Program

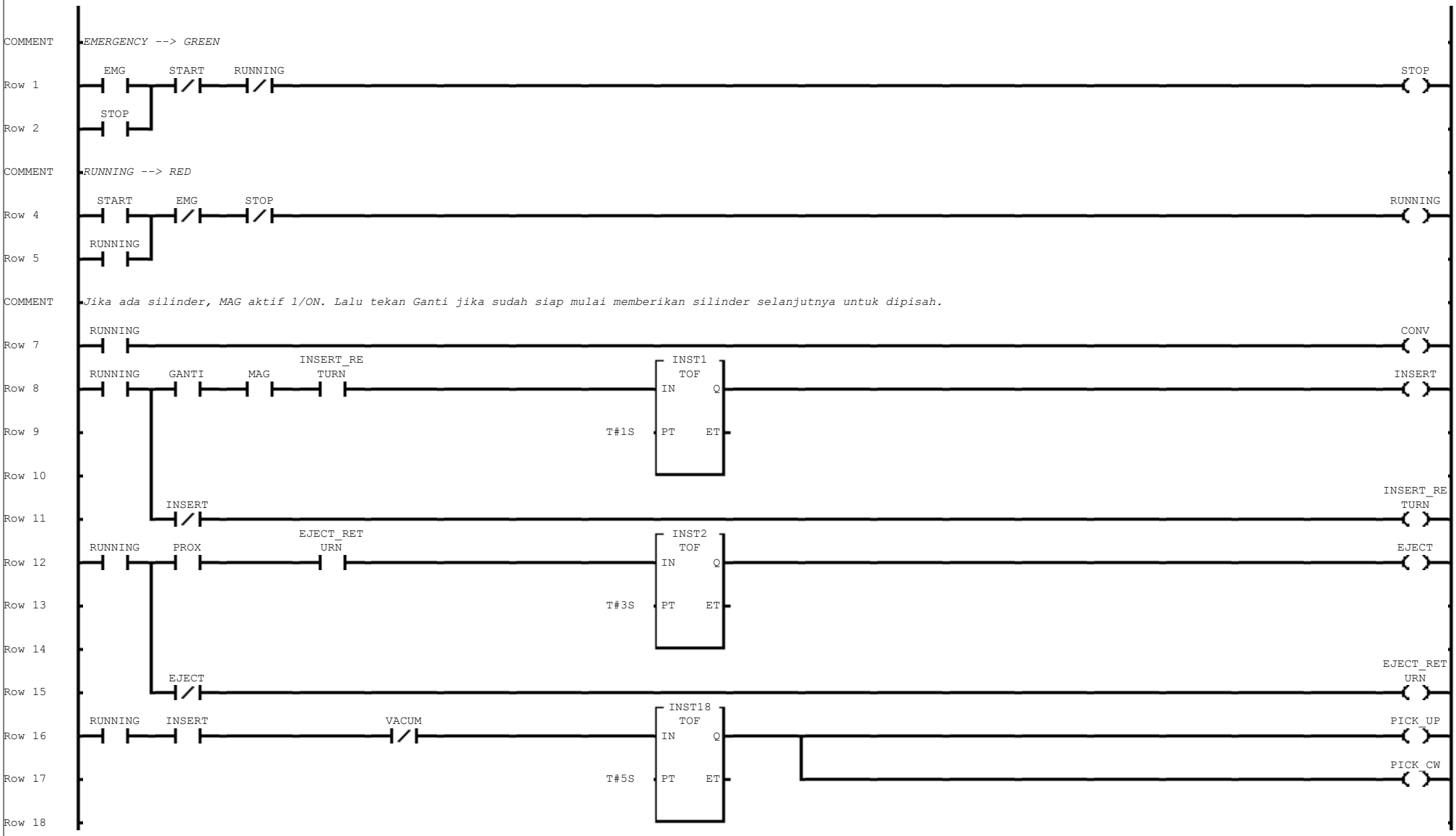
noname00.src

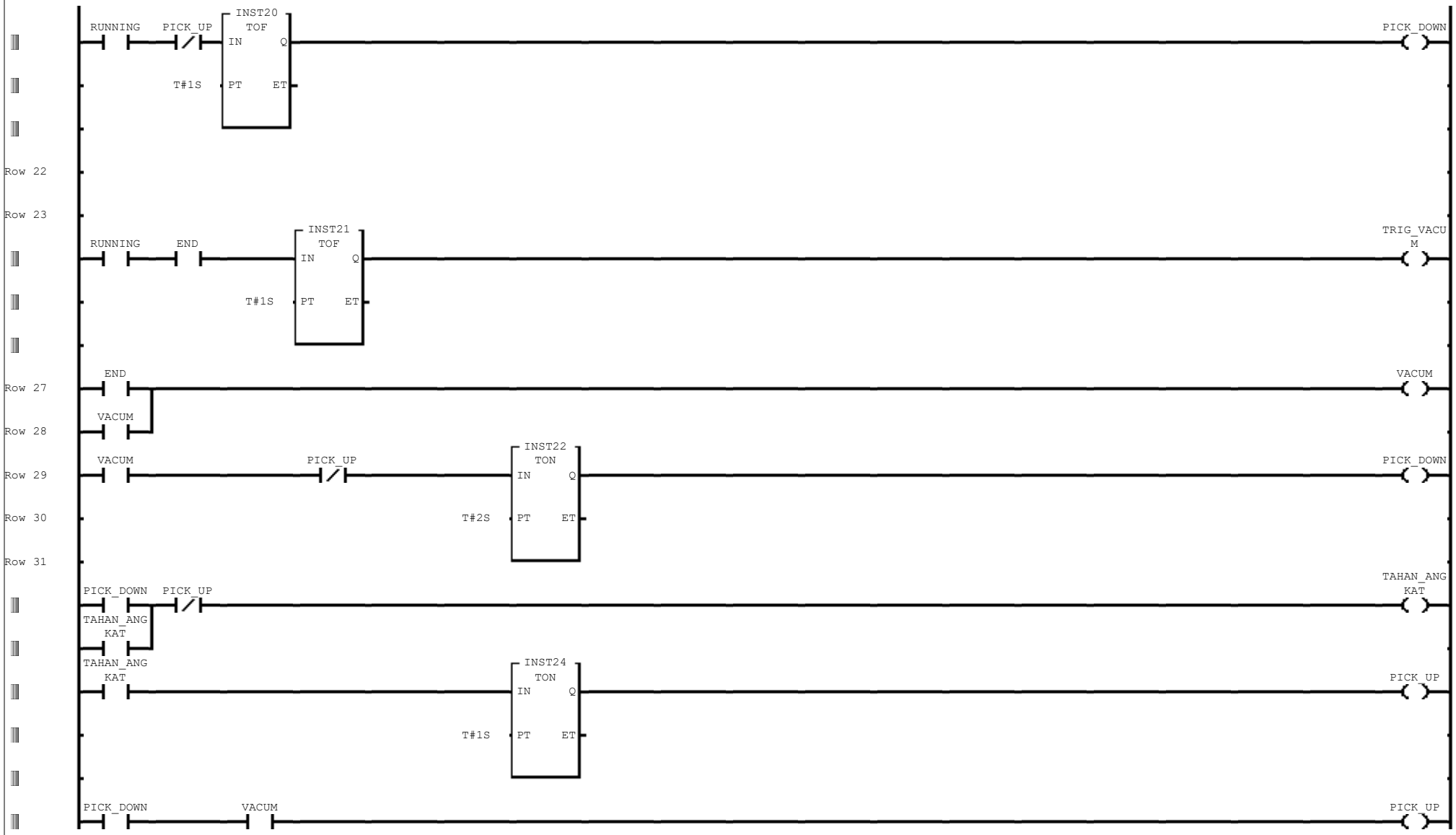
2022.11.25

Variable name	Variable kind	Data type	(Memory allocation) (Initial value)
CONV	VAR	BOOL	AT %QX0.2.10
EJECT	VAR	BOOL	AT %QX0.2.8
EJECT_RETURN	VAR	BOOL	AT %QX0.2.9
EMG	VAR	BOOL	AT %IX0.1.11
END	VAR	BOOL	AT %IX0.0.14
GANTI	VAR	BOOL	AT %IX0.1.12
INS_BT	VAR	BOOL	
INS_RET_BT	VAR	BOOL	
INSERT	VAR	BOOL	AT %QX0.2.6
INSERT_RETURN	VAR	BOOL	AT %QX0.2.7
INST0	VAR	FB Instance	
INST1	VAR	FB Instance	
INST10	VAR	FB Instance	
INST11	VAR	FB Instance	
INST12	VAR	FB Instance	
INST13	VAR	FB Instance	
INST14	VAR	FB Instance	
INST15	VAR	FB Instance	
INST16	VAR	FB Instance	
INST17	VAR	FB Instance	
INST18	VAR	FB Instance	
INST19	VAR	FB Instance	
INST2	VAR	FB Instance	
INST20	VAR	FB Instance	
INST21	VAR	FB Instance	

Variable name	Variable kind	Data type	(Memory allocation) (Initial value)
INST22	VAR	FB Instance	
INST23	VAR	FB Instance	
INST24	VAR	FB Instance	
INST3	VAR	FB Instance	
INST4	VAR	FB Instance	
INST5	VAR	FB Instance	
INST6	VAR	FB Instance	
INST7	VAR	FB Instance	
INST8	VAR	FB Instance	
INST9	VAR	FB Instance	
MAG	VAR	BOOL	AT %IX0.0.6
PICK_CCW	VAR	BOOL	AT %QX0.3.6
PICK_CW	VAR	BOOL	AT %QX0.3.7
PICK_DOWN	VAR	BOOL	AT %QX0.3.9
PICK_UP	VAR	BOOL	AT %QX0.3.8
PROX	VAR	BOOL	AT %IX0.0.8
RUNNING	VAR	BOOL	AT %QX0.3.11
START	VAR	BOOL	AT %IX0.0.15
STOP	VAR	BOOL	AT %QX0.3.13
T_EXTEND	VAR	BOOL	
TAHAN_ANGKAT	VAR	BOOL	
TRIG_VACUM	VAR	BOOL	
VACUM	VAR	BOOL	AT %QX0.3.10
Y1	VAR	BOOL	
Y2	VAR	BOOL	

Variable name	Variable kind	Data type	(Memory allocation) (Initial value)


COMMENT
EMERGENCY --> GREEN
Row 1
EMG
START
RUNNING
STOP
Row 2
STOP
COMMENT
RUNNING --> RED
Row 4
START
EMG
STOP
RUNNING
Row 5
RUNNING
COMMENT
Jika ada silinder, MAG aktif 1/ON. Lalu tekan Ganti jika sudah siap mulai memberikan silinder selanjutnya untuk dipisah.
Row 7
RUNNING
CONV
Row 8
RUNNING
GANTI
MAG
INSERT_RE
TURN
INST1
TOF
IN
Q
INSERT
Row 9
T#1S
PT
ET
Row 10
Row 11
INSERT
INSERT_RE
TURN
Row 12
RUNNING
PROX
EJECT_RET
URN
INST2
TOF
IN
Q
EJECT
Row 13
T#3S
PT
ET
Row 14
Row 15
EJECT
EJECT_RET
URN
Row 16
RUNNING
INSERT
VACUM
INST18
TOF
IN
Q
PICK_UP
Row 17
T#5S
PT
ET
PICK_CW
Row 18


RUNNING
PICK_UP
INST20
TOF
IN
Q
T#1S
PT
ET
PICK_DOWN
Row 22
Row 23
RUNNING
END
INST21
TOF
IN
Q
T#1S
PT
ET
TRIG_VACUM
END
VACUM
Row 27
VACUM
Row 28
VACUM
PICK_UP
INST22
TON
IN
Q
T#2S
PT
ET
PICK_DOWN
Row 29
Row 30
Row 31
PICK_DOWN
PICK_UP
TAHAN_ANG
KAT
TAHAN_ANG
KAT
TAHAN_ANG
KAT
INST24
TON
IN
Q
T#1S
PT
ET
PICK_UP
PICK_DOWN
VACUM
PICK_UP