



Totally Integrated Automation Portal

Symbol	Address	Type	Comment
"Tag_21"	%M1.6	Bool	

Network 5: Start

Symbol	Address	Type	Comment
"Start_button"	%I1.5	Bool	
"Start_contactor"	%Q2.5	Bool	
"Stop_button"	%I1.7	Bool	

Network 6: Emitter 1

Symbol	Address	Type	Comment
"Emitter_1"	%Q0.2	Bool	
"Start_contactor"	%Q2.5	Bool	

Network 7: Emitter 2

Symbol	Address	Type	Comment
"Emitter_2"	%Q0.1	Bool	
"Start_contactor"	%Q2.5	Bool	

Network 8: CNC Start

Symbol	Address	Type	Comment
"Diffuser_sensor_1"	%I0.0	Bool	
"Machining center_start"	%Q0.0	Bool	

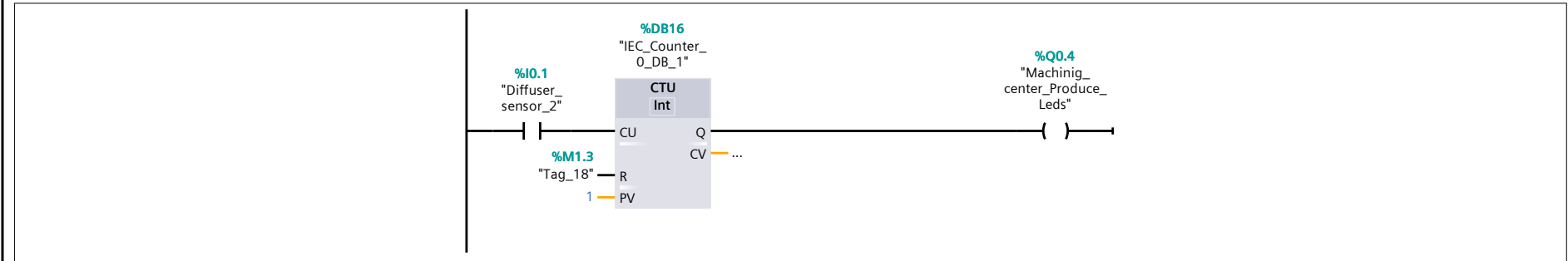
Network 9: Belt Conveyor 6m

Symbol	Address	Type	Comment
"Belt_conveyyor_6m_1"	%Q0.3	Bool	
"Diffuser_sensor_3"	%I0.2	Bool	

Network 10: CNC Producing lids

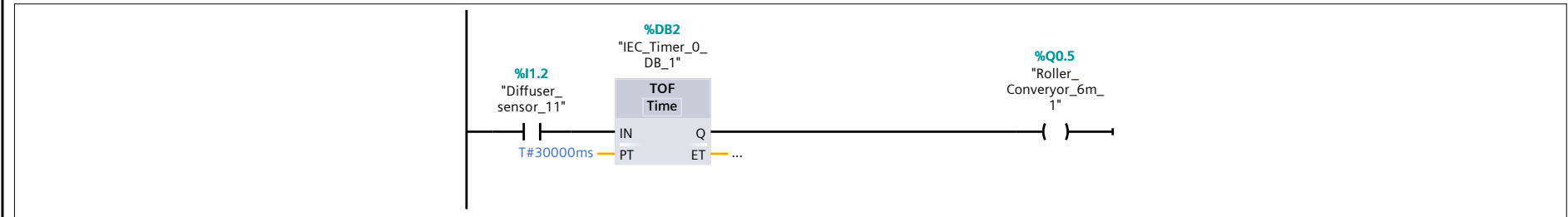
Symbol	Address	Type	Comment
"Tag_18"	%M1.3	Bool	
"Vision_sensor_1"	%I1.3	Bool	
"Vision_sensor_4"	%I3.5	Bool	

Network 11: CNC Producing lids



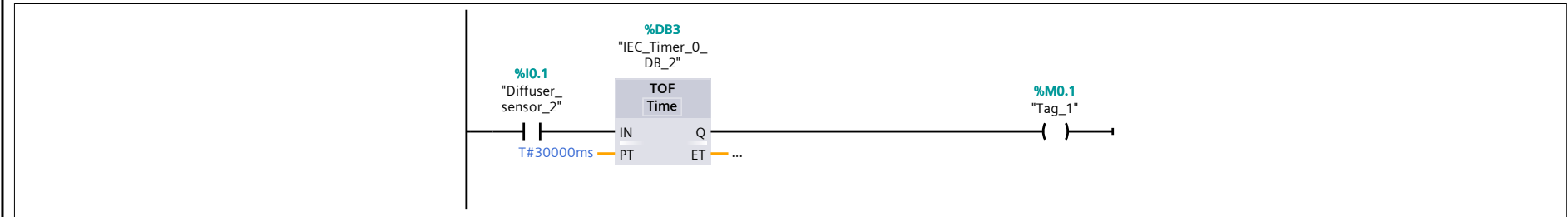
Symbol	Address	Type	Comment
"Diffuser_sensor_2"	%I0.1	Bool	
"Machinig_center_Produce_Leds"	%Q0.4	Bool	
"Tag_18"	%M1.3	Bool	

Network 12: Roller Conveyor 6m



Symbol	Address	Type	Comment
"Diffuser_sensor_11"	%I1.2	Bool	
"Roller_Conveyyor_6m_1"	%Q0.5	Bool	

Network 13: Belt Conveyor 4m-1



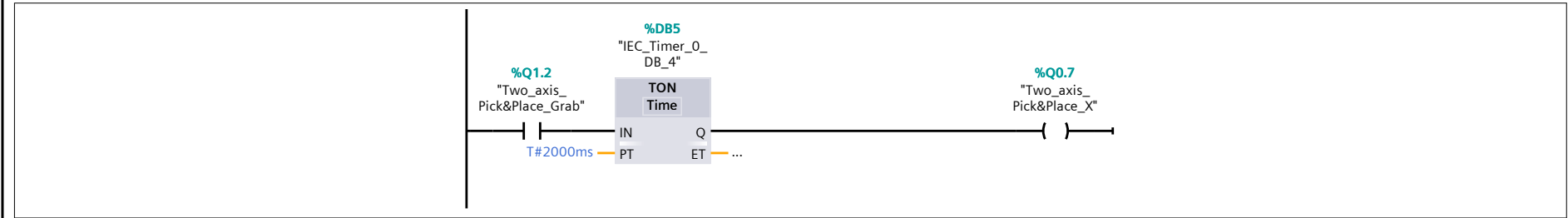
Symbol	Address	Type	Comment
"Diffuser_sensor_2"	%I0.1	Bool	
"Tag_1"	%M0.1	Bool	

