| Totally Integ<br>Automation   |          |                 |           |      |             |      |                   |             |
|-------------------------------|----------|-----------------|-----------|------|-------------|------|-------------------|-------------|
| Sekvence                      | 2        | egovec_dip      |           | [CI  | PU 1513-1   | I PN | ] / Progra        | am blocks / |
| Okretni_stol_se               | ekvenca  | Properties      |           |      |             |      |                   |             |
| General                       |          |                 |           |      |             |      |                   |             |
| Name                          | Okretni_ | _stol_sekvenca  | Number    | 3    |             |      | Гуре              | FB          |
| 3 3                           | LAD      |                 | Numbering | Auto | matic       |      |                   |             |
| Information                   |          |                 | ,,        |      |             |      |                   |             |
| Title                         |          |                 | Author    |      |             |      | Comment           |             |
| Family                        |          |                 | Version   | 0.1  |             | 11.  | Jser-defined<br>D |             |
|                               |          |                 |           |      |             |      |                   |             |
| Okretni_stol_se               | ekvenca  |                 |           |      |             |      |                   |             |
| •                             |          |                 |           |      |             |      |                   |             |
| Name                          |          |                 |           |      |             |      |                   |             |
| Name                          |          | Input           |           |      |             |      |                   |             |
| Data type                     |          |                 |           |      |             |      |                   |             |
| Data type                     |          |                 |           |      |             |      |                   |             |
| Default value                 |          |                 |           |      |             |      |                   |             |
| Default value                 |          |                 |           |      |             |      |                   |             |
| Retain                        |          |                 |           |      |             |      |                   |             |
| Retain                        |          |                 |           |      |             |      |                   |             |
| Accessible from               |          | PC UA/Web API   |           |      |             |      |                   |             |
| Accessible from HMI/OPC UA/We |          |                 |           |      |             |      |                   |             |
| Writable from H               | HMI/OPC  | UA/Web API      |           |      |             |      |                   |             |
| Writable from HMI/OPC UA/We   | eh API   |                 |           |      |             |      |                   |             |
| Visible in HMI e              |          | rina            |           |      |             |      |                   |             |
| Visible in HMI e              |          | 9               |           |      |             |      |                   |             |
| neering                       | -9-      |                 |           |      |             |      |                   |             |
| Setpoint                      |          |                 |           |      |             |      |                   |             |
| Setpoint                      |          |                 |           |      |             |      |                   |             |
| Supervision                   |          |                 |           |      |             |      |                   |             |
| Supervision                   |          |                 |           |      | Supervision |      |                   |             |
| Supervision                   |          |                 |           |      | Supervision |      |                   |             |
| Comment                       |          |                 |           |      |             |      |                   |             |
| Comment                       |          |                 |           |      |             |      |                   |             |
| Name                          |          |                 |           |      |             |      |                   |             |
| Name                          |          | inicijalizacija |           |      |             |      |                   |             |
| Data type                     |          |                 |           |      |             |      |                   |             |
| Data type                     |          | Bool            |           |      |             |      |                   |             |
| Default value                 |          |                 |           |      |             |      |                   |             |
| Default value                 |          | false           |           |      |             |      |                   |             |
| Retain                        |          |                 |           |      |             |      |                   |             |
| Retain                        |          | Non-retain      |           |      |             |      |                   |             |
| Accessible from               | n HMI/O  | PC UA/Web API   |           |      |             |      |                   |             |

Accessible from

HMI/OPC UA/Web API

Writable from HMI/OPC UA/Web API Visible in HMI engineering Visible in HMI engi-

neering

Writable from HMI/OPC UA/Web API

True

True

| Totally Integrated         |               |             |  |
|----------------------------|---------------|-------------|--|
| Automation Portal          |               |             |  |
|                            |               |             |  |
| Setpoint                   |               |             |  |
| Setpoint                   | False         |             |  |
| Supervision                | i dise        |             |  |
|                            |               | Suponision  |  |
| Supervision                |               | Supervision |  |
| Supervision                |               | Supervision |  |
| Comment                    |               |             |  |
| Comment                    |               |             |  |
| Name                       | 1.            | 1           |  |
| Name                       | Output        |             |  |
| Data type                  |               |             |  |
| Data type                  |               |             |  |
| Default value              |               |             |  |
| Default value              |               |             |  |
| Retain                     |               |             |  |
| Retain                     |               |             |  |
| Accessible from HMI/C      | PC UA/Web API |             |  |
| Accessible from            |               |             |  |
| HMI/OPC UA/Web API         |               |             |  |
| Writable from HMI/OP       | C UA/Web API  |             |  |
| Writable from              |               |             |  |
| HMI/OPC UA/Web API         |               |             |  |
| Visible in HMI enginee     | ering         |             |  |
| Visible in HMI engi-       |               |             |  |
| neering                    |               |             |  |
| Setpoint                   |               |             |  |
| Setpoint                   |               |             |  |
| Supervision                |               |             |  |
| Supervision                |               | Supervision |  |
| Supervision                |               | Supervision |  |
| Comment                    |               |             |  |
| Comment                    |               |             |  |
| Name                       |               |             |  |
| Name                       | InOut         |             |  |
| Data type                  | inout         |             |  |
|                            |               |             |  |
| Data type<br>Default value |               |             |  |
|                            |               |             |  |
| Default value              |               |             |  |
| Retain                     |               | _           |  |
| Retain                     |               |             |  |
| Accessible from HMI/C      | PC UA/Web API |             |  |
| Accessible from            |               |             |  |
| HMI/OPC UA/Web API         |               |             |  |
| Writable from HMI/OP       | C UA/Web API  |             |  |
| Writable from              |               |             |  |
| HMI/OPC UA/Web API         |               |             |  |
| Visible in HMI enginee     | ering         |             |  |
| Visible in HMI engi-       |               |             |  |
| neering                    |               |             |  |
| Setpoint                   |               |             |  |
| Setpoint                   |               |             |  |
| Supervision                |               |             |  |
| Supervision                |               | Supervision |  |
| Supervision                |               | Supervision |  |
| Comment                    |               |             |  |
| Comment                    |               |             |  |
| <b>—</b>                   |               |             |  |
| Name                       |               |             |  |
| Name                       | Static        | 1           |  |
| IVAIIIE                    | Jane          |             |  |
|                            | <del></del>   |             |  |
|                            |               |             |  |
|                            |               |             |  |

| Totally Integrated Automation Portal  |               |             |  |
|---------------------------------------|---------------|-------------|--|
|                                       |               |             |  |
| Data type                             |               |             |  |
| Data type                             |               |             |  |
| Default value                         |               |             |  |
| Default value                         |               |             |  |
| Retain                                |               |             |  |
| Retain                                |               |             |  |
| Accessible from HMI/O                 | PC UA/Web API |             |  |
| Accessible from<br>HMI/OPC UA/Web API |               |             |  |
| Nritable from HMI/OPC                 |               |             |  |
| Vritable from Hivil/OPC               | . UA/Web API  |             |  |
| IMI/OPC UA/Web API                    |               |             |  |
| isible in HMI engineer                | ring          |             |  |
| isible in HMI engi-                   | Tillig        |             |  |
| neering                               |               |             |  |
| Setpoint                              |               |             |  |
| Setpoint                              |               |             |  |
| Supervision                           |               |             |  |
| Supervision                           |               | Supervision |  |
| Supervision                           |               | Supervision |  |
| Comment                               |               | Supervision |  |
| Comment                               |               |             |  |
|                                       |               |             |  |
| lame<br>lame                          | stan Numa     |             |  |
|                                       | stepNum       |             |  |
| Data type                             |               |             |  |
| 71                                    | Int           |             |  |
| Default value                         | 0             |             |  |
|                                       | 0             |             |  |
| Retain                                | N             |             |  |
|                                       | Non-retain    |             |  |
| Accessible from HMI/O                 |               |             |  |
| Accessible from<br>HMI/OPC UA/Web API | True          |             |  |
| Vritable from HMI/OPC                 | CIIA/Mah ARI  |             |  |
|                                       | True          |             |  |
| MI/OPC UA/Web API                     | True          |             |  |
| isible in HMI enginee                 | ring          |             |  |
|                                       | True          |             |  |
| neering                               | Tide          |             |  |
| Setpoint                              |               |             |  |
|                                       | False         |             |  |
| Supervision                           |               |             |  |
| Supervision                           |               | Supervision |  |
| Supervision                           |               | Supervision |  |
| Comment                               |               | рафенный.   |  |
| Comment                               |               |             |  |
| lame                                  |               |             |  |
|                                       | stepNumPrev   |             |  |
| Data type                             |               |             |  |
|                                       | Int           |             |  |
| Default value                         |               |             |  |
|                                       | 0             |             |  |
| Retain                                |               |             |  |
|                                       | Non-retain    |             |  |
| Accessible from HMI/O                 |               |             |  |
|                                       | True          |             |  |
| IMI/OPC UA/Web API                    | Tiuc          |             |  |

