network 3: PUT TO 3,4,5

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Location			
Designed By	Description 1st		
Checked By	Description 2nd	Language en-US	
Approved By	1st View	Version	Sheet 7 - 3



Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Location			
Designed By	Description 1st		
Checked By	Description 2nd	Language en-US	
Approved By	1st View	Version	Sheet 7 - 4

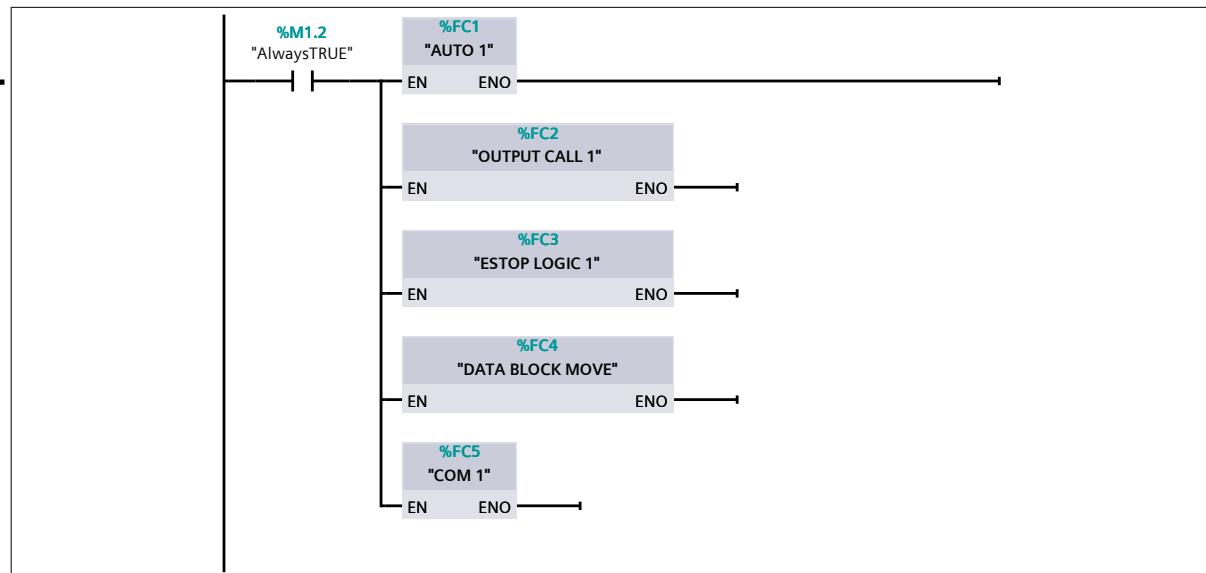
Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks

Main [OB1]

Main Properties			
General			
Name	Main	Number	1
Type	OB	Language	LAD
Numbering	Automatic		
Information			
Title	"Main Program Sweep (Cycle)"	Author	
Comment		Family	
Version	0.1	User-defined ID	

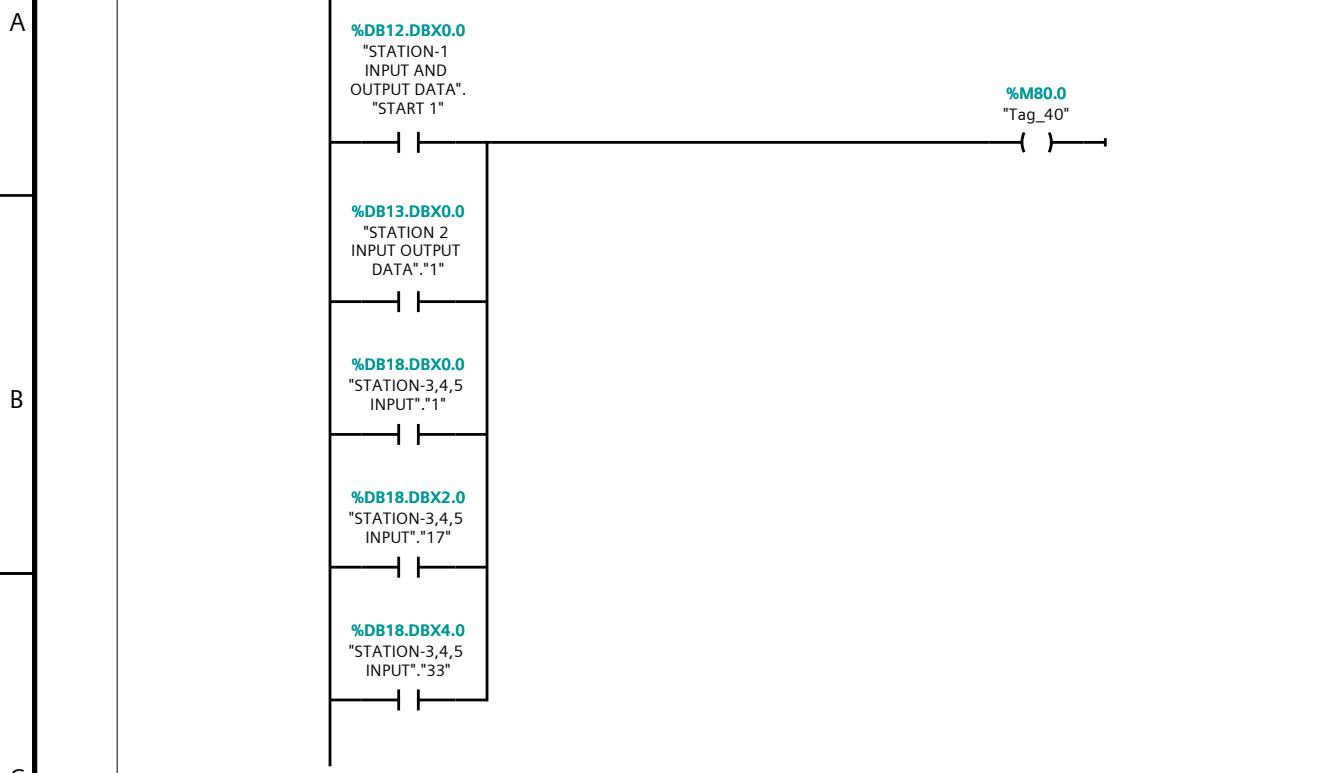
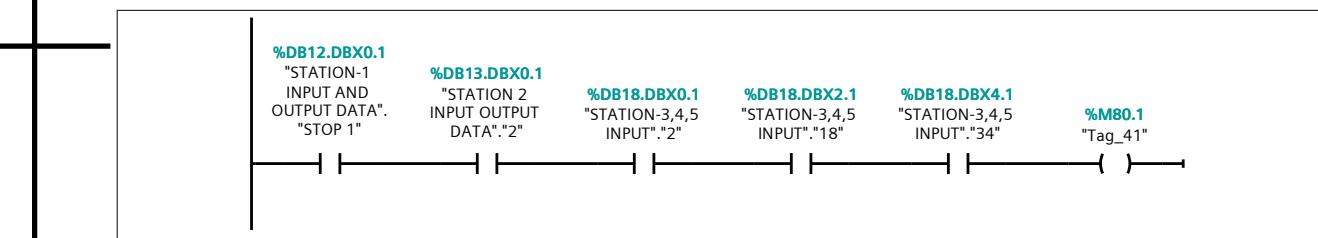
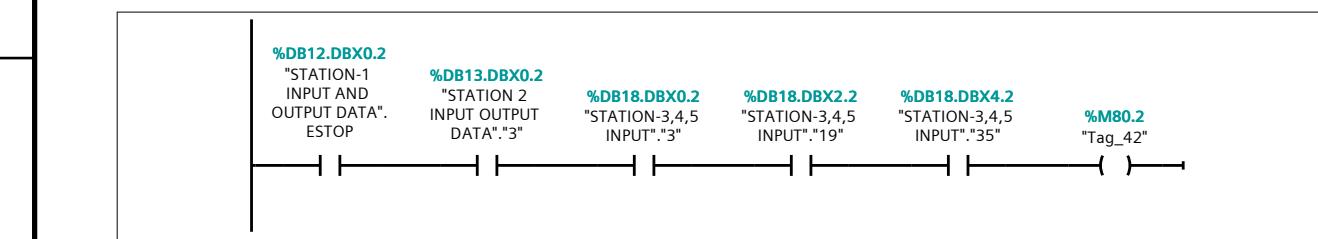
Name	Data type	Default value	Comment
▼ Input			
Initial_Call	Bool		Initial call of this OB
Remanence	Bool		=True, if remanent data are available
Temp			
Constant			

Network 1:



Network 2: START COMMON

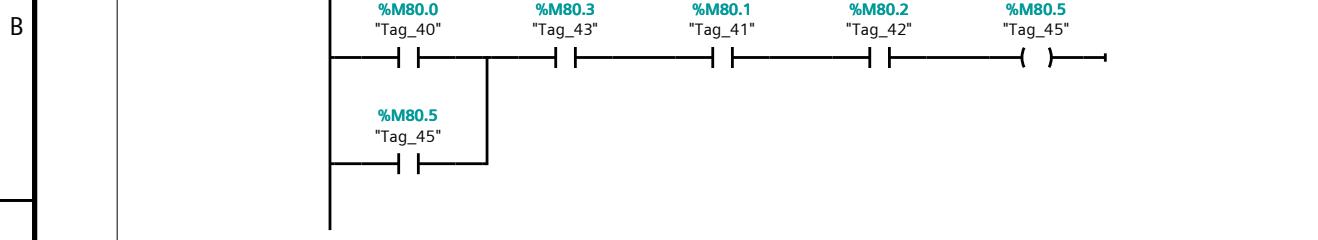
Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 8 - 1

**Network 3: STOP COMMON****Network 4: ESTOP COMMON****Network 5: SELECTOR COMMON**

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Location			
Designed By	Description 1st		
Checked By	Description 2nd	Language en-US	
Approved By	1st View	Version	Sheet 8 - 2



Network 6: START STOP LOGIC FOR ALL STATION COMMON



Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 8 - 3

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks

STATION-1 INPUT AND OUTPUT DATA [DB12]

STATION-1 INPUT AND OUTPUT DATA Properties

General

Name	STATION-1 INPUT AND OUTPUT DATA	Number	12
Type	DB	Language	DB

Information

Title	Author
Comment	Family
Version	User-defined ID



Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	START 1	Data type	Bool
Offset	0.0	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	STOP 1	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	ESTOP	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location		
Checked By	Description 1st		
Approved By	Description 2nd	Language en-US	Version Sheet 9 - 1

F

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name Offset Retain	True False AUTO/MANUAL 0.3 False	Visible in HMI engineering Supervision Data type Start value Accessible from HMI/OPC UA/Web API	True Bool false True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name Offset Retain	True False 1 0.4 False	Visible in HMI engineering Supervision Data type Start value Accessible from HMI/OPC UA/Web API	True Bool false True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name Offset Retain	True False 2 0.5 False	Visible in HMI engineering Supervision Data type Start value Accessible from HMI/OPC UA/Web API	True Bool false True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name Offset Retain	True False 3 0.6 False	Visible in HMI engineering Supervision Data type Start value Accessible from HMI/OPC UA/Web API	True Bool false True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name Offset Retain	True False 4 0.7 False	Visible in HMI engineering Supervision Data type Start value Accessible from HMI/OPC UA/Web API	True Bool false True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Language en-US Version	Date 7/12/2025 Sheet 9 - 2

A	Comment		
	Name	5	Data type Bool
	Offset	1.0	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	6	Data type Bool
	Offset	1.1	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	7	Data type Bool
	Offset	1.2	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	8	Data type Bool
C	Offset	1.3	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	9	Data type Bool
	Offset	1.4	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
D	Comment		
	Name	10	Data type Bool
	Offset	1.5	Start value false
	Offset	1.5	Start value false
	Offset	1.5	Start value false
	Offset	1.5	Start value false
	Offset	1.5	Start value false
	Offset	1.5	Start value false
	Offset	1.5	Start value false
	Offset	1.5	Start value false
E	Owner	Project name	Automation Production Station Code
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code
	Designed By	Description 1st	
	Checked By	Description 2nd	Language en-US
	Approved By	1st View	Version
			Sheet 9 - 3

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
Designed By	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Checked By	Location			
Approved By	Description 1st	Description 2nd	Language	en-US
	1st View		Version	Sheet 9 - 3

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	11	Data type	Bool
	Offset	1.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	12	Data type	Bool
	Offset	1.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	13	Data type	Bool
	Offset	2.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	14	Data type	Bool
	Offset	2.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	15	Data type	Bool
	Offset	2.2	Start value	false
F	Retain	False	Accessible from HMI/OPC UA/Web API	True
Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
Approved By		Description 2nd	Language en-US	
		1st View	Version	Sheet 9 - 4

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 16 Offset 2.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 17 Offset 2.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 18 Offset 2.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 19 Offset 2.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 20 Offset 2.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 9 - 5

A	Comment		
	Name	21	Data type
	Offset	3.0	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	22	Data type
	Offset	3.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	23	Data type
	Offset	3.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	24	Data type
C	Offset	3.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	25	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
D	Comment		
	Name	26	Data type
	Offset	3.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	26	Data type
	Offset	3.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
E	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	26	Data type
	Offset	3.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	26	Data type
F	Offset	3.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	26	Data type
	Offset	3.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision

Owner	Project name Automation Production Station Code		Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 9 - 6

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	27	Data type	Bool
	Offset	3.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	28	Data type	Bool
	Offset	3.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	29	Data type	Bool
	Offset	4.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	30	Data type	Bool
	Offset	4.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	31	Data type	Bool
	Offset	4.2	Start value	false
F	Retain	False	Accessible from HMI/OPC UA/Web API	True
Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
Approved By		Description 2nd	Language en-US	
		1st View	Version	Sheet 9 - 7

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 32 Offset 4.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 33 Offset 4.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 34 Offset 4.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 35 Offset 4.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 36 Offset 4.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 9 - 8

A	Comment		
	Name	37	Data type
	Offset	5.0	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	38	Data type
	Offset	5.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	39	Data type
	Offset	5.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	40	Data type
D	Offset	5.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	41	Data type
	Offset	5.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
E	Comment		
	Name	42	Data type
	Offset	5.5	Start value
	Comment		
	Name	43	Data type
	Offset	5.6	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		

Owner	Project name Automation Production Station Code		Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 9 - 9

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	43	Data type	Bool
	Offset	5.6	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	44	Data type	Bool
	Offset	5.7	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	45	Data type	Bool
	Offset	6.0	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
D	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	46	Data type	Bool
	Offset	6.1	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
F	Owner	Project name	Automation Production Station Code	Date 7/12/2025
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location		
	Checked By	Description 1st		
	Approved By	Description 2nd	Language	en-US
		1st View	Version	Sheet 9 - 10

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks

STATION 2 INPUT OUTPUT DATA [DB13]

STATION 2 INPUT OUTPUT DATA Properties

General

Name	STATION 2 INPUT OUTPUT DATA	Number	13
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	
Comment		Family	
Version	0.1	User-defined ID	



Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	1	Data type	Bool
Offset	0.0	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	2	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	3	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 10 - 1

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	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 7 Offset 0.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 8 Offset 0.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version Sheet 10 - 2	

A	Comment		
	Name	9	Data type Bool
	Offset	1.0	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
B	Comment		
	Name	10	Data type Bool
	Offset	1.1	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
C	Comment		
	Name	11	Data type Bool
	Offset	1.2	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
D	Comment		
	Name	12	Data type Bool
	Offset	1.3	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
E	Comment		
	Name	13	Data type Bool
	Offset	1.4	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
F	Name	14	Data type Bool
	Offset	1.5	Start value false

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 10 - 3

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	15	Data type	Bool
	Offset	1.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	16	Data type	Bool
	Offset	1.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	17	Data type	Bool
	Offset	2.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	18	Data type	Bool
	Offset	2.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	19	Data type	Bool
	Offset	2.2	Start value	false
F	Retain	False	Accessible from HMI/OPC UA/Web API	True
Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
Approved By		Description 2nd	Language en-US	Version
		1st View	Sheet 10 - 4	

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 20 Offset 2.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 21 Offset 2.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 22 Offset 2.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 23 Offset 2.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 24 Offset 2.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 10 - 5

A	Comment		
	Name	25	Data type
	Offset	3.0	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	26	Data type
	Offset	3.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	27	Data type
	Offset	3.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	28	Data type
C	Offset	3.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	29	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
D	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
E	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	30	Data type
F	Offset	3.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location		
Checked By	Description 1st		
Approved By	Description 2nd	Language en-US	Version Sheet 10 - 6
	1st View		

A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	31	Data type	Bool
	Offset	3.6	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	32	Data type	Bool
	Offset	3.7	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			

D																															
E																															
F	<table border="1"> <tr> <td>Owner</td> <td>Project name</td> <td>Automation Production Station Code</td> <td>Date</td> <td>7/12/2025</td> </tr> <tr> <td>Operator</td> <td>Project path</td> <td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td> </tr> <tr> <td>Designed By</td> <td>Location</td> <td colspan="3"></td> </tr> <tr> <td>Checked By</td> <td>Description 1st</td> <td colspan="3"></td> </tr> <tr> <td>Approved By</td> <td>Description 2nd</td> <td>Language</td> <td>en-US</td> <td></td> </tr> <tr> <td></td> <td>1st View</td> <td>Version</td> <td colspan="2">Sheet 10 - 7</td> </tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 10 - 7	
Owner	Project name	Automation Production Station Code	Date	7/12/2025																											
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																													
Designed By	Location																														
Checked By	Description 1st																														
Approved By	Description 2nd	Language	en-US																												
	1st View	Version	Sheet 10 - 7																												

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks

STATION-3,4,5 INPUT [DB18]

STATION-3,4,5 INPUT Properties

General

Name	STATION-3,4,5 INPUT	Number	18
Type	DB	Language	DB
Numbering	Automatic		

Information

Title	Author
Comment	Family
Version	User-defined ID



Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	1	Data type	Bool
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Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	2	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	3	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 11 - 1

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	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 7 Offset 0.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 8 Offset 0.7 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 11 - 2

A	Comment		
	Name	9	Data type Bool
	Offset	1.0	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	10	Data type Bool
	Offset	1.1	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	11	Data type Bool
	Offset	1.2	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	12	Data type Bool
C	Offset	1.3	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	13	Data type Bool
	Offset	1.4	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
D	Comment		
	Name	14	Data type Bool
	Offset	1.5	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	15	Data type Bool
	Offset	1.6	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
E	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	16	Data type Bool
	Offset	1.7	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	17	Data type Bool
F	Offset	1.8	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	18	Data type Bool
	Offset	1.9	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location		
Checked By	Description 1st		
Approved By	Description 2nd Language en-US		
	1st View Version Sheet 11 - 3		

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	15	Data type	Bool
	Offset	1.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	16	Data type	Bool
	Offset	1.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	17	Data type	Bool
	Offset	2.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	18	Data type	Bool
	Offset	2.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	19	Data type	Bool
	Offset	2.2	Start value	false
F	Retain	False	Accessible from HMI/OPC UA/Web API	True
Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
Approved By		Description 2nd	Language en-US	
		1st View	Version	Sheet 11 - 4

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 20 Offset 2.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 21 Offset 2.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 22 Offset 2.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 23 Offset 2.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 24 Offset 2.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 11 - 5

A	Comment		
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	Setpoint	False	Supervision
	Comment		
	Name	26	Data type
	Offset	3.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	27	Data type
	Offset	3.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	28	Data type
C	Offset	3.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	29	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
D	Comment		
	Name	29	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		
E	Owner	Automation Production Station Code	Date 7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Operator		
	Location		
	Designed By	Description 1st	
	Checked By	Description 2nd	Language en-US
	Approved By	1st View	Version
			Sheet 11 - 6

Owner	Automation Production Station Code	Date 7/12/2025
Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator		
Location		
Designed By	Description 1st	
Checked By	Description 2nd	Language en-US
Approved By	1st View	Version
		Sheet 11 - 6

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	31	Data type	Bool
	Offset	3.6	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	32	Data type	Bool
	Offset	3.7	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	33	Data type	Bool
	Offset	4.0	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
D	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	34	Data type	Bool
	Offset	4.1	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	35	Data type	Bool
	Offset	4.2	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
F	Owner	Project name	Automation Production Station Code	Date 7/12/2025
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location		
	Checked By	Description 1st		
	Approved By	Description 2nd	Language	en-US
		1st View	Version	Sheet 11 - 7

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 36 Offset 4.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 37 Offset 4.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 38 Offset 4.5 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 39 Offset 4.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 40 Offset 4.7 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 11 - 8

A	Comment		
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	Offset	5.0	Start value
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	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	42	Data type
	Offset	5.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	43	Data type
	Offset	5.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	44	Data type
D	Offset	5.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	45	Data type
	Offset	5.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
E	Comment		
	Name	46	Data type
	Offset	5.5	Start value
	Comment		
	Name	46	Data type
	Offset	5.5	Start value
	Comment		
	Name	46	Data type
	Offset	5.5	Start value
	Comment		

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 11 - 9

A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	47	Data type	Bool
	Offset	5.6	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			

C		
D		
E		
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View Language en-US Version Sheet 11 - 10

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_1 [DB2]

IEC_Timer_0_DB_1 Properties

General

Name	IEC_Timer_0_DB_1	Number	2
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 12 - 1

F

	1	2	3	4																															
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Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False																																
Visible in HMI engineering	True	Setpoint	False																																
Supervision		Comment																																	
B																																			
C																																			
D																																			
E																																			
F	<table border="1"> <tr> <td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr> <td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr> <td>Designed By</td><td>Location</td><td colspan="3"></td></tr> <tr> <td>Checked By</td><td>Description 1st</td><td colspan="3"></td></tr> <tr> <td>Approved By</td><td>Description 2nd</td><td>Language</td><td>en-US</td><td></td></tr> <tr> <td></td><td>1st View</td><td>Version</td><td colspan="2">Sheet 12 - 2</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 12 - 2					
Owner	Project name	Automation Production Station Code	Date	7/12/2025																															
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																																	
Designed By	Location																																		
Checked By	Description 1st																																		
Approved By	Description 2nd	Language	en-US																																
	1st View	Version	Sheet 12 - 2																																

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_2 [DB3]

IEC_Timer_0_DB_2 Properties

General

Name	IEC_Timer_0_DB_2	Number	3
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
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Supervision		Comment	
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Supervision		Comment	
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
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Start value	false	Retain	False

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Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 13 - 1

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Owner	Project name Automation Production Station Code	
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By	Location	
Checked By	Description 1st	
Approved By	Description 2nd	Language en-US
	1st View	Version
		Sheet 13 - 2

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Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_3 [DB4]

IEC_Timer_0_DB_3 Properties

General

Name	IEC_Timer_0_DB_3	Number	4
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
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Supervision		Comment	
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Supervision		Comment	
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Start value	false	Retain	False

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Approved By	1st View		Version	Sheet 14 - 1

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	1st View	Version	Sheet 14 - 2																																

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_4 [DB5]

IEC_Timer_0_DB_4 Properties			
General			
Name	IEC_Timer_0_DB_4	Number	5
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC TMR

Name	Static	Data type	
Start value		Retain	
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Supervision		Comment	
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
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Supervision		Comment	
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Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 15 - 1	

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Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																			
Designed By	Location																			
Checked By	Description 2nd	Language en-US																		
Approved By	1st View	Version																		
		Sheet 15 - 2																		

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_5 [DB6]

IEC_Timer_0_DB_5 Properties			
General			
Name	IEC_Timer_0_DB_5	Number	6
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR

Name	Static	Data type	
Start value		Retain	
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Supervision		Comment	
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
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Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
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Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
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Visible in HMI engineering	True													
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	1st View	Version	Sheet 16 - 2																												

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Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_6 [DB7]

IEC_Timer_0_DB_6 Properties

General

Name	IEC_Timer_0_DB_6	Number	7
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
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Supervision		Comment	
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Supervision		Comment	
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
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Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 17 - 1

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Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_7 [DB8]

IEC_Timer_0_DB_7 Properties

General

Name	IEC_Timer_0_DB_7	Number	8
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
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Supervision		Comment	
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Owner	Project name	Automation Production Station Code	Date	7/12/2025
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Designed By	Location			
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Approved By	Description 2nd	Language	en-US	Version
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Owner	Project name	Automation Production Station Code	Date	7/12/2025																															
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Approved By	Description 2nd	Language	en-US																																
	1st View	Version	Sheet 18 - 2																																

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Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_8 [DB9]

IEC_Timer_0_DB_8 Properties

General

Name	IEC_Timer_0_DB_8	Number	9
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
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Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
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Designed By	Location																														
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Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_9 [DB10]

IEC_Timer_0_DB_9 Properties

General

Name	IEC_Timer_0_DB_9	Number	10
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



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Supervision		Comment	
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Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	
	1st View	Version	Sheet 20 - 1	

F

A	<p>Accessible from HMI/OPC UA/Web API</p> <p>Visible in HMI engineering</p> <p>Supervision</p>	<p>True</p>	<p>Writable from HMI/OPC UA/Web API</p> <p>Setpoint</p> <p>Comment</p>	<p>False</p>
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B

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D

E

F

Owner	Project name Automation Production Station Code	
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By	Location	
Checked By	Description 2nd	Language en-US
Approved By	1st View	Version
		Sheet 20 - 2

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_10 [DB11]

IEC_Timer_0_DB_10 Properties			
General			
Name	IEC_Timer_0_DB_10	Number	11
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 21 - 1	

A	<p>Accessible from HMI/OPC UA/Web API</p> <p>Visible in HMI engineering</p> <p>Supervision</p>	<p>True</p>	<p>Writable from HMI/OPC UA/Web API</p> <p>Setpoint</p> <p>Comment</p>	<p>False</p>
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B

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E

F

Owner	Project name Automation Production Station Code	
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Location		
Designed By	Description 1st	
Checked By	Description 2nd	Language en-US
Approved By	1st View	Version
		Sheet 21 - 2

A **Automation Production Station Code /
PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks /
Program resources**

GET_DB [DB14]

GET_DB Properties

General

Name	GET_DB	Number	14
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	SIMATIC
Comment		Family	COM_FUNC
Version	1.1	User-defined ID	GET



Name	Input	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	REQ	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ID	Data type	Word
Start value	16#0	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	



Name	Output	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	NDR	Data type	Bool

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	
	1st View	Version		Sheet 22 - 1

A	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	ADDR_4	Data type	Remote
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	RD_1	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
B	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_2	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_3	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
C	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_4	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	Static	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	False
D	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_4	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	Static	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	False
E	Visible in HMI engineering		Setpoint	
	Supervision		Comment	

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location		
Checked By	Description 1st		
Approved By	Description 2nd	Language en-US	Version Sheet 22 - 3
	1st View		

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

PUT_DB [DB15]

PUT_DB Properties

General

Name	PUT_DB	Number	15
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	SIMATIC
Comment		Family	COM_FUNC
Version	1.1	User-defined ID	PUT



Name	Input	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	REQ	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ID	Data type	Word
Start value	16#0	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	



Name	Output	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	DONE	Data type	Bool

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
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A	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	ADDR_4	Data type	Remote
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	SD_1	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
B	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	SD_2	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	SD_3	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
C	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	SD_4	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	Static	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	False
D	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name		Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name		Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	False
E	Visible in HMI engineering		Setpoint	
	Supervision		Comment	
	Owner	Automation Production Station Code	Date	7/12/2025
	Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	Project path	
	Designed By	Description 1st	Location	
	Checked By	Description 2nd	Language	en-US
	Approved By	1st View	Version	Sheet 23 - 3

Owner	Automation Production Station Code	Date	7/12/2025
Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Description 1st		
Checked By	Description 2nd		
Approved By	1st View	Version	Sheet 23 - 3

A **Automation Production Station Code /
PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks /
Program resources**

GET_DB_2 [DB17]

GET_DB_2 Properties

General

Name	GET_DB_2	Number	17
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	SIMATIC
Comment		Family	COM_FUNC
Version	1.1	User-defined ID	GET

▼			
Name	Input	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	REQ	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ID	Data type	Word
Start value	16#0	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
▼			
Name	Output	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	NDR	Data type	Bool
Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location		
Checked By	Description 1st	Description 2nd	Language en-US
Approved By	1st View	Version	Sheet 24 - 1

	1	2	3	4
A	Start value	false	Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	ERROR	Data type	Bool
	Start value	false	Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	STATUS	Data type	Word
B	Start value	16#0	Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name		Data type	
	Start value		Retain	
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
	Visible in HMI engineering		Setpoint	
	Supervision		Comment	
	▼			
C	Name	InOut	Data type	
	Start value		Retain	
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
	Visible in HMI engineering		Setpoint	
	Supervision		Comment	
	Name	ADDR_1	Data type	Remote
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
D	Name	ADDR_2	Data type	Remote
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	ADDR_3	Data type	Remote
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
E	Owner	Project name	Automation Production Station Code	Date 7/12/2025
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Description 1st		
	Checked By	Description 2nd	Language	en-US
	Approved By	1st View	Version	Sheet 24 - 2

A	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	ADDR_4	Data type	Remote
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	RD_1	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
B	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_2	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_3	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
C	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_4	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	Static	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	False
D	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name		Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name		Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	False
E	Visible in HMI engineering		Setpoint	
	Supervision		Comment	
	Owner	Automation Production Station Code	Date	7/12/2025
	Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	Project path	
	Designed By	Description 1st	Location	
	Checked By	Description 2nd	Language	en-US
	Approved By	1st View	Version	Sheet 24 - 3

Owner	Automation Production Station Code	Date	7/12/2025
Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Description 1st		
Checked By	Description 2nd	Language	en-US
Approved By	1st View	Version	Sheet 24 - 3

A **Automation Production Station Code /
PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks /
Program resources**

GET_DB_3 [DB19]

GET_DB_3 Properties

General

Name	GET_DB_3	Number	19
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	SIMATIC
Comment		Family	COM_FUNC
Version	1.1	User-defined ID	GET



Name	Input	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	REQ	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True

Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ID	Data type	Word
Start value	16#0	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	



Name	Output	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	NDR	Data type	Bool

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
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	1	2	3	4
A	Start value	false	Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	ERROR	Data type	Bool
	Start value	false	Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	STATUS	Data type	Word
B	Start value	16#0	Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name		Data type	
	Start value		Retain	
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
	Visible in HMI engineering		Setpoint	
	Supervision		Comment	
	▼			
C	Name	InOut	Data type	
	Start value		Retain	
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
	Visible in HMI engineering		Setpoint	
	Supervision		Comment	
	Name	ADDR_1	Data type	Remote
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
D	Name	ADDR_2	Data type	Remote
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	ADDR_3	Data type	Remote
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
E	Owner	Project name	Automation Production Station Code	Date 7/12/2025
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Description 1st		
	Checked By	Description 2nd	Language	en-US
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A	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	ADDR_4	Data type	Remote
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	RD_1	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
B	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_2	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_3	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
C	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_4	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	Static	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	False
D	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name		Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name		Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	False
E	Visible in HMI engineering		Setpoint	
	Supervision		Comment	
	Owner	Automation Production Station Code	Date	7/12/2025
	Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	Project path	
	Designed By	Description 1st	Location	
	Checked By	Description 2nd	Language	en-US
	Approved By	1st View	Version	Sheet 25 - 3

Owner	Automation Production Station Code	Date	7/12/2025
Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Description 1st		
Checked By	Description 2nd	Language	en-US
Approved By	1st View	Version	Sheet 25 - 3

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

GET_DB_4 [DB20]

GET_DB_4 Properties

General

Name	GET_DB_4	Number	20
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	SIMATIC
Comment		Family	COM_FUNC
Version	1.1	User-defined ID	GET



Name	Input	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	REQ	Data type	Bool
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Name	Output	Data type	
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Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	NDR	Data type	Bool

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
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F	Owner	Project name	Automation Production Station Code	Date 7/12/2025																																																								
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	Supervision		Comment	
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	Owner	Automation Production Station Code	Date	7/12/2025
	Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	Project path	
	Designed By	Description 1st	Location	
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Owner	Automation Production Station Code	Date	7/12/2025
Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Description 1st		
Checked By	Description 2nd	Language	en-US
Approved By	1st View	Version	Sheet 26 - 3

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

PUT_DB_1 [DB21]

PUT_DB_1 Properties

General

Name	PUT_DB_1	Number	21
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	SIMATIC
Comment		Family	COM_FUNC
Version	1.1	User-defined ID	PUT



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Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
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Owner	Automation Production Station Code	Date	7/12/2025
Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
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Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

PUT_DB_2 [DB22]

PUT_DB_2 Properties

General

Name	PUT_DB_2	Number	22
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	SIMATIC
Comment		Family	COM_FUNC
Version	1.1	User-defined ID	PUT



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Owner	Project name	Automation Production Station Code	Date	7/12/2025
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	Designed By	Location																																																										
	Checked By	Description 1st																																																										
	Approved By	Description 2nd	Language en-US	Version Sheet 28 - 2																																																								

A	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
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	Start value		Retain	False
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	Supervision		Comment	
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	Supervision		Comment	
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	Supervision		Comment	
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C	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	SD_4	Data type	Variant
	Start value		Retain	False
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	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
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D	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name		Data type	Variant
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	Supervision		Comment	
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	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
E	Visible in HMI engineering		Setpoint	
	Supervision		Comment	
	Owner	Automation Production Station Code	Date	7/12/2025
	Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	Project path	
	Designed By	Description 1st	Location	
	Checked By	Description 2nd	Language	en-US
	Approved By	1st View	Version	Sheet 28 - 3

Owner	Automation Production Station Code	Date	7/12/2025
Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Description 1st		
Checked By	Description 2nd	Language	en-US
Approved By	1st View	Version	Sheet 28 - 3

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

PUT_DB_3 [DB23]

PUT_DB_3 Properties

General

Name	PUT_DB_3	Number	23
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	SIMATIC
Comment		Family	COM_FUNC
Version	1.1	User-defined ID	PUT



Name	Input	Data type	
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Visible in HMI engineering		Setpoint	
Supervision		Comment	
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Visible in HMI engineering	True	Setpoint	False

Supervision

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Supervision		Comment	



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Visible in HMI engineering		Setpoint	
Supervision		Comment	
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Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
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Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 29 - 1

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F	Owner	Project name	Automation Production Station Code	Date 7/12/2025																																																								
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	Supervision		Comment	
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	Supervision		Comment	
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C	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
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	Supervision		Comment	
	Owner	Automation Production Station Code	Date	7/12/2025
	Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	Project path	
	Designed By	Description 1st	Location	
	Checked By	Description 2nd	Language	en-US
	Approved By	1st View	Version	Sheet 29 - 3

Owner	Automation Production Station Code	Date	7/12/2025
Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Description 1st		
Checked By	Description 2nd	Language	en-US
Approved By	1st View	Version	Sheet 29 - 3

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_11 [DB16]

IEC_Timer_0_DB_11 Properties			
General			
Name	IEC_Timer_0_DB_11	Number	16
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR

Name	Static	Data type	
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Visible in HMI engineering		Setpoint	
Supervision		Comment	
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 30 - 1	

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Approved By	1st View		Version	Sheet 30 - 2																										

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_12 [DB24]

IEC_Timer_0_DB_12 Properties			
General			
Name	IEC_Timer_0_DB_12	Number	24
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR

Name	Static	Data type	
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Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 31 - 1	

	1	2	3	4																										
A	<table border="1"> <tr> <td>Accessible from HMI/OPC UA/Web API</td><td>True</td><td>Writable from HMI/OPC UA/Web API</td><td>False</td></tr> <tr> <td>Visible in HMI engineering</td><td>True</td><td>Setpoint</td><td>False</td></tr> <tr> <td>Supervision</td><td></td><td>Comment</td><td></td></tr> </table>	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False	Visible in HMI engineering	True	Setpoint	False	Supervision		Comment																		
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False																											
Visible in HMI engineering	True	Setpoint	False																											
Supervision		Comment																												
B																														
C																														
D																														
E																														
F	<table border="1"> <tr> <td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr> <td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr> <td>Designed By</td><td>Location</td><td colspan="3"></td></tr> <tr> <td>Checked By</td><td>Description 1st</td><td>Description 2nd</td><td>Language</td><td>en-US</td></tr> <tr> <td>Approved By</td><td>1st View</td><td></td><td>Version</td><td>Sheet 31 - 2</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st	Description 2nd	Language	en-US	Approved By	1st View		Version	Sheet 31 - 2				
Owner	Project name	Automation Production Station Code	Date	7/12/2025																										
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																												
Designed By	Location																													
Checked By	Description 1st	Description 2nd	Language	en-US																										
Approved By	1st View		Version	Sheet 31 - 2																										

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC]

Technology objects

This folder is empty.

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
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A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC]

PLC tags

PLC tags						
Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
■	AlwaysFALSE	Bool	%M1.3	True	True	
■	AlwaysTRUE	Bool	%M1.2	True	True	
■	Clock_0.5Hz	Bool	%M0.7	True	True	
■	Clock_0.625 Hz	Bool	%M0.6	True	True	
■	Clock_1.25Hz	Bool	%M0.4	True	True	
■	Clock_1Hz	Bool	%M0.5	True	True	
■	Clock_2.5Hz	Bool	%M0.2	True	True	
■	Clock_2Hz	Bool	%M0.3	True	True	
■	Clock_5Hz	Bool	%M0.1	True	True	
■	Clock_10Hz	Bool	%M0.0	True	True	
■	Clock_Byte	Byte	%MBO	True	True	
■	DiagStatusUpdate	Bool	%M1.1	True	True	
■	FirstScan	Bool	%M1.0	True	True	
■	System_Byte	Byte	%MB1	True	True	
■	Tag_1	Bool	%I0.0	True	True	
■	Tag_2	Bool	%I0.2	True	True	
■	Tag_3	Bool	%I0.4	True	True	
■	Tag_4	Bool	%I0.5	True	True	
■	Tag_5	Bool	%I1.1	True	True	
■	Tag_6	Bool	%M10.0	True	True	
■	Tag_7	Bool	%I0.6	True	True	
■	Tag_8	Bool	%I0.7	True	True	
■	Tag_9	Bool	%I1.2	True	True	
■	Tag_10	Bool	%I1.4	True	True	
■	Tag_11	Bool	%M10.1	True	True	
■	Tag_12	Bool	%I1.0	True	True	
■	Tag_13	Bool	%M10.4	True	True	
■	Tag_14	Bool	%M15.0	True	True	
■	Tag_15	Bool	%M10.2	True	True	

Owner	Project name	Automation Production Station Code	Date	7/12/2025
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Designed By	Location			
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	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
A	Tag_16	Bool		%M10.3	True	True	
	Tag_17	Bool		%I1.3	True	True	
	Tag_18	Bool		%M11.1	True	True	
	Tag_19	Bool		%M10.5	True	True	
	Tag_20	Bool		%M15.1	True	True	
B	Tag_21	Bool		%Q0.0	True	True	
	Tag_22	Bool		%Q0.2	True	True	
	Tag_23	Bool		%Q0.3	True	True	
	Tag_24	Bool		%Q0.4	True	True	
	Tag_25	Bool		%Q0.5	True	True	
C	Tag_26	Bool		%Q0.1	True	True	
	Tag_27	Bool		%M49.0	True	True	
	Tag_28	Bool		%M48.0	True	True	
	Tag_29	Bool		%M50.0	True	True	
	Tag_30	Bool		%M60.0	True	True	
D	Tag_31	Bool		%M60.2	True	True	
	Tag_32	Bool		%M60.5	True	True	
	Tag_33	Bool		%M55.0	True	True	
	Tag_34	Byte		%IB0	True	True	
	Tag_35	Byte		%IB1	True	True	
	Tag_36	Byte		%IB2	True	True	
E	Tag_37	Byte		%QB0	True	True	
	Tag_38	Byte		%MB70	True	True	
	Tag_39	Bool		%M70.0	True	True	
	Tag_40	Bool		%M80.0	True	True	
	Tag_41	Bool		%M80.1	True	True	
	Tag_42	Bool		%M80.2	True	True	
	Tag_43	Bool		%M80.3	True	True	
	Tag_44	Bool		%M85.0	True	True	
	Tag_45	Bool		%M80.5	True	True	
	Tag_46	Byte		%MB80	True	True	
	Tag_47	Bool		%I0.3	True	True	
	Tag_48	Bool		%M48.2	True	True	
F	Tag_49	Bool		%M11.0	True	True	
	Tag_50	Bool		%I0.1	True	True	
	Tag_51	Bool		%M5.0	True	True	

Owner	Project name	Automation Production Station Code	Date	7/12/2025
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Designed By	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
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A	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
		Tag_52	Bool	%M4.0	True	True	
		Tag_53	Bool	%M16.0	True	True	
		Tag_54	Bool	%M48.4	True	True	

B																															
C																															
D																															
E																															
F	<table border="1"> <tr> <td>Owner</td> <td>Project name</td> <td>Automation Production Station Code</td> <td>Date</td> <td>7/12/2025</td> </tr> <tr> <td>Operator</td> <td>Project path</td> <td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td> </tr> <tr> <td>Designed By</td> <td>Location</td> <td colspan="3"></td> </tr> <tr> <td>Checked By</td> <td>Description 1st</td> <td colspan="3"></td> </tr> <tr> <td>Approved By</td> <td>Description 2nd</td> <td>Language</td> <td>en-US</td> <td></td> </tr> <tr> <td></td> <td>1st View</td> <td>Version</td> <td colspan="2">Sheet 33 - 3</td> </tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 33 - 3	
Owner	Project name	Automation Production Station Code	Date	7/12/2025																											
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																													
Designed By	Location																														
Checked By	Description 1st																														
Approved By	Description 2nd	Language	en-US																												
	1st View	Version	Sheet 33 - 3																												

A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / PLC tags

Default tag table [94]

PLC tags						
Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
■	AlwaysFALSE	Bool	%M1.3	True	True	
■	AlwaysTRUE	Bool	%M1.2	True	True	
■	Clock_0.5Hz	Bool	%M0.7	True	True	
■	Clock_0.625 Hz	Bool	%M0.6	True	True	
■	Clock_1.25Hz	Bool	%M0.4	True	True	
■	Clock_1Hz	Bool	%M0.5	True	True	
■	Clock_2.5Hz	Bool	%M0.2	True	True	
■	Clock_2Hz	Bool	%M0.3	True	True	
■	Clock_5Hz	Bool	%M0.1	True	True	
■	Clock_10Hz	Bool	%M0.0	True	True	
■	Clock_Byte	Byte	%MBO	True	True	
■	DiagStatusUpdate	Bool	%M1.1	True	True	
■	FirstScan	Bool	%M1.0	True	True	
■	System_Byte	Byte	%MB1	True	True	
■	Tag_1	Bool	%I0.0	True	True	
■	Tag_2	Bool	%I0.2	True	True	
■	Tag_3	Bool	%I0.4	True	True	
■	Tag_4	Bool	%I0.5	True	True	
■	Tag_5	Bool	%I1.1	True	True	
■	Tag_6	Bool	%M10.0	True	True	
■	Tag_7	Bool	%I0.6	True	True	
■	Tag_8	Bool	%I0.7	True	True	
■	Tag_9	Bool	%I1.2	True	True	
■	Tag_10	Bool	%I1.4	True	True	
■	Tag_11	Bool	%M10.1	True	True	
■	Tag_12	Bool	%I1.0	True	True	
■	Tag_13	Bool	%M10.4	True	True	
■	Tag_14	Bool	%M15.0	True	True	
■	Tag_15	Bool	%M10.2	True	True	

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	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
A	Tag_16	Bool		%M10.3	True	True	
	Tag_17	Bool		%I1.3	True	True	
	Tag_18	Bool		%M11.1	True	True	
	Tag_19	Bool		%M10.5	True	True	
	Tag_20	Bool		%M15.1	True	True	
B	Tag_21	Bool		%Q0.0	True	True	
	Tag_22	Bool		%Q0.2	True	True	
	Tag_23	Bool		%Q0.3	True	True	
	Tag_24	Bool		%Q0.4	True	True	
	Tag_25	Bool		%Q0.5	True	True	
C	Tag_26	Bool		%Q0.1	True	True	
	Tag_27	Bool		%M49.0	True	True	
	Tag_28	Bool		%M48.0	True	True	
	Tag_29	Bool		%M50.0	True	True	
	Tag_30	Bool		%M60.0	True	True	
D	Tag_31	Bool		%M60.2	True	True	
	Tag_32	Bool		%M60.5	True	True	
	Tag_33	Bool		%M55.0	True	True	
	Tag_34	Byte		%IB0	True	True	
	Tag_35	Byte		%IB1	True	True	
	Tag_36	Byte		%IB2	True	True	
E	Tag_37	Byte		%QB0	True	True	
	Tag_38	Byte		%MB70	True	True	
	Tag_39	Bool		%M70.0	True	True	
	Tag_40	Bool		%M80.0	True	True	
	Tag_41	Bool		%M80.1	True	True	
	Tag_42	Bool		%M80.2	True	True	
	Tag_43	Bool		%M80.3	True	True	
	Tag_44	Bool		%M85.0	True	True	
	Tag_45	Bool		%M80.5	True	True	
	Tag_46	Byte		%MB80	True	True	
	Tag_47	Bool		%I0.3	True	True	
	Tag_48	Bool		%M48.2	True	True	
F	Tag_49	Bool		%M11.0	True	True	
	Tag_50	Bool		%I0.1	True	True	
	Tag_51	Bool		%M5.0	True	True	

Owner	Project name	Automation Production Station Code	Date	7/12/2025
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Designed By	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
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A	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
		Tag_52	Bool	%M4.0	True	True	
		Tag_53	Bool	%M16.0	True	True	
		Tag_54	Bool	%M48.4	True	True	

B																															
C																															
D																															
E																															
F	<table border="1"> <tr> <td>Owner</td> <td>Project name</td> <td>Automation Production Station Code</td> <td>Date</td> <td>7/12/2025</td> </tr> <tr> <td>Operator</td> <td>Project path</td> <td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td> </tr> <tr> <td>Designed By</td> <td>Location</td> <td colspan="3"></td> </tr> <tr> <td>Checked By</td> <td>Description 1st</td> <td colspan="3"></td> </tr> <tr> <td>Approved By</td> <td>Description 2nd</td> <td>Language</td> <td>en-US</td> <td></td> </tr> <tr> <td></td> <td>1st View</td> <td>Version</td> <td colspan="2">Sheet 34 - 3</td> </tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 34 - 3	
Owner	Project name	Automation Production Station Code	Date	7/12/2025																											
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																													
Designed By	Location																														
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A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / PLC data types

System data types

This folder is empty.

B

C

D

E

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A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Watch and force tables

Force table

Name	Address	Display format	Force value	Comment

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
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A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC]

Traces

Name

B

C

D

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
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A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Traces

Measurements

This folder is empty.

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
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A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Traces

Combined measurements

Name

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
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A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC]

PLC alarm text lists

This folder is empty.

B

C

D

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
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A

Automation Production Station Code / PLC_1 [CPU 1214C DC/DC/DC] / Local modules

PLC_1 [CPU 1214C DC/DC/DC]

PLC_1			
General\Project information			
Name	PLC_1	Author	MTC-MECH-05
Comment		Slot	1
Rack	0		
General\Catalog information			
Short designation	CPU 1214C DC/DC/DC	Description	Work memory 75 KB; 24VDC power supply with DI14 x 24VDC SINK/SOURCE, DQ10 x 24VDC and AI2 on board; 6 high-speed counters and 4 pulse outputs on board; signal board expands on-board I/O; up to 3 communication modules for serial communication; up to 8 signal modules for I/O expansion; PROFINET interface for programming, HMI and PLC-to-PLC communication
Article number	6ES7 214-1AG40-0XB0	Firmware version	V4.0
General\Identification & Maintenance			
Plant designation		Location identifier	
Installation date	2025-06-11 05:41:27.236	Additional information	
Connection resources			
PG communication:	1	OP communication:	1
S7 basic communication:	0	S7 communication:	0
Maximum number of S7 connection resources:	38		
PROFINET interface [X1]\General			
Name	PROFINET interface_1	Author	MTC-MECH-05
Comment			
PROFINET interface [X1]\General\Project information			
Name	DI 14/DQ 10_1	Comment	
Name	AI 2_1	Comment	
PROFINET interface [X1]\Ethernet addresses\Interface networked with			
Subnet:	PN/IE_1		
PROFINET interface [X1]\Ethernet addresses\IP protocol			
IP configuration	Set IP address in the project	IP address:	192.168.0.1
Subnet mask:	255.255.255.0	Use router	False
PROFINET interface [X1]\Ethernet addresses\PROFINET			
PROFINET device name is set directly at the device	False	Generate PROFINET device name automatically	True
PROFINET device name:	plc_1	Converted name:	plcxb1d0ed

Owner	Project name Automation Production Station Code		Date 7/12/2025
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A	Device number:	0		
	PROFINET interface [X1]\Time synchronization			
	Enable time synchronization via NTP server	Enable time synchronization via NTP server		IP addresses
	Server 1	0.0.0.0	Server 2	0.0.0.0
	Server 3	0.0.0.0	Server 4	0.0.0.0
	Update interval	10sec		
	PROFINET interface [X1]\Digital inputs\Channel0			
	Channel address	I0.0	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel0\			
B	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49152
	Event name:	0	Hardware interrupt:	0
	Rising edge0	Rising edge0		
	PROFINET interface [X1]\Digital inputs\Channel0\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49280
	Event name:	0	Hardware interrupt:	0
	Falling edge0	Falling edge0		
	PROFINET interface [X1]\Digital inputs\Channel1			
	Channel address	I0.1	Input filters	6.4 millisec
	Enable pulse catch	0		
C	PROFINET interface [X1]\Digital inputs\Channel1\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49153
	Event name:	0	Hardware interrupt:	0
	Rising edge1	Rising edge1		
	PROFINET interface [X1]\Digital inputs\Channel1\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49281
	Event name:	0	Hardware interrupt:	0
	Falling edge1	Falling edge1		
	PROFINET interface [X1]\Digital inputs\Channel2			
	Channel address	I0.2	Input filters	6.4 millisec
D	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel2\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49154
	Event name:	0	Hardware interrupt:	0
	Rising edge2	Rising edge2		
	PROFINET interface [X1]\Digital inputs\Channel2\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49282
	Event name:	0	Hardware interrupt:	0
	Falling edge2	Falling edge2		
	Owner	Project name Automation Production Station Code		Date 7/12/2025
E	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
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A	PROFINET interface [X1]\Digital inputs\Channel3			
	Channel address	I0.3	Input filters	6.4 millisec
B	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49155
	Event name:	0	Hardware interrupt:	0
C	Rising edge3	Rising edge3		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49283
	Event name:	0	Hardware interrupt:	0
D	Falling edge3	Falling edge3		
	PROFINET interface [X1]\Digital inputs\Channel4			
	Channel address	I0.4	Input filters	6.4 millisec
	Enable pulse catch	0		
E	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49156
	Event name:	0	Hardware interrupt:	0
	Rising edge4	Rising edge4		
F	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49284
	Event name:	0	Hardware interrupt:	0
	Falling edge4	Falling edge4		
D	PROFINET interface [X1]\Digital inputs\Channel5			
	Channel address	I0.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel5\			
E	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49157
	Event name:	0	Hardware interrupt:	0
	Rising edge5	Rising edge5		
	PROFINET interface [X1]\Digital inputs\Channel5\			
F	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49285
	Event name:	0	Hardware interrupt:	0
	Falling edge5	Falling edge5		
	PROFINET interface [X1]\Digital inputs\Channel6			
G	Channel address	I0.6	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel6\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49158
H	Event name:	0	Hardware interrupt:	0
	Owner	Project name Automation Production Station Code		Date 7/12/2025
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	Designed By	Location		
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A	Rising edge6	Rising edge6		
	PROFINET interface [X1]\Digital inputs\Channel6\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49286
	Event name:	0	Hardware inter-rupt:	0
	Falling edge6	Falling edge6		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Channel address	I0.7	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49159
B	Event name:	0	Hardware inter-rupt:	0
	Rising edge7	Rising edge7		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49287
	Event name:	0	Hardware inter-rupt:	0
	Falling edge7	Falling edge7		
	PROFINET interface [X1]\Digital inputs\Channel8\			
	Channel address	I1.0	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel8\			
C	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49160
	Event name:	0	Hardware inter-rupt:	0
	Rising edge8	Rising edge8		
	PROFINET interface [X1]\Digital inputs\Channel8\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49288
	Event name:	0	Hardware inter-rupt:	0
	Falling edge8	Falling edge8		
	PROFINET interface [X1]\Digital inputs\Channel9\			
	Channel address	I1.1	Input filters	6.4 millisec
	Enable pulse catch	0		
D	PROFINET interface [X1]\Digital inputs\Channel9\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49161
	Event name:	0	Hardware inter-rupt:	0
	Rising edge9	Rising edge9		
	PROFINET interface [X1]\Digital inputs\Channel9\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49289
	Event name:	0	Hardware inter-rupt:	0
	Falling edge9	Falling edge9		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025
	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
	Operator	Location		
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A	PROFINET interface [X1]\Digital inputs\Channel10			
	Channel address	I1.2	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49162
	Event name:	0	Hardware interrupt:	0
	Rising edge10	Rising edge10		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49290
	Event name:	0	Hardware interrupt:	0
B	Falling edge10	Falling edge10		
	PROFINET interface [X1]\Digital inputs\Channel11			
	Channel address	I1.3	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49163
	Event name:	0	Hardware interrupt:	0
	Rising edge11	Rising edge11		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49291
C	Event name:	0	Hardware interrupt:	0
	Falling edge11	Falling edge11		
	PROFINET interface [X1]\Digital inputs\Channel12			
	Channel address	I1.4	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel13			
	Channel address	I1.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Analog inputs\Noise reduction			
	Integration time	50 Hz (20 ms)		
D	PROFINET interface [X1]\Analog inputs\Channel0			
	Channel address	IW64	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Analog inputs\Channel1			
	Channel address	IW66	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Digital outputs			
	Reaction to CPU STOP	Use substitute value		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
	Designed By	Location		
	Checked By	Description 1st		
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A	PROFINET interface [X1]\Digital outputs\Channel0					
	Channel address	Q0.0	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel1					
	Channel address	Q0.1	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel2					
	Channel address	Q0.2	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel3					
	Channel address	Q0.3	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel4					
	Channel address	Q0.4	Substitute a value of 1 on a change from RUN to STOP.	0		
B	PROFINET interface [X1]\Digital outputs\Channel5					
	Channel address	Q0.5	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel6					
	Channel address	Q0.6	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel7					
	Channel address	Q0.7	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel8					
	Channel address	Q1.0	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel9					
	Channel address	Q1.1	Substitute a value of 1 on a change from RUN to STOP.	0		
C	PROFINET interface [X1]\Operating mode					
	IO controller	True	IO system			
	Device number	0	IO device	False		
	PROFINET interface [X1]\I/O addresses\Input addresses					
	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Input addresses					
	Start address	64	End address	67		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Output addresses					
D	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Output addresses					
	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025		
	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code					
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A	PROFINET interface [X1]\Advanced options\Interface options			
	Support device replacement without exchangeable medium	True	Use IEC V2.2 LLDP mode	
	Keep-Alive connection monitoring:	30s		

B	PROFINET interface [X1]\Advanced options\Real time settings\IO communication		
	Send clock:	1.000ms	
	PROFINET interface [X1]\Advanced options\Real time settings\Real time options		
	Calculated bandwidth for cyclic IO data:	0.000ms	Calculated bandwidth for cyclic IO data:
	0.000%		

	PROFINET interface [X1]\Advanced options\Port [X1 P1]\General		
	Name	Port_1	Author
	Comment		
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Local port:		
	Local port:	PLC_1\PROFINET interface_1 [X1]\Port_1 [X1 P1]	Medium:
	Cable name:	---	Copper



	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Partner port:		
	Monitoring of partner port is not possible	Partner port:	Any partner

	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Activate		
	Activate this port for use	True	

D	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Connection		
	Transmission rate / duplex:	Automatic	Monitor
	Enable autonegotiation	True	False

	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Boundaries		
	End of detection of accessible devices	False	End of topology discovery
	End of the sync domain	False	False

E	High speed counters (HSC)\HSC1\General\Enable		
	Enable this high speed counter	0	Enable this high speed counter
	Enable this high speed counter	0	Enable this high speed counter
	Enable this high speed counter	0	Enable this high speed counter
	High speed counters (HSC)\HSC1\General\Project information		
	Name	HSC_1	Comment

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A	Name	HSC_2	Comment	
	Name	HSC_3	Comment	
	Name	HSC_4	Comment	
	Name	HSC_5	Comment	
	Name	HSC_6	Comment	
	High speed counters (HSC)\HSC1\I/O addresses\Input addresses			
B	Start address	1000.0	End address	1003.7
	Start address	1004.0	End address	1007.7
	Organization block	0	Start address	1008.0
	End address	1011.7	Organization block	0
	Process image	0	Start address	1012.0
	End address	1015.7	Organization block	0
	Process image	0	Start address	1016.0
	End address	1019.7	Organization block	0
	Process image	0	Start address	1020.0
	End address	1023.7	Organization block	0
	Process image	0	Organization block	0
	Process image	0	Process image	0
C	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Enable			
	Enable this pulse generator	0	Enable this pulse generator	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Project information			
	Name	Pulse_1	Comment	
	Name	Pulse_2	Comment	
	Pulse generators (PTO/PWM)\PTO1/PWM1\I/O addresses\Output addresses			
D	Start address	1000.0	End address	1001.7
	Start address	1002.0	End address	1003.7
	Organization block	0	Organization block	0
	Process image	0	Process image	0
	Startup			
	Startup after POWER ON	Warm restart - mode before POWER OFF	Comparison preset to actual configuration	Startup CPU even if mismatch
	Configuration time	60000ms	OBs should be interruptible	1
	Cycle			
	Cycle monitoring time	150ms		
	Enable minimum cycle time for cyclic OBs	0	Minimum cycle time	1ms
	Communication load			
	Cycle load due to communication	20%		
E	System and clock memory\System memory bits			
	Enable the use of system memory byte	1	Address of system memory byte (MBx)	1
	First cycle	%M1.0 (FirstScan)	Diagnostic status changed	%M1.1 (DiagStatusUpdate)
	Always 1 (high)	%M1.2 (AlwaysTRUE)	Always 0 (low)	%M1.3 (AlwaysFALSE)

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System and clock memory\Clock memory bits			
Enable the use of clock memory byte	1	Address of clock memory byte (MBx)	0
10 Hz clock	%M0.0 (Clock_10Hz)	5 Hz clock	%M0.1 (Clock_5Hz)
2.5 Hz clock	%M0.2 (Clock_2.5Hz)	2 Hz clock	%M0.3 (Clock_2Hz)
1.25 Hz clock	%M0.4 (Clock_1.25Hz)	1 Hz clock	%M0.5 (Clock_1Hz)
0.625 Hz clock	%M0.6 (Clock_0.625Hz)	0.5 Hz clock	%M0.7 (Clock_0.5Hz)
Web server\General			
Activate web server on this module	False	Permit access only with HTTPS	True
Web server\Automatic update			
Enable automatic update	True	Update interval	0s
Web server\User interface languages			
Assign project language		User interface languages	
English (United States)		German	
English (United States)		English	
English (United States)		French	
English (United States)		Spanish	
English (United States)		Italian	
English (United States)		Chinese (simplified)	
Web server\User management			
User name		User rights	
Everybody			
Web server\User-defined web pages			
Application name	HTML source path	Default HTML page	Files with dynamic content
		index.htm	.htm;.html
			333
			334
User interface languages			
Assign project language		User interface languages	
English (United States)		German	
English (United States)		English	
English (United States)		French	
English (United States)		Spanish	
English (United States)		Italian	
English (United States)		Chinese (simplified)	
Time of day\Local time			
Time zone	(UTC +01:00) Berlin, Bern, Brussels, Rome, Stockholm, Vienna		
Time of day\Daylight saving time			
Activate daylight saving time	1	Difference between standard and daylight saving time	60mins
Time of day\Daylight saving time\Start of daylight saving time			
Starting week of the month:	Last		Sunday
of	March	at	01:00 a.m.
Time of day\Daylight saving time\Start of standard time			
Last			Sunday
of	October	at	02:00 a.m.
Protection & Security			
Level of protection	No protection		
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A

Protection & Security\Connection mechanisms

Permit access with True
 PUT/GET communication from remote partner

Overview of addresses\Overview of addresses\Overview of addresses

Inputs	True	Outputs	True
Address gaps	False	Slot	True

B

C

D

E

F

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A	Type	I	Addr. from	0	Addr. to	1
	Module	DI 14/DQ 10_1	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 1		
	Type	O	Addr. from	0	Addr. to	1
	Module	DI 14/DQ 10_1	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
B	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 1		
	Type	I	Addr. from	64	Addr. to	67
	Module	AI 2_1	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 2		
C	Type	I	Addr. from	1000	Addr. to	1003
	Module	HSC_1	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 16		
	Type	I	Addr. from	1004	Addr. to	1007
	Module	HSC_2	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
D	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 17		
	Type	I	Addr. from	1008	Addr. to	1011
	Module	HSC_3	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 18		
E	Type	I	Addr. from	1012	Addr. to	1015
	Module	HSC_4	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 19		
	Type	I	Addr. from	1016	Addr. to	1019
	Module	HSC_5	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
F	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 20		
	Type	I	Addr. from	1020	Addr. to	1023
	Module	HSC_6	PIP	Automatic update	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-

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A	Rack	0	Slot	1 21	Addr. to	1001
	Type	O	Addr. from	1000	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Module	Pulse_1	PIP	Automatic update	Master / IO system	-
	Device number	-	Size	2 Bytes		
B	Rack	0	Slot	1 32	Addr. to	1003
	Type	O	Addr. from	1002	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Module	Pulse_2	PIP	Automatic update	Master / IO system	-
	Device number	-	Size	2 Bytes		
C	Rack	0	Slot	1 33	Addr. to	1005
	Type	O	Addr. from	1004	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Module	Pulse_3	PIP	Automatic update	Master / IO system	-
	Device number	-	Size	2 Bytes		
D	Rack	0	Slot	1 34	Addr. to	1007
	Type	O	Addr. from	1006	Device name	PLC_1 [CPU 1214C DC/DC/DC]
	Module	Pulse_4	PIP	Automatic update	Master / IO system	-
	Device number	-	Size	2 Bytes		
E	Rack	0	Slot	1 35		

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A

Automation Production Station Code

PLC_2 [CPU 1214C DC/DC/DC]

PLC_2			
General\Project information			
Name	PLC_2	Author	MTC-MECH-05
Comment		Slot	1
Rack	0		
General\Catalog information			
Short designation	CPU 1214C DC/DC/DC	Description	Work memory 75 KB; 24VDC power supply with DI14 x 24VDC SINK/SOURCE, DQ10 x 24VDC and AI2 on board; 6 high-speed counters and 4 pulse outputs on board; signal board expands on-board I/O; up to 3 communication modules for serial communication; up to 8 signal modules for I/O expansion; PROFINET interface for programming, HMI and PLC-to-PLC communication
Article number	6ES7 214-1AG40-0XB0	Firmware version	V4.0
General\Identification & Maintenance			
Plant designation		Location identifier	
Installation date	2025-06-11 05:57:39.105	Additional information	
Connection resources			
PG communication:	1	OP communication:	1
S7 basic communication:	0	S7 communication:	0
Maximum number of S7 connection resources:	38		
PROFINET interface [X1]\General			
Name	PROFINET interface_1	Author	MTC-MECH-05
Comment			
PROFINET interface [X1]\General\Project information			
Name	DI 14/DQ 10_1	Comment	
Name	AI 2_1	Comment	
PROFINET interface [X1]\Ethernet addresses\Interface networked with			
Subnet:	PN/IE_1		
PROFINET interface [X1]\Ethernet addresses\IP protocol			
IP configuration	Set IP address in the project	IP address:	192.168.0.2
Subnet mask:	255.255.255.0	Use router	False
PROFINET interface [X1]\Ethernet addresses\PROFINET			
PROFINET device name is set directly at the device	False	Generate PROFINET device name automatically	True
PROFINET device name:	plc_2	Converted name:	plcxb2d1ad
Device number:	0		

