_	oxing_line [FB7]				
	g_line Properties				
General		lla a			
Name	green_boxing_line	Number	7	Type FB	
anguage nformation	LAD	Numbering	Automatic		
itle		Author		Comment	
amily		Version	0.1	User-defined	
uniny		Version	0.1	ID	
		'			
reen_boxin	g_line		Data tour	Default :!:-	
lame			Data type	Default value	
▼ Input					
RST			Bool	false	
Output					
box_co	unt		Int	0	
in_box_	_count		Int	0	
boxing			Bool	false	
InOut					
Static					
M1			Bool	false	
M2			Bool	false	
step_do	one		Bool	false	
box_en	tered		Bool	false	
increan	nent_in_box		Bool	false	
in_box	_rst		Bool	false	
in_box_	_counter		CTU_INT		
box_co	unter		CTU_INT		
step			Int	1	
Temp					
Constant					
Network 1	: Clamp the final pr	oduct in place	2		
	%I3.5 "green_boxing product_in"	_		%Q3.3 "green_boxing_ clamp"  ( S )	

## Totally Integrated **Automation Portal** %Q3.2 "green\_boxing\_ box\_belt" #box\_entered **-(** s **)**--**-//**| %Q3.4 "green\_boxing\_ stop\_blade" \_( R )\_ Network 3: -%13.4 %Q3.2 "green\_boxing\_ box\_in" "green\_boxing\_ box\_belt" **⊣**₽ **⊢** -( R )-#M1 %Q3.4 "green\_boxing\_ stop\_blade" **-(** s **)**-#box\_entered \_( s )\_ #in\_box\_rst $\leftarrow$ $\succ$ 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** %FC1 #step "green\_boxing\_move\_to\_XYZ" == | Int | - EN ENO -0.3 — X done →#step\_done 2.5 — Y 0.0 — Z #boxing -( R )-Network 12: **%Q3.3**"green\_boxing\_ clamp" %FC1 #step "green\_boxing\_move\_to\_XYZ" Int I - EN ENO -0.3 — X done →#step\_done 2.5 — Y 8.0 **—** Z #boxing \_( s )\_ Network 13: %Q3.5 "green\_boxing\_ grab" #step |==| |nt| (s)— %Q3.3 "green\_boxing\_ clamp" -( R )-#step\_done -( s )-Network 14: %FC1 #step "green\_boxing\_move\_to\_XYZ" == Int - EN ENO · 0.3 — X done -#step\_done 2.5 — Y 0.0 **—** Z Network 15:

#### 

#### Network 16:

```
%FC1
#step
             #in_box_count
                                                 "green_boxing_move_to_XYZ"
                 ==
Int
==
Int
                                               - EN
                                                                         ENO ·
                                          6.1 — X
                                                                        done →#step_done
                  0
                                         0.5 — Y
                                          9.0 — Z
             #in_box_count
                                                 "green_boxing_move_to_XYZ"
                ==
Int
                                               - EN
                                                                         ENO -
                                          6.1 — X
                                                                        done →#step_done
                                          0.5 — Y
                                          6.5 — Z
             #in_box_count
                                                "green_boxing_move_to_XYZ"
                 ==
Int
                                               - EN
                                                                         ENO
                                          6.1 — X
                                                                        done →#step_done
                                         0.5 — Y
                                          4.0 — 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 #box\_count — IN %QW30 "green\_boxing\_ box\_count" Network 21:

Automation Portal			
	#RST	MOVE EN ENO 1 — #step	
		#M1	
		#M2 	
		#step_done	
	_	#box_entered R }	
		#increament_ in_box 	
		#in_box_rst 	
	<u> </u>		