






















## PLC tags

	Name	Data type	Address	Retain	Access- ible from HMI/OPC UA	Writable from HMI/OPC UA	Visible in HMI engi- neering	Supervision	Comment
	Start Button	Bool	%I0.0	False	True	True	True		
	Reset Button	Bool	%I0.1	False	True	True	True		
	Vision Sensor 1	Bool	%I0.2	False	True	True	True		
	Blue Reset Sensor	Bool	%I0.3	False	True	True	True		
	Conveyor 1	Bool	%Q0.0	False	True	True	True		
	Conveyor 2	Bool	%Q0.1	False	True	True	True		
	Conveyor 3	Bool	%Q0.2	False	True	True	True		
	Blue Pivot	Bool	%Q0.3	False	True	True	True		
	Blue Pivot Move	Bool	%Q0.4	False	True	True	True		
	Conveyor 4	Bool	%Q0.5	False	True	True	True		
	Conveyor 5	Bool	%Q0.6	False	True	True	True		
	Convayor 6	Bool	%Q0.7	False	True	True	True		
	Convayor 7	Bool	%Q1.0	False	True	True	True		
	Blue Push Sensor	Bool	%I0.4	False	True	True	True		
	Blue Pusher	Bool	%Q1.1	False	True	True	True		
	Green Push Sensor	Bool	%I0.5	False	True	True	True		
	Green Pusher	Bool	%Q1.2	False	True	True	True		
	Green Counter Reset Sensor	Bool	%I0.6	False	True	True	True		
	Blue Counter Reset Sensor	Bool	%I0.7	False	True	True	True		
	Convayor 8	Bool	%Q1.3	False	True	True	True		
	Convayor 9	Bool	%Q1.4	False	True	True	True		
	Convayor 10	Bool	%Q1.5	False	True	True	True		
	Convayor 11	Bool	%Q1.6	False	True	True	True		
	Convayor 12	Bool	%Q1.7	False	True	True	True		
	Convayor 13	Bool	%Q2.0	False	True	True	True		
	Convayor 14	Bool	%Q2.1	False	True	True	True		
	Convayor 15	Bool	%Q2.2	False	True	True	True		
	Convayor 16	Bool	%Q2.3	False	True	True	True		
	Blue Pusher Move	Bool	%Q2.4	False	True	True	True		
	Green Pusher Move	Bool	%Q2.5	False	True	True	True		
	Blue Aligner Pusher 1	Bool	%Q2.6	False	True	True	True		
	Blue Aligner Pusher 2	Bool	%Q2.7	False	True	True	True		
	Green Aligner Pusher	Bool	%Q3.0	False	True	True	True		
	Blue Aligner Sensor 1	Bool	%I1.0	False	True	True	True		
	Blue Aligner Sensor 2	Bool	%I1.1	False	True	True	True		
	Green Aligner Sensor 1	Bool	%I1.2	False	True	True	True		
	Green Aligner Pusher Out	Bool	%I1.3	False	True	True	True		
	Blue Aligner Pusher Out 1	Bool	%I1.4	False	True	True	True		
	Blue Aligner Pusher Out 2	Bool	%I1.5	False	True	True	True		
	Green Machine End Sensor	Bool	%I1.6	False	True	True	True		
	Green Machine Start	Bool	%Q3.1	False	True	True	True		
	Green Machine Lid	Bool	%Q3.2	False	True	True	True		
	Green Machine Reset	Bool	%Q3.3	False	True	True	True		
	Blue Machine Start 2	Bool	%Q3.4	False	True	True	True		
	Blue Machine Reset 2	Bool	%Q3.5	False	True	True	True		
	Blue Machine Lid 2	Bool	%Q3.6	False	True	True	True		
	Blue Machine End Sensor 2	Bool	%I1.7	False	True	True	True		
	Blue Machine End Sensor 1	Bool	%I2.0	False	True	True	True		
	Blue Diffuse Sensor Top	Bool	%I2.1	False	True	True	True		
	Blue Diffuse Sensor Bottom	Bool	%I2.2	False	True	True	True		
	Blue Top Clamped	Bool	%I2.3	False	True	True	True		
	Blue Bottom Clamped	Bool	%I2.4	False	True	True	True		
	Blue Bottom Conveyor	Bool	%Q3.7	False	True	True	True		
	Blue Top Conveyor	Bool	%Q4.0	False	True	True	True		
	Blue Top Conveyor 2	Bool	%Q4.1	False	True	True	True		
	Blue Top Conveyor 3	Bool	%Q4.2	False	True	True	True		



Totally Integrated Automation Portal										
	Name	Data type	Address	Retain	Accessi-ble from HMI/OPC UA	Writable from HMI/OPC UA	Visible in HMI engi-neering	Supervision	Comment	
	Extend Arm	Bool	%Q8.0	False	True	True	True			
	Tag_3	Bool	%Q8.1	False	True	True	True			
	Tag_4	Bool	%Q8.2	False	True	True	True			
	Tag_5	Bool	%Q8.3	False	True	True	True			
	Tag_6	Bool	%M0.4	False	True	True	True			
	Tag_7	Bool	%M0.5	False	True	True	True			
	Tag_8	Bool	%M0.7	False	True	True	True			

Totally Integrated Automation Portal																
<div>Default tag table [175]</div> <div>User constants</div> <table><tr><th colspan="4">User constants</th></tr><tr><th></th><th>Name</th><th>Data type</th><th>Value</th><th>Comment</th></tr><tr><td colspan="5"></td></tr></table>			User constants					Name	Data type	Value	Comment					
User constants																
	Name	Data type	Value	Comment												