

Totally Integrated Automation Portal

IA\_Project / PLC\_1 [CPU 1511-1 PN] / Program blocks / 04 green boxing line

green\_boxing\_line [FB7]

green\_boxing\_line Properties

General

Name	green_boxing_line	Number	7	Type	FB
Language	LAD	Numbering	Automatic		

Information

Title		Author		Comment	
Family		Version	0.1	User-defined ID	

green\_boxing\_line

Name	Data type	Default value
▼ Input		
RST	Bool	false
▼ 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

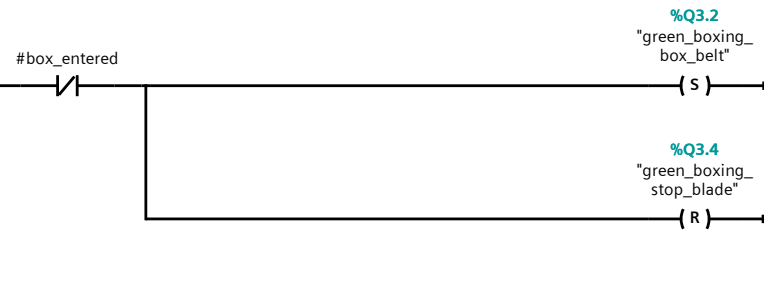
step 0 is only for initialization

%I3.5  
"green\_boxing\_  
product\_in"

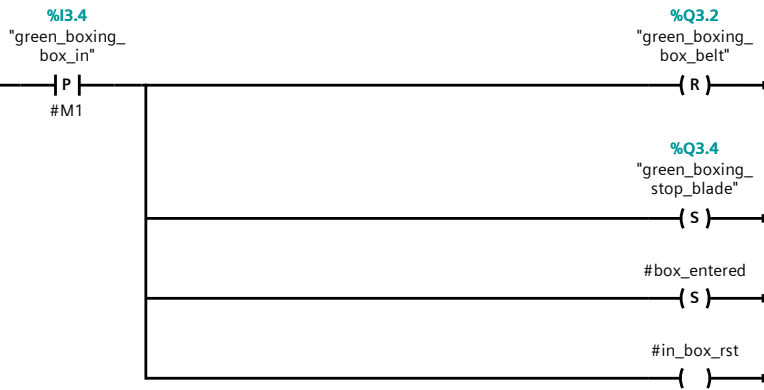
%Q3.3  
"green\_boxing\_  
clamp"

( S )

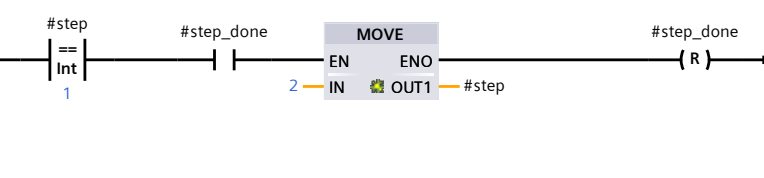
Network 2:



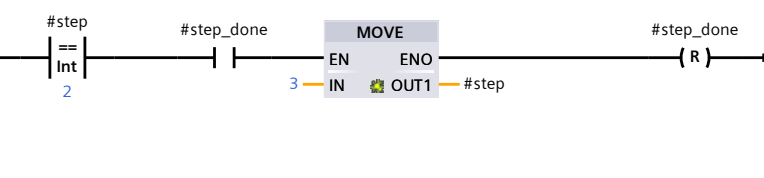
Network 3: -



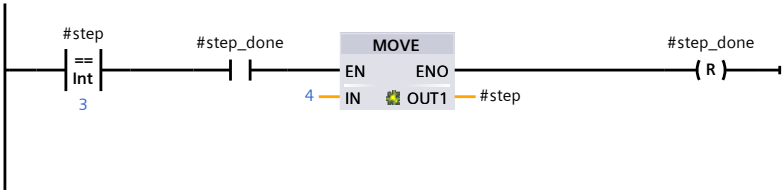
Network 4:



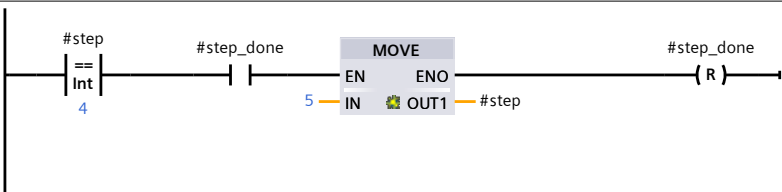
Network 5:



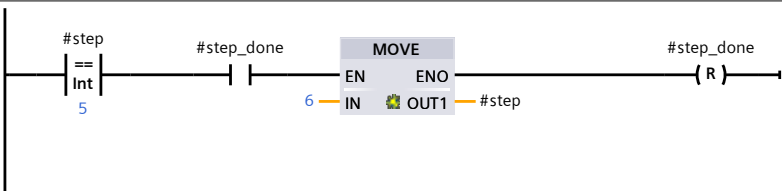
Network 6:



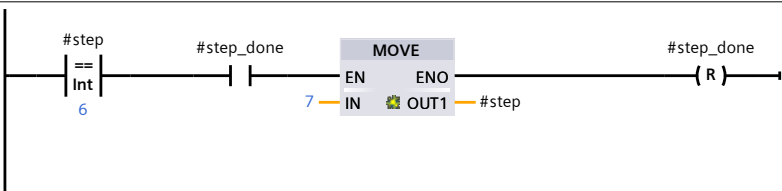
Network 7:



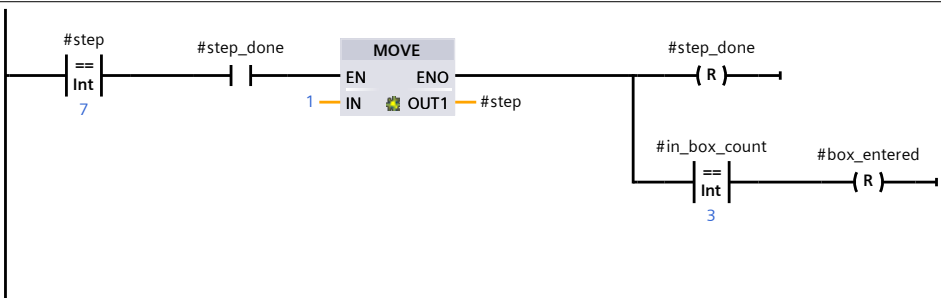
Network 8:



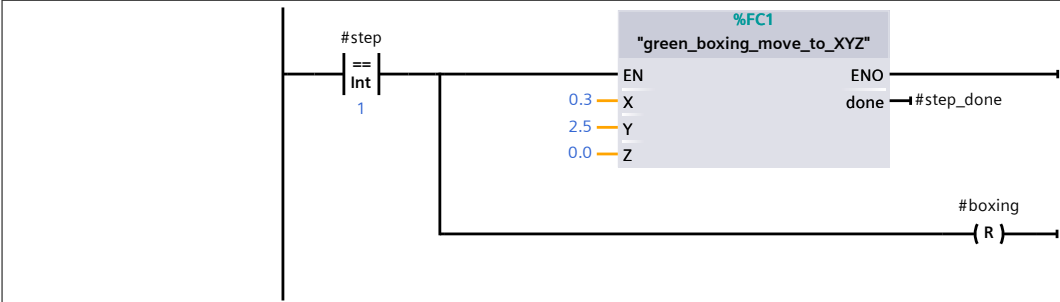
Network 9:



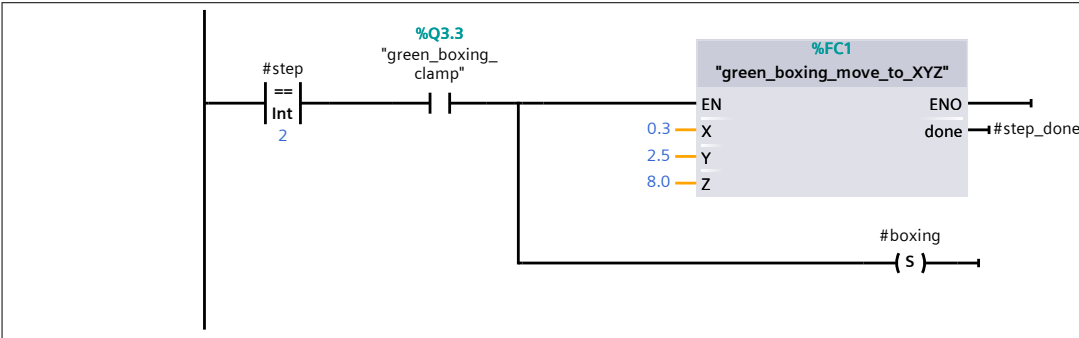
Network 10:



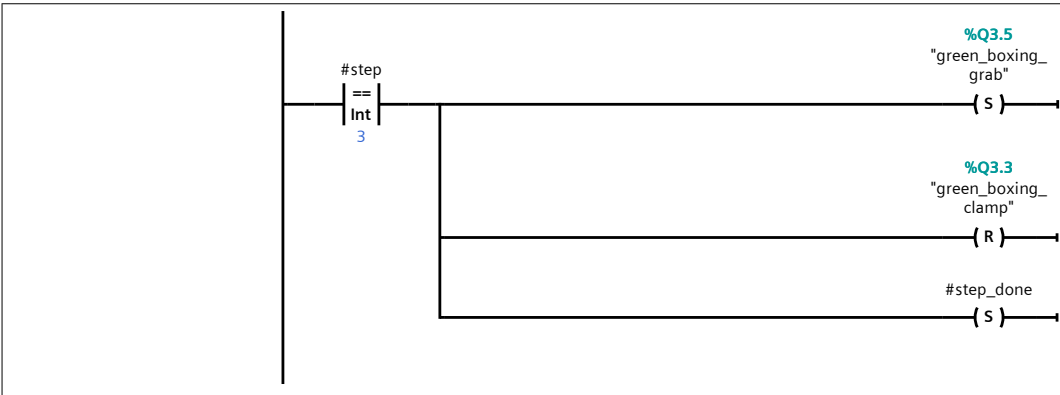
Network 11:



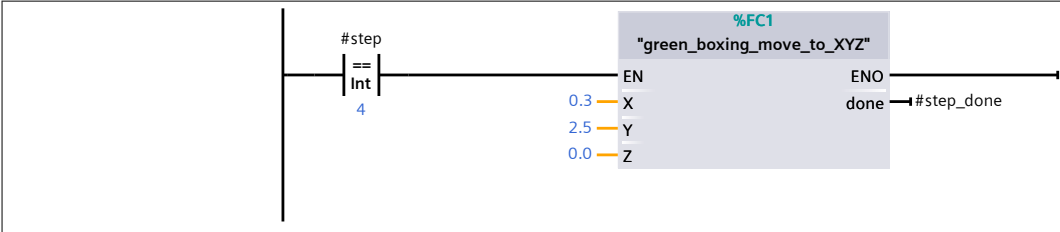
Network 12:



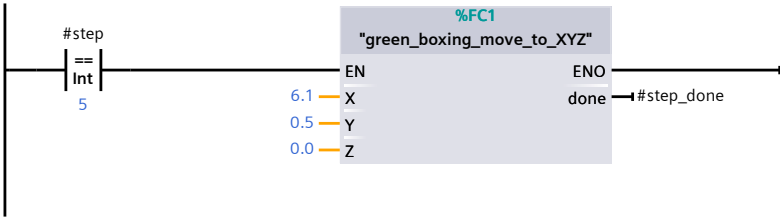
Network 13:



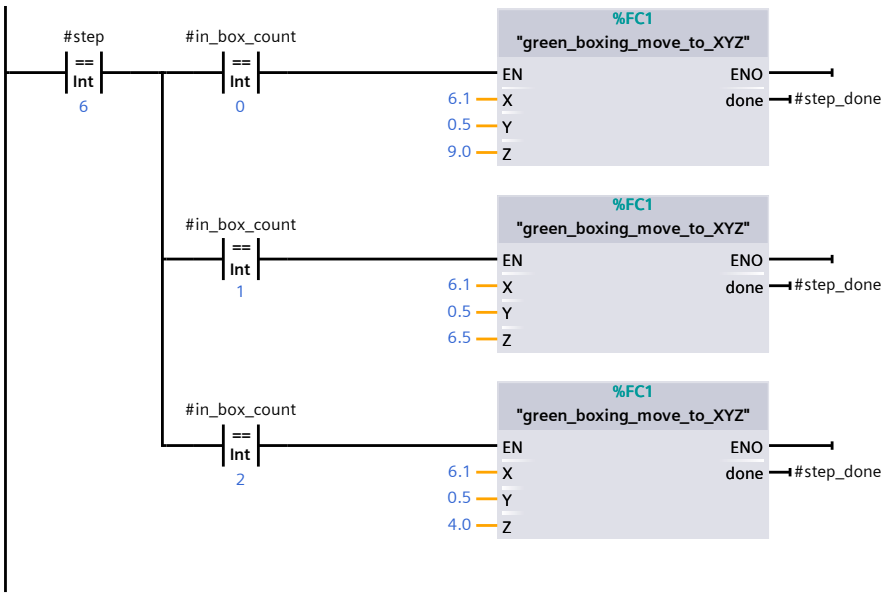
Network 14:



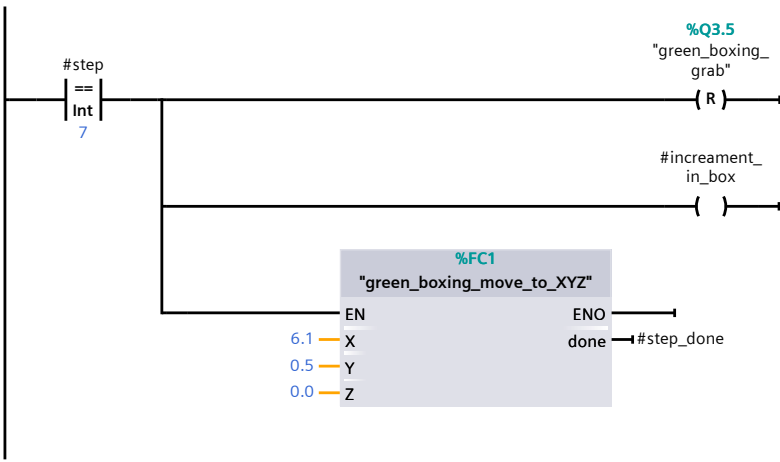
Network 15:



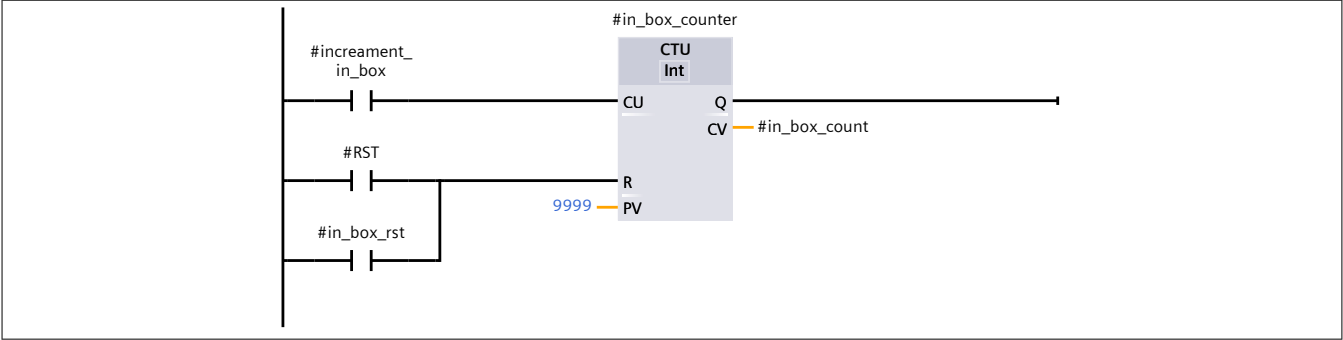
Network 16:



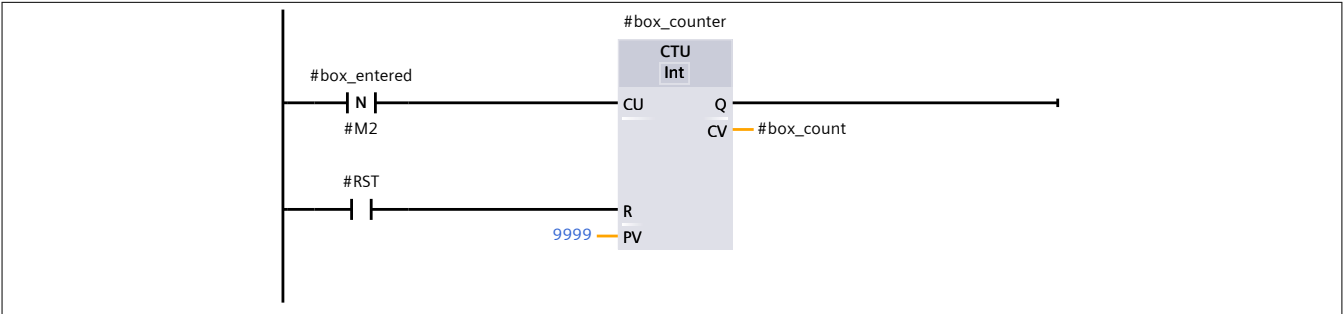
Network 17: -



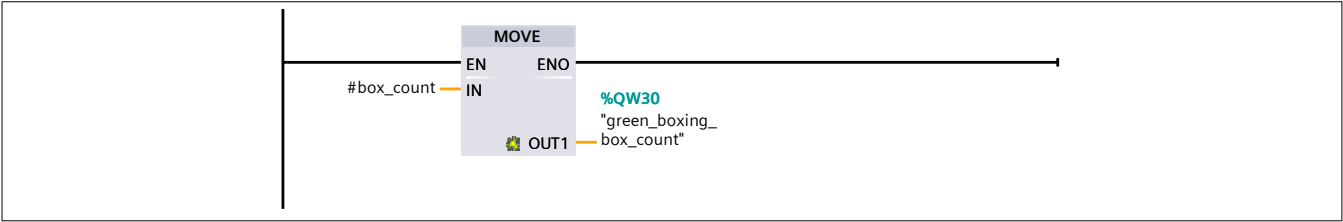
Network 18:



Network 19:



Network 20:



Network 21:

