Totally Integr Automation I											
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					

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

User-defined ID

Network 1: LID STARTING HANDLE

0.1

Version

Network 2: LID_BEGINNING_COVNVYER

Network 3: LID_EMITTER_HANDLER

```
%IO.1 "IEC_Timer_O_DB"

"state_of_ beginning_lid_ %IO.0 TOF %MO.4 start_LID" sensor" "lid_detection" Time "To_emit_lid"

T#500ms PT ET ...
```

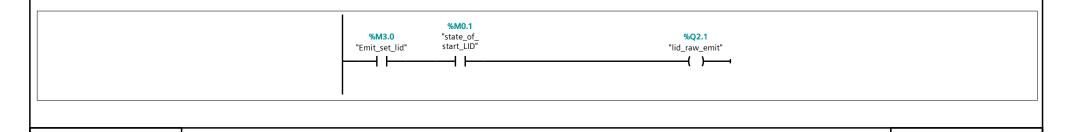
Network 4: FIRST LID TO EMIT

```
%DB2
"IEC_Timer_O_
DB_1"

NH.4
"Iid_start_button"

T#600ms — T#600
```

Network 5: Emit emergency handle lid



```
Totally Integrated
  Automation Portal
Network 6: LID_PICKUP_ROBOT
                                                                              %DB11
                                                                            "PICK_UP_LID_
ROBOT_DB"
                                                                              %FB1
                                                                        "PICK_UP_LID_ROBOT"
                                                                                           ENO
                                                                   - EN
Network 7: FEEDING_CONVYER_HANDLER_LID
                                                                                                                                      %Q0.1
"lid_feeding_
conveyr"
                                                                                       %M0.1
                                                                                     "state_of_
start_LID"
                                                                      %M1.1
                                                                  "CNC_lid_empty"
Network 8: LID_MACHINNING_CONVYER
                                                                                       %M0.1
                                                                                     "state_of_
start_LID"
                                                                                                                                     "lid-machinning_
conveyr"
                                                                      %M1.1
                                                                  "CNC_lid_empty"
Network 9: DETECT_IS_ANY_PART_IN_CNC_LID
                                                                                       %DB6
                                                                                    "IEC_Timer_0_
DB_5"
                                                                      %I3.4
                                                                   "into_cnc_lid_
sensor"
                                                                                        TOF
                                                                                                                                         %M1.1
                                                                                                                                     "CNC_lid_empty"
                                                                         T#500MS — PT
                                                                                             ET -
Network 10: LID_KEEP_DISTANCE
                                                                  %M1.1 %Q2.6
"CNC_lid_empty" "KEEP_DISTANCE"
                                                                                                                                    %Q2.5
"ONE_OBJECT_IN"
Network 11: LID_execess_station
                                                                              %DB14
                                                                          "LID_execess_
remove_station_
DB"
                                                                               %FB4
                                                                     "LID_execess_remove_station"
                                                                                            ENO
                                                                   EN
Network 12: CNC
                                                                                                                                     %Q3.6
"MachineCenter1
                                                                                  %Q3.5
"MachineCenter1
__lid_start"
                                                                                                                                      _lid_
produceLids"
                                                                      %M1.1
                                                                  "CNC_lid_empty"
Network 13: SORTING_STATION
                                                                           %DB12
"LID_SORTING_
STATION_DB"
                                                                              %FB3
                                                                       "LID_SORTING_STATION"
                                                                                           ENO -
```