B

C

D

E

F

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A	PROFINET interface [X1]\Time synchronization			
	Enable time synchronization via NTP server	Enable time synchronization via NTP server		IP addresses
	Server 1	0.0.0.0	Server 2	0.0.0.0
	Server 3	0.0.0.0	Server 4	0.0.0.0
	Update interval	10sec		
	PROFINET interface [X1]\Digital inputs\Channel0			
	Channel address	I0.0	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel0\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49152
B	Event name:	0	Hardware interrupt:	0
	Rising edge0	Rising edge0		
	PROFINET interface [X1]\Digital inputs\Channel0\			
C	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49280
	Event name:	0	Hardware interrupt:	0
	Falling edge0	Falling edge0		
D	PROFINET interface [X1]\Digital inputs\Channel1			
	Channel address	I0.1	Input filters	6.4 millisec
	Enable pulse catch	0		
E	PROFINET interface [X1]\Digital inputs\Channel1\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49153
	Event name:	0	Hardware interrupt:	0
F	Rising edge1	Rising edge1		
	PROFINET interface [X1]\Digital inputs\Channel1\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49281
G	Event name:	0	Hardware interrupt:	0
	Falling edge1	Falling edge1		
	PROFINET interface [X1]\Digital inputs\Channel2			
H	Channel address	I0.2	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel2\			
I	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49154
	Event name:	0	Hardware interrupt:	0
	Rising edge2	Rising edge2		
J	PROFINET interface [X1]\Digital inputs\Channel2\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49282
	Event name:	0	Hardware interrupt:	0
K	Falling edge2	Falling edge2		
	Project Information			
	Owner	Project name	Automation Production Station Code	Date 7/12/2025
L	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
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A	PROFINET interface [X1]\Digital inputs\Channel3			
	Channel address	I0.3	Input filters	6.4 millisec
B	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49155
	Event name:	0	Hardware interrupt:	0
C	Rising edge3	Rising edge3		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49283
	Event name:	0	Hardware interrupt:	0
D	Falling edge3	Falling edge3		
	PROFINET interface [X1]\Digital inputs\Channel4			
	Channel address	I0.4	Input filters	6.4 millisec
	Enable pulse catch	0		
E	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49156
	Event name:	0	Hardware interrupt:	0
	Rising edge4	Rising edge4		
F	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49284
	Event name:	0	Hardware interrupt:	0
	Falling edge4	Falling edge4		
D	PROFINET interface [X1]\Digital inputs\Channel5			
	Channel address	I0.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel5\			
E	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49157
	Event name:	0	Hardware interrupt:	0
	Rising edge5	Rising edge5		
	PROFINET interface [X1]\Digital inputs\Channel5\			
F	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49285
	Event name:	0	Hardware interrupt:	0
	Falling edge5	Falling edge5		
	PROFINET interface [X1]\Digital inputs\Channel6			
G	Channel address	I0.6	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel6\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49158
H	Event name:	0	Hardware interrupt:	0
	Owner	Project name Automation Production Station Code		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
	Designed By	Location		
I	Checked By	Description 1st		
	Approved By	1st View	Language en-US	Version
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A	Rising edge6	Rising edge6		
	PROFINET interface [X1]\Digital inputs\Channel6\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49286
	Event name:	0	Hardware inter-rupt:	0
	Falling edge6	Falling edge6		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Channel address	I0.7	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49159
B	Event name:	0	Hardware inter-rupt:	0
	Rising edge7	Rising edge7		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49287
	Event name:	0	Hardware inter-rupt:	0
	Falling edge7	Falling edge7		
	PROFINET interface [X1]\Digital inputs\Channel8\			
	Channel address	I1.0	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel8\			
C	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49160
	Event name:	0	Hardware inter-rupt:	0
	Rising edge8	Rising edge8		
	PROFINET interface [X1]\Digital inputs\Channel8\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49288
	Event name:	0	Hardware inter-rupt:	0
	Falling edge8	Falling edge8		
	PROFINET interface [X1]\Digital inputs\Channel9\			
	Channel address	I1.1	Input filters	6.4 millisec
	Enable pulse catch	0		
D	PROFINET interface [X1]\Digital inputs\Channel9\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49161
	Event name:	0	Hardware inter-rupt:	0
	Rising edge9	Rising edge9		
	PROFINET interface [X1]\Digital inputs\Channel9\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49289
	Event name:	0	Hardware inter-rupt:	0
	Falling edge9	Falling edge9		
E	Owner	Project name	Automation Production Station Code	Date 7/12/2025
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location		
	Checked By	Description 1st		
	Approved By	Description 2nd	Language	en-US
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A	PROFINET interface [X1]\Digital inputs\Channel10			
	Channel address	I1.2	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49162
	Event name:	0	Hardware interrupt:	0
	Rising edge10	Rising edge10		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49290
	Event name:	0	Hardware interrupt:	0
B	Falling edge10	Falling edge10		
	PROFINET interface [X1]\Digital inputs\Channel11			
	Channel address	I1.3	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49163
	Event name:	0	Hardware interrupt:	0
	Rising edge11	Rising edge11		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49291
C	Event name:	0	Hardware interrupt:	0
	Falling edge11	Falling edge11		
	PROFINET interface [X1]\Digital inputs\Channel12			
	Channel address	I1.4	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel13			
	Channel address	I1.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Analog inputs\Noise reduction			
	Integration time	50 Hz (20 ms)		
D	PROFINET interface [X1]\Analog inputs\Channel0			
	Channel address	IW64	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Analog inputs\Channel1			
	Channel address	IW66	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Digital outputs			
	Reaction to CPU STOP	Use substitute value		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
	Designed By	Location		
	Checked By	Description 1st		
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A	PROFINET interface [X1]\Digital outputs\Channel0					
	Channel address	Q0.0	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel1					
	Channel address	Q0.1	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel2					
	Channel address	Q0.2	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel3					
	Channel address	Q0.3	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel4					
	Channel address	Q0.4	Substitute a value of 1 on a change from RUN to STOP.	0		
B	PROFINET interface [X1]\Digital outputs\Channel5					
	Channel address	Q0.5	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel6					
	Channel address	Q0.6	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel7					
	Channel address	Q0.7	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel8					
	Channel address	Q1.0	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel9					
	Channel address	Q1.1	Substitute a value of 1 on a change from RUN to STOP.	0		
C	PROFINET interface [X1]\Operating mode					
	IO controller	True	IO system			
	Device number	0	IO device	False		
	PROFINET interface [X1]\I/O addresses\Input addresses					
	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Input addresses					
	Start address	64	End address	67		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Output addresses					
D	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Output addresses					
	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025		
	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code					
	Location					
	Designed By	Description 1st				
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A	PROFINET interface [X1]\Advanced options\Interface options		
	Support device replacement without exchangeable medium:	True	Use IEC V2.2 LLDP mode
	Keep-Alive connection monitoring:	30s	
	PROFINET interface [X1]\Advanced options\Real time settings\IO communication		
	Send clock:	1.000ms	
B	PROFINET interface [X1]\Advanced options\Real time settings\Real time options		
	Calculated bandwidth for cyclic IO data:	0.000ms	Calculated bandwidth for cyclic IO data:
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\General		
	Name	Port_1	Author
	Comment		
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Local port:		
	Local port:	PLC_2\PROFINET interface_1 [X1]\Port_1 [X1 P1]	Medium:
	Cable name:	---	Copper
			
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Partner port:		
		Monitoring of partner port is not possible	Partner port:
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Activate		
	Activate this port for use	True	
D	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Connection		
	Transmission rate / duplex:	Automatic	Monitor
	Enable autonegotiation	True	False
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Boundaries		
	End of detection of accessible devices	False	End of topology discovery
	End of the sync domain	False	False
E	High speed counters (HSC)\HSC1\General\Enable		
	Enable this high speed counter	0	Enable this high speed counter
	Enable this high speed counter	0	Enable this high speed counter
	Enable this high speed counter	0	Enable this high speed counter
	High speed counters (HSC)\HSC1\General\Project information		
	Name	HSC_1	Comment
F	Owner	Project name	Automation Production Station Code
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code
	Designed By	Description 1st	
	Checked By	Description 2nd	Language
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A	Name	HSC_2	Comment	
	Name	HSC_3	Comment	
	Name	HSC_4	Comment	
	Name	HSC_5	Comment	
	Name	HSC_6	Comment	
	High speed counters (HSC)\HSC1\I/O addresses\Input addresses			
B	Start address	1000.0	End address	1003.7
	Start address	1004.0	End address	1007.7
	Organization block	0	Start address	1008.0
	End address	1011.7	Organization block	0
	Process image	0	Start address	1012.0
	End address	1015.7	Organization block	0
	Process image	0	Start address	1016.0
	End address	1019.7	Organization block	0
	Process image	0	Start address	1020.0
	End address	1023.7	Organization block	0
C	Process image	0	Organization block	0
	Process image	0	Process image	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Enable			
	Enable this pulse generator	0	Enable this pulse generator	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Project information			
	Name	Pulse_1	Comment	
	Name	Pulse_2	Comment	
	Pulse generators (PTO/PWM)\PTO1/PWM1\I/O addresses\Output addresses			
	Start address	1000.0	End address	1001.7
	Start address	1002.0	End address	1003.7
D	Organization block	0	Organization block	0
	Process image	0	Process image	0
	Startup			
	Startup after POWER ON	Warm restart - mode before POWER OFF	Comparison preset to actual configuration	Startup CPU even if mismatch
	Configuration time	60000ms	OBs should be interruptible	1
	Cycle			
	Cycle monitoring time	150ms		
	Enable minimum cycle time for cyclic OBs	0	Minimum cycle time	1ms
	Communication load			
	Cycle load due to communication	20%		
E	System and clock memory\System memory bits			
	Enable the use of system memory byte	1	Address of system memory byte (MBx)	1
	First cycle	%M1.0 (FirstScan)	Diagnostic status changed	%M1.1 (DiagStatusUpdate)
	Always 1 (high)	%M1.2 (Tag_1)	Always 0 (low)	%M1.3 (AlwaysFALSE)
F	Owner	Project name Automation Production Station Code		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
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A	System and clock memory\Clock memory bits					
	Enable the use of clock memory byte	1	Address of clock memory byte (MBx)			
	10 Hz clock	%M0.0 (Clock_10Hz)	5 Hz clock			
	2.5 Hz clock	%M0.2 (Clock_2.5Hz)	2 Hz clock			
	1.25 Hz clock	%M0.4 (Clock_1.25Hz)	1 Hz clock			
	0.625 Hz clock	%M0.6 (Clock_0.625Hz)	0.5 Hz clock			
B	Web server\General					
	Activate web server on this module	False	Permit access only with HTTPS			
	Web server\Automatic update					
	Enable automatic update	True	Update interval			
C	Web server\User interface languages					
	Assign project language		User interface languages			
	English (United States)		German			
	English (United States)		English			
	English (United States)		French			
	English (United States)		Spanish			
	English (United States)		Italian			
	English (United States)		Chinese (simplified)			
D	Web server\User management					
	User name		User rights			
	Everybody					
E	Web server\User-defined web pages					
	Application name	HTML source path	Default HTML page	Files with dynamic content	Web DB number	Fragment DB number
			index.htm	.htm;.html	333	334
F	User interface languages					
	Assign project language		User interface languages			
	English (United States)		German			
	English (United States)		English			
	English (United States)		French			
	English (United States)		Spanish			
	English (United States)		Italian			
	English (United States)		Chinese (simplified)			
	Time of day\Local time					
	Time zone	(UTC +01:00) Berlin, Bern, Brussels, Rome, Stockholm, Vienna				
	Time of day\Daylight saving time					
	Activate daylight saving time	1	Difference between standard and daylight saving time			
			60mins			
	Time of day\Daylight saving time\Start of daylight saving time					
	Starting week of the month:	Last	Sunday			
	of	March	at 01:00 a.m.			
	Time of day\Daylight saving time\Start of standard time					
	Last		Sunday			
	of	October	at 02:00 a.m.			
	Protection & Security					
	Level of protection	No protection				
	Owner	Project name	Automation Production Station Code	Date	7/12/2025	
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
	Designed By	Location				
	Checked By	Description 1st	Description 2nd	Language	en-US	
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A

Protection & Security\Connection mechanisms

Permit access with True
 PUT/GET communication from remote partner

Overview of addresses\Overview of addresses\Overview of addresses

Inputs	True	Outputs	True
Address gaps	False	Slot	True

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
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A	Type	I	Addr. from	0	Addr. to	1
	Module	DI 14/DQ 10_1	PIP	Automatic update	Device name	PLC_2 [CPU 1214C DC/DC/DC]
B	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 1	Addr. to	1
C	Type	O	Addr. from	0	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Module	DI 14/DQ 10_1	PIP	Automatic update	Master / IO system	-
D	Device number	-	Size	2 Bytes	Addr. to	67
	Rack	0	Slot	1 1	Device name	PLC_2 [CPU 1214C DC/DC/DC]
E	Type	I	Addr. from	64	Master / IO system	-
	Module	AI 2_1	PIP	Automatic update	Addr. to	1003
F	Device number	-	Size	4 Bytes	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Rack	0	Slot	1 2	Master / IO system	-
G	Type	I	Addr. from	1000	Addr. to	1007
	Module	HSC_1	PIP	Automatic update	Device name	PLC_2 [CPU 1214C DC/DC/DC]
H	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 16	Addr. to	1007
I	Type	I	Addr. from	1004	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Module	HSC_2	PIP	Automatic update	Master / IO system	-
J	Device number	-	Size	4 Bytes	Addr. to	1007
	Rack	0	Slot	1 17	Device name	PLC_2 [CPU 1214C DC/DC/DC]
K	Type	I	Addr. from	1008	Master / IO system	-
	Module	HSC_3	PIP	Automatic update	Addr. to	1011
L	Device number	-	Size	4 Bytes	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Rack	0	Slot	1 18	Master / IO system	-
M	Type	I	Addr. from	1012	Addr. to	1015
	Module	HSC_4	PIP	Automatic update	Device name	PLC_2 [CPU 1214C DC/DC/DC]
N	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 19	Addr. to	1019
O	Type	I	Addr. from	1016	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Module	HSC_5	PIP	Automatic update	Master / IO system	-
P	Device number	-	Size	4 Bytes	Addr. to	1019
	Rack	0	Slot	1 20	Device name	PLC_2 [CPU 1214C DC/DC/DC]
Q	Type	I	Addr. from	1020	Master / IO system	-
	Module	HSC_6	PIP	Automatic update	Addr. to	1023
R	Device number	-	Size	4 Bytes	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Rack	0	Slot	1 20	Master / IO system	-

Owner	Project name Automation Production Station Code		Date 7/12/2025
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A	Rack	0	Slot	1 21	Addr. to	1001
	Type	O	Addr. from	1000	Device name	PLC_2 [CPU 1214C DC/DC/DC]
B	Module	Pulse_1	PIP	Automatic update	Master / IO system	-
	Device number	-	Size	2 Bytes	Addr. to	1003
C	Rack	0	Slot	1 32	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Type	O	Addr. from	1002	Master / IO system	-
D	Module	Pulse_2	PIP	Automatic update	Addr. to	1005
	Device number	-	Size	2 Bytes	Device name	PLC_2 [CPU 1214C DC/DC/DC]
E	Rack	0	Slot	1 33	Master / IO system	-
	Type	O	Addr. from	1004	Addr. to	1007
F	Module	Pulse_3	PIP	Automatic update	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
G	Rack	0	Slot	1 34	Addr. to	1006
	Type	O	Addr. from	1006	Device name	PLC_2 [CPU 1214C DC/DC/DC]
H	Module	Pulse_4	PIP	Automatic update	Master / IO system	-
	Device number	-	Size	2 Bytes	Addr. to	1007
I	Rack	0	Slot	1 35	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Type	O	Addr. from	1007	Master / IO system	-

Owner	Project name Automation Production Station Code		Date 7/12/2025
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A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks

AUTO 2 [FC1]

AUTO 2 Properties

General

Name	AUTO 2	Number	1
Type	FC	Language	LAD

Numbering Automatic

Information

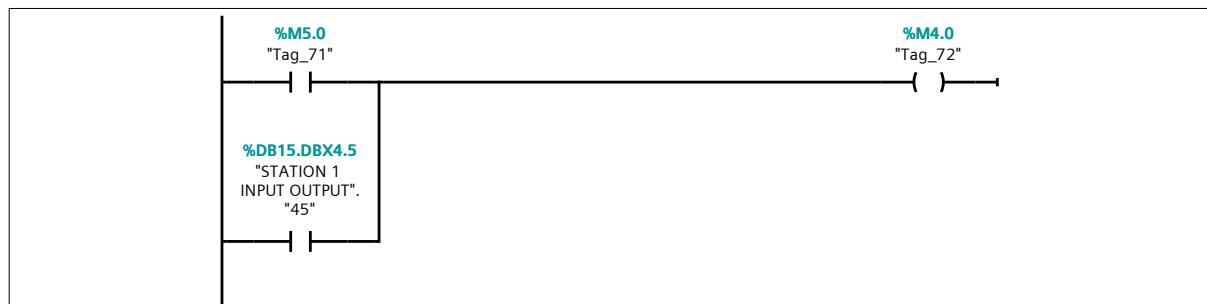
Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
AUTO 2	Void		

Network 1: START STOP LOGIC FOR MANUAL



Network 2: START STOP CONTROL FOR BOTH AUTO & MANUAL

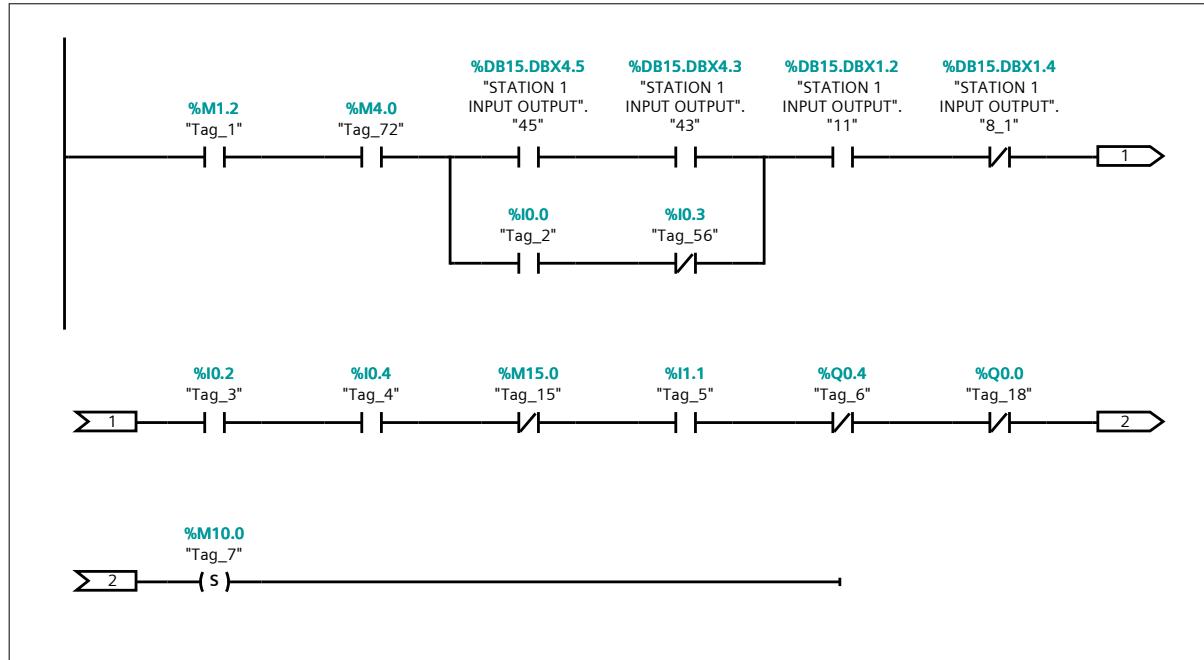


Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
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A

Network 3: CLAMPING

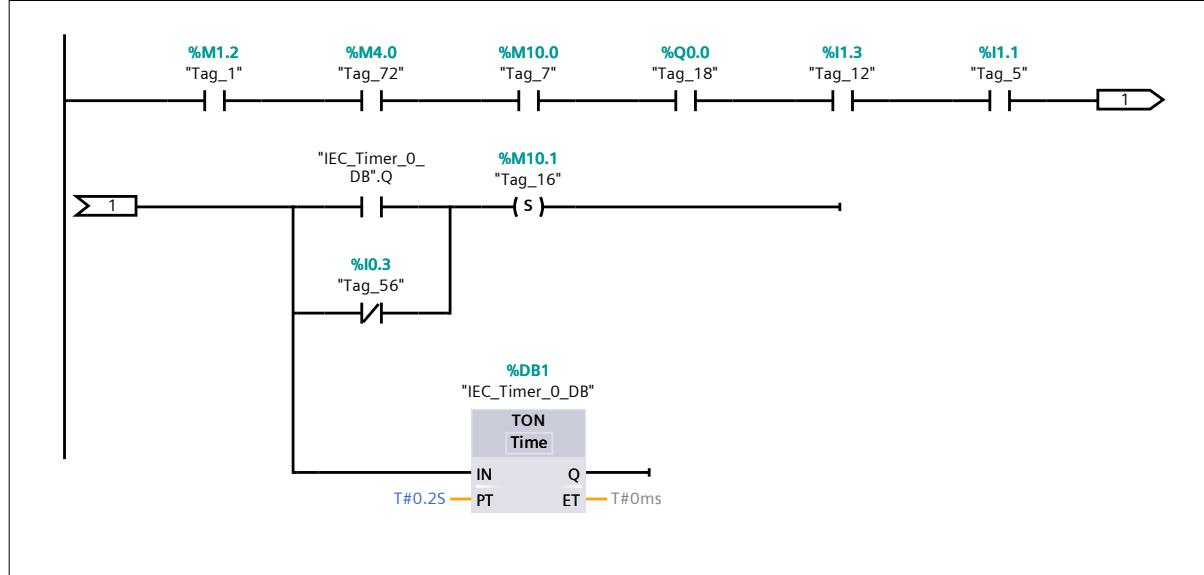
B

Network 3: CLAMPING

C

Network 4: HCM EXTEND

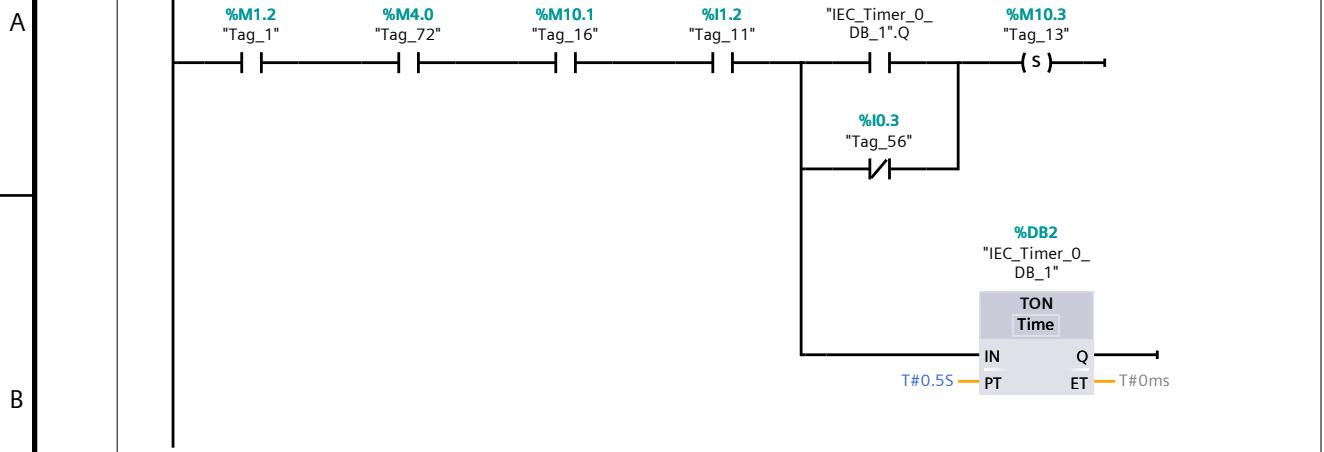
D

Network 4: HCM EXTEND

E

Network 5: HCM DOWN

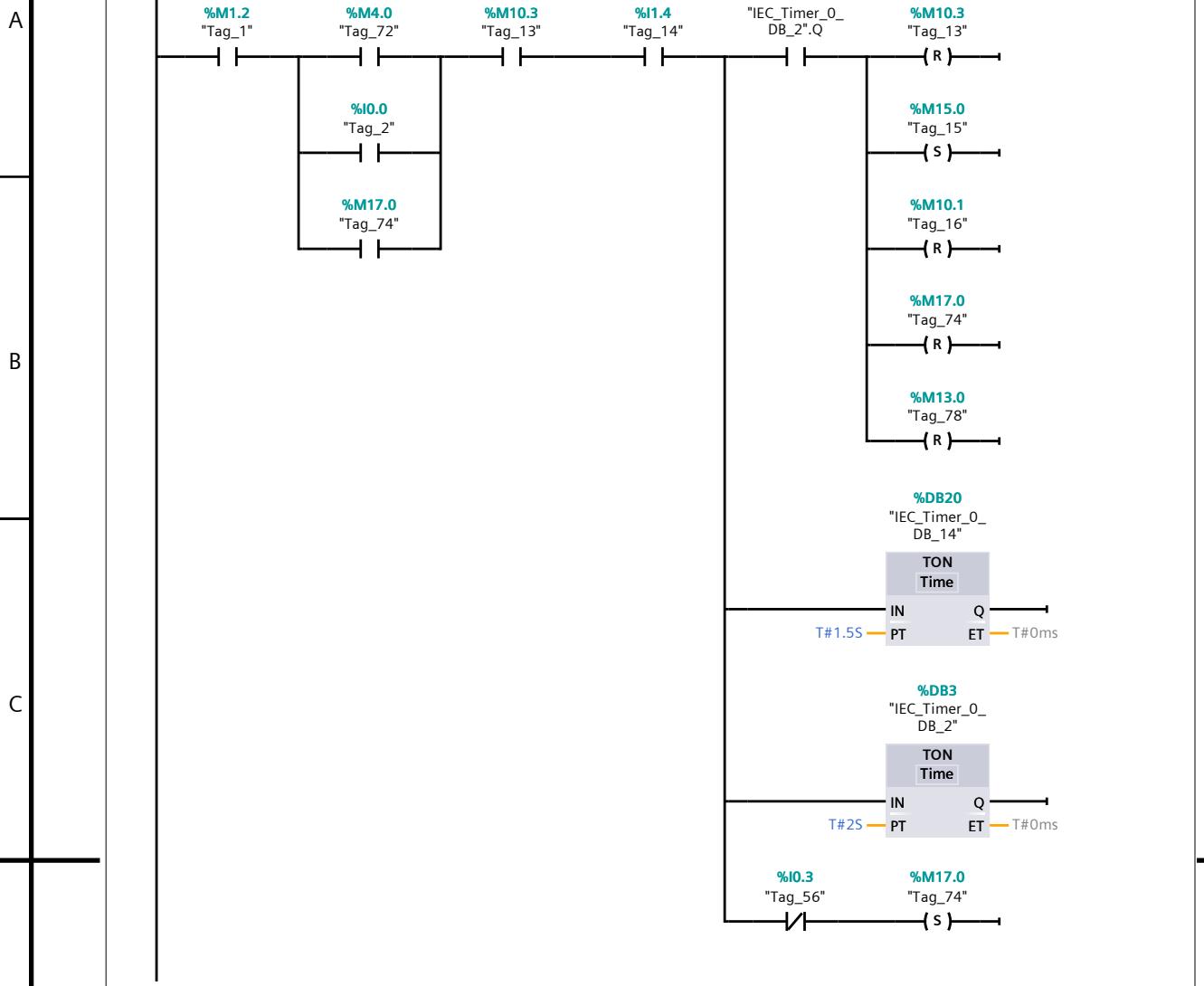
Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
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Network 6: HCM UP

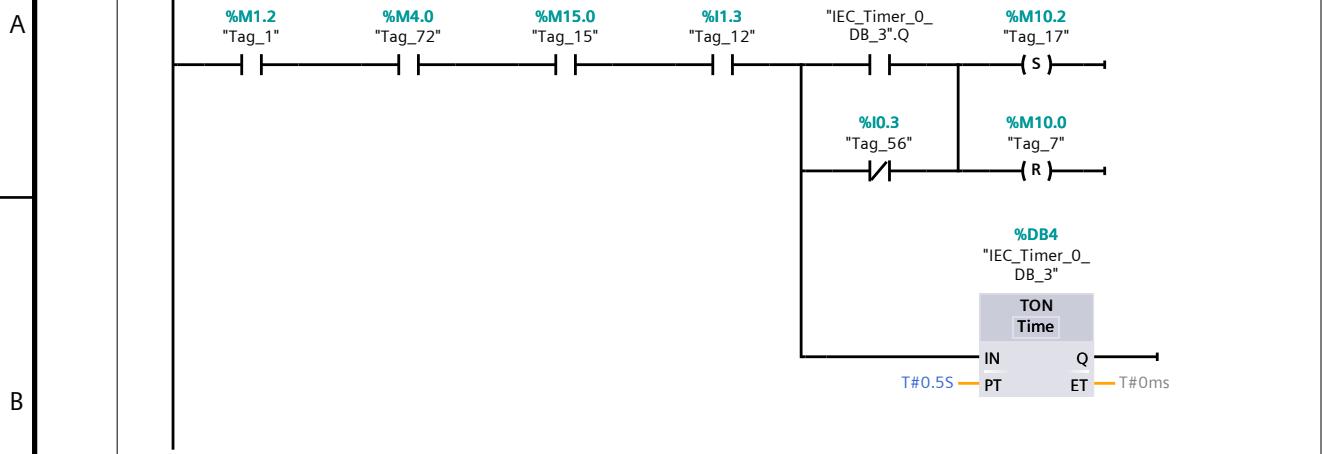
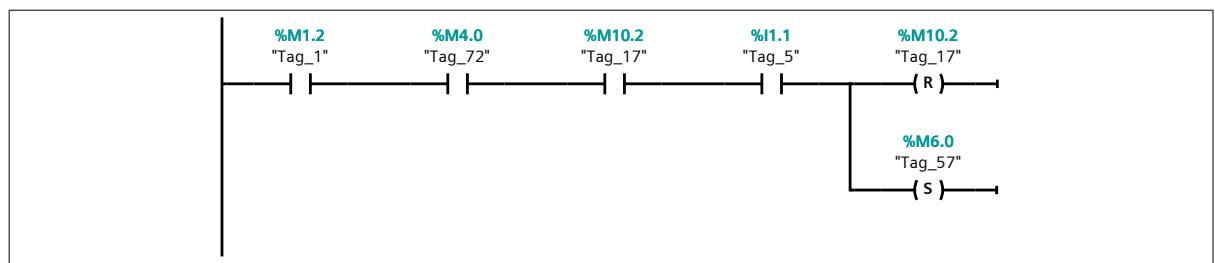
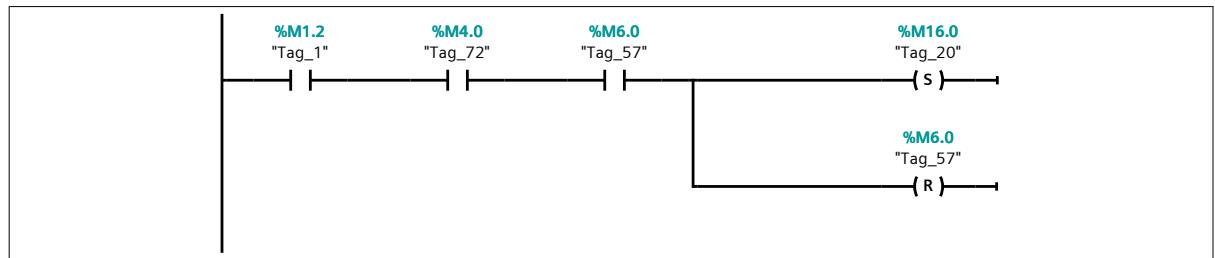


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Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
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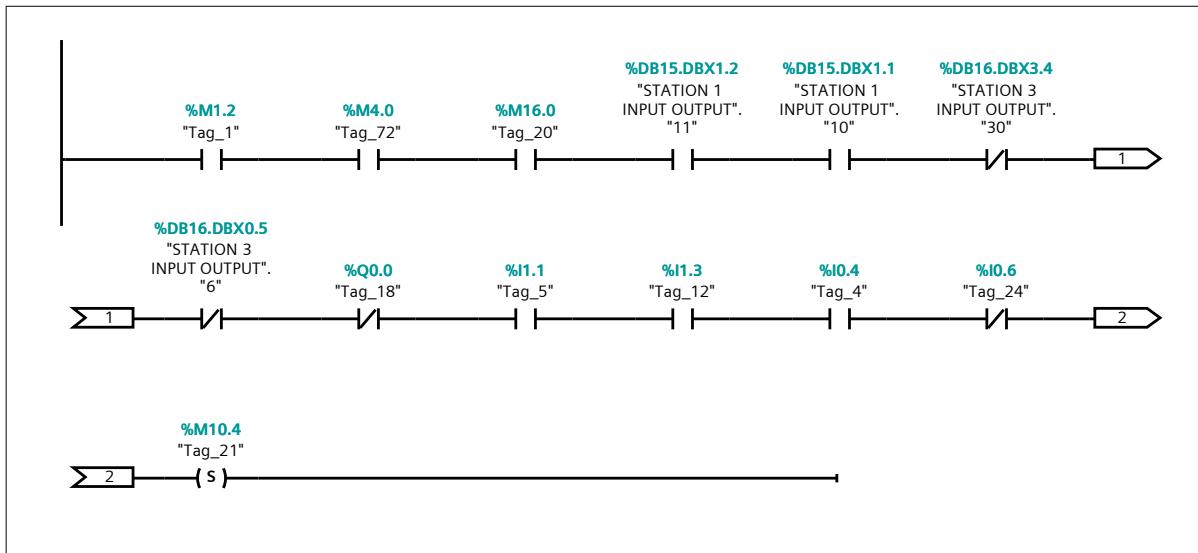
Network 7: HCM RETRACT AND CLAMPING RETRACT

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
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**Network 8: HCM HOME****Network 9: CONVEYOR****Network 10: CONVEYOR RUN**

Owner	Project name	Automation Production Station Code	Date	7/12/2025			
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code					
Location							
Designed By	Description 1st						
Checked By	Description 2nd	Language	en-US				
Approved By	1st View	Version		Sheet 43 - 5			

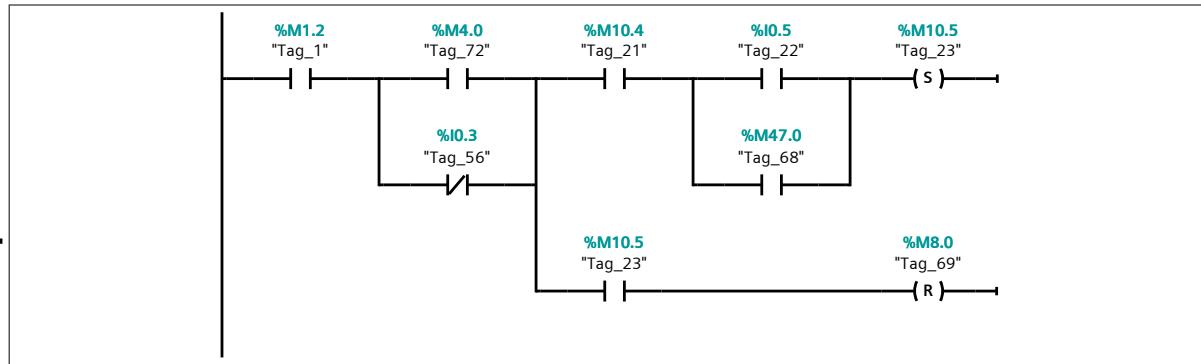
A

Network 10: CONVEYOR RUN

B

Network 11: METAL REJECTION LOGIC & RM EXTEND

C

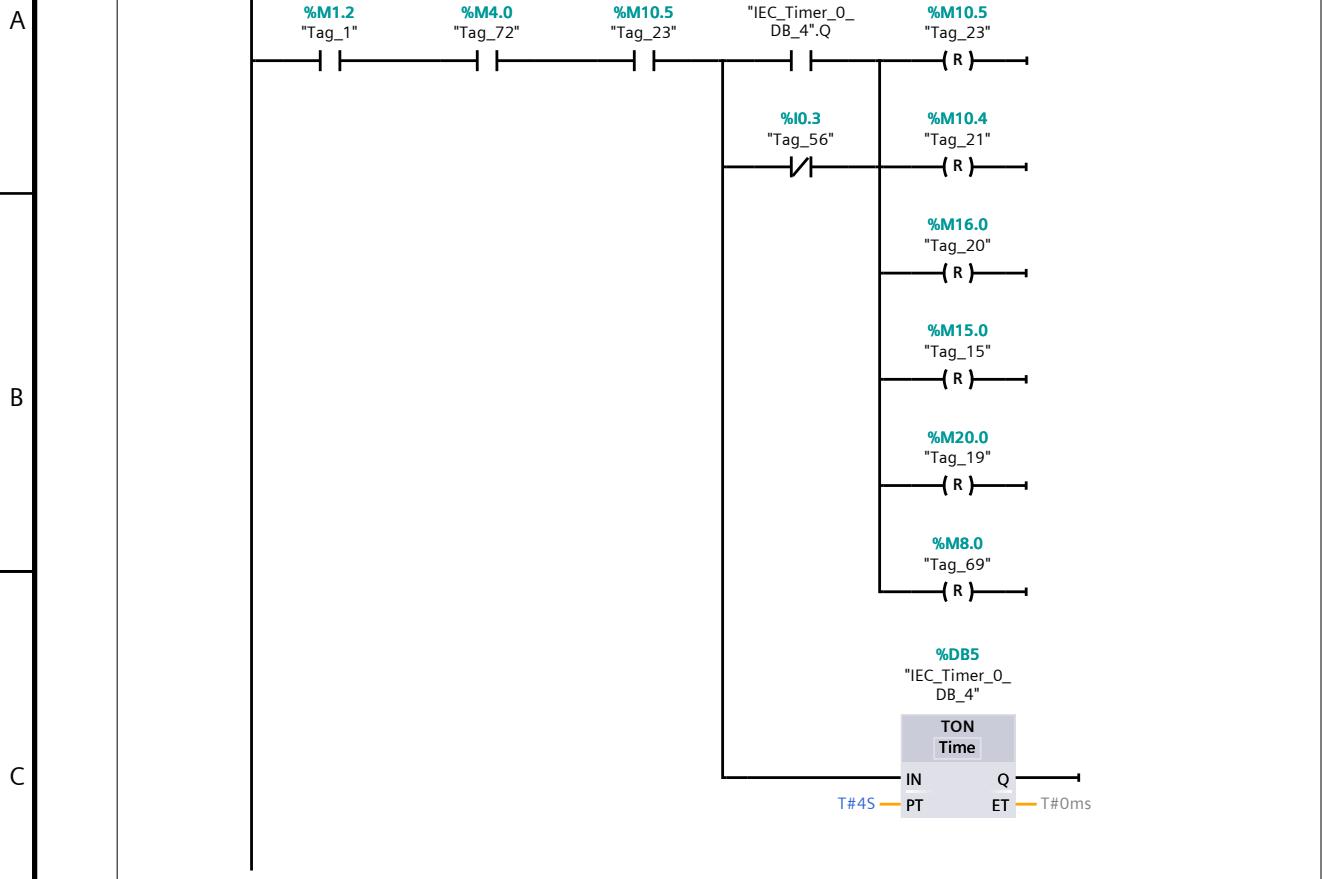


D

Network 12: RM RETRACT AND CONVEYOR STOP AFTER REJECTION

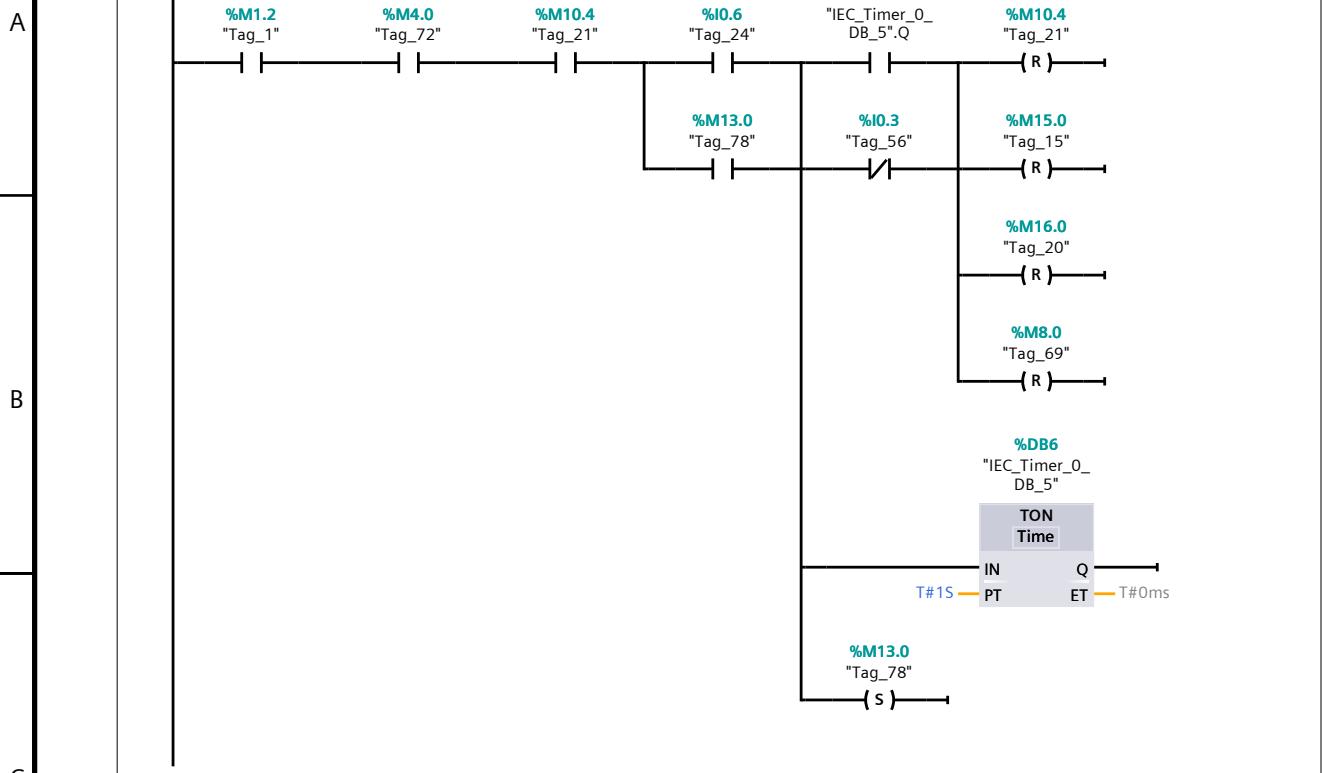
E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 43 - 6

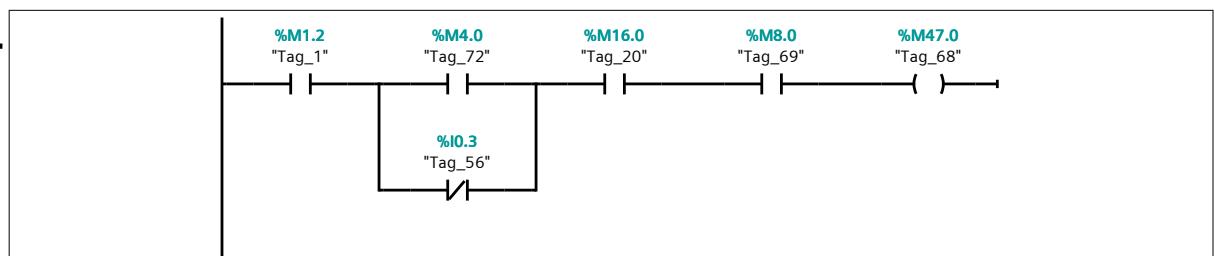


Network 13: CONVEYOR STOP AT END POSITION

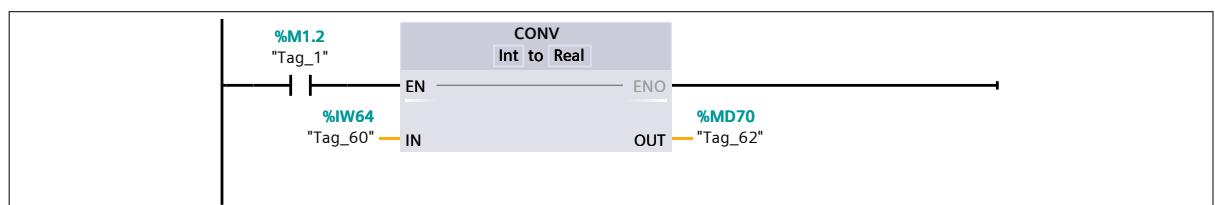
D			
E			
F	Owner: Automation Production Station Code Project path: C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Operator: Location: Designed By: Description 1st Checked By: Description 2nd Language: en-US Approved By: 1st View Version Sheet 43 - 7		



Network 14: HEIGHT CHECK PROCESS

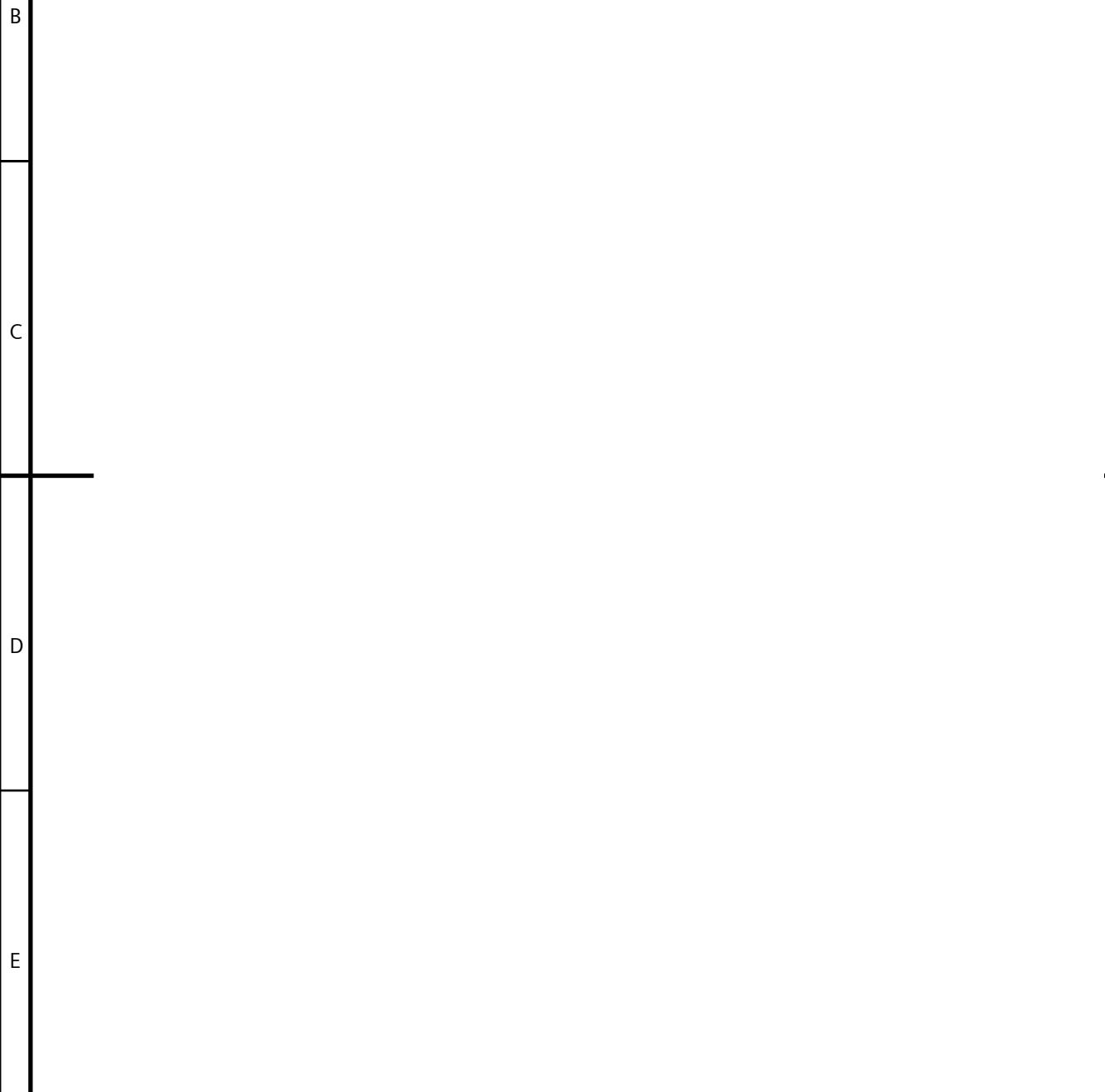
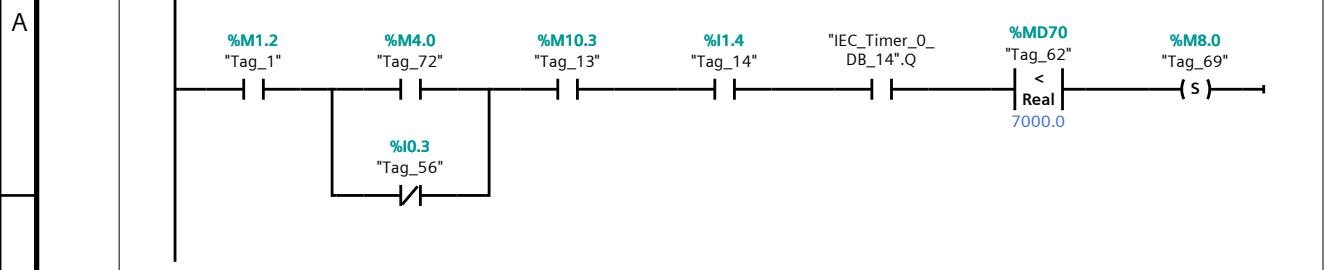


Network 15:



Network 16:

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Location			
Designed By	Description 1st		
Checked By	Description 2nd	Language en-US	
Approved By	1st View	Version	Sheet 43 - 8



F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 43 - 9

A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks

OUTPUT CALL 2 [FC2]

OUTPUT CALL 2 Properties

General

Name	OUTPUT CALL 2	Number	2
Type	FC	Language	LAD

Numbering

Information

Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
OUTPUT CALL 2	Void		

Network 1:

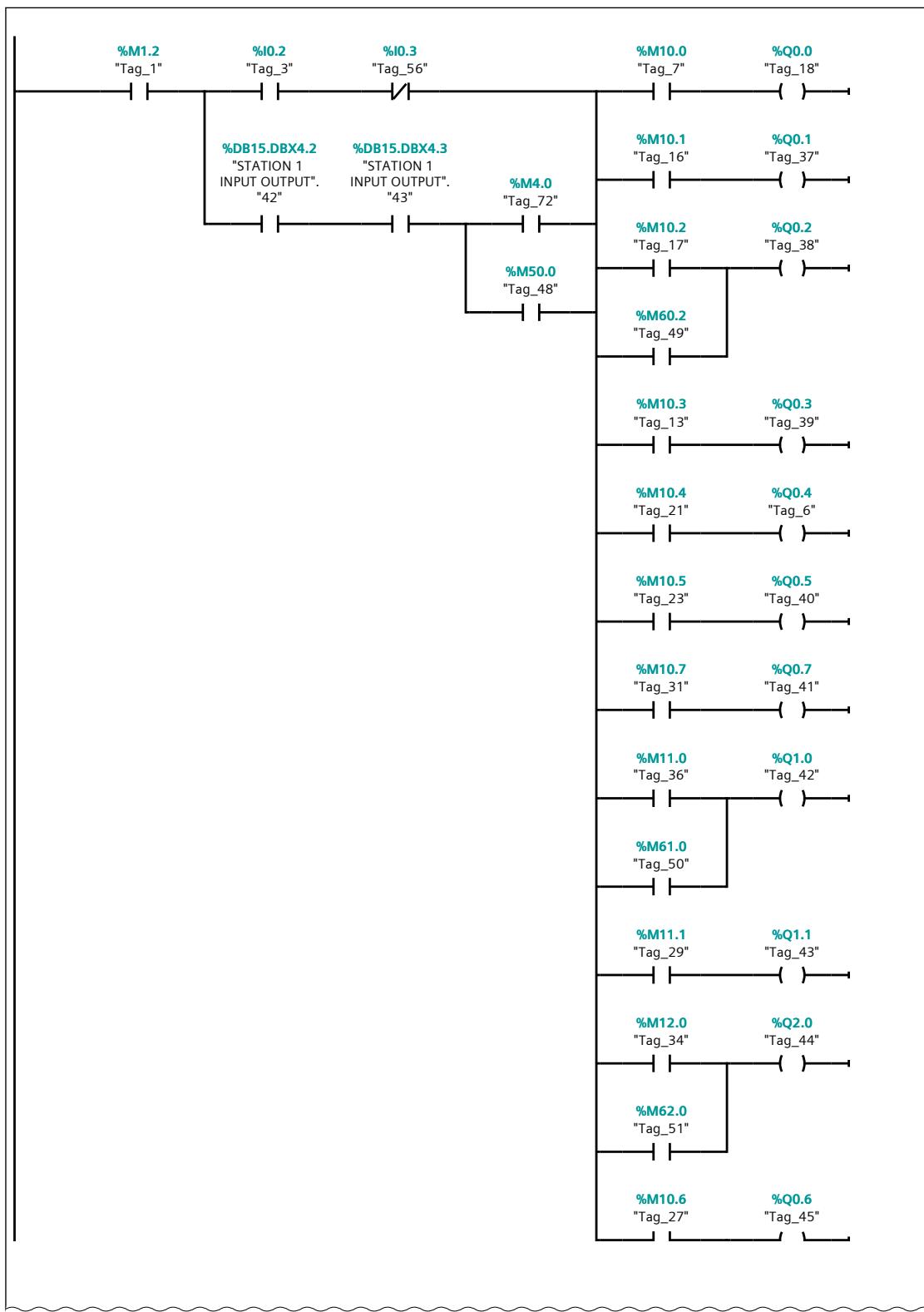
D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 44 - 1

Network 1: (1.1 / 2.1)

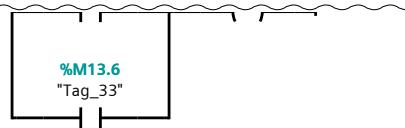


2.1 (Page44 - 3)

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 44 - 2

Network 1: (2.1 / 2.1)

1.1 (Page44 - 2)



A

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 44 - 3

A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks

ESTOP LOGIC 2 [FC3]

ESTOP LOGIC 2 Properties

General

Name	ESTOP LOGIC 2	Number	3
Type	FC	Language	LAD

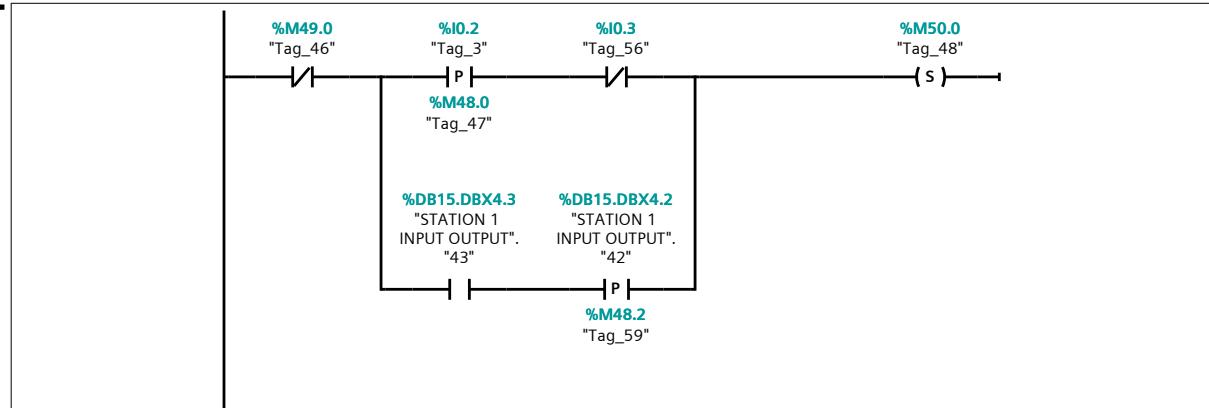
Numbering

Information

Title	Author
Comment	Family
Version	User-defined ID

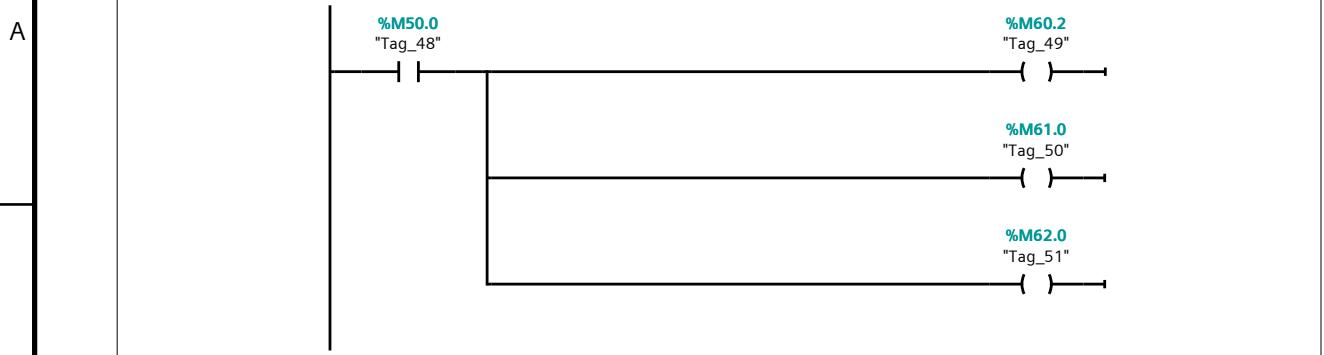
Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
ESTOP LOGIC 2	Void		

Network 1: ESTOP HOMING POSITION LOGIC



Network 2: OUTPUT CALL FOR HOMING

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 45 - 1

**Network 3: MEMORY RESET**

B

C

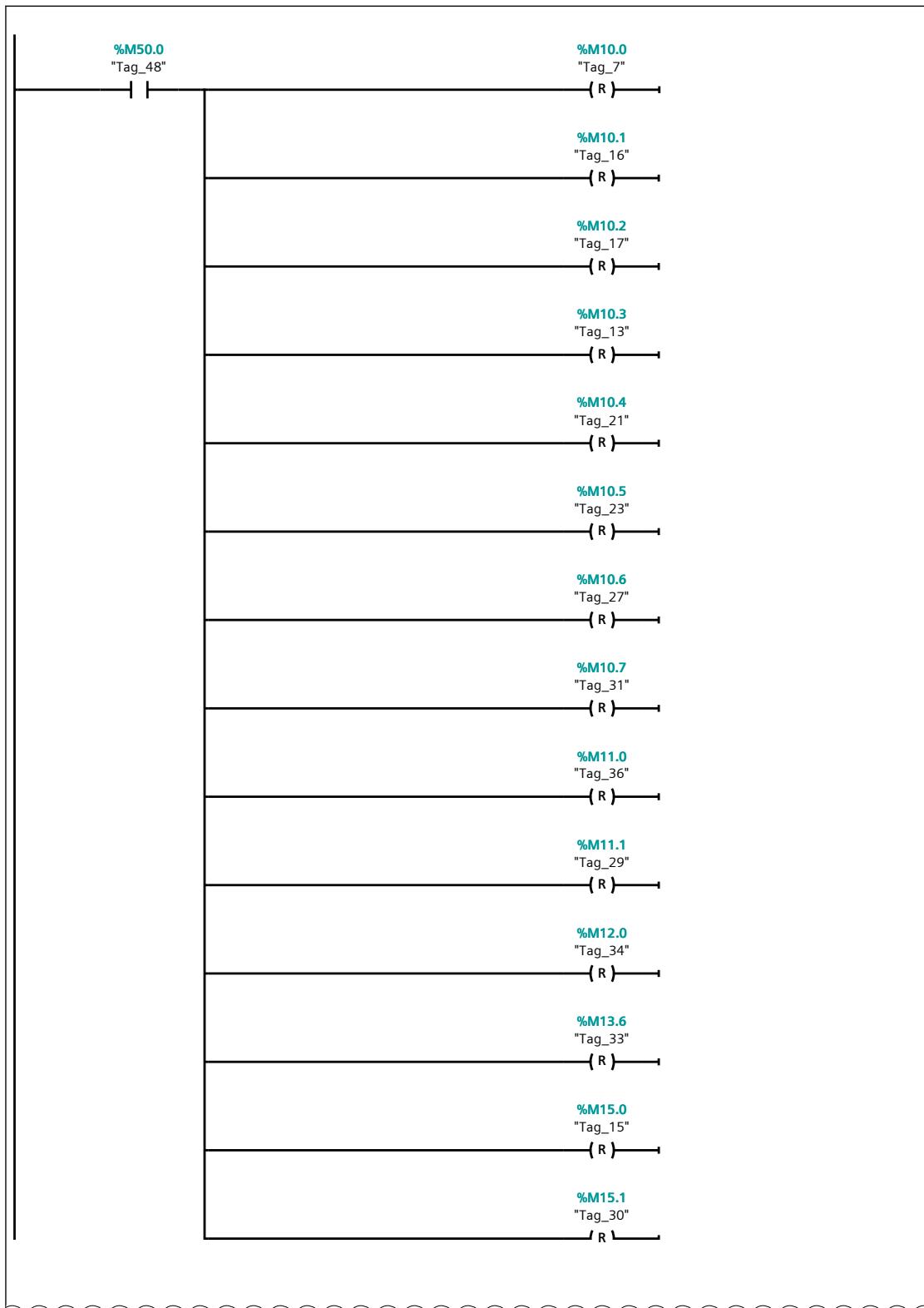
D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 45 - 2

Network 3: MEMORY RESET (1.1 / 2.1)

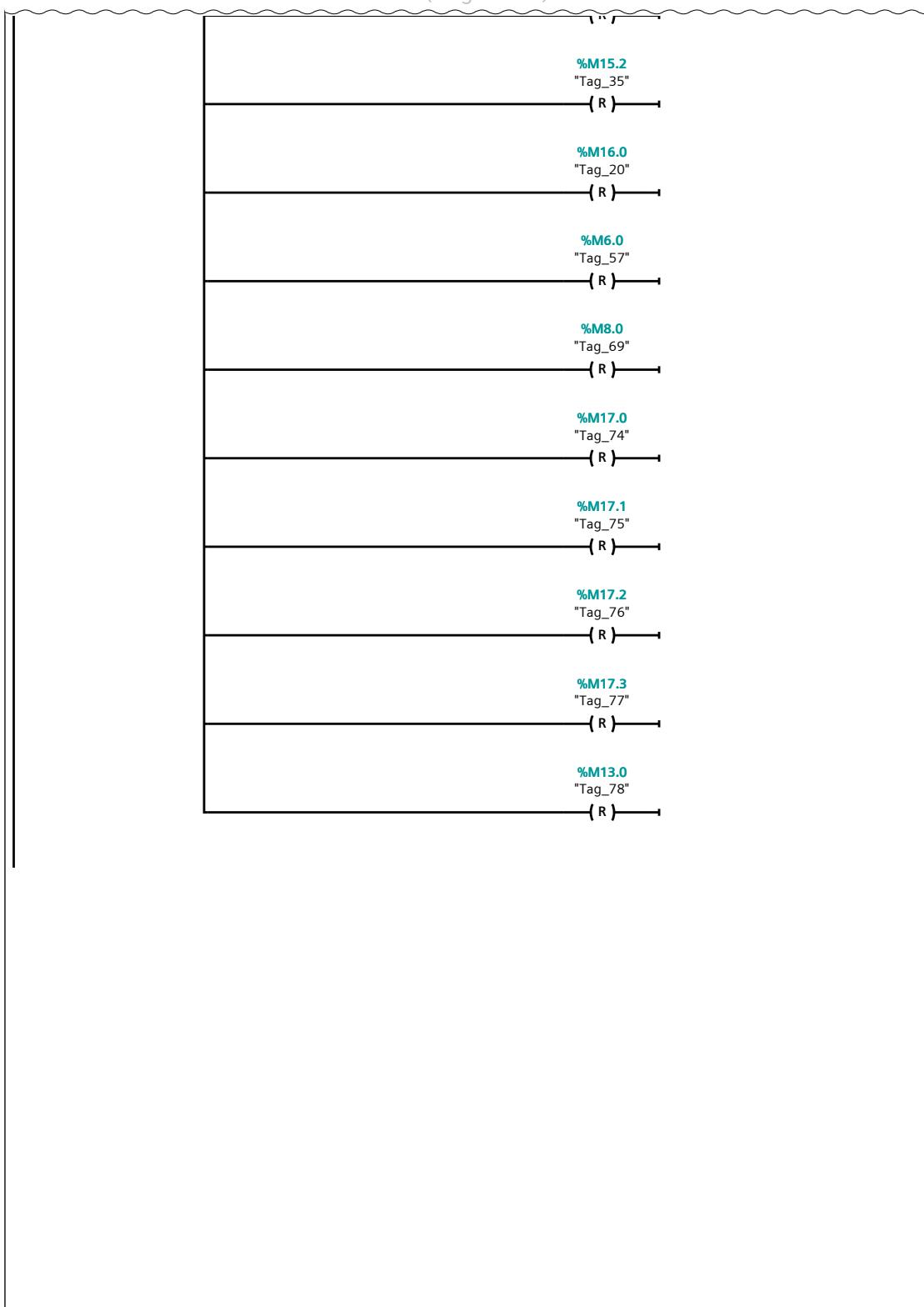


2.1 (Page45 - 4)

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	
	1st View	Version		Sheet 45 - 3

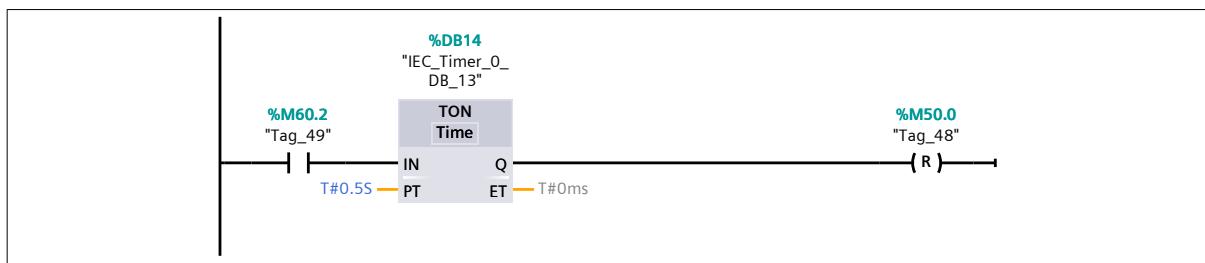
Network 3: MEMORY RESET (2.1 / 2.1)

1.1 (Page45 - 3)



Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 45 - 4

Network 4: ESTOP LOGIC RESET



B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 45 - 5

A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks

DATA BLOCK MOVE [FC4]

DATA BLOCK MOVE Properties

General

Name	DATA BLOCK MOVE	Number	4
Type	FC	Language	LAD

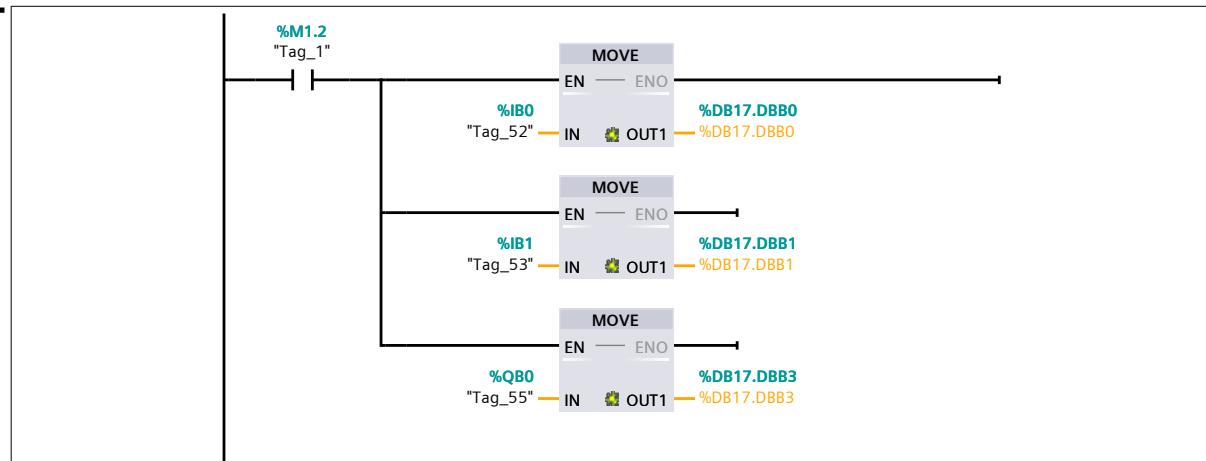
Numbering

Information

Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
DATA BLOCK MOVE	Void		

Network 1:



D

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 46 - 1

F

A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks

COM 2 [FC5]

COM 2 Properties

General

Name	COM 2	Number	5
Type	FC	Language	LAD

Numbering Automatic

Information

Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
COM 2	Void		

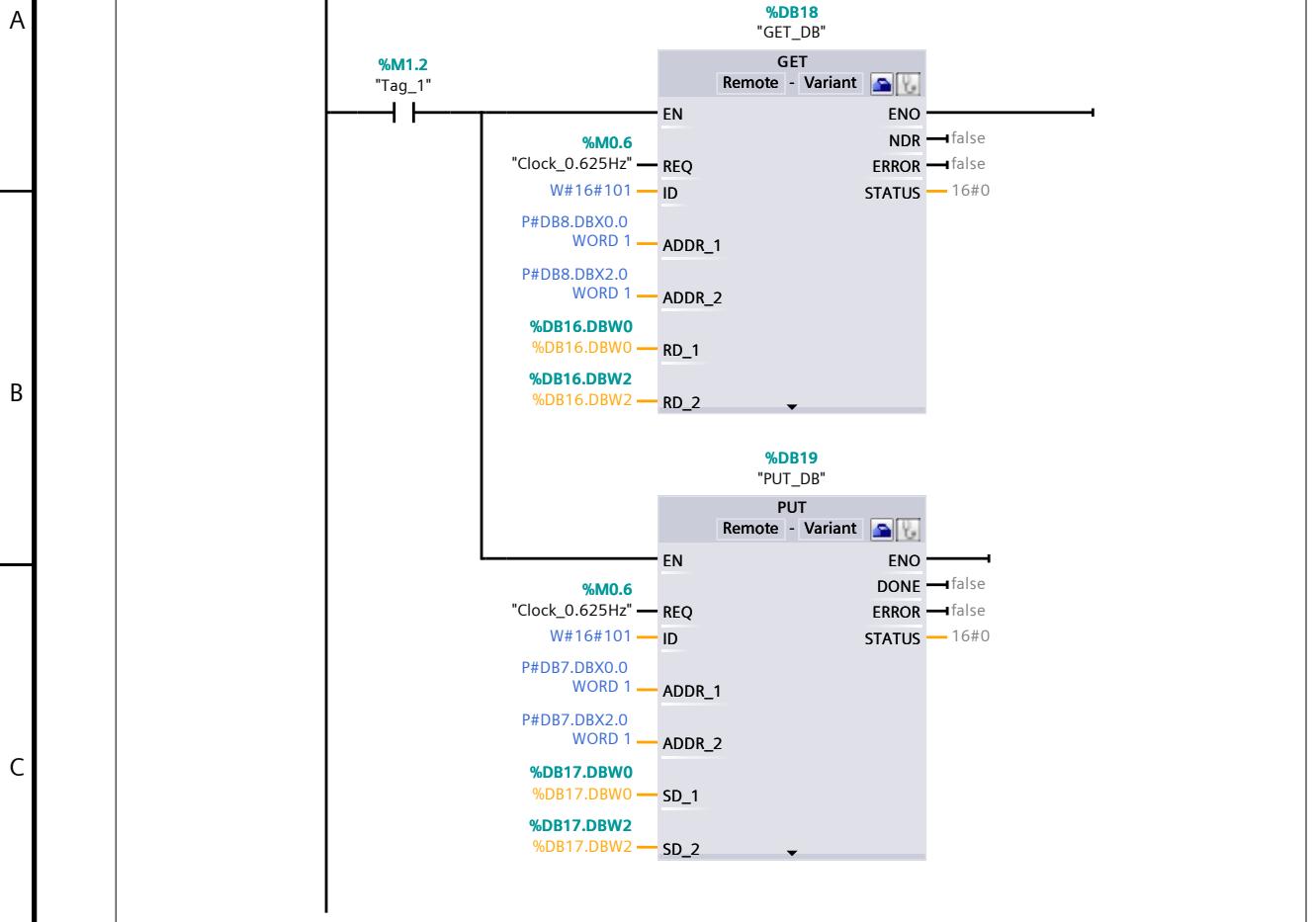
Network 1:

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
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Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Location			
Designed By	Description 1st		
Checked By	Description 2nd	Language en-US	
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A Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks

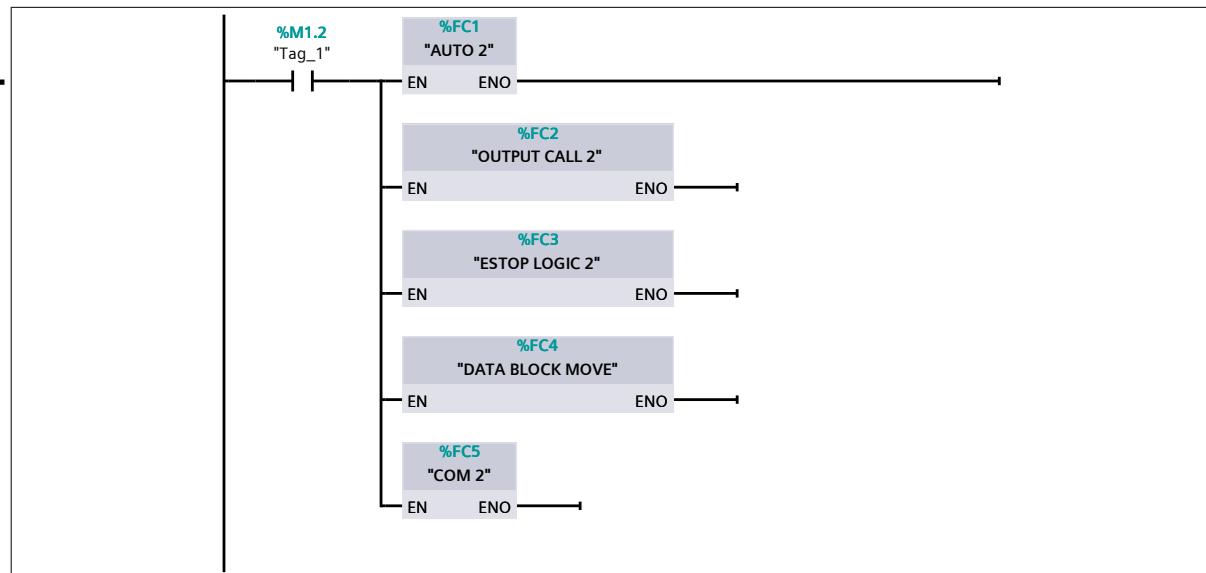
Main [OB1]

Main Properties			
General			
Name	Main	Number	1
Type	OB	Language	LAD
Numbering	Automatic		

Information			
Title	"Main Program Sweep (Cycle)"	Author	
Comment		Family	
Version	0.1	User-defined ID	

Name	Data type	Default value	Comment
▼ Input			
Initial_Call	Bool		Initial call of this OB
Remanence	Bool		=True, if remanent data are available
Temp			
Constant			

C Network 1:



Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 48 - 1

A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks

STATION 1 INPUT OUTPUT [DB15]

STATION 1 INPUT OUTPUT Properties

General

Name	STATION 1 INPUT OUTPUT	Number	15
Type	DB	Language	DB
Numbering	Automatic		

Information

Title	Author
Comment	Family
Version	User-defined ID



Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	1	Data type	Bool
Offset	0.0	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	2	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	3	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
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F

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 7 Offset 0.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 8 Offset 0.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 49 - 2

A	Comment		
	Name	9	Data type Bool
	Offset	1.0	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	10	Data type Bool
	Offset	1.1	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	11	Data type Bool
	Offset	1.2	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	12	Data type Bool
C	Offset	1.3	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	12	Data type Bool
	Offset	1.3	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
D	Comment		
	Name	8_1	Data type Bool
	Offset	1.4	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	8_1	Data type Bool
	Offset	1.4	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
E	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	9_1	Data type Bool
	Offset	1.5	Start value false
	Comment		
	Name	9_1	Data type Bool
	Offset	1.5	Start value false
	Comment		
	Name	9_1	Data type Bool

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
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	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	10_1	Data type	Bool
	Offset	1.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	11_1	Data type	Bool
	Offset	1.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	12_1	Data type	Bool
	Offset	2.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	13	Data type	Bool
	Offset	2.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	9_2	Data type	Bool
	Offset	2.2	Start value	false
F	Retain	False	Accessible from HMI/OPC UA/Web API	True
Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
Approved By		Description 2nd	Language en-US	Version
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	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 10_2 Offset 2.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 8_2 Offset 2.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 9_3 Offset 2.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 10_3 Offset 2.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 11_2 Offset 2.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version Sheet 49 - 5	

A	Comment		
	Name	12_2	Data type
	Offset	3.0	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	13_1	Data type
	Offset	3.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	8_2_1	Data type
	Offset	3.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	9_2_1	Data type
C	Offset	3.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	8_3	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
D	Comment		
	Name	9_4	Data type
	Offset	3.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	9_4	Data type
	Offset	3.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
E	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	9_4	Data type
	Offset	3.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	9_4	Data type
F	Offset	3.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	9_4	Data type
	Offset	3.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision

Owner	Project name Automation Production Station Code		Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd Language en-US			
	1st View Version Sheet 49 - 6			

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	10_4	Data type	Bool
	Offset	3.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	32	Data type	Bool
	Offset	3.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	40	Data type	Bool
	Offset	4.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	41	Data type	Bool
	Offset	4.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	42	Data type	Bool
	Offset	4.2	Start value	false
F	Retain	False	Accessible from HMI/OPC UA/Web API	True
Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
Approved By		Description 2nd	Language en-US	Version
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	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 43 Offset 4.3 Retain False	True	Visible in HMI engineering Supervision Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 44 Offset 4.4 Retain False	True	Visible in HMI engineering Supervision Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 45 Offset 4.5 Retain False	True	Visible in HMI engineering Supervision Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
D				
E				
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 49 - 8

A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks

STATION 3 INPUT OUTPUT [DB16]

STATION 3 INPUT OUTPUT Properties

General

Name	STATION 3 INPUT OUTPUT	Number	16
Type	DB	Language	DB
Numbering	Automatic		

B

Information

Title		Author	
Comment		Family	
Version	0.1	User-defined ID	

C

Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	1	Data type	Bool
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Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	2	Data type	Bool
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Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	3	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 50 - 1

F

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 7 Offset 0.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 8 Offset 0.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 50 - 2

A	<table border="1"> <tr><td>Comment</td><td></td></tr> <tr><td>Name</td><td>9</td></tr> <tr><td>Offset</td><td>1.0</td></tr> <tr><td>Retain</td><td>False</td></tr> <tr><td>Writable from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Setpoint</td><td>False</td></tr> <tr><td>Comment</td><td></td></tr> </table>	Comment		Name	9	Offset	1.0	Retain	False	Writable from HMI/OPC UA/Web API	True	Setpoint	False	Comment		<table border="1"> <tr><td>Data type</td><td>Bool</td></tr> <tr><td>Start value</td><td>false</td></tr> <tr><td>Accessible from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Visible in HMI engineering</td><td>True</td></tr> <tr><td>Supervision</td><td></td></tr> </table>	Data type	Bool	Start value	false	Accessible from HMI/OPC UA/Web API	True	Visible in HMI engineering	True	Supervision				
Comment																													
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B	<table border="1"> <tr><td>Name</td><td>10</td></tr> <tr><td>Offset</td><td>1.1</td></tr> <tr><td>Retain</td><td>False</td></tr> <tr><td>Writable from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Setpoint</td><td>False</td></tr> <tr><td>Comment</td><td></td></tr> </table>	Name	10	Offset	1.1	Retain	False	Writable from HMI/OPC UA/Web API	True	Setpoint	False	Comment		<table border="1"> <tr><td>Data type</td><td>Bool</td></tr> <tr><td>Start value</td><td>false</td></tr> <tr><td>Accessible from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Visible in HMI engineering</td><td>True</td></tr> <tr><td>Supervision</td><td></td></tr> </table>	Data type	Bool	Start value	false	Accessible from HMI/OPC UA/Web API	True	Visible in HMI engineering	True	Supervision						
Name	10																												
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Supervision																													
C	<table border="1"> <tr><td>Name</td><td>11</td></tr> <tr><td>Offset</td><td>1.2</td></tr> <tr><td>Retain</td><td>False</td></tr> <tr><td>Writable from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Setpoint</td><td>False</td></tr> <tr><td>Comment</td><td></td></tr> </table>	Name	11	Offset	1.2	Retain	False	Writable from HMI/OPC UA/Web API	True	Setpoint	False	Comment		<table border="1"> <tr><td>Data type</td><td>Bool</td></tr> <tr><td>Start value</td><td>false</td></tr> <tr><td>Accessible from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Visible in HMI engineering</td><td>True</td></tr> <tr><td>Supervision</td><td></td></tr> </table>	Data type	Bool	Start value	false	Accessible from HMI/OPC UA/Web API	True	Visible in HMI engineering	True	Supervision						
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Accessible from HMI/OPC UA/Web API	True																												
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Supervision																													
D	<table border="1"> <tr><td>Name</td><td>12</td></tr> <tr><td>Offset</td><td>1.3</td></tr> <tr><td>Retain</td><td>False</td></tr> <tr><td>Writable from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Setpoint</td><td>False</td></tr> <tr><td>Comment</td><td></td></tr> </table>	Name	12	Offset	1.3	Retain	False	Writable from HMI/OPC UA/Web API	True	Setpoint	False	Comment		<table border="1"> <tr><td>Data type</td><td>Bool</td></tr> <tr><td>Start value</td><td>false</td></tr> <tr><td>Accessible from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Visible in HMI engineering</td><td>True</td></tr> <tr><td>Supervision</td><td></td></tr> </table>	Data type	Bool	Start value	false	Accessible from HMI/OPC UA/Web API	True	Visible in HMI engineering	True	Supervision						
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Offset	1.3																												
Retain	False																												
Writable from HMI/OPC UA/Web API	True																												
Setpoint	False																												
Comment																													
Data type	Bool																												
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Accessible from HMI/OPC UA/Web API	True																												
Visible in HMI engineering	True																												
Supervision																													
E	<table border="1"> <tr><td>Name</td><td>13</td></tr> <tr><td>Offset</td><td>1.4</td></tr> <tr><td>Retain</td><td>False</td></tr> <tr><td>Writable from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Setpoint</td><td>False</td></tr> <tr><td>Comment</td><td></td></tr> </table>	Name	13	Offset	1.4	Retain	False	Writable from HMI/OPC UA/Web API	True	Setpoint	False	Comment		<table border="1"> <tr><td>Data type</td><td>Bool</td></tr> <tr><td>Start value</td><td>false</td></tr> <tr><td>Accessible from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Visible in HMI engineering</td><td>True</td></tr> <tr><td>Supervision</td><td></td></tr> </table>	Data type	Bool	Start value	false	Accessible from HMI/OPC UA/Web API	True	Visible in HMI engineering	True	Supervision						
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Offset	1.4																												
Retain	False																												
Writable from HMI/OPC UA/Web API	True																												
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Comment																													
Data type	Bool																												
Start value	false																												
Accessible from HMI/OPC UA/Web API	True																												
Visible in HMI engineering	True																												
Supervision																													
F	<table border="1"> <tr><td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr><td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr><td>Designed By</td><td>Description 1st</td><td colspan="3"></td></tr> <tr><td>Checked By</td><td>Description 2nd</td><td>Language</td><td colspan="2">en-US</td></tr> <tr><td>Approved By</td><td>1st View</td><td>Version</td><td colspan="2">Sheet 50 - 3</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Description 1st				Checked By	Description 2nd	Language	en-US		Approved By	1st View	Version	Sheet 50 - 3				
Owner	Project name	Automation Production Station Code	Date	7/12/2025																									
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																											
Designed By	Description 1st																												
Checked By	Description 2nd	Language	en-US																										
Approved By	1st View	Version	Sheet 50 - 3																										

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
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B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	16	Data type	Bool
	Offset	1.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
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	Setpoint	False	Supervision	
	Comment			
	Name	17	Data type	Bool
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D	Retain	False	Accessible from HMI/OPC UA/Web API	True
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	Setpoint	False	Supervision	
	Comment			
	Name	18	Data type	Bool
	Offset	2.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
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	Setpoint	False	Supervision	
	Comment			
	Name	19	Data type	Bool
	Offset	2.2	Start value	false
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Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
Approved By		Description 2nd	Language en-US	Version
		1st View	Sheet 50 - 4	

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 20 Offset 2.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 21 Offset 2.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 22 Offset 2.5 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 23 Offset 2.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 24 Offset 2.7 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version Sheet 50 - 5	

A	Comment		
	Name	25	Data type
	Offset	3.0	Start value
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	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	26	Data type
	Offset	3.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	27	Data type
	Offset	3.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	29	Data type
D	Offset	3.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	30	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
E	Comment		
	Name	31	Data type
	Offset	3.5	Start value
	Comment		
	Name	31	Data type
	Offset	3.5	Start value
	Comment		
	Name	31	Data type
	Offset	3.5	Start value
	Comment		

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 50 - 6

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
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	Comment			
	Name	32	Data type	Bool
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B	Retain	False	Accessible from HMI/OPC UA/Web API	True
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	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
D				
E				
F	Owner	Project name	Automation Production Station Code	Date 7/12/2025
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location		
	Checked By	Description 1st	Description 2nd	Language en-US
	Approved By	1st View	Version	Sheet 50 - 7

A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks

STATION 2 INPUT OUTPUT [DB17]

STATION 2 INPUT OUTPUT Properties

General

Name	STATION 2 INPUT OUTPUT	Number	17
Type	DB	Language	DB
Numbering	Automatic		

B

Information

Title		Author	
Comment		Family	
Version	0.1	User-defined ID	



C

Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			

D

Name	1	Data type	Bool
Offset	0.0	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			

E

Name	2	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 51 - 1

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 7 Offset 0.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 8 Offset 0.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 51 - 2

A	<table border="1"> <tr><td>Comment</td><td></td></tr> <tr><td>Name</td><td>9</td></tr> <tr><td>Offset</td><td>1.0</td></tr> <tr><td>Retain</td><td>False</td></tr> <tr><td>Writable from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Setpoint</td><td>False</td></tr> <tr><td>Comment</td><td></td></tr> </table>	Comment		Name	9	Offset	1.0	Retain	False	Writable from HMI/OPC UA/Web API	True	Setpoint	False	Comment		<table border="1"> <tr><td>Data type</td><td>Bool</td></tr> <tr><td>Start value</td><td>false</td></tr> <tr><td>Accessible from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Visible in HMI engineering</td><td>True</td></tr> <tr><td>Supervision</td><td></td></tr> </table>	Data type	Bool	Start value	false	Accessible from HMI/OPC UA/Web API	True	Visible in HMI engineering	True	Supervision				
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C	<table border="1"> <tr><td>Name</td><td>11</td></tr> <tr><td>Offset</td><td>1.2</td></tr> <tr><td>Retain</td><td>False</td></tr> <tr><td>Writable from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Setpoint</td><td>False</td></tr> <tr><td>Comment</td><td></td></tr> </table>	Name	11	Offset	1.2	Retain	False	Writable from HMI/OPC UA/Web API	True	Setpoint	False	Comment		<table border="1"> <tr><td>Data type</td><td>Bool</td></tr> <tr><td>Start value</td><td>false</td></tr> <tr><td>Accessible from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Visible in HMI engineering</td><td>True</td></tr> <tr><td>Supervision</td><td></td></tr> </table>	Data type	Bool	Start value	false	Accessible from HMI/OPC UA/Web API	True	Visible in HMI engineering	True	Supervision						
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D	<table border="1"> <tr><td>Name</td><td>12</td></tr> <tr><td>Offset</td><td>1.3</td></tr> <tr><td>Retain</td><td>False</td></tr> <tr><td>Writable from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Setpoint</td><td>False</td></tr> <tr><td>Comment</td><td></td></tr> </table>	Name	12	Offset	1.3	Retain	False	Writable from HMI/OPC UA/Web API	True	Setpoint	False	Comment		<table border="1"> <tr><td>Data type</td><td>Bool</td></tr> <tr><td>Start value</td><td>false</td></tr> <tr><td>Accessible from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Visible in HMI engineering</td><td>True</td></tr> <tr><td>Supervision</td><td></td></tr> </table>	Data type	Bool	Start value	false	Accessible from HMI/OPC UA/Web API	True	Visible in HMI engineering	True	Supervision						
Name	12																												
Offset	1.3																												
Retain	False																												
Writable from HMI/OPC UA/Web API	True																												
Setpoint	False																												
Comment																													
Data type	Bool																												
Start value	false																												
Accessible from HMI/OPC UA/Web API	True																												
Visible in HMI engineering	True																												
Supervision																													
E	<table border="1"> <tr><td>Name</td><td>13</td></tr> <tr><td>Offset</td><td>1.4</td></tr> <tr><td>Retain</td><td>False</td></tr> <tr><td>Writable from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Setpoint</td><td>False</td></tr> <tr><td>Comment</td><td></td></tr> </table>	Name	13	Offset	1.4	Retain	False	Writable from HMI/OPC UA/Web API	True	Setpoint	False	Comment		<table border="1"> <tr><td>Data type</td><td>Bool</td></tr> <tr><td>Start value</td><td>false</td></tr> <tr><td>Accessible from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Visible in HMI engineering</td><td>True</td></tr> <tr><td>Supervision</td><td></td></tr> </table>	Data type	Bool	Start value	false	Accessible from HMI/OPC UA/Web API	True	Visible in HMI engineering	True	Supervision						
Name	13																												
Offset	1.4																												
Retain	False																												
Writable from HMI/OPC UA/Web API	True																												
Setpoint	False																												
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Data type	Bool																												
Start value	false																												
Accessible from HMI/OPC UA/Web API	True																												
Visible in HMI engineering	True																												
Supervision																													
F	<table border="1"> <tr><td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr><td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr><td>Designed By</td><td>Description 1st</td><td colspan="3"></td></tr> <tr><td>Checked By</td><td>Description 2nd</td><td>Language</td><td colspan="2">en-US</td></tr> <tr><td>Approved By</td><td>1st View</td><td>Version</td><td colspan="2">Sheet 51 - 3</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Description 1st				Checked By	Description 2nd	Language	en-US		Approved By	1st View	Version	Sheet 51 - 3				
Owner	Project name	Automation Production Station Code	Date	7/12/2025																									
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																											
Designed By	Description 1st																												
Checked By	Description 2nd	Language	en-US																										
Approved By	1st View	Version	Sheet 51 - 3																										

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
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	Name	17	Data type	Bool
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D	Retain	False	Accessible from HMI/OPC UA/Web API	True
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Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
Approved By		Description 2nd	Language en-US	
		1st View	Version	Sheet 51 - 4

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 20 Offset 2.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 21 Offset 2.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 22 Offset 2.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 23 Offset 2.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 24 Offset 2.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 51 - 5

A	Comment		
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	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
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	Offset	3.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	27	Data type
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	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
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	Setpoint	False	Supervision
D	Comment		
	Name	29	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
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	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		
E	Owner	Automation Production Station Code	Date 7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Operator		
	Location		
	Designed By	Description 1st	
	Checked By	Description 2nd	Language en-US
	Approved By	1st View	Version
			Sheet 51 - 6

Owner	Automation Production Station Code	Date 7/12/2025
Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator		
Location		
Designed By	Description 1st	
Checked By	Description 2nd	Language en-US
Approved By	1st View	Version
		Sheet 51 - 6

A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
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B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
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C	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			

D	
E	

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 51 - 7

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Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_1 [DB2]

IEC_Timer_0_DB_1 Properties

General

Name	IEC_Timer_0_DB_1	Number	2
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	
	1st View	Version		Sheet 52 - 1

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F	<table border="1"> <tr> <td>Owner</td> <td>Project name Automation Production Station Code</td> <td>Date 7/12/2025</td> </tr> <tr> <td>Operator</td> <td colspan="2">Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td> </tr> <tr> <td>Designed By</td> <td colspan="2">Location</td> </tr> <tr> <td>Checked By</td> <td>Description 2nd</td> <td>Language en-US</td> </tr> <tr> <td>Approved By</td> <td>1st View</td> <td>Version</td> </tr> <tr> <td></td> <td></td> <td>Sheet 52 - 2</td> </tr> </table>	Owner	Project name Automation Production Station Code	Date 7/12/2025	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		Designed By	Location		Checked By	Description 2nd	Language en-US	Approved By	1st View	Version			Sheet 52 - 2	
Owner	Project name Automation Production Station Code	Date 7/12/2025																		
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																			
Designed By	Location																			
Checked By	Description 2nd	Language en-US																		
Approved By	1st View	Version																		
		Sheet 52 - 2																		

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Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_2 [DB3]

IEC_Timer_0_DB_2 Properties

General

Name	IEC_Timer_0_DB_2	Number	3
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 53 - 1

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	1	2	3	4
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B				
C				
D				
E				
F	<p>Owner</p> <p>Operator</p> <p>Designed By</p> <p>Checked By</p> <p>Approved By</p>	<p>Project name</p> <p>Project path</p> <p>Description 1st</p> <p>Description 2nd</p> <p>1st View</p>	<p>Automation Production Station Code</p> <p>C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</p> <p>Location</p> <p>en-US</p> <p>Version</p>	<p>Date 7/12/2025</p>

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Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_3 [DB4]

IEC_Timer_0_DB_3 Properties

General

Name	IEC_Timer_0_DB_3	Number	4
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 54 - 1

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Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False																																
Visible in HMI engineering	True	Setpoint	False																																
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B																																			
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F	<table border="1"> <tr> <td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr> <td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr> <td>Designed By</td><td>Location</td><td colspan="3"></td></tr> <tr> <td>Checked By</td><td>Description 1st</td><td colspan="3"></td></tr> <tr> <td>Approved By</td><td>Description 2nd</td><td>Language</td><td>en-US</td><td></td></tr> <tr> <td></td><td>1st View</td><td>Version</td><td colspan="2">Sheet 54 - 2</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 54 - 2					
Owner	Project name	Automation Production Station Code	Date	7/12/2025																															
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Designed By	Location																																		
Checked By	Description 1st																																		
Approved By	Description 2nd	Language	en-US																																
	1st View	Version	Sheet 54 - 2																																

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_4 [DB5]

IEC_Timer_0_DB_4 Properties			
General			
Name	IEC_Timer_0_DB_4	Number	5
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC TMR

Name	Static	Data type	
Start value		Retain	
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Supervision		Comment	
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Visible in HMI engineering	True	Setpoint	False
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Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 55 - 1	

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Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False											
Visible in HMI engineering	True	Setpoint	False											
Supervision		Comment												

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F	<table border="1"> <tr> <td>Owner</td> <td>Project name</td> <td>Automation Production Station Code</td> <td>Date</td> <td>7/12/2025</td> </tr> <tr> <td>Operator</td> <td>Project path</td> <td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td> </tr> <tr> <td>Designed By</td> <td>Location</td> <td colspan="3"></td> </tr> <tr> <td>Checked By</td> <td>Description 1st</td> <td colspan="3"></td> </tr> <tr> <td>Approved By</td> <td>Description 2nd</td> <td>Language</td> <td>en-US</td> <td></td> </tr> <tr> <td></td> <td>1st View</td> <td>Version</td> <td colspan="2">Sheet 55 - 2</td> </tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 55 - 2		
Owner	Project name	Automation Production Station Code	Date	7/12/2025																												
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																														
Designed By	Location																															
Checked By	Description 1st																															
Approved By	Description 2nd	Language	en-US																													
	1st View	Version	Sheet 55 - 2																													

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Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_5 [DB6]

IEC_Timer_0_DB_5 Properties

General

Name	IEC_Timer_0_DB_5	Number	6
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
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Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
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Supervision		Comment	
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
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Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 56 - 1

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	1	2	3	4
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B				
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F	<p>Owner</p> <p>Operator</p> <p>Designed By</p> <p>Checked By</p> <p>Approved By</p>	<p>Project name</p> <p>Project path</p> <p>Description 1st</p> <p>Description 2nd</p> <p>1st View</p>	<p>Automation Production Station Code</p> <p>C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</p> <p>Location</p> <p>en-US</p> <p>Version</p>	<p>Date 7/12/2025</p>

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB [DB1]

IEC_Timer_0_DB Properties			
General			
Name	IEC_Timer_0_DB	Number	1
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 57 - 1	

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Supervision		Comment																												
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F	<table border="1"> <tr> <td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr> <td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr> <td>Designed By</td><td>Location</td><td colspan="3"></td></tr> <tr> <td>Checked By</td><td>Description 1st</td><td>Description 2nd</td><td>Language</td><td>en-US</td></tr> <tr> <td>Approved By</td><td>1st View</td><td></td><td>Version</td><td>Sheet 57 - 2</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st	Description 2nd	Language	en-US	Approved By	1st View		Version	Sheet 57 - 2				
Owner	Project name	Automation Production Station Code	Date	7/12/2025																										
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																												
Designed By	Location																													
Checked By	Description 1st	Description 2nd	Language	en-US																										
Approved By	1st View		Version	Sheet 57 - 2																										

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Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_13 [DB14]

IEC_Timer_0_DB_13 Properties

General

Name	IEC_Timer_0_DB_13	Number	14
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	
	1st View	Version		Sheet 58 - 1

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	1	2	3	4
A	<p>Accessible from HMI/OPC UA/Web API</p> <p>Visible in HMI engineering</p> <p>Supervision</p>	<p>True</p>	<p>Writable from HMI/OPC UA/Web API</p> <p>Setpoint</p> <p>Comment</p>	<p>False</p>
B				
C				
D				
E				
F	<p>Owner</p> <p>Operator</p> <p>Designed By</p> <p>Checked By</p> <p>Approved By</p>	<p>Project name</p> <p>Project path</p> <p>Description 1st</p> <p>Description 2nd</p> <p>1st View</p>	<p>Automation Production Station Code</p> <p>C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</p> <p>Location</p> <p>en-US</p> <p>Version</p>	<p>Date 7/12/2025</p>

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Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

GET_DB [DB18]

GET_DB Properties

General

Name	GET_DB	Number	18
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	SIMATIC
Comment		Family	COM_FUNC
Version	1.1	User-defined ID	GET



Name	Input	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	REQ	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ID	Data type	Word
Start value	16#0	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	



Name	Output	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	NDR	Data type	Bool

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 59 - 1

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A	<table border="1"> <tr><td>Start value</td><td>false</td></tr> <tr><td>Accessible from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Visible in HMI engineering</td><td>True</td></tr> <tr><td>Supervision</td><td></td></tr> <tr><td>Name</td><td>ERROR</td></tr> <tr><td>Start value</td><td>false</td></tr> <tr><td>Accessible from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Visible in HMI engineering</td><td>True</td></tr> <tr><td>Supervision</td><td></td></tr> <tr><td>Name</td><td>STATUS</td></tr> <tr><td>Start value</td><td>16#0</td></tr> <tr><td>Accessible from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Visible in HMI engineering</td><td>True</td></tr> <tr><td>Supervision</td><td></td></tr> </table>	Start value	false	Accessible from HMI/OPC UA/Web API	True	Visible in HMI engineering	True	Supervision		Name	ERROR	Start value	false	Accessible from HMI/OPC UA/Web API	True	Visible in HMI engineering	True	Supervision		Name	STATUS	Start value	16#0	Accessible from HMI/OPC UA/Web API	True	Visible in HMI engineering	True	Supervision		<table border="1"> <tr><td>Retain</td><td>False</td></tr> <tr><td>Writable from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Setpoint</td><td>False</td></tr> <tr><td>Comment</td><td></td></tr> <tr><td>Data type</td><td>Bool</td></tr> <tr><td>Retain</td><td>False</td></tr> <tr><td>Writable from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Setpoint</td><td>False</td></tr> <tr><td>Comment</td><td></td></tr> <tr><td>Data type</td><td>Word</td></tr> <tr><td>Retain</td><td>False</td></tr> <tr><td>Writable from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Setpoint</td><td>False</td></tr> <tr><td>Comment</td><td></td></tr> </table>	Retain	False	Writable from HMI/OPC UA/Web API	True	Setpoint	False	Comment		Data type	Bool	Retain	False	Writable from HMI/OPC UA/Web API	True	Setpoint	False	Comment		Data type	Word	Retain	False	Writable from HMI/OPC UA/Web API	True	Setpoint	False	Comment			
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Setpoint	False																																																											
Comment																																																												
F	Owner	Project name	Automation Production Station Code	Date 7/12/2025																																																								
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																																																									
	Designed By	Location																																																										
	Checked By	Description 1st																																																										
	Approved By	Description 2nd	Language en-US	Version Sheet 59 - 2																																																								

A	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	ADDR_4	Data type	Remote
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	RD_1	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
B	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_2	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_3	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
C	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_4	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	Static	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	False
D	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name		Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name		Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	False
E	Visible in HMI engineering		Setpoint	
	Supervision		Comment	
	Owner	Automation Production Station Code	Date	7/12/2025
	Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	Project path	
	Designed By	Description 1st	Location	
	Checked By	Description 2nd	Language	en-US
	Approved By	1st View	Version	Sheet 59 - 3

Owner	Automation Production Station Code	Date	7/12/2025
Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Description 1st		
Checked By	Description 2nd	Language	en-US
Approved By	1st View	Version	Sheet 59 - 3

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Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

PUT_DB [DB19]

PUT_DB Properties

General

Name	PUT_DB	Number	19
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	SIMATIC
Comment		Family	COM_FUNC
Version	1.1	User-defined ID	PUT



Name	Input	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	REQ	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	

D

Name	ID	Data type	Word
Start value	16#0	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	

E

Name	Output	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	DONE	Data type	Bool

F

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location		
Checked By	Description 1st		
Approved By	Description 2nd Language en-US		
	1st View Version Sheet 60 - 1		

A	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	ADDR_4	Data type	Remote
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	SD_1	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
B	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	SD_2	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	SD_3	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
C	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	SD_4	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	Static	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	False
D	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name		Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name		Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	False
E	Visible in HMI engineering		Setpoint	
	Supervision		Comment	
	Owner	Automation Production Station Code	Date	7/12/2025
	Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	Project path	
	Designed By	Description 1st	Location	
	Checked By	Description 2nd	Language	en-US
	Approved By	1st View	Version	Sheet 60 - 3

Owner	Automation Production Station Code	Date	7/12/2025
Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Description 1st		
Checked By	Description 2nd	Language	en-US
Approved By	1st View	Version	Sheet 60 - 3

A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_14 [DB20]

IEC_Timer_0_DB_14 Properties

General

Name	IEC_Timer_0_DB_14	Number	20
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	
	1st View	Version		Sheet 61 - 1

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A	<table border="1"> <tr><td>Accessible from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Visible in HMI engineering</td><td>True</td></tr> <tr><td>Supervision</td><td></td></tr> </table>	Accessible from HMI/OPC UA/Web API	True	Visible in HMI engineering	True	Supervision		<table border="1"> <tr><td>Writable from HMI/OPC UA/Web API</td><td>False</td></tr> <tr><td>Setpoint</td><td>False</td></tr> <tr><td>Comment</td><td></td></tr> </table>	Writable from HMI/OPC UA/Web API	False	Setpoint	False	Comment	
Accessible from HMI/OPC UA/Web API	True													
Visible in HMI engineering	True													
Supervision														
Writable from HMI/OPC UA/Web API	False													
Setpoint	False													
Comment														
B														
C														

D																															
E																															
F	<table border="1"> <tr><td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr><td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr><td>Designed By</td><td>Location</td><td colspan="3"></td></tr> <tr><td>Checked By</td><td>Description 1st</td><td colspan="3"></td></tr> <tr><td>Approved By</td><td>Description 2nd</td><td>Language</td><td colspan="2">en-US</td></tr> <tr><td></td><td>1st View</td><td>Version</td><td colspan="2">Sheet 61 - 2</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 61 - 2	
Owner	Project name	Automation Production Station Code	Date	7/12/2025																											
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																													
Designed By	Location																														
Checked By	Description 1st																														
Approved By	Description 2nd	Language	en-US																												
	1st View	Version	Sheet 61 - 2																												

A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC]

Technology objects

This folder is empty.

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language en-US		
Approved By	1st View	Version	Sheet 62 - 1	

A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC]

PLC tags

PLC tags						
Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
■	AlwaysFALSE	Bool	%M1.3	True	True	
■	Clock_0.5Hz	Bool	%M0.7	True	True	
■	Clock_0.625 Hz	Bool	%M0.6	True	True	
■	Clock_1.25Hz	Bool	%M0.4	True	True	
■	Clock_1Hz	Bool	%M0.5	True	True	
■	Clock_2.5Hz	Bool	%M0.2	True	True	
■	Clock_2Hz	Bool	%M0.3	True	True	
■	Clock_5Hz	Bool	%M0.1	True	True	
■	Clock_10Hz	Bool	%M0.0	True	True	
■	Clock_BytE	Byte	%MBO	True	True	
■	DiagStatussUpdate	Bool	%M1.1	True	True	
■	FirstScan	Bool	%M1.0	True	True	
■	System_BytE	Byte	%MB1	True	True	
■	Tag_1	Bool	%M1.2	True	True	
■	Tag_2	Bool	%I0.0	True	True	
■	Tag_3	Bool	%I0.2	True	True	
■	Tag_4	Bool	%I0.4	True	True	
■	Tag_5	Bool	%I1.1	True	True	
■	Tag_6	Bool	%Q0.4	True	True	
■	Tag_7	Bool	%M10.0	True	True	
■	Tag_8	Bool	%I0.7	True	True	
■	Tag_9	Bool	%I1.0	True	True	
■	Tag_10	Bool	%M0.1	True	True	
■	Tag_11	Bool	%I1.2	True	True	
■	Tag_12	Bool	%I1.3	True	True	
■	Tag_13	Bool	%M10.3	True	True	
■	Tag_14	Bool	%I1.4	True	True	
■	Tag_15	Bool	%M15.0	True	True	
■	Tag_16	Bool	%M10.1	True	True	

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By				
Approved By	1st View	Language	en-US	Version
				Sheet 63 - 1

	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
A	Tag_17	Bool	%M10.2	True	True		
	Tag_18	Bool	%Q0.0	True	True		
	Tag_19	Bool	%M20.0	True	True		
	Tag_20	Bool	%M16.0	True	True		
	Tag_21	Bool	%M10.4	True	True		
	Tag_22	Bool	%I0.5	True	True		
B	Tag_23	Bool	%M10.5	True	True		
	Tag_24	Bool	%I0.6	True	True		
	Tag_25	Bool	%I1.5	True	True		
	Tag_26	Bool	%I2.1	True	True		
	Tag_27	Bool	%M10.6	True	True		
C	Tag_28	Bool	%I2.2	True	True		
	Tag_29	Bool	%M11.1	True	True		
	Tag_30	Bool	%M15.1	True	True		
	Tag_31	Bool	%M10.7	True	True		
D	Tag_32	Bool	%I2.0	True	True		
	Tag_33	Bool	%M13.6	True	True		
	Tag_34	Bool	%M12.0	True	True		
	Tag_35	Bool	%M15.2	True	True		
	Tag_36	Bool	%M11.0	True	True		
	Tag_37	Bool	%Q0.1	True	True		
	Tag_38	Bool	%Q0.2	True	True		
	Tag_39	Bool	%Q0.3	True	True		
	Tag_40	Bool	%Q0.5	True	True		
	Tag_41	Bool	%Q0.7	True	True		
	Tag_42	Bool	%Q1.0	True	True		
E	Tag_43	Bool	%Q1.1	True	True		
	Tag_44	Bool	%Q2.0	True	True		
	Tag_45	Bool	%Q0.6	True	True		
	Tag_46	Bool	%M49.0	True	True		
	Tag_47	Bool	%M48.0	True	True		
	Tag_48	Bool	%M50.0	True	True		
	Tag_49	Bool	%M60.2	True	True		
	Tag_50	Bool	%M61.0	True	True		
	Tag_51	Bool	%M62.0	True	True		
	Tag_52	Byte	%IB0	True	True		

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 63 - 2

	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
A		Tag_53	Byte	%IB1	True	True	
		Tag_54	Byte	%IB2	True	True	
		Tag_55	Byte	%QBO	True	True	
		Tag_56	Bool	%I0.3	True	True	
		Tag_57	Bool	%M6.0	True	True	
		Tag_58	Bool	%M48.1	True	True	
B		Tag_59	Bool	%M48.2	True	True	
		Tag_60	Word	%IW64	True	True	
		Tag_61	Bool	%M22.0	True	True	
		Tag_62	Real	%MD70	True	True	
		Tag_63	Real	%MD24	True	True	
C		Tag_64	Real	%MD90	True	True	
		Tag_65	Bool	%M22.1	True	True	
		Tag_66	Bool	%M21.0	True	True	
		Tag_67	Bool	%M20.5	True	True	
		Tag_68	Bool	%M47.0	True	True	
D		Tag_69	Bool	%M8.0	True	True	
		Tag_70	Bool	%I0.1	True	True	
		Tag_71	Bool	%M5.0	True	True	
		Tag_72	Bool	%M4.0	True	True	
		Tag_73	Bool	%M48.4	True	True	
		Tag_74	Bool	%M17.0	True	True	
		Tag_75	Bool	%M17.1	True	True	
		Tag_76	Bool	%M17.2	True	True	
		Tag_77	Bool	%M17.3	True	True	
		Tag_78	Bool	%M13.0	True	True	
E							
F	Owner		Project name	Automation Production Station Code		Date	7/12/2025
	Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
	Designed By		Location				
	Checked By	Description 1st					
	Approved By	Description 2nd	Language	en-US			
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A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / PLC tags

Default tag table [117]

PLC tags						
Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
B	AlwaysFALSE	Bool	%M1.3	True	True	
	Clock_0.5Hz	Bool	%M0.7	True	True	
	Clock_0.625 Hz	Bool	%M0.6	True	True	
	Clock_1.25Hz	Bool	%M0.4	True	True	
	Clock_1Hz	Bool	%M0.5	True	True	
	Clock_2.5Hz	Bool	%M0.2	True	True	
	Clock_2Hz	Bool	%M0.3	True	True	
	Clock_5Hz	Bool	%M0.1	True	True	
	Clock_10Hz	Bool	%M0.0	True	True	
	Clock_Byt	Byte	%MBO	True	True	
	DiagStatussUpdate	Bool	%M1.1	True	True	
	FirstScan	Bool	%M1.0	True	True	
	System_Byt	Byte	%MB1	True	True	
	Tag_1	Bool	%M1.2	True	True	
	Tag_2	Bool	%I0.0	True	True	
C	Tag_3	Bool	%I0.2	True	True	
	Tag_4	Bool	%I0.4	True	True	
	Tag_5	Bool	%I1.1	True	True	
	Tag_6	Bool	%Q0.4	True	True	
	Tag_7	Bool	%M10.0	True	True	
	Tag_8	Bool	%I0.7	True	True	
	Tag_9	Bool	%I1.0	True	True	
	Tag_10	Bool	%M0.1	True	True	
	Tag_11	Bool	%I1.2	True	True	
	Tag_12	Bool	%I1.3	True	True	
	Tag_13	Bool	%M10.3	True	True	
	Tag_14	Bool	%I1.4	True	True	
	Tag_15	Bool	%M15.0	True	True	
	Tag_16	Bool	%M10.1	True	True	

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 64 - 1

	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
A	Tag_17	Bool	%M10.2	True	True		
	Tag_18	Bool	%Q0.0	True	True		
	Tag_19	Bool	%M20.0	True	True		
	Tag_20	Bool	%M16.0	True	True		
	Tag_21	Bool	%M10.4	True	True		
	Tag_22	Bool	%I0.5	True	True		
B	Tag_23	Bool	%M10.5	True	True		
	Tag_24	Bool	%I0.6	True	True		
	Tag_25	Bool	%I1.5	True	True		
	Tag_26	Bool	%I2.1	True	True		
	Tag_27	Bool	%M10.6	True	True		
C	Tag_28	Bool	%I2.2	True	True		
	Tag_29	Bool	%M11.1	True	True		
	Tag_30	Bool	%M15.1	True	True		
	Tag_31	Bool	%M10.7	True	True		
D	Tag_32	Bool	%I2.0	True	True		
	Tag_33	Bool	%M13.6	True	True		
	Tag_34	Bool	%M12.0	True	True		
	Tag_35	Bool	%M15.2	True	True		
	Tag_36	Bool	%M11.0	True	True		
	Tag_37	Bool	%Q0.1	True	True		
	Tag_38	Bool	%Q0.2	True	True		
	Tag_39	Bool	%Q0.3	True	True		
	Tag_40	Bool	%Q0.5	True	True		
	Tag_41	Bool	%Q0.7	True	True		
	Tag_42	Bool	%Q1.0	True	True		
E	Tag_43	Bool	%Q1.1	True	True		
	Tag_44	Bool	%Q2.0	True	True		
	Tag_45	Bool	%Q0.6	True	True		
	Tag_46	Bool	%M49.0	True	True		
	Tag_47	Bool	%M48.0	True	True		
	Tag_48	Bool	%M50.0	True	True		
	Tag_49	Bool	%M60.2	True	True		
	Tag_50	Bool	%M61.0	True	True		
	Tag_51	Bool	%M62.0	True	True		
	Tag_52	Byte	%IB0	True	True		

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 64 - 2

	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
A		Tag_53	Byte	%IB1	True	True	
		Tag_54	Byte	%IB2	True	True	
		Tag_55	Byte	%QBO	True	True	
		Tag_56	Bool	%I0.3	True	True	
		Tag_57	Bool	%M6.0	True	True	
		Tag_58	Bool	%M48.1	True	True	
B		Tag_59	Bool	%M48.2	True	True	
		Tag_60	Word	%IW64	True	True	
		Tag_61	Bool	%M22.0	True	True	
		Tag_62	Real	%MD70	True	True	
		Tag_63	Real	%MD24	True	True	
C		Tag_64	Real	%MD90	True	True	
		Tag_65	Bool	%M22.1	True	True	
		Tag_66	Bool	%M21.0	True	True	
		Tag_67	Bool	%M20.5	True	True	
		Tag_68	Bool	%M47.0	True	True	
D		Tag_69	Bool	%M8.0	True	True	
		Tag_70	Bool	%I0.1	True	True	
		Tag_71	Bool	%M5.0	True	True	
		Tag_72	Bool	%M4.0	True	True	
		Tag_73	Bool	%M48.4	True	True	
		Tag_74	Bool	%M17.0	True	True	
		Tag_75	Bool	%M17.1	True	True	
		Tag_76	Bool	%M17.2	True	True	
		Tag_77	Bool	%M17.3	True	True	
		Tag_78	Bool	%M13.0	True	True	
E							
F	Owner		Project name	Automation Production Station Code		Date	7/12/2025
	Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
	Designed By		Location				
	Checked By	Description 1st					
	Approved By	Description 2nd	Language	en-US			
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A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / PLC data types

System data types

This folder is empty.

B

C

D

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Sheet 65 - 1
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A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Watch and force tables

Force table

Name	Address	Display format	Force value	Comment

B

C

D

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 66 - 1

A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC]

Traces

Name

B

C

D

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
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A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Traces

Measurements

This folder is empty.

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Sheet 68 - 1
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A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Traces

Combined measurements

Name

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View	Version	Sheet	69 - 1

A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC]

PLC alarm text lists

This folder is empty.

B

C

D

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
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A

Automation Production Station Code / PLC_2 [CPU 1214C DC/DC/DC] / Local modules

PLC_2 [CPU 1214C DC/DC/DC]

PLC_2			
General\Project information			
Name	PLC_2	Author	MTC-MECH-05
Comment		Slot	1
Rack	0		
General\Catalog information			
Short designation	CPU 1214C DC/DC/DC	Description	Work memory 75 KB; 24VDC power supply with DI14 x 24VDC SINK/SOURCE, DQ10 x 24VDC and AI2 on board; 6 high-speed counters and 4 pulse outputs on board; signal board expands on-board I/O; up to 3 communication modules for serial communication; up to 8 signal modules for I/O expansion; PROFINET interface for programming, HMI and PLC-to-PLC communication
Article number	6ES7 214-1AG40-0XB0	Firmware version	V4.0
General\Identification & Maintenance			
Plant designation		Location identifier	
Installation date	2025-06-11 05:57:39.105	Additional information	
Connection resources			
PG communication:	1	OP communication:	1
S7 basic communication:	0	S7 communication:	0
Maximum number of S7 connection resources:	38		
PROFINET interface [X1]\General			
Name	PROFINET interface_1	Author	MTC-MECH-05
Comment			
PROFINET interface [X1]\General\Project information			
Name	DI 14/DQ 10_1	Comment	
Name	AI 2_1	Comment	
PROFINET interface [X1]\Ethernet addresses\Interface networked with			
Subnet:	PN/IE_1		
PROFINET interface [X1]\Ethernet addresses\IP protocol			
IP configuration	Set IP address in the project	IP address:	192.168.0.2
Subnet mask:	255.255.255.0	Use router	False
PROFINET interface [X1]\Ethernet addresses\PROFINET			
PROFINET device name is set directly at the device	False	Generate PROFINET device name automatically	True
PROFINET device name:	plc_2	Converted name:	plcxb2d1ad

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A	Device number:	0		
	PROFINET interface [X1]\Time synchronization			
	Enable time synchronization via NTP server	Enable time synchronization via NTP server		IP addresses
	Server 1	0.0.0.0	Server 2	0.0.0.0
	Server 3	0.0.0.0	Server 4	0.0.0.0
	Update interval	10sec		
	PROFINET interface [X1]\Digital inputs\Channel0			
	Channel address	I0.0	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel0\			
B	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49152
	Event name:	0	Hardware interrupt:	0
	Rising edge0	Rising edge0		
	PROFINET interface [X1]\Digital inputs\Channel0\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49280
	Event name:	0	Hardware interrupt:	0
	Falling edge0	Falling edge0		
	PROFINET interface [X1]\Digital inputs\Channel1			
	Channel address	I0.1	Input filters	6.4 millisec
	Enable pulse catch	0		
C	PROFINET interface [X1]\Digital inputs\Channel1\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49153
	Event name:	0	Hardware interrupt:	0
	Rising edge1	Rising edge1		
	PROFINET interface [X1]\Digital inputs\Channel1\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49281
	Event name:	0	Hardware interrupt:	0
	Falling edge1	Falling edge1		
	PROFINET interface [X1]\Digital inputs\Channel2			
	Channel address	I0.2	Input filters	6.4 millisec
D	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel2\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49154
	Event name:	0	Hardware interrupt:	0
	Rising edge2	Rising edge2		
	PROFINET interface [X1]\Digital inputs\Channel2\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49282
	Event name:	0	Hardware interrupt:	0
	Falling edge2	Falling edge2		
	Owner	Project name Automation Production Station Code		Date 7/12/2025
E	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
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A	PROFINET interface [X1]\Digital inputs\Channel3			
	Channel address	I0.3	Input filters	6.4 millisec
B	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49155
	Event name:	0	Hardware interrupt:	0
C	Rising edge3	Rising edge3		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49283
	Event name:	0	Hardware interrupt:	0
D	Falling edge3	Falling edge3		
	PROFINET interface [X1]\Digital inputs\Channel4			
	Channel address	I0.4	Input filters	6.4 millisec
	Enable pulse catch	0		
E	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49156
	Event name:	0	Hardware interrupt:	0
	Rising edge4	Rising edge4		
F	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49284
	Event name:	0	Hardware interrupt:	0
	Falling edge4	Falling edge4		
D	PROFINET interface [X1]\Digital inputs\Channel5			
	Channel address	I0.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel5\			
E	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49157
	Event name:	0	Hardware interrupt:	0
	Rising edge5	Rising edge5		
	PROFINET interface [X1]\Digital inputs\Channel5\			
F	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49285
	Event name:	0	Hardware interrupt:	0
	Falling edge5	Falling edge5		
	PROFINET interface [X1]\Digital inputs\Channel6			
G	Channel address	I0.6	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel6\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49158
H	Event name:	0	Hardware interrupt:	0
	Owner	Project name Automation Production Station Code		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
	Designed By	Location		
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	1	2	3	4
A	Rising edge6	Rising edge6		
	PROFINET interface [X1]\Digital inputs\Channel6\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49286
	Event name:	0	Hardware inter-rupt:	0
	Falling edge6	Falling edge6		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Channel address	I0.7	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel7\			
B	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49159
	Event name:	0	Hardware inter-rupt:	0
	Rising edge7	Rising edge7		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49287
	Event name:	0	Hardware inter-rupt:	0
	Falling edge7	Falling edge7		
	PROFINET interface [X1]\Digital inputs\Channel8\			
C	Channel address	I1.0	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel8\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49160
	Event name:	0	Hardware inter-rupt:	0
	Rising edge8	Rising edge8		
	PROFINET interface [X1]\Digital inputs\Channel8\			
D	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49288
	Event name:	0	Hardware inter-rupt:	0
	Falling edge8	Falling edge8		
	PROFINET interface [X1]\Digital inputs\Channel9\			
	Channel address	I1.1	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel9\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49161
	Event name:	0	Hardware inter-rupt:	0
	Rising edge9	Rising edge9		
	PROFINET interface [X1]\Digital inputs\Channel9\			
E	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49289
	Event name:	0	Hardware inter-rupt:	0
	Falling edge9	Falling edge9		
F	Owner	Project name	Automation Production Station Code	Date 7/12/2025
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location		
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A	PROFINET interface [X1]\Digital inputs\Channel10			
	Channel address	I1.2	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49162
	Event name:	0	Hardware interrupt:	0
	Rising edge10	Rising edge10		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49290
	Event name:	0	Hardware interrupt:	0
B	Falling edge10	Falling edge10		
	PROFINET interface [X1]\Digital inputs\Channel11			
	Channel address	I1.3	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49163
	Event name:	0	Hardware interrupt:	0
	Rising edge11	Rising edge11		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49291
C	Event name:	0	Hardware interrupt:	0
	Falling edge11	Falling edge11		
	PROFINET interface [X1]\Digital inputs\Channel12			
	Channel address	I1.4	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel13			
	Channel address	I1.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Analog inputs\Noise reduction			
	Integration time	50 Hz (20 ms)		
D	PROFINET interface [X1]\Analog inputs\Channel0			
	Channel address	IW64	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Analog inputs\Channel1			
	Channel address	IW66	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Digital outputs			
	Reaction to CPU STOP	Use substitute value		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
	Designed By	Location		
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A	PROFINET interface [X1]\Digital outputs\Channel0					
	Channel address	Q0.0	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel1					
	Channel address	Q0.1	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel2					
	Channel address	Q0.2	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel3					
	Channel address	Q0.3	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel4					
	Channel address	Q0.4	Substitute a value of 1 on a change from RUN to STOP.	0		
B	PROFINET interface [X1]\Digital outputs\Channel5					
	Channel address	Q0.5	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel6					
	Channel address	Q0.6	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel7					
	Channel address	Q0.7	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel8					
	Channel address	Q1.0	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel9					
	Channel address	Q1.1	Substitute a value of 1 on a change from RUN to STOP.	0		
C	PROFINET interface [X1]\Operating mode					
	IO controller	True	IO system			
	Device number	0	IO device	False		
	PROFINET interface [X1]\I/O addresses\Input addresses					
	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Input addresses					
	Start address	64	End address	67		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Output addresses					
D	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Output addresses					
	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025		
	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code					
	Location					
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A	PROFINET interface [X1]\Advanced options\Interface options				
	Support device replacement without exchangeable medium	True	Use IEC V2.2 LLDP mode	True	
B	Keep-Alive connection monitoring:	30s			
	PROFINET interface [X1]\Advanced options\Real time settings\IO communication				
C	Send clock:	1.000ms			
	PROFINET interface [X1]\Advanced options\Real time settings\Real time options				
D	Calculated bandwidth for cyclic IO data:	0.000ms	Calculated bandwidth for cyclic IO data:	0.000%	
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\General				
E	Name	Port_1	Author	MTC-MECH-05	
	Comment				
F	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Local port:				
	Local port:	PLC_2\PROFINET interface_1 [X1]\Port_1 [X1 P1]	Medium:	Copper	
G	Cable name:	---			
					
H	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Partner port:				
	Monitoring of partner port is not possible	Partner port:	Any partner		
I	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Activate				
	Activate this port for use	True			
J	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Connection				
	Transmission rate / duplex:	Automatic	Monitor	False	
K	Enable autonegotiation	True			
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Boundaries				
L	End of detection of accessible devices	False	End of topology discovery	False	
	End of the sync domain	False			
M	High speed counters (HSC)\HSC1\General\Enable				
	Enable this high speed counter	0	Enable this high speed counter	0	
N	Enable this high speed counter	0	Enable this high speed counter	0	
	Enable this high speed counter	0	Enable this high speed counter	0	
O	High speed counters (HSC)\HSC1\General\Project information				
	Name	HSC_1	Comment		
P	Owner	Project name Automation Production Station Code		Date 7/12/2025	
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Q	Designed By	Location			
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A	Name	HSC_2	Comment	
	Name	HSC_3	Comment	
	Name	HSC_4	Comment	
	Name	HSC_5	Comment	
	Name	HSC_6	Comment	
	High speed counters (HSC)\HSC1\I/O addresses\Input addresses			
B	Start address	1000.0	End address	1003.7
	Start address	1004.0	End address	1007.7
	Organization block	0	Start address	1008.0
	End address	1011.7	Organization block	0
	Process image	0	Start address	1012.0
	End address	1015.7	Organization block	0
	Process image	0	Start address	1016.0
	End address	1019.7	Organization block	0
	Process image	0	Start address	1020.0
	End address	1023.7	Organization block	0
C	Process image	0	Organization block	0
	Process image	0	Process image	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Enable			
	Enable this pulse generator	0	Enable this pulse generator	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Project information			
	Name	Pulse_1	Comment	
	Name	Pulse_2	Comment	
	Pulse generators (PTO/PWM)\PTO1/PWM1\I/O addresses\Output addresses			
	Start address	1000.0	End address	1001.7
	Start address	1002.0	End address	1003.7
D	Organization block	0	Organization block	0
	Process image	0	Process image	0
	Startup			
	Startup after POWER ON	Warm restart - mode before POWER OFF	Comparison preset to actual configuration	Startup CPU even if mismatch
	Configuration time	60000ms	OBs should be interruptible	1
	Cycle			
	Cycle monitoring time	150ms		
	Enable minimum cycle time for cyclic OBs	0	Minimum cycle time	1ms
	Communication load			
	Cycle load due to communication	20%		
E	System and clock memory\System memory bits			
	Enable the use of system memory byte	1	Address of system memory byte (MBx)	1
	First cycle	%M1.0 (FirstScan)	Diagnostic status changed	%M1.1 (DiagStatusUpdate)
	Always 1 (high)	%M1.2 (Tag_1)	Always 0 (low)	%M1.3 (AlwaysFALSE)
F	Owner	Project name Automation Production Station Code		Date 7/12/2025
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A	System and clock memory\Clock memory bits			
	Enable the use of clock memory byte	1	Address of clock memory byte (MBx)	0
	10 Hz clock	%M0.0 (Clock_10Hz)	5 Hz clock	%M0.1 (Clock_5Hz)
	2.5 Hz clock	%M0.2 (Clock_2.5Hz)	2 Hz clock	%M0.3 (Clock_2Hz)
	1.25 Hz clock	%M0.4 (Clock_1.25Hz)	1 Hz clock	%M0.5 (Clock_1Hz)
	0.625 Hz clock	%M0.6 (Clock_0.625Hz)	0.5 Hz clock	%M0.7 (Clock_0.5Hz)
B	Web server\General			
	Activate web server on this module	False	Permit access only with HTTPS	True
	Web server\Automatic update			
	Enable automatic update	True	Update interval	0s
C	Web server\User interface languages			
	Assign project language		User interface languages	
	English (United States)		German	
	English (United States)		English	
	English (United States)		French	
	English (United States)		Spanish	
	English (United States)		Italian	
	English (United States)		Chinese (simplified)	
D	Web server\User management			
	User name		User rights	
	Everybody			
E	Web server\User-defined web pages			
	Application name	HTML source path	Default HTML page	Files with dynamic content
			index.htm	.htm;.html
				333
				334
F	User interface languages			
	Assign project language		User interface languages	
	English (United States)		German	
	English (United States)		English	
	English (United States)		French	
	English (United States)		Spanish	
	English (United States)		Italian	
	English (United States)		Chinese (simplified)	
	Time of day\Local time			
	Time zone	(UTC +01:00) Berlin, Bern, Brussels, Rome, Stockholm, Vienna		
	Time of day\Daylight saving time			
	Activate daylight saving time	1	Difference between standard and daylight saving time	60mins
	Time of day\Daylight saving time\Start of daylight saving time			
	Starting week of the month:	Last		Sunday
	of	March	at	01:00 a.m.
	Time of day\Daylight saving time\Start of standard time			
		Last		Sunday
	of	October	at	02:00 a.m.
	Protection & Security			
	Level of protection	No protection		
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A

Protection & Security\Connection mechanisms

Permit access with True
 PUT/GET communication from remote partner

Overview of addresses\Overview of addresses\Overview of addresses

Inputs	True	Outputs	True
Address gaps	False	Slot	True

B

C

D

E

F

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A	Type	I	Addr. from	0	Addr. to	1
	Module	DI 14/DQ 10_1	PIP	Automatic update	Device name	PLC_2 [CPU 1214C DC/DC/DC]
B	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 1	Addr. to	1
C	Type	O	Addr. from	0	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Module	DI 14/DQ 10_1	PIP	Automatic update	Master / IO system	-
D	Device number	-	Size	2 Bytes	Addr. to	67
	Rack	0	Slot	1 1	Device name	PLC_2 [CPU 1214C DC/DC/DC]
E	Type	I	Addr. from	64	Master / IO system	-
	Module	AI 2_1	PIP	Automatic update	Addr. to	1003
F	Device number	-	Size	4 Bytes	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Rack	0	Slot	1 2	Master / IO system	-
G	Type	I	Addr. from	1000	Addr. to	1007
	Module	HSC_1	PIP	Automatic update	Device name	PLC_2 [CPU 1214C DC/DC/DC]
H	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 16	Addr. to	1007
I	Type	I	Addr. from	1004	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Module	HSC_2	PIP	Automatic update	Master / IO system	-
J	Device number	-	Size	4 Bytes	Addr. to	1007
	Rack	0	Slot	1 17	Device name	PLC_2 [CPU 1214C DC/DC/DC]
K	Type	I	Addr. from	1008	Master / IO system	-
	Module	HSC_3	PIP	Automatic update	Addr. to	1011
L	Device number	-	Size	4 Bytes	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Rack	0	Slot	1 18	Master / IO system	-
M	Type	I	Addr. from	1012	Addr. to	1015
	Module	HSC_4	PIP	Automatic update	Device name	PLC_2 [CPU 1214C DC/DC/DC]
N	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 19	Addr. to	1019
O	Type	I	Addr. from	1016	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Module	HSC_5	PIP	Automatic update	Master / IO system	-
P	Device number	-	Size	4 Bytes	Addr. to	1019
	Rack	0	Slot	1 20	Device name	PLC_2 [CPU 1214C DC/DC/DC]
Q	Type	I	Addr. from	1020	Master / IO system	-
	Module	HSC_6	PIP	Automatic update	Addr. to	1023
R	Device number	-	Size	4 Bytes	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Rack	0	Slot	1 20	Master / IO system	-

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A	Rack	0	Slot	1 21		
	Type	O	Addr. from	1000	Addr. to	1001
	Module	Pulse_1	PIP	Automatic update	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Device num- ber	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 32		
	Type	O	Addr. from	1002	Addr. to	1003
	Module	Pulse_2	PIP	Automatic update	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Device num- ber	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 33		
	Type	O	Addr. from	1004	Addr. to	1005
B	Module	Pulse_3	PIP	Automatic update	Device name	PLC_2 [CPU 1214C DC/DC/DC]
	Device num- ber	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 34		
	Type	O	Addr. from	1006	Addr. to	1007
	Module	Pulse_4	PIP	Automatic update	Device name	PLC_2 [CPU 1214C DC/DC/DC]
C	Device num- ber	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 35		

D																										
E																										
F	<table border="1"> <tr> <td>Owner</td> <td>Project name</td> <td>Automation Production Station Code</td> <td>Date</td> <td>7/12/2025</td> </tr> <tr> <td>Operator</td> <td>Project path</td> <td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td> </tr> <tr> <td>Designed By</td> <td>Description 1st</td> <td colspan="3"></td> </tr> <tr> <td>Checked By</td> <td>Description 2nd</td> <td>Language</td> <td colspan="2">en-US</td> </tr> <tr> <td>Approved By</td> <td>1st View</td> <td>Version</td> <td colspan="2">Sheet 71 - 12</td> </tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Description 1st				Checked By	Description 2nd	Language	en-US		Approved By	1st View	Version	Sheet 71 - 12	
Owner	Project name	Automation Production Station Code	Date	7/12/2025																						
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																								
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A

Automation Production Station Code

PLC_3 [CPU 1214C DC/DC/DC]

PLC_3			
General\Project information			
Name	PLC_3	Author	MTC-MECH-05
Comment		Slot	1
Rack	0		
General\Catalog information			
Short designation	CPU 1214C DC/DC/DC	Description	Work memory 75 KB; 24VDC power supply with DI14 x 24VDC SINK/SOURCE, DQ10 x 24VDC and AI2 on board; 6 high-speed counters and 4 pulse outputs on board; signal board expands on-board I/O; up to 3 communication modules for serial communication; up to 8 signal modules for I/O expansion; PROFINET interface for programming, HMI and PLC-to-PLC communication
Article number	6ES7 214-1AG40-0XB0	Firmware version	V4.0
General\Identification & Maintenance			
Plant designation		Location identifier	
Installation date	2025-06-11 06:03:00.170	Additional information	
Connection resources			
PG communication:	1	OP communication:	1
S7 basic communication:	0	S7 communication:	0
Maximum number of S7 connection resources:	38		
PROFINET interface [X1]\General			
Name	PROFINET interface_1	Author	MTC-MECH-05
Comment			
PROFINET interface [X1]\General\Project information			
Name	DI 14/DQ 10_1	Comment	
Name	AI 2_1	Comment	
Name	DI 4x24VDC_1	Comment	
PROFINET interface [X1]\General\Catalog information			
Short designation	DI4 signal board (200 kHz)	Description	Signal board DI4 x 24 VDC / 200 kHz SOURCE; selectable input delay; plug-in terminal blocks
Article number	6ES7 221-3BD30-0XB0	Firmware version	V1.0
PROFINET interface [X1]\Ethernet addresses\Interface networked with			
Subnet:	PN/IE_1		
PROFINET interface [X1]\Ethernet addresses\IP protocol			
IP configuration	Set IP address in the project	IP address:	192.168.0.3
Subnet mask:	255.255.255.0	Use router	False

