IA_Project / PLC_1 [CPU 1511-1 PN] / Program blocks / 07 blue boxing line

blue_boxing_line [FB8]

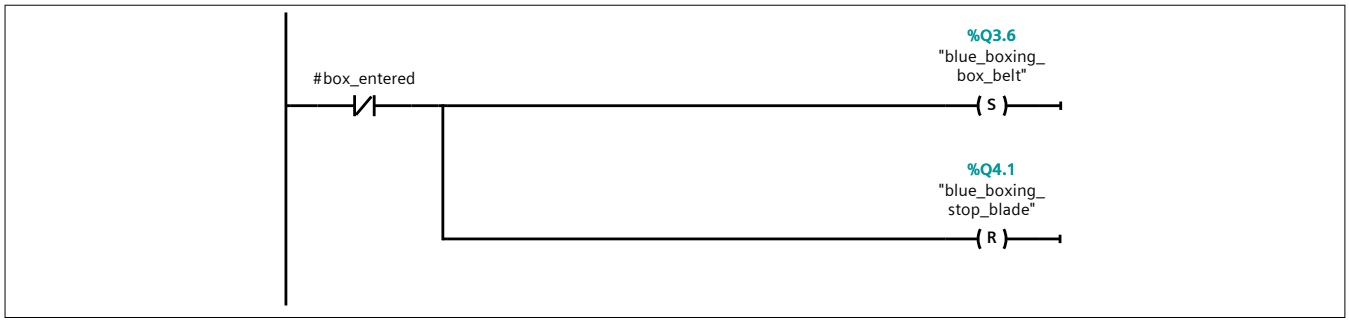
blue_boxing_line Properties					
General					
Name	blue_boxing_line	**Number**	8	**Type**	FB
Language	LAD	**Numbering**	Automatic		
Information					
Title		**Author**		**Comment**	
Family		**Version**	0.1	**User-defined ID**	

blue_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		

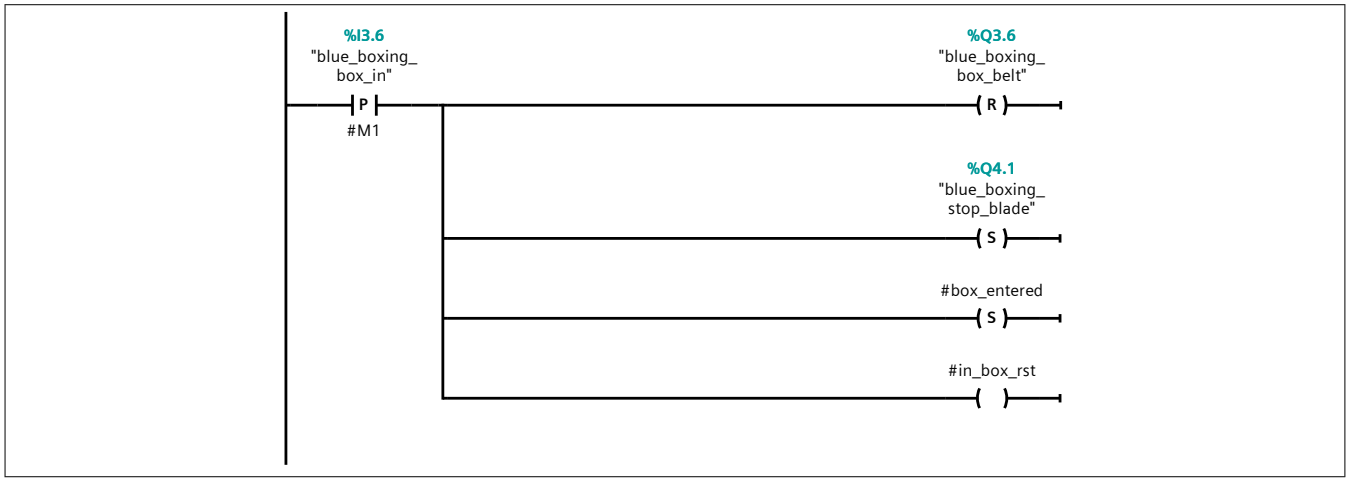
Network 1: Clamp the final product in place

step 0 is only for initialization

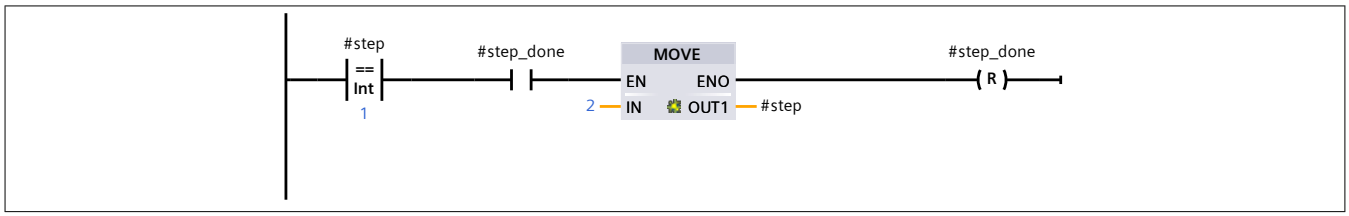
Network 2:



Network 3: -



Network 4:



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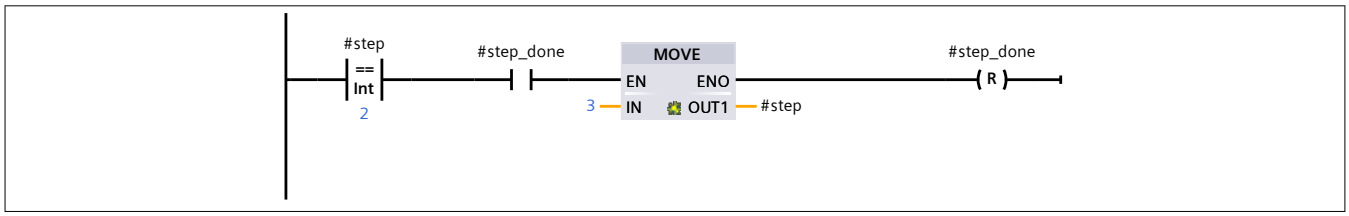

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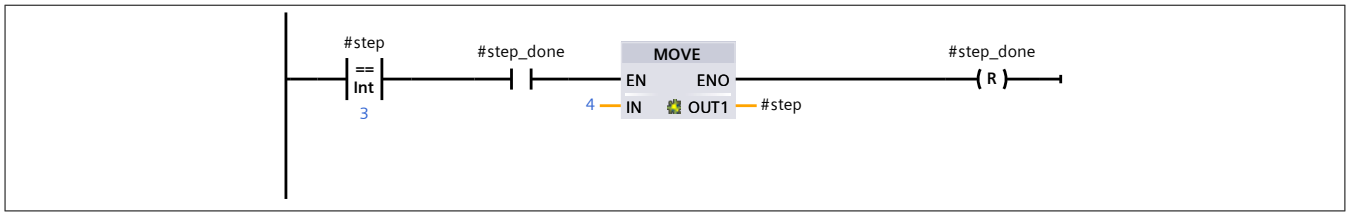

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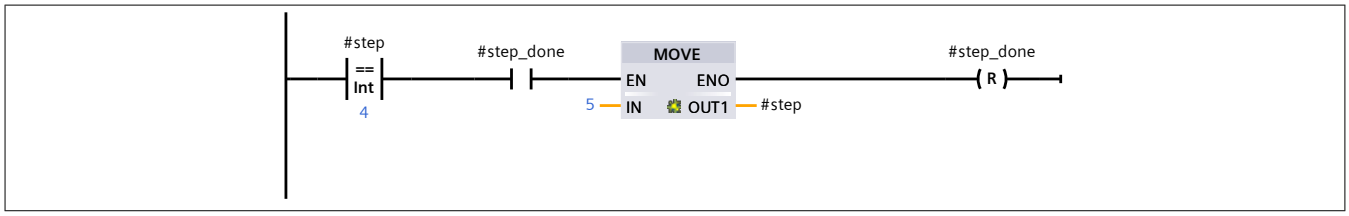

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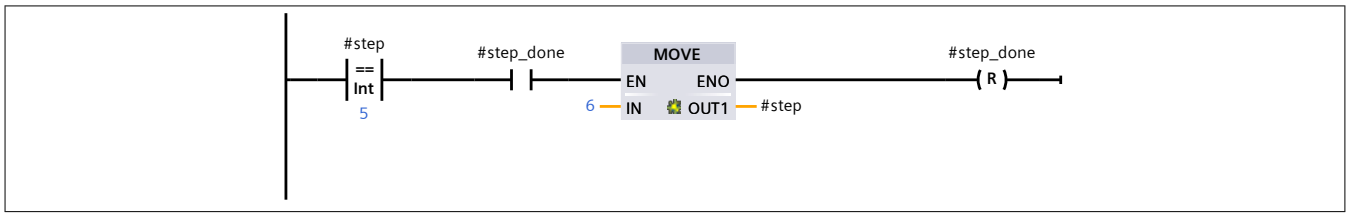

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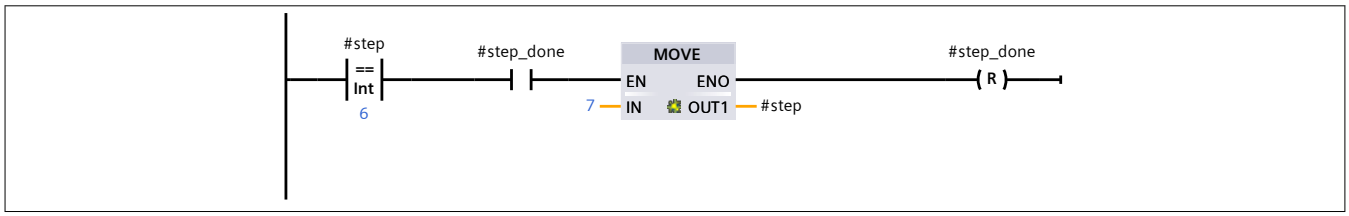

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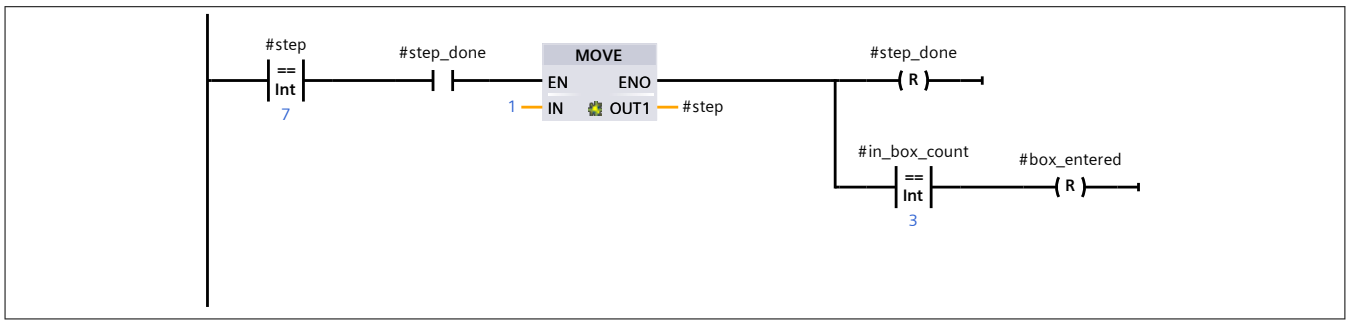

