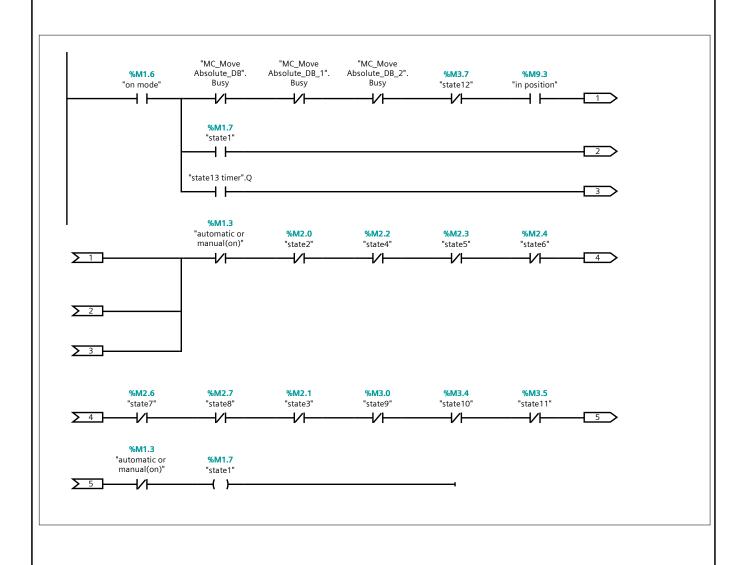
Change Position of Robot [FC6]

Change Position of Robot Properties								
General								
Name	Change Position of Robot	Number	6	Туре	FC			
Language	LAD	Numbering	Automatic					
Information								
Title		Author		Comment				
Family		Version	0.1	User-defined				
				ID				

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
Change Position of Robot	Void		

Network 1: STATE 1 ON



Totally Integrated
Automation Portal

Network 2: Vi tri cua state1

```
%M1.7 "state1"
                           MOVE
 <del>|</del> | |
                           EN - ENO
                    450.0 — IN
                                        %MD100
                               OUT1 — "px"
                           MOVE
                           EN - ENO
                      0.0 — IN
                                        %MD104
                              🚜 OUT1 — "py"
                           MOVE
                           EN - ENO
                     25.0 -
                          - IN
                                        %MD108
                               OUT1 — "pz"
```

Network 3:

```
%M1.7 "state1"
                               IN_RANGE
                                                                    IN_RANGE
                                                                                                          IN_RANGE
                                 Real
                                                                       Real
                                                                                                           Real
                   449.99 -
                                                          -0.01 -
                                                                   MIN
                                                                                               24.99 -
                                                                                                        MIN
                 %MD288
                                                       %MD292
                                                                                            %MD296
                                                      "actual py"
                "actual px" -
                                                                                           "actual pz" -
                   450.01 — MAX
                                                           0.01 — MAX
                                                                                               25.01 — MAX
                                                                      %DB21
                                                                   "state1 timer
                            "MC_Move
Absolute_DB_1".
            "MC_Move
                                                 "MC_Move
                                                                       TON
          Absolute_DB".
                                               Absolute_DB_2".
              Busy
                                 Busy
                                                    Busy
                                                                      Time
\sum_{i=1}^{n}
                                                                  · IN
                                                         T#5MS — PT
                                                                             ET — T#0ms
```