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
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PROFINET interface [X1]\Ethernet addresses\PROFINET			
PROFINET device name is set directly at the device	False	Generate PROFINET device name automatically	True
PROFINET device name:	plc_3	Converted name:	plcxb3116c
Device number:	0		
PROFINET interface [X1]\Time synchronization			
Enable time synchronization via NTP server	Enable time synchronization via NTP server		IP addresses
Server 1	0.0.0.0	Server 2	0.0.0.0
Server 3	0.0.0.0	Server 4	0.0.0.0
Update interval	10sec		
PROFINET interface [X1]\Digital inputs\Channel0\			
Channel address	I0.0	Input filters	6.4 millisec
Channel address	I4.0	Input filters	6.4 millisec
Enable pulse catch	0	Enable pulse catch	0
PROFINET interface [X1]\Digital inputs\Channel0\			
Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49152
Enable rising edge detection	0	Event name:	0
Hardware interrupt:	0	RidPrefixRisingEdgeEvent	49152
Rising edge0	Rising edge0	Event name:	0
Hardware interrupt:	0	Rising edge0	Rising edge0
PROFINET interface [X1]\Digital inputs\Channel0\			
Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49280
Enable falling edge detection	0	Event name:	0
Hardware interrupt:	0	RidPrefixFallingEdgeEvent	49280
Falling edge0	Falling edge0	Event name:	0
Hardware interrupt:	0	Falling edge0	Falling edge0
PROFINET interface [X1]\Digital inputs\Channel1\			
Channel address	I0.1	Input filters	6.4 millisec
Channel address	I4.1	Input filters	6.4 millisec
Enable pulse catch	0	Enable pulse catch	0
PROFINET interface [X1]\Digital inputs\Channel1\			
Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49153
Enable rising edge detection	0	Event name:	0
Hardware interrupt:	0	RidPrefixRisingEdgeEvent	49153
Rising edge1	Rising edge1	Event name:	0
Hardware interrupt:	0	Rising edge1	Rising edge1

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PROFINET interface [X1]\Digital inputs\Channel1\			
Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49281
Enable falling edge detection	0	Event name:	0
Hardware interrupt:	0	RidPrefixFallin-gEdgeEvent	49281
Falling edge1	Falling edge1	Event name:	0
Hardware interrupt:	0	Falling edge1	Falling edge1
PROFINET interface [X1]\Digital inputs\Channel2\			
Channel address	I0.2	Input filters	6.4 millisec
Channel address	I4.2	Input filters	6.4 millisec
Enable pulse catch	0	Enable pulse catch	0
PROFINET interface [X1]\Digital inputs\Channel2\			
Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49154
Enable rising edge detection	0	Event name:	0
Hardware interrupt:	0	RidPrefixRisingEdg-eEvent	49154
Rising edge2	Rising edge2	Event name:	0
Hardware interrupt:	0	Rising edge2	Rising edge2
PROFINET interface [X1]\Digital inputs\Channel2\			
Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49282
Enable falling edge detection	0	Event name:	0
Hardware interrupt:	0	RidPrefixFallin-gEdgeEvent	49282
Falling edge2	Falling edge2	Event name:	0
Hardware interrupt:	0	Falling edge2	Falling edge2
PROFINET interface [X1]\Digital inputs\Channel3\			
Channel address	I0.3	Input filters	6.4 millisec
Channel address	I4.3	Input filters	6.4 millisec
Enable pulse catch	0	Enable pulse catch	0
PROFINET interface [X1]\Digital inputs\Channel3\			
Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49155
Enable rising edge detection	0	Event name:	0
Hardware interrupt:	0	RidPrefixRisingEdg-eEvent	49155
Rising edge3	Rising edge3	Event name:	0
Hardware interrupt:	0	Rising edge3	Rising edge3
PROFINET interface [X1]\Digital inputs\Channel3\			
Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49283
Enable falling edge detection	0	Event name:	0

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	1	2	3	4
A	Hardware interrupt: Falling edge3 Hardware interrupt: PROFINET interface [X1]\Digital inputs\Channel4 Channel address Enable pulse catch	0 Falling edge3 0 10.4 0	RidPrefixFallin- gEdgeEvent Falling edge3 Event name: Input filters	49283 Falling edge3 0 6.4 millisec
B	Enable rising edge detection Event name: Rising edge4 PROFINET interface [X1]\Digital inputs\Channel4 Enable falling edge detection Event name: Falling edge4	0 0 Rising edge4 0 0 Falling edge4	RidPrefixRisingEdg- eEvent Hardware inter- rupt:	49156 0 0
C	Enable rising edge detection Event name: Rising edge5 PROFINET interface [X1]\Digital inputs\Channel5 Enable falling edge detection Event name: Falling edge5	0 0 Rising edge5 0 0 Falling edge5	RidPrefixRisingEdg- eEvent Hardware inter- rupt:	49157 0 0
D	Enable falling edge detection Event name: Falling edge5 PROFINET interface [X1]\Digital inputs\Channel6 Channel address Enable pulse catch	0 0 Falling edge5 0 0	RidPrefixFallin- gEdgeEvent Hardware inter- rupt:	49285 0 0
E	Enable rising edge detection Event name: Rising edge6 PROFINET interface [X1]\Digital inputs\Channel6 Enable falling edge detection Event name: Falling edge6	0 0 Rising edge6 0 0 Falling edge6	RidPrefixRisingEdg- eEvent Hardware inter- rupt:	49158 0 0
F	Owner Operator Designed By Checked By Approved By	Project name Project path Location Description 1st Description 2nd 1st View	Automation Production Station Code C:\Users\DEEL\Desktop\VSM\Automation Production Station Code en-US Version	Date 7/12/2025

A	PROFINET interface [X1]\Digital inputs\Channel7\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49159
B	Event name:	0	Hardware interrupt:	0
	Rising edge7	Rising edge7		
C	PROFINET interface [X1]\Digital inputs\Channel8\			
	Channel address	I1.0	Input filters	6.4 millisec
D	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel8\			
E	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49160
	Event name:	0	Hardware interrupt:	0
F	Rising edge8	Rising edge8		
	PROFINET interface [X1]\Digital inputs\Channel9\			
G	Channel address	I1.1	Input filters	6.4 millisec
	Enable pulse catch	0		
H	PROFINET interface [X1]\Digital inputs\Channel9\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49161
I	Event name:	0	Hardware interrupt:	0
	Rising edge9	Rising edge9		
J	PROFINET interface [X1]\Digital inputs\Channel9\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49289
K	Event name:	0	Hardware interrupt:	0
	Falling edge9	Falling edge9		
L	PROFINET interface [X1]\Digital inputs\Channel10\			
	Channel address	I1.2	Input filters	6.4 millisec
M	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel10\			
N	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49162
	Event name:	0	Hardware interrupt:	0
O	Rising edge10	Rising edge10		

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A	PROFINET interface [X1]\Digital inputs\Channel10\		
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent 49290
	Event name:	0	Hardware inter-rupt: 0
	Falling edge10	Falling edge10	
	PROFINET interface [X1]\Digital inputs\Channel11\		
	Channel address	I1.3	Input filters 6.4 millisec
	Enable pulse catch	0	
B	PROFINET interface [X1]\Digital inputs\Channel11\		
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent 49163
	Event name:	0	Hardware inter-rupt: 0
	Rising edge11	Rising edge11	
	PROFINET interface [X1]\Digital inputs\Channel11\		
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent 49291
	Event name:	0	Hardware inter-rupt: 0
	Falling edge11	Falling edge11	
C	PROFINET interface [X1]\Digital inputs\Channel12\		
	Channel address	I1.4	Input filters 6.4 millisec
	Enable pulse catch	0	
	PROFINET interface [X1]\Digital inputs\Channel13\		
	Channel address	I1.5	Input filters 6.4 millisec
	Enable pulse catch	0	
	PROFINET interface [X1]\Analog inputs\Noise reduction\		
	Integration time	50 Hz (20 ms)	
D	PROFINET interface [X1]\Analog inputs\Channel0\		
	Channel address	IW64	Measurement type Voltage
	Voltage range	0..10 V	Smoothing Weak (4 cycles)
			Enable overflow di-agnostics 1
	PROFINET interface [X1]\Analog inputs\Channel1\		
	Channel address	IW66	Measurement type Voltage
	Voltage range	0..10 V	Smoothing Weak (4 cycles)
			Enable overflow di-agnostics 1
	PROFINET interface [X1]\Digital outputs\		
	Reaction to CPU STOP	Use substitute value	
E	PROFINET interface [X1]\Digital outputs\Channel0\		
	Channel address	Q0.0	Substitute a value of 1 on a change from RUN to STOP. 0
	PROFINET interface [X1]\Digital outputs\Channel1\		
	Channel address	Q0.1	Substitute a value of 1 on a change from RUN to STOP. 0
F	Owner	Project name Automation Production Station Code	Date 7/12/2025
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A	PROFINET interface [X1]\Digital outputs\Channel2			
	Channel address	Q0.2	Substitute a value of 1 on a change from RUN to STOP.	0
	PROFINET interface [X1]\Digital outputs\Channel3			
B	Channel address	Q0.3	Substitute a value of 1 on a change from RUN to STOP.	0
	PROFINET interface [X1]\Digital outputs\Channel4			
	Channel address	Q0.4	Substitute a value of 1 on a change from RUN to STOP.	0
C	PROFINET interface [X1]\Digital outputs\Channel5			
	Channel address	Q0.5	Substitute a value of 1 on a change from RUN to STOP.	0
	PROFINET interface [X1]\Digital outputs\Channel6			
D	Channel address	Q0.6	Substitute a value of 1 on a change from RUN to STOP.	0
	PROFINET interface [X1]\Digital outputs\Channel7			
	Channel address	Q0.7	Substitute a value of 1 on a change from RUN to STOP.	0
E	PROFINET interface [X1]\Digital outputs\Channel8			
	Channel address	Q1.0	Substitute a value of 1 on a change from RUN to STOP.	0
	PROFINET interface [X1]\Digital outputs\Channel9			
F	Channel address	Q1.1	Substitute a value of 1 on a change from RUN to STOP.	0
	PROFINET interface [X1]\Operating mode			
	IO controller	True	IO system	
G	Device number	0	IO device	False
	PROFINET interface [X1]\I/O addresses\Input addresses			
	Start address	0.0	End address	1.7
H	Start address	4.0	End address	4.7
	Organization block	0	Organization block	0
	Process image	0	Process image	0
I	PROFINET interface [X1]\I/O addresses\Input addresses			
	Start address	64	End address	67
	Organization block	0	Process image	0
J	PROFINET interface [X1]\I/O addresses\Output addresses			
	Start address	0.0	End address	1.7
	Organization block	0	Process image	0
K	PROFINET interface [X1]\Advanced options\Interface options			
	Support device re-placement without exchangeable medium	True	Use IEC V2.2 LLDP mode	True
	Keep-Alive connection monitoring:	30s		

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A	PROFINET interface [X1]\Advanced options\Real time settings\IO communication			
	Send clock:	1.000ms		
	PROFINET interface [X1]\Advanced options\Real time settings\Real time options			
	Calculated band-width for cyclic IO data:	0.000ms	Calculated band-width for cyclic IO data:	0.000%
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\General			
	Name	Port_1	Author	MTC-MECH-05
	Comment			
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Local port:			
	Local port:	PLC_3\PROFINET interface_1 [X1]\Port_1 [X1 P1]	Medium:	Copper
	Cable name:	---		
B				
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Partner port:			
	Monitoring of partner port is not possible		Partner port:	Any partner
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Activate			
	Activate this port for use	True		
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Connection			
	Transmission rate / duplex:	Automatic	Monitor	False
	Enable autonegotiation	True		
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Boundaries			
	End of detection of accessible devices	False	End of topology discovery	False
C	End of the sync domain	False		
	High speed counters (HSC)\HSC1\General\Enable			
	Enable this high speed counter	0	Enable this high speed counter	0
	Enable this high speed counter	0	Enable this high speed counter	0
	Enable this high speed counter	0	Enable this high speed counter	0
	High speed counters (HSC)\HSC1\General\Project information			
	Name	HSC_1	Comment	
	Name	HSC_2	Comment	
	Name	HSC_3	Comment	
	Name	HSC_4	Comment	
D	Name	HSC_5	Comment	
	Name	HSC_6	Comment	
	Owner			
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E	Operator			
	Location			
	Designed By			
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	Description 2nd			
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A	High speed counters (HSC)\HSC1\I/O addresses\Input addresses <table border="1"> <tr><td>Start address</td><td>1000.0</td><td>End address</td><td>1003.7</td></tr> <tr><td>Start address</td><td>1004.0</td><td>End address</td><td>1007.7</td></tr> <tr><td>Organization block</td><td>0</td><td>Start address</td><td>1008.0</td></tr> <tr><td>End address</td><td>1011.7</td><td>Organization block</td><td>0</td></tr> <tr><td>Process image</td><td>0</td><td>Start address</td><td>1012.0</td></tr> <tr><td>End address</td><td>1015.7</td><td>Organization block</td><td>0</td></tr> <tr><td>Process image</td><td>0</td><td>Start address</td><td>1016.0</td></tr> <tr><td>End address</td><td>1019.7</td><td>Organization block</td><td>0</td></tr> <tr><td>Process image</td><td>0</td><td>Start address</td><td>1020.0</td></tr> <tr><td>End address</td><td>1023.7</td><td>Organization block</td><td>0</td></tr> <tr><td>Process image</td><td>0</td><td>Organization block</td><td>0</td></tr> <tr><td>Process image</td><td>0</td><td>Process image</td><td>0</td></tr> </table>	Start address	1000.0	End address	1003.7	Start address	1004.0	End address	1007.7	Organization block	0	Start address	1008.0	End address	1011.7	Organization block	0	Process image	0	Start address	1012.0	End address	1015.7	Organization block	0	Process image	0	Start address	1016.0	End address	1019.7	Organization block	0	Process image	0	Start address	1020.0	End address	1023.7	Organization block	0	Process image	0	Organization block	0	Process image	0	Process image	0	
Start address	1000.0	End address	1003.7																																															
Start address	1004.0	End address	1007.7																																															
Organization block	0	Start address	1008.0																																															
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Process image	0	Start address	1012.0																																															
End address	1015.7	Organization block	0																																															
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Process image	0	Start address	1020.0																																															
End address	1023.7	Organization block	0																																															
Process image	0	Organization block	0																																															
Process image	0	Process image	0																																															
B	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Enable <table border="1"> <tr><td>Enable this pulse generator</td><td>0</td><td>Enable this pulse generator</td><td>0</td></tr> </table> Pulse generators (PTO/PWM)\PTO1/PWM1\General\Project information <table border="1"> <tr><td>Name</td><td>Pulse_1</td><td>Comment</td><td></td></tr> <tr><td>Name</td><td>Pulse_2</td><td>Comment</td><td></td></tr> </table>	Enable this pulse generator	0	Enable this pulse generator	0	Name	Pulse_1	Comment		Name	Pulse_2	Comment																																						
Enable this pulse generator	0	Enable this pulse generator	0																																															
Name	Pulse_1	Comment																																																
Name	Pulse_2	Comment																																																
C	Pulse generators (PTO/PWM)\PTO1/PWM1\I/O addresses\Output addresses <table border="1"> <tr><td>Start address</td><td>1000.0</td><td>End address</td><td>1001.7</td></tr> <tr><td>Start address</td><td>1002.0</td><td>End address</td><td>1003.7</td></tr> <tr><td>Organization block</td><td>0</td><td>Organization block</td><td>0</td></tr> <tr><td>Process image</td><td>0</td><td>Process image</td><td>0</td></tr> </table> Startup <table border="1"> <tr><td>Startup after POWER ON</td><td>Warm restart - mode before POWER OFF</td><td>Comparison preset to actual configuration</td><td>Startup CPU even if mismatch</td></tr> <tr><td>Configuration time</td><td>60000ms</td><td>OBs should be interruptible</td><td>1</td></tr> </table>	Start address	1000.0	End address	1001.7	Start address	1002.0	End address	1003.7	Organization block	0	Organization block	0	Process image	0	Process image	0	Startup after POWER ON	Warm restart - mode before POWER OFF	Comparison preset to actual configuration	Startup CPU even if mismatch	Configuration time	60000ms	OBs should be interruptible	1																									
Start address	1000.0	End address	1001.7																																															
Start address	1002.0	End address	1003.7																																															
Organization block	0	Organization block	0																																															
Process image	0	Process image	0																																															
Startup after POWER ON	Warm restart - mode before POWER OFF	Comparison preset to actual configuration	Startup CPU even if mismatch																																															
Configuration time	60000ms	OBs should be interruptible	1																																															
D	Cycle <table border="1"> <tr><td>Cycle monitoring time</td><td>150ms</td><td></td><td></td></tr> <tr><td>Enable minimum cycle time for cyclic OBs</td><td>0</td><td>Minimum cycle time</td><td>1ms</td></tr> </table> Communication load <table border="1"> <tr><td>Cycle load due to communication</td><td>20%</td><td></td><td></td></tr> </table>	Cycle monitoring time	150ms			Enable minimum cycle time for cyclic OBs	0	Minimum cycle time	1ms	Cycle load due to communication	20%																																							
Cycle monitoring time	150ms																																																	
Enable minimum cycle time for cyclic OBs	0	Minimum cycle time	1ms																																															
Cycle load due to communication	20%																																																	
E	System and clock memory\System memory bits <table border="1"> <tr><td>Enable the use of system memory byte</td><td>1</td><td>Address of system memory byte (MBx)</td><td>1</td></tr> <tr><td>First cycle</td><td>%M1.0 (FirstScan)</td><td>Diagnostic status changed</td><td>%M1.1 (DiagStatusUpdate)</td></tr> <tr><td>Always 1 (high)</td><td>%M1.2 (AlwaysTRUE)</td><td>Always 0 (low)</td><td>%M1.3 (AlwaysFALSE)</td></tr> </table> System and clock memory\Clock memory bits <table border="1"> <tr><td>Enable the use of clock memory byte</td><td>1</td><td>Address of clock memory byte (MBx)</td><td>0</td></tr> <tr><td>10 Hz clock</td><td>%M0.0 (Clock_10Hz)</td><td>5 Hz clock</td><td>%M0.1 (Clock_5Hz)</td></tr> <tr><td>2.5 Hz clock</td><td>%M0.2 (Clock_2.5Hz)</td><td>2 Hz clock</td><td>%M0.3 (Clock_2Hz)</td></tr> <tr><td>1.25 Hz clock</td><td>%M0.4 (Clock_1.25Hz)</td><td>1 Hz clock</td><td>%M0.5 (Clock_1Hz)</td></tr> <tr><td>0.625 Hz clock</td><td>%M0.6 (Clock_0.625Hz)</td><td>0.5 Hz clock</td><td>%M0.7 (Clock_0.5Hz)</td></tr> </table>	Enable the use of system memory byte	1	Address of system memory byte (MBx)	1	First cycle	%M1.0 (FirstScan)	Diagnostic status changed	%M1.1 (DiagStatusUpdate)	Always 1 (high)	%M1.2 (AlwaysTRUE)	Always 0 (low)	%M1.3 (AlwaysFALSE)	Enable the use of clock memory byte	1	Address of clock memory byte (MBx)	0	10 Hz clock	%M0.0 (Clock_10Hz)	5 Hz clock	%M0.1 (Clock_5Hz)	2.5 Hz clock	%M0.2 (Clock_2.5Hz)	2 Hz clock	%M0.3 (Clock_2Hz)	1.25 Hz clock	%M0.4 (Clock_1.25Hz)	1 Hz clock	%M0.5 (Clock_1Hz)	0.625 Hz clock	%M0.6 (Clock_0.625Hz)	0.5 Hz clock	%M0.7 (Clock_0.5Hz)																	
Enable the use of system memory byte	1	Address of system memory byte (MBx)	1																																															
First cycle	%M1.0 (FirstScan)	Diagnostic status changed	%M1.1 (DiagStatusUpdate)																																															
Always 1 (high)	%M1.2 (AlwaysTRUE)	Always 0 (low)	%M1.3 (AlwaysFALSE)																																															
Enable the use of clock memory byte	1	Address of clock memory byte (MBx)	0																																															
10 Hz clock	%M0.0 (Clock_10Hz)	5 Hz clock	%M0.1 (Clock_5Hz)																																															
2.5 Hz clock	%M0.2 (Clock_2.5Hz)	2 Hz clock	%M0.3 (Clock_2Hz)																																															
1.25 Hz clock	%M0.4 (Clock_1.25Hz)	1 Hz clock	%M0.5 (Clock_1Hz)																																															
0.625 Hz clock	%M0.6 (Clock_0.625Hz)	0.5 Hz clock	%M0.7 (Clock_0.5Hz)																																															
F	<table border="1"> <tr><td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr><td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr><td>Designed By</td><td>Description 1st</td><td colspan="3"></td></tr> <tr><td>Checked By</td><td>Description 2nd</td><td>Language</td><td colspan="2">en-US</td></tr> <tr><td>Approved By</td><td>1st View</td><td>Version</td><td colspan="2">Sheet 72 - 9</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Description 1st				Checked By	Description 2nd	Language	en-US		Approved By	1st View	Version	Sheet 72 - 9																									
Owner	Project name	Automation Production Station Code	Date	7/12/2025																																														
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																																																
Designed By	Description 1st																																																	
Checked By	Description 2nd	Language	en-US																																															
Approved By	1st View	Version	Sheet 72 - 9																																															

Web server\General			
Activate web server on this module	False	Permit access only with HTTPS	True
Web server\Automatic update			
Enable automatic update	True	Update interval	0s
Web server\User interface languages			
Assign project language		User interface languages	
English (United States)		German	
English (United States)		English	
English (United States)		French	
English (United States)		Spanish	
English (United States)		Italian	
English (United States)		Chinese (simplified)	
Web server\User management			
User name		User rights	
Everybody			
Web server\User-defined web pages			
Application name	HTML source path	Default HTML page	Files with dynamic content
		index.htm	.htm;.html
			333
			334
User interface languages			
Assign project language		User interface languages	
English (United States)		German	
English (United States)		English	
English (United States)		French	
English (United States)		Spanish	
English (United States)		Italian	
English (United States)		Chinese (simplified)	
Time of day\Local time			
Time zone	(UTC +01:00) Berlin, Bern, Brussels, Rome, Stockholm, Vienna		
Time of day\Daylight saving time			
Activate daylight saving time	1	Difference between standard and daylight saving time	60mins
Time of day\Daylight saving time\Start of daylight saving time			
Starting week of the month:	Last		Sunday
of	March	at	01:00 a.m.
Time of day\Daylight saving time\Start of standard time			
of	Last		Sunday
of	October	at	02:00 a.m.
Protection & Security			
Level of protection	No protection		
Protection & Security\Connection mechanisms			
Permit access with PUT/GET communication from remote partner	True		
Overview of addresses\Overview of addresses\Overview of addresses			
Inputs	True	Outputs	True
Owner	Project name	Automation Production Station Code	Date 7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By	Description 1st		
Checked By	Description 2nd	Language	en-US
Approved By	1st View	Version	Sheet 72 - 10

	1	2	3	4
A	Address gaps	False	Slot	True
B				
C				
D				
E				
F	Owner	Project name	Automation Production Station Code	Date 7/12/2025
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location		
	Checked By	Description 1st		
	Approved By	Description 2nd	Language en-US	
		1st View	Version	Sheet 72 - 11

A	Type	I	Addr. from	0	Addr. to	1
	Module	DI 14/DQ 10_1	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 1		
	Type	O	Addr. from	0	Addr. to	1
	Module	DI 14/DQ 10_1	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 1		
	Type	I	Addr. from	64	Addr. to	67
	Module	AI 2_1	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
B	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 2		
	Type	I	Addr. from	4	Addr. to	4
	Module	DI 4x24VDC_1	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	1 Bytes	Master / IO system	-
	Rack	0	Slot	1 3		
	Type	I	Addr. from	1000	Addr. to	1003
	Module	HSC_1	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 16		
C	Type	I	Addr. from	1004	Addr. to	1007
	Module	HSC_2	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 17		
	Type	I	Addr. from	1008	Addr. to	1011
	Module	HSC_3	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 18		
	Type	I	Addr. from	1012	Addr. to	1015
	Module	HSC_4	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
D	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 19		
	Type	I	Addr. from	1016	Addr. to	1019
	Module	HSC_5	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
E	Owner	Project name Automation Production Station Code			Date	7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code				
	Designed By	Location				
	Checked By	Description 1st				
	Approved By	Description 2nd	Language	en-US	Version	Sheet 72 - 12

Owner	Project name Automation Production Station Code		Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 72 - 12

A	Rack	0	Slot	1 20		
	Type	I	Addr. from	1020	Addr. to	1023
	Module	HSC_6	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 21		
	Type	O	Addr. from	1000	Addr. to	1001
	Module	Pulse_1	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 32		
	Type	O	Addr. from	1002	Addr. to	1003
B	Module	Pulse_2	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 33		
	Type	O	Addr. from	1004	Addr. to	1005
	Module	Pulse_3	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 34		
	Type	O	Addr. from	1006	Addr. to	1007
	Module	Pulse_4	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
C	Rack	0	Slot	1 35		
D						
E						
F	Owner		Project name	Automation Production Station Code	Date	7/12/2025
	Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
	Designed By		Location			
	Checked By	Description 1st				
	Approved By	Description 2nd	Language	en-US		
			Version		Sheet	72 - 13

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Project path				
Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd			
	Language			
	en-US			
	Version			
	Sheet 72 - 13			

A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks

AUTO 3 [FC1]

B

AUTO 3 Properties			
General			
Name	AUTO 3	Number	1
Type	FC	Language	LAD
Numbering	Automatic		

8

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
AUTO 3	Void		

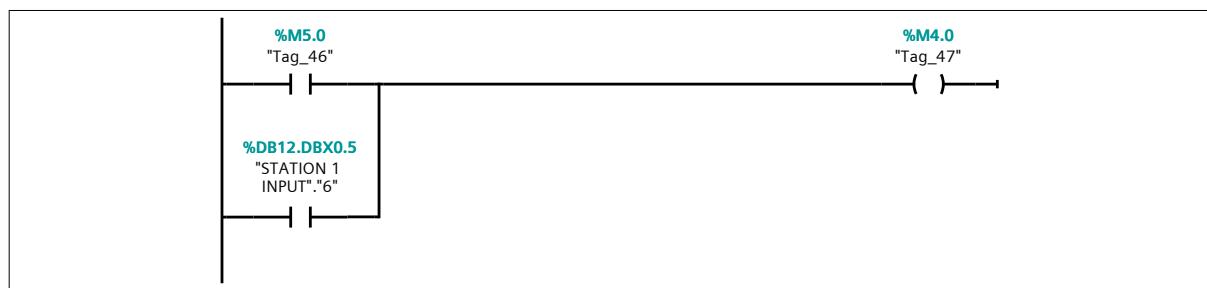
Network 1:

4



Network 2:

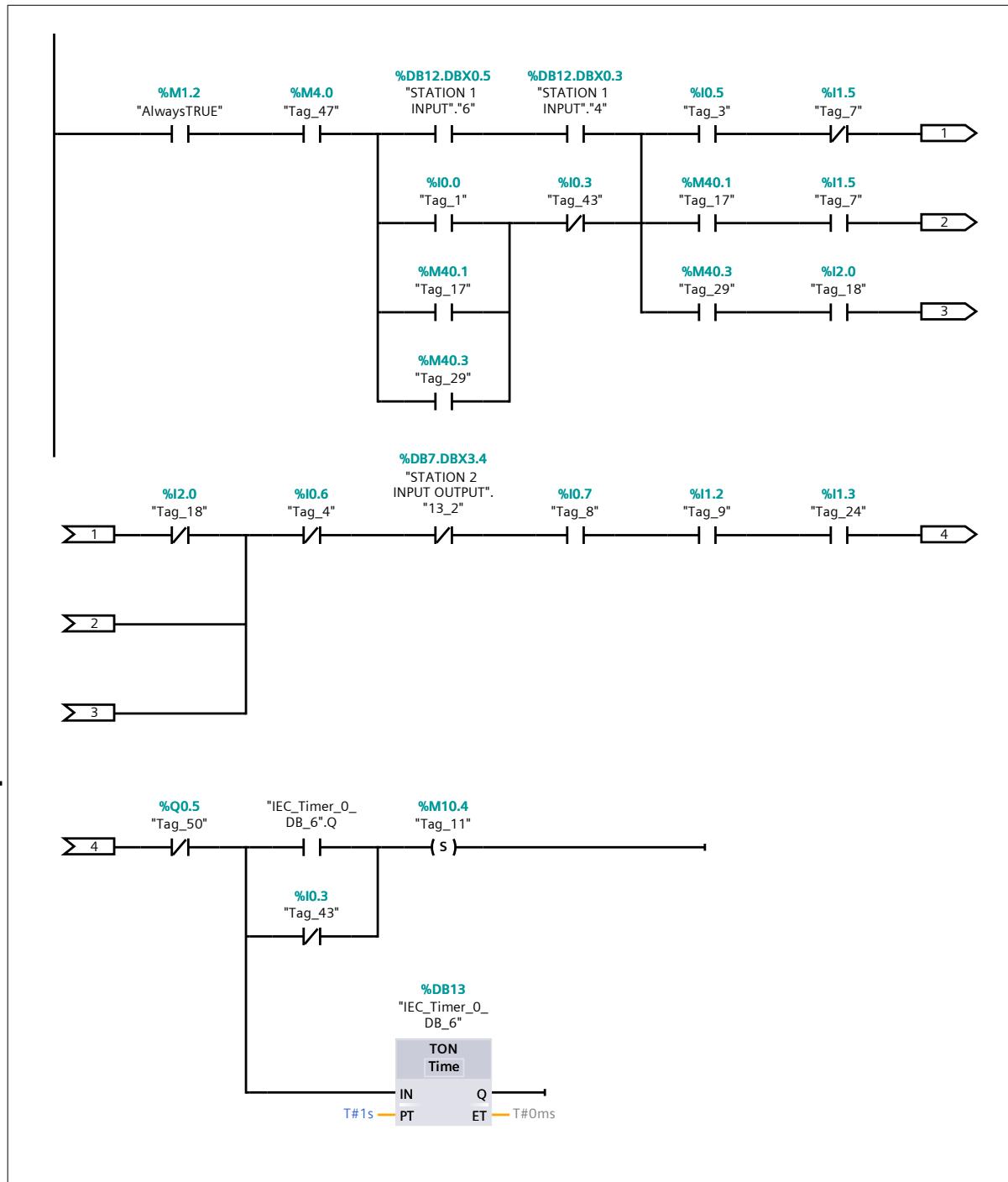
E



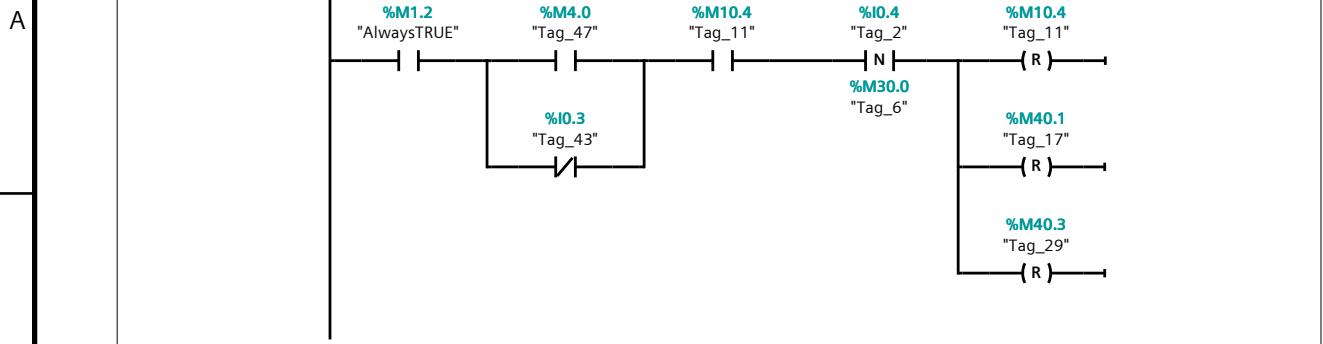
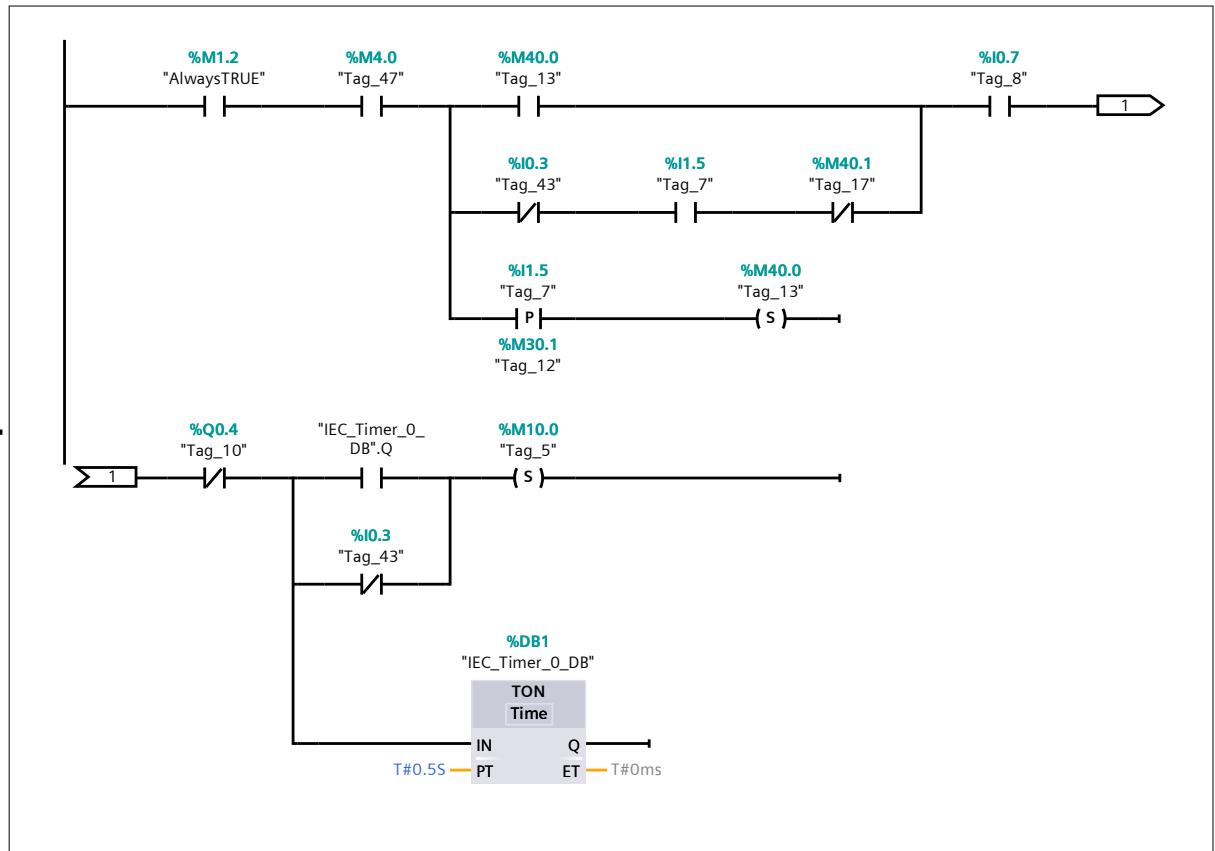
Network 3: INDEXING RUN

F

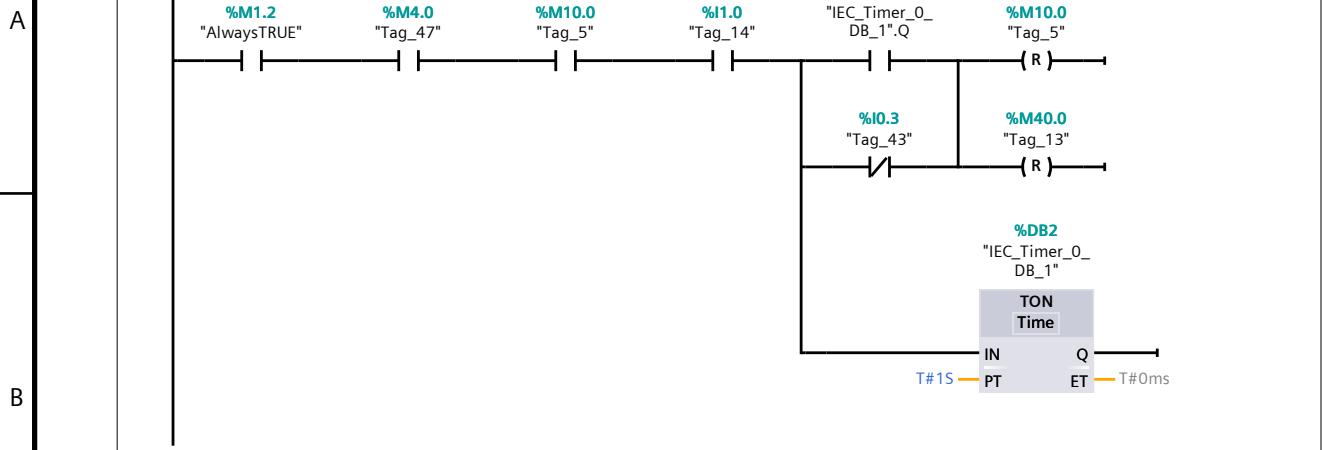
Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet	73 - 1

Network 3: INDEXING RUN**Network 4: INDEXING STOP**

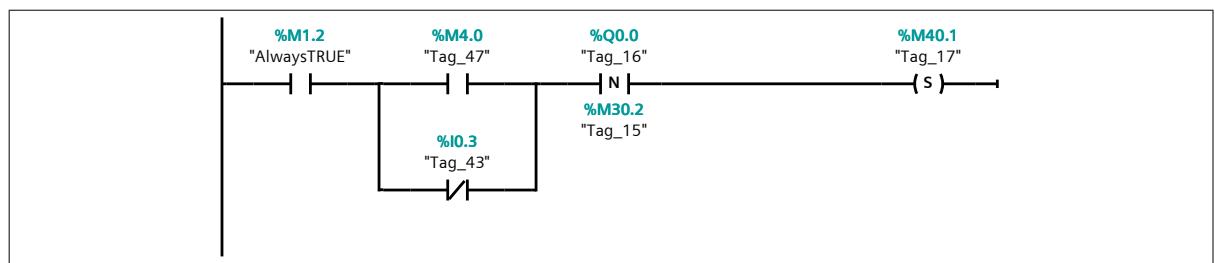
Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 73 - 2

**Network 5: FILLING MODULE EXTEND****Network 5: FILLING MODULE EXTEND****Network 6: FM RETRACT**

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
Location	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 73 - 3



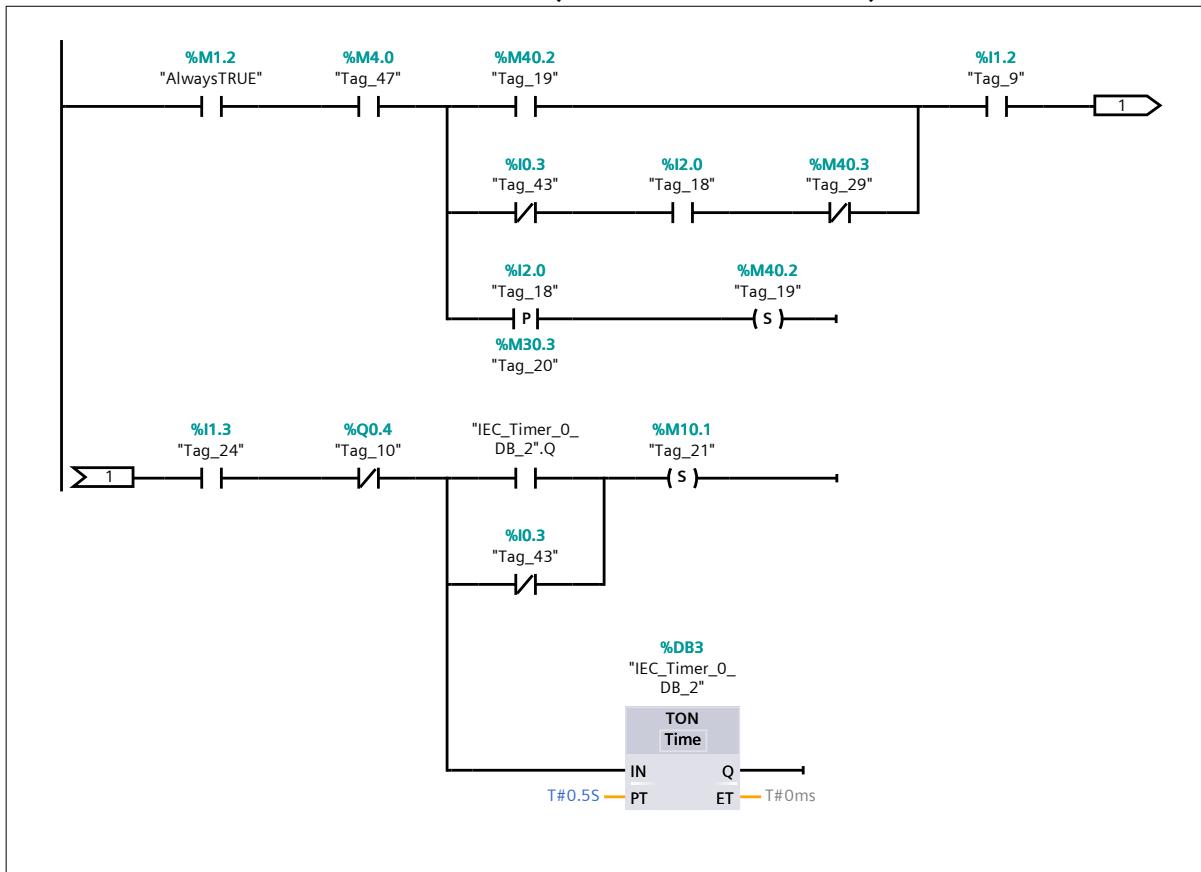
Network 7: FOR INDEXING RUN 2 AFTER FILLING



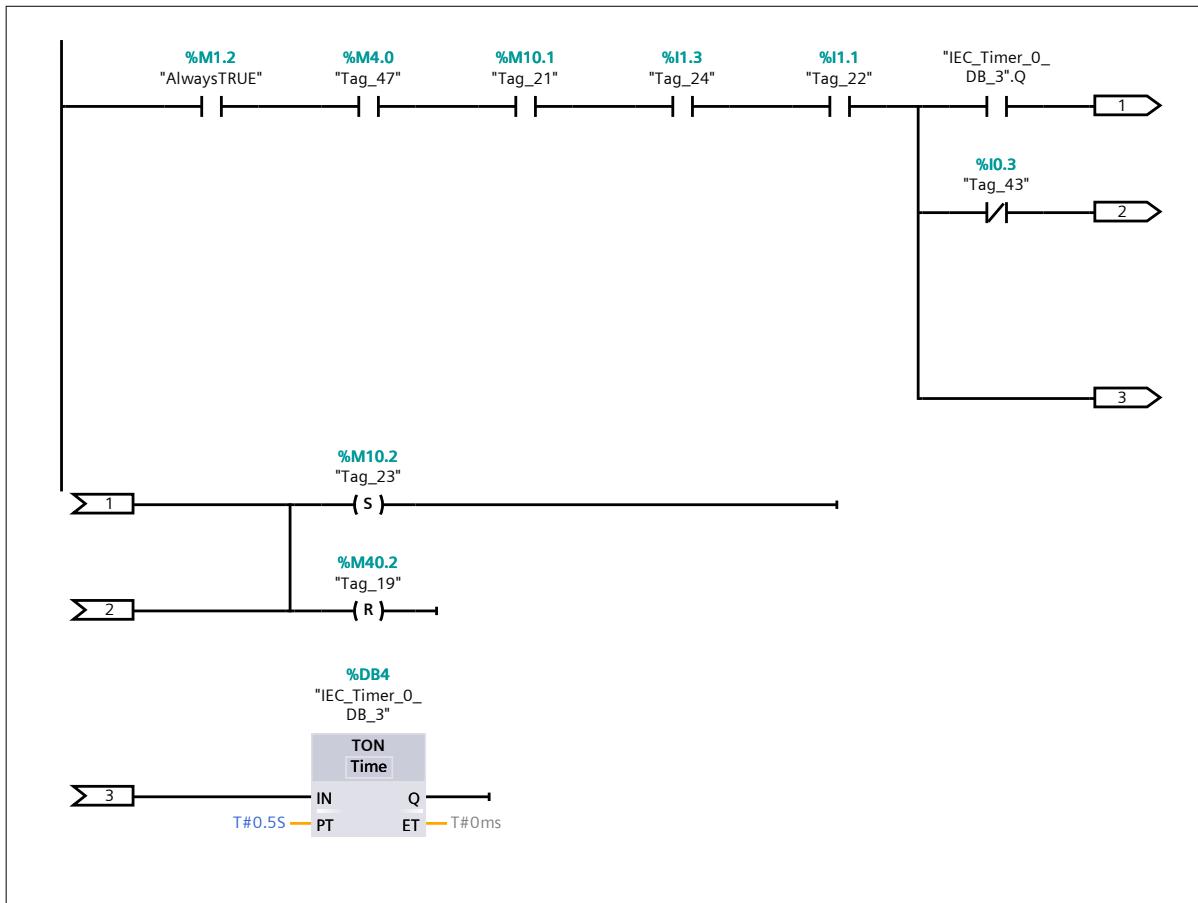
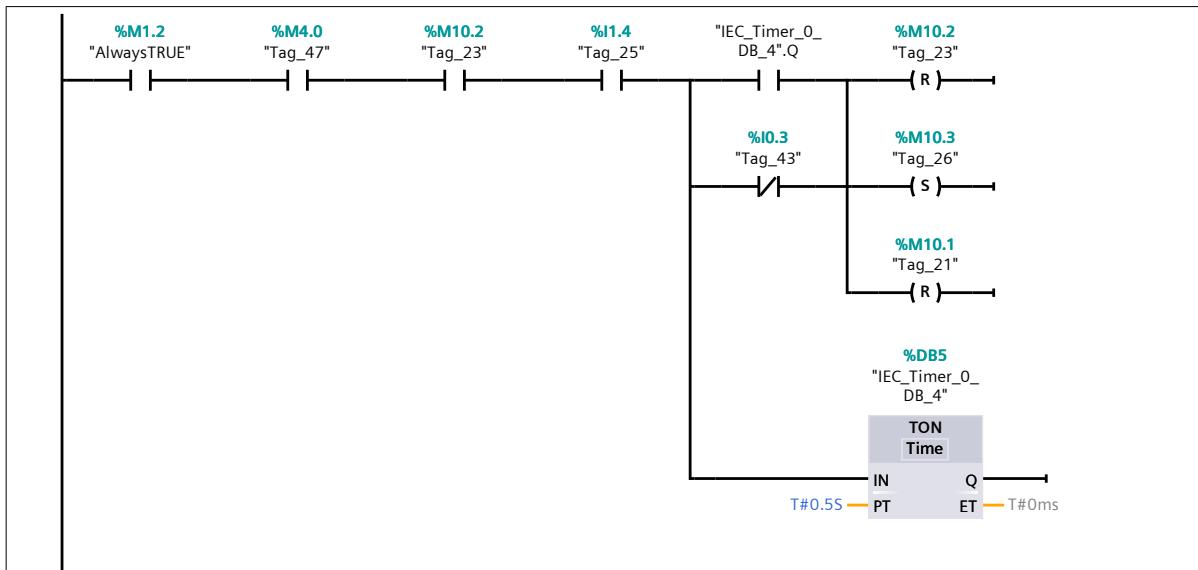
Network 8: CAPPING MODULE RETRACT (CAP MOVES FORWARD)



Owner	Project name	Automation Production Station Code	Date	7/12/2025			
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code					
Location							
Designed By	Description 1st						
Checked By	Description 2nd	Language	en-US				
Approved By	1st View	Version		Sheet 73 - 4			

Network 8: CAPPING MODULE RETRACT (CAP MOVES FORWARD)**Network 9: VERTICAL CYL DOWN**

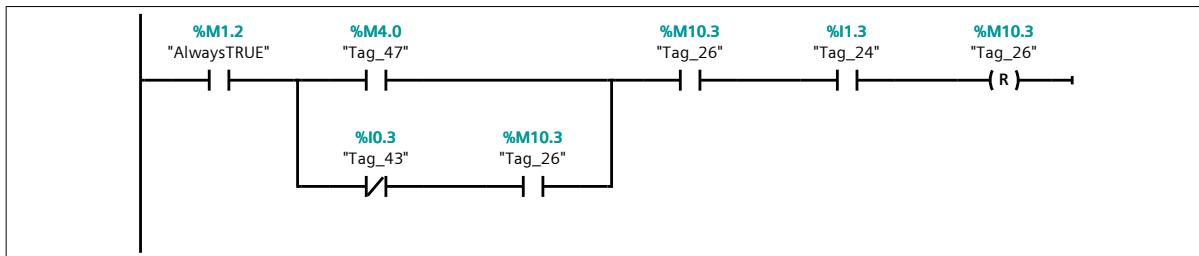
Owner	Project name	Automation Production Station Code	Date	7/12/2025			
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code					
Location							
Designed By	Description 1st						
Checked By	Description 2nd	Language	en-US				
Approved By	1st View	Version		Sheet 73 - 5			

Network 9: VERTICAL CYL DOWN**Network 10: VERTICAL CYL RETRACT**

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Location			
Designed By	Description 1st		
Checked By	Description 2nd	Language en-US	
Approved By	1st View	Version	Sheet 73 - 6

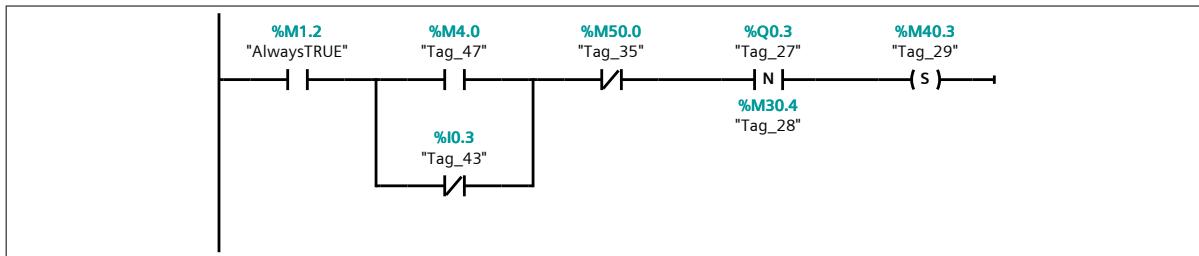
A

Network 11: CAPPING MOD HOME



B

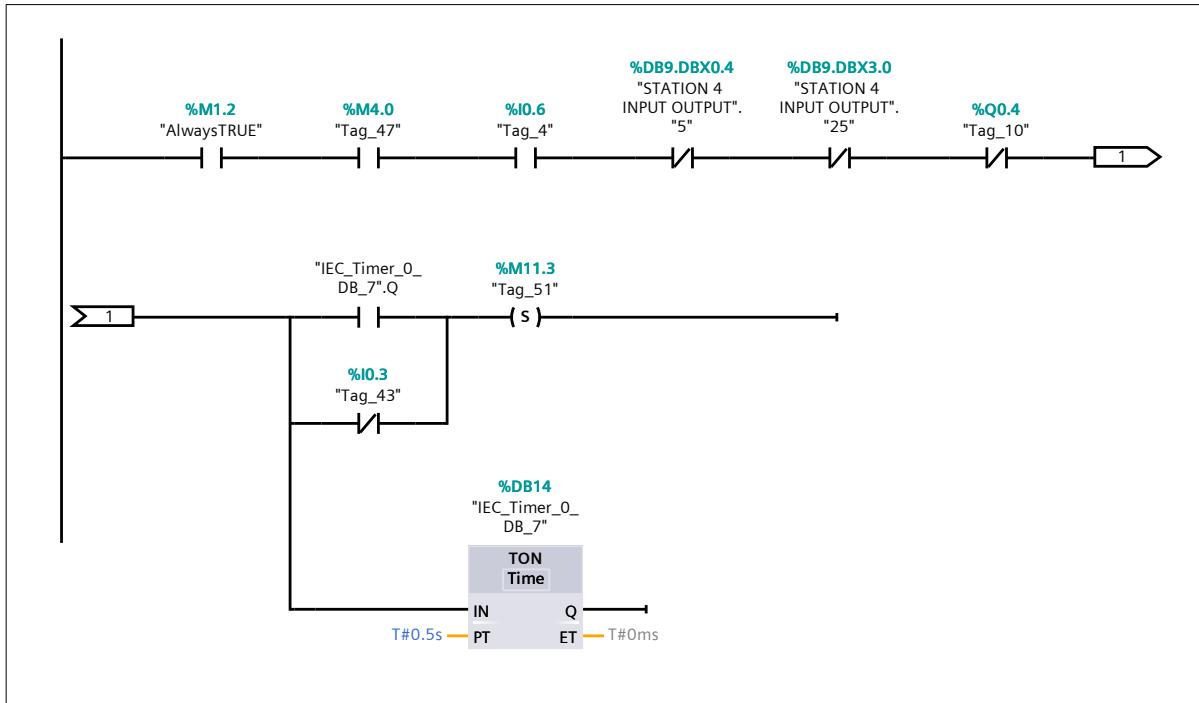
Network 12: FOR INDEXING RUN 3 AFTER CAPPING



C

Network 13: RPM start

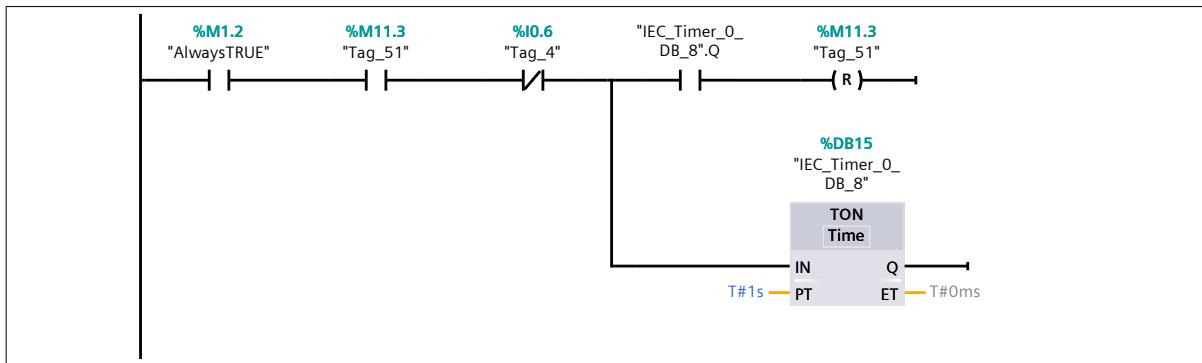
Network 13: RPM start



E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 73 - 7

Network 14: rpm stop



A

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 73 - 8

A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks

OUTPUT CALL 3 [FC2]

OUTPUT CALL 3 Properties

General

Name	OUTPUT CALL 3	Number	2
Type	FC	Language	LAD

Numbering

Information

Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
OUTPUT CALL 3	Void		

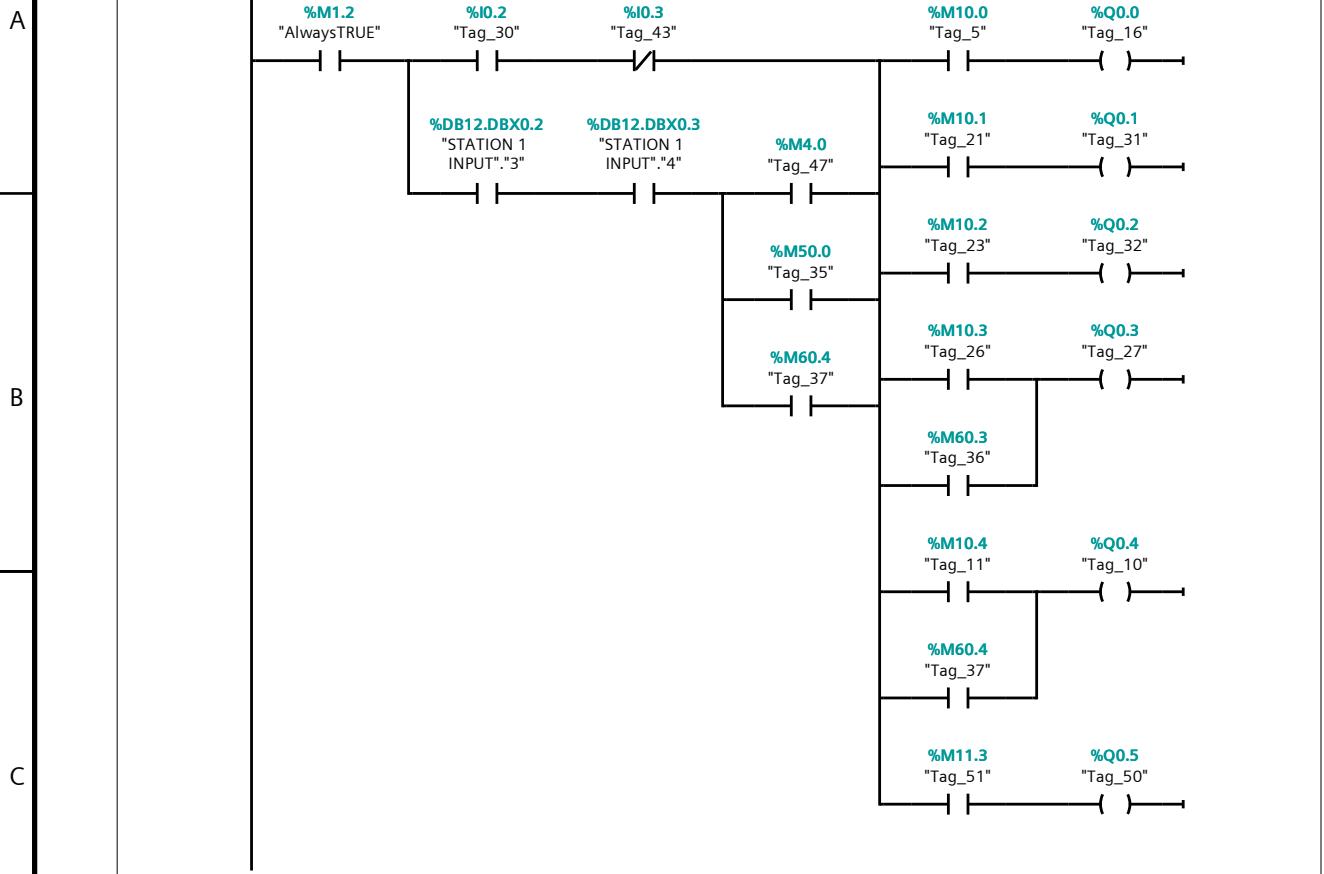
Network 1:

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 74 - 1



Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Location	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 74 - 2	

A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks

ESTOP LOGIC 3 [FC3]

ESTOP LOGIC 3 Properties

General

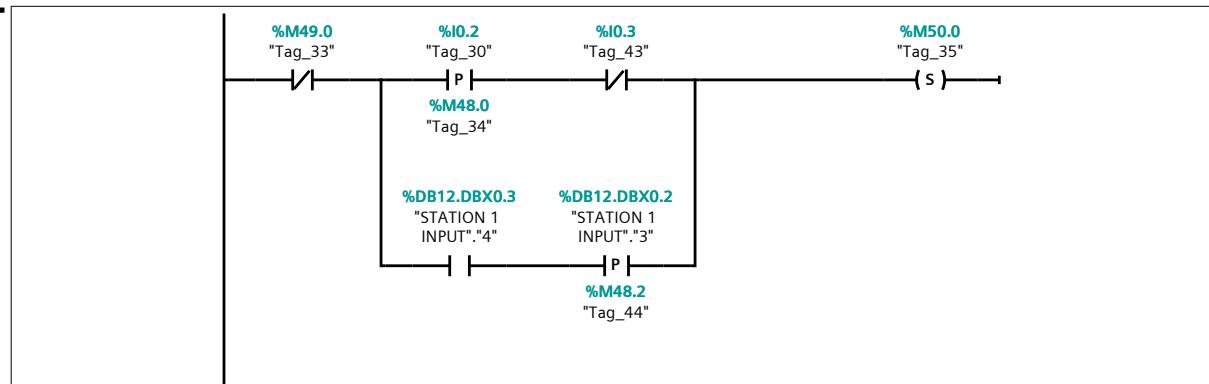
Name	ESTOP LOGIC 3	Number	3
Type	FC	Language	LAD
Numbering	Automatic		

Information

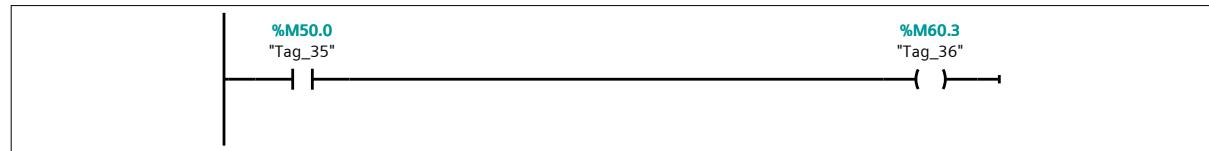
Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
ESTOP LOGIC 3	Void		

Network 1: ESTOP HOMING POSITION LOGIC

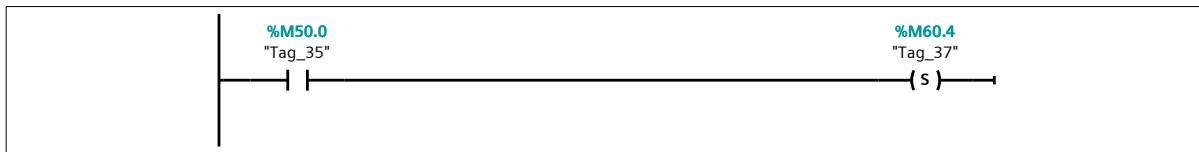
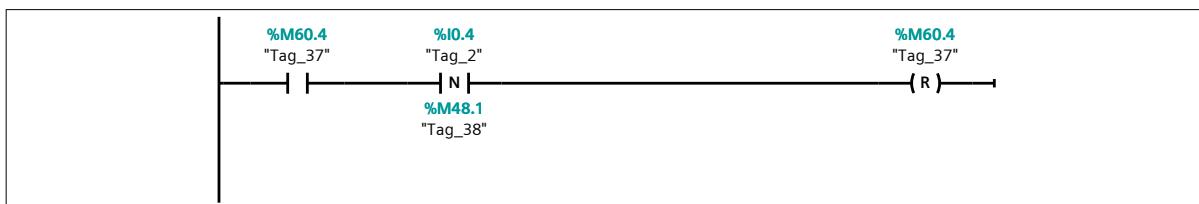


Network 2: OUTPUT CALL FOR HOMING



Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 75 - 1

A

Network 3: INDEXING HOMING**Network 4:****Network 5: MEMORY RESET**

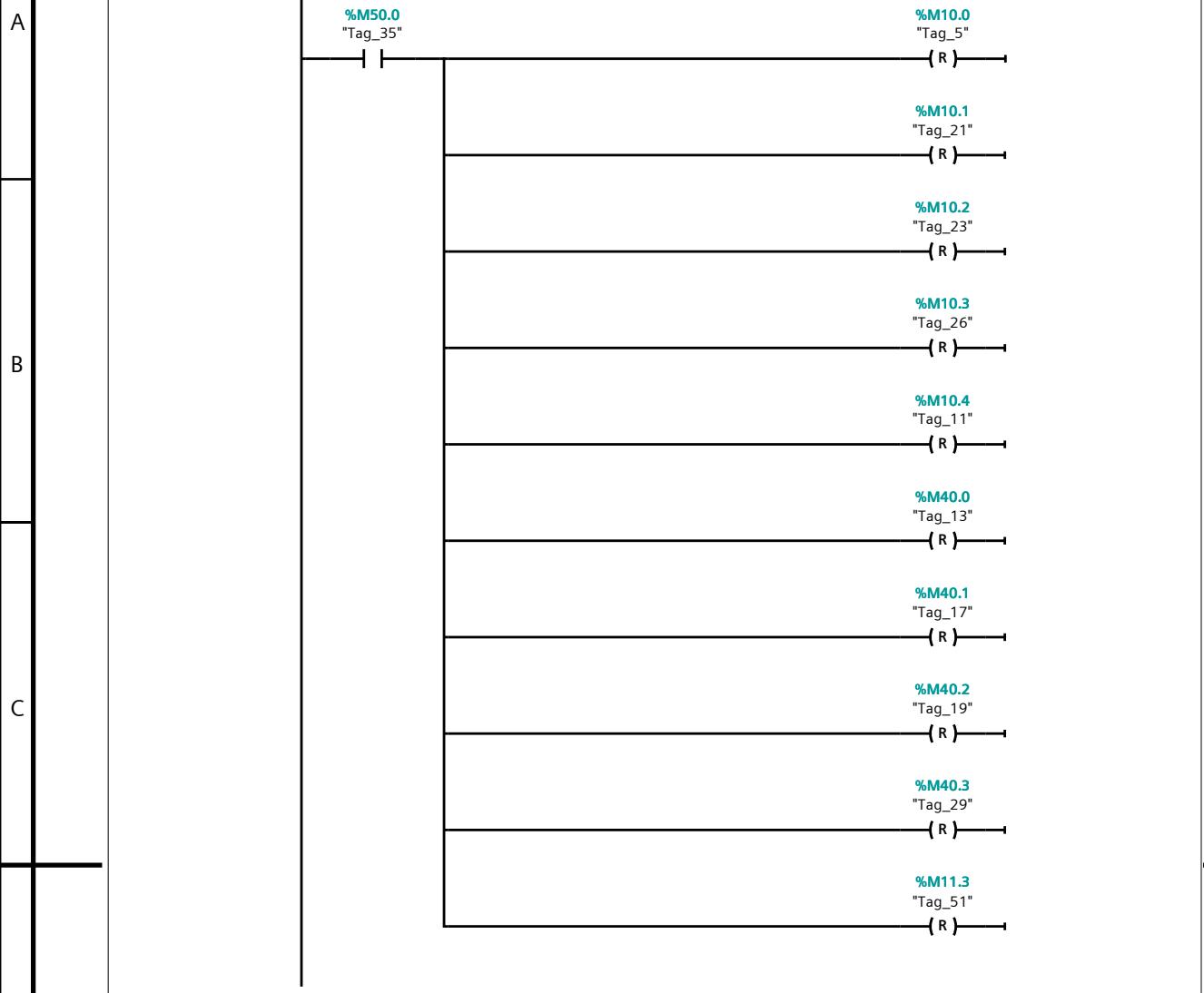
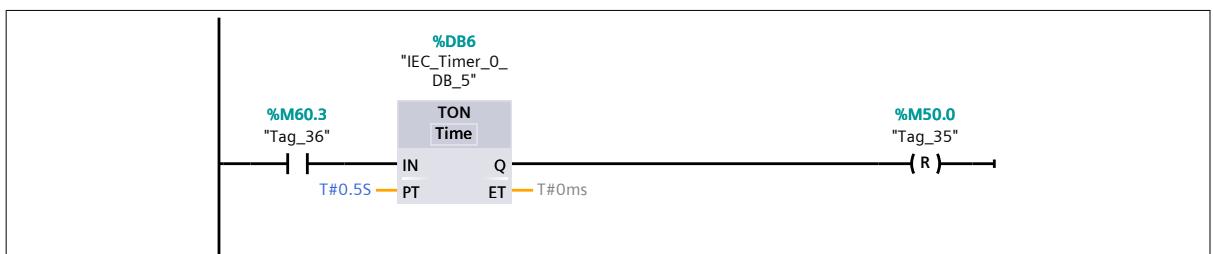
C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 75 - 2

