green_CNC_line Properties					
General					
Name	green_CNC_line	Number	1	Туре	FB
anguage nformation	LAD	Numbering	Automatic		
niormation Title		Author		Comment	
amily		Version	0.1	User-defined ID	
reen_CNC_l	line				
Name			Data type	Default value	
▼ Input					
RST			Bool	false	
unpau	se		Bool	false	
▼ Output					
•	equat		Int	0	
base_count lid_count			Int	0	
			Bool	false	
base_CNC_on lid_CNC_on			Bool	false	
InOut			Воот	Tuise	
▼ Static					
			D I	false	
M1 M2			Bool	false	
			Bool	false	
activate_pusher X			Bool	false	
Y			Bool	false	
pause_base_CNC			Bool	false	
pause_base_CNC pause_lid_CNC			Bool	false	
base_counter			CTU_INT	Tuise	
lid_counter			CTU_INT		
Temp			510_1111		

```
Totally Integrated
   Automation Portal
                                             %I1.1
                                                                                                                                  %Q1.4
                                        "green_CNC_
base_produced"
                                                                                                                               "green_CNC_
base_start"
                                              \dashv \vdash
                                                                                                                                  -( R )-
                                                                                                                              #pause_base_
CNC
                                                                                                                                  (s)——
Network 3:
                                          %Q1.4
"green_CNC_
base_start"
                                                                                                                             #base_CNC_on
                                              <del>1</del> F
                                                                                                                                  <del>(</del> )—
Network 4:
                                                                                                                               %Q1.3
"green_CNC_
lid_start"
                                             %12.0
                                          "green_CNC_
lid_loaded"
                                                             #pause_lid_CNC
                                              +
                                                                  -1/|-
                                                                                                                                 -( s )-
Network 5:
                                                                                                                               %Q1.3
"green_CNC_
lid_start"
                                             %I1.0
                                         "green_CNC_
lid_produced"
                                              ⊣ ⊢
                                                                                                                                  -( R )-
                                                                                                                            #pause_lid_CNC
                                                                                                                                —( s )——
Network 6:
                                             %Q1.3
                                          "green_CNC_
lid_start"
                                                                                                                              #lid_CNC_on
                                              +
                                                                                                                                 ⊣ )–
Network 7:
```

```
Totally Integrated
  Automation Portal
                                    #unpause
                                                                                                         #pause_lid_CNC
                                      \dashv \vdash
                                                                                                             -( R )---
                                                                                                          #pause_base_
CNC
                                                                                                              -( R )-
Network 8:
                                      %I1.7
                                                                                                             %Q1.5
                                   "green_CNC_
base_loaded"
                                                                                                           "green_CNC_
base_belt"
Network 9:
                                                                                                           %Q1.6
"green_CNC_
lid_belt"
                                      %I2.0
                                   "green_CNC_
lid_loaded"
Network 10:
                                   %I0.6
"green_CNC_
in_sensor"
                                                                                                               #Y
                                       -1P |-
                                       #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** %Q0.4 "green_CNC_ pusher" #X SR **-**|₽|-Q #M1 %10.7 "green_CNC_ pusher_limit" Network 13: #base_counter **%I1.1**"green_CNC_ base_produced" CTU \dashv \vdash CU cv — #base_count #RST 9999 — PV Network 14: MOVE EN ENO #base_count — IN %QW16 "green_CNC_ base_count" Network 15: #lid_counter **%I1.0** CTU "green_CNC_ lid_produced" Int CU cv — #lid_count #RST 9999 — PV Network 16:

