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# Pick & Place XYZ\_V15.1\_V20 / PLC\_1 [CPU 1211C DC/DC/DC] / Program blocks

## Pick & Place XYZ [FC1]

Pick & Place XYZ Properties								
General								
Name	Pick & Place XYZ	Number	1	Туре	FC	Language	LAD	
Numbering	Automatic							
Information								
Title		Author		Comment		Family		
Version	0.1	User-defined ID						

Pick & Place XYZ							
Name	Data type Default value		Comment				
Input							
Output							
InOut							
Temp							
Constant							
<b>→</b> Return							
Pick & Place XYZ	Void						

#### **Network 1: Box conveyor**

### **Network 2: Part conveyor**

```
%M0.0

"Run"

"Start"

"Part conveyor"

($ $ )

%M0.1

"Part at place"

| P |

%M10.5

"Tag_6"

%40.1

"Part at place"

"Part
```

Network 3: XYZ

Totally Integrated **Automation Portal %M0.0** "Run" "Start" MOVE 8.3 — IN — ENO — %QD30 — "SP X" %ID38 "Z" **%Q0.4** "Grab" %I0.1 "Part at place" %I0.0 "Box at place" %Q0.0 MOVE "Box conveyor" == Real 5.3 — IN — ENO — %QD34 — "SP Y" <del>-</del>|/|-**--/**/⊦ **-1/**1-%ID30 "X" <= Real %ID34 "Y" | >= | Real %ID34 "Y" <= Real 5.4 >= Real 4.8 — IN Network 4: Dem san pham %DB1 "Counting\_sp" %ID30 "X" %ID30 "X" %ID34 "Y" %ID34 "Y" CTU **%M0.0** "Run" **%Q0.4** "Grab" Int >= Real <= Real >= Real <= Real  $\dashv$ P $\vdash$ · CU **%M100.4** "Tag\_5" **CV** — 0 %I0.0 "Box at place" "Counting\_sp".CV == Int  $\dashv$ P $\vdash$ **%M101.1** "Tag\_10" 3 — PV Network 5: **%M0.0** "Run" %I0.2 "Detected" **%Q0.4** "Grab"  $\dashv$ P $\vdash$ **-(** s **)**− **%M100.2** "Tag\_3" %Q0.3 "C +" "Counting\_sp".CV Network 6: SP 1

Totally Integrated Automation Portal

```
%ID30
                                                              %ID30
                                                                             %ID34
                                                                                             %ID34
%M0.0
                              %Q0.4
           "Counting\_sp".CV
                                                              "X"
"Run"
                              "Grab"
                                                                                                                        MOVE
                                                              <=
Real
               | == |
| Int |
                                              >=
Real
                                                                             >=
Real
                                                                                             <=
Real
                                                                                                                  0.0 — ENO — %QD38
                               H F
                                                                                                                        %ID30
"X"
                                                                                            %ID34
"Y"
                                                                                                            %ID34
"Y"
                                                                                                                           %ID38
"Z"
                                                             %ID30
"X"
                                              %10.2
                                            "Detected"
                                                                                                                                                       MOVE
                                                                                             >=
Real
                                                                                                                           ==
Real
                                                                                                                                                  EN — ENO — %QD30 — "SP X"
                                                              Real
                                                                             Real
                                                                                                            Real
                                                                                                                                                       MOVE
                                                                                                                                                  6.3 — ENO — MQD34
                                                                                                                                                       %ID30
"X"
                                                                                            %ID34
"Y"
                                                                                                            %ID34
"Y"
                                                             %ID30
"X"
                                              %10.2
                                                                                                                                       MOVE
                                            "Detected"
                                                                             <=
Real
                                                                                             >=
Real
                                                                                                            <=
Real
                                                                                                                                       EN - ENO
                                                                                                                                 10.0 — IN
                                                                                                                                                     %QD38
                                                                                                                                        ₫ OUT1 — "SP Z"
                                                                                                                           %ID38
"Z"
== |
Real
                                                                                                                                           %Q0.4
"Grab"
                                                                                                                                           -( R )-
```

#### Network 7: SP 2

```
%ID30
                                                     %ID30
                                                                  %ID34
                                                                               %ID34
%M0.0
"Run"
                          %Q0.4
"Grab"
          "Counting_sp".CV
                                        "X"
                                                                   "Y"
                                                      "X"
                                                     <=
Real
             Int -
                                        >=
Real
                                                                  >=
Real
                                                                                <=
Real
                                                                                                  - OUT1 - "SP Z"
                                                                               %ID34
"Y"
                                                                                            %ID34
"Y"
                                                                                                          %ID38
"Z"
                                                     %ID30
                                                                  %ID30
                                        %10.2
                                      "Detected"
                                                                                                                                  MOVE
                                                                                                          ==
Real
                                                     >=
Real
                                                                  <=
Real
                                                                                             <=
Real
                                                                                >=
Real
                                                                                                                             - OUT1 — "SP X"
                                                                                                                             EN — ENO — %QD34
                                                                                                                                  %ID30
"X"
                                                                               %ID34
"Y"
                                                                                            %ID34
"Y"
                                                     %ID30
"X"
                                        %10.2
                                                                                                                    MOVE
                                                     >=
Real
                                                                  <=
Real
                                                                                >=
Real
                                                                                            <=
Real
                                                                                                             %ID38
                                                                                                                       %Q0.4
                                                                                                           "Z"
==
                                                                                                                       "Grab"
                                                                                                          Real
```

Network 8: SP 3

Totally Integrated **Automation Portal** %ID30 "X" | >= | | Real %ID30 "X" | <= | | Real %ID34 "Y" %ID34 "Y" **%M0.0** "Run" **%Q0.4** "Grab" "Counting\_sp".CV MOVE >= Real |==| |<sub>Int</sub>| <= | Real | 5.4 -EN - ENO 0.0 — IN %ID30 "X" %ID30 "X" %ID34 "Y" %ID34 "Y" %ID38 "Z" %10.2 "Detected" MOVE >= Real <= Real >= Real 5.2 <= Real == Real EN - ENO -IN %QD30 - □ OUT1 --- "SP X" 3.0 — IN MOVE EN - ENO 4.8 — IN %ID30 "X" >= Real %ID30 "X" <= Real %ID34 "Y" %ID34 "Y" %10.2 "Y >= Real 4.7 "Detected" MOVE <= Real EN - ENO 5.5 — IN **%QD38** - "SP Z" d OUT1 %ID38 "Z" >= | Real %ID38 "Z" <= | Real **%Q0.4** "Grab" -( R )-Network 9: **%M0.0** "Run" **%Q0.4** "Grab" MOVE  $\exists \, \mathsf{P}$ **%M100.3** "Tag\_4" 0.0 — IN **Network 10: Exit conveyor %M0.0** "Run" %Q0.2
"Exit conveyor"