Totally Integrated Automation Portal

Project / PLC_2 [CPU 319-3 PN/DP] / Program blocks

LID_execess_remove_station [FB4]

LID_execess_remove_station Properties									
General									
Name	LID_execess_remove_station	Number	4	Type	FB	Language	LAD		
Numbering	Automatic								
Information									
Title		Author		Comment		Family			
Version	0.1	User-defined ID							

LID_execess_remove_station									
Name	Data type	Offset	Default value	Accessible from HMI/OPC UA	able	HMI engi-	Setpoint	Supervi- sion	Comment
Input									
Output									
InOut									
Static									
Temp									
Constant									

Network 1: LID_BELT_EXECESS_CONVYR_HANDLER

```
%IO.5

"LID_machining_ entrance_ sensor" state_of_ start_LID"

WM0.1

Time

WQ2.2

"lid_belt_ convyer_excess"

WM1.1

"CNC_lid_empty"

"LID_machining_ wM0.1

"State_of_ start_LID"

Time

Time

CONVYER_EXCESS"

"EC_Timer_O_
DB.4"

WQ2.2

"lid_belt_ convyer_excess"

"IN Q T#500ms PT ET ...
```

Network 2: COUNTING NO OF BLUE MATERIAL OF EXECCES

```
%B4

"IEC_Counter_
O_DB"

%A12.6

"Blue_vision_lid"

CU
Q
CV
...

%M1.2

"ARE WE
THERE_YET
BLUE_lid"

BLUE_lid"

()

*M3.5

"LID_COUNTER
RESET_BUTTON_
BLUE"

R

5 — PV
```

Network 3: PUSH_FORWARD_EXECS_BLUE

Network 4: PUSH_RETURN_EXECESS_BLUE

Totally Integrated **Automation Portal** %M1.2 "ARE_WE_ THERE_YET_ BLUE_lid" %13.0 %Q2.3 "front_blue_ push_lid" "push_excess_ blue_lid" -(R)-%I3.5

"LID_COUNTER_
RESET_BUTTON_
BLUE" %M0.1 "state_of_ start_LID" **Network 5: COUNTING NO OF GREEN MATERIAL** %DB9
"IEC_Counter_
0_DB_1" **%M1.3**"ARE_WE_
THERE_YET_
GREEN_lid" CTU %I2.7 "green_vision_lid" Int CU CV — ... %I4.0

"LID_COUNTER_
RESET_BUTTON_
GREEN" 5 — PV Network 6: PUSH_FORWARD_EXECS_GREEN **%M1.3**"ARE_WE_
THERE_YET_
GREEN_lid" %13.3 %Q2.4 "back_green_ push_lid" "push_excess_ green_lid" **%I2.7** "green_vision_lid" %DB8 "IEC_Timer_0_ DB_6" %Q3.0 "TO_STORAGE_ GREEN_ CONVYER_lid" TOF Time - IN Q-T#3S — PT ET Network 7: PUSH_RETURN_GREEN "ARE_WE_ THERE_YET_ GREEN_lid" **%I3.2** %Q2.4 "front_green_ push_lid" "push_excess_ green_lid" **-(** R **)**-%I4.0

"LID_COUNTER_
RESET_BUTTON_
GREEN" %M0.1 "state_of_ start_LID" Network 8: light blue if reached **%M1.2**"ARE_WE_
THERE_YET_
BLUE_lid" %Q5.4 "excess blue lid raw led light" Network 9: light green if reached

Totally Integrated Automation Portal				
	%M1.3 "ARE_WE_ THERE_YET_ GREEN_lid"	"e	%Q5.5 xcess green lid raw led light"	
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