

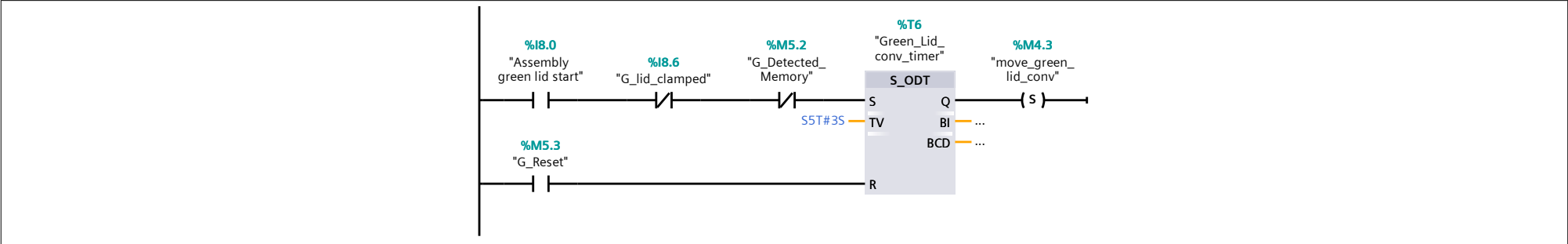
Project / PLC_2 [CPU 319-3 PN/DP] / Program blocks

Assembly_conv [FB9]

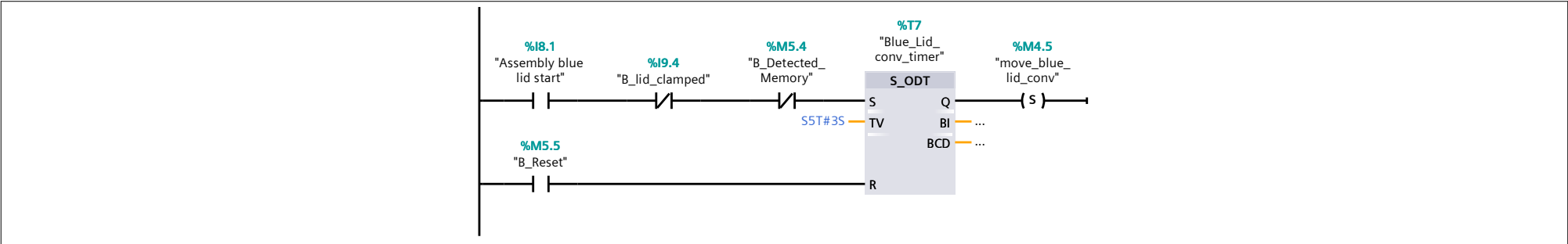
Assembly_conv Properties							
General							
Name	Assembly_conv	Number	9	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

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										

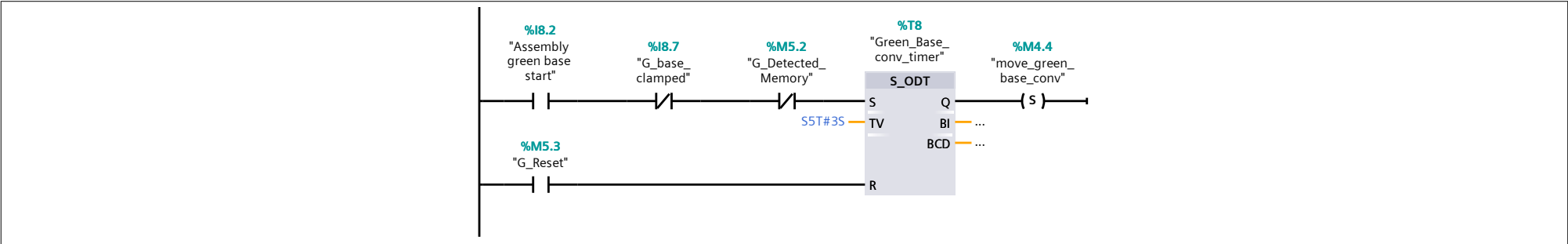
Network 1:



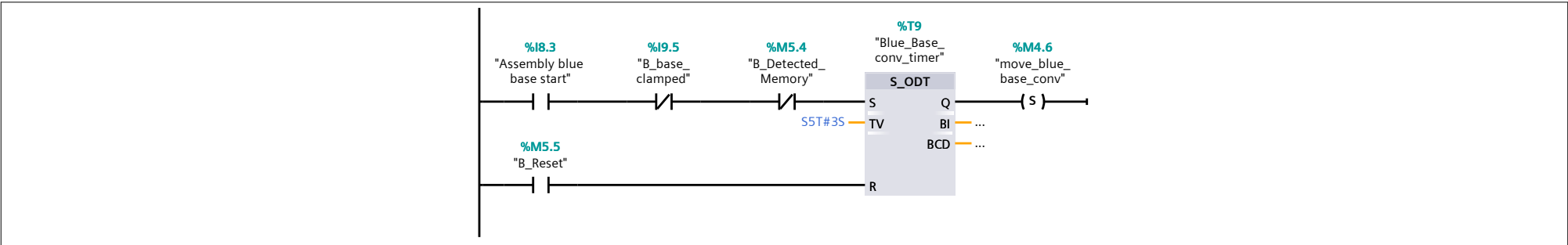
Network 2:



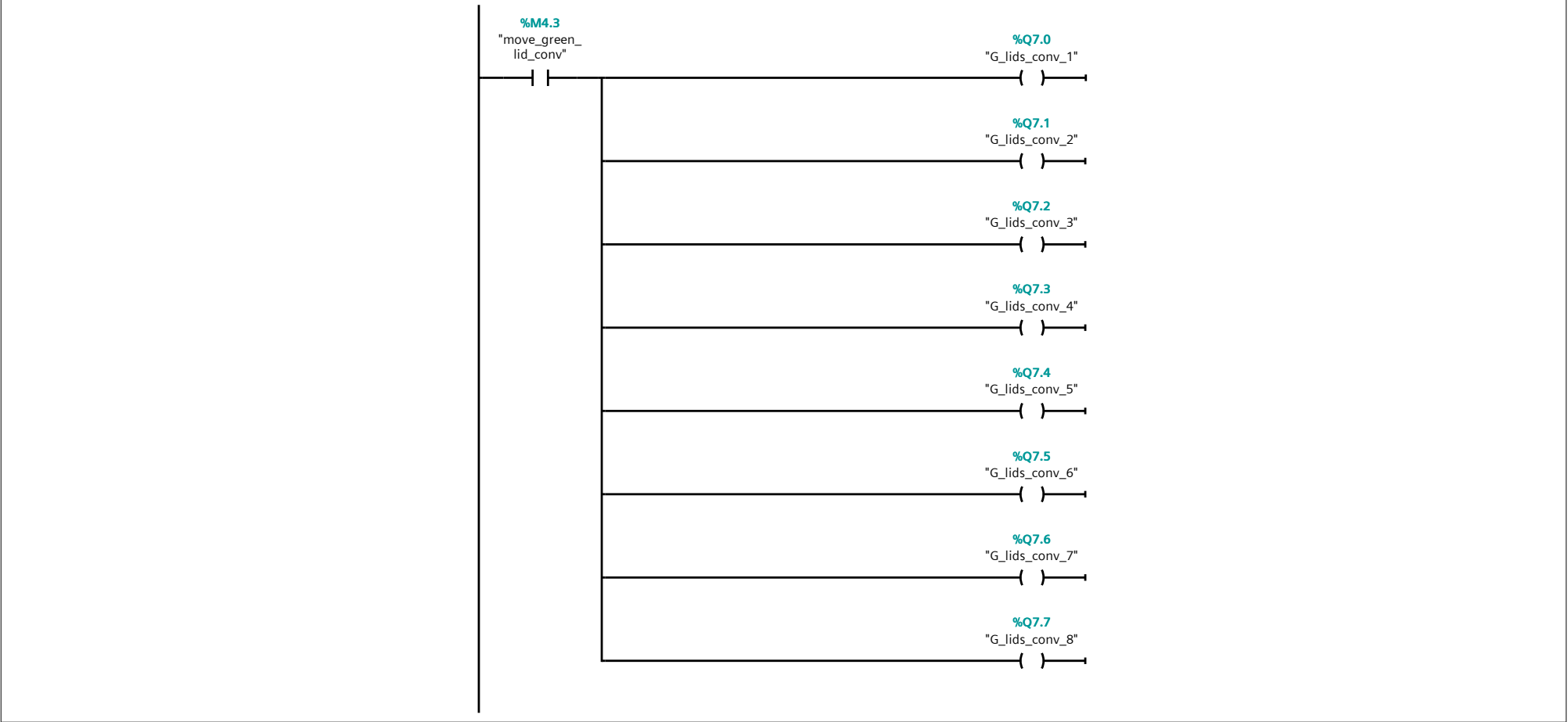
Network 3:



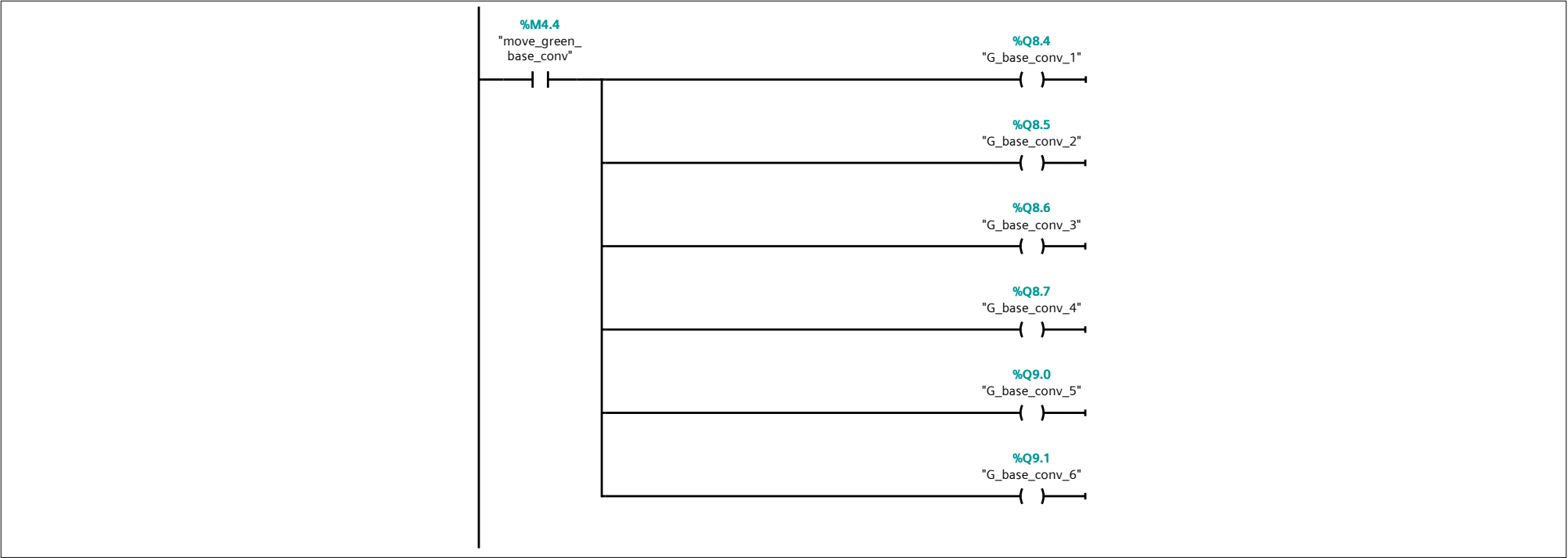
Network 4:



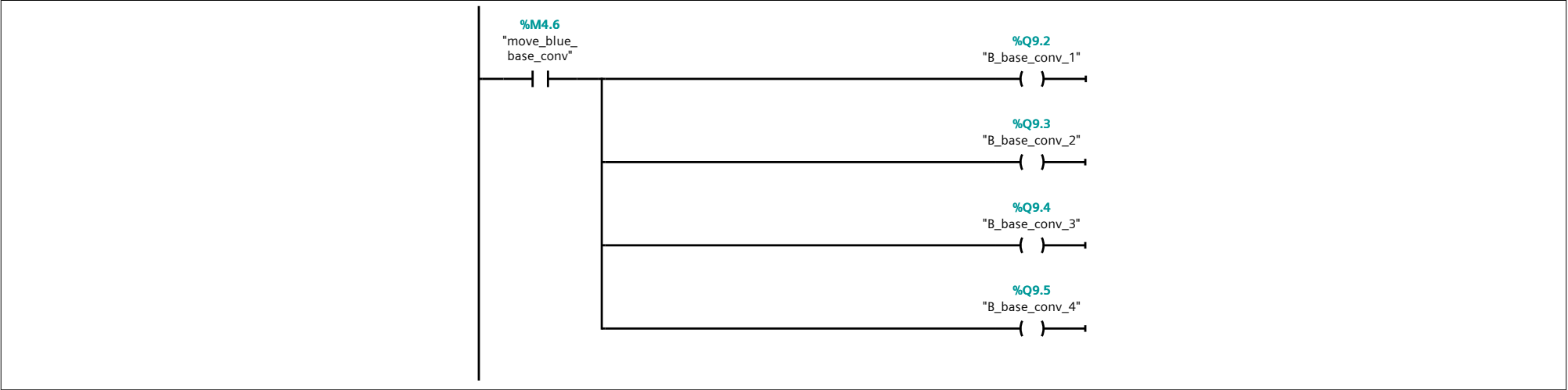
Network 5:



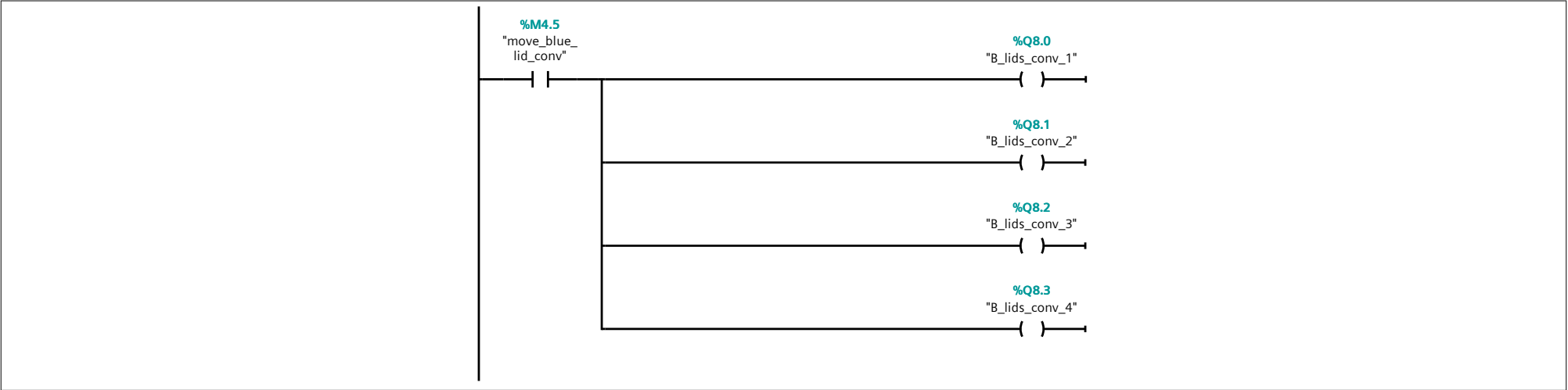
Network 6:



Network 7:



Network 8:



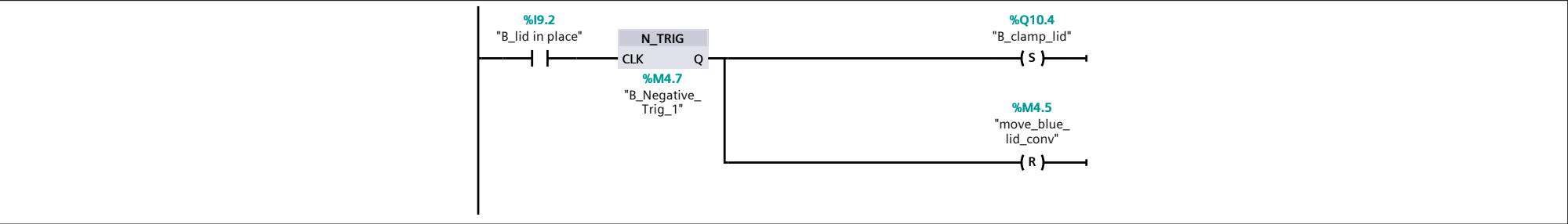
Project / PLC_2 [CPU 319-3 PN/DP] / Program blocks

Assembly_Blue [FB11]

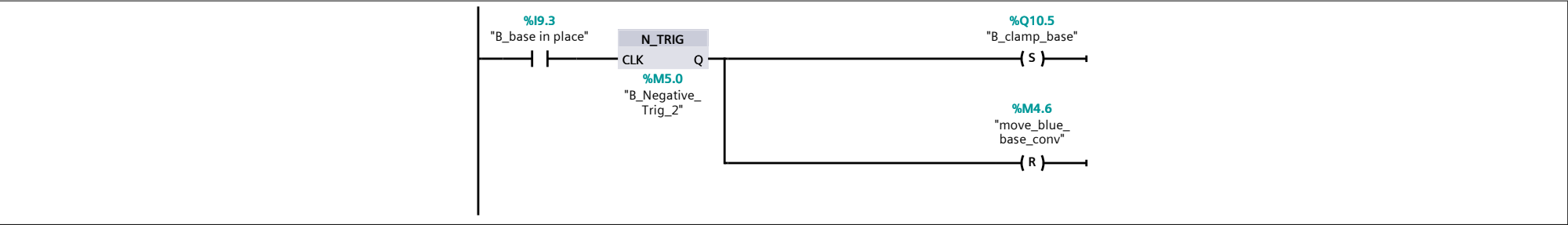
Assembly_Blue Properties							
General							
Name	Assembly_Blue	Number	11	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

