

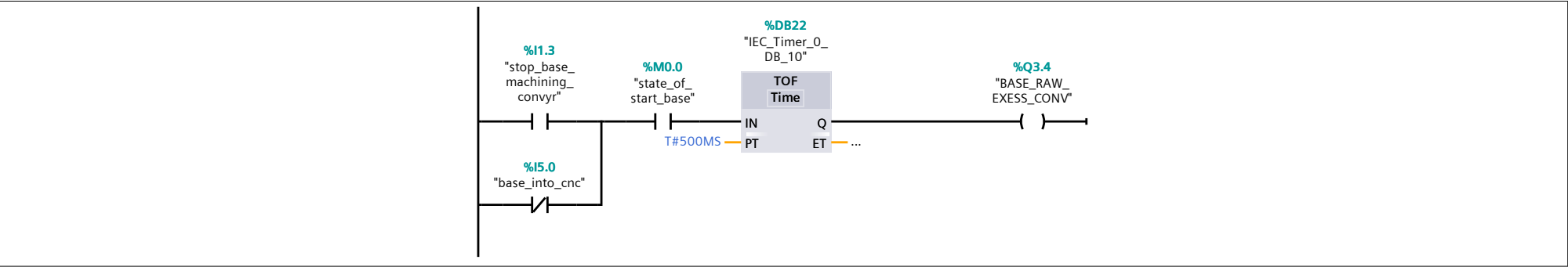
Project / PLC\_2 [CPU 319-3 PN/DP] / Program blocks

BASE\_execess\_remove\_station [FB7]

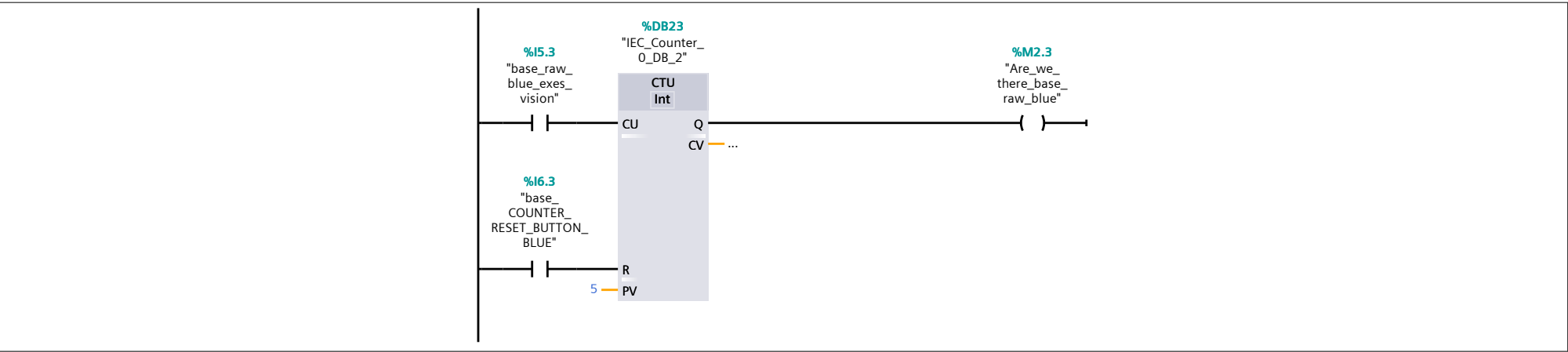
BASE_execess_remove_station Properties							
General							
Name	BASE_execess_remove_station	Number	7	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

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

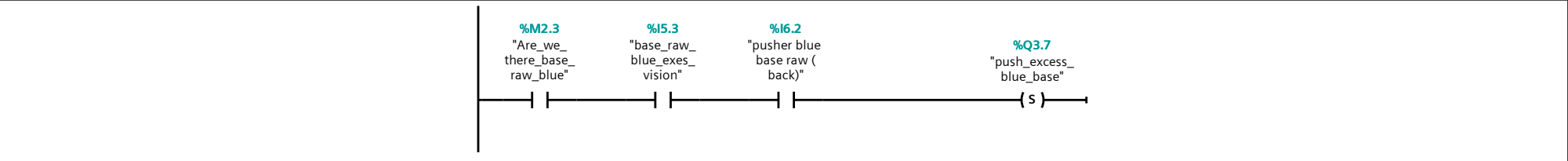
Network 1: LID\_BELT\_EXECESS\_CONVYR\_HANDLER



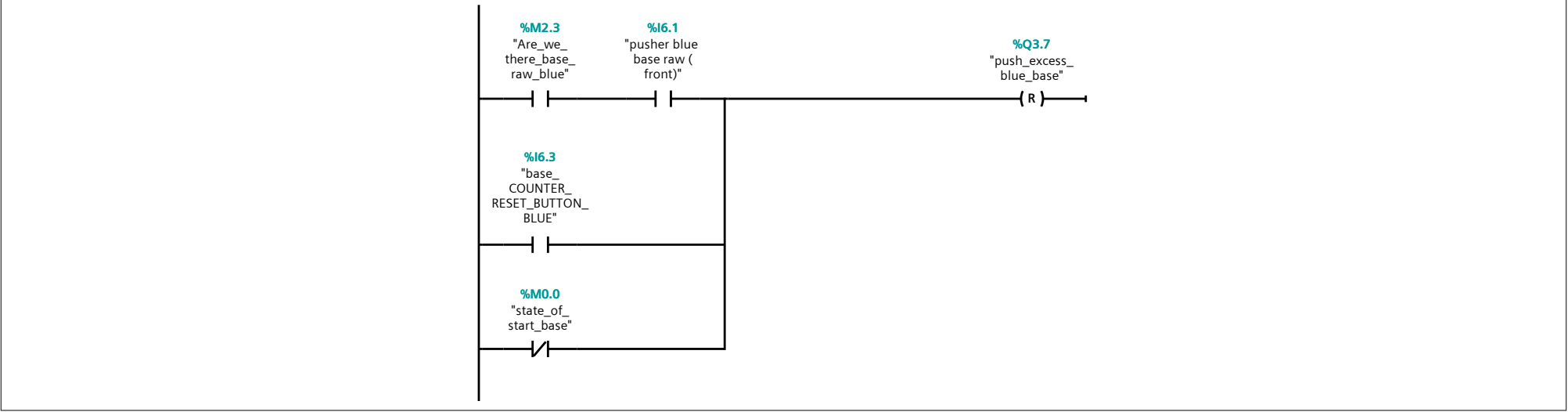
Network 2: COUNTING NO OF BLUE MATERIAL OF EXECCES



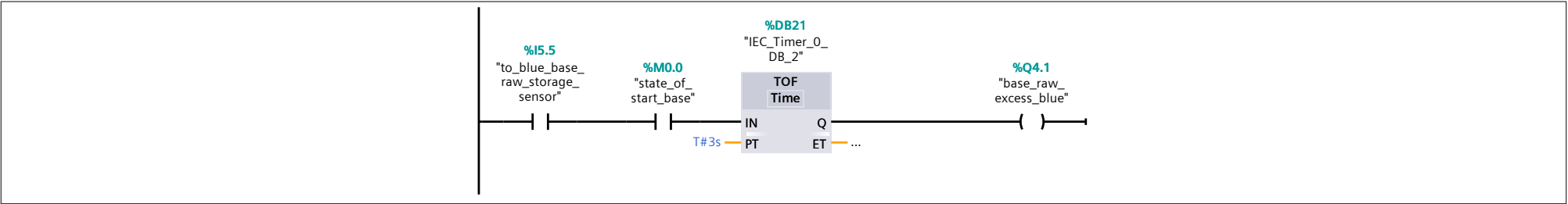
Network 3: PUSH\_FORWARD\_EXECS\_BLUE



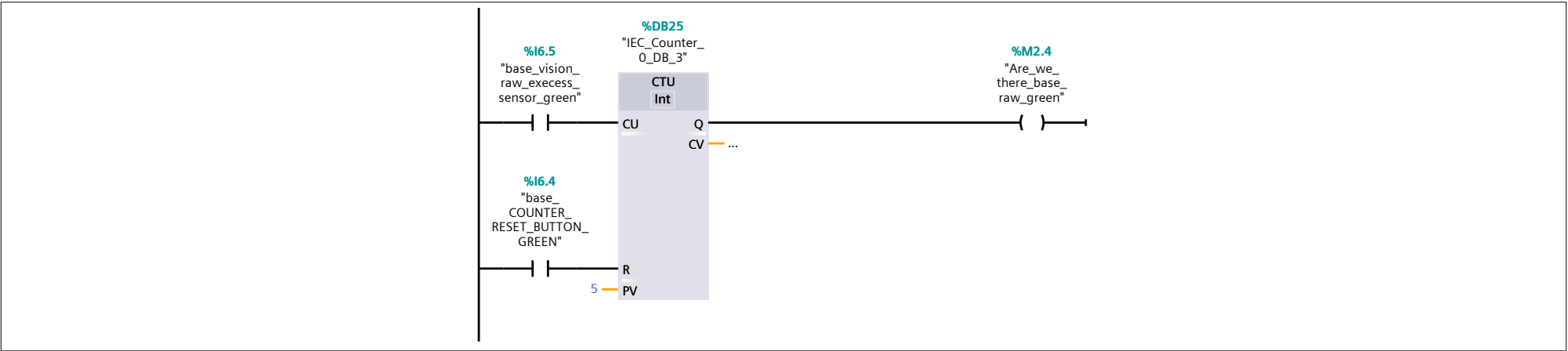
Network 4: PUSH\_RETURN\_EXECESS\_BLUE



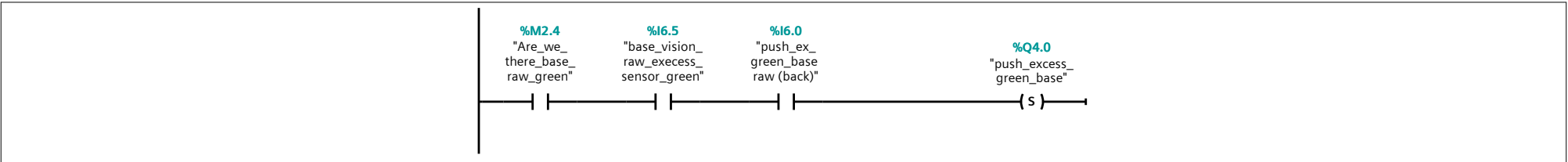
Network 5: RETURN\_EXECESS\_BLUE\_TO\_STORAGE



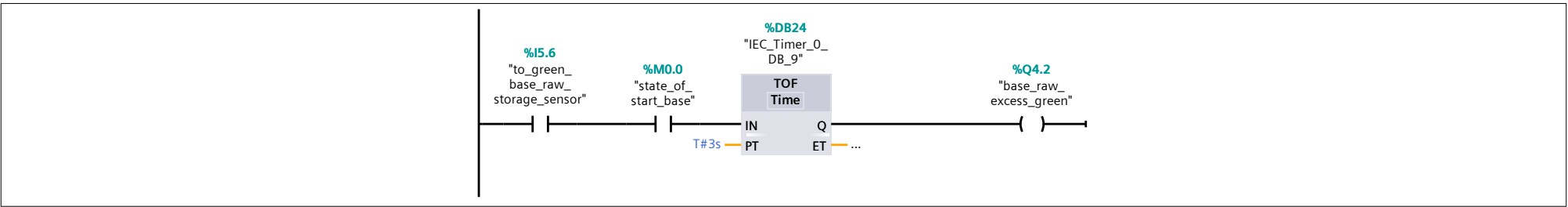
Network 6: COUNTING NO OF GREEN MATERIAL



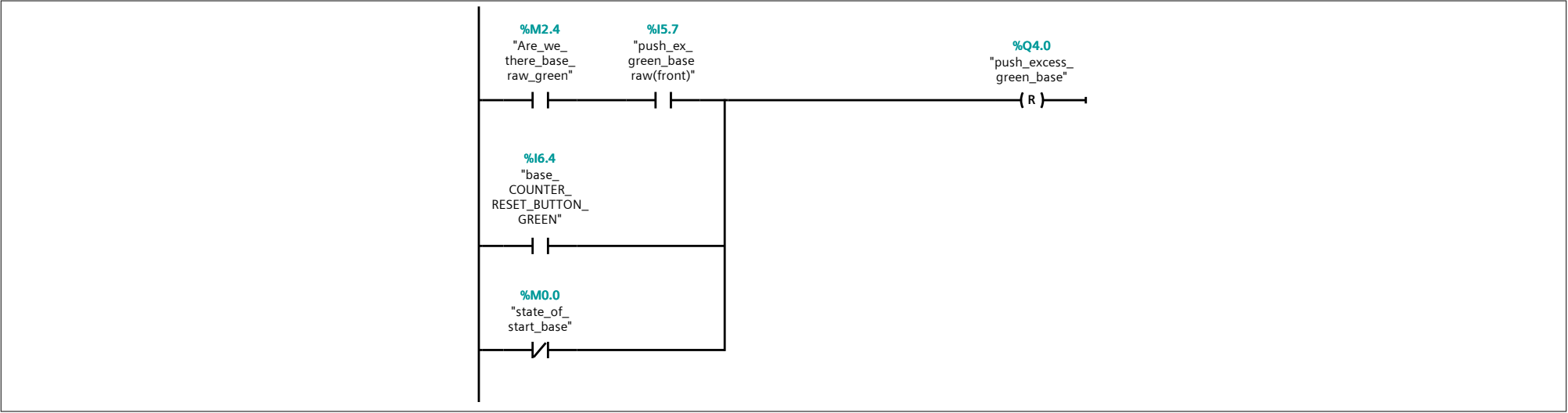
Network 7: PUSH\_FORWARD\_EXECS\_GREEN



Network 8: RETURN\_EXECESS\_GREEN\_TO\_STORAGE



Network 9: PUSH\_RETURN\_GREEN



Network 10: excess blue light



Network 11:

