

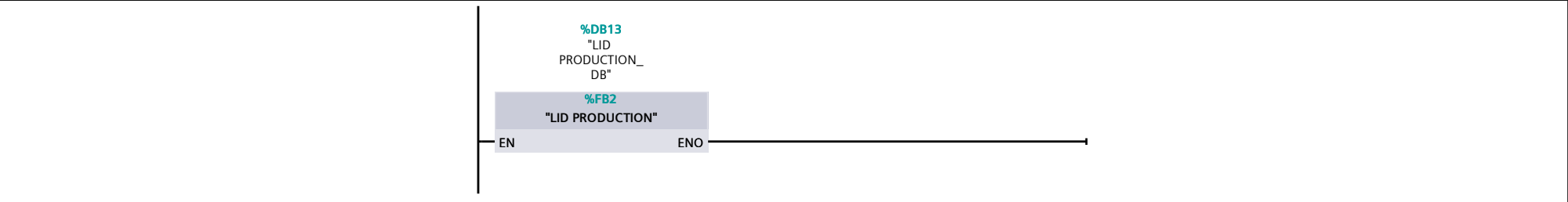
Project / PLC\_2 [CPU 319-3 PN/DP] / Program blocks

Main [OB1]

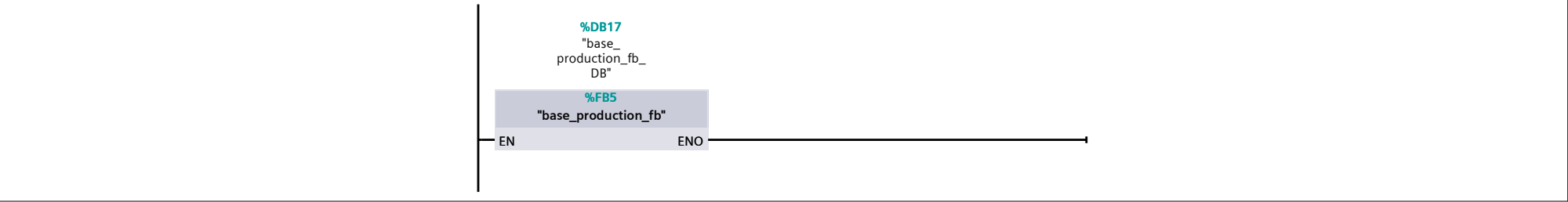
Main Properties							
General							
Name	Main	Number	1	Type	OB	Language	LAD
Numbering	Manual						
Information							
Title	"Main Program Sweep (Cycle)"	Author		Comment		Family	
Version	0.1	User-defined ID					

Main				
Name	Data type	Offset	Default value	Comment
▼ Temp				
OB1_EV_CLASS	Byte	0.0		Bits 0-3 = 1 (Coming event), Bits 4-7 = 1 (Event class 1)
OB1_SCAN_1	Byte	1.0		1 (Cold restart scan 1 of OB 1), 3 (Scan 2-n of OB 1)
OB1_PRIORITY	Byte	2.0		Priority of OB Execution
OB1_OB_NUMBR	Byte	3.0		1 (Organization block 1, OB1)
OB1_RESERVED_1	Byte	4.0		Reserved for system
OB1_RESERVED_2	Byte	5.0		Reserved for system
OB1_PREV_CYCLE	Int	6.0		Cycle time of previous OB1 scan (milliseconds)
OB1_MIN_CYCLE	Int	8.0		Minimum cycle time of OB1 (milliseconds)
OB1_MAX_CYCLE	Int	10.0		Maximum cycle time of OB1 (milliseconds)
OB1_DATE_TIME	Date_And_Time	12.0		Date and time OB1 started
Constant				

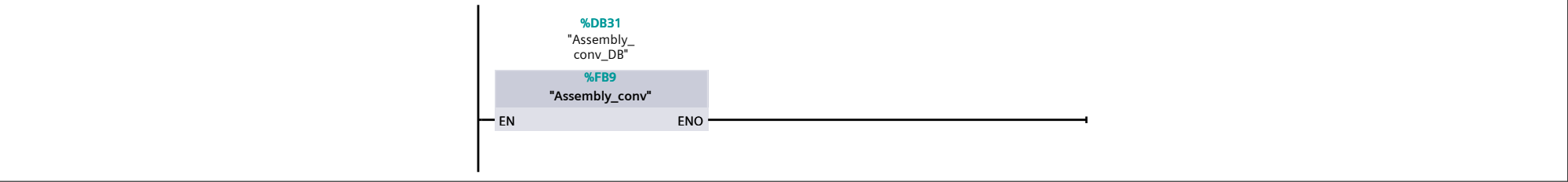
Network 1: LID\_PRODUCTION\_STATION



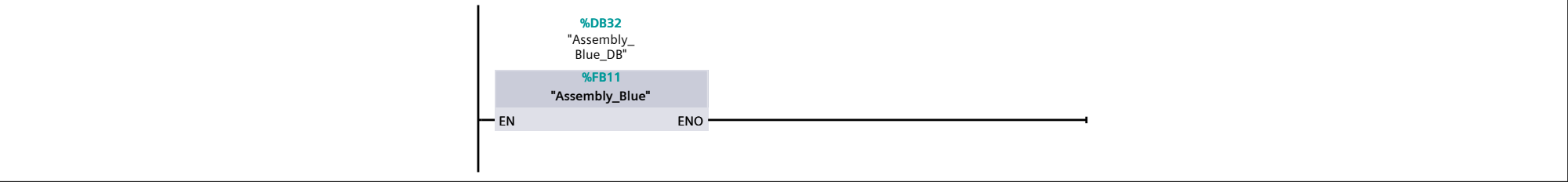
Network 2: BASE\_PRODUCTION\_STATION



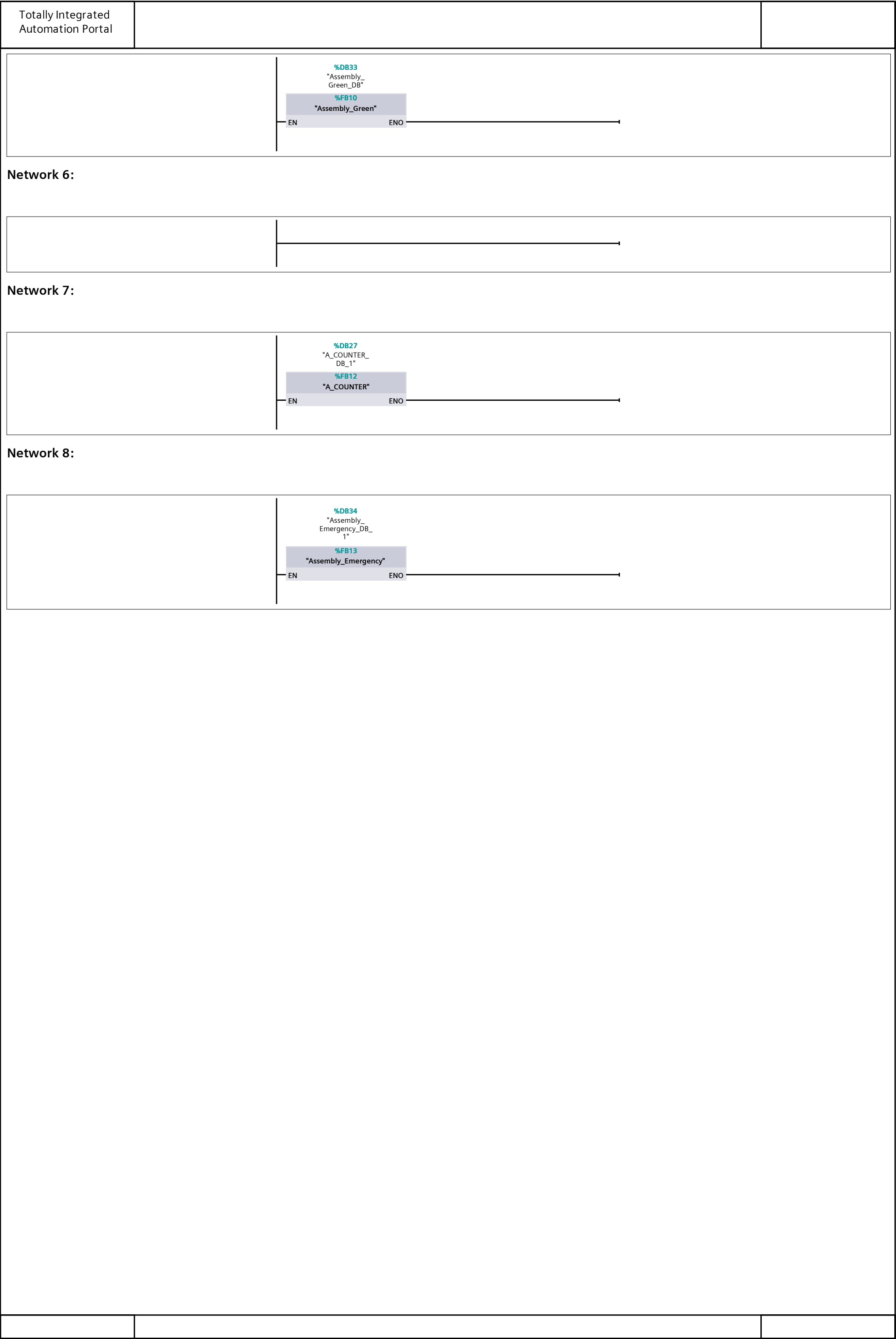
Network 3: Assembly\_conv



Network 4: Assembly\_Blue



Network 5: Assembly\_Green



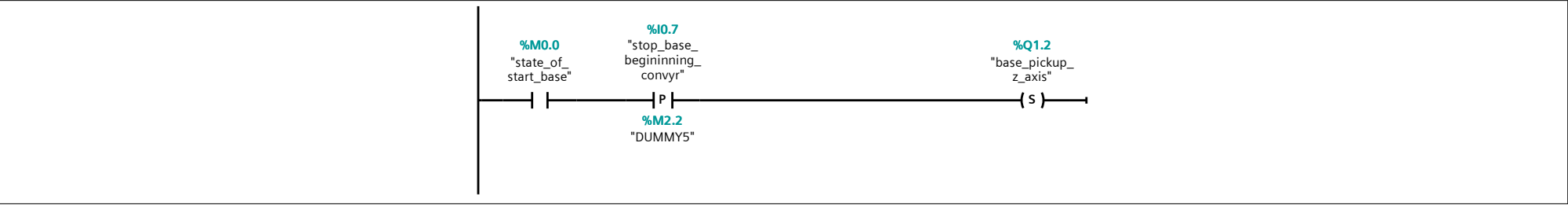
Project / PLC\_2 [CPU 319-3 PN/DP] / Program blocks

PICK\_UP\_BASE\_ROBOT [FB6]

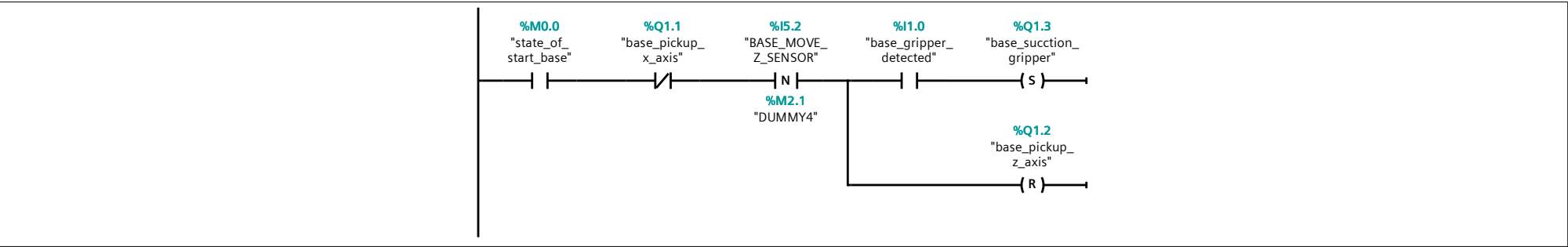
PICK_UP_BASE_ROBOT Properties							
General							
Name	PICK_UP_BASE_ROBOT	Number	6	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

PICK_UP_BASE_ROBOT										
Name	Data type	Offset	Default value	Accessible from HMI/OPC UA	Writable from HMI/OPC UA	Visible in HMI engineering	Setpoint	Supervision	Comment	
Input										
Output										
InOut										
Static										
Temp										
Constant										

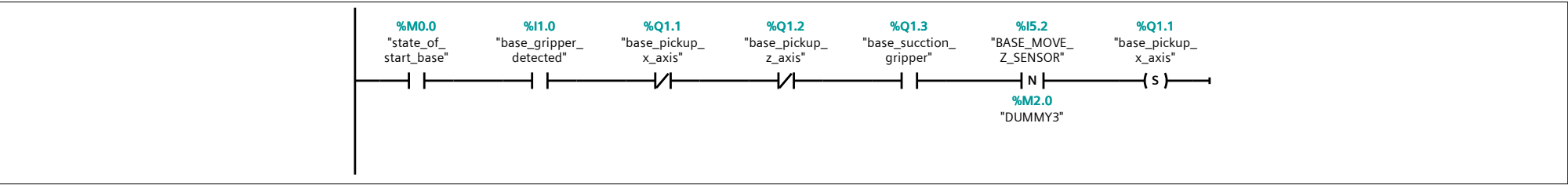
Network 1: BASE\_PICKUP\_ROBOT\_LOWERING\_Z\_AXIS



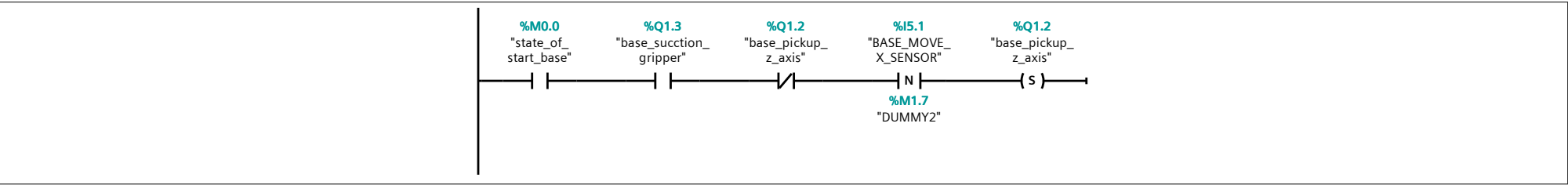
Network 2: BASE\_PICKUP\_OPERATE\_SUCCTION



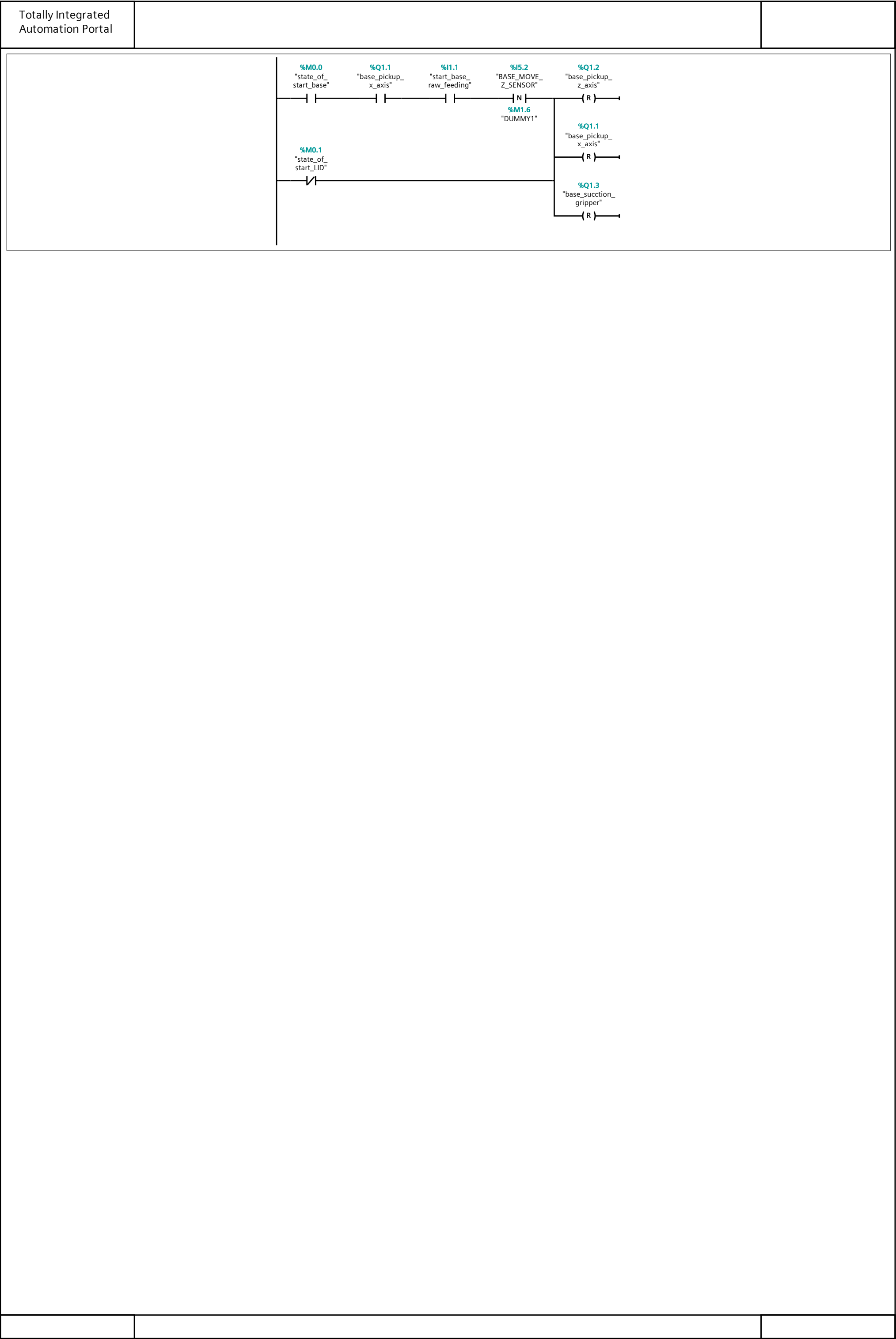
Network 3: PICK\_UP\_BASE\_GO\_TO\_FEEDING



Network 4: LID\_PICK\_UP\_LOWERING\_Z\_AXIS\_IN\_FEEDING



Network 5: LID\_RETURN\_TO\_ORIGIN\_PICKUP



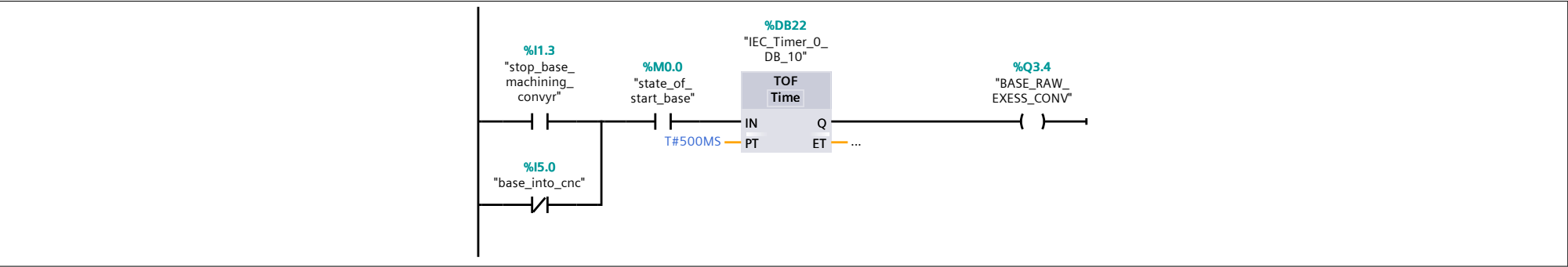
Project / PLC\_2 [CPU 319-3 PN/DP] / Program blocks

BASE\_execess\_remove\_station [FB7]

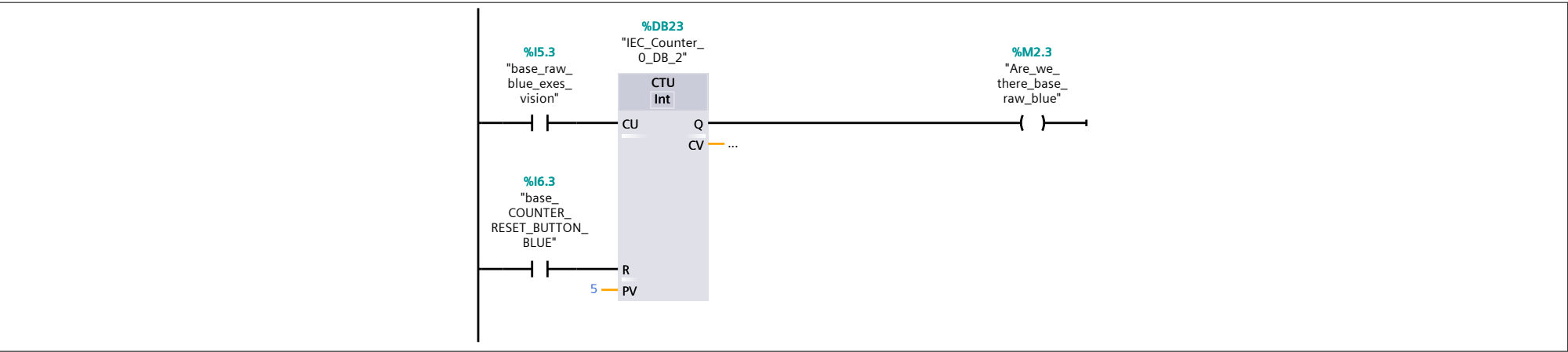
BASE_execess_remove_station Properties							
General							
Name	BASE_execess_remove_station	Number	7	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

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										

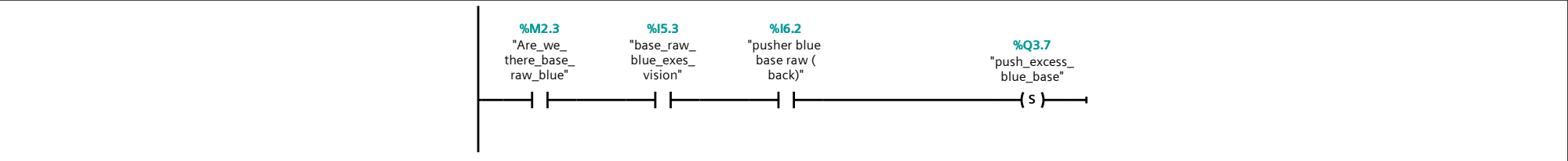
Network 1: LID\_BELT\_EXECESS\_CONVYR\_HANDLER



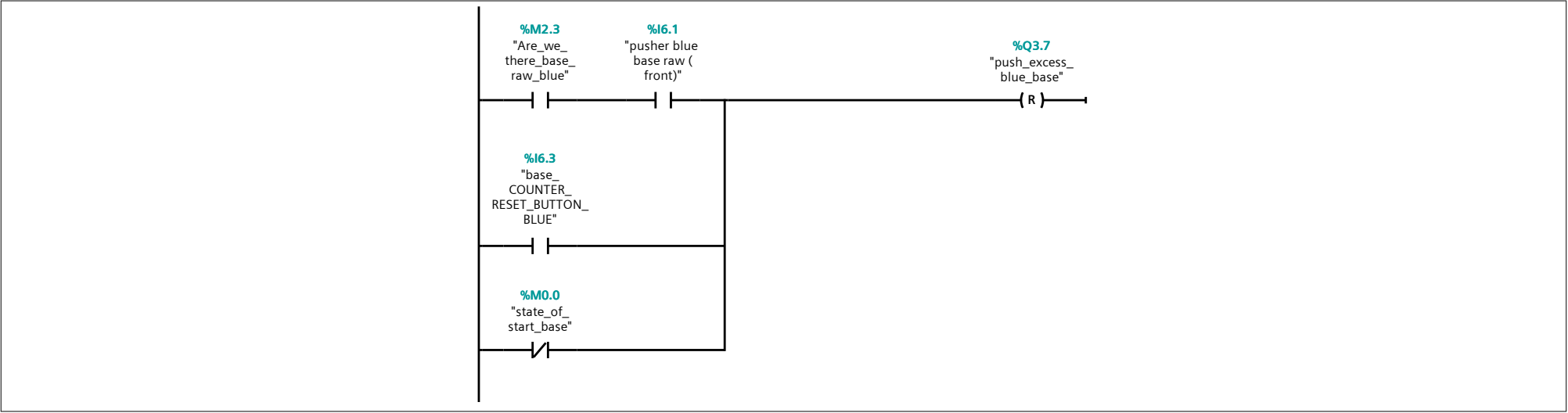
Network 2: COUNTING NO OF BLUE MATERIAL OF EXECCES



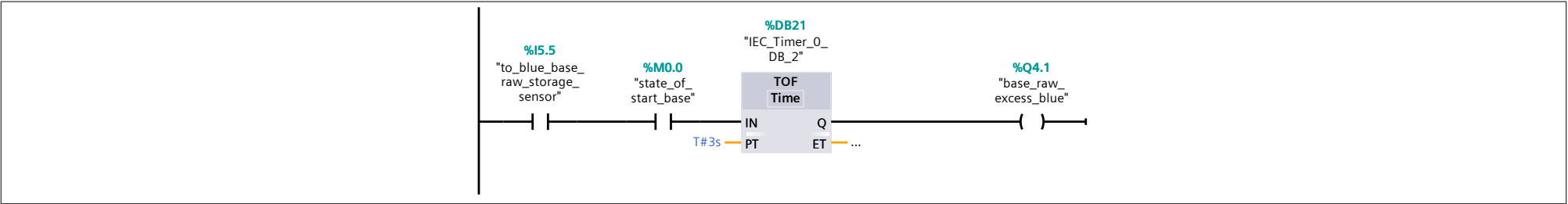
Network 3: PUSH\_FORWARD\_EXECS\_BLUE



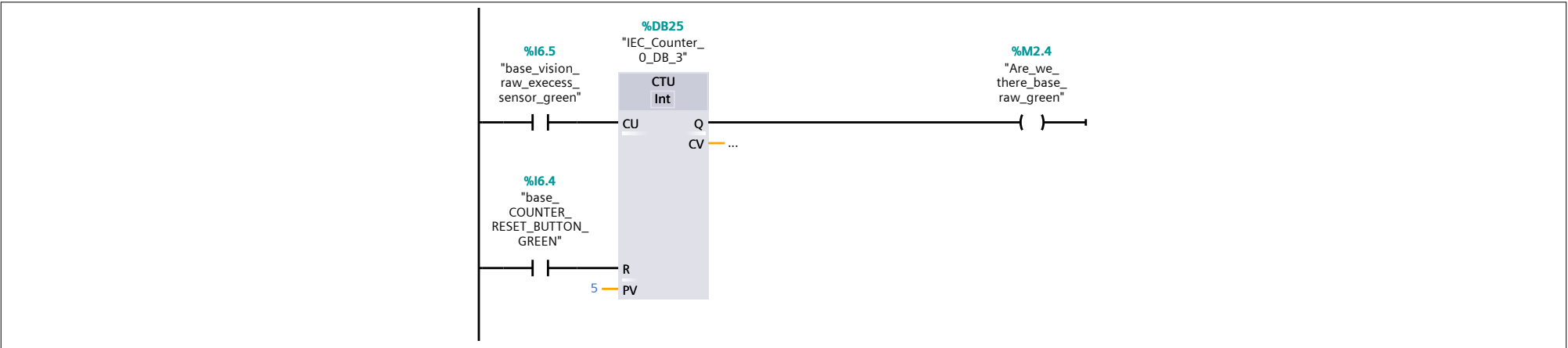
Network 4: PUSH\_RETURN\_EXECESS\_BLUE



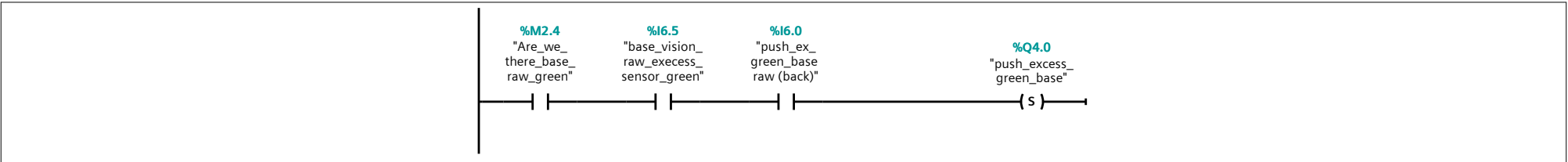
Network 5: RETURN\_EXECESS\_BLUE\_TO\_STORAGE



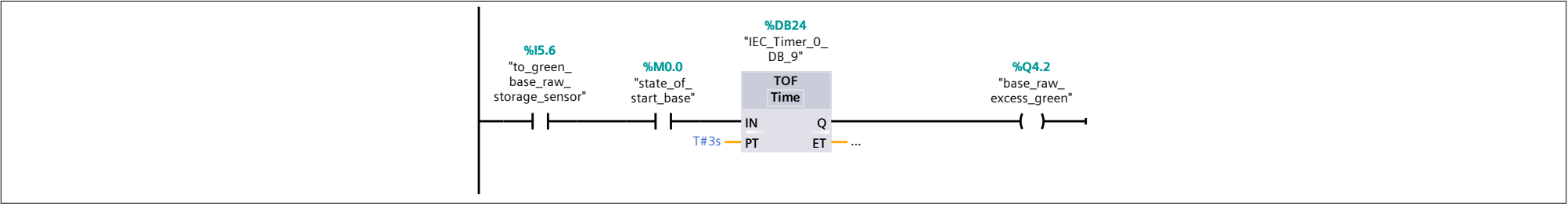
Network 6: COUNTING NO OF GREEN MATERIAL



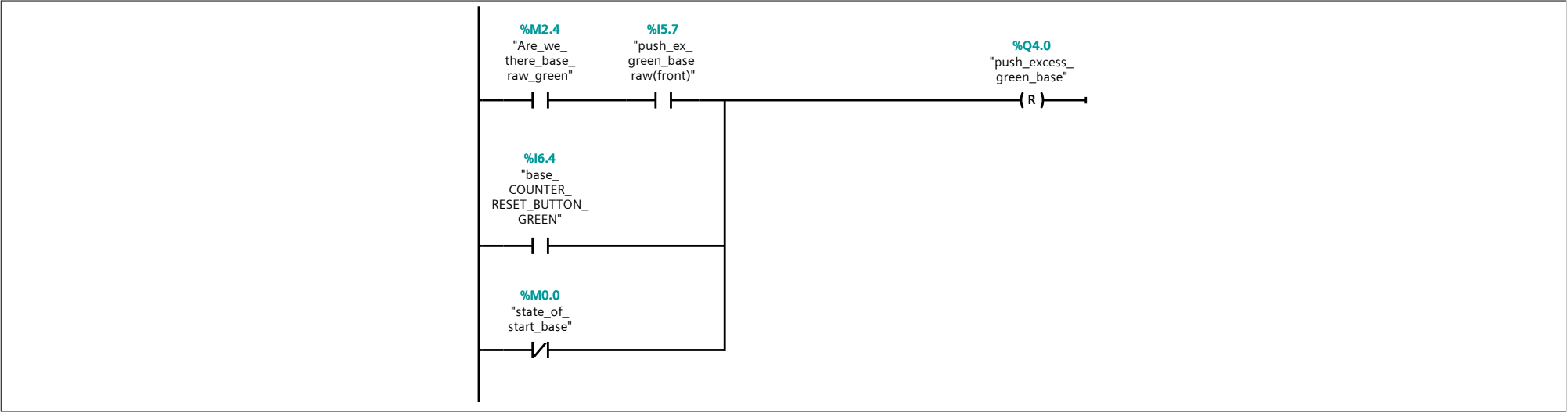
Network 7: PUSH\_FORWARD\_EXECS\_GREEN



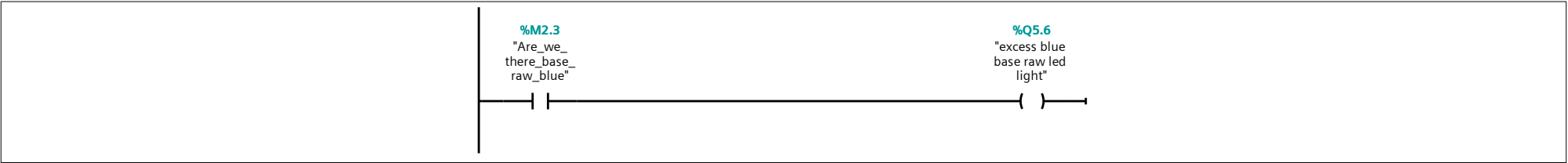
Network 8: RETURN\_EXECESS\_GREEN\_TO\_STORAGE



Network 9: PUSH\_RETURN\_GREEN



Network 10: excess blue light



Network 11:



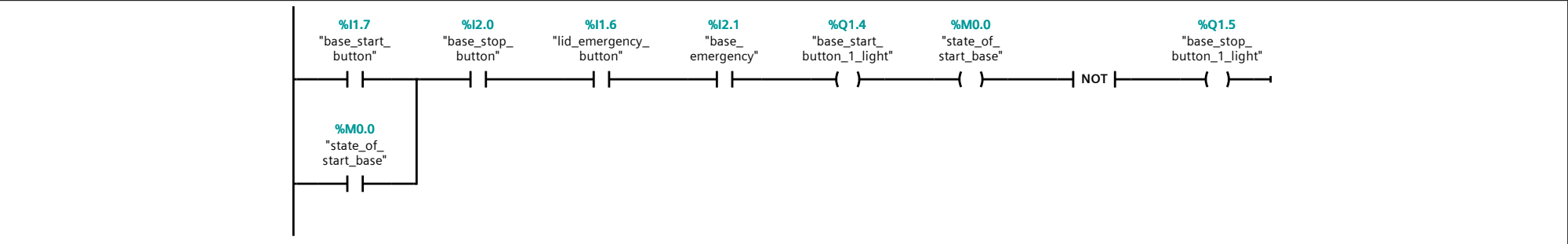
Project / PLC\_2 [CPU 319-3 PN/DP] / Program blocks

base\_production\_fb [FB5]

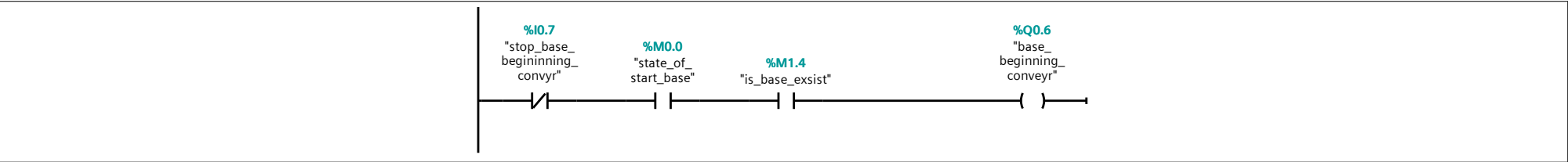
base_production_fb Properties							
General							
Name	base_production_fb	Number	5	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

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

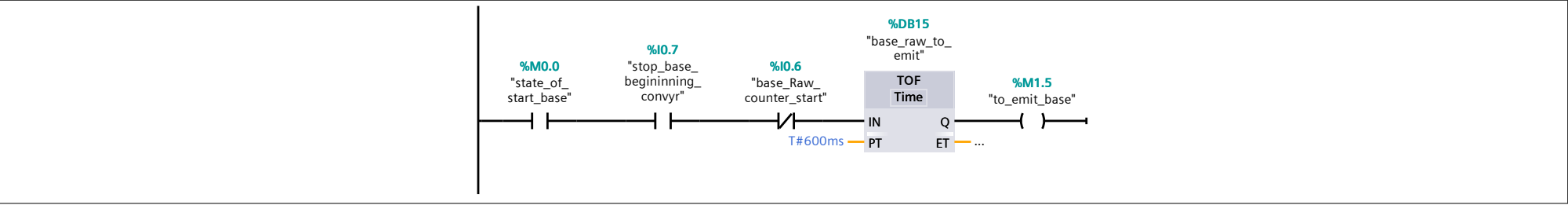
Network 1: base\_production\_station



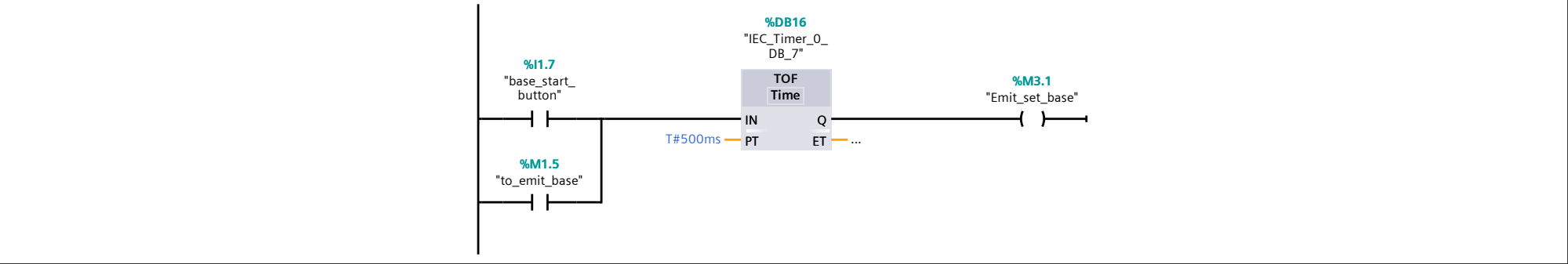
Network 2: base\_begin\_conveyer



Network 3: emit\_base\_handler



Network 4: emitting\_base

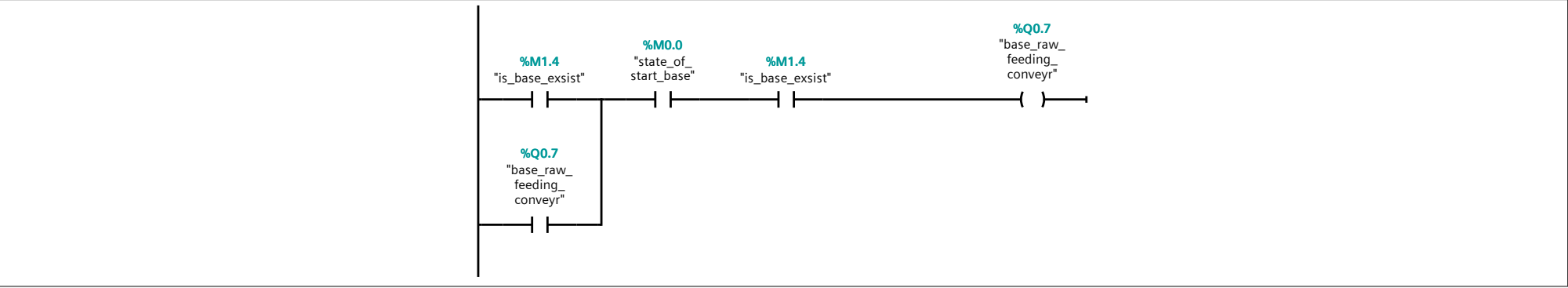


Network 5: Emit emergency handle base

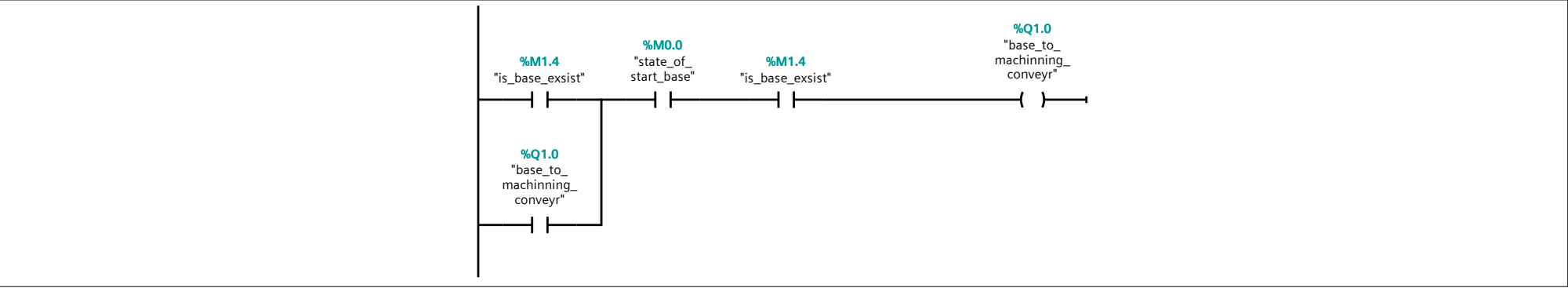




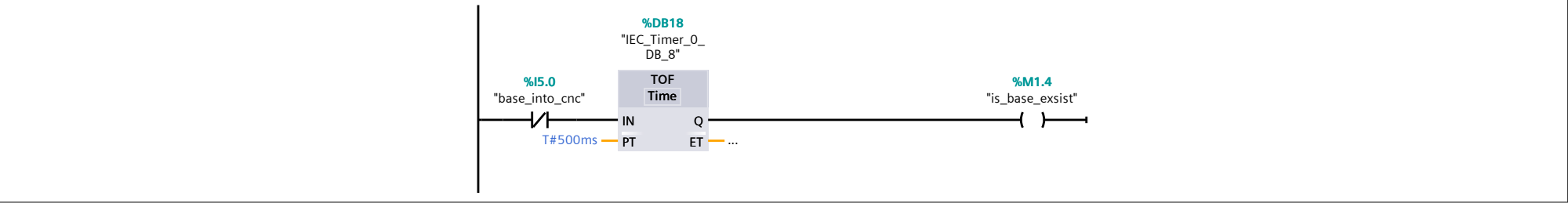
Network 6: FEEDING\_CONVYER\_HANDLER\_BASE



Network 7: base\_machinning\_handle



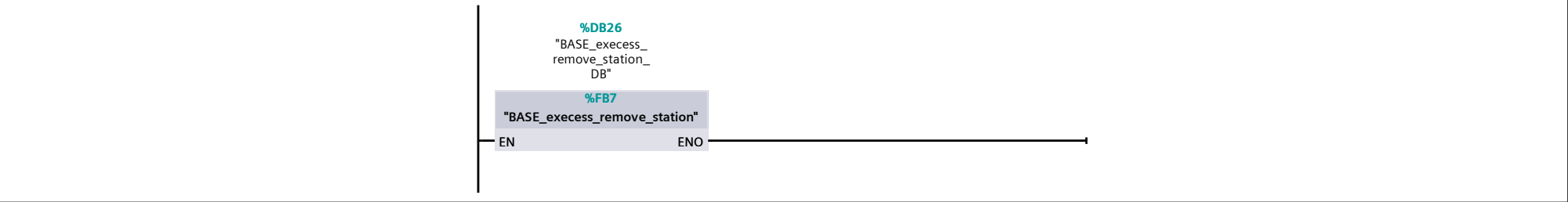
Network 8: base\_raw\_into\_cnc



Network 9: BASE\_KEEP\_DISTANCE



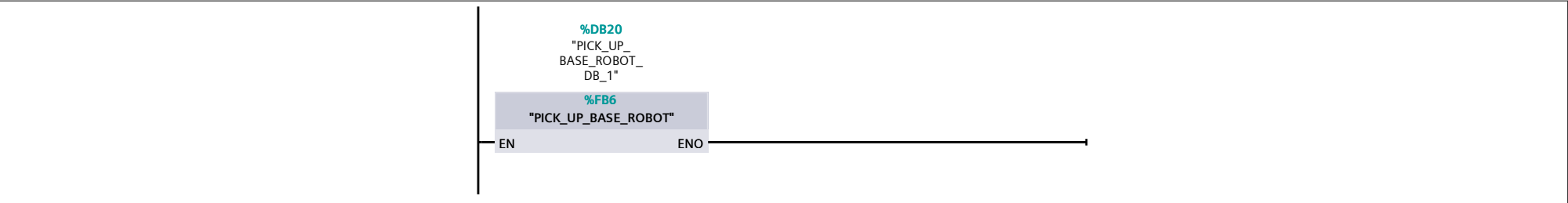
Network 10: base\_excess



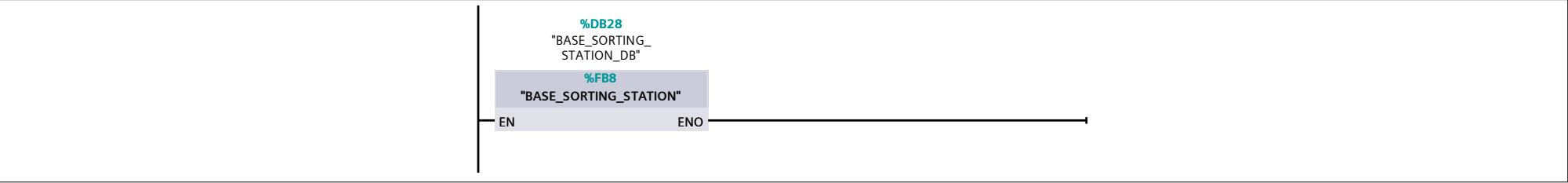
Network 11: CNC\_BASE



Network 12: pick\_and\_place\_base



Network 13: Base sorting



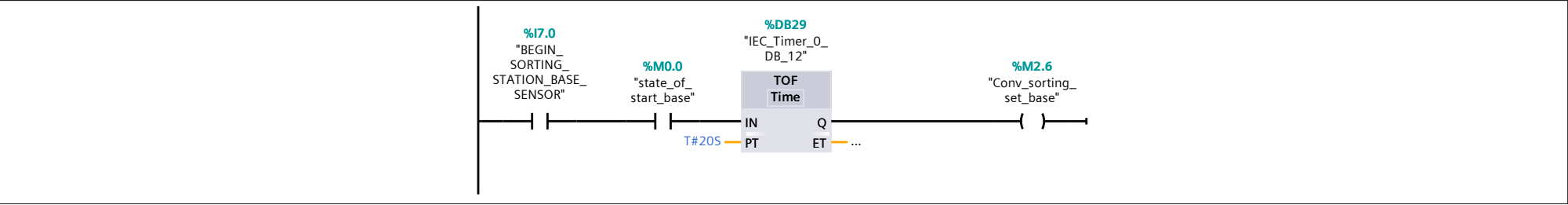
Project / PLC\_2 [CPU 319-3 PN/DP] / Program blocks

BASE\_SORTING\_STATION [FB8]

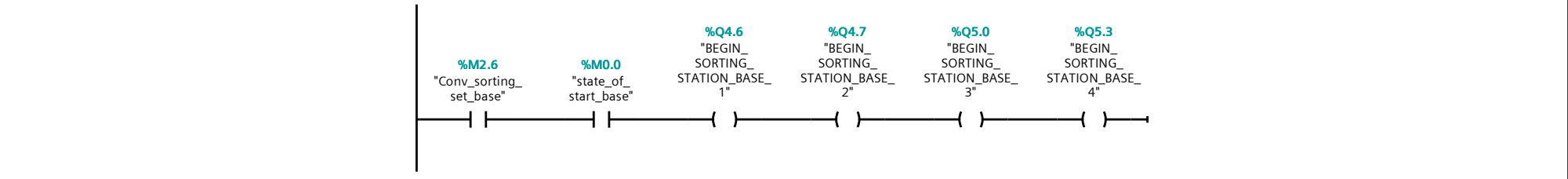
BASE_SORTING_STATION Properties							
General							
Name	BASE_SORTING_STATION	Number	8	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

BASE_SORTING_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: BEGIN SORTING CONVYER



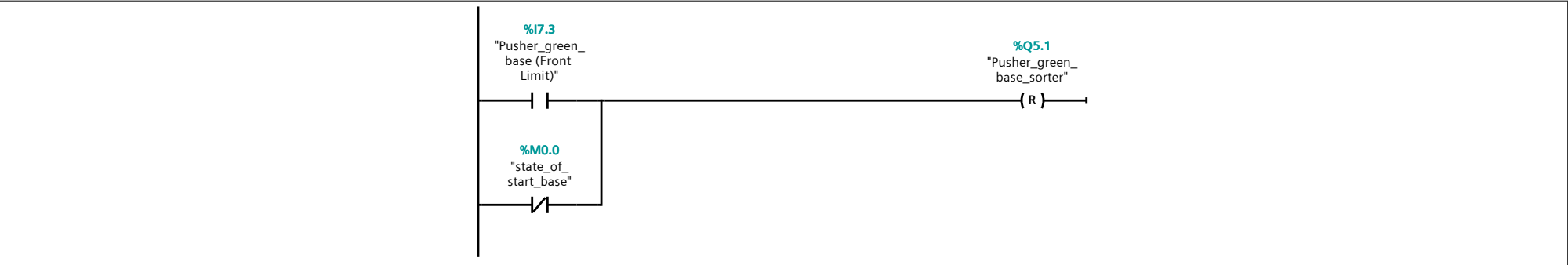
Network 2: Conv base sorting handle



Network 3: GREEN BASE PUSH FRONT



Network 4: GREEN PUSHER SORTING RETURN



Network 5: BLUE PUSHER SORTING PUSH



Network 6: BLUE\_PUSHER\_SORTING\_RETURN



Network 7: light\_blue



Network 8: light green



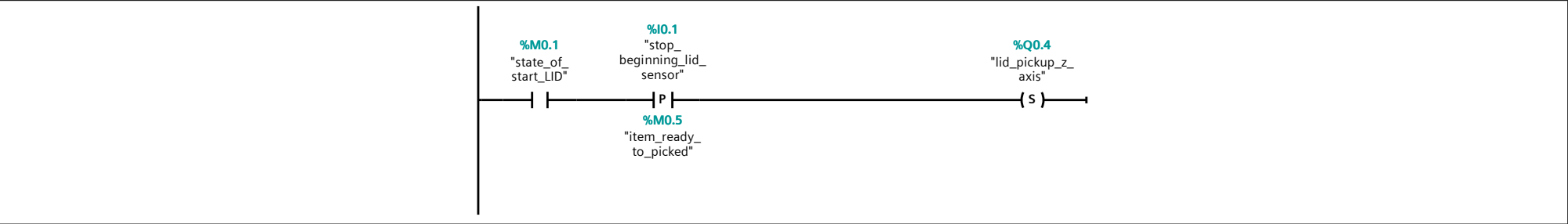
Project / PLC\_2 [CPU 319-3 PN/DP] / Program blocks

PICK\_UP\_LID\_ROBOT [FB1]

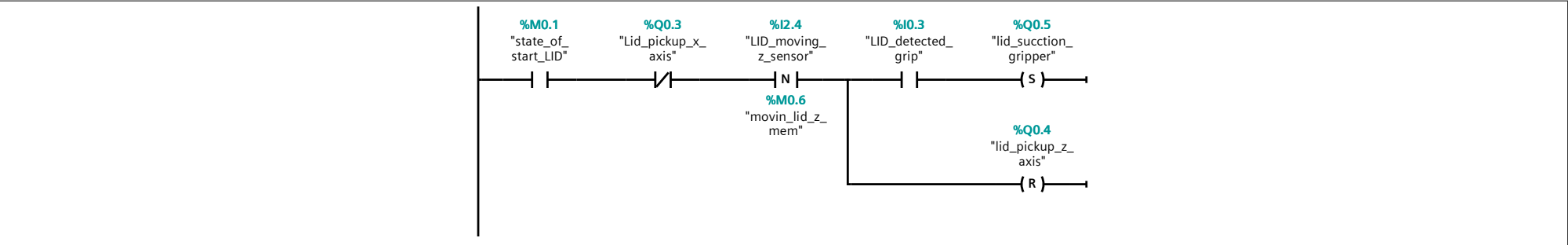
PICK_UP_LID_ROBOT Properties							
General							
Name	PICK_UP_LID_ROBOT	Number	1	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

PICK_UP_LID_ROBOT									
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									

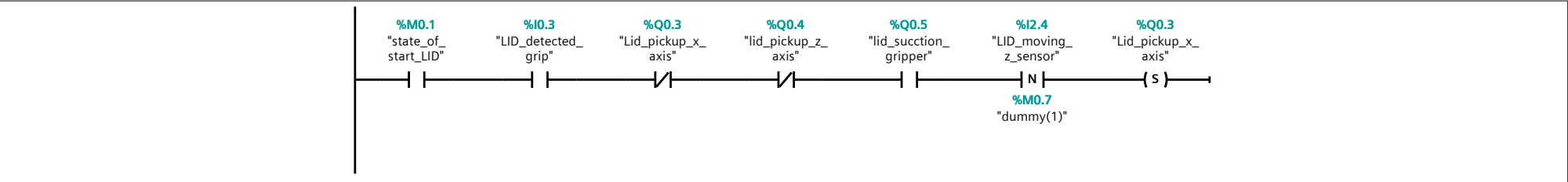
Network 1: LID\_PICKUP\_ROBOT\_LOWERING\_Z\_AXIS



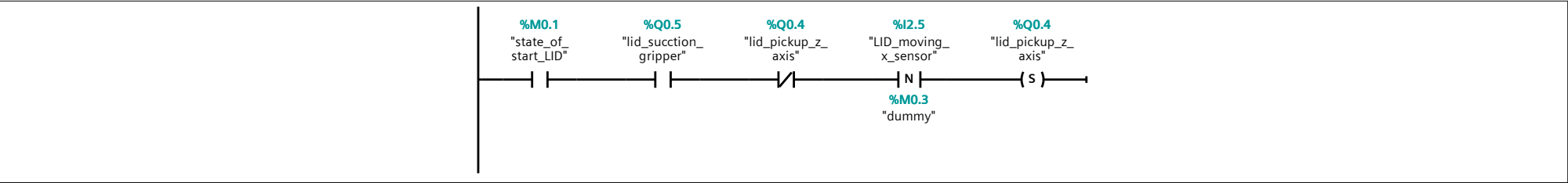
Network 2: LID\_PICKUP\_OPERATE\_SUCCTION



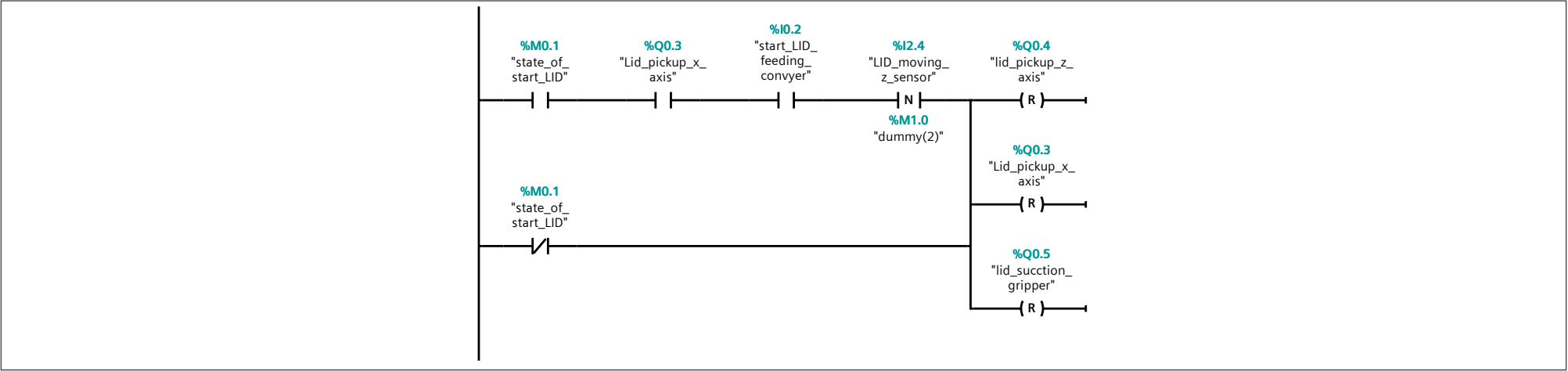
Network 3: PICK\_UP\_LID\_GO\_TO\_FEEDING



Network 4: LID\_PICK\_UP\_LOWERING\_Z\_AXIS\_IN\_FEEDING



Network 5: LID\_RETURN\_TO\_ORIGIN\_PICKUP



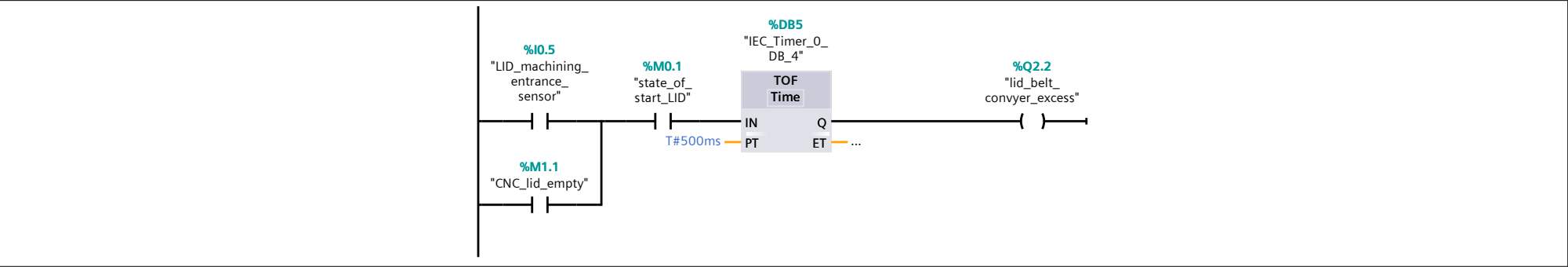
Project / PLC\_2 [CPU 319-3 PN/DP] / Program blocks

LID\_execess\_remove\_station [FB4]

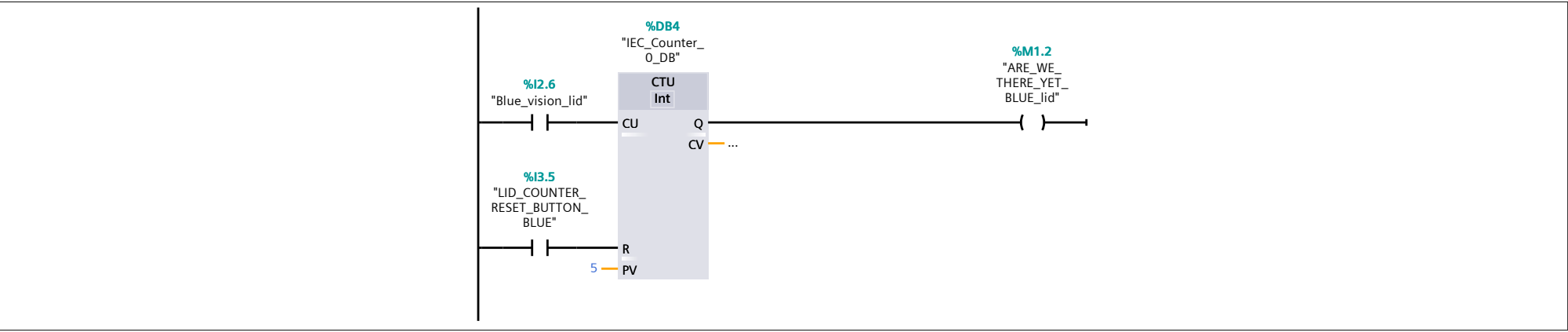
LID_execess_remove_station Properties							
General							
Name	LID_execess_remove_station	Number	4	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

LID_execess_remove_station										
Name	Data type	Offset	Default value	Accessible from HMI/OPC UA	Writable from HMI/OPC UA	Visible in HMI engineering	Setpoint	Supervision	Comment	
Input										
Output										
InOut										
Static										
Temp										
Constant										

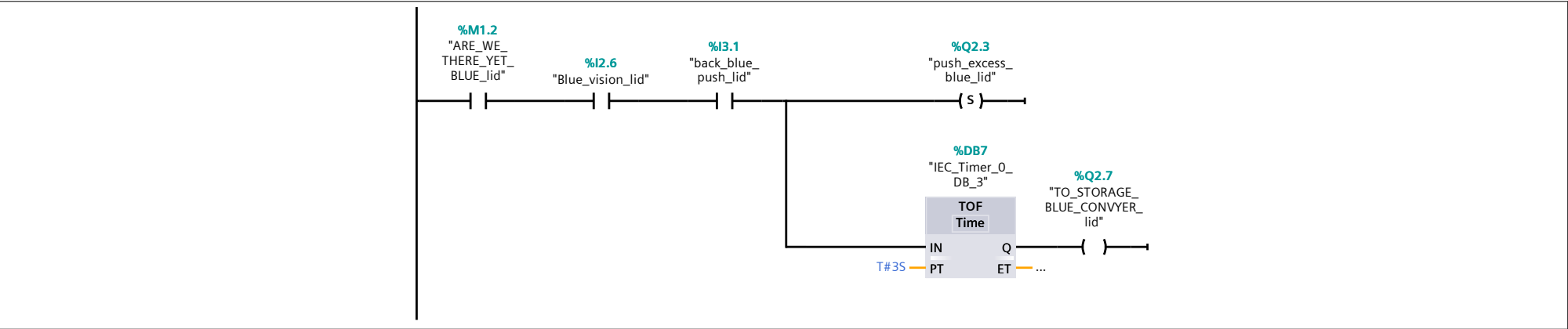
Network 1: LID\_BELT\_EXECESS\_CONVYR\_HANDLER



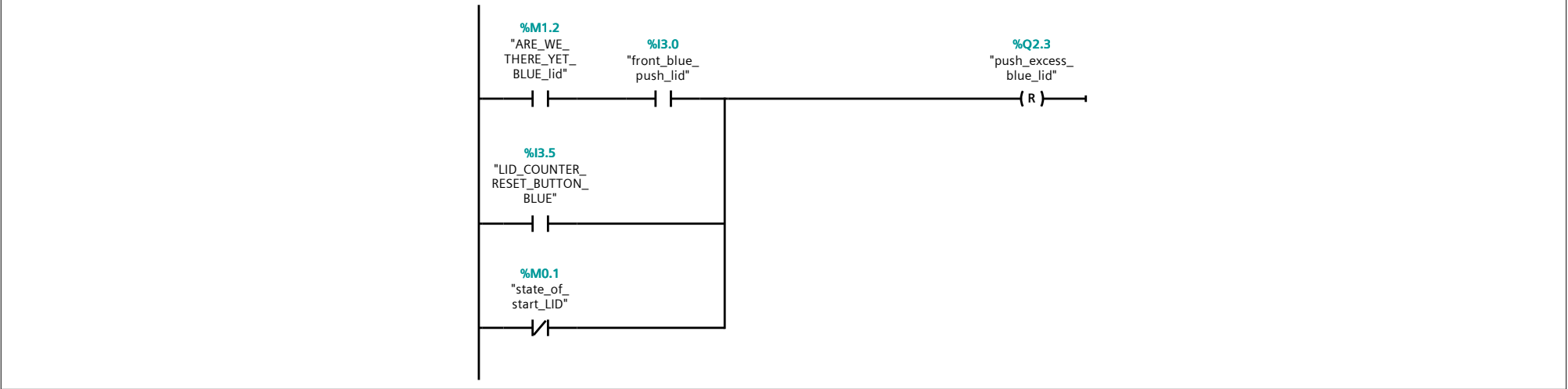
Network 2: COUNTING NO OF BLUE MATERIAL OF EXECCES



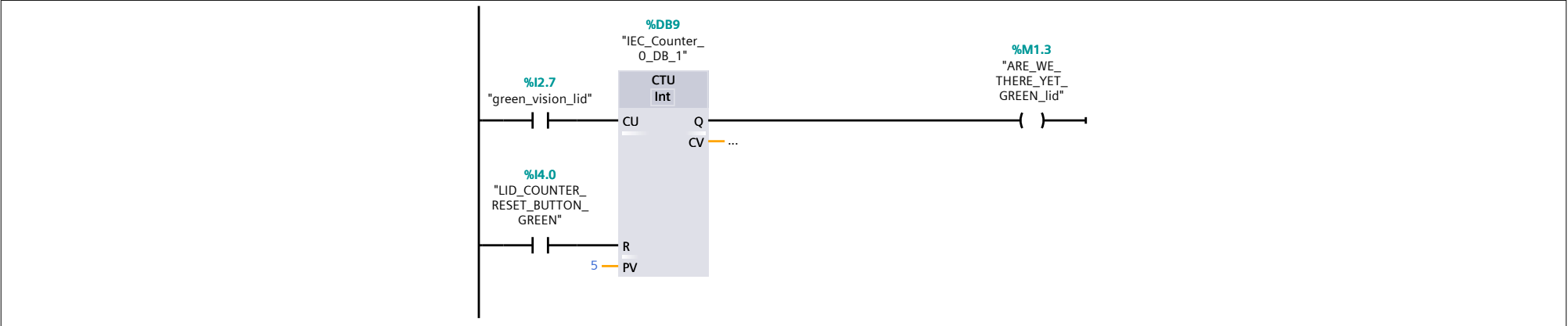
Network 3: PUSH\_FORWARD\_EXECS\_BLUE



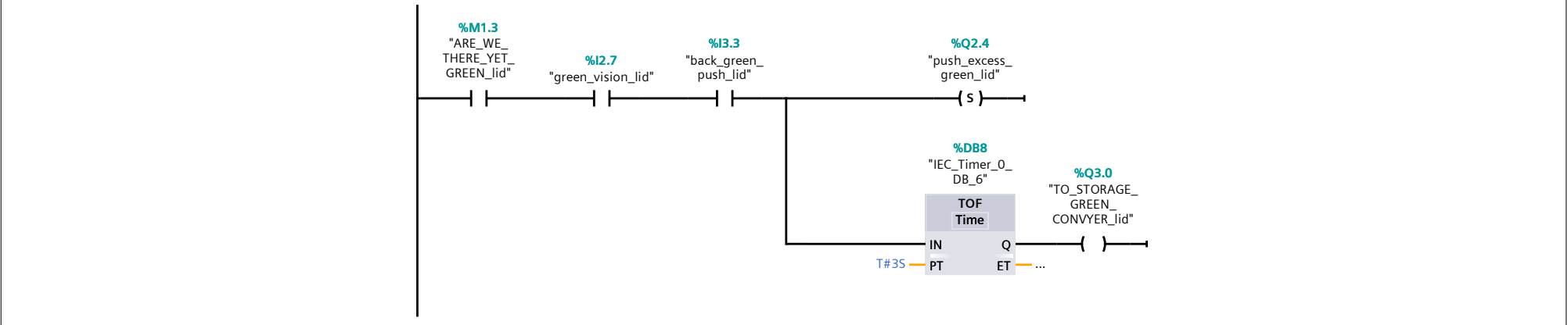
Network 4: PUSH\_RETURN\_EXECESS\_BLUE



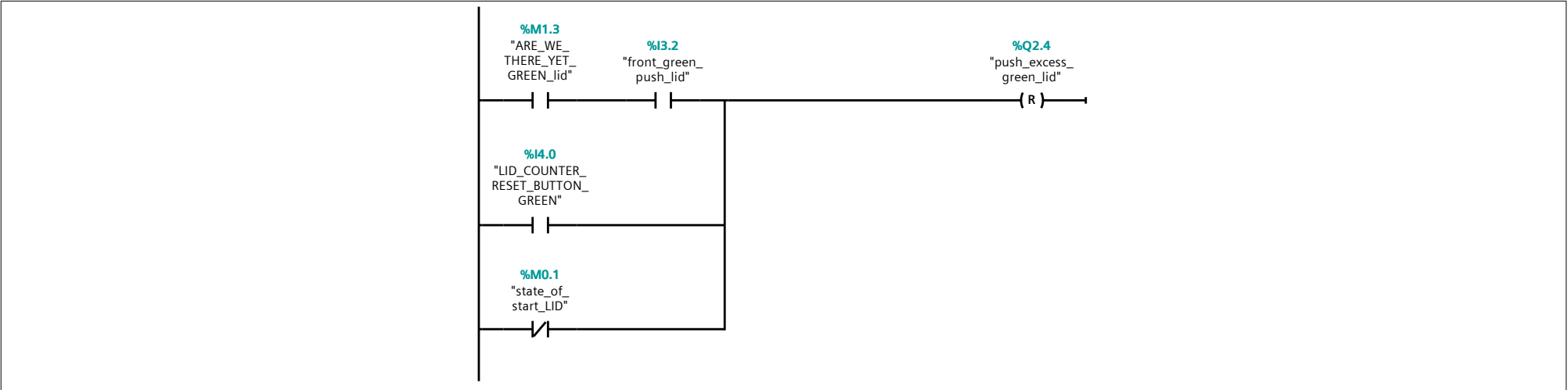
Network 5: COUNTING NO OF GREEN MATERIAL



Network 6: PUSH\_FORWARD\_EXECS\_GREEN



Network 7: PUSH\_RETURN\_GREEN

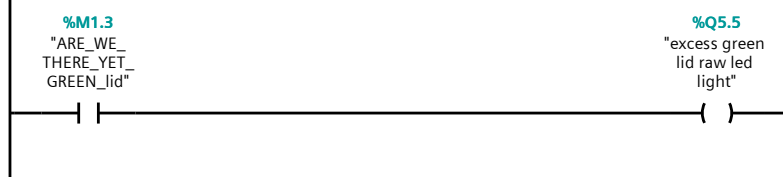


Network 8: light blue if reached



Network 9: light green if reached





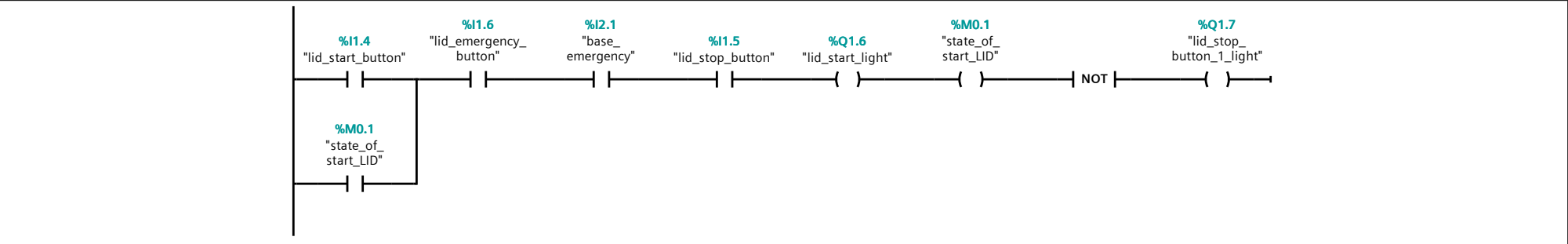
Project / PLC\_2 [CPU 319-3 PN/DP] / Program blocks

LID PRODUCTION [FB2]

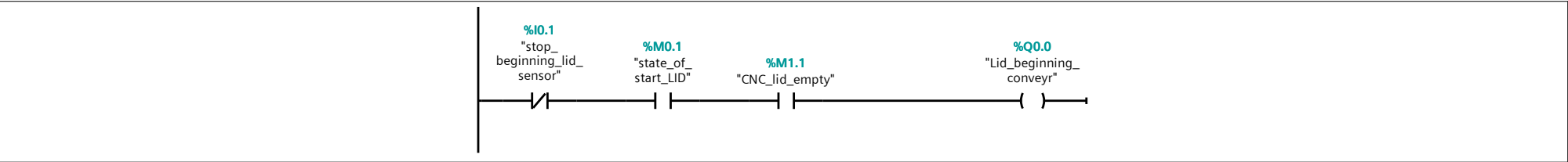
LID PRODUCTION Properties							
General							
Name	LID PRODUCTION	Number	2	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

LID PRODUCTION										
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										

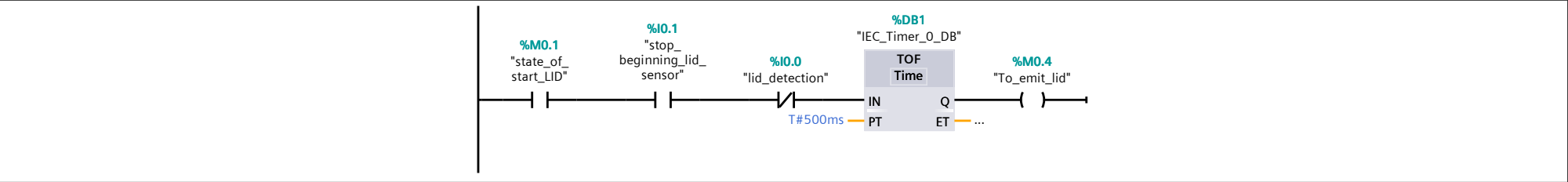
Network 1: LID STARTING HANDLE



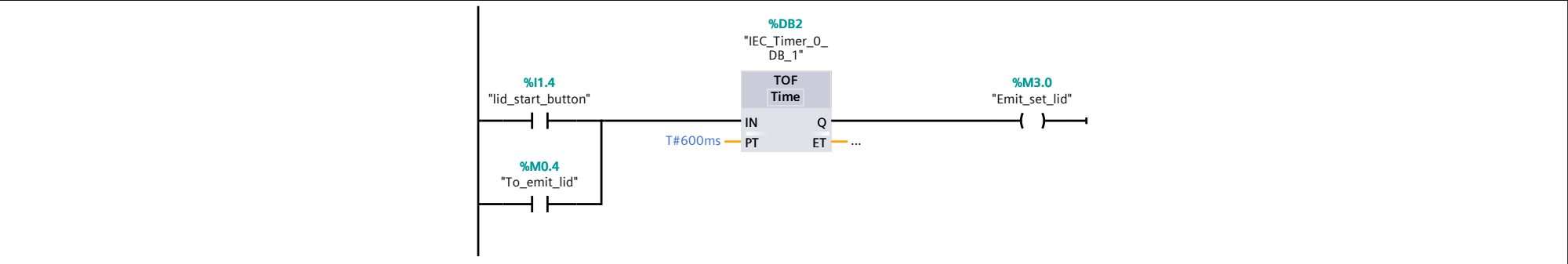
Network 2: LID\_BEGINNING\_COVNVYER



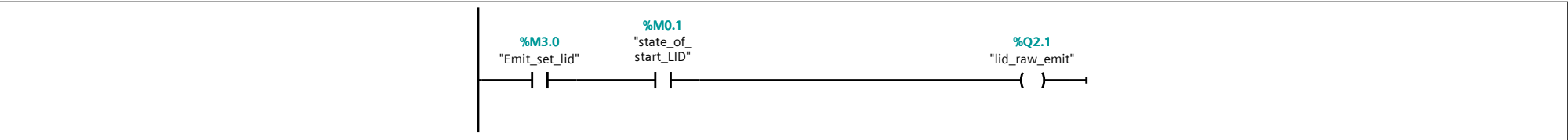
Network 3: LID\_EMITTER\_HANDLER

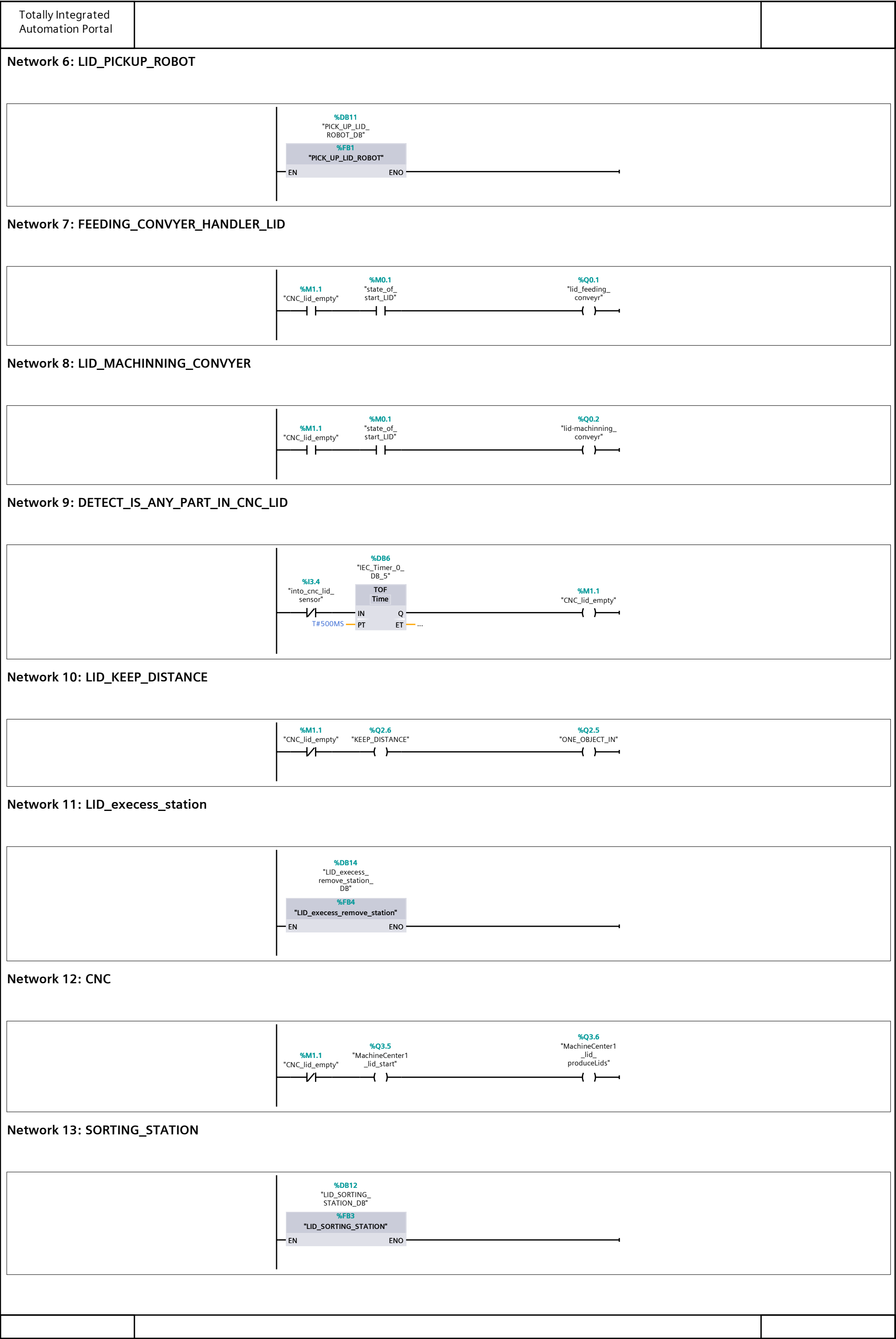


Network 4: FIRST LID TO EMIT



Network 5: Emit emergency handle lid





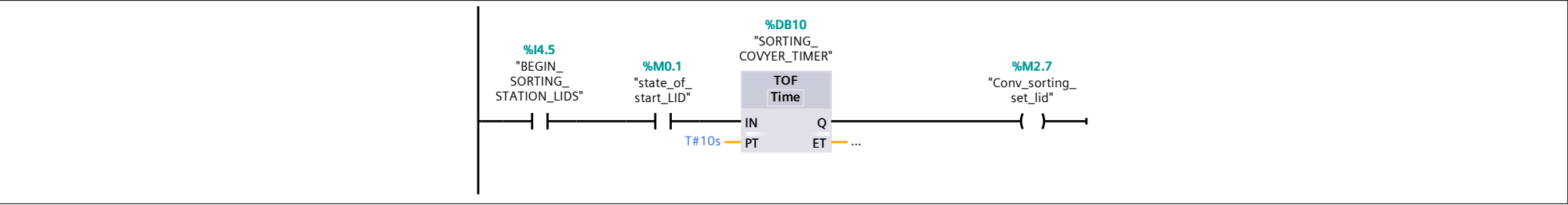
Project / PLC\_2 [CPU 319-3 PN/DP] / Program blocks

LID\_SORTING\_STATION [FB3]

LID_SORTING_STATION Properties							
General							
Name	LID_SORTING_STATION	Number	3	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

LID_SORTING_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										

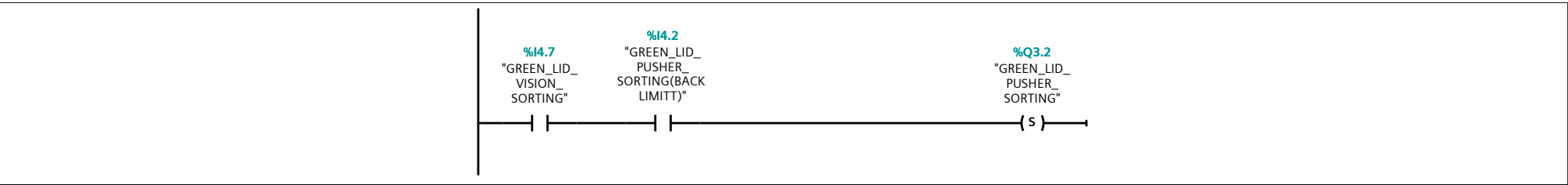
Network 1: BEGIN SORTING CONVYER



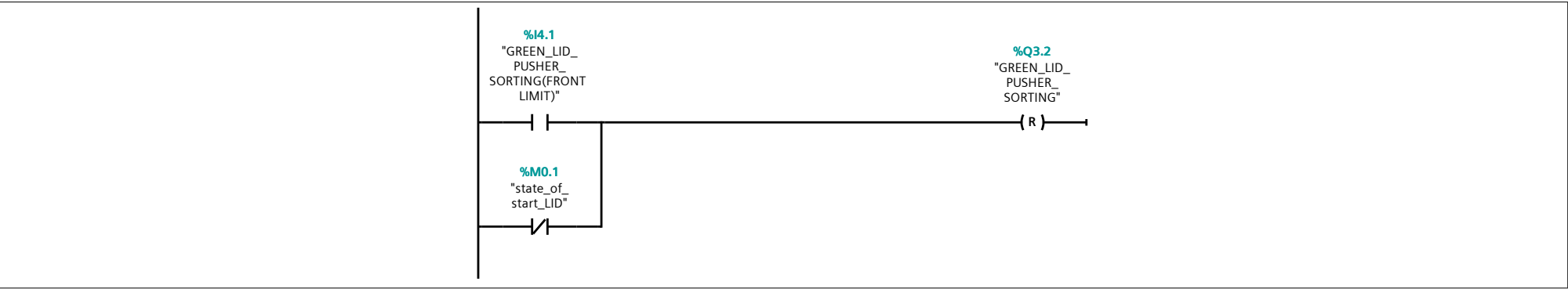
Network 2:



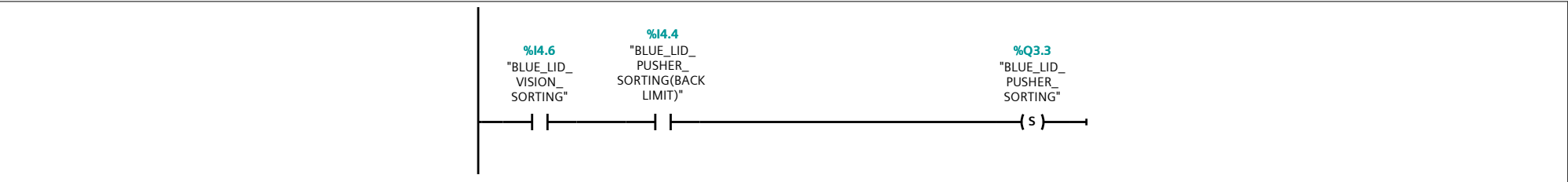
Network 3: GREEN LID PUSH FRONT



Network 4: GREEN PUSHER SORTING RETURN



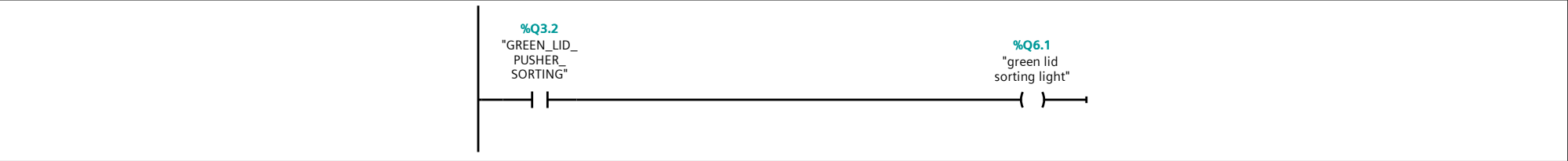
Network 5: BLUE PUSHER SORTING PUSH



Network 6: BLUE\_PUSHER\_SORTING\_RETURN



Network 7: green lid if blue



Network 8: blue lid



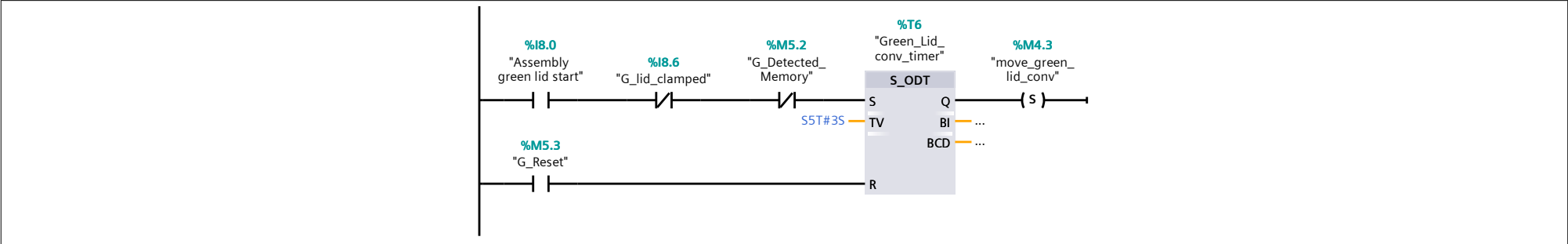
Project / PLC\_2 [CPU 319-3 PN/DP] / Program blocks

Assembly\_conv [FB9]

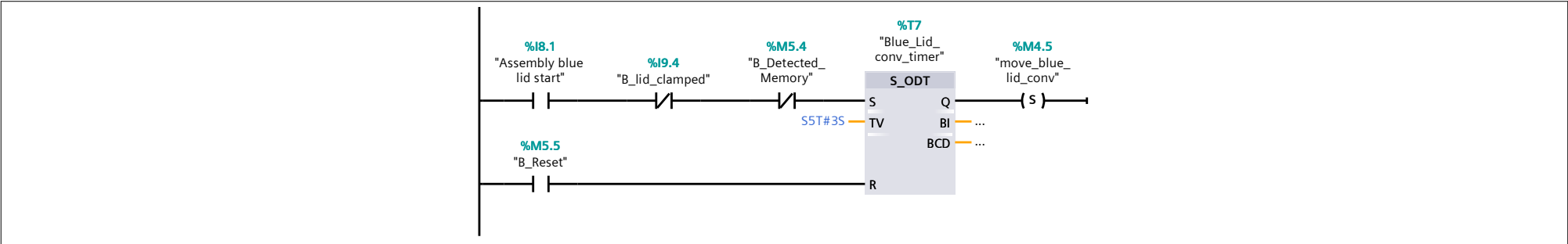
Assembly_conv Properties							
General							
Name	Assembly_conv	Number	9	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

Assembly_conv										
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										

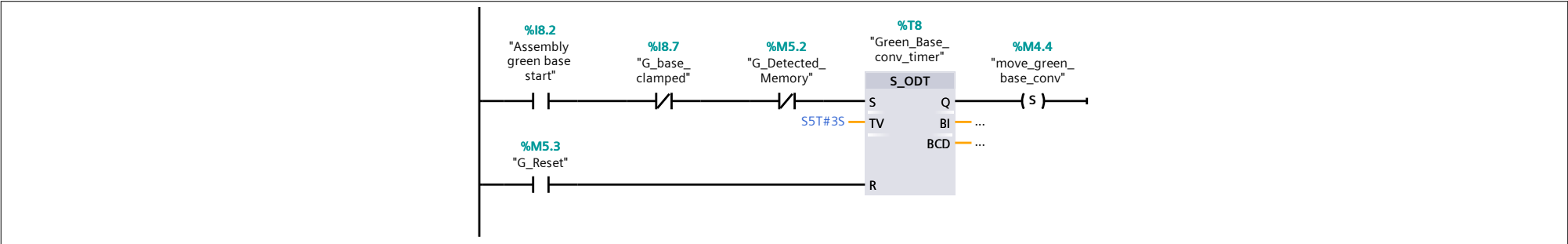
Network 1:



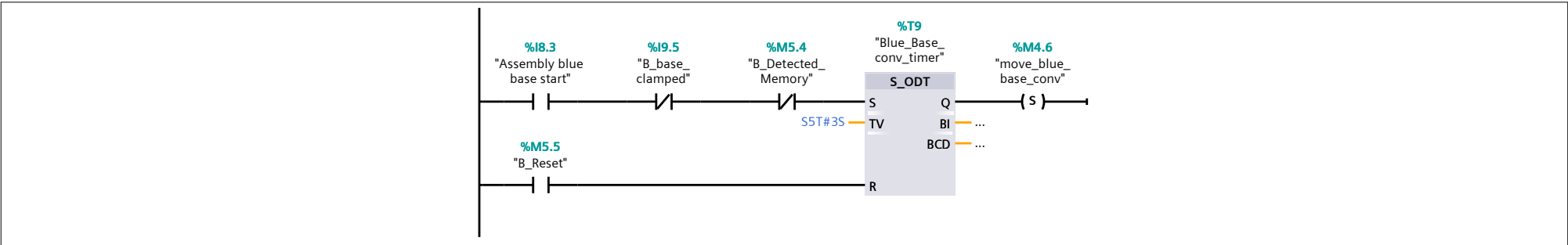
Network 2:



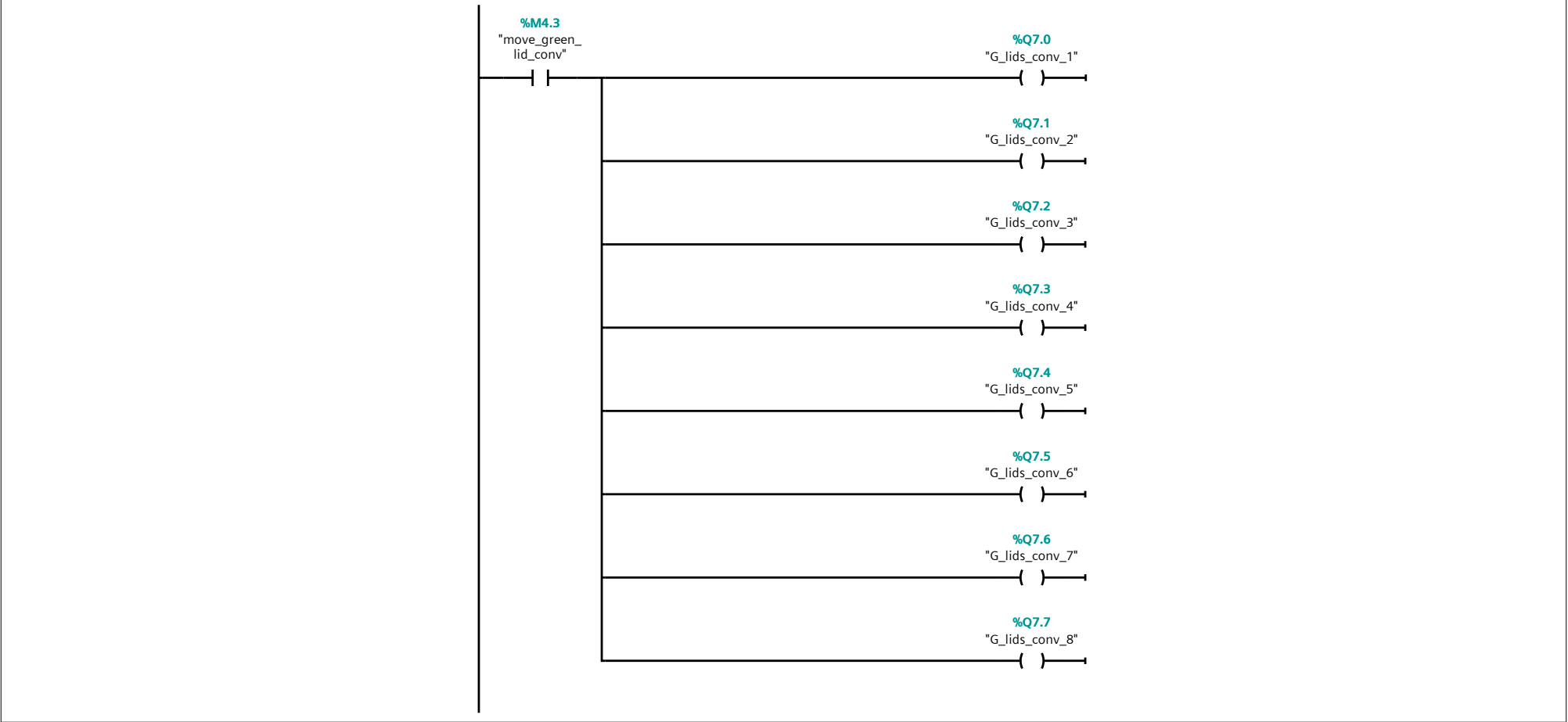
Network 3:



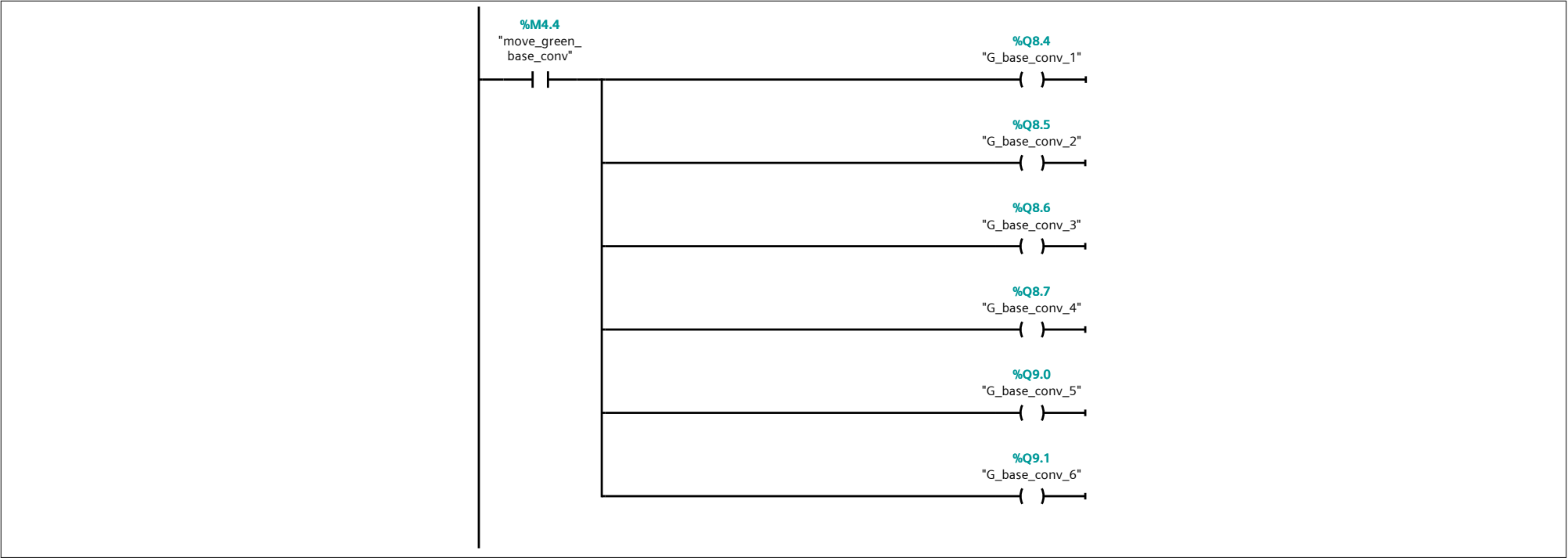
Network 4:



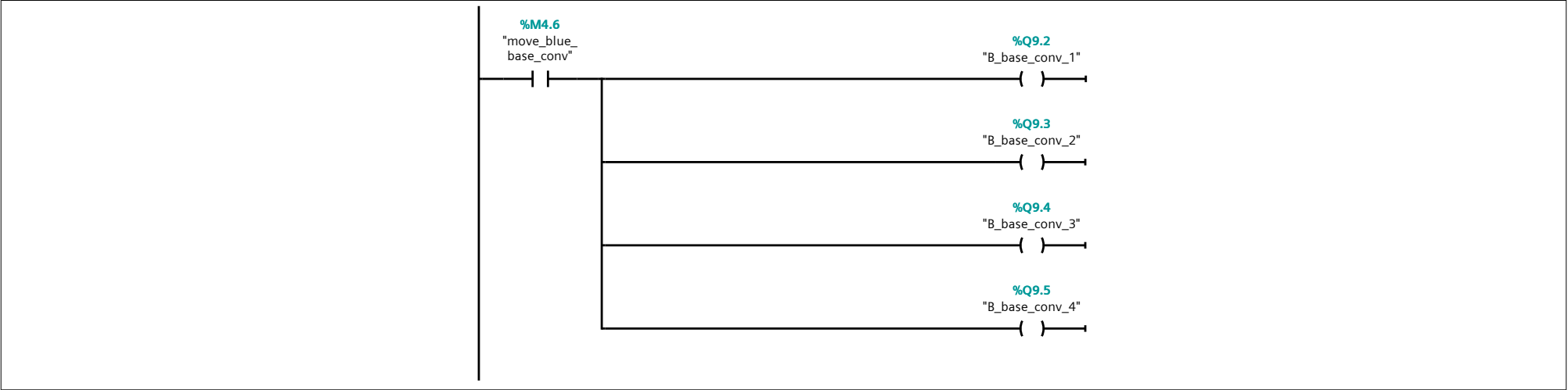
Network 5:



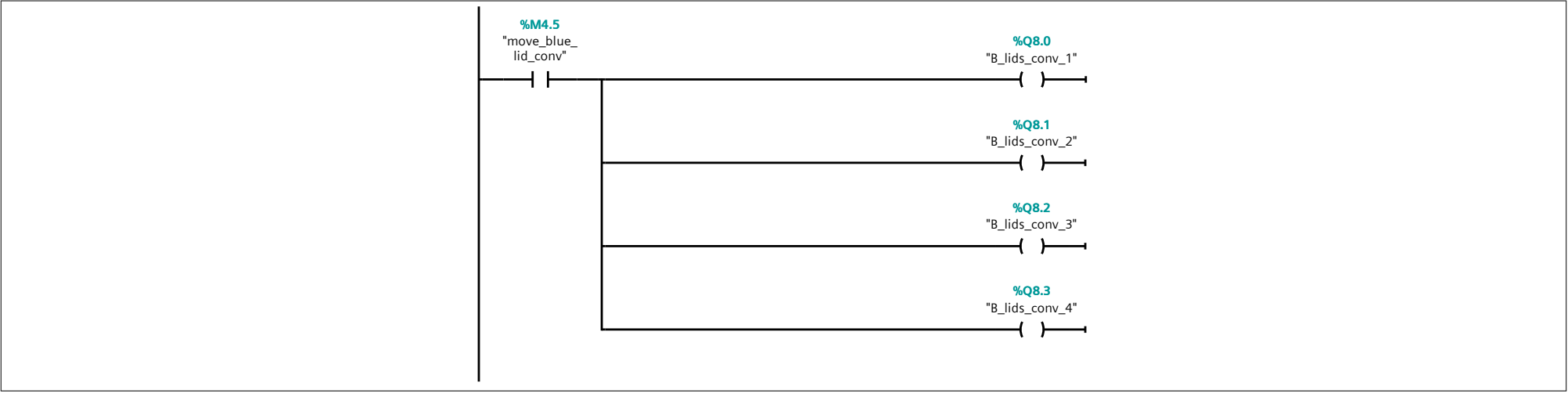
Network 6:



Network 7:



Network 8:





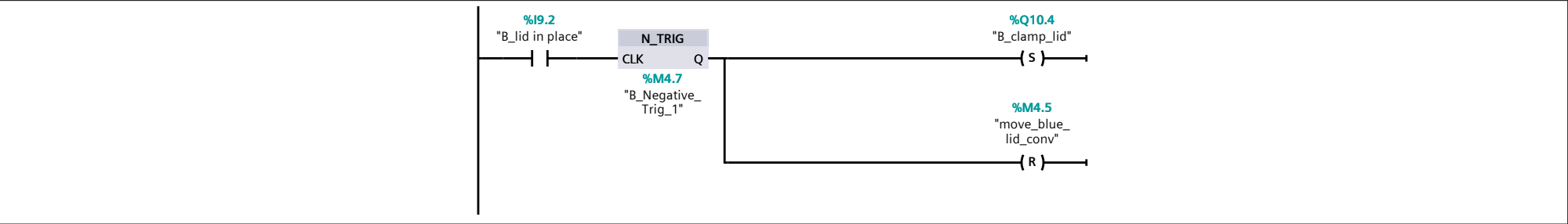
Project / PLC\_2 [CPU 319-3 PN/DP] / Program blocks

Assembly\_Blue [FB11]

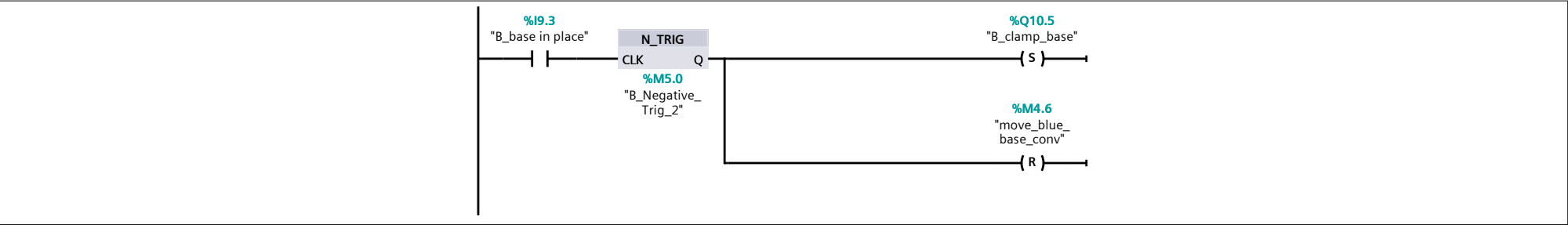
Assembly_Blue Properties							
General							
Name	Assembly_Blue	Number	11	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

Assembly_Blue										
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										

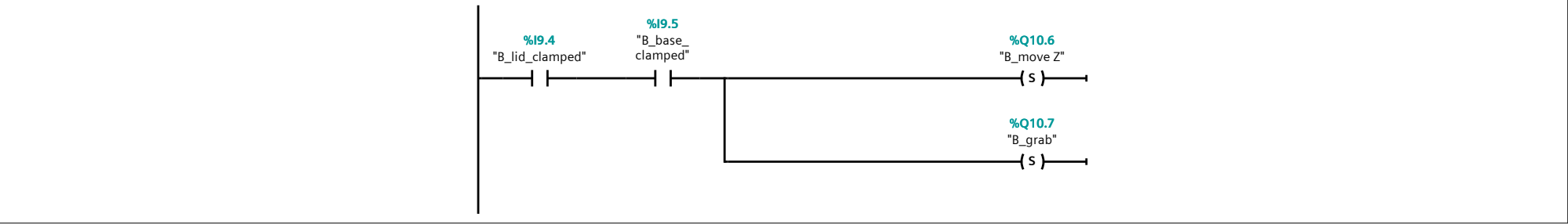
Network 1: Clamp when blue lid in place



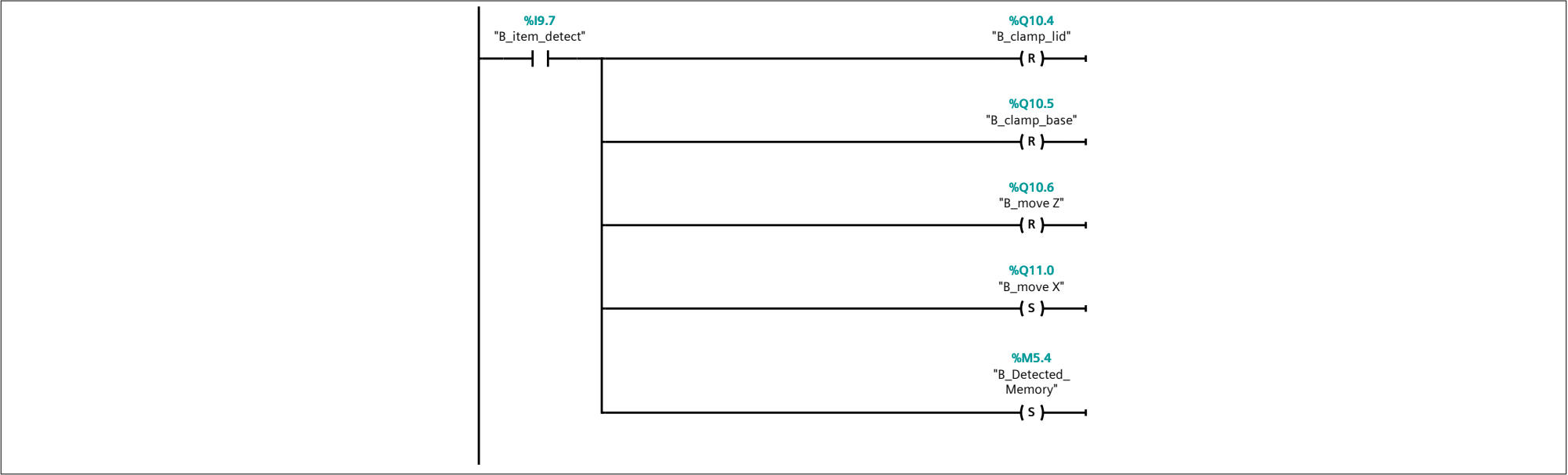
Network 2: Clamp when blue base in place



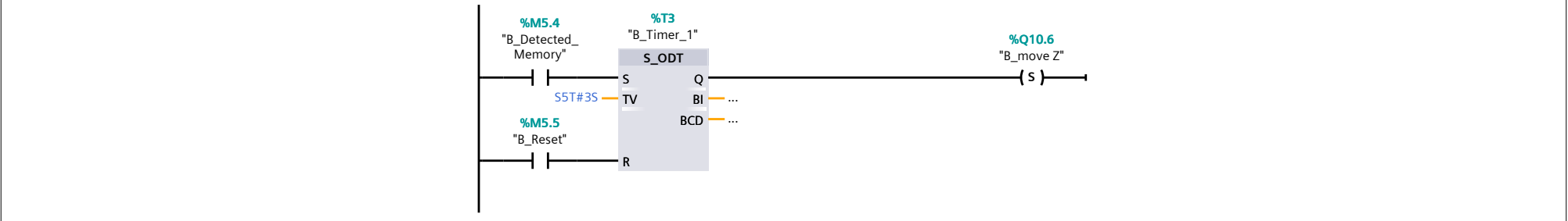
Network 3: move Z and Grab when Base and Lid clamped



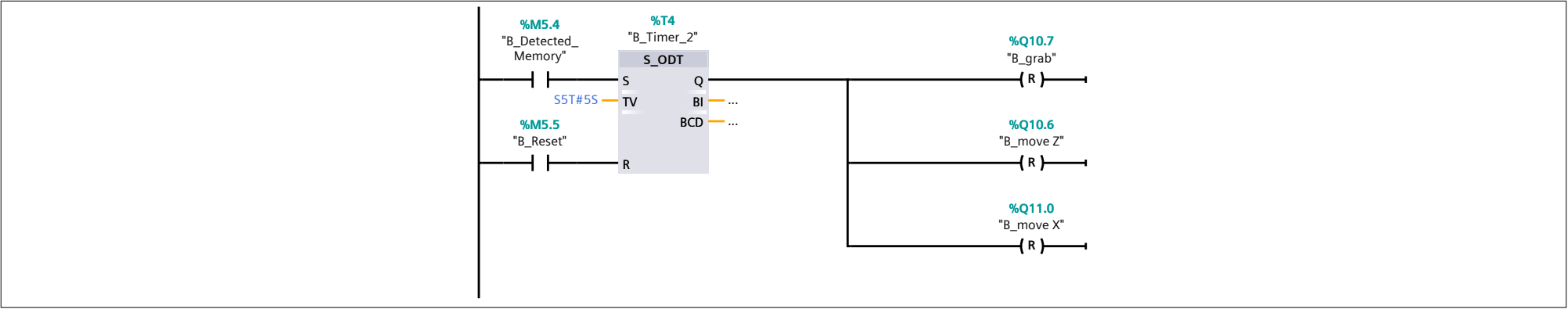
Network 4: unclamp when item detected, raise z and extend x



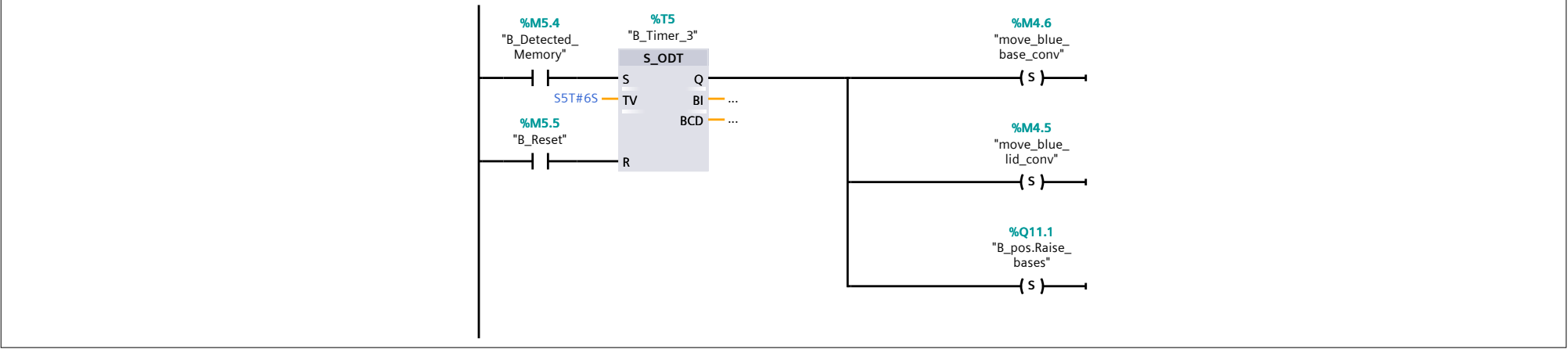
Network 5: lower z after 3 s



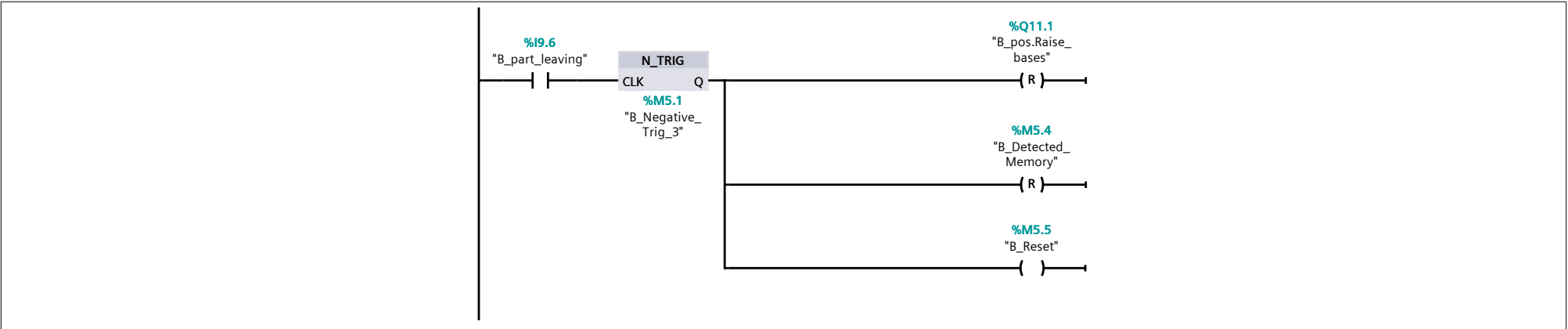
Network 6: ungrab, raise z and unextend x after 5s



