

IA_Project / PLC_1 [CPU 1511-1 PN] / Program blocks / 02 green CNC line green_CNC_line [FB1]

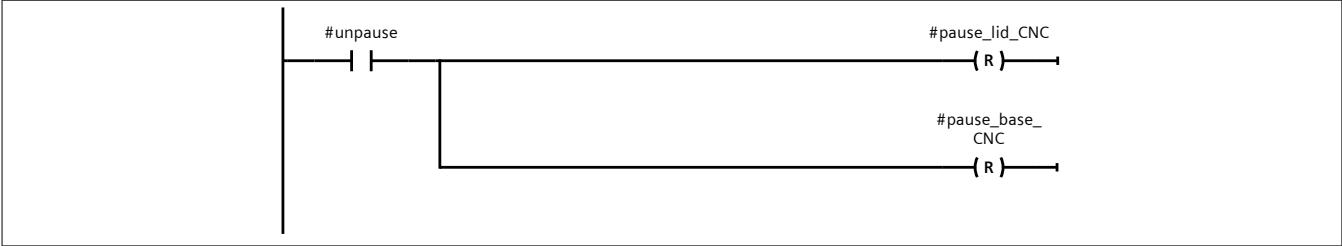



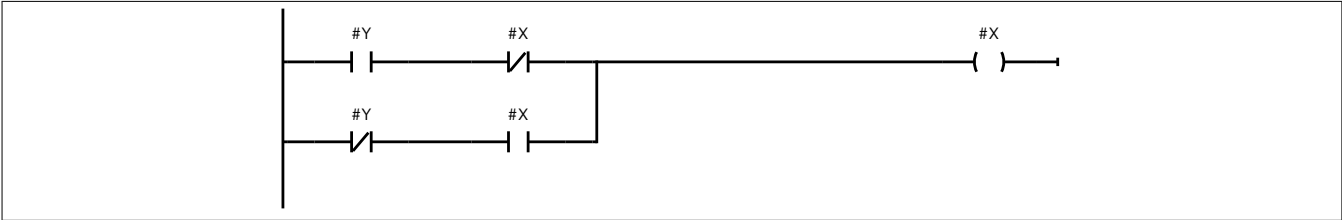
green_CNC_line Properties					
General					
Name	green_CNC_line	Number	1	Type	FB
Language	LAD	Numbering	Automatic		
Information					
Title		Author		Comment	
Family		Version	0.1	User-defined ID	

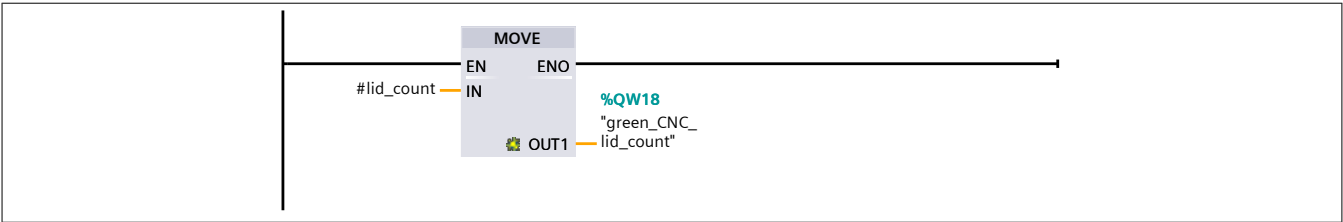
green_CNC_line		
Name	Data type	Default value
▼ Input		
RST	Bool	false
unpause	Bool	false
▼ Output		
base_count	Int	0
lid_count	Int	0
base_CNC_on	Bool	false
lid_CNC_on	Bool	false
InOut		
▼ Static		
M1	Bool	false
M2	Bool	false
activate_pusher	Bool	false
X	Bool	false
Y	Bool	false
pause_base_CNC	Bool	false
pause_lid_CNC	Bool	false
base_counter	CTU_INT	
lid_counter	CTU_INT	
Temp		
Constant		

Network 1: Start signal of the CNC responsible for producing green bases



Network 2:

Totally Integrated Automation Portal		
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Network 8:		
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Network 9:		
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Network 10:		
<div></div>		
Network 11: this network toggles X when Y activates		
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Network 12:		



Network 17:

