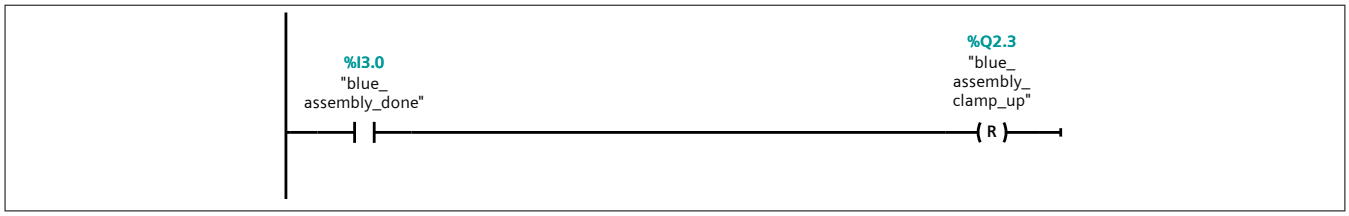
IA_Project / PLC_1 [CPU 1511-1 PN] / Program blocks / 06 blue assembly line

blue_assembly_line [FB5]

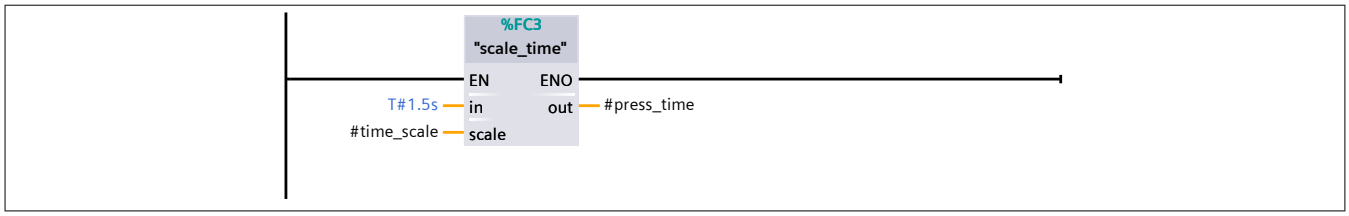
blue_assembly_line Properties					
General					
Name	blue_assembly_line	**Number**	5	**Type**	FB
Language	LAD	**Numbering**	Automatic		
Information					
Title		**Author**		**Comment**	
Family		**Version**	0.1	**User-defined ID**	

blue_assembly_line		
Name	**Data type**	**Default value**
▼ Input		
RST	Bool	false
time_scale	Real	0.0
▼ Output		
assembly_count	Int	0
assembling	Bool	false
InOut		
▼ Static		
step	Int	1
M1	Bool	false
M2	Bool	false
M3	Bool	false
M4	Bool	false
M5	Bool	false
M6	Bool	false
step_done	Bool	false
product_counter	CTU_INT	
press_timer	TON_TIME	
press	Bool	false
press_time	Time	T#0ms
Temp		
Constant		

Network 1: Raise the base clamp to allow the final product to exit the assembly line



Network 2:



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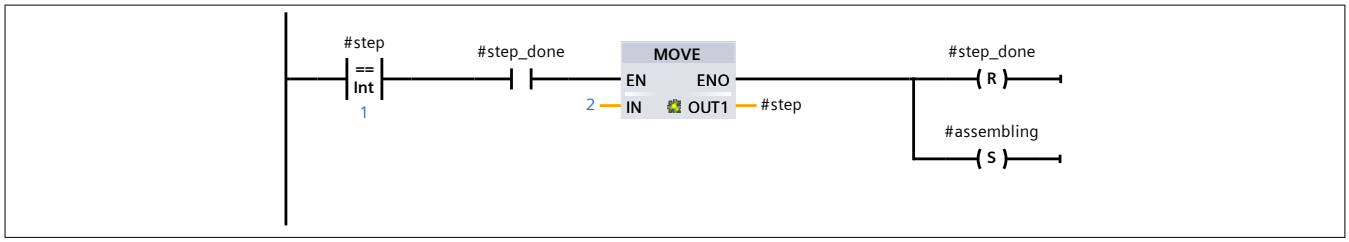

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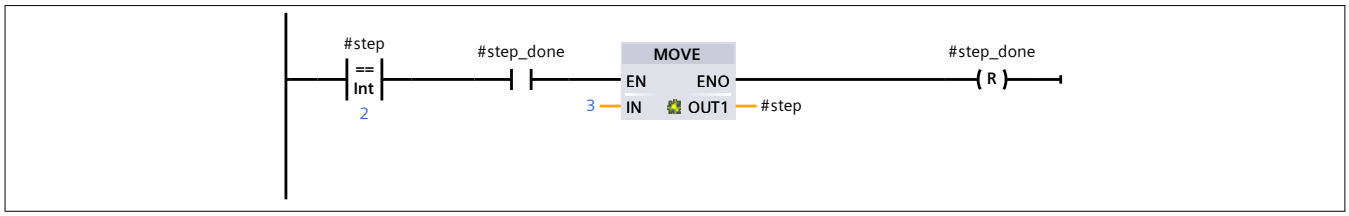

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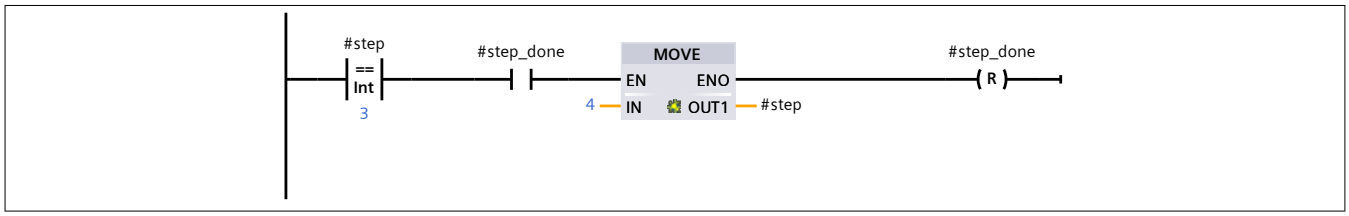

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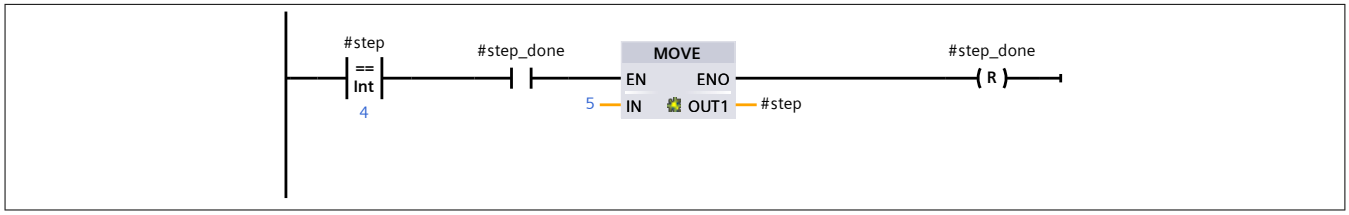

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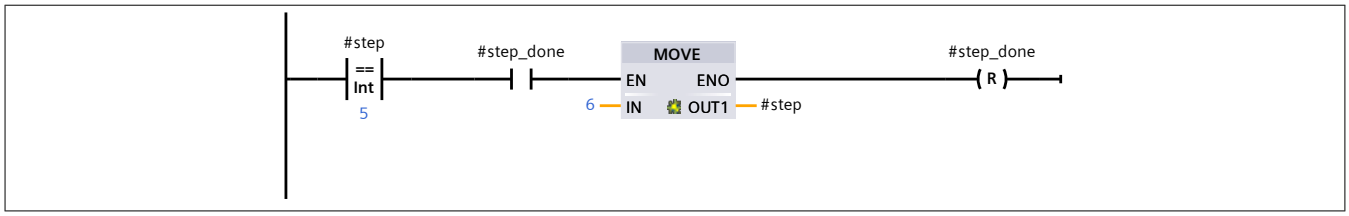

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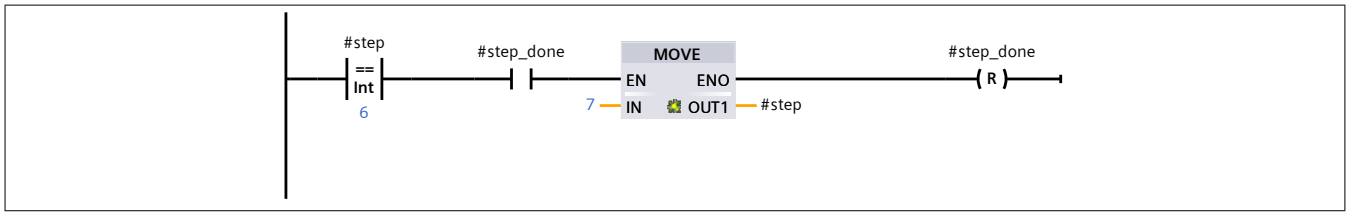

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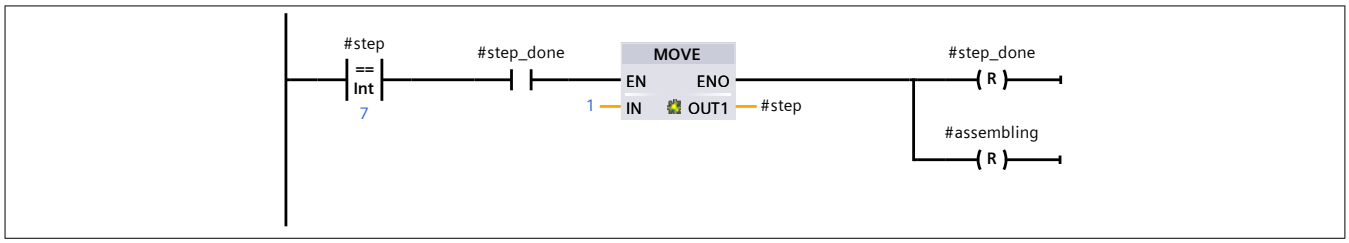
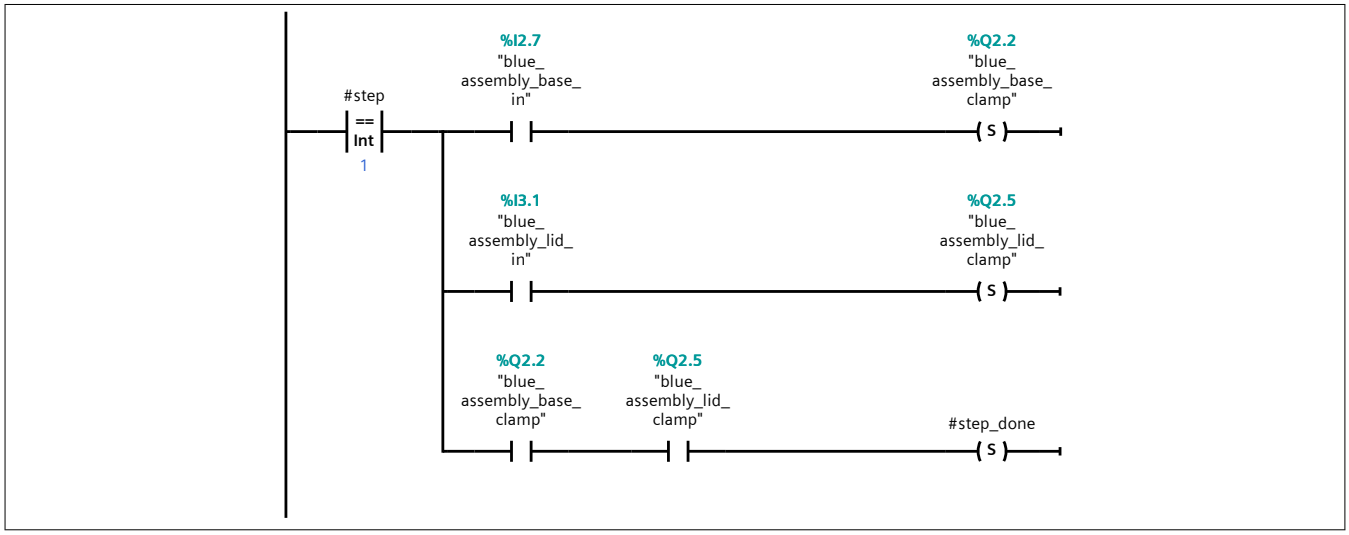
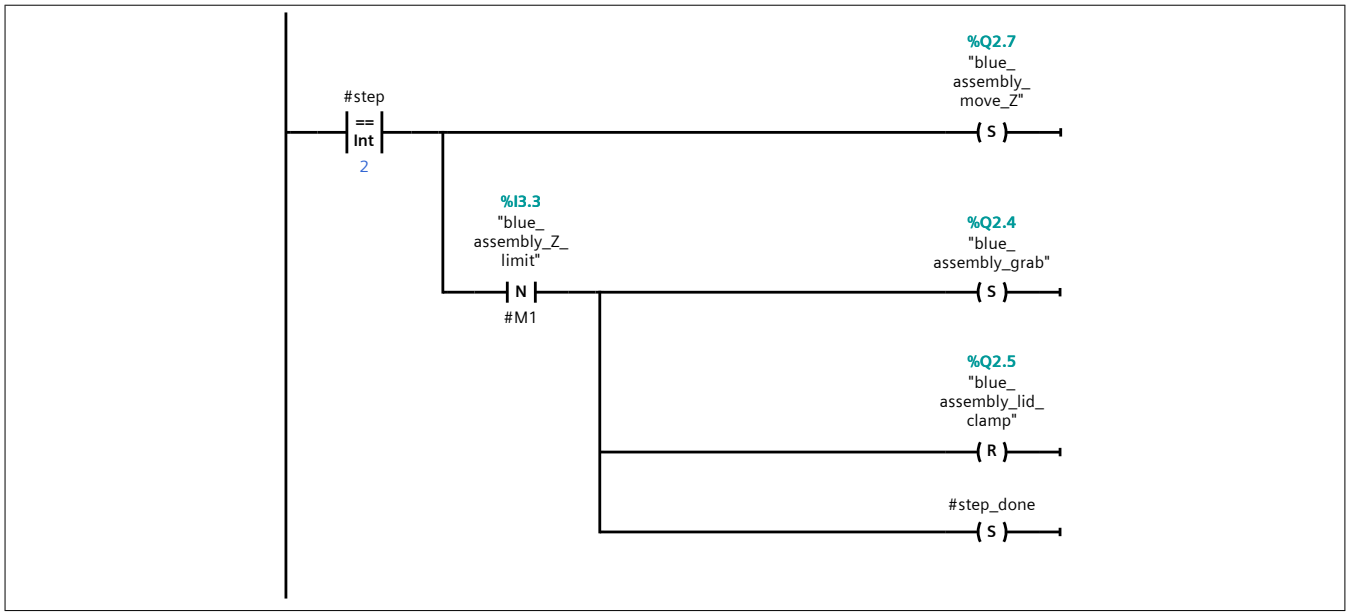


Network 10:



Network 11:



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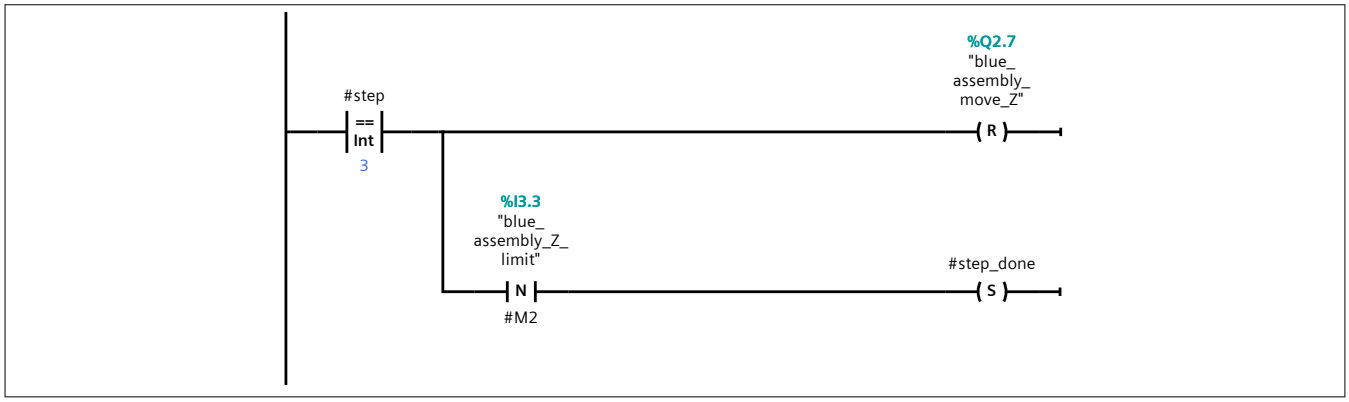
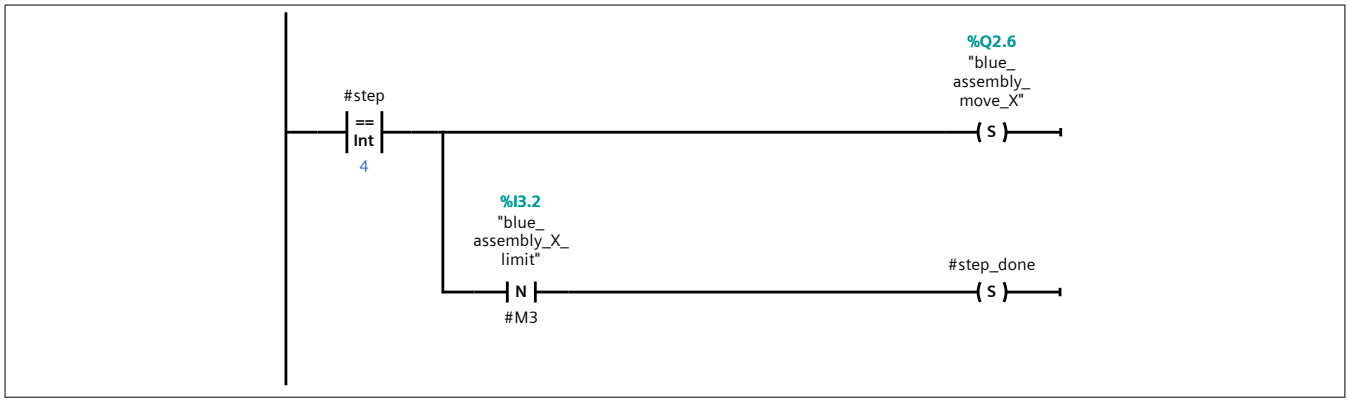
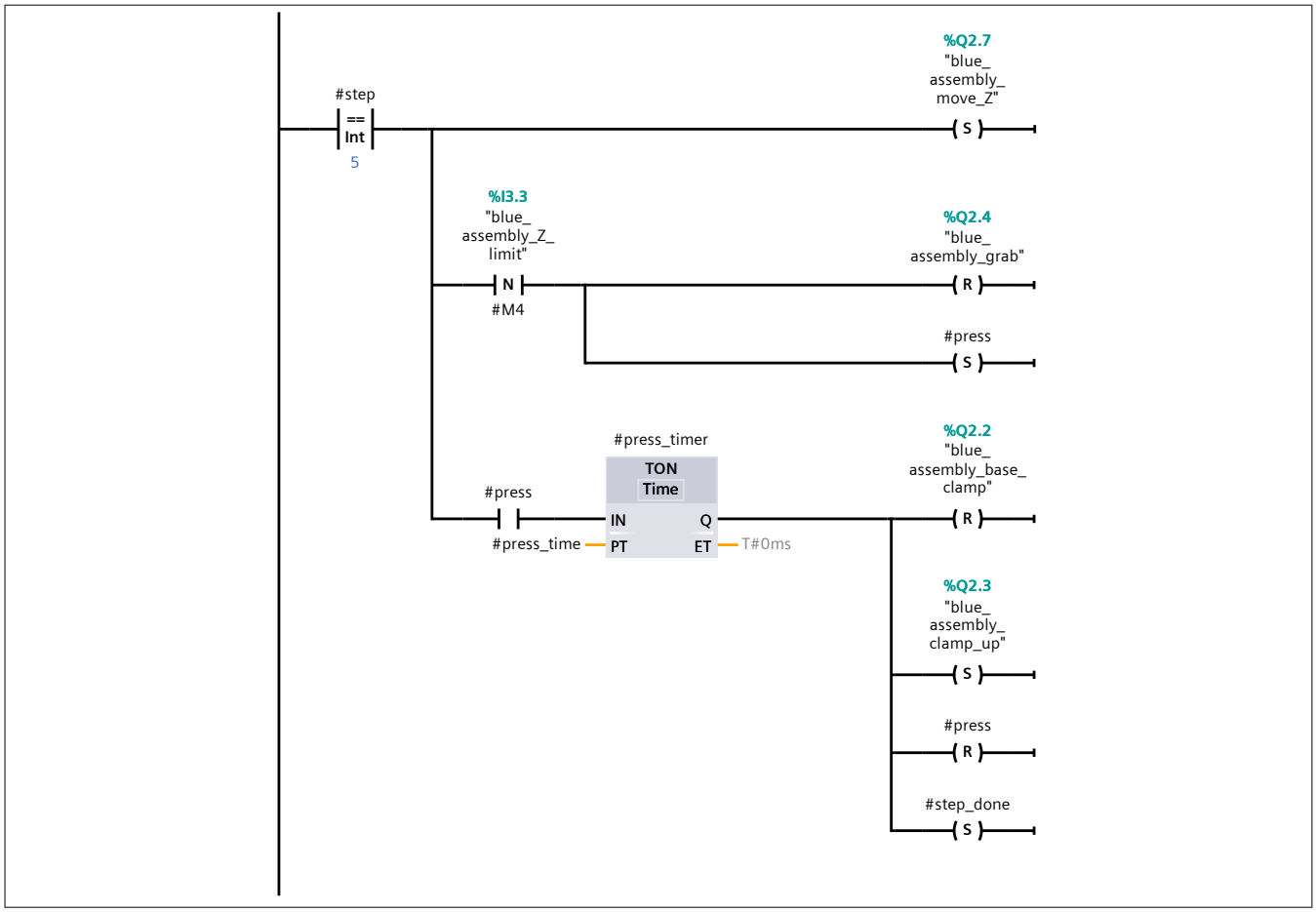


Network 13:



Network 14: 0 = gripper is up , 1= gripper is down



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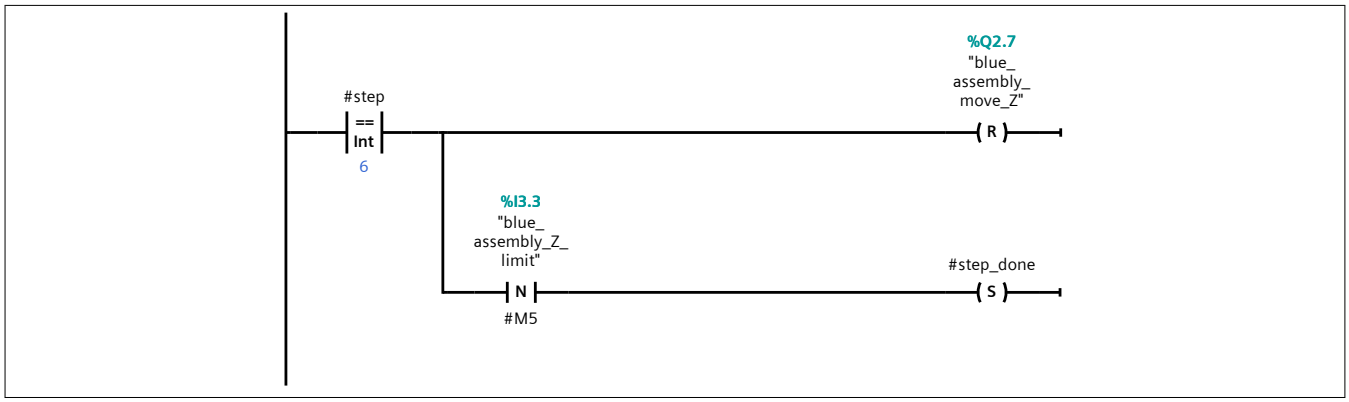
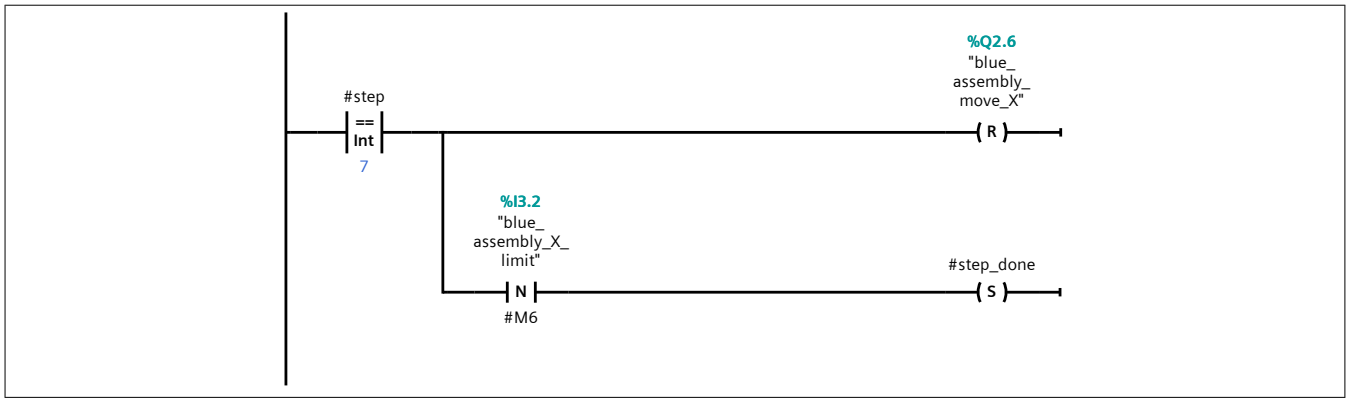
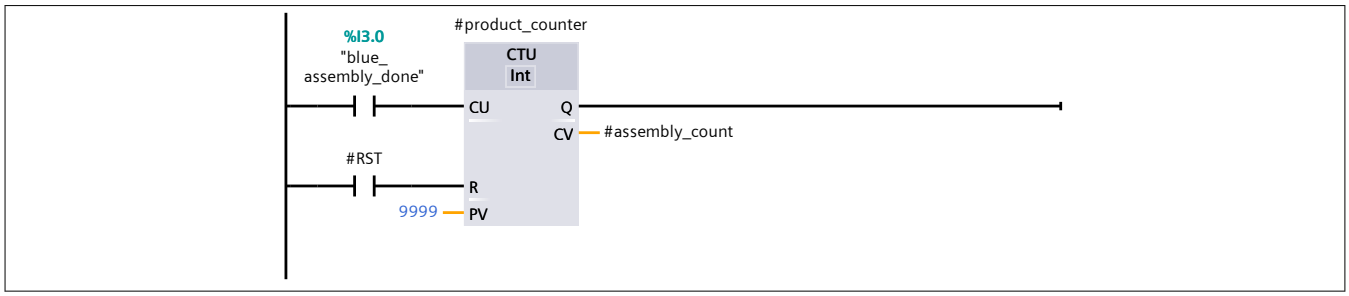


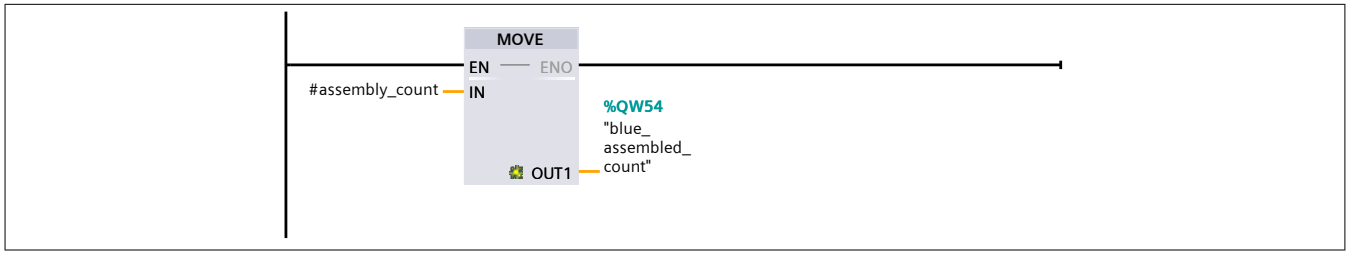
Network 16:



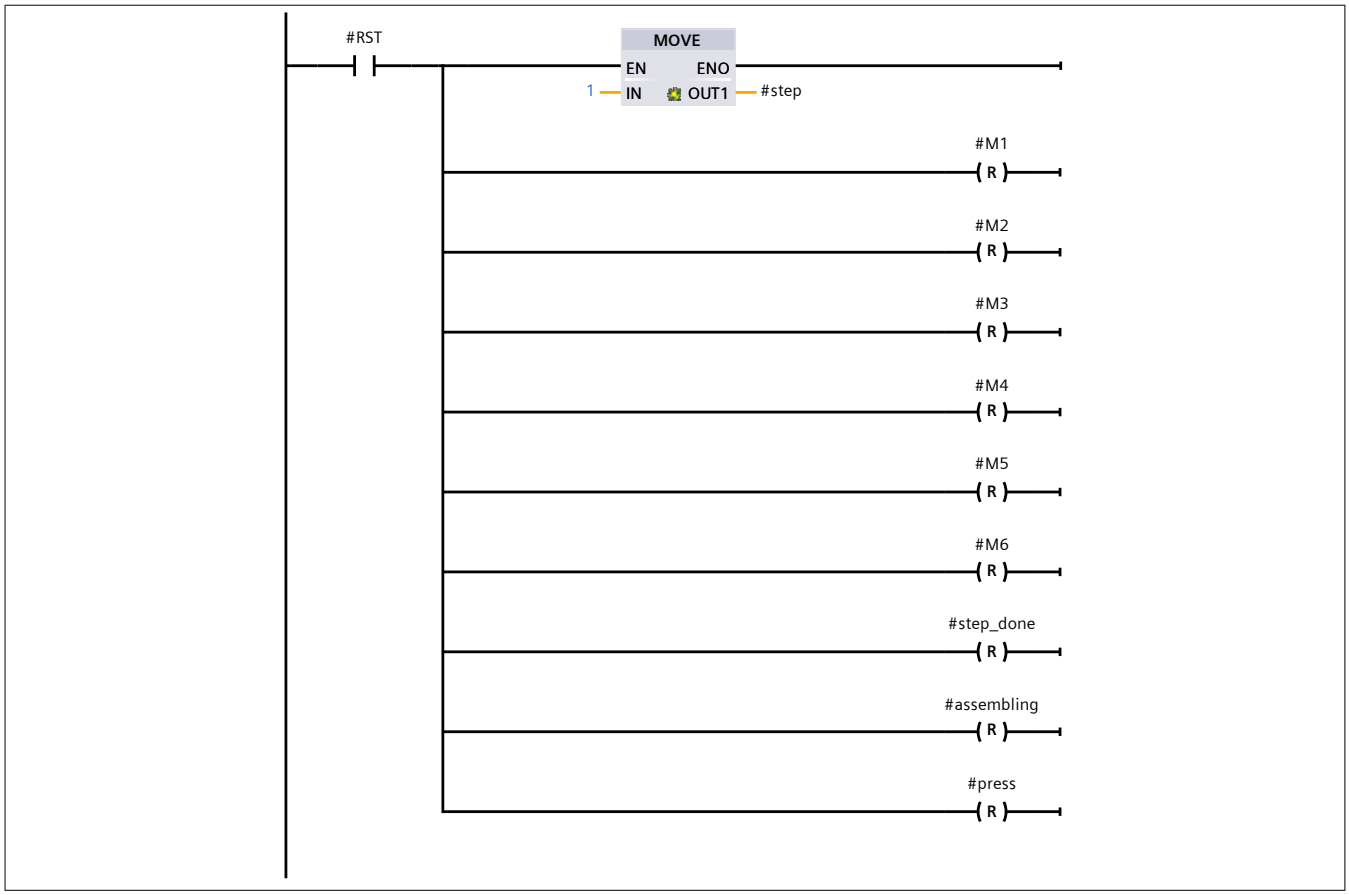
Network 17:



Network 18:



Network 19:


#RST
MOVE
EN
ENO
1
IN
OUT1
#step
#M1
R
#M2
R
#M3
R
#M4
R
#M5
R
#M6
R
#step_done
R
#assembling
R
#press
R