|--|

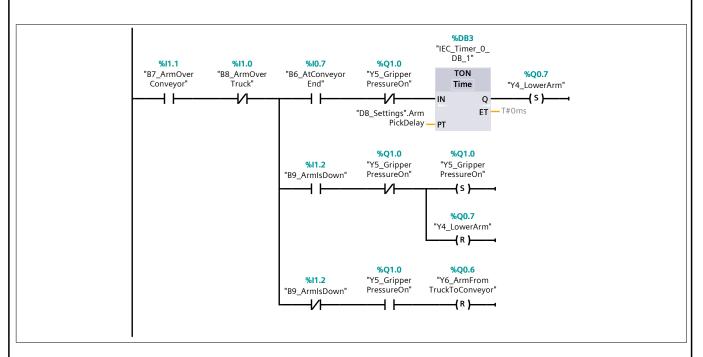
conveyor-push-sort / PLC_1 [CPU 1214C AC/DC/Rly] / Program blocks

FC_PickAndPlace [FC3]

FC_PickAndPlace Properties									
General									
Name	FC_PickAndPlace	Number	3	Type	FC				
Language	LAD	Numbering	Automatic						
Information									
Title		Author		Comment					
Family		Version	0.1	User-defined					
				ID					

FC_PickAndPlace							
Name	Data type	Default value	Comment				
Input							
Output							
InOut							
Temp							
Constant							
▼ Return							
FC_PickAndPlace	Void						

Network 1:



Network 2:

Totally Integrated
Automation Portal

```
%DB7
                                                                                       "IEC_Timer_0_
DB_2"
%l1.1
"B7_ArmOver
Conveyor"
                                            %Q1.0
"Y5_Gripper PressureOn"
                         %I1.0
                     "B8_ArmOver
Truck"
                                                                                            TON
                                                                      %I1.2
                                                                                                                 %Q0.7
                                                                                            Time
                                                               "B9_ArmIsDown"
                                                                                                            "Y4_LowerArm"
    -V-
                                                +
                                                                                                    Q-
                                                                                                                  (s)-
                                                               "DB_Settings".Arm
PlaceDelay _
                                                                                                    ET — T#0ms
                                                                                        %Q1.0
"Y5_Gripper
PressureOn"
                                                                      %I1.2
                                                                "B9_ArmIsDown"
                                                                                            -(R)-
                                                                      \dashv \vdash
                                               %Q1.0
                                            "Y5_Gripper
PressureOn"
                                                                      %I1.2
                                                                                           %Q0.7
                                                                                      "Y4_LowerArm"
                                                               "B9_ArmIsDown"
                                                                       -(R)-
                                                                                           %Q0.6
                                                               %I1.2 "Y6_ArmFrom
"B9_ArmIsDown" TruckToConveyor"
                                                                                            -(s)-
```