1]	
OTOR Number 1 Type FC Language LAD	
omatic	
Author Comment Family	
User-defined ID	
Data type Default value Comment	
Void	

Totally Integrated Automation Portal

```
%DB39
                                                                               "MB_CLIENT_DB"
"TIMER_DELAY".Q
                                                                                 MB_CLIENT
                                                                                                ENO -
                                                                                                       %DB1.DBX14.0
                                     %MW1002
                     %M0.5
                                                                                                       CONFIGURATION".
MB_CLIENT_
                                       "Tag_1"
"TIMER_DELAY".Q
                   "Clock_1Hz"
                                                                                              DONE -DONE_1
                                        ==
Int
                                                                       REQ
                                                                                                       %DB1.DBX14.1
                                                                                                       "МВ
                                                                                                       CONFIGURATION".
                                                                                                       MB_CLIENT_BUSY_
  %MW1002
                                                                                               BUSY — 1
    "Tag_1"
     | == |
Int |
                                                                                                       %DB1.DBX14.2
                                                                       DISCONNECT
                                                                  0 — MB_MODE
                                                                                                       CONFIGURATION".
                                                              40001 — MB_DATA_ADDR
                                                                                                       MB_CLIENT_
                                                                                              ERROR → ERROR_1
                                                                  6 — MB_DATA_LEN
                                                      P#DB1.DBX30.0
                                                                                                       %DB1.DBW16
                                                               "MB
                                                   CONFIGURATION".

"READ DATA" ____ MB_DATA_PTR
                                                                                            CONFIGURATION".

MB_CLIENT_
STATUS_1
                                                       P#DB1.DBX0.0
                                                    CONFIGURATION".
                                                           CONNECT __ CONNECT
```

Network 2:

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Automation Portal

**DB39

"MB_CLIENT_DB"

**MB_CLIENT
FN FNO

```
EN
                                                                                   ENO -
                       %M0.1
                                                                                           %DB1.DBX18.0
"TIMER_DELAY".Q
                    "Clock_5Hz"
                                                         REQ
                                                                                          CONFIGURATION".
MB_CLIENT_
                                        "WRITE DATA".
DISCONNECT — DISCONNECT
                                                                                  DONE -DONE_2
                       %M1.2
                                                   1 — MB_MODE
                    "AlwaysTRUE"
                                                                                           %DB1.DBX18.1
                                               40047 — MB_DATA_ADDR
                                                   4 — MB_DATA_LEN
                                                                                           CONFIGURATION".
MB_CLIENT_BUSY_
                                       P#DB1.DBX42.0
                                                                                  BUSY →<sup>2</sup>
                                                 "MB
                                     CONFIGURATION".
                                        "WRITE DATA" — MB_DATA_PTR
                                                                                           %DB1.DBX18.2
                                                                                           CONFIGURATION".
                                        P#DB1.DBX0.0
                                                                                           MB_CLIENT_
                                                 "МВ
                                                                                 ERROR → ERROR_2
                                     CONFIGURATION".

CONNECT ___ CONNECT
                                                                                           %DB1.DBW20
                                                                                           "MB
                                                                               CONFIGURATION".

MB_CLIENT_
STATUS_2
```

Network 3:

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Automation Portal

*DB39

"MB_CLIENT_DB"

