Totally Integrated	
Automation Portal	

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

Assembly_Blue [FB11]

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

Assembly_Blue									
Name	Data type	Offset	Default value	HMI/OPC UA	able	HMI engi-		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

```
"B_base in place"

CLK

WM5.0

"B_Negative_Trig_2"

"M4.6

"move_blue_base_conv"

(R)
```

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

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

Totally Integrated **Automation Portal %I9.7**"B_item_detect" %Q10.4 "B_clamp_lid" **-(** R **)**-%Q10.5 "B_clamp_base" -(R)-**%Q10.6** "B_move Z" **-(** R **)**− **%Q11.0**"B_move X" **-(** s **)**-**%M5.4**"B_Detected_
Memory" **-(** s **)**-Network 5: lower z after 3 s **%T3** "B_Timer_1" %M5.4 "B_Detected_ Memory" **%Q10.6** "B_move Z" S_ODT **-(** s **)-**ВІ — ... BCD — ... %M5.5 "B_Reset" Network 6: ungrab, raise z and unextend x after 5s **%T4** "B_Timer_2" **%M5.4**"B_Detected_
Memory" **%Q10.7** "B_grab" S_ODT **-(** R **)**-Q-S5T#5S — **TV** ВІ — ... **%M5.5**"B_Reset" BCD — ... **%Q10.6** "B_move Z" **-(** R **)**-%Q11.0 "B_move X" -(R)-Network 7: turn conv on and raise post after 6 s **%T5** "B_Timer_3" **%M5.4**"B_Detected_
Memory" **%M4.6**"move_blue_base_conv" S_ODT Q-S5T#6S — TV ві — ... **%M5.5**"B_Reset" BCD --- ... %M4.5 "move_blue_ lid_conv" %Q11.1 "B_pos.Raise_ bases" **-(** s **)**-Network 8: lower post after part leaves %Q11.1 "B_pos.Raise_ bases" "B_part_leaving" N_TRIG CLK Q - %M5.1 "B_Negative_ Trig_3" %M5.4 "B_Detected_ Memory" _(R)_ **%M5.5**"B_Reset"