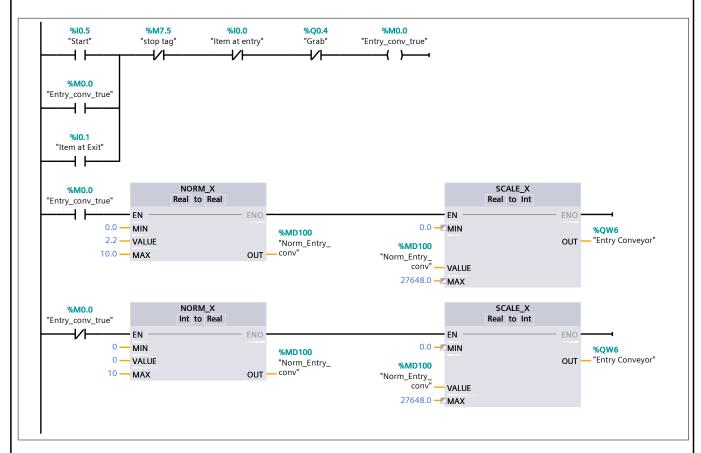
|--|

Main_1 [OB123]

Main_1 Prope	erties				
General					
Name	Main_1	Number	123	Туре	ОВ
Language	LAD	Numbering	Automatic		
Information					
Title	"Main Program Sweep (Cycle)"	Author		Comment	
Family		Version	0.1	User-defined ID	

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:



Network 2:

```
Totally Integrated
   Automation Portal
                                                                      %I0.7 "Stop"
                                               %10.5
"Start"
                                                                                                                                      %Q0.5
"Start Light"
                                                \dashv \vdash
                                               %Q0.5
                                            "Start Light"
                                                +
Network 3:
                                                %10.7 "Stop"
                                                                      %I0.5
"Start"
                                                                                                                                      %Q0.7
"Stop Light"
                                                <del>-</del>//-
                                            %Q0.7
"Stop Light"
                                                \dashv \vdash
                                                %10.7
"Stop"
                                                                   %Q0.5
"Start Light"
                                                                                                                                       %M7.5 "stop tag"
                                                <del>-</del>1/1-
                                                                                                                                          <del>(</del> )-
                                               %M7.5
                                              "stop tag"
                                                <del>|</del> | |
Network 4:
                                                                      %DB1
                                                                "IEC_Timer_0_DB"
                                                                TON
Time
                                                %10.0
                                           "Item at entry"
                                                                             Q-
                                                      T#0.5s — PT
                                                                              ET — T#0ms
Network 5:
```

Totally Integrated Automation Portal

```
"IEC_Timer_0_
DB".Q
                 %I0.4
"Item Detected"
                                       %M7.5 "stop tag"
                                                                             %M0.3
                                                                          "Move_z_True"
    1 H
                       <del>/</del>/}
                                                                              %M0.3
"Move_z_True"
    \dashv \vdash
   %M7.2
"-ve edge to
start z"
                     %M7.4
                    "o/ps off"
    4 F
                            NORM_X
Real to Real
                                                                                                        SCALE_X
   %M0.3
                                                                                                      Real to Int
"Move_z_True"
    +
                  EN -
                                             ENO:
                                                                                            - EN
                                                                                                                       ENO
           0.0 — MIN
                                                                                     0.0 ─■MIN
                                                     %MD116
                                                                                                                               %QW20
           10.0 — VALUE
                                                                                                                               "Move z"
                                             OUT
                                                    - "Norm _Move z"
                                                                                                                       OUT
                                                                                 %MD116
           10.0 — MAX
                                                                           "Norm _Move z" — VALUE
                                                                                 27648.0 — MAX
                              NORM_X
                                                                                                        SCALE_X
   %M0.3
"Move_z_True"
                            Real to Real
                                                                                                      Real to Int
                  EN -
                                             ENO
            0.0 — MIN
                                                                                      0.0 - MIN
                                                     %MD116
                                                                                                                               %QW20
           0.0 — VALUE
                                                    Norm _Move z"
                                                                                                                              - "Move z"
                                             OUT
                                                                                 %MD116
                                                                                                                        OUT
           10.0 — MAX
                                                                           "Norm _Move z" — VALUE
                                                                                 27648.0 —ℤMAX
```

Network 6:

```
%I0.4 %M7.4 %Q0.4 "Grab" ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) — ( ) —
```

Network 7:

Totally Integrated Automation Portal

```
%M7.3
 "-ve edge to
                      %M7.4
                                        %M7.5
                                                                              %M0.2
   start x"
                     "o/ps off"
                                       "stop tag"
                                                                          "Move_x_True"
                                          <del>1</del>/}
                       <del>//</del>|
    4 H
                                                                               ( )-
   %M0.2
"Move_x_True"
                              NORM_X
                                                                                                         SCALE_X
   %M0.2
"Move_x_True"
                            Real to Real
                                                                                                       Real to Int
    \dashv \vdash
                  EN ·
                                             ENO
                                                                                             - EN
                                                                                                                        ENO
                                                                                      0.0 ─☑MIN
           0.0 — MIN
                                                      %MD112
                                                                                                                                %QW18
           10.0 — VALUE
                                                      "Norm_Move_x"
                                                                                                                                Move x"
                                             OUT
                                                                                                                         OUT
                                                                                  %MD112
           10.0 — MAX
                                                                            "Norm_Move_x" — VALUE
                                                                                  27648.0 - MAX
                            NORM_X
Real to Real
                                                                                                       SCALE_X
Real to Int
   %M0.2
"Move_x_True"
                  - EN
                                                                                             - FN
                                             ENO
                                                                                                                        ENO
            0.0 — MIN
                                                                                       0.0 -MIN
                                                      %MD112
                                                                                                                                %OW18
            0.0 — VALUE
                                                      "Norm_Move_x"
                                                                                                                                - "Move x"
                                              OUT
                                                                                  %MD112
                                                                                                                         OUT
           10.0 — MAX
                                                                            "Norm_Move_x"
                                                                                             - VALUE
                                                                                  27648.0 ─ℤMAX
```

Network 8:

```
%I0.1
                     %M7.5
                                                                           %M0.1
                                                                       "Exit_Conv_true"
 "Item at Exit"
                    "stop tag"
                                                                           ( )-
     4 H
    %M0.1
"Exit_Conv_true"
     1 F
                                                                                                    SCALE_X
    %M0.1
                             NORM_X
"Exit_Conv_true"
                            Real to Real
                                                                                                   Real to Int
                  EN -
                                            ENO
                                                                                         EN
                                                                                                                   ENO
            0.0 — MIN
                                                                                   0.0 -MIN
                                                    %MD104
                                                                                                                          %OW8
            2.2 — VALUE
                                                                                                                         "Exit Conveyor"
                                            OUT — "Norm_Exit_conv"
                                                                                                                   OUT ·
                                                                              %MD104
           10.0 — MAX
                                                                       "Norm_Exit_conv" — VALUE
                                                                              27648.0 - MAX
```

Network 9:

```
%M7.2
                                                                                   "-ve edge to
start z"
   %10.2
                       %M7.4
                                           %M7.5
                                                                %Q0.4
                      "o/ps off"
"Moving x"
                                                                 "Grab"
                                          "stop tag"
                                                                                     ( )
   ┨╖┞
  %M7.1
"-ve edge x"
  %M7.2
"-ve edge to
  start z"
```

.		
Totally Integrated Automation Portal		
Network 10:		
	%M7.3 "Moving Z" "o/ps off" "Item at entry" %M7.0 "-ve edge to start x" %M7.3 "-ve edge to start x"	-1
Network 11:		
	%I0.1 %I0.0 %M7.4 "o/ps off" ()	-1
Network 12:		
_	%M0.1 "Exit_Conv_true" EN ENO -6000 IN %QW10 "Feeding_ Curved_Conv"	-1
Network 13:		
	%M0.1 "Exit_Conv_true" EN ENO 7500 IN WQW12 "To Sorting Conv"	-1
Network 14:		

Totally Integrated **Automation Portal** %DB2 "IEC_Timer_0_ DB_1" %I1.3 "Vision Sensor Blue" TP %Q1.0 "Sorting Rollers" Time ()-Q ET — T#0ms T#2.5s — PT **%I1.4** "Vision Sensor Green" %Q1.0 "Sorting Rollers" Network 15: %I1.3 "Vision Sensor Blue" "IEC_Timer_0_ DB_1".Q %Q1.2 "Left Pose" 4 F %Q1.2 "Left Pose" +Network 16: **%l1.4** "Vision Sensor Green" %Q1.1 "Right Pose" "IEC_Timer_0_ DB_1".Q %Q1.1 "Right Pose" +Network 17:

Totally Integrated **Automation Portal %I1.5 %I1.6** %M0.6 "Start Green "Start Blue "Start Green Conv sesnor" Conv sensor" conv bit" **(**)-%M0.6 "Start Green conv bit" %M0.6 "Start Green conv bit" MOVE 4 F EN - ENO -10000 — IN %QW16 OUT1 — "Green Conv" %I1.6 "Start Blue Conv sensor" MOVE \dashv \vdash EN --- ENO 0 — IN %QW16 d OUT1 -– "Green Conv" %DB4 "IEC_Counter_ 0_DB_1" **%I1.5** "Start Green Conv sesnor" \dashv \vdash - cu Qfalse — R **cv** — 0 Network 18: %M0.7 **%I1.6** %I1.5 "Start Blue Conv sensor" "Start Green Conv sesnor" "Start Blue Conv bit" | | | **()** %M0.7 "Start Blue Conv bit" %M0.7 "Start Blue Conv bit" MOVE - EN --- ENO -10000 — IN %QW14 dount --- "Blue Conv"

Network 19:

%I1.5"Start Green
Conv sesnor"

MOVE EN — ENO

%QW14

OUT1 — "Blue Conv"

0 — IN

Totally Integrated **Automation Portal** %M0.6 "Start Green conv bit" MOVE **H** F EN - ENO -10000 — IN %QW24 double of the order of the orde MOVE OUT1 — "Green Conv 3" MOVE 10000 — EN — ENO — %QW28 d OUT1 — "Green Conv 4" Network 20: %M0.7 "Start Blue Conv bit" 10000 — IN — ENO %QW22 double Out 1 — "Blue Conv 2" Network 21:

Totally Integrated **Automation Portal** %Q1.3 "Machining Blue Start" %10.5 %M7.5 "Start" "stop tag" 1/} **()** %Q1.3 %Q1.5 "Machining Blue Start" "Machining Green Start" **-** | | ()-%Q1.5 "Machining Green Start" %DB5 "IEC_Counter_ 0_DB_2" **%I2.0** "Green Machining Sensor Exit" CTU $\dashv \vdash$ – cu Q**cv** — 0 false — R 125 — PV %DB6 "IEC_Counter_ O_DB_3" **%l1.7**"Blue Machining Sensor Exit" \dashv \vdash - cu Qfalse — R **cv** — 0 "IEC_Counter_ 0_DB_2".CV. %X0 %Q1.6 "Machining Green prod_lid" \leftarrow "IEC_Counter_ 0_DB_3".CV. %X0 %Q1.4 "Machining Blue prod_lid" ()-Network 22:

Totally Integrated **Automation Portal** "Green Machining Sensor Exit" MOVE | | | EN - ENO 10000 — IN %QW30 "Green Conv MOVE - EN --- ENO -10000 — - IN %QW34 "Green Conv to - Assembly" d OUT1 -**%I2.6** "Green Base Vision Sensor" MOVE +- EN — ENO 0 — IN %QW34 "Green Conv to — Assembly" **%I2.4** ₫ OUT1 -"Green Base Assembly Sensor" MOVE \dashv P \vdash EN - ENO %M15.0 0 — IN %QW30 "+ve edge green base "Green Conv after mach." sesnsor" **%I2.5** "Green Lid Assembly Sensor" \dashv P \vdash %M15.1 "+ve edge green lid sensor" Network 23: **%I1.7**"Blue Machining Sensor Exit" MOVE EN --- ENO 10000 — IN %QW32 "Blue Conv after mach." Network 24:

Totally Integrated **Automation Portal** %M12.1 "+ve edge Pusher Green true" **%I2.6** %Q2.0 "Green Base Vision Sensor" "Pusher Green Base" 1 ()-%Q2.0 "Pusher Green Base" Network 25: %M12.1 %12.7 %Q2.0 "+ve edge "Pusher Green F_Limit" "Pusher Green Base" Pusher Green true" **-**|P|-**-()**-%M12.0 "+ve edge Pusher Green" %M12.1 "+ve edge Pusher Green true"

Network 26:

```
%12.6
"Green Base
Vision Sensor"
                       MOVE
                   - EN
                           - ENO
          10000 — IN
                                     %QW40
                                     "Green Base
Conv Assembly"
                         d OUT1 -
   %I3.2
"Green Base
Clamped"
                                        MOVE
    \dashvP\vdash
                                        EN - ENO
   %M25.0
"Tag_2"
                                   0 — IN
                                                          %QW40
                                                        "Green Base
Conv Assembly"
                                              ₫ OUT1 -
```

Network 27:

Totally Integrated **Automation Portal** %13.0 "Green Lid Vision Sensor" MOVE 1 H EN - ENO 10000 — IN %QW38 "Green lid OUT1 — Conv Assembly" MOVE - EN - ENO 10000 — IN %QW36 "Curvred Green Conv assembly" d OUT1 -**%I2.5** "Green Lid Assembly Sensor" MOVE \dashv N \vdash - EN - ENO %M65.0 0 — IN %QW38 "Tag_5" "Green lid — Conv Assembly" d OUT1 MOVE · EN -- ENO 0 — IN %QW36 "Curvred Green Conv assembly"

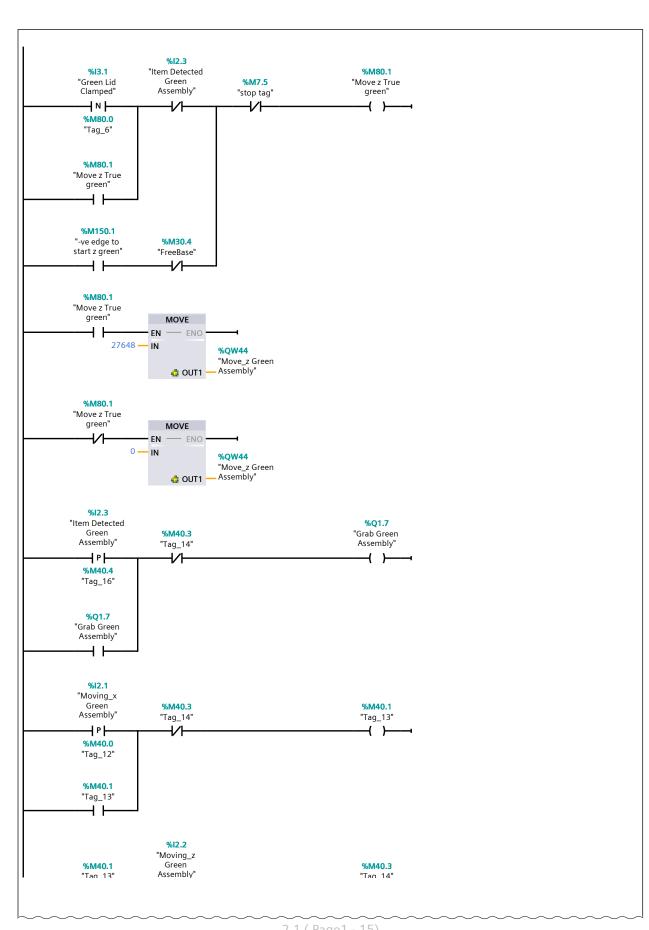
Network 28:

```
%12.4
 "Green Base
                                                                                     %Q2.2
 Assembly
Sensor"
                                                                                  "Clamp Green
Base"
                       %M40.6
                       "Tag_18"
    ⊢P F
  %M40.7
  "Tag_19"
   %Q2.2
"Clamp Green
Base"
    %DB7
                                        "IEC_Timer_0_
DB_3"
  %M150.1
                        %Q2.2
                                             TON
"-ve edge to
start z green"
                    "Clamp Green
Base"
                                                                                     %M30.4
                                         Time
                                                                                    "FreeBase"
    +
                                                                                      <del>(</del> )-
                                        - IN
                                                    Q-
                                T#1s — PT
                                                    ET — T#0ms
   %M30.4
 "FreeBase"
    H F
```

Network 29:

```
Totally Integrated
    Automation Portal
                                                        %13.2
                                                    "Green Base
Clamped"
                                                                                                                                                                %M40.6
"Tag_18"
                                                         -|₽|-
                                                                                                                                                                  <del>(</del> )-
                                                       %M40.5
                                                      "Tag_17"
Network 30:
                                                        %I2.5
                                                                                 %M61.1
                                                     "Green Lid
Assembly
Sensor"
                                                                              "+ve edge to
relase G lid (
true)"
                                                                                                                                                                 %Q2.1
                                                                                                                                                            "Clamp Green
Lid"
                                                        ⊣ N ⊢
                                                                                                                                                                  <del>(</del> )-
                                                      %M60.0 "Tag_3"
                                                       %Q2.1
                                                   "Clamp Green
Lid"
                                                                                                                                                                %M61.1
                                                     %I3.1
"Green Lid
Clamped"
                                                                             %Q2.1
"Clamp Green
Lid"
                                                                                                                                                             "+ve edge to
relase G lid (
true)"
                                                        \dashvP\vdash
                                                      %M61.0 "Tag_4"
                                                      %M61.1
                                                   "+ve edge to
relase G lid (
true)"
Network 31:
```

Totally Integrated **Automation Portal** Network 31: (1.1 / 2.1)



2.1 (Page1 - 15)

Totally Integrated Automation Portal					
letwork 31: (2.1 / 2.1)					
		1.1 (Page1 - 14)	~~~~~	······	\preceq
	%M40.2 "Tag_15"	(

Totally Integrated
Automation Portal

Network 32:

```
%12.2
                          %I2.5
  "Moving_z
                       "Green Lid
                                                                                        %M30.2
                                                                                     "-ve edge to
start x green"
                        Assembly
Sensor"
  Green
Assembly"
     HN H
                                                                                          <del>(</del> )-
   %M55.0
   "Tag_11"
   %M30.2
"-ve edge to
start x green"
     %M30.2
"-ve edge to start x green"
                                                                                        %M30.3
                                                                                     "Move_x Green
True"
                         %M40.3
                        "Tag_14"
     \dashvP\vdash
                                                                                          ( )
    %M41.0
   "Tag_20"
   %M30.3
"Move_x Green
True"
   %M30.3
"Move_x Green
True"
                     MOVE
     H F
                    EN - ENO
          27610 — IN
                                        %QW42
                          "Move_x Green
Asssembly"
   %M30.3
"Move_x Green
True"
                         MOVE
                     EN -
                0 — IN
                                        %QW42
                          "Move_x Green
Asssembly"
```

Network 33:

```
%I2.1
 "Moving_x
                               %Q1.7
                                                                                                                 %M150.1
                            "Grab Green
Assembly"
                                                                                                              "-ve edge to
start z green"
    Green
  Assembly"
     \exists N \vdash
                                 4 F
                                                                                                                    <del>(</del> )-
   %M150.0
   "Tag_9"
  %M150.1
"-ve edge to
start z green"
     \dashv \vdash
```

Network 34:

Totally Integrated **Automation Portal** %Q2.4 "IEC_Timer_0_ DB_5".Q "GreenPositionerR aise" **-**| |-**←**)— Network 35: **%M40.3** "Tag_14" **%M41.2** "Tag_21" +%M41.2 "Tag_21" \dashv \vdash %DB8 "IEC_Timer_0_ DB_4" **%DB9**"IEC_Timer_0_ DB_5" %M41.2 TON TP "Tag_21" Time Time IN Q· · IN Q· ET — T#0ms T#3s — PT ET — T#0ms Network 36: **%Q2.4**"GreenPositionerR %13.3 "Green Product Base Limit" MOVE \mathbf{H}_{P} - EN 10000 — IN %M41.3 %QW40 "Green Base OUT1 — Conv Assembly" "Tag_22" "IEC_Timer_0_ DB_5".Q MOVE **⊣** № | EN - ENO %M41.4 0 — IN

%QW40

"Green Base
OUT1 — Conv Assembly"

"Tag_23"