ı

| Totally Integrated                    |                   |             |   |   |
|---------------------------------------|-------------------|-------------|---|---|
| Automation Portal                     |                   |             |   |   |
| Writable from HMI/OP                  |                   |             |   |   |
| Writable from                         | True              |             |   |   |
| HMI/OPC UA/Web API                    |                   |             |   |   |
| Visible in HMI enginee                | ering             |             |   |   |
| Visible in HMI engi-                  | True              |             |   |   |
| neering                               |                   |             |   |   |
| Setpoint                              | r I.              |             |   |   |
| Setpoint<br>Supervision               | False             |             |   |   |
| Supervision                           |                   | Supervision |   |   |
| Supervision                           |                   | Supervision |   |   |
| Comment                               |                   | Supervision |   |   |
| Comment                               |                   |             |   |   |
| ▼ /                                   |                   | <u> </u>    |   |   |
| Name                                  |                   |             | _ | _ |
| Name                                  | bit_na_brid       |             |   |   |
| Data type                             | STC_IIG_STIG      |             |   |   |
| Data type                             | Array[02] of Bool |             |   |   |
| Default value                         |                   |             |   |   |
| Default value                         |                   |             |   |   |
| Retain                                |                   |             |   |   |
| Retain                                | Non-retain        |             |   |   |
| Accessible from HMI/C                 |                   |             |   |   |
| Accessible from<br>HMI/OPC UA/Web API | False             |             |   |   |
| Writable from HMI/OP                  |                   |             |   |   |
| Writable from<br>HMI/OPC UA/Web API   | False             |             |   |   |
| Visible in HMI enginee                | ering             |             |   |   |
| Visible in HMI engi-<br>neering       | False             |             |   |   |
| Setpoint                              |                   |             |   |   |
| Setpoint                              | False             |             |   |   |
| Supervision                           |                   |             |   |   |
| Supervision                           |                   | Supervision |   |   |
| Supervision                           |                   | Supervision |   |   |
| Comment<br>Comment                    |                   |             |   |   |
| Name                                  |                   |             |   |   |
| Name                                  | bit_na_brid[0]    |             |   |   |
| Data type                             | 511_114_5114[5]   |             |   |   |
| Data type                             | Bool              |             |   |   |
| Default value                         |                   |             |   |   |
| Default value                         | false             |             |   |   |
| Retain                                |                   |             |   |   |
| Retain                                | Non-retain        |             |   |   |
| Accessible from HMI/C                 |                   |             |   |   |
| Accessible from<br>HMI/OPC UA/Web API | False             |             |   |   |
| Writable from HMI/OP                  |                   |             |   |   |
| Writable from<br>HMI/OPC UA/Web API   | False             |             |   |   |
| Visible in HMI enginee                |                   |             |   |   |
| Visible in HMI engi-<br>neering       | False             |             |   |   |
| Setpoint                              |                   |             |   |   |
| Setpoint                              | False             |             |   |   |
|                                       |                   |             |   |   |
|                                       | 1                 |             | ] |   |

