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

base_production_fb [FB5]

base_production_fb Properties								
General								
Name	base_production_fb	Number	5	Type	FB	Language	LAD
Numbering	Automatic							
Information								
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

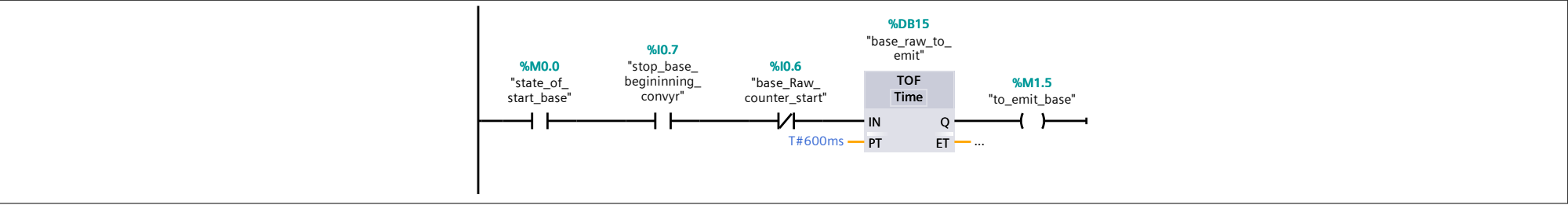| base_production_fb									
Name	Data type	Offset	Default value	Accessible from HMI/OPC UA	Writable from HMI/ OPC UA	Visible in HMI engi-neering	Setpoint	Supervi-sion	Comment
Input									
Output									
InOut									
Static									
Temp									
Constant									

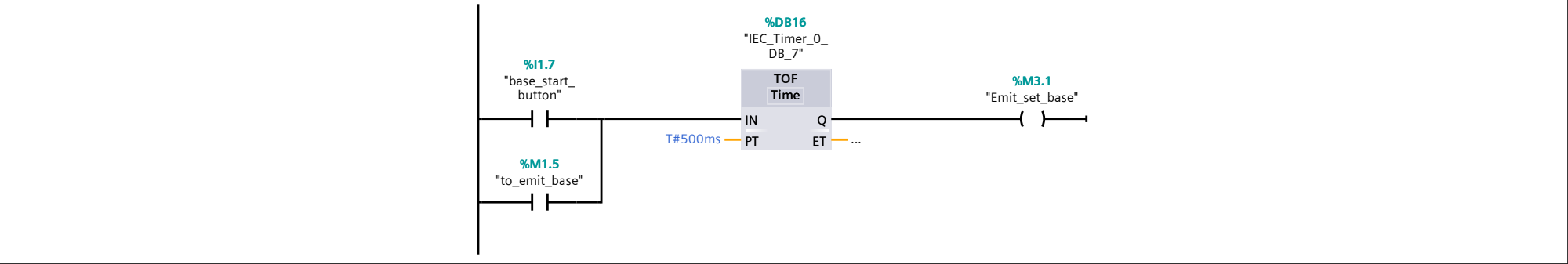**Network 1: base_production_station**
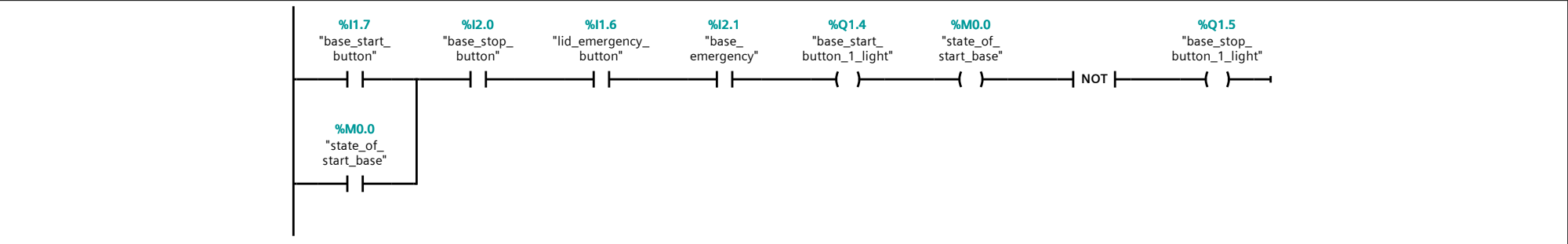
Network 2: base_begin_convyer
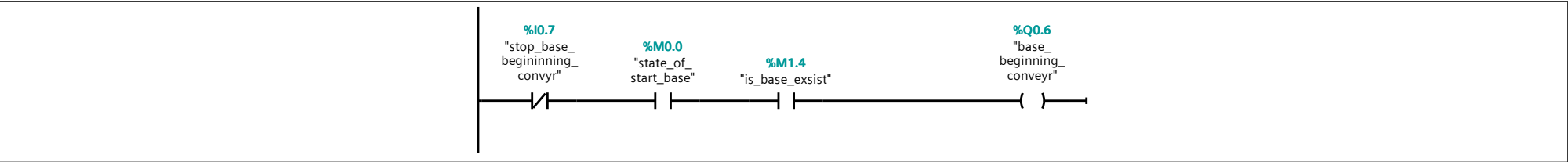
Network 3: emit_base_handler

