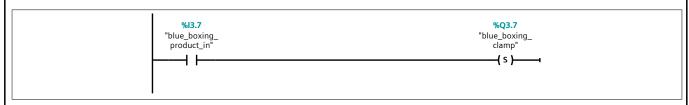
Totally Integrated Automation Portal					
IA_Project / PLC_1 [CPU 1511-1 PN] / Program blocks / 07 blue boxing line					
blue_boxing_line [FB8]					

blue_boxing_line Properties								
General								
Name	blue_boxing_line	Number	8	Туре	FB			
Language	LAD	Numbering	Automatic					
Information								
Title		Author		Comment				
Family		Version	0.1	User-defined				
				ID				

lue_boxing_line					
Vame	Data type	Default value			
<b>▼</b> Input					
RST	Bool	false			
<b>▼</b> Output					
box_count	Int	0			
in_box_count	Int	0			
boxing	Bool	false			
InOut					
▼ Static					
M1	Bool	false			
M2	Bool	false			
step_done	Bool	false			
box_entered	Bool	false			
increament_in_box	Bool	false			
in_box_rst	Bool	false			
in_box_counter	CTU_INT				
box_counter	CTU_INT				
step	Int	1			
Temp					
Constant					

## Network 1: Clamp the final product in place

step 0 is only for initialization



### Network 2:

# Totally Integrated **Automation Portal** %Q3.6 "blue\_boxing\_ box\_belt" #box\_entered -( s )-**-//**| %Q4.1 "blue\_boxing\_ stop\_blade" -( R )-Network 3: -%13.6 %Q3.6 "blue\_boxing\_ box\_in" "blue\_boxing\_ box\_belt" **⊣**₽ **⊢** \_( R )\_ #M1 %Q4.1 "blue\_boxing\_ stop\_blade" **-(** s )− #box\_entered **-(** s **)**-#in\_box\_rst **→** > Network 4: #step #step\_done MOVE #step\_done | == | | | Int | - EN ENO --( R )-2 — IN 👑 OUT1 — #step Network 5: #step MOVE #step\_done #step\_done $\dashv \vdash$ EN ENO **—(** R **)**— Int 3 — IN 🚜 OUT1 — #step Network 6:

```
Totally Integrated
           Automation Portal
                                                                                                                                                                                                       #step_done MOVE
EN ENO
4 IN @ OUT1 #step
                                                                                                                                                                                                                                                                                                                                                                                                    #step_done
                                                                                                                                                 == |
Int |
                                                                                                                                                                                                                                                                                                                                                                                                                ——( R )——
Network 7:
                                                                                                                                                #step #step_done #step
Network 8:
                                                                                                                                                Network 9:
                                                                                                                                                                         #step
                                                                                                                                                                                                                                                                                                                                                                                                    #step_done
                                                                                                                                                 ==
Int
                                                                                                                                                                                                                                                                                                                                                                                                                  —( R )——
Network 10:
                                                                                                                #step
                                                                                                                                                                    #step_done
                                                                                                                                                                                                                                                                                                                                                                                     —( R )—
                                                                                                                 Int
                                                                                                                                                                                                                                                                                                                                                                            #in_box_count
                                                                                                                                                                                                                                                                                                                                                                                                                                              #box_entered
                                                                                                                                                                                                                                                                                                                                                                                     == |
Int |
                                                                                                                                                                                                                                                                                                                                                                                                                                                    —( R )——
Network 11:
```

# Totally Integrated **Automation Portal** #step "blue\_boxing\_move\_to\_XYZ" == | Int | - EN ENO -0.3 — X done →#step\_done 2.5 — Y 0.0 — Z #boxing -( R )-Network 12: **%Q3.7**"blue\_boxing\_ clamp" %FC4 #step "blue\_boxing\_move\_to\_XYZ" - EN ENO -Int 0.3 — X done →#step\_done 2.5 — Y 8.0 **—** Z #boxing \_( s )\_ Network 13: %Q4.0 "blue\_boxing\_ grab" #step |==| |nt| -( s )-**%Q3.7**"blue\_boxing\_ clamp" -( R )-#step\_done -( s )-Network 14: %FC4 #step "blue\_boxing\_move\_to\_XYZ" == Int - EN ENO · 0.3 — X done →#step\_done 2.5 — Y 0.0 **—** Z Network 15:

#### 

#### Network 16:

```
%FC4
#step
             #in_box_count
                                                  "blue_boxing_move_to_XYZ"
                 ==
Int
==
Int
                                               - EN
                                                                         ENO ·
                                          6.1 — X
                                                                         done →#step_done
                  0
                                          1.3 — Y
                                         10.0 — Z
             #in_box_count
                                                  "blue_boxing_move_to_XYZ"
                 ==
Int
                                               - EN
                                                                         ENO ·
                                          6.1 — X
                                                                         done →#step_done
                                          1.3 — Y
                                          8.5 — Z
             #in_box_count
                                                  "blue_boxing_move_to_XYZ"
                 ==
Int
                                               - EN
                                                                         ENO
                                          6.1 — X
                                                                         done →#step_done
                                          1.3 — Y
                                          6.0 — Z
```

#### Network 17: -

#### Network 18:

# Totally Integrated Automation Portal #in\_box\_counter #increament\_ in\_box CTU Int <del>|</del> | | · CU CV — #in\_box\_count #RST 4 F 9999 **— PV** #in\_box\_rst $\dashv$ $\vdash$ Network 19: #box\_counter CTU Int #box\_entered · CU #M2 CV — #box\_count #RST 9999 — PV Network 20: MOVE - EN ENO #box\_count — IN %QW38 "blue\_boxing\_ box\_count" Network 21:

Totally Integrated Automation Portal			
	#RST	MOVE EN ENO  1 — IN   2 OUT1 — #step	<b>-</b>
		#M1	<b>→</b>
	_	#M2 ————————————————————————————————————	<b>-</b> -
	-	#step_done ————————————————————————————————————	<b>-</b> -
	-	#box_entere 	d —
		#increament in_box 	- <b>→</b>
		#in_box_rs'	
	1		