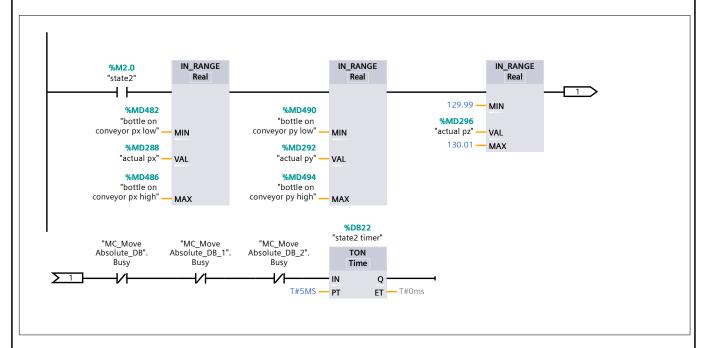
Network 4:

```
%M1.3
                                                                                                        "automatic or
manual(on)"
                        %M9.3
                                             %M4.0
                                                                  %M2.1
                                                                                      %M1.6
                                                                                                                                %M2.0
"state1 timer".Q
                      "in position"
                                           "box is full"
                                                                                     "on mode"
                                                                  "state3"
                                                                                                                               "state2"
                                                                                        -| |-
      4 H
    %M2.0
                                                                                                                               %M11.0
    "state2"
                                                                                                                             "chai co nap"
                                                                                                                                 -(R)-
      4 F
```

Network 5:

Totally Integrated **Automation Portal** %M2.0 "state2" MOVE +EN - ENO %MD100 %MD474 "bottle on conveyor px" — IN 😃 OUT1 -MOVE EN - ENO %MD104 %MD478 👛 OUT1 — "py" "bottle on conveyor py" -MOVE — ENO 130.0 -- IN %MD108 👛 OUT1 — "pz"

Network 6:



Network 7:

```
%DB54
"end timer"
                     %18.2
                                          TON
                "sensor end of conveyor"
%M2.0
                                         Time
"state2'
 4 H
                                     · IN
                                                 Q·
                            T#2s — PT
                                                ET — T#0ms
                    %M11.7
                                                             %M3.0
                                                                                  %M3.4
                                                                                                      %M3.5
                                                                                                                          %M3.7
                                                                                                                                              %M11.0
                                         %M2.7
                                                             "state9"
                                                                                 "state10"
                                                                                                     "state11"
                                                                                                                          "state12"
                "camera detect"
                                         "state8"
                                                                                                                                            "chai co nap"
                                                                                                                                                (s)-
```

Network 8:

Totally Integrated Automation Portal %M1.3 "automatic or manual(on)" %M9.3 %M2.2 %M2.1 %M1.6 "state2 timer".Q "in position" "end timer".Q "state4" "on mode" "state3" 1/} \dashv \vdash ┨┠ ()-%M2.1 "state3" H

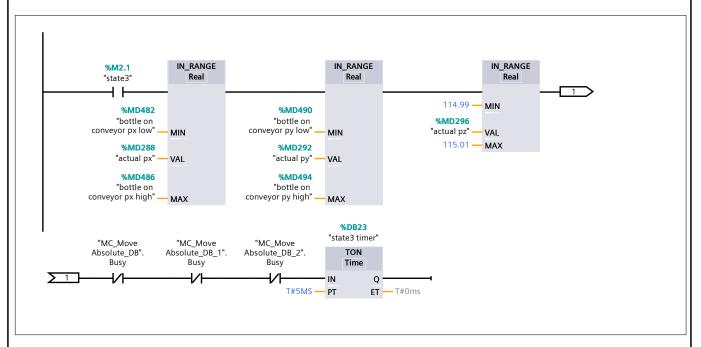
Network 9:

```
%M2.1 "state3"
                               MOVE
                               EN - ENO
                                              %MD100
                    %MD474
                                   COUT1
                   "bottle on
                                              "px"
                 conveyor px" -
                              - IN
                               MOVE
                               ΕN
                                  --- ENO
                                              %MD104
                    %MD478

    OUT1 ─ "py"

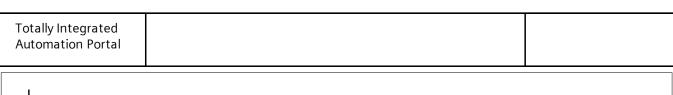
                 "bottle on
conveyor py" -
                                  MOVE
                               - EN
                                    - ENO
                       115.0 — IN
                                              %MD108
                                   OUT1 — "pz"
```