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										

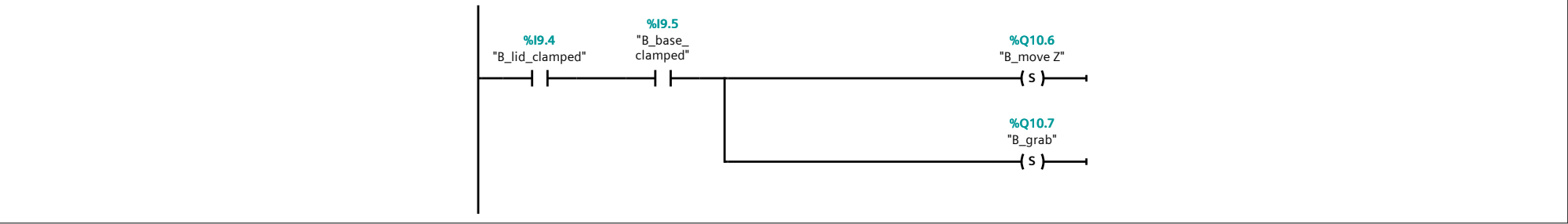
Network 1: Clamp when blue lid in place



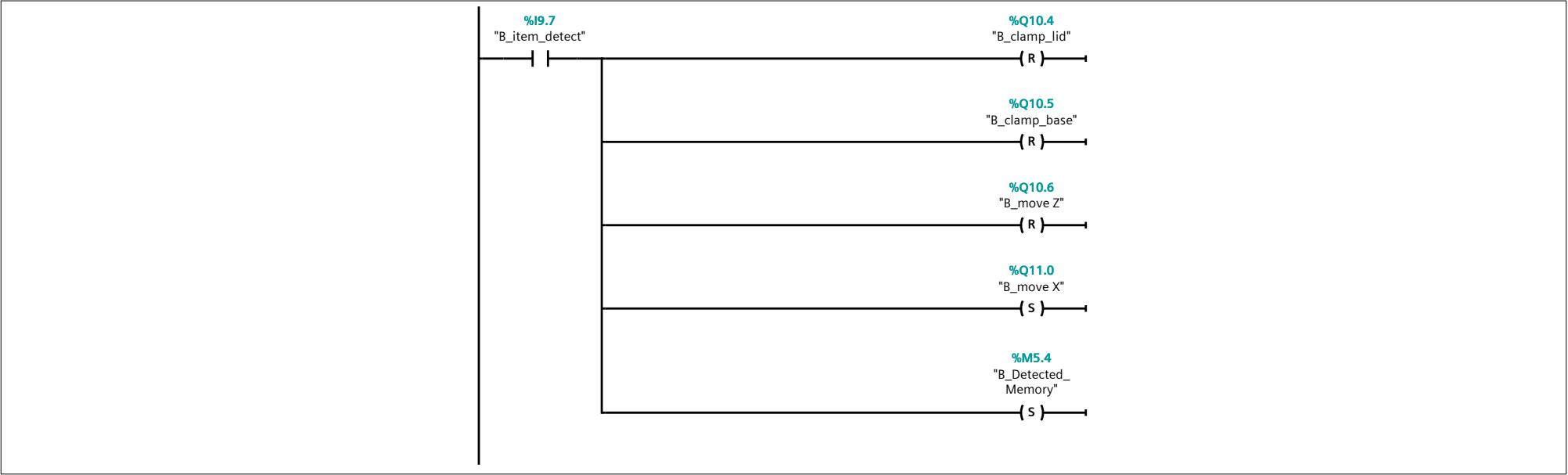
Network 2: Clamp when blue base in place



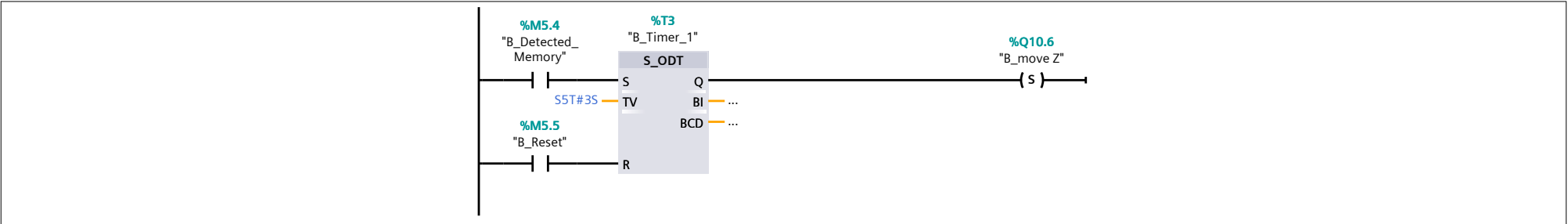
Network 3: move Z and Grab when Base and Lid clamped



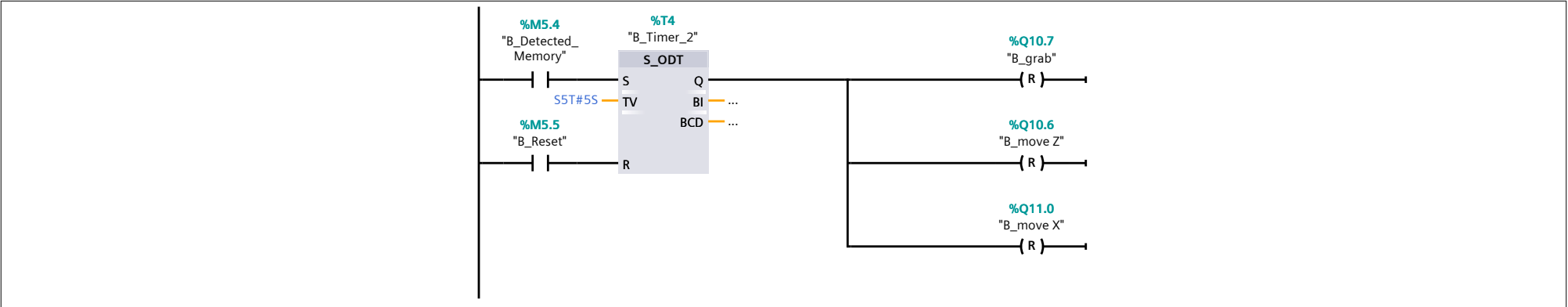
Network 4: unclamp when item detected, raise z and extend x



