Totally Integrated	
Automation Portal	

# 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			able	HMI engi-	Setpoint	Supervi- sion	Comment
Input									
Output									
InOut									
Static									
Temp									
Constant									

#### Network 1:

```
"Green_Lid_
conv_timer"
    %18.0
                                               %M5.2
                                                                                          %M4.3
"Assembly
green lid start"
                                           "G_Detected_
Memory"
                                                                                      "move_green_
lid_conv"
                          %18.6
                                                                S_ODT
                    "G_lid_clamped"
                                                                                          -( s )-
                                                                             Q-
                                                     S5T#3S — TV
                                                                             ВІ — ...
                                                                          BCD — ...
    %M5.3
   "G_Reset"
```

#### Network 2:

```
"Blue_Lid_
conv_timer"
    %I8.1
                                            %M5.4
                                                                                    %M4.5
"Assembly blue
lid start"
                                                                                 "move_blue_
lid_conv"
                        %19.4
                                         "B_Detected_
                                                            S_ODT
                    "B_lid_clamped"
                                          Memory"
                                                                        Q-
                                                                                    -( s )-
                                                 S5T#3S — TV
                                                                        ВІ — ...
                                                                      BCD — ...
    %M5.5
   "B_Reset"
     +
```

#### Network 3:

```
%I8.2
"Assembly green base start"
                                                                      %T8
                                                                  "Green_Base_
conv_timer"
                         %18.7
                                               %M5.2
                                                                                           %M4.4
                       "G_base_
clamped"
                                                                                        "move_green_
base_conv"
                                           "G_Detected_
                                             Memory"
                                                                  S_ODT
                                                                                            -( s )-
                                                                              Q-
                                                     S5T#3S — TV
                                                                              ВІ — ...
                                                                            BCD — ...
   %M5.3
 "G_Reset"
```

### Network 4:

```
%T9
                                                            "Blue_Base_
conv_timer"
                                           %M5.4
    %18.3
                        %19.5
                                                                                  %M4.6
                     "B_base_
clamped"
                                                                             "move_blue_
base_conv"
"Assembly blue
                                        "B_Detected_
                                         Memory"
 base start"
                                                           S_ODT
                                                                      Q _____
                                                                                  -( s )-
                                                S5T#3S — TV
                                                                    BCD — ...
    %M5.5
   "B_Reset"
     -| |-
```

#### Network 5:

```
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                                                                        %M4.3
                                                                     "move_green_
lid_conv"
                                                                                                                                         %Q7.0
"G_lids_conv_1"
                                                                                                                                             →
                                                                                                                                         %Q7.1
"G_lids_conv_2"
                                                                                                                                             →
                                                                                                                                        %Q7.2
"G_lids_conv_3"
———( )———
                                                                                                                                            %Q7.3
                                                                                                                                         "G_lids_conv_4"
                                                                                                                                             %Q7.4
"G_lids_conv_5"
                                                                                                                                             →
                                                                                                                                         %Q7.5
"G_lids_conv_6"
                                                                                                                                         %Q7.6
"G_lids_conv_7"
                                                                                                                                             %Q7.7
                                                                                                                                         "G_lids_conv_8"
                                                                                                                                            \prec \longrightarrow
Network 6:
                                                                       %M4.4
                                                                     "move_green_
base_conv"
                                                                                                                                        %Q8.4
"G_base_conv_1"
                                                                                                                                             %Q8.5
"G_base_conv_2"
                                                                                                                                             %Q8.6
                                                                                                                                        "G_base_conv_3"
                                                                                                                                             %Q8.7
"G_base_conv_4"
                                                                                                                                            %Q9.0
                                                                                                                                         "G_base_conv_5"
                                                                                                                                            →
                                                                                                                                        %Q9.1
"G_base_conv_6"
                                                                                                                                             → →
Network 7:
                                                                        %M4.6
                                                                      "move_blue_
base_conv"
                                                                                                                                        %Q9.2
"B_base_conv_1"
                                                                        \dashv \vdash
                                                                                                                                            %Q9.3
                                                                                                                                         "B_base_conv_2"
                                                                                                                                            %Q9.4
                                                                                                                                        "B_base_conv_3"
                                                                                                                                        %Q9.5
"B_base_conv_4"
Network 8:
```