MB_CLIENT

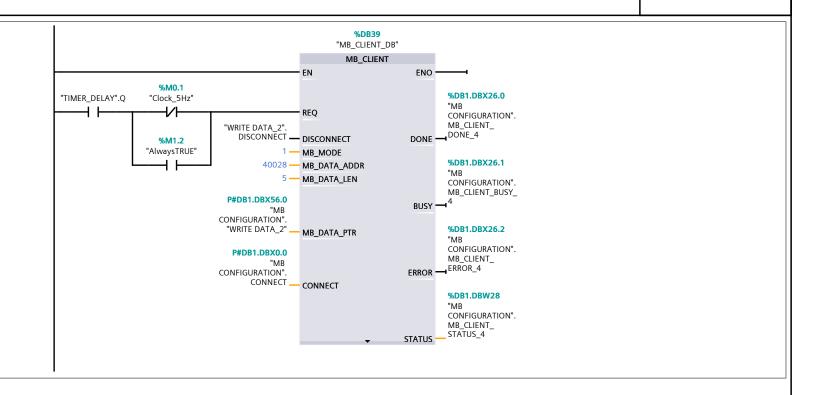
```
ENO -
                        %M0.1
                                                                                             %DB1.DBX22.0
"TIMER_DELAY".Q
                     "Clock_5Hz"
                                                          REQ
                                                                                            CONFIGURATION".
MB_CLIENT_
                                       "WRITE DATA_1".
DISCONNECT — DISCONNECT
                                                                                   DONE -DONE_3
                       %M1.2
                                                    1 — MB_MODE
                    "AlwaysTRUE"
                                                                                             %DB1.DBX22.1
                                                40125 — MB_DATA_ADDR
                                                    1 — MB_DATA_LEN
                                                                                             CONFIGURATION".
MB_CLIENT_BUSY_
                                        P#DB1.DBX50.0
                                                                                    BUSY →<sup>3</sup>
                                                  "MB
                                      CONFIGURATION".
                                       "WRITE DATA_1" — MB_DATA_PTR
                                                                                             %DB1.DBX22.2
                                                                                             CONFIGURATION".
                                         P#DB1.DBX0.0
                                                                                             MB_CLIENT_
                                                  "МВ
                                                                                   ERROR → ERROR_3
                                     CONFIGURATION".

CONNECT ___ CONNECT
                                                                                             %DB1.DBW24
                                                                                 CONFIGURATION".

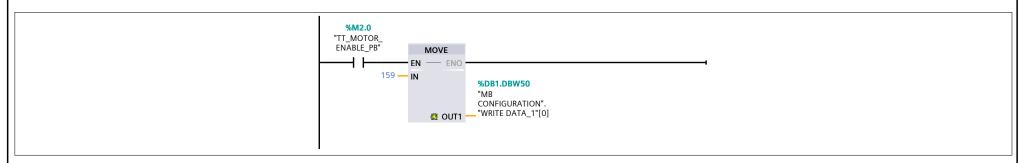
MB_CLIENT_
STATUS — STATUS_3
```

Network 4:

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Network 5: SERVO ON

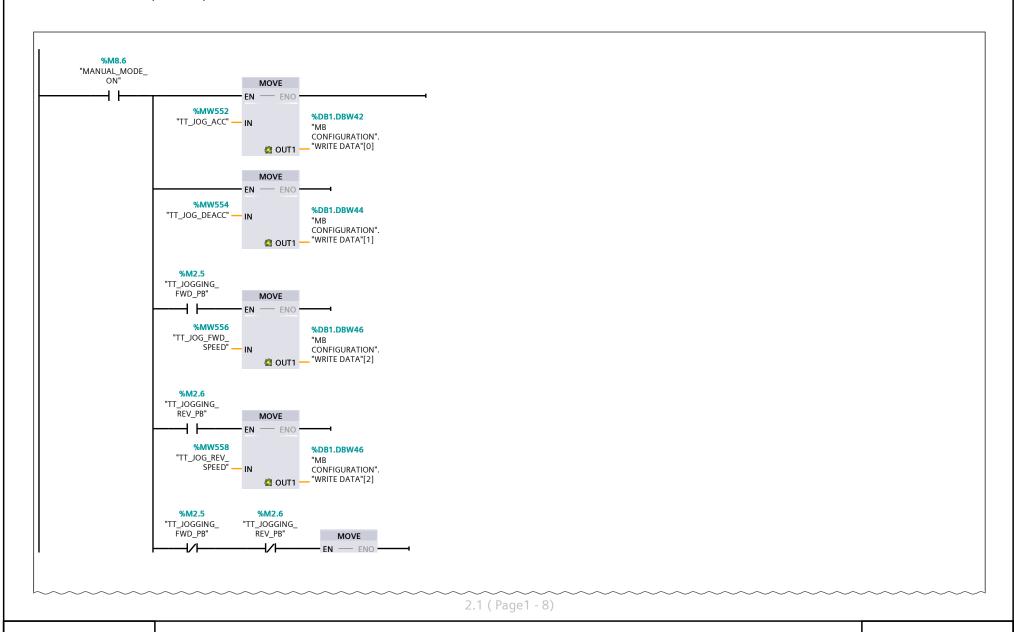


Network 6: SERVO OFF

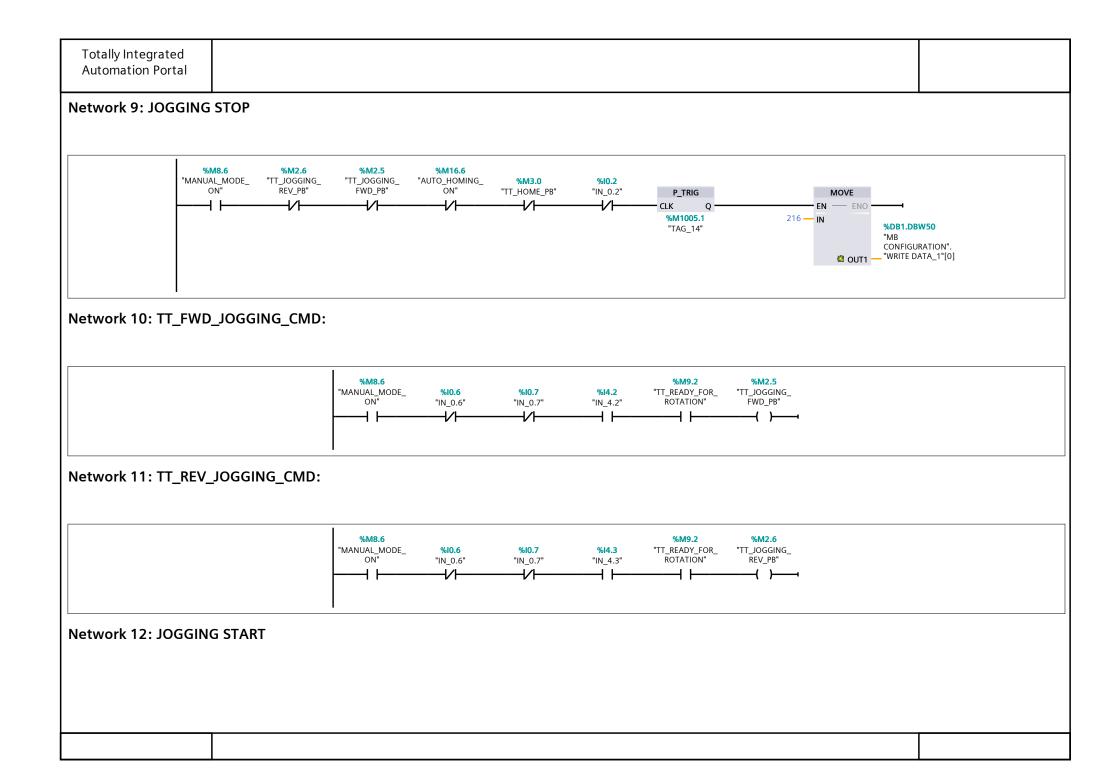
Totally Integrated Automation Portal %M2.1 "TT_MOTOR_ DISABLE_PB" MOVE - EN --- ENO 158 — IN %DB1.DBW50 CONFIGURATION". OUT1 — "WRITE DATA_1"[0] **Network 7: ALARM RESET** %10.2 "IN_0.2" MOVE - EN - ENO 186 — IN %DB1.DBW50 "MB CONFIGURATION". COUT1 — "WRITE DATA_1"[0] Network 8: JOG DATA

Totally Integrated Automation Portal

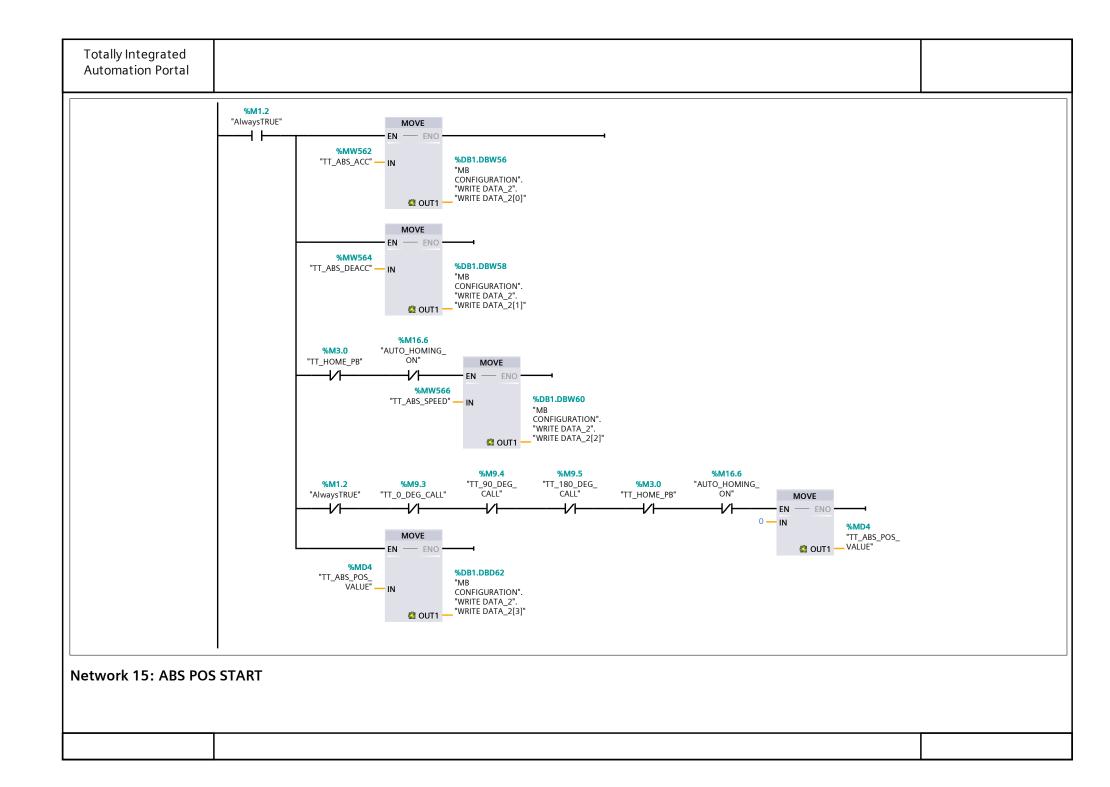
Network 8: JOG DATA (1.1 / 2.1)



Totally Integrated Automation Portal			
etwork 8: JOG DATA	(2.1 / 2.1)		
	MOVE EN ENO "TT_MAX_SPEED" IN "MB CON © OUT1 "WR	"MB CONFIGURATION". "WRITE DATA"[2] "B1.DBW48	

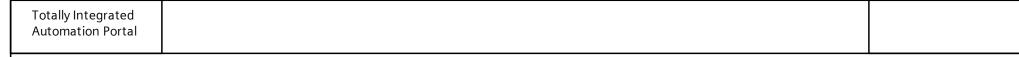


Totally Integrated **Automation Portal** %M8.6 %M2.5 %M9.2 %M52.4 "TT_READY_FOR_ ROTATION" "MANUAL_MODE_ ON" "TT_JOGGING_ FWD_PB" "TT_SERVO_ ALARM" MOVE - ENO -150 — IN %DB1.DBW50 %M2.6 "TT_JOGGING_ CONFIGURATION". OUT1 — "WRITE DATA_1"[0] REV_PB" **Network 13: EMG STOP ALL** %M2.7 "EMG_STOP_PB" MOVE - EN - ENO 226 — IN %DB1.DBW50 %10.0 "IN_0.0" CONFIGURATION". OUT1 — "WRITE DATA_1"[0] **%I3.6** "IN_3.6" Network 14: ABS POS DATA



