/// all stations working //////

/// Green light integrated in all stations//

/// Red light integrated in seg 1...no workpiece in slider in station 1///

///Looping sucessfully integrated///

//Blue light for Slide full sensor integrated(detects all teh slides together)///

//Orange blink in station 1 and 2 for comms btwn stn1 and stn 2///

//Orange blink in station 3 and 2 for comms btwn stn3 and stn 2

IF "Reset" THEN

"CP\_Conveyor" := 0;

"S\_Conveyor" := 0;

"WP\_Vaccum \_Off" := 0;

"WP\_Vaccum \_On" := 0;

"CP\_Vaccum\_ON" := 0;

#count := 0;

END\_IF;

IF NOT "Stop" THEN //Reset Mechanism

"Start\_light" := 0;

"WP\_Slider\_Extend" := 0;

"WP\_Hand\_Ret" := 0;

"WP\_Hand\_Ext" := 1;

"WP\_Vaccum \_Off" := 0;

"WP\_Vaccum \_On" := 0;

"CP\_Conveyor" := 0;

"CP\_Z\_Movement\_ON" := 0;

"CP\_X\_Movement\_Ext" := 0;

"CP\_Vaccum\_ON" := 0;

"S\_Conveyor" := 0;

"S\_WP\_stopper" := 0;

"S\_Sep\_1" := 0;

"S\_sep\_2" := 0;

#Step := 1;

END\_IF;

CASE #Step OF

1:

"WP\_Hand\_Ext" := 1;

"WP\_Slider\_Extend" := 0;

"CP\_Conveyor" := 0;

"CP\_X\_Movement\_Ext" := 0;

"CP\_X\_Movement\_Ret" := 1;

"CP\_Z\_Movement\_ON" := 0;

"S\_Conveyor" := 0;

"Start" := 0;

#Step := 2;

"S2\_transmitter" := 1;

"S3\_Comm\_Transmitter" := 1;

;

2: //all segement Green

"seg1\_1" := 1;

"seg1\_2" := 0;

"seg1\_3" := 0;

"seg1\_blink" := 0;

"seg2\_1" := 1;

"seg2\_2" := 0;

"seg2\_3" := 0;

"seg2\_blink" := 0;

"seg3\_1" := 1;

"seg3\_2" := 0;

"seg3\_3" := 0;

"seg3\_blink" := 0;

"seg4\_1" := 0;

"seg4\_2" := 0;

"seg4\_3" := 0;

"seg4\_blink" := 0;

"seg5\_1" := 0;

"seg5\_2" := 0;

"seg5\_3" := 0;

"seg5\_blink" := 0;

"buzzer\_type1" := 0;

"buzzer\_type2" := 0;

"buzzer\_state" := 0;

"Segment\_mode" := 1;

"level\_mode" := 0;

"runlight\_mode" := 0;

"flexible\_mode" := 0;

"sync\_start" := 0;

"sync\_impulse" := 0;

"No\_of\_segments" := 3;

"blink\_seg1" := 0;

"blink\_seg2" := 0;

"blink\_seg3" := 0;

"blink\_seg4" := 0;

"blink\_seg5" := 0;

"blinking\_freequency" := 5;

"buzzer\_volume" := 255;

// End of all green

IF "Start" THEN

IF NOT "S2\_S3\_Com\_receiver" THEN

IF NOT "S1\_S2\_COM" THEN

"Start\_light" := 1;

// all segement off

"seg1\_1" := 0;

"seg1\_2" := 0;

"seg1\_3" := 0;

"seg1\_blink" := 0;

"seg2\_1" := 0;

"seg2\_2" := 0;

"seg2\_3" := 0;

"seg2\_blink" := 0;

"seg3\_1" := 0;

"seg3\_2" := 0;

"seg3\_3" := 0;

"seg3\_blink" := 0;

"seg4\_1" := 0;

"seg4\_2" := 0;

"seg4\_3" := 0;

"seg4\_blink" := 0;

"seg5\_1" := 0;

"seg5\_2" := 0;

"seg5\_3" := 0;

"seg5\_blink" := 0;

"buzzer\_type1" := 0;

"buzzer\_type2" := 0;

"buzzer\_state" := 0;

"Segment\_mode" := 1;

"level\_mode" := 0;

"runlight\_mode" := 0;

"flexible\_mode" := 0;

"sync\_start" := 0;

"sync\_impulse" := 0;

"No\_of\_segments" := 3;

"blink\_seg1" := 0;

"blink\_seg2" := 0;

"blink\_seg3" := 0;

"blink\_seg4" := 0;

"blink\_seg5" := 0;

"blinking\_freequency" := 5;

"buzzer\_volume" := 255;

//end of all seg off//

#Step := 3;

ELSE

//segment1-2 orange blink for no communication btwn s1 and s2

"seg1\_1" := 1;

"seg1\_2" := 0;

"seg1\_3" := 1;

"seg1\_blink" := 1;

"seg2\_1" := 1;

"seg2\_2" := 0;

"seg2\_3" := 1;

"seg2\_blink" := 1;

"seg3\_1" := 0;

"seg3\_2" := 0;

"seg3\_3" := 0;

"seg3\_blink" := 0;

"seg4\_1" := 0;

"seg4\_2" := 0;

"seg4\_3" := 0;

"seg4\_blink" := 0;

"seg5\_1" := 0;

"seg5\_2" := 0;

"seg5\_3" := 0;

"seg5\_blink" := 0;

"buzzer\_type1" := 0;

"buzzer\_type2" := 0;

"buzzer\_state" := 0;

"Segment\_mode" := 1;

"level\_mode" := 0;

"runlight\_mode" := 0;

"flexible\_mode" := 0;

"sync\_start" := 0;

"sync\_impulse" := 0;

"No\_of\_segments" := 3;

"blink\_seg1" := 0;

"blink\_seg2" := 0;

"blink\_seg3" := 0;

"blink\_seg4" := 0;

"blink\_seg5" := 0;

"blinking\_freequency" := 5;

"buzzer\_volume" := 255;

//end of seg 1-2 orange blink//

END\_IF;

ELSE

//segment2-3 orange blink for no communication btwn s1 and s2

"seg1\_1" := 0;

"seg1\_2" := 0;

"seg1\_3" := 0;

"seg1\_blink" := 0;

"seg2\_1" := 1;

"seg2\_2" := 0;

"seg2\_3" := 1;

"seg2\_blink" := 1;

"seg3\_1" := 1;

"seg3\_2" := 0;

"seg3\_3" := 1;

"seg3\_blink" := 1;

"seg4\_1" := 0;

"seg4\_2" := 0;

"seg4\_3" := 0;

"seg4\_blink" := 0;

"seg5\_1" := 0;

"seg5\_2" := 0;

"seg5\_3" := 0;

"seg5\_blink" := 0;

"buzzer\_type1" := 0;

"buzzer\_type2" := 0;

"buzzer\_state" := 0;

"Segment\_mode" := 1;

"level\_mode" := 0;

"runlight\_mode" := 0;

"flexible\_mode" := 0;

"sync\_start" := 0;

"sync\_impulse" := 0;

"No\_of\_segments" := 3;

"blink\_seg1" := 0;

"blink\_seg2" := 0;

"blink\_seg3" := 0;

"blink\_seg4" := 0;

"blink\_seg5" := 0;

"blinking\_freequency" := 5;

"buzzer\_volume" := 255;

//end of seg 2-3 orange blink

END\_IF;

END\_IF;

3:

IF NOT "WP\_Sensor\_ON" THEN

//

"WP\_Hand\_Ext" := 1;

"WP\_Slider\_Extend" := 0;

"CP\_Conveyor" := 0;

"CP\_X\_Movement\_Ext" := 0;

"CP\_X\_Movement\_Ret" := 1;

"CP\_Z\_Movement\_ON" := 0;

//

"WP\_Slider\_Extend" := 1;

"WP\_Vaccum \_On" := 1;

"WP\_Hand\_Ext" := 0;

"WP\_Hand\_Ret" := 1;

#Step := 4;

ELSE

//segment1 red for non availablity of workpiece

"seg1\_1" := 0;

"seg1\_2" := 1;

"seg1\_3" := 0;

"seg1\_blink" := 0;

"seg2\_1" := 0;

"seg2\_2" := 0;

"seg2\_3" := 0;

"seg2\_blink" := 0;

"seg3\_1" := 0;

"seg3\_2" := 0;

"seg3\_3" := 0;

"seg3\_blink" := 0;

"seg4\_1" := 0;

"seg4\_2" := 0;

"seg4\_3" := 0;

"seg4\_blink" := 0;

"seg5\_1" := 0;

"seg5\_2" := 0;

"seg5\_3" := 0;

"seg5\_blink" := 0;

"buzzer\_type1" := 0;

"buzzer\_type2" := 0;

"buzzer\_state" := 0;

"Segment\_mode" := 1;

"level\_mode" := 0;

"runlight\_mode" := 0;

"flexible\_mode" := 0;

"sync\_start" := 0;

"sync\_impulse" := 0;

"No\_of\_segments" := 3;

"blink\_seg1" := 0;

"blink\_seg2" := 0;

"blink\_seg3" := 0;

"blink\_seg4" := 0;

"blink\_seg5" := 0;

"blinking\_freequency" := 5;

"buzzer\_volume" := 255;

////End of seg 1 red

#Step := 3;

END\_IF;

;

4:

IF "WP\_Hand\_Ret\_Sensor" THEN

// segment1 Green

"seg1\_1" := 1;

"seg1\_2" := 0;

"seg1\_3" := 0;///

"seg1\_blink" := 0;

"seg2\_1" := 0;

"seg2\_2" := 0;

"seg2\_3" := 0;

"seg2\_blink" := 0;

"seg3\_1" := 0;

"seg3\_2" := 0;

"seg3\_3" := 0;

"seg3\_blink" := 0;

"seg4\_1" := 0;

"seg4\_2" := 0;

"seg4\_3" := 0;

"seg4\_blink" := 0;

"seg5\_1" := 0;

"seg5\_2" := 0;

"seg5\_3" := 0;

"seg5\_blink" := 0;

"buzzer\_type1" := 0;

"buzzer\_type2" := 0;

"buzzer\_state" := 0;

"Segment\_mode" := 1;

"level\_mode" := 0;

"runlight\_mode" := 0;

"flexible\_mode" := 0;

"sync\_start" := 0;

"sync\_impulse" := 0;

"No\_of\_segments" := 3;

"blink\_seg1" := 0;

"blink\_seg2" := 0;

"blink\_seg3" := 0;

"blink\_seg4" := 0;

"blink\_seg5" := 0;

"blinking\_freequency" := 5;

"buzzer\_volume" := 255;

//End of segment1 green

"WP\_Slider\_Extend" := 0;

"WP\_Hand\_Ret" := 0;

"WP\_Hand\_Ext" := 1;

#Step := 5;

ELSE

IF "WP\_Slider\_Ext\_sensor" THEN

// Workpiece reverse segment1 orange

"seg1\_1" := 1;

"seg1\_2" := 0;

"seg1\_3" := 1;///turning light orange

"seg1\_blink" := 1;

"seg2\_1" := 0;

"seg2\_2" := 0;

"seg2\_3" := 0;

"seg2\_blink" := 0;

"seg3\_1" := 0;

"seg3\_2" := 0;

"seg3\_3" := 0;

"seg3\_blink" := 0;

"seg4\_1" := 0;

"seg4\_2" := 0;

"seg4\_3" := 0;

"seg4\_blink" := 0;

"seg5\_1" := 0;

"seg5\_2" := 0;

"seg5\_3" := 0;

"seg5\_blink" := 0;

"buzzer\_type1" := 0;

"buzzer\_type2" := 0;

"buzzer\_state" := 0;

"Segment\_mode" := 1;

"level\_mode" := 0;

"runlight\_mode" := 0;

"flexible\_mode" := 0;

"sync\_start" := 0;

"sync\_impulse" := 0;

"No\_of\_segments" := 3;

"blink\_seg1" := 0;

"blink\_seg2" := 0;

"blink\_seg3" := 0;

"blink\_seg4" := 0;

"blink\_seg5" := 0;

"blinking\_freequency" := 5;

"buzzer\_volume" := 255;

//End of segment1 orange blink due to Workpiece reversed

IF "Reset" THEN

"CP\_Conveyor" := 0;

"S\_Conveyor" := 0;

"WP\_Vaccum \_Off" := 0;

"WP\_Vaccum \_On" := 0;

"CP\_Vaccum\_ON" := 0;

END\_IF;

END\_IF;

END\_IF

;

5:

IF "WP\_Hand\_Ext\_Sensor" THEN

"WP\_Vaccum \_On" := 0;

"WP\_Vaccum \_Off" := 1;

"WP\_Hand\_Ext" := 0;

"WP\_Hand\_Ret" := 1;

#Step := 6;

END\_IF

;

6:

IF "CP\_WP\_Entry\_Sensor" AND "WP\_Hand\_Ret\_Sensor" THEN

//segment1\_off

"seg1\_1" := 0;

"seg1\_2" := 0;

"seg1\_3" := 0;

"seg1\_blink" := 0;

"seg2\_1" := 0;

"seg2\_2" := 0;

"seg2\_3" := 0;

"seg2\_blink" := 0;

"seg3\_1" := 0;

"seg3\_2" := 0;

"seg3\_3" := 0;

"seg3\_blink" := 0;

"seg4\_1" := 0;

"seg4\_2" := 0;

"seg4\_3" := 0;

"seg4\_blink" := 0;

"seg5\_1" := 0;

"seg5\_2" := 0;

"seg5\_3" := 0;

"seg5\_blink" := 0;

"buzzer\_type1" := 0;

"buzzer\_type2" := 0;

"buzzer\_state" := 0;

"Segment\_mode" := 1;

"level\_mode" := 0;

"runlight\_mode" := 0;

"flexible\_mode" := 0;

"sync\_start" := 0;

"sync\_impulse" := 0;

"No\_of\_segments" := 3;

"blink\_seg1" := 0;

"blink\_seg2" := 0;

"blink\_seg3" := 0;

"blink\_seg4" := 0;

"blink\_seg5" := 0;

"blinking\_freequency" := 5;

"buzzer\_volume" := 255;

//segment2 green

"seg1\_1" := 0;

"seg1\_2" := 0;

"seg1\_3" := 0;

"seg1\_blink" := 0;

"seg2\_1" := 1;

"seg2\_2" := 0;

"seg2\_3" := 0;

"seg2\_blink" := 0;

"seg3\_1" := 0;

"seg3\_2" := 0;

"seg3\_3" := 0;

"seg3\_blink" := 0;

"seg4\_1" := 0;

"seg4\_2" := 0;

"seg4\_3" := 0;

"seg4\_blink" := 0;

"seg5\_1" := 0;

"seg5\_2" := 0;

"seg5\_3" := 0;

"seg5\_blink" := 0;

"buzzer\_type1" := 0;

"buzzer\_type2" := 0;

"buzzer\_state" := 0;

"Segment\_mode" := 1;

"level\_mode" := 0;

"runlight\_mode" := 0;

"flexible\_mode" := 0;

"sync\_start" := 0;

"sync\_impulse" := 0;

"No\_of\_segments" := 3;

"blink\_seg1" := 0;

"blink\_seg2" := 0;

"blink\_seg3" := 0;

"blink\_seg4" := 0;

"blink\_seg5" := 0;

"blinking\_freequency" := 5;

"buzzer\_volume" := 255;

//Sorting station Conveyor reset mechanismm//

"S\_Conveyor" := 0;

//end of conveyor reset

//Sorting station separator reset mechanism

"S\_Sep\_1" := 0;

"S\_sep\_2" := 0;

// end of sorting mechanism

#count += 1;

#Step := 7;

END\_IF;

;

7://Not capping 3rd work piece

IF #count MOD 3 = 0 THEN

"CP\_Stopper\_On" := 1;

"CP\_Conveyor" := 1;

"WP\_Hand\_Ext" := 1;

"WP\_Hand\_Ret" := 0;

IF "CP\_WP\_Stopper\_Sensor" THEN

"CP\_Stopper\_On" := 0;

#Step := 12;

END\_IF;

ELSIF #count MOD 3 <> 0 THEN

"WP\_Vaccum \_Off" := 0;

"CP\_Conveyor" := 1;

"CP\_Stopper\_On" := 1;

// z\_movement\_init

"CP\_Z\_Movement\_ON" := 1;

"CP\_Vaccum\_ON" := 1;

#Step := 8;

END\_IF;

;

8://capping process starts

IF "CP\_WP\_Stopper\_Sensor"THEN

"CP\_Z\_Movement\_ON" := 0;

#Step := 9;

END\_IF

;

;

9://checking for cap

//at this point we have checked for cap in 2nd station, then extending X now

IF "CP\_Z\_Movement\_Sensor" AND "CP\_Pressure\_sensor" THEN

"CP\_X\_Movement\_Ext" := 1;

//segment2 green

"seg1\_1" := 0;

"seg1\_2" := 0;

"seg1\_3" := 0;

"seg1\_blink" := 0;

"seg2\_1" := 1;

"seg2\_2" := 0;

"seg2\_3" := 0;

"seg2\_blink" := 0;

"seg3\_1" := 0;

"seg3\_2" := 0;

"seg3\_3" := 0;

"seg3\_blink" := 0;

"seg4\_1" := 0;

"seg4\_2" := 0;

"seg4\_3" := 0;

"seg4\_blink" := 0;

"seg5\_1" := 0;

"seg5\_2" := 0;

"seg5\_3" := 0;

"seg5\_blink" := 0;

"buzzer\_type1" := 0;

"buzzer\_type2" := 0;

"buzzer\_state" := 0;

"Segment\_mode" := 1;

"level\_mode" := 0;

"runlight\_mode" := 0;

"flexible\_mode" := 0;

"sync\_start" := 0;

"sync\_impulse" := 0;

"No\_of\_segments" := 3;

"blink\_seg1" := 0;

"blink\_seg2" := 0;

"blink\_seg3" := 0;

"blink\_seg4" := 0;

"blink\_seg5" := 0;

"blinking\_freequency" := 5;

"buzzer\_volume" := 255;

//end of seg 2 green

#Step := 10;

ELSE//If cap not found

//No cap found segment2 red

"seg1\_1" := 0;

"seg1\_2" := 0;

"seg1\_3" := 0;

"seg1\_blink" := 0;

"seg2\_1" := 0;

"seg2\_2" := 1;

"seg2\_3" := 0;

"seg2\_blink" := 1;

"seg3\_1" := 0;

"seg3\_2" := 0;

"seg3\_3" := 0;

"seg3\_blink" := 0;

"seg4\_1" := 0;

"seg4\_2" := 0;

"seg4\_3" := 0;

"seg4\_blink" := 0;

"seg5\_1" := 0;

"seg5\_2" := 0;

"seg5\_3" := 0;

"seg5\_blink" := 0;

"buzzer\_type1" := 0;

"buzzer\_type2" := 0;

"buzzer\_state" := 0;

"Segment\_mode" := 1;

"level\_mode" := 0;

"runlight\_mode" := 0;

"flexible\_mode" := 0;

"sync\_start" := 0;

"sync\_impulse" := 0;

"No\_of\_segments" := 3;

"blink\_seg1" := 0;

"blink\_seg2" := 0;

"blink\_seg3" := 0;

"blink\_seg4" := 0;

"blink\_seg5" := 0;

"blinking\_freequency" := 5;

"buzzer\_volume" := 255;

IF "Reset" THEN

"CP\_Conveyor" := 0;

"S\_Conveyor" := 0;

"WP\_Vaccum \_Off" := 0;

"WP\_Vaccum \_On" := 0;

"CP\_Vaccum\_ON" := 0;

END\_IF;

END\_IF;

10:

IF "CP\_X\_Movement\_Ext\_Sensor" THEN

"CP\_Z\_Movement\_ON" := 1;

#Step := 11;

END\_IF

;

;

11:

IF "CP\_Z\_Movement\_Sensor" THEN

"CP\_Z\_Movement\_ON" := 0;

"CP\_Vaccum\_ON" := 0;

"CP\_Stopper\_On" := 0;

"WP\_Hand\_Ext" := 1;

"WP\_Hand\_Ret" := 0;

#Step := 12;

;

END\_IF;

;

12:

IF "S\_WP\_Entry\_sensor" THEN

IF NOT "S\_slideFull\_sensor" THEN

//segment2 off

"seg1\_1" := 0;

"seg1\_2" := 0;

"seg1\_3" := 0;

"seg1\_blink" := 0;

"seg2\_1" := 0;

"seg2\_2" := 0;

"seg2\_3" := 0;

"seg2\_blink" := 0;

"seg3\_1" := 0;

"seg3\_2" := 0;

"seg3\_3" := 0;

"seg3\_blink" := 0;

"seg4\_1" := 0;

"seg4\_2" := 0;

"seg4\_3" := 0;

"seg4\_blink" := 0;

"seg5\_1" := 0;

"seg5\_2" := 0;

"seg5\_3" := 0;

"seg5\_blink" := 0;

"buzzer\_type1" := 0;

"buzzer\_type2" := 0;

"buzzer\_state" := 0;

"Segment\_mode" := 1;

"level\_mode" := 0;

"runlight\_mode" := 0;

"flexible\_mode" := 0;

"sync\_start" := 0;

"sync\_impulse" := 0;

"No\_of\_segments" := 3;

"blink\_seg1" := 0;

"blink\_seg2" := 0;

"blink\_seg3" := 0;

"blink\_seg4" := 0;

"blink\_seg5" := 0;

"blinking\_freequency" := 5;

"buzzer\_volume" := 255;

//segment3 green

"seg1\_1" := 0;

"seg1\_2" := 0;

"seg1\_3" := 0;

"seg1\_blink" := 0;

"seg2\_1" := 0;

"seg2\_2" := 0;

"seg2\_3" := 0;

"seg2\_blink" := 0;

"seg3\_1" := 1;

"seg3\_2" := 0;

"seg3\_3" := 0;

"seg3\_blink" := 0;

"seg4\_1" := 0;

"seg4\_2" := 0;

"seg4\_3" := 0;

"seg4\_blink" := 0;

"seg5\_1" := 0;

"seg5\_2" := 0;

"seg5\_3" := 0;

"seg5\_blink" := 0;

"buzzer\_type1" := 0;

"buzzer\_type2" := 0;

"buzzer\_state" := 0;

"Segment\_mode" := 1;

"level\_mode" := 0;

"runlight\_mode" := 0;

"flexible\_mode" := 0;

"sync\_start" := 0;

"sync\_impulse" := 0;

"No\_of\_segments" := 3;

"blink\_seg1" := 0;

"blink\_seg2" := 0;

"blink\_seg3" := 0;

"blink\_seg4" := 0;

"blink\_seg5" := 0;

"blinking\_freequency" := 5;

"buzzer\_volume" := 255;

"CP\_Conveyor" := 0;

"S\_Conveyor" := 1;

"S\_WP\_stopper" := 0;

"TimerOn" := 1;

#Step := 13;

ELSE

//Seg 3 blue for slide full sensor

"seg1\_1" := 0;

"seg1\_2" := 0;

"seg1\_3" := 0;

"seg1\_blink" := 0;

"seg2\_1" := 0;

"seg2\_2" := 0;

"seg2\_3" := 0;

"seg2\_blink" := 0;

"seg3\_1" := 1;

"seg3\_2" := 1;

"seg3\_3" := 0;

"seg3\_blink" := 0;

"seg4\_1" := 0;

"seg4\_2" := 0;

"seg4\_3" := 0;

"seg4\_blink" := 0;

"seg5\_1" := 0;

"seg5\_2" := 0;

"seg5\_3" := 0;

"seg5\_blink" := 0;

"buzzer\_type1" := 0;

"buzzer\_type2" := 0;

"buzzer\_state" := 0;

"Segment\_mode" := 1;

"level\_mode" := 0;

"runlight\_mode" := 0;

"flexible\_mode" := 0;

"sync\_start" := 0;

"sync\_impulse" := 0;

"No\_of\_segments" := 3;

"blink\_seg1" := 0;

"blink\_seg2" := 0;

"blink\_seg3" := 0;

"blink\_seg4" := 0;

"blink\_seg5" := 0;

"blinking\_freequency" := 5;

"buzzer\_volume" := 255;

//end of seg3 blue

"S\_Conveyor" := 0;

"CP\_Conveyor" := 0;

END\_IF

;

END\_IF;

13:

// Sorting Mechanism //

IF "TimerOff" AND "S\_Inductive\_sensor" AND "S\_Red\_WP\_sensor" THEN

"S\_WP\_stopper" := 1;

"TimerOn" := 0;

"S\_sep\_2" := 0;

"S\_Sep\_1" := 1;

#Step := 3;

END\_IF;

IF "TimerOff" AND "S\_Red\_WP\_sensor" THEN

"S\_WP\_stopper" := 1;

"TimerOn" := 0;

"S\_sep\_2" := 1;

#Step := 3;

END\_IF;

IF "TimerOff" THEN

"S\_WP\_stopper" := 1;

"TimerOn" := 0;

#Step := 3;

END\_IF;

END\_CASE;

"IEC\_Timer\_0\_DB".TON(IN:="TimerOn",

PT:=T#2s,

Q=>"TimerOff");