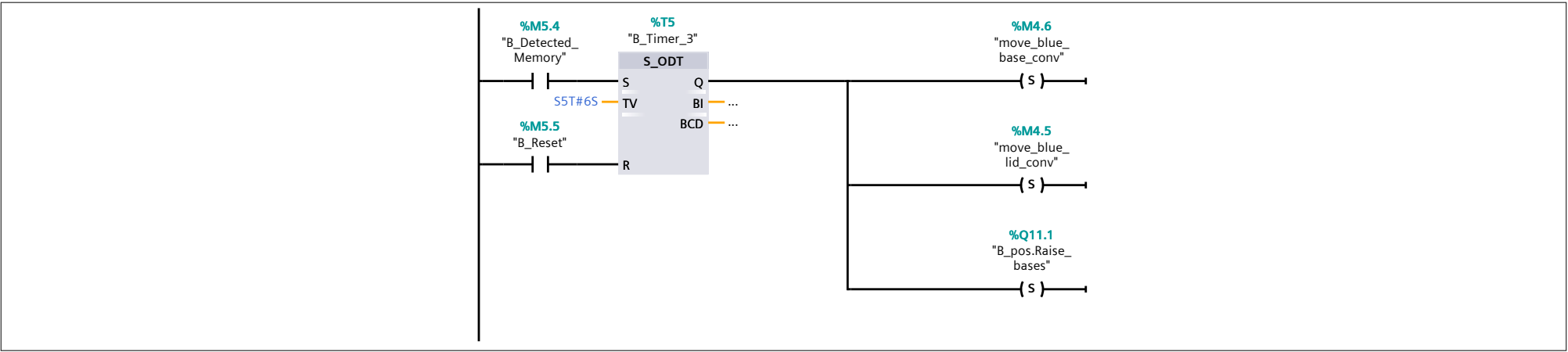
Network 5: lower z after 3 s



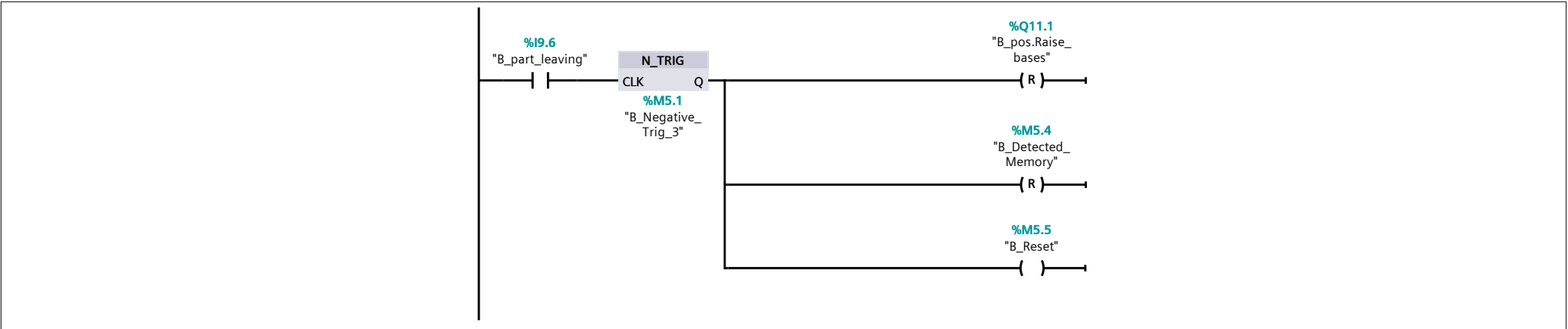
Network 6: ungrab, raise z and unextend x after 5s



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



Network 8: lower post after part leaves



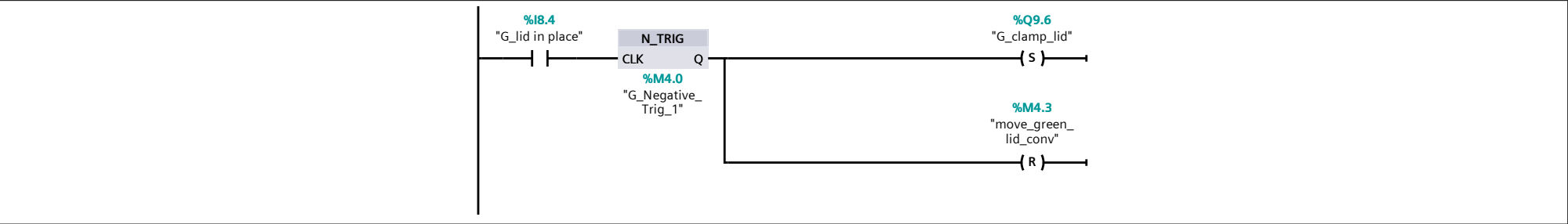
Project / PLC_2 [CPU 319-3 PN/DP] / Program blocks

Assembly_Green [FB10]

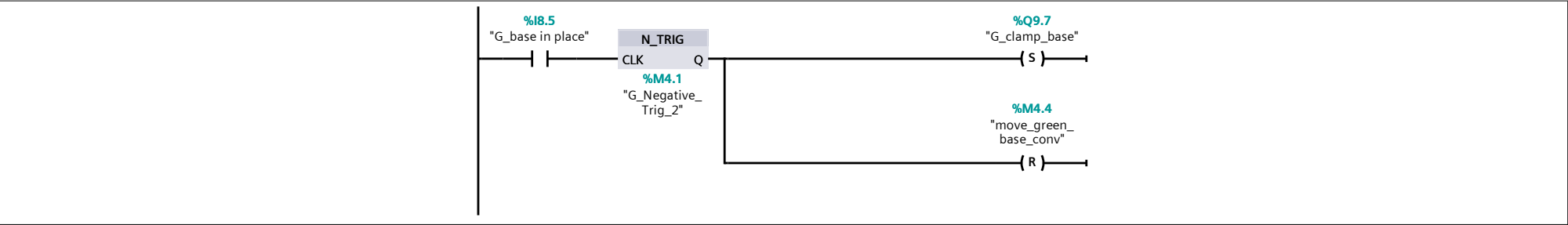
Assembly_Green Properties							
General							
Name	Assembly_Green	Number	10	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

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										

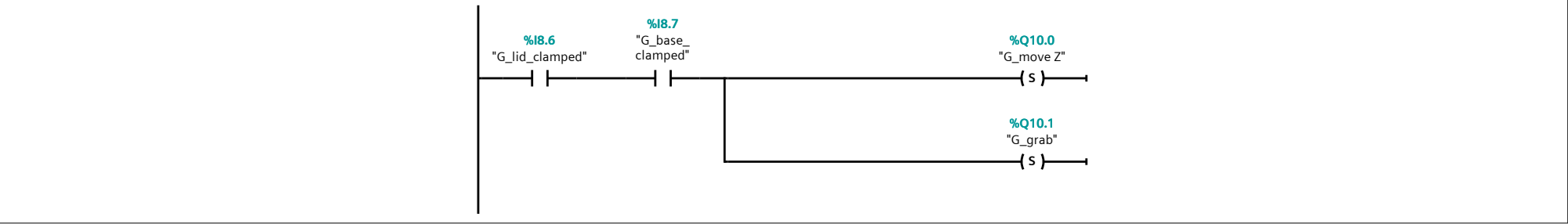
Network 1:



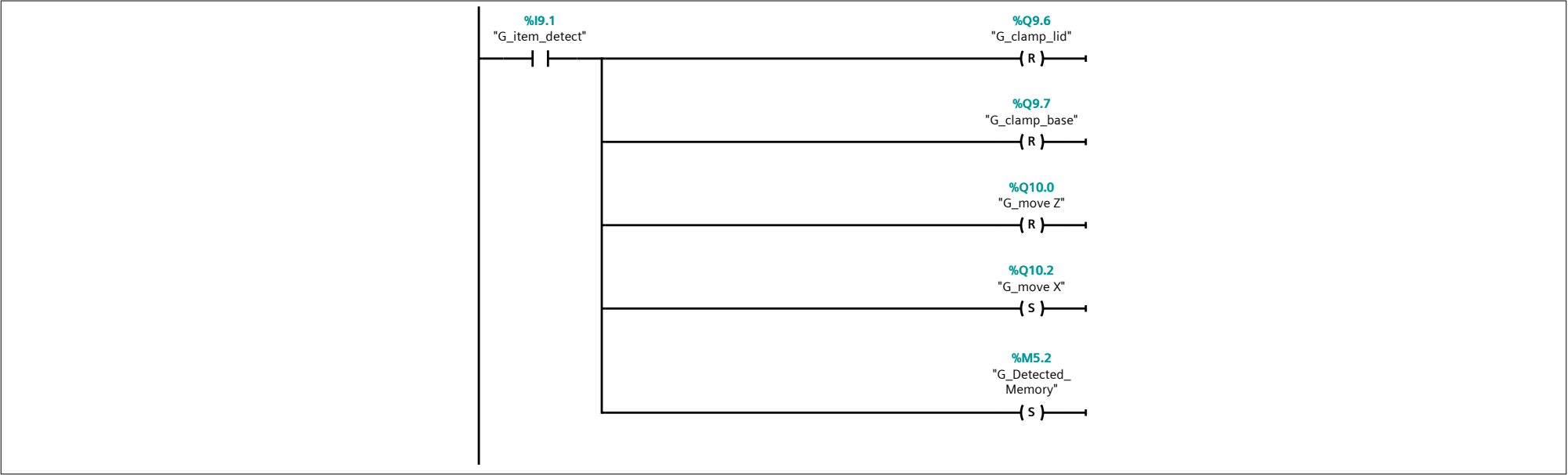
Network 2:



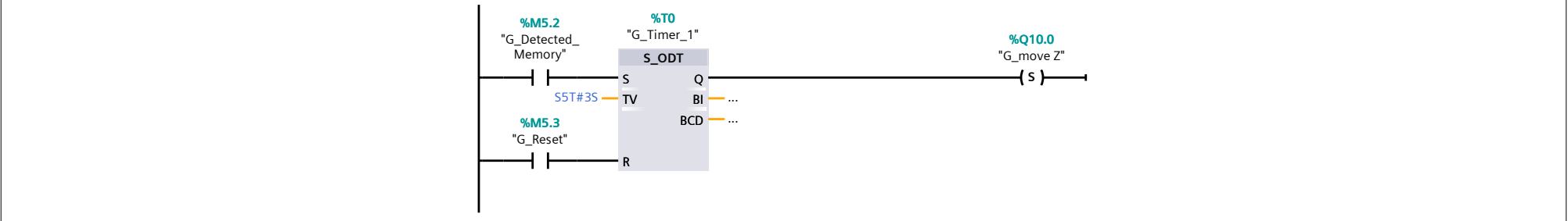
Network 3:



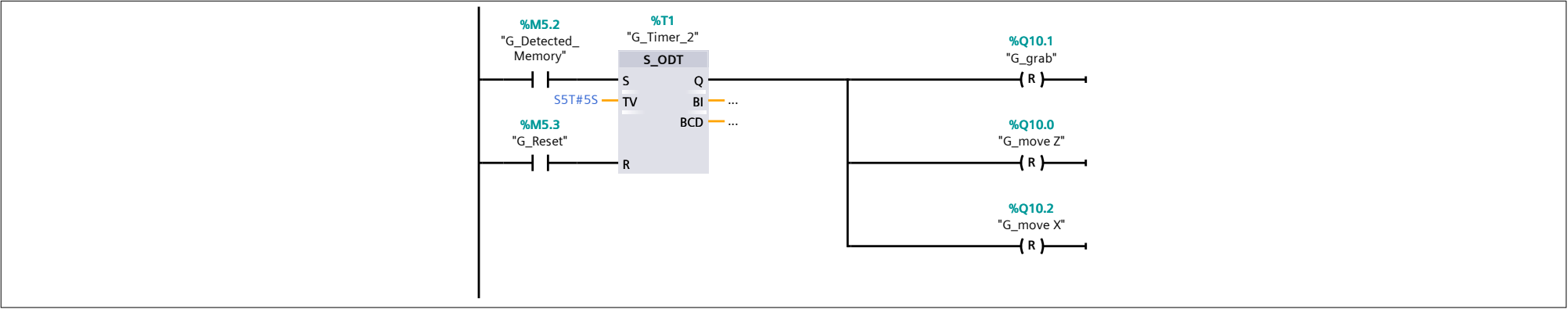
Network 4:



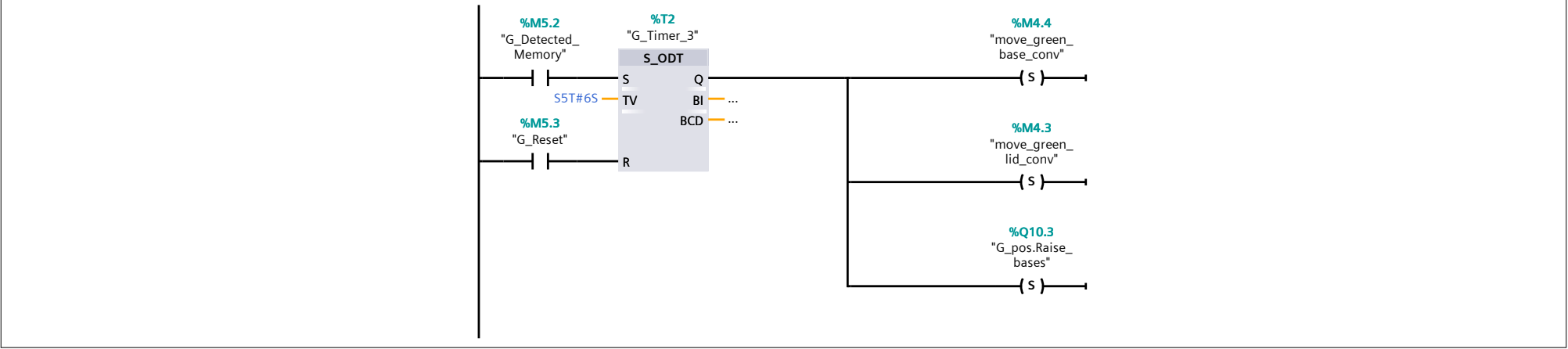
Network 5:



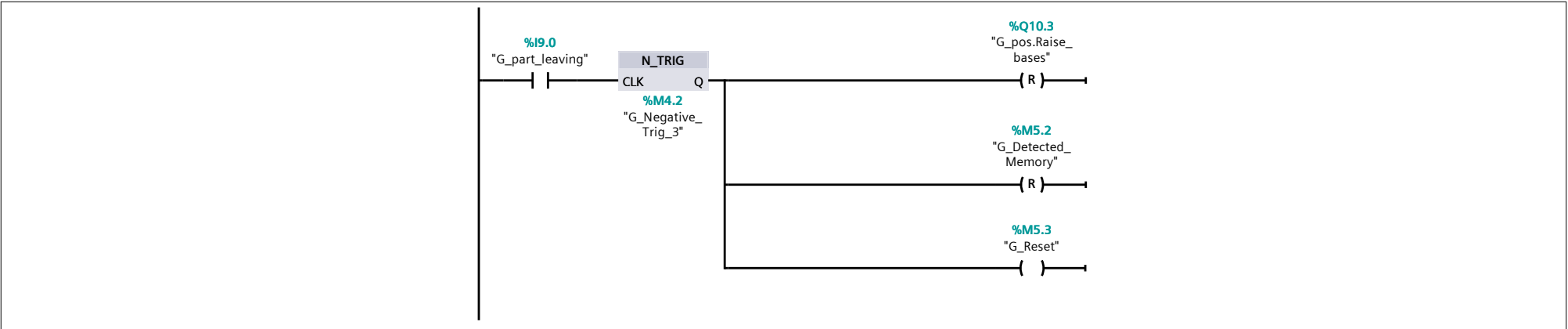
Network 6:



Network 7:



Network 8:



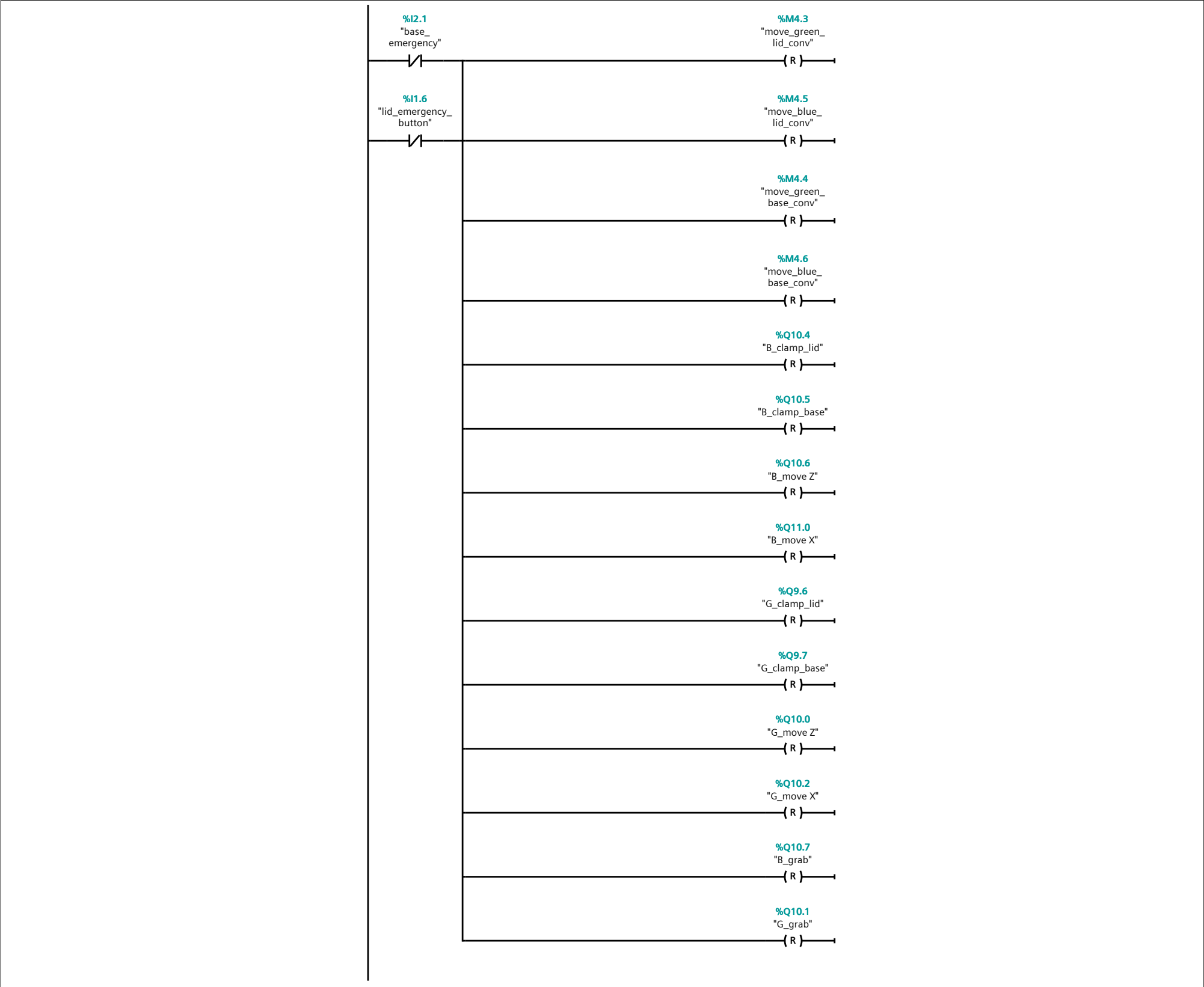
Project / PLC_2 [CPU 319-3 PN/DP] / Program blocks

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					

[illegible]

Network 1:



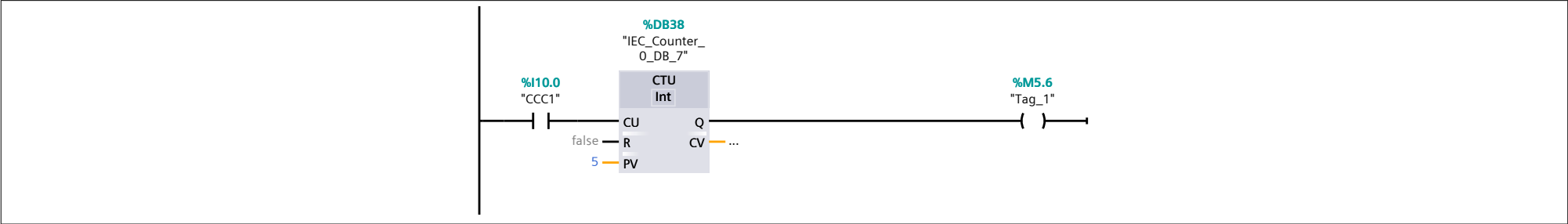
Project / PLC_2 [CPU 319-3 PN/DP] / Program blocks

A_COUNTER [FB12]

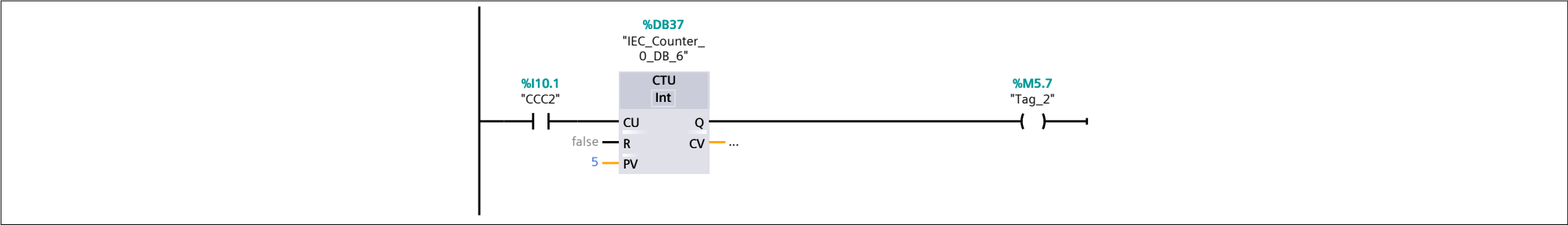
A_COUNTER Properties							
General							
Name	A_COUNTER	Number	12	Type	FB	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

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										

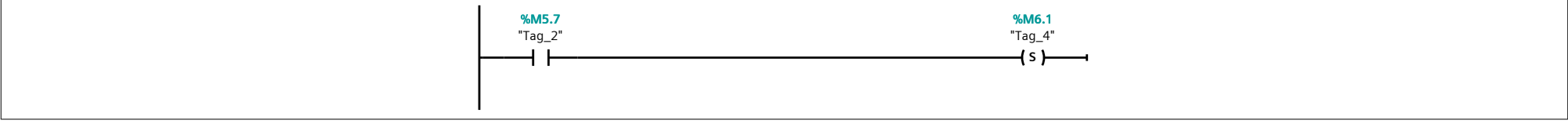
Network 1:



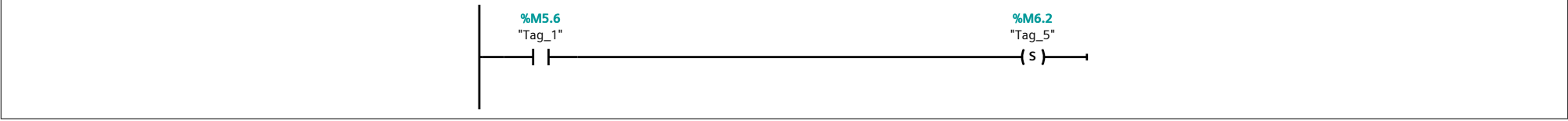
Network 2:



Network 3:



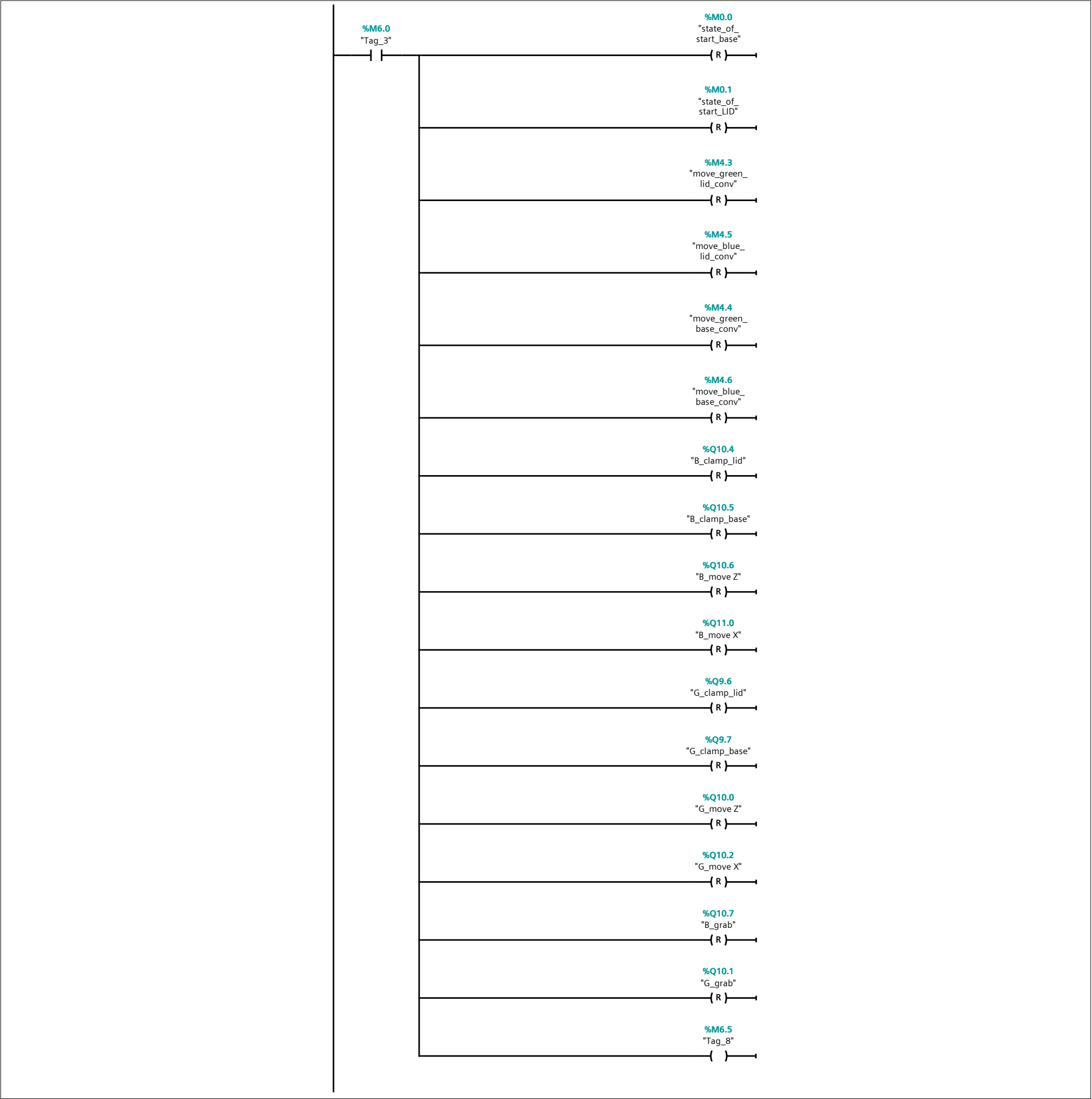
Network 4:



Network 5:



Network 6:



Network 7:



Network 8:

