Totally Integrated Automation Portal	
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Project / PLC_2 [CPU 319-3 PN/DP] / Program blocks

Assembly_Green [FB10]

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

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

Network 1:

```
#B.4

"G_lid in place"

N_TRIG

CLK

%M4.0

"G_Negative_Trig_1"

WM4.3

"move_green_lid"

( S )

"move_green_lid"

( R )
```

Network 2:

```
%I8.5

"G_base in place"

CLK

%M4.1

"G_Negative_
Trig_2"

%M4.4

"move_green_
base_conv"

(R)
```

Network 3:

Network 4:

```
Totally Integrated
   Automation Portal
                                                                            %I9.1
"G_item_detect"
                                                                                                                                                          %Q9.6
"G_clamp_lid"
                                                                                                                                                              -( R }--
                                                                                                                                                             %Q9.7
                                                                                                                                                         "G_clamp_base"
                                                                                                                                                              _( R )___
                                                                                                                                                           %Q10.0
"G_move Z"
                                                                                                                                                              _( R )__
                                                                                                                                                           %Q10.2
"G_move X"
                                                                                                                                                             -( s )-
                                                                                                                                                          %M5.2
"G_Detected_
Memory"
                                                                                                                                                              -( s )-
Network 5:
                                                                                                %T0
"G_Timer_1"
                                                                                %M5.2
                                                                             "G_Detected_
Memory"
                                                                                                                                                           %Q10.0
"G_move Z"
                                                                                               S_ODT
                                                                                                                                                              -( s )-
                                                                                                %M5.3
"G_Reset"
                                                                                                         BCD — ...
                                                                                  \dashv \vdash
Network 6:
                                                                                                 %T1
"G_Timer_2"
                                                                              %M5.2
"G_Detected_
Memory"
                                                                                                                                                            %Q10.1
"G_grab"
                                                                                               S_ODT
                                                                                               -( R )-
                                                                                    S5T#5S — TV
                                                                                                         BCD — ...
                                                                               %M5.3
"G_Reset"
                                                                                                                                                           %Q10.0
"G_move Z"
                                                                                                                                                             —( R )—
                                                                                                                                                            %Q10.2
                                                                                                                                                           "G_move X"
                                                                                                                                                              _( R )_
Network 7:
                                                                                                 %T2
"G_Timer_3"
                                                                              %M5.2
"G_Detected_
Memory"
                                                                                                                                                             %M4.4
                                                                                                                                                          "move_green_
base_conv"
                                                                                               S_ODT
                                                                                                                                                              -( s )-
                                                                                                           Q-
                                                                                     S5T#6S — TV
                                                                                                          ві — ...
                                                                                                         BCD — ...
                                                                               %M5.3
"G_Reset"
                                                                                                                                                             %M4.3
                                                                                                                                                          "move_green_
lid_conv"
                                                                                                                                                          %Q10.3
"G_pos.Raise_
bases"
                                                                                                                                                              -( s )-
Network 8:
                                                                                                                                                             %Q10.3
                                                                                                                                                          "G_pos.Raise_
bases"
                                                                            "G_part_leaving"
                                                                                               N_TRIG
                                                                                                CLK Q -
                                                                                                "G_Negative_
Trig_3"
                                                                                                                                                             %M5.2
                                                                                                                                                          "G_Detected_
Memory"
                                                                                                                                                             _( R )_
                                                                                                                                                            %M5.3
"G_Reset"
```