Network 4: emitting_base

Network 5: Emit emergency handle base

Network 6: FEEDING_CONVYER_HANDLER_BASE

```
        %M1.4           %M0.0          %M1.4                   %Q0.7
     "is_base_exsist"  "state_of_     "is_base_exsist"      "base_raw_
                        start_base"                          feeding_
                                                             conveyr"
         ┤ ├─────┬─────── ┤ ├────────── ┤ ├──────────────────( )──
               |
        %Q0.7  |
     "base_raw_|
      feeding_ |
      conveyr" |
         ┤ ├───┘
```
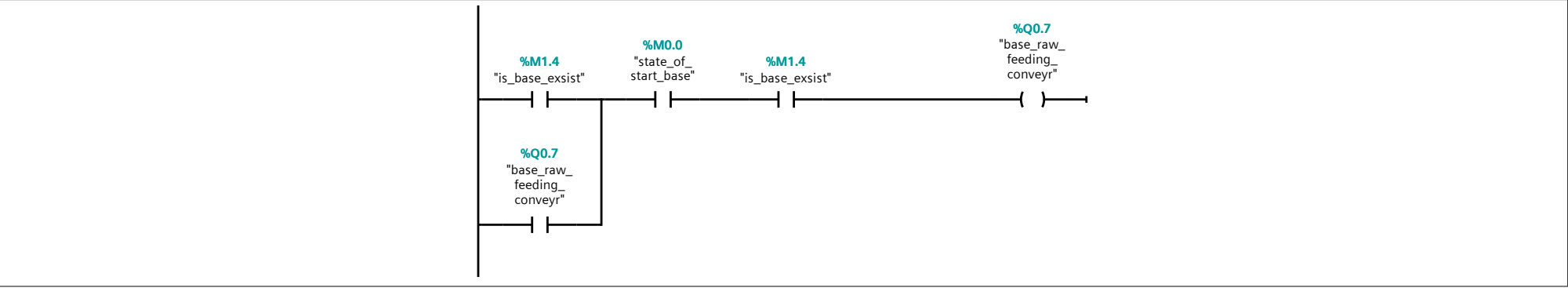
Network 7: base_machinning_handle

```
        %M1.4           %M0.0          %M1.4                   %Q1.0
     "is_base_exsist"  "state_of_     "is_base_exsist"      "base_to_
                        start_base"                          machinning_
                                                             conveyr"
         ┤ ├─────┬─────── ┤ ├────────── ┤ ├──────────────────( )──
               |
        %Q1.0  |
     "base_to_ |
      machinning_|
      conveyr" |
         ┤ ├───┘
```
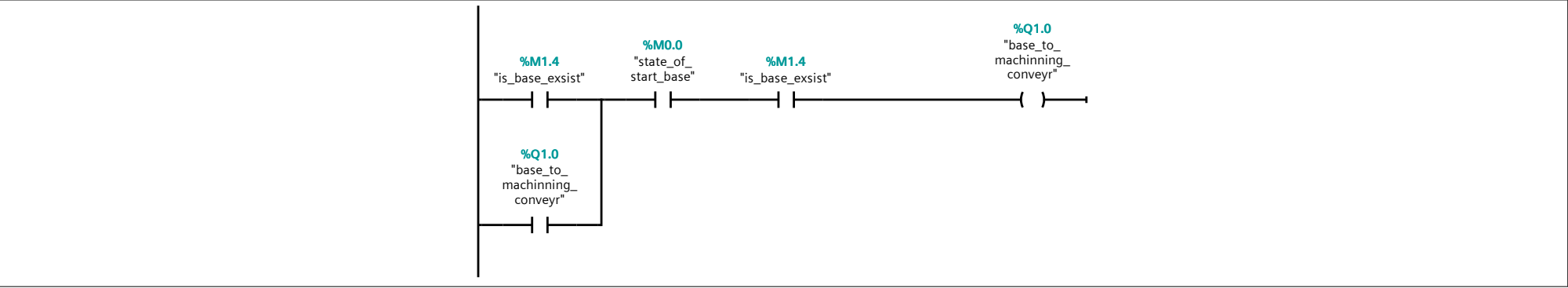
Network 8: base_raw_into_cnc

```
                              %DB18
                           "IEC_Timer_0_
                              DB_8"
        %I5.0               ┌──TOF──┐                        %M1.4
    "base_into_cnc"         │  Time │                     "is_base_exsist"
         ┤/├────────────────┤IN    Q├──────────────────────( )──
                   T#500ms ─┤PT   ET├─ ...
                            └───────┘
```
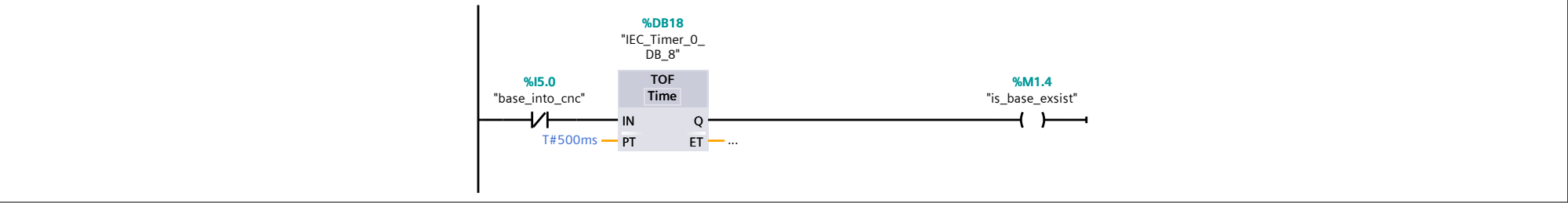
Network 9: BASE_KEEP_DISTANCE

```
        %M1.4          %Q4.4                               %Q4.5
     "is_base_exsist"  "Stop_blade4"                     "Stop_blade5"
         ┤/├──────────( )─────────────────────────────────( )──
```

Network 10: base_excess

```
                          %DB26
                       "BASE_execess_
                       remove_station_
                            DB"
                          %FB7
                 "BASE_execess_remove_station"
              ─┤EN                        ENO├──────────
```

Network 11: CNC_BASE

```
        %M1.4                                            %Q4.3
     "is_base_exsist"                                 "MachineCenter2
                                                       _base_start"
         ┤/├──────────────────────────────────────────( )──
```
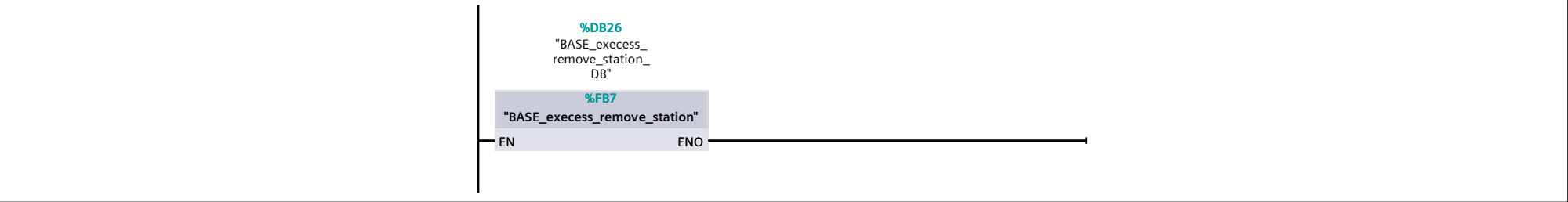
Network 12: pick_and_place_base

```
                          %DB20
                        "PICK_UP_
                       BASE_ROBOT_
                          DB_1"
                          %FB6
                   "PICK_UP_BASE_ROBOT"
              ─┤EN                        ENO├──────────
```

Network 13: Base sorting

```
                                    %DB28
                              "BASE_SORTING_
                                STATION_DB"
                                    %FB8
                            "BASE_SORTING_STATION"
                         EN                    ENO
```