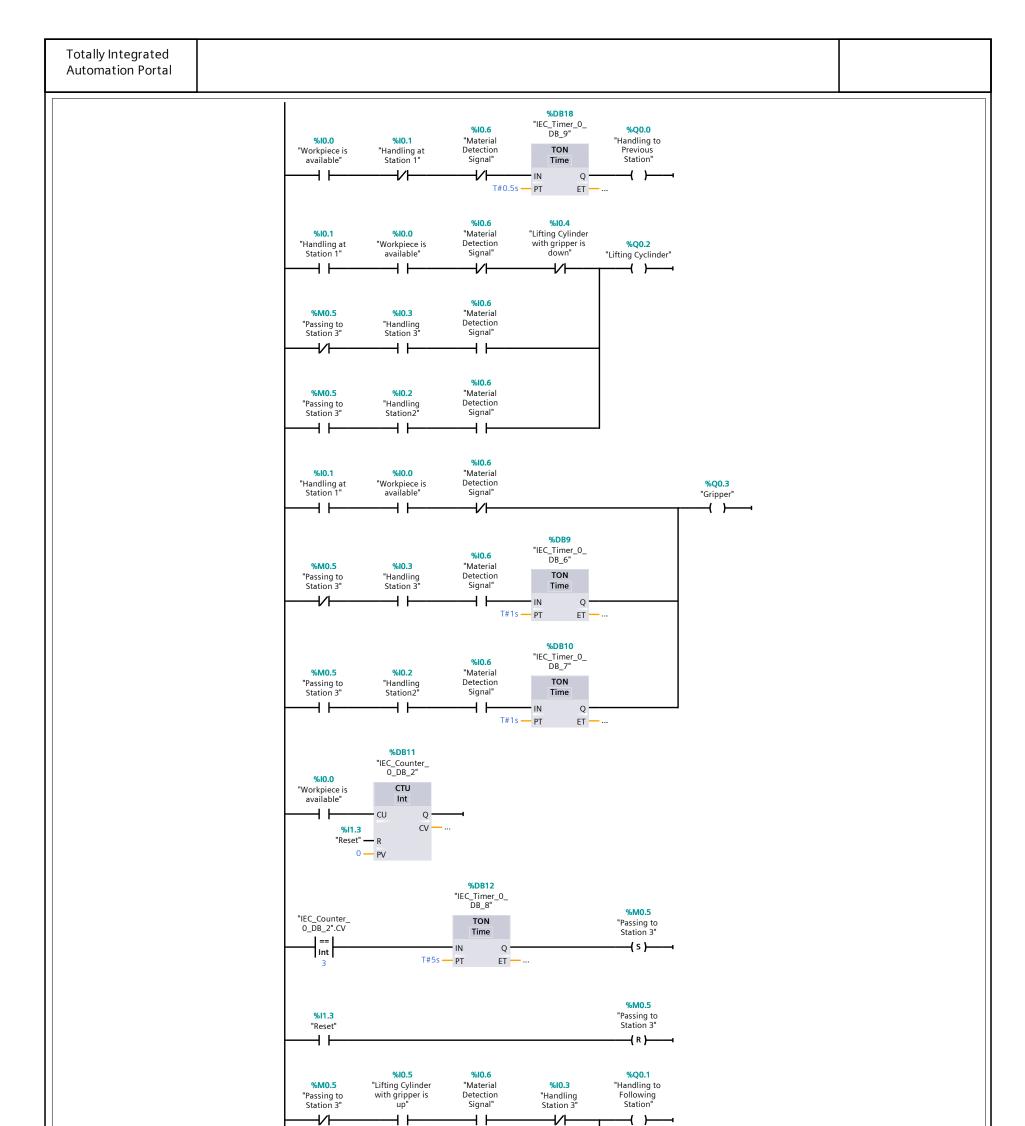
reaction "Main Program Sweep (Cy-cle)"	"Main Program Sweep (Cy- cle)" ion 0.1 User-defined ID Data type Default value Comment Comment Comment Initial_Call Bool Remanence Bool Family Family Family Initial call of this OB =True, if remanent data are available Family Family Initial call of this OB =True, if remanent data are available Family Family Family Family Initial call of this OB =True, if remanent data are available	lain Properti eneral ame umbering	Main automatic	Number 1		Туре	ОВ	Language	LAD
cle)" sion 0.1 User-defined ID n ne Data type Default value Comment Input Initial_Call Bool Initial call of this OB Remanence Bool =True, if remanent data are available Temp Constant	cle)" O.1 User-defined ID Data type Default value Comment Initial_Call Bool Initial call of this OB Remanence Bool =True, if remanent data are available Temp Constant	ormation le		y- Author		Comment		Family	
Input Initial_Call Remanence Bool Temp Constant Data type Default value Comment Comme	ne Data type Default value Comment Initial_Call Bool Initial call of this OB Remanence Bool =True, if remanent data are available Temp Constant	sion	cle)"	User-defined		Comment		. uniniy	
Input Initial_Call Bool Remanence Bool Temp Constant Initial call of this OB Initial call of this OB =True, if remanent data are available	Initial_Call Bool Initial call of this OB Remanence Bool =True, if remanent data are available Temp Constant Constant	in me		Data type	Default value		Comment		
Remanence Bool =True, if remanent data are available Temp Constant	Remanence Bool =True, if remanent data are available Temp Constant	Input							
Temp Constant	Temp Constant								
Constant	Constant		nce	ROOI			= i rue, it remanent	uata are available	
twork 1:	work 1:	Constant							

Totally Integrated **Automation Portal** Network 1: (1.1 / 4.1) %I1.3 "Reset" MOVE EN - ENO 10 — IN "Product
— Recognition" %MW100 OUT2 %MW140 OUT3 — "Belt Status" %DB6 "IEC_Timer_0_ DB_3" TON "Slow Belt' Time MOVE EN - ENO IN T#0.4s — PT 10 — IN ET · %MW122 %Q0.6 "Product "Fast Belt" OUT1 — Recognition" $\dashv \vdash$ %DB19 %I1.0 "Start" MOVE T#0.1s — PT ET — ... 11 — IN %MW140 C3 OUT1 — "Belt Status" %MW140 %Q0.5 "Belt Status" "Slow Belt" Int %DB1 "IEC_Timer_0_DB" %11.4 "Light Barrier" - IN Q T#1.5s — PT ET — ... %MW140 %Q0.6 "Belt Status" "Fast Belt" Int %DB1 "IEC_Timer_0_DB" "Light Barrier" Time %MW122 "IEC Counter %M0.4 "Product 0_DB_1".CV Recognition" "Selection Part" MOVE == Int **-**| |-EN - ENO Int %MW102 0 "1.product" C3 OUT1 — "Belt Status" %MW122 "Product "IEC_Counter_ 0_DB_1".CV %M0.4 Recognition" "Selection Part" MOVE | == | Int Int 11 — IN %MW140 %MW104 OUT1 — "Belt Status" "2.product" %MW122 "IEC_Counter_ 0_DB_1".CV "Product %M0.4 Recognition" "Selection Part" MOVE == | Int | == Int \dashv \vdash EN - ENO 11 — IN %MW106 "3.product" C3 OUT1 — "Belt Status" %MW122 "Product "IEC_Counter_ 0_DB_1".CV %M0.4 Recognition" "Selection Part" MOVE | == | | | Int | == | Int EN — ENO — %MW140 \dashv \vdash %MW108 "4.product" C3 OUT1 — "Belt Status" %MW122 "IEC_Counter_ 0_DB_1".CV "Product %M0.4 Recognition" MOVE "Selection Part" == | Int | == Int EN - ENO 11 — IN 2.1 (Page1 - 3)

Totally Integrated **Automation Portal** Network 1: (3.1 / 4.1) 2.1 (Page1 - 3) E3 OUT1 — Recognition" %DB4 "IEC_Timer_0_ DB_2" TON %Q0.6 "Fast Belt" %M0.4 %Q0.5 **%I1.4** %I1.5 %10.7 "Slow Belt" "Light Barrier" "Selection Part" "Reflective" Time "Inductive" MOVE EN Q· ENO T#0.2s — PT 4 — IN ET -%MW122 "Product - Recognition" COUT1 %DB2 "IEC_Counter_ 0_DB" CTU %11.4 %Q0.5 %M0.4 "Light Barrier" "Slow Belt" "Selection Part" CU %MW120 - "Tag_23" CV **%I1.3** "Reset" %MW120 %M0.4 "Tag_23" "Selection Part" MOVE |== |nt| %MW100 %MW102 "Product" — IN 23 OUT1 — "1.product" **%MW120**"Tag_23" %M0.4 MOVE "Selection Part" == | Int | EN ENO %MW100 %MW104 "Product" — IN 🛂 OUT1 — "2.product" %MW120 %M0.4 "Tag_23" "Selection Part" MOVE -1/1-EN ENO Int %MW106 %MW100 "Product" — IN 🛂 OUT1 — "3.product" %MW120 %M0.4 "Tag_23" "Selection Part" MOVE |== Int -1/} %MW100 %MW108 "Product" — IN 23 OUT1 — "4.product" %MW120 %M0.4 "Tag_23" MOVE "Selection Part" EN ENO Int %MW100 %MW110 "Product" — IN 🛂 OUT1 — "5.product" %MW120 %M0.4 "Tag_23" "Selection Part" MOVE == Int -1/1-EN ENO %MW100 %MW112 "Product" — IN 23 OUT1 — "6.product" %DB3 "IEC_Timer_0_ DB_1" "IEC_Counter_ TON %M0.4 0_DB".CV Time "Selection Part" == Int (s) · IN T#3.2s — PT ET --- ... "IEC_Counter_ %M0.4 0_DB".CV <> Int -(R)-%DB26 %DB27 "IEC_Timer_0_ DB_22" "IEC_Counter_ 0_DB_4" %MW122 "IEC_Counter_ "Product TON CTU %M0.4 0_DB_1".CV Recognition" "Selection Part" Time Int == | Int | IN Q CU Q Int T#0.3s — PT **%I1.3** CV -%MW102 "Reset" — "1.product" 0 — PV %DB8 %DB5 "IEC_Counter_ 0_DB_1" %MW122 "IEC_Timer_0_ DB_5" "IEC_Counter_ "Product %M0.4 0_DB_1".CV Recognition" CTU "Selection Part" TON == | Int | == Int +Int IN %MW104 T#1.7s — PT "2.product" ET --- ... CV -**%I1.3** "Reset" -0 — PV %MW122 "Product "IEC_Counter_ %M0.4 4.1 (Page1 - 5)

Totally Integrated Automation Portal				
		Туре	Comment	
"1.product"	%MW102	Int		
	%MW104	Int		
	%MW106	Int		
"4.product"	%MW108	Int		
#F rand dust"				
	%MW110	Int		
	%MW112	Int		
"Belt Status"	%MW140	Int		
"Electronic Gate"	%Q0.4	Bool		
	%Q0.6	Bool		
	///Q0.0	Int		
"IEC_Counter_0_DB".CV				
"IEC_Counter_0_DB_1".CV		Int		
"IEC_Counter_0_DB_4".CV		Int		
"Inductive"	%10.7	Bool		
	%I1.4	Bool		
"Product Recognition"	%MW122	Int		
Product Recognition			N	
	%MW100	Int	Metal	
	%I1.5	Bool		
"Reset"	%I1.3	Bool		
	%M0.4	Bool		
	%Q0.5	Bool		
	%11.0	Bool		
"Tag_23"	%MW120	Int		
Network 2:				
Symbol	Address	Туре	Comment	
Network 3:				



Symbol	Address	Type	Comment
"Gripper"	%Q0.3	Bool	
"Handling at Station 1"	%IO.1	Bool	
"Handling Station2"	%10.2	Bool	
"Handling Station 3"	%10.3	Bool	
"Handling to Following Station"	%Q0.1	Bool	
"Handling to Previous Station"	%Q0.0	Bool	
"IEC_Counter_0_DB_2".CV		Int	
"Lifting Cyclinder"	%Q0.2	Bool	
"Lifting Cylinder with gripper is down"	%10.4	Bool	
"Lifting Cylinder with gripper is up"	%10.5	Bool	
"Material Detection Signal"	%10.6	Bool	
"Passing to Station 3"	%M0.5	Bool	
"Reset"	%l1.3	Bool	
"Workpiece is available"	%10.0	Bool	

%10.5

"Lifting Cylinder

with gripper is up"

%M0.5

"Passing to Station 3"

⊣ ⊢

%10.6

"Material

Detection

Signal"

%10.2

"Handling Station2"