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

Main [OB1]

Main Properties								
General								
Name	Main	Number	1	Туре	OB			
Language	LAD	Numbering	Automatic					
Information								
Title	"Main Program Sweep (Cycle)"	Author		Comment				
Family		Version	0.1	User-defined ID				

Main							
Name	Data type	Default value	Comment				
✓ Input							
Initial_Call	Bool		Initial call of this OB				
Remanence	Bool		=True, if remanent data are available				
Temp							
Constant							

Network 1:

```
%M11.2

"M_Start_One
"S1_Start"

N |
%M11.1

"M_Start_Last
State_Negative"
```

Network 2:

```
%M11.3

%I0.1

"S2_Stop"

RS

"P1_LightGreen"

W_Start_One
Shot_Negative"

S1
```

Network 3:

```
Totally Integrated
  Automation Portal
                                                                %FC1
                                      %M11.3
                                    "M_Running"
                                                            "FC_Conveyor"
                                        \dashv \vdash
                                                    - EN
                                                                            ENO
                                                   %I0.7
"B6_AtConveyor End"
                                                                                                     %Q0.4
"M1_Conveyor Move"
                                      %M11.3
                                    "M_Running"
Network 4:
                                                    %FC2
                                      %M11.3
                                                    "FC_Feeder"
                                    "M_Running"
                                                    EN
                                                           ENO
Network 5:
                                                               %FC3
                                      %M11.3
                                                         "FC_PickAndPlace"
                                    "M_Running"
                                        \dashv \vdash
                                                    - EN
                                                                            ENO -
Network 6:
                                    %M11.3
"M_Running"
                                                       %FC4
                                                     "FC_Truck"
                                        +
                                                          ENO ·
Network 7:
                                                                %FC5
                                      %M11.3
                                                          "FC_ArmSafeStop"
                                    "M_Running"
                                        <del>-</del>1/1-
                                                    - EN
                                                                            ENO -
Network 8:
```

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Totally Integrated			
Automation Portal			
	%M11.2	"DB_A Steps"	ArmSafeStop .MovedOver onveyor
	"M_Start_One Shot_Negative"	Co	onveyor
			-(R)
		"DB_A	ArmSafeStop S".Lowered
		Step	s".Lowered —(R)———•
		"DB_A Step:	ArmSafeStop s".Released
			-(R)
		"DB A	ArmSafeStop
			ArmSafeStop ps".Lifted
			-(R)