Totally Integrated **Automation Portal** %M3.2 "TT_ABS_POS_ START" MOVE - ENO 103 — IN %DB1.DBW50 CONFIGURATION". OUT1 — "WRITE DATA_1"[0] Network 16: TT_ABS_POS_START: %M3.2 %M9.2 "TT_ABS_POS_ START" "TT_READY_FOR_ %M9.3 %10.2 %M17.1 ROTATION" "TT_0_DEG_CALL" "IN_0.2" "ACR_ALL_FAULT" %M9.4 "TT_90_DEG_ CALL" %M9.5 "TT_180_DEG_ CALL" Network 17: TT_AT_0DEG_POSITION:

```
Totally Integrated
  Automation Portal
                                                                 %DB1.DBD38
                                                                                 %DB1.DBD38
                                                                    "MB
                                                               CONFIGURATION". CONFIGURATION".
                                                                                                                                  %M26.6
                                                                "READ DATA".
                                                                                "READ DATA".
                                                                                                                               "TT_AT_0_DEG_
POS"
                                                                                                   %I3.7
                                                                "READ DATA[4]"
                                                                               "READ DATA[4]"
                                                                                                   "IN_3.7"
                                                                   <=
DInt
                                                                                   >=
DInt
                                                                    2148
                                                                                    -2148
Network 18: TT_AT_90_DEG_POSITION:
                                                                 %DB1.DBD38
                                                                                 %DB1.DBD38
                                                               CONFIGURATION". CONFIGURATION". "READ DATA". "READ DATA".
                                                                                                                                  %M26.7
                                                                                                                               "TT_AT_90_DEG_
POS"
                                                                "READ DATA[4]"
                                                                               "READ DATA[4]"
                                                                    <=
                                                                                    >=
                                                                  |Dint
                                                                                   Dint
                                                                   195481
                                                                                   191185
Network 19: TT_AT_180_DEG_POSITION:
                                                                 %DB1.DBD38
                                                                                 %DB1.DBD38
                                                               "MB "MB CONFIGURATION".
                                                                                                                                  %M28.3
                                                                "READ DATA".
                                                                                "READ DATA".
                                                                                                                              "TT_AT_180_DEG_
                                                                "READ DATA[4]"
                                                                               "READ DATA[4]"
                                                                                                                                   POS"
                                                                   Dint
                                                                                   Dint
                                                                   388814
                                                                                   384518
```



Network 20: TT READY FOR ROTATION BIT:

```
%M52.0
                   %M52.1
                                      %M17.2
                                                                                            %M9.2
                                   "EXTRACTOR_
"TT_SERVO_
ENABLE"
                  "TT_SERVO_
                                                         %I3.6
                                                                          %M17.1
                                                                                        "TT_READY_FOR_
                    READY"
                                  ZERO_POSITION"
                                                                                           ROTATION"
                                                        "IN_3.6"
                                                                      "ACR_ALL_FAULT"
                                                                            <del>//</del>|
                                      %M28.0
                                  "EXTRACTOR_AT_
                                     REV_POS"
```

Network 21: TT 0 DEG CALL:

```
%M8.6
                    %M9.6
                                     %M9.2
"MANUAL_MODE_ "TT_0_EG_CALL_ "TT_READY_FOR_
ON" PB" ROTATION"
                                                                      %M9.3
                                                                 "TT_0_DEG_CALL"
                                                                      →
   %M8.5
                    %M26.0
"AUTO_MODE_
                 "PICKING_TT_0_
     ON"
                   DEG_ON"
                   %M44.7
                "DROPPING_TT_0_
                   DEG_ON"
```

Network 22: TT 0 DEG POSITION VALUE

```
Totally Integrated
  Automation Portal
                                                             %M9.3
                                                         "TT_0_DEG_CALL"
                                                                           MOVE
                                                                        - EN
                                                                     0 — IN
                                                                                     %MD4
                                                                            "TT_ABS_POS_
VALUE"
Network 23: TT 90 DEG CALL:
                                                             %M8.6
                                                                           %M9.7
                                                                                         %M9.2
                                                                                                                      %M9.4
                                                         "MANUAL_MODE_
                                                                        "TT_90_DEG_
                                                                                     "TT_READY_FOR_
                                                                                                                    "TT_90_DEG_
                                                                          CALL_PB"
                                                                                        ROTATION"
                                                                                                                      CALL"
                                                            %M8.5
                                                                           %M28.1
                                                                       "PICKING_TT_90_
DEG_ON"
                                                          "AUTO_MODE_
                                                             ON"
                                                                          %M47.6
                                                                        "DROPPING_TT_
                                                                         90_DEG_ON"
Network 24: TT 90 DEG POSITION VALUE
                                                            %M9.4
                                                          "TT_90_DEG_
                                                             CALL"
                                                                           MOVE
                                                                        - EN --- ENO -
                                                                 193333 — IN
                                                                                     %MD4
                                                                                     "TT_ABS_POS_
                                                                            OUT1 — VALUE"
```



Network 25: TT 180 DEG CALL:

```
%M8.6
                   %M16.0
                                    %M9.2
                                                                     %M9.5
"MANUAL_MODE_ "TT_180_DEG_
                                "TT_READY_FOR_
                                                                  "TT_180_DEG_
                   CALL_PB"
                                  ROTATION"
                                                                     CALL"
   %M8.5
                   %M26.2
"AUTO_MODE_ "PICKING_TT_180_
ON" DEG_ON"
                   %M45.1
                "DROPPING_TT_
                 180_DEG_ON"
```

Network 26: TT 180 DEG POSITION VALUE

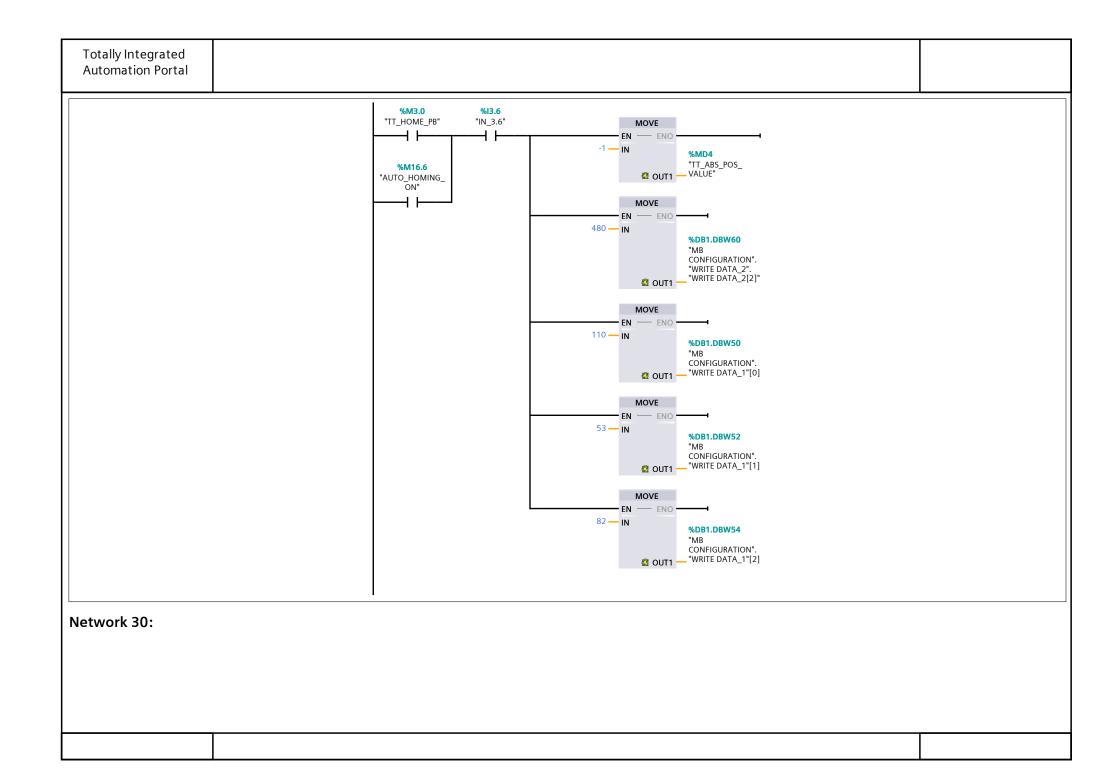
```
*M9.5
"TT_180_DEG_
CALL"

MOVE
EN ENO
N

*MD4
"TT_ABS_POS_
VALUE"
```

Network 27:

Totally Integrated **Automation Portal** %M16.7 %M36.1 %M16.6 %M16.6 "AUTO_HOMING_ "AUTO_HOMING_ ON" ON" %M1.2 %M1.0 "PICKING_AUTO_ CYCLE_ON" "DROPPING_ AUTO_CYCLE_ON" "AlwaysTRUE" "FirstScan" _(s)____ %M8.6 "MANUAL_MODE_ ON" %M1.2 %10.1 "AlwaysTRUE" "IN_0.1" Network 28: %M16.6 %M16.6 "AUTO_HOMING_ **%I3.7** "AUTO_HOMING_ "IN_3.7" ON" ON" –(R)—— **Network 29: HOMMING**



Totally Integrated Automation Portal		
	*M49.3 "EMG_STOP_ FAULT" "OUT_3.3" *\Q3.4 "OUT_3.4" ()	