Totally Integrated Automation Portal		
IA_Project / PLC_blue_CNC_line [FB	_1 [CPU 1511-1 PN] / Program blocks / 05	blue CNC line
blue_CNC_line Properties		

blue_CNC_lin	ne Properties				
General					
Name	blue_CNC_line	Number	4	Туре	FB
Language	LAD	Numbering	Automatic		
Information					
Title		Author		Comment	
Family		Version	0.1	User-defined	
				ID	

<u> </u>	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
Υ	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 blue bases



Network 2:

```
Totally Integrated
   Automation Portal
                                                                                                                        %Q1.7
"blue_CNC_
base_start"
                                           %12.2
                                        "blue_CNC_
                                      base_produced"
                                                                                                                           -( R )-
                                           +
                                                                                                                      #pause_base_
CNC
                                                                                                                          (s)——
Network 3:
                                        %Q1.7
"blue_CNC_
base_start"
                                                                                                                      #base_CNC_on
                                           <del>1</del> F
                                                                                                                          <del>(</del> )—
Network 4:
                                      %I2.4
"blue_CNC_lid_
loaded"
                                                                                                                      %Q2.0
"blue_CNC_lid_
start"
                                                         #pause_lid_CNC
                                           -1/|-
                                                                                                                          (s)——
Network 5:
                                      %I2.5
"blue_CNC_lid_
produced"
                                                                                                                      %Q2.0
"blue_CNC_lid_
start"
                                           -( R )---
                                                                                                                     #pause_lid_CNC
                                                                                                                         —( s )——
Network 6:
                                          %Q2.0
                                      "blue_CNC_lid_
start"
                                                                                                                       #lid_CNC_on
                                           H F
                                                                                                                          ⊣ )–
Network 7:
```

```
Totally Integrated
  Automation Portal
                                     #unpause
                                                                                                          #pause_lid_CNC
                                      \dashv \vdash
                                                                                                              -( R )---
                                                                                                           #pause_base_
CNC
                                                                                                               -( R )-
Network 8:
                                                                                                            %Q3.0
"blue_CNC_
base_belt"
                                      %I2.1
                                   "blue_CNC_
base_loaded"
Network 9:
                                      %I2.4
                                                                                                              %Q3.1
                                  "blue_CNC_lid_
loaded"
                                                                                                          "blue_CNC_lid_
belt"
Network 10:
                                   %I2.3
"blue_CNC_in_
sensor"
                                                                                                               #Y
                                       \dashv P \vdash
                                       #M2
Network 11: this network toggles X when Y activates
                                        #Y
                                                         #X
                                                                                                               #X
                                                         <del>1</del>/}
                                                                                                               1 H
                                        #Y
                                                         #X
Network 12:
```

Totally Integrated **Automation Portal %Q2.1**"blue_CNC_ pusher" #X SR **-**|₽|-Q #M1 **%I2.6** "blue_CNC_ pusher_limit" Network 13: #base_counter %12.2 "blue_CNC_ base_produced" CTU CU cv — #base_count #RST 9999 — PV Network 14: MOVE EN ENO #base_count — IN %QW20 "blue_CNC_ base_count" Network 15: #lid_counter **%12.5** CTU "blue_CNC_lid_ produced" Int CU cv — #lid_count #RST 9999 — PV Network 16:

