

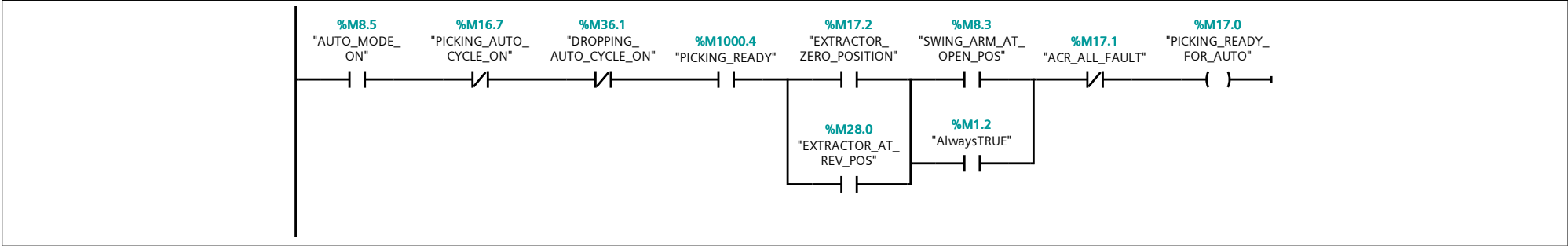
ACR_NEW_11122024 / AMR V 3 [CPU 1214C DC/DC/DC] / Program blocks

PICKING AUTO LOGIC [FC7]

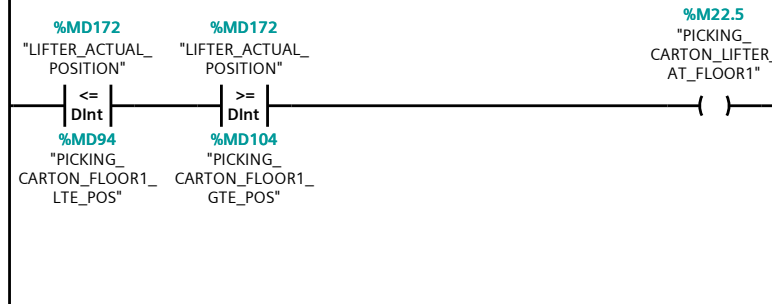
PICKING AUTO LOGIC Properties							
General							
Name	PICKING AUTO LOGIC	Number	7	Type	FC	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

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

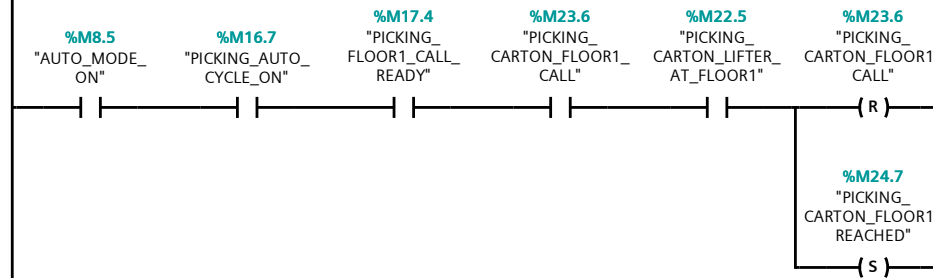
Network 1: PICKING_CYCLE_READY_FOR_AUTO:



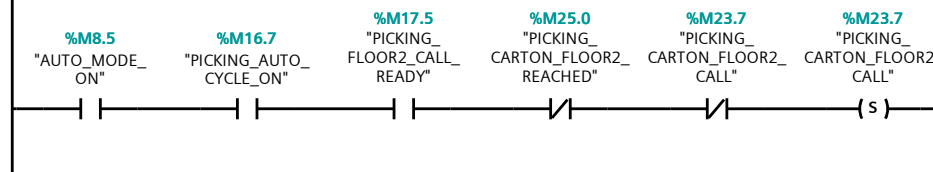
Totally Integrated Automation Portal		
Network 2: PICKING_AUTO_CYCLE_START:		
<div><div></div><div><div><div>%M8.5 "AUTO_MODE_ON"</div><div>%M17.3 "PICKING_START"</div><div>%M17.0 "PICKING_READY_FOR_AUTO"</div><div>%M17.1 "ACR_ALL_FAULT"</div><div>%M16.7 "PICKING_AUTO_CYCLE_ON"</div><div>%M16.7 "PICKING_AUTO_CYCLE_ON"</div></div><div><div></div><div></div><div></div><div><div></div><div></div></div><div><div></div><div></div></div><div><div></div><div>(S)</div></div></div></div></div>		
Network 3: PICKING_FIRST_FLOOR_CALL:		
<div><div></div><div><div><div>%M8.5 "AUTO_MODE_ON"</div><div>%M16.7 "PICKING_AUTO_CYCLE_ON"</div><div>%M17.4 "PICKING_FLOOR1_CALL_READY"</div><div>%M24.7 "PICKING_CARTON_FLOOR1_REACHED"</div><div>%M23.6 "PICKING_CARTON_FLOOR1_CALL"</div><div>%M23.6 "PICKING_CARTON_FLOOR1_CALL"</div></div><div><div></div><div></div><div></div><div><div></div><div></div></div><div><div></div><div></div></div><div><div></div><div>(S)</div></div></div></div></div>		
Network 4: PICKING_CARTON_FLOOR1_CALL_VALUE:		
<div><div></div><div><div><div><div>%M23.6 "PICKING_CARTON_FLOOR1_CALL"</div><div>%MD58 "PICKING_CARTON_FLOOR1_CALL_POS"</div></div><div><div>MOVE</div><div>EN</div><div>ENO</div><div>OUT1</div><div>IN</div></div><div><div>%MD54 "LIFTER_ABS_POS_VALUE"</div></div></div><div></div></div></div>		
Network 5: LIFTER_AT_FLOOR1_FOR_CARTON_PICKING:		



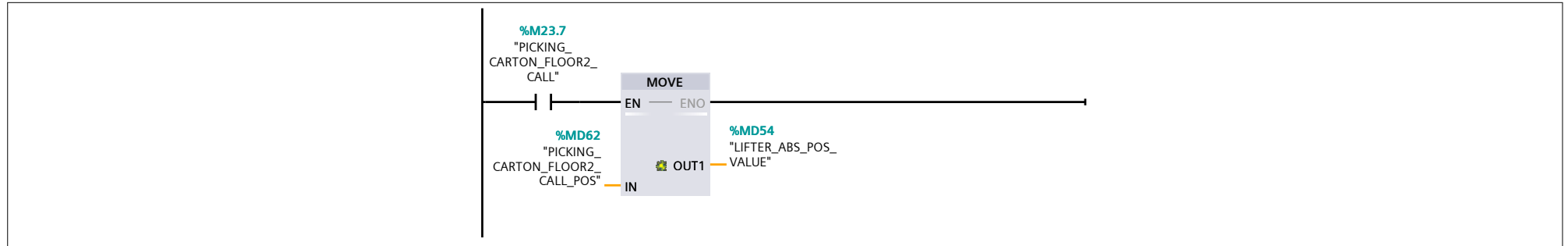
Network 6: PICKING_FIRST_FLOOR_CALL_RESET:



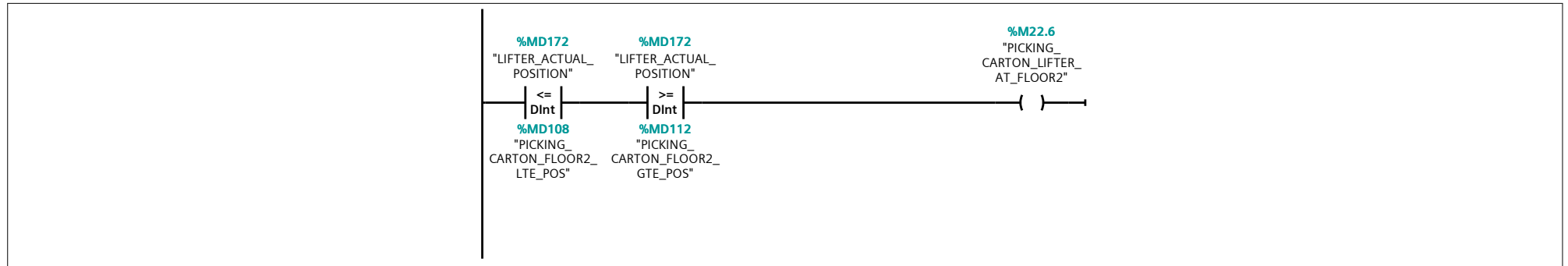
Network 7: PICKING_SECOND_FLOOR_CALL:



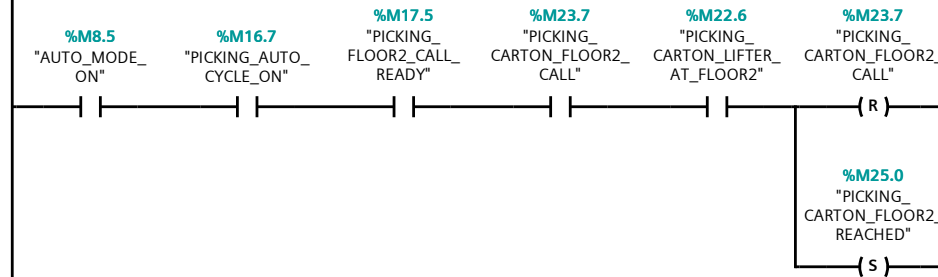
Network 8: PICKING_CARTON_FLOOR2_CALL_VALUE:



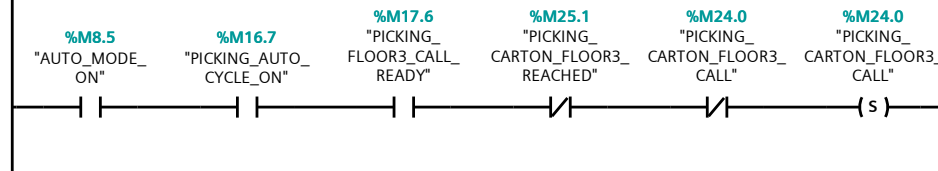
Network 9: LIFTER_AT_FLOOR2_FOR_CARTON_PICKING:



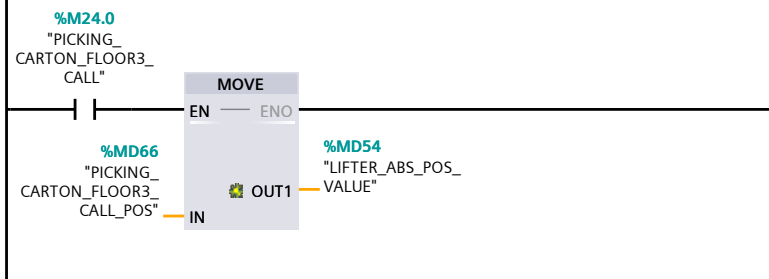
Network 10: PICKING_SECOND_FLOOR_CALL_RESET:



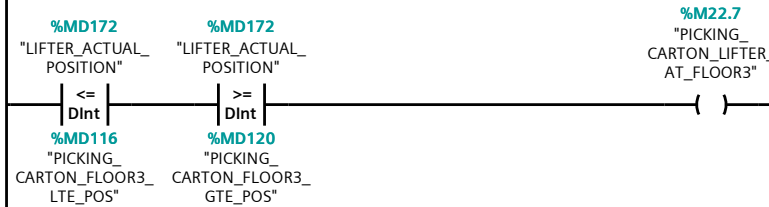
Network 11: PICKING_THIRD_FLOOR_CALL:



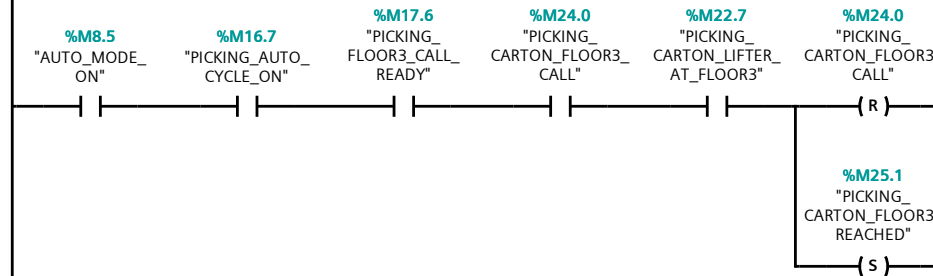
Network 12: PICKING_CARTON_FLOOR3_CALL_VALUE:



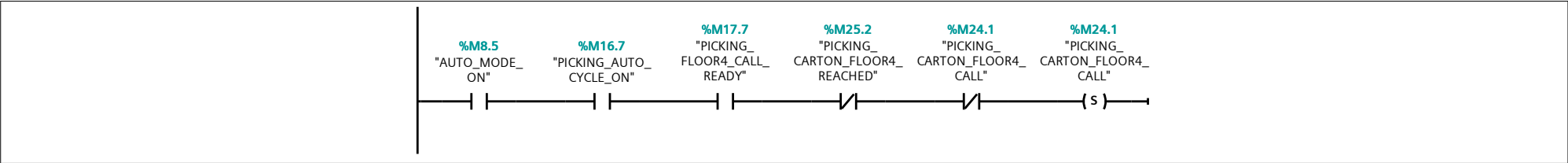
Network 13: LIFTER_AT_FLOOR3_FOR_CARTON_PICKING:



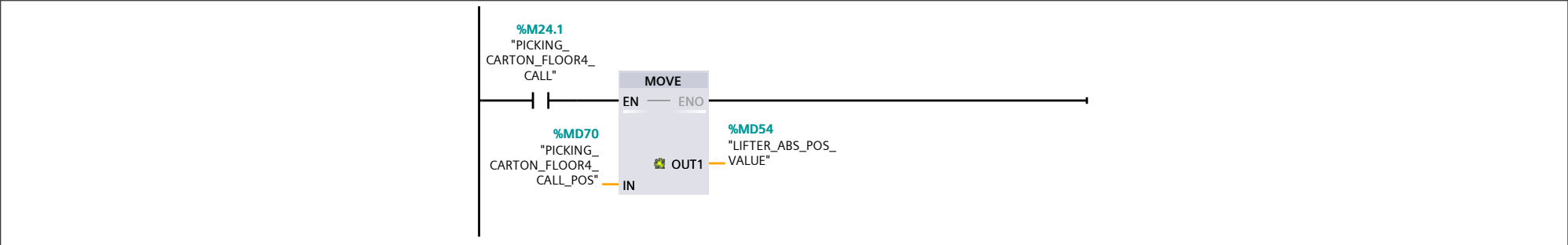
Network 14: PICKING_THIRD_FLOOR_CALL_RESET:



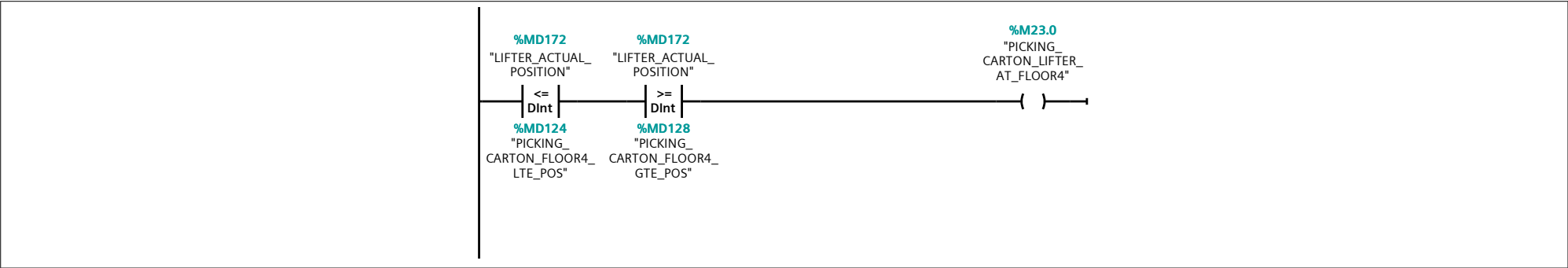
Network 15: PICKING_FOURTH_FLOOR_CALL:



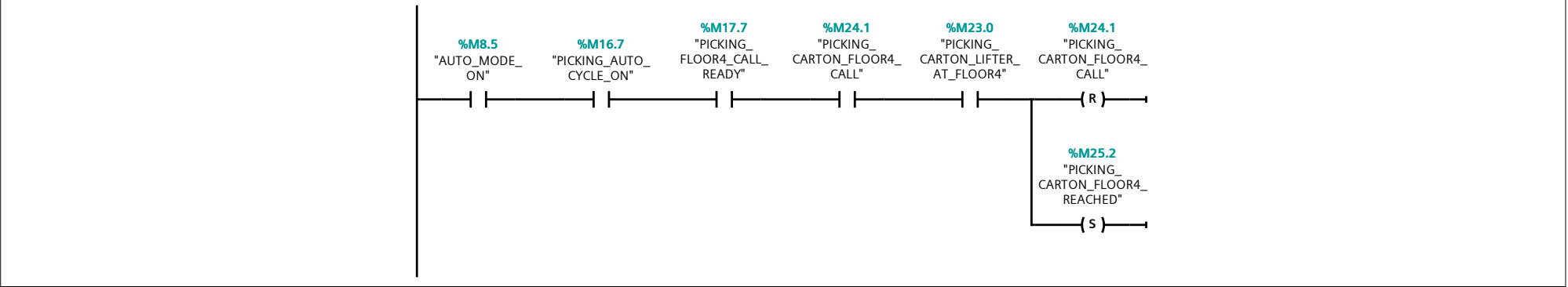
Network 16: PICKING_CARTON_FLOOR4_CALL_VALUE:



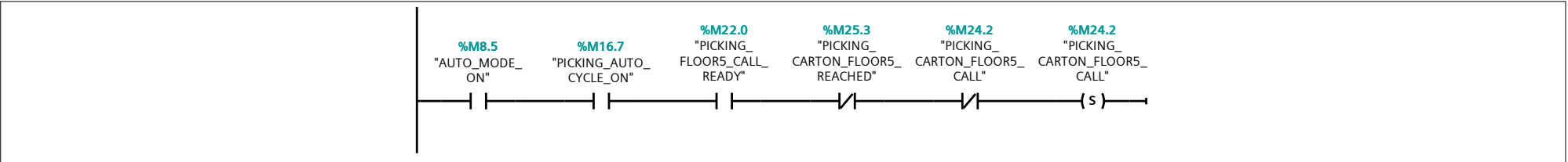
Network 17: LIFTER_AT_FLOOR4_FOR_CARTON_PICKING:



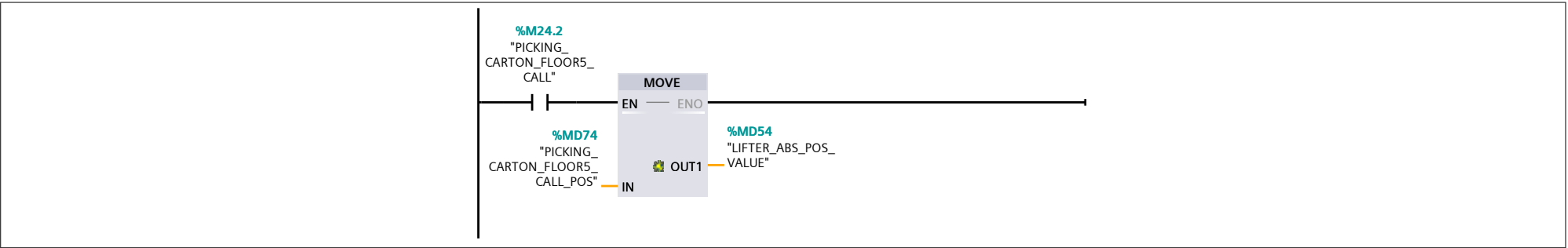
Network 18: PICKING_FOURTH_FLOOR_CALL_RESET:



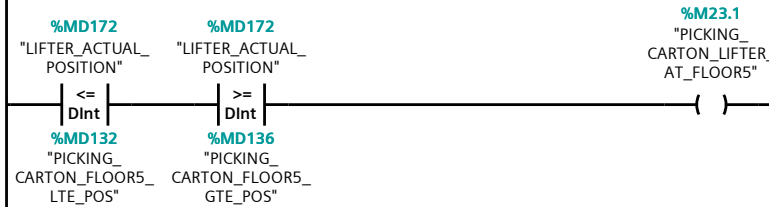
Network 19: PICKING_FIFTH_FLOOR_CALL:



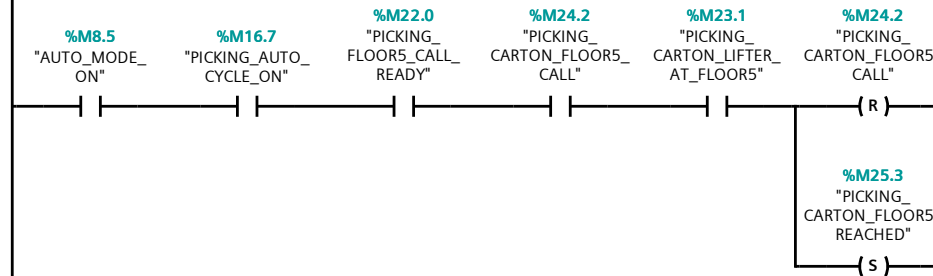
Network 20: PICKING_CARTON_FLOOR5_CALL_VALUE:



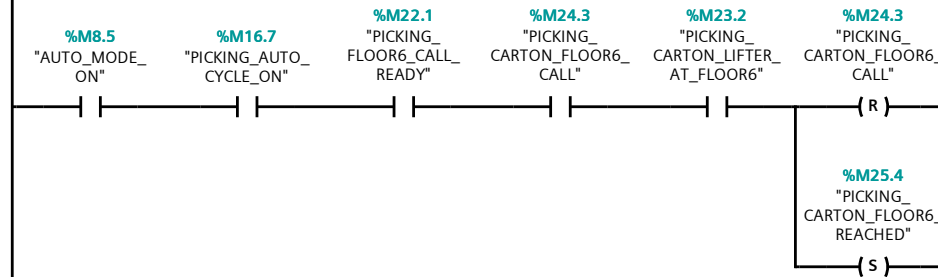
Network 21: LIFTER_AT_FLOOR5_FOR_CARTON_PICKING:



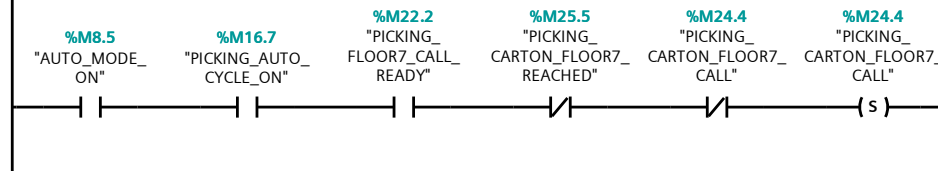
Network 22: PICKING_FIFTH_FLOOR_CALL_RESET:



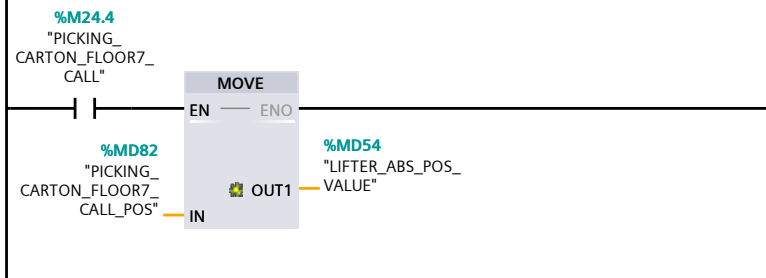
Network 23: PICKING_SIXTH_FLOOR_CALL:



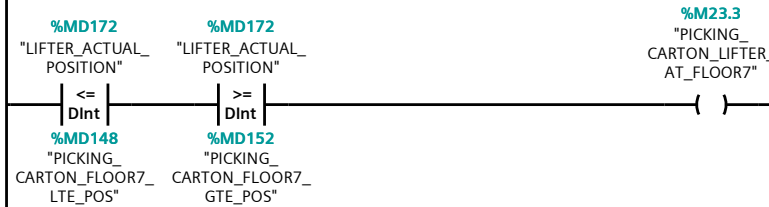
Network 27: PICKING_SEVENTH_FLOOR_CALL:



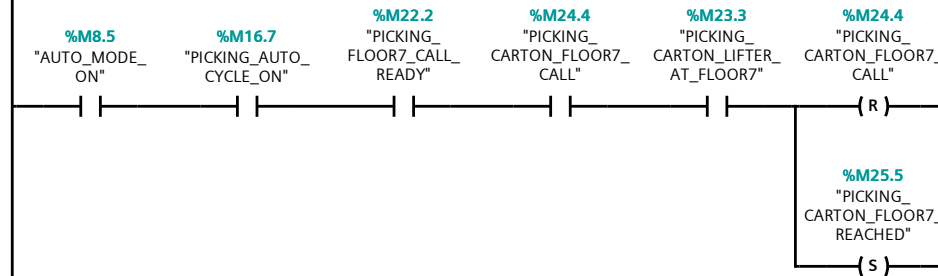
Network 28: PICKING_CARTON_FLOOR7_CALL_VALUE:



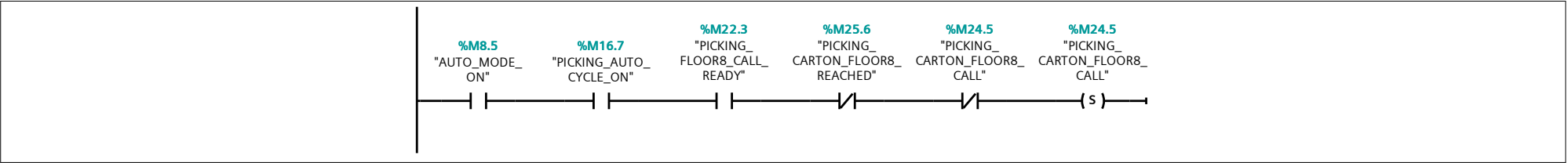
Network 29: LIFTER_AT_FLOOR7_FOR_CARTON_PICKING:



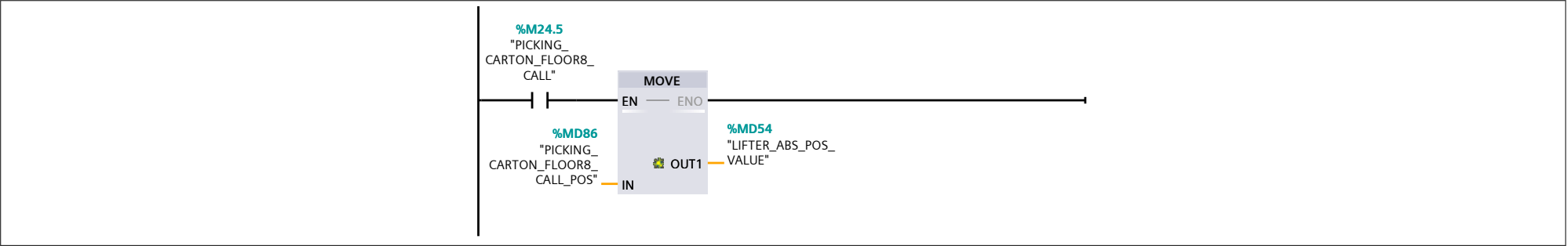
Network 30: PICKING_SEVENTH_FLOOR_CALL_RESET:



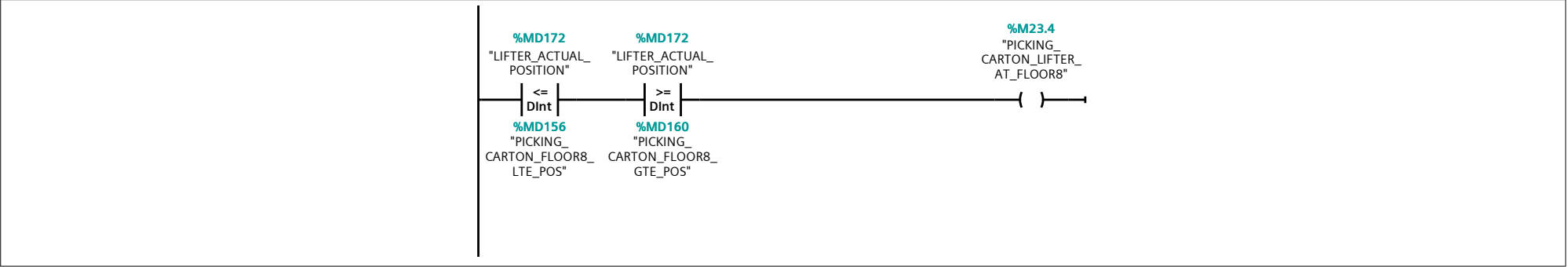
Network 31: PICKING_EIGHTH_FLOOR_CALL:



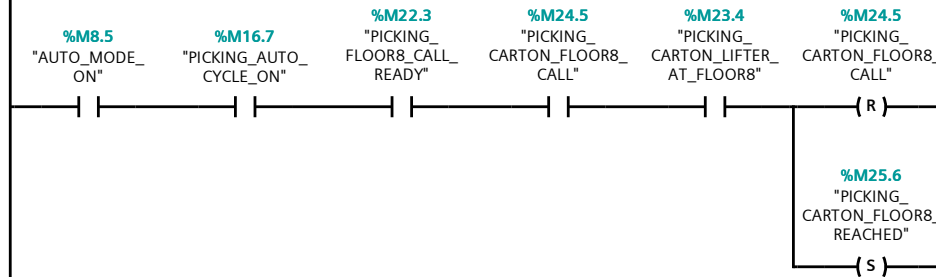
Network 32: PICKING_CARTON_FLOOR8_CALL_VALUE:



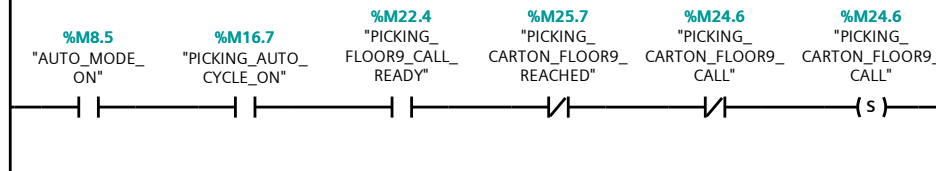
Network 33: LIFTER_AT_FLOOR8_FOR_CARTON_PICKING:



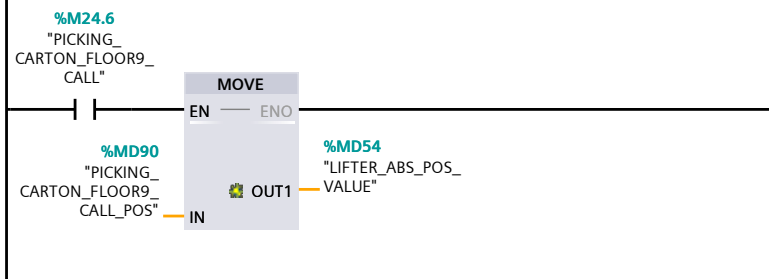
Network 34: PICKING_EIGHTH_FLOOR_CALL_RESET:



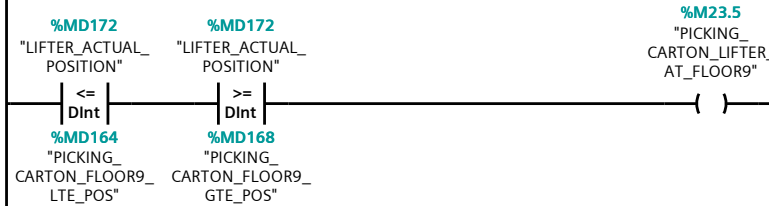
Network 35: PICKING_NINTH_FLOOR_CALL:



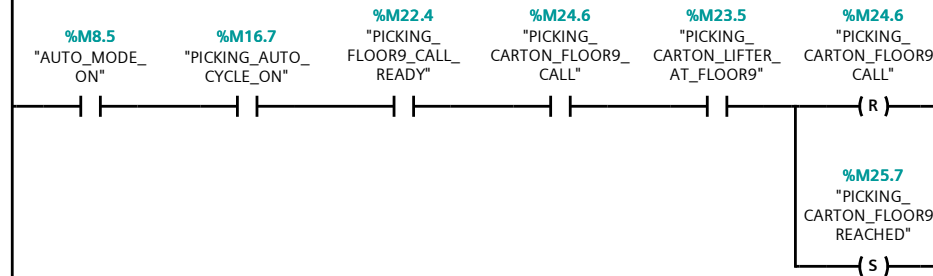
Network 36: PICKING_CARTON_FLOOR9_CALL_VALUE:



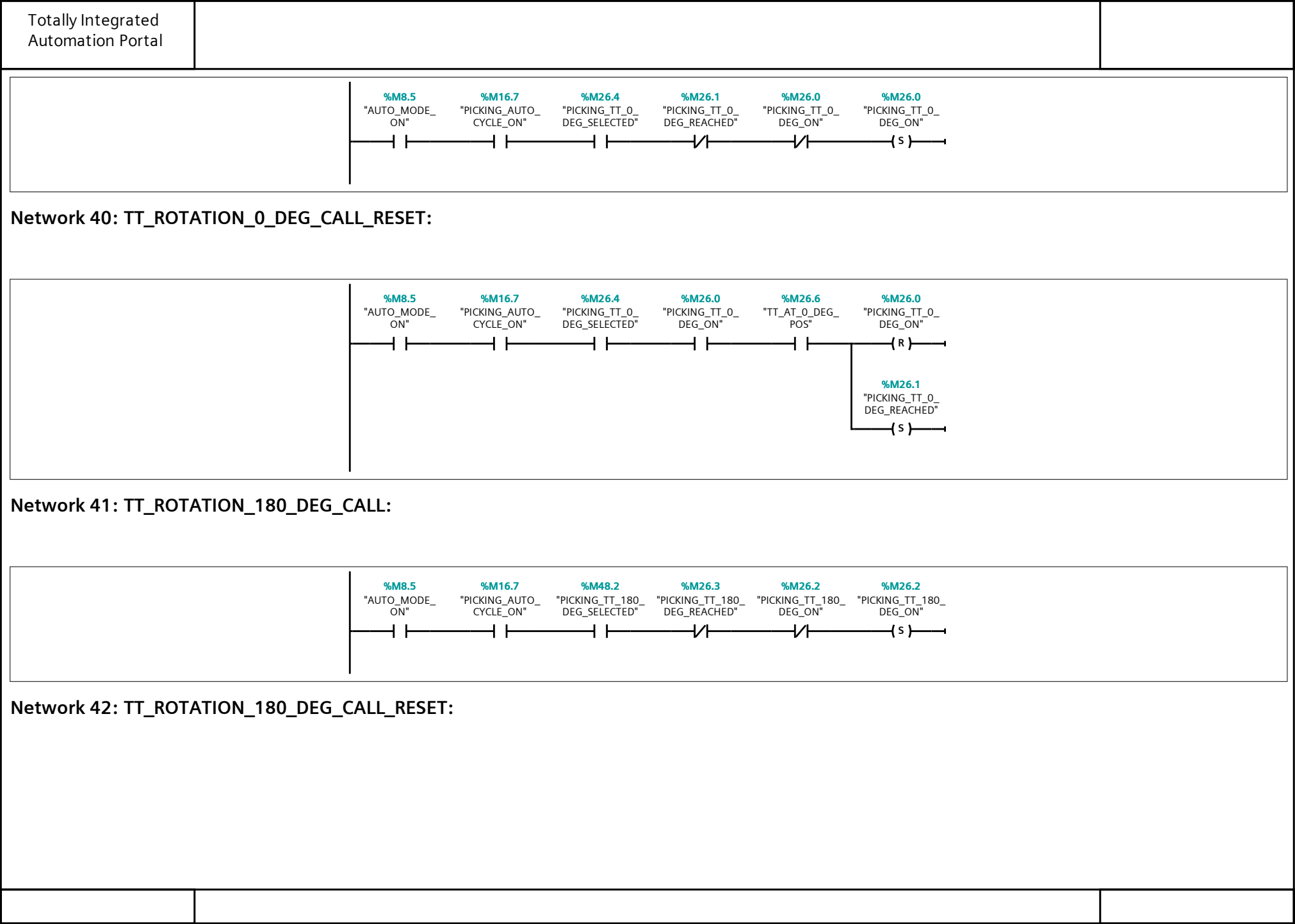
Network 37: LIFTER_AT_FLOOR9_FOR_CARTON_PICKING:

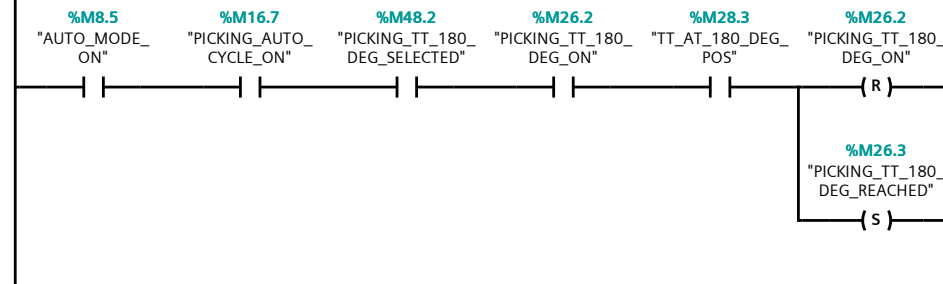


Network 38: PICKING_NINTH_FLOOR_CALL_RESET:

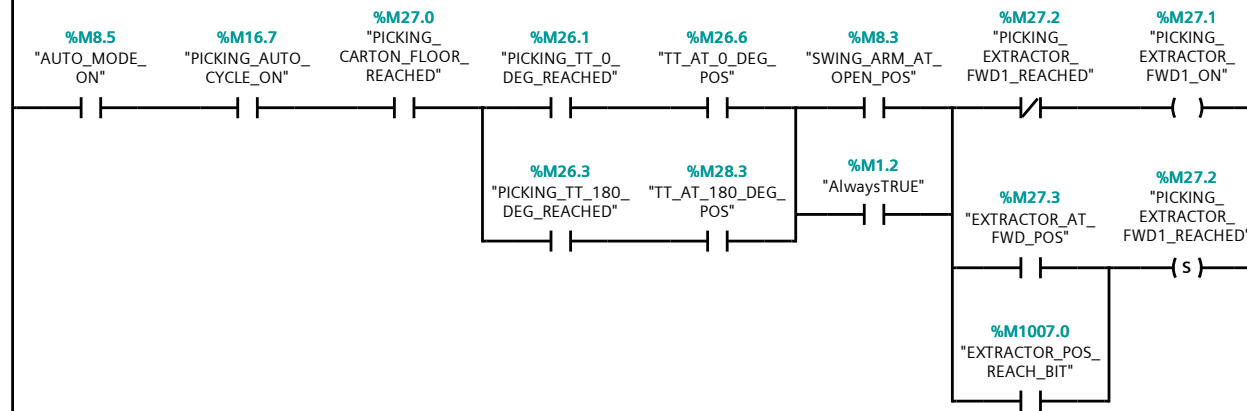


Network 39: TT_ROTATION_0_DEG_CALL:

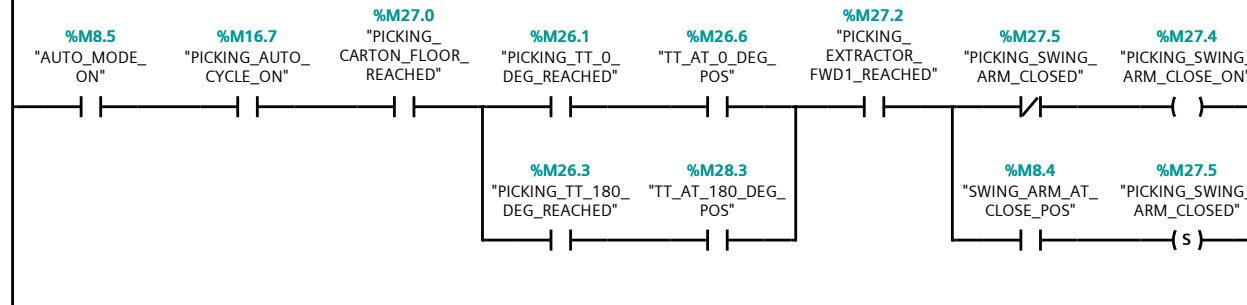




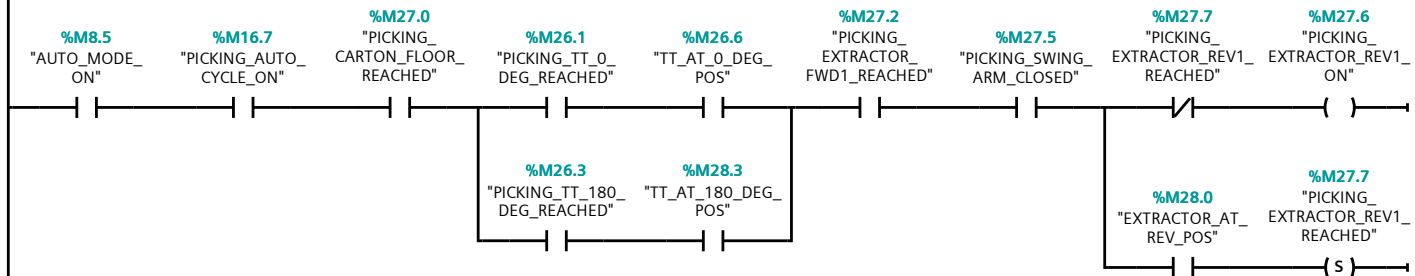
Network 43: EXTRACTOR_FORWARD_FOR_PICKING_CARTON_FROM_RACK:



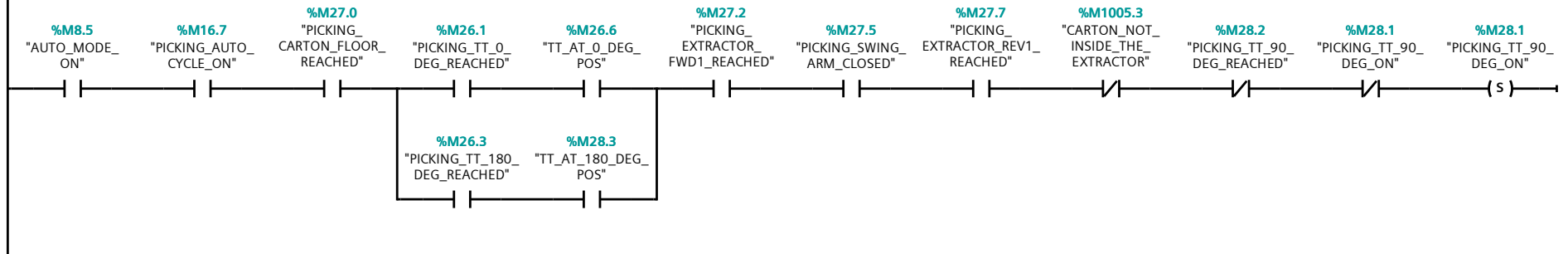
Network 44: SWING_ARM_CLOSED_FOR_PICKING_CARTON_FROM_RACK:



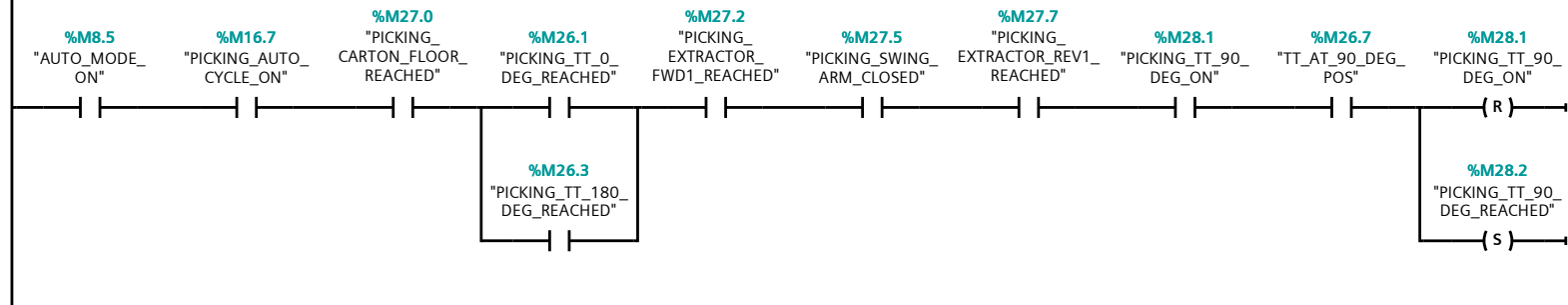
Network 45: EXTRACTOR_REVERSE_AFTER_PICKING_CARTON_FROM_RACK:



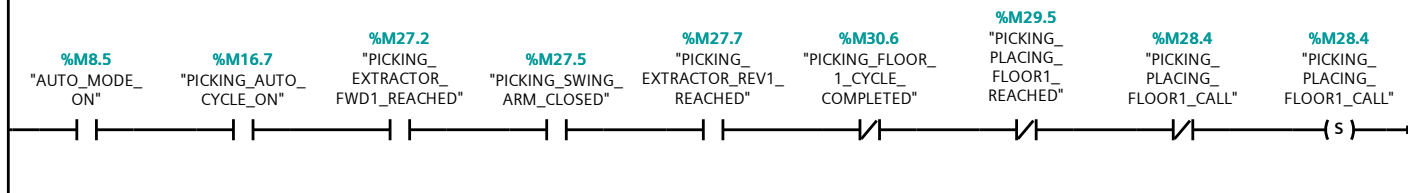
Network 46: TT_ROTATION_TO_90_DEG_CALL_AFTER_PICKING_CARTON_FROM_RACK:



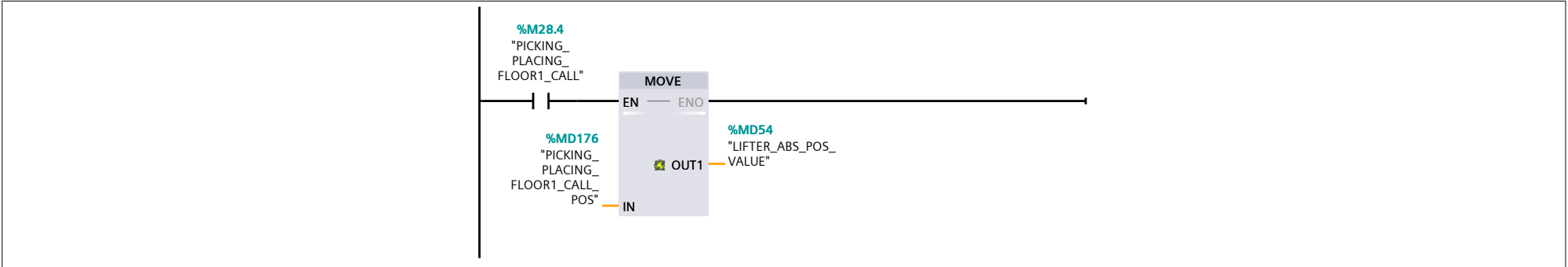
Network 47: TT_ROTATION_TO_90_DEG_CALL_RESET_AFTER_PICKING_CARTON_FROM_RACK:



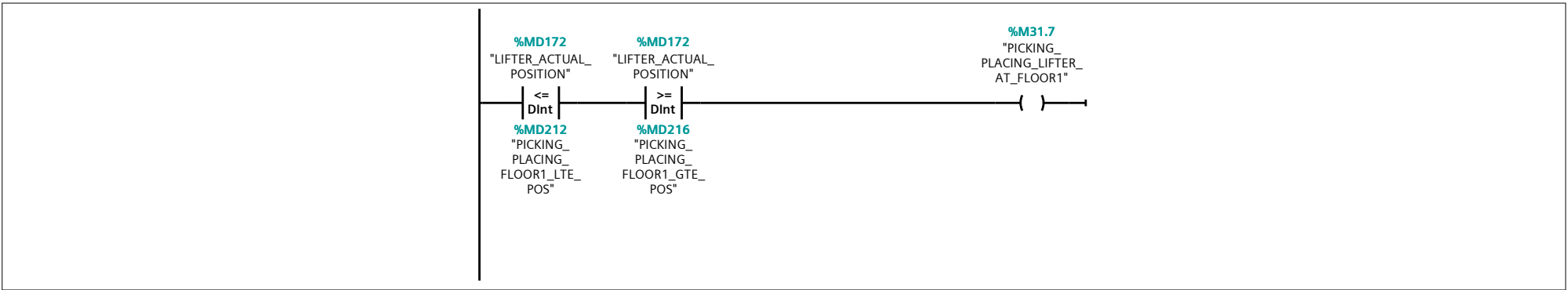
Network 48: AFTER_PICKING_FIRST_CARTON_FIRST_FLOOR_CALL:



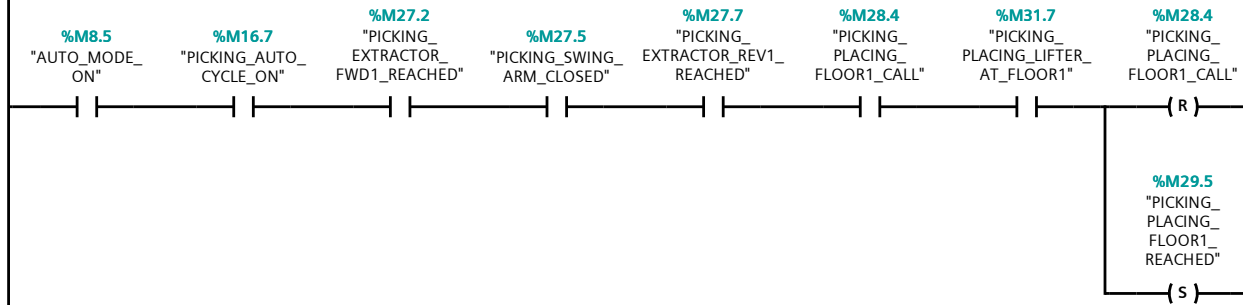
Network 49: PICKING_PLACING_FLOOR1_CALL_VALUE:



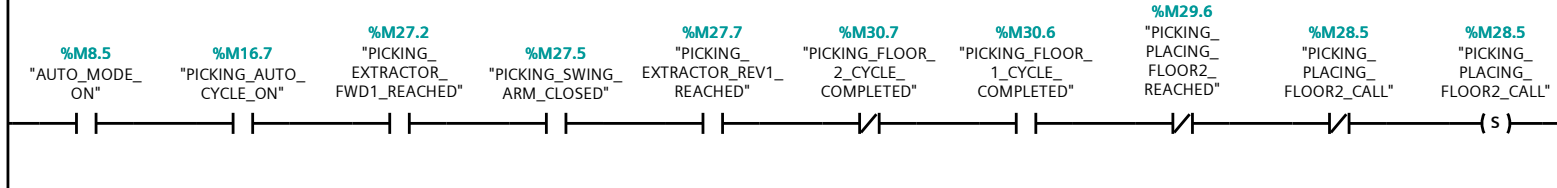
Network 50: FOR_CARTON_PLACING_LIFTER_AT_FLOOR1:



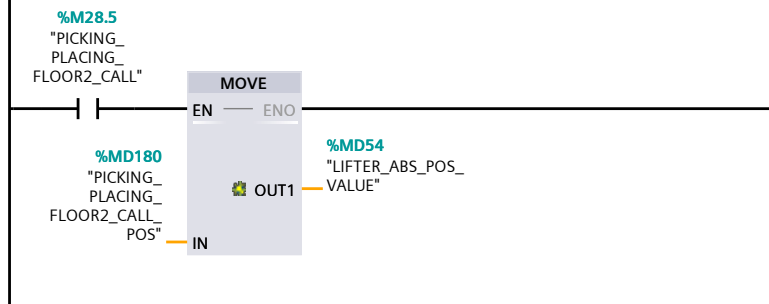
Network 51: AFTER_PICKING_FIRST_CARTON_FIRST_FLOOR_CALL_RESET:



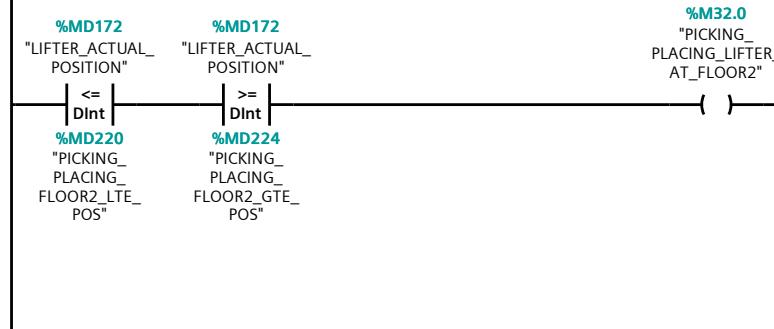
Network 52: AFTER_PICKING_SECOND_CARTON_SECOND_FLOOR_CALL:



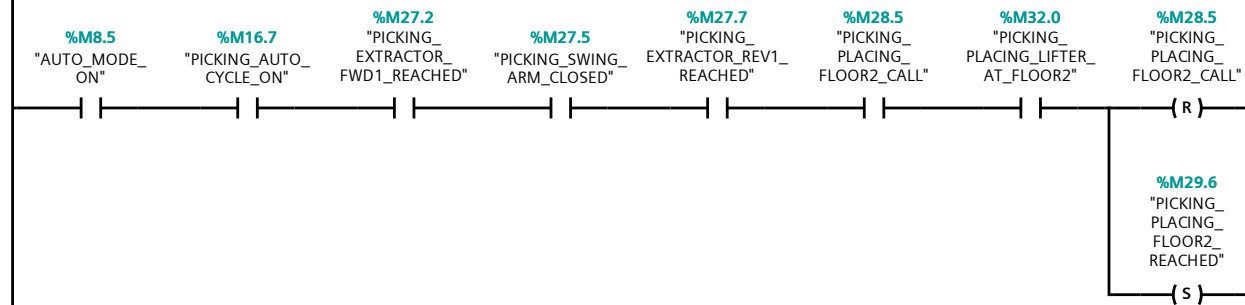
Network 53: PICKING_PLACING_FLOOR2_CALL_VALUE:



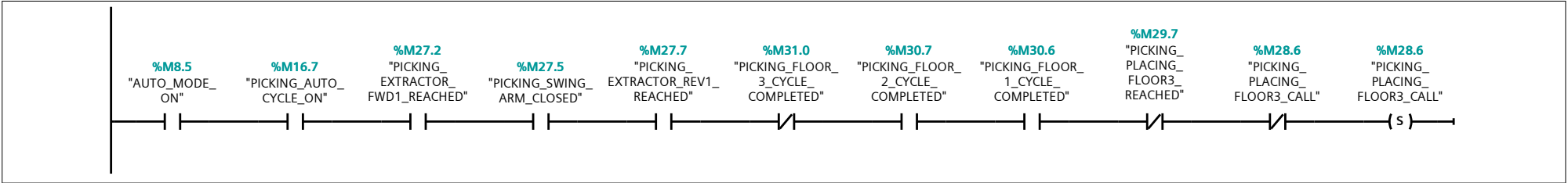
Network 54: FOR_CARTON_PLACING_LIFTER_AT_FLOOR2:



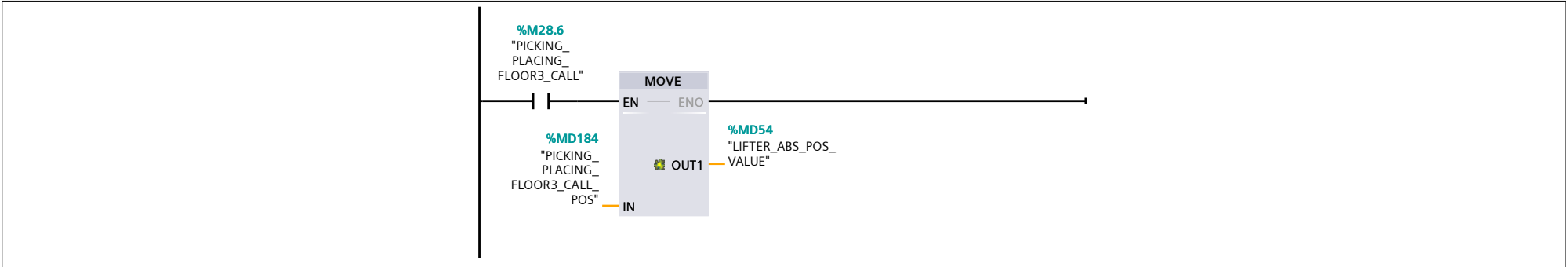
Network 55: AFTER_PICKING_SECOND_CARTON_SECOND_FLOOR_CALL_RESET:



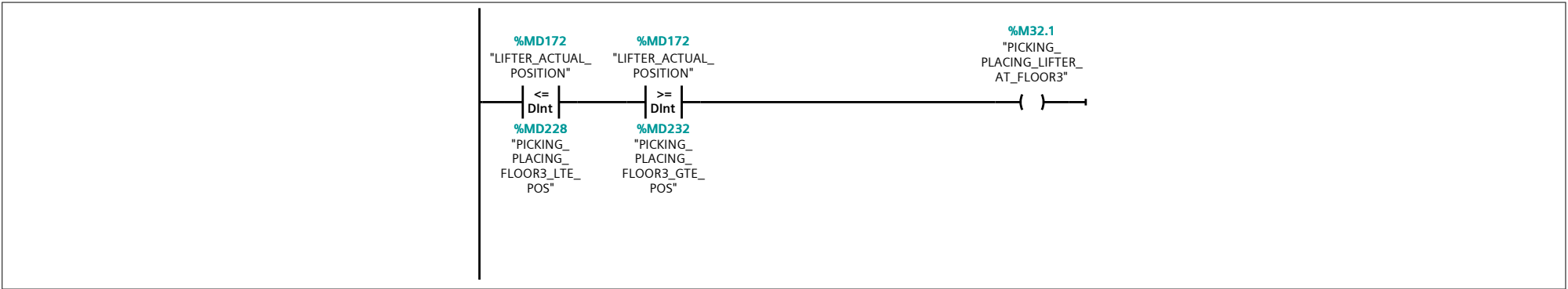
Network 56: AFTER_PICKING_THIRD_CARTON_THIRD_FLOOR_CALL:



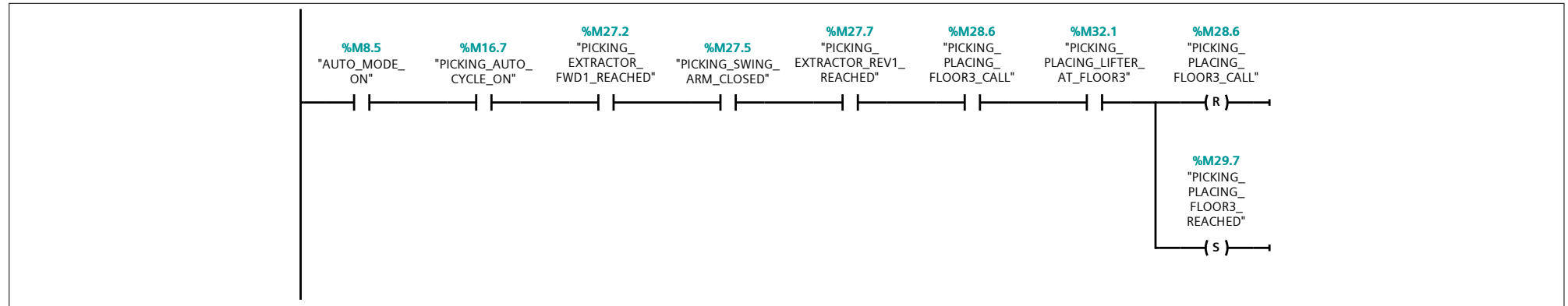
Network 57: PICKING_PLACING_FLOOR3_CALL_VALUE:



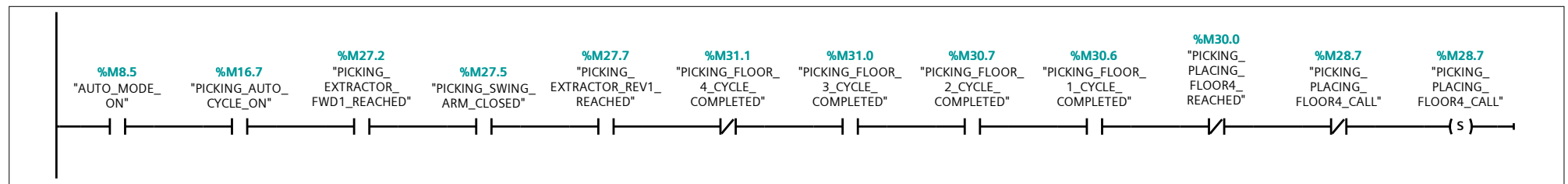
Network 58: FOR_CARTON_PLACING_LIFTER_AT_FLOOR3:



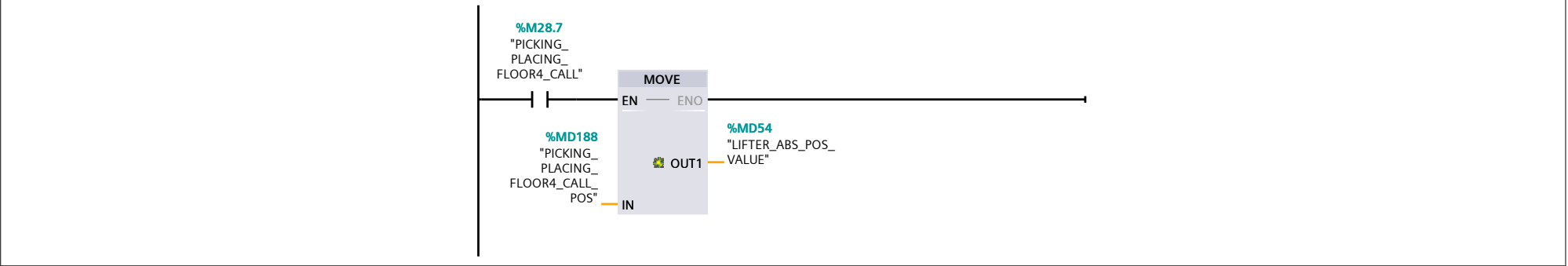
Network 59: AFTER_PICKING_THIRD_CARTON_THIRD_FLOOR_CALL_RESET:



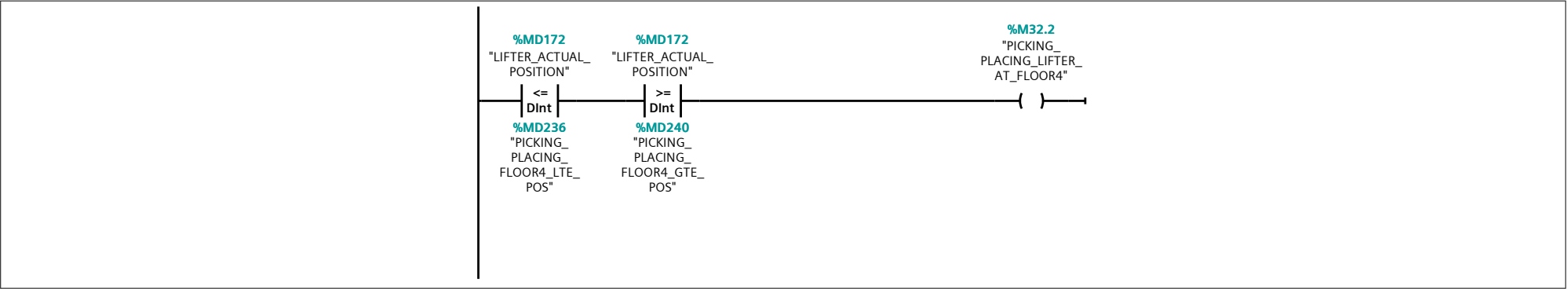
Network 60: AFTER_PICKING_FOURTH_CARTON_FOURTH_FLOOR_CALL:



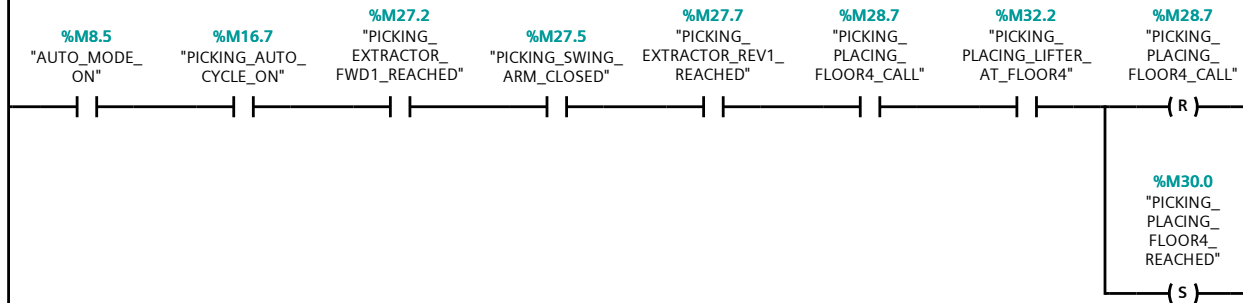
Network 61: PICKING_PLACING_FLOOR4_CALL_VALUE:



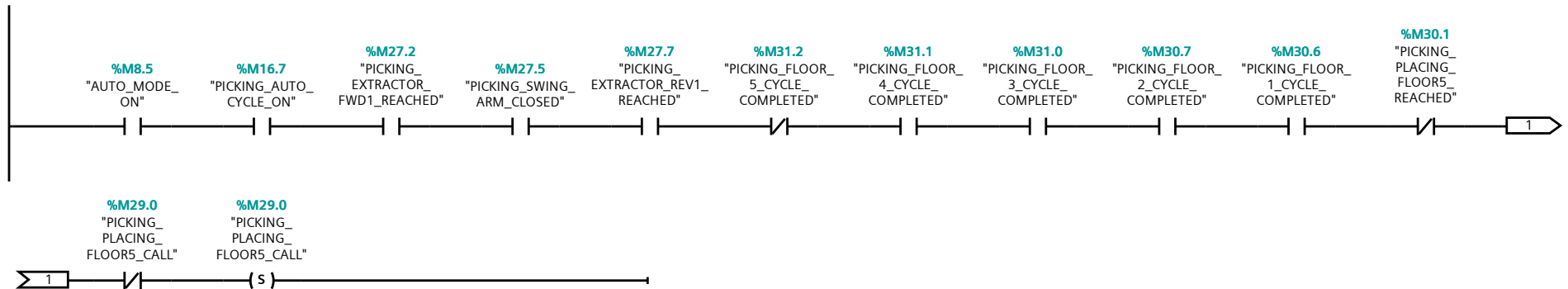
Network 62: FOR_CARTON_PLACING_LIFTER_AT_FLOOR4:



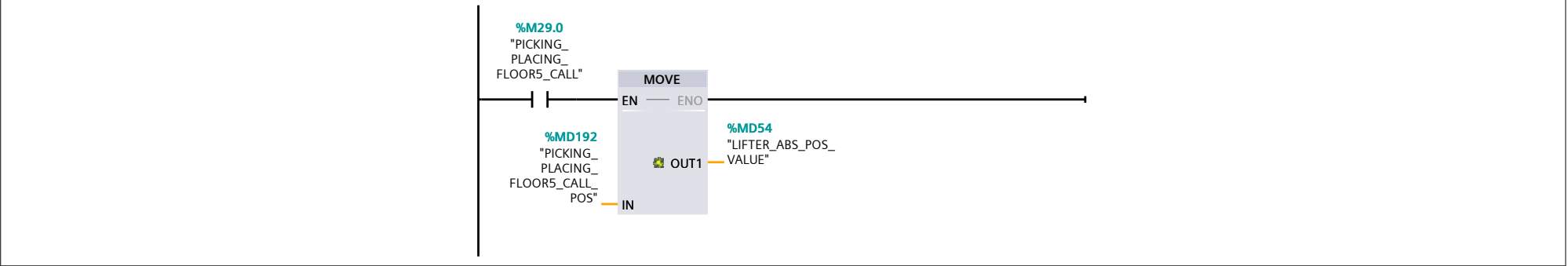
Network 63: AFTER_PICKING_FOURTH_CARTON_FOURTH_FLOOR_CALL_RESET:



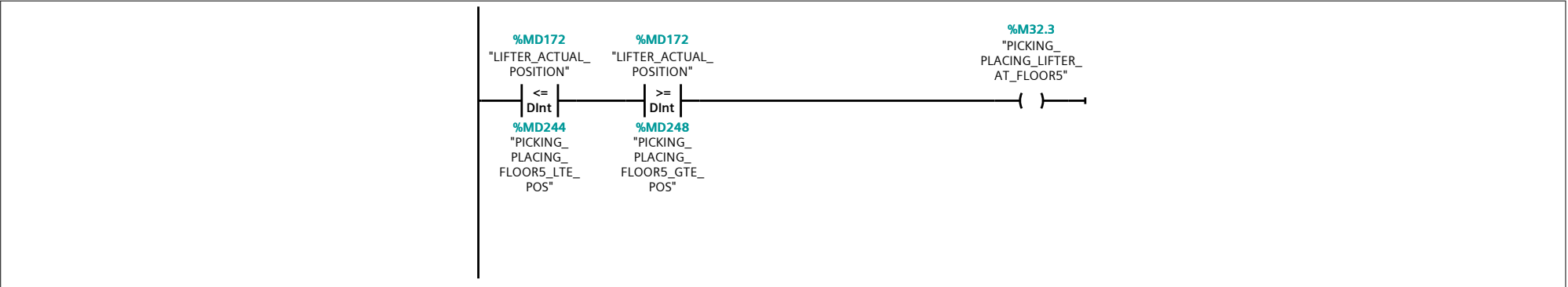
Network 64: AFTER_PICKING_FIFTH_CARTON_FIFTH_FLOOR_CALL:



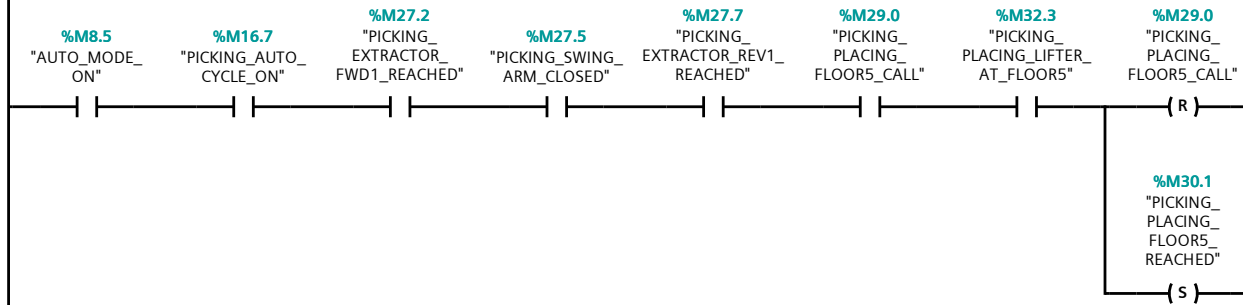
Network 65: PICKING_PLACING_FLOOR5_CALL_VALUE:



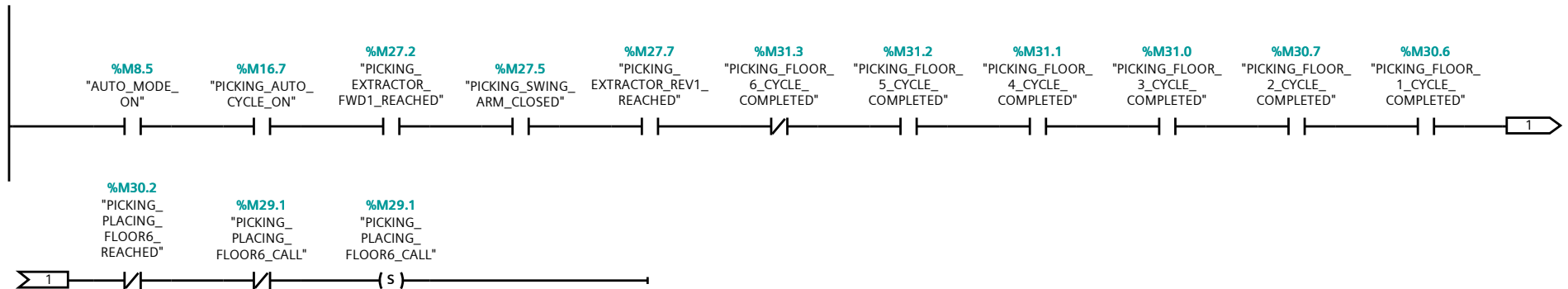
Network 66: FOR_CARTON_PLACING_LIFTER_AT_FLOOR5:



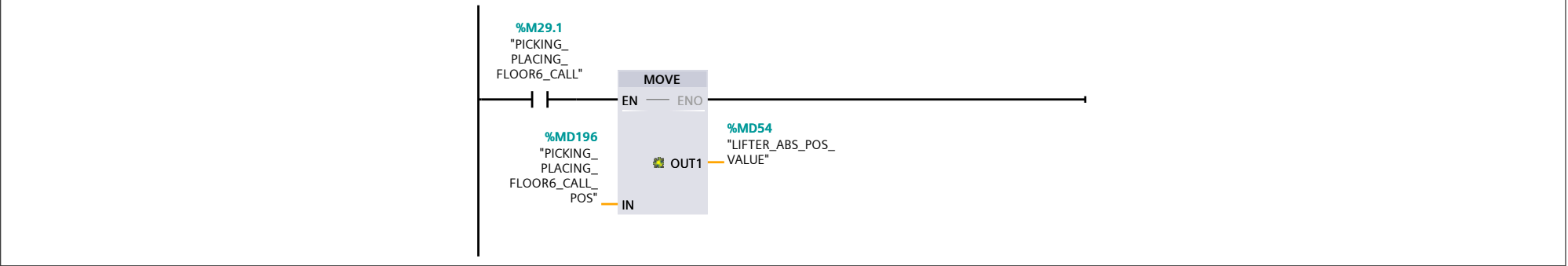
Network 67: AFTER_PICKING_FIFTH_CARTON_FIFTH_FLOOR_CALL_RESET:



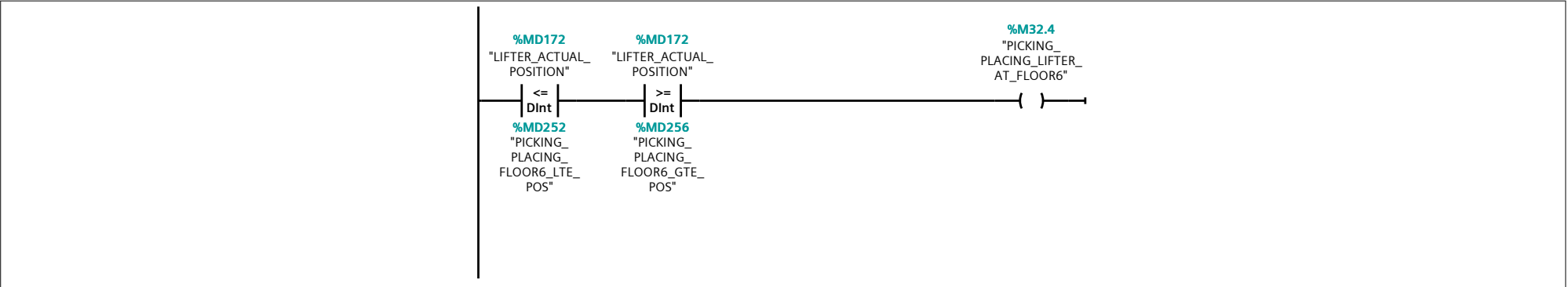
Network 68: AFTER_PICKING_SIXTH_CARTON_SIXTH_FLOOR_CALL:



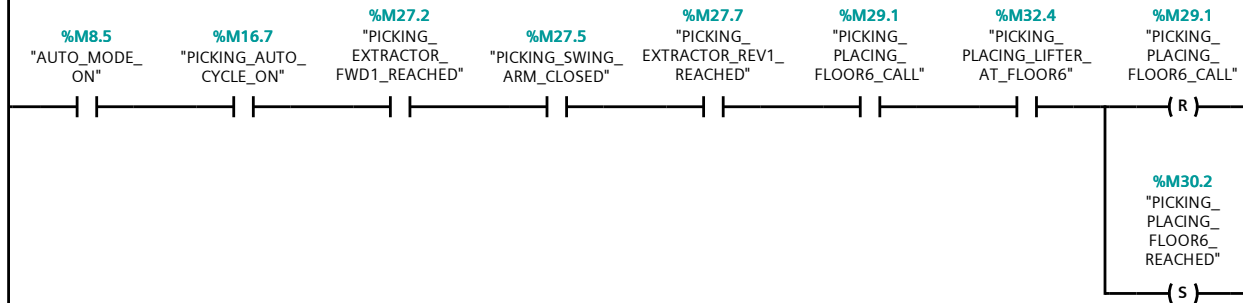
Network 69: PICKING_PLACING_FLOOR6_CALL_VALUE:



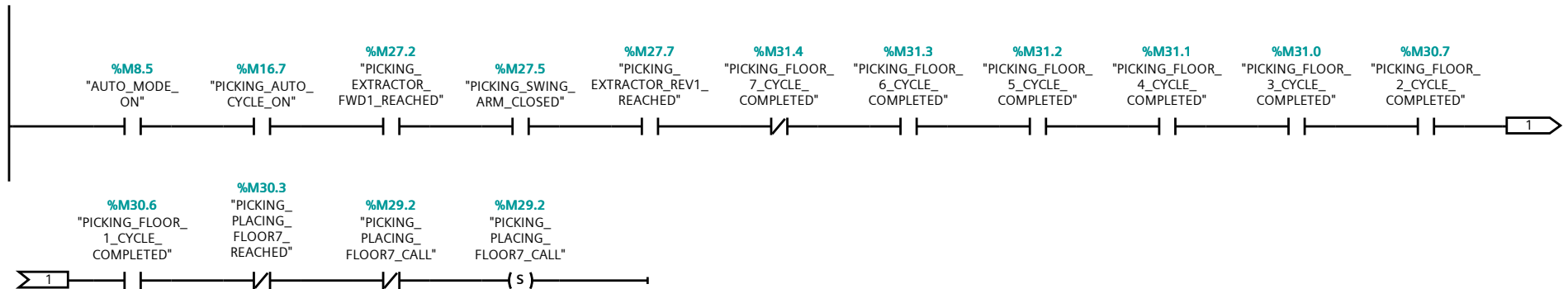
Network 70: FOR_CARTON_PLACING_LIFTER_AT_FLOOR6:



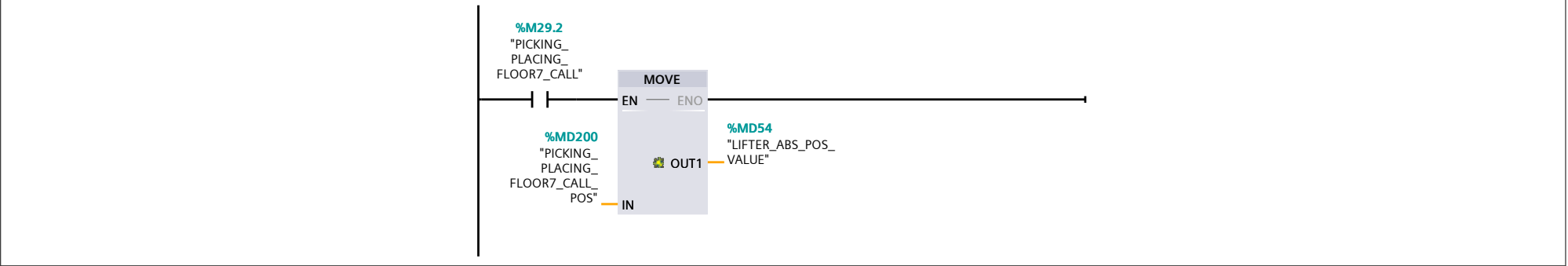
Network 71: AFTER_PICKING_SIXTH_CARTON_SIXTH_FLOOR_CALL_RESET:



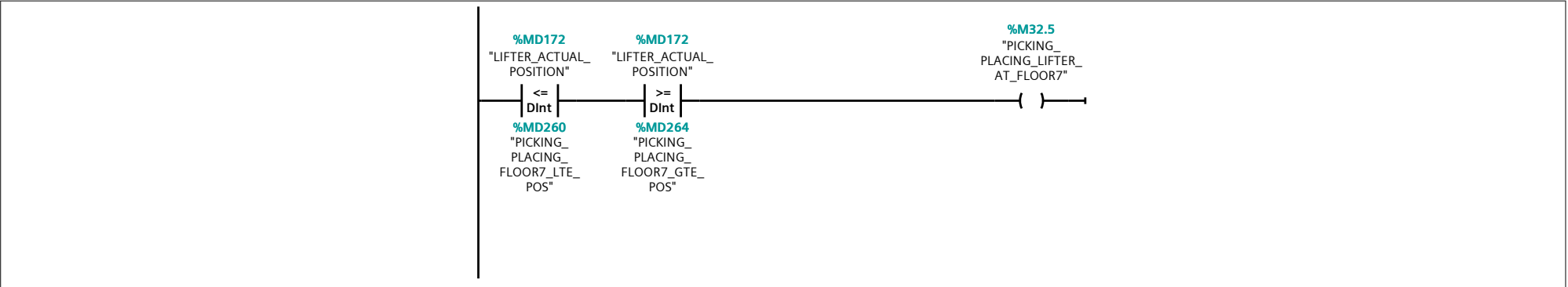
Network 72: AFTER_PICKING_SEVENTH_CARTON_SEVENTH_FLOOR_CALL:



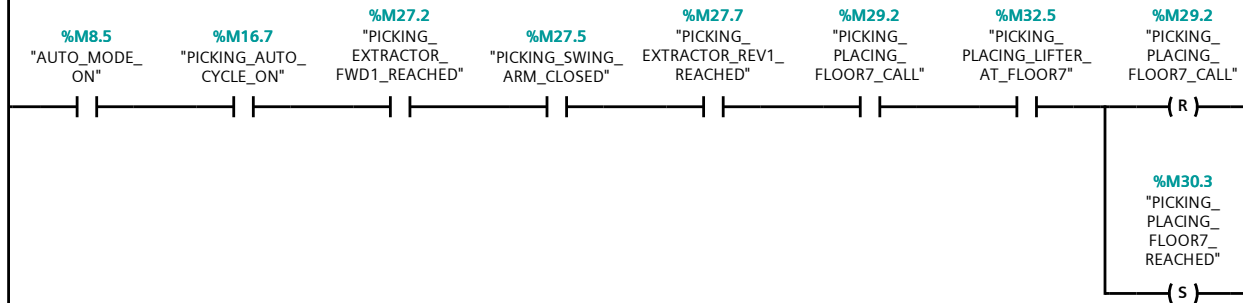
Network 73: PICKING_PLACING_FLOOR7_CALL_VALUE:



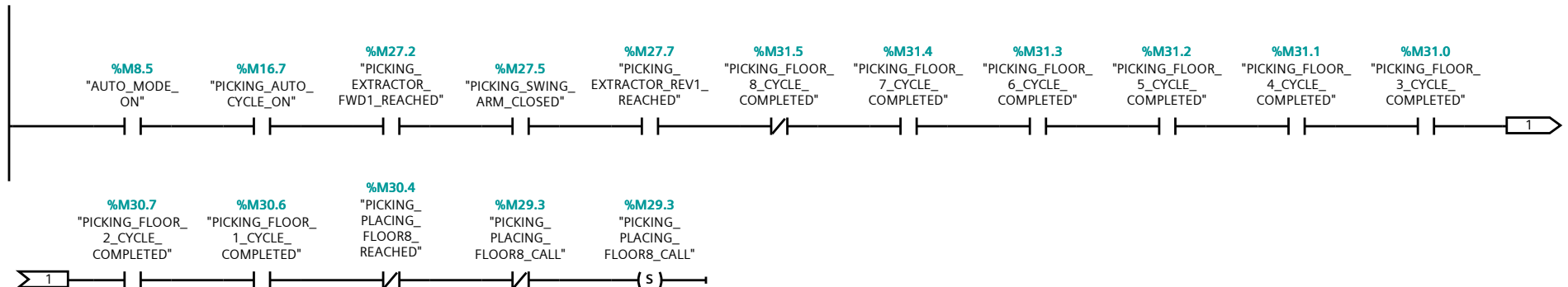
Network 74: FOR_CARTON_PLACING_LIFTER_AT_FLOOR7:



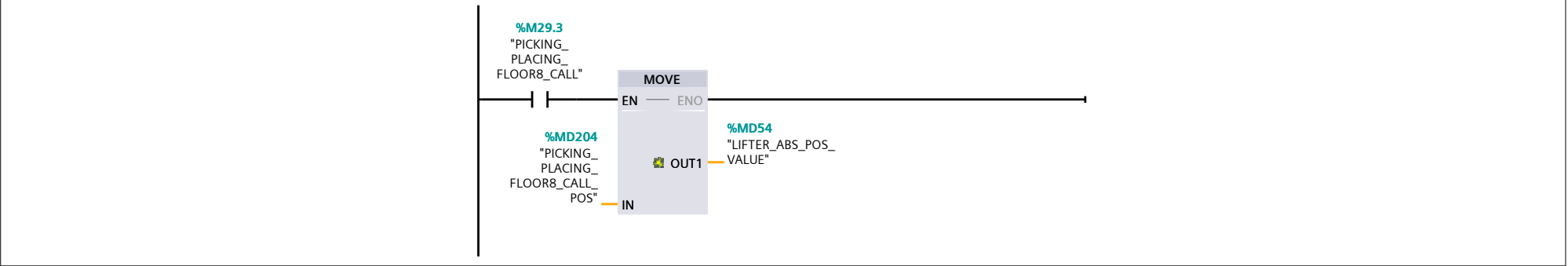
Network 75: AFTER_PICKING_SEVENTH_CARTON_SEVENTH_FLOOR_CALL_RESET:



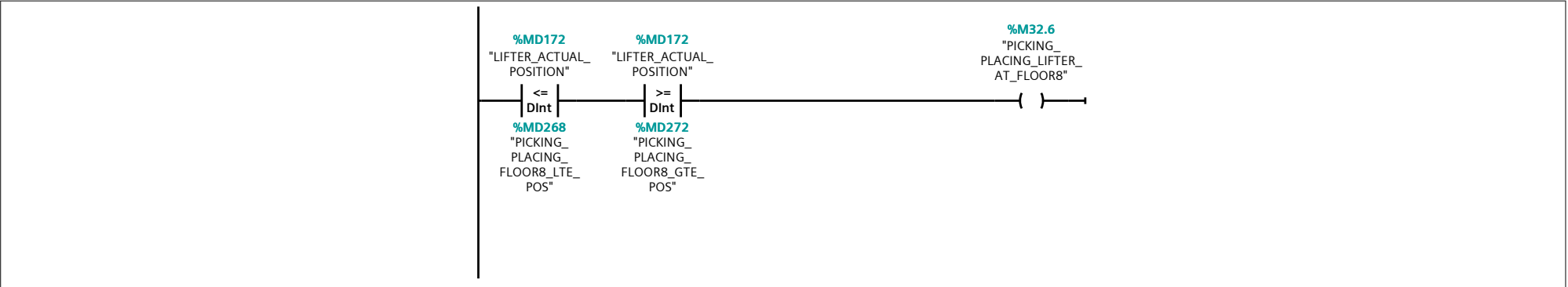
Network 76: AFTER_PICKING_EIGHTH_CARTON_EIGHTH_FLOOR_CALL:



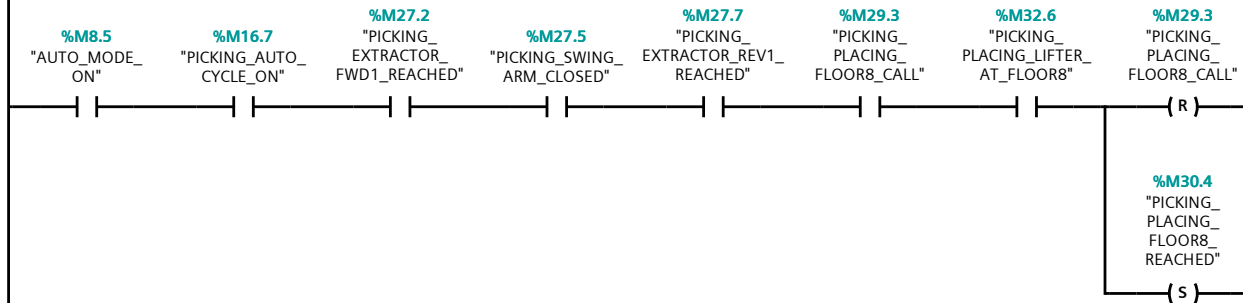
Network 77: PICKING_PLACING_FLOOR8_CALL_VALUE:



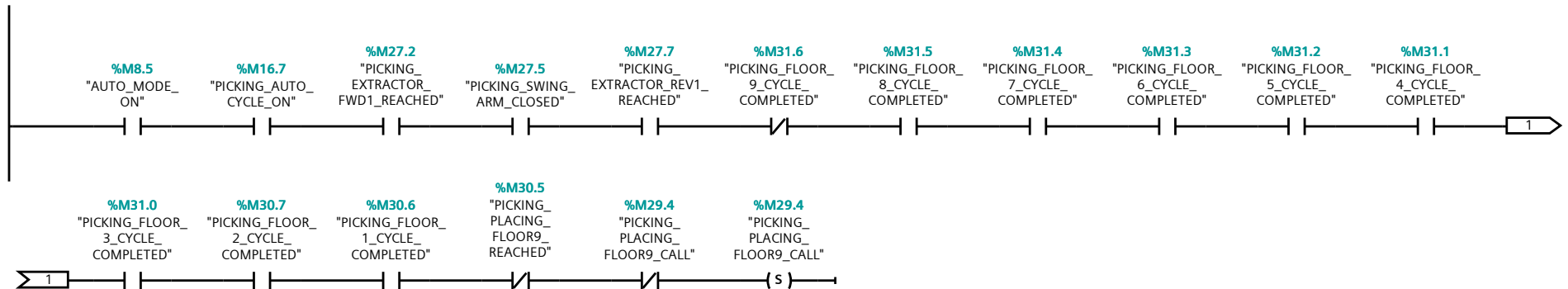
Network 78: FOR_CARTON_PLACING_LIFTER_AT_FLOOR8:



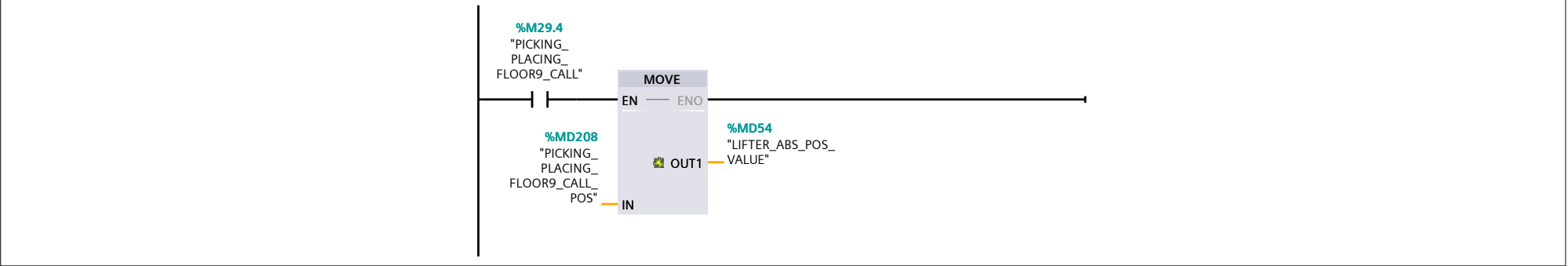
Network 79: AFTER_PICKING_EIGHTH_CARTON_EIGHTH_FLOOR_CALL_RESET:



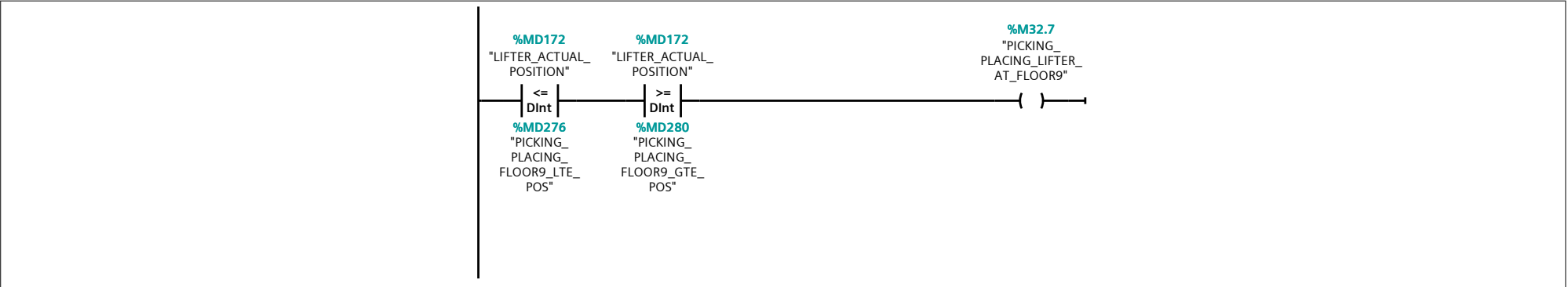
Network 80: AFTER_PICKING_NINTH_CARTON_NINTH_FLOOR_CALL:



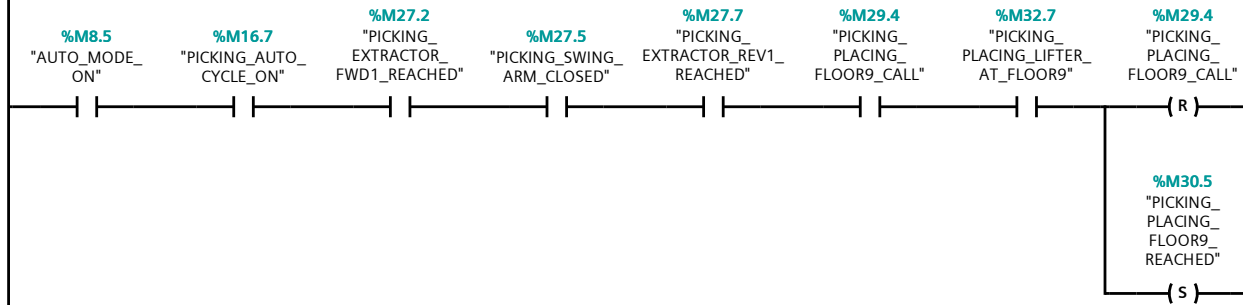
Network 81: PICKING_PLACING_FLOOR9_CALL_VALUE:



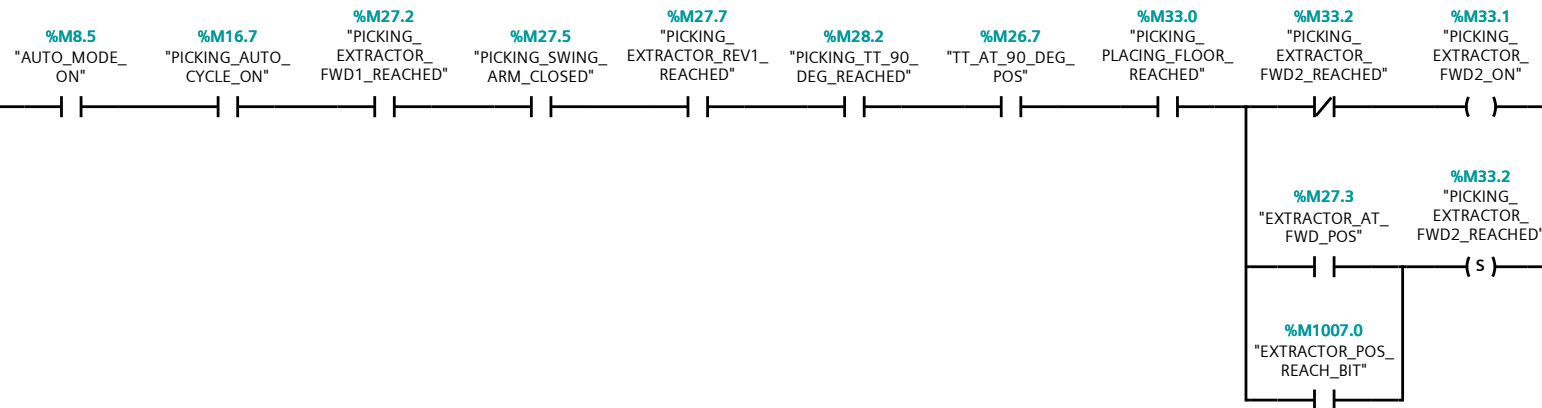
Network 82: FOR_CARTON_PLACING_LIFTER_AT_FLOOR9:



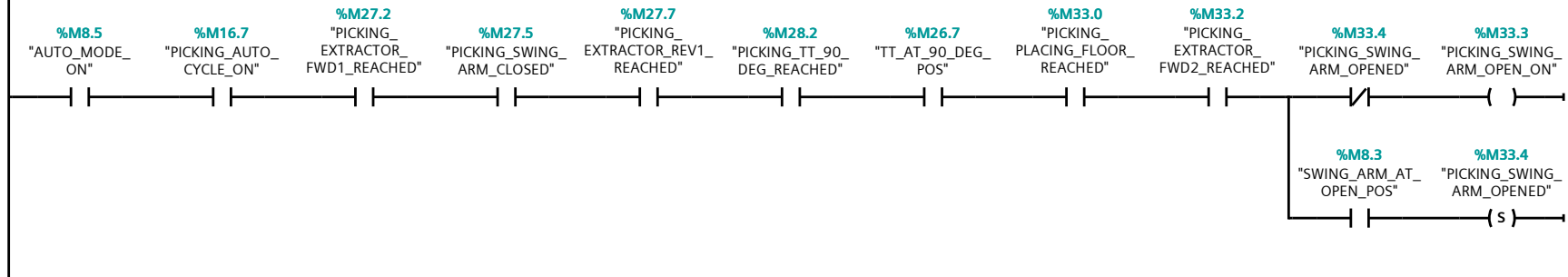
Network 83: AFTER_PICKING_NINTH_CARTON_NINTH_FLOOR_CALL_RESET:



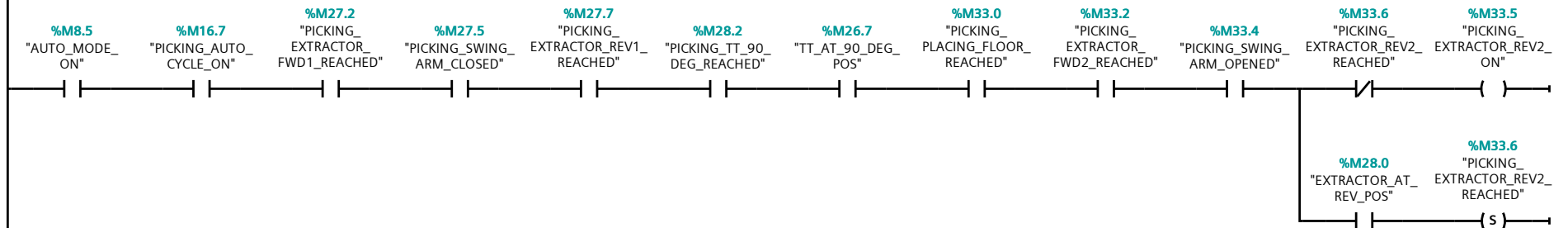
Network 84: EXTRACTOR_FORWARD_FOR_PLACING_CARTON_AT_INSIDE_ACR:



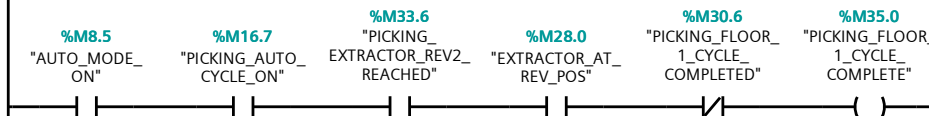
Network 85: SWING_ARM_OPEN_AT_INSIDE_ACR:



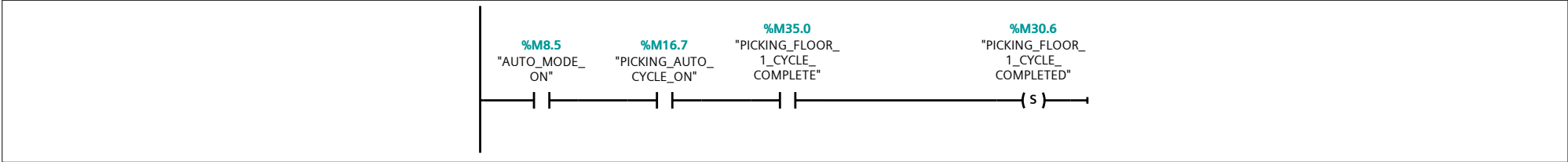
Network 86: EXTRACTOR_REVERSE_AFTER_PLACING_CARTON_AT_INSIDE_ACR:



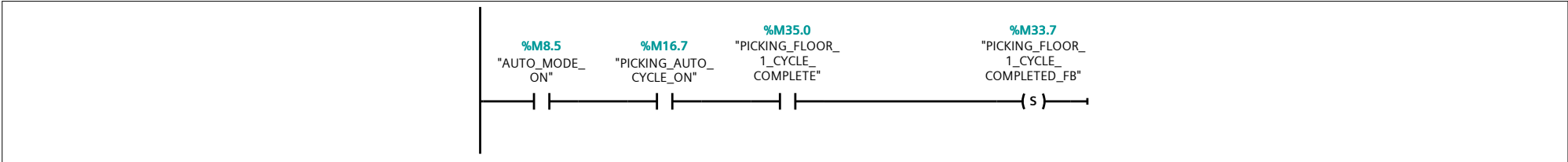
Network 87: PICKING_FIRST_FLOOR_CYCLE_COMPLETE:



Network 88: PICKING_FIRST_FLOOR_CYCLE_COMPLETED:

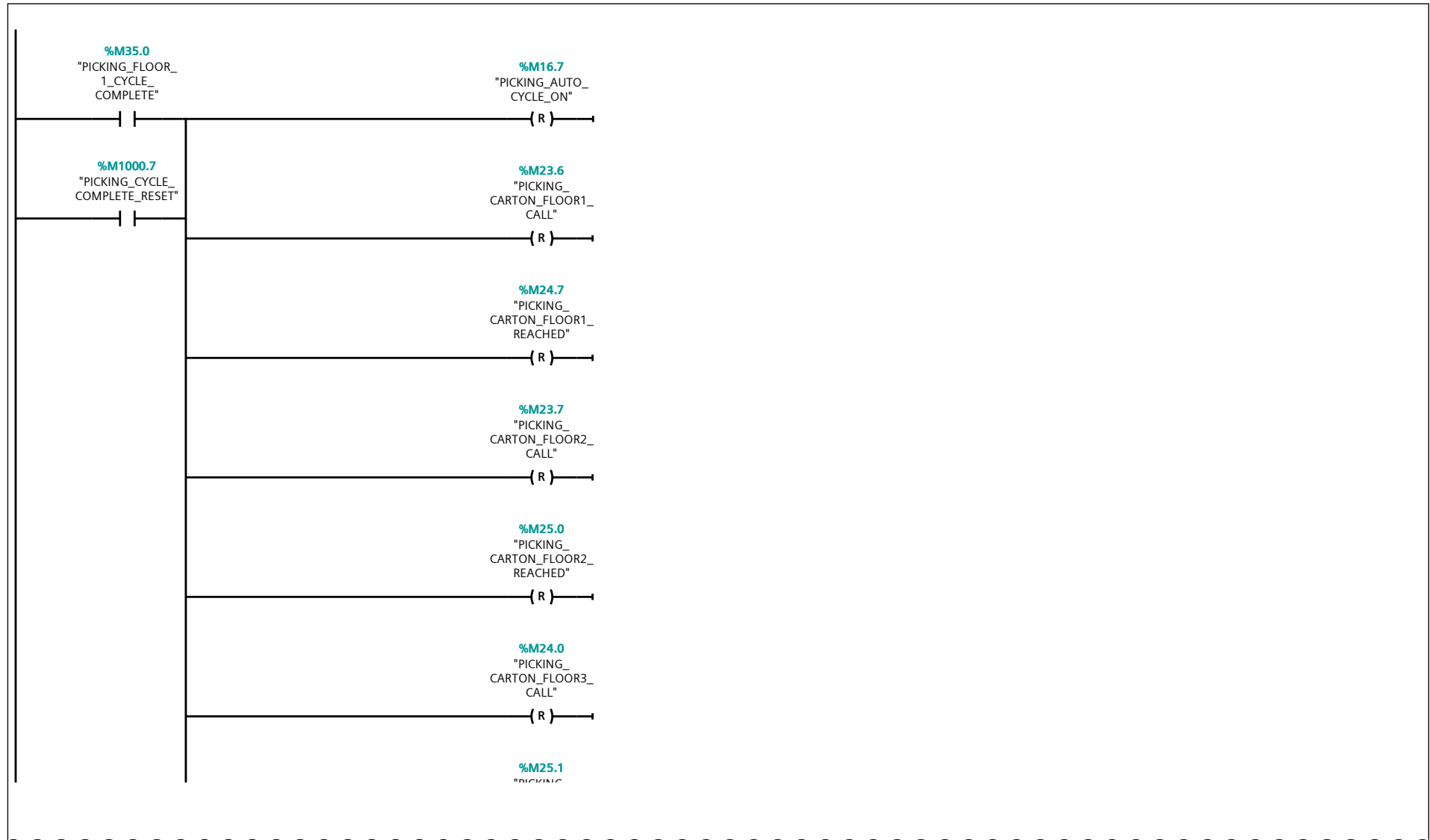


Network 89: PICKING_FIRST_FLOOR_CYCLE_COMPLETED_FB:



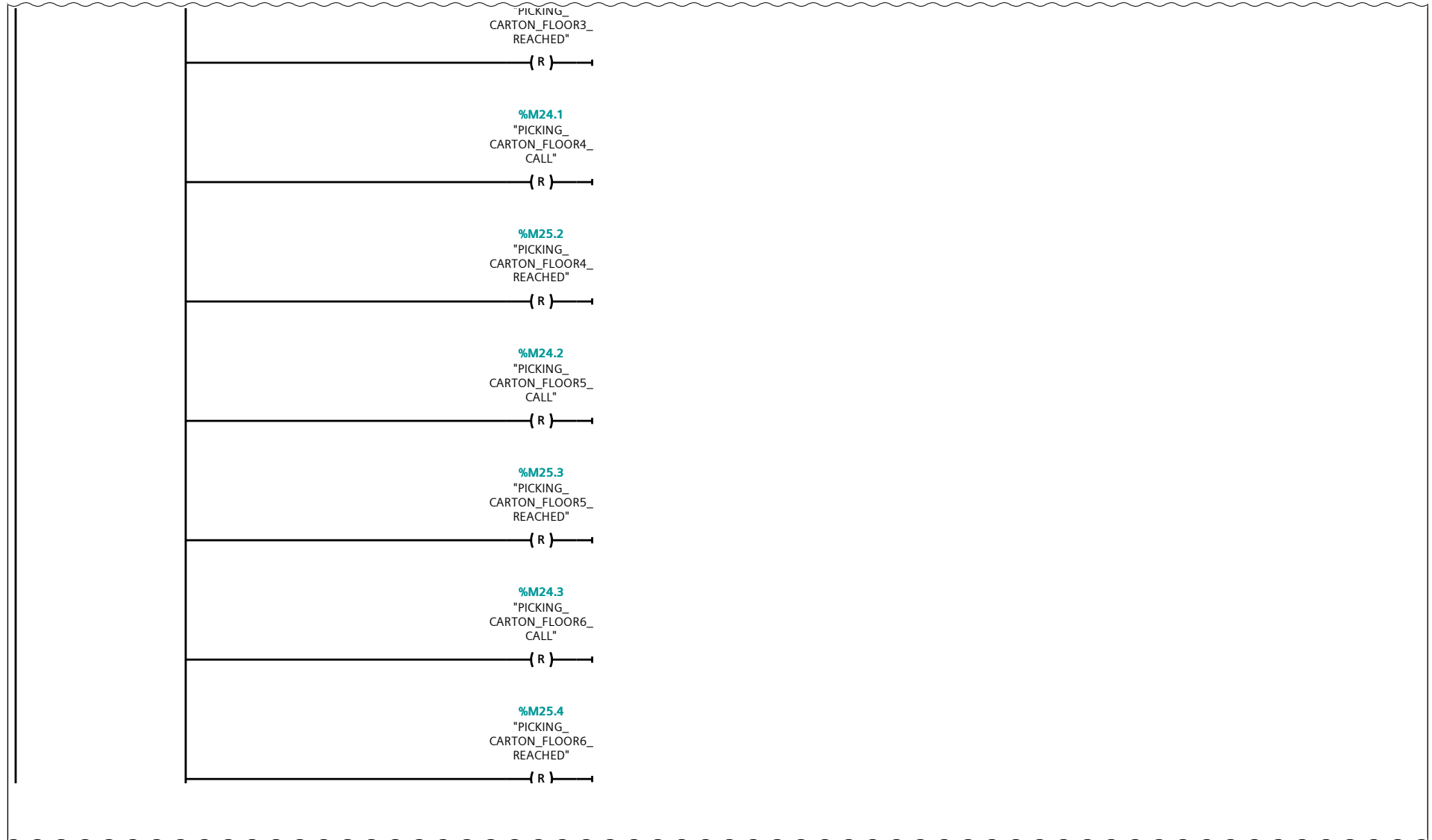
Network 90: PICKING_AUTO_CYCLE_RESET:

Network 90: PICKING_AUTO_CYCLE_RESET: (1.1 / 8.1)



Network 90: PICKING_AUTO_CYCLE_RESET: (2.1 / 8.1)

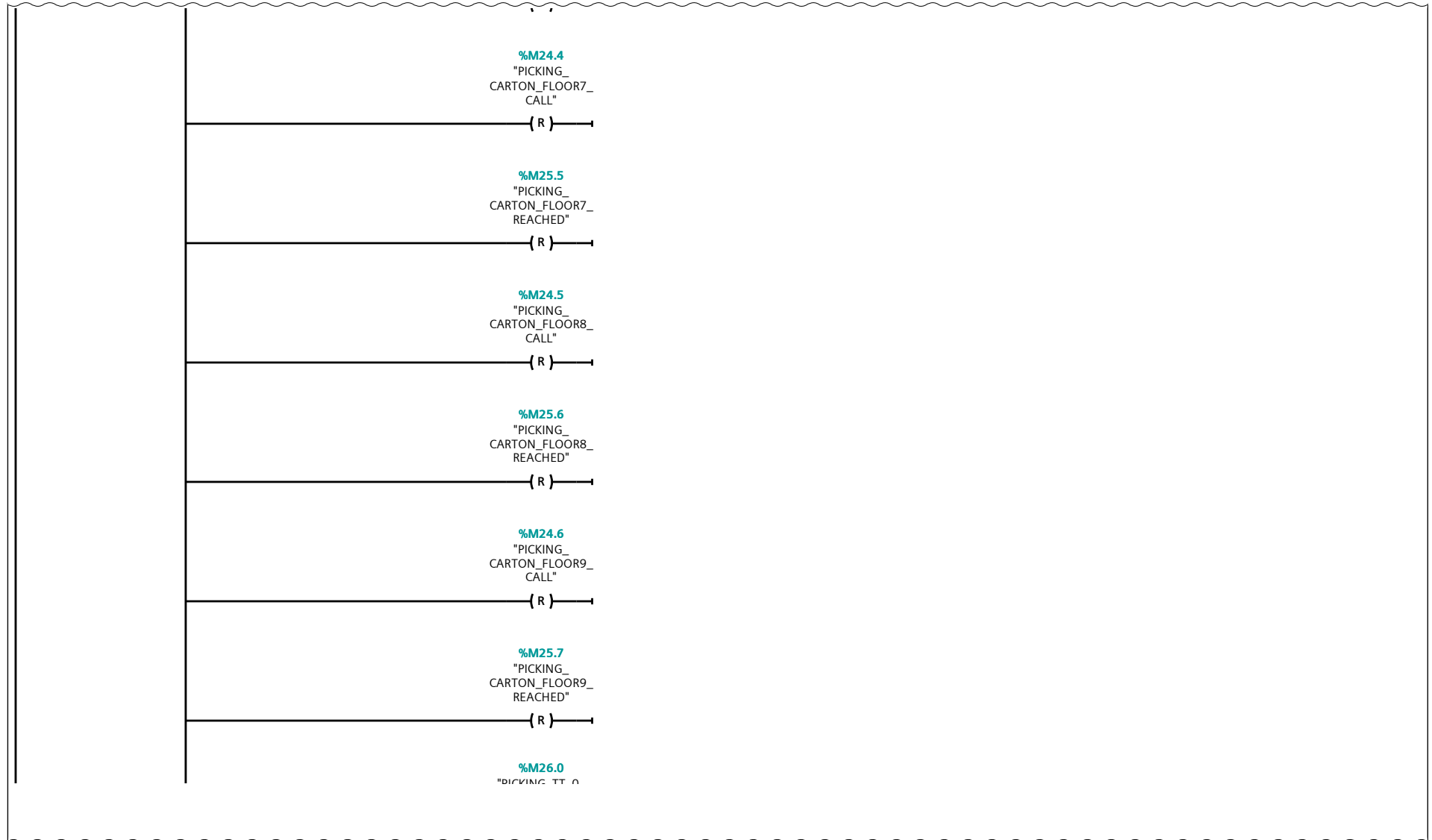
1.1 (Page1 - 39)



3.1 (Page1 - 41)

Network 90: PICKING_AUTO_CYCLE_RESET: (3.1 / 8.1)

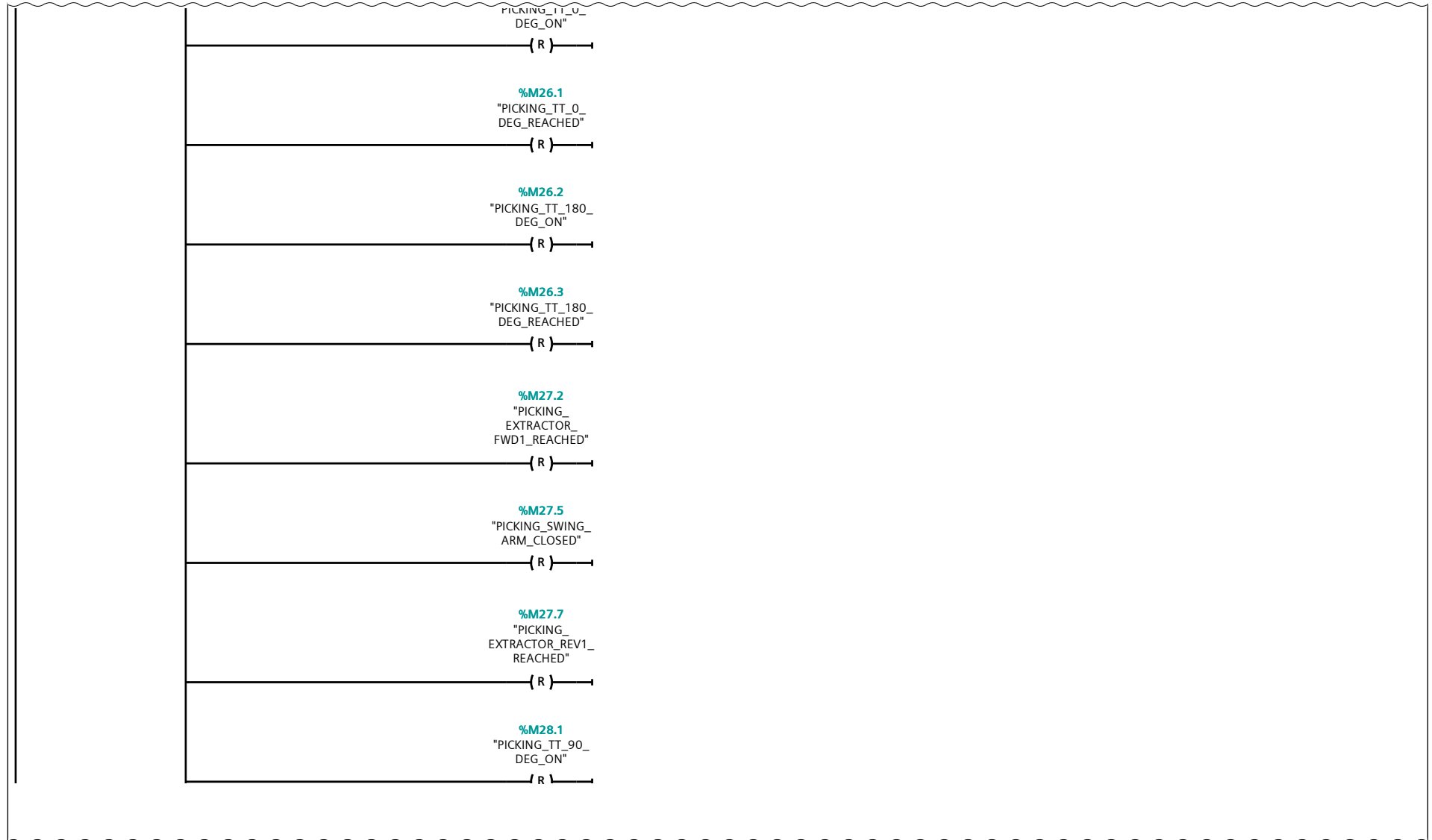
2.1 (Page1 - 40)



4.1 (Page1 - 42)

Network 90: PICKING_AUTO_CYCLE_RESET: (4.1 / 8.1)

3.1 (Page1 - 41)



5.1 (Page1 - 43)

Network 90: PICKING_AUTO_CYCLE_RESET: (5.1 / 8.1)

4.1 (Page1 - 42)

%M28.2
"PICKING_TT_90_
DEG_REACHED"

(R)

%M28.4
"PICKING_
PLACING_
FLOOR1_CALL"

(R)

%M29.5
"PICKING_
PLACING_
FLOOR1_
REACHED"

(R)

%M28.5
"PICKING_
PLACING_
FLOOR2_CALL"

(R)

%M29.6
"PICKING_
PLACING_
FLOOR2_
REACHED"

(R)

%M28.6
"PICKING_
PLACING_
FLOOR3_CALL"

(R)

6.1 (Page1 - 44)

Network 90: PICKING_AUTO_CYCLE_RESET: (6.1 / 8.1)

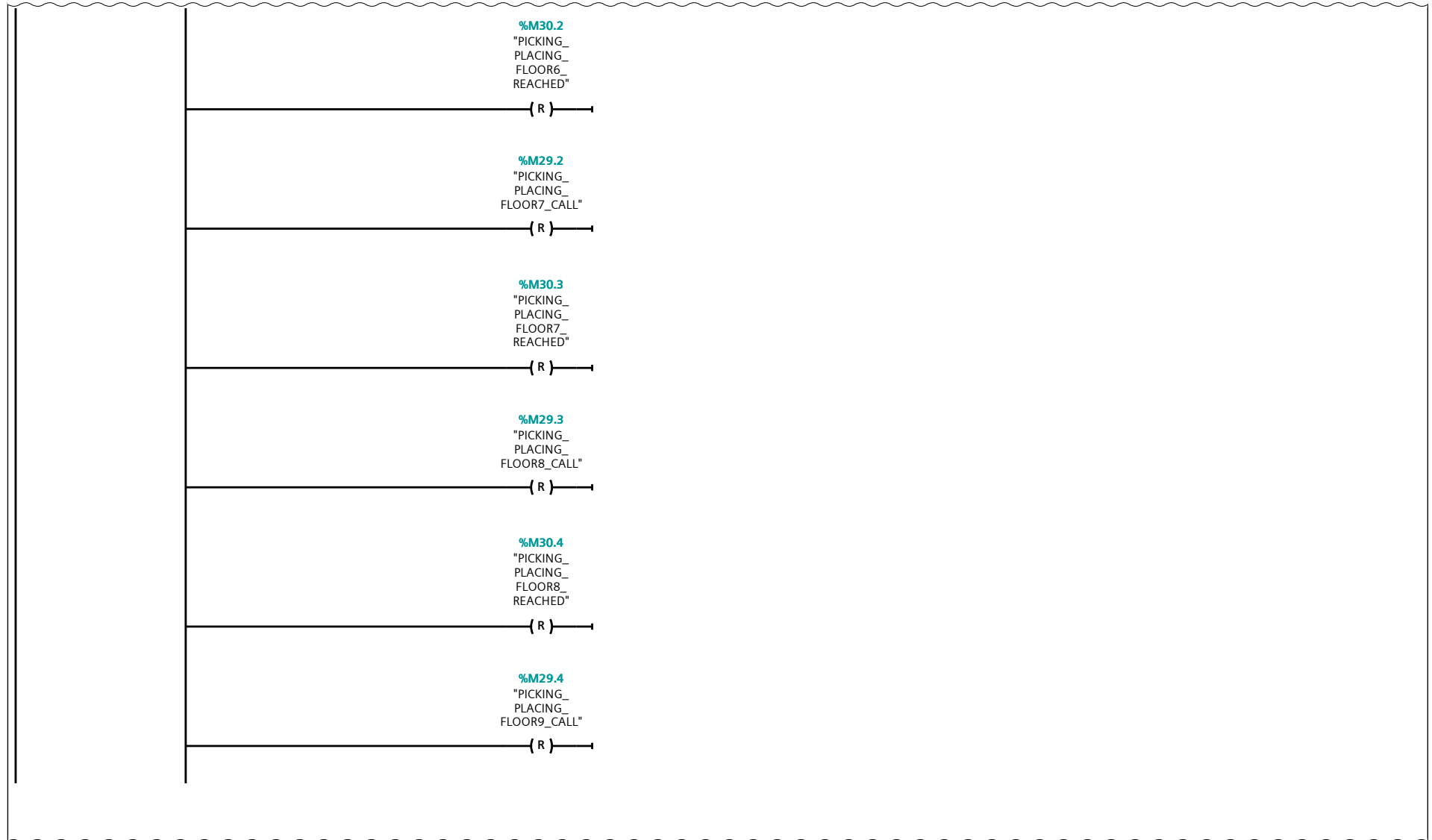
5.1 (Page1 - 43)

%M29.7
"PICKING_
PLACING_
FLOOR3_
REACHED"
(R)
%M28.7
"PICKING_
PLACING_
FLOOR4_CALL"
(R)
%M30.0
"PICKING_
PLACING_
FLOOR4_
REACHED"
(R)
%M29.0
"PICKING_
PLACING_
FLOOR5_CALL"
(R)
%M30.1
"PICKING_
PLACING_
FLOOR5_
REACHED"
(R)
%M29.1
"PICKING_
PLACING_
FLOOR6_CALL"
(R)

7.1 (Page1 - 45)

Network 90: PICKING_AUTO_CYCLE_RESET: (7.1 / 8.1)

6.1 (Page1 - 44)



8.1 (Page1 - 46)

Network 90: PICKING_AUTO_CYCLE_RESET: (8.1 / 8.1)

7.1 (Page1 - 45)

%M30.5
"PICKING_
PLACING_
FLOOR9_
REACHED"

(R)

%M33.2
"PICKING_
EXTRACTOR_
FWD2_REACHED"

(R)

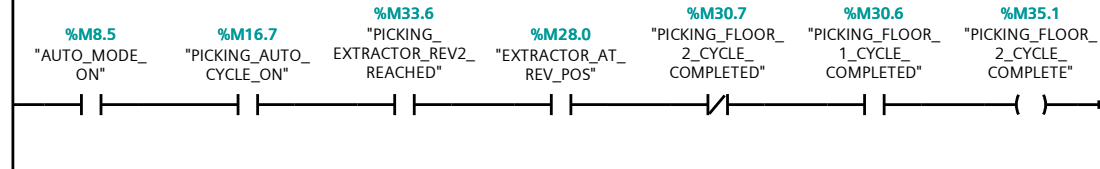
%M33.4
"PICKING_SWING_
ARM_OPENED"

(R)

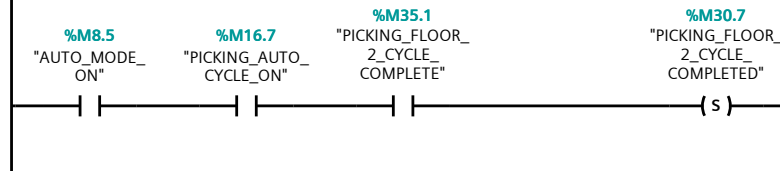
%M33.6
"PICKING_
EXTRACTOR_REV2_
REACHED"

(R)

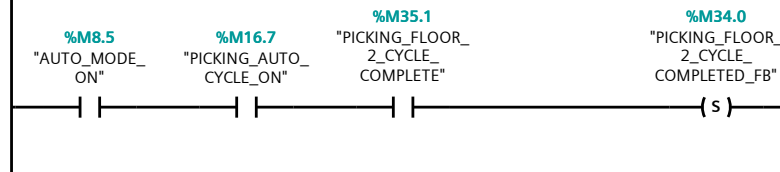
Network 91: PICKING_SECOND_FLOOR_CYCLE_COMPLETE:



Network 92: PICKING_SECOND_FLOOR_CYCLE_COMPLETED:

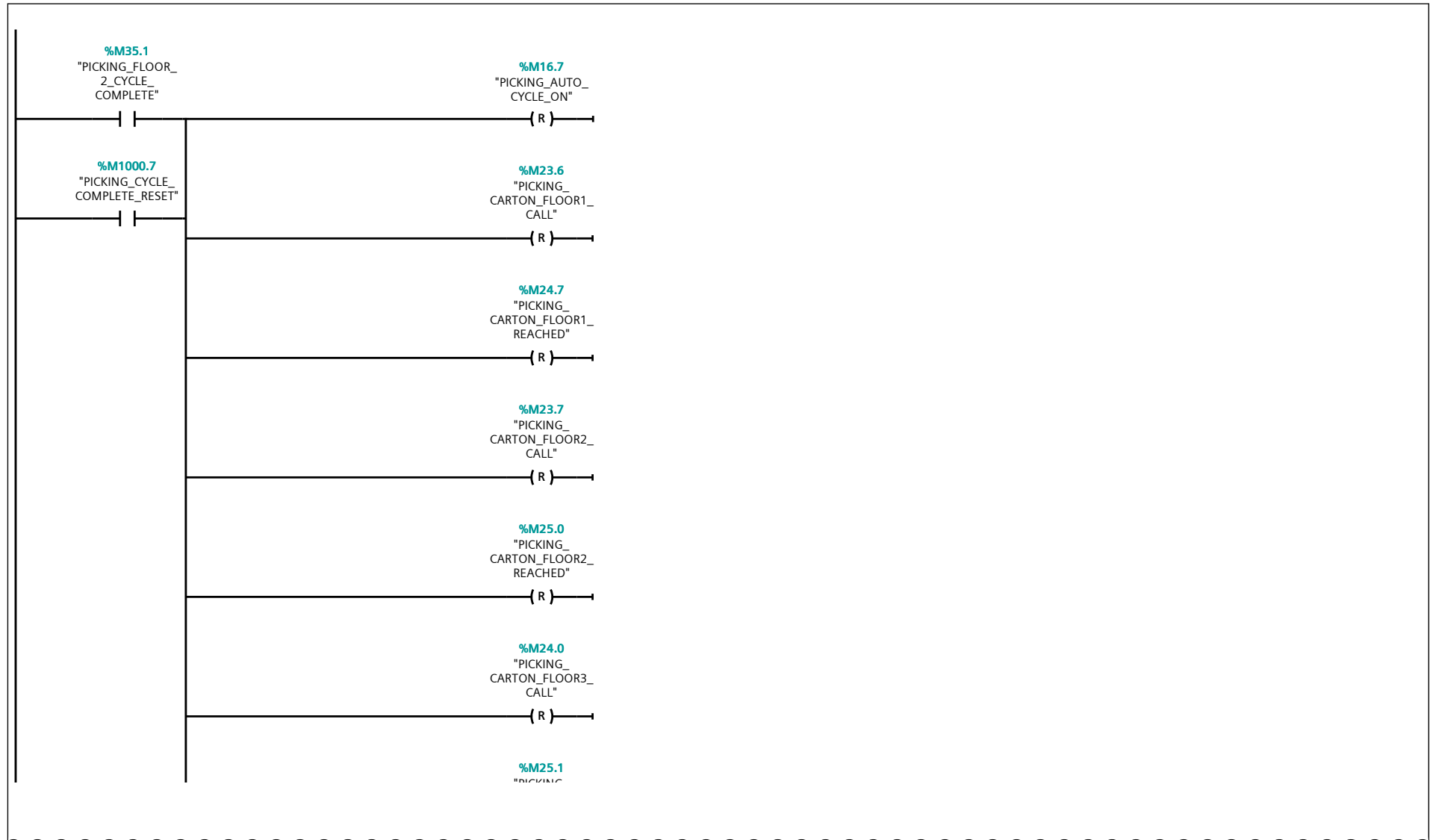


Network 93: PICKING_SECOND_FLOOR_CYCLE_COMPLETED_FB:



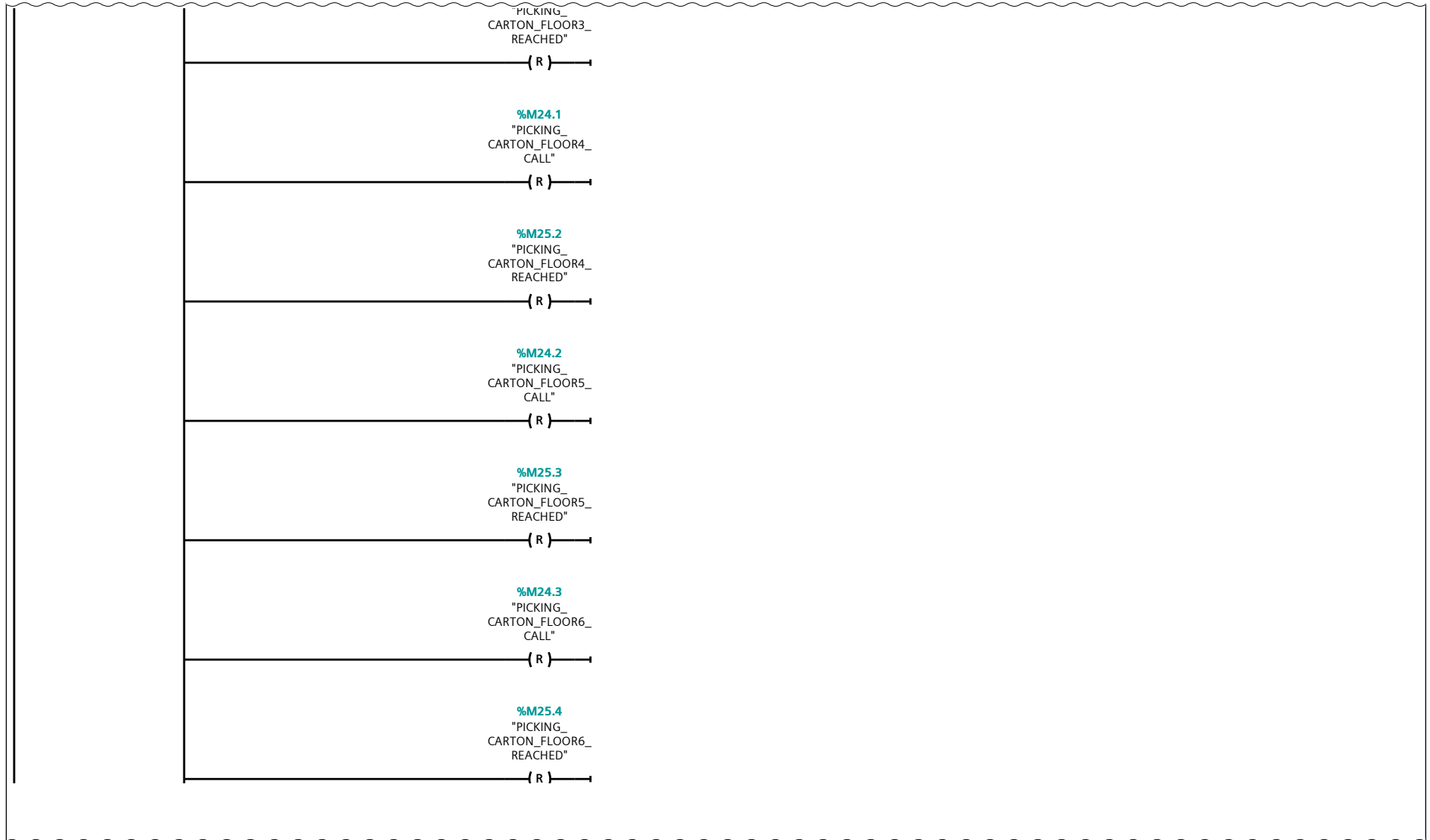
Network 94: PICKING_AUTO_CYCLE_RESET:

Network 94: PICKING_AUTO_CYCLE_RESET: (1.1 / 8.1)



Network 94: PICKING_AUTO_CYCLE_RESET: (2.1 / 8.1)

1.1 (Page1 - 48)



3.1 (Page1 - 50)

Network 94: PICKING_AUTO_CYCLE_RESET: (3.1 / 8.1)

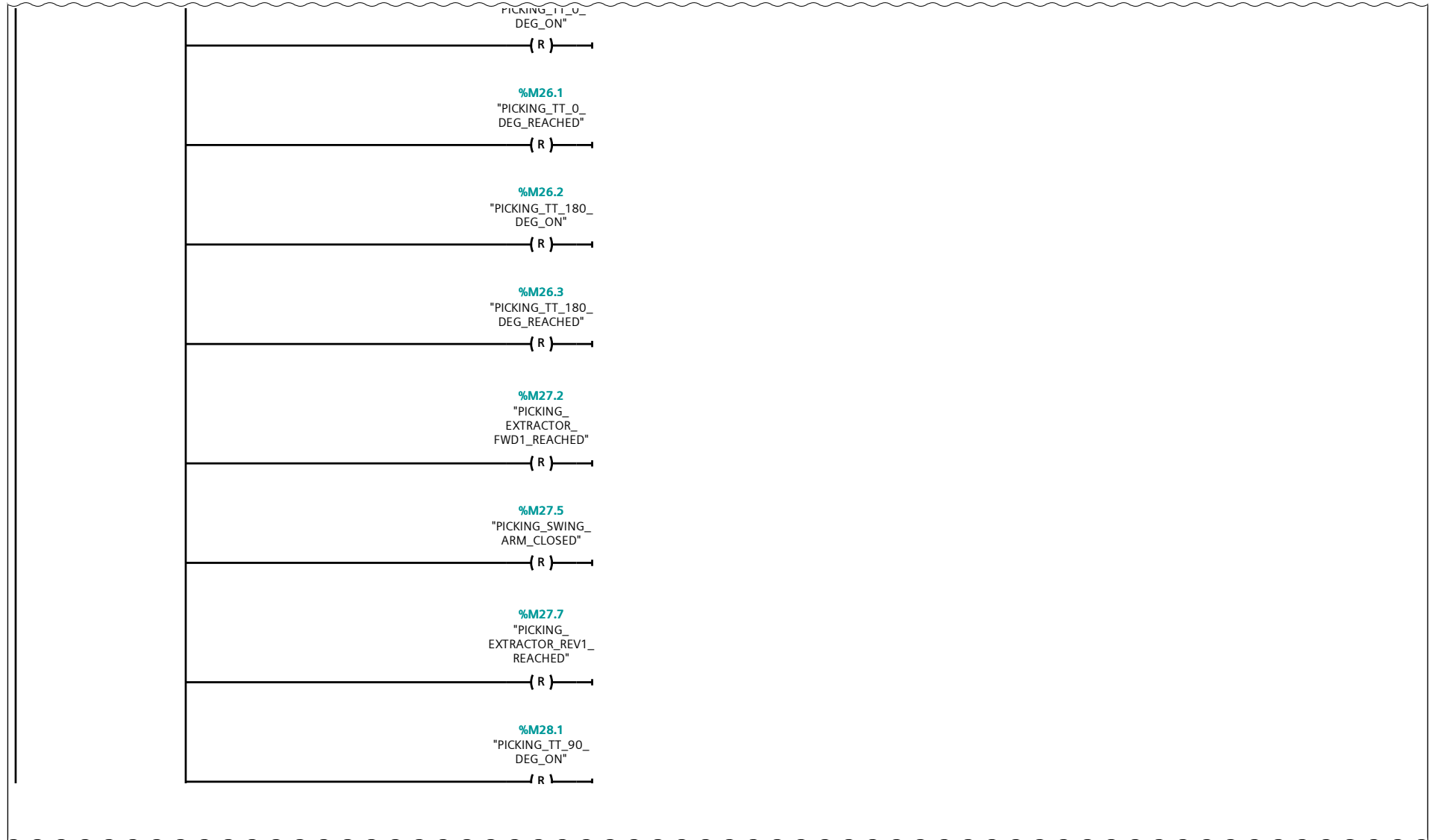
2.1 (Page1 - 49)



4.1 (Page1 - 51)

Network 94: PICKING_AUTO_CYCLE_RESET: (4.1 / 8.1)

3.1 (Page1 - 50)



5.1 (Page1 - 52)

Network 94: PICKING_AUTO_CYCLE_RESET: (5.1 / 8.1)

4.1 (Page1 - 51)

%M28.2
"PICKING_TT_90_
DEG_REACHED"

(R)

%M28.4
"PICKING_
PLACING_
FLOOR1_CALL"

(R)

%M29.5
"PICKING_
PLACING_
FLOOR1_
REACHED"

(R)

%M28.5
"PICKING_
PLACING_
FLOOR2_CALL"

(R)

%M29.6
"PICKING_
PLACING_
FLOOR2_
REACHED"

(R)

%M28.6
"PICKING_
PLACING_
FLOOR3_CALL"

(R)

6.1 (Page1 - 53)

Network 94: PICKING_AUTO_CYCLE_RESET: (6.1 / 8.1)

5.1 (Page1 - 52)

%M29.7
"PICKING_
PLACING_
FLOOR3_
REACHED"
(R)
%M28.7
"PICKING_
PLACING_
FLOOR4_CALL"
(R)
%M30.0
"PICKING_
PLACING_
FLOOR4_
REACHED"
(R)
%M29.0
"PICKING_
PLACING_
FLOOR5_CALL"
(R)
%M30.1
"PICKING_
PLACING_
FLOOR5_
REACHED"
(R)
%M29.1
"PICKING_
PLACING_
FLOOR6_CALL"
(R)

7.1 (Page1 - 54)

Network 94: PICKING_AUTO_CYCLE_RESET: (7.1 / 8.1)

6.1 (Page1 - 53)



8.1 (Page1 - 55)

Network 94: PICKING_AUTO_CYCLE_RESET: (8.1 / 8.1)

7.1 (Page1 - 54)

%M30.5
"PICKING_
PLACING_
FLOOR9_
REACHED"

(R)

%M33.2
"PICKING_
EXTRACTOR_
FWD2_REACHED"

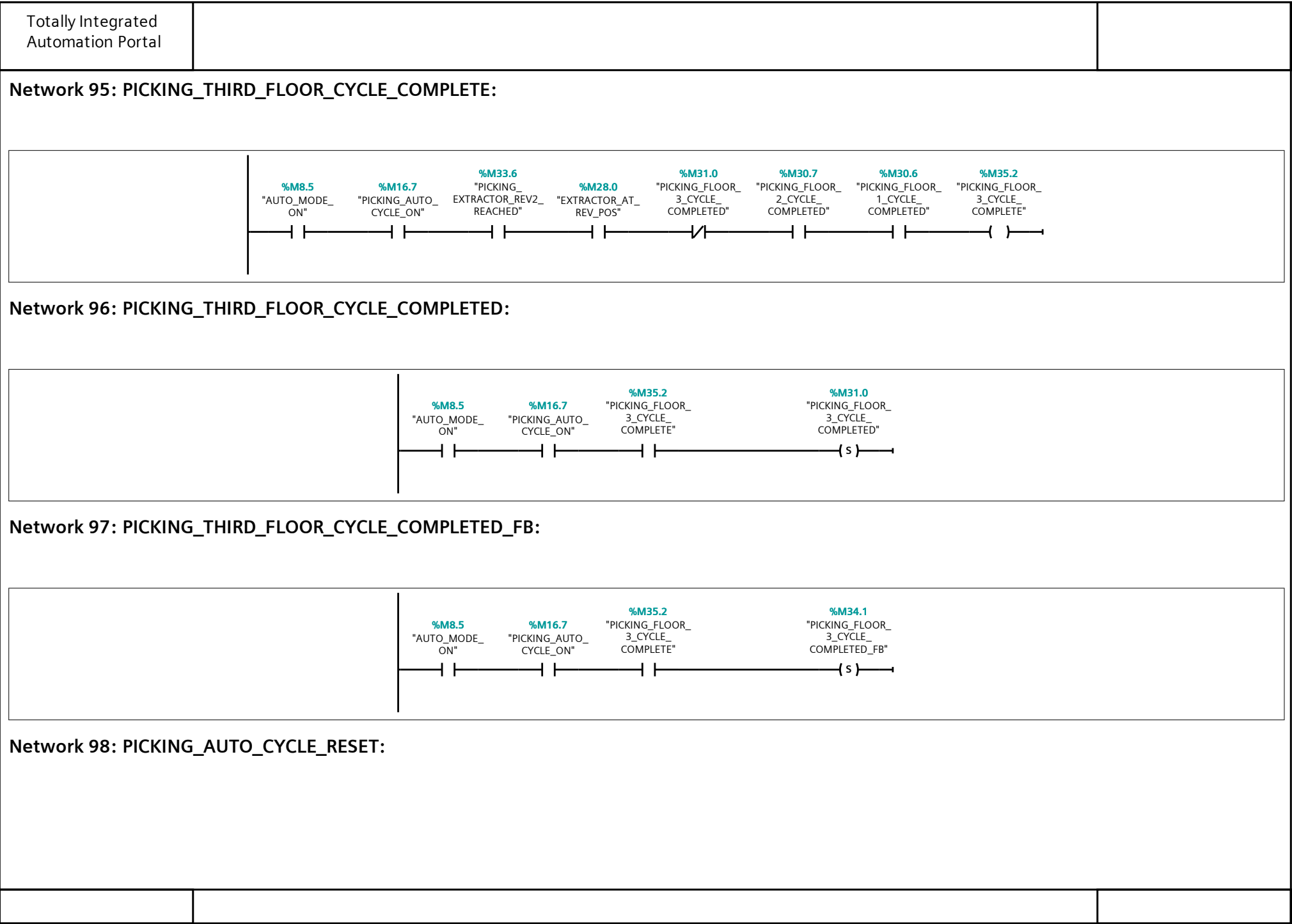
(R)

%M33.4
"PICKING_SWING_
ARM_OPENED"

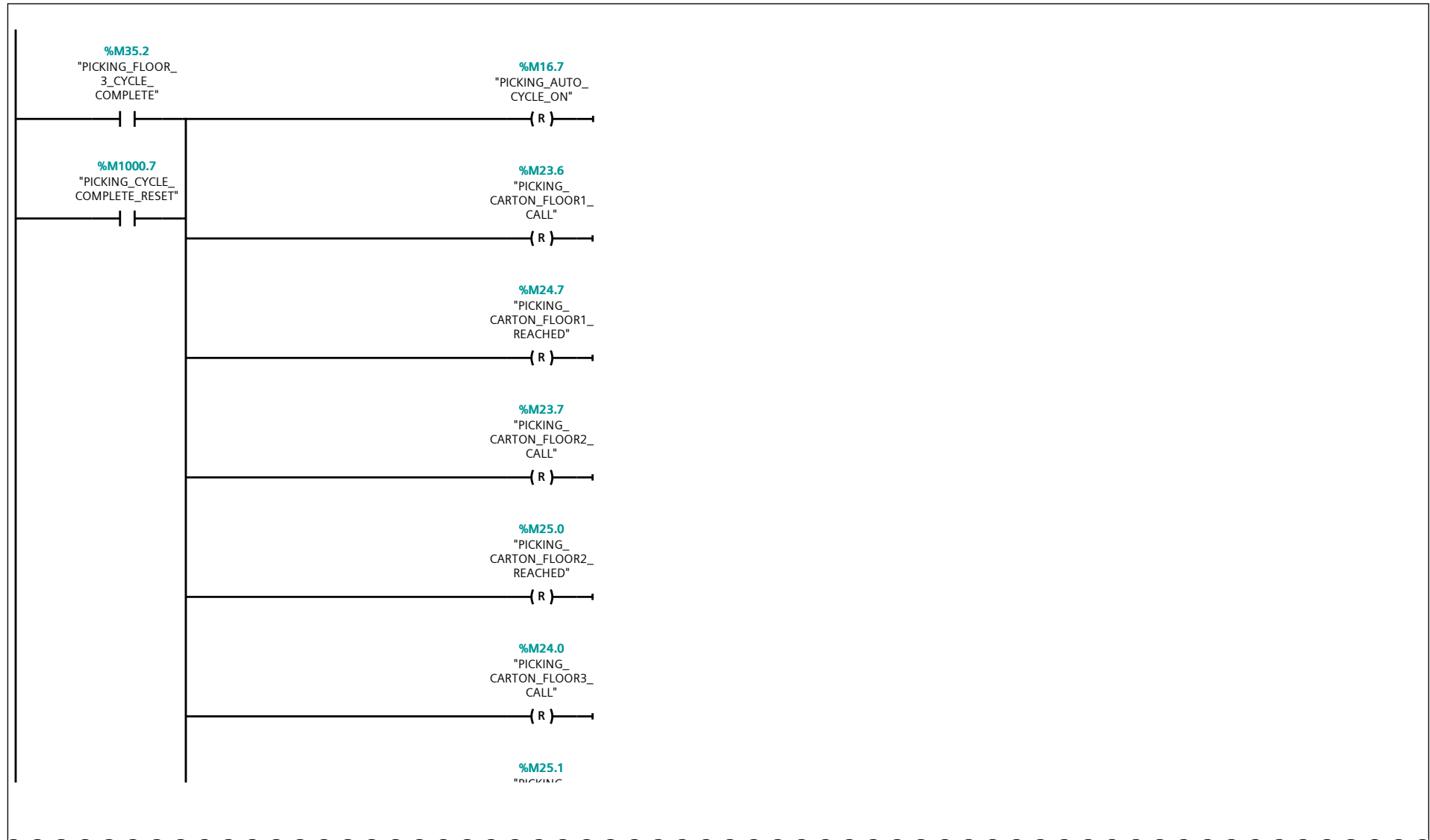
(R)

%M33.6
"PICKING_
EXTRACTOR_REV2_
REACHED"

(R)

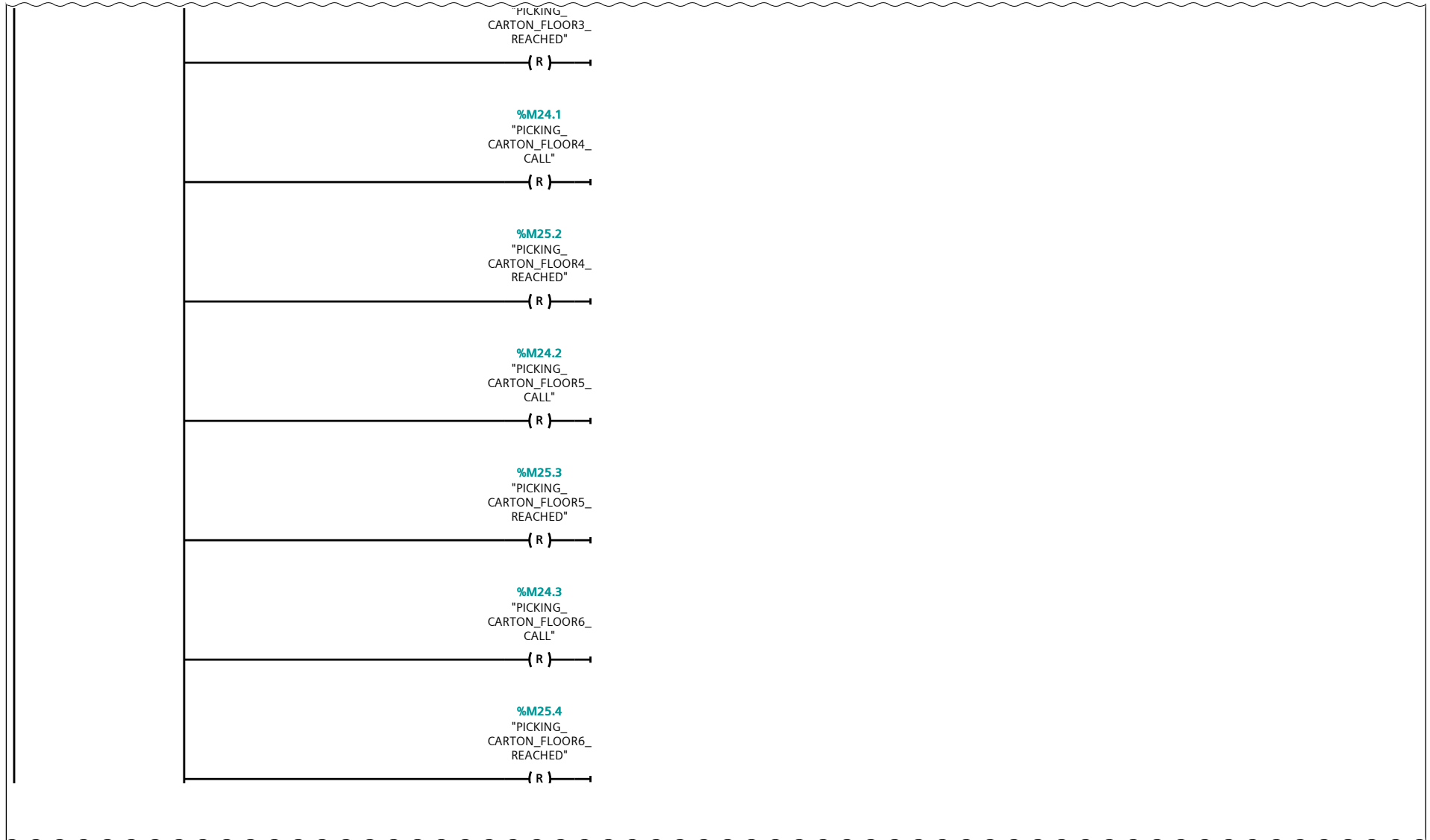


Network 98: PICKING_AUTO_CYCLE_RESET: (1.1 / 8.1)



Network 98: PICKING_AUTO_CYCLE_RESET: (2.1 / 8.1)

1.1 (Page1 - 57)



3.1 (Page1 - 59)

Network 98: PICKING_AUTO_CYCLE_RESET: (3.1 / 8.1)

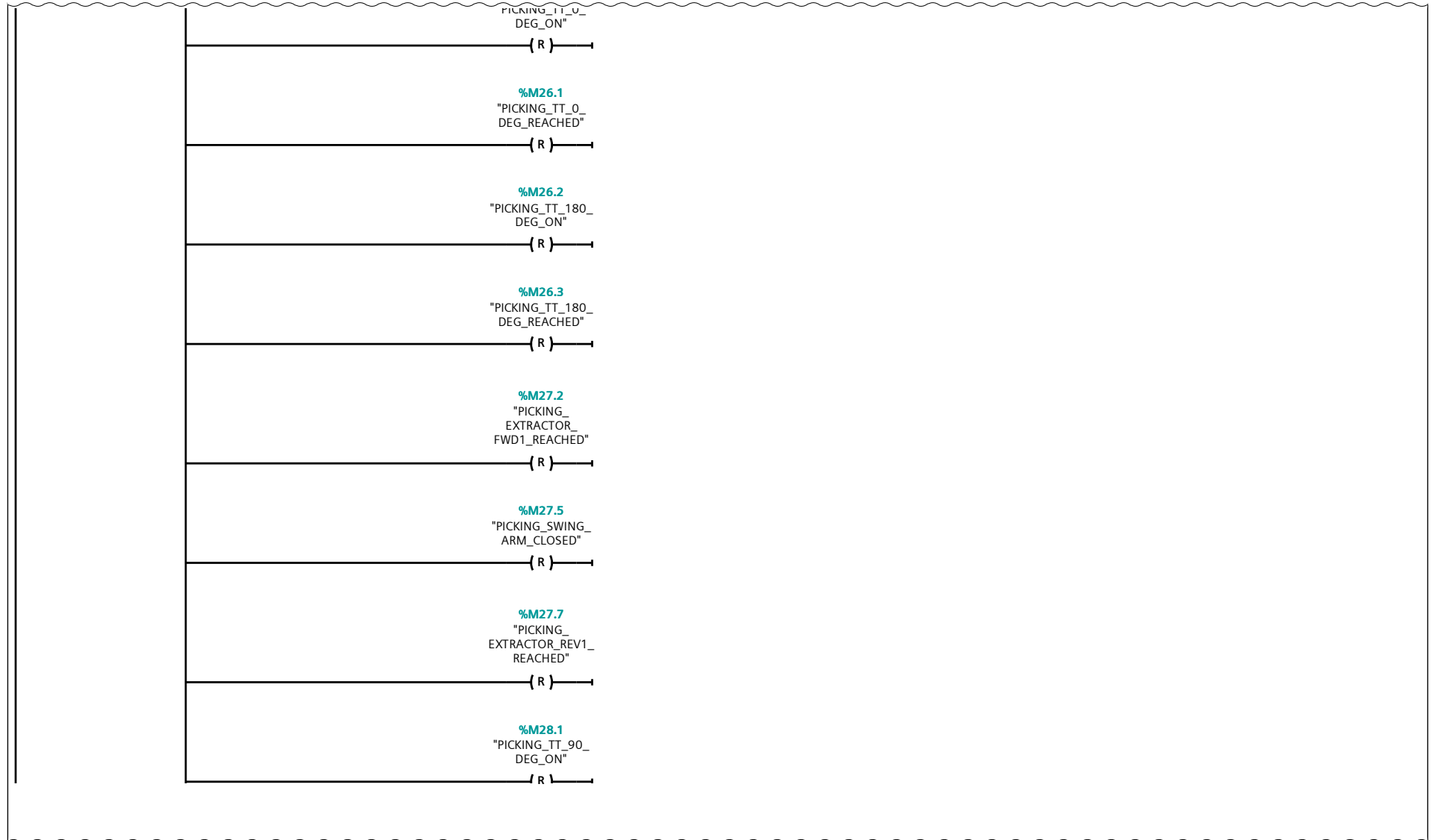
2.1 (Page1 - 58)



4.1 (Page1 - 60)

Network 98: PICKING_AUTO_CYCLE_RESET: (4.1 / 8.1)

3.1 (Page1 - 59)



5.1 (Page1 - 61)

Network 98: PICKING_AUTO_CYCLE_RESET: (5.1 / 8.1)

4.1 (Page1 - 60)

%M28.2
"PICKING_TT_90_
DEG_REACHED"

(R)

%M28.4
"PICKING_
PLACING_
FLOOR1_CALL"

(R)

%M29.5
"PICKING_
PLACING_
FLOOR1_
REACHED"

(R)

%M28.5
"PICKING_
PLACING_
FLOOR2_CALL"

(R)

%M29.6
"PICKING_
PLACING_
FLOOR2_
REACHED"

(R)

%M28.6
"PICKING_
PLACING_
FLOOR3_CALL"

(R)

6.1 (Page1 - 62)

Network 98: PICKING_AUTO_CYCLE_RESET: (6.1 / 8.1)

5.1 (Page1 - 61)

%M29.7
"PICKING_
PLACING_
FLOOR3_
REACHED"
(R)
%M28.7
"PICKING_
PLACING_
FLOOR4_CALL"
(R)
%M30.0
"PICKING_
PLACING_
FLOOR4_
REACHED"
(R)
%M29.0
"PICKING_
PLACING_
FLOOR5_CALL"
(R)
%M30.1
"PICKING_
PLACING_
FLOOR5_
REACHED"
(R)
%M29.1
"PICKING_
PLACING_
FLOOR6_CALL"
(R)

7.1 (Page1 - 63)

Network 98: PICKING_AUTO_CYCLE_RESET: (7.1 / 8.1)

6.1 (Page1 - 62)

%M30.2
"PICKING_
PLACING_
FLOOR6_
REACHED"
(R)
%M29.2
"PICKING_
PLACING_
FLOOR7_CALL"
(R)
%M30.3
"PICKING_
PLACING_
FLOOR7_
REACHED"
(R)
%M29.3
"PICKING_
PLACING_
FLOOR8_CALL"
(R)
%M30.4
"PICKING_
PLACING_
FLOOR8_
REACHED"
(R)
%M29.4
"PICKING_
PLACING_
FLOOR9_CALL"
(R)

8.1 (Page1 - 64)

Network 98: PICKING_AUTO_CYCLE_RESET: (8.1 / 8.1)

7.1 (Page1 - 63)

%M30.5
"PICKING_
PLACING_
FLOOR9_
REACHED"

(R)

%M33.2
"PICKING_
EXTRACTOR_
FWD2_REACHED"

(R)

%M33.4
"PICKING_SWING_
ARM_OPENED"

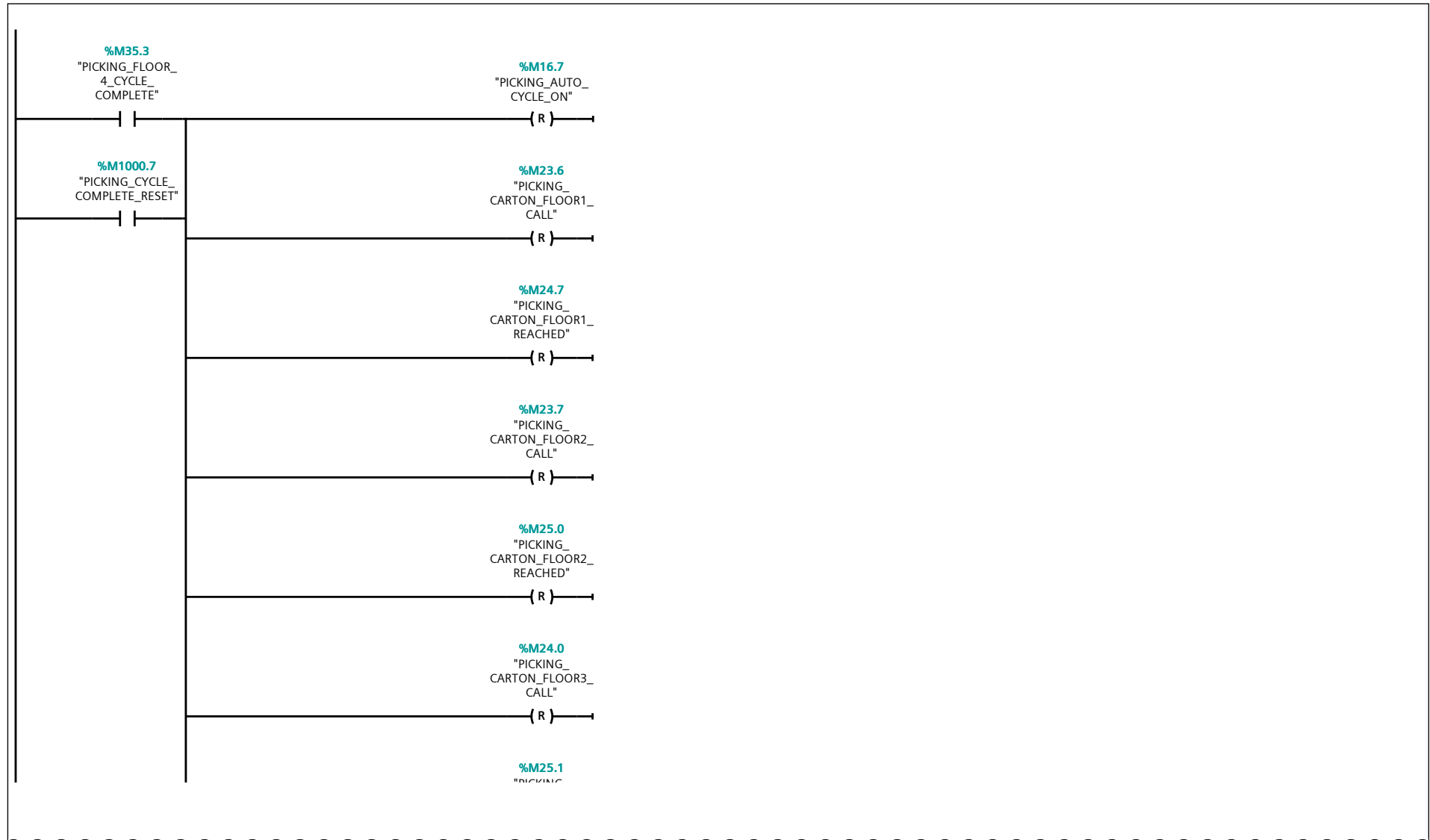
(R)

%M33.6
"PICKING_
EXTRACTOR_REV2_
REACHED"

(R)

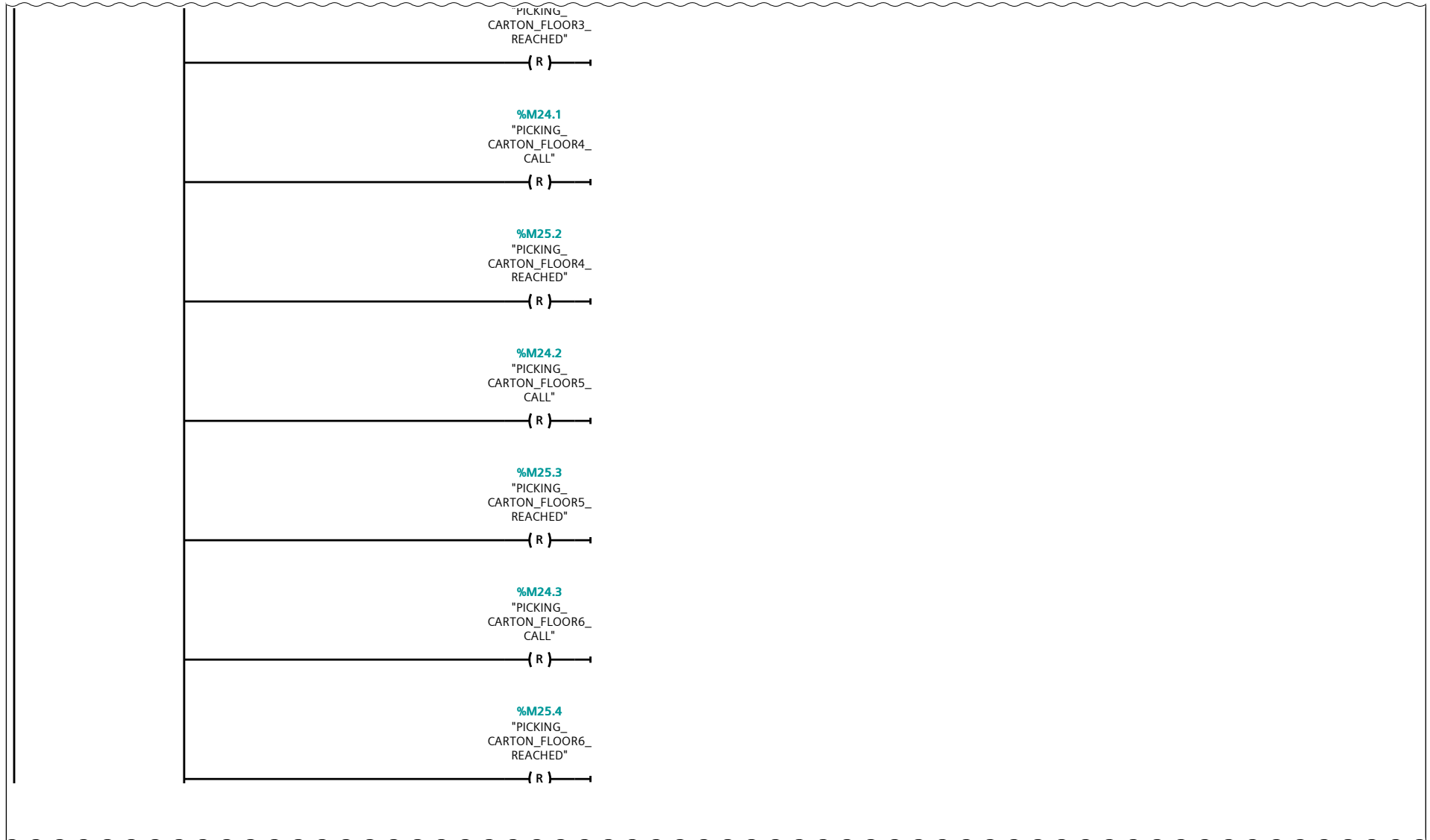
Totally Integrated Automation Portal		
Network 99: PICKING_FOURTH_FLOOR_CYCLE_COMPLETE:		
	<div><div></div><div><div><div><div>%M8.5 "AUTO_MODE_ON"</div><div>%M16.7 "PICKING_AUTO_CYCLE_ON"</div><div>%M33.6 "PICKING_EXTRACTOR_REV2_REACHED"</div><div>%M28.0 "EXTRACTOR_AT_REV_POS"</div><div>%M31.1 "PICKING_FLOOR_4_CYCLE_COMPLETED"</div><div>%M31.0 "PICKING_FLOOR_3_CYCLE_COMPLETED"</div><div>%M30.7 "PICKING_FLOOR_2_CYCLE_COMPLETED"</div><div>%M30.6 "PICKING_FLOOR_1_CYCLE_COMPLETED"</div><div>%M35.3 "PICKING_FLOOR_4_CYCLE_COMPLETE"</div></div></div><div></div></div></div>	
Network 100: PICKING_FOURTH_FLOOR_CYCLE_COMPLETED:		
	<div><div></div><div><div><div><div>%M8.5 "AUTO_MODE_ON"</div><div>%M16.7 "PICKING_AUTO_CYCLE_ON"</div><div>%M35.3 "PICKING_FLOOR_4_CYCLE_COMPLETE"</div><div>%M31.1 "PICKING_FLOOR_4_CYCLE_COMPLETED"</div></div></div><div></div><div>{ s }</div></div></div>	
Network 101: PICKING_FOURTH_FLOOR_CYCLE_COMPLETED_FB:		
	<div><div></div><div><div><div><div>%M8.5 "AUTO_MODE_ON"</div><div>%M16.7 "PICKING_AUTO_CYCLE_ON"</div><div>%M35.3 "PICKING_FLOOR_4_CYCLE_COMPLETE"</div><div>%M34.2 "PICKING_FLOOR_4_CYCLE_COMPLETED_FB"</div></div></div><div></div><div>{ s }</div></div></div>	
Network 102: PICKING_AUTO_CYCLE_RESET:		

Network 102: PICKING_AUTO_CYCLE_RESET: (1.1 / 8.1)



Network 102: PICKING_AUTO_CYCLE_RESET: (2.1 / 8.1)

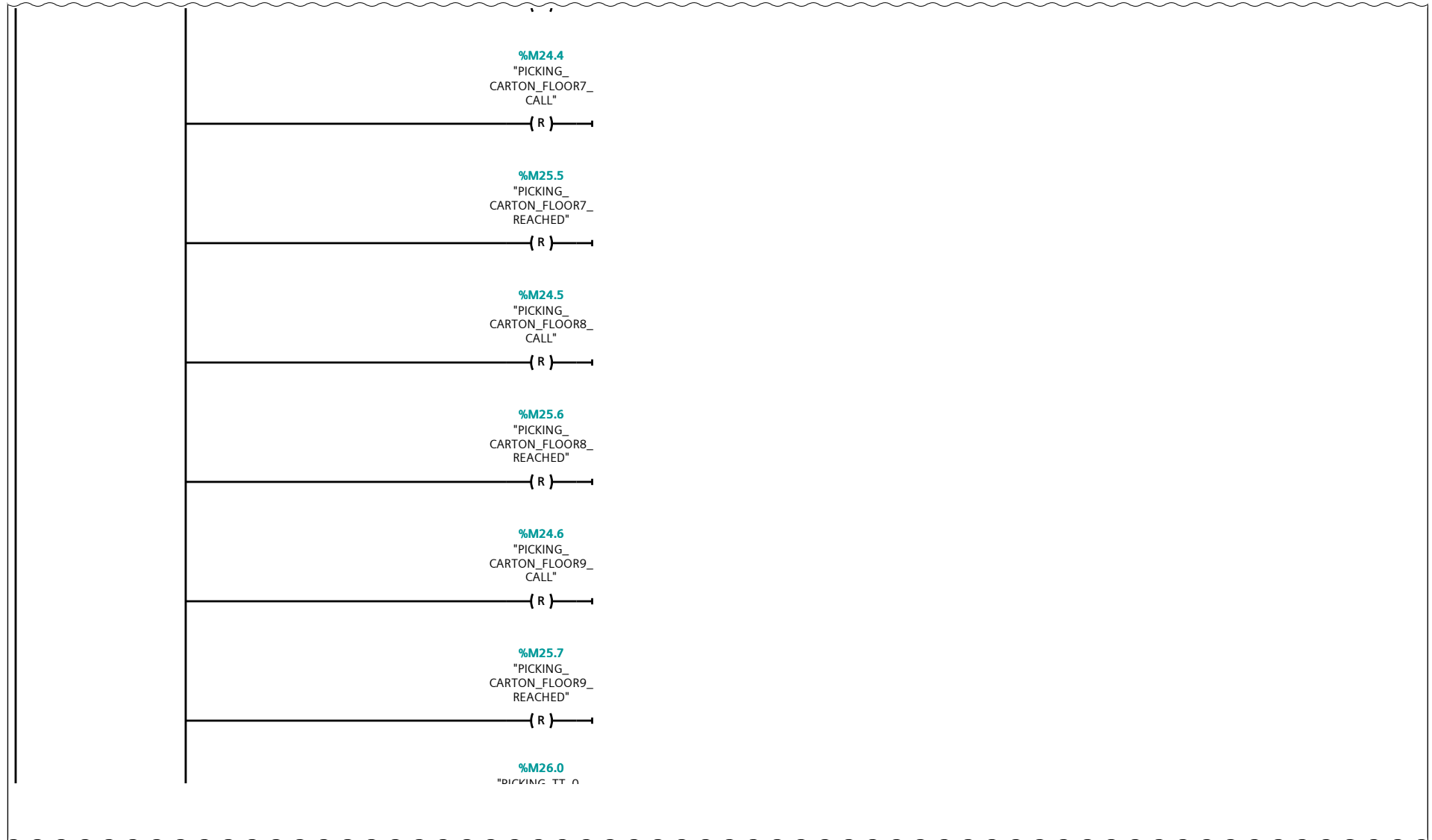
1.1 (Page1 - 66)



3.1 (Page1 - 68)

Network 102: PICKING_AUTO_CYCLE_RESET: (3.1 / 8.1)

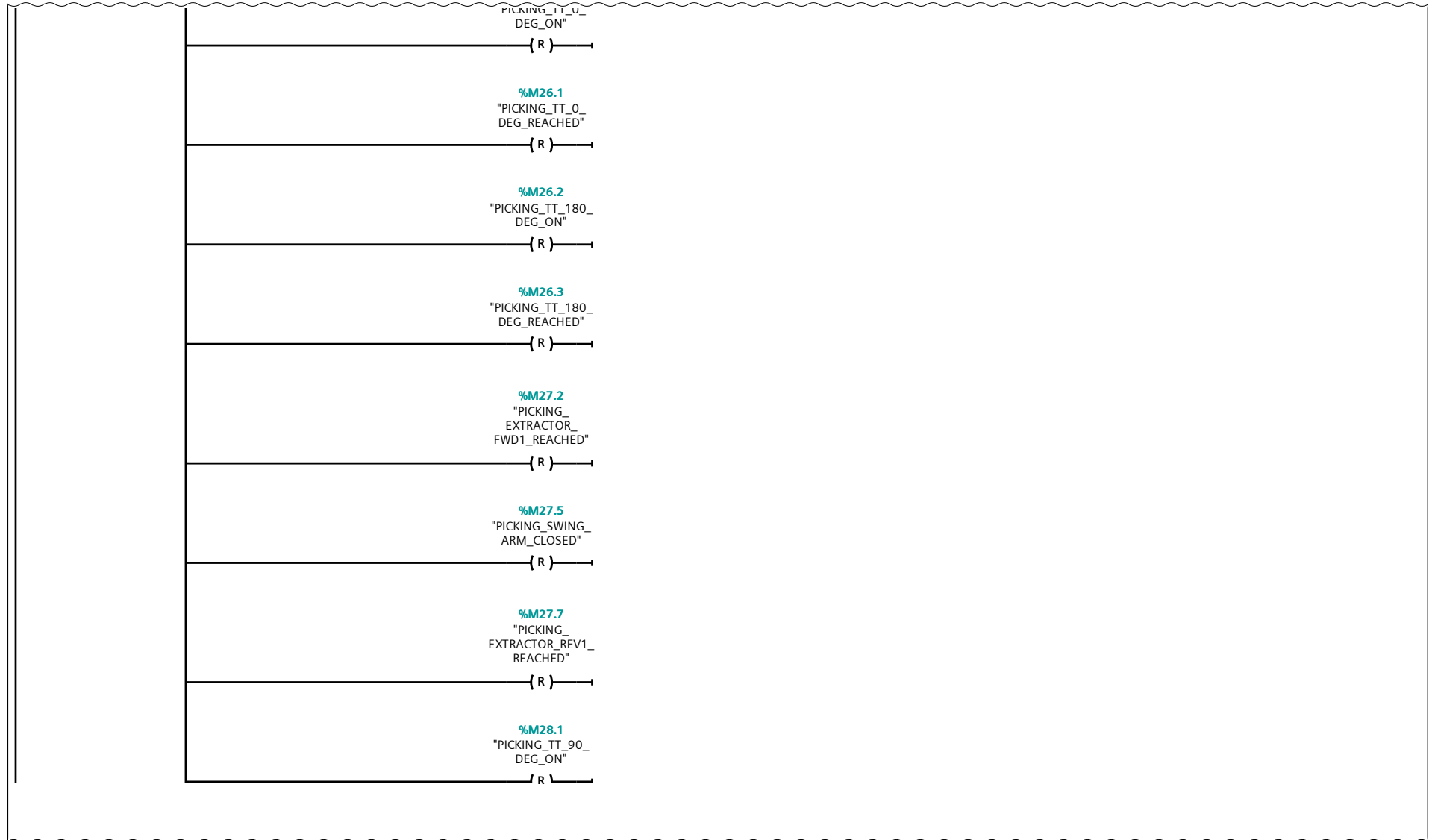
2.1 (Page1 - 67)



4.1 (Page1 - 69)

Network 102: PICKING_AUTO_CYCLE_RESET: (4.1 / 8.1)

3.1 (Page1 - 68)



5.1 (Page1 - 70)

Network 102: PICKING_AUTO_CYCLE_RESET: (5.1 / 8.1)

4.1 (Page1 - 69)

%M28.2
"PICKING_TT_90_
DEG_REACHED"

(R)

%M28.4
"PICKING_
PLACING_
FLOOR1_CALL"

(R)

%M29.5
"PICKING_
PLACING_
FLOOR1_
REACHED"

(R)

%M28.5
"PICKING_
PLACING_
FLOOR2_CALL"

(R)

%M29.6
"PICKING_
PLACING_
FLOOR2_
REACHED"

(R)

%M28.6
"PICKING_
PLACING_
FLOOR3_CALL"

(R)

6.1 (Page1 - 71)

Network 102: PICKING_AUTO_CYCLE_RESET: (6.1 / 8.1)

5.1 (Page1 - 70)

%M29.7
"PICKING_
PLACING_
FLOOR3_
REACHED"

(R)

%M28.7
"PICKING_
PLACING_
FLOOR4_CALL"

(R)

%M30.0
"PICKING_
PLACING_
FLOOR4_
REACHED"

(R)

%M29.0
"PICKING_
PLACING_
FLOOR5_CALL"

(R)

%M30.1
"PICKING_
PLACING_
FLOOR5_
REACHED"

(R)

%M29.1
"PICKING_
PLACING_
FLOOR6_CALL"

(R)

7.1 (Page1 - 72)

Network 102: PICKING_AUTO_CYCLE_RESET: (7.1 / 8.1)

6.1 (Page1 - 71)

%M30.2
"PICKING_
PLACING_
FLOOR6_
REACHED"
(R)
%M29.2
"PICKING_
PLACING_
FLOOR7_CALL"
(R)
%M30.3
"PICKING_
PLACING_
FLOOR7_
REACHED"
(R)
%M29.3
"PICKING_
PLACING_
FLOOR8_CALL"
(R)
%M30.4
"PICKING_
PLACING_
FLOOR8_
REACHED"
(R)
%M29.4
"PICKING_
PLACING_
FLOOR9_CALL"
(R)

8.1 (Page1 - 73)

Network 102: PICKING_AUTO_CYCLE_RESET: (8.1 / 8.1)

7.1 (Page1 - 72)

%M30.5
"PICKING_
PLACING_
FLOOR9_
REACHED"

(R)

%M33.2
"PICKING_
EXTRACTOR_
FWD2_REACHED"

(R)

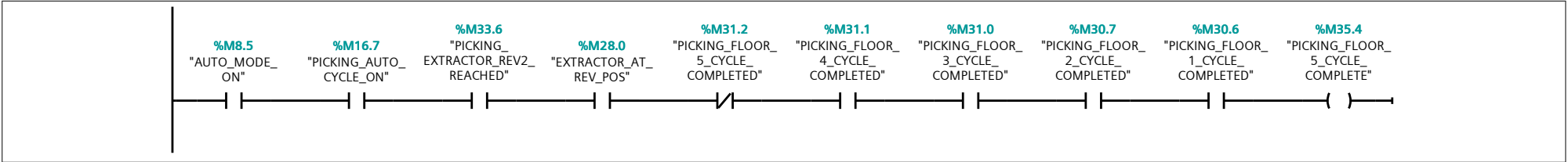
%M33.4
"PICKING_SWING_
ARM_OPENED"

(R)

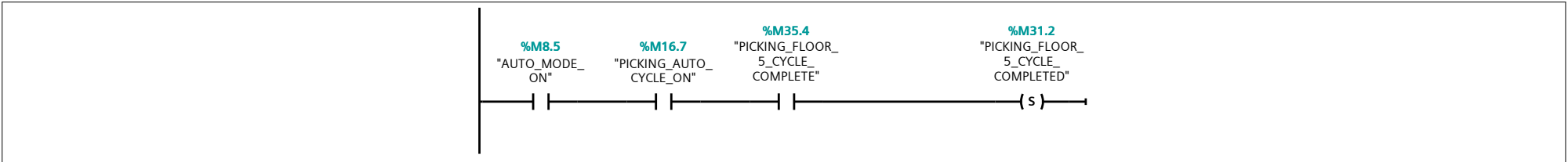
%M33.6
"PICKING_
EXTRACTOR_REV2_
REACHED"

(R)

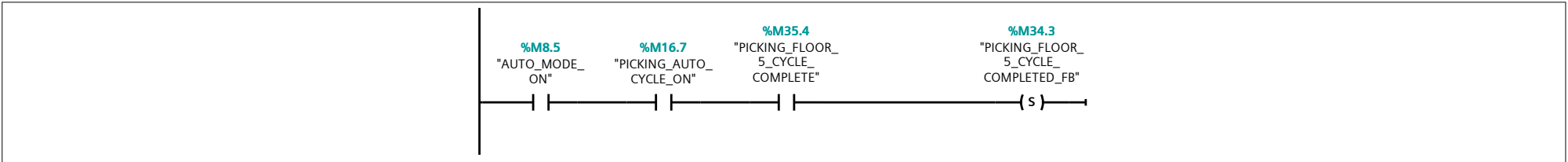
Network 103: PICKING_FIFTH_FLOOR_CYCLE_COMPLETE:



Network 104: PICKING_FIFTH_FLOOR_CYCLE_COMPLETED:

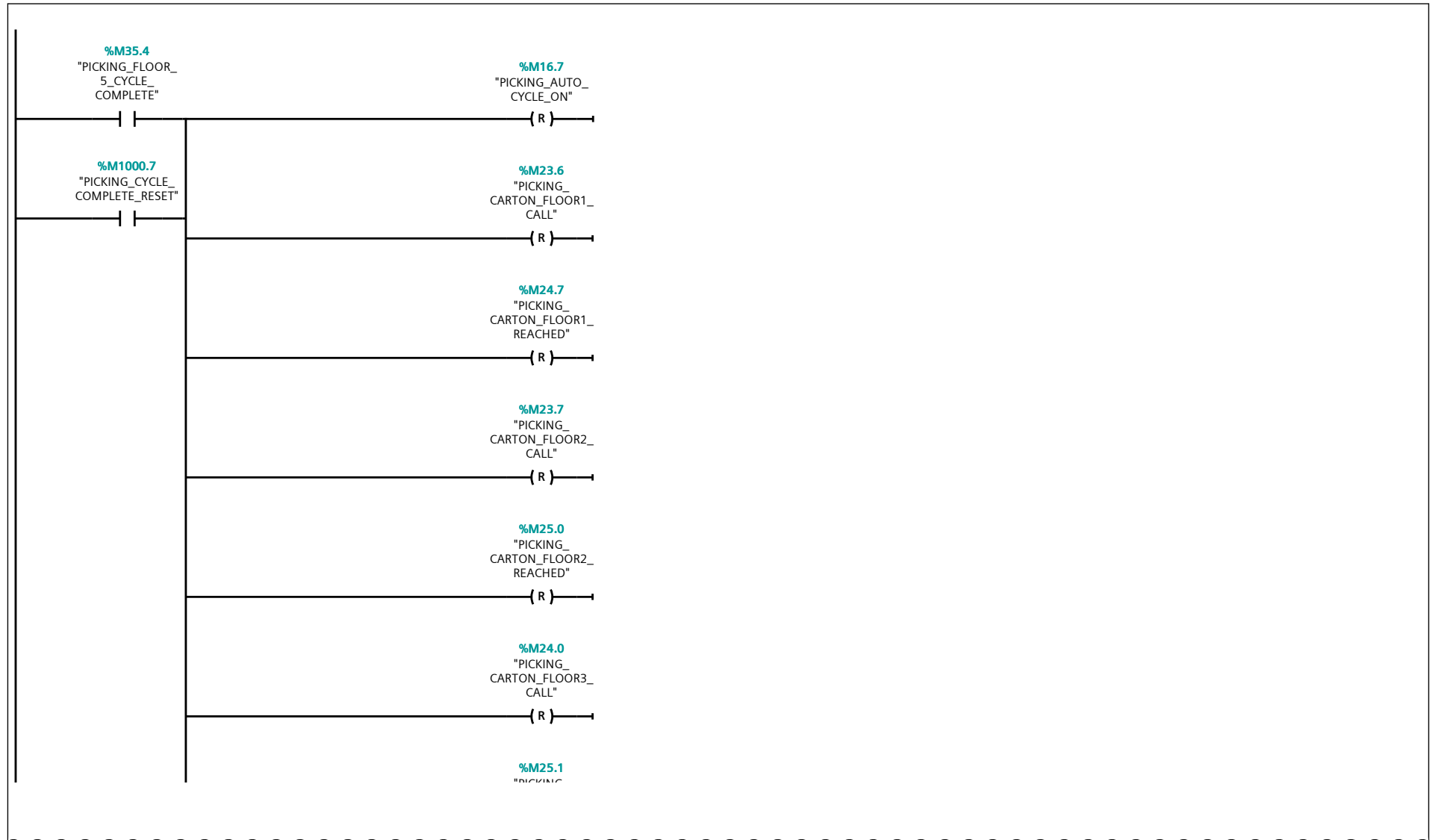


Network 105: PICKING_FIFTH_FLOOR_CYCLE_COMPLETED_FB:



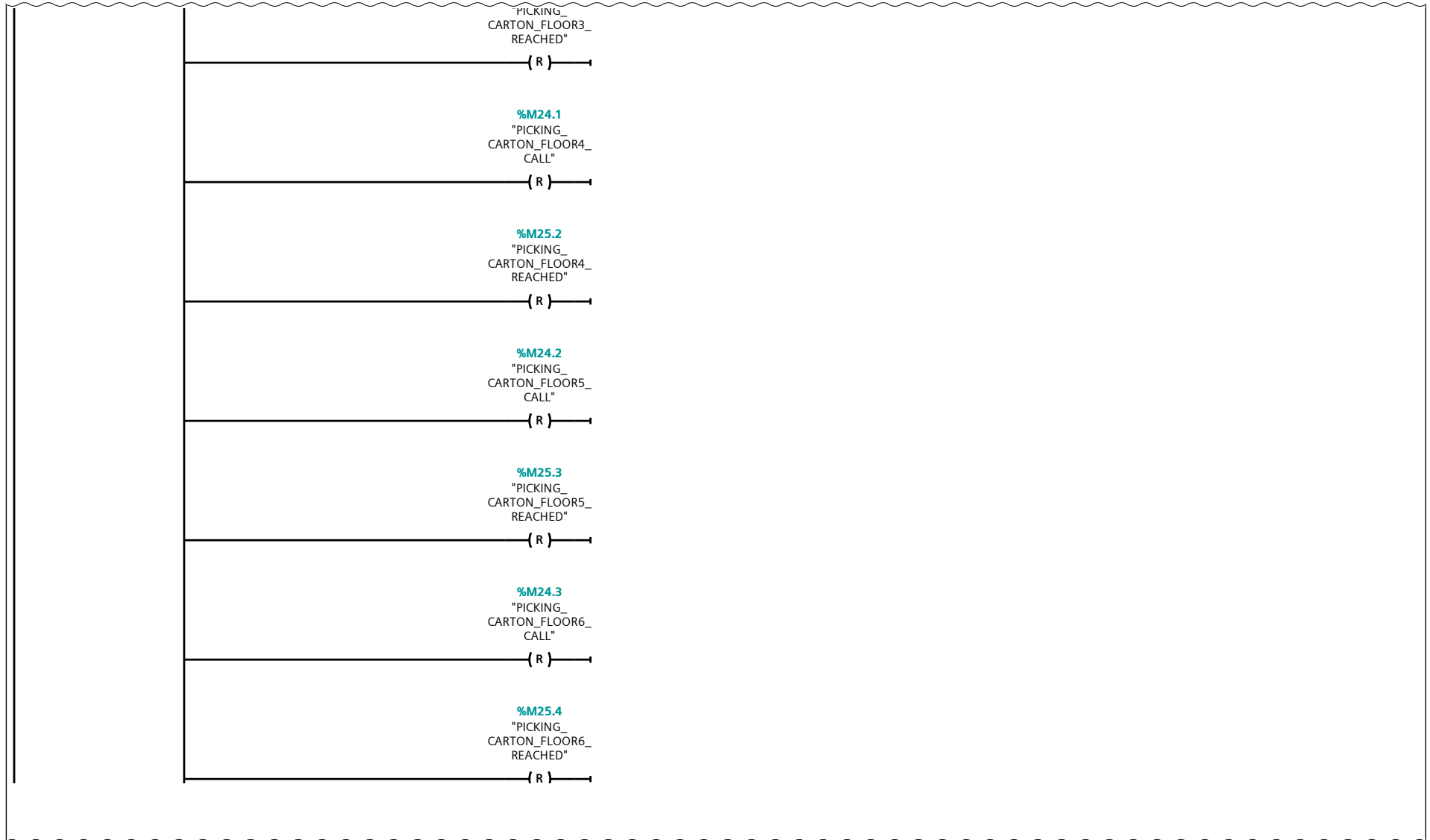
Network 106: PICKING_AUTO_CYCLE_RESET:

Network 106: PICKING_AUTO_CYCLE_RESET: (1.1 / 8.1)



Network 106: PICKING_AUTO_CYCLE_RESET: (2.1 / 8.1)

1.1 (Page1 - 75)



3.1 (Page1 - 77)

Network 106: PICKING_AUTO_CYCLE_RESET: (3.1 / 8.1)

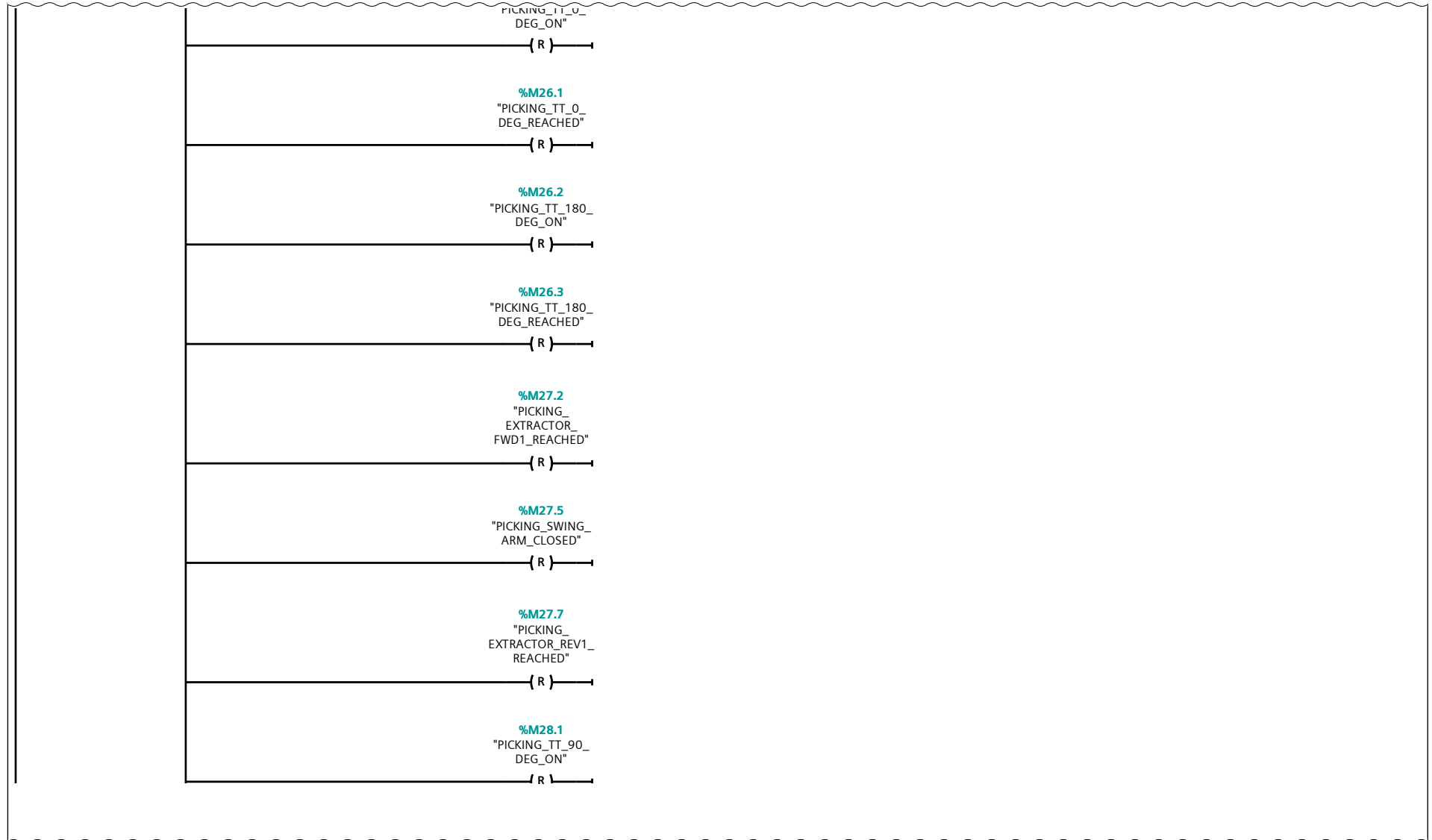
2.1 (Page1 - 76)



4.1 (Page1 - 78)

Network 106: PICKING_AUTO_CYCLE_RESET: (4.1 / 8.1)

3.1 (Page1 - 77)



5.1 (Page1 - 79)

Network 106: PICKING_AUTO_CYCLE_RESET: (5.1 / 8.1)

4.1 (Page1 - 78)

%M28.2
"PICKING_TT_90_
DEG_REACHED"

(R)

%M28.4
"PICKING_
PLACING_
FLOOR1_CALL"

(R)

%M29.5
"PICKING_
PLACING_
FLOOR1_
REACHED"

(R)

%M28.5
"PICKING_
PLACING_
FLOOR2_CALL"

(R)

%M29.6
"PICKING_
PLACING_
FLOOR2_
REACHED"

(R)

%M28.6
"PICKING_
PLACING_
FLOOR3_CALL"

(R)

6.1 (Page1 - 80)

Network 106: PICKING_AUTO_CYCLE_RESET: (6.1 / 8.1)

5.1 (Page1 - 79)

%M29.7
"PICKING_
PLACING_
FLOOR3_
REACHED"
(R)
%M28.7
"PICKING_
PLACING_
FLOOR4_CALL"
(R)
%M30.0
"PICKING_
PLACING_
FLOOR4_
REACHED"
(R)
%M29.0
"PICKING_
PLACING_
FLOOR5_CALL"
(R)
%M30.1
"PICKING_
PLACING_
FLOOR5_
REACHED"
(R)
%M29.1
"PICKING_
PLACING_
FLOOR6_CALL"
(R)

7.1 (Page1 - 81)

Network 106: PICKING_AUTO_CYCLE_RESET: (7.1 / 8.1)

6.1 (Page1 - 80)

%M30.2
"PICKING_
PLACING_
FLOOR6_
REACHED"

(R)

%M29.2
"PICKING_
PLACING_
FLOOR7_CALL"

(R)

%M30.3
"PICKING_
PLACING_
FLOOR7_
REACHED"

(R)

%M29.3
"PICKING_
PLACING_
FLOOR8_CALL"

(R)

%M30.4
"PICKING_
PLACING_
FLOOR8_
REACHED"

(R)

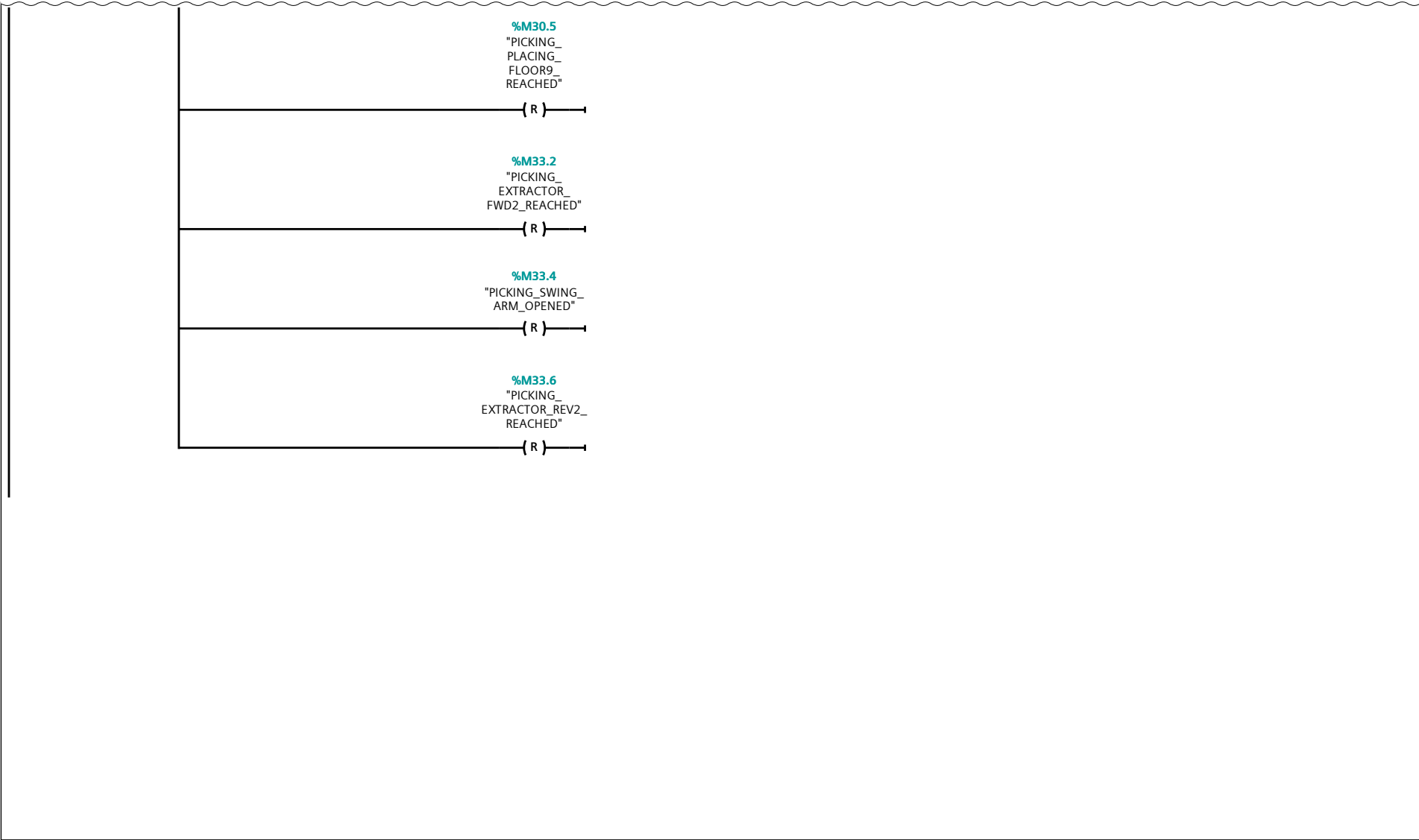
%M29.4
"PICKING_
PLACING_
FLOOR9_CALL"

(R)

8.1 (Page1 - 82)

Network 106: PICKING_AUTO_CYCLE_RESET: (8.1 / 8.1)

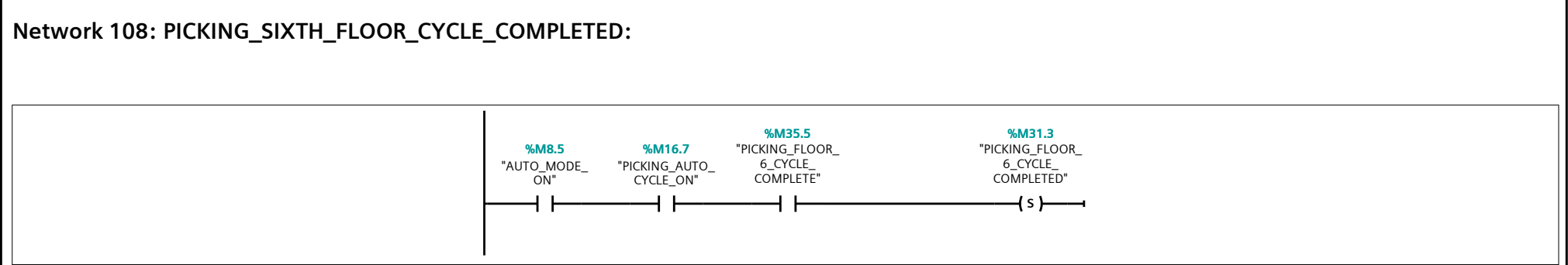
7.1 (Page1 - 81)



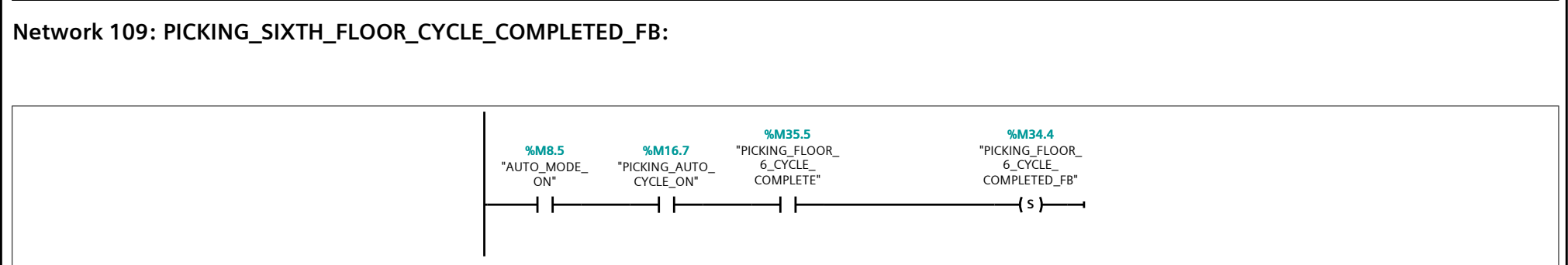
Network 107: PICKING_SIXTH_FLOOR_CYCLE_COMPLETE:

The diagram illustrates the sequence of events for Network 107: PICKING_SIXTH_FLOOR_CYCLE_COMPLETE. The events are as follows:

- %M8.5 "AUTO_MODE_ON"
- %M16.7 "PICKING_AUTO_CYCLE_ON"
- %M33.6 "PICKING_EXTRACTOR_REV2_REACHED"
- %M28.0 "EXTRACTOR_AT_REV_POS"
- %M31.3 "PICKING_FLOOR_6_CYCLE_COMPLETED"
- %M31.2 "PICKING_FLOOR_5_CYCLE_COMPLETED"
- %M31.1 "PICKING_FLOOR_4_CYCLE_COMPLETED"
- %M31.0 "PICKING_FLOOR_3_CYCLE_COMPLETED"
- %M30.7 "PICKING_FLOOR_2_CYCLE_COMPLETED"
- %M30.6 "PICKING_FLOOR_1_CYCLE_COMPLETED"
- %M35.5 "PICKING_FLOOR_6_CYCLE_COMPLETE"



Timing diagram for the 'PICKING_FLOOR_6_CYCLE_COMPLETE' signal. The diagram shows a sequence of events: 'AUTO_MODE_ON' (M8.5) occurs, followed by 'PICKING_AUTO_CYCLE_ON' (M16.7), then 'PICKING_FLOOR_6_CYCLE_COMPLETE' (M35.5), and finally 'PICKING_FLOOR_6_CYCLE_COMPLETED' (M31.3). A time scale bar at the bottom indicates a duration of 1 second.



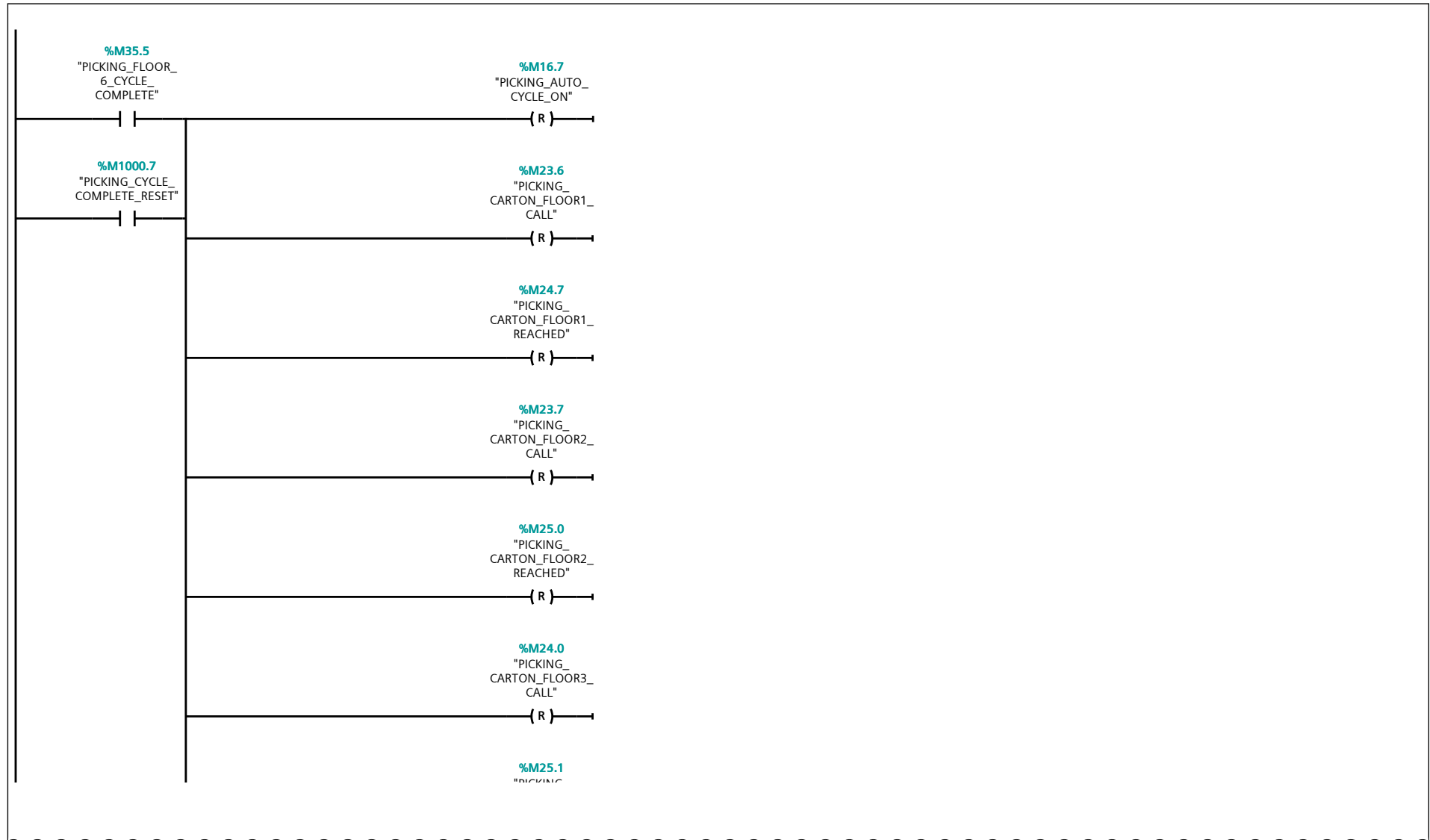
Timing diagram for the sequence of events in the "PICKING_FLOOR_6_CYCLE_COMPLETE" state:

- %M8.5 "AUTO_MODE_ON"
- %M16.7 "PICKING_AUTO_CYCLE_ON"
- %M35.5 "PICKING_FLOOR_6_CYCLE_COMPLETE"
- %M34.4 "PICKING_FLOOR_6_CYCLE_COMPLETED_FB"



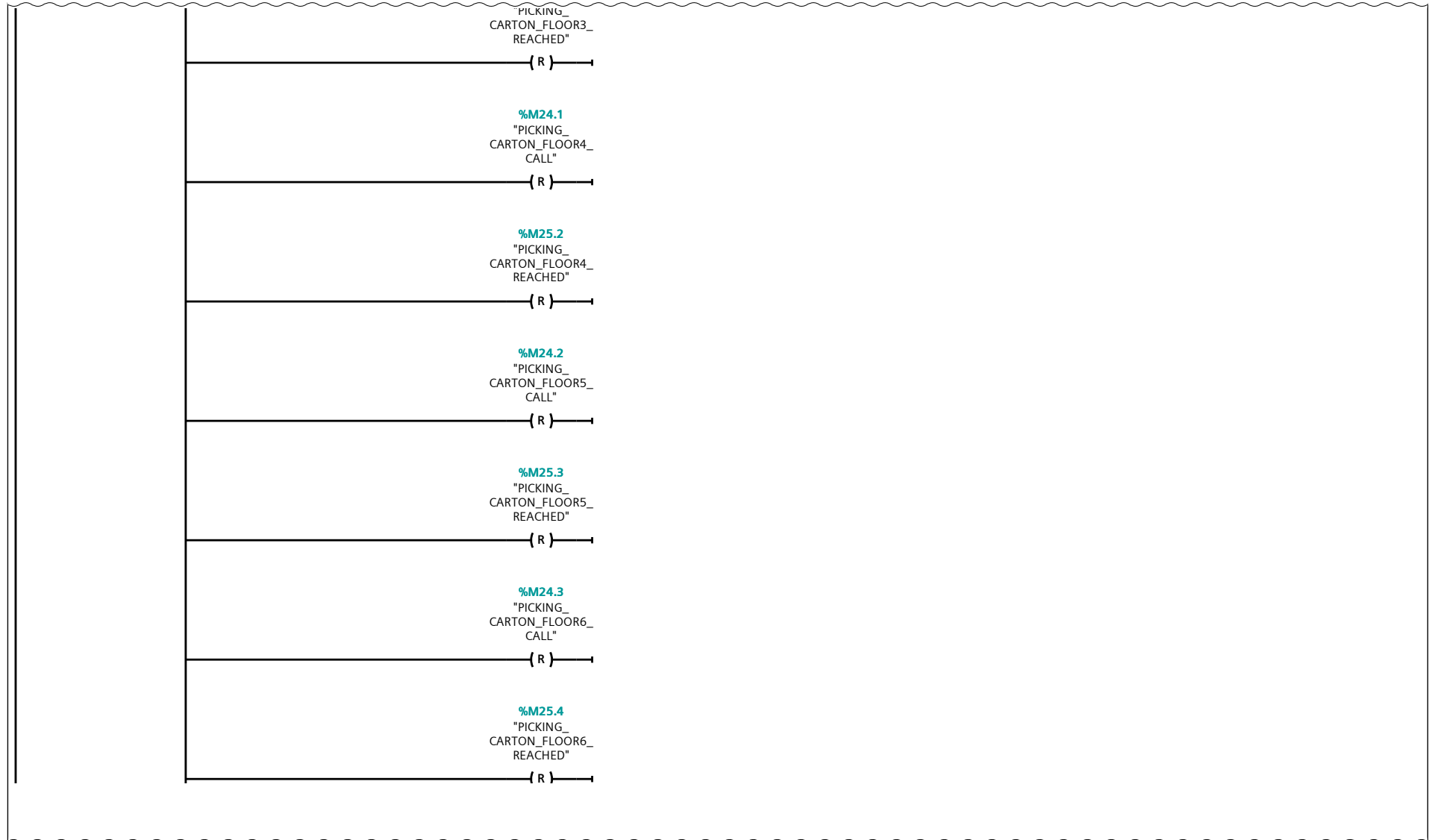
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Network 110: PICKING_AUTO_CYCLE_RESET: (1.1 / 8.1)



Network 110: PICKING_AUTO_CYCLE_RESET: (2.1 / 8.1)

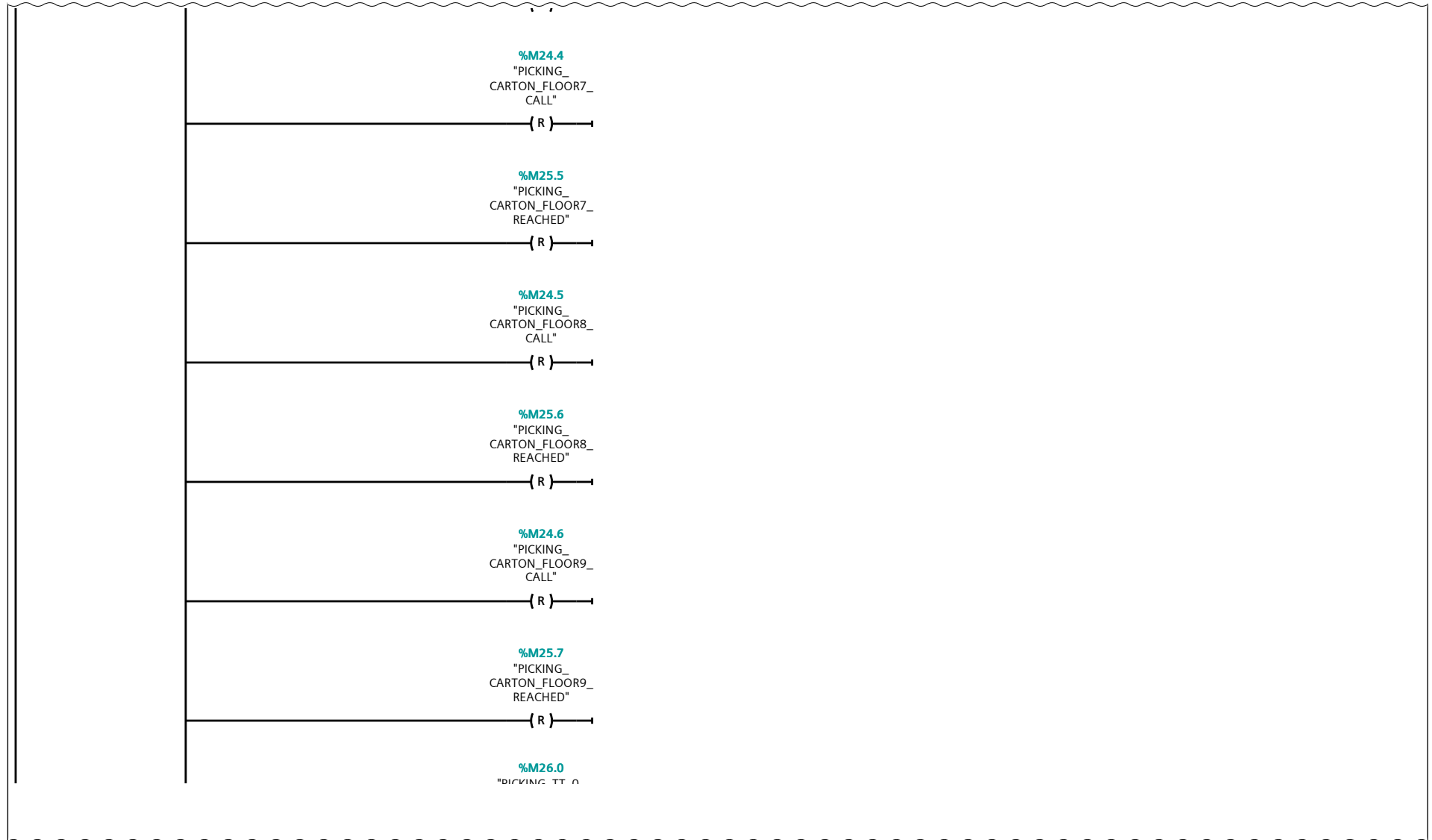
1.1 (Page1 - 84)



3.1 (Page1 - 86)

Network 110: PICKING_AUTO_CYCLE_RESET: (3.1 / 8.1)

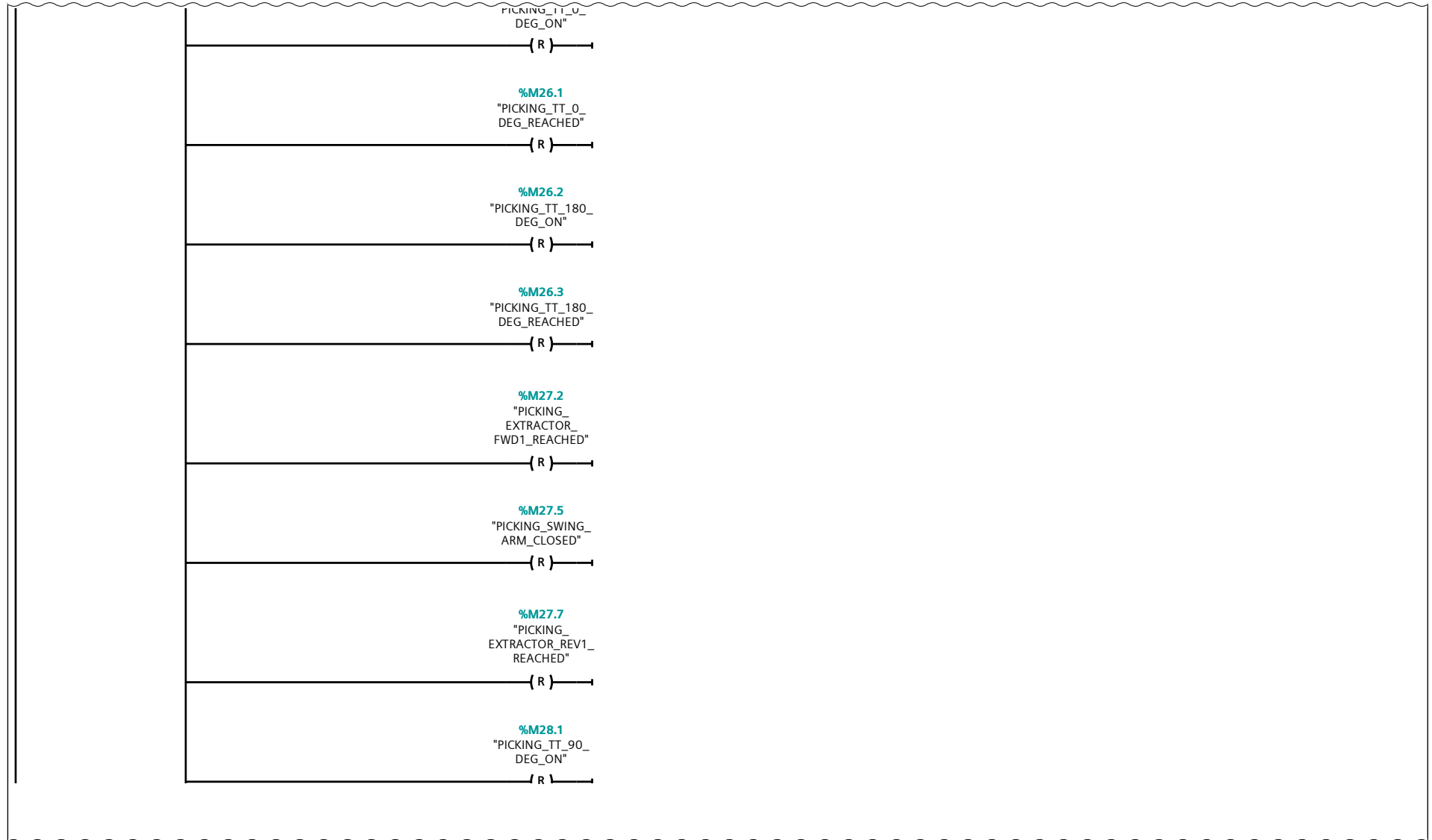
2.1 (Page1 - 85)



4.1 (Page1 - 87)

Network 110: PICKING_AUTO_CYCLE_RESET: (4.1 / 8.1)

3.1 (Page1 - 86)



5.1 (Page1 - 88)

Network 110: PICKING_AUTO_CYCLE_RESET: (5.1 / 8.1)

4.1 (Page1 - 87)

%M28.2
"PICKING_TT_90_
DEG_REACHED"

(R)

%M28.4
"PICKING_
PLACING_
FLOOR1_CALL"

(R)

%M29.5
"PICKING_
PLACING_
FLOOR1_
REACHED"

(R)

%M28.5
"PICKING_
PLACING_
FLOOR2_CALL"

(R)

%M29.6
"PICKING_
PLACING_
FLOOR2_
REACHED"

(R)

%M28.6
"PICKING_
PLACING_
FLOOR3_CALL"

(R)

6.1 (Page1 - 89)

Network 110: PICKING_AUTO_CYCLE_RESET: (6.1 / 8.1)

5.1 (Page1 - 88)

%M29.7
"PICKING_
PLACING_
FLOOR3_
REACHED"
(R)
%M28.7
"PICKING_
PLACING_
FLOOR4_CALL"
(R)
%M30.0
"PICKING_
PLACING_
FLOOR4_
REACHED"
(R)
%M29.0
"PICKING_
PLACING_
FLOOR5_CALL"
(R)
%M30.1
"PICKING_
PLACING_
FLOOR5_
REACHED"
(R)
%M29.1
"PICKING_
PLACING_
FLOOR6_CALL"
(R)

7.1 (Page1 - 90)

Network 110: PICKING_AUTO_CYCLE_RESET: (7.1 / 8.1)

6.1 (Page1 - 89)

%M30.2
"PICKING_
PLACING_
FLOOR6_
REACHED"

(R)

%M29.2
"PICKING_
PLACING_
FLOOR7_CALL"

(R)

%M30.3
"PICKING_
PLACING_
FLOOR7_
REACHED"

(R)

%M29.3
"PICKING_
PLACING_
FLOOR8_CALL"

(R)

%M30.4
"PICKING_
PLACING_
FLOOR8_
REACHED"

(R)

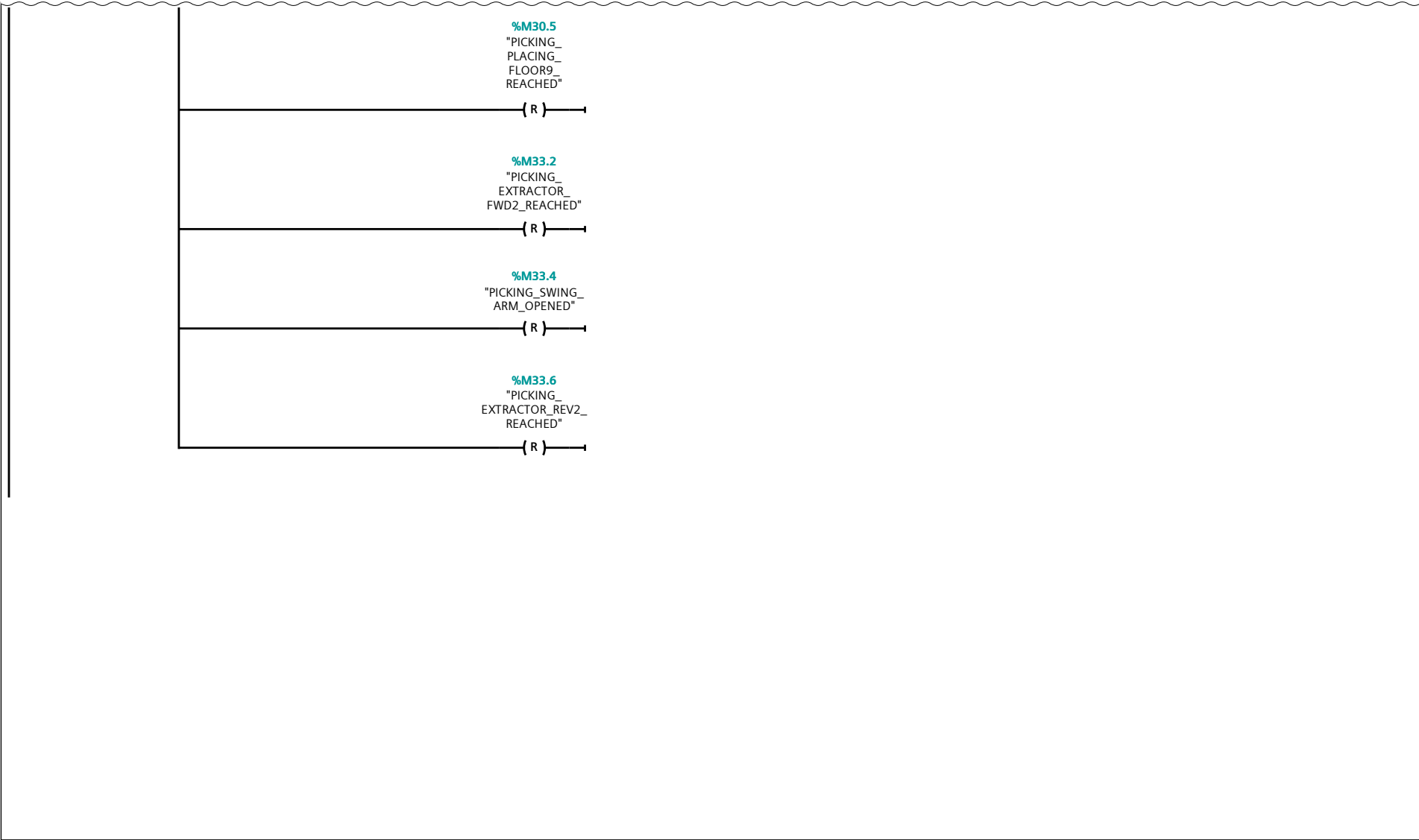
%M29.4
"PICKING_
PLACING_
FLOOR9_CALL"

(R)

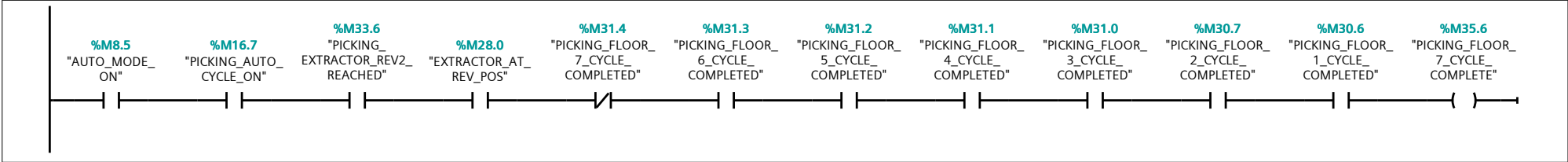
8.1 (Page1 - 91)

Network 110: PICKING_AUTO_CYCLE_RESET: (8.1 / 8.1)

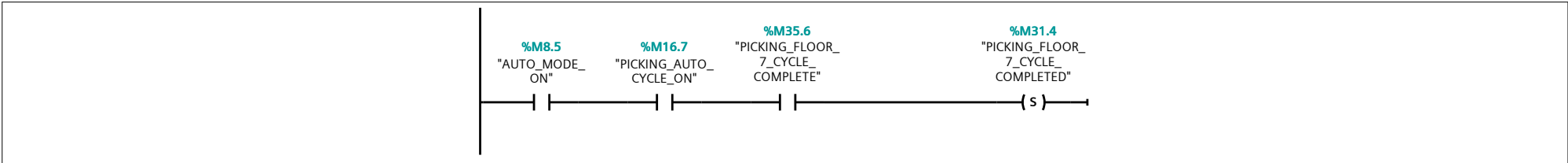
7.1 (Page1 - 90)



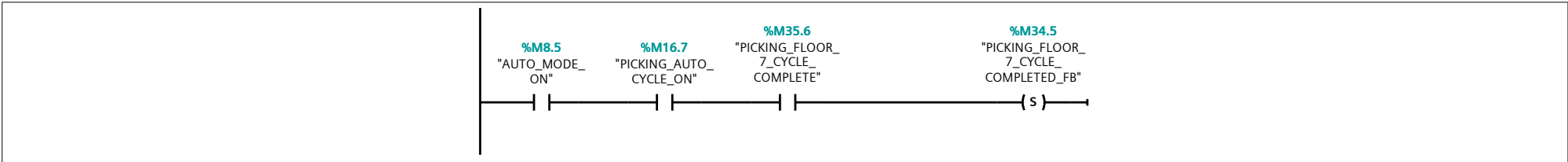
Network 111: PICKING_SEVENTH_FLOOR_CYCLE_COMPLETE:



Network 112: PICKING_SEVENTH_FLOOR_CYCLE_COMPLETED:

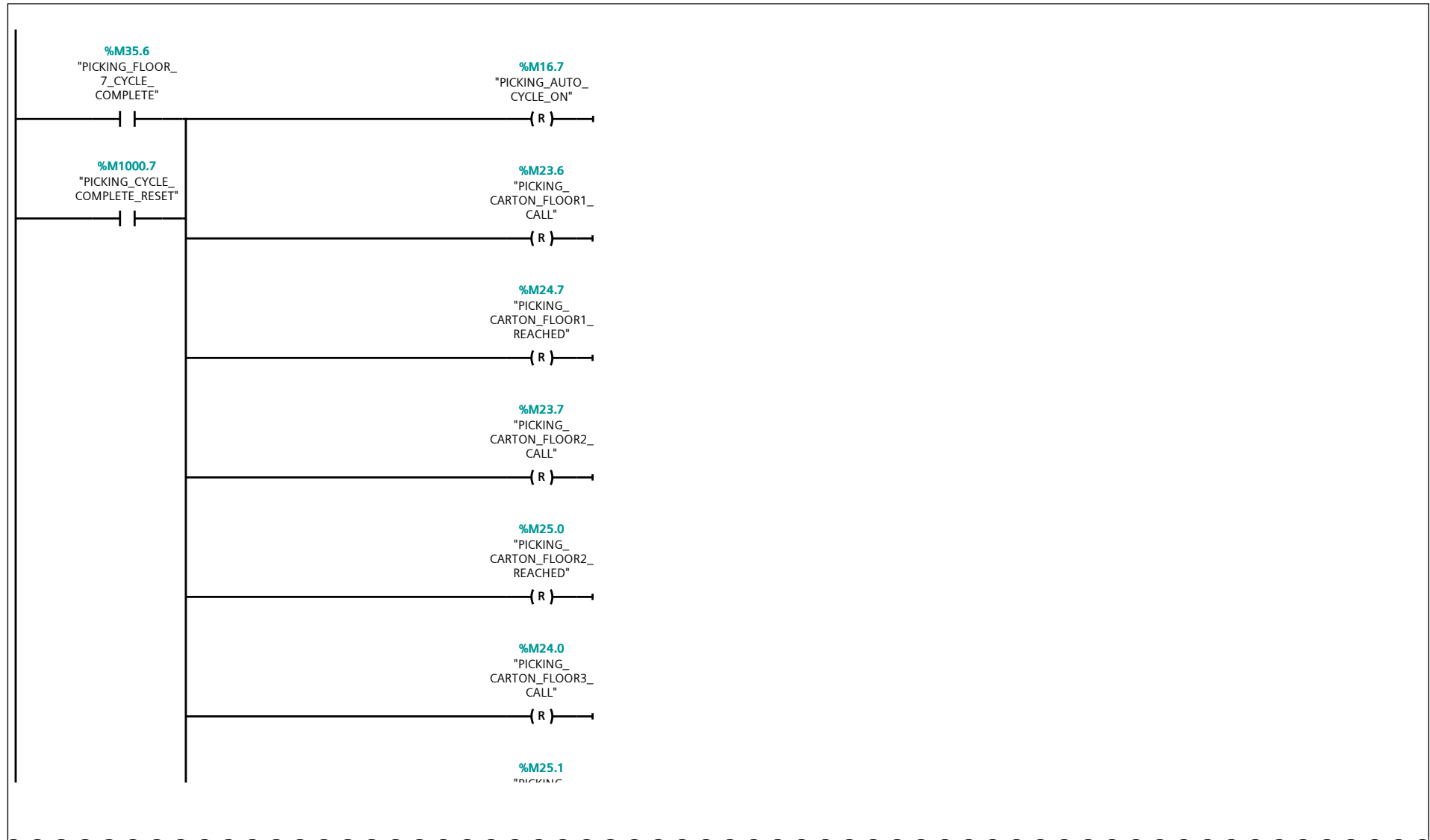


Network 113: PICKING_SEVENTH_FLOOR_CYCLE_COMPLETED_FB:



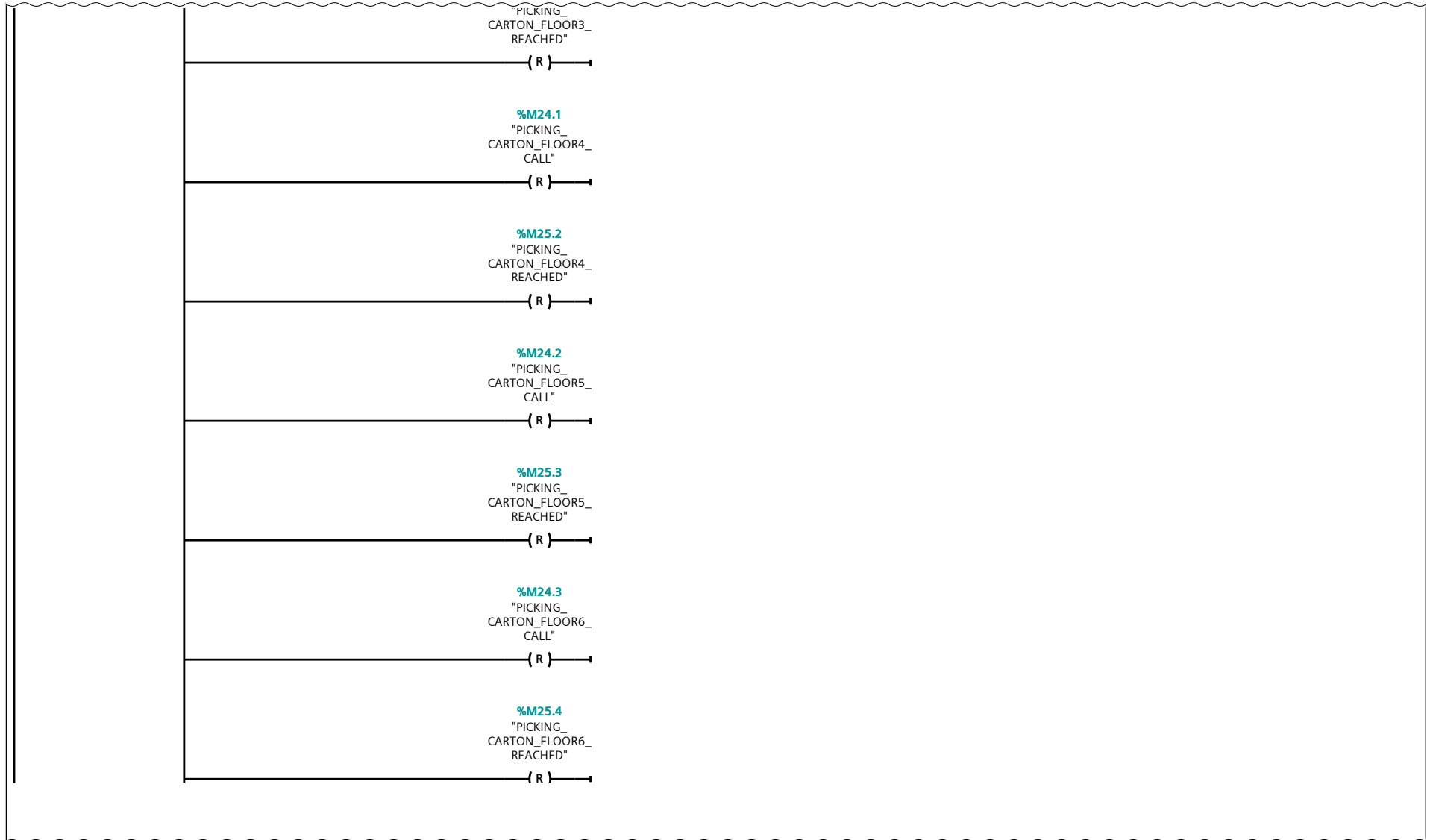
Network 114: PICKING_AUTO_CYCLE_RESET:

Network 114: PICKING_AUTO_CYCLE_RESET: (1.1 / 8.1)



Network 114: PICKING_AUTO_CYCLE_RESET: (2.1 / 8.1)

1.1 (Page1 - 93)



3.1 (Page1 - 95)

Network 114: PICKING_AUTO_CYCLE_RESET: (3.1 / 8.1)

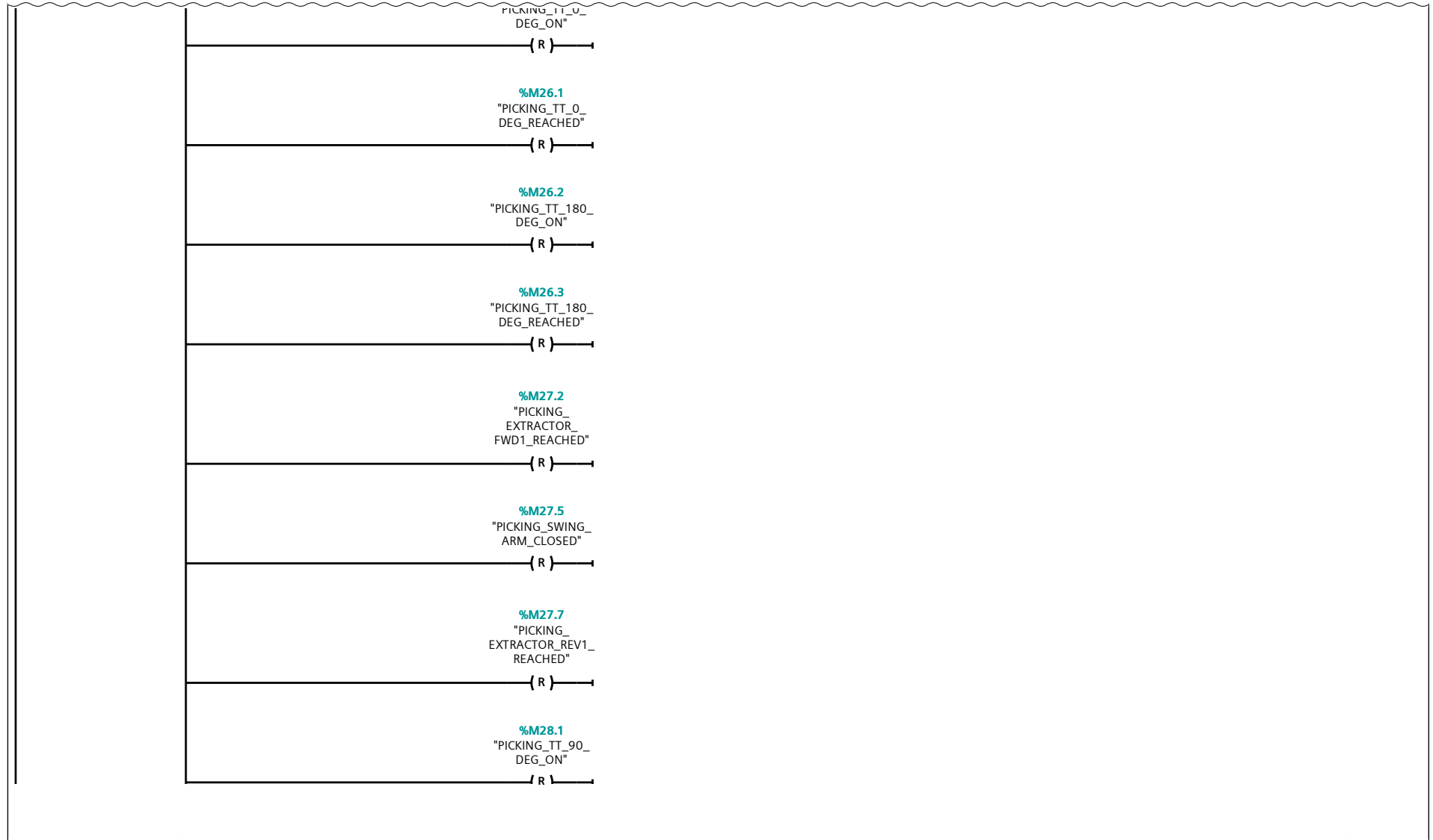
2.1 (Page1 - 94)



4.1 (Page1 - 96)

Network 114: PICKING_AUTO_CYCLE_RESET: (4.1 / 8.1)

3.1 (Page1 - 95)



5.1 (Page1 - 97)

Network 114: PICKING_AUTO_CYCLE_RESET: (5.1 / 8.1)

4.1 (Page1 - 96)

%M28.2
"PICKING_TT_90_
DEG_REACHED"

(R)

%M28.4
"PICKING_
PLACING_
FLOOR1_CALL"

(R)

%M29.5
"PICKING_
PLACING_
FLOOR1_
REACHED"

(R)

%M28.5
"PICKING_
PLACING_
FLOOR2_CALL"

(R)

%M29.6
"PICKING_
PLACING_
FLOOR2_
REACHED"

(R)

%M28.6
"PICKING_
PLACING_
FLOOR3_CALL"

(R)

6.1 (Page1 - 98)

Network 114: PICKING_AUTO_CYCLE_RESET: (6.1 / 8.1)

5.1 (Page1 - 97)

%M29.7
"PICKING_
PLACING_
FLOOR3_
REACHED"
(R)
%M28.7
"PICKING_
PLACING_
FLOOR4_CALL"
(R)
%M30.0
"PICKING_
PLACING_
FLOOR4_
REACHED"
(R)
%M29.0
"PICKING_
PLACING_
FLOOR5_CALL"
(R)
%M30.1
"PICKING_
PLACING_
FLOOR5_
REACHED"
(R)
%M29.1
"PICKING_
PLACING_
FLOOR6_CALL"
(R)

7.1 (Page1 - 99)

Network 114: PICKING_AUTO_CYCLE_RESET: (7.1 / 8.1)

6.1 (Page1 - 98)

%M30.2
"PICKING_
PLACING_
FLOOR6_
REACHED"

(R)

%M29.2
"PICKING_
PLACING_
FLOOR7_CALL"

(R)

%M30.3
"PICKING_
PLACING_
FLOOR7_
REACHED"

(R)

%M29.3
"PICKING_
PLACING_
FLOOR8_CALL"

(R)

%M30.4
"PICKING_
PLACING_
FLOOR8_
REACHED"

(R)

%M29.4
"PICKING_
PLACING_
FLOOR9_CALL"

(R)

8.1 (Page1 - 100)

Network 114: PICKING_AUTO_CYCLE_RESET: (8.1 / 8.1)

7.1 (Page1 - 99)

%M30.5
"PICKING_
PLACING_
FLOOR9_
REACHED"

(R)

%M33.2
"PICKING_
EXTRACTOR_
FWD2_REACHED"

(R)

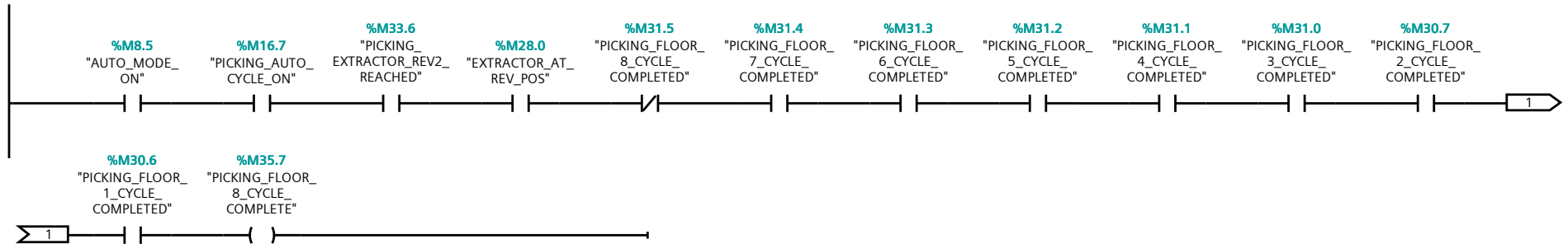
%M33.4
"PICKING_SWING_
ARM_OPENED"

(R)

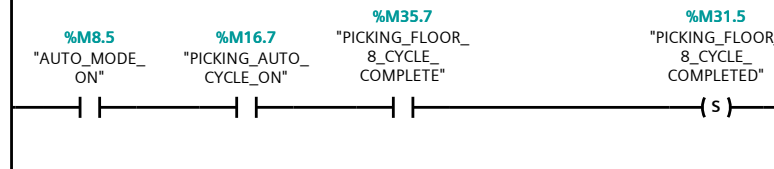
%M33.6
"PICKING_
EXTRACTOR_REV2_
REACHED"

(R)

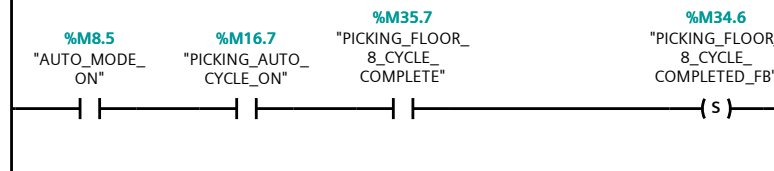
Network 115: PICKING_EIGHTH_FLOOR_CYCLE_COMPLETE:



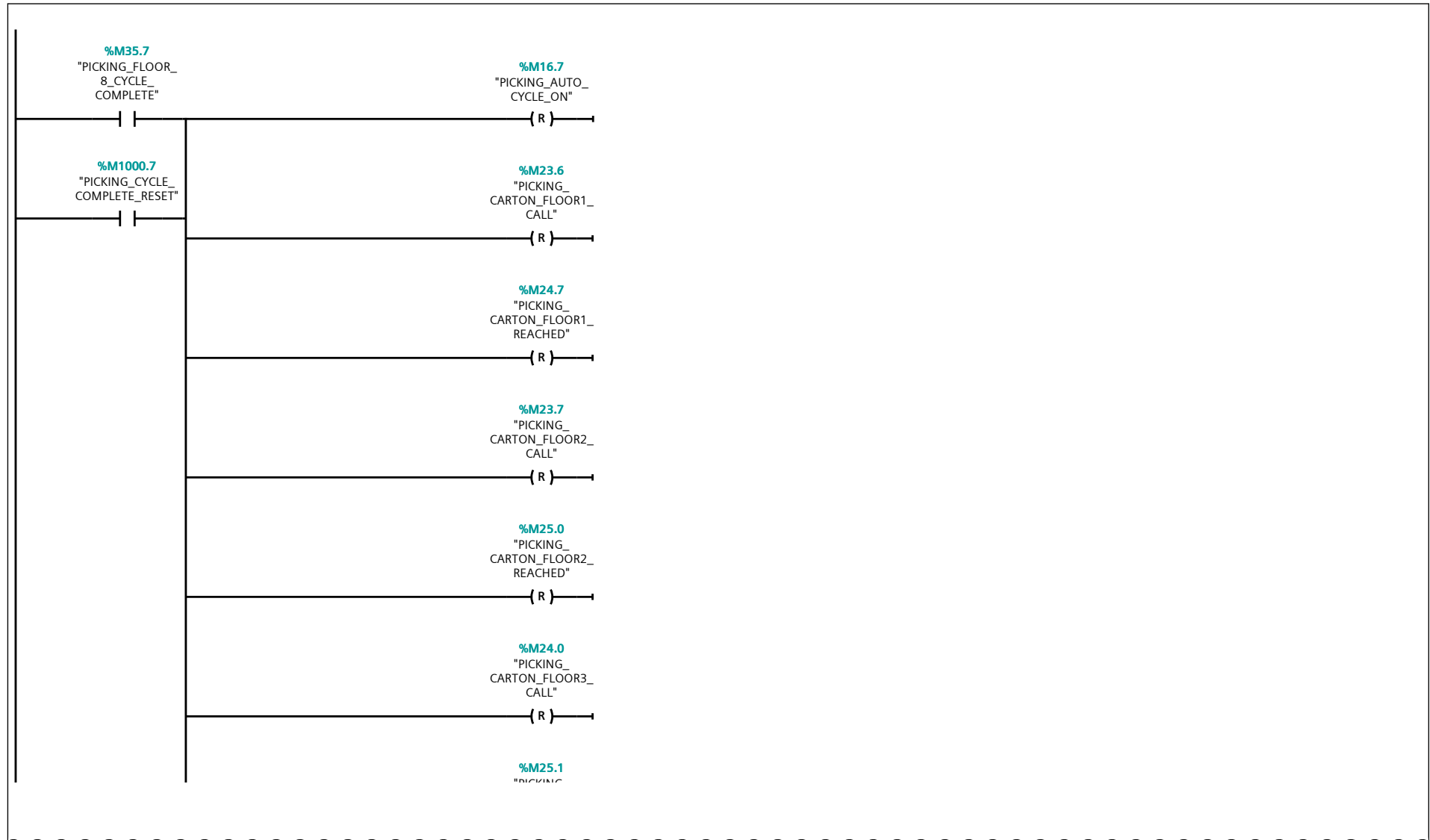
Network 116: PICKING_EIGHTH_FLOOR_CYCLE_COMPLETED:



Network 117: PICKING_EIGHTH_FLOOR_CYCLE_COMPLETED_FB:

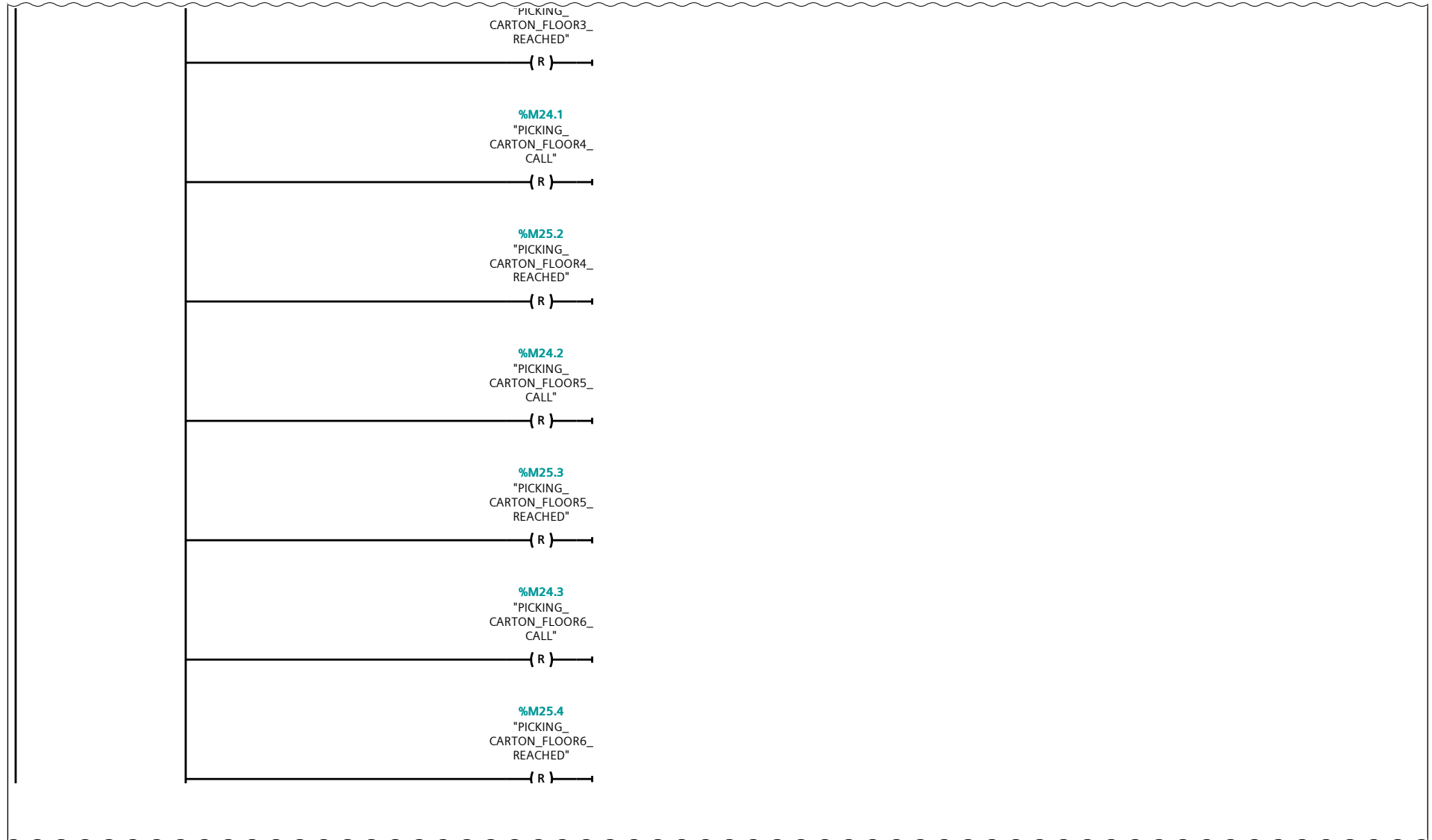


Network 118: PICKING_AUTO_CYCLE_RESET: (1.1 / 8.1)



Network 118: PICKING_AUTO_CYCLE_RESET: (2.1 / 8.1)

1.1 (Page1 - 103)



3.1 (Page1 - 105)

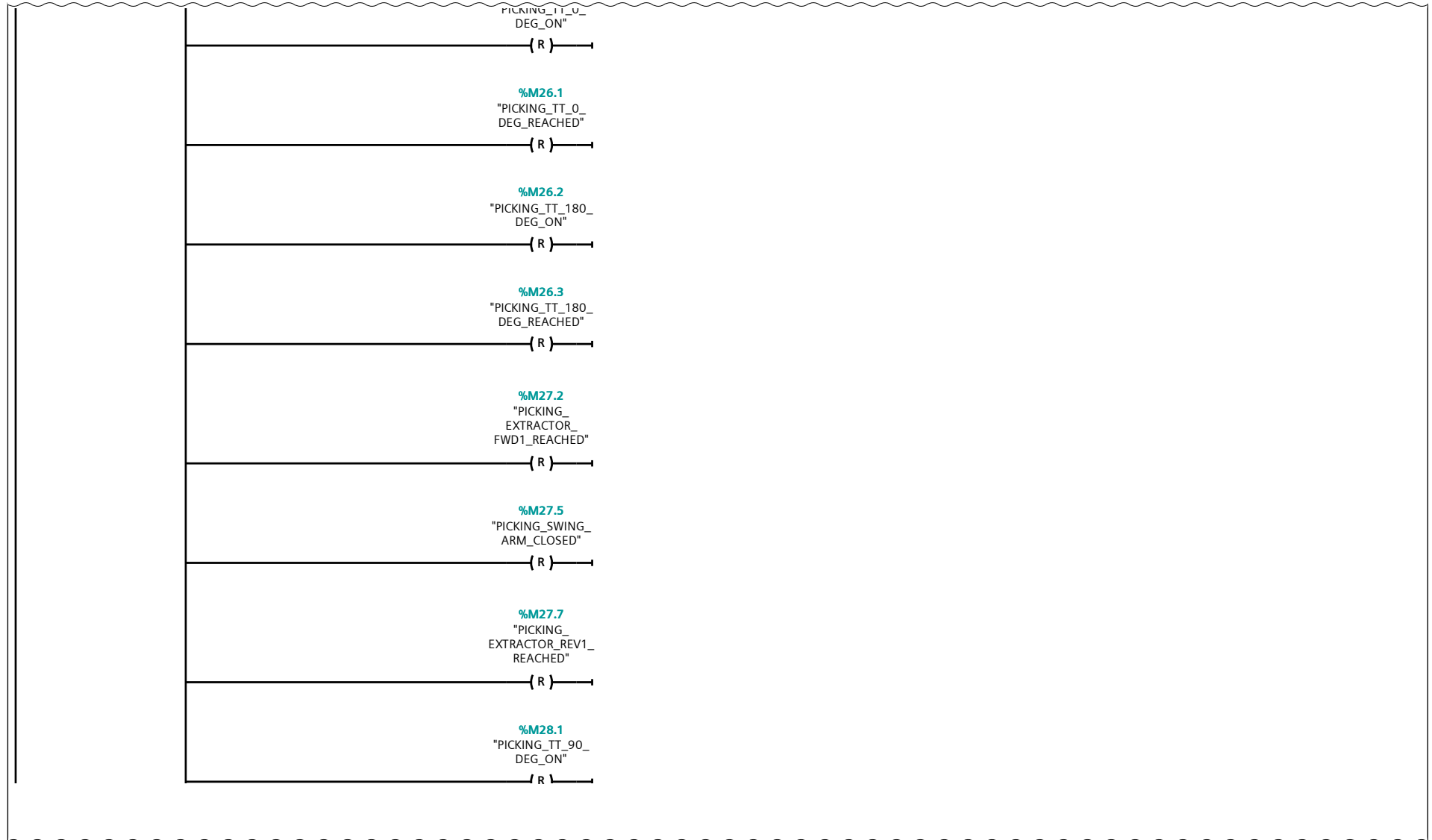
Network 118: PICKING_AUTO_CYCLE_RESET: (3.1 / 8.1)

2.1 (Page1 - 104)



4.1 (Page1 - 106)

Network 118: PICKING_AUTO_CYCLE_RESET: (4.1 / 8.1)



5.1 (Page1 - 107)

Network 118: PICKING_AUTO_CYCLE_RESET: (5.1 / 8.1)

4.1 (Page1 - 106)

%M28.2
"PICKING_TT_90_
DEG_REACHED"

(R)

%M28.4
"PICKING_
PLACING_
FLOOR1_CALL"

(R)

%M29.5
"PICKING_
PLACING_
FLOOR1_
REACHED"

(R)

%M28.5
"PICKING_
PLACING_
FLOOR2_CALL"

(R)

%M29.6
"PICKING_
PLACING_
FLOOR2_
REACHED"

(R)

%M28.6
"PICKING_
PLACING_
FLOOR3_CALL"

(R)

6.1 (Page1 - 108)

Network 118: PICKING_AUTO_CYCLE_RESET: (6.1 / 8.1)

5.1 (Page1 - 107)

%M29.7
"PICKING_
PLACING_
FLOOR3_
REACHED"

(R)

%M28.7
"PICKING_
PLACING_
FLOOR4_CALL"

(R)

%M30.0
"PICKING_
PLACING_
FLOOR4_
REACHED"

(R)

%M29.0
"PICKING_
PLACING_
FLOOR5_CALL"

(R)

%M30.1
"PICKING_
PLACING_
FLOOR5_
REACHED"

(R)

%M29.1
"PICKING_
PLACING_
FLOOR6_CALL"

(R)

7.1 (Page1 - 109)

Network 118: PICKING_AUTO_CYCLE_RESET: (7.1 / 8.1)

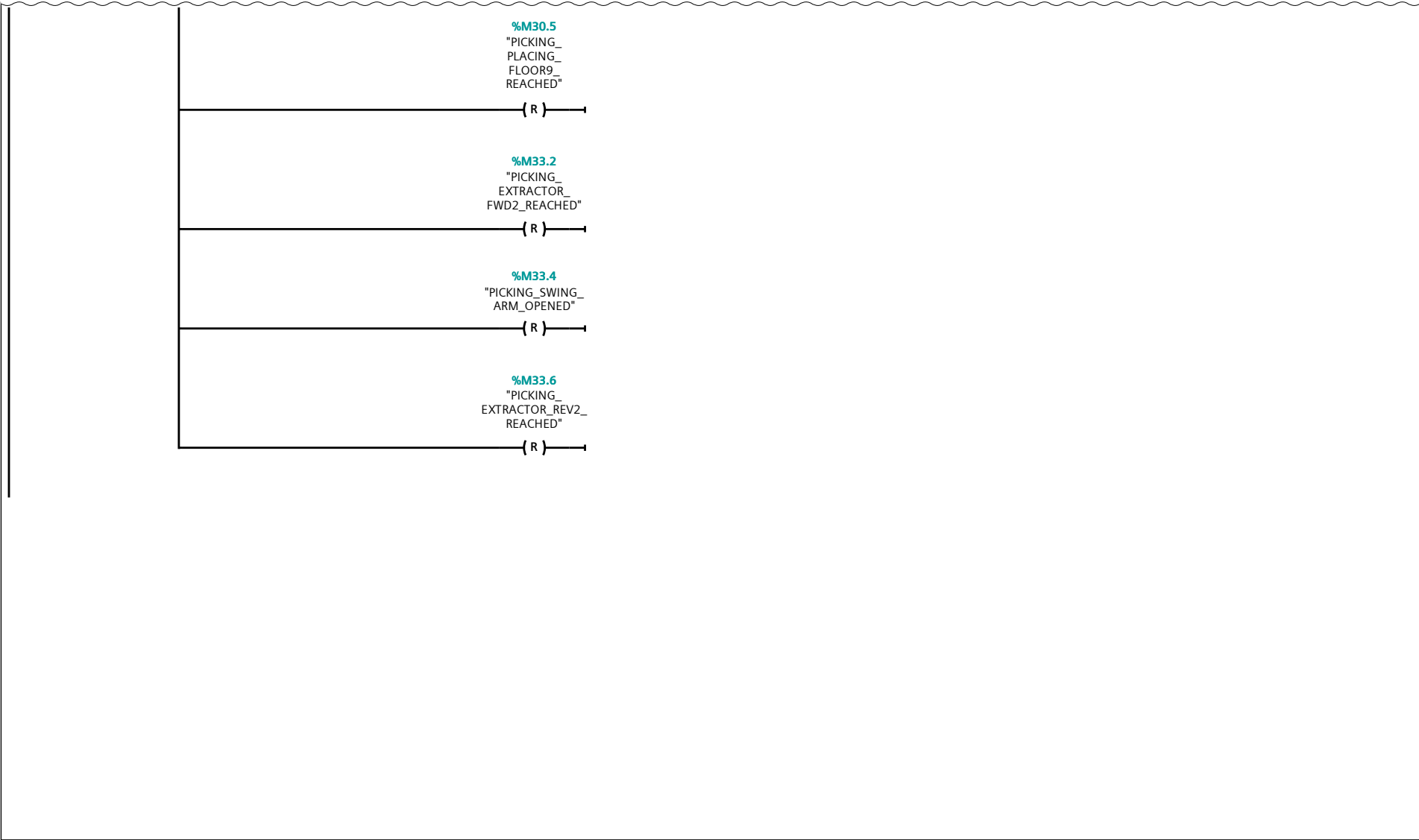
6.1 (Page1 - 108)

%M30.2
"PICKING_
PLACING_
FLOOR6_
REACHED"
(R)
%M29.2
"PICKING_
PLACING_
FLOOR7_CALL"
(R)
%M30.3
"PICKING_
PLACING_
FLOOR7_
REACHED"
(R)
%M29.3
"PICKING_
PLACING_
FLOOR8_CALL"
(R)
%M30.4
"PICKING_
PLACING_
FLOOR8_
REACHED"
(R)
%M29.4
"PICKING_
PLACING_
FLOOR9_CALL"
(R)

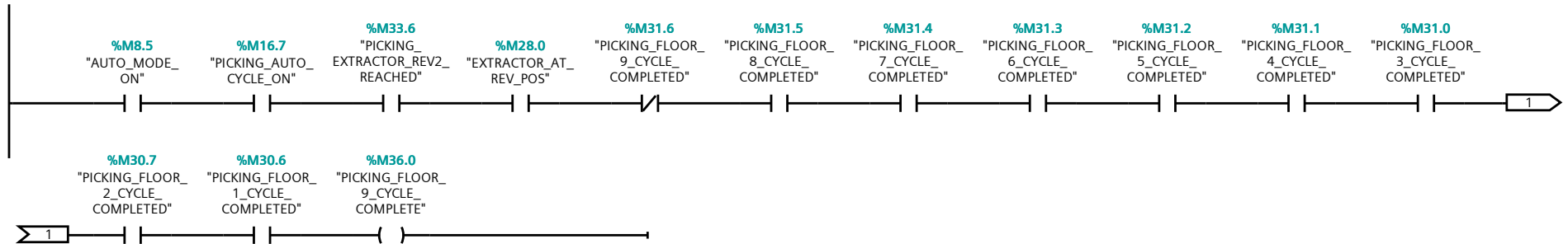
8.1 (Page1 - 110)

Network 118: PICKING_AUTO_CYCLE_RESET: (8.1 / 8.1)

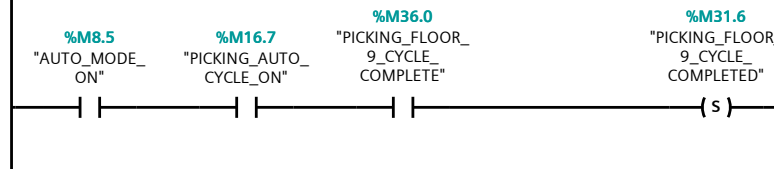
7.1 (Page1 - 109)



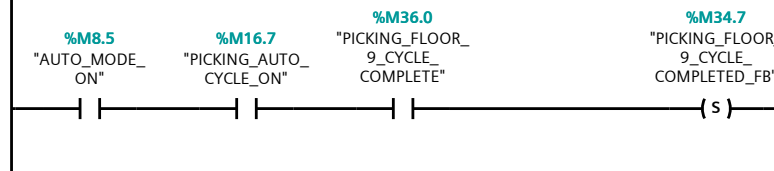
Network 119: PICKING_NINTH_FLOOR_CYCLE_COMPLETE:



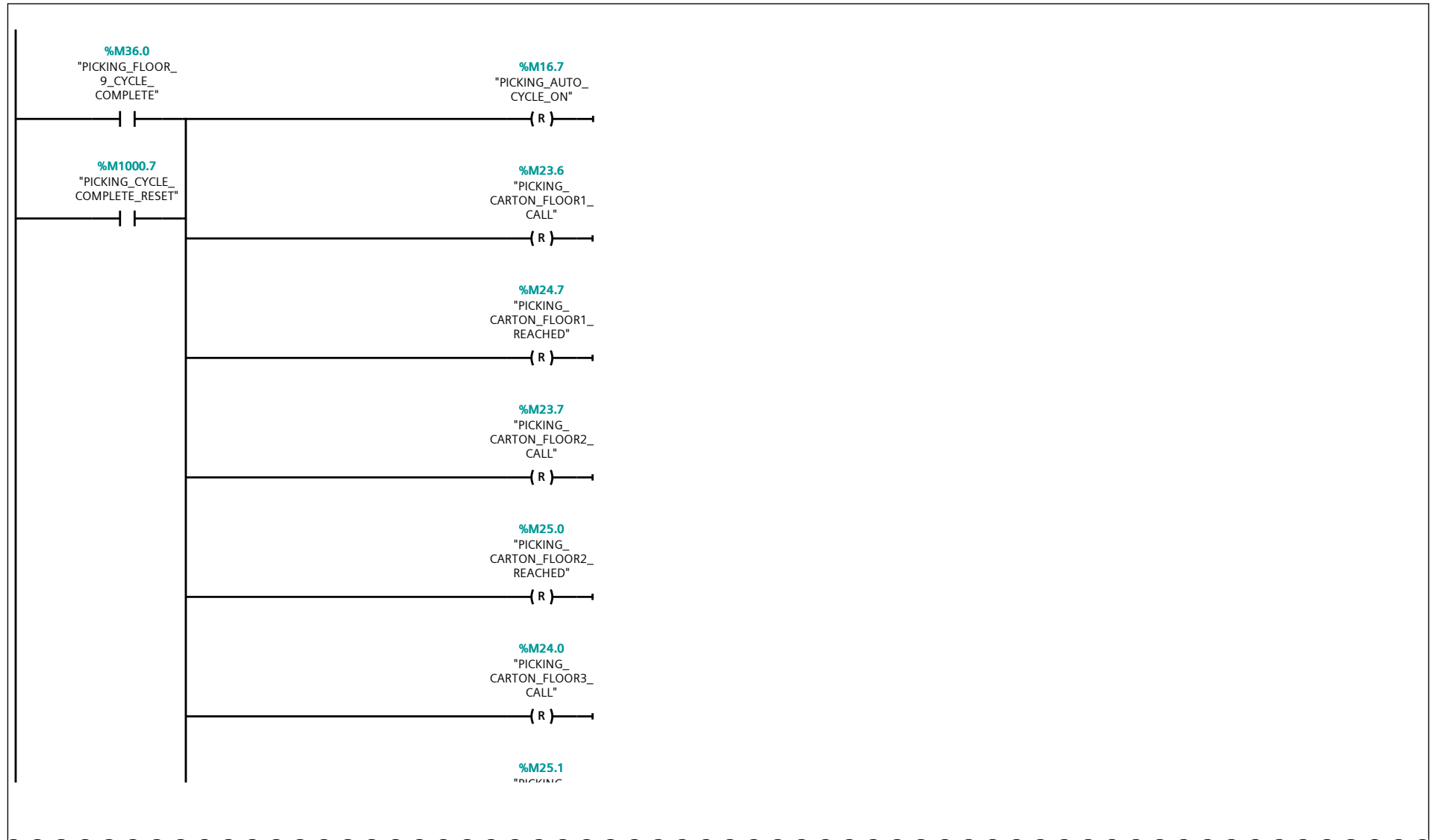
Network 120: PICKING_NINTH_FLOOR_CYCLE_COMPLETED:



Network 121: PICKING_NINTH_FLOOR_CYCLE_COMPLETED_FB:

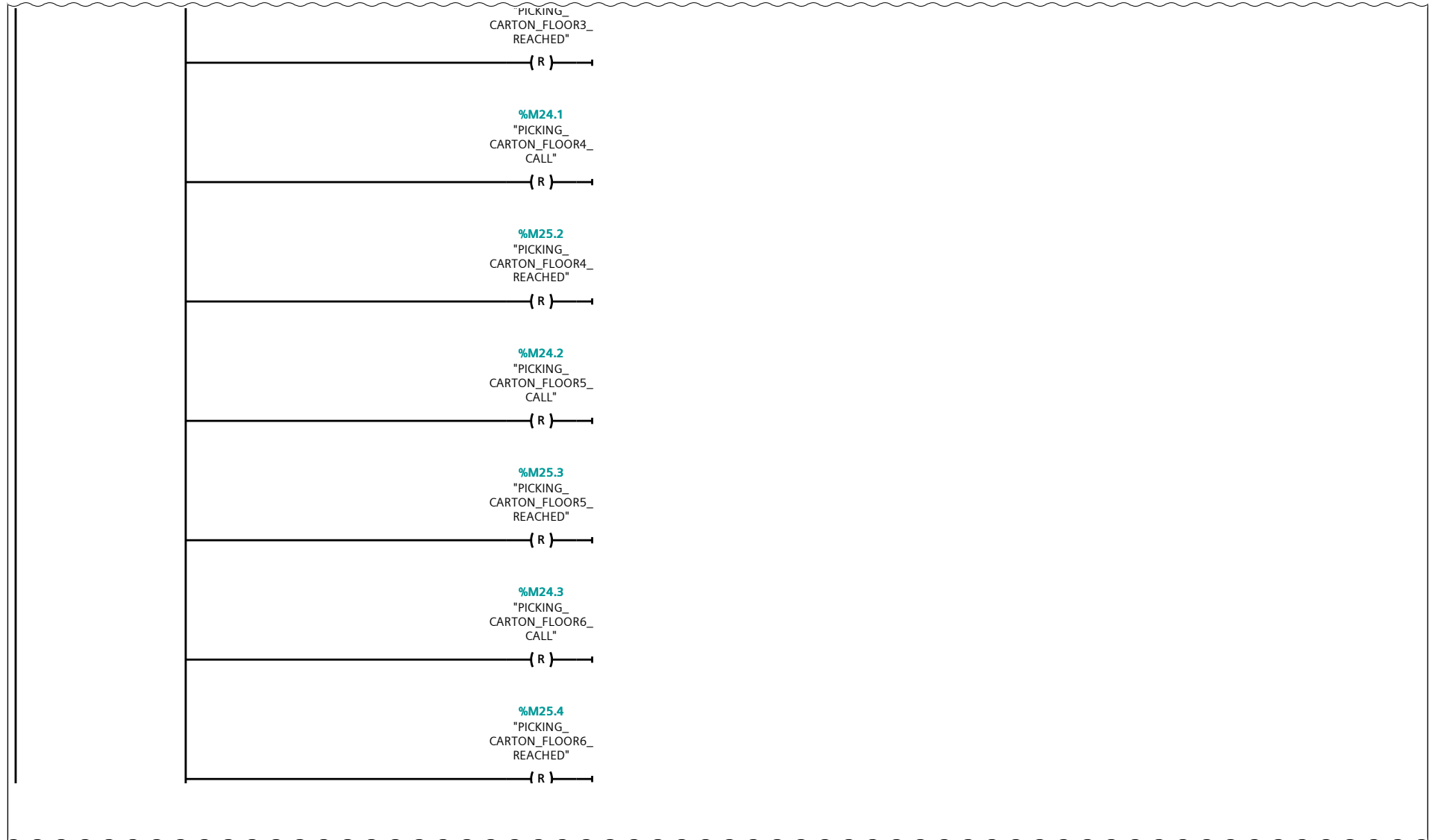


Network 122: PICKING_AUTO_CYCLE_RESET: (1.1 / 8.1)



Network 122: PICKING_AUTO_CYCLE_RESET: (2.1 / 8.1)

1.1 (Page1 - 113)



3.1 (Page1 - 115)

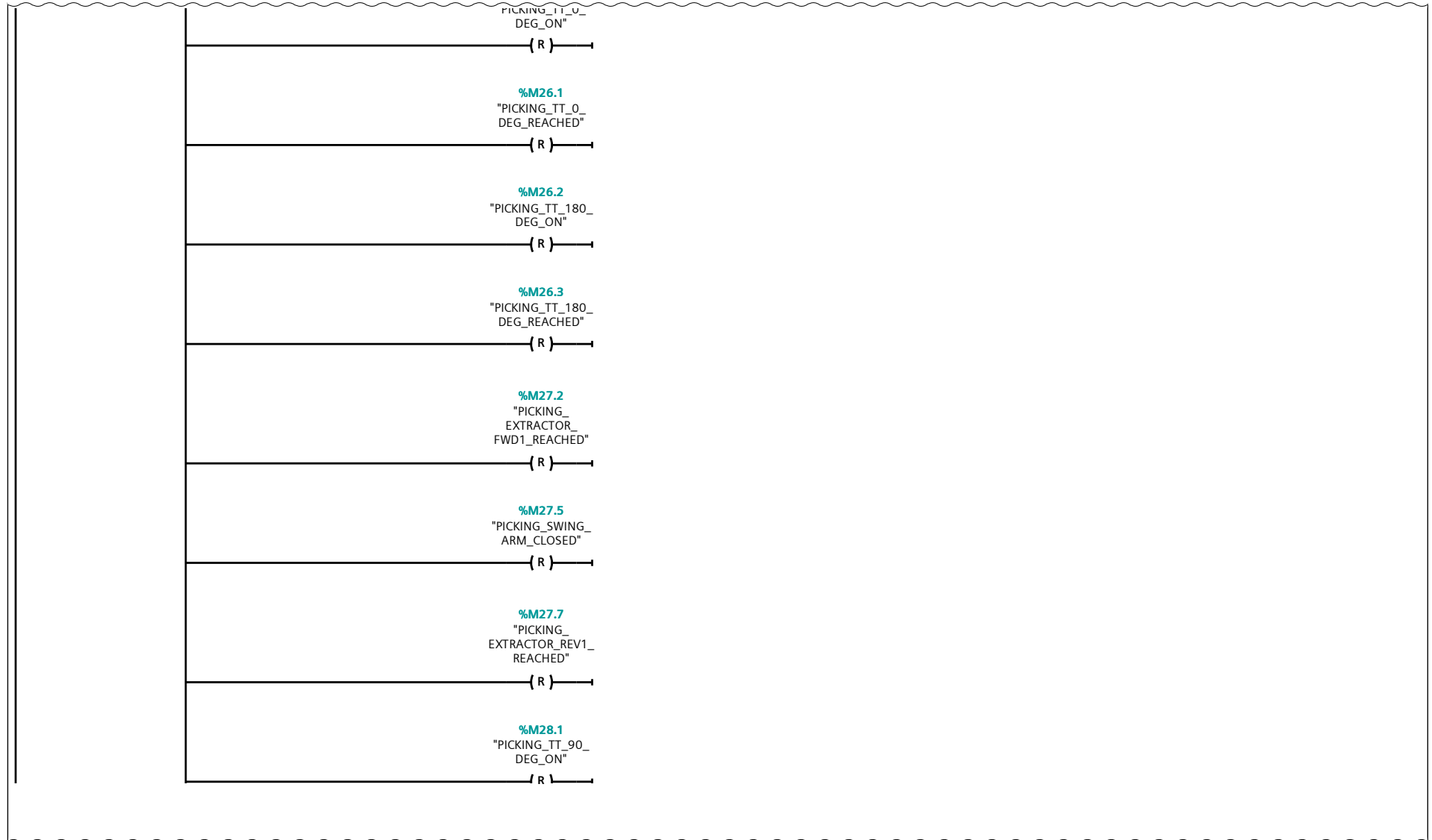
Network 122: PICKING_AUTO_CYCLE_RESET: (3.1 / 8.1)

2.1 (Page1 - 114)



4.1 (Page1 - 116)

Network 122: PICKING_AUTO_CYCLE_RESET: (4.1 / 8.1)



Network 122: PICKING_AUTO_CYCLE_RESET: (5.1 / 8.1)

4.1 (Page1 - 116)

%M28.2
"PICKING_TT_90_
DEG_REACHED"

(R)

%M28.4
"PICKING_
PLACING_
FLOOR1_CALL"

(R)

%M29.5
"PICKING_
PLACING_
FLOOR1_
REACHED"

(R)

%M28.5
"PICKING_
PLACING_
FLOOR2_CALL"

(R)

%M29.6
"PICKING_
PLACING_
FLOOR2_
REACHED"

(R)

%M28.6
"PICKING_
PLACING_
FLOOR3_CALL"

(R)

6.1 (Page1 - 118)

Network 122: PICKING_AUTO_CYCLE_RESET: (6.1 / 8.1)

5.1 (Page1 - 117)

%M29.7
"PICKING_
PLACING_
FLOOR3_
REACHED"

(R)

%M28.7
"PICKING_
PLACING_
FLOOR4_CALL"

(R)

%M30.0
"PICKING_
PLACING_
FLOOR4_
REACHED"

(R)

%M29.0
"PICKING_
PLACING_
FLOOR5_CALL"

(R)

%M30.1
"PICKING_
PLACING_
FLOOR5_
REACHED"

(R)

%M29.1
"PICKING_
PLACING_
FLOOR6_CALL"

(R)

7.1 (Page1 - 119)

Network 122: PICKING_AUTO_CYCLE_RESET: (7.1 / 8.1)

6.1 (Page1 - 118)

%M30.2
"PICKING_
PLACING_
FLOOR6_
REACHED"

(R)

%M29.2
"PICKING_
PLACING_
FLOOR7_CALL"

(R)

%M30.3
"PICKING_
PLACING_
FLOOR7_
REACHED"

(R)

%M29.3
"PICKING_
PLACING_
FLOOR8_CALL"

(R)

%M30.4
"PICKING_
PLACING_
FLOOR8_
REACHED"

(R)

%M29.4
"PICKING_
PLACING_
FLOOR9_CALL"

(R)

8.1 (Page1 - 120)

Network 122: PICKING_AUTO_CYCLE_RESET: (8.1 / 8.1)

7.1 (Page1 - 119)

%M30.5
"PICKING_
PLACING_
FLOOR9_
REACHED"

(R)

%M33.2
"PICKING_
EXTRACTOR_
FWD2_REACHED"

(R)

%M33.4
"PICKING_SWING_
ARM_OPENED"

(R)

%M33.6
"PICKING_
EXTRACTOR_REV2_
REACHED"

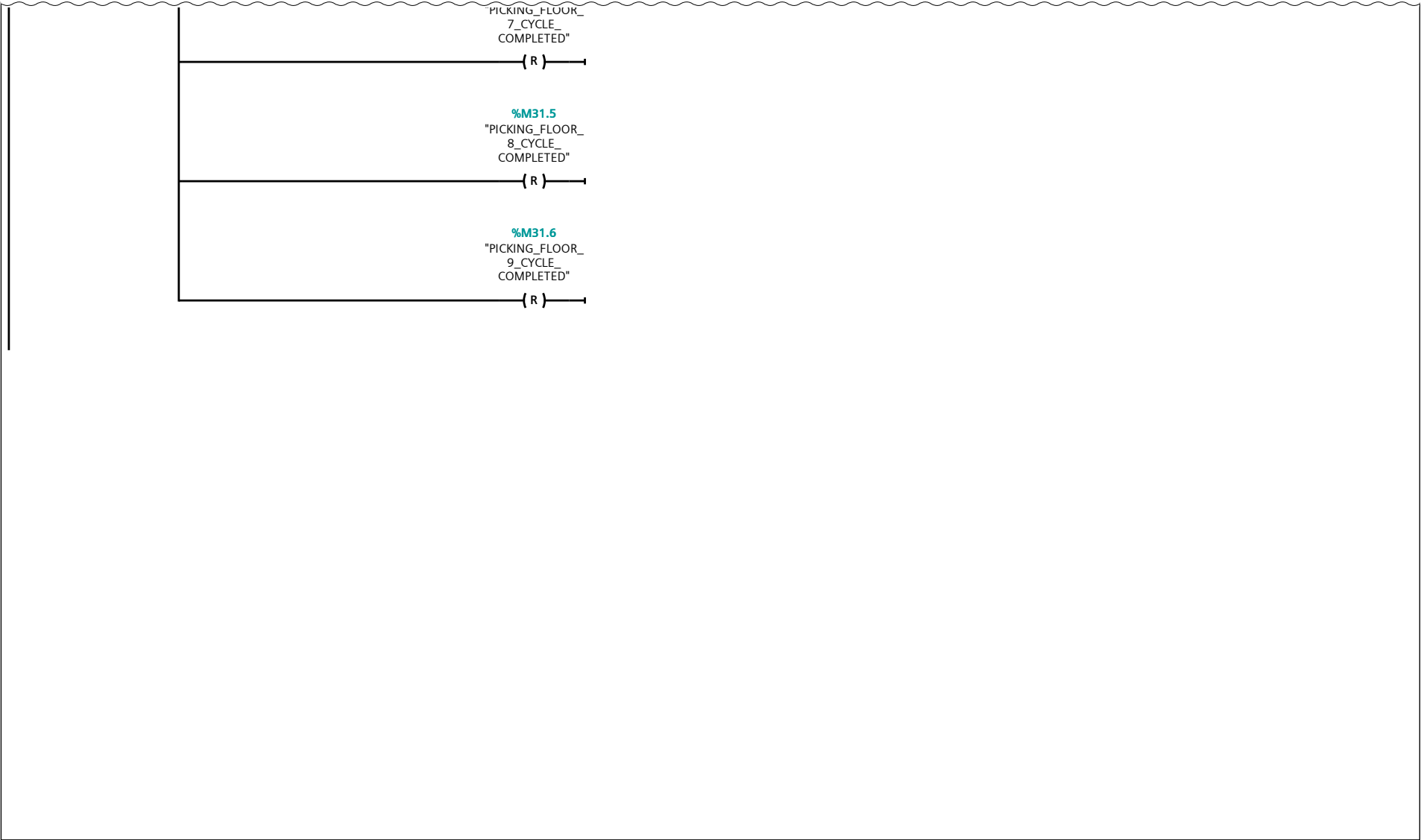
(R)

Network 123: PICKING_AUTO_CYCLE_RESET: (1.1 / 2.1)

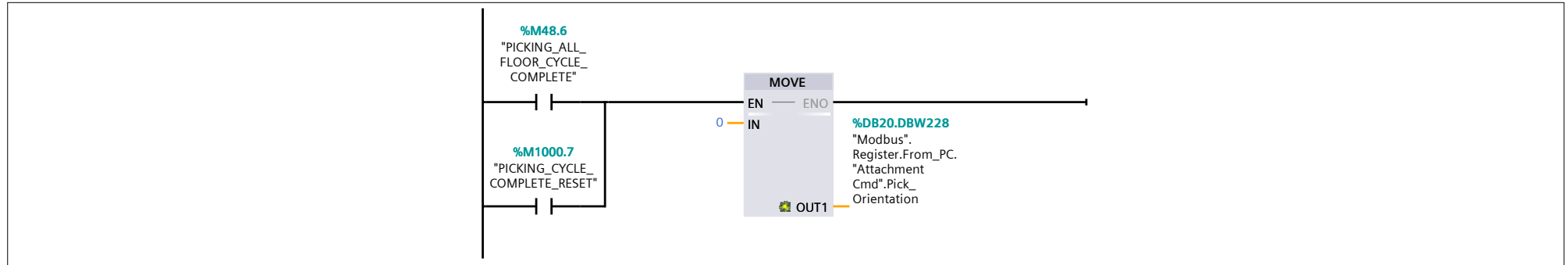


Network 123: PICKING_AUTO_CYCLE_RESET: (2.1 / 2.1)

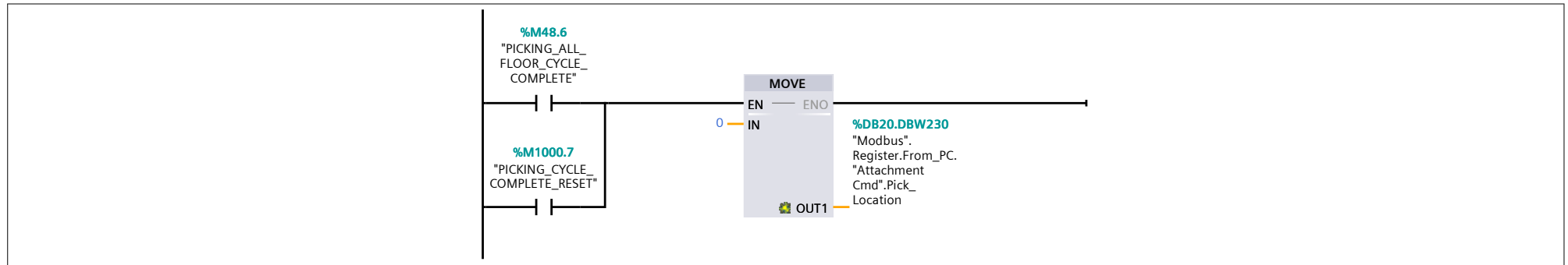
1.1 (Page1 - 122)



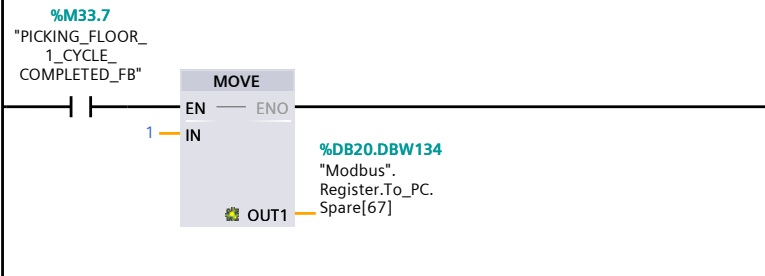
Network 124: PICKING_CYCLE_RESET:



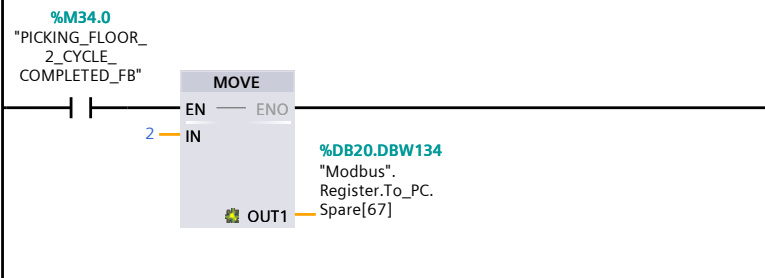
Network 125: PICKING_CYCLE_RESET:



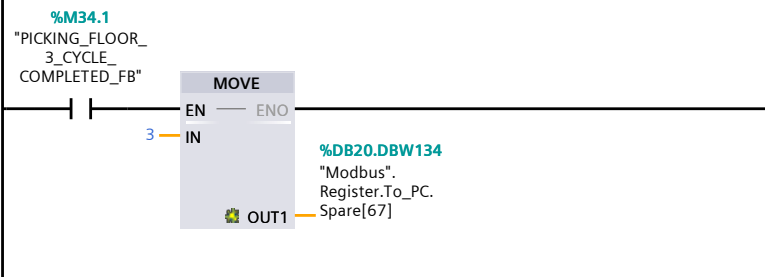
Network 126: PICKING_FLOOR1_CYCLE_COMPLETE_FB_TO_ROS:



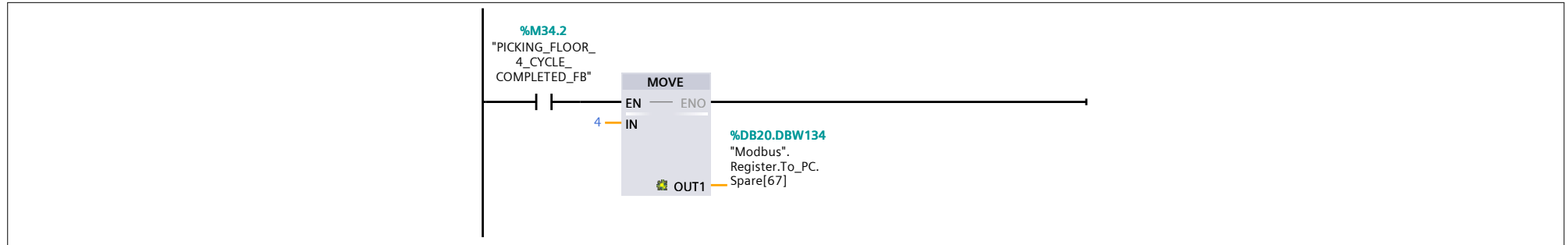
Network 127: PICKING_FLOOR2_CYCLE_COMPLETE_FB_TO_ROS:



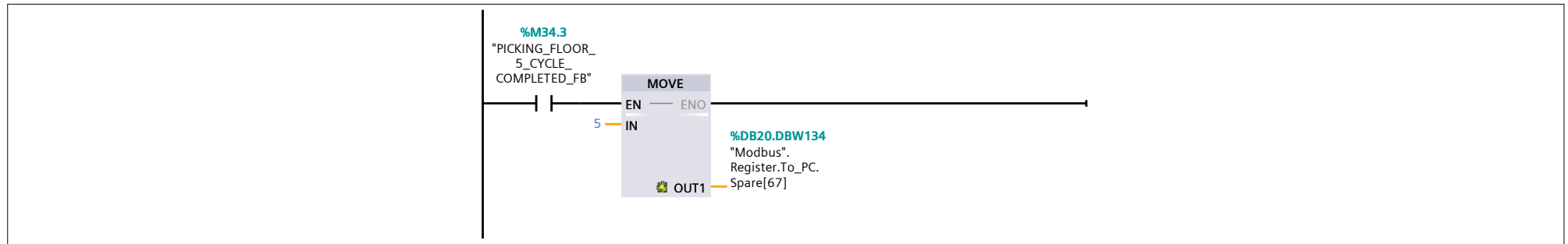
Network 128: PICKING_FLOOR3_CYCLE_COMPLETE_FB_TO_ROS:



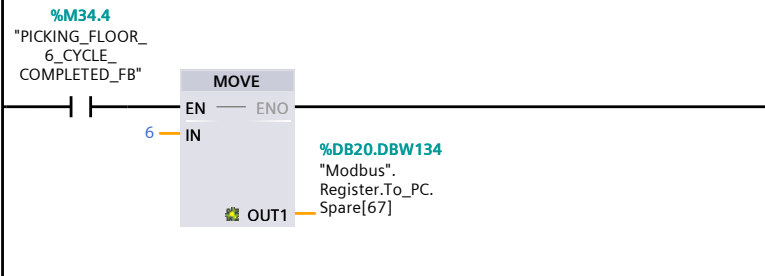
Network 129: PICKING_FLOOR4_CYCLE_COMPLETE_FB_TO_ROS:



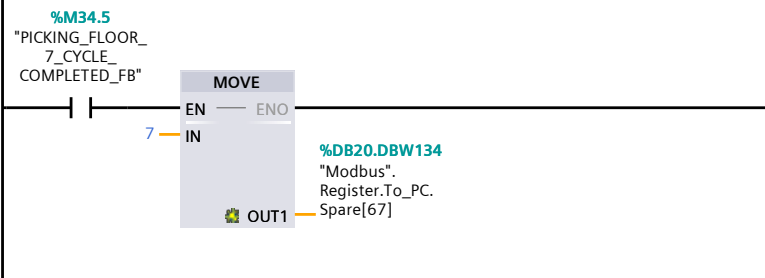
Network 130: PICKING_FLOOR5_CYCLE_COMPLETE_FB_TO_ROS:



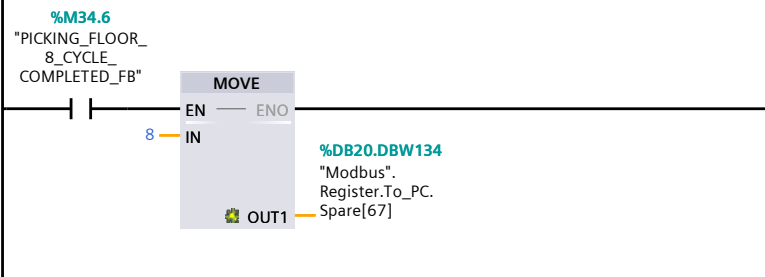
Network 131: PICKING_FLOOR6_CYCLE_COMPLETE_FB_TO_ROS:



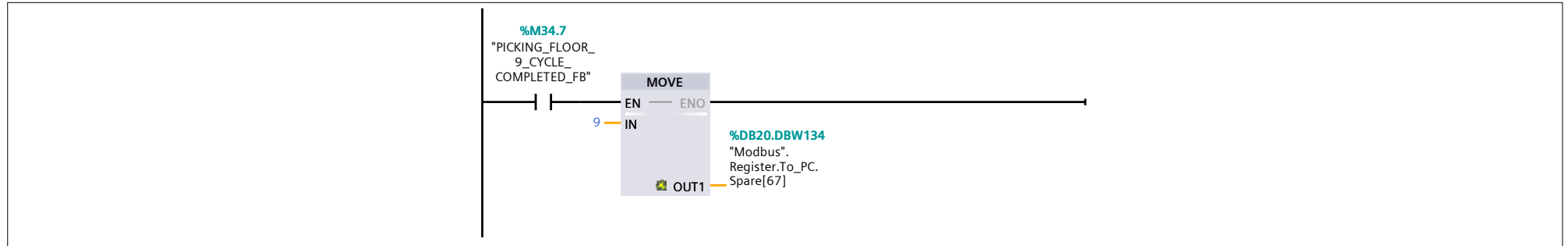
Network 132: PICKING_FLOOR7_CYCLE_COMPLETE_FB_TO_ROS:



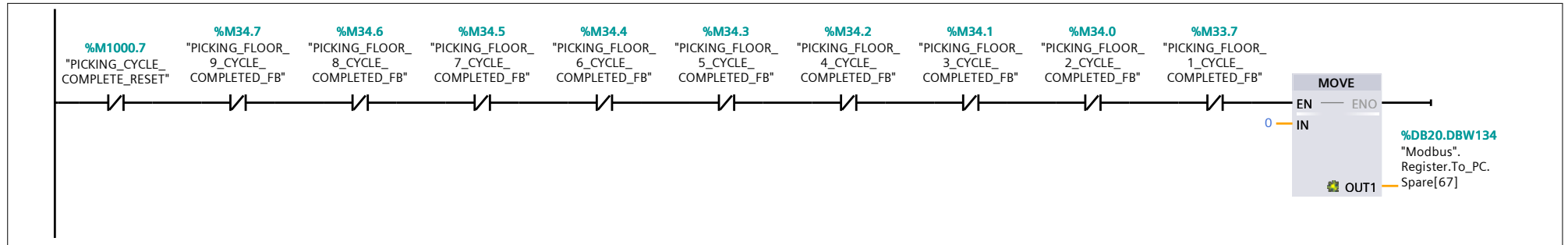
Network 133: PICKING_FLOOR8_CYCLE_COMPLETE_FB_TO_ROS:



Network 134: PICKING_FLOOR9_CYCLE_COMPLETE_FB_TO_ROS:

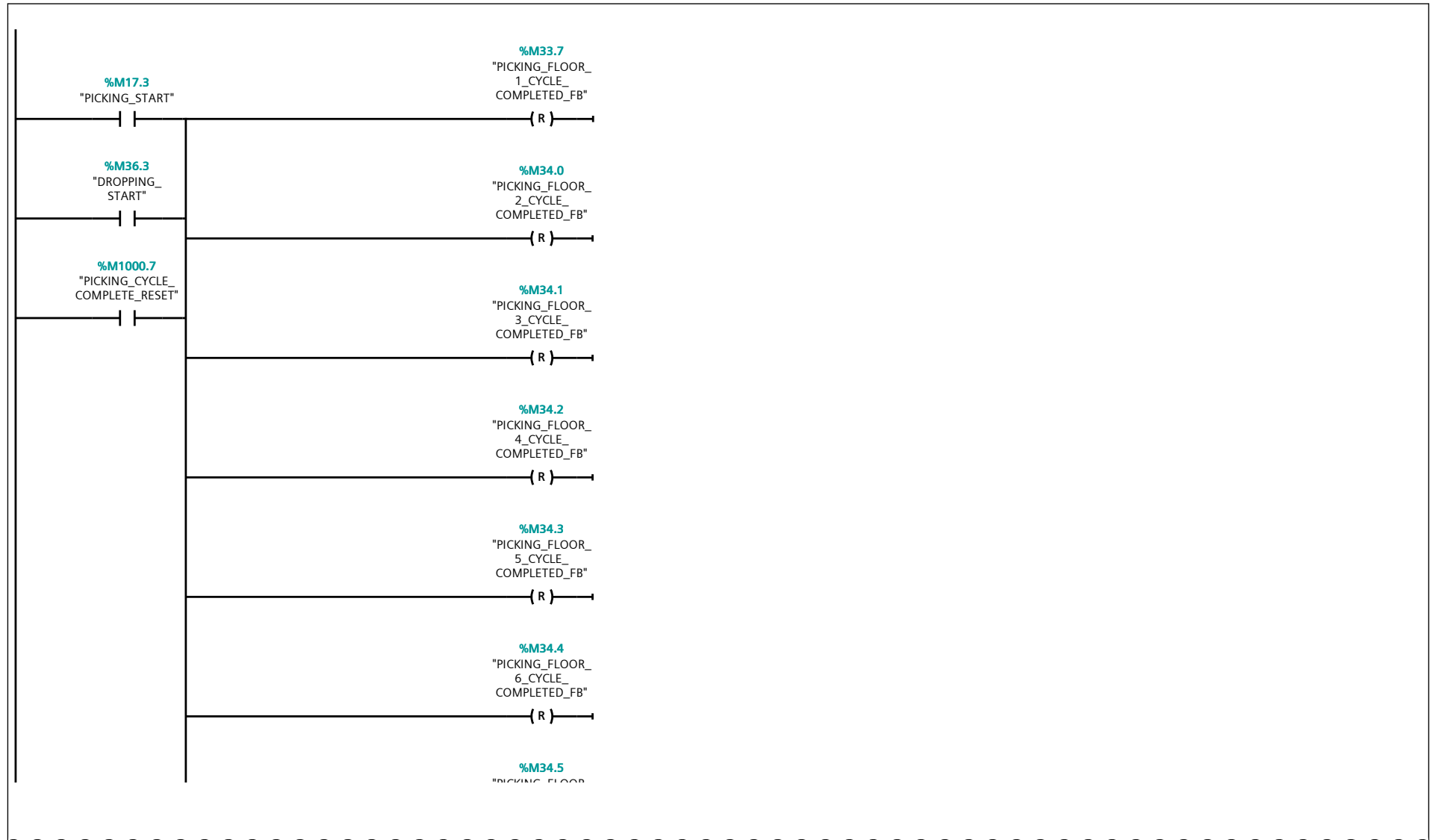


Network 135: PICKING_CYCLE_COMPLETE_FB_ZERO_TO_ROS:



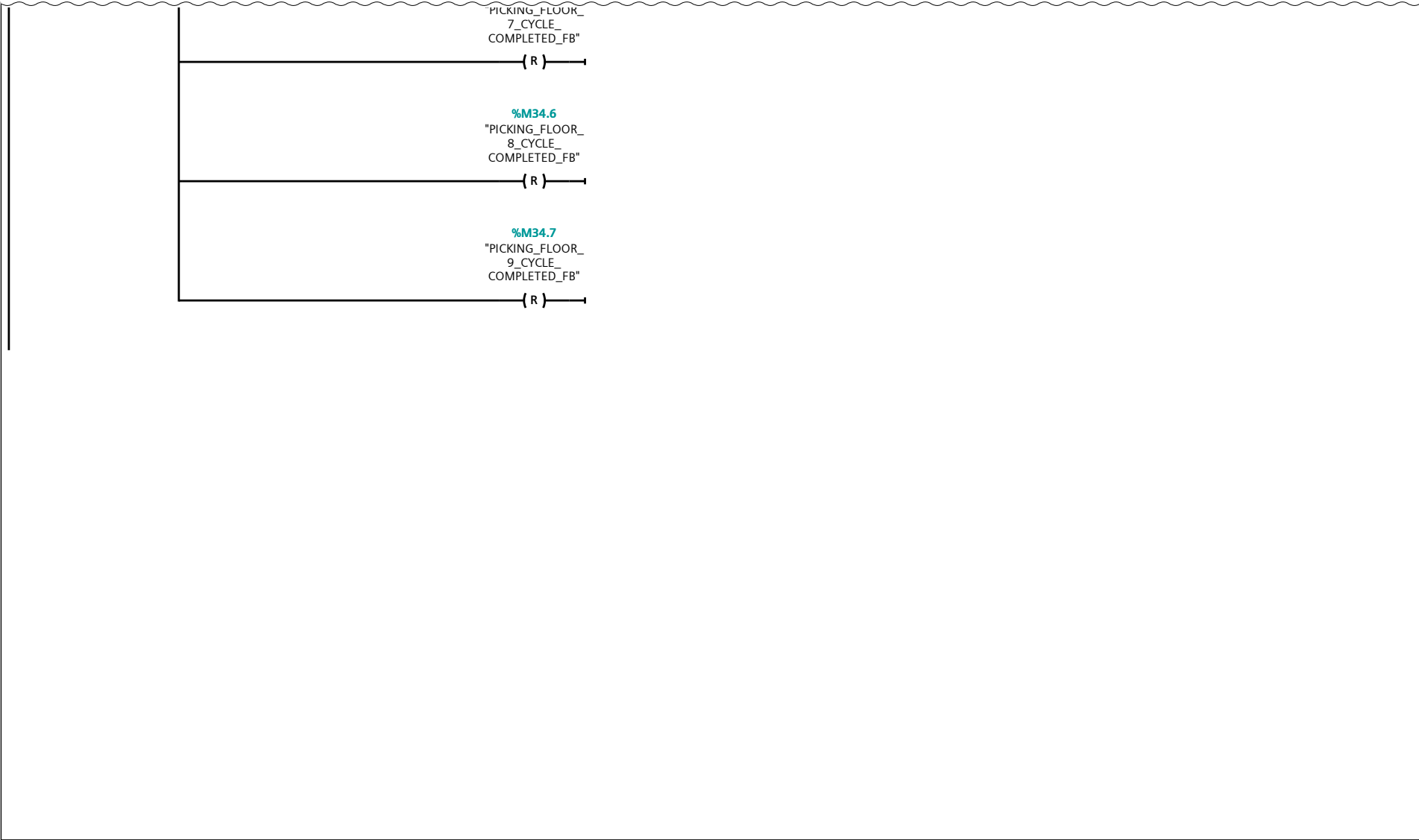
Network 136: PICKING_CYCLE_COMPLETE_RESET:

Network 136: PICKING_CYCLE_COMPLETE_RESET: (1.1 / 2.1)

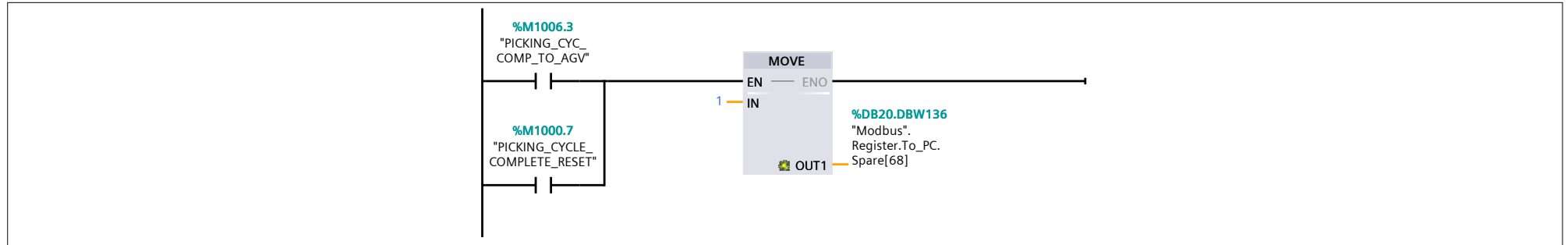


Network 136: PICKING_CYCLE_COMPLETE_RESET: (2.1 / 2.1)

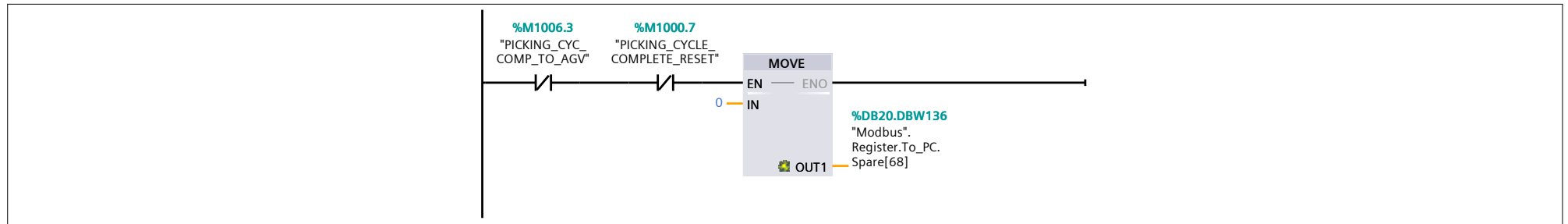
1.1 (Page1 - 129)



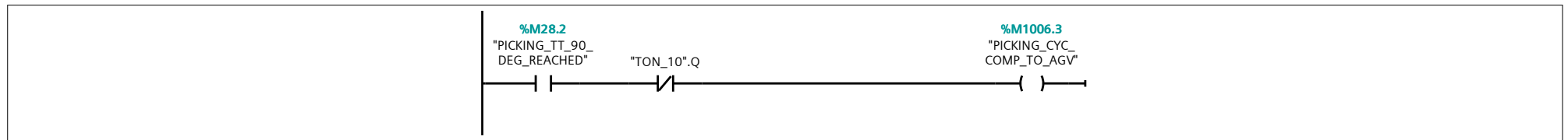
Network 137: PICKING_COMPLETE_SIGNAL_TO_ROS_FOR_ACR_MOVING:



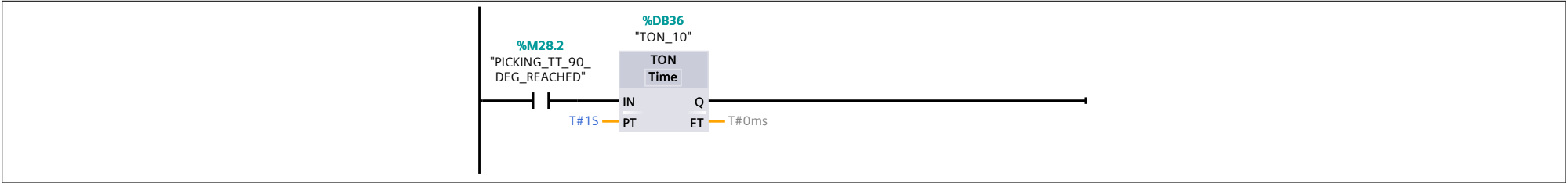
Network 138: PICKING_COMPLETE_SIGNAL_TO_ROS_FOR_ACR_MOVING:



Network 139: PICKING_TT_90_DEG_FB_TO_ROS:



Network 140: PICKING_TT_90_DEG_FB_RESET_TIMER:



Network 141:

