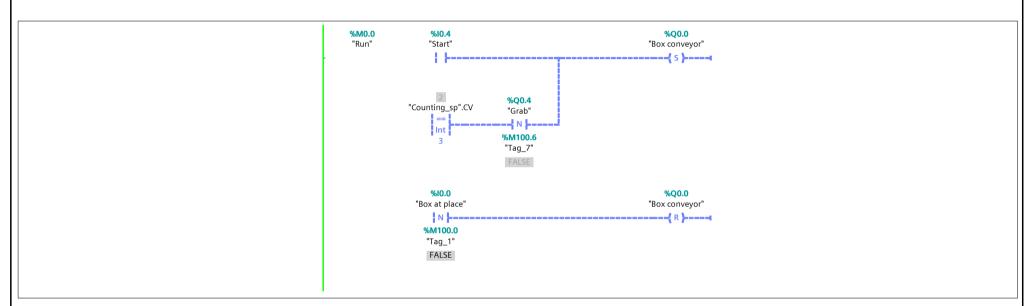
# Pick & Place XYZ\_V15.1\_V20 / PLC\_1 [CPU 1211C DC/DC/DC] / Program blocks

## Pick & Place XYZ [FC1]

Pick & Place XYZ Properties								
General								
Name	Pick & Place XYZ	Number	1	Type	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"
                      %I0.4
"Start"
                                                                                     %Q0.1
"Part conveyor"
 4 6
                                                                                          -{ s }----
                  %I0.1
"Part at place"
                       - P
                    %M100.5
"Tag_6"
                      FALSE
                  %I0.1
"Part at place"
                                                                                    %Q0.1
"Part conveyor"
                      -- N
                                                                                        --(R)----
                     %M100.1
                      "Tag_2"
                      FALSE
```

Network 3: XYZ

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%M0.0 %I0.4

```
%M0.0
"Run"
                          %I0.4
"Start"
                                                                                                                                                                         8.3 — IN
                                                                                                                                                                                                        %QD30
- "SP X"
                                                    10.0
%ID38
"Z"
==
Real
0.0
                                                                                                                                                                                         d OUT1
                     %Q0.0
"Box conveyor"
                                                                              %Q0.4 "Grab"
                                                                                                    %I0.1
"Part at place"
                                                                                                                                   %10.0
                                                                                                                               "Box at place"
                                                                                                                                                                         5.3 — IN
                                                                                                                                                                                                        %QD34
- "SP Y"
                                                                                                                                                                                         d OUT1
                                                                                                                                                                                      %ID30
"X"
                                                                                                                                                                                                                 %ID34
"Y"
                                                                                                                                                                                                                                           %ID34
"Y"
                                                                                                                                                            >=
Real
8.2
                                                                                                                                                                                       <=
Real
                                                                                                                                                                                                                 >=
Real
                                                                                                                                                                                                                                           <=
Real
                                                                                                                                                                                        8.4
                                                                                                                                                                                                                  5.2
            4.8 —
                                           %QD38
- "SP Z"
                            d OUT1
```

#### Network 4: Dem san pham

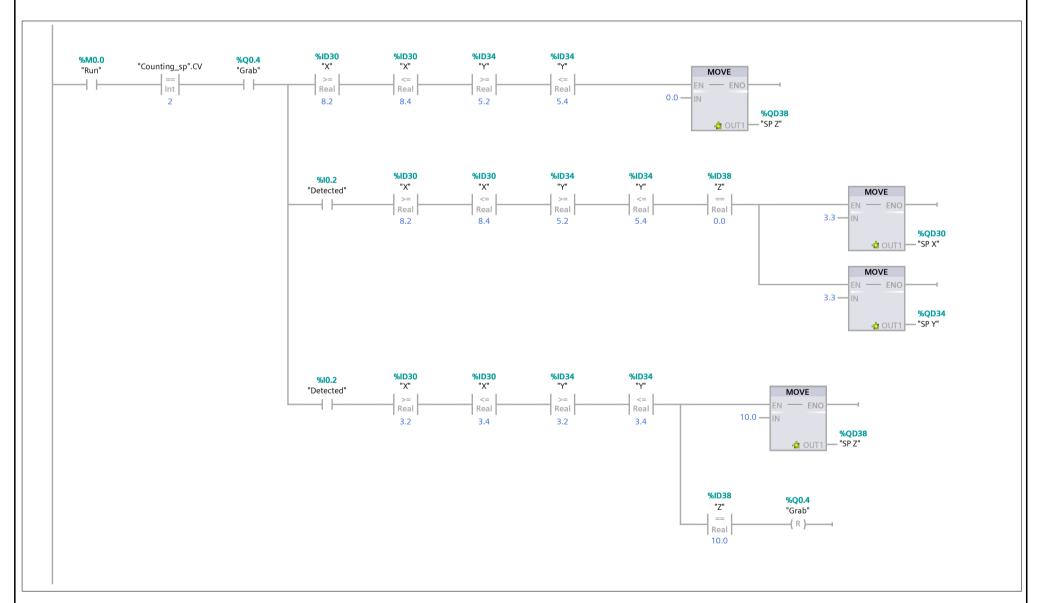
#### Network 5:

#### Network 6: SP 1

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```
%ID30
"X"
                                                                                               %ID30
"X"
                                                                                                                       %ID34
"Y"
                                                                                                                                                %ID34
"Y"
%M0.0
"Run"
                                                %Q0.4
"Grab"
                  "Counting_sp".CV
                                                                                                                                                                                               MOVE
                                                                        >=
Real
                                                                                                <=
Real
                                                                                                                        >=
Real
                                                                                                                                                <=
Real
                                                                                                                                                                                   0.0 -
                                                                                                                                                                                                               %QD38
-- "SP Z"
                                                                                                                                                                                                  d OUT1
                                                                                                                       %ID30
"X"
                                                                                                                                               %ID34
"Y"
                                                                                               %ID30
"X"
                                                                                                                                                                       %ID34
                                                                                                                                                                                               %ID38
                                                                         %10.2
                                                                                                                                                                                                  "Z"
                                                                     "Detected"
                                                                                                                                                                                                                                               MOVE
                                                                                                >= |
| Real |
| 8.2
                                                                                                                        <=
Real
8.4
                                                                                                                                                                       <=
Real
5.4
                                                                                                                                                >=
Real
5.2
                                                                                                                                                                                               Real 0.0
                                                                                                                                                                                                                                                   — ENO
                                                                                                                                                                                                                                   3.3 —
                                                                                                                                                                                                                                                               %QD30
- "SP X"
                                                                                                                                                                                                                                                  d OUT1
                                                                                                                                                                                                                                               MOVE
                                                                                                                                                                                                                                                   - ENO
                                                                                                                                                                                                                                   6.3 —
                                                                                                                                                                                                                                                               %QD34
-- "SP Y"
                                                                                                                                                                                                                                                  d OUT1
                                                                                                %ID30
"X"
                                                                                                                       %ID30
"X"
                                                                                                                                               %ID34
"Y"
                                                                                                                                                                       %ID34
"Y"
                                                                         %10.2
                                                                     "Detected"
                                                                                                                                                                                                                       MOVE
                                                                                                >=
Real
                                                                                                                        <=
Real
                                                                                                                                                >= |
| Real |
| 6.2
                                                                                                                                                                       <=
Real
                                                                                                                                                                                                         10.0 –
                                                                                                                                                                                                                                       %QD38
- "SP Z"
                                                                                                                                                                                               %ID38
                                                                                                                                                                                                                       %Q0.4
                                                                                                                                                                                                  "Z"
                                                                                                                                                                                                                       "Grab"
                                                                                                                                                                                               == |
Real |
10.0
```

### Network 7: SP 2



Network 8: SP 3

Totally Integrated **Automation Portal** 3.000111 %ID30 "X" 3.000111 %ID30 "X" 4.800079 %ID34 "Y" %ID34 "Y" "Counting\_sp".CV **%M0.0** "Run" **%Q0.4** "Grab" MOVE <= Real Real 0.0 -8.2 8.4 **%QD38** – "SP Z" d OUT1 3.000111 %ID30 "X" 3.000111 **%ID30** %ID34 "Y" %ID34 "Y" %ID38 %10.2 "X" "Z" "Detected" MOVE >= Real 8.2 <= Real 5.4 == | Real | 0.0 >= | Real | 5.2 Real 8.4 3.0 — **%QD30** - "SP X" MOVE 4.8 — **%QD34** -- "SP Y" d OUT1 3.000111 %ID30 "X" 3.000111 %ID30 "X" %ID34 "Y" %ID34 "Y" %10.2 "Detected" MOVE >= | Real | 4.7 <= Real 4.9 Real 5.5 -2.9 **%QD38** - "SP Z" %ID38 %ID38 **%Q0.4** "Grab" "Z" | >= | | Real | | 5.4 "Z" | <= | | Real | | 5.6 Network 9: **%M0.0** "Run" **%Q0.4** "Grab" MOVE -| N |en --- eno **%M100.3** "Tag\_4" 0.0 — **%QD38** - "SP Z" **Network 10: Exit conveyor %Q0.2**"Exit conveyor" **%M0.0** "Run" -( )-