**Network 6:**

Owner	Project name	Automation Production Station Code	Date	7/12/2025			
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code					
Location							
Designed By	Description 1st						
Checked By	Description 2nd	Language	en-US				
Approved By	1st View	Version		Sheet 75 - 3			

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks

DATA BLOCK MOVE [FC4]

DATA BLOCK MOVE Properties

General

Name	DATA BLOCK MOVE	Number	4
Type	FC	Language	LAD

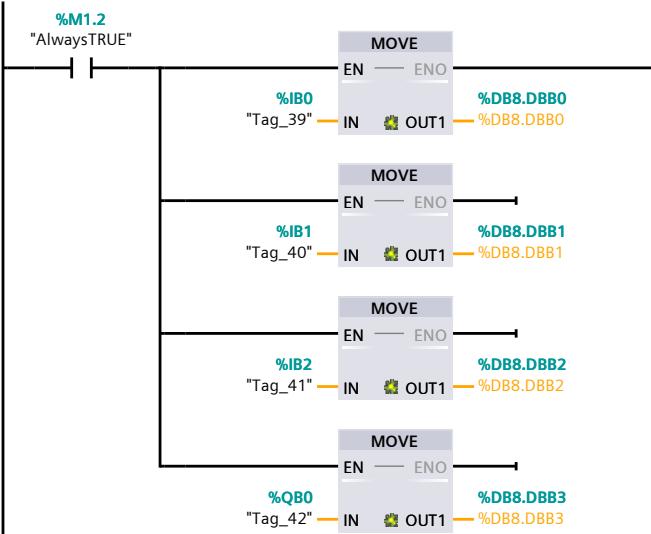
Numbering

Information

Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
DATA BLOCK MOVE	Void		

Network 1:



Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	
	1st View	Version		Sheet 76 - 1

A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks

COM 3 [FC5]

COM 3 Properties

General

Name	COM 3	Number	5
Type	FC	Language	LAD

Numbering Automatic

Information

Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
COM 3	Void		

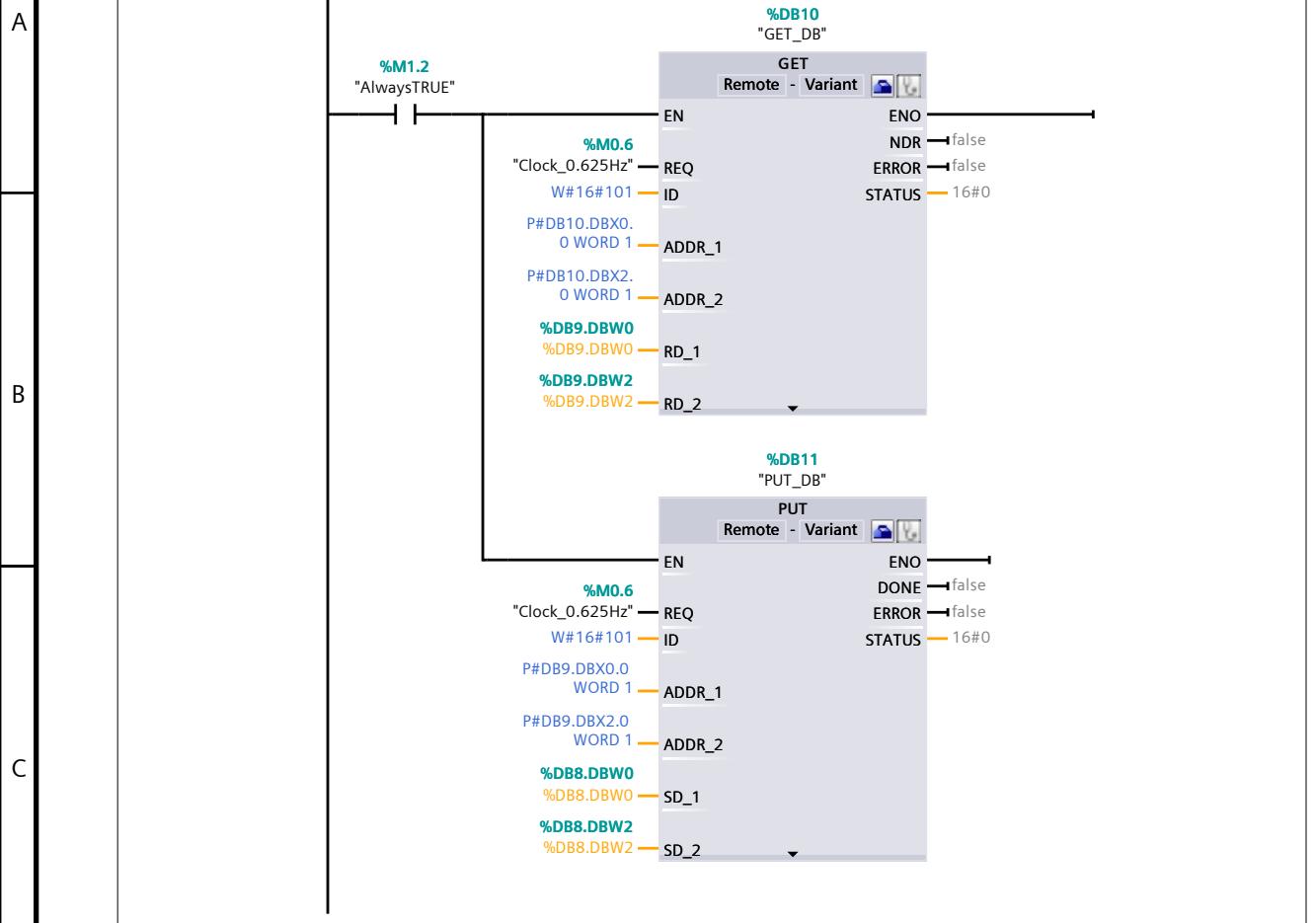
Network 1:

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 77 - 1



Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 77 - 2

A Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks

Main [OB1]

Main Properties

General

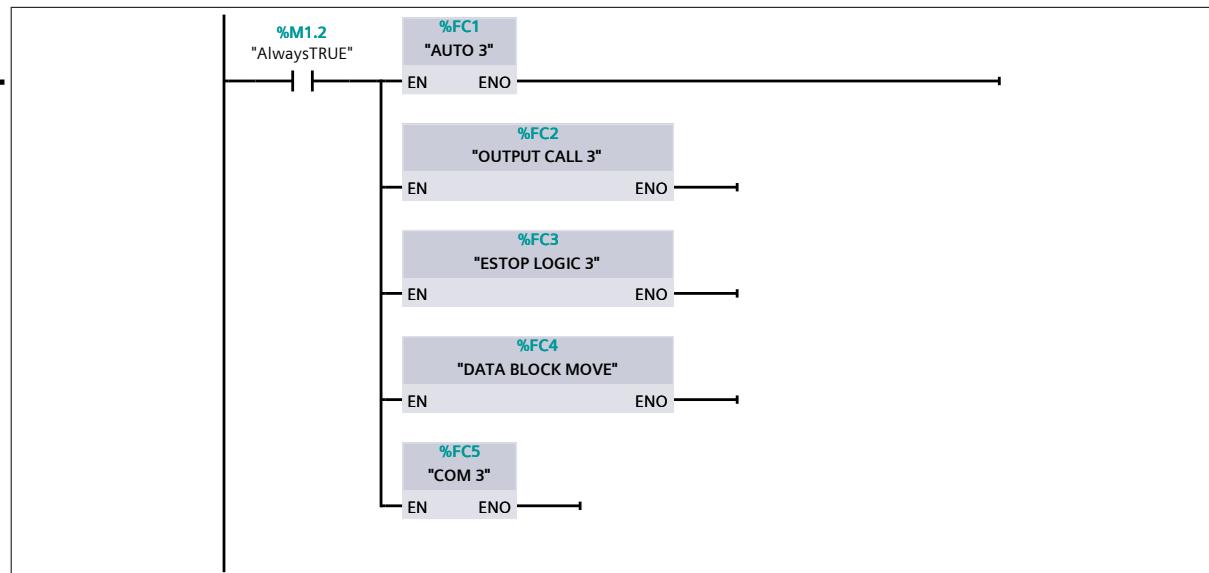
Name	Main	Number	1
Type	OB	Language	LAD
Numbering	Automatic		

Information

Title	"Main Program Sweep (Cycle)"	Author	
Comment		Family	
Version	0.1	User-defined ID	

Name	Data type	Default value	Comment
▼ Input			
Initial_Call	Bool		Initial call of this OB
Remanence	Bool		=True, if remanent data are available
Temp			
Constant			

C Network 1:



Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
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A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks

STATION 2 INPUT OUTPUT [DB7]

STATION 2 INPUT OUTPUT Properties

General

Name	STATION 2 INPUT OUTPUT	Number	7
Type	DB	Language	DB
Numbering	Automatic		

Information

Title	Author
Comment	Family
Version	User-defined ID



Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	1	Data type	Bool
Offset	0.0	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	2	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	3	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
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	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 7 Offset 0.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6_1 Offset 0.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 79 - 2

A	Comment		
	Name	7_1	Data type
	Offset	1.0	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	8	Data type
	Offset	1.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	7_2	Data type
	Offset	1.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	8_1	Data type
C	Offset	1.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	8_2	Data type
	Offset	1.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
D	Comment		
	Name	9	Data type
	Offset	1.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	8_2	Data type
	Offset	1.5	Start value
	Comment		
E	Owner	Automation Production Station Code	Date 7/12/2025
	Project name		
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Operator		
	Location		
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Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator		
Location		
Designed By	Description 1st	
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	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	9_1	Data type	Bool
	Offset	1.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	10	Data type	Bool
	Offset	1.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	9_2	Data type	Bool
	Offset	2.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	10_1	Data type	Bool
	Offset	2.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	11	Data type	Bool
	Offset	2.2	Start value	false
F	Retain	False	Accessible from HMI/OPC UA/Web API	True
Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
Approved By		Description 2nd	Language en-US	Version
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	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 10_2 Offset 2.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 11_1 Offset 2.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 12 Offset 2.5 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 11_2 Offset 2.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 12_1 Offset 2.7 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version Sheet 79 - 5	

A	Comment		
	Name	13	Data type
	Offset	3.0	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	12_2	Data type
	Offset	3.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	13_1	Data type
	Offset	3.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	14	Data type
D	Offset	3.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	13_2	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
E	Comment		
	Name	14_1	Data type
	Offset	3.5	Start value

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
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	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	15	Data type	Bool
	Offset	3.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	14_2	Data type	Bool
	Offset	3.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	Static_10	Data type	Bool
	Offset	4.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	Static_1	Data type	Bool
	Offset	4.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	Static_11	Data type	Bool
	Offset	4.2	Start value	false
F	Retain	False	Accessible from HMI/OPC UA/Web API	True
Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
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	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name: Static_12 Offset: 4.3 Retain: False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name: Static_13 Offset: 4.4 Retain: False	True	Data type: Bool Start value: false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name: Static_14 Offset: 4.5 Retain: False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name: Static_15 Offset: 4.6 Retain: False	True	Data type: Bool Start value: false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name: Static_16 Offset: 4.7 Retain: False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name: Automation Production Station Code Project path: C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date: 7/12/2025 Language: en-US Version	Sheet 79 - 8

A	Comment		
	Name	Static_17	Data type
	Offset	5.0	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	Static_18	Data type
	Offset	5.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	Static_19	Data type
	Offset	5.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	Static_20	Data type
C	Offset	5.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	Static_21	Data type
	Offset	5.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
D	Comment		
	Name	Static_22	Data type
	Offset	5.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	Static_22	Data type
	Offset	5.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
E	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	Static_22	Data type
	Offset	5.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	Static_22	Data type
F	Offset	5.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	Static_22	Data type
	Offset	5.5	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision

Owner	Project name Automation Production Station Code		Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
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	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	Static_23	Data type	Bool
	Offset	5.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	Static_24	Data type	Bool
	Offset	5.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
D				
E				
F	Owner	Project name	Automation Production Station Code	Date 7/12/2025
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location		
	Checked By	Description 1st	Description 2nd	Language en-US
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A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks

STATION 3 INPUT OUTPUT [DB8]

STATION 3 INPUT OUTPUT Properties

General

Name	STATION 3 INPUT OUTPUT	Number	8
Type	DB	Language	DB
Numbering	Automatic		

B

Information

Title		Author	
Comment		Family	
Version	0.1	User-defined ID	

C

Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	1	Data type	Bool
Offset	0.0	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	2	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	3	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
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	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 7 Offset 0.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 8 Offset 0.7 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Language en-US Version	Date 7/12/2025 Sheet 80 - 2

A	Comment		
	Name	9	Data type Bool
	Offset	1.0	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
B	Comment		
	Name	10	Data type Bool
	Offset	1.1	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
C	Comment		
	Name	11	Data type Bool
	Offset	1.2	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
D	Comment		
	Name	12	Data type Bool
	Offset	1.3	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
E	Comment		
	Name	13	Data type Bool
	Offset	1.4	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
F	Comment		
	Name	14	Data type Bool
	Offset	1.5	Start value false

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
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	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	15	Data type	Bool
	Offset	1.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	16	Data type	Bool
	Offset	1.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	17	Data type	Bool
	Offset	2.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	18	Data type	Bool
	Offset	2.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	19	Data type	Bool
	Offset	2.2	Start value	false
F	Retain	False	Accessible from HMI/OPC UA/Web API	True
Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
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	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 20 Offset 2.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 21 Offset 2.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 22 Offset 2.5 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 23 Offset 2.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 24 Offset 2.7 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version Sheet 80 - 5	

A	Comment		
	Name	25	Data type
	Offset	3.0	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	26	Data type
	Offset	3.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	27	Data type
	Offset	3.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	28	Data type
D	Offset	3.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	29	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
E	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
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A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	31	Data type	Bool
	Offset	3.6	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	32	Data type	Bool
	Offset	3.7	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			

D			
E			
F	Owner	Project name	Automation Production Station Code
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location	
	Checked By	Description 1st	
	Approved By	Description 2nd	Language en-US
		1st View	Version
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A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks

STATION 4 INPUT OUTPUT [DB9]

STATION 4 INPUT OUTPUT Properties

General

Name	STATION 4 INPUT OUTPUT	Number	9
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	
Comment		Family	
Version	0.1	User-defined ID	



Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	1	Data type	Bool
Offset	0.0	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	2	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	3	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 81 - 1

F

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 7 Offset 0.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 8 Offset 0.7 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version Sheet 81 - 2	

A	Comment		
	Name	9	Data type Bool
	Offset	1.0	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	10	Data type Bool
	Offset	1.1	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	11	Data type Bool
	Offset	1.2	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	12	Data type Bool
C	Offset	1.3	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	13	Data type Bool
	Offset	1.4	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
D	Comment		
	Name	13	Data type Bool
	Offset	1.4	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	14	Data type Bool
	Offset	1.5	Start value false
	Comment		
E	Owner	Project name	Automation Production Station Code
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code
	Designed By	Description 1st	
	Checked By	Description 2nd	Language en-US
	Approved By	1st View	Version
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Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
Designed By	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Checked By	Location			
Approved By	Description 1st	Description 2nd	Language	en-US
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	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	15	Data type	Bool
	Offset	1.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	16	Data type	Bool
	Offset	1.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	17	Data type	Bool
	Offset	2.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	18	Data type	Bool
	Offset	2.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	19	Data type	Bool
	Offset	2.2	Start value	false
F	Retain	False	Accessible from HMI/OPC UA/Web API	True
Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
Approved By		Description 2nd	Language en-US	
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	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 20 Offset 2.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 21 Offset 2.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 22 Offset 2.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 23 Offset 2.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 24 Offset 2.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 81 - 5

A	Comment		
	Name	25	Data type
	Offset	3.0	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	26	Data type
	Offset	3.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	27	Data type
	Offset	3.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	28	Data type
C	Offset	3.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	29	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
D	Comment		
	Name	29	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		
E	Owner	Automation Production Station Code	Date 7/12/2025
	Project name		
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Operator		
	Location		
	Designed By	Description 1st	
	Checked By	Description 2nd	Language en-US
	Approved By	1st View	Version
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Owner	Automation Production Station Code	Date 7/12/2025
Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator		
Location		
Designed By	Description 1st	
Checked By	Description 2nd	Language en-US
Approved By	1st View	Version
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	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	31	Data type	Bool
	Offset	3.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	32	Data type	Bool
	Offset	3.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	33	Data type	Bool
	Offset	4.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
E				
F	Owner	Project name	Automation Production Station Code	Date 7/12/2025
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location		
	Checked By	Description 1st		
	Approved By	Description 2nd	Language	en-US
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Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks

STATION 1 INPUT [DB12]

STATION 1 INPUT Properties

General

Name	STATION 1 INPUT	Number	12
Type	DB	Language	DB
Numbering	Automatic		

Information

Title	Author
Comment	Family
Version	User-defined ID



Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	1	Data type	Bool
Offset	0.0	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	2	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	3	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 82 - 1

F

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Visible in HMI engineering Supervision Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Visible in HMI engineering Supervision Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment	True	Visible in HMI engineering Supervision	True
E				
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 82 - 2

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB [DB1]

IEC_Timer_0_DB Properties			
General			
Name	IEC_Timer_0_DB	Number	1
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet	83 - 1

A	<p>Accessible from HMI/OPC UA/Web API</p> <p>Visible in HMI engineering</p> <p>Supervision</p>	<p>True</p>	<p>Writable from HMI/OPC UA/Web API</p> <p>Setpoint</p> <p>Comment</p>	<p>False</p>
---	---	--------------------	---	---------------------

B

C

D

E

F

Owner	Project name Automation Production Station Code	
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By	Location	
Checked By	Description 1st	
Approved By	Description 2nd	Language en-US
	1st View	Version
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Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_1 [DB2]

IEC_Timer_0_DB_1 Properties			
General			
Name	IEC_Timer_0_DB_1	Number	2
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet	84 - 1

	1	2	3	4
A	<p>Accessible from HMI/OPC UA/Web API</p> <p>Visible in HMI engineering</p> <p>Supervision</p>	<p>True</p>	<p>Writable from HMI/OPC UA/Web API</p> <p>Setpoint</p> <p>Comment</p>	<p>False</p>
B				
C				
D				
E				
F	<p>Owner</p> <p>Operator</p> <p>Designed By</p> <p>Checked By</p> <p>Approved By</p>	<p>Project name</p> <p>Project path</p> <p>Description 1st</p> <p>Description 2nd</p> <p>1st View</p>	<p>Automation Production Station Code</p> <p>C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</p> <p>Location</p> <p>en-US</p> <p>Version</p>	<p>Date 7/12/2025</p>

A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_2 [DB3]

IEC_Timer_0_DB_2 Properties

General

Name	IEC_Timer_0_DB_2	Number	3
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By				
Approved By	Description 1st	Description 2nd	Language	en-US
			Version	Sheet 85 - 1

F

A	<table border="1"> <tr><td>Accessible from HMI/OPC UA/Web API</td><td>True</td></tr> <tr><td>Visible in HMI engineering</td><td>True</td></tr> <tr><td>Supervision</td><td></td></tr> </table>	Accessible from HMI/OPC UA/Web API	True	Visible in HMI engineering	True	Supervision		<table border="1"> <tr><td>Writable from HMI/OPC UA/Web API</td><td>False</td></tr> <tr><td>Setpoint</td><td>False</td></tr> <tr><td>Comment</td><td></td></tr> </table>	Writable from HMI/OPC UA/Web API	False	Setpoint	False	Comment	
Accessible from HMI/OPC UA/Web API	True													
Visible in HMI engineering	True													
Supervision														
Writable from HMI/OPC UA/Web API	False													
Setpoint	False													
Comment														
B														
C														

D																															
E																															
F	<table border="1"> <tr><td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr><td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr><td>Designed By</td><td>Location</td><td colspan="3"></td></tr> <tr><td>Checked By</td><td>Description 1st</td><td colspan="3"></td></tr> <tr><td>Approved By</td><td>Description 2nd</td><td>Language</td><td colspan="2">en-US</td></tr> <tr><td></td><td>1st View</td><td>Version</td><td colspan="2">Sheet 85 - 2</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 85 - 2	
Owner	Project name	Automation Production Station Code	Date	7/12/2025																											
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																													
Designed By	Location																														
Checked By	Description 1st																														
Approved By	Description 2nd	Language	en-US																												
	1st View	Version	Sheet 85 - 2																												

A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_3 [DB4]

IEC_Timer_0_DB_3 Properties

General

Name	IEC_Timer_0_DB_3	Number	4
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 86 - 1

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Visible in HMI engineering	True	Setpoint	False										
Supervision		Comment											
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F	<table border="1"> <tr> <td>Owner</td> <td>Project name</td> <td>Automation Production Station Code</td> <td>Date</td> <td>7/12/2025</td> </tr> <tr> <td>Operator</td> <td>Project path</td> <td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td> </tr> <tr> <td>Designed By</td> <td>Location</td> <td colspan="3"></td> </tr> <tr> <td>Checked By</td> <td>Description 1st</td> <td colspan="3"></td> </tr> <tr> <td>Approved By</td> <td>Description 2nd</td> <td>Language</td> <td colspan="2">en-US</td> </tr> <tr> <td></td> <td>1st View</td> <td>Version</td> <td colspan="2">Sheet 86 - 2</td> </tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 86 - 2	
Owner	Project name	Automation Production Station Code	Date	7/12/2025																											
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																													
Designed By	Location																														
Checked By	Description 1st																														
Approved By	Description 2nd	Language	en-US																												
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Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_4 [DB5]

IEC_Timer_0_DB_4 Properties

General

Name	IEC_Timer_0_DB_4	Number	5
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	
	1st View	Version		Sheet 87 - 1

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	1	2	3	4
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C				
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E				
F	<p>Owner</p> <p>Operator</p> <p>Designed By</p> <p>Checked By</p> <p>Approved By</p>	<p>Project name</p> <p>Project path</p> <p>Description 1st</p> <p>Description 2nd</p> <p>1st View</p>	<p>Automation Production Station Code</p> <p>C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</p> <p>Location</p> <p>en-US</p> <p>Version</p>	<p>Date 7/12/2025</p>

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Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_5 [DB6]

IEC_Timer_0_DB_5 Properties

General

Name	IEC_Timer_0_DB_5	Number	6
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 88 - 1

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Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False										
Visible in HMI engineering	True	Setpoint	False										
Supervision		Comment											
B													
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D																															
E																															
F	<table border="1"> <tr> <td>Owner</td> <td>Project name</td> <td>Automation Production Station Code</td> <td>Date</td> <td>7/12/2025</td> </tr> <tr> <td>Operator</td> <td>Project path</td> <td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td> </tr> <tr> <td>Designed By</td> <td>Location</td> <td colspan="3"></td> </tr> <tr> <td>Checked By</td> <td>Description 1st</td> <td colspan="3"></td> </tr> <tr> <td>Approved By</td> <td>Description 2nd</td> <td>Language</td> <td colspan="2">en-US</td> </tr> <tr> <td></td> <td>1st View</td> <td>Version</td> <td colspan="2">Sheet 88 - 2</td> </tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 88 - 2	
Owner	Project name	Automation Production Station Code	Date	7/12/2025																											
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																													
Designed By	Location																														
Checked By	Description 1st																														
Approved By	Description 2nd	Language	en-US																												
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Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

GET_DB [DB10]

GET_DB Properties

General

Name	GET_DB	Number	10
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	SIMATIC
Comment		Family	COM_FUNC
Version	1.1	User-defined ID	GET



Name	Input	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	REQ	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ID	Data type	Word
Start value	16#0	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	



Name	Output	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	NDR	Data type	Bool

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 89 - 1

A	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	ADDR_4	Data type	Remote
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	RD_1	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
B	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_2	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_3	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
C	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_4	Data type	Variant
	Start value		Retain	False
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	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	Static	Data type	Variant
	Start value		Retain	False
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D	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_4	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	Static	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	False
E	Visible in HMI engineering		Setpoint	
	Supervision		Comment	

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 89 - 3

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Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

PUT_DB [DB11]

PUT_DB Properties

General

Name	PUT_DB	Number	11
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	SIMATIC
Comment		Family	COM_FUNC
Version	1.1	User-defined ID	PUT



Name	Input	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	REQ	Data type	Bool
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Visible in HMI engineering	True	Setpoint	False

Supervision

Name	ID	Data type	Word
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	



Name	Output	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	DONE	Data type	Bool

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location		
Checked By	Description 1st		
Approved By	Description 2nd Language en-US		
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A	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
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	Start value		Retain	False
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	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
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	Start value		Retain	False
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B	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	SD_2	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	SD_3	Data type	Variant
	Start value		Retain	False
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C	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	SD_4	Data type	Variant
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	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	Static	Data type	Variant
	Start value		Retain	False
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D	Visible in HMI engineering	False	Setpoint	False
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E	Visible in HMI engineering		Setpoint	
	Supervision		Comment	
	Owner	Automation Production Station Code	Date	7/12/2025
	Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	Project path	
	Designed By	Description 1st	Location	
	Checked By	Description 2nd	Language	en-US
	Approved By	1st View	Version	Sheet 90 - 3

Owner	Automation Production Station Code	Date	7/12/2025
Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Description 1st		
Checked By	Description 2nd	Language	en-US
Approved By	1st View	Version	Sheet 90 - 3

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_6 [DB13]

IEC_Timer_0_DB_6 Properties			
General			
Name	IEC_Timer_0_DB_6	Number	13
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 91 - 1	

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C				
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E				
F	<p>Owner</p> <p>Operator</p> <p>Designed By</p> <p>Checked By</p> <p>Approved By</p>	<p>Project name</p> <p>Project path</p> <p>Description 1st</p> <p>Description 2nd</p> <p>1st View</p>	<p>Automation Production Station Code</p> <p>C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</p> <p>Location</p> <p>en-US</p> <p>Version</p>	<p>Date 7/12/2025</p>

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_7 [DB14]

IEC_Timer_0_DB_7 Properties			
General			
Name	IEC_Timer_0_DB_7	Number	14
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
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Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
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Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 92 - 1	

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Visible in HMI engineering	True	Setpoint	False																																
Supervision		Comment																																	
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F	<table border="1"> <tr> <td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr> <td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr> <td>Designed By</td><td>Location</td><td colspan="3"></td></tr> <tr> <td>Checked By</td><td>Description 1st</td><td colspan="3"></td></tr> <tr> <td>Approved By</td><td>Description 2nd</td><td>Language</td><td>en-US</td><td></td></tr> <tr> <td></td><td>1st View</td><td>Version</td><td colspan="2">Sheet 92 - 2</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 92 - 2					
Owner	Project name	Automation Production Station Code	Date	7/12/2025																															
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																																	
Designed By	Location																																		
Checked By	Description 1st																																		
Approved By	Description 2nd	Language	en-US																																
	1st View	Version	Sheet 92 - 2																																

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_8 [DB15]

IEC_Timer_0_DB_8 Properties			
General			
Name	IEC_Timer_0_DB_8	Number	15
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

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	1	2	3	4
A	<p>Accessible from HMI/OPC UA/Web API</p> <p>Visible in HMI engineering</p> <p>Supervision</p>	<p>True</p>	<p>Writable from HMI/OPC UA/Web API</p> <p>Setpoint</p> <p>Comment</p>	<p>False</p>
B				
C				
D				
E				
F	<p>Owner</p> <p>Operator</p> <p>Designed By</p> <p>Checked By</p> <p>Approved By</p>	<p>Project name</p> <p>Project path</p> <p>Description 1st</p> <p>Description 2nd</p> <p>1st View</p>	<p>Automation Production Station Code</p> <p>C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</p> <p>Location</p> <p>en-US</p> <p>Version</p>	<p>Date 7/12/2025</p>

A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC]

Technology objects

This folder is empty.

B

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D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
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Location				
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A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC]

PLC tags

PLC tags						
Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
■	AlwaysFALSE	Bool	%M1.3	True	True	
■	AlwaysTRUE	Bool	%M1.2	True	True	
■	Clock_0.5Hz	Bool	%M0.7	True	True	
■	Clock_0.625 Hz	Bool	%M0.6	True	True	
■	Clock_1.25Hz	Bool	%M0.4	True	True	
■	Clock_1Hz	Bool	%M0.5	True	True	
■	Clock_2.5Hz	Bool	%M0.2	True	True	
■	Clock_2Hz	Bool	%M0.3	True	True	
■	Clock_5Hz	Bool	%M0.1	True	True	
■	Clock_10Hz	Bool	%M0.0	True	True	
■	Clock_Byte	Byte	%MBO	True	True	
■	DiagStatusUpdate	Bool	%M1.1	True	True	
■	FirstScan	Bool	%M1.0	True	True	
■	System_Byte	Byte	%MB1	True	True	
■	Tag_1	Bool	%I0.0	True	True	
■	Tag_2	Bool	%I0.4	True	True	
■	Tag_3	Bool	%I0.5	True	True	
■	Tag_4	Bool	%I0.6	True	True	
■	Tag_5	Bool	%M10.0	True	True	
■	Tag_6	Bool	%M30.0	True	True	
■	Tag_7	Bool	%I1.5	True	True	
■	Tag_8	Bool	%I0.7	True	True	
■	Tag_9	Bool	%I1.2	True	True	
■	Tag_10	Bool	%Q0.4	True	True	
■	Tag_11	Bool	%M10.4	True	True	
■	Tag_12	Bool	%M30.1	True	True	
■	Tag_13	Bool	%M40.0	True	True	
■	Tag_14	Bool	%I1.0	True	True	
■	Tag_15	Bool	%M30.2	True	True	

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	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
A	Tag_16	Bool	%Q0.0	True	True		
	Tag_17	Bool	%M40.1	True	True		
	Tag_18	Bool	%I2.0	True	True		
	Tag_19	Bool	%M40.2	True	True		
	Tag_20	Bool	%M30.3	True	True		
B	Tag_21	Bool	%M10.1	True	True		
	Tag_22	Bool	%I1.1	True	True		
	Tag_23	Bool	%M10.2	True	True		
	Tag_24	Bool	%I1.3	True	True		
	Tag_25	Bool	%I1.4	True	True		
C	Tag_26	Bool	%M10.3	True	True		
	Tag_27	Bool	%Q0.3	True	True		
	Tag_28	Bool	%M30.4	True	True		
	Tag_29	Bool	%M40.3	True	True		
	Tag_30	Bool	%I0.2	True	True		
D	Tag_31	Bool	%Q0.1	True	True		
	Tag_32	Bool	%Q0.2	True	True		
	Tag_33	Bool	%M49.0	True	True		
	Tag_34	Bool	%M48.0	True	True		
	Tag_35	Bool	%M50.0	True	True		
	Tag_36	Bool	%M60.3	True	True		
	Tag_37	Bool	%M60.4	True	True		
	Tag_38	Bool	%M48.1	True	True		
E	Tag_39	Byte	%IB0	True	True		
	Tag_40	Byte	%IB1	True	True		
	Tag_41	Byte	%IB2	True	True		
	Tag_42	Byte	%QBO	True	True		
	Tag_43	Bool	%I0.3	True	True		
	Tag_44	Bool	%M48.2	True	True		
	Tag_45	Bool	%I0.1	True	True		
	Tag_46	Bool	%M5.0	True	True		
	Tag_47	Bool	%M4.0	True	True		
	Tag_48	Bool	%M48.4	True	True		
	Tag_49	Bool	%M50.3	True	True		
	Tag_50	Bool	%Q0.5	True	True		

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A	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
		Tag_51	Bool	%M11.3	True	True	

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A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / PLC tags

Default tag table [92]

PLC tags						
Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
■	AlwaysFALSE	Bool	%M1.3	True	True	
■	AlwaysTRUE	Bool	%M1.2	True	True	
■	Clock_0.5Hz	Bool	%M0.7	True	True	
■	Clock_0.625 Hz	Bool	%M0.6	True	True	
■	Clock_1.25Hz	Bool	%M0.4	True	True	
■	Clock_1Hz	Bool	%M0.5	True	True	
■	Clock_2.5Hz	Bool	%M0.2	True	True	
■	Clock_2Hz	Bool	%M0.3	True	True	
■	Clock_5Hz	Bool	%M0.1	True	True	
■	Clock_10Hz	Bool	%M0.0	True	True	
■	Clock_Byte	Byte	%MBO	True	True	
■	DiagStatusUpdate	Bool	%M1.1	True	True	
■	FirstScan	Bool	%M1.0	True	True	
■	System_Byte	Byte	%MB1	True	True	
■	Tag_1	Bool	%I0.0	True	True	
■	Tag_2	Bool	%I0.4	True	True	
■	Tag_3	Bool	%I0.5	True	True	
■	Tag_4	Bool	%I0.6	True	True	
■	Tag_5	Bool	%M10.0	True	True	
■	Tag_6	Bool	%M30.0	True	True	
■	Tag_7	Bool	%I1.5	True	True	
■	Tag_8	Bool	%I0.7	True	True	
■	Tag_9	Bool	%I1.2	True	True	
■	Tag_10	Bool	%Q0.4	True	True	
■	Tag_11	Bool	%M10.4	True	True	
■	Tag_12	Bool	%M30.1	True	True	
■	Tag_13	Bool	%M40.0	True	True	
■	Tag_14	Bool	%I1.0	True	True	
■	Tag_15	Bool	%M30.2	True	True	

Owner	Project name	Automation Production Station Code	Date	7/12/2025
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	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
A	Tag_16	Bool	%Q0.0	True	True		
	Tag_17	Bool	%M40.1	True	True		
	Tag_18	Bool	%I2.0	True	True		
	Tag_19	Bool	%M40.2	True	True		
	Tag_20	Bool	%M30.3	True	True		
B	Tag_21	Bool	%M10.1	True	True		
	Tag_22	Bool	%I1.1	True	True		
	Tag_23	Bool	%M10.2	True	True		
	Tag_24	Bool	%I1.3	True	True		
	Tag_25	Bool	%I1.4	True	True		
C	Tag_26	Bool	%M10.3	True	True		
	Tag_27	Bool	%Q0.3	True	True		
	Tag_28	Bool	%M30.4	True	True		
	Tag_29	Bool	%M40.3	True	True		
	Tag_30	Bool	%I0.2	True	True		
D	Tag_31	Bool	%Q0.1	True	True		
	Tag_32	Bool	%Q0.2	True	True		
	Tag_33	Bool	%M49.0	True	True		
	Tag_34	Bool	%M48.0	True	True		
	Tag_35	Bool	%M50.0	True	True		
	Tag_36	Bool	%M60.3	True	True		
	Tag_37	Bool	%M60.4	True	True		
	Tag_38	Bool	%M48.1	True	True		
E	Tag_39	Byte	%IB0	True	True		
	Tag_40	Byte	%IB1	True	True		
	Tag_41	Byte	%IB2	True	True		
	Tag_42	Byte	%QBO	True	True		
	Tag_43	Bool	%I0.3	True	True		
	Tag_44	Bool	%M48.2	True	True		
	Tag_45	Bool	%I0.1	True	True		
	Tag_46	Bool	%M5.0	True	True		
	Tag_47	Bool	%M4.0	True	True		
	Tag_48	Bool	%M48.4	True	True		
	Tag_49	Bool	%M50.3	True	True		
	Tag_50	Bool	%Q0.5	True	True		

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A	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
		Tag_51	Bool	%M11.3	True	True	

B

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F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
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A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / PLC data types

System data types

This folder is empty.

B

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A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Watch and force tables

Force table

Name	Address	Display format	Force value	Comment

B

C

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E

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A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC]

Traces

Name

B

C

D

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
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A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Traces

Measurements

This folder is empty.

B

C

D

E

F

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A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Traces

Combined measurements

Name

B

C

D

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
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A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC]

PLC alarm text lists

This folder is empty.

B

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Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
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A

Automation Production Station Code / PLC_3 [CPU 1214C DC/DC/DC] / Local modules

PLC_3 [CPU 1214C DC/DC/DC]

PLC_3			
General\Project information			
Name	PLC_3	Author	MTC-MECH-05
Comment		Slot	1
Rack	0		
General\Catalog information			
Short designation	CPU 1214C DC/DC/DC	Description	Work memory 75 KB; 24VDC power supply with DI14 x 24VDC SINK/SOURCE, DQ10 x 24VDC and AI2 on board; 6 high-speed counters and 4 pulse outputs on board; signal board expands on-board I/O; up to 3 communication modules for serial communication; up to 8 signal modules for I/O expansion; PROFINET interface for programming, HMI and PLC-to-PLC communication
Article number	6ES7 214-1AG40-0XB0	Firmware version	V4.0
General\Identification & Maintenance			
Plant designation		Location identifier	
Installation date	2025-06-11 06:03:00.170	Additional information	
Connection resources			
PG communication:	1	OP communication:	1
S7 basic communication:	0	S7 communication:	0
Maximum number of S7 connection resources:	38		
PROFINET interface [X1]\General			
Name	PROFINET interface_1	Author	MTC-MECH-05
Comment			
PROFINET interface [X1]\General\Project information			
Name	DI 14/DQ 10_1	Comment	
Name	AI 2_1	Comment	
Name	DI 4x24VDC_1	Comment	
PROFINET interface [X1]\General\Catalog information			
Short designation	DI4 signal board (200 kHz)	Description	Signal board DI4 x 24 VDC / 200 kHz SOURCE; selectable input delay; plug-in terminal blocks
Article number	6ES7 221-3BD30-0XB0	Firmware version	V1.0
PROFINET interface [X1]\Ethernet addresses\Interface networked with			
Subnet:	PN/IE_1		
PROFINET interface [X1]\Ethernet addresses\IP protocol			
IP configuration	Set IP address in the project	IP address:	192.168.0.3
Subnet mask:	255.255.255.0	Use router	False
Owner	Project name Automation Production Station Code		Date 7/12/2025
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PROFINET interface [X1]\Ethernet addresses\PROFINET			
PROFINET device name is set directly at the device	False	Generate PROFINET device name automatically	True
PROFINET device name:	plc_3	Converted name:	plcxb3116c
Device number:	0		
PROFINET interface [X1]\Time synchronization			
Enable time synchronization via NTP server	Enable time synchronization via NTP server		IP addresses
Server 1	0.0.0.0	Server 2	0.0.0.0
Server 3	0.0.0.0	Server 4	0.0.0.0
Update interval	10sec		
PROFINET interface [X1]\Digital inputs\Channel0\			
Channel address	I0.0	Input filters	6.4 millisec
Channel address	I4.0	Input filters	6.4 millisec
Enable pulse catch	0	Enable pulse catch	0
PROFINET interface [X1]\Digital inputs\Channel0\			
Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49152
Enable rising edge detection	0	Event name:	0
Hardware interrupt:	0	RidPrefixRisingEdgeEvent	49152
Rising edge0	Rising edge0	Event name:	0
Hardware interrupt:	0	Rising edge0	Rising edge0
PROFINET interface [X1]\Digital inputs\Channel0\			
Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49280
Enable falling edge detection	0	Event name:	0
Hardware interrupt:	0	RidPrefixFallingEdgeEvent	49280
Falling edge0	Falling edge0	Event name:	0
Hardware interrupt:	0	Falling edge0	Falling edge0
PROFINET interface [X1]\Digital inputs\Channel1\			
Channel address	I0.1	Input filters	6.4 millisec
Channel address	I4.1	Input filters	6.4 millisec
Enable pulse catch	0	Enable pulse catch	0
PROFINET interface [X1]\Digital inputs\Channel1\			
Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49153
Enable rising edge detection	0	Event name:	0
Hardware interrupt:	0	RidPrefixRisingEdgeEvent	49153
Rising edge1	Rising edge1	Event name:	0
Hardware interrupt:	0	Rising edge1	Rising edge1

Owner	Project name Automation Production Station Code		Date 7/12/2025
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A	PROFINET interface [X1]\Digital inputs\Channel1\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49281
	Enable falling edge detection	0	Event name:	0
	Hardware interrupt:	0	RidPrefixFallin-gEdgeEvent	49281
	Falling edge1	Falling edge1	Event name:	0
	Hardware interrupt:	0	Falling edge1	Falling edge1
B	PROFINET interface [X1]\Digital inputs\Channel2\			
	Channel address	I0.2	Input filters	6.4 millisec
	Channel address	I4.2	Input filters	6.4 millisec
	Enable pulse catch	0	Enable pulse catch	0
C	PROFINET interface [X1]\Digital inputs\Channel2\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49154
	Enable rising edge detection	0	Event name:	0
	Hardware interrupt:	0	RidPrefixRisingEdg-eEvent	49154
	Rising edge2	Rising edge2	Event name:	0
	Hardware interrupt:	0	Rising edge2	Rising edge2
D	PROFINET interface [X1]\Digital inputs\Channel3\			
	Channel address	I0.3	Input filters	6.4 millisec
	Channel address	I4.3	Input filters	6.4 millisec
	Enable pulse catch	0	Enable pulse catch	0
E	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49155
	Enable rising edge detection	0	Event name:	0
	Hardware interrupt:	0	RidPrefixRisingEdg-eEvent	49155
	Rising edge3	Rising edge3	Event name:	0
	Hardware interrupt:	0	Rising edge3	Rising edge3
F	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49283
	Enable falling edge detection	0	Event name:	0

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A	Hardware interrupt: Falling edge3	0 Falling edge3	RidPrefixFallin- gEdgeEvent Falling edge3	49283 0 Falling edge3
	PROFINET interface [X1]\Digital inputs\Channel4			
	Channel address	I0.4	Input filters	6.4 millisec
	Enable pulse catch	0		
B	PROFINET interface [X1]\Digital inputs\Channel4			
	Enable rising edge detection	0	RidPrefixRisingEdg- eEvent	49156
	Event name:	0	Hardware inter- rupt:	0
	Rising edge4	Rising edge4		
	PROFINET interface [X1]\Digital inputs\Channel4			
	Enable falling edge detection	0	RidPrefixFallin- gEdgeEvent	49284
	Event name:	0	Hardware inter- rupt:	0
	Falling edge4	Falling edge4		
C	PROFINET interface [X1]\Digital inputs\Channel5			
	Channel address	I0.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel5			
	Enable rising edge detection	0	RidPrefixRisingEdg- eEvent	49157
	Event name:	0	Hardware inter- rupt:	0
	Rising edge5	Rising edge5		
D	PROFINET interface [X1]\Digital inputs\Channel5			
	Enable falling edge detection	0	RidPrefixFallin- gEdgeEvent	49285
	Event name:	0	Hardware inter- rupt:	0
	Falling edge5	Falling edge5		
	PROFINET interface [X1]\Digital inputs\Channel6			
	Channel address	I0.6	Input filters	6.4 millisec
	Enable pulse catch	0		
E	PROFINET interface [X1]\Digital inputs\Channel6			
	Enable rising edge detection	0	RidPrefixRisingEdg- eEvent	49158
	Event name:	0	Hardware inter- rupt:	0
	Rising edge6	Rising edge6		
	PROFINET interface [X1]\Digital inputs\Channel6			
	Enable falling edge detection	0	RidPrefixFallin- gEdgeEvent	49286
	Event name:	0	Hardware inter- rupt:	0
	Falling edge6	Falling edge6		
F	PROFINET interface [X1]\Digital inputs\Channel7			
	Channel address	I0.7	Input filters	6.4 millisec
	Enable pulse catch	0		
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A	PROFINET interface [X1]\Digital inputs\Channel7\		
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent 49159
	Event name:	0	Hardware interrupt: 0
	Rising edge7	Rising edge7	
B	PROFINET interface [X1]\Digital inputs\Channel7\		
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent 49287
	Event name:	0	Hardware interrupt: 0
	Falling edge7	Falling edge7	
C	PROFINET interface [X1]\Digital inputs\Channel8\		
	Channel address	I1.0	Input filters 6.4 millisec
	Enable pulse catch	0	
	PROFINET interface [X1]\Digital inputs\Channel8\		
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent 49160
	Event name:	0	Hardware interrupt: 0
	Rising edge8	Rising edge8	
D	PROFINET interface [X1]\Digital inputs\Channel8\		
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent 49288
	Event name:	0	Hardware interrupt: 0
	Falling edge8	Falling edge8	
E	PROFINET interface [X1]\Digital inputs\Channel9\		
	Channel address	I1.1	Input filters 6.4 millisec
	Enable pulse catch	0	
	PROFINET interface [X1]\Digital inputs\Channel9\		
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent 49161
	Event name:	0	Hardware interrupt: 0
	Rising edge9	Rising edge9	
F	PROFINET interface [X1]\Digital inputs\Channel9\		
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent 49289
	Event name:	0	Hardware interrupt: 0
	Falling edge9	Falling edge9	
	PROFINET interface [X1]\Digital inputs\Channel10\		
	Channel address	I1.2	Input filters 6.4 millisec
	Enable pulse catch	0	
	PROFINET interface [X1]\Digital inputs\Channel10\		
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent 49162
	Event name:	0	Hardware interrupt: 0
	Rising edge10	Rising edge10	
	Owner	Project name Automation Production Station Code	Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
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A	PROFINET interface [X1]\Digital inputs\Channel10\		
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent 49290
	Event name:	0	Hardware inter-rupt: 0
	Falling edge10	Falling edge10	
	PROFINET interface [X1]\Digital inputs\Channel11\		
	Channel address	I1.3	Input filters 6.4 millisec
	Enable pulse catch	0	
B	PROFINET interface [X1]\Digital inputs\Channel11\		
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent 49163
	Event name:	0	Hardware inter-rupt: 0
	Rising edge11	Rising edge11	
	PROFINET interface [X1]\Digital inputs\Channel11\		
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent 49291
	Event name:	0	Hardware inter-rupt: 0
	Falling edge11	Falling edge11	
C	PROFINET interface [X1]\Digital inputs\Channel12\		
	Channel address	I1.4	Input filters 6.4 millisec
	Enable pulse catch	0	
	PROFINET interface [X1]\Digital inputs\Channel13\		
	Channel address	I1.5	Input filters 6.4 millisec
	Enable pulse catch	0	
	PROFINET interface [X1]\Analog inputs\Noise reduction\		
	Integration time	50 Hz (20 ms)	
D	PROFINET interface [X1]\Analog inputs\Channel0\		
	Channel address	IW64	Measurement type Voltage
	Voltage range	0..10 V	Smoothing Weak (4 cycles)
			Enable overflow di-agnostics 1
	PROFINET interface [X1]\Analog inputs\Channel1\		
	Channel address	IW66	Measurement type Voltage
	Voltage range	0..10 V	Smoothing Weak (4 cycles)
			Enable overflow di-agnostics 1
	PROFINET interface [X1]\Digital outputs\		
	Reaction to CPU STOP	Use substitute value	
E	PROFINET interface [X1]\Digital outputs\Channel0\		
	Channel address	Q0.0	Substitute a value of 1 on a change from RUN to STOP. 0
	PROFINET interface [X1]\Digital outputs\Channel1\		
	Channel address	Q0.1	Substitute a value of 1 on a change from RUN to STOP. 0
F	Owner	Project name Automation Production Station Code	Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
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A	PROFINET interface [X1]\Digital outputs\Channel2			
	Channel address	Q0.2	Substitute a value of 1 on a change from RUN to STOP.	0
	PROFINET interface [X1]\Digital outputs\Channel3			
B	Channel address	Q0.3	Substitute a value of 1 on a change from RUN to STOP.	0
	PROFINET interface [X1]\Digital outputs\Channel4			
	Channel address	Q0.4	Substitute a value of 1 on a change from RUN to STOP.	0
C	PROFINET interface [X1]\Digital outputs\Channel5			
	Channel address	Q0.5	Substitute a value of 1 on a change from RUN to STOP.	0
	PROFINET interface [X1]\Digital outputs\Channel6			
D	Channel address	Q0.6	Substitute a value of 1 on a change from RUN to STOP.	0
	PROFINET interface [X1]\Digital outputs\Channel7			
	Channel address	Q0.7	Substitute a value of 1 on a change from RUN to STOP.	0
E	PROFINET interface [X1]\Digital outputs\Channel8			
	Channel address	Q1.0	Substitute a value of 1 on a change from RUN to STOP.	0
	PROFINET interface [X1]\Digital outputs\Channel9			
F	Channel address	Q1.1	Substitute a value of 1 on a change from RUN to STOP.	0
	PROFINET interface [X1]\Operating mode			
	IO controller	True	IO system	
G	Device number	0	IO device	False
	PROFINET interface [X1]\I/O addresses\Input addresses			
	Start address	0.0	End address	1.7
H	Start address	4.0	End address	4.7
	Organization block	0	Organization block	0
	Process image	0	Process image	0
I	PROFINET interface [X1]\I/O addresses\Input addresses			
	Start address	64	End address	67
	Organization block	0	Process image	0
J	PROFINET interface [X1]\I/O addresses\Output addresses			
	Start address	0.0	End address	1.7
	Organization block	0	Process image	0
K	PROFINET interface [X1]\Advanced options\Interface options			
	Support device re-placement without exchangeable medium	True	Use IEC V2.2 LLDP mode	True
	Keep-Alive connection monitoring:	30s		

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A	PROFINET interface [X1]\Advanced options\Real time settings\IO communication			
	Send clock:	1.000ms		
	PROFINET interface [X1]\Advanced options\Real time settings\Real time options			
	Calculated band-width for cyclic IO data:	0.000ms	Calculated band-width for cyclic IO data:	0.000%
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\General			
	Name	Port_1	Author	MTC-MECH-05
	Comment			
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Local port:			
	Local port:	PLC_3\PROFINET interface_1 [X1]\Port_1 [X1 P1]	Medium:	Copper
	Cable name:	---		
B				
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Partner port:			
	Monitoring of partner port is not possible		Partner port:	Any partner
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Activate			
	Activate this port for use	True		
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Connection			
	Transmission rate / duplex:	Automatic	Monitor	False
	Enable autonegotiation	True		
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Boundaries			
	End of detection of accessible devices	False	End of topology discovery	False
C	End of the sync domain	False		
	High speed counters (HSC)\HSC1\General\Enable			
	Enable this high speed counter	0	Enable this high speed counter	0
	Enable this high speed counter	0	Enable this high speed counter	0
	Enable this high speed counter	0	Enable this high speed counter	0
	High speed counters (HSC)\HSC1\General\Project information			
	Name	HSC_1	Comment	
	Name	HSC_2	Comment	
	Name	HSC_3	Comment	
	Name	HSC_4	Comment	
D	Name	HSC_5	Comment	
	Name	HSC_6	Comment	
	Owner			
	Project name			7/12/2025
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E	Operator			
	Location			
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A	High speed counters (HSC)\HSC1\I/O addresses\Input addresses			
	Start address	1000.0	End address	1003.7
	Start address	1004.0	End address	1007.7
	Organization block	0	Start address	1008.0
	End address	1011.7	Organization block	0
	Process image	0	Start address	1012.0
	End address	1015.7	Organization block	0
	Process image	0	Start address	1016.0
	End address	1019.7	Organization block	0
	Process image	0	Start address	1020.0
B	End address	1023.7	Organization block	0
	Process image	0	Organization block	0
	Process image	0	Process image	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Enable			
	Enable this pulse generator	0	Enable this pulse generator	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Project information			
	Name	Pulse_1	Comment	
	Name	Pulse_2	Comment	
	Pulse generators (PTO/PWM)\PTO1/PWM1\I/O addresses\Output addresses			
	Start address	1000.0	End address	1001.7
C	Start address	1002.0	End address	1003.7
	Organization block	0	Organization block	0
	Process image	0	Process image	0
	Startup			
	Startup after POWER ON	Warm restart - mode before POWER OFF	Comparison preset to actual configuration	Startup CPU even if mismatch
	Configuration time	60000ms	OBs should be interruptible	1
	Cycle			
	Cycle monitoring time	150ms		
	Enable minimum cycle time for cyclic OBs	0	Minimum cycle time	1ms
	Communication load			
D	Cycle load due to communication	20%		
	System and clock memory\System memory bits			
	Enable the use of system memory byte	1	Address of system memory byte (MBx)	1
	First cycle	%M1.0 (FirstScan)	Diagnostic status changed	%M1.1 (DiagStatusUpdate)
	Always 1 (high)	%M1.2 (AlwaysTRUE)	Always 0 (low)	%M1.3 (AlwaysFALSE)
	System and clock memory\Clock memory bits			
	Enable the use of clock memory byte	1	Address of clock memory byte (MBx)	0
	10 Hz clock	%M0.0 (Clock_10Hz)	5 Hz clock	%M0.1 (Clock_5Hz)
	2.5 Hz clock	%M0.2 (Clock_2.5Hz)	2 Hz clock	%M0.3 (Clock_2Hz)
	1.25 Hz clock	%M0.4 (Clock_1.25Hz)	1 Hz clock	%M0.5 (Clock_1Hz)
E	0.625 Hz clock	%M0.6 (Clock_0.625Hz)	0.5 Hz clock	%M0.7 (Clock_0.5Hz)
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A	Web server\General				
	Activate web server on this module	False	Permit access only with HTTPS	True	
	Web server\Automatic update				
	Enable automatic update	True	Update interval	0s	
	Web server\User interface languages				
	Assign project language		User interface languages		
	English (United States)		German		
	English (United States)		English		
	English (United States)		French		
	English (United States)		Spanish		
B	English (United States)		Italian		
	English (United States)		Chinese (simplified)		
	Web server\User management				
	User name		User rights		
	Everybody				
	Web server\User-defined web pages				
	Application name	HTML source path	Default HTML page	Files with dy- namic content	Web DB number
			index.htm	.htm;.html	333
					334
	User interface languages				
C	Assign project language		User interface languages		
	English (United States)		German		
	English (United States)		English		
	English (United States)		French		
	English (United States)		Spanish		
	English (United States)		Italian		
	English (United States)		Chinese (simplified)		
	Time of day\Local time				
	Time zone	(UTC +01:00) Berlin, Bern, Brus- sels, Rome, Stockholm, Vienna			
	Time of day\Daylight saving time				
D	Activate daylight saving time	1	Difference between standard and day- light saving time	60mins	
	Time of day\Daylight saving time\Start of daylight saving time				
	Starting week of the month:	Last		Sunday	
	of	March	at	01:00 a.m.	
	Time of day\Daylight saving time\Start of standard time				
		Last		Sunday	
	of	October	at	02:00 a.m.	
	Protection & Security				
	Level of protection	No protection			
	Protection & Security\Connection mechanisms				
E	Permit access with PUT/GET commun- ication from remote partner	True			
	Overview of addresses\Overview of addresses\Overview of addresses				
	Inputs	True	Outputs	True	
	Owner	Project name	Automation Production Station Code	Date	7/12/2025
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A	Address gaps	False	Slot	True
B				
C				
D				
E				
F	Owner	Project name	Automation Production Station Code	Date 7/12/2025
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A	Type	I	Addr. from	0	Addr. to	1
	Module	DI 14/DQ 10_1	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
B	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 1	Addr. to	1
C	Type	O	Addr. from	0	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Module	DI 14/DQ 10_1	PIP	Automatic update	Master / IO system	-
D	Device number	-	Size	2 Bytes	Addr. to	67
	Rack	0	Slot	1 1	Device name	PLC_3 [CPU 1214C DC/DC/DC]
E	Type	I	Addr. from	64	Master / IO system	-
	Module	AI 2_1	PIP	Automatic update	Addr. to	4
F	Device number	-	Size	4 Bytes	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Rack	0	Slot	1 2	Master / IO system	-
G	Type	I	Addr. from	4	Addr. to	1003
	Module	DI 4x24VDC_1	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
H	Device number	-	Size	1 Bytes	Master / IO system	-
	Rack	0	Slot	1 3	Addr. to	1004
I	Type	I	Addr. from	1000	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Module	HSC_1	PIP	Automatic update	Master / IO system	-
J	Device number	-	Size	4 Bytes	Addr. to	1007
	Rack	0	Slot	1 16	Device name	PLC_3 [CPU 1214C DC/DC/DC]
K	Type	I	Addr. from	1004	Master / IO system	-
	Module	HSC_2	PIP	Automatic update	Addr. to	1011
L	Device number	-	Size	4 Bytes	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Rack	0	Slot	1 17	Master / IO system	-
M	Type	I	Addr. from	1008	Addr. to	1015
	Module	HSC_3	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
N	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 18	Addr. to	1019
O	Type	I	Addr. from	1012	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Module	HSC_4	PIP	Automatic update	Master / IO system	-
P	Device number	-	Size	4 Bytes	Addr. to	1019
	Rack	0	Slot	1 19	Device name	PLC_3 [CPU 1214C DC/DC/DC]
Q	Type	I	Addr. from	1016	Master / IO system	-
	Module	HSC_5	PIP	Automatic update	Version	Sheet 103 - 12
R	Owner	Project name Automation Production Station Code			Date	7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Location	
S	Designed By	Description 1st			Language	en-US
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A	Rack	0	Slot	1 20		
	Type	I	Addr. from	1020	Addr. to	1023
	Module	HSC_6	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 21		
	Type	O	Addr. from	1000	Addr. to	1001
	Module	Pulse_1	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 32		
	Type	O	Addr. from	1002	Addr. to	1003
B	Module	Pulse_2	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 33		
	Type	O	Addr. from	1004	Addr. to	1005
	Module	Pulse_3	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 34		
	Type	O	Addr. from	1006	Addr. to	1007
	Module	Pulse_4	PIP	Automatic update	Device name	PLC_3 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
C	Rack	0	Slot	1 35		
D						
E						
F	Owner		Project name	Automation Production Station Code	Date	7/12/2025
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A

Automation Production Station Code

PLC_4 [CPU 1214C DC/DC/DC]

PLC_4			
General\Project information			
Name	PLC_4	Author	MTC-MECH-05
Comment		Slot	1
Rack	0		
General\Catalog information			
Short designation	CPU 1214C DC/DC/DC	Description	Work memory 75 KB; 24VDC power supply with DI14 x 24VDC SINK/SOURCE, DQ10 x 24VDC and AI2 on board; 6 high-speed counters and 4 pulse outputs on board; signal board expands on-board I/O; up to 3 communication modules for serial communication; up to 8 signal modules for I/O expansion; PROFINET interface for programming, HMI and PLC-to-PLC communication
Article number	6ES7 214-1AG40-0XB0	Firmware version	V4.0
General\Identification & Maintenance			
Plant designation		Location identifier	
Installation date	2025-06-11 06:03:20.618	Additional information	
Connection resources			
PG communication:	1	OP communication:	1
S7 basic communication:	0	S7 communication:	0
Maximum number of S7 connection resources:	38		
PROFINET interface [X1]\General			
Name	PROFINET interface_1	Author	MTC-MECH-05
Comment			
PROFINET interface [X1]\General\Project information			
Name	DI 14/DQ 10_1	Comment	
Name	AI 2_1	Comment	
PROFINET interface [X1]\Ethernet addresses\Interface networked with			
Subnet:	PN/IE_1		
PROFINET interface [X1]\Ethernet addresses\IP protocol			
IP configuration	Set IP address in the project	IP address:	192.168.0.4
Subnet mask:	255.255.255.0	Use router	False
PROFINET interface [X1]\Ethernet addresses\PROFINET			
PROFINET device name is set directly at the device	False	Generate PROFINET device name automatically	True
PROFINET device name:	plc_4	Converted name:	plcxb4d32d
Device number:	0		

B

C

D

E

F

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PROFINET interface [X1]\Time synchronization			
Enable time synchronization via NTP server	Enable time synchronization via NTP server		IP addresses
Server 1	0.0.0.0	Server 2	0.0.0.0
Server 3	0.0.0.0	Server 4	0.0.0.0
Update interval	10sec		
PROFINET interface [X1]\Digital inputs\Channel0			
Channel address	I0.0	Input filters	6.4 millisec
Enable pulse catch	0		
PROFINET interface [X1]\Digital inputs\Channel0\			
Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49152
Event name:	0	Hardware interrupt:	0
Rising edge0	Rising edge0		
PROFINET interface [X1]\Digital inputs\Channel0\			
Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49280
Event name:	0	Hardware interrupt:	0
Falling edge0	Falling edge0		
PROFINET interface [X1]\Digital inputs\Channel1			
Channel address	I0.1	Input filters	6.4 millisec
Enable pulse catch	0		
PROFINET interface [X1]\Digital inputs\Channel1\			
Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49153
Event name:	0	Hardware interrupt:	0
Rising edge1	Rising edge1		
PROFINET interface [X1]\Digital inputs\Channel1\			
Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49281
Event name:	0	Hardware interrupt:	0
Falling edge1	Falling edge1		
PROFINET interface [X1]\Digital inputs\Channel2			
Channel address	I0.2	Input filters	6.4 millisec
Enable pulse catch	0		
PROFINET interface [X1]\Digital inputs\Channel2\			
Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49154
Event name:	0	Hardware interrupt:	0
Rising edge2	Rising edge2		
PROFINET interface [X1]\Digital inputs\Channel2\			
Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49282
Event name:	0	Hardware interrupt:	0
Falling edge2	Falling edge2		

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A	PROFINET interface [X1]\Digital inputs\Channel3			
	Channel address	I0.3	Input filters	6.4 millisec
B	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49155
	Event name:	0	Hardware interrupt:	0
C	Rising edge3	Rising edge3		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49283
	Event name:	0	Hardware interrupt:	0
D	Falling edge3	Falling edge3		
	PROFINET interface [X1]\Digital inputs\Channel4			
	Channel address	I0.4	Input filters	6.4 millisec
	Enable pulse catch	0		
E	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49156
	Event name:	0	Hardware interrupt:	0
	Rising edge4	Rising edge4		
F	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49284
	Event name:	0	Hardware interrupt:	0
	Falling edge4	Falling edge4		
D	PROFINET interface [X1]\Digital inputs\Channel5			
	Channel address	I0.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel5\			
E	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49157
	Event name:	0	Hardware interrupt:	0
	Rising edge5	Rising edge5		
	PROFINET interface [X1]\Digital inputs\Channel5\			
F	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49285
	Event name:	0	Hardware interrupt:	0
	Falling edge5	Falling edge5		
	PROFINET interface [X1]\Digital inputs\Channel6			
G	Channel address	I0.6	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel6\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49158
H	Event name:	0	Hardware interrupt:	0
	Owner	Project name Automation Production Station Code		Date 7/12/2025
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	1	2	3	4
A	Rising edge6	Rising edge6		
	PROFINET interface [X1]\Digital inputs\Channel6\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49286
	Event name:	0	Hardware inter-rupt:	0
	Falling edge6	Falling edge6		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Channel address	I0.7	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel7\			
B	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49159
	Event name:	0	Hardware inter-rupt:	0
	Rising edge7	Rising edge7		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49287
	Event name:	0	Hardware inter-rupt:	0
	Falling edge7	Falling edge7		
	PROFINET interface [X1]\Digital inputs\Channel8\			
C	Channel address	I1.0	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel8\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49160
	Event name:	0	Hardware inter-rupt:	0
	Rising edge8	Rising edge8		
	PROFINET interface [X1]\Digital inputs\Channel8\			
D	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49288
	Event name:	0	Hardware inter-rupt:	0
	Falling edge8	Falling edge8		
	PROFINET interface [X1]\Digital inputs\Channel9\			
	Channel address	I1.1	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel9\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49161
	Event name:	0	Hardware inter-rupt:	0
	Rising edge9	Rising edge9		
	PROFINET interface [X1]\Digital inputs\Channel9\			
E	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49289
	Event name:	0	Hardware inter-rupt:	0
	Falling edge9	Falling edge9		
F	Owner	Project name	Automation Production Station Code	Date 7/12/2025
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location		
	Checked By	Description 1st	Language	en-US
	Approved By	1st View	Version	Sheet 104 - 4

A	PROFINET interface [X1]\Digital inputs\Channel10			
	Channel address	I1.2	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49162
	Event name:	0	Hardware interrupt:	0
	Rising edge10	Rising edge10		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49290
	Event name:	0	Hardware interrupt:	0
B	Falling edge10	Falling edge10		
	PROFINET interface [X1]\Digital inputs\Channel11			
	Channel address	I1.3	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49163
	Event name:	0	Hardware interrupt:	0
	Rising edge11	Rising edge11		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49291
C	Event name:	0	Hardware interrupt:	0
	Falling edge11	Falling edge11		
	PROFINET interface [X1]\Digital inputs\Channel12			
	Channel address	I1.4	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel13			
	Channel address	I1.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Analog inputs\Noise reduction			
	Integration time	50 Hz (20 ms)		
D	PROFINET interface [X1]\Analog inputs\Channel0			
	Channel address	IW64	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Analog inputs\Channel1			
	Channel address	IW66	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Digital outputs			
	Reaction to CPU STOP	Use substitute value		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
	Designed By	Location		
	Checked By	Description 1st		
	Approved By	Description 2nd	Language en-US	
		1st View	Version	Sheet 104 - 5

A	PROFINET interface [X1]\Digital outputs\Channel0					
	Channel address	Q0.0	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel1					
	Channel address	Q0.1	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel2					
	Channel address	Q0.2	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel3					
	Channel address	Q0.3	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel4					
	Channel address	Q0.4	Substitute a value of 1 on a change from RUN to STOP.	0		
B	PROFINET interface [X1]\Digital outputs\Channel5					
	Channel address	Q0.5	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel6					
	Channel address	Q0.6	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel7					
	Channel address	Q0.7	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel8					
	Channel address	Q1.0	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel9					
	Channel address	Q1.1	Substitute a value of 1 on a change from RUN to STOP.	0		
C	PROFINET interface [X1]\Operating mode					
	IO controller	True	IO system			
	Device number	0	IO device	False		
	PROFINET interface [X1]\I/O addresses\Input addresses					
	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Input addresses					
	Start address	64	End address	67		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Output addresses					
D	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Output addresses					
	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025		
	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code					
	Location					
	Designed By	Description 1st				
	Checked By	Description 2nd	Language en-US			
F	Approved By	1st View	Version	Sheet 104 - 6		

A	PROFINET interface [X1]\Advanced options\Interface options			
	Support device replacement without exchangeable medium	True	Use IEC V2.2 LLDP mode	
	Keep-Alive connection monitoring:	30s		

B	PROFINET interface [X1]\Advanced options\Real time settings\IO communication		
	Send clock:	1.000ms	
	PROFINET interface [X1]\Advanced options\Real time settings\Real time options		
	Calculated bandwidth for cyclic IO data:	0.000ms	Calculated bandwidth for cyclic IO data:
	0.000%		

	PROFINET interface [X1]\Advanced options\Port [X1 P1]\General		
	Name	Port_1	Author
	Comment		
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Local port:		
	Local port:	PLC_4\PROFINET interface_1 [X1]\Port_1 [X1 P1]	Medium:
	Cable name:	---	Copper



	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Partner port:		
	Monitoring of partner port is not possible	Partner port:	Any partner

	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Activate		
	Activate this port for use	True	

D	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Connection		
	Transmission rate / duplex:	Automatic	Monitor
	Enable autonegotiation	True	False

	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Boundaries		
	End of detection of accessible devices	False	End of topology discovery
	End of the sync domain	False	False

E	High speed counters (HSC)\HSC1\General\Enable		
	Enable this high speed counter	0	Enable this high speed counter
	Enable this high speed counter	0	Enable this high speed counter
	Enable this high speed counter	0	Enable this high speed counter
	High speed counters (HSC)\HSC1\General\Project information		
	Name	HSC_1	Comment

	Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
	Designed By	Location			
	Checked By	Description 1st			
F	Approved By	Description 2nd	Language	en-US	Version
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A	Name	HSC_2	Comment	
	Name	HSC_3	Comment	
	Name	HSC_4	Comment	
	Name	HSC_5	Comment	
	Name	HSC_6	Comment	
	High speed counters (HSC)\HSC1\I/O addresses\Input addresses			
B	Start address	1000.0	End address	1003.7
	Start address	1004.0	End address	1007.7
	Organization block	0	Start address	1008.0
	End address	1011.7	Organization block	0
	Process image	0	Start address	1012.0
	End address	1015.7	Organization block	0
	Process image	0	Start address	1016.0
	End address	1019.7	Organization block	0
	Process image	0	Start address	1020.0
	End address	1023.7	Organization block	0
C	Process image	0	Organization block	0
	Process image	0	Process image	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Enable			
	Enable this pulse generator	0	Enable this pulse generator	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Project information			
	Name	Pulse_1	Comment	
	Name	Pulse_2	Comment	
	Pulse generators (PTO/PWM)\PTO1/PWM1\I/O addresses\Output addresses			
	Start address	1000.0	End address	1001.7
	Start address	1002.0	End address	1003.7
D	Organization block	0	Organization block	0
	Process image	0	Process image	0
	Startup			
	Startup after POWER ON	Warm restart - mode before POWER OFF	Comparison preset to actual configuration	Startup CPU even if mismatch
	Configuration time	60000ms	OBs should be interruptible	1
	Cycle			
	Cycle monitoring time	150ms		
	Enable minimum cycle time for cyclic OBs	0	Minimum cycle time	1ms
	Communication load			
	Cycle load due to communication	20%		
E	System and clock memory\System memory bits			
	Enable the use of system memory byte	1	Address of system memory byte (MBx)	1
	First cycle	%M1.0 (FirstScan)	Diagnostic status changed	%M1.1 (DiagStatusUpdate)
	Always 1 (high)	%M1.2 (AlwaysTRUE)	Always 0 (low)	%M1.3 (AlwaysFALSE)
F	Owner	Project name Automation Production Station Code		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
	Designed By	Location		
	Checked By	Description 1st	Description 2nd	Language en-US
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A	System and clock memory\Clock memory bits					
	Enable the use of clock memory byte	1	Address of clock memory byte (MBx)			
	10 Hz clock	%M0.0 (Clock_10Hz)	5 Hz clock			
	2.5 Hz clock	%M0.2 (Clock_2.5Hz)	2 Hz clock			
	1.25 Hz clock	%M0.4 (Clock_1.25Hz)	1 Hz clock			
	0.625 Hz clock	%M0.6 (Clock_0.625Hz)	0.5 Hz clock			
B	Web server\General					
	Activate web server on this module	False	Permit access only with HTTPS			
	Web server\Automatic update					
	Enable automatic update	True	Update interval			
C	Web server\User interface languages					
	Assign project language		User interface languages			
	English (United States)		German			
	English (United States)		English			
	English (United States)		French			
	English (United States)		Spanish			
	English (United States)		Italian			
	English (United States)		Chinese (simplified)			
D	Web server\User management					
	User name		User rights			
	Everybody					
E	Web server\User-defined web pages					
	Application name	HTML source path	Default HTML page	Files with dynamic content	Web DB number	Fragment DB number
			index.htm	.htm;.html	333	334
F	User interface languages					
	Assign project language		User interface languages			
	English (United States)		German			
	English (United States)		English			
	English (United States)		French			
	English (United States)		Spanish			
	English (United States)		Italian			
	English (United States)		Chinese (simplified)			
	Time of day\Local time					
	Time zone	(UTC +01:00) Berlin, Bern, Brussels, Rome, Stockholm, Vienna				
	Time of day\Daylight saving time					
	Activate daylight saving time	1	Difference between standard and daylight saving time			
			60mins			
	Time of day\Daylight saving time\Start of daylight saving time					
	Starting week of the month:	Last	Sunday			
	of	March	at 01:00 a.m.			
	Time of day\Daylight saving time\Start of standard time					
	Last		Sunday			
	of	October	at 02:00 a.m.			
	Protection & Security					
	Level of protection	No protection				
	Owner	Project name	Automation Production Station Code	Date	7/12/2025	
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
	Designed By	Location				
	Checked By	Description 1st	Description 2nd	Language	en-US	
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A

Protection & Security\Connection mechanisms

Permit access with True
 PUT/GET communication from remote partner

Overview of addresses\Overview of addresses\Overview of addresses

Inputs	True	Outputs	True
Address gaps	False	Slot	True

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 104 - 10

A	Type	I	Addr. from	0	Addr. to	1
	Module	DI 14/DQ 10_1	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 1		
	Type	O	Addr. from	0	Addr. to	1
	Module	DI 14/DQ 10_1	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
B	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 1		
	Type	I	Addr. from	64	Addr. to	67
	Module	AI 2_1	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 2		
C	Type	I	Addr. from	1000	Addr. to	1003
	Module	HSC_1	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 16		
	Type	I	Addr. from	1004	Addr. to	1007
	Module	HSC_2	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
D	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 17		
	Type	I	Addr. from	1008	Addr. to	1011
	Module	HSC_3	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 18		
E	Type	I	Addr. from	1012	Addr. to	1015
	Module	HSC_4	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 19		
	Type	I	Addr. from	1016	Addr. to	1019
	Module	HSC_5	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
F	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 20		
	Type	I	Addr. from	1020	Addr. to	1023
	Module	HSC_6	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location		
Checked By	Description 1st		
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A	Rack	0	Slot	1 21		
	Type	O	Addr. from	1000	Addr. to	1001
	Module	Pulse_1	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Device num- ber	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 32		
	Type	O	Addr. from	1002	Addr. to	1003
	Module	Pulse_2	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Device num- ber	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 33		
	Type	O	Addr. from	1004	Addr. to	1005
B	Module	Pulse_3	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Device num- ber	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 34		
	Type	O	Addr. from	1006	Addr. to	1007
	Module	Pulse_4	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
C	Device num- ber	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 35		

D																										
E																										
F	<table border="1"> <tr> <td>Owner</td> <td>Project name</td> <td>Automation Production Station Code</td> <td>Date</td> <td>7/12/2025</td> </tr> <tr> <td>Operator</td> <td>Project path</td> <td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td> </tr> <tr> <td>Designed By</td> <td>Description 1st</td> <td colspan="3"></td> </tr> <tr> <td>Checked By</td> <td>Description 2nd</td> <td>Language</td> <td colspan="2">en-US</td> </tr> <tr> <td>Approved By</td> <td>1st View</td> <td>Version</td> <td colspan="2">Sheet 104 - 12</td> </tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Description 1st				Checked By	Description 2nd	Language	en-US		Approved By	1st View	Version	Sheet 104 - 12	
Owner	Project name	Automation Production Station Code	Date	7/12/2025																						
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																								
Designed By	Description 1st																									
Checked By	Description 2nd	Language	en-US																							
Approved By	1st View	Version	Sheet 104 - 12																							

A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks

AUTO 4 [FC1]

AUTO 4 Properties

General

Name	AUTO 4	Number	1
Type	FC	Language	LAD

Numbering Automatic

Information

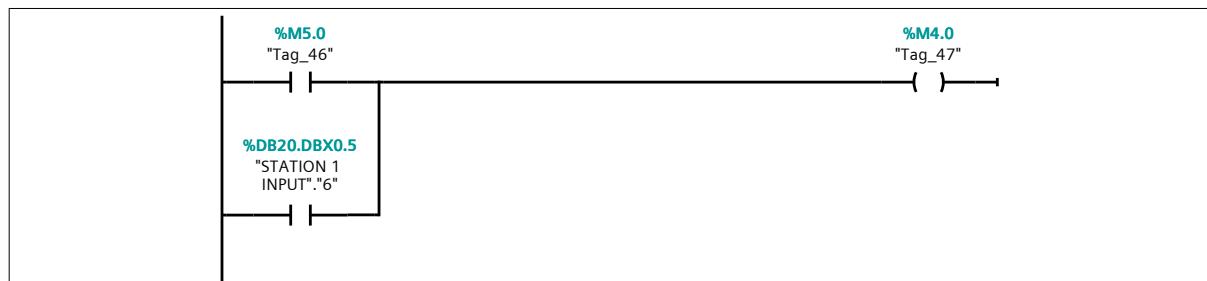
Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
AUTO 4	Void		

Network 1:

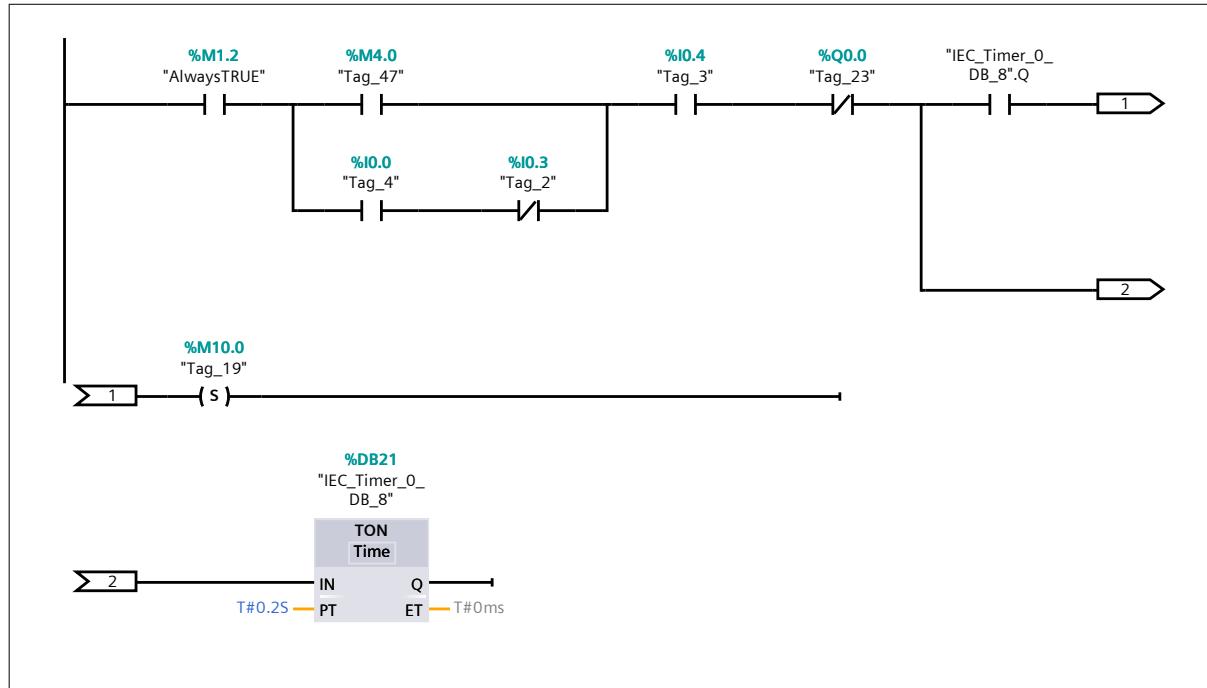
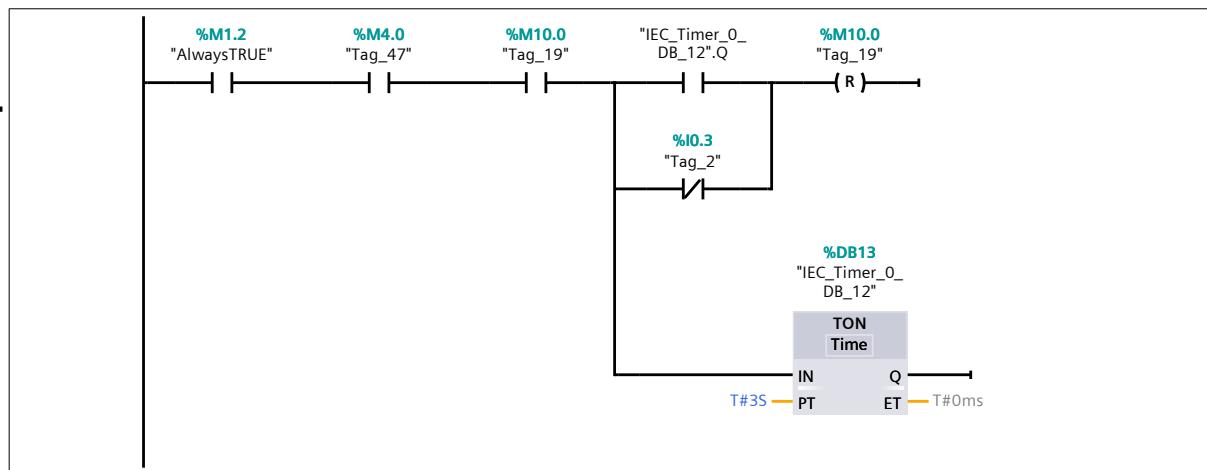


Network 2:

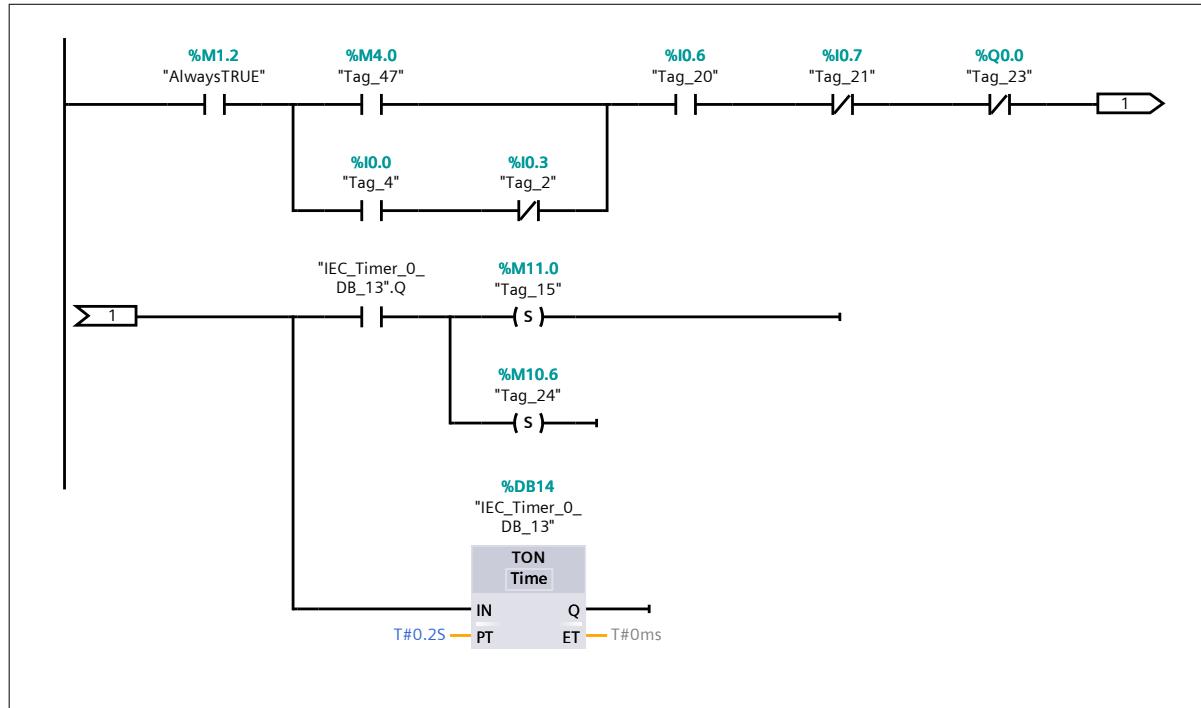
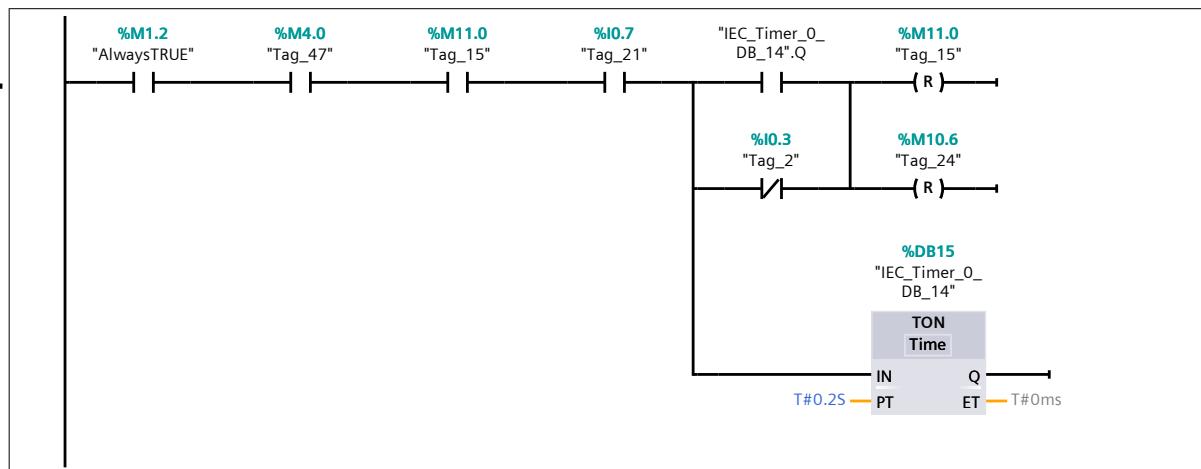


Network 3: CONVEYOR RUN1(START TO BUFFER CYL1)

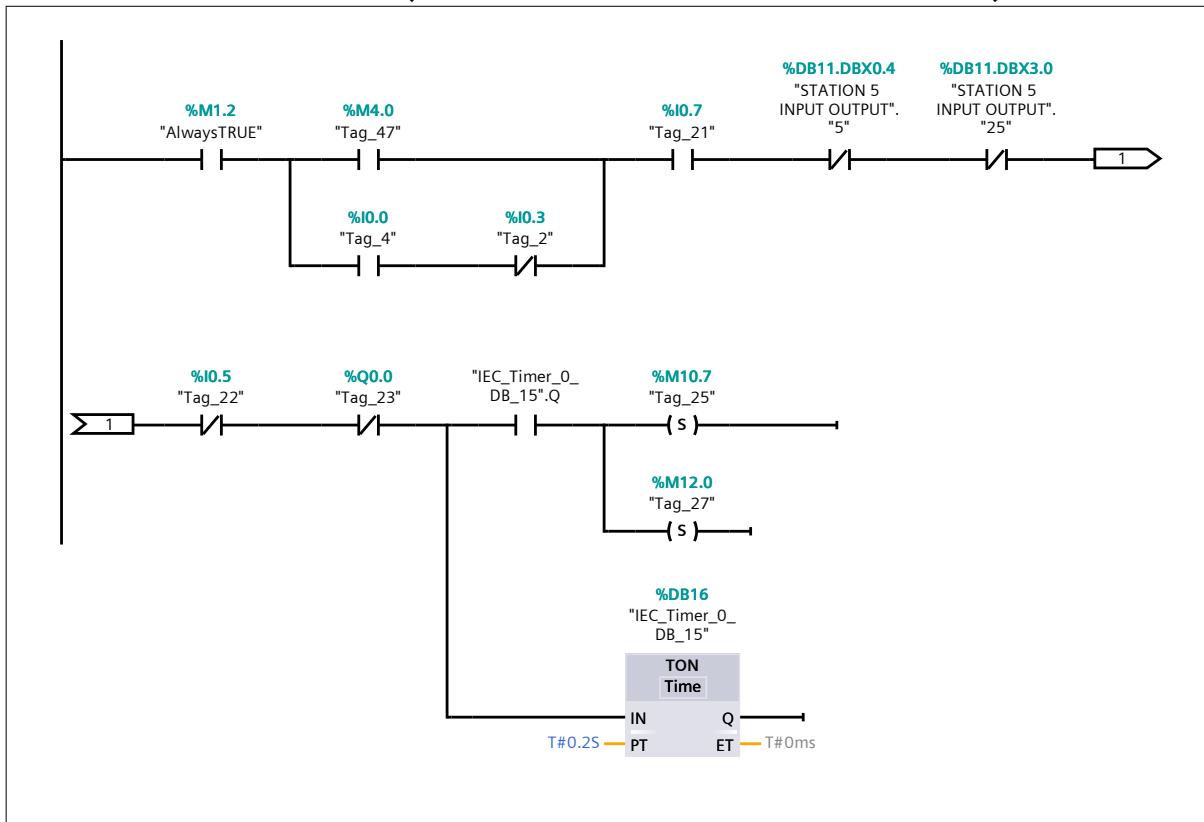
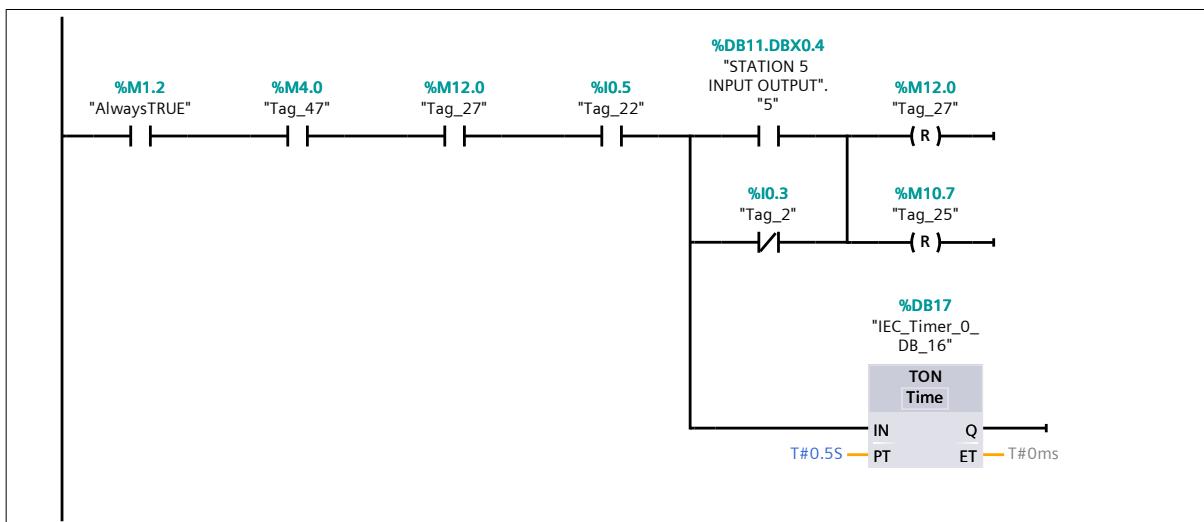
Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
Designed By	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Checked By	Location			
Approved By	Description 1st			
	Description 2nd		Language	en-US
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Network 3: CONVEYOR RUN1(START TO BUFFER CYL1)**Network 4:****Network 5: CONVEYOR RUN2 (BUFFER CYL1 TO BUFFER CYL2)**

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 105 - 2

Network 5: CONVEYOR RUN2 (BUFFER CYL1 TO BUFFER CYL2)**Network 6:****Network 7: CONVEYOR RUN3(BOTTLE MOVE FROM BUFFER CYL2 TO END)**

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
Location	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 105 - 3

Network 7: CONVEYOR RUN3(BOTTLE MOVE FROM BUFFER CYL2 TO END)**Network 8:**

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 105 - 4

A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks

OUTPUTCALL 4 [FC2]

OUTPUTCALL 4 Properties

General

Name	OUTPUTCALL 4	Number	2
Type	FC	Language	LAD

Numbering Automatic

Information

Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
OUTPUTCALL 4	Void		

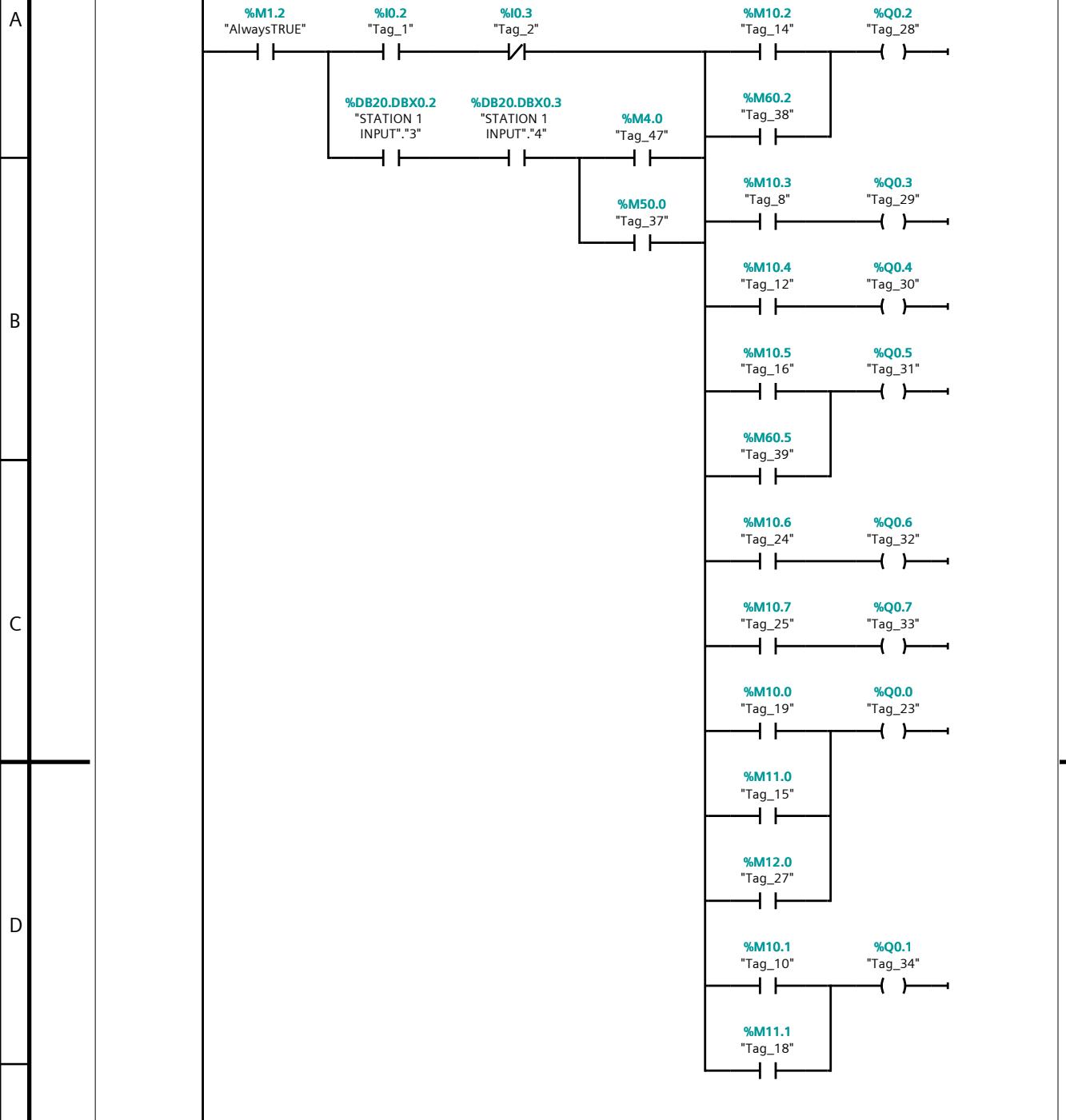
Network 1:

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
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A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks

ESTOP LOGIC 4 [FC3]

ESTOP LOGIC 4 Properties

General

Name	ESTOP LOGIC 4	Number	3
Type	FC	Language	LAD

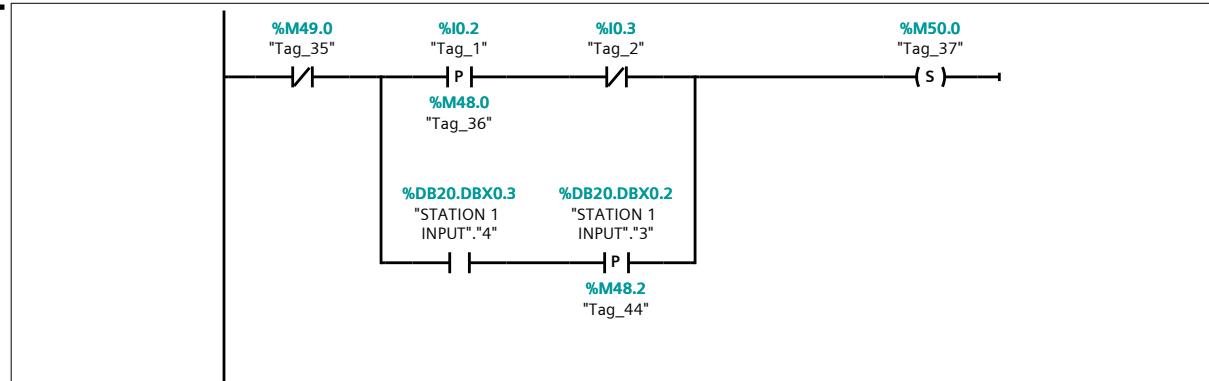
Numbering

Information

Title	Author
Comment	Family
Version	User-defined ID

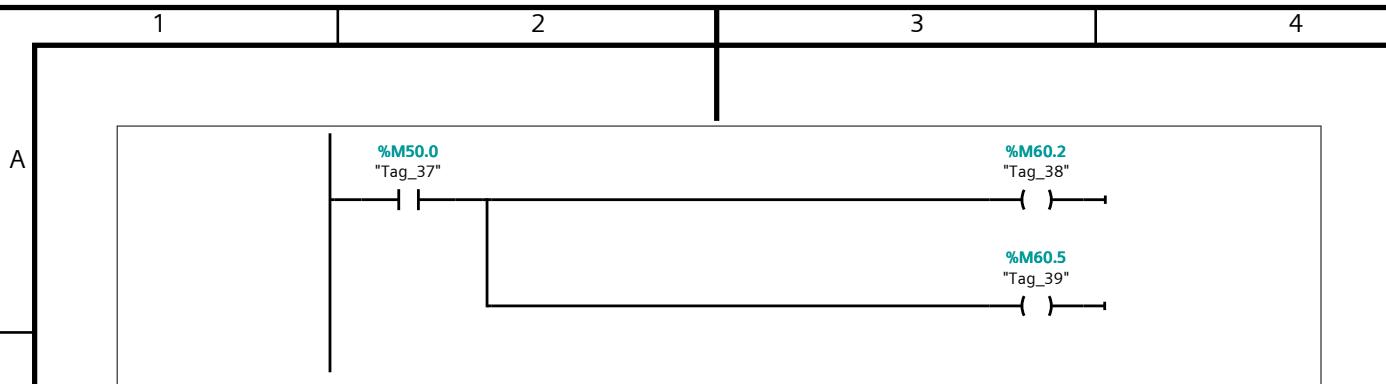
Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
ESTOP LOGIC 4	Void		

Network 1: ESTOP HOMING POSITION LOGIC



Network 2: OUTPUT CALL FOR HOMING

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
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**Network 3: MEMORY RESET**

B

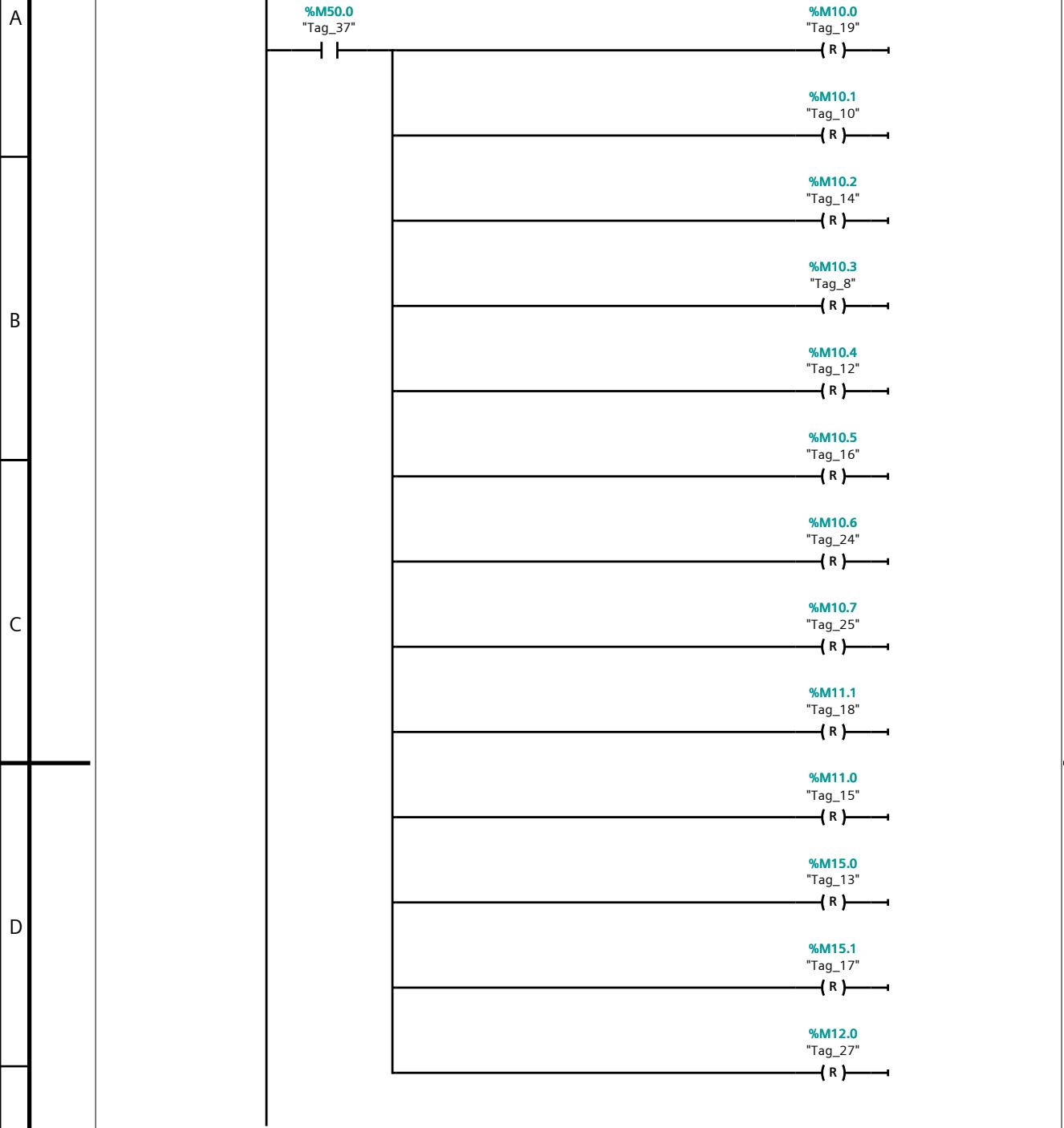
C

D

E

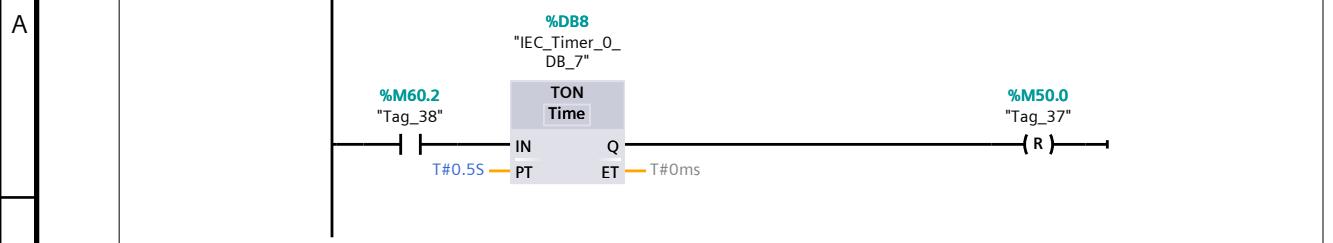
F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 107 - 2



Network 4: ESTOP LOGIC RESET

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 107 - 3



F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 107 - 4

A Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks

DATA BLOCK MOVE [FC4]

DATA BLOCK MOVE Properties

General

Name	DATA BLOCK MOVE	Number	4
Type	FC	Language	LAD

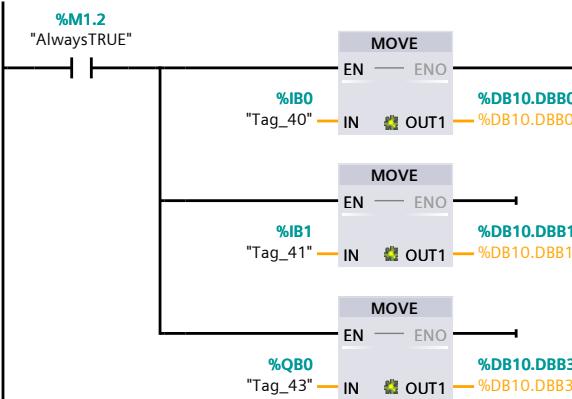
Numbering

Information

Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
DATA BLOCK MOVE	Void		

Network 1:



Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 108 - 1

A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks

COM 4 [FC5]

COM 4 Properties

General

Name	COM 4	Number	5
Type	FC	Language	LAD

Numbering Automatic

Information

Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
COM 4	Void		

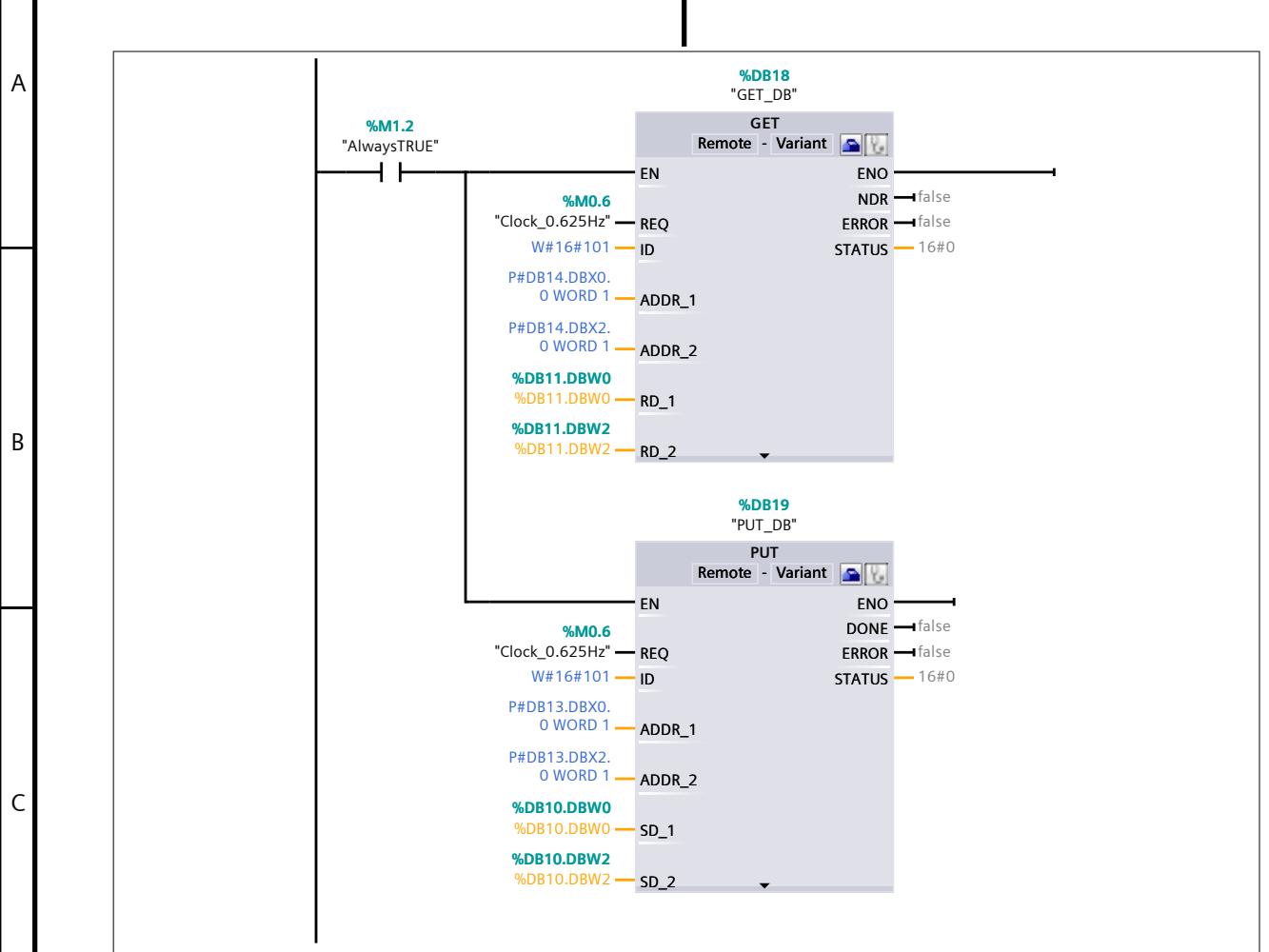
Network 1:

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 109 - 1



Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 109 - 2	

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks

Main [OB1]

Main Properties

General

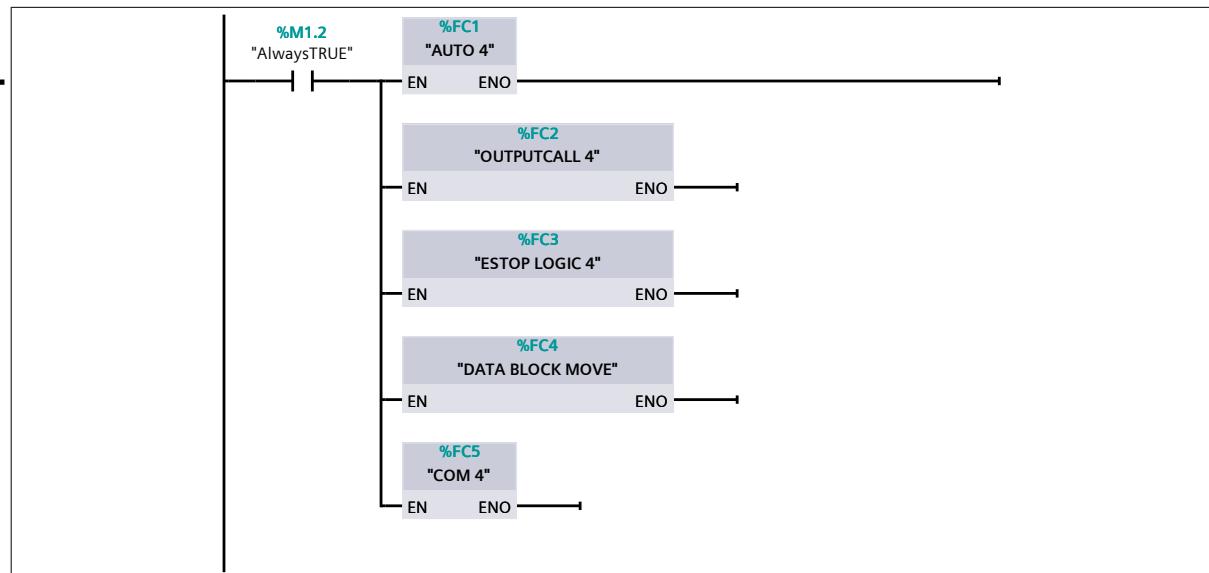
Name	Main	Number	1
Type	OB	Language	LAD
Numbering	Automatic		

Information

Title	"Main Program Sweep (Cycle)"	Author	
Comment		Family	
Version	0.1	User-defined ID	

Name	Data type	Default value	Comment
▼ Input			
Initial_Call	Bool		Initial call of this OB
Remanence	Bool		=True, if remanent data are available
Temp			
Constant			

Network 1:



Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 110 - 1

A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks

STATION 3 INPUT OUTPUT [DB9]

STATION 3 INPUT OUTPUT Properties

General

Name	STATION 3 INPUT OUTPUT	Number	9
Type	DB	Language	DB
Numbering	Automatic		

Information

Title	Author
Comment	Family
Version	User-defined ID



Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	1	Data type	Bool
Offset	0.0	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	2	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	3	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 111 - 1

F

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 7 Offset 0.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 8 Offset 0.7 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 111 - 2

A	Comment		
	Name	9	Data type Bool
	Offset	1.0	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
B	Comment		
	Name	10	Data type Bool
	Offset	1.1	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
C	Comment		
	Name	11	Data type Bool
	Offset	1.2	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
D	Comment		
	Name	12	Data type Bool
	Offset	1.3	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
E	Comment		
	Name	13	Data type Bool
	Offset	1.4	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
F	Name	14	Data type Bool
	Offset	1.5	Start value false

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 111 - 3

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	15	Data type	Bool
	Offset	1.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	16	Data type	Bool
	Offset	1.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	17	Data type	Bool
	Offset	2.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	18	Data type	Bool
	Offset	2.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	19	Data type	Bool
	Offset	2.2	Start value	false
F	Retain	False	Accessible from HMI/OPC UA/Web API	True
Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
Approved By		Description 2nd	Language en-US	Version
		1st View	Sheet 111 - 4	

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 20 Offset 2.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 21 Offset 2.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 22 Offset 2.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 23 Offset 2.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 24 Offset 2.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 111 - 5

A	Comment		
	Name	25	Data type
	Offset	3.0	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	26	Data type
	Offset	3.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	27	Data type
	Offset	3.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	28	Data type
C	Offset	3.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	29	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
D	Comment		
	Name	29	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		
E	Owner	Automation Production Station Code	Date 7/12/2025
	Project name		
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Operator		
	Location		
	Designed By	Description 1st	
	Checked By	Description 2nd	Language en-US
	Approved By	1st View	Version
			Sheet 111 - 6

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 111 - 6

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	31	Data type	Bool
	Offset	3.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	32	Data type	Bool
	Offset	3.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	33	Data type	Bool
	Offset	4.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
E				
F	Owner	Project name	Automation Production Station Code	Date 7/12/2025
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location		
	Checked By	Description 1st		
	Approved By	Description 2nd	Language	en-US
		1st View	Version	Sheet 111 - 7

A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks

STATION 4 INPUT OUTPUT [DB10]

STATION 4 INPUT OUTPUT Properties

General

Name	STATION 4 INPUT OUTPUT	Number	10
Type	DB	Language	DB
Numbering	Automatic		

B

Information

Title		Author	
Comment		Family	
Version	0.1	User-defined ID	

C

Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	1	Data type	Bool
Offset	0.0	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	2	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	3	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 112 - 1

F

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 7 Offset 0.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 8 Offset 0.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 112 - 2

A	Comment		
	Name	9	Data type Bool
	Offset	1.0	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	10	Data type Bool
	Offset	1.1	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	11	Data type Bool
	Offset	1.2	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	12	Data type Bool
C	Offset	1.3	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	13	Data type Bool
	Offset	1.4	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
D	Comment		
	Name	14	Data type Bool
	Offset	1.5	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	15	Data type Bool
	Offset	1.6	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
E	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	16	Data type Bool
	Offset	1.7	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	17	Data type Bool
F	Offset	1.8	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	18	Data type Bool
	Offset	1.9	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location		
Checked By	Description 1st		
Approved By	Description 2nd Language en-US		
	1st View Version Sheet 112 - 3		

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	15	Data type	Bool
	Offset	1.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	16	Data type	Bool
	Offset	1.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	17	Data type	Bool
	Offset	2.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	18	Data type	Bool
	Offset	2.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	19	Data type	Bool
	Offset	2.2	Start value	false
F	Retain	False	Accessible from HMI/OPC UA/Web API	True
Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
Approved By		Description 2nd	Language en-US	Version
		1st View	Sheet 112 - 4	

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 20 Offset 2.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 21 Offset 2.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 22 Offset 2.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 23 Offset 2.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 24 Offset 2.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 112 - 5

A	Comment		
	Name	25	Data type
	Offset	3.0	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	26	Data type
	Offset	3.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	27	Data type
	Offset	3.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	28	Data type
C	Offset	3.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	29	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
D	Comment		
	Name	29	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		
E	Owner	Automation Production Station Code	Date 7/12/2025
	Project name		
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Operator		
	Location		
	Designed By	Description 1st	
	Checked By	Description 2nd	Language en-US
	Approved By	1st View	Version
			Sheet 112 - 6

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	
	1st View	Version		Sheet 112 - 6

A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	31	Data type	Bool
	Offset	3.6	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	32	Data type	Bool
	Offset	3.7	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			

D			
E			
F	Owner	Project name	Automation Production Station Code
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location	
	Checked By	Description 1st	
	Approved By	Description 2nd	Language en-US
		1st View	Version
			Sheet 112 - 7

A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks

STATION 5 INPUT OUTPUT [DB11]

STATION 5 INPUT OUTPUT Properties

General

Name	STATION 5 INPUT OUTPUT	Number	11
Type	DB	Language	DB
Numbering	Automatic		

Information

Title	Author
Comment	Family
Version	User-defined ID



Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	1	Data type	Bool
Offset	0.0	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	2	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	3	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 113 - 1

F

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 7 Offset 0.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 8 Offset 0.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 113 - 2

A	Comment		
	Name	9	Data type Bool
	Offset	1.0	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
B	Comment		
	Name	10	Data type Bool
	Offset	1.1	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
C	Comment		
	Name	11	Data type Bool
	Offset	1.2	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
D	Comment		
	Name	12	Data type Bool
	Offset	1.3	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
E	Comment		
	Name	13	Data type Bool
	Offset	1.4	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
F	Name	14	Data type Bool
	Offset	1.5	Start value false

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 113 - 3

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	15	Data type	Bool
	Offset	1.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	16	Data type	Bool
	Offset	1.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	17	Data type	Bool
	Offset	2.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	18	Data type	Bool
	Offset	2.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	19	Data type	Bool
	Offset	2.2	Start value	false
F	Retain	False	Accessible from HMI/OPC UA/Web API	True
Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
Approved By		Description 2nd	Language en-US	Version
		1st View	Sheet 113 - 4	

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 20 Offset 2.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 21 Offset 2.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 22 Offset 2.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 23 Offset 2.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 24 Offset 2.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 113 - 5

A	Comment		
	Name	25	Data type
	Offset	3.0	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	26	Data type
	Offset	3.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	27	Data type
	Offset	3.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	28	Data type
D	Offset	3.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	29	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
E	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 113 - 6

A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	31	Data type	Bool
	Offset	3.6	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	32	Data type	Bool
	Offset	3.7	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			

D			
E			
F	Owner	Project name	Automation Production Station Code
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location	
	Checked By	Description 1st	
	Approved By	Description 2nd	Language en-US
		1st View	Version
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A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks

STATION 1 INPUT [DB20]

STATION 1 INPUT Properties

General

Name	STATION 1 INPUT	Number	20
Type	DB	Language	DB
Numbering	Automatic		

Information

Title	Author
Comment	Family
Version	User-defined ID



Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	1	Data type	Bool
Offset	0.0	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	2	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	3	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 114 - 1

F

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Visible in HMI engineering Supervision Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Visible in HMI engineering Supervision Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment	True	Visible in HMI engineering Supervision	True
E				
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 114 - 2

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_7 [DB8]

IEC_Timer_0_DB_7 Properties			
General			
Name	IEC_Timer_0_DB_7	Number	8
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 115 - 1	

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Visible in HMI engineering	True	Setpoint	False										
Supervision		Comment											
B													
C													

D																															
E																															
F	<table border="1"> <tr> <td>Owner</td> <td>Project name</td> <td>Automation Production Station Code</td> <td>Date</td> <td>7/12/2025</td> </tr> <tr> <td>Operator</td> <td>Project path</td> <td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td> </tr> <tr> <td>Designed By</td> <td>Location</td> <td colspan="3"></td> </tr> <tr> <td>Checked By</td> <td>Description 1st</td> <td colspan="3"></td> </tr> <tr> <td>Approved By</td> <td>Description 2nd</td> <td>Language</td> <td>en-US</td> <td></td> </tr> <tr> <td></td> <td>1st View</td> <td>Version</td> <td colspan="2">Sheet 115 - 2</td> </tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 115 - 2	
Owner	Project name	Automation Production Station Code	Date	7/12/2025																											
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																													
Designed By	Location																														
Checked By	Description 1st																														
Approved By	Description 2nd	Language	en-US																												
	1st View	Version	Sheet 115 - 2																												

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_12 [DB13]

IEC_Timer_0_DB_12 Properties			
General			
Name	IEC_Timer_0_DB_12	Number	13
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 116 - 1	

	1	2	3	4																									
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Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False																										
Visible in HMI engineering	True	Setpoint	False																										
Supervision		Comment																											
B																													
C																													
D																													
E																													
F	<table border="1"> <tr> <td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr> <td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr> <td>Designed By</td><td>Location</td><td colspan="3"></td></tr> <tr> <td>Checked By</td><td>Description 1st</td><td>Description 2nd</td><td>Language</td><td>en-US</td></tr> <tr> <td>Approved By</td><td>1st View</td><td></td><td>Version</td><td>Sheet 116 - 2</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st	Description 2nd	Language	en-US	Approved By	1st View		Version	Sheet 116 - 2			
Owner	Project name	Automation Production Station Code	Date	7/12/2025																									
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																											
Designed By	Location																												
Checked By	Description 1st	Description 2nd	Language	en-US																									
Approved By	1st View		Version	Sheet 116 - 2																									

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_13 [DB14]

IEC_Timer_0_DB_13 Properties			
General			
Name	IEC_Timer_0_DB_13	Number	14
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 117 - 1	

	1	2	3	4																									
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Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False																										
Visible in HMI engineering	True	Setpoint	False																										
Supervision		Comment																											
B																													
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F	<table border="1"> <tr> <td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr> <td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr> <td>Designed By</td><td>Location</td><td colspan="3"></td></tr> <tr> <td>Checked By</td><td>Description 1st</td><td>Description 2nd</td><td>Language</td><td>en-US</td></tr> <tr> <td>Approved By</td><td>1st View</td><td></td><td>Version</td><td>Sheet 117 - 2</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st	Description 2nd	Language	en-US	Approved By	1st View		Version	Sheet 117 - 2			
Owner	Project name	Automation Production Station Code	Date	7/12/2025																									
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																											
Designed By	Location																												
Checked By	Description 1st	Description 2nd	Language	en-US																									
Approved By	1st View		Version	Sheet 117 - 2																									

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_14 [DB15]

IEC_Timer_0_DB_14 Properties			
General			
Name	IEC_Timer_0_DB_14	Number	15
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
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Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 118 - 1	

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Visible in HMI engineering	True	Setpoint	False											
Supervision		Comment												

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F	<table border="1"> <tr> <td>Owner</td> <td>Project name</td> <td>Automation Production Station Code</td> <td>Date</td> <td>7/12/2025</td> </tr> <tr> <td>Operator</td> <td>Project path</td> <td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td> </tr> <tr> <td>Designed By</td> <td>Location</td> <td colspan="3"></td> </tr> <tr> <td>Checked By</td> <td>Description 1st</td> <td colspan="3"></td> </tr> <tr> <td>Approved By</td> <td>Description 2nd</td> <td>Language</td> <td>en-US</td> <td></td> </tr> <tr> <td></td> <td>1st View</td> <td>Version</td> <td colspan="2">Sheet 118 - 2</td> </tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 118 - 2		
Owner	Project name	Automation Production Station Code	Date	7/12/2025																												
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Approved By	Description 2nd	Language	en-US																													
	1st View	Version	Sheet 118 - 2																													

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	
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Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_15 [DB16]

IEC_Timer_0_DB_15 Properties			
General			
Name	IEC_Timer_0_DB_15	Number	16
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 119 - 1	

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Visible in HMI engineering	True													
Supervision														
Writable from HMI/OPC UA/Web API	False													
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F	<table border="1"> <tr><td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr><td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr><td>Designed By</td><td>Location</td><td colspan="3"></td></tr> <tr><td>Checked By</td><td>Description 1st</td><td colspan="3"></td></tr> <tr><td>Approved By</td><td>Description 2nd</td><td>Language</td><td>en-US</td><td></td></tr> <tr><td></td><td>1st View</td><td>Version</td><td colspan="2">Sheet 119 - 2</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 119 - 2	
Owner	Project name	Automation Production Station Code	Date	7/12/2025																											
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																													
Designed By	Location																														
Checked By	Description 1st																														
Approved By	Description 2nd	Language	en-US																												
	1st View	Version	Sheet 119 - 2																												

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Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_16 [DB17]

IEC_Timer_0_DB_16 Properties

General

Name	IEC_Timer_0_DB_16	Number	17
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
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Start value	T#0ms	Retain	False
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	
	1st View	Version		Sheet 120 - 1

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F	<table border="1"> <tr> <td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr> <td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr> <td>Designed By</td><td>Location</td><td colspan="3"></td></tr> <tr> <td>Checked By</td><td>Description 1st</td><td colspan="3"></td></tr> <tr> <td>Approved By</td><td>Description 2nd</td><td>Language</td><td>en-US</td><td></td></tr> <tr> <td></td><td>1st View</td><td>Version</td><td colspan="2">Sheet 120 - 2</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 120 - 2					
Owner	Project name	Automation Production Station Code	Date	7/12/2025																															
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																																	
Designed By	Location																																		
Checked By	Description 1st																																		
Approved By	Description 2nd	Language	en-US																																
	1st View	Version	Sheet 120 - 2																																

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Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

GET_DB [DB18]

GET_DB Properties

General

Name	GET_DB	Number	18
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	SIMATIC
Comment		Family	COM_FUNC
Version	1.1	User-defined ID	GET



Name	Input	Data type	
Start value		Retain	
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Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	REQ	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ID	Data type	Word
Start value	16#0	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	



Name	Output	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	NDR	Data type	Bool

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 121 - 1

A	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	ADDR_4	Data type	Remote
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	RD_1	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
B	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_2	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_3	Data type	Variant
	Start value		Retain	False
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C	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
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	Start value		Retain	False
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	Name	Static	Data type	Variant
	Start value		Retain	False
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D	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	RD_4	Data type	Variant
	Start value		Retain	False
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	Name	Static	Data type	Variant
	Start value		Retain	False
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E	Visible in HMI engineering		Setpoint	
	Supervision		Comment	

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 121 - 3

A **Automation Production Station Code /
PLC_4 [CPU 1214C DC/DC/DC] / Program blocks / System blocks /
Program resources**

PUT_DB [DB19]

PUT_DB Properties

General

Name	PUT_DB	Number	19
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	SIMATIC
Comment		Family	COM_FUNC
Version	1.1	User-defined ID	PUT



Name	Input	Data type	
Start value		Retain	
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Visible in HMI engineering		Setpoint	
Supervision		Comment	
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Start value	false	Retain	False
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	



Name	Output	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	DONE	Data type	Bool

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
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	Supervision		Comment	
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	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
	Visible in HMI engineering	True	Setpoint	False
	Supervision		Comment	
	Name	SD_1	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
B	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	SD_2	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
	Visible in HMI engineering	False	Setpoint	False
	Supervision		Comment	
	Name	SD_3	Data type	Variant
	Start value		Retain	False
	Accessible from HMI/OPC UA/Web API	False	Writable from HMI/OPC UA/Web API	False
C	Visible in HMI engineering	False	Setpoint	False
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	Name	Static	Data type	Variant
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	Designed By	Description 1st	Location	
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	Approved By	1st View	Version	Sheet 122 - 3

Owner	Automation Production Station Code	Date	7/12/2025
Operator	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Description 1st		
Checked By	Description 2nd	Language	en-US
Approved By	1st View	Version	Sheet 122 - 3

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_8 [DB21]

IEC_Timer_0_DB_8 Properties			
General			
Name	IEC_Timer_0_DB_8	Number	21
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 123 - 1	

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Supervision		Comment																											
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D																													
E																													
F	<table border="1"> <tr> <td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr> <td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr> <td>Designed By</td><td>Location</td><td colspan="3"></td></tr> <tr> <td>Checked By</td><td>Description 1st</td><td>Description 2nd</td><td>Language</td><td>en-US</td></tr> <tr> <td>Approved By</td><td>1st View</td><td></td><td>Version</td><td>Sheet 123 - 2</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st	Description 2nd	Language	en-US	Approved By	1st View		Version	Sheet 123 - 2			
Owner	Project name	Automation Production Station Code	Date	7/12/2025																									
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A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC]

Technology objects

This folder is empty.

B

C

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E

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A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC]

PLC tags

PLC tags						
Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
■	AlwaysFALSE	Bool	%M1.3	True	True	
■	AlwaysTRUE	Bool	%M1.2	True	True	
■	Clock_0.5Hz	Bool	%M0.7	True	True	
■	Clock_0.625 Hz	Bool	%M0.6	True	True	
■	Clock_1.25Hz	Bool	%M0.4	True	True	
■	Clock_1Hz	Bool	%M0.5	True	True	
■	Clock_2.5Hz	Bool	%M0.2	True	True	
■	Clock_2Hz	Bool	%M0.3	True	True	
■	Clock_5Hz	Bool	%M0.1	True	True	
■	Clock_10Hz	Bool	%M0.0	True	True	
■	Clock_Byte	Byte	%MBO	True	True	
■	DiagStatusUpdate	Bool	%M1.1	True	True	
■	FirstScan	Bool	%M1.0	True	True	
■	System_Byte	Byte	%MB1	True	True	
■	Tag_1	Bool	%I0.2	True	True	
■	Tag_2	Bool	%I0.3	True	True	
■	Tag_3	Bool	%I0.4	True	True	
■	Tag_4	Bool	%I0.0	True	True	
■	Tag_5	Bool	%I1.0	True	True	
■	Tag_6	Bool	%I1.3	True	True	
■	Tag_7	Bool	%I1.4	True	True	
■	Tag_8	Bool	%M10.3	True	True	
■	Tag_9	Bool	%I1.1	True	True	
■	Tag_10	Bool	%M10.1	True	True	
■	Tag_11	Bool	%I1.2	True	True	
■	Tag_12	Bool	%M10.4	True	True	
■	Tag_13	Bool	%M15.0	True	True	
■	Tag_14	Bool	%M10.2	True	True	
■	Tag_15	Bool	%M11.0	True	True	

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	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
A		Tag_16	Bool	%M10.5	True	True	
		Tag_17	Bool	%M15.1	True	True	
		Tag_18	Bool	%M11.1	True	True	
		Tag_19	Bool	%M10.0	True	True	
		Tag_20	Bool	%I0.6	True	True	
		Tag_21	Bool	%I0.7	True	True	
B		Tag_22	Bool	%I0.5	True	True	
		Tag_23	Bool	%Q0.0	True	True	
		Tag_24	Bool	%M10.6	True	True	
		Tag_25	Bool	%M10.7	True	True	
C		Tag_26	Bool	%M11.6	True	True	
		Tag_27	Bool	%M12.0	True	True	
		Tag_28	Bool	%Q0.2	True	True	
		Tag_29	Bool	%Q0.3	True	True	
		Tag_30	Bool	%Q0.4	True	True	
D		Tag_31	Bool	%Q0.5	True	True	
		Tag_32	Bool	%Q0.6	True	True	
		Tag_33	Bool	%Q0.7	True	True	
		Tag_34	Bool	%Q0.1	True	True	
		Tag_35	Bool	%M49.0	True	True	
		Tag_36	Bool	%M48.0	True	True	
		Tag_37	Bool	%M50.0	True	True	
		Tag_38	Bool	%M60.2	True	True	
		Tag_39	Bool	%M60.5	True	True	
E		Tag_40	Byte	%IB0	True	True	
		Tag_41	Byte	%IB1	True	True	
		Tag_42	Byte	%IB2	True	True	
		Tag_43	Byte	%QBO	True	True	
		Tag_44	Bool	%M48.2	True	True	
		Tag_45	Bool	%I0.1	True	True	
		Tag_46	Bool	%M5.0	True	True	
		Tag_47	Bool	%M4.0	True	True	
		Tag_48	Bool	%M48.4	True	True	

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A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / PLC tags

Default tag table [88]

PLC tags						
Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
■	AlwaysFALSE	Bool	%M1.3	True	True	
■	AlwaysTRUE	Bool	%M1.2	True	True	
■	Clock_0.5Hz	Bool	%M0.7	True	True	
■	Clock_0.625 Hz	Bool	%M0.6	True	True	
■	Clock_1.25Hz	Bool	%M0.4	True	True	
■	Clock_1Hz	Bool	%M0.5	True	True	
■	Clock_2.5Hz	Bool	%M0.2	True	True	
■	Clock_2Hz	Bool	%M0.3	True	True	
■	Clock_5Hz	Bool	%M0.1	True	True	
■	Clock_10Hz	Bool	%M0.0	True	True	
■	Clock_Byte	Byte	%MBO	True	True	
■	DiagStatusUpdate	Bool	%M1.1	True	True	
■	FirstScan	Bool	%M1.0	True	True	
■	System_Byte	Byte	%MB1	True	True	
■	Tag_1	Bool	%I0.2	True	True	
■	Tag_2	Bool	%I0.3	True	True	
■	Tag_3	Bool	%I0.4	True	True	
■	Tag_4	Bool	%I0.0	True	True	
■	Tag_5	Bool	%I1.0	True	True	
■	Tag_6	Bool	%I1.3	True	True	
■	Tag_7	Bool	%I1.4	True	True	
■	Tag_8	Bool	%M10.3	True	True	
■	Tag_9	Bool	%I1.1	True	True	
■	Tag_10	Bool	%M10.1	True	True	
■	Tag_11	Bool	%I1.2	True	True	
■	Tag_12	Bool	%M10.4	True	True	
■	Tag_13	Bool	%M15.0	True	True	
■	Tag_14	Bool	%M10.2	True	True	
■	Tag_15	Bool	%M11.0	True	True	

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	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
A	Tag_16	Bool	%M10.5	True	True		
	Tag_17	Bool	%M15.1	True	True		
	Tag_18	Bool	%M11.1	True	True		
	Tag_19	Bool	%M10.0	True	True		
	Tag_20	Bool	%I0.6	True	True		
	Tag_21	Bool	%I0.7	True	True		
B	Tag_22	Bool	%I0.5	True	True		
	Tag_23	Bool	%Q0.0	True	True		
	Tag_24	Bool	%M10.6	True	True		
	Tag_25	Bool	%M10.7	True	True		
C	Tag_26	Bool	%M11.6	True	True		
	Tag_27	Bool	%M12.0	True	True		
	Tag_28	Bool	%Q0.2	True	True		
	Tag_29	Bool	%Q0.3	True	True		
	Tag_30	Bool	%Q0.4	True	True		
D	Tag_31	Bool	%Q0.5	True	True		
	Tag_32	Bool	%Q0.6	True	True		
	Tag_33	Bool	%Q0.7	True	True		
	Tag_34	Bool	%Q0.1	True	True		
	Tag_35	Bool	%M49.0	True	True		
	Tag_36	Bool	%M48.0	True	True		
	Tag_37	Bool	%M50.0	True	True		
	Tag_38	Bool	%M60.2	True	True		
	Tag_39	Bool	%M60.5	True	True		
E	Tag_40	Byte	%IB0	True	True		
	Tag_41	Byte	%IB1	True	True		
	Tag_42	Byte	%IB2	True	True		
	Tag_43	Byte	%QBO	True	True		
	Tag_44	Bool	%M48.2	True	True		
	Tag_45	Bool	%I0.1	True	True		
	Tag_46	Bool	%M5.0	True	True		
	Tag_47	Bool	%M4.0	True	True		
	Tag_48	Bool	%M48.4	True	True		

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A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / PLC data types

System data types

This folder is empty.

