

IA_Project / PLC_1 [CPU 1511-1 PN] / Program blocks / 05 blue CNC line
blue_CNC_line [FB4]

blue_CNC_line Properties

General

Name	blue_CNC_line	Number	4	Type	FB
Language	LAD	Numbering	Automatic		

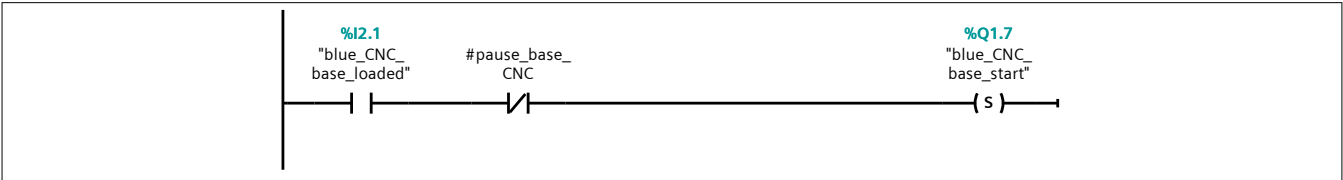
Information

Title		Author		Comment	
Family		Version	0.1	User-defined ID	

blue_CNC_line

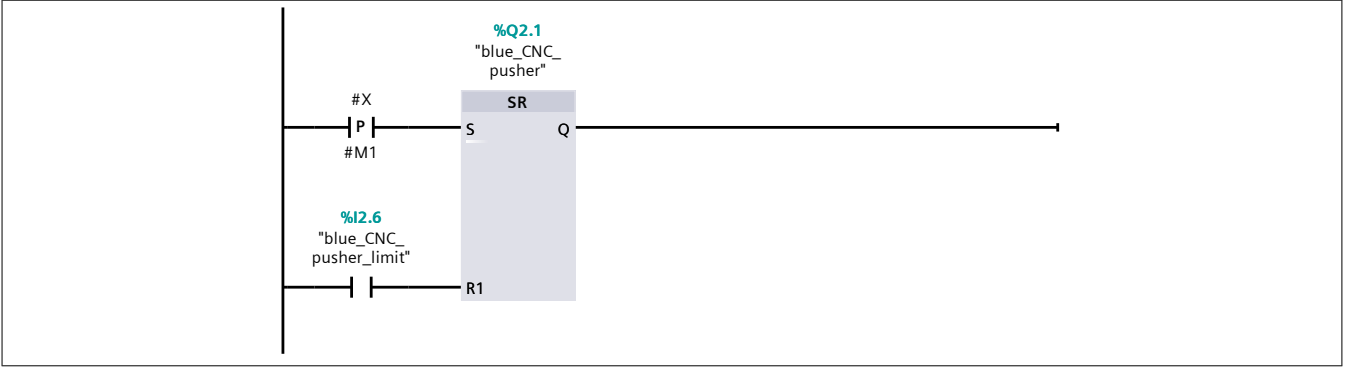
Name	Data type	Default value
▼ Input		
RST	Bool	false
unpause	Bool	false
▼ Output		
base_count	Int	0
lid_count	Int	0
base_CNC_on	Bool	false
lid_CNC_on	Bool	false
InOut		
▼ Static		
M1	Bool	false
M2	Bool	false
activate_pusher	Bool	false
X	Bool	false
Y	Bool	false
pause_base_CNC	Bool	false
pause_lid_CNC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

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

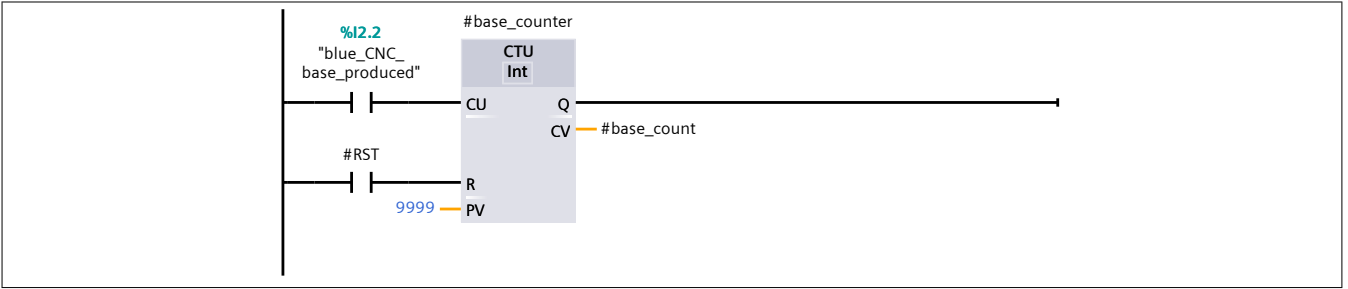


Network 2:

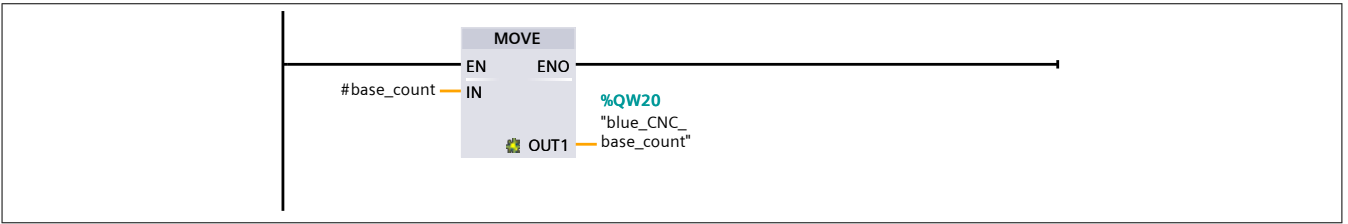
Totally Integrated Automation Portal		
<div><div><div><div>#unpause</div><div><div></div><div></div></div><div><div></div><div></div></div></div><div><div></div><div></div></div><div><div></div><div></div></div><div><div>#pause_lid_CNC</div><div>(R)</div></div><div><div>#pause_base_CNC</div><div>(R)</div></div></div></div>		
Network 8:		
<div><div><div><div>%I2.1</div><div>"blue_CNC_base_loaded"</div><div><div></div><div></div></div></div><div><div></div><div></div></div><div><div>%Q3.0</div><div>"blue_CNC_base_belt"</div><div>()</div></div></div></div>		
Network 9:		
<div><div><div><div>%I2.4</div><div>"blue_CNC_lid_loaded"</div><div><div></div><div></div></div></div><div><div></div><div></div></div><div><div>%Q3.1</div><div>"blue_CNC_lid_belt"</div><div>()</div></div></div></div>		
Network 10:		
<div><div><div><div>%I2.3</div><div>"blue_CNC_in_sensor"</div><div><div></div><div>P</div></div></div><div><div></div><div></div></div><div><div>#M2</div><div></div></div><div><div></div><div></div></div><div><div></div><div></div></div><div><div>#Y</div><div>()</div></div></div></div>		
Network 11: this network toggles X when Y activates		
<div><div><div><div>#Y</div><div><div></div><div></div></div></div><div><div></div><div></div></div><div><div>#X</div><div><div></div><div></div></div></div><div><div></div><div></div></div><div><div></div><div></div></div><div><div>#Y</div><div><div></div><div></div></div></div><div><div></div><div></div></div><div><div>#X</div><div><div></div><div></div></div></div><div><div></div><div></div></div><div><div></div><div></div></div><div><div>#X</div><div>()</div></div></div></div>		
Network 12:		



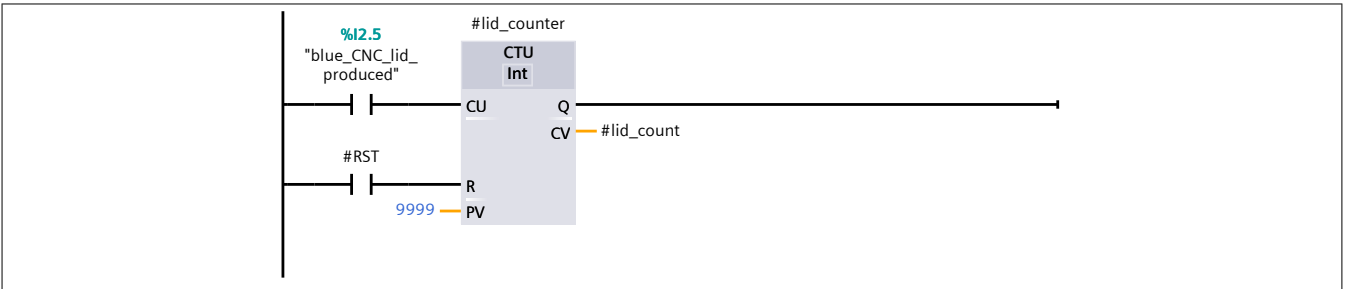
Network 13:



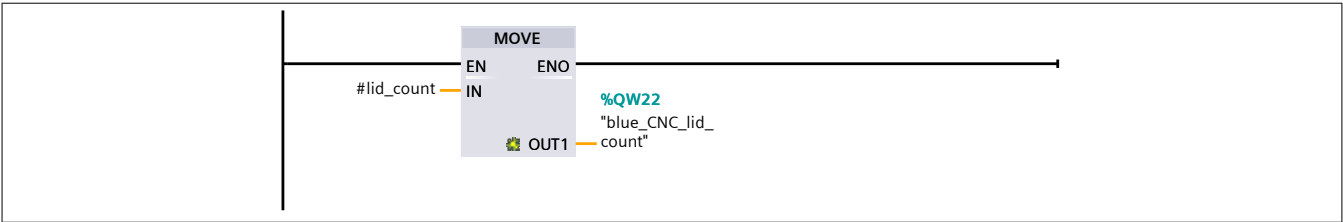
Network 14:



Network 15:



Network 16:



Network 17:

