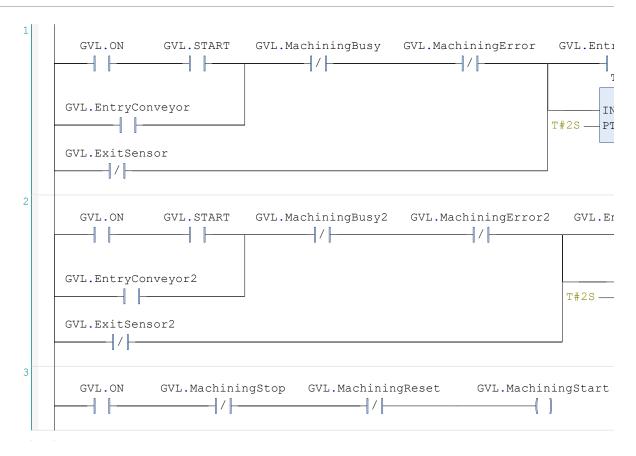
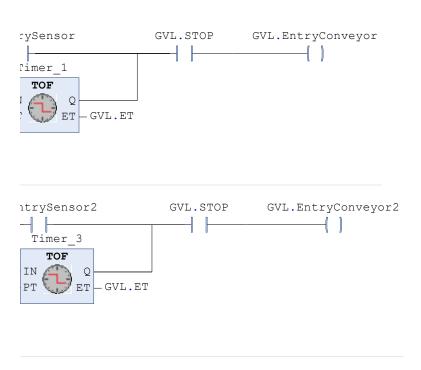
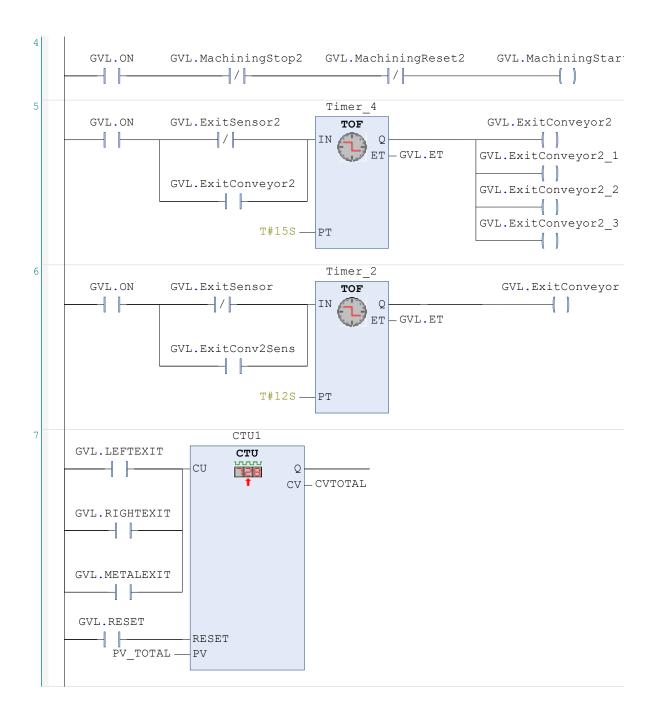
```
PROGRAM PRODUCTIONLINEMACHINING
2
      VAR
3
         Timer 1: TOF;
         Timer 2: TOF;
5
         Timer 3 : TOF;
         Timer 4: TOF;
7
         CTU1 : CTU;;
8
         PV : WORD ;
9
         CVTOTAL : WORD ;
10
          CTU2 : CTU;
11
          CTU3 : CTU;
12
         CTU4: CTU;
13
         CVGREEN: WORD;
14
         CVMETAL : WORD ;
15
         CVBLUE : WORD ;
         PV TOTAL : WORD ;
16
         PV GREEN: WORD;
17
         PV METAL: WORD;
18
19
         PV_BLUE : WORD ;
20
     END_VAR
21
```







t2

```
CTU2
       GVL.LEFTEXIT
                             CTU
                       CU
                             158
                                     Q
       GVL.RESET
                                     CV — CVBLUE
                       RESET
                 PV -
                      PV
9
                              CTU3
       GVL.METALEXIT
                              CTU
                              158
       GVL.RESET
                                     CV — CVMETAL
                        RESET
                  PV -
                        PV
10
                              CTU4
       GVL.RIGHTEXIT
                              CTU
                              Q
       GVL.RESET
                                     CV - CVGREEN
                        RESET
                  PV ---
```

POU: PRODUCTIONLINEMACHINING