| Totally Integrated                           |                |             |  |
|--|----------------|-------------|--|
| Automation Porta                             |                |             |  |
|  |                |             |  |
| Supervision                                  |                |             |  |
| Supervision                                  |                | Supervision |  |
| Supervision                                  |                | Supervision |  |
| Comment                                      |                |             |  |
| Comment                                      |                |             |  |
| Name   |                | <u> </u>    |  |
| Name   | bit_na_brid[1] |             |  |
| Data type                                    |                |             |  |
| Data type                                    | Bool           |             |  |
| Default value                                |                |             |  |
| Default value                                | false          |             |  |
| Retain                                       |                |             |  |
| Retain                                       | Non-retain     |             |  |
| Accessible from HMI                          | OPC UA/Web API |             |  |
| Accessible from                              | False          |             |  |
| HMI/OPC UA/Web AP<br>Writable from HMI/O     |                |             |  |
| Writable from HIVII/O<br>Writable from       | False          |             |  |
| Writable from<br>HMI/OPC UA/Web AP           |                |             |  |
| Visible in HMI engine                        |                |             |  |
| visible in HMI engi-<br>Visible in HMI engi- | False          |             |  |
| neering                                      | ו מואכ         |             |  |
| Setpoint                                     |                |             |  |
| Setpoint                                     | False          |             |  |
| Supervision                                  | i aise         |             |  |
|  |                | Cunamisian  |  |
| Supervision                                  |                | Supervision |  |
| Supervision                                  |                | Supervision |  |
| Comment                                      |                |             |  |
| Comment                                      |                |             |  |
| Name   |                |             |  |
| Name<br>-                                    | bit_na_brid[2] |             |  |
| Data type                                    | <u> </u>       |             |  |
| Data type                                    | Bool           |             |  |
| Default value                                |                |             |  |
| Default value                                | false          |             |  |
| Retain                                       |                | <u> </u>    |  |
| Retain                                       | Non-retain     |             |  |
| Accessible from HMI                          | OPC UA/Web API |             |  |
| Accessible from                              | False          |             |  |
| HMI/OPC UA/Web AP                            |                |             |  |
| Writable from HMI/O                          |                |             |  |
| Writable from                                | False          |             |  |
| HMI/OPC UA/Web AP                            |                |             |  |
| Visible in HMI engine                        |                |             |  |
| Visible in HMI engi-                         | False          |             |  |
| neering                                      |                |             |  |
| Setpoint                                     |                |             |  |
| Setpoint                                     | False          |             |  |
| Supervision                                  |                |             |  |
| Supervision                                  |                | Supervision |  |
| Supervision                                  |                | Supervision |  |
| Comment                                      |                |             |  |
| Comment                                      |                |             |  |
| ▼  |                |             |  |
| Name   |                |             |  |
| Name   | Temp           |             |  |
| Data type                                    |                |             |  |
|  |                |             |  |
| Data type                                    |                |             |  |

| Totally Integrated<br>Automation Portal |                  |               |   |  |
|---|------------------|---------------|---|--|
|   |                  |               |   |  |
| Default value                           |                  |               |   |  |
| Default value                           |                  |               |   |  |
| Retain                                  |                  |               |   |  |
| Retain                                  |                  |               |   |  |
| Accessible from HMI/O                   | PC UA/Web API    |               |   |  |
| Accessible from                         |                  |               |   |  |
| HMI/OPC UA/Web API                      |                  |               |   |  |
| Writable from HMI/OPC                   | CUA/Web API      |               |   |  |
| Writable from                           | 2 0,41100 / 11 1 |               |   |  |
| HMI/OPC UA/Web API                      |                  |               |   |  |
| Visible in HMI enginee                  | ring             |               |   |  |
|   | ring             |               |   |  |
| Visible in HMI engi-                    |                  |               |   |  |
| neering                                 |                  |               |   |  |
| Setpoint                                |                  |               |   |  |
| Setpoint                                |                  |               |   |  |
| Supervision                             |                  |               |   |  |
| Supervision                             |                  | Supervision   |   |  |
| Supervision                             |                  | Supervision   |   |  |
| Comment                                 |                  |               |   |  |
| Comment                                 |                  |               |   |  |
| Name                                    |                  |               |   |  |
|   | 200              |               |   |  |
|   | nop              |               |   |  |
| Data type                               |                  |               |   |  |
| 71                                      | Bool             |               |   |  |
| Default value                           |                  |               |   |  |
| Default value                           |                  |               |   |  |
| Retain                                  |                  |               |   |  |
| Retain                                  |                  |               |   |  |
| Accessible from HMI/O                   | PC IIA/Web API   |               |   |  |
| Accessible from minitor                 | I C OA/Web Al I  |               |   |  |
| HMI/OPC UA/Web API                      |                  |               |   |  |
|   | CIIA MALA DI     |               |   |  |
| Writable from HMI/OPC                   | _ UA/Web API     |               |   |  |
| Writable from                           |                  |               |   |  |
| HMI/OPC UA/Web API                      |                  |               |   |  |
| Visible in HMI enginee                  | ring             |               |   |  |
| Visible in HMI engi-                    |                  |               |   |  |
| neering                                 |                  |               |   |  |
| Setpoint                                |                  |               |   |  |
| Setpoint                                |                  |               |   |  |
| Supervision                             |                  |               |   |  |
| Supervision                             |                  | Supervision   |   |  |
| Supervision                             |                  | Supervision   |   |  |
| Comment                                 |                  | Juhei Aisioii |   |  |
|   |                  |               |   |  |
| Comment                                 |                  |               |   |  |
| Name                                    |                  |               |   |  |
|   | Constant         |               |   |  |
| Data type                               |                  |               |   |  |
| Data type                               |                  |               |   |  |
| Default value                           |                  |               |   |  |
| Default value                           |                  |               |   |  |
| Retain                                  |                  |               |   |  |
| Retain                                  |                  |               |   |  |
|   | DC LIA/Mak ADI   |               |   |  |
| Accessible from HMI/O                   | rc da/web API    |               |   |  |
| Accessible from                         |                  |               |   |  |
| HMI/OPC UA/Web API                      |                  |               |   |  |
| Writable from HMI/OPC                   | CUA/Web API      |               |   |  |
| Writable from                           |                  |               |   |  |
| HMI/OPC UA/Web API                      |                  |               |   |  |
| HIVITORC DATWED AFT                     |                  |               |   |  |
| HIVII/OFC DA/WED AFI                    |                  |               |   |  |
| HIMI/OFC DA/WED AFI                     |                  |               | _ |  |

| Totally Integrated                         |   |  |                            |  |
|--|---|--|----------------------------|--|
| Automation Portal                          |   |  |                            |  |
|  |   |  |                            |  |
| Visible in HMI engineering                 | J   |  |                            |  |
| Visible in HMI engi-                       |   |  |                            |  |
| neering                                    |   |  |                            |  |
| Setpoint                                   |   |  |                            |  |
| Setpoint                                   |   |  |                            |  |
| Supervision                                |   |  |                            |  |
| Supervision                                |   | Supervision  |                            |  |
| Supervision                                |   | Supervision  |                            |  |
| Comment                                    |   |  |                            |  |
| Comment                                    |   |  |                            |  |
| Network 1: Inicijaliza                     | cija sekvence   |  |                            |  |
|  | #inicijalizacija MOVE   |  |                            |  |
|  | #inicijalizacija MOVE EN ENO  |  |                            |  |
|  | 0 — IN · in OUT1 — #stepNu  | m  | •                          |  |
|  |   |  |                            |  |
|  | 1   |  |                            |  |
| Network 2: Automati                        | ka aktivna  |  |                            |  |
|  | "pom_bits".   |  |                            |  |
|  | automatika_   |  |                            |  |
|  | aktivna   |  | KRAJ                       |  |
|  | V   |  | — <b>(</b> JMP <b>)</b> —— |  |
|  | Ī   |  |                            |  |
| Network 3: KORACI: 1                       | <br> - stol u početnoj poziciji, 1  | 01 - stol u okrenuto   | oi poziciii                |  |
| Network 3: KORACI: 1 Network 4: S0 - Počet | l<br>I - stol u početnoj poziciji, 1<br>ak sekvence   | 01 - stol u okrenuto   | j poziciji                 |  |
|  | ak sekvence   | 01 - stol u okrenuto   | j poziciji                 |  |
|  | ak sekvence  "Handshake".  #stepNum "Handshake". Spremna_opskrba M  | 01 - stol u okrenuto   | j poziciji                 |  |
|  | #stepNum "Handshake".  Spremna_opskrba M Int EN   | OVE<br>— ENO   | j poziciji                 |  |
|  | #stepNum "Handshake".  Spremna_opskrba M Int EN   | OVE  | j poziciji                 |  |
|  | #stepNum "Handshake". Spremna_opskrba M   | OVE<br>— ENO   | j poziciji                 |  |
|  | #stepNum "Handshake". Spremna_opskrba M   | OVE<br>— ENO   | oj poziciji                |  |
| Network 4: S0 - Počet                      | #stepNum "Handshake". Spremna_opskrba EN EN IN  | OVE<br>— ENO   | j poziciji                 |  |
| Network 4: S0 - Počet                      | #stepNum "Handshake". Spremna_opskrba M Int   | OVE<br>— ENO   | j poziciji                 |  |
| Network 4: S0 - Počet                      | #stepNum "Handshake". Spremna_opskrba M Int O 100 IN  zicija okretnog stola  #stepNum "stol_home" M   | OVE ENO  | j poziciji                 |  |
| Network 4: S0 - Počet                      | #stepNum "Handshake".  Spremna_opskrba M Int  | OVE ENO #stepNum  OVE#stepNum                                  | j poziciji                 |  |
| Network 4: S0 - Počet                      | #stepNum "Handshake".  Spremna_opskrba M Int  | OVE ENO OUT1 —#stepNum   | oj poziciji                |  |
| Network 4: S0 - Počet                      | #stepNum "Handshake".  Spremna_opskrba M EN  Int  O  #stepNum Spremna_opskrba Int  O  #stepNum Spremna_opskrba EN  EN  Stol_home"  #stepNum "stol_home"  #stepNum "stol_home" | OVE ENO #stepNum  OVE#stepNum                                  | oj poziciji                |  |
| Network 4: S0 - Počet                      | #stepNum "Handshake". Spremna_opskrba M Int   | OVE  | oj poziciji                |  |
| Network 4: S0 - Počet                      | #stepNum  | OVE#stepNum  OVEBNO  OUT1#stepNum  OVEBNO OVEBNO OVEBNO OVEBNO | j poziciji                 |  |
|  | #stepNum  | OVE  | j poziciji                 |  |
| Network 4: S0 - Počet                      | #stepNum  | OVE#stepNum  OVEBNO  OUT1#stepNum  OVEBNO OVEBNO OVEBNO OVEBNO | j poziciji                 |  |
| Network 4: S0 - Počet                      | #stepNum  | OVE#stepNum  OVEBNO  OUT1#stepNum  OVEBNO OVEBNO OVEBNO OVEBNO | j poziciji                 |  |
| Network 4: S0 - Počet                      | #stepNum  | OVE#stepNum  OVEBNO  OUT1#stepNum  OVEBNO OVEBNO OVEBNO OVEBNO | oj poziciji                |  |
| Network 4: S0 - Počet                      | #stepNum  | OVE#stepNum  OVEBNO  OUT1#stepNum  OVEBNO OVEBNO OVEBNO OVEBNO | oj poziciji                |  |
| Network 4: S0 - Počet                      | #stepNum  | OVE#stepNum  OVEBNO  OUT1#stepNum  OVEBNO OVEBNO OVEBNO OVEBNO | oj poziciji                |  |
| Network 4: S0 - Počet                      | #stepNum  | OVE#stepNum  OVEBNO  OUT1#stepNum  OVEBNO OVEBNO OVEBNO OVEBNO | oj poziciji                |  |
| Network 4: S0 - Počet                      | #stepNum  | OVE#stepNum  OVEBNO  OUT1#stepNum  OVEBNO OVEBNO OVEBNO OVEBNO | oj poziciji                |  |

Totally Integrated
Automation Portal

## Network 6: S1 - Status stezaljki

# Network 7: S2 - Čekanje da se izvuku pinovi i otvore stezaljke

```
#stepNum "Senzori". "Senzori".pins1_
clamps1_open out MOVE
Int EN ENO
IN & OUT1 #stepNum
```

## Network 8: S3 - Provjera prisutnosti radnih komada na okretnom stolu

```
%15.5
                %I5.6
                              %15.4
#stepNum
              "s1_mk_ind"
                            "s1_vk_ind1"
                                           "s1_vk_ind2"
                                                        MOVE
                                                        EN --- ENO
 Int
                                                     4 — IN 👍 OUT1 — #stepNum
                %15.6
             "s1_mk_ind"
                                                        MOVE
                                                        EN - ENO
                                                     5 — IN 👲 OUT1 — #stepNum
                %15.4
                               %15.5
              "s1_vk_ind1"
                            "s1_vk_ind2"
```

Network 9: S4 - ćekanje da čovjek odnese zavarene komade

Network 10: S204 - Uklanjanje zavarenih predmeta

# Totally Integrated **Automation Portal** "Zavareno\_unisti\_ end" #stepNum EN --- ENO Int 5 — IN do OUT1 — #stepNum Network 11: S5 - Čekanje da čovjek opskrbi stol radnim komadima **%I4.7** "Op1\_veci\_okvir\_ end" "Op2\_manji\_ #stepNum okvir\_end" 4 F $\dashv$ $\vdash$ - EN --- ENO -Int Network 12: S6 - Potvrda safetyja "pom\_bits". sigurnosni\_ skener\_OK %M1.1 #stepNum "bijelo" MOVE 1 F EN - ENO Int 7 — IN ₫ OUT1 — #stepNum %M100.2 "AlwaysTRUE" Network 13: S7 - Slanje handshake signala PLC-u "Handshake".Stol\_ #stepNum PLC\_OK MOVE EN --- ENO Int 8 — IN d OUT1 — #stepNum Network 14: S8 - Spremno za stezanje radnih komada "Handshake". Spremno\_za\_ #stepNum stez\_i\_okret MOVE EN --- ENO Int 9 — IN 🎂 OUT1 — #stepNum "Handshake". Spremno\_za\_ stez\_i\_povrat MOVE EN - ENO 109 — IN 🛕 OUT1 — #stepNum

Totally Integrated Automation Portal

# Network 15: S9 - stezanje radnih komada i uvlačenje pinova

#### Network 16: S10 - Okret stola

```
#stepNum "stol_final" MOVE

== Int | Stol_final | EN ENO | IN & OUT1 | #stepNum
```

#### Network 17: S101 - Status stezaljki

# Network 18: S102 - Čekanje da se pinovi izvuku i otvore stezaljke

```
#stepNum clamps2_open out MOVE

== Int 103 IN & OUT1 - #stepNum
```

Network 19: S103 - Provjera prisutnosti radnih komada na okretnom stolu

#### Totally Integrated **Automation Portal** %19.2 %19.0 **%I9.1** #stepNum "s2\_mk\_ind" "s2\_vk\_ind1" "s2\_vk\_ind2" MOVE == Int ┨┞ EN - ENO 104 — IN die OUT1 — #stepNum %19.2 "s2\_mk\_ind" MOVE -EN --- ENO -%19.1 %19.0 "s2\_vk\_ind1" "s2\_vk\_ind2" Network 20: S104 - ćekanje da čovjek odnese zavarene komade %18.4 "Op3\_zavareni\_ #stepNum end\_2" MOVE EN - ENO Int 304 — IN 👍 OUT1 — #stepNum Network 21: S104 - ćekanje da čovjek odnese zavarene komade %18.5 "Zavareno\_unisti\_ end\_2" #stepNum MOVE EN --- ENO Int 105 — IN 🛕 OUT1 — #stepNum Network 22: S105 - Čekanje da čovjek opskrbi stol radnim komadima %18.0 %18.2 "Op2\_manji\_ okvir\_end\_2" "Op1\_veci\_okvir\_ end\_2" #stepNum MOVE $\dashv$ $\vdash$ $\dashv \vdash$ EN --- ENO Int 106 — IN dig OUT1 — #stepNum Network 23: S106 - Potvrda safetyja "pom\_bits". sigurnosni\_ %M1.1 #stepNum skener\_OK "bijelo" MOVE 4 F +EN --- ENO Int 107 — IN 👛 OUT1 — #stepNum %M100.2 "AlwaysTRUE" ┨┞

Totally Integrated
Automation Portal

# Network 24: S107 - Slanje handshake signala PLC-u

```
#stepNum "Handshake".Stol_
PLC_OK MOVE
Int | EN EN EN OUT1 #stepNum
```

# Network 25: S108 - spremno za stezanje radnih komada

## Network 26: S109 - stezanje radnih komada i uvlačenje pinova

#### Network 27: S110 - Okret stola

**Network 28: RADNJE** 

Network 29: Otvori stezaljke

# Totally Integrated **Automation Portal** "Sekvence\_DB". ventil\_pin\_1\_uklj == Int <del>(</del> )-"Sekvence\_DB". ventil\_1\_iskljuci "Senzori".pins1\_ out <del>(</del> )-<del>|</del> | | "Sekvence\_DB". ventil\_pin\_2\_uklj #stepNum == Int <del>(</del> )-"Sekvence\_DB". ventil\_2\_iskljuci "Senzori".pins2\_ out Network 30: Čovjek nosi zavarene komade sa stola "Sekvence\_DB". Op3\_zavareni\_ start #stepNum Int

"Sekvence\_DB". Op3\_zavareni\_2\_ start

<del>(</del> )-

Network 31: Čovjek nosi nezavarene komade na stol

#stepNum

Network 32: Opskrba stola završena

# Totally Integrated **Automation Portal** "Handshake".Stol\_ PLC == Int <del>( )—</del> #stepNum == Int Network 33: Stezanje radnih komada "Sekvence\_DB". ventil\_1\_ukljuci #stepNum == Int <del>(</del> )-"Sekvence\_DB". ventil\_pin\_1\_isklj "Senzori". $clamps 1\_closed$ **←** )— "Sekvence\_DB". ventil\_2\_ukljuci #stepNum == | Int | $\leftarrow$ "Sekvence\_DB". ventil\_pin\_2\_isklj "Senzori". clamps2\_closed <del>(</del> )-Network 34: Okretanje stola HOME -> FINAL "Sekvence\_DB". stol\_okret #stepNum Int Network 35: Okretanje stola FINAL -> HOME "Sekvence\_DB". #stepNum stol\_povratak == Int <del>(</del> )-

Network 36: Uklanjanje zavarenih komada

# Totally Integrated Automation Portal "Sekvence\_DB". Zavareno\_unisti\_ start #stepNum == | | Int | | 204 ( )-"Sekvence\_DB". Zavareno\_unisti\_ 2\_start #stepNum |==| |nt| **-( )**-Network 37: Kraj KRAJ #nop