B

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E

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A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Watch and force tables

Force table

Name	Address	Display format	Force value	Comment

B

C

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E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
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A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC]

Traces

Name

B

C

D

E

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Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Traces

Measurements

This folder is empty.

B

C

D

E

F

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Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
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A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Traces

Combined measurements

Name

B

C

D

E

F

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A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC]

PLC alarm text lists

This folder is empty.

B

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A

Automation Production Station Code / PLC_4 [CPU 1214C DC/DC/DC] / Local modules

PLC_4 [CPU 1214C DC/DC/DC]

PLC_4			
General\Project information			
Name	PLC_4	Author	MTC-MECH-05
Comment		Slot	1
Rack	0		
General\Catalog information			
Short designation	CPU 1214C DC/DC/DC	Description	Work memory 75 KB; 24VDC power supply with DI14 x 24VDC SINK/SOURCE, DQ10 x 24VDC and AI2 on board; 6 high-speed counters and 4 pulse outputs on board; signal board expands on-board I/O; up to 3 communication modules for serial communication; up to 8 signal modules for I/O expansion; PROFINET interface for programming, HMI and PLC-to-PLC communication
Article number	6ES7 214-1AG40-0XB0	Firmware version	V4.0
General\Identification & Maintenance			
Plant designation		Location identifier	
Installation date	2025-06-11 06:03:20.618	Additional information	
Connection resources			
PG communication:	1	OP communication:	1
S7 basic communication:	0	S7 communication:	0
Maximum number of S7 connection resources:	38		
PROFINET interface [X1]\General			
Name	PROFINET interface_1	Author	MTC-MECH-05
Comment			
PROFINET interface [X1]\General\Project information			
Name	DI 14/DQ 10_1	Comment	
Name	AI 2_1	Comment	
PROFINET interface [X1]\Ethernet addresses\Interface networked with			
Subnet:	PN/IE_1		
PROFINET interface [X1]\Ethernet addresses\IP protocol			
IP configuration	Set IP address in the project	IP address:	192.168.0.4
Subnet mask:	255.255.255.0	Use router	False
PROFINET interface [X1]\Ethernet addresses\PROFINET			
PROFINET device name is set directly at the device	False	Generate PROFINET device name automatically	True
PROFINET device name:	plc_4	Converted name:	plcxb4d32d

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A	Device number:	0		
	PROFINET interface [X1]\Time synchronization			
	Enable time synchronization via NTP server	Enable time synchronization via NTP server		IP addresses
	Server 1	0.0.0.0	Server 2	0.0.0.0
	Server 3	0.0.0.0	Server 4	0.0.0.0
	Update interval	10sec		
	PROFINET interface [X1]\Digital inputs\Channel0			
	Channel address	I0.0	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel0\			
B	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49152
	Event name:	0	Hardware interrupt:	0
	Rising edge0	Rising edge0		
	PROFINET interface [X1]\Digital inputs\Channel0\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49280
	Event name:	0	Hardware interrupt:	0
	Falling edge0	Falling edge0		
	PROFINET interface [X1]\Digital inputs\Channel1			
	Channel address	I0.1	Input filters	6.4 millisec
	Enable pulse catch	0		
C	PROFINET interface [X1]\Digital inputs\Channel1\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49153
	Event name:	0	Hardware interrupt:	0
	Rising edge1	Rising edge1		
	PROFINET interface [X1]\Digital inputs\Channel1\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49281
	Event name:	0	Hardware interrupt:	0
	Falling edge1	Falling edge1		
	PROFINET interface [X1]\Digital inputs\Channel2			
	Channel address	I0.2	Input filters	6.4 millisec
D	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel2\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49154
	Event name:	0	Hardware interrupt:	0
	Rising edge2	Rising edge2		
	PROFINET interface [X1]\Digital inputs\Channel2\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49282
	Event name:	0	Hardware interrupt:	0
	Falling edge2	Falling edge2		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025
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A	PROFINET interface [X1]\Digital inputs\Channel3			
	Channel address	I0.3	Input filters	6.4 millisec
B	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49155
	Event name:	0	Hardware interrupt:	0
C	Rising edge3	Rising edge3		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49283
	Event name:	0	Hardware interrupt:	0
D	Falling edge3	Falling edge3		
	PROFINET interface [X1]\Digital inputs\Channel4			
	Channel address	I0.4	Input filters	6.4 millisec
	Enable pulse catch	0		
E	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49156
	Event name:	0	Hardware interrupt:	0
	Rising edge4	Rising edge4		
F	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49284
	Event name:	0	Hardware interrupt:	0
	Falling edge4	Falling edge4		
D	PROFINET interface [X1]\Digital inputs\Channel5			
	Channel address	I0.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel5\			
E	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49157
	Event name:	0	Hardware interrupt:	0
	Rising edge5	Rising edge5		
	PROFINET interface [X1]\Digital inputs\Channel5\			
F	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49285
	Event name:	0	Hardware interrupt:	0
	Falling edge5	Falling edge5		
	PROFINET interface [X1]\Digital inputs\Channel6			
G	Channel address	I0.6	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel6\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49158
H	Event name:	0	Hardware interrupt:	0
	Owner	Project name Automation Production Station Code		Date 7/12/2025
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	1	2	3	4
A	Rising edge6	Rising edge6		
	PROFINET interface [X1]\Digital inputs\Channel6\			
	Enable falling edge detection	0	RidPrefixFallin- gEdgeEvent	49286
	Event name:	0	Hardware inter- rupt:	0
	Falling edge6	Falling edge6		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Channel address	I0.7	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel7\			
B	Enable rising edge detection	0	RidPrefixRisingEdg- eEvent	49159
	Event name:	0	Hardware inter- rupt:	0
	Rising edge7	Rising edge7		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Enable falling edge detection	0	RidPrefixFallin- gEdgeEvent	49287
	Event name:	0	Hardware inter- rupt:	0
	Falling edge7	Falling edge7		
	PROFINET interface [X1]\Digital inputs\Channel8\			
C	Channel address	I1.0	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel8\			
	Enable rising edge detection	0	RidPrefixRisingEdg- eEvent	49160
	Event name:	0	Hardware inter- rupt:	0
	Rising edge8	Rising edge8		
	PROFINET interface [X1]\Digital inputs\Channel8\			
D	Enable falling edge detection	0	RidPrefixFallin- gEdgeEvent	49288
	Event name:	0	Hardware inter- rupt:	0
	Falling edge8	Falling edge8		
	PROFINET interface [X1]\Digital inputs\Channel9\			
	Channel address	I1.1	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel9\			
	Enable rising edge detection	0	RidPrefixRisingEdg- eEvent	49161
	Event name:	0	Hardware inter- rupt:	0
	Rising edge9	Rising edge9		
	PROFINET interface [X1]\Digital inputs\Channel9\			
E	Enable falling edge detection	0	RidPrefixFallin- gEdgeEvent	49289
	Event name:	0	Hardware inter- rupt:	0
	Falling edge9	Falling edge9		
F	Owner	Project name	Automation Production Station Code	Date 7/12/2025
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A	PROFINET interface [X1]\Digital inputs\Channel10			
	Channel address	I1.2	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49162
	Event name:	0	Hardware interrupt:	0
	Rising edge10	Rising edge10		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49290
	Event name:	0	Hardware interrupt:	0
B	Falling edge10	Falling edge10		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Channel address	I1.3	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49163
	Event name:	0	Hardware interrupt:	0
	Rising edge11	Rising edge11		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49291
C	Event name:	0	Hardware interrupt:	0
	Falling edge11	Falling edge11		
	PROFINET interface [X1]\Digital inputs\Channel12			
	Channel address	I1.4	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel13			
	Channel address	I1.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Analog inputs\Noise reduction			
	Integration time	50 Hz (20 ms)		
D	PROFINET interface [X1]\Analog inputs\Channel0			
	Channel address	IW64	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Analog inputs\Channel1			
	Channel address	IW66	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Digital outputs			
	Reaction to CPU STOP	Use substitute value		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025
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A	PROFINET interface [X1]\Digital outputs\Channel0					
	Channel address	Q0.0	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel1					
	Channel address	Q0.1	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel2					
	Channel address	Q0.2	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel3					
	Channel address	Q0.3	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel4					
	Channel address	Q0.4	Substitute a value of 1 on a change from RUN to STOP.	0		
B	PROFINET interface [X1]\Digital outputs\Channel5					
	Channel address	Q0.5	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel6					
	Channel address	Q0.6	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel7					
	Channel address	Q0.7	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel8					
	Channel address	Q1.0	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel9					
	Channel address	Q1.1	Substitute a value of 1 on a change from RUN to STOP.	0		
C	PROFINET interface [X1]\Operating mode					
	IO controller	True	IO system			
	Device number	0	IO device	False		
	PROFINET interface [X1]\I/O addresses\Input addresses					
	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Input addresses					
	Start address	64	End address	67		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Output addresses					
D	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Output addresses					
	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025		
	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code					
	Location					
	Designed By	Description 1st				
	Checked By	Description 2nd	Language en-US			
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A	PROFINET interface [X1]\Advanced options\Interface options				
	Support device replacement without exchangeable medium	True	Use IEC V2.2 LLDP mode	True	
B	Keep-Alive connection monitoring:	30s			
	PROFINET interface [X1]\Advanced options\Real time settings\IO communication				
C	Send clock:	1.000ms			
	PROFINET interface [X1]\Advanced options\Real time settings\Real time options				
D	Calculated bandwidth for cyclic IO data:	0.000ms	Calculated bandwidth for cyclic IO data:	0.000%	
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\General				
E	Name	Port_1	Author	MTC-MECH-05	
	Comment				
F	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Local port:				
	Local port:	PLC_4\PROFINET interface_1 [X1]\Port_1 [X1 P1]	Medium:	Copper	
G	Cable name:	---			
					
H	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Partner port:				
	Monitoring of partner port is not possible	Partner port:	Any partner		
I	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Activate				
	Activate this port for use	True			
J	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Connection				
	Transmission rate / duplex:	Automatic	Monitor	False	
K	Enable autonegotiation	True			
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Boundaries				
L	End of detection of accessible devices	False	End of topology discovery	False	
	End of the sync domain	False			
M	High speed counters (HSC)\HSC1\General\Enable				
	Enable this high speed counter	0	Enable this high speed counter	0	
N	Enable this high speed counter	0	Enable this high speed counter	0	
	Enable this high speed counter	0	Enable this high speed counter	0	
O	High speed counters (HSC)\HSC1\General\Project information				
	Name	HSC_1	Comment		
P	Owner	Project name Automation Production Station Code		Date 7/12/2025	
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Q	Designed By	Location			
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A	Name	HSC_2	Comment	
	Name	HSC_3	Comment	
	Name	HSC_4	Comment	
	Name	HSC_5	Comment	
	Name	HSC_6	Comment	
	High speed counters (HSC)\HSC1\I/O addresses\Input addresses			
B	Start address	1000.0	End address	1003.7
	Start address	1004.0	End address	1007.7
	Organization block	0	Start address	1008.0
	End address	1011.7	Organization block	0
	Process image	0	Start address	1012.0
	End address	1015.7	Organization block	0
	Process image	0	Start address	1016.0
	End address	1019.7	Organization block	0
	Process image	0	Start address	1020.0
	End address	1023.7	Organization block	0
C	Process image	0	Organization block	0
	Process image	0	Process image	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Enable			
	Enable this pulse generator	0	Enable this pulse generator	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Project information			
	Name	Pulse_1	Comment	
	Name	Pulse_2	Comment	
	Pulse generators (PTO/PWM)\PTO1/PWM1\I/O addresses\Output addresses			
	Start address	1000.0	End address	1001.7
	Start address	1002.0	End address	1003.7
D	Organization block	0	Organization block	0
	Process image	0	Process image	0
	Startup			
	Startup after POWER ON	Warm restart - mode before POWER OFF	Comparison preset to actual configuration	Startup CPU even if mismatch
	Configuration time	60000ms	OBs should be interruptible	1
	Cycle			
	Cycle monitoring time	150ms		
	Enable minimum cycle time for cyclic OBs	0	Minimum cycle time	1ms
	Communication load			
	Cycle load due to communication	20%		
E	System and clock memory\System memory bits			
	Enable the use of system memory byte	1	Address of system memory byte (MBx)	1
	First cycle	%M1.0 (FirstScan)	Diagnostic status changed	%M1.1 (DiagStatusUpdate)
	Always 1 (high)	%M1.2 (AlwaysTRUE)	Always 0 (low)	%M1.3 (AlwaysFALSE)

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A	System and clock memory\Clock memory bits					
	Enable the use of clock memory byte	1	Address of clock memory byte (MBx)			
	10 Hz clock	%M0.0 (Clock_10Hz)	5 Hz clock			
	2.5 Hz clock	%M0.2 (Clock_2.5Hz)	2 Hz clock			
	1.25 Hz clock	%M0.4 (Clock_1.25Hz)	1 Hz clock			
	0.625 Hz clock	%M0.6 (Clock_0.625Hz)	0.5 Hz clock			
B	Web server\General					
	Activate web server on this module	False	Permit access only with HTTPS			
	Web server\Automatic update					
	Enable automatic update	True	Update interval			
C	Web server\User interface languages					
	Assign project language		User interface languages			
	English (United States)		German			
	English (United States)		English			
	English (United States)		French			
	English (United States)		Spanish			
	English (United States)		Italian			
	English (United States)		Chinese (simplified)			
D	Web server\User management					
	User name		User rights			
	Everybody					
E	Web server\User-defined web pages					
	Application name	HTML source path	Default HTML page	Files with dynamic content	Web DB number	Fragment DB number
			index.htm	.htm;.html	333	334
F	User interface languages					
	Assign project language		User interface languages			
	English (United States)		German			
	English (United States)		English			
	English (United States)		French			
	English (United States)		Spanish			
	English (United States)		Italian			
	English (United States)		Chinese (simplified)			
	Time of day\Local time					
	Time zone	(UTC +01:00) Berlin, Bern, Brussels, Rome, Stockholm, Vienna				
	Time of day\Daylight saving time					
	Activate daylight saving time	1	Difference between standard and daylight saving time			
			60mins			
	Time of day\Daylight saving time\Start of daylight saving time					
	Starting week of the month:	Last	Sunday			
	of	March	at 01:00 a.m.			
	Time of day\Daylight saving time\Start of standard time					
	Last		Sunday			
	of	October	at 02:00 a.m.			
	Protection & Security					
	Level of protection	No protection				
	Owner	Project name	Automation Production Station Code	Date	7/12/2025	
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
	Designed By	Location				
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A

Protection & Security\Connection mechanisms

Permit access with True
 PUT/GET communication from remote partner

Overview of addresses\Overview of addresses\Overview of addresses

Inputs	True	Outputs	True
Address gaps	False	Slot	True

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
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A	Type	I	Addr. from	0	Addr. to	1
	Module	DI 14/DQ 10_1	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 1		
	Type	O	Addr. from	0	Addr. to	1
	Module	DI 14/DQ 10_1	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
B	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 1		
	Type	I	Addr. from	64	Addr. to	67
	Module	AI 2_1	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 2		
C	Type	I	Addr. from	1000	Addr. to	1003
	Module	HSC_1	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 16		
	Type	I	Addr. from	1004	Addr. to	1007
	Module	HSC_2	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
D	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 17		
	Type	I	Addr. from	1008	Addr. to	1011
	Module	HSC_3	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 18		
E	Type	I	Addr. from	1012	Addr. to	1015
	Module	HSC_4	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 19		
	Type	I	Addr. from	1016	Addr. to	1019
	Module	HSC_5	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
F	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 20		
	Type	I	Addr. from	1020	Addr. to	1023
	Module	HSC_6	PIP	Automatic update	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Device number	-	Size	4 Bytes	Master / IO system	-

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A	Rack	0	Slot	1 21	Addr. to	1001
	Type	O	Addr. from	1000	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Module	Pulse_1	PIP	Automatic update	Master / IO system	-
	Device number	-	Size	2 Bytes		
B	Rack	0	Slot	1 32	Addr. to	1003
	Type	O	Addr. from	1002	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Module	Pulse_2	PIP	Automatic update	Master / IO system	-
	Device number	-	Size	2 Bytes		
C	Rack	0	Slot	1 33	Addr. to	1005
	Type	O	Addr. from	1004	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Module	Pulse_3	PIP	Automatic update	Master / IO system	-
	Device number	-	Size	2 Bytes		
D	Rack	0	Slot	1 34	Addr. to	1007
	Type	O	Addr. from	1006	Device name	PLC_4 [CPU 1214C DC/DC/DC]
	Module	Pulse_4	PIP	Automatic update	Master / IO system	-
	Device number	-	Size	2 Bytes		
C	Rack	0	Slot	1 35		

D	Owner	Project name	Automation Production Station Code	Date	7/12/2025
E	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
F	Designed By	Location			
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A

Automation Production Station Code

PLC_5 [CPU 1214C DC/DC/DC]

PLC_5			
General\Project information			
Name	PLC_5	Author	MTC-MECH-05
Comment		Slot	1
Rack	0		
General\Catalog information			
Short designation	CPU 1214C DC/DC/DC	Description	Work memory 75 KB; 24VDC power supply with DI14 x 24VDC SINK/SOURCE, DQ10 x 24VDC and AI2 on board; 6 high-speed counters and 4 pulse outputs on board; signal board expands on-board I/O; up to 3 communication modules for serial communication; up to 8 signal modules for I/O expansion; PROFINET interface for programming, HMI and PLC-to-PLC communication
Article number	6ES7 214-1AG40-0XB0	Firmware version	V4.0
General\Identification & Maintenance			
Plant designation		Location identifier	
Installation date	2025-06-11 06:03:42.488	Additional information	
Connection resources			
PG communication:	1	OP communication:	1
S7 basic communication:	0	S7 communication:	0
Maximum number of S7 connection resources:	38		
PROFINET interface [X1]\General			
Name	PROFINET interface_1	Author	MTC-MECH-05
Comment			
PROFINET interface [X1]\General\Project information			
Name	DI 14/DQ 10_1	Comment	
Name	AI 2_1	Comment	
PROFINET interface [X1]\Ethernet addresses\Interface networked with			
Subnet:	PN/IE_1		
PROFINET interface [X1]\Ethernet addresses\IP protocol			
IP configuration	Set IP address in the project	IP address:	192.168.0.5
Subnet mask:	255.255.255.0	Use router	False
PROFINET interface [X1]\Ethernet addresses\PROFINET			
PROFINET device name is set directly at the device	False	Generate PROFINET device name automatically	True
PROFINET device name:	plc_5	Converted name:	plcxb513ec
Device number:	0		

B

C

D

E

F

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PROFINET interface [X1]\Time synchronization			
Enable time synchronization via NTP server	Enable time synchronization via NTP server		IP addresses
Server 1	0.0.0.0	Server 2	0.0.0.0
Server 3	0.0.0.0	Server 4	0.0.0.0
Update interval	10sec		
PROFINET interface [X1]\Digital inputs\Channel0			
Channel address	I0.0	Input filters	6.4 millisec
Enable pulse catch	0		
PROFINET interface [X1]\Digital inputs\Channel0\			
Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49152
Event name:	0	Hardware interrupt:	0
Rising edge0	Rising edge0		
PROFINET interface [X1]\Digital inputs\Channel0\			
Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49280
Event name:	0	Hardware interrupt:	0
Falling edge0	Falling edge0		
PROFINET interface [X1]\Digital inputs\Channel1			
Channel address	I0.1	Input filters	6.4 millisec
Enable pulse catch	0		
PROFINET interface [X1]\Digital inputs\Channel1\			
Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49153
Event name:	0	Hardware interrupt:	0
Rising edge1	Rising edge1		
PROFINET interface [X1]\Digital inputs\Channel1\			
Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49281
Event name:	0	Hardware interrupt:	0
Falling edge1	Falling edge1		
PROFINET interface [X1]\Digital inputs\Channel2			
Channel address	I0.2	Input filters	6.4 millisec
Enable pulse catch	0		
PROFINET interface [X1]\Digital inputs\Channel2\			
Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49154
Event name:	0	Hardware interrupt:	0
Rising edge2	Rising edge2		
PROFINET interface [X1]\Digital inputs\Channel2\			
Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49282
Event name:	0	Hardware interrupt:	0
Falling edge2	Falling edge2		

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A	PROFINET interface [X1]\Digital inputs\Channel3			
	Channel address	I0.3	Input filters	6.4 millisec
B	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49155
	Event name:	0	Hardware interrupt:	0
C	Rising edge3	Rising edge3		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49283
	Event name:	0	Hardware interrupt:	0
D	Falling edge3	Falling edge3		
	PROFINET interface [X1]\Digital inputs\Channel4			
	Channel address	I0.4	Input filters	6.4 millisec
	Enable pulse catch	0		
E	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49156
	Event name:	0	Hardware interrupt:	0
	Rising edge4	Rising edge4		
F	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49284
	Event name:	0	Hardware interrupt:	0
	Falling edge4	Falling edge4		
D	PROFINET interface [X1]\Digital inputs\Channel5			
	Channel address	I0.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel5\			
E	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49157
	Event name:	0	Hardware interrupt:	0
	Rising edge5	Rising edge5		
	PROFINET interface [X1]\Digital inputs\Channel5\			
F	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49285
	Event name:	0	Hardware interrupt:	0
	Falling edge5	Falling edge5		
	PROFINET interface [X1]\Digital inputs\Channel6			
G	Channel address	I0.6	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel6\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49158
H	Event name:	0	Hardware interrupt:	0
	Owner	Project name Automation Production Station Code		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
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	1	2	3	4
A	Rising edge6	Rising edge6		
	PROFINET interface [X1]\Digital inputs\Channel6\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49286
	Event name:	0	Hardware inter-rupt:	0
	Falling edge6	Falling edge6		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Channel address	I0.7	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel7\			
B	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49159
	Event name:	0	Hardware inter-rupt:	0
	Rising edge7	Rising edge7		
	PROFINET interface [X1]\Digital inputs\Channel7\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49287
	Event name:	0	Hardware inter-rupt:	0
	Falling edge7	Falling edge7		
	PROFINET interface [X1]\Digital inputs\Channel8\			
C	Channel address	I1.0	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel8\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49160
	Event name:	0	Hardware inter-rupt:	0
	Rising edge8	Rising edge8		
	PROFINET interface [X1]\Digital inputs\Channel8\			
D	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49288
	Event name:	0	Hardware inter-rupt:	0
	Falling edge8	Falling edge8		
	PROFINET interface [X1]\Digital inputs\Channel9\			
	Channel address	I1.1	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel9\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49161
	Event name:	0	Hardware inter-rupt:	0
	Rising edge9	Rising edge9		
	PROFINET interface [X1]\Digital inputs\Channel9\			
E	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49289
	Event name:	0	Hardware inter-rupt:	0
	Falling edge9	Falling edge9		
F	Owner	Project name	Automation Production Station Code	Date 7/12/2025
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location		
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A	PROFINET interface [X1]\Digital inputs\Channel10			
	Channel address	I1.2	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49162
	Event name:	0	Hardware interrupt:	0
	Rising edge10	Rising edge10		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49290
	Event name:	0	Hardware interrupt:	0
B	Falling edge10	Falling edge10		
	PROFINET interface [X1]\Digital inputs\Channel11			
	Channel address	I1.3	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49163
	Event name:	0	Hardware interrupt:	0
	Rising edge11	Rising edge11		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49291
C	Event name:	0	Hardware interrupt:	0
	Falling edge11	Falling edge11		
	PROFINET interface [X1]\Digital inputs\Channel12			
	Channel address	I1.4	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel13			
	Channel address	I1.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Analog inputs\Noise reduction			
	Integration time	50 Hz (20 ms)		
D	PROFINET interface [X1]\Analog inputs\Channel0			
	Channel address	IW64	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Analog inputs\Channel1			
	Channel address	IW66	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Digital outputs			
	Reaction to CPU STOP	Use substitute value		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
	Designed By	Location		
	Checked By	Description 1st		
	Approved By	Description 2nd	Language en-US	
		1st View	Version	Sheet 134 - 5

A	PROFINET interface [X1]\Digital outputs\Channel0					
	Channel address	Q0.0	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel1					
	Channel address	Q0.1	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel2					
	Channel address	Q0.2	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel3					
	Channel address	Q0.3	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel4					
	Channel address	Q0.4	Substitute a value of 1 on a change from RUN to STOP.	0		
B	PROFINET interface [X1]\Digital outputs\Channel5					
	Channel address	Q0.5	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel6					
	Channel address	Q0.6	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel7					
	Channel address	Q0.7	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel8					
	Channel address	Q1.0	Substitute a value of 1 on a change from RUN to STOP.	0		
	PROFINET interface [X1]\Digital outputs\Channel9					
	Channel address	Q1.1	Substitute a value of 1 on a change from RUN to STOP.	0		
C	PROFINET interface [X1]\Operating mode					
	IO controller	True	IO system			
	Device number	0	IO device	False		
	PROFINET interface [X1]\I/O addresses\Input addresses					
	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Input addresses					
	Start address	64	End address	67		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Output addresses					
D	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
	PROFINET interface [X1]\I/O addresses\Output addresses					
	Start address	0.0	End address	1.7		
	Organization block	0	Process image	0		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025		
	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code					
	Location					
	Designed By	Description 1st				
	Checked By	Description 2nd	Language en-US			
F	Approved By	1st View	Version	Sheet 134 - 6		

A	PROFINET interface [X1]\Advanced options\Interface options				
	Support device replacement without exchangeable medium	True	Use IEC V2.2 LLDP mode	True	
B	Keep-Alive connection monitoring:	30s			
	PROFINET interface [X1]\Advanced options\Real time settings\IO communication				
C	Send clock:	1.000ms			
	PROFINET interface [X1]\Advanced options\Real time settings\Real time options				
D	Calculated bandwidth for cyclic IO data:	0.000ms	Calculated bandwidth for cyclic IO data:	0.000%	
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\General				
E	Name	Port_1	Author	MTC-MECH-05	
	Comment				
F	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Local port:				
	Local port:	PLC_5\PROFINET interface_1 [X1]\Port_1 [X1 P1]	Medium:	Copper	
G	Cable name:	---			
					
H	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Partner port:				
	Monitoring of partner port is not possible	Partner port:	Any partner		
I	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Activate				
	Activate this port for use	True			
J	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Connection				
	Transmission rate / duplex:	Automatic	Monitor	False	
K	Enable autonegotiation	True			
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Boundaries				
L	End of detection of accessible devices	False	End of topology discovery	False	
	End of the sync domain	False			
M	High speed counters (HSC)\HSC1\General\Enable				
	Enable this high speed counter	0	Enable this high speed counter	0	
N	Enable this high speed counter	0	Enable this high speed counter	0	
	Enable this high speed counter	0	Enable this high speed counter	0	
O	High speed counters (HSC)\HSC1\General\Project information				
	Name	HSC_1	Comment		
P	Owner	Project name Automation Production Station Code		Date 7/12/2025	
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Q	Designed By	Location			
	Checked By	Description 1st			
R	Approved By	Description 2nd	Language en-US	Version	
		1st View		Sheet 134 - 7	

A	Name	HSC_2	Comment	
	Name	HSC_3	Comment	
	Name	HSC_4	Comment	
	Name	HSC_5	Comment	
	Name	HSC_6	Comment	
	High speed counters (HSC)\HSC1\I/O addresses\Input addresses			
B	Start address	1000.0	End address	1003.7
	Start address	1004.0	End address	1007.7
	Organization block	0	Start address	1008.0
	End address	1011.7	Organization block	0
	Process image	0	Start address	1012.0
	End address	1015.7	Organization block	0
	Process image	0	Start address	1016.0
	End address	1019.7	Organization block	0
	Process image	0	Start address	1020.0
	End address	1023.7	Organization block	0
	Process image	0	Organization block	0
	Process image	0	Process image	0
C	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Enable			
	Enable this pulse generator	0	Enable this pulse generator	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Project information			
	Name	Pulse_1	Comment	
	Name	Pulse_2	Comment	
	Pulse generators (PTO/PWM)\PTO1/PWM1\I/O addresses\Output addresses			
D	Start address	1000.0	End address	1001.7
	Start address	1002.0	End address	1003.7
	Organization block	0	Organization block	0
	Process image	0	Process image	0
	Startup			
	Startup after POWER ON	Warm restart - mode before POWER OFF	Comparison preset to actual configuration	Startup CPU even if mismatch
	Configuration time	60000ms	OBs should be interruptible	1
	Cycle			
	Cycle monitoring time	150ms		
	Enable minimum cycle time for cyclic OBs	0	Minimum cycle time	1ms
	Communication load			
	Cycle load due to communication	20%		
E	System and clock memory\System memory bits			
	Enable the use of system memory byte	1	Address of system memory byte (MBx)	1
	First cycle	%M1.0 (FirstScan)	Diagnostic status changed	%M1.1 (DiagStatusUpdate)
	Always 1 (high)	%M1.2 (AlwaysTRUE)	Always 0 (low)	%M1.3 (AlwaysFALSE)

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location		
Checked By	Description 1st		
Approved By	Description 2nd	Language en-US	Version Sheet 134 - 8
	1st View		

A	System and clock memory\Clock memory bits					
	Enable the use of clock memory byte	1	Address of clock memory byte (MBx)			
	10 Hz clock	%M0.0 (Clock_10Hz)	5 Hz clock			
	2.5 Hz clock	%M0.2 (Clock_2.5Hz)	2 Hz clock			
	1.25 Hz clock	%M0.4 (Clock_1.25Hz)	1 Hz clock			
	0.625 Hz clock	%M0.6 (Clock_0.625Hz)	0.5 Hz clock			
B	Web server\General					
	Activate web server on this module	False	Permit access only with HTTPS			
	Web server\Automatic update					
	Enable automatic update	True	Update interval			
C	Web server\User interface languages					
	Assign project language		User interface languages			
	English (United States)		German			
	English (United States)		English			
	English (United States)		French			
	English (United States)		Spanish			
	English (United States)		Italian			
	English (United States)		Chinese (simplified)			
D	Web server\User management					
	User name		User rights			
	Everybody					
E	Web server\User-defined web pages					
	Application name	HTML source path	Default HTML page	Files with dynamic content	Web DB number	Fragment DB number
			index.htm	.htm;.html	333	334
F	User interface languages					
	Assign project language		User interface languages			
	English (United States)		German			
	English (United States)		English			
	English (United States)		French			
	English (United States)		Spanish			
	English (United States)		Italian			
	English (United States)		Chinese (simplified)			
	Time of day\Local time					
	Time zone	(UTC +01:00) Berlin, Bern, Brussels, Rome, Stockholm, Vienna				
	Time of day\Daylight saving time					
	Activate daylight saving time	1	Difference between standard and daylight saving time			
			60mins			
	Time of day\Daylight saving time\Start of daylight saving time					
	Starting week of the month:	Last	Sunday			
	of	March	at 01:00 a.m.			
	Time of day\Daylight saving time\Start of standard time					
	Last		Sunday			
	of	October	at 02:00 a.m.			
	Protection & Security					
	Level of protection	No protection				
	Owner	Project name	Automation Production Station Code	Date	7/12/2025	
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
	Designed By	Location				
	Checked By	Description 1st	Description 2nd	Language	en-US	
	Approved By	1st View		Version	Sheet 134 - 9	

A

Protection & Security\Connection mechanisms

Permit access with True
 PUT/GET communication from remote partner

Overview of addresses\Overview of addresses\Overview of addresses

Inputs	True	Outputs	True
Address gaps	False	Slot	True

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 134 - 10

A	Type	I	Addr. from	0	Addr. to	1
	Module	DI 14/DQ 10_1	PIP	Automatic update	Device name	PLC_5 [CPU 1214C DC/DC/DC]
B	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 1	Addr. to	1
C	Type	O	Addr. from	0	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Module	DI 14/DQ 10_1	PIP	Automatic update	Master / IO system	-
D	Device number	-	Size	2 Bytes	Addr. to	67
	Rack	0	Slot	1 1	Device name	PLC_5 [CPU 1214C DC/DC/DC]
E	Type	I	Addr. from	64	Master / IO system	-
	Module	AI 2_1	PIP	Automatic update	Addr. to	1003
F	Device number	-	Size	4 Bytes	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Rack	0	Slot	1 2	Master / IO system	-
G	Type	I	Addr. from	1000	Addr. to	1007
	Module	HSC_1	PIP	Automatic update	Device name	PLC_5 [CPU 1214C DC/DC/DC]
H	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 16	Addr. to	1007
I	Type	I	Addr. from	1004	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Module	HSC_2	PIP	Automatic update	Master / IO system	-
J	Device number	-	Size	4 Bytes	Addr. to	1007
	Rack	0	Slot	1 17	Device name	PLC_5 [CPU 1214C DC/DC/DC]
K	Type	I	Addr. from	1008	Master / IO system	-
	Module	HSC_3	PIP	Automatic update	Addr. to	1011
L	Device number	-	Size	4 Bytes	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Rack	0	Slot	1 18	Master / IO system	-
M	Type	I	Addr. from	1012	Addr. to	1015
	Module	HSC_4	PIP	Automatic update	Device name	PLC_5 [CPU 1214C DC/DC/DC]
N	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 19	Addr. to	1019
O	Type	I	Addr. from	1016	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Module	HSC_5	PIP	Automatic update	Master / IO system	-
P	Device number	-	Size	4 Bytes	Addr. to	1019
	Rack	0	Slot	1 20	Device name	PLC_5 [CPU 1214C DC/DC/DC]
Q	Type	I	Addr. from	1020	Master / IO system	-
	Module	HSC_6	PIP	Automatic update	Addr. to	1023
R	Device number	-	Size	4 Bytes	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Rack	0	Slot	1 20	Master / IO system	-

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location		
Checked By	Description 1st		
Approved By	Description 2nd	Language en-US	Version Sheet 134 - 11
	1st View		

A	Rack	0	Slot	1 21	Addr. to	1001
	Type	O	Addr. from	1000	Device name	PLC_5 [CPU 1214C DC/DC/DC]
B	Module	Pulse_1	PIP	Automatic update	Master / IO system	-
	Device number	-	Size	2 Bytes	Addr. to	1003
C	Rack	0	Slot	1 32	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Type	O	Addr. from	1002	Master / IO system	-
D	Module	Pulse_2	PIP	Automatic update	Addr. to	1005
	Device number	-	Size	2 Bytes	Device name	PLC_5 [CPU 1214C DC/DC/DC]
E	Rack	0	Slot	1 33	Master / IO system	-
	Type	O	Addr. from	1004	Addr. to	1007
F	Module	Pulse_3	PIP	Automatic update	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Device number	-	Size	2 Bytes	Master / IO system	-
G	Rack	0	Slot	1 34	Addr. to	1006
	Type	O	Addr. from	1006	Device name	PLC_5 [CPU 1214C DC/DC/DC]
H	Module	Pulse_4	PIP	Automatic update	Master / IO system	-
	Device number	-	Size	2 Bytes	Addr. to	1007
I	Rack	0	Slot	1 35	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Type	O	Addr. from	1007	Master / IO system	-

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location		
Checked By	Description 1st		
Approved By	Description 2nd	Language en-US	Version Sheet 134 - 12

A

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Program blocks

AUTO 5 [FC1]

AUTO 5 Properties

General

Name	AUTO 5	Number	1
Type	FC	Language	LAD

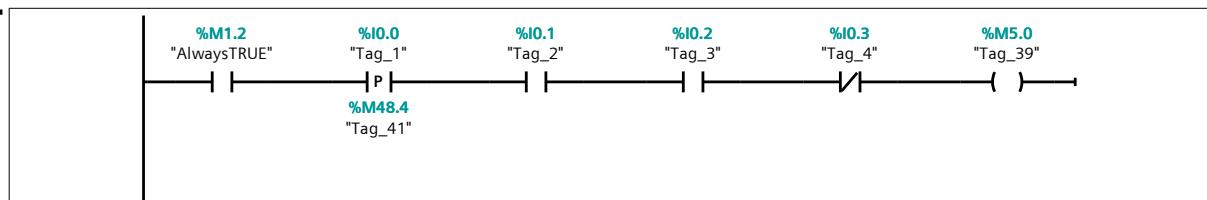
Numbering Automatic

Information

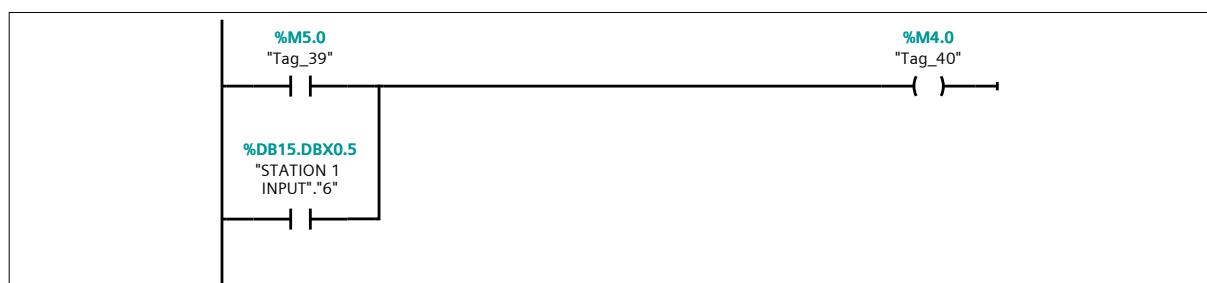
Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
AUTO 5	Void		

Network 1:

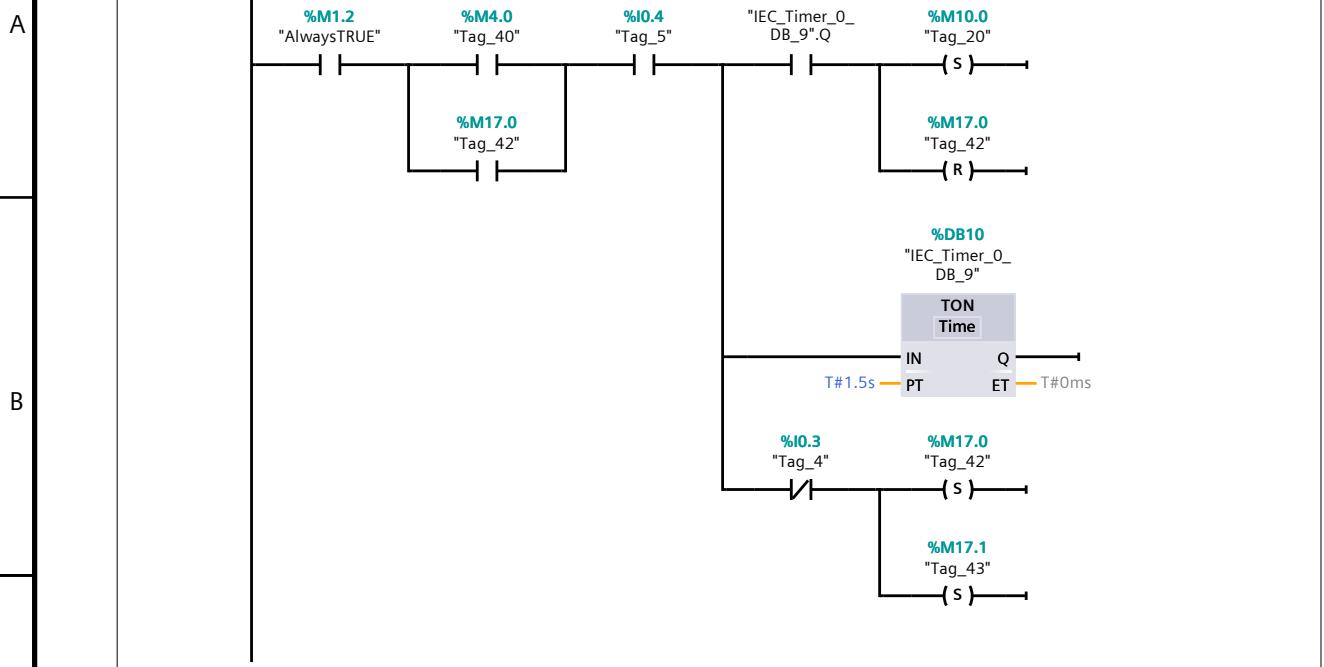
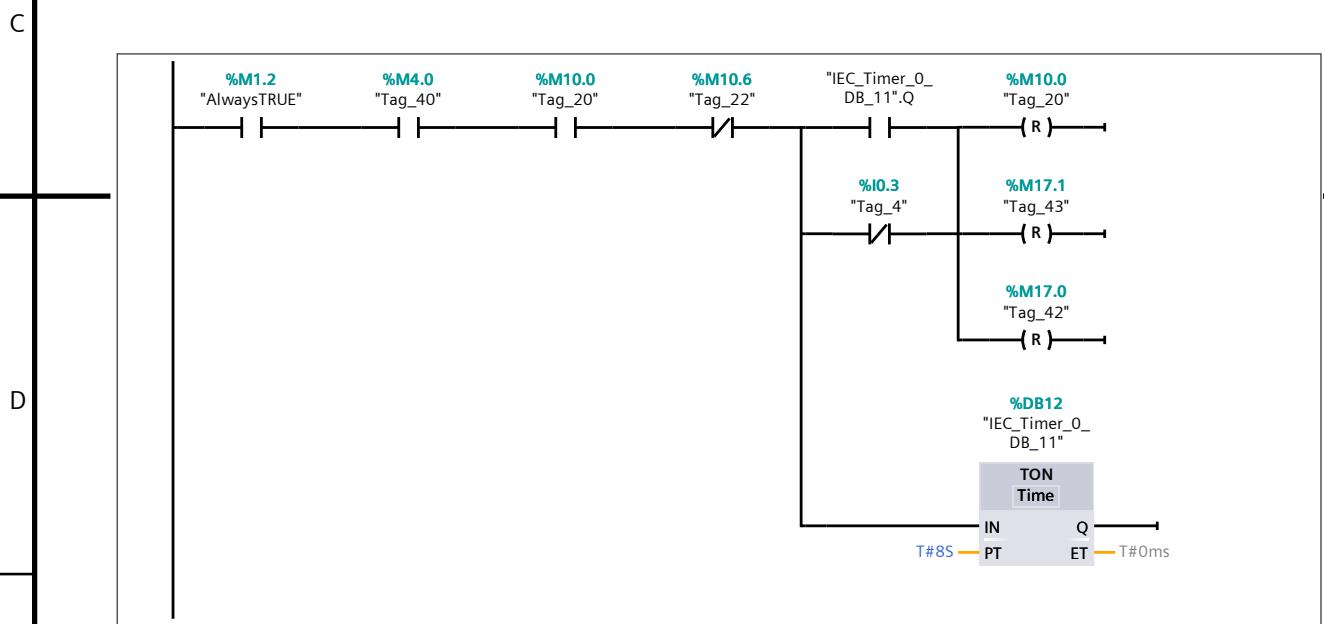


Network 2:

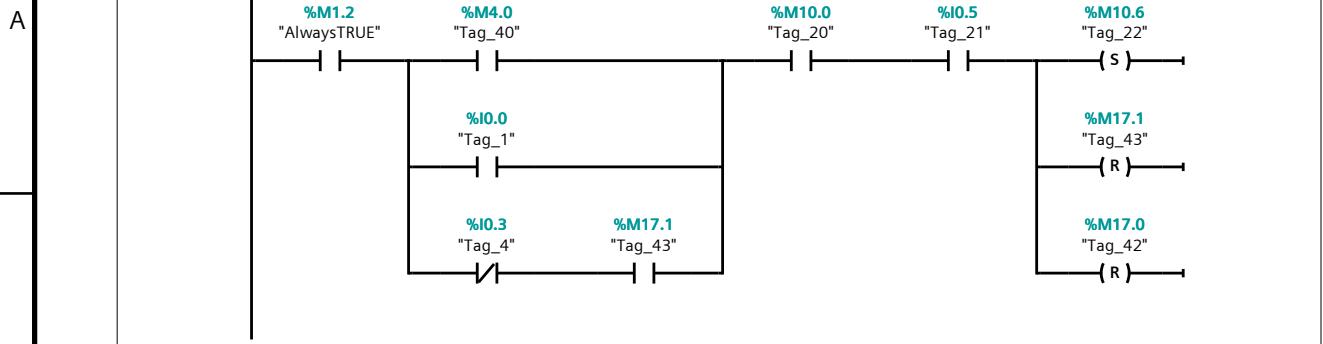


Network 3: CONVEYOR RUN

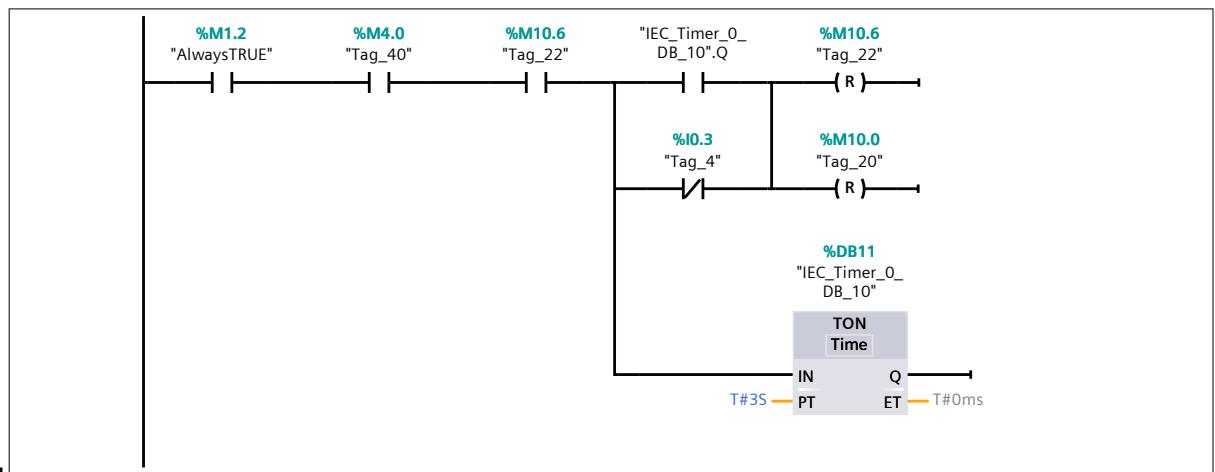
Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
Designed By	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Checked By	Location			
Approved By	Description 1st	Description 2nd	Language	en-US
			Version	Sheet 135 - 1

**Network 4: CONVEYOR STOP****Network 5: SORTING EXTEND**

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 135 - 2



Network 6: SORTING RETRACT



Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
Location	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 135 - 3

A

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Program blocks

OUTPUT CALL 5 [FC2]

OUTPUT CALL 5 Properties

General

Name	OUTPUT CALL 5	Number	2
Type	FC	Language	LAD

Numbering

Information

Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
OUTPUT CALL 5	Void		

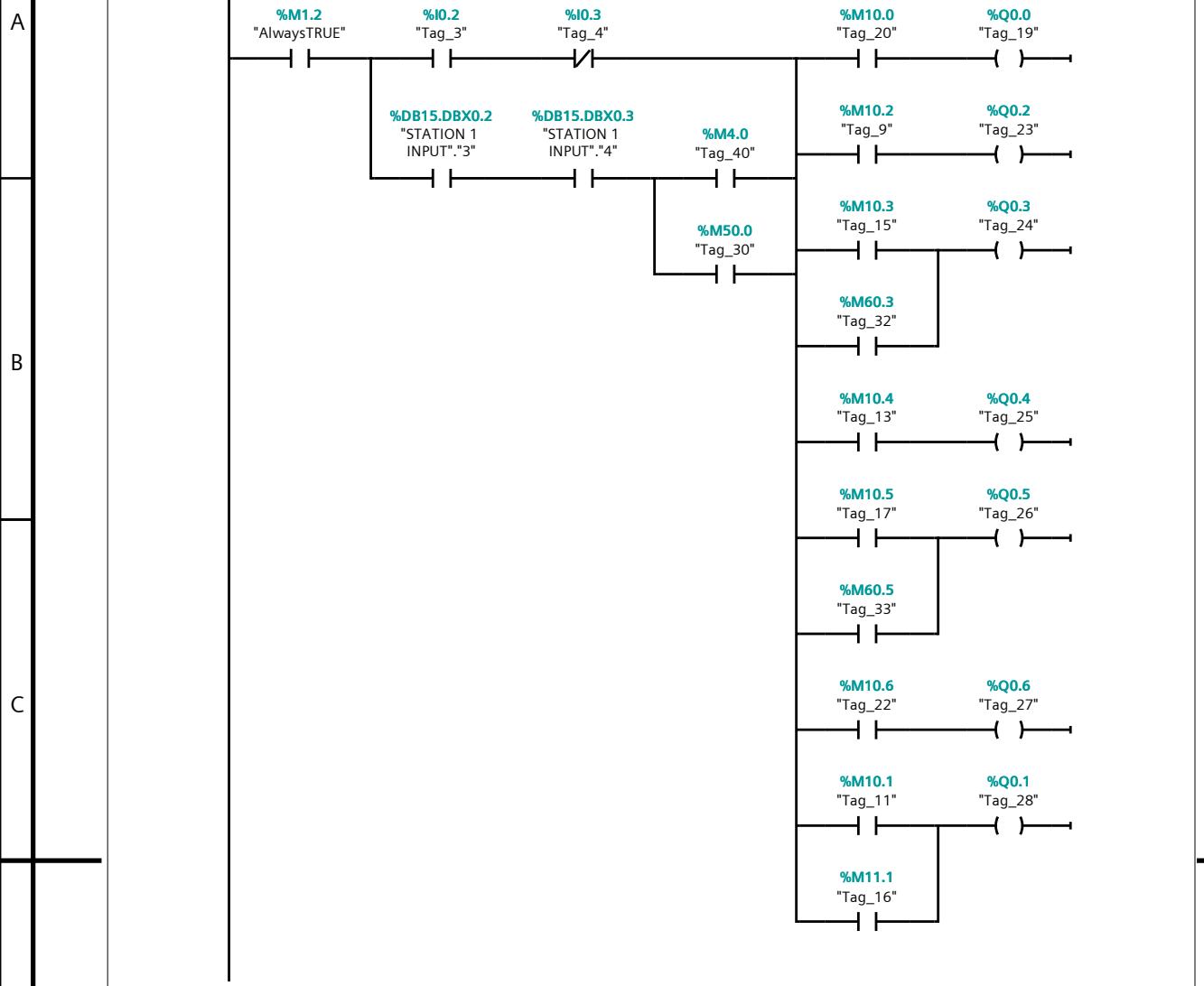
Network 1:

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
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Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language en-US		
Approved By	1st View	Version	Sheet 136 - 2	

A

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Program blocks

ESTOP LOGIC 5 [FC3]

ESTOP LOGIC 5 Properties

General

Name	ESTOP LOGIC 5	Number	3
Type	FC	Language	LAD

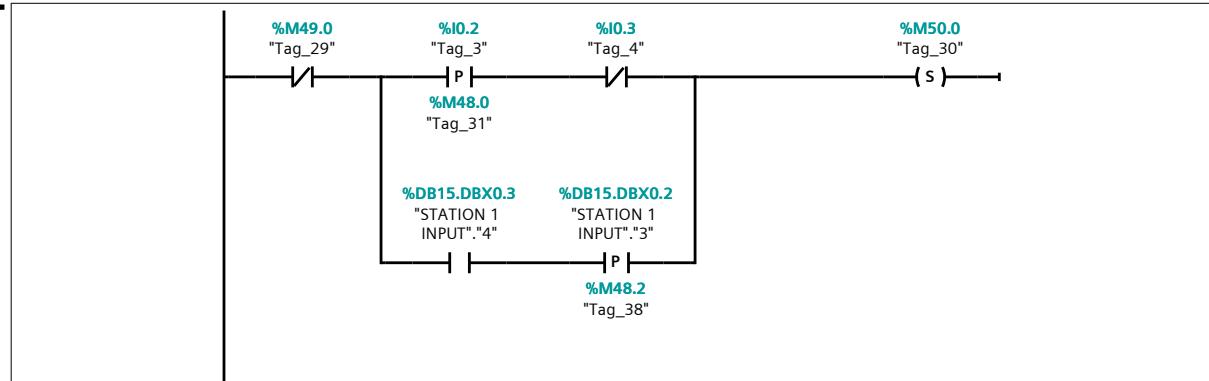
Numbering

Information

Title	Author
Comment	Family
Version	User-defined ID

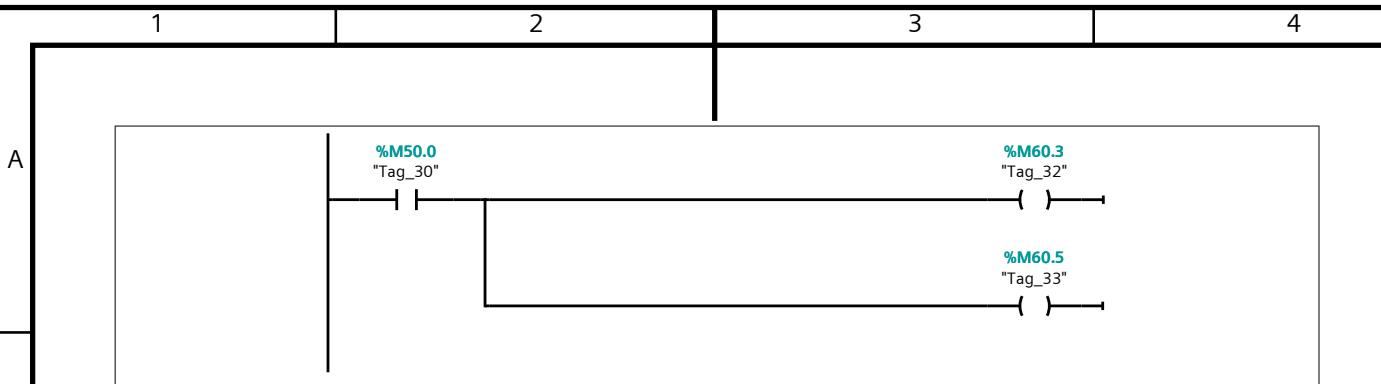
Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
ESTOP LOGIC 5	Void		

Network 1: ESTOP HOMING POSITION LOGIC



Network 2: OUTPUT CALL FOR HOMING

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 137 - 1



Network 3: MEMORY RESET

B

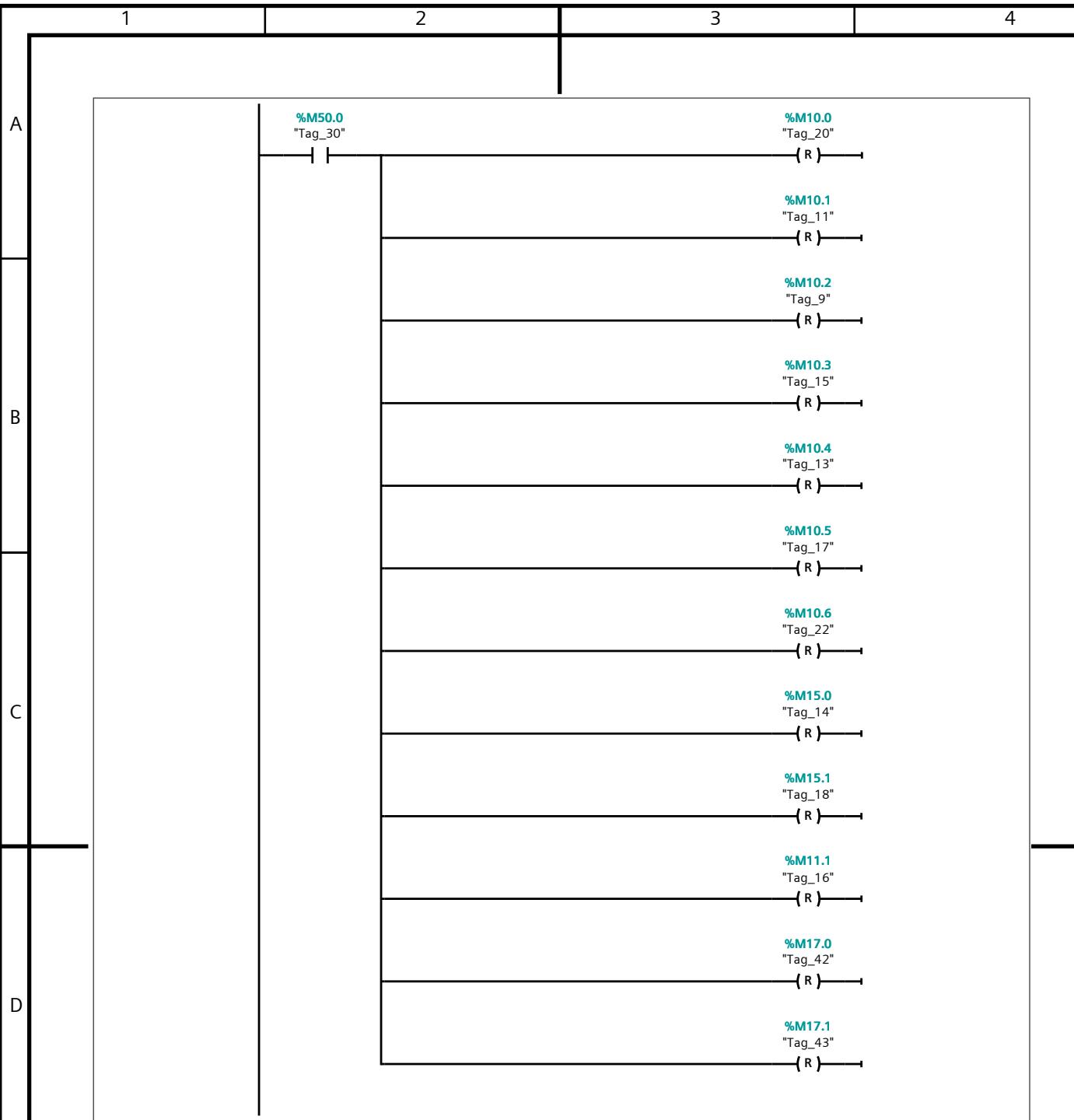
C

D

E

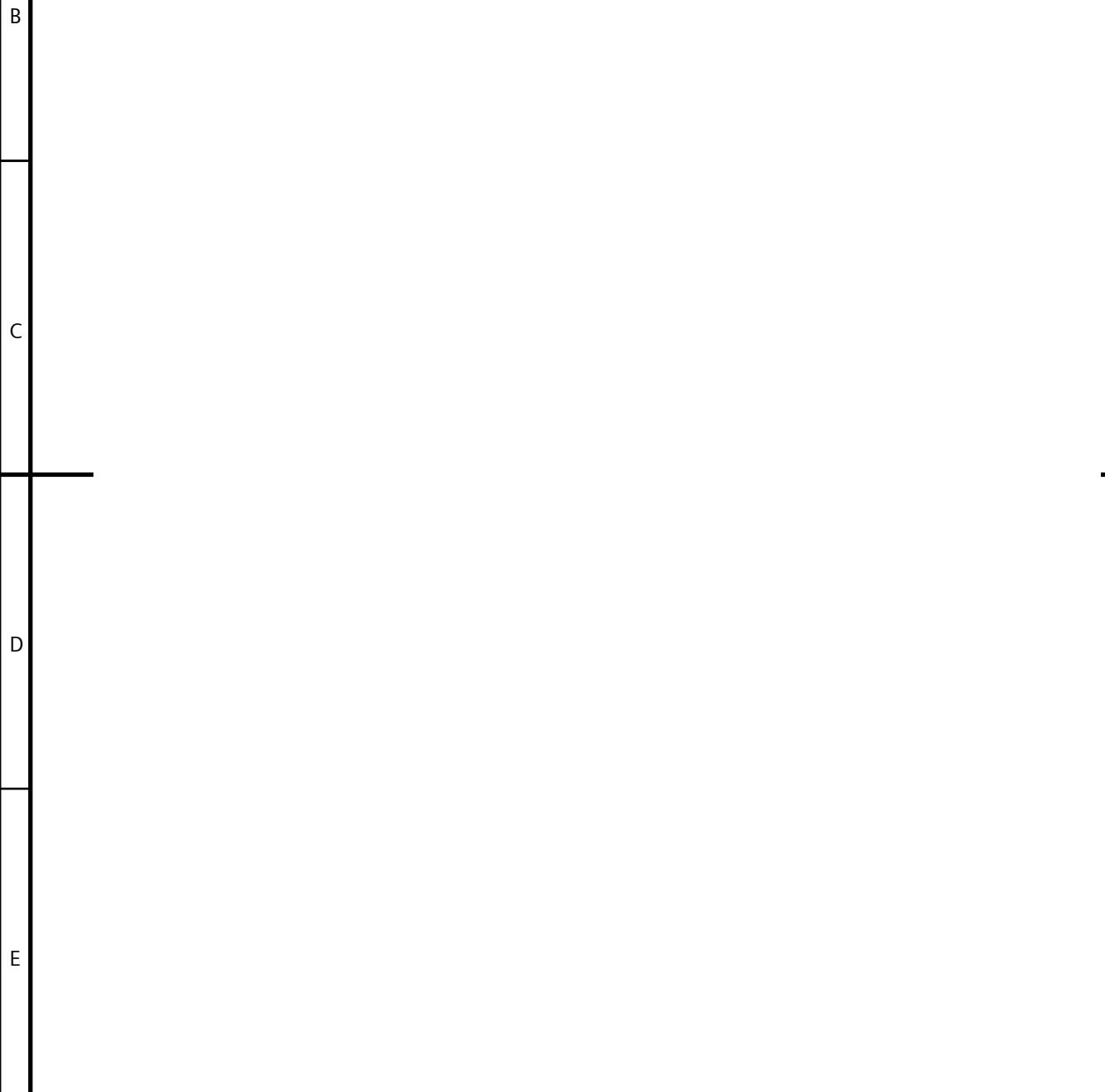
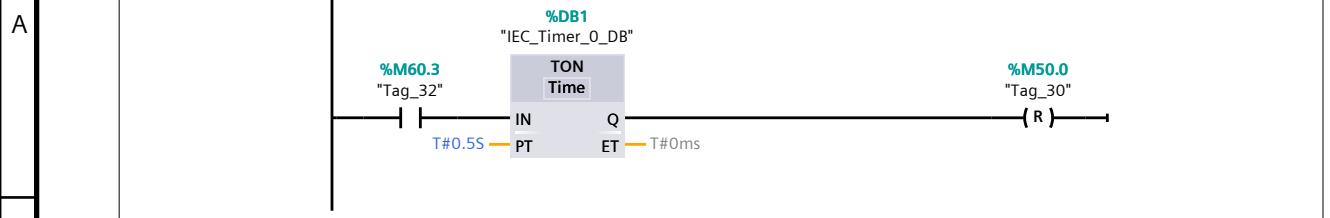
F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 137 - 2



Network 4: ESTOP LOGIC RESET

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 137 - 3



F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Location				
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 137 - 4

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Program blocks

DATA BLOCK MOVE [FC4]

DATA BLOCK MOVE Properties

General

Name	DATA BLOCK MOVE	Number	4
Type	FC	Language	LAD

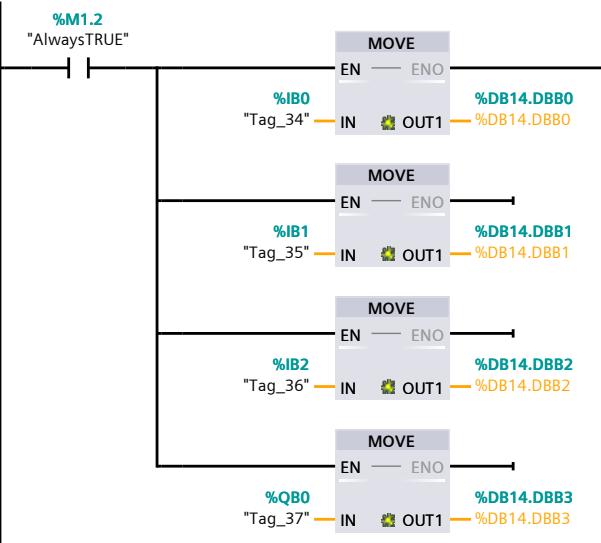
Numbering

Information

Title	Author
Comment	Family
Version	User-defined ID

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
DATA BLOCK MOVE	Void		

Network 1:



Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	
	1st View	Version		Sheet 138 - 1

A

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Program blocks

Main [OB1]

Main Properties			
General			
Name	Main	Number	1
Type	OB	Language	LAD
Numbering	Automatic		

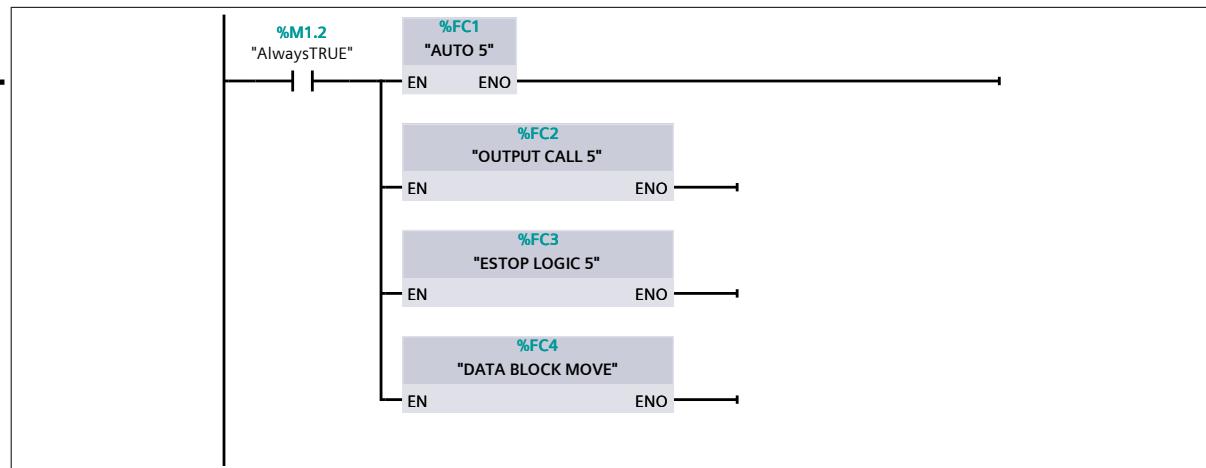
B

Information			
Title	"Main Program Sweep (Cycle)"	Author	
Comment		Family	
Version	0.1	User-defined ID	

Name	Data type	Default value	Comment
▼ Input			
Initial_Call	Bool		Initial call of this OB
Remanence	Bool		=True, if remanent data are available
Temp			
Constant			

C

Network 1:



D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version		Sheet 139 - 1

A

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Program blocks

STATION 4 INPUT OUTPUT [DB13]

STATION 4 INPUT OUTPUT Properties

General

Name	STATION 4 INPUT OUTPUT	Number	13
Type	DB	Language	DB
Numbering	Automatic		

B

Information

Title		Author	
Comment		Family	
Version	0.1	User-defined ID	

C

Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	1	Data type	Bool
Offset	0.0	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	2	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	3	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 140 - 1

F

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 7 Offset 0.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 8 Offset 0.7 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 140 - 2

A	Comment		
	Name	9	Data type Bool
	Offset	1.0	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	10	Data type Bool
	Offset	1.1	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	11	Data type Bool
	Offset	1.2	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	12	Data type Bool
C	Offset	1.3	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	13	Data type Bool
	Offset	1.4	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
D	Comment		
	Name	14	Data type Bool
	Offset	1.5	Start value false
	Offset	1.5	Start value false
	Offset	1.5	Start value false
	Offset	1.5	Start value false
	Offset	1.5	Start value false
	Offset	1.5	Start value false
	Offset	1.5	Start value false
	Offset	1.5	Start value false
E	Owner	Project name	Automation Production Station Code
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code
	Designed By	Description 1st	
	Checked By	Description 2nd	Language en-US
	Approved By	1st View	Version
			Sheet 140 - 3

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
Designed By	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Checked By	Location			
Approved By	Description 1st	Description 2nd	Language	en-US
			Version	Sheet 140 - 3

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	15	Data type	Bool
	Offset	1.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	16	Data type	Bool
	Offset	1.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	17	Data type	Bool
	Offset	2.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	18	Data type	Bool
	Offset	2.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	19	Data type	Bool
	Offset	2.2	Start value	false
F	Retain	False	Accessible from HMI/OPC UA/Web API	True
Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
Approved By		Description 2nd	Language en-US	Version
		1st View	Sheet 140 - 4	

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 20 Offset 2.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 21 Offset 2.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 22 Offset 2.5 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 23 Offset 2.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 24 Offset 2.7 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version Sheet 140 - 5	

A	Comment		
	Name	25	Data type
	Offset	3.0	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	26	Data type
	Offset	3.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	27	Data type
	Offset	3.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	28	Data type
D	Offset	3.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	29	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
E	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 140 - 6

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	31	Data type	Bool
	Offset	3.6	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	32	Data type	Bool
	Offset	3.7	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	33	Data type	Bool
	Offset	4.0	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
D	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	34	Data type	Bool
	Offset	4.1	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
F	Owner	Project name	Automation Production Station Code	Date 7/12/2025
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location		
	Checked By	Description 1st		
	Approved By	Description 2nd	Language	en-US
		1st View	Version	Sheet 140 - 7

A

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Program blocks

STATION 5 INPUT OUTPUT [DB14]

STATION 5 INPUT OUTPUT Properties

General

Name	STATION 5 INPUT OUTPUT	Number	14
Type	DB	Language	DB
Numbering	Automatic		

B

Information

Title		Author	
Comment		Family	
Version	0.1	User-defined ID	

C

Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	1	Data type	Bool
Offset	0.0	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	2	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	3	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 141 - 1

F

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 7 Offset 0.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 8 Offset 0.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 141 - 2

A	Comment		
	Name	9	Data type Bool
	Offset	1.0	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	10	Data type Bool
	Offset	1.1	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	11	Data type Bool
	Offset	1.2	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	12	Data type Bool
C	Offset	1.3	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	13	Data type Bool
	Offset	1.4	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
D	Comment		
	Name	14	Data type Bool
	Offset	1.5	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	15	Data type Bool
	Offset	1.6	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
E	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	16	Data type Bool
	Offset	1.7	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	17	Data type Bool
F	Offset	1.8	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision
	Comment		
	Name	18	Data type Bool
	Offset	1.9	Start value false
	Retain	False	Accessible from HMI/OPC UA/Web API True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engi- neering True
	Setpoint	False	Supervision

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location		
Checked By	Description 1st		
Approved By	Description 2nd Language en-US		
	1st View Version Sheet 141 - 3		

	1	2	3	4
A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	15	Data type	Bool
	Offset	1.6	Start value	false
B	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	16	Data type	Bool
	Offset	1.7	Start value	false
C	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	17	Data type	Bool
	Offset	2.0	Start value	false
D	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	18	Data type	Bool
	Offset	2.1	Start value	false
E	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	19	Data type	Bool
	Offset	2.2	Start value	false
F	Retain	False	Accessible from HMI/OPC UA/Web API	True
Owner		Project name	Automation Production Station Code	Date 7/12/2025
Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By		Location		
Checked By		Description 1st		
Approved By		Description 2nd	Language en-US	Version
		1st View	Sheet 141 - 4	

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 20 Offset 2.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 21 Offset 2.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 22 Offset 2.5 Retain False	True	Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment Name 23 Offset 2.6 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API	True
E	Writable from HMI/OPC UA/Web API Setpoint Comment Name 24 Offset 2.7 Retain False	True	Visible in HMI engineering Supervision	True
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 141 - 5

A	Comment		
	Name	25	Data type
	Offset	3.0	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	26	Data type
	Offset	3.1	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	27	Data type
	Offset	3.2	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	28	Data type
D	Offset	3.3	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
	Comment		
	Name	29	Data type
	Offset	3.4	Start value
	Retain	False	Accessible from HMI/OPC UA/Web API
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering
	Setpoint	False	Supervision
E	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		
	Name	30	Data type
	Offset	3.5	Start value
	Comment		

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
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A	Retain	False	Accessible from HMI/OPC UA/Web API	True
	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			
	Name	31	Data type	Bool
	Offset	3.6	Start value	false
	Retain	False	Accessible from HMI/OPC UA/Web API	True
B	Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
	Setpoint	False	Supervision	
	Comment			

C		
D		
E		
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View Language en-US Version Sheet 141 - 7

A

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Program blocks

STATION 1 INPUT [DB15]

STATION 1 INPUT Properties

General

Name	STATION 1 INPUT	Number	15
Type	DB	Language	DB
Numbering	Automatic		

Information

Title	Author
Comment	Family
Version	User-defined ID



Name	Static	Data type	
Offset		Start value	
Retain		Accessible from HMI/OPC UA/Web API	
Writable from HMI/OPC UA/Web API		Visible in HMI engineering	
Setpoint		Supervision	
Comment			
Name	1	Data type	Bool
Offset	0.0	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	2	Data type	Bool
Offset	0.1	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True
Writable from HMI/OPC UA/Web API	True	Visible in HMI engineering	True
Setpoint	False	Supervision	
Comment			
Name	3	Data type	Bool
Offset	0.2	Start value	false
Retain	False	Accessible from HMI/OPC UA/Web API	True

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 142 - 1

F

	1	2	3	4
A	Writable from HMI/OPC UA/Web API Setpoint Comment Name 4 Offset 0.3 Retain False	True	Visible in HMI engineering Supervision	True
B	Writable from HMI/OPC UA/Web API Setpoint Comment Name 5 Offset 0.4 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
C	Writable from HMI/OPC UA/Web API Setpoint Comment Name 6 Offset 0.5 Retain False	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
D	Writable from HMI/OPC UA/Web API Setpoint Comment	True	Data type Bool Start value false Accessible from HMI/OPC UA/Web API Visible in HMI engineering Supervision	True
E				
F	Owner Operator Designed By Checked By Approved By	Project name Automation Production Station Code Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code Location Description 1st Description 2nd 1st View	Date 7/12/2025 Language en-US Version	Sheet 142 - 2

A

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB [DB1]

IEC_Timer_0_DB Properties

General

Name	IEC_Timer_0_DB	Number	1
Type	DB	Language	DB
Numbering	Automatic		

Information

Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR



Name

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	

Name

Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	

Name

Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	

Name

Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	

Name

Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	

Name

Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	

Name

Name	IN	Data type	Bool
Start value	false	Retain	False
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Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	

Name

Name	IN	Data type	Bool
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Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	

Name

Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	

Name

Name	Q	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	

Name

Name	Q	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	

Name

Owner	Project name Automation Production Station Code	
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By	Location	
Checked By	Description 1st	
Approved By	Description 2nd	Language en-US
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Owner	Project name Automation Production Station Code	
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By	Location	
Checked By	Description 1st	
Approved By	Description 2nd	Language en-US
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Owner	Project name Automation Production Station Code	
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By	Location	
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Owner	Project name Automation Production Station Code	
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By	Location	
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Owner	Project name Automation Production Station Code	
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By	Location	
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	1st View	Version
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Owner	Project name Automation Production Station Code	
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Owner	Project name Automation Production Station Code	
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Owner	Project name Automation Production Station Code	
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Owner	Project name Automation Production Station Code	
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Designed By	Location	
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Approved By	Description 2nd	Language en-US
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Owner	Project name Automation Production Station Code	
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Designed By	Location	
Checked By	Description 1st	
Approved By	Description 2nd	Language en-US
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Owner	Project name Automation Production Station Code	
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
Designed By	Location	
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Approved By	Description 2nd	Language en-US
	1st View	Version
		Sheet 143 - 1

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F	<table border="1"> <tr> <td>Owner</td><td>Project name</td><td>Automation Production Station Code</td><td>Date</td><td>7/12/2025</td></tr> <tr> <td>Operator</td><td>Project path</td><td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td></tr> <tr> <td>Designed By</td><td>Location</td><td colspan="3"></td></tr> <tr> <td>Checked By</td><td>Description 1st</td><td colspan="3"></td></tr> <tr> <td>Approved By</td><td>Description 2nd</td><td>Language</td><td>en-US</td><td></td></tr> <tr> <td></td><td>1st View</td><td>Version</td><td colspan="2">Sheet 143 - 2</td></tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Location				Checked By	Description 1st				Approved By	Description 2nd	Language	en-US			1st View	Version	Sheet 143 - 2					
Owner	Project name	Automation Production Station Code	Date	7/12/2025																															
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Checked By	Description 1st																																		
Approved By	Description 2nd	Language	en-US																																
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Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_9 [DB10]

IEC_Timer_0_DB_9 Properties			
General			
Name	IEC_Timer_0_DB_9	Number	10
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 144 - 1	

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Approved By	Description 2nd	Language	en-US																																
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Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_10 [DB11]

IEC_Timer_0_DB_10 Properties			
General			
Name	IEC_Timer_0_DB_10	Number	11
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
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Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
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Approved By	1st View	Version	Sheet 145 - 1	

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Owner	Project name	Automation Production Station Code	Date	7/12/2025																														
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																																
Designed By	Location																																	
Checked By	Description 1st																																	
Approved By	Description 2nd	Language	en-US																															
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Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Program blocks / System blocks / Program resources

IEC_Timer_0_DB_11 [DB12]

IEC_Timer_0_DB_11 Properties			
General			
Name	IEC_Timer_0_DB_11	Number	12
Type	DB	Language	DB
Numbering	Automatic		
Information			
Title		Author	Simatic
Comment		Family	IEC
Version	1.0	User-defined ID	IEC_TMR

Name	Static	Data type	
Start value		Retain	
Accessible from HMI/OPC UA/Web API		Writable from HMI/OPC UA/Web API	
Visible in HMI engineering		Setpoint	
Supervision		Comment	
Name	PT	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	ET	Data type	Time
Start value	T#0ms	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	IN	Data type	Bool
Start value	false	Retain	False
Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	True
Visible in HMI engineering	True	Setpoint	False
Supervision		Comment	
Name	Q	Data type	Bool
Start value	false	Retain	False

Owner	Project name	Automation Production Station Code	Date	7/12/2025
	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Operator	Location			
Designed By	Description 1st			
Checked By	Description 2nd	Language	en-US	
Approved By	1st View	Version	Sheet 146 - 1	

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A	<table border="1"> <tr> <td>Accessible from HMI/OPC UA/Web API</td><td>True</td><td>Writable from HMI/OPC UA/Web API</td><td>False</td></tr> <tr> <td>Visible in HMI engineering</td><td>True</td><td>Setpoint</td><td>False</td></tr> <tr> <td>Supervision</td><td></td><td>Comment</td><td></td></tr> </table>	Accessible from HMI/OPC UA/Web API	True	Writable from HMI/OPC UA/Web API	False	Visible in HMI engineering	True	Setpoint	False	Supervision		Comment																							
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Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC]

Technology objects

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Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
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Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC]

PLC tags

PLC tags						
Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
■	AlwaysFALSE	Bool	%M1.3	True	True	
■	AlwaysTRUE	Bool	%M1.2	True	True	
■	Clock_0.5Hz	Bool	%M0.7	True	True	
■	Clock_0.625 Hz	Bool	%M0.6	True	True	
■	Clock_1.25Hz	Bool	%M0.4	True	True	
■	Clock_1Hz	Bool	%M0.5	True	True	
■	Clock_2.5Hz	Bool	%M0.2	True	True	
■	Clock_2Hz	Bool	%M0.3	True	True	
■	Clock_5Hz	Bool	%M0.1	True	True	
■	Clock_10Hz	Bool	%M0.0	True	True	
■	Clock_Byte	Byte	%MBO	True	True	
■	DiagStatusUpdate	Bool	%M1.1	True	True	
■	FirstScan	Bool	%M1.0	True	True	
■	System_Byte	Byte	%MB1	True	True	
■	Tag_1	Bool	%I0.0	True	True	
■	Tag_2	Bool	%I0.1	True	True	
■	Tag_3	Bool	%I0.2	True	True	
■	Tag_4	Bool	%I0.3	True	True	
■	Tag_5	Bool	%I0.4	True	True	
■	Tag_6	Bool	%I0.7	True	True	
■	Tag_7	Bool	%I1.0	True	True	
■	Tag_8	Bool	%I1.2	True	True	
■	Tag_9	Bool	%M10.2	True	True	
■	Tag_10	Bool	%I0.6	True	True	
■	Tag_11	Bool	%M10.1	True	True	
■	Tag_12	Bool	%I1.1	True	True	
■	Tag_13	Bool	%M10.4	True	True	
■	Tag_14	Bool	%M15.0	True	True	
■	Tag_15	Bool	%M10.3	True	True	

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 148 - 1

	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
A		Tag_16	Bool	%M11.1	True	True	
		Tag_17	Bool	%M10.5	True	True	
		Tag_18	Bool	%M15.1	True	True	
		Tag_19	Bool	%Q0.0	True	True	
		Tag_20	Bool	%M10.0	True	True	
		Tag_21	Bool	%I0.5	True	True	
B		Tag_22	Bool	%M10.6	True	True	
		Tag_23	Bool	%Q0.2	True	True	
		Tag_24	Bool	%Q0.3	True	True	
		Tag_25	Bool	%Q0.4	True	True	
		Tag_26	Bool	%Q0.5	True	True	
		Tag_27	Bool	%Q0.6	True	True	
C		Tag_28	Bool	%Q0.1	True	True	
		Tag_29	Bool	%M49.0	True	True	
		Tag_30	Bool	%M50.0	True	True	
		Tag_31	Bool	%M48.0	True	True	
		Tag_32	Bool	%M60.3	True	True	
		Tag_33	Bool	%M60.5	True	True	
D		Tag_34	Byte	%IB0	True	True	
		Tag_35	Byte	%IB1	True	True	
		Tag_36	Byte	%IB2	True	True	
		Tag_37	Byte	%QB0	True	True	
		Tag_38	Bool	%M48.2	True	True	
		Tag_39	Bool	%M5.0	True	True	
		Tag_40	Bool	%M4.0	True	True	
		Tag_41	Bool	%M48.4	True	True	
		Tag_42	Bool	%M17.0	True	True	
		Tag_43	Bool	%M17.1	True	True	
E							
F	Owner		Project name	Automation Production Station Code		Date	7/12/2025
	Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
	Designed By		Location				
	Checked By	Description 1st					
	Approved By	Description 2nd	Language	en-US			
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Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / PLC tags

Default tag table [83]

PLC tags						
Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
	AlwaysFALSE	Bool	%M1.3	True	True	
	AlwaysTRUE	Bool	%M1.2	True	True	
	Clock_0.5Hz	Bool	%M0.7	True	True	
	Clock_0.625 Hz	Bool	%M0.6	True	True	
	Clock_1.25Hz	Bool	%M0.4	True	True	
	Clock_1Hz	Bool	%M0.5	True	True	
	Clock_2.5Hz	Bool	%M0.2	True	True	
	Clock_2Hz	Bool	%M0.3	True	True	
	Clock_5Hz	Bool	%M0.1	True	True	
	Clock_10Hz	Bool	%M0.0	True	True	
	Clock_Byte	Byte	%MBO	True	True	
	DiagStatusUpdate	Bool	%M1.1	True	True	
	FirstScan	Bool	%M1.0	True	True	
	System_Byte	Byte	%MB1	True	True	
	Tag_1	Bool	%I0.0	True	True	
	Tag_2	Bool	%I0.1	True	True	
	Tag_3	Bool	%I0.2	True	True	
	Tag_4	Bool	%I0.3	True	True	
	Tag_5	Bool	%I0.4	True	True	
	Tag_6	Bool	%I0.7	True	True	
	Tag_7	Bool	%I1.0	True	True	
	Tag_8	Bool	%I1.2	True	True	
	Tag_9	Bool	%M10.2	True	True	
	Tag_10	Bool	%I0.6	True	True	
	Tag_11	Bool	%M10.1	True	True	
	Tag_12	Bool	%I1.1	True	True	
	Tag_13	Bool	%M10.4	True	True	
	Tag_14	Bool	%M15.0	True	True	
	Tag_15	Bool	%M10.3	True	True	

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st			
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	Icon	Name	Data type	Address	Visible in HMI engineering	Accessible from HMI/OPC UA/Web API	Comment
A		Tag_16	Bool	%M11.1	True	True	
		Tag_17	Bool	%M10.5	True	True	
		Tag_18	Bool	%M15.1	True	True	
		Tag_19	Bool	%Q0.0	True	True	
		Tag_20	Bool	%M10.0	True	True	
		Tag_21	Bool	%I0.5	True	True	
B		Tag_22	Bool	%M10.6	True	True	
		Tag_23	Bool	%Q0.2	True	True	
		Tag_24	Bool	%Q0.3	True	True	
		Tag_25	Bool	%Q0.4	True	True	
		Tag_26	Bool	%Q0.5	True	True	
		Tag_27	Bool	%Q0.6	True	True	
C		Tag_28	Bool	%Q0.1	True	True	
		Tag_29	Bool	%M49.0	True	True	
		Tag_30	Bool	%M50.0	True	True	
		Tag_31	Bool	%M48.0	True	True	
		Tag_32	Bool	%M60.3	True	True	
		Tag_33	Bool	%M60.5	True	True	
D		Tag_34	Byte	%IB0	True	True	
		Tag_35	Byte	%IB1	True	True	
		Tag_36	Byte	%IB2	True	True	
		Tag_37	Byte	%QB0	True	True	
		Tag_38	Bool	%M48.2	True	True	
		Tag_39	Bool	%M5.0	True	True	
		Tag_40	Bool	%M4.0	True	True	
		Tag_41	Bool	%M48.4	True	True	
		Tag_42	Bool	%M17.0	True	True	
		Tag_43	Bool	%M17.1	True	True	
E							
F	Owner		Project name	Automation Production Station Code		Date	7/12/2025
	Operator		Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
	Designed By		Location				
	Checked By	Description 1st					
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A

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / PLC data types

System data types

This folder is empty.

B

C

D

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
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A

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Watch and force tables

Force table

Name	Address	Display format	Force value	Comment

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
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A

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC]

Traces

Name

B

C

D

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
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A

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Traces

Measurements

This folder is empty.

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
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A

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Traces

Combined measurements

Name

B

C

D

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
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A

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC]

PLC alarm text lists

This folder is empty.

B

C

D

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
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A

Automation Production Station Code / PLC_5 [CPU 1214C DC/DC/DC] / Local modules

PLC_5 [CPU 1214C DC/DC/DC]

PLC_5			
General\Project information			
Name	PLC_5	Author	MTC-MECH-05
Comment		Slot	1
Rack	0		
General\Catalog information			
Short designation	CPU 1214C DC/DC/DC	Description	Work memory 75 KB; 24VDC power supply with DI14 x 24VDC SINK/SOURCE, DQ10 x 24VDC and AI2 on board; 6 high-speed counters and 4 pulse outputs on board; signal board expands on-board I/O; up to 3 communication modules for serial communication; up to 8 signal modules for I/O expansion; PROFINET interface for programming, HMI and PLC-to-PLC communication
Article number	6ES7 214-1AG40-0XB0	Firmware version	V4.0
General\Identification & Maintenance			
Plant designation		Location identifier	
Installation date	2025-06-11 06:03:42.488	Additional information	
Connection resources			
PG communication:	1	OP communication:	1
S7 basic communication:	0	S7 communication:	0
Maximum number of S7 connection resources:	38		
PROFINET interface [X1]\General			
Name	PROFINET interface_1	Author	MTC-MECH-05
Comment			
PROFINET interface [X1]\General\Project information			
Name	DI 14/DQ 10_1	Comment	
Name	AI 2_1	Comment	
PROFINET interface [X1]\Ethernet addresses\Interface networked with			
Subnet:	PN/IE_1		
PROFINET interface [X1]\Ethernet addresses\IP protocol			
IP configuration	Set IP address in the project	IP address:	192.168.0.5
Subnet mask:	255.255.255.0	Use router	False
PROFINET interface [X1]\Ethernet addresses\PROFINET			
PROFINET device name is set directly at the device	False	Generate PROFINET device name automatically	True
PROFINET device name:	plc_5	Converted name:	plcxb513ec

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
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A	Device number:	0		
	PROFINET interface [X1]\Time synchronization			
	Enable time synchronization via NTP server	Enable time synchronization via NTP server		IP addresses
	Server 1	0.0.0.0	Server 2	0.0.0.0
	Server 3	0.0.0.0	Server 4	0.0.0.0
	Update interval	10sec		
	PROFINET interface [X1]\Digital inputs\Channel0			
	Channel address	I0.0	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel0\			
B	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49152
	Event name:	0	Hardware interrupt:	0
	Rising edge0	Rising edge0		
	PROFINET interface [X1]\Digital inputs\Channel0\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49280
	Event name:	0	Hardware interrupt:	0
	Falling edge0	Falling edge0		
	PROFINET interface [X1]\Digital inputs\Channel1			
	Channel address	I0.1	Input filters	6.4 millisec
	Enable pulse catch	0		
C	PROFINET interface [X1]\Digital inputs\Channel1\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49153
	Event name:	0	Hardware interrupt:	0
	Rising edge1	Rising edge1		
	PROFINET interface [X1]\Digital inputs\Channel1\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49281
	Event name:	0	Hardware interrupt:	0
	Falling edge1	Falling edge1		
	PROFINET interface [X1]\Digital inputs\Channel2			
	Channel address	I0.2	Input filters	6.4 millisec
D	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel2\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49154
	Event name:	0	Hardware interrupt:	0
	Rising edge2	Rising edge2		
	PROFINET interface [X1]\Digital inputs\Channel2\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49282
	Event name:	0	Hardware interrupt:	0
	Falling edge2	Falling edge2		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
	Designed By	Location		
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A	PROFINET interface [X1]\Digital inputs\Channel3			
	Channel address	I0.3	Input filters	6.4 millisec
B	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49155
	Event name:	0	Hardware interrupt:	0
C	Rising edge3	Rising edge3		
	PROFINET interface [X1]\Digital inputs\Channel3\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49283
	Event name:	0	Hardware interrupt:	0
D	Falling edge3	Falling edge3		
	PROFINET interface [X1]\Digital inputs\Channel4			
	Channel address	I0.4	Input filters	6.4 millisec
	Enable pulse catch	0		
E	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49156
	Event name:	0	Hardware interrupt:	0
	Rising edge4	Rising edge4		
F	PROFINET interface [X1]\Digital inputs\Channel4\			
	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49284
	Event name:	0	Hardware interrupt:	0
	Falling edge4	Falling edge4		
D	PROFINET interface [X1]\Digital inputs\Channel5			
	Channel address	I0.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel5\			
E	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49157
	Event name:	0	Hardware interrupt:	0
	Rising edge5	Rising edge5		
	PROFINET interface [X1]\Digital inputs\Channel5\			
F	Enable falling edge detection	0	RidPrefixFallingEdgeEvent	49285
	Event name:	0	Hardware interrupt:	0
	Falling edge5	Falling edge5		
	PROFINET interface [X1]\Digital inputs\Channel6			
G	Channel address	I0.6	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel6\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49158
H	Event name:	0	Hardware interrupt:	0
	Owner	Project name Automation Production Station Code		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
	Designed By	Location		
I	Checked By	Description 1st		
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Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
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	1	2	3	4
A	Rising edge6	Rising edge6 PROFINET interface [X1]\Digital inputs\Channel6\		
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49286
	Event name:	0	Hardware inter-rupt:	0
	Falling edge6	Falling edge6 PROFINET interface [X1]\Digital inputs\Channel7\		
	Channel address	I0.7	Input filters	6.4 millisec
	Enable pulse catch	0		
B	PROFINET interface [X1]\Digital inputs\Channel7\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49159
	Event name:	0	Hardware inter-rupt:	0
	Rising edge7	Rising edge7 PROFINET interface [X1]\Digital inputs\Channel7\		
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49287
C	Event name:	0	Hardware inter-rupt:	0
	Falling edge7	Falling edge7 PROFINET interface [X1]\Digital inputs\Channel8\		
	Channel address	I1.0	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel8\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49160
D	Event name:	0	Hardware inter-rupt:	0
	Rising edge8	Rising edge8 PROFINET interface [X1]\Digital inputs\Channel8\		
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49288
	Event name:	0	Hardware inter-rupt:	0
	Falling edge8	Falling edge8 PROFINET interface [X1]\Digital inputs\Channel9\		
	Channel address	I1.1	Input filters	6.4 millisec
	Enable pulse catch	0		
E	PROFINET interface [X1]\Digital inputs\Channel9\			
	Enable rising edge detection	0	RidPrefixRisingEdg-eEvent	49161
	Event name:	0	Hardware inter-rupt:	0
	Rising edge9	Rising edge9 PROFINET interface [X1]\Digital inputs\Channel9\		
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49289
F	Event name:	0	Hardware inter-rupt:	0
	Falling edge9	Falling edge9		
	Owner	Project name	Automation Production Station Code	Date 7/12/2025
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
	Designed By	Location		
	Checked By	Description 1st	Language	en-US
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A	PROFINET interface [X1]\Digital inputs\Channel10			
	Channel address	I1.2	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49162
	Event name:	0	Hardware interrupt:	0
	Rising edge10	Rising edge10		
	PROFINET interface [X1]\Digital inputs\Channel10\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49290
	Event name:	0	Hardware interrupt:	0
B	Falling edge10	Falling edge10		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Channel address	I1.3	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable rising edge detection	0	RidPrefixRisingEdgeEvent	49163
	Event name:	0	Hardware interrupt:	0
	Rising edge11	Rising edge11		
	PROFINET interface [X1]\Digital inputs\Channel11\			
	Enable falling edge detection	0	RidPrefixFallin-gEdgeEvent	49291
C	Event name:	0	Hardware interrupt:	0
	Falling edge11	Falling edge11		
	PROFINET interface [X1]\Digital inputs\Channel12			
	Channel address	I1.4	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Digital inputs\Channel13			
	Channel address	I1.5	Input filters	6.4 millisec
	Enable pulse catch	0		
	PROFINET interface [X1]\Analog inputs\Noise reduction			
	Integration time	50 Hz (20 ms)		
D	PROFINET interface [X1]\Analog inputs\Channel0			
	Channel address	IW64	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Analog inputs\Channel1			
	Channel address	IW66	Measurement type	Voltage
	Voltage range	0..10 V	Smoothing	Weak (4 cycles)
			Enable overflow di-agnostics	1
	PROFINET interface [X1]\Digital outputs			
	Reaction to CPU STOP	Use substitute value		
E	Owner	Project name Automation Production Station Code		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
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A	PROFINET interface [X1]\Digital outputs\Channel0			
	Channel address	Q0.0	Substitute a value of 1 on a change from RUN to STOP.	0
PROFINET interface [X1]\Digital outputs\Channel1				
	Channel address	Q0.1	Substitute a value of 1 on a change from RUN to STOP.	0
PROFINET interface [X1]\Digital outputs\Channel2				
	Channel address	Q0.2	Substitute a value of 1 on a change from RUN to STOP.	0
PROFINET interface [X1]\Digital outputs\Channel3				
	Channel address	Q0.3	Substitute a value of 1 on a change from RUN to STOP.	0
PROFINET interface [X1]\Digital outputs\Channel4				
	Channel address	Q0.4	Substitute a value of 1 on a change from RUN to STOP.	0
PROFINET interface [X1]\Digital outputs\Channel5				
	Channel address	Q0.5	Substitute a value of 1 on a change from RUN to STOP.	0
PROFINET interface [X1]\Digital outputs\Channel6				
	Channel address	Q0.6	Substitute a value of 1 on a change from RUN to STOP.	0
PROFINET interface [X1]\Digital outputs\Channel7				
	Channel address	Q0.7	Substitute a value of 1 on a change from RUN to STOP.	0
PROFINET interface [X1]\Digital outputs\Channel8				
	Channel address	Q1.0	Substitute a value of 1 on a change from RUN to STOP.	0
PROFINET interface [X1]\Digital outputs\Channel9				
	Channel address	Q1.1	Substitute a value of 1 on a change from RUN to STOP.	0
PROFINET interface [X1]\Operating mode				
	IO controller	True	IO system	
	Device number	0	IO device	False
PROFINET interface [X1]\I/O addresses\Input addresses				
	Start address	0.0	End address	1.7
	Organization block	0	Process image	0
PROFINET interface [X1]\I/O addresses\Input addresses				
	Start address	64	End address	67
	Organization block	0	Process image	0
PROFINET interface [X1]\I/O addresses\Output addresses				
	Start address	0.0	End address	1.7
	Organization block	0	Process image	0

Owner	Project name Automation Production Station Code		Date 7/12/2025
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A	PROFINET interface [X1]\Advanced options\Interface options				
	Support device replacement without exchangeable medium	True	Use IEC V2.2 LLDP mode	True	
B	Keep-Alive connection monitoring:	30s			
	PROFINET interface [X1]\Advanced options\Real time settings\IO communication				
C	Send clock:	1.000ms			
	PROFINET interface [X1]\Advanced options\Real time settings\Real time options				
D	Calculated bandwidth for cyclic IO data:	0.000ms	Calculated bandwidth for cyclic IO data:	0.000%	
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\General				
E	Name	Port_1	Author	MTC-MECH-05	
	Comment				
F	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Local port:				
	Local port:	PLC_5\PROFINET interface_1 [X1]\Port_1 [X1 P1]	Medium:	Copper	
G	Cable name:	---			
					
H	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port interconnection\Partner port:				
	Monitoring of partner port is not possible	Partner port:	Any partner		
I	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Activate				
	Activate this port for use	True			
J	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Connection				
	Transmission rate / duplex:	Automatic	Monitor	False	
K	Enable autonegotiation	True			
	PROFINET interface [X1]\Advanced options\Port [X1 P1]\Port options\Boundaries				
L	End of detection of accessible devices	False	End of topology discovery	False	
	End of the sync domain	False			
M	High speed counters (HSC)\HSC1\General\Enable				
	Enable this high speed counter	0	Enable this high speed counter	0	
N	Enable this high speed counter	0	Enable this high speed counter	0	
	Enable this high speed counter	0	Enable this high speed counter	0	
O	High speed counters (HSC)\HSC1\General\Project information				
	Name	HSC_1	Comment		
P	Owner	Project name Automation Production Station Code		Date 7/12/2025	
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Q	Designed By	Location			
	Checked By	Description 1st			
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A	Name	HSC_2	Comment	
	Name	HSC_3	Comment	
	Name	HSC_4	Comment	
	Name	HSC_5	Comment	
	Name	HSC_6	Comment	
	High speed counters (HSC)\HSC1\I/O addresses\Input addresses			
B	Start address	1000.0	End address	1003.7
	Start address	1004.0	End address	1007.7
	Organization block	0	Start address	1008.0
	End address	1011.7	Organization block	0
	Process image	0	Start address	1012.0
	End address	1015.7	Organization block	0
	Process image	0	Start address	1016.0
	End address	1019.7	Organization block	0
	Process image	0	Start address	1020.0
	End address	1023.7	Organization block	0
C	Process image	0	Organization block	0
	Process image	0	Process image	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Enable			
	Enable this pulse generator	0	Enable this pulse generator	0
	Pulse generators (PTO/PWM)\PTO1/PWM1\General\Project information			
	Name	Pulse_1	Comment	
	Name	Pulse_2	Comment	
	Pulse generators (PTO/PWM)\PTO1/PWM1\I/O addresses\Output addresses			
	Start address	1000.0	End address	1001.7
	Start address	1002.0	End address	1003.7
D	Organization block	0	Organization block	0
	Process image	0	Process image	0
	Startup			
	Startup after POWER ON	Warm restart - mode before POWER OFF	Comparison preset to actual configuration	Startup CPU even if mismatch
	Configuration time	60000ms	OBs should be interruptible	1
	Cycle			
	Cycle monitoring time	150ms		
	Enable minimum cycle time for cyclic OBs	0	Minimum cycle time	1ms
	Communication load			
	Cycle load due to communication	20%		
E	System and clock memory\System memory bits			
	Enable the use of system memory byte	1	Address of system memory byte (MBx)	1
	First cycle	%M1.0 (FirstScan)	Diagnostic status changed	%M1.1 (DiagStatusUpdate)
	Always 1 (high)	%M1.2 (AlwaysTRUE)	Always 0 (low)	%M1.3 (AlwaysFALSE)
F	Owner	Project name Automation Production Station Code		Date 7/12/2025
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A	System and clock memory\Clock memory bits					
	Enable the use of clock memory byte	1	Address of clock memory byte (MBx)			
	10 Hz clock	%M0.0 (Clock_10Hz)	5 Hz clock			
	2.5 Hz clock	%M0.2 (Clock_2.5Hz)	2 Hz clock			
	1.25 Hz clock	%M0.4 (Clock_1.25Hz)	1 Hz clock			
	0.625 Hz clock	%M0.6 (Clock_0.625Hz)	0.5 Hz clock			
B	Web server\General					
	Activate web server on this module	False	Permit access only with HTTPS			
	Web server\Automatic update					
	Enable automatic update	True	Update interval			
C	Web server\User interface languages					
	Assign project language		User interface languages			
	English (United States)		German			
	English (United States)		English			
	English (United States)		French			
	English (United States)		Spanish			
	English (United States)		Italian			
	English (United States)		Chinese (simplified)			
D	Web server\User management					
	User name		User rights			
	Everybody					
E	Web server\User-defined web pages					
	Application name	HTML source path	Default HTML page	Files with dynamic content	Web DB number	Fragment DB number
			index.htm	.htm;.html	333	334
F	User interface languages					
	Assign project language		User interface languages			
	English (United States)		German			
	English (United States)		English			
	English (United States)		French			
	English (United States)		Spanish			
	English (United States)		Italian			
	English (United States)		Chinese (simplified)			
	Time of day\Local time					
	Time zone	(UTC +01:00) Berlin, Bern, Brussels, Rome, Stockholm, Vienna				
	Time of day\Daylight saving time					
	Activate daylight saving time	1	Difference between standard and daylight saving time			
			60mins			
	Time of day\Daylight saving time\Start of daylight saving time					
	Starting week of the month:	Last	Sunday			
	of	March	at 01:00 a.m.			
	Time of day\Daylight saving time\Start of standard time					
	Last		Sunday			
	of	October	at 02:00 a.m.			
	Protection & Security					
	Level of protection	No protection				
	Owner	Project name	Automation Production Station Code	Date	7/12/2025	
	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
	Designed By	Location				
	Checked By	Description 1st	Description 2nd	Language	en-US	
	Approved By	1st View		Version	Sheet 156 - 9	

A

Protection & Security\Connection mechanisms

Permit access with True
 PUT/GET communication from remote partner

Overview of addresses\Overview of addresses\Overview of addresses

Inputs	True	Outputs	True
Address gaps	False	Slot	True

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 156 - 10

A	Type	I	Addr. from	0	Addr. to	1
	Module	DI 14/DQ 10_1	PIP	Automatic update	Device name	PLC_5 [CPU 1214C DC/DC/DC]
B	Device number	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 1	Addr. to	1
C	Type	O	Addr. from	0	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Module	DI 14/DQ 10_1	PIP	Automatic update	Master / IO system	-
D	Device number	-	Size	2 Bytes	Addr. to	67
	Rack	0	Slot	1 1	Device name	PLC_5 [CPU 1214C DC/DC/DC]
E	Type	I	Addr. from	64	Master / IO system	-
	Module	AI 2_1	PIP	Automatic update	Addr. to	1003
F	Device number	-	Size	4 Bytes	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Rack	0	Slot	1 2	Master / IO system	-
G	Type	I	Addr. from	1000	Addr. to	1007
	Module	HSC_1	PIP	Automatic update	Device name	PLC_5 [CPU 1214C DC/DC/DC]
H	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 16	Addr. to	1007
I	Type	I	Addr. from	1004	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Module	HSC_2	PIP	Automatic update	Master / IO system	-
J	Device number	-	Size	4 Bytes	Addr. to	1007
	Rack	0	Slot	1 17	Device name	PLC_5 [CPU 1214C DC/DC/DC]
K	Type	I	Addr. from	1008	Master / IO system	-
	Module	HSC_3	PIP	Automatic update	Addr. to	1011
L	Device number	-	Size	4 Bytes	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Rack	0	Slot	1 18	Master / IO system	-
M	Type	I	Addr. from	1012	Addr. to	1015
	Module	HSC_4	PIP	Automatic update	Device name	PLC_5 [CPU 1214C DC/DC/DC]
N	Device number	-	Size	4 Bytes	Master / IO system	-
	Rack	0	Slot	1 19	Addr. to	1019
O	Type	I	Addr. from	1016	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Module	HSC_5	PIP	Automatic update	Master / IO system	-
P	Device number	-	Size	4 Bytes	Addr. to	1019
	Rack	0	Slot	1 20	Device name	PLC_5 [CPU 1214C DC/DC/DC]
Q	Type	I	Addr. from	1020	Master / IO system	-
	Module	HSC_6	PIP	Automatic update	Addr. to	1023
R	Device number	-	Size	4 Bytes	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Rack	0	Slot	1 20	Master / IO system	-

Owner	Project name Automation Production Station Code		Date 7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Description 1st		
Checked By	Description 2nd	Language en-US	
Approved By	1st View	Version	Sheet 156 - 11

A	Rack	0	Slot	1 21		
	Type	O	Addr. from	1000	Addr. to	1001
	Module	Pulse_1	PIP	Automatic update	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Device num- ber	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 32		
	Type	O	Addr. from	1002	Addr. to	1003
	Module	Pulse_2	PIP	Automatic update	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Device num- ber	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 33		
	Type	O	Addr. from	1004	Addr. to	1005
B	Module	Pulse_3	PIP	Automatic update	Device name	PLC_5 [CPU 1214C DC/DC/DC]
	Device num- ber	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 34		
	Type	O	Addr. from	1006	Addr. to	1007
	Module	Pulse_4	PIP	Automatic update	Device name	PLC_5 [CPU 1214C DC/DC/DC]
C	Device num- ber	-	Size	2 Bytes	Master / IO system	-
	Rack	0	Slot	1 35		

D																										
E																										
F	<table border="1"> <tr> <td>Owner</td> <td>Project name</td> <td>Automation Production Station Code</td> <td>Date</td> <td>7/12/2025</td> </tr> <tr> <td>Operator</td> <td>Project path</td> <td colspan="3">C:\Users\DEEL\Desktop\VSM\Automation Production Station Code</td> </tr> <tr> <td>Designed By</td> <td>Description 1st</td> <td colspan="3"></td> </tr> <tr> <td>Checked By</td> <td>Description 2nd</td> <td>Language</td> <td colspan="2">en-US</td> </tr> <tr> <td>Approved By</td> <td>1st View</td> <td>Version</td> <td colspan="2">Sheet 156 - 12</td> </tr> </table>	Owner	Project name	Automation Production Station Code	Date	7/12/2025	Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			Designed By	Description 1st				Checked By	Description 2nd	Language	en-US		Approved By	1st View	Version	Sheet 156 - 12	
Owner	Project name	Automation Production Station Code	Date	7/12/2025																						
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code																								
Designed By	Description 1st																									
Checked By	Description 2nd	Language	en-US																							
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A

Automation Production Station Code

Ungrouped devices

This folder is empty.

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 157 - 1

A

Automation Production Station Code

Security settings

This folder is empty.

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
Approved By	Description 2nd	Language	en-US	Version
	1st View			Sheet 158 - 1

A

Automation Production Station Code / Cross-device functions / Project traces

Measurements

This folder is empty.

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
Checked By	Description 1st			
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A

Automation Production Station Code / Common data

Alarm classes

Alarm classes	
Name	Acknowledgement
Display name	A
Acknowledgment	True
Priority	0
Name	No Acknowledgement
Display name	NA
Acknowledgment	False
Priority	0

B

C

D

E

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
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F

A

Automation Production Station Code / Common data

Logs

This folder is empty.

B

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code		
Designed By	Location			
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A

Automation Production Station Code / Languages & resources

Project languages

Languages

Reference language

English (United States)

Editing language

English (United States)

B

Other project languages

Empty

C

D

E

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
Designed By	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Checked By	Location			
Approved By	Description 1st	Description 2nd	Language	en-US
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A

Automation Production Station Code / Languages & resources / Project texts

Project texts

Project texts	
English (United States)	
Category	Text category tag comment
Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_1\Comment
English (United States)	
Category	Text category tag comment
Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_2\Comment
English (United States)	
Category	Text category tag comment
Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_3\Comment
English (United States)	
Category	Text category tag comment
Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_4\Comment
English (United States)	
Category	Text category tag comment
Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_5\Comment
English (United States)	
Category	Text category tag comment
Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_7\Comment
English (United States)	
Category	Text category tag comment
Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_8\Comment
English (United States)	
Category	Text category tag comment
Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_9\Comment
English (United States)	
Category	Text category tag comment
Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_10\Comment
English (United States)	
Category	Text category tag comment
Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_12\Comment
English (United States)	
Category	Text category tag comment
Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_17\Comment
English (United States)	

F

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
Approved By	1st View		Version	Sheet 163 - 1

A	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_34\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_35\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_36\Comment
	English (United States)	
	Category	Text category tag comment
B	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_47\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_50\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_21\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_22\Comment
C	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_24\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_25\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_26\Comment
	English (United States)	
D	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_37\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\System_Byte\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\System_Byte\Comment
	English (United States)	
	Category	Text category tag comment
E	Owner	Project name Automation Production Station Code
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code
	Designed By	Location
	Checked By	Description 1st
	Approved By	Description 2nd Language en-US
		Version
		Sheet 163 - 2

A	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\FirstScan\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\DiagStatusUpdate\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\AlwaysTRUE\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\AlwaysFALSE\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Clock_Bytel\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Clock_10Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Clock_5Hz\Comment
	English (United States)	
C	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Clock_2.5Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Clock_1.25Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Clock_0.625Hz\Comment
	English (United States)	
	Category	Text category tag comment
D	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Clock_2Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Clock_1.25Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Clock_1Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Clock_0.5Hz\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Clock_0.5Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Clock_0.5Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Clock_0.5Hz\Comment
	English (United States)	
F	Owner	Project name Automation Production Station Code
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code
	Designed By	Description 1st
	Checked By	Description 2nd
	Approved By	Language en-US
		Version
		Sheet 163 - 3

A	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_6\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_11\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_13\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_14\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_15\Comment
C	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_16\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_18\Comment
D	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_20\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_27\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_28\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_29\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_30\Comment
F	English (United States)	
	Category	Text category tag comment

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
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A	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_31\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_32\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_33\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_38\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_39\Comment
C	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_40\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_41\Comment
D	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_43\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_44\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_45\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_46\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_48\Comment
F	English (United States)	
	Category	Text category tag comment

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
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A	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_49\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_51\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_52\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_53\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [94]\Tag_54\Comment
C	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_2\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_3\Comment
D	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_5\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_8\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_9\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_11\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_12\Comment
F	English (United States)	
	Category	Text category tag comment

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path			
	C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Location			
Checked By	Description 1st	Description 2nd	Language	en-US
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A	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_14\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_22\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_24\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_25\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_26\Comment
C	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_28\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_32\Comment
D	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_53\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_54\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_56\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_60\Comment
F	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_70\Comment
	English (United States)	
	Category	Text category tag comment

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A	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_6\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_18\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_37\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_38\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_39\Comment
C	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_40\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_41\Comment
D	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_43\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_44\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_45\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_55\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_1\Comment
	English (United States)	
	Category	Text category tag comment

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A	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_7\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_10\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_13\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_15\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_16\Comment
C	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_17\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_19\Comment
D	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_21\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_23\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_27\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_29\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_30\Comment
F	English (United States)	
	Category	Text category tag comment

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A	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_31\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_33\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\System_Byte\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\FirstScan\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\DiagStatusUpdate\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\AlwaysFALSE\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Clock_Byt\Comment
	English (United States)	
C	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Clock_10Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Clock_2.5Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Clock_2Hz\Comment
	English (United States)	
	Category	Text category tag comment
D	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Clock_1.25Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Clock_1Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Clock_0.625Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Clock_0.3125Hz\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Clock_0.15625Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Clock_0.078125Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Clock_0.0390625Hz\Comment
	English (United States)	
F	Owner	Project name Automation Production Station Code
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code
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A	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Clock_0.5Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_34\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_35\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_36\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_46\Comment
C	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_47\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_49\Comment
D	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_50\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_51\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_57\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_58\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_59\Comment
F	English (United States)	
	Category	Text category tag comment

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A	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_61\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_62\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_63\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_64\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_65\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_66\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_67\Comment
	English (United States)	
C	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_68\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_69\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_71\Comment
	English (United States)	
	Category	Text category tag comment
D	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_72\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_73\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_74\Comment
	English (United States)	
	Category	Text category tag comment
E	Owner	Project name Automation Production Station Code
		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code
		Location
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	Checked By	Description 2nd
F		Language en-US
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	Location			
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A	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_75\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_76\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_77\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [117]\Tag_78\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_1\Comment
C	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_2\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_3\Comment
D	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_7\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_8\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_9\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_14\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_18\Comment
F	English (United States)	
	Category	Text category tag comment

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A	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_22\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_24\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_25\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_30\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_39\Comment
C	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_41\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_43\Comment
D	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_45\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_10\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_16\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_27\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_31\Comment
F	English (United States)	
	Category	Text category tag comment

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A	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_32\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_42\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_50\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\System_Byt\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\FirstScan\Comment
C	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\AlwaysTRUE\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\AlwaysFALSE\Comment
D	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Clock_Byt\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Clock_10Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Clock_5Hz\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Clock_2.5Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Clock_2Hz\Comment
F	English (United States)	
	Category	Text category tag comment

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Designed By	Location			
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A	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Clock_1.25Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Clock_1Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Clock_0.625Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Clock_0.5Hz\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_5\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_6\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_11\Comment
	English (United States)	
C	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_12\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_13\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_15\Comment
	English (United States)	
	Category	Text category tag comment
D	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_17\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_19\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_20\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	
E	Owner	Project name Automation Production Station Code
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code
	Designed By	Description 1st
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A	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_21\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_23\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_26\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_28\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_29\Comment
C	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_33\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_35\Comment
D	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_36\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_37\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_38\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_44\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_46\Comment
F	English (United States)	
	Category	Text category tag comment

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A	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_47\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_48\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_49\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [92]\Tag_51\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_1\Comment
C	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_2\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_3\Comment
D	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_5\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_6\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_7\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_9\Comment
F	English (United States)	
	Category	Text category tag comment

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A	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_20\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_21\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_22\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_40\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_41\Comment
C	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_45\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_23\Comment
D	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_28\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_29\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_30\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_31\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_32\Comment
F	English (United States)	
	Category	Text category tag comment

Owner	Project name	Automation Production Station Code	Date	7/12/2025
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Designed By	Location			
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A	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_33\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_34\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_43\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\System_Byt\Comment	
B	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\System_Byt\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\FirstScan\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\DiagStatusUpdate\Comment	
	English (United States)		
C	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\AlwaysTRUE\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\AlwaysFALSE\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Clock_Byt\Comment	
	English (United States)		
	Category	Text category tag comment	
D	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Clock_10Hz\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Clock_5Hz\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Clock_2.5Hz\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Clock_2Hz\Comment	
E	English (United States)		
	Category	Text category tag comment	
F	Owner	Project name Automation Production Station Code	Date 7/12/2025
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	Description 1st		
	Description 2nd	Language en-US	
Checked By	1st View	Version	Sheet 163 - 20
Approved By			

A	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Clock_1.25Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Clock_1Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Clock_0.625Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Clock_0.5Hz\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_8\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_10\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_12\Comment
	English (United States)	
C	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_13\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_14\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_15\Comment
	English (United States)	
	Category	Text category tag comment
D	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_16\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_17\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_18\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_19\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_20\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_21\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_22\Comment
	English (United States)	
F	Owner	Project name Automation Production Station Code
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code
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	Checked By	Description 2nd
	Approved By	Language en-US
		Version
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A	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_19\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_24\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_25\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_26\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_27\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_35\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_36\Comment
	English (United States)	
C	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_37\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_38\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_40\Comment
	English (United States)	
	Category	Text category tag comment
D	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_41\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_42\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_43\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_45\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_46\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_47\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	
	English (United States)	

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A	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [88]\Tag_48\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_1\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_2\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_3\Comment	
B	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_4\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_5\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_6\Comment	
	English (United States)		
C	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_7\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_8\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_10\Comment	
	English (United States)		
	Category	Text category tag comment	
D	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_12\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_21\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_34\Comment	
	English (United States)		
	Category	Text category tag comment	
E	Owner	Project name Automation Production Station Code	
		Date 7/12/2025	
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
		Location	
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	Checked By	Description 2nd	
F		Language en-US	
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A	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_35\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_36\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_19\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_23\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_24\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_25\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_26\Comment
	English (United States)	
C	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_27\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_28\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\System_Byt\Comment
	English (United States)	
	Category	Text category tag comment
D	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\FirstScan\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\DiagStatusUpdate\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\1st View\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	
E	Owner	Project name Automation Production Station Code
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code
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	Checked By	Description 2nd
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Checked By	Description 2nd			
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A	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\AlwaysTRUE\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\AlwaysFALSE\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Clock_Bytel\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Clock_10Hz\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Clock_10Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Clock_5Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Clock_2.5Hz\Comment
	English (United States)	
C	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Clock_2Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Clock_1.25Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Clock_1Hz\Comment
	English (United States)	
	Category	Text category tag comment
D	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Clock_0.625Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Clock_0.5Hz\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_9\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_11\Comment
E	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_11\Comment
	English (United States)	
	Category	Text category tag comment

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Operator	Project path			
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Designed By	Location			
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A	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_13\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_14\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_15\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_16\Comment	
B	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_17\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_18\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_20\Comment	
	English (United States)		
C	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_22\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_29\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_30\Comment	
	English (United States)		
	Category	Text category tag comment	
D	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_31\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_32\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_33\Comment	
	English (United States)		
	Category	Text category tag comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_33\Comment	
E	English (United States)		
	Category	Text category tag comment	
F	Owner	Project name Automation Production Station Code	Date 7/12/2025
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A	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_38\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_39\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_40\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_41\Comment
B	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_42\Comment
	English (United States)	
	Category	Text category tag comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\PLC tags\Default tag table [83]\Tag_43\Comment
	English (United States)	"Main Program Sweep (Cycle)"
	Category	Block comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\Main [OB1]\Block title
	English (United States)	"Main Program Sweep (Cycle)"
C	Category	Block comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\Main [OB1]\Block title
	English (United States)	"Main Program Sweep (Cycle)"
	Category	Block comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\Main [OB1]\Block title
	English (United States)	"Main Program Sweep (Cycle)"
	Category	Block comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\Program blocks\Main [OB1]\Block title
	English (United States)	"Main Program Sweep (Cycle)"
	Category	Block comment
D	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\Program blocks\Main [OB1]\Block title
	English (United States)	=True, if remanent data are available
	Category	Block comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\Main [OB1]\Remanence
	English (United States)	=True, if remanent data are available
	Category	Block comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\Main [OB1]\Remanence
	English (United States)	=True, if remanent data are available
	Category	Block comment
E	Owner	Project name Automation Production Station Code
		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code
		Location
	Designed By	Description 1st
	Checked By	Description 2nd
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A	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\Main [OB1]\Remanence
	English (United States)	=True, if remanent data are available
	Category	Block comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\Program blocks\Main [OB1]\Remanence
	English (United States)	=True, if remanent data are available
	Category	Block comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\Program blocks\Main [OB1]\Remanence
	English (United States)	A
	Category	Alarm class text
	Reference	Automation Production Station Code\Acknowledgement\AlarmClass-Data_IDisplayNaming_DisplayName
B	English (United States)	A
	Category	Alarm class text
	Reference	Automation Production Station Code\Acknowledgement\ShortName
	English (United States)	CAPPING MOD HOME
	Category	Block comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 3 [FC1]\Network 11>Title
	English (United States)	CAPPING MODULE RETRACT (CAP MOVES FORWARD)
	Category	Block comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 3 [FC1]\Network 8>Title
	English (United States)	CLAMPING
C	Category	Block comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 2 [FC1]\Network 3>Title
	English (United States)	CONVEYOR
	Category	Block comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 2 [FC1]\Network 9>Title
	English (United States)	CONVEYOR RUN
	Category	Block comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 2 [FC1]\Network 10>Title
	English (United States)	CONVEYOR RUN
	Category	Block comment
D	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 5 [FC1]\Network 3>Title
	English (United States)	CONVEYOR RUN1(START TO BUFFER CYL1)
	Category	Block comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 4 [FC1]\Network 3>Title
	English (United States)	CONVEYOR RUN2 (BUFFER CYL1 TO BUFFER CYL2)
	Category	Block comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 4 [FC1]\Network 5>Title
	English (United States)	CONVEYOR RUN3(BOTTLE MOVE FROM BUFFER CYL2 TO END)
	Category	Block comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 4 [FC1]\Network 7>Title
E	Owner	Project name Automation Production Station Code
		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code
		Location
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F	Approved By	Language en-US
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A	English (United States)	CONVEYOR STOP	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 5 [FC1]\Network 4>Title	
	English (United States)	CONVEYOR STOP AT END POSITION	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 2 [FC1]\Network 13>Title	
	English (United States)	dispensing extend	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 1 [FC1]\Network 3>Title	
B	English (United States)	DISPENSING RETRACT	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks>Main [OB1]\Network 4>Title	
	English (United States)	ESTOP COMMON	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks>Main [OB1]\Network 4>Title	
	English (United States)	ESTOP HOMING POSITION LOGIC	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 1 [FC3]\Network 1>Title	
C	English (United States)	ESTOP HOMING POSITION LOGIC	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 2 [FC3]\Network 1>Title	
	English (United States)	ESTOP HOMING POSITION LOGIC	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 3 [FC3]\Network 1>Title	
D	English (United States)	ESTOP HOMING POSITION LOGIC	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 4 [FC3]\Network 1>Title	
	English (United States)	ESTOP HOMING POSITION LOGIC	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 5 [FC3]\Network 1>Title	
	English (United States)	ESTOP LOGIC RESET	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 1 [FC3]\Network 4>Title	
	English (United States)	ESTOP LOGIC RESET	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 2 [FC3]\Network 4>Title	
E	English (United States)	ESTOP LOGIC RESET	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 4 [FC3]\Network 4>Title	
	English (United States)	ESTOP LOGIC RESET	

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A	Category	Block comment	
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 5 [FC3]\Network 4>Title	
	English (United States)	FILLING MODULE EXTEND	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 3 [FC1]\Network 5>Title	
	English (United States)	FM RETRACT	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 3 [FC1]\Network 6>Title	
	English (United States)	FOR INDEXING RUN 2 AFTER FILLING	
	Category	Block comment	
B	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 3 [FC1]\Network 7>Title	
	English (United States)	FOR INDEXING RUN 3 AFTER CAPPING	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 3 [FC1]\Network 12>Title	
	English (United States)	FROM STATION 2	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\COM 1 [FC5]\Network 1>Title	
	English (United States)	GET FROM 3,4,5	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\COM 1 [FC5]\Network 2>Title	
C	English (United States)	GRIPPER CLOSE	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 1 [FC1]\Network 6>Title	
	English (United States)	GRIPPER OPEN	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 1 [FC1]\Network 10>Title	
	English (United States)	HCM DOWN	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 2 [FC1]\Network 5>Title	
	English (United States)	HCM EXTEND	
D	Category	Block comment	
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 2 [FC1]\Network 4>Title	
	English (United States)	HCM HOME	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 2 [FC1]\Network 8>Title	
	English (United States)	HCM RETRACT AND CLAMPING RETRACT	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 2 [FC1]\Network 7>Title	
	English (United States)	HCM UP	
	Category	Block comment	
E	Owner	Project name Automation Production Station Code	
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A	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 2 [FC1]\Network 6>Title
	English (United States)	HEIGHT CHECK PROCESS
	Category	Block comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 2 [FC1]\Network 14>Title
	English (United States)	INDEXING HOMING
	Category	Block comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 3 [FC3]\Network 3>Title
	English (United States)	INDEXING RUN
	Category	Block comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 3 [FC1]\Network 3>Title
B	English (United States)	INDEXING STOP
	Category	Block comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 3 [FC1]\Network 4>Title
	English (United States)	Initial call of this OB
	Category	Block comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks>Main [OB1]\Initial_Call
	English (United States)	Initial call of this OB
	Category	Block comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks>Main [OB1]\Initial_Call
	English (United States)	Initial call of this OB
C	Category	Block comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks>Main [OB1]\Initial_Call
	English (United States)	Initial call of this OB
	Category	Block comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\Main [OB1]\Initial_Call
	English (United States)	Initial call of this OB
	Category	Block comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\Main [OB1]\Initial_Call
	English (United States)	Initial call of this OB
	Category	Block comment
D	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\Program blocks>Main [OB1]\Initial_Call
	English (United States)	Initial call of this OB
	Category	Block comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\Program blocks>Main [OB1]\Initial_Call
	English (United States)	MEMORY RESET
	Category	Block comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 1 [FC3]\Network 3>Title
	English (United States)	MEMORY RESET
	Category	Block comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 2 [FC3]\Network 3>Title
E	English (United States)	MEMORY RESET
	Category	Block comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 3 [FC3]\Network 5>Title
	English (United States)	MEMORY RESET
	Category	Block comment

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A	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 4 [FC3]\Network 3>Title
	English (United States)	MEMORY RESET
	Category	Block comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 5 [FC3]\Network 3>Title
	English (United States)	METAL REJECTION LOGIC & RM EXTEND
	Category	Block comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 2 [FC1]\Network 11>Title
	English (United States)	NA
	Category	Alarm class text
	Reference	Automation Production Station Code\No Acknowledgement\Alarm-ClassData_DisplayNaming_DisplayName
B	English (United States)	NA
	Category	Alarm class text
	Reference	Automation Production Station Code\No Acknowledgement\Short-Name
	English (United States)	OUTPUT CALL
	Category	Block comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\OUTPUT CALL 1 [FC2]\Network 1>Title
	English (United States)	OUTPUT CALL FOR HOMING
	Category	Block comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 1 [FC3]\Network 2>Title
	English (United States)	OUTPUT CALL FOR HOMING
C	Category	Block comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 2 [FC3]\Network 2>Title
	English (United States)	OUTPUT CALL FOR HOMING
	Category	Block comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 3 [FC3]\Network 2>Title
	English (United States)	OUTPUT CALL FOR HOMING
	Category	Block comment
	Reference	Automation Production Station Code\PLC_4 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 4 [FC3]\Network 2>Title
	English (United States)	OUTPUT CALL FOR HOMING
	Category	Block comment
D	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\Program blocks\ESTOP LOGIC 5 [FC3]\Network 2>Title
	English (United States)	PUT TO 3,4,5
	Category	Block comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\COM 1 [FC5]\Network 3>Title
	English (United States)	PUT VALUE FOR START STOP LOGIC
	Category	Block comment
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\DATA BLOCK MOVE [FC4]\Network 3>Title
	English (United States)	RM RETRACT AND CONVEYOR STOP AFTER REJECTION
	Category	Block comment
	Owner	Project name Automation Production Station Code
E	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code
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A	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 2 [FC1]\Network 12>Title
	English (United States)	RPM start
	Category	Block comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 3 [FC1]\Network 13>Title
	English (United States)	rpm stop
	Category	Block comment
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 3 [FC1]\Network 14>Title
	English (United States)	RPP DOWN
	Category	Block comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 1 [FC1]\Network 9>Title
B	English (United States)	RPP FOR PICKING BOTTLE (RPP DOWN)
	Category	Block comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 1 [FC1]\Network 5>Title
	English (United States)	RPP HOME
	Category	Block comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 1 [FC1]\Network 13>Title
	English (United States)	RPP ROTATE CCW
	Category	Block comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 1 [FC1]\Network 8>Title
	English (United States)	RPP ROTATE CW
C	Category	Block comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 1 [FC1]\Network 12>Title
	English (United States)	RPP UP
	Category	Block comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 1 [FC1]\Network 7>Title
	English (United States)	RPP UP
	Category	Block comment
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 1 [FC1]\Network 11>Title
	English (United States)	SELECTOR COMMON
	Category	Block comment
D	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks>Main [OB1]\Network 5>Title
	English (United States)	SORTING EXTEND
	Category	Block comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 5 [FC1]\Network 5>Title
	English (United States)	SORTING RETRACT
	Category	Block comment
	Reference	Automation Production Station Code\PLC_5 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 5 [FC1]\Network 6>Title
	English (United States)	START COMMON
	Category	Block comment
F	Owner	Project name Automation Production Station Code
		Date 7/12/2025
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code
		Location
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	Checked By	Description 2nd
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A	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks>Main [OB1]\Network 2>Title	
	English (United States)	START STOP CONTROL FOR BOTH AUTO & MANUAL	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 1 [FC1]\Network 2>Title	
	English (United States)	START STOP CONTROL FOR BOTH AUTO & MANUAL	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 2 [FC1]\Network 2>Title	
	English (United States)	START STOP LOGIC FOR ALL STATION COMMON	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\MAIN [OB1]\Network 6>Title	
B	English (United States)	START STOP LOGIC FOR MANUAL	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 1 [FC1]\Network 1>Title	
	English (United States)	START STOP LOGIC FOR MANUAL	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_2 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 2 [FC1]\Network 1>Title	
	English (United States)	STOP COMMON	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_1 [CPU 1214C DC/DC/DC]\Program blocks>Main [OB1]\Network 3>Title	
	English (United States)	The automation production station is the core of a mechatronic system where actual assembly or manufacturing tasks are performed automatically. It typically integrates actuators, sensors, robotic arms or pneumatic devices, and is controlled by a PLC or microcontroller. This station executes critical functions like assembling components, inserting parts, or performing pick-and-place operations. It demonstrates the seamless interaction between mechanical systems, electronics, and software, embodying the essence of industrial automation. By simulating real-world production environments, the station is essential for training students and professionals in efficient, accurate, and high-speed automated manufacturing processes.	
D	Category	Other text category	
	Reference	Automation Production Station Code\Comment	
	English (United States)	VERTICAL CYL DOWN	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 3 [FC1]\Network 9>Title	
	English (United States)	VERTICAL CYL RETRACT	
	Category	Block comment	
	Reference	Automation Production Station Code\PLC_3 [CPU 1214C DC/DC/DC]\Program blocks\AUTO 3 [FC1]\Network 10>Title	
	Owner	Project name Automation Production Station Code	
	Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code	
E	Designed By	Description 1st	
	Checked By	Description 2nd	
	Approved By	1st View	
		Language en-US	
		Version	Sheet 163 - 34

Owner	Project name	Automation Production Station Code	Date	7/12/2025
Operator	Project path C:\Users\DEEL\Desktop\VSM\Automation Production Station Code			
Designed By	Description 1st			
Checked By	Description 2nd			
Approved By	1st View	Language	en-US	Version
				Sheet 163 - 34