Network 7: turn conv on and raise post after 6 s



Network 8: lower post after part leaves



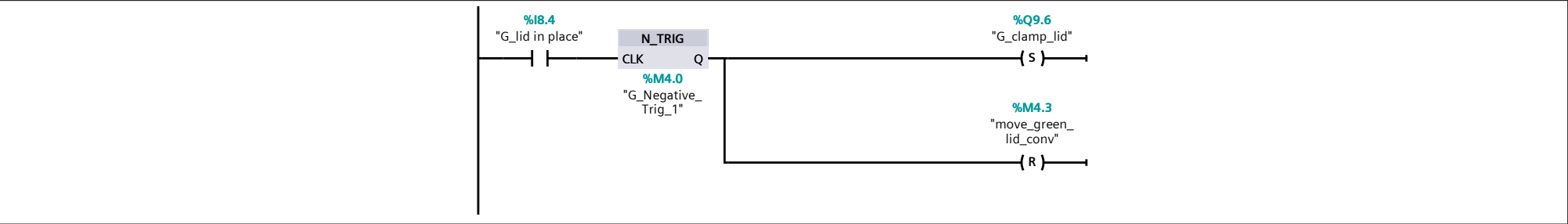
Project / PLC\_2 [CPU 319-3 PN/DP] / Program blocks

Assembly\_Green [FB10]

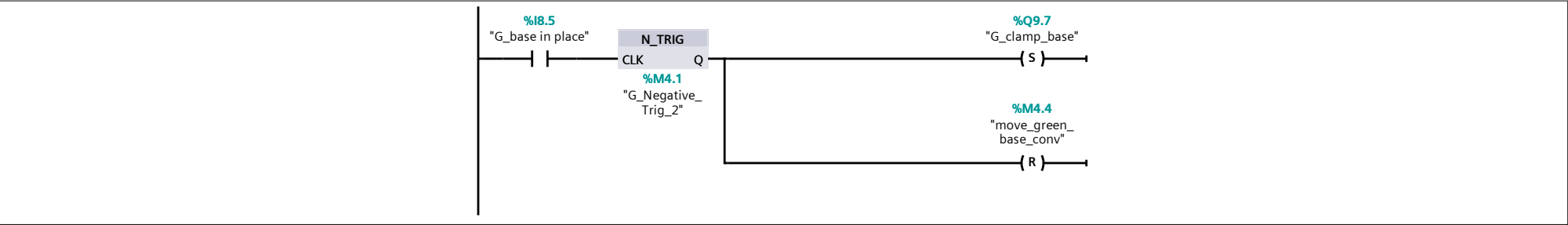
Assembly_Green Properties							
General							
Name	Assembly_Green	Number	10	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

Assembly_Green										
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										

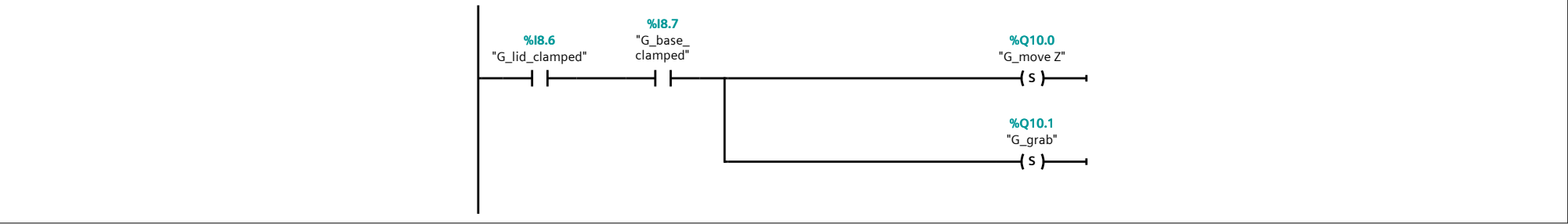
Network 1:



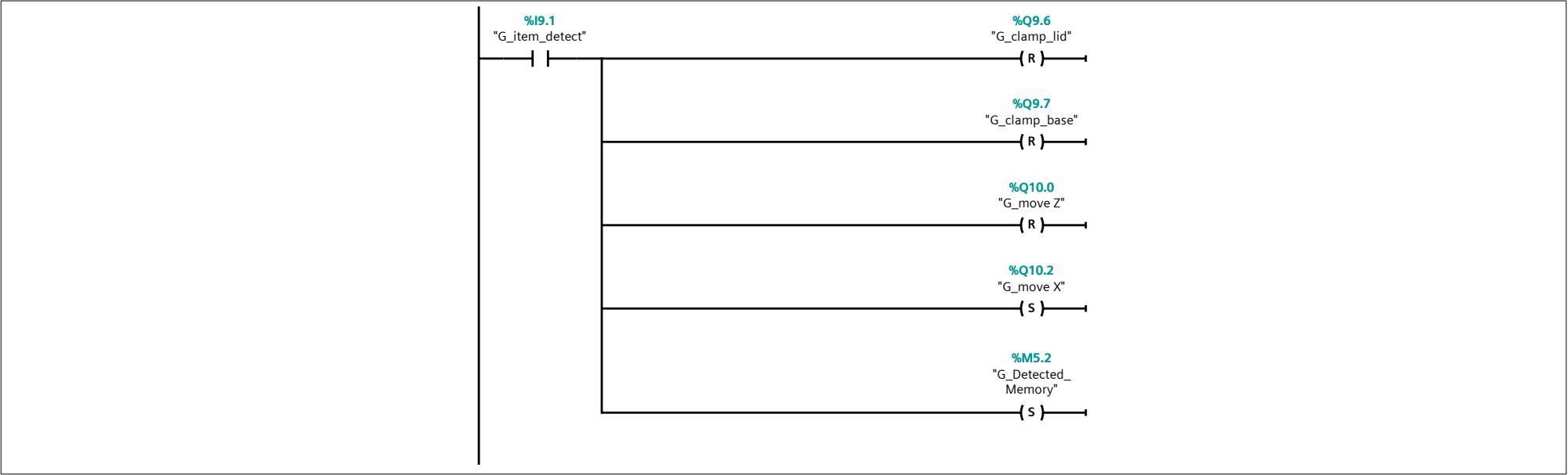
Network 2:



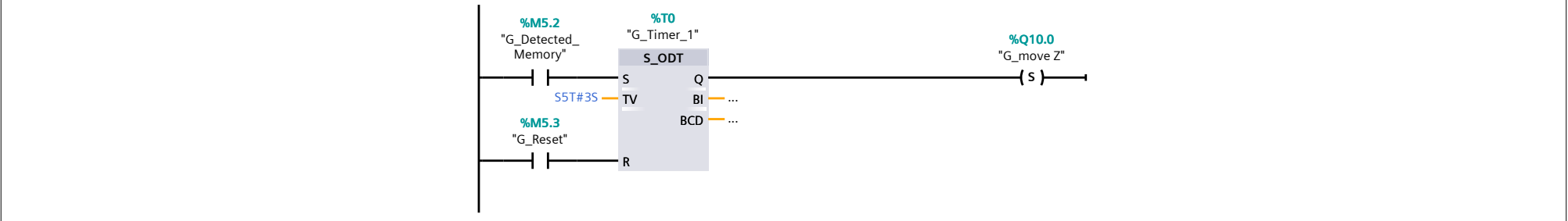
Network 3:



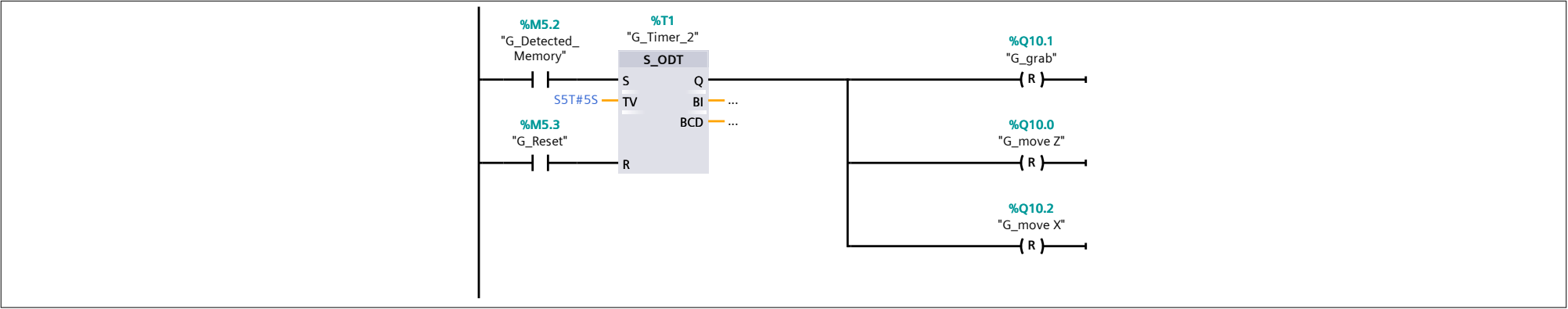
Network 4:



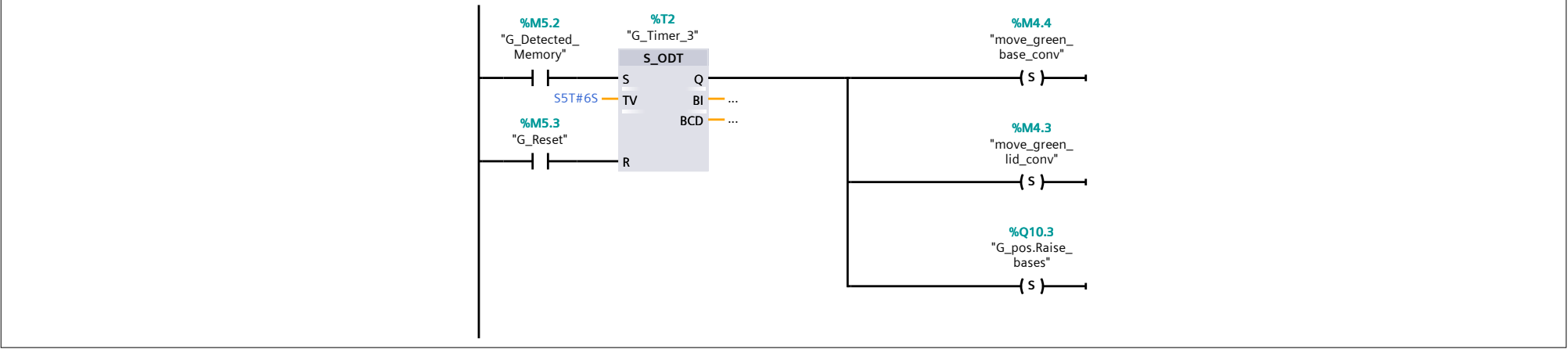
Network 5:



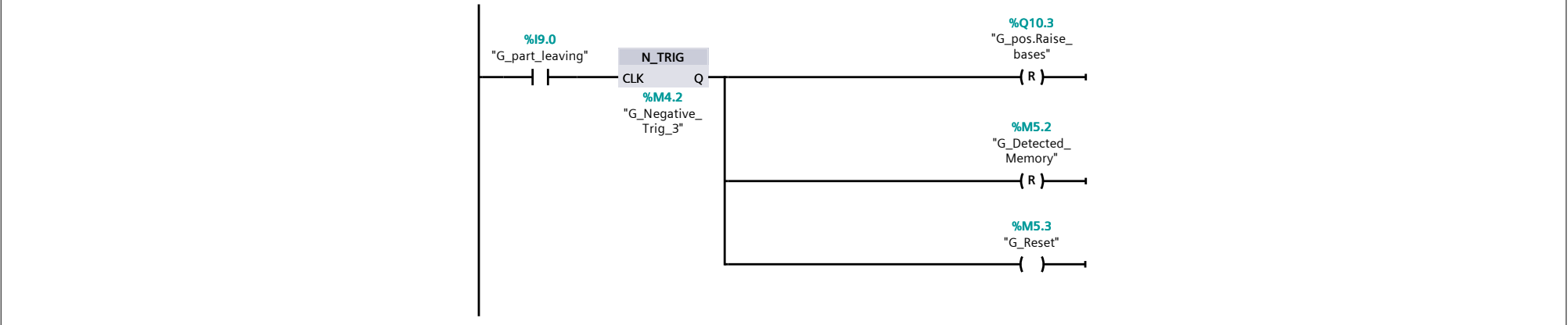
Network 6:



Network 7:



Network 8:



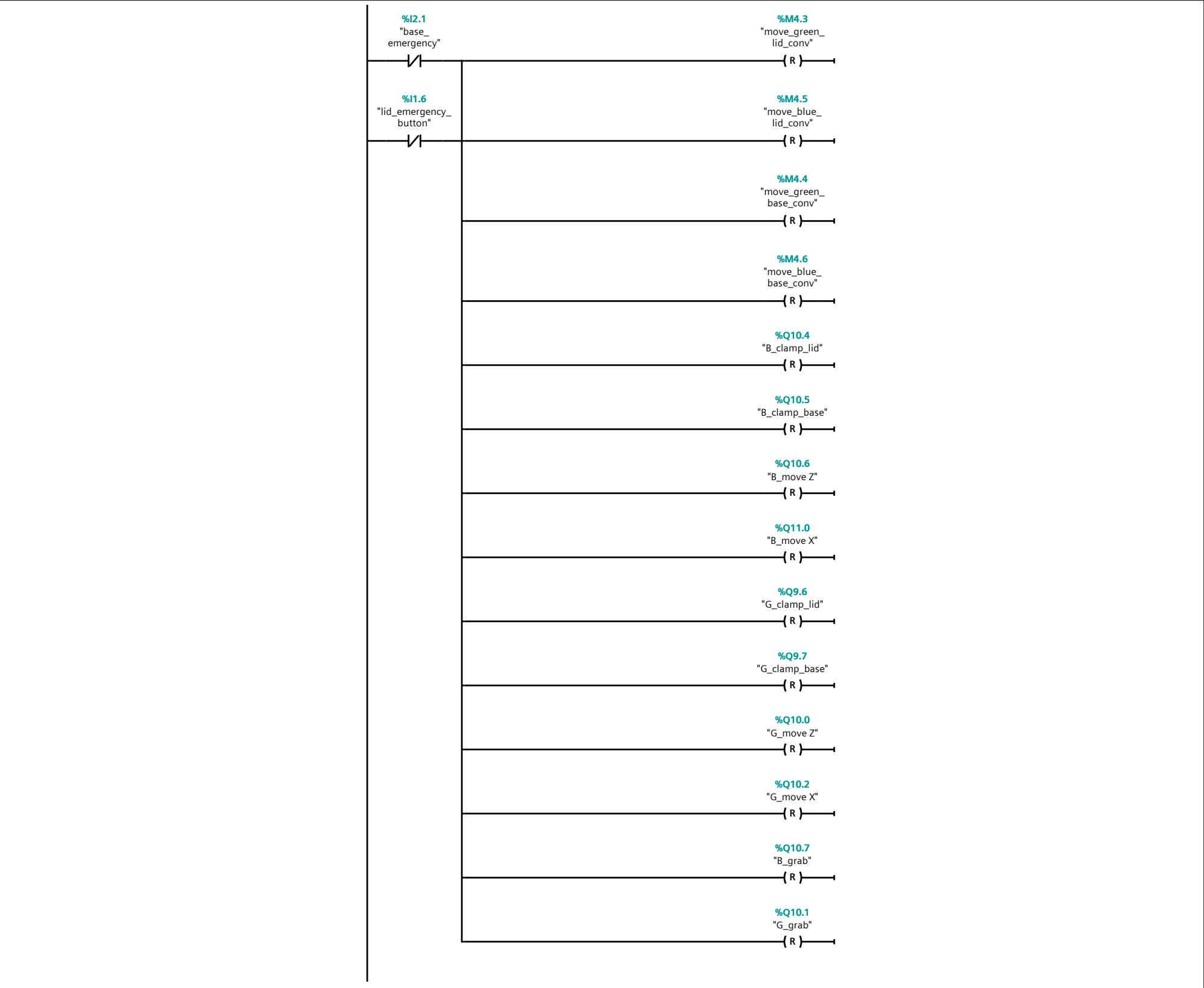
Project / PLC\_2 [CPU 319-3 PN/DP] / Program blocks

Assembly\_Emergency [FB13]

Assembly_Emergency Properties							
General							
Name	Assembly_Emergency	Number	13	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

Assembly_Emergency									
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:



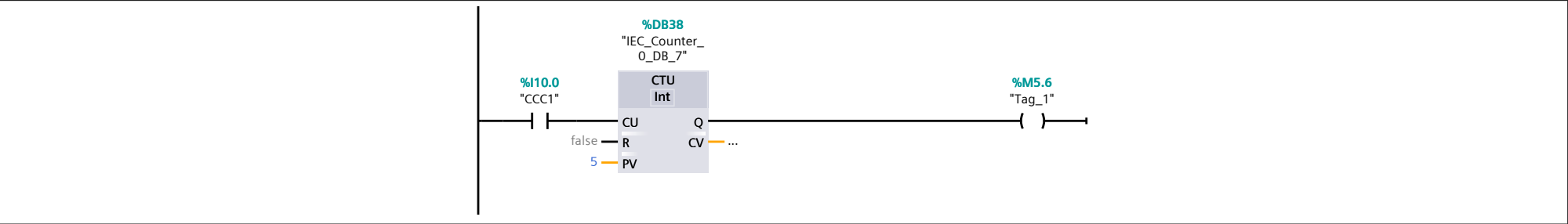
Project / PLC\_2 [CPU 319-3 PN/DP] / Program blocks

A\_COUNTER [FB12]

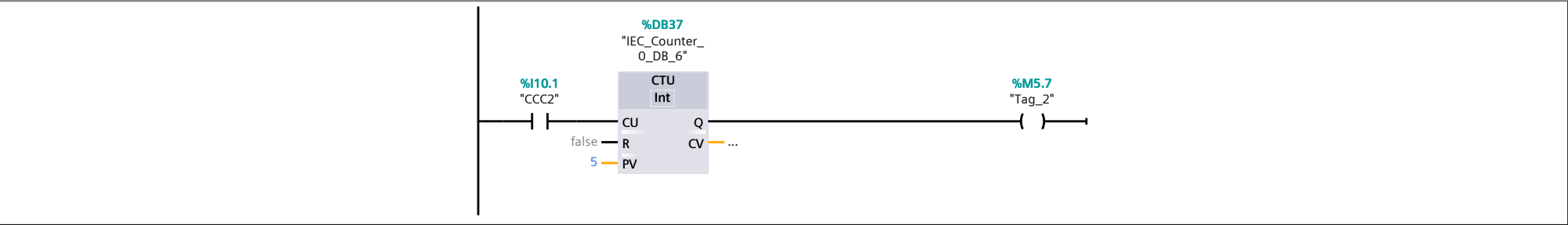
A_COUNTER Properties							
General							
Name	A_COUNTER	Number	12	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

A_COUNTER										
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										

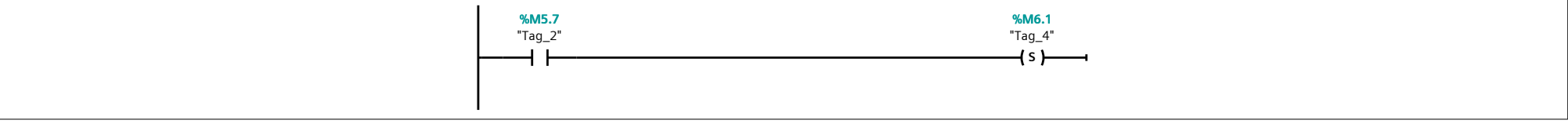
Network 1:



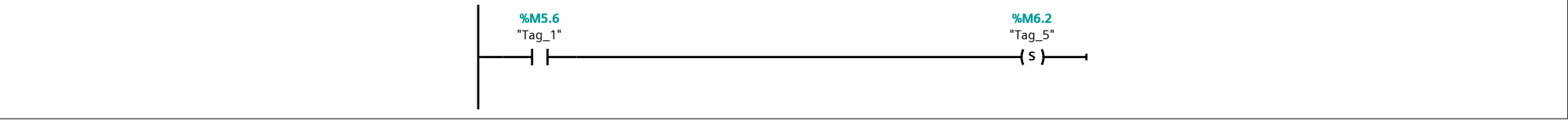
Network 2:



Network 3:



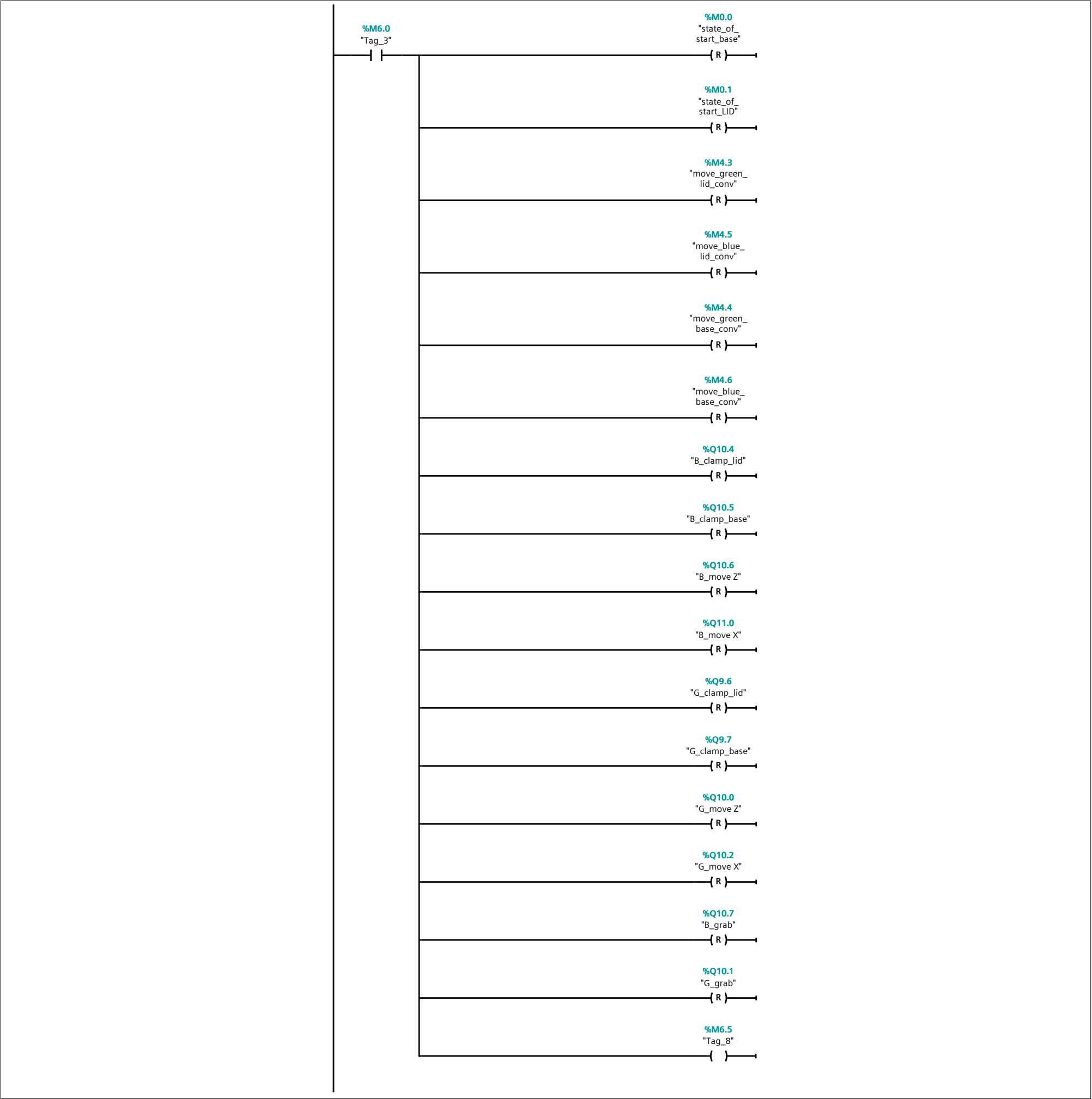
Network 4:



Network 5:



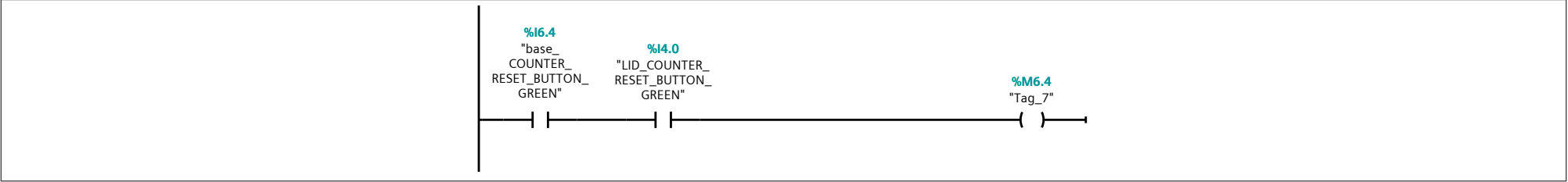
Network 6:






















































**Network 7:**




**Network 8:**























## PLC tags

	Name	Data type	Address	Retain	Accessi-ble from HMI/OPC UA	Writable from HMI/OPC UA	Visible in HMI engi-neering	Supervision	Comment
	lid_detection	Bool	%I0.0		True	True	True		
	stop_beginning_lid_sensor	Bool	%I0.1		True	True	True		
	start_LID_feeding_convyer	Bool	%I0.2		True	True	True		
	LID_detected_grip	Bool	%I0.3		True	True	True		
	stop_LID_Feeding	Bool	%I0.4		True	True	True		
	LID_machining_entrance_sensor	Bool	%I0.5		True	True	True		
	base_Raw_counter_start	Bool	%I0.6		True	True	True		
	stop_base_begininning_convyr	Bool	%I0.7		True	True	True		
	base_gripper_detected	Bool	%I1.0		True	True	True		
	start_base_raw_feeding	Bool	%I1.1		True	True	True		
	stop_base_raw_feeding	Bool	%I1.2		True	True	True		
	stop_base_machining_convyr	Bool	%I1.3		True	True	True		
	lid_start_button	Bool	%I1.4		True	True	True		
	lid_stop_button	Bool	%I1.5		True	True	True		
	lid_emergency_button	Bool	%I1.6		True	True	True		
	base_start_button	Bool	%I1.7		True	True	True		
	base_stop_button	Bool	%I2.0		True	True	True		
	base_emergency	Bool	%I2.1		True	True	True		
	Lid_beginning_conveyr	Bool	%Q0.0		True	True	True		
	lid_feeding_conveyr	Bool	%Q0.1		True	True	True		
	Lid_pickup_x_axis	Bool	%Q0.3		True	True	True		
	lid_pickup_z_axis	Bool	%Q0.4		True	True	True		
	lid_suction_gripper	Bool	%Q0.5		True	True	True		
	base_beginning_conveyr	Bool	%Q0.6		True	True	True		
	lid-machinning_conveyr	Bool	%Q0.2		True	True	True		
	base_raw_feeding_conveyr	Bool	%Q0.7		True	True	True		
	base_to_machinning_conveyr	Bool	%Q1.0		True	True	True		
	base_pickup_x_axis	Bool	%Q1.1		True	True	True		
	base_pickup_z_axis	Bool	%Q1.2		True	True	True		
	base_suction_gripper	Bool	%Q1.3		True	True	True		
	base_start_button_1_light	Bool	%Q1.4		True	True	True		
	base_stop_button_1_light	Bool	%Q1.5		True	True	True		
	lid_start_light	Bool	%Q1.6		True	True	True		
	lid_stop_button_1_light	Bool	%Q1.7		True	True	True		
	base_raw_material	Bool	%Q2.0		True	True	True		
	lid_raw_emit	Bool	%Q2.1		True	True	True		
	state_of_start_base	Bool	%M0.0		True	True	True		
	state_of_start_LID	Bool	%M0.1		True	True	True		
	state_of_lid	Bool	%M0.2		True	True	True		
	dummy	Bool	%M0.3		True	True	True		
	To_emit_lid	Bool	%M0.4		True	True	True		
	item_ready_to_picked	Bool	%M0.5		True	True	True		
	movin_lid_z_mem	Bool	%M0.6		True	True	True		
	LID_moving_z_sensor	Bool	%I2.4		True	True	True		
	LID_moving_x_sensor	Bool	%I2.5		True	True	True		
	dummy(1)	Bool	%M0.7		True	True	True		
	dummy(2)	Bool	%M1.0		True	True	True		
	lid_belt_convyer_excess	Bool	%Q2.2		True	True	True		
	push_excess_blue_lid	Bool	%Q2.3		True	True	True		
	push_excess_green_lid	Bool	%Q2.4		True	True	True		
	Blue_vision_lid	Bool	%I2.6		True	True	True		
	green_vision_lid	Bool	%I2.7		True	True	True		
	front_blue_push_lid	Bool	%I3.0		True	True	True		
	back_blue_push_lid	Bool	%I3.1		True	True	True		
	front_green_push_lid	Bool	%I3.2		True	True	True		
	back_green_push_lid	Bool	%I3.3		True	True	True		
	into_cnc_lid_sensor	Bool	%I3.4		True	True	True		



Totally Integrated Automation Portal										
	Name	Data type	Address	Retain	Accessi-ble from HMI/OPC UA	Writable from HMI/OPC UA	Visible in HMI engi-neering	Supervision	Comment	
	CNC_lid_empty	Bool	%M1.1		True	True	True			
	ONE_OBJECT_IN	Bool	%Q2.5		True	True	True			
	KEEP_DISTANCE	Bool	%Q2.6		True	True	True			
	ARE_WE_THERE_YET_BLUE_lid	Bool	%M1.2		True	True	True			
	ARE_WE_THERE_YET_GREEN_lid	Bool	%M1.3		True	True	True			
	LID_COUNTER_RESET_BUTTON_BLUE	Bool	%I3.5		True	True	True			
	TO_STORAGE_BLUE_CONVYER_lid	Bool	%Q2.7		True	True	True			
	TO_STORAGE_GREEN_CONVYER_lid	Bool	%Q3.0		True	True	True			
	TO_STORAGE_BLUE_SENSOR_lid	Bool	%I3.6		True	True	True			
	TO_STORAGE_GREEN_SENSOR_lid	Bool	%I3.7		True	True	True			
	LID_COUNTER_RESET_BUTTON_GREEN	Bool	%I4.0		True	True	True			
	GREEN_LID_PUSHER_SORTING(FRONT LIMIT)	Bool	%I4.1		True	True	True			
	GREEN_LID_PUSHER_SORTING(BACK LIMITT)	Bool	%I4.2		True	True	True			
	BLUE_LID_PUSHER_SORTING(FRONT LIMIT)	Bool	%I4.3		True	True	True			
	BLUE_LID_PUSHER_SORTING(BACK LIMIT)	Bool	%I4.4		True	True	True			
	BEGIN_SORTING_STATION_LIDS	Bool	%I4.5		True	True	True			
	BLUE_LID_VISION_SORTING	Bool	%I4.6		True	True	True			
	GREEN_LID_VISION_SORTING	Bool	%I4.7		True	True	True			
	SORTING_CONVYER_LID	Bool	%Q3.1		True	True	True			
	GREEN_LID_PUSHER_SORTING	Bool	%Q3.2		True	True	True			
	BLUE_LID_PUSHER_SORTING	Bool	%Q3.3		True	True	True			
	CNC_base_empty	Bool	%M2.5		True	True	True			
	to_emit_base	Bool	%M1.5		True	True	True			
	base_into_cnc	Bool	%I5.0		True	True	True			
	BASE_MOVE_X_SENSOR	Bool	%I5.1		True	True	True			
	BASE_MOVE_Z_SENSOR	Bool	%I5.2		True	True	True			
	DUMMY1	Bool	%M1.6		True	True	True			
	DUMMY2	Bool	%M1.7		True	True	True			
	DUMMY3	Bool	%M2.0		True	True	True			
	DUMMY4	Bool	%M2.1		True	True	True			
	DUMMY5	Bool	%M2.2		True	True	True			
	BASE_RAW_EXESS_CONV	Bool	%Q3.4		True	True	True			
	Are_we_there_base_raw_blue	Bool	%M2.3		True	True	True			
	Are_we_there_base_raw_green	Bool	%M2.4		True	True	True			
	base_raw_blue_exes_vision	Bool	%I5.3		True	True	True			
	base_raw_green_exes_vision	Bool	%I5.4		True	True	True			
	to_blue_base_raw_storage_sensor	Bool	%I5.5		True	True	True			
	to_green_base_raw_storage_sensor	Bool	%I5.6		True	True	True			
	push_ex_green_base raw(front)	Bool	%I5.7		True	True	True			
	push_ex_green_base raw (back)	Bool	%I6.0		True	True	True			
	pusher blue base raw (front)	Bool	%I6.1		True	True	True			
	pusher blue base raw (back)	Bool	%I6.2		True	True	True			
	MachineCenter1_lid_start	Bool	%Q3.5		True	True	True			
	MachineCenter1_lid_produceLids	Bool	%Q3.6		True	True	True			
	push_excess_blue_base	Bool	%Q3.7		True	True	True			
	push_excess_green_base	Bool	%Q4.0		True	True	True			
	base_COUNTER_RESET_BUTTON_BLUE	Bool	%I6.3		True	True	True			
	base_COUNTER_RESET_BUTTON_GREEN	Bool	%I6.4		True	True	True			
	base_raw_excess_blue	Bool	%Q4.1		True	True	True			
	base_raw_excess_green	Bool	%Q4.2		True	True	True			
	base_vision_raw_execcess_sensor_green	Bool	%I6.5		True	True	True			
	base_vision_raw_execcess_sensor_blue	Bool	%I6.6		True	True	True			
	MachineCenter2_base_start	Bool	%Q4.3		True	True	True			
	is_base_exist	Bool	%M1.4		True	True	True			
	Stop_blade4	Bool	%Q4.4		True	True	True			



Totally Integrated Automation Portal										
	Name	Data type	Address	Retain	Accessi-ble from HMI/OPC UA	Writable from HMI/OPC UA	Visible in HMI engi-neering	Supervision	Comment	
	G_Timer_1	Timer	%T0		True	True	True			
	G_Timer_2	Timer	%T1		True	True	True			
	G_Timer_3	Timer	%T2		True	True	True			
	B_Timer_1	Timer	%T3		True	True	True			
	B_Timer_2	Timer	%T4		True	True	True			
	B_Timer_3	Timer	%T5		True	True	True			
	Green_Lid_conv_timer	Timer	%T6		True	True	True			
	Blue_Lid_conv_timer	Timer	%T7		True	True	True			
	Green_Base_conv_timer	Timer	%T8		True	True	True			
	Blue_Base_conv_timer	Timer	%T9		True	True	True			
	G_lids_conv_1	Bool	%Q7.0		True	True	True			
	G_lids_conv_2	Bool	%Q7.1		True	True	True			
	G_lids_conv_3	Bool	%Q7.2		True	True	True			
	G_lids_conv_4	Bool	%Q7.3		True	True	True			
	G_lids_conv_5	Bool	%Q7.4		True	True	True			
	G_lids_conv_6	Bool	%Q7.5		True	True	True			
	G_lids_conv_7	Bool	%Q7.6		True	True	True			
	G_lids_conv_8	Bool	%Q7.7		True	True	True			
	B_lids_conv_1	Bool	%Q8.0		True	True	True			
	B_lids_conv_2	Bool	%Q8.1		True	True	True			
	B_lids_conv_3	Bool	%Q8.2		True	True	True			
	B_lids_conv_4	Bool	%Q8.3		True	True	True			
	G_base_conv_1	Bool	%Q8.4		True	True	True			
	G_base_conv_2	Bool	%Q8.5		True	True	True			
	G_base_conv_3	Bool	%Q8.6		True	True	True			
	G_base_conv_4	Bool	%Q8.7		True	True	True			
	G_base_conv_5	Bool	%Q9.0		True	True	True			
	G_base_conv_6	Bool	%Q9.1		True	True	True			
	B_base_conv_1	Bool	%Q9.2		True	True	True			
	B_base_conv_2	Bool	%Q9.3		True	True	True			
	B_base_conv_3	Bool	%Q9.4		True	True	True			
	B_base_conv_4	Bool	%Q9.5		True	True	True			
	G_clamp_lid	Bool	%Q9.6		True	True	True			
	G_clamp_base	Bool	%Q9.7		True	True	True			
	G_move Z	Bool	%Q10.0		True	True	True			
	G_grab	Bool	%Q10.1		True	True	True			
	G_move X	Bool	%Q10.2		True	True	True			
	G_pos.Raise_bases	Bool	%Q10.3		True	True	True			
	B_clamp_lid	Bool	%Q10.4		True	True	True			
	B_clamp_base	Bool	%Q10.5		True	True	True			
	B_move Z	Bool	%Q10.6		True	True	True			
	B_grab	Bool	%Q10.7		True	True	True			
	B_move X	Bool	%Q11.0		True	True	True			
	B_pos.Raise_bases	Bool	%Q11.1		True	True	True			
	CCC1	Bool	%I10.0		True	True	True			
	CCC2	Bool	%I10.1		True	True	True			
	Tag_1	Bool	%M5.6		True	True	True			
	Tag_2	Bool	%M5.7		True	True	True			
	Tag_3	Bool	%M6.0		True	True	True			
	Tag_4	Bool	%M6.1		True	True	True			
	Tag_5	Bool	%M6.2		True	True	True			
	Tag_6	Bool	%M6.3		True	True	True			
	Tag_7	Bool	%M6.4		True	True	True			
	Tag_8	Bool	%M6.5		True	True	True			
	Tag_9	Bool	%M6.6		True	True	True			