Network 14:



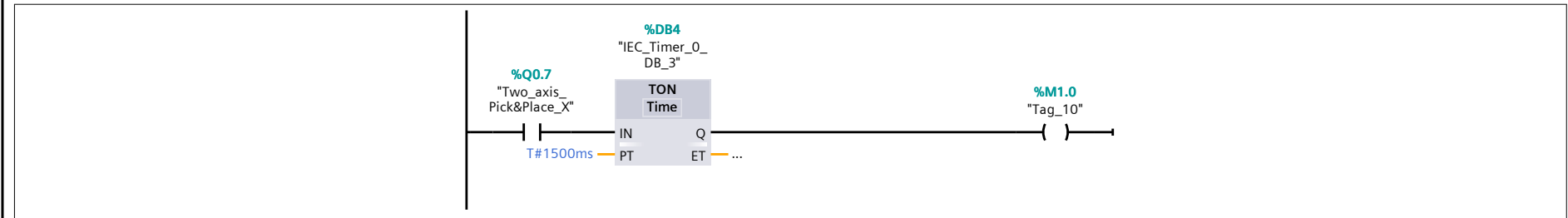
Symbol	Address	Type	Comment
"Belt_conveyyor_4m_1"	%Q2.6	Bool	
"Diffuser_sensor_4"	%I0.3	Bool	
"Tag_1"	%M0.1	Bool	

Network 15: Two Axis Place (1) Motion in X



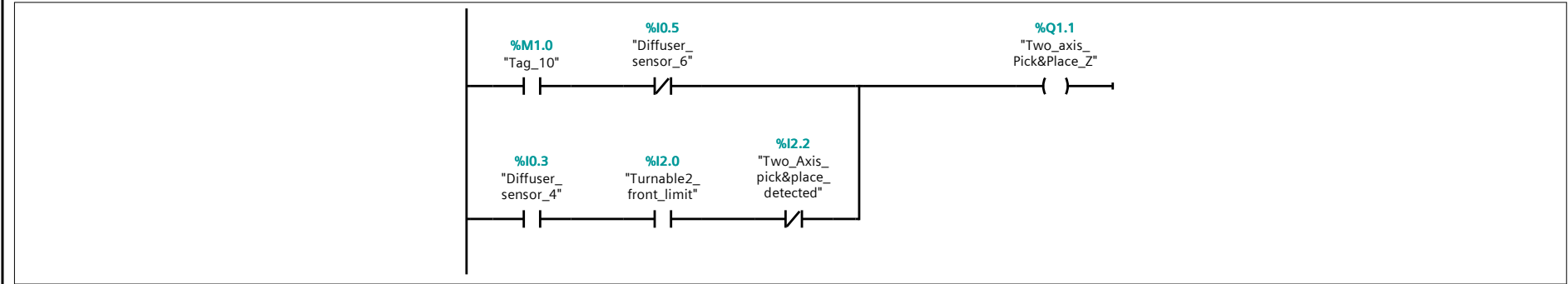
Symbol	Address	Type	Comment
"Two_axis_Pick&Place_Grab"	%Q1.2	Bool	
"Two_axis_Pick&Place_X"	%Q0.7	Bool	

Network 16: Two Axis Place (1) Motion in Z



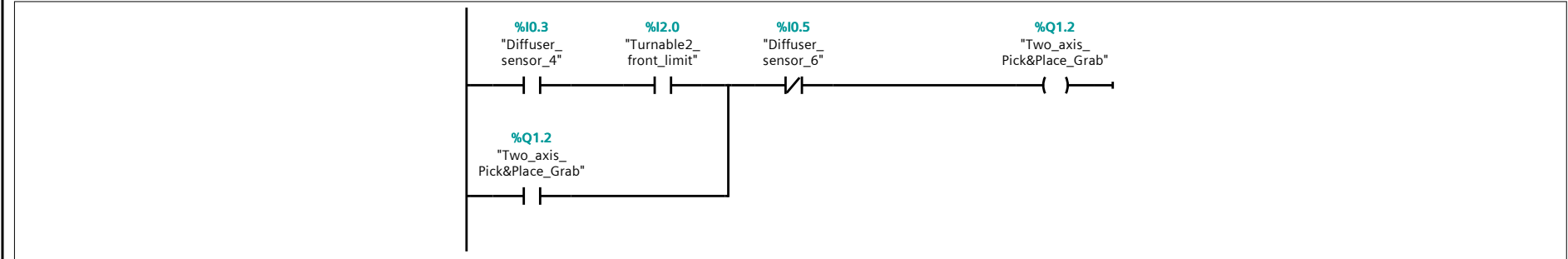
Symbol	Address	Type	Comment
"Tag_10"	%M1.0	Bool	
"Two_axis_Pick&Place_X"	%Q0.7	Bool	

Network 17: Two Axis Place (1) Motion in Z



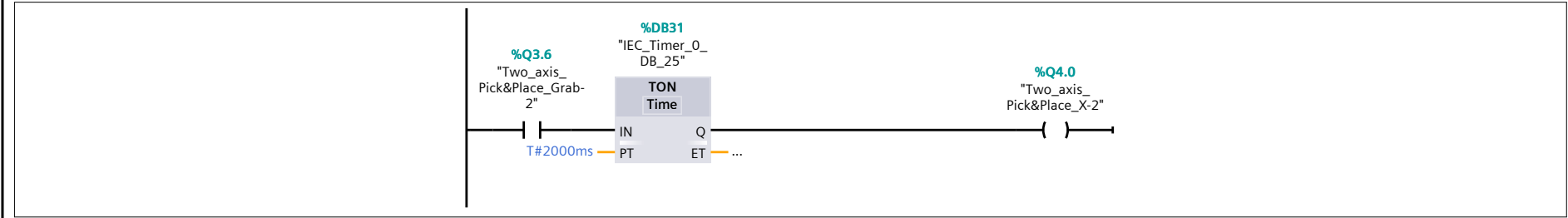
Symbol	Address	Type	Comment
"Diffuser_sensor_4"	%I0.3	Bool	
"Diffuser_sensor_6"	%I0.5	Bool	
"Tag_10"	%M1.0	Bool	
"Turnable2_front_limit"	%I2.0	Bool	
"Two_Axis_pick&place_detected"	%I2.2	Bool	
"Two_axis_Pick&Place_Z"	%Q1.1	Bool	

Network 18: Two Axis Place (1) Grabbing



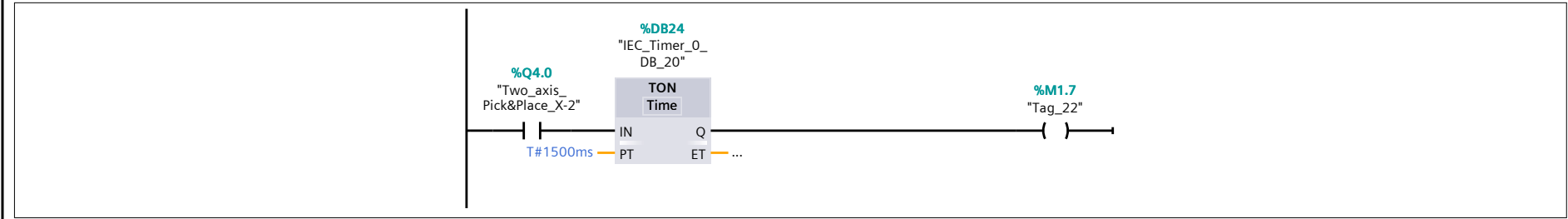
Symbol	Address	Type	Comment
"Diffuser_sensor_4"	%I0.3	Bool	
"Diffuser_sensor_6"	%I0.5	Bool	
"Turnable2_front_limit"	%I2.0	Bool	
"Two_axis_Pick&Place_Grab"	%Q1.2	Bool	

Network 19: Two Axis Place (2) Motion in X



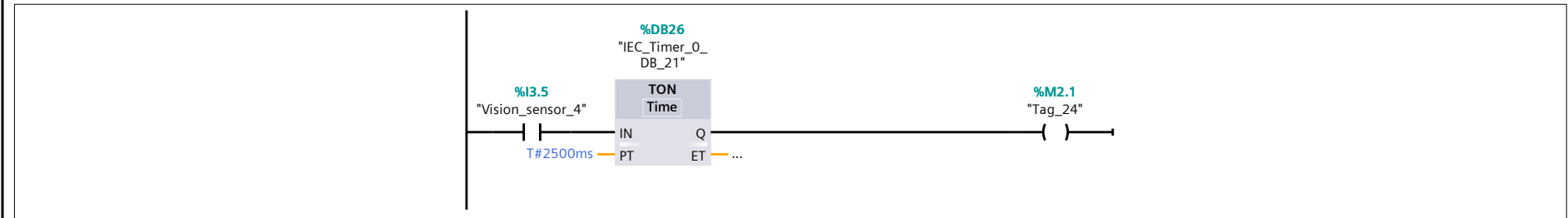
Symbol	Address	Type	Comment
"Two_axis_Pick&Place_Grab-2"	%Q3.6	Bool	
"Two_axis_Pick&Place_X-2"	%Q4.0	Bool	

Network 20:



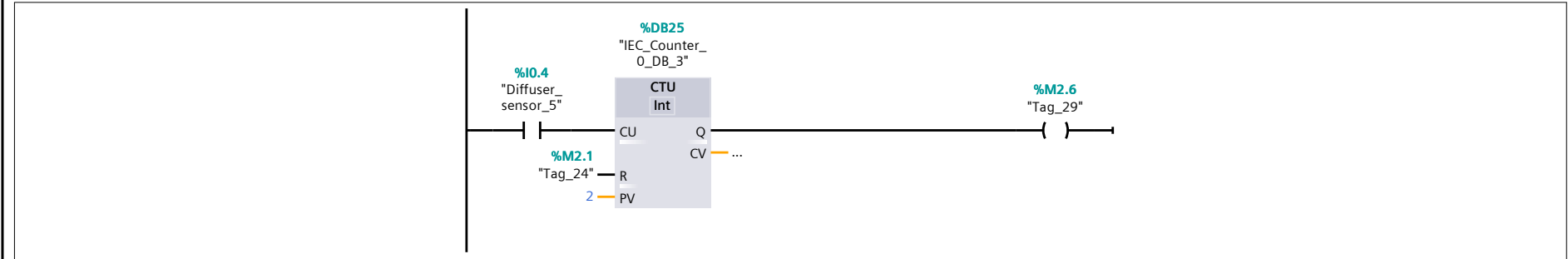
Symbol	Address	Type	Comment
"Tag_22"	%M1.7	Bool	
"Two_axis_Pick&Place_X-2"	%Q4.0	Bool	

Network 21: Two Axis Place (2) Motion in Z & Grabbing



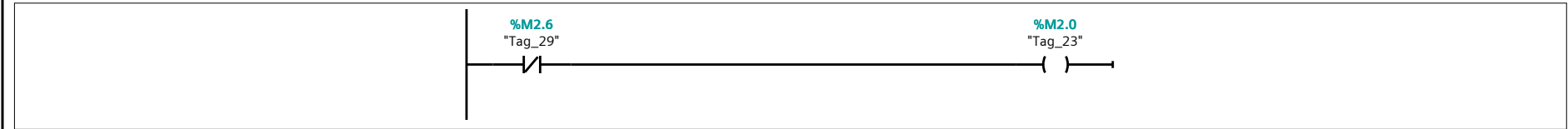
Symbol	Address	Type	Comment
"Tag_24"	%M2.1	Bool	
"Vision_sensor_4"	%I3.5	Bool	

Network 22: Two Axis Place (2) Motion in Z & Grabbing



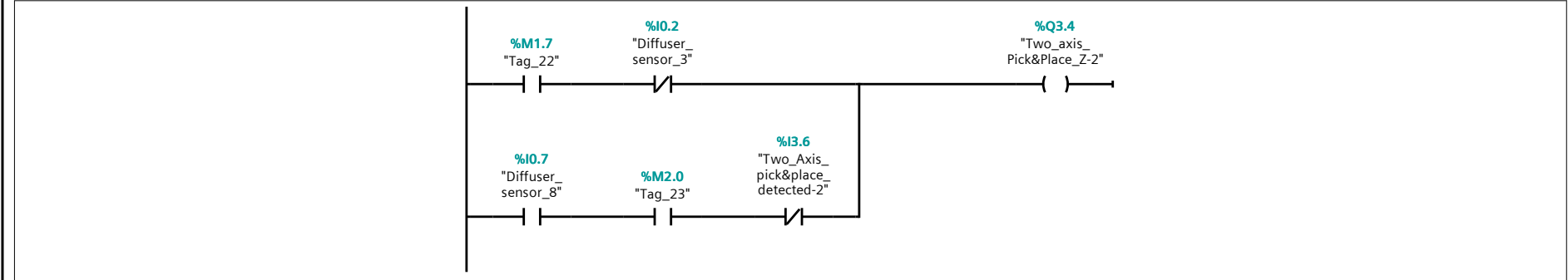
Symbol	Address	Type	Comment
"Diffuser_sensor_5"	%I0.4	Bool	
"Tag_24"	%M2.1	Bool	
"Tag_29"	%M2.6	Bool	

Network 23: Two Axis Place (2) Motion in Z & Grabbing



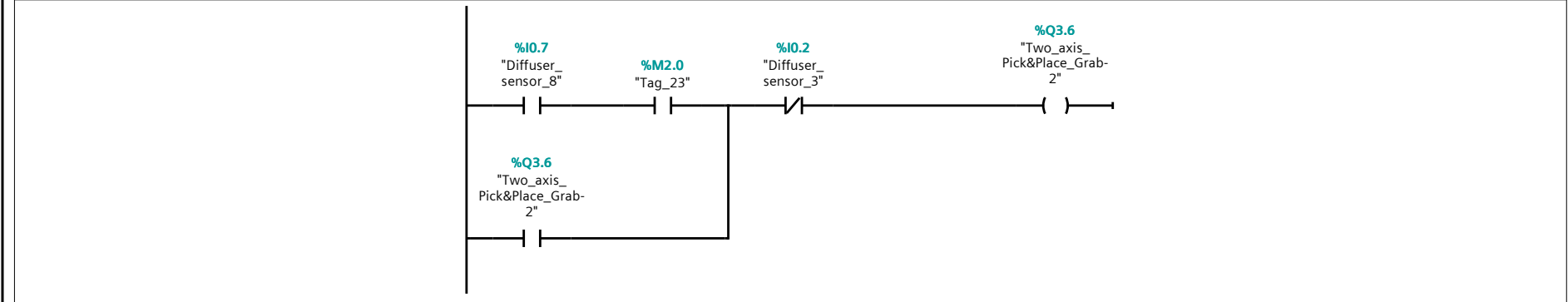
Symbol	Address	Type	Comment
"Tag_23"	%M2.0	Bool	
"Tag_29"	%M2.6	Bool	

Network 24: Two Axis Place (2) Motion in Z



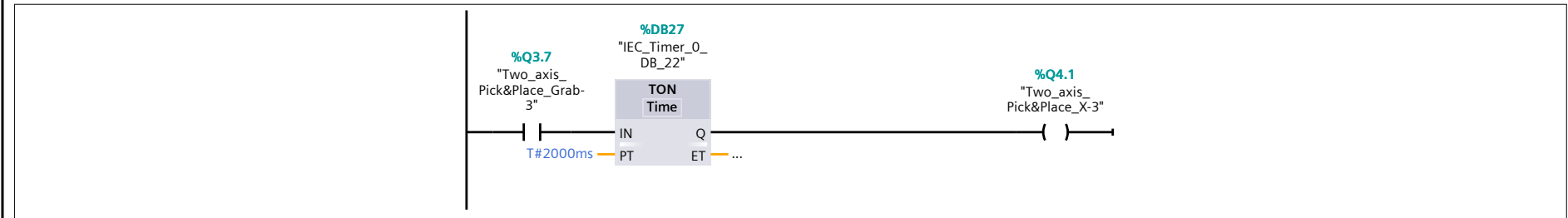
Symbol	Address	Type	Comment
"Diffuser_sensor_3"	%I0.2	Bool	
"Diffuser_sensor_8"	%I0.7	Bool	
"Tag_22"	%M1.7	Bool	
"Tag_23"	%M2.0	Bool	
"Two_Axis_pick&place_detected-2"	%I3.6	Bool	
"Two_axis_Pick&Place_Z-2"	%Q3.4	Bool	

Network 25: Two Axis Place (2) Grabbing



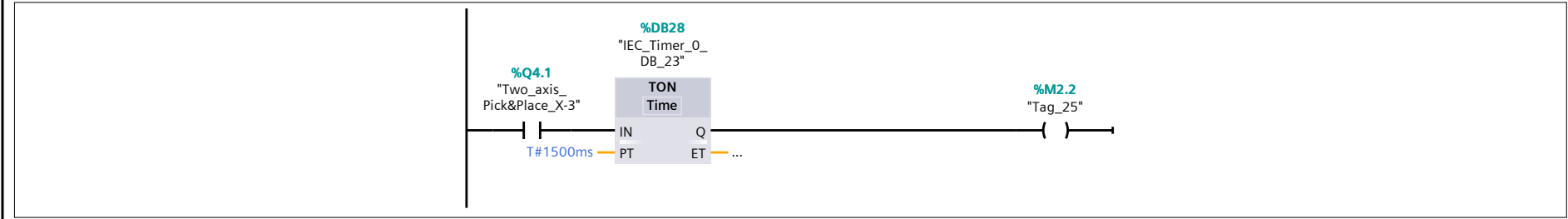
Symbol	Address	Type	Comment
"Diffuser_sensor_3"	%I0.2	Bool	
"Diffuser_sensor_8"	%I0.7	Bool	
"Tag_23"	%M2.0	Bool	
"Two_axis_Pick&Place_Grab-2"	%Q3.6	Bool	

Network 26: Two Axis Place (3) Motion in X



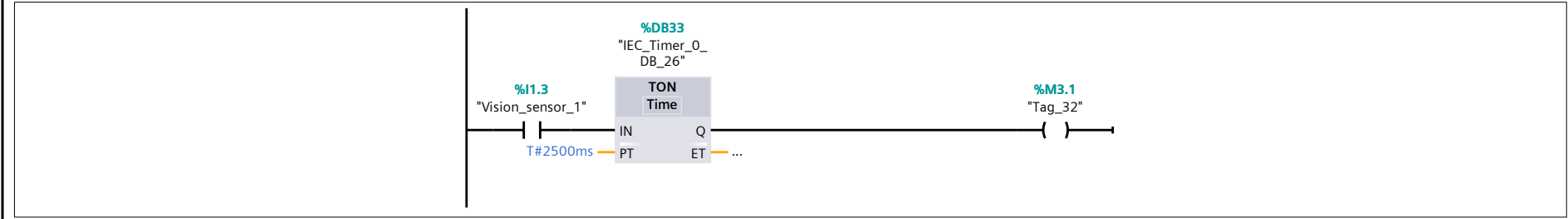
Symbol	Address	Type	Comment
"Two_axis_Pick&Place_Grab-3"	%Q3.7	Bool	
"Two_axis_Pick&Place_X-3"	%Q4.1	Bool	

Network 27: Two Axis Place (3) Motion in Z



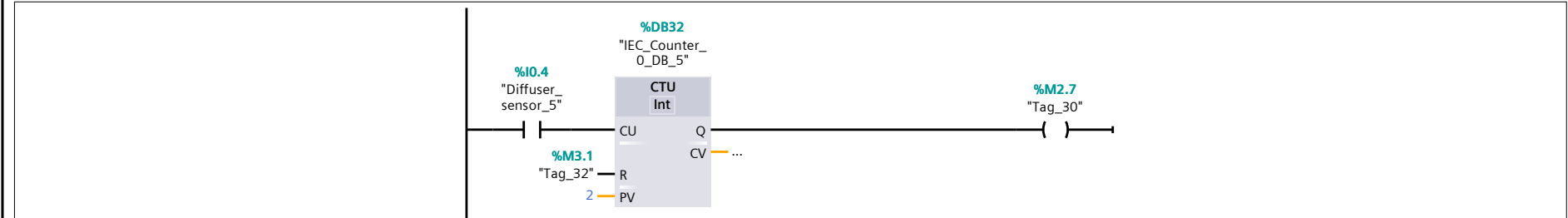
Symbol	Address	Type	Comment
"Tag_25"	%M2.2	Bool	
"Two_axis_Pick&Place_X-3"	%Q4.1	Bool	

Network 28: Two Axis Place (3) Motion in Z & Grabbing



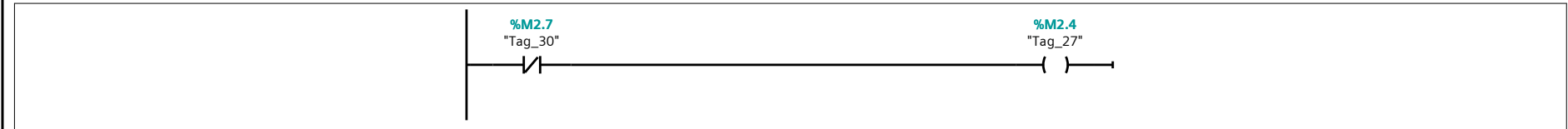
Symbol	Address	Type	Comment
"Tag_32"	%M3.1	Bool	
"Vision_sensor_1"	%I1.3	Bool	

Network 29: Two Axis Place (3) Motion in Z & Grabbing



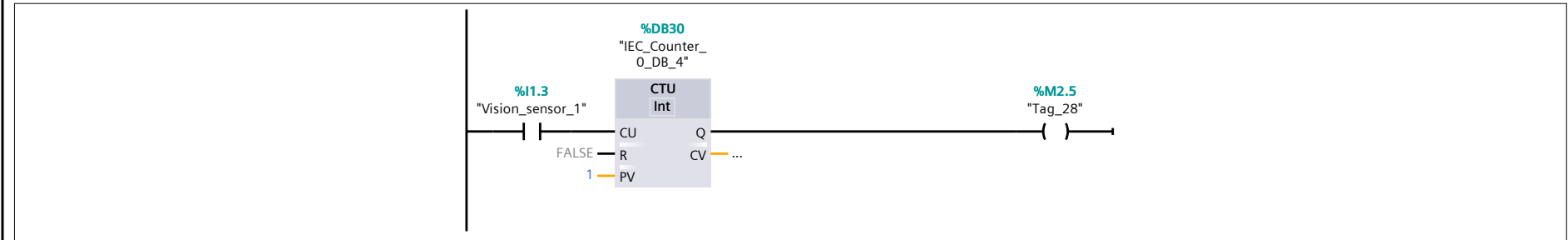
Symbol	Address	Type	Comment
"Diffuser_sensor_5"	%I0.4	Bool	
"Tag_30"	%M2.7	Bool	
"Tag_32"	%M3.1	Bool	

Network 30: Two Axis Place (3) Motion in Z & Grabbing



Symbol	Address	Type	Comment
"Tag_27"	%M2.4	Bool	
"Tag_30"	%M2.7	Bool	

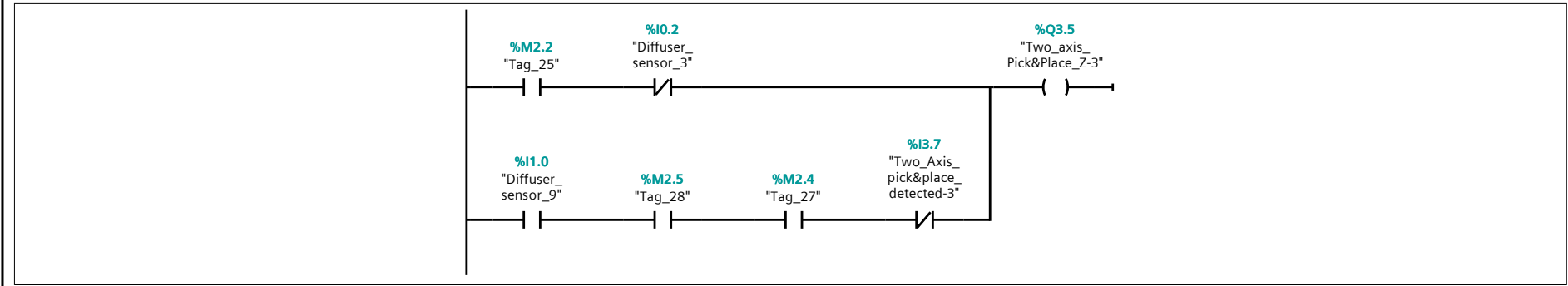
Network 31: Two Axis Place (2) Motion in Z & Grabbing



Symbol	Address	Type	Comment
"Tag_28"	%M2.5	Bool	

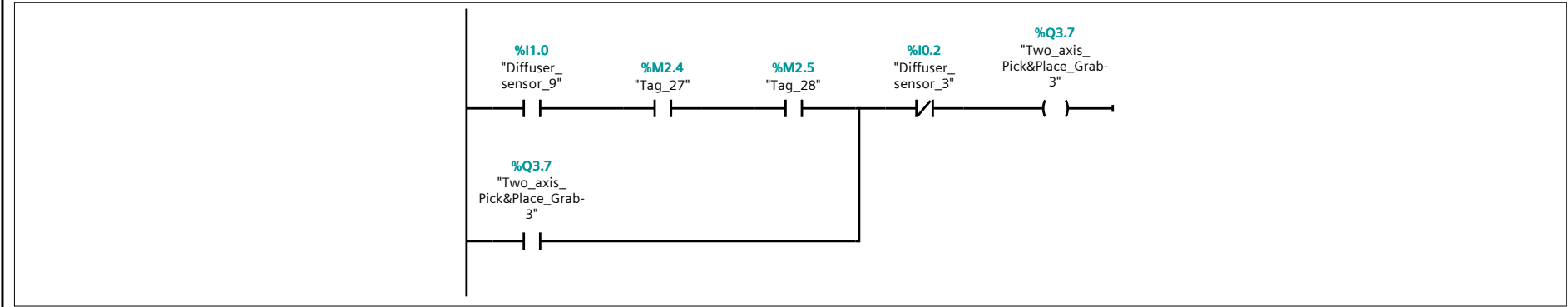
Symbol	Address	Type	Comment
"Vision_sensor_1"	%I1.3	Bool	

Network 32:



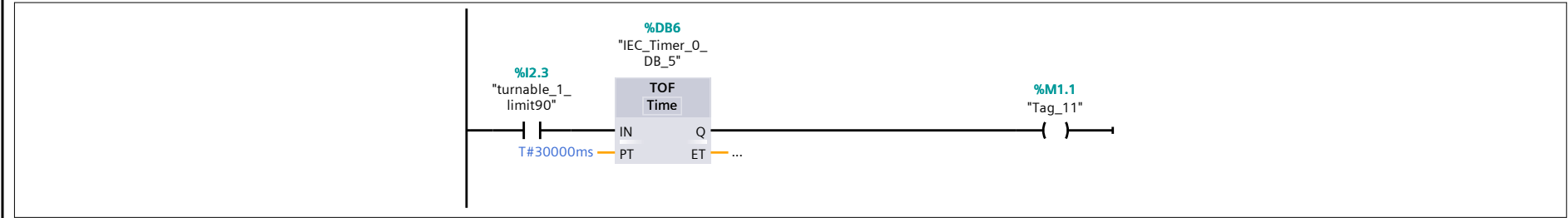
Symbol	Address	Type	Comment
"Diffuser_sensor_3"	%I0.2	Bool	
"Diffuser_sensor_9"	%I1.0	Bool	
"Tag_25"	%M2.2	Bool	
"Tag_27"	%M2.4	Bool	
"Tag_28"	%M2.5	Bool	
"Two_Axis_pick&place_detected-3"	%I3.7	Bool	
"Two_axis_Pick&Place_Z-3"	%Q3.5	Bool	

Network 33: Two Axis Place (3) Grabbing



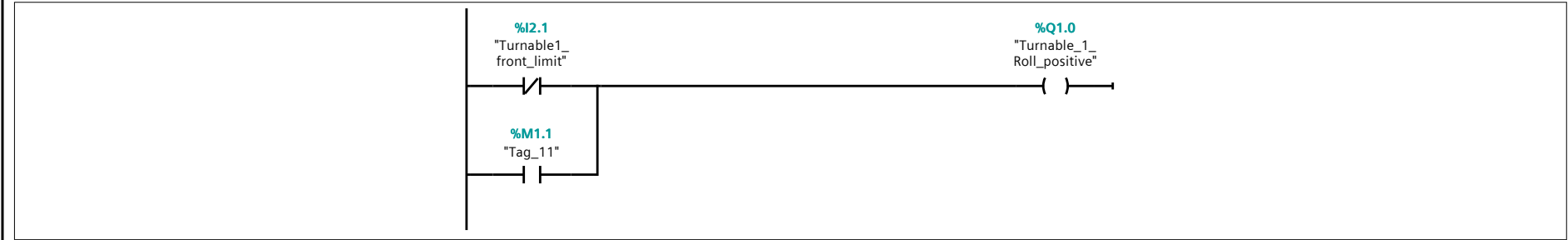
Symbol	Address	Type	Comment
"Diffuser_sensor_3"	%I0.2	Bool	
"Diffuser_sensor_9"	%I1.0	Bool	
"Tag_27"	%M2.4	Bool	
"Tag_28"	%M2.5	Bool	
"Two_axis_Pick&Place_Grab-3"	%Q3.7	Bool	

Network 34: Turnable 1 Roll (+)



Symbol	Address	Type	Comment
"Tag_11"	%M1.1	Bool	
"turnable_1_limit90"	%I2.3	Bool	

Network 35: Turnable 1 Roll (+)



Symbol	Address	Type	Comment
"Tag_11"	%M1.1	Bool	
"Turnable1_front_limit"	%I2.1	Bool	
"Turnable_1_Roll_positive"	%Q1.0	Bool	

Network 36: Turnable 1 Turn





Network 42: Turnable 2 Roll (+)

%I2.0  
"Turnable2\_ front\_limit"

%Q1.6  
"Turnable\_2\_ roll\_negative"

%Q2.2  
"Turnable\_2\_ roll\_positive"

Symbol	Address	Type	Comment
"Turnable2_ front_limit"	%I2.0	Bool	
"Turnable_2_ roll_negative"	%Q1.6	Bool	
"Turnable_2_ roll_positive"	%Q2.2	Bool	

Network 43: Emitter 3

%I0.2  
"Diffuser\_ sensor\_3"

%I0.1  
"Diffuser\_ sensor\_2"

%DB21  
"IEC\_Counter\_ 0\_DB\_2"

CTU  
Int

CU

Q

CV

...

R

PV

2

%M3.0  
"Tag\_31"

Symbol	Address	Type	Comment
"Diffuser_sensor_2"	%I0.1	Bool	
"Diffuser_sensor_3"	%I0.2	Bool	
"Tag_31"	%M3.0	Bool	

Network 44: Emitter 3

%I0.2  
"Diffuser\_ sensor\_3"

%M3.0  
"Tag\_31"

%DB13  
"IEC\_Timer\_0\_ DB\_12"

TOF  
Time

IN

Q

PT

ET

...

T#13500ms

%M0.7  
"Tag\_9"

Symbol	Address	Type	Comment
"Diffuser_sensor_3"	%I0.2	Bool	
"Tag_9"	%M0.7	Bool	
"Tag_31"	%M3.0	Bool	

Network 45: Emitter 3

%M0.7  
"Tag\_9"

%DB12  
"IEC\_Timer\_0\_ DB\_11"

TON  
Time

IN

Q

PT

ET

...