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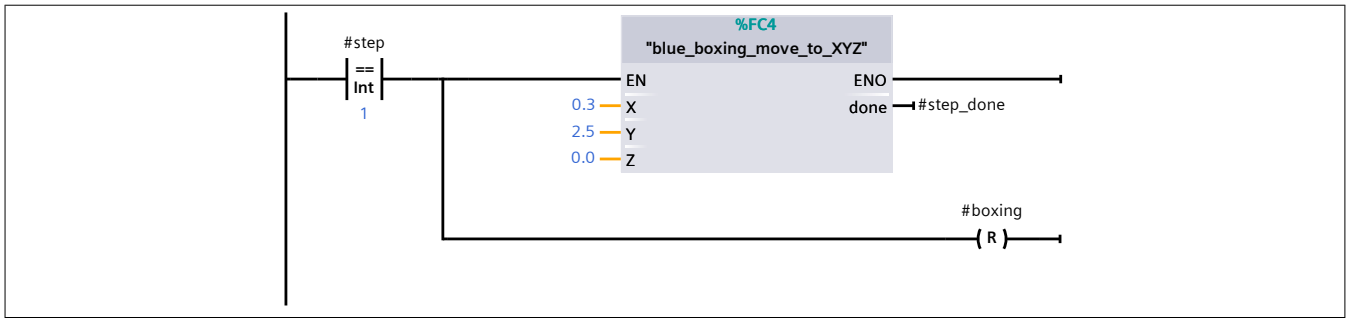
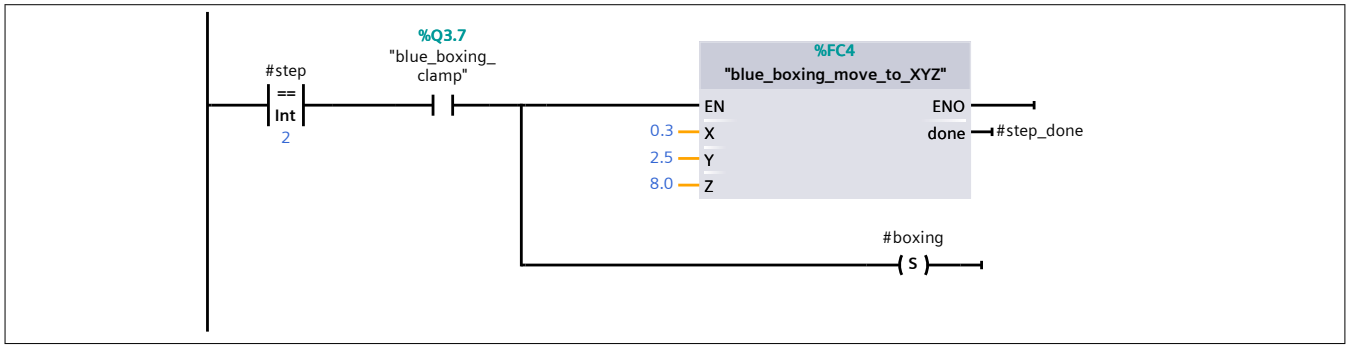


Network 12:



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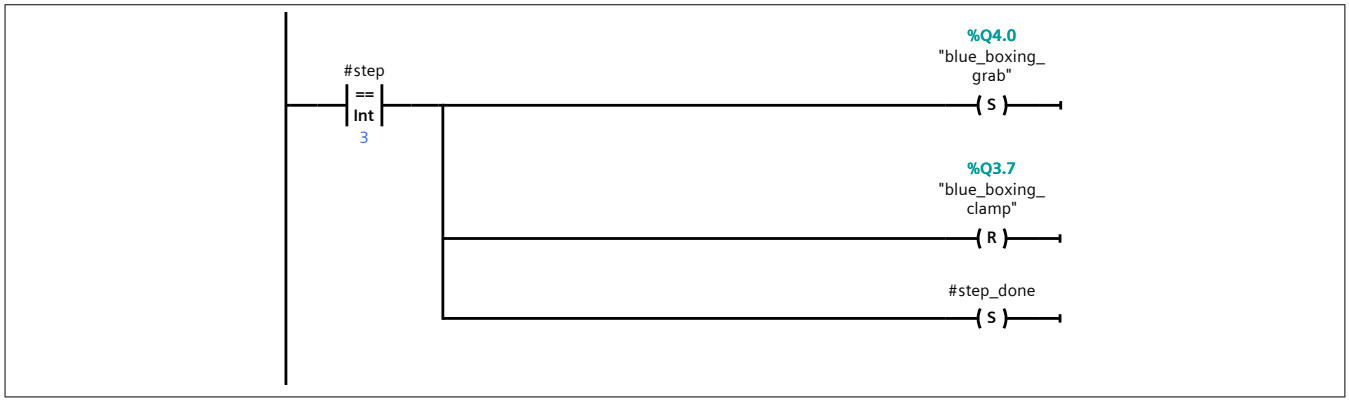

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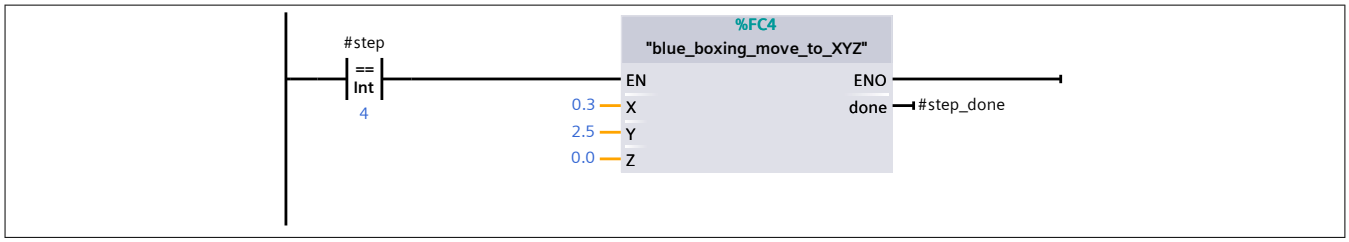

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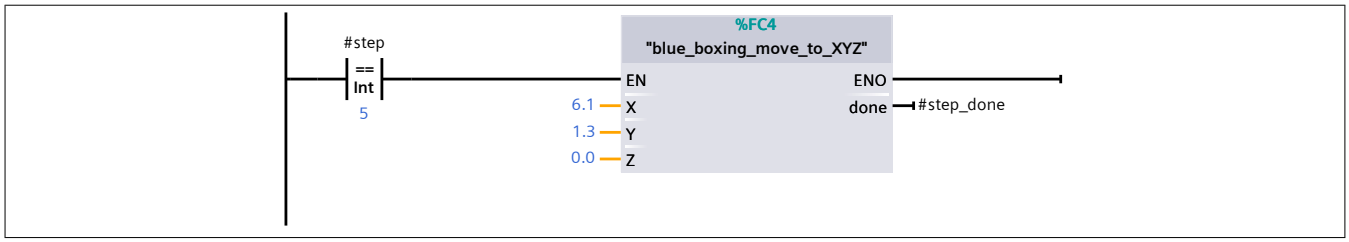
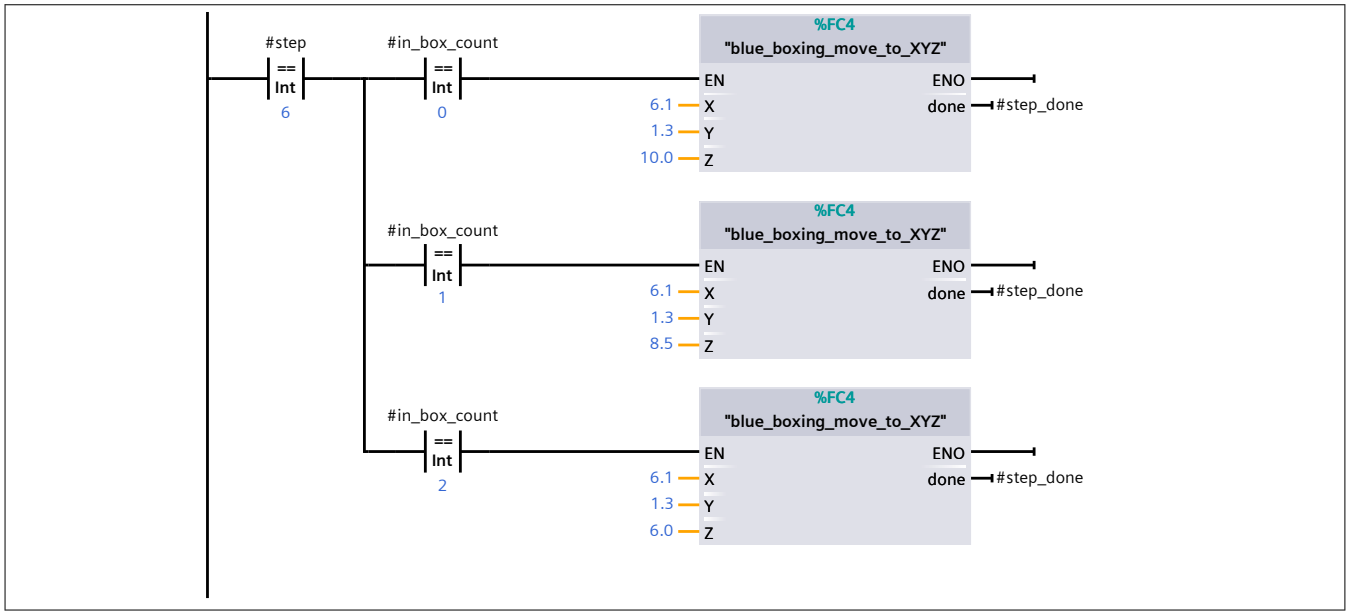
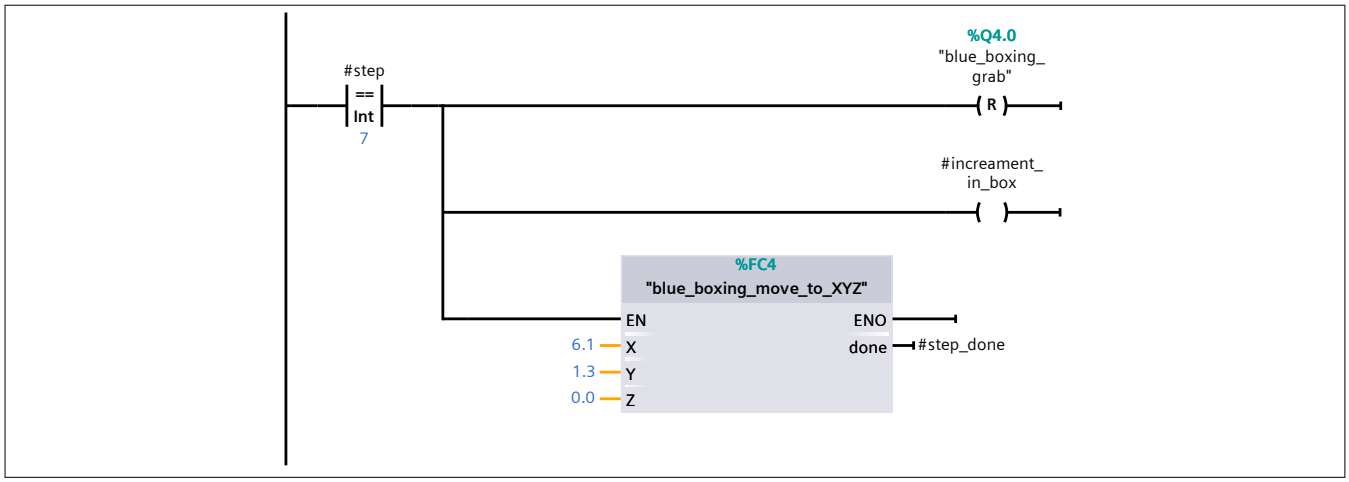


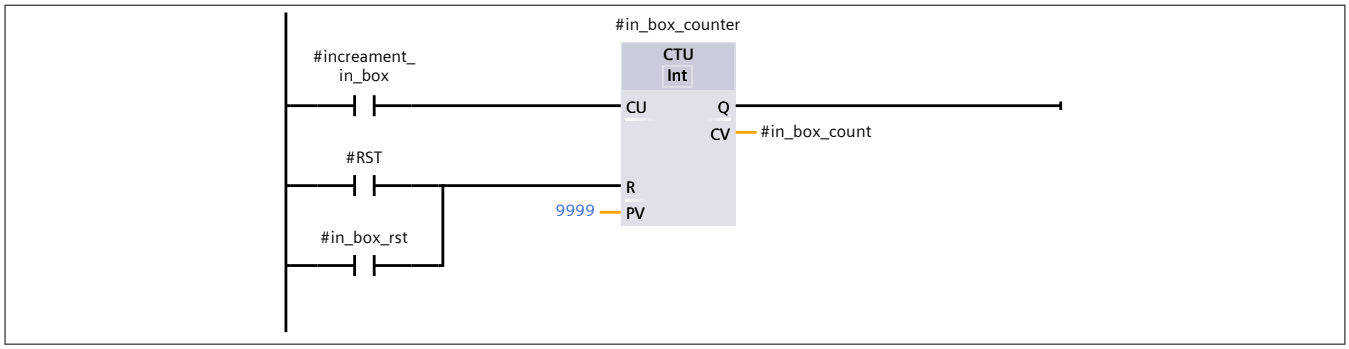
Network 16:



Network 17: -



Network 18:



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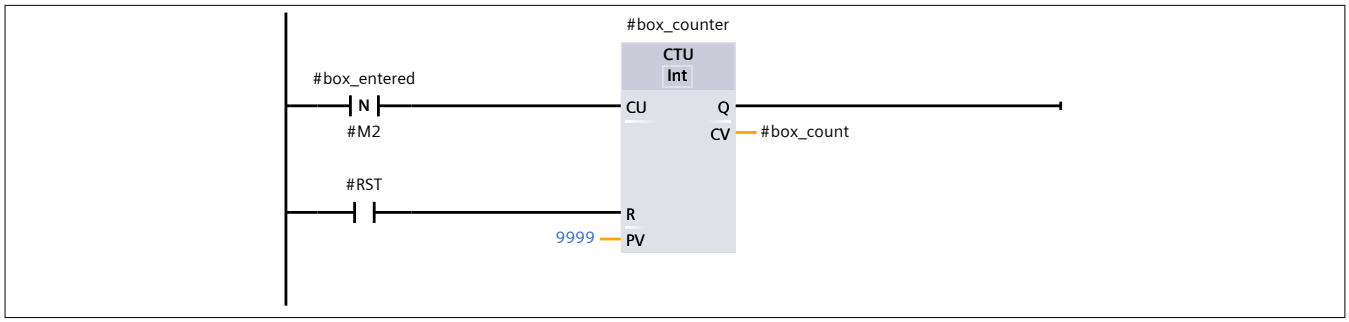
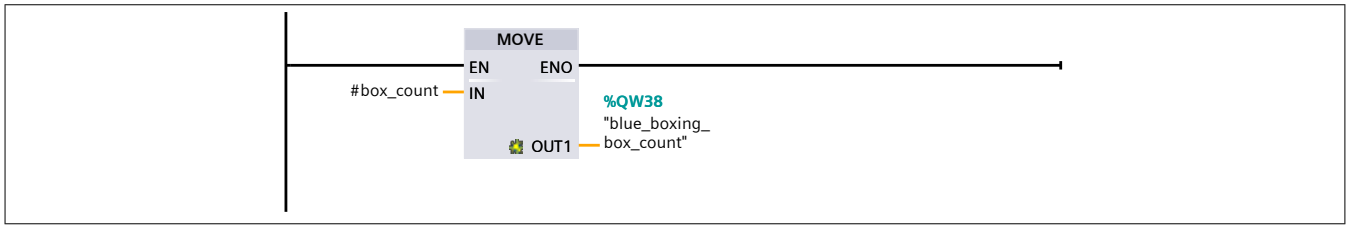


Network 20:



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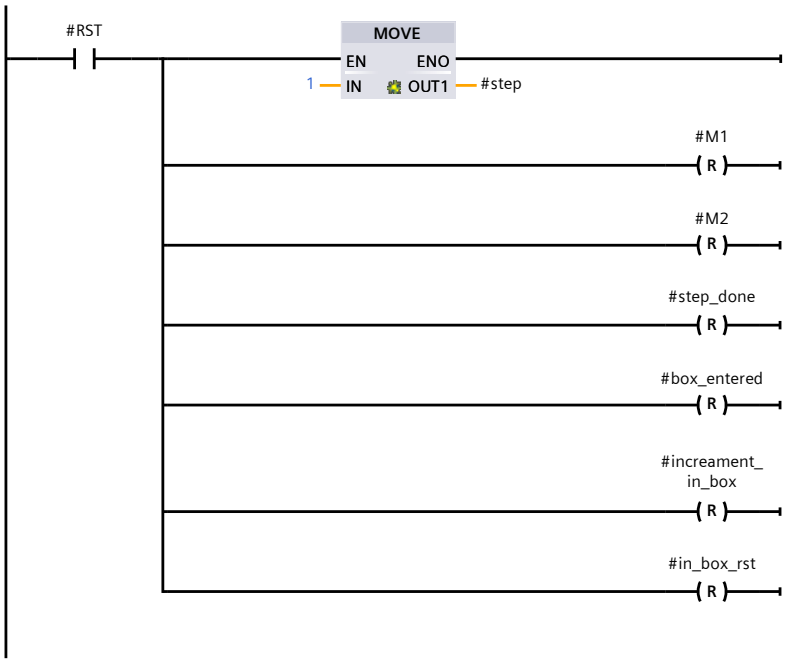
#RST
MOVE
EN
ENO
1
IN
OUT1
#step
#M1
R
#M2
R
#step_done
R
#box_entered
R
#increament_
in_box
R
#in_box_rst
R