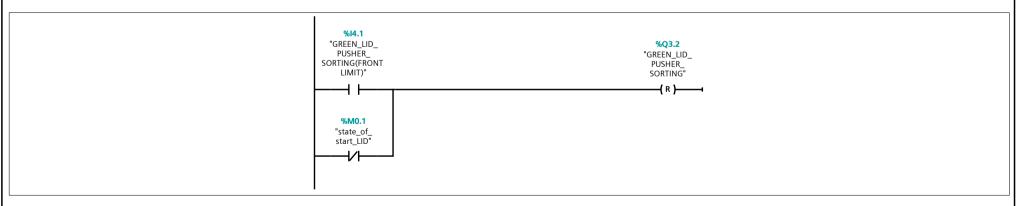
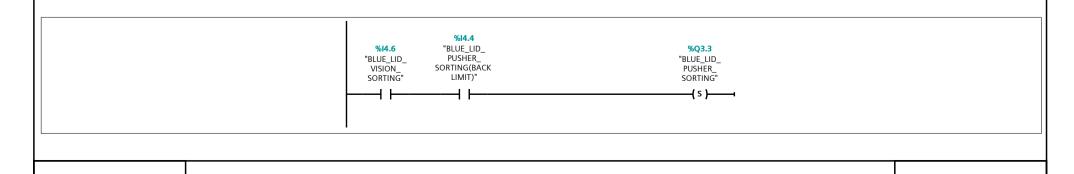
Automation	ortal										
Proiect / F	PLC_2 [CPU 3	19-3 PN/D	P1 / Proc	ıram blocks							
	 NG_STATION [F			,							
	TATION Properties										
General											
lame	LID_SORTING_STATIO	Numbe	3		Туре	F	В		L	anguage	LAD
Numbering nformation	Automatic										
itle		Author			Comr	nent			F	amily	
/ersion	0.1	User-de	fined ID								
.ID_SORTING_S	TATION										
Name		Data type	Offset	Default value		Accessible from HMI/OPC UA	able	HMI engi-	Setpoint	Supervi- sion	Comment
Input											
Output											
InOut											
Static											
Temp Constant											
	EGIN SORTING CO		%I4.5  "BEGIN_ SORTING_ STATION_LIC	"SCOVY <b>%M0.1</b> "state of	6DB10 DRTING_ ER_TIMER'' TOF Time  Q ET	<b>-</b>	"(	%M2.7 Conv_sorting_ set_lid"			
letwork 2:											
			%M2.7 "Conv_sortin set_lid"	%M0.1 g_ "state_of_ start_LID"				%Q3.1 "SORTING_ ONVYER_LID"			
			1								

## Network 4: GREEN PUSHER SORTING RETURN



## **Network 5: BLUE PUSHER SORTING PUSH**



Totally Integrated Automation Portal				
Network 6: BLUE_PU	SHER_SORTING_RETURN			•
		%I4.3  "BLUE_LID_ PUSHER_ SORTING(FRONT LIMIT)"  %M0.1  "state_of_ start_LID"	%Q3.3  "BLUE_LID_ PUSHER_ SORTING"  (R)	
Network 7: green lid	if blue			
		%Q3.2 "GREEN_LID_ PUSHER_ SORTING"	%Q6.1 "green lid sorting light"	
Network 8: blue lid	·			
		%Q3.3 "BLUE_LID_ PUSHER_ SORTING"	%Q6.0  "blue lid sorting light"	