T#9500ms

%Q1.7  
"Emitter\_3"

Symbol	Address	Type	Comment
"Emitter_3"	%Q1.7	Bool	
"Tag_9"	%M0.7	Bool	

Network 46: Turnable 2 Turn

%I1.3  
"Vision\_sensor\_1"

%I3.5  
"Vision\_sensor\_4"

%DB14  
"IEC\_Timer\_0\_ DB\_13"

TON  
Time

IN

Q

PT

ET

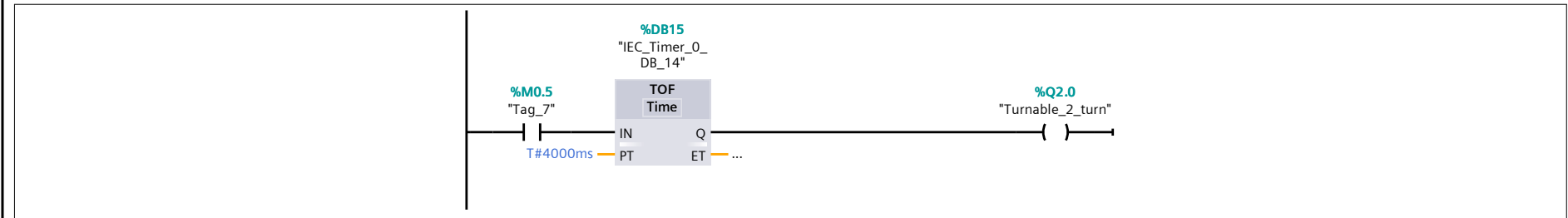
...

T#3000ms

%M0.5  
"Tag\_7"

Symbol	Address	Type	Comment
"Tag_7"	%M0.5	Bool	
"Vision_sensor_1"	%I1.3	Bool	
"Vision_sensor_4"	%I3.5	Bool	

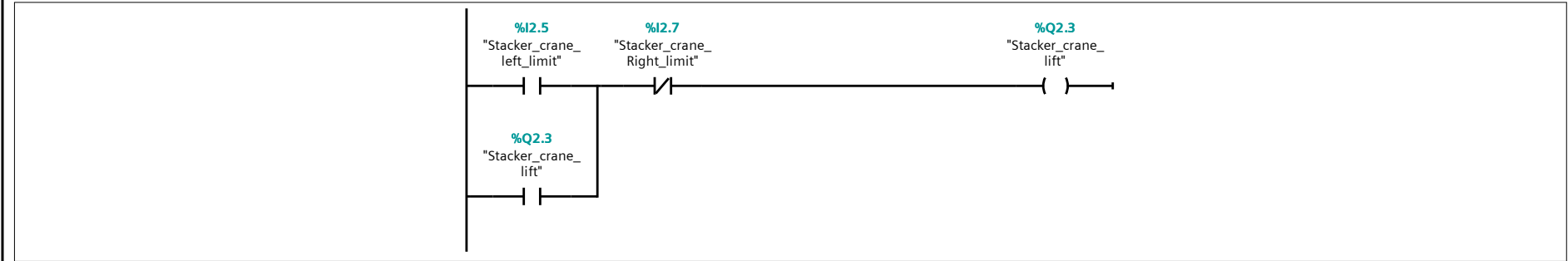
Network 47: Turnable 2 Turn



Symbol	Address	Type	Comment
"Tag_7"	%M0.5	Bool	
"Turnable_2_turn"	%Q2.0	Bool	

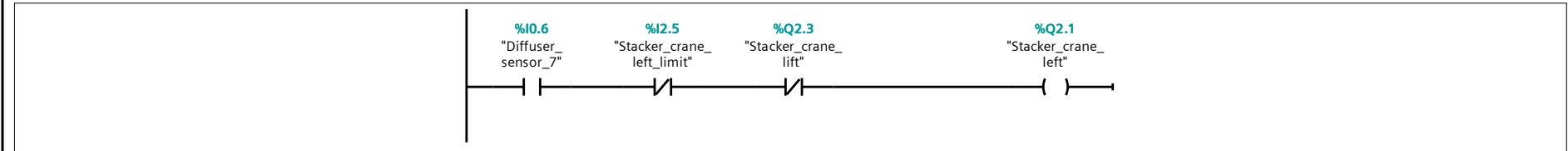
Network 48: Stacker Crane lift

crane beginning



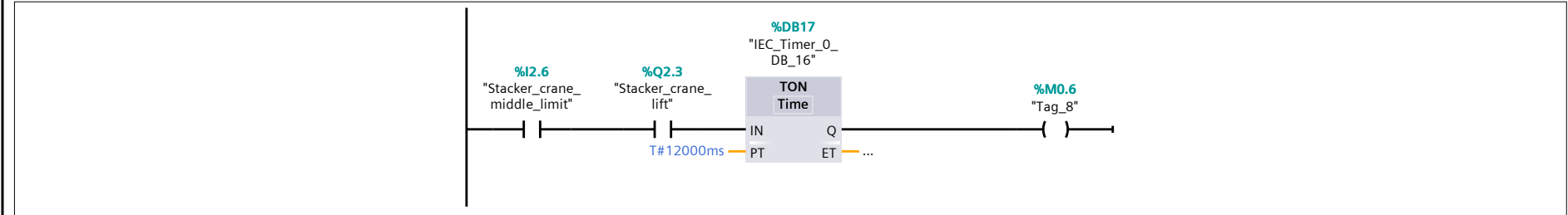
Symbol	Address	Type	Comment
"Stacker_crane_left_limit"	%I2.5	Bool	
"Stacker_crane_lift"	%Q2.3	Bool	
"Stacker_crane_Right_limit"	%I2.7	Bool	

Network 49: Stacker Crane left



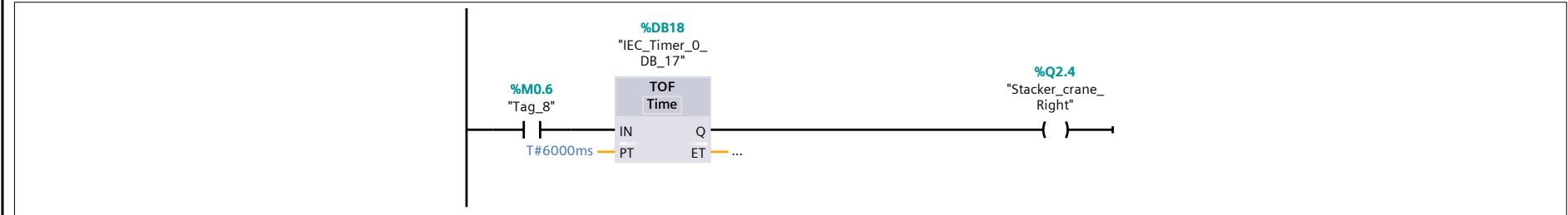
Symbol	Address	Type	Comment
"Diffuser_sensor_7"	%I0.6	Bool	
"Stacker_crane_left"	%Q2.1	Bool	
"Stacker_crane_left_limit"	%I2.5	Bool	
"Stacker_crane_lift"	%Q2.3	Bool	

Network 50: Stacker Crane Right



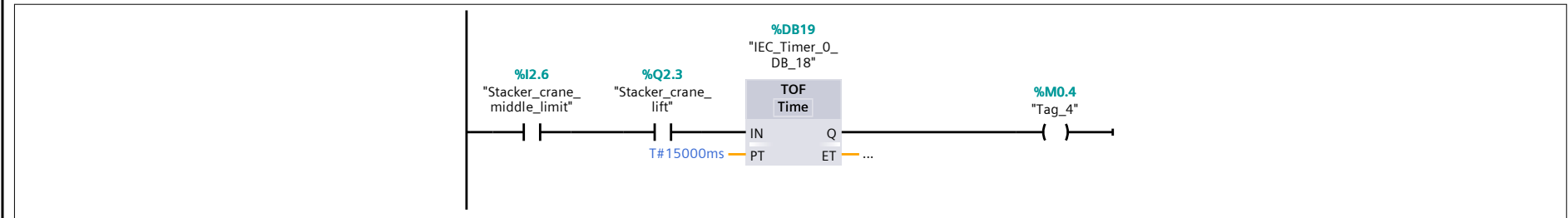
Symbol	Address	Type	Comment
"Stacker_crane_lift"	%Q2.3	Bool	
"Stacker_crane_middle_limit"	%I2.6	Bool	
"Tag_8"	%M0.6	Bool	

Network 51: Stacker Crane Right



Symbol	Address	Type	Comment
"Stacker_crane_Right"	%Q2.4	Bool	
"Tag_8"	%M0.6	Bool	

Network 52: Stacker Crane Position



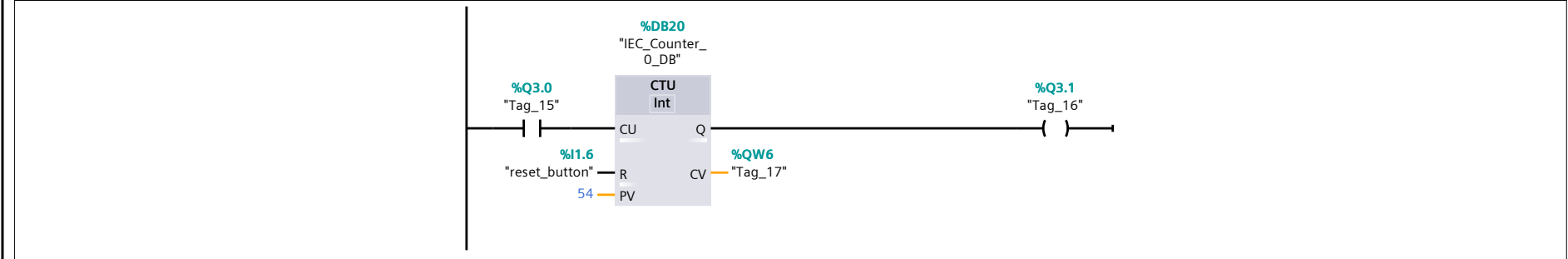
Symbol	Address	Type	Comment
"Stacker_crane_lift"	%Q2.3	Bool	
"Stacker_crane_middle_limit"	%I2.6	Bool	
"Tag_4"	%M0.4	Bool	

Network 53: Stacker Crane Position



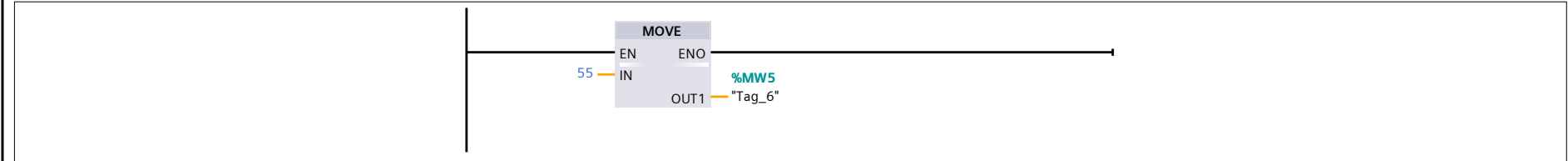
Symbol	Address	Type	Comment
"Diffuser_sensor_7"	%I0.6	Bool	
"Tag_15"	%Q3.0	Bool	

Network 54: Stacker Crane Position Counter



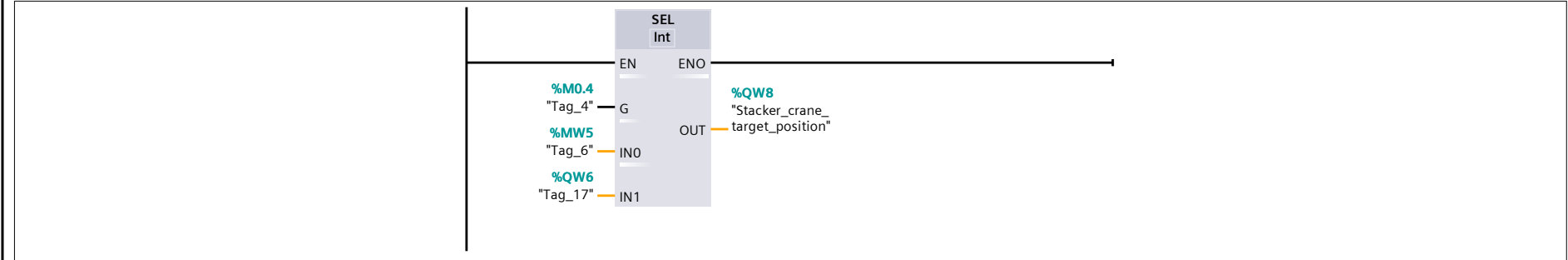
Symbol	Address	Type	Comment
"reset_button"	%I1.6	Bool	
"Tag_15"	%Q3.0	Bool	
"Tag_16"	%Q3.1	Bool	
"Tag_17"	%QW6	Int	

Network 55: Stacker Crane Position



Symbol	Address	Type	Comment
"Tag_6"	%MW5	Int	

Network 56: Stacker Crane Position



Symbol	Address	Type	Comment
"Stacker_crane_target_position"	%QW8	Int	
"Tag_4"	%M0.4	Bool	
"Tag_6"	%MW5	Int	
"Tag_17"	%QW6	Int	