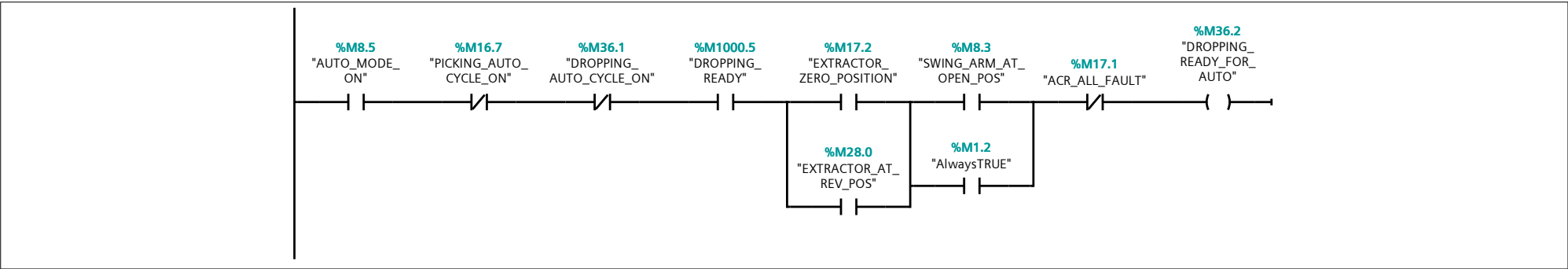


DROPPING AUTO LOGIC [FC6]

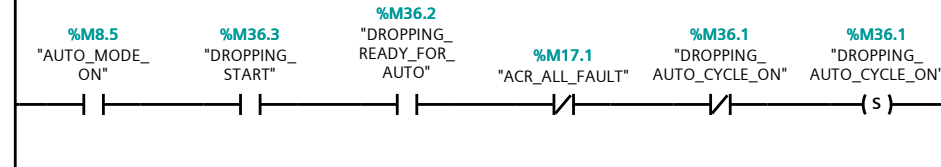
DROPPING AUTO LOGIC Properties							
General							
Name	DROPPING AUTO LOGIC	Number	6	Type	FC	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
DROPPING AUTO LOGIC	Void		

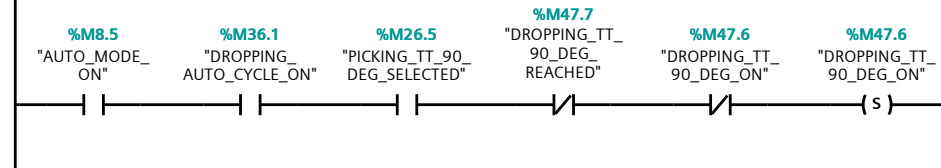
Network 1: DROPPING_CYCLE_READY_FOR_AUTO:



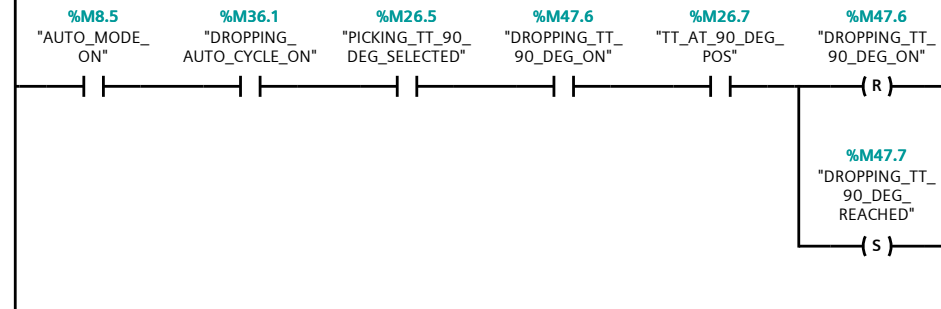
Network 2: DROPPING_AUTO_CYCLE_START:



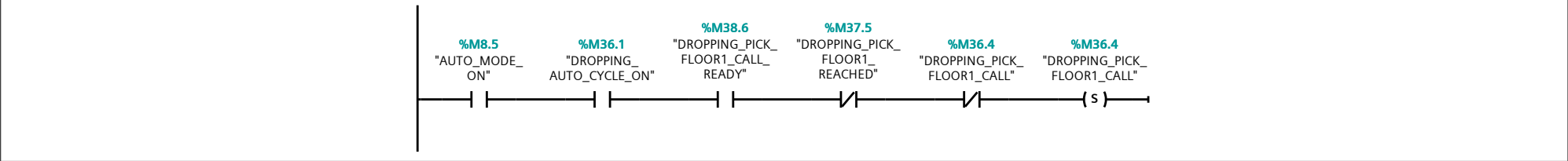
Network 3: TT_ROTATION_90_DEG_CALL_FOR_PICKING_CARTON_FROM_ACR_SHELVES:



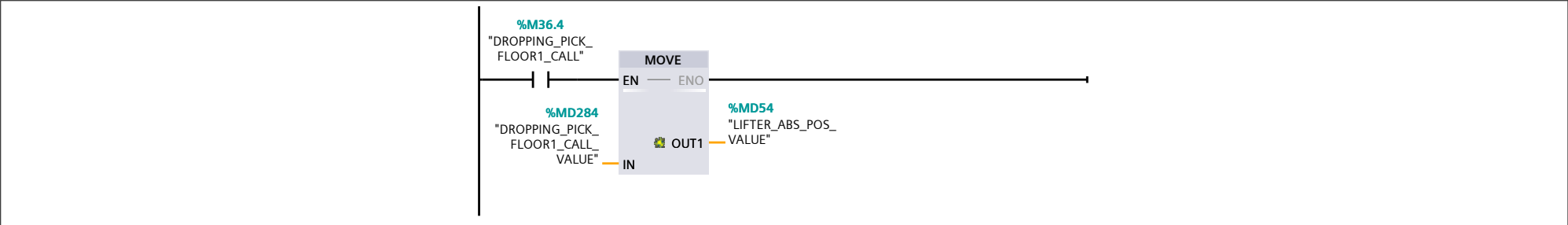
Network 4: TT_ROTATION_90_DEG_CALL_RESET_FOR_PICKING_CARTON_FROM_ACR_SHELVES:



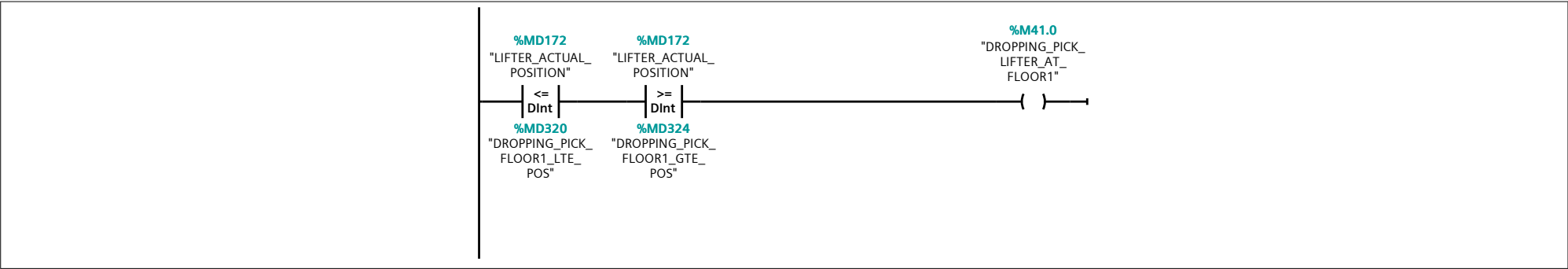
Network 5: FIRST_FLOOR_CALL_FOR_PICKING_CARTON_FROM_ACR_SELVES:



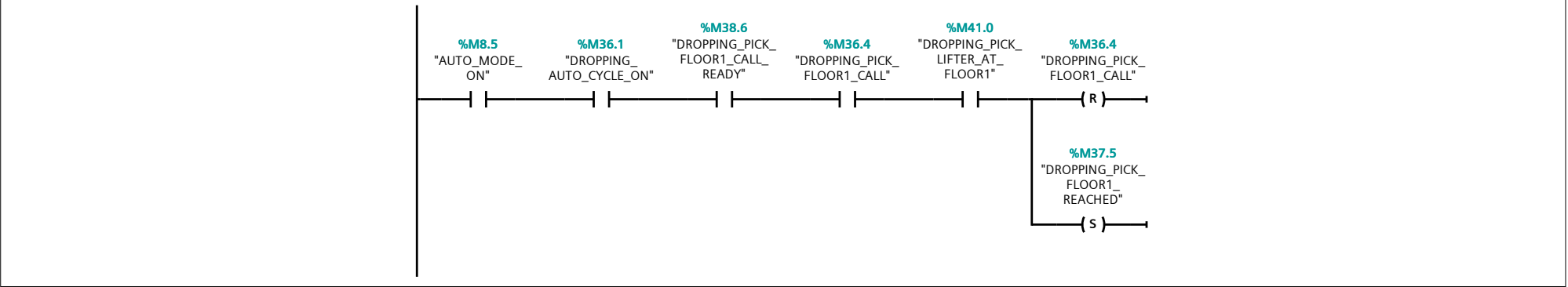
Network 6: DROPPING_PICK_FLOOR1_CALL_VALUE:



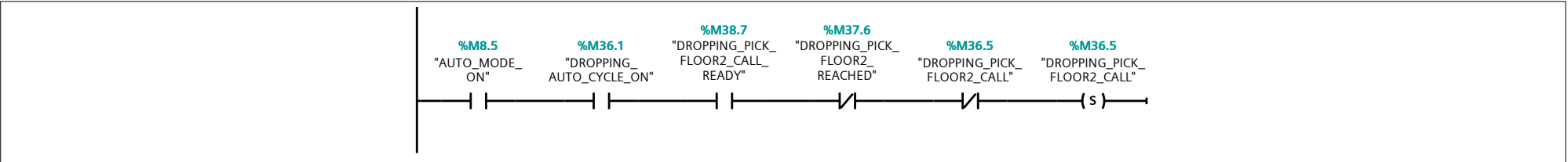
Network 7: FOR_DROPPING_PICK_LIFTER_AT_FLOOR1:



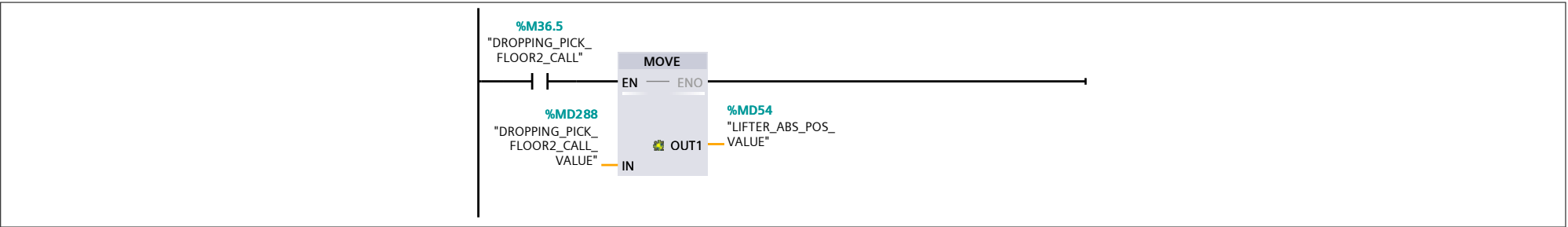
Network 8: FIRST_FLOOR_CALL_RESET_FOR_PICKING_CARTON_FROM_ACR_SELVES:



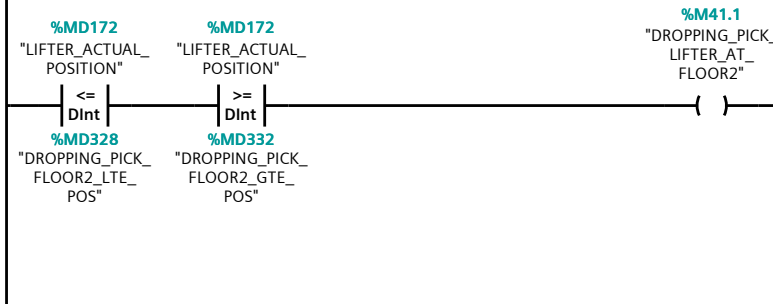
Network 9: SECOND_FLOOR_CALL_FOR_PICKING_CARTON_FROM_ACR_SELVES:



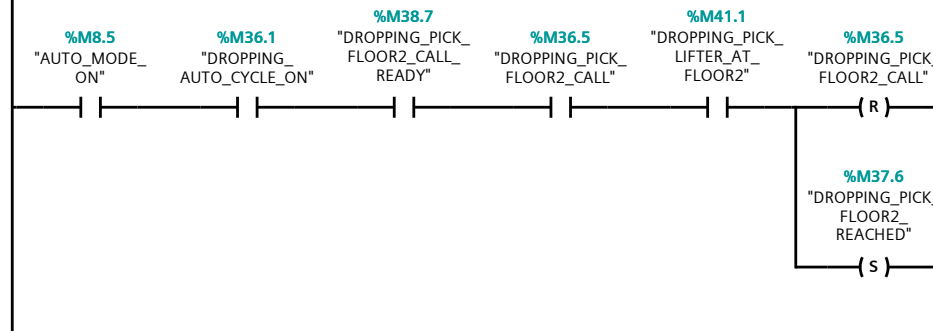
Network 10: DROPPING_PICK_FLOOR2_CALL_VALUE:



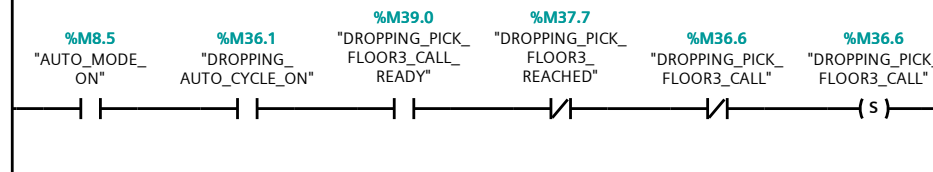
Network 11: FOR_DROPPING_PICK_LIFTER_AT_FLOOR2:



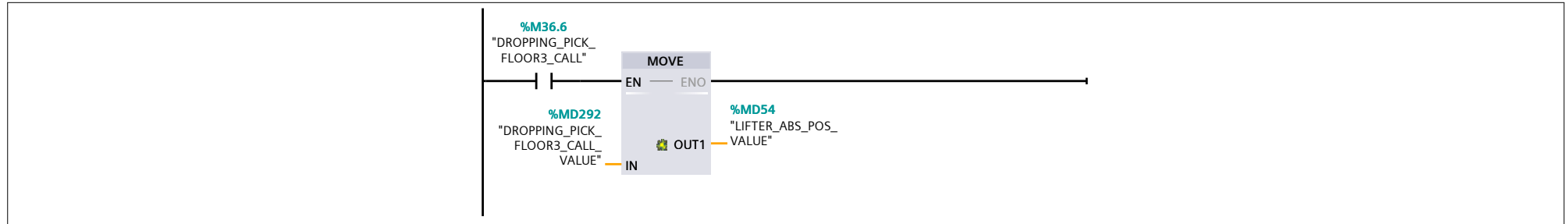
Network 12: SECOND_FLOOR_CALL_RESET_FOR_PICKING_CARTON_FROM_ACR_SELVES:



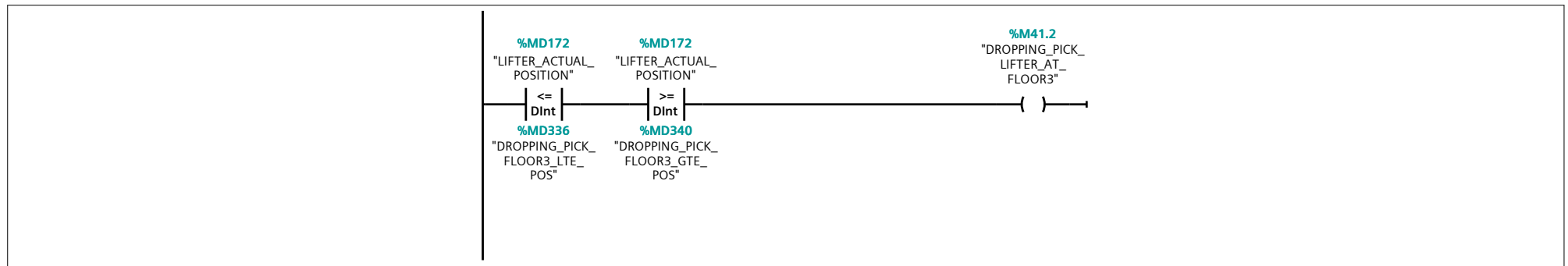
Network 13: THIRD_FLOOR_CALL_FOR_PICKING_CARTON_FROM_ACR_SELVES:



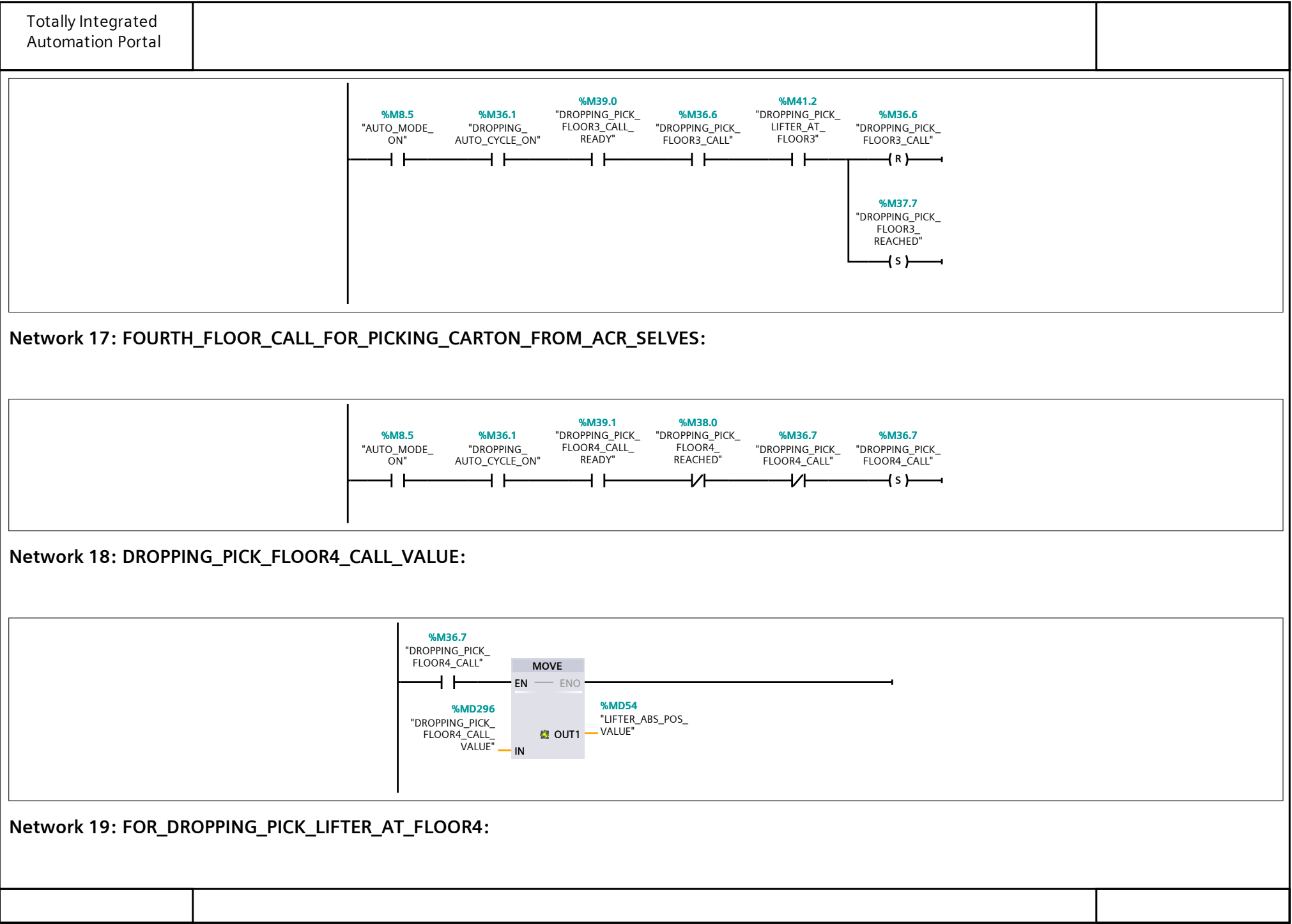
Network 14: DROPPING_PICK_FLOOR3_CALL_VALUE:

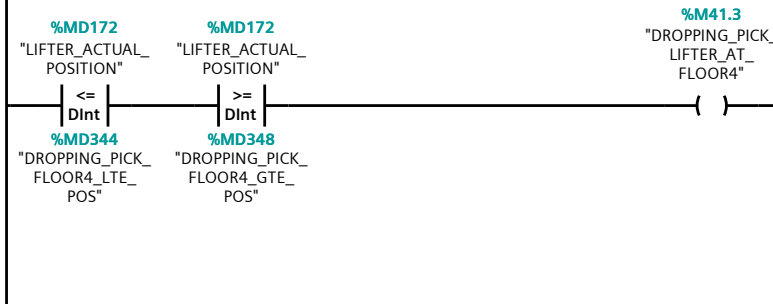


Network 15: FOR_DROPPING_PICK_LIFTER_AT_FLOOR3:

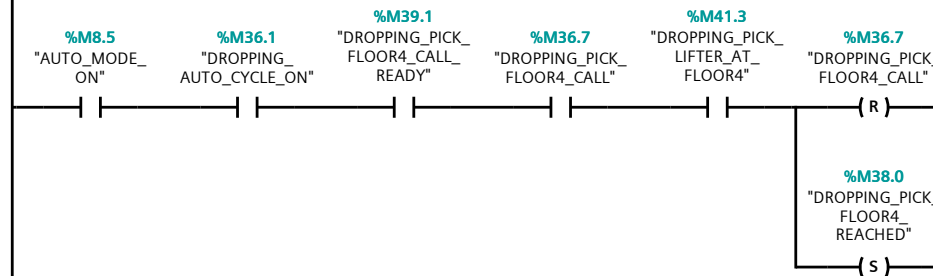


Network 16: THIRD_FLOOR_CALL_RESET_FOR_PICKING_CARTON_FROM_ACR_SELVES:

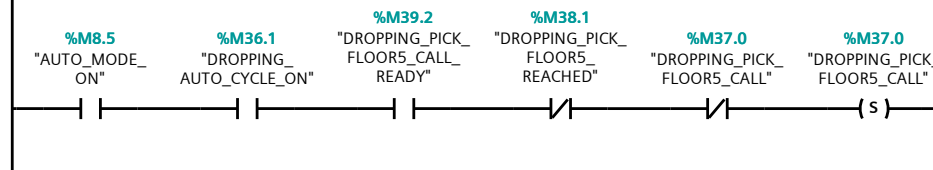




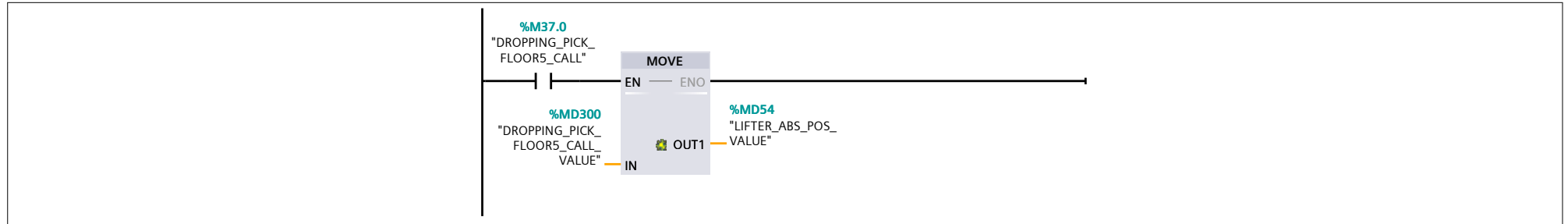
Network 20: FOURTH_FLOOR_CALL_RESET_FOR_PICKING_CARTON_FROM_ACR_SELVES:



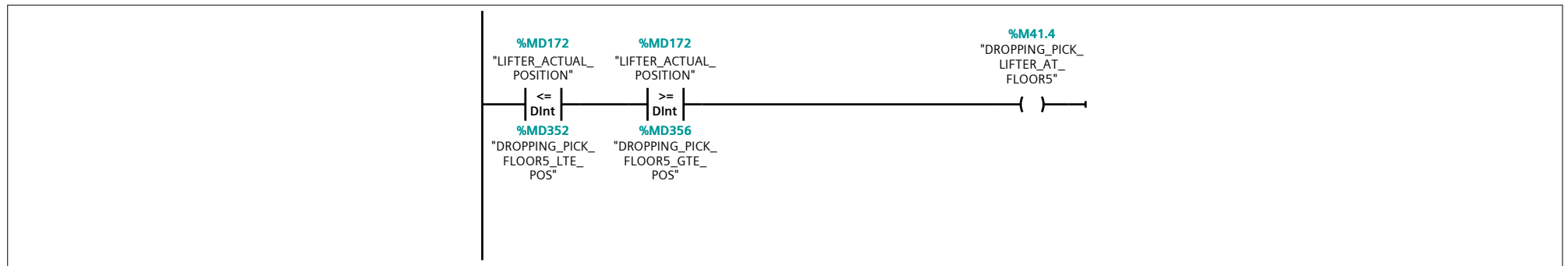
Network 21: FIFTH_FLOOR_CALL_FOR_PICKING_CARTON_FROM_ACR_SELVES:



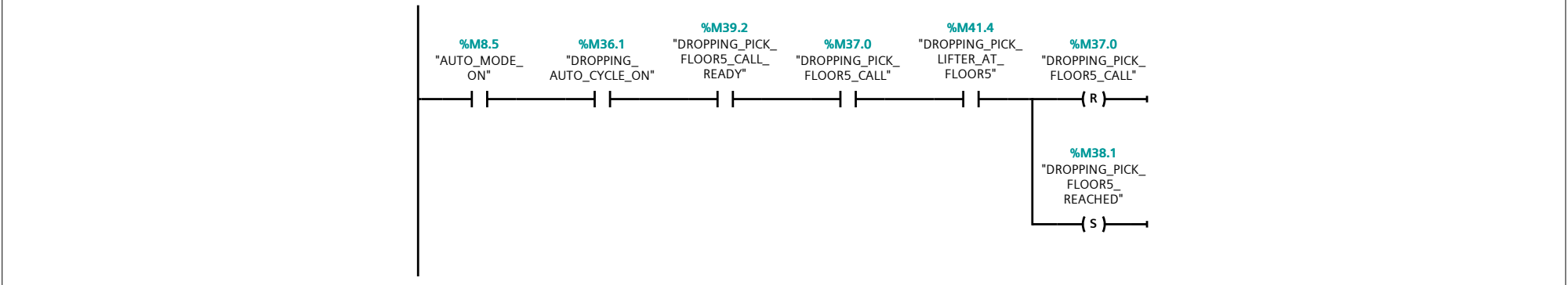
Network 22: DROPPING_PICK_FLOOR5_CALL_VALUE:



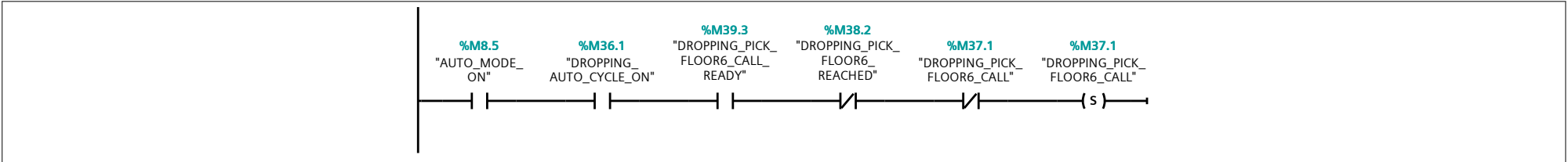
Network 23: FOR_DROPPING_PICK_LIFTER_AT_FLOOR5:



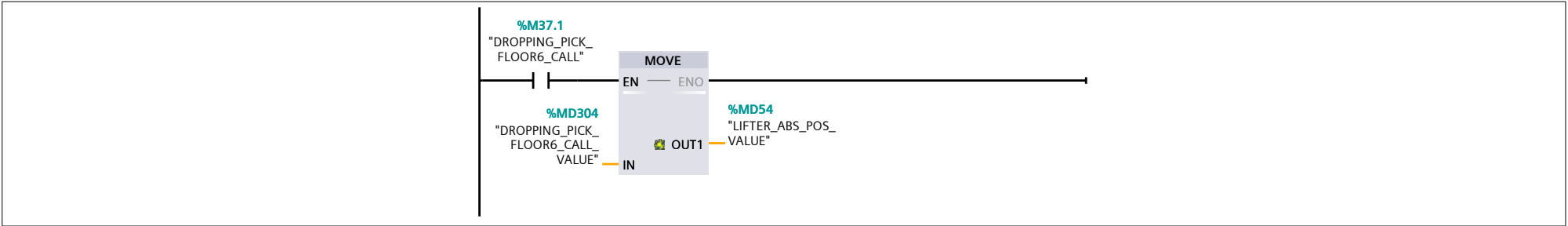
Network 24: FIFTH_FLOOR_CALL_RESET_FOR_PICKING_CARTON_FROM_ACR_SELVES:



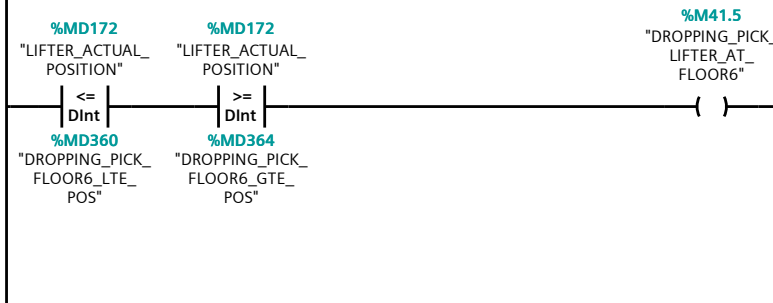
Network 25: SIXTH_FLOOR_CALL_FOR_PICKING_CARTON_FROM_ACR_SELVES:



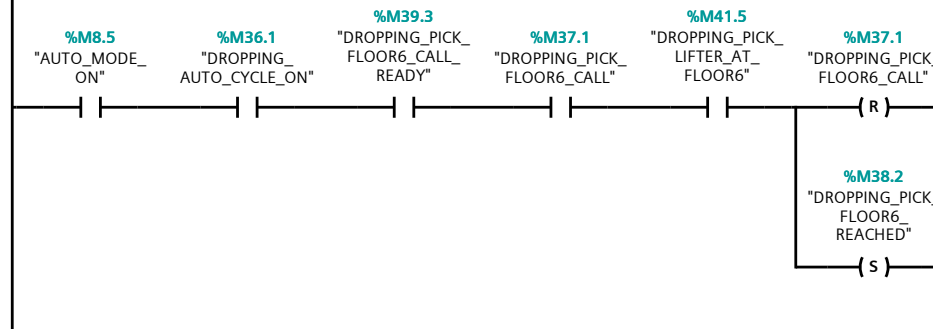
Network 26: DROPPING_PICK_FLOOR6_CALL_VALUE:



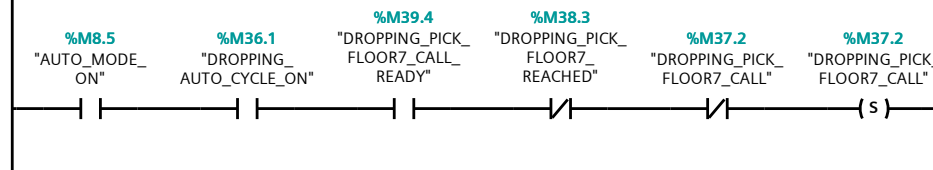
Network 27: FOR_DROPPING_PICK_LIFTER_AT_FLOOR6:



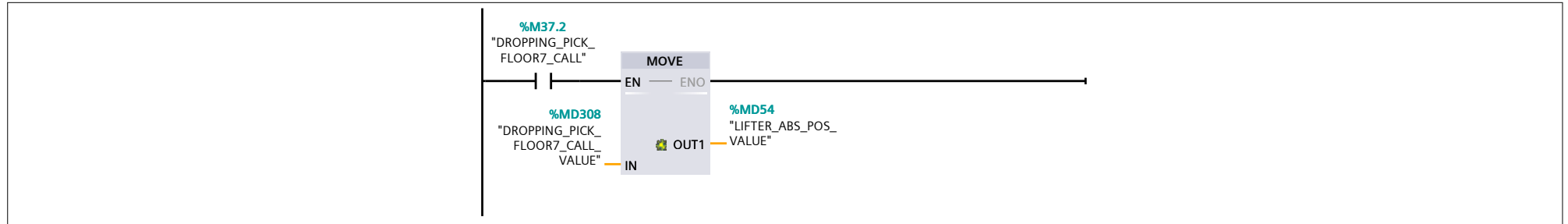
Network 28: SIXTH_FLOOR_CALL_RESET_FOR_PICKING_CARTON_FROM_ACR_SELVES:



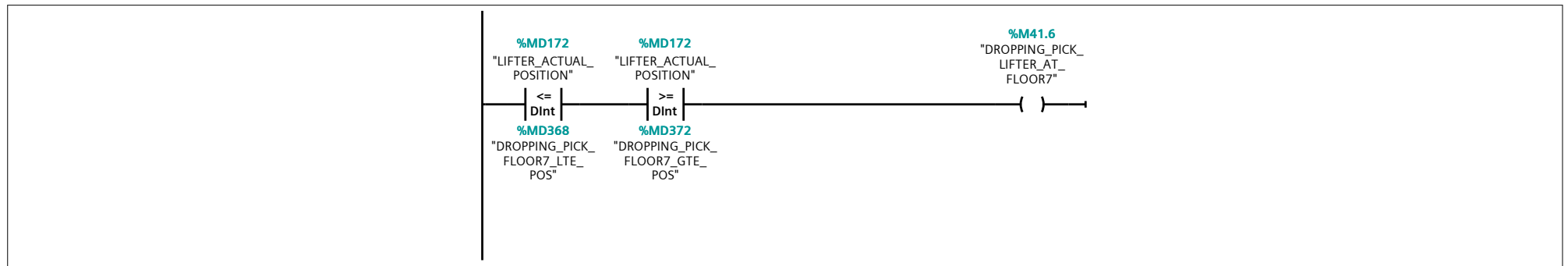
Network 29: SEVENTH_FLOOR_CALL_FOR_PICKING_CARTON_FROM_ACR_SELVES:



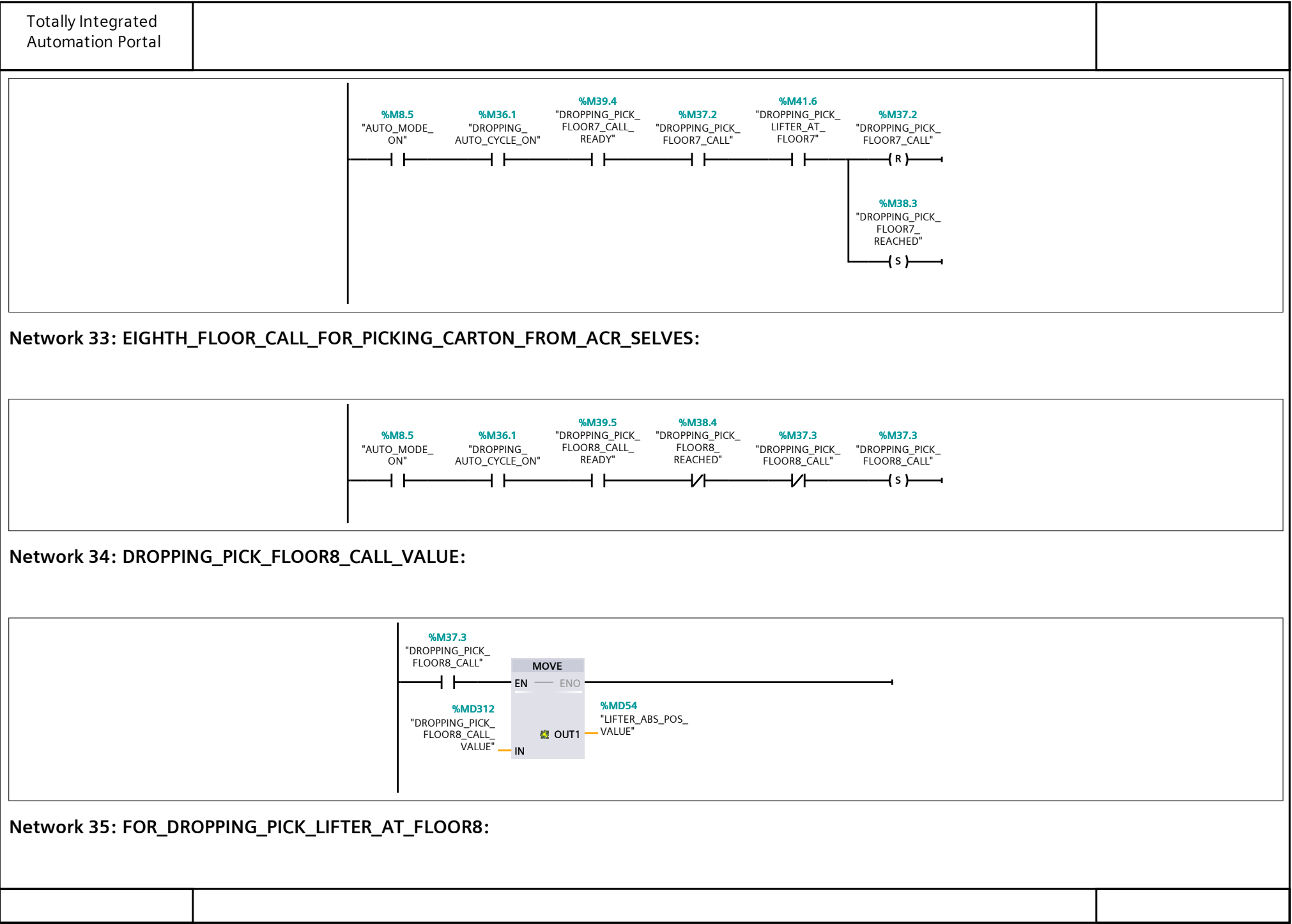
Network 30: DROPPING_PICK_FLOOR7_CALL_VALUE:

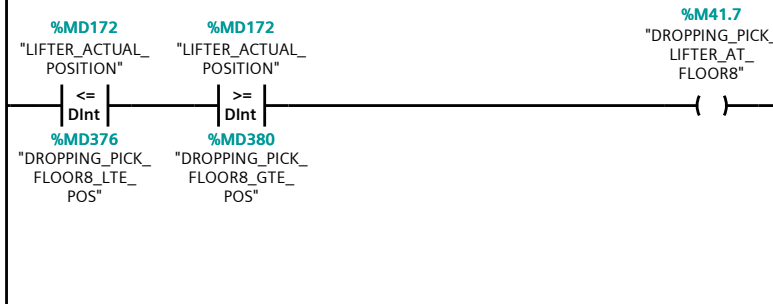


Network 31: FOR_DROPPING_PICK_LIFTER_AT_FLOOR7:

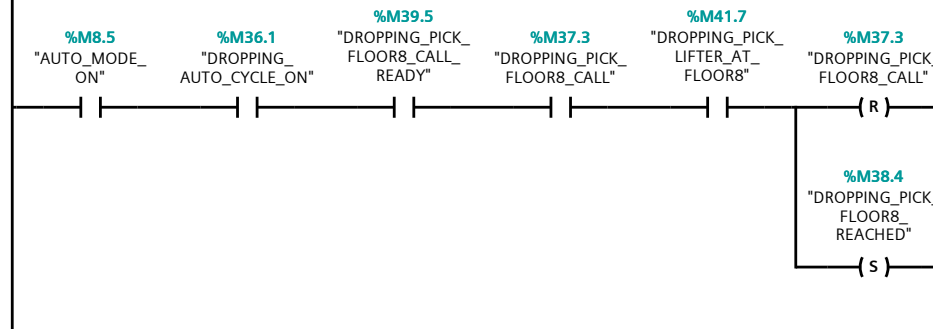


Network 32: SEVENTH_FLOOR_CALL_RESET_FOR_PICKING_CARTON_FROM_ACR_SELVES:

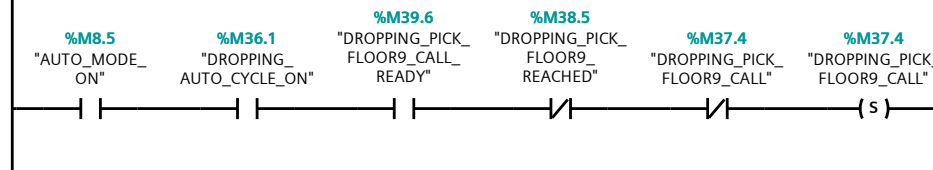




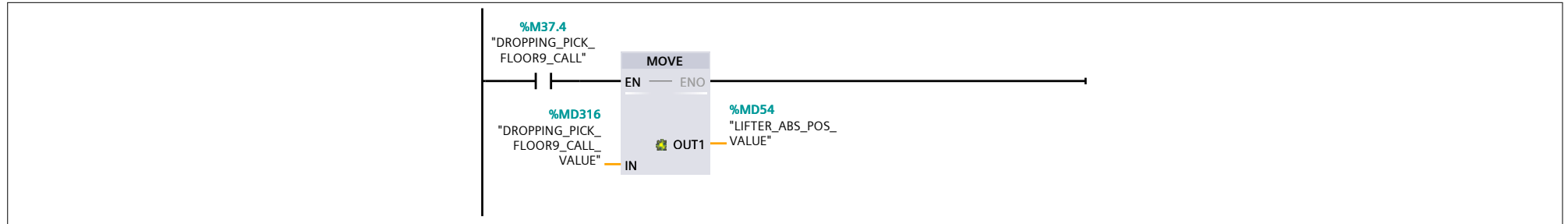
Network 36: EIGHTH_FLOOR_CALL_RESET_FOR_PICKING_CARTON_FROM_ACR_SELVES:



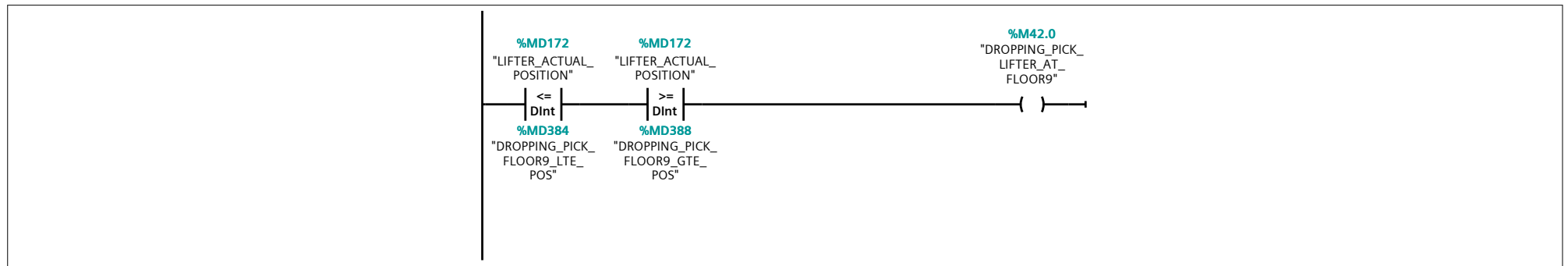
Network 37: NINTH_FLOOR_CALL_FOR_PICKING_CARTON_FROM_ACR_SELVES:



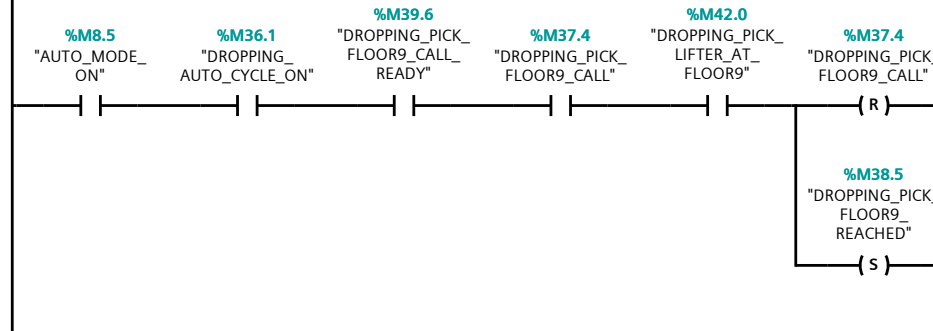
Network 38: DROPPING_PICK_FLOOR9_CALL_VALUE:



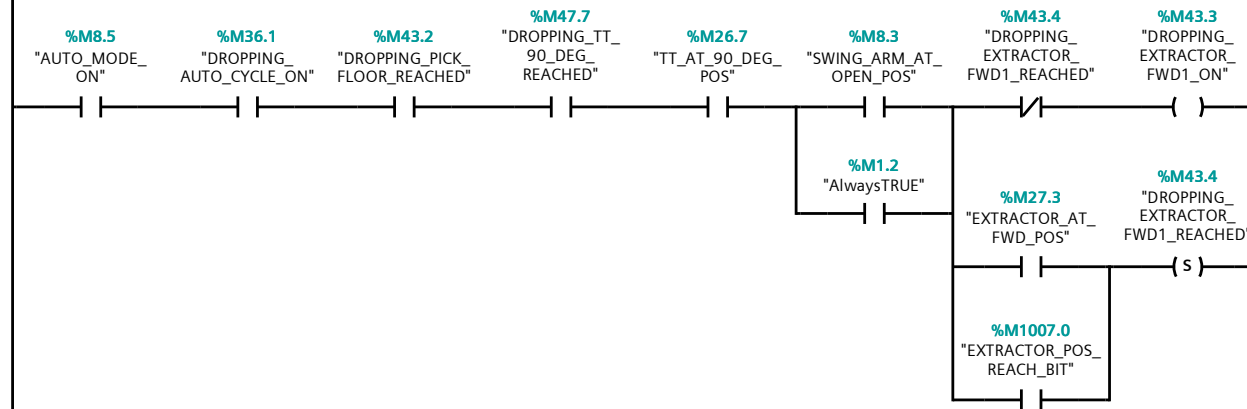
Network 39: FOR_DROPPING_PICK_LIFTER_AT_FLOOR9:



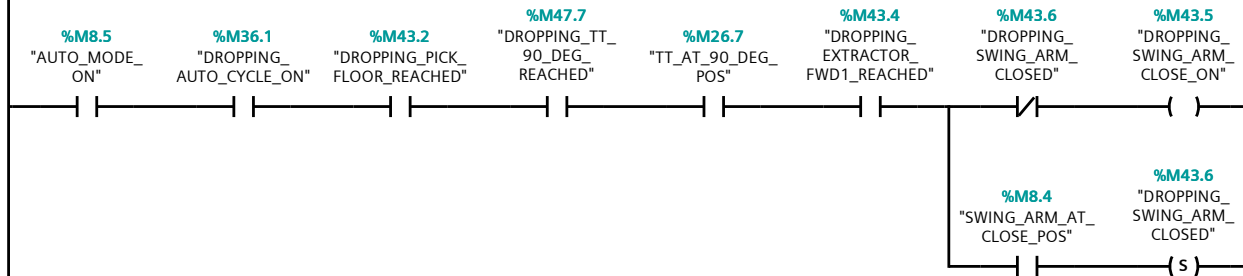
Network 40: NINTH_FLOOR_CALL_RESET_FOR_PICKING_CARTON_FROM_ACR_SELVES:



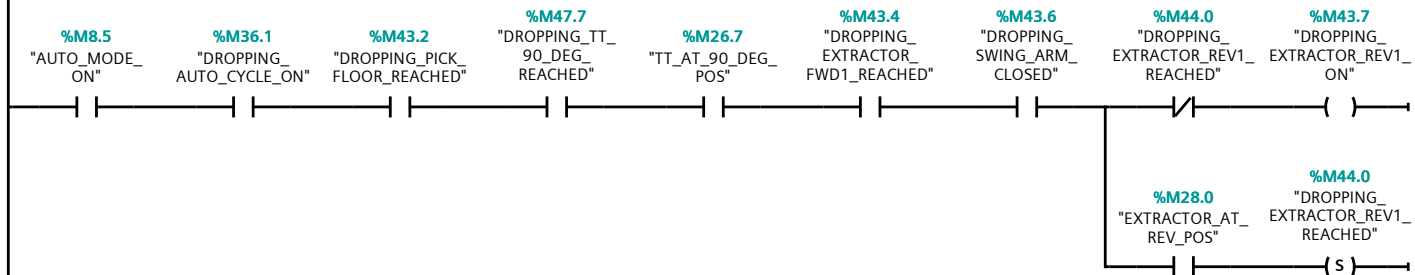
Network 41: EXTRACTOR_FORWARD_FOR_PICKING_CARTON_FROM_ACR_SHELVES:



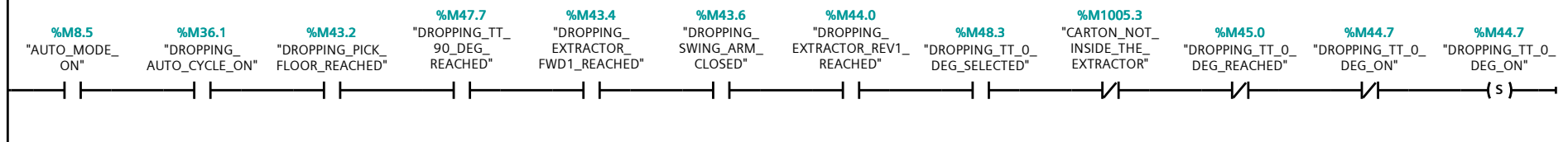
Network 42: SWING_ARM_CLOSED_FOR_PICKING_CARTON_FROM_ACR_SHELVES:



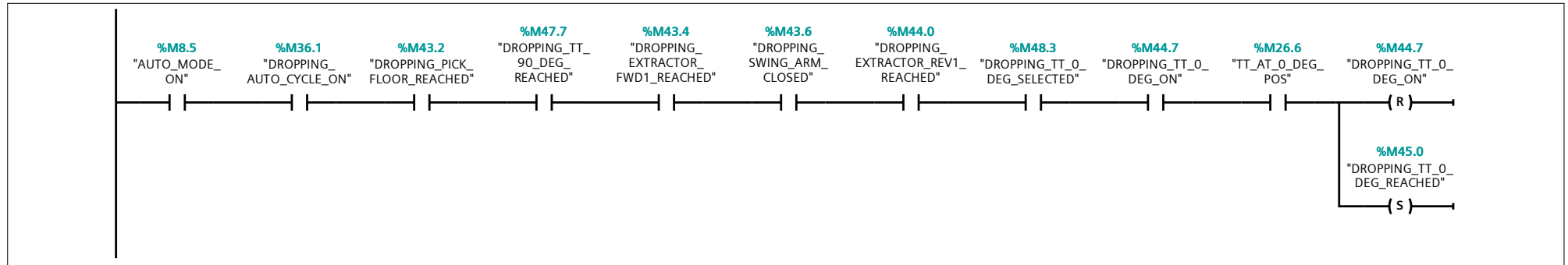
Network 43: EXTRACTOR_REVERSE_AFTER_PICKING_CARTON_FROM_ACR_SHELVES:



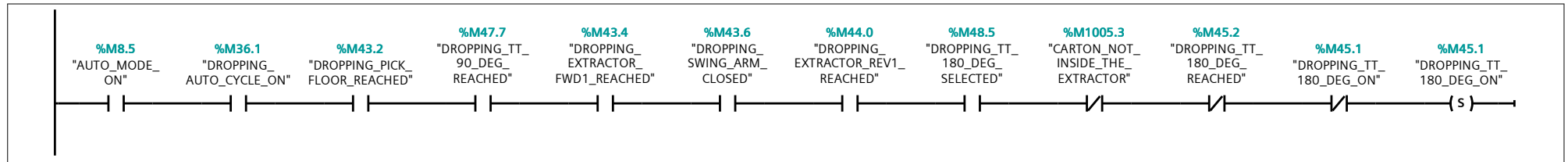
Network 44: TT_0_DEG_ROTATION_CALL_AFTER_PICKING_CARTON_FROM_ACR_SHELVES:



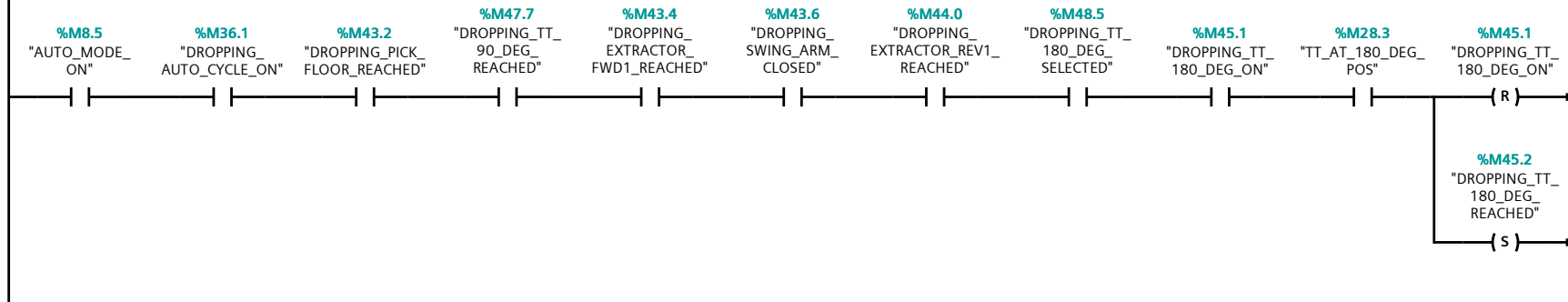
Network 45: TT_0_DEG_ROTATION_CALL_RESET_AFTER_PICKING_CARTON_FROM_ACR_SHELVES:



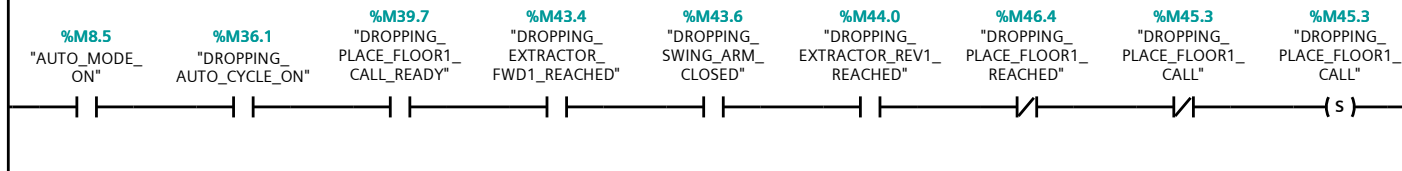
Network 46: TT_180_DEG_ROTATION_CALL_AFTER_PICKING_CARTON_FROM_ACR_SHELVES:



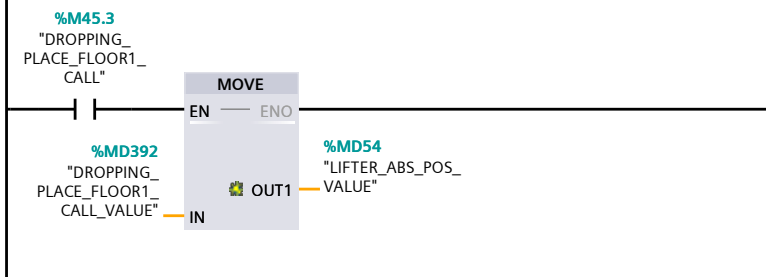
Network 47: TT_180_DEG_ROTATION_CALL_RESET_AFTER_PICKING_CARTON_FROM_ACR_SHELVES:



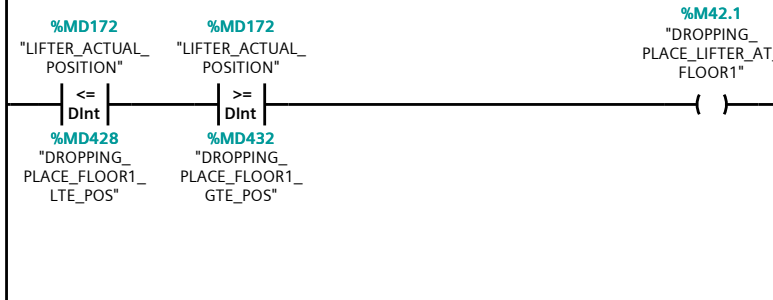
Network 48: AFTER_PICKING_CARTON_FIRST_FLOOR_CALL_FOR_DROPPING:



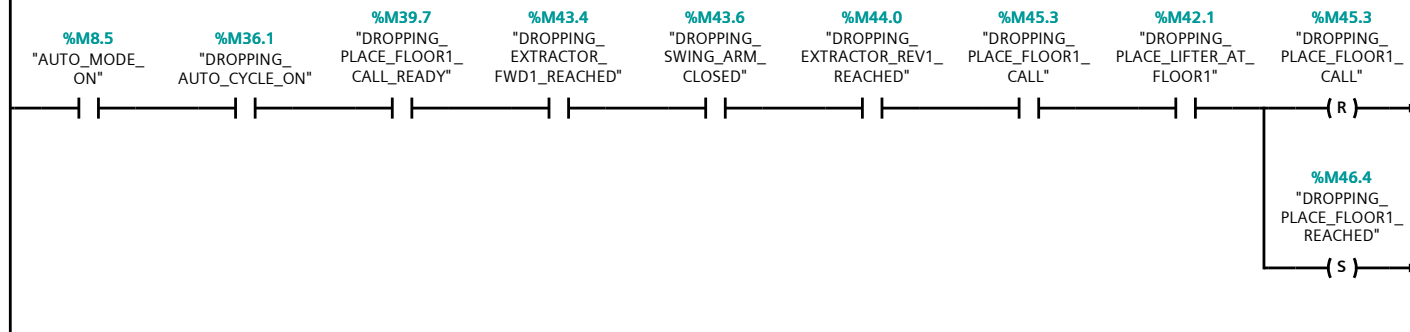
Network 49: DROPPING_PLACE_FLOOR1_CALL_VALUE:



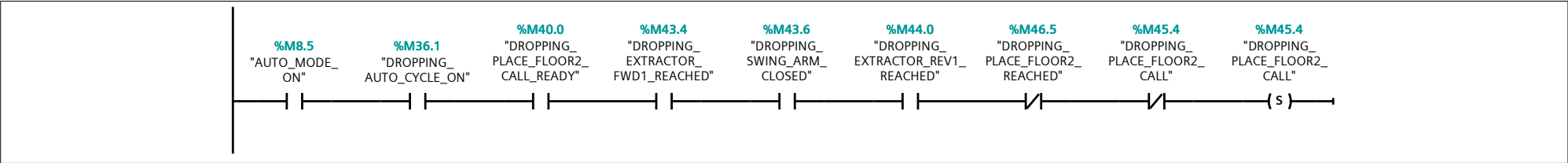
Network 50: FOR_DROPPING_PLACE_LIFTER_AT_FLOOR1:



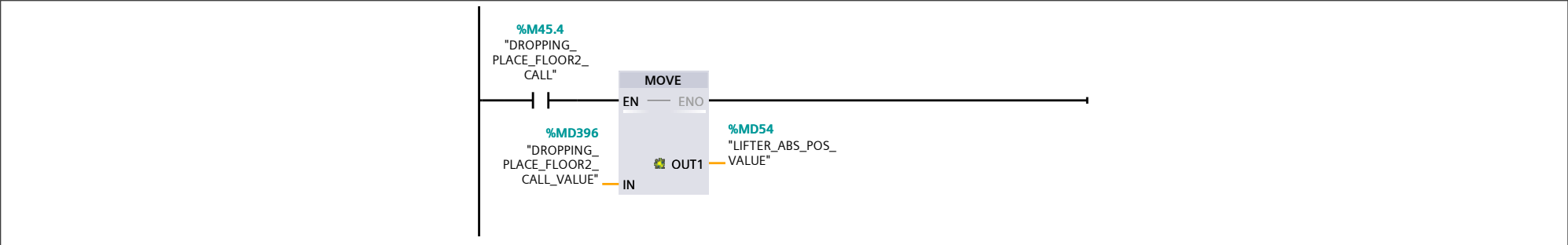
Network 51: AFTER_PICKING_CARTON_FIRST_FLOOR_CALL_RESET_FOR_DROPPING:



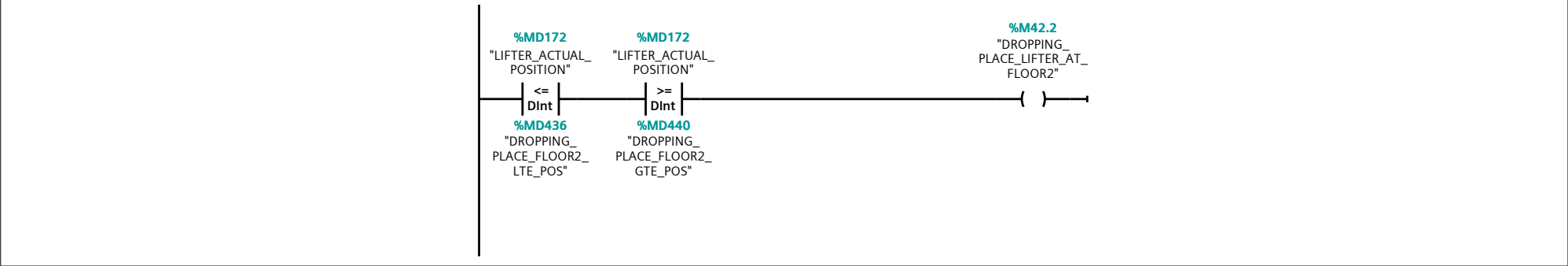
Network 52: AFTER_PICKING_CARTON_SECOND_FLOOR_CALL_FOR_DROPPING:



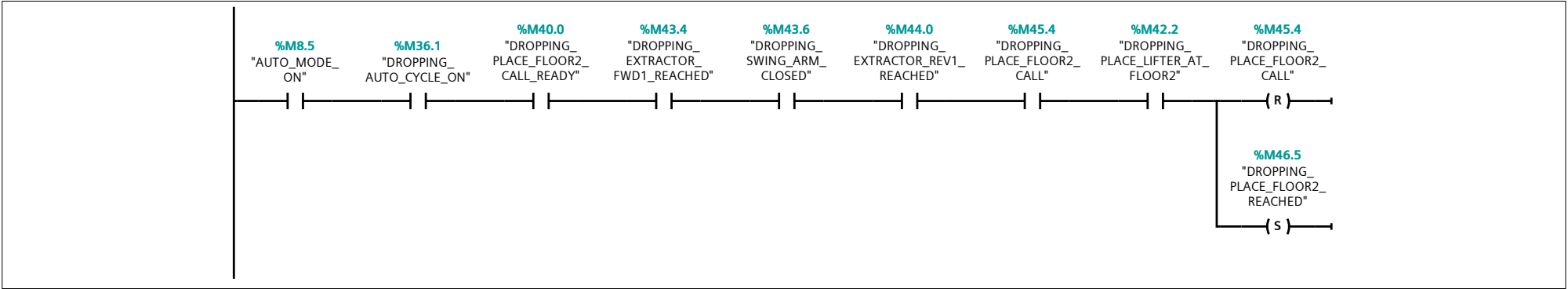
Network 53: DROPPING_PLACE_FLOOR2_CALL_VALUE:



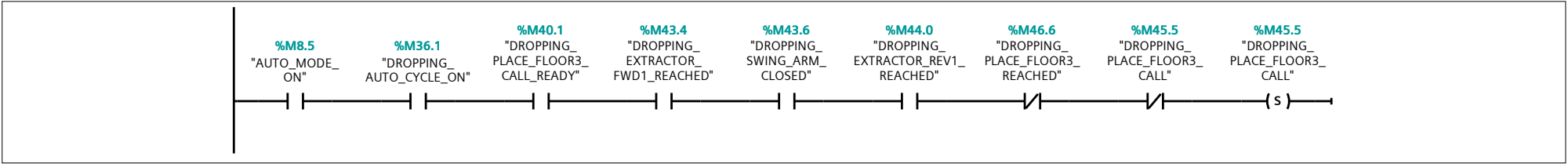
Network 54: FOR_DROPPING_PLACE_LIFTER_AT_FLOOR2:



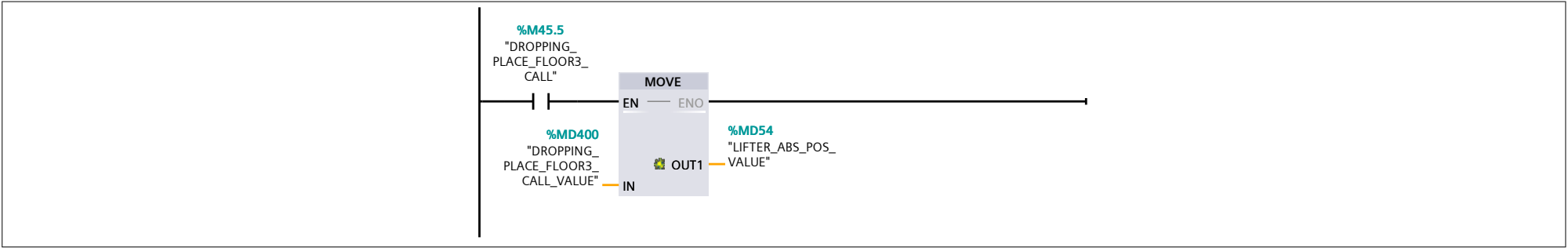
Network 55: AFTER_PICKING_CARTON_SECOND_FLOOR_CALL_RESET_FOR_DROPPING:



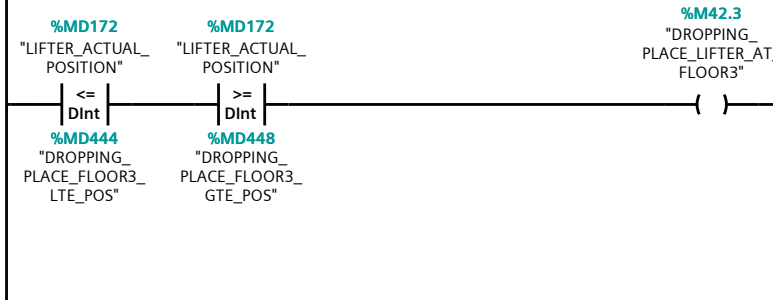
Network 56: AFTER_PICKING_CARTON_THIRD_FLOOR_CALL_FOR_DROPPING:



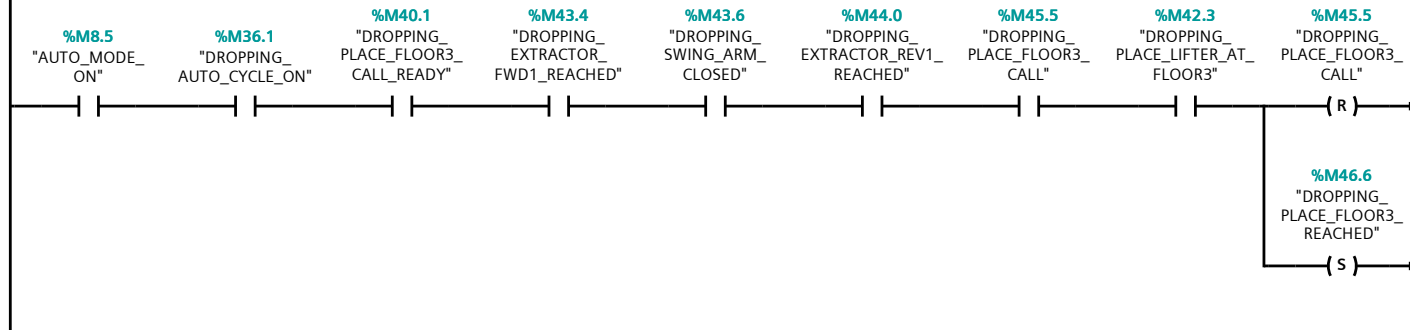
Network 57: DROPPING_PLACE_FLOOR3_CALL_VALUE:



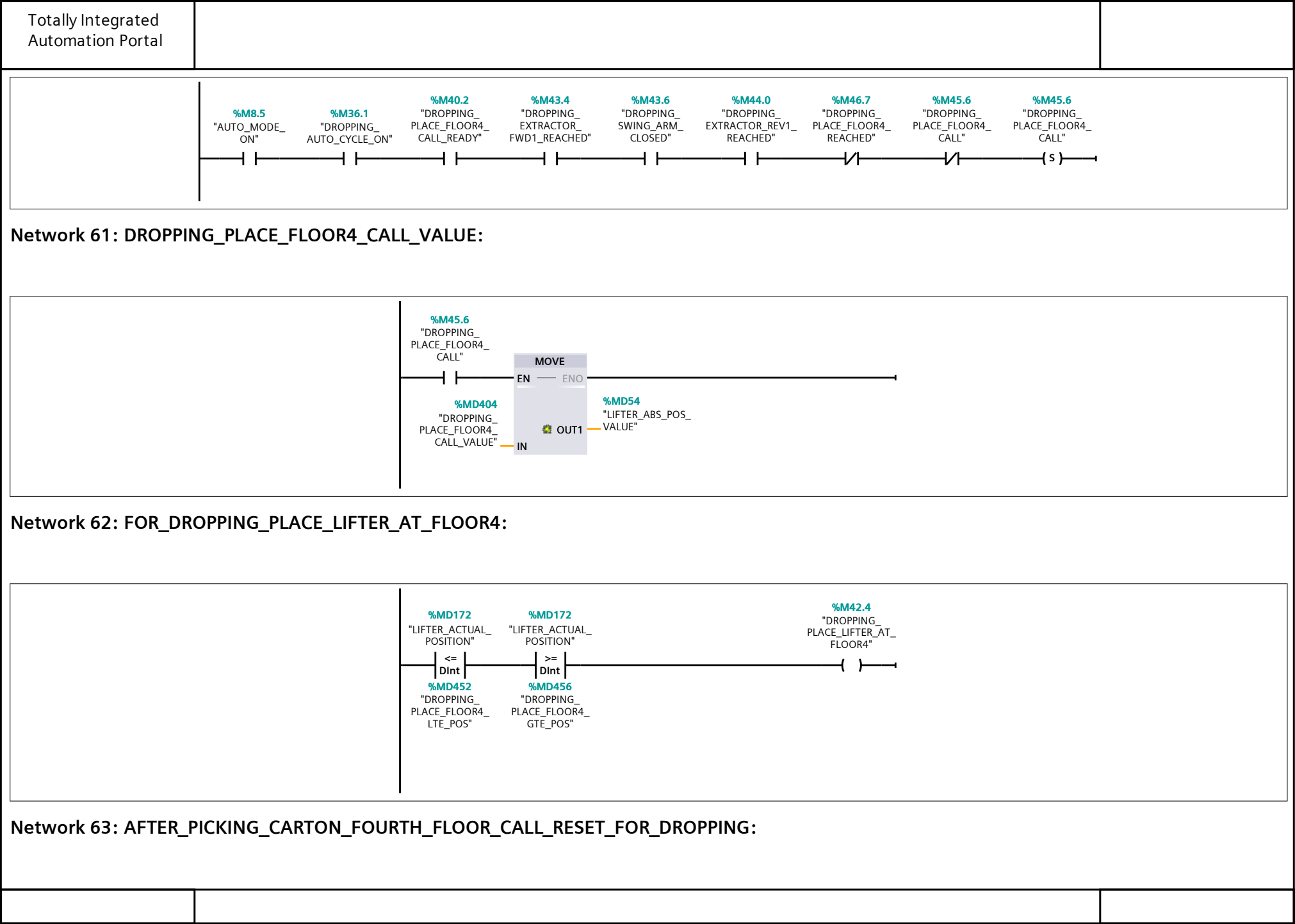
Network 58: FOR_DROPPING_PLACE_LIFTER_AT_FLOOR3:

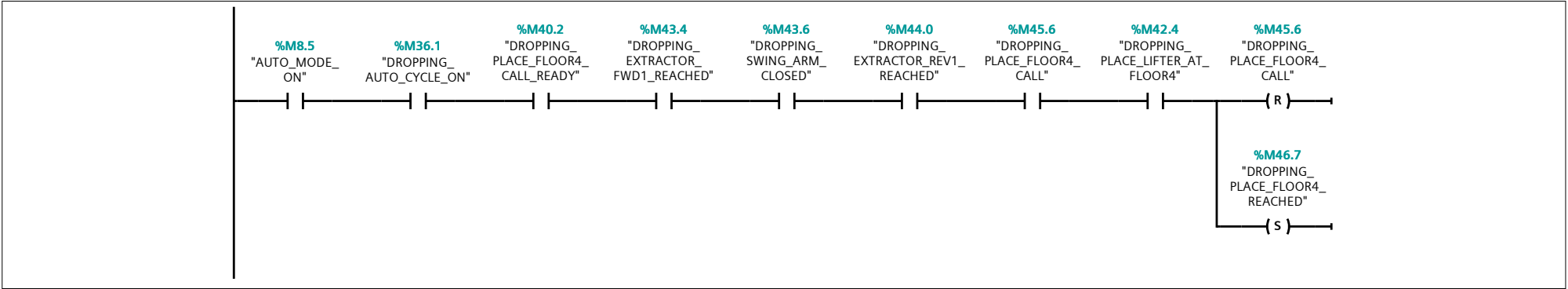


Network 59: AFTER_PICKING_CARTON_THIRD_FLOOR_CALL_RESET_FOR_DROPPING:

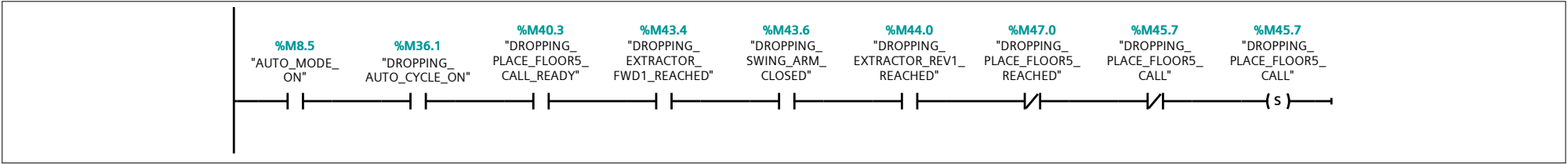


Network 60: AFTER_PICKING_CARTON_FOURTH_FLOOR_CALL_FOR_DROPPING:

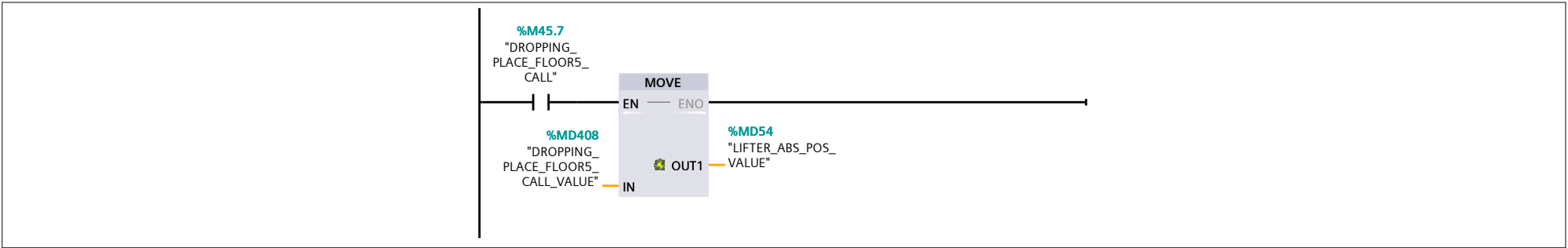




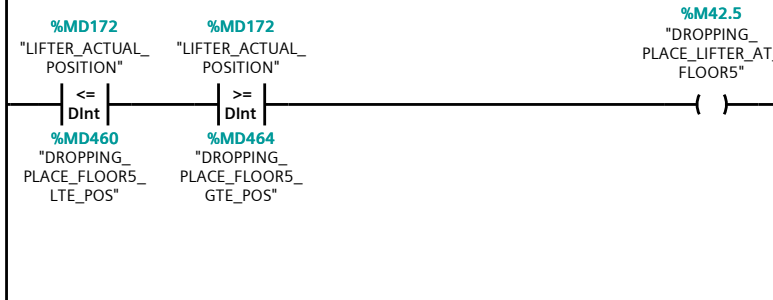
Network 64: AFTER_PICKING_CARTON_FIFTH_FLOOR_CALL_FOR_DROPPING:



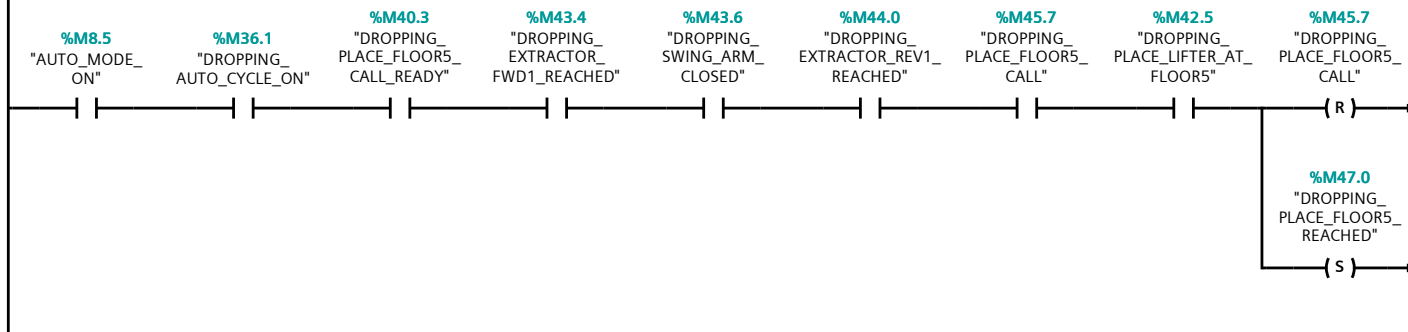
Network 65: DROPPING_PLACE_FLOOR5_CALL_VALUE:



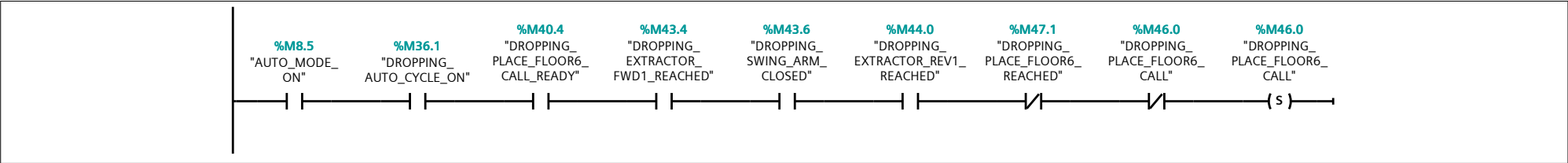
Network 66: FOR_DROPPING_PLACE_LIFTER_AT_FLOOR5:



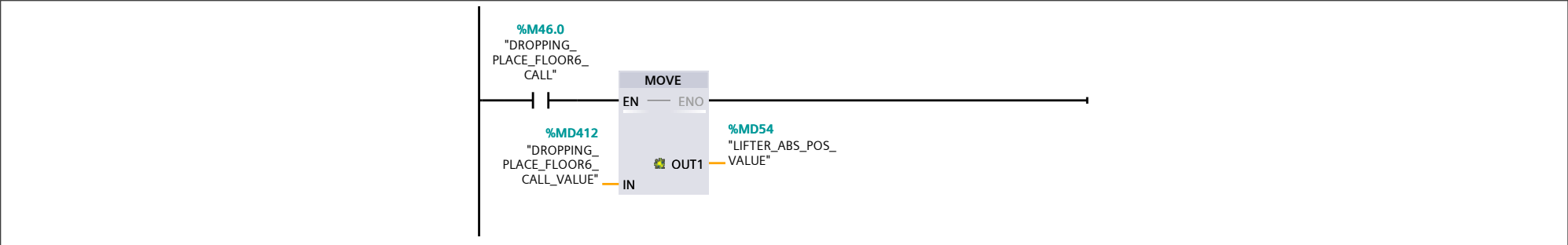
Network 67: AFTER_PICKING_CARTON_FIFTH_FLOOR_CALL_RESET_FOR_DROPPING:



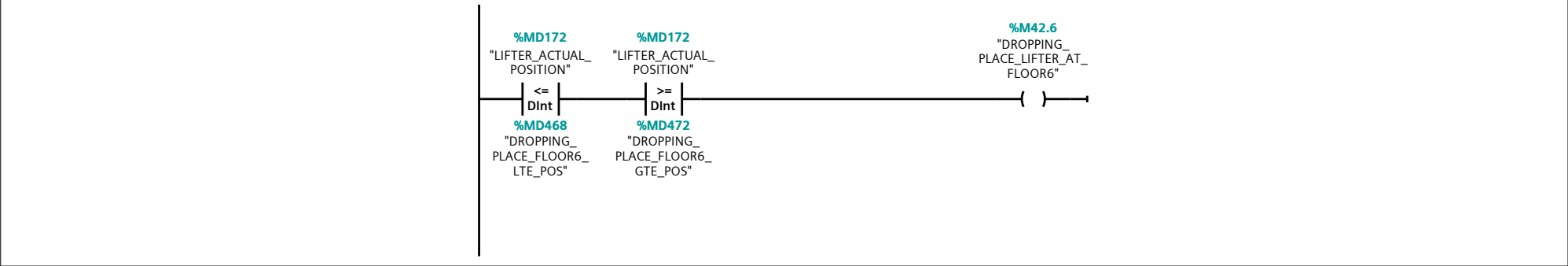
Network 68: AFTER_PICKING_CARTON_SIXTH_FLOOR_CALL_FOR_DROPPING:



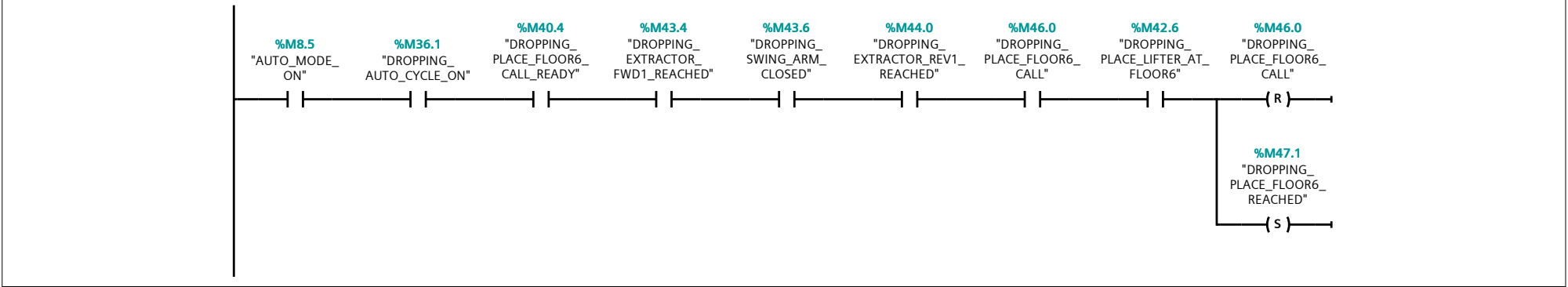
Network 69: DROPPING_PLACE_FLOOR6_CALL_VALUE:



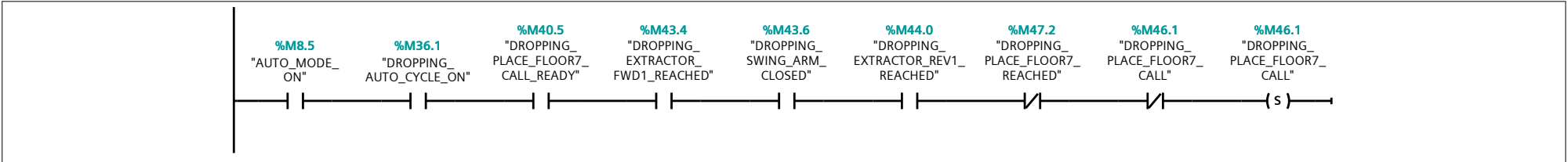
Network 70: FOR_DROPPING_PLACE_LIFTER_AT_FLOOR6:



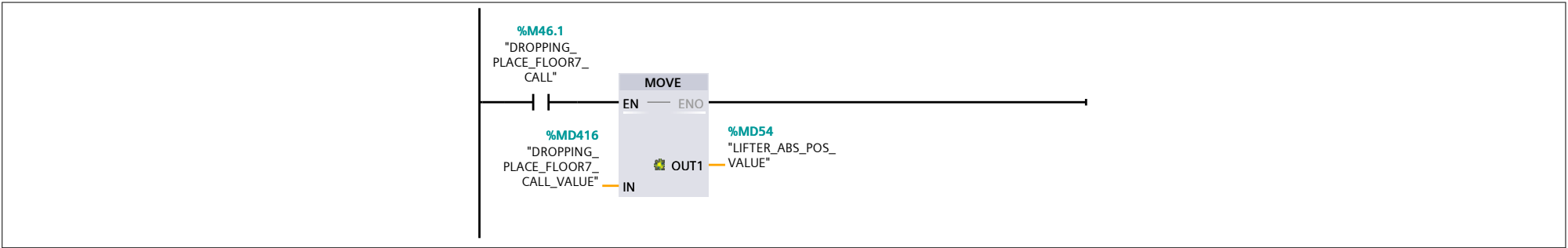
Network 71: AFTER_PICKING_CARTON_SIXTH_FLOOR_CALL_RESET_FOR_DROPPING:



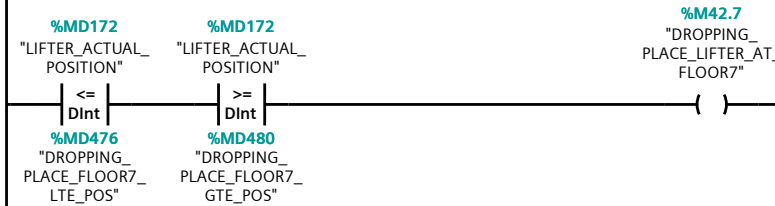
Network 72: AFTER_PICKING_CARTON_SEVENTH_FLOOR_CALL_FOR_DROPPING:



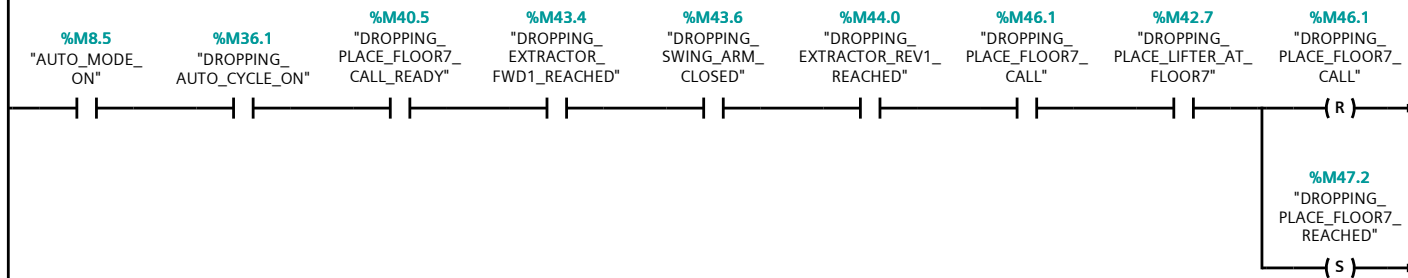
Network 73: DROPPING_PLACE_FLOOR7_CALL_VALUE:



Network 74: FOR_DROPPING_PLACE_LIFTER_AT_FLOOR7:

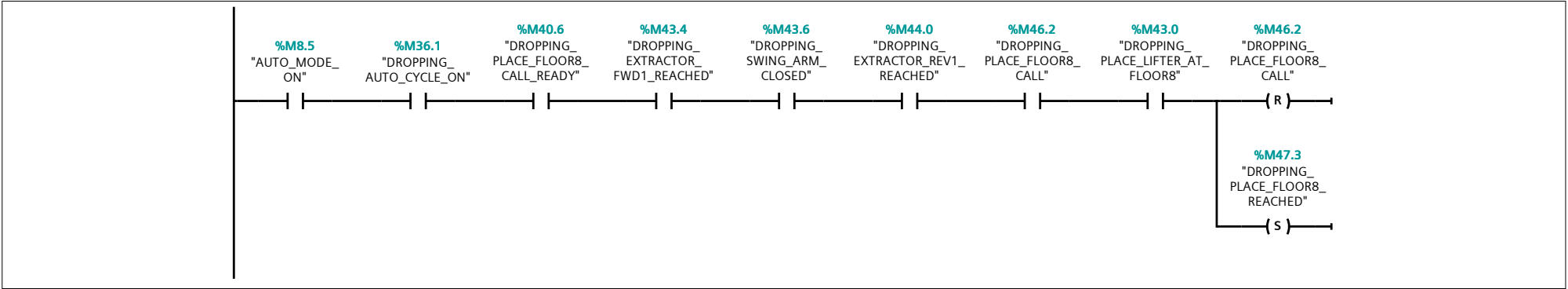


Network 75: AFTER_PICKING_CARTON_SEVENTH_FLOOR_CALL_RESET_FOR_DROPPING:

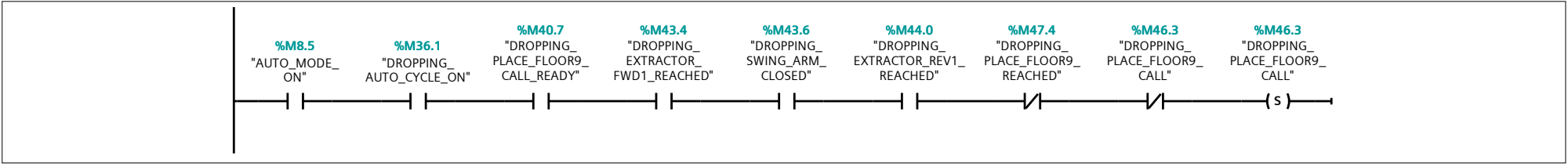


Network 76: AFTER_PICKING_CARTON_EIGHTH_FLOOR_CALL_FOR_DROPPING:

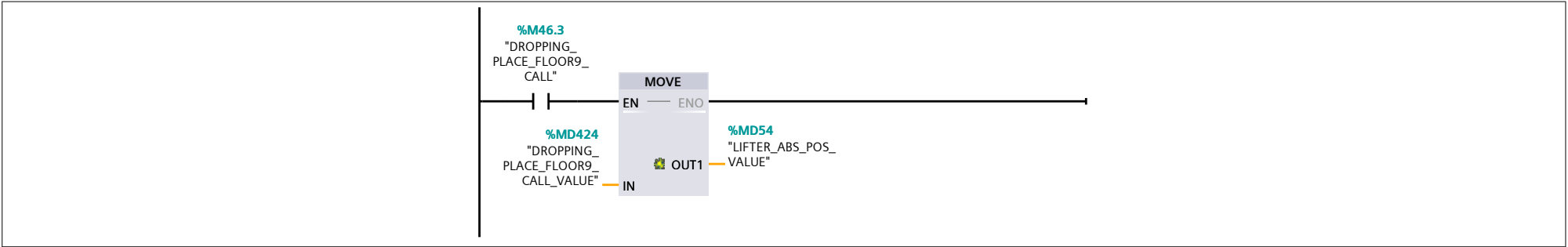
Totally Integrated Automation Portal		
	Network 77: DROPPING_PLACE_FLOOR8_CALL_VALUE:	
	Network 78: FOR_DROPPING_PLACE_LIFTER_AT_FLOOR8:	
	Network 79: AFTER_PICKING_CARTON_EIGHTH_FLOOR_CALL_RESET_FOR_DROPPING:	



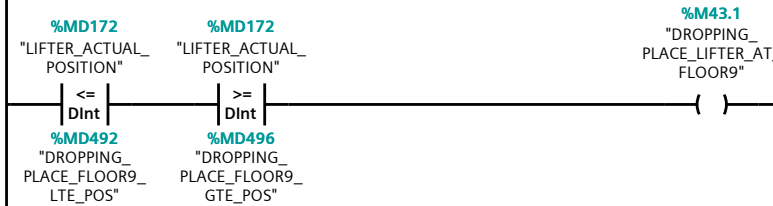
Network 80: AFTER_PICKING_CARTON_NINTH_FLOOR_CALL_FOR_DROPPING:



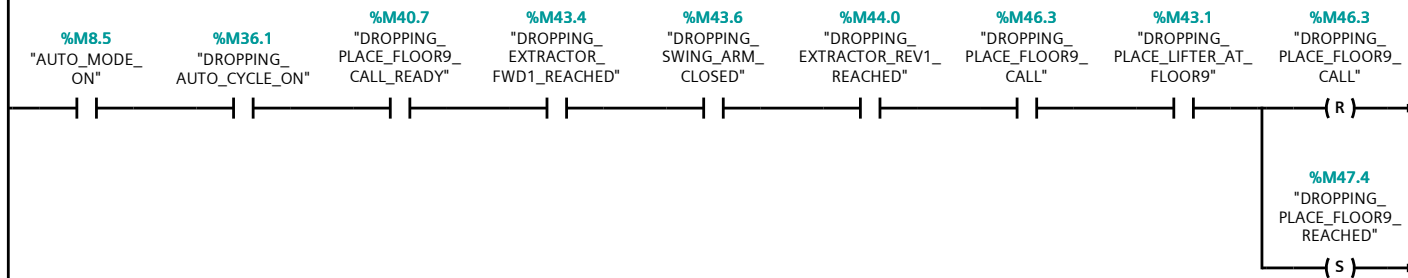
Network 81: DROPPING_PLACE_FLOOR9_CALL_VALUE:



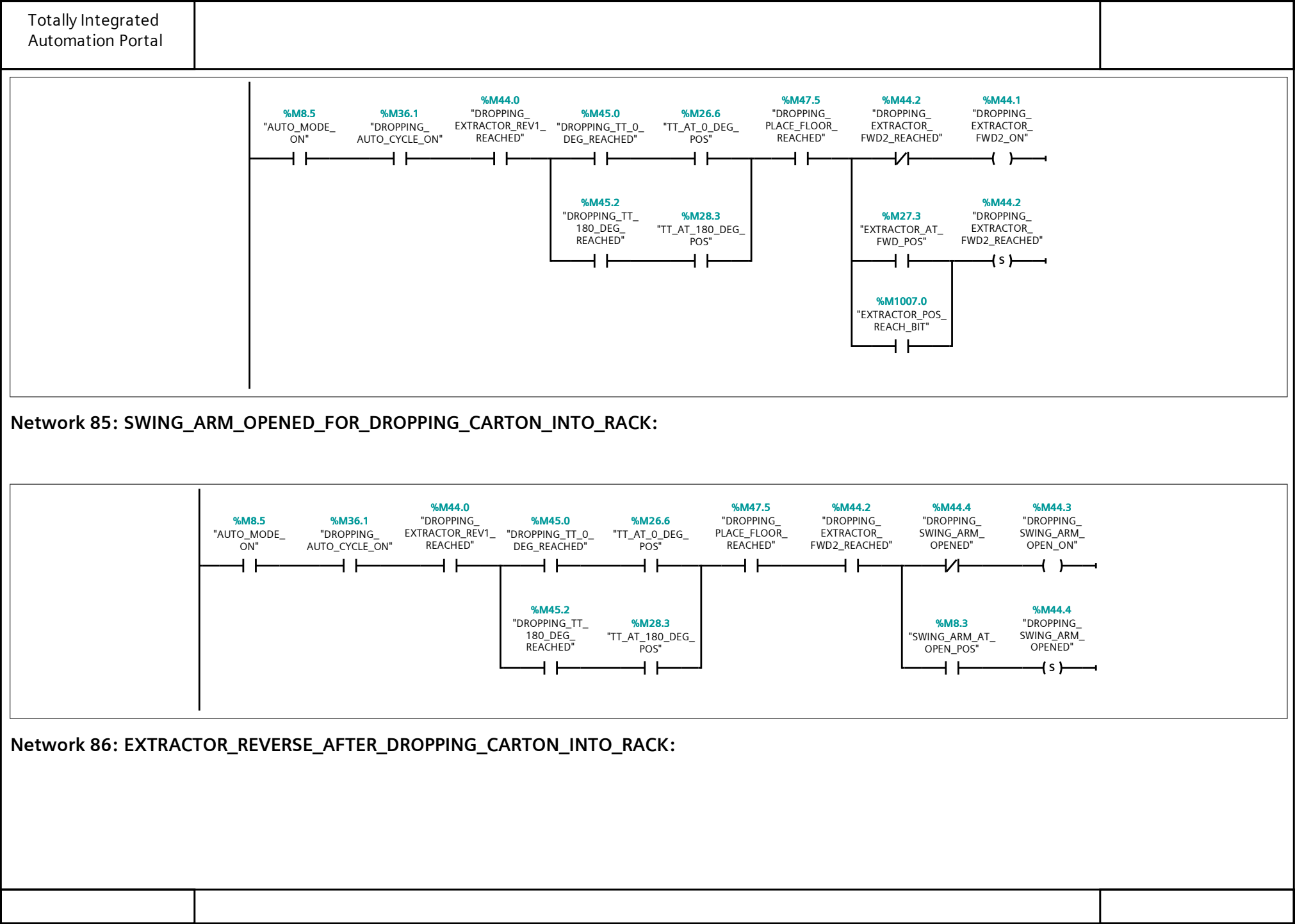
Network 82: FOR_DROPPING_PLACE_LIFTER_AT_FLOOR9:

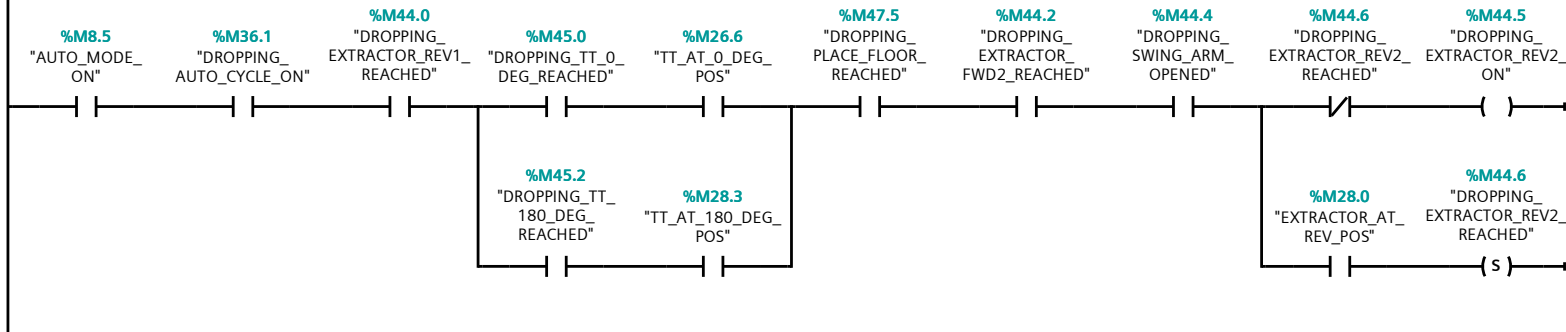


Network 83: AFTER_PICKING_CARTON_NINTH_FLOOR_CALL_RESET_FOR_DROPPING:

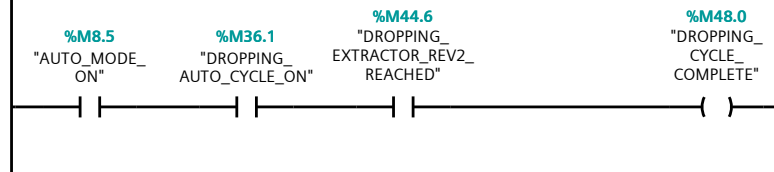


Network 84: EXTRACTOR_FORWARD_FOR_DROPPING_CARTON_INTO_RACK:

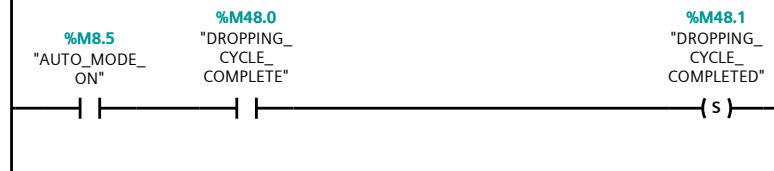




Network 87: DROPPING_CARTON_CYCLE_COMPLETE:

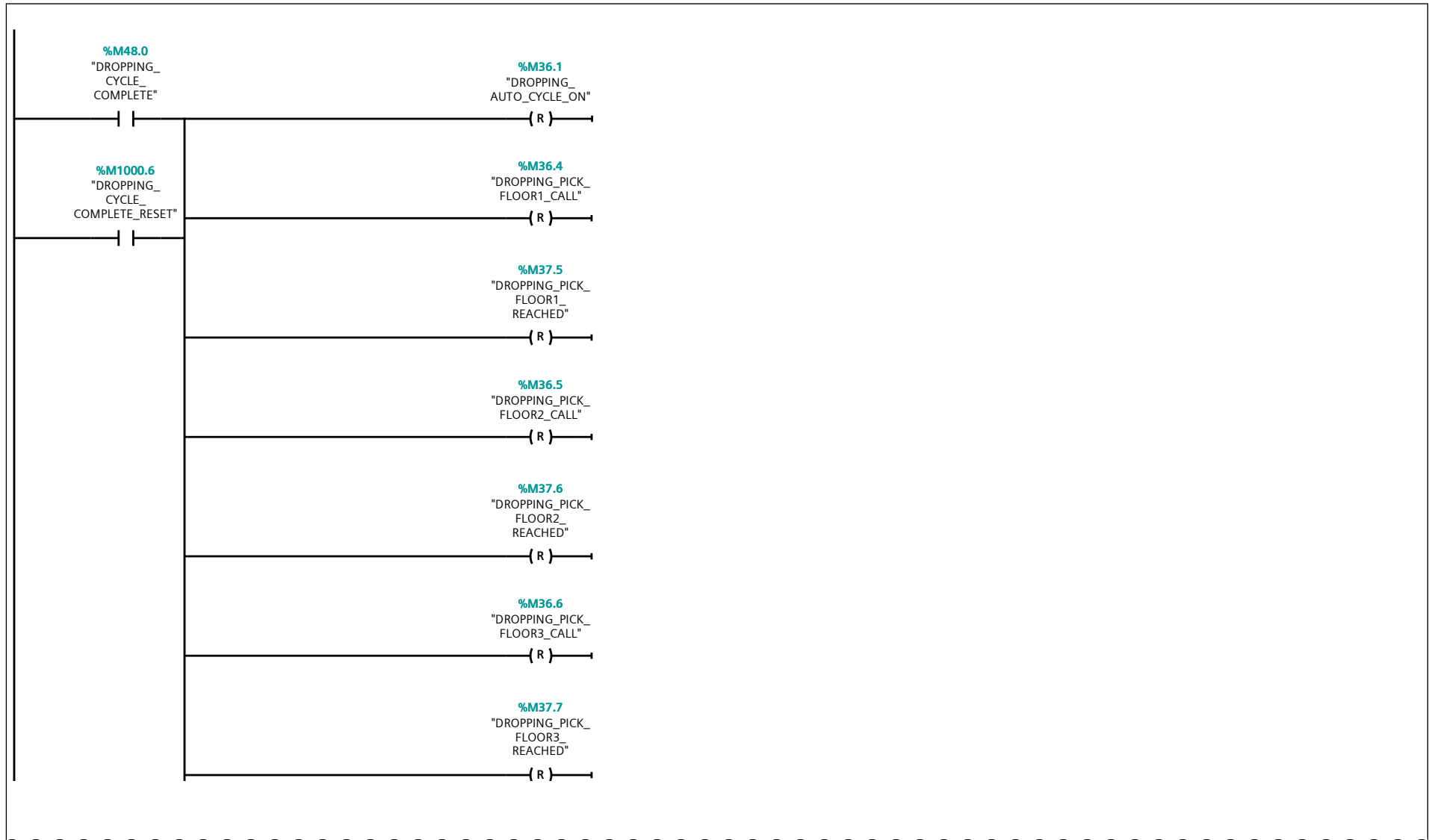


Network 88: DROPPING_CARTON_CYCLE_COMPLETED:



Network 89: DROPPING_AUTO_CYCLE_RESET:

Network 89: DROPPING_AUTO_CYCLE_RESET: (1.1 / 8.1)



Network 89: DROPPING_AUTO_CYCLE_RESET: (2.1 / 8.1)

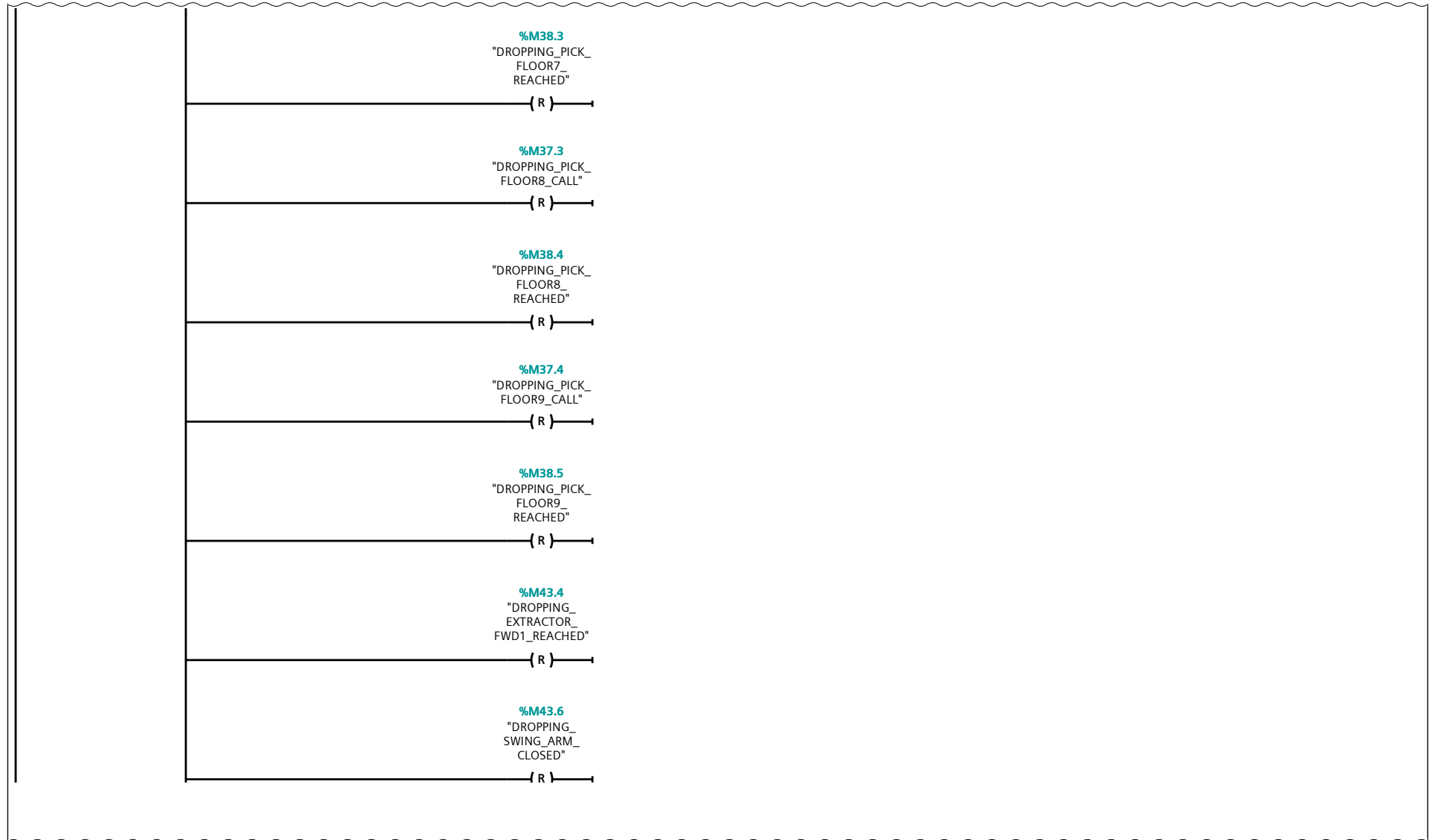
1.1 (Page1 - 35)



3.1 (Page1 - 37)

Network 89: DROPPING_AUTO_CYCLE_RESET: (3.1 / 8.1)

2.1 (Page1 - 36)



4.1 (Page1 - 38)

Network 89: DROPPING_AUTO_CYCLE_RESET: (4.1 / 8.1)

3.1 (Page1 - 37)

%M44.0
"DROPPING_
EXTRACTOR_REV1_
REACHED"

(R)

%M44.7
"DROPPING_TT_0_
DEG_ON"

(R)

%M45.0
"DROPPING_TT_0_
DEG_REACHED"

(R)

%M45.1
"DROPPING_TT_
180_DEG_ON"

(R)

%M45.2
"DROPPING_TT_
180_DEG_
REACHED"

(R)

%M45.3
"DROPPING_
PLACE_FLOOR1_
CALL"

(R)

%M46.4
"DROPPING_
PLACE_FLOOR1_
REACHED"

(R)

5.1 (Page1 - 39)

Network 89: DROPPING_AUTO_CYCLE_RESET: (5.1 / 8.1)

4.1 (Page1 - 38)

%M45.4
"DROPPING_
PLACE_FLOOR2_
CALL"

(R)

%M46.5
"DROPPING_
PLACE_FLOOR2_
REACHED"

(R)

%M45.5
"DROPPING_
PLACE_FLOOR3_
CALL"

(R)

%M46.6
"DROPPING_
PLACE_FLOOR3_
REACHED"

(R)

%M45.6
"DROPPING_
PLACE_FLOOR4_
CALL"

(R)

%M46.7
"DROPPING_
PLACE_FLOOR4_
REACHED"

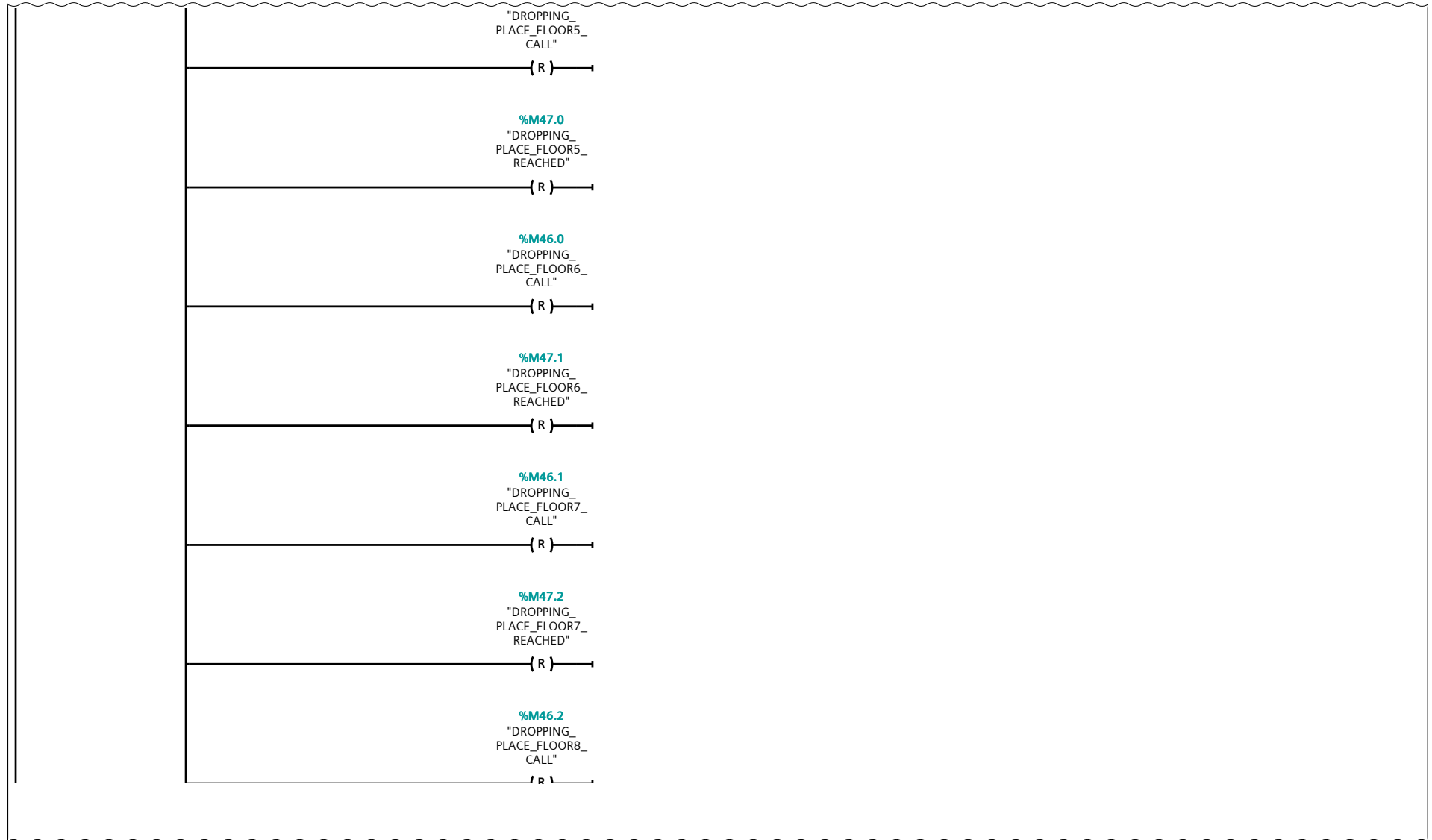
(R)

%M45.7

6.1 (Page1 - 40)

Network 89: DROPPING_AUTO_CYCLE_RESET: (6.1 / 8.1)

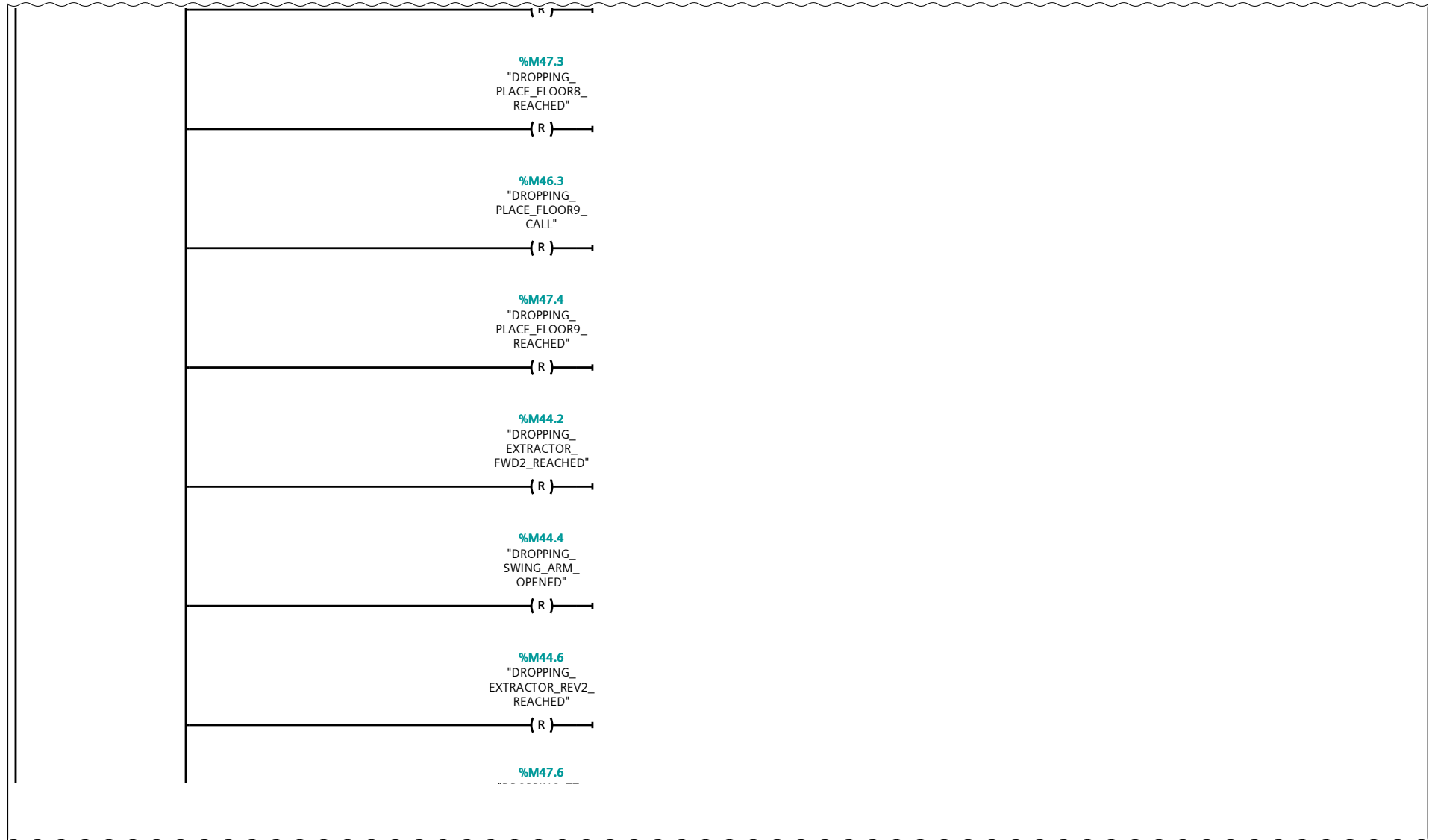
5.1 (Page1 - 39)



7.1 (Page1 - 41)

Network 89: DROPPING_AUTO_CYCLE_RESET: (7.1 / 8.1)

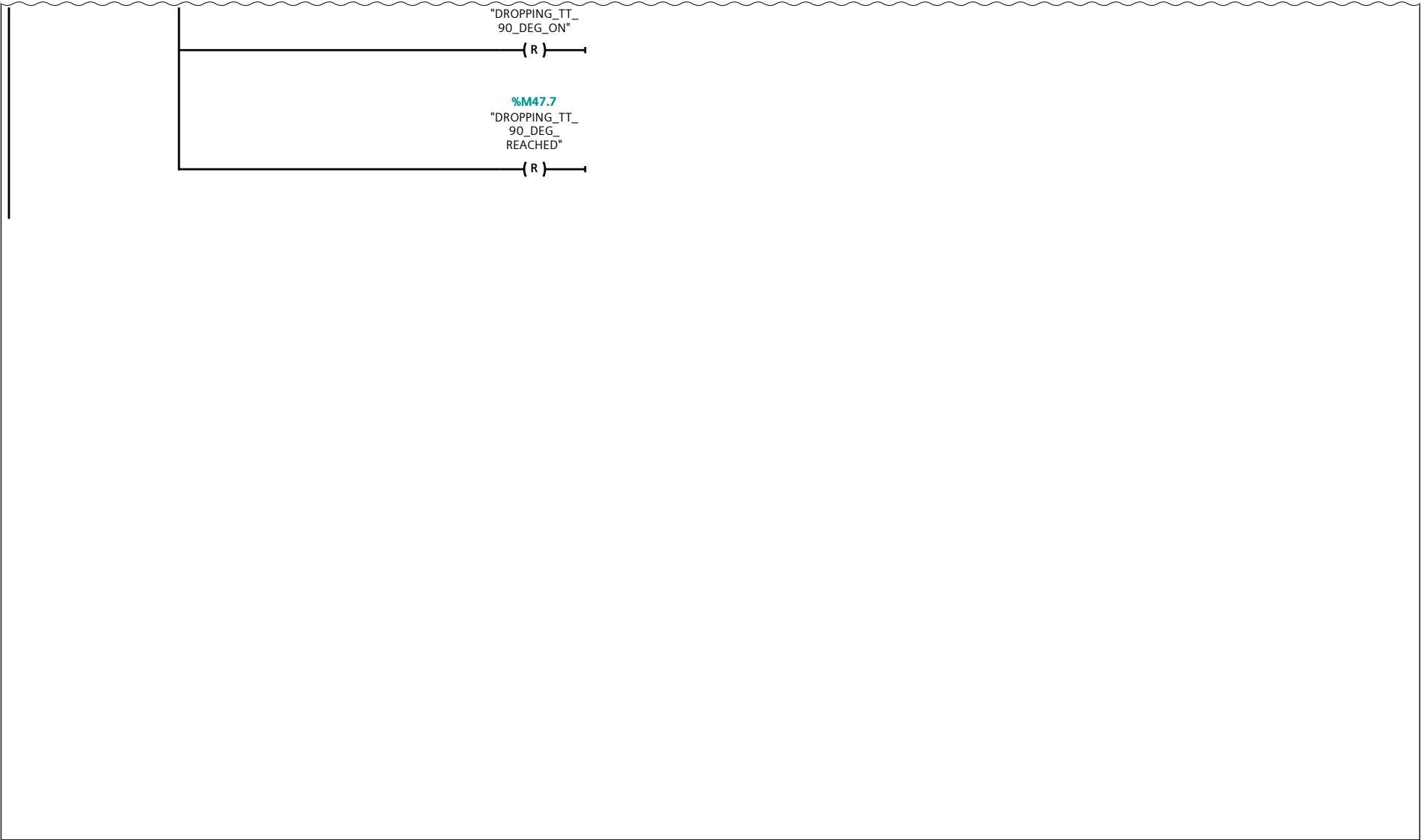
6.1 (Page1 - 40)



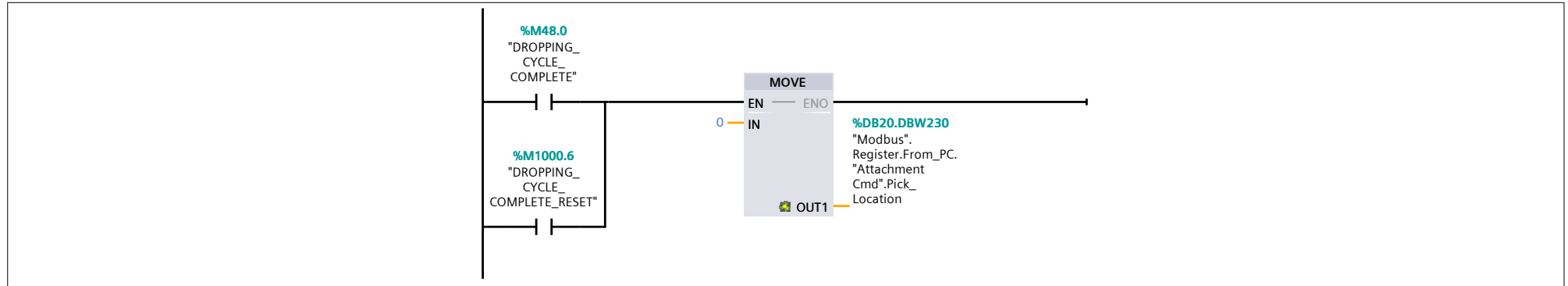
8.1 (Page1 - 42)

Network 89: DROPPING_AUTO_CYCLE_RESET: (8.1 / 8.1)

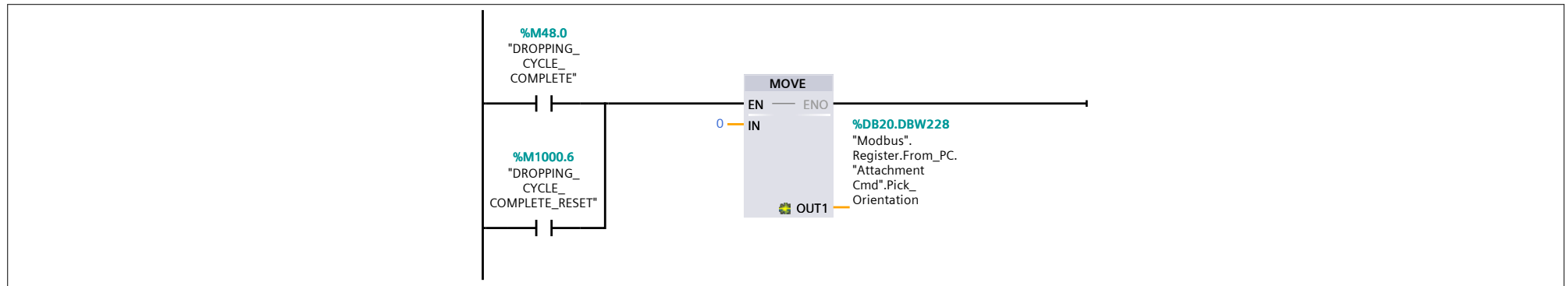
7.1 (Page1 - 41)



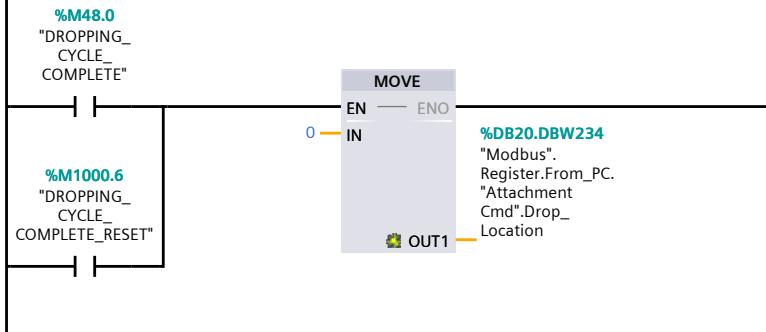
Network 90: DROPPING_CYCLE_RESET:



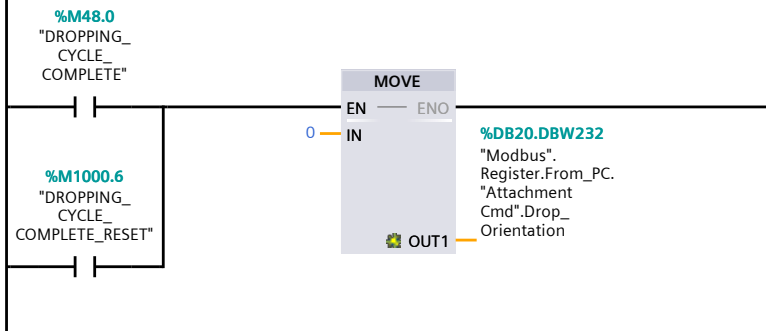
Network 91: DROPPING_CYCLE_RESET:



Network 92: DROPPING_CYCLE_RESET:



Network 93: DROPPING_CYCLE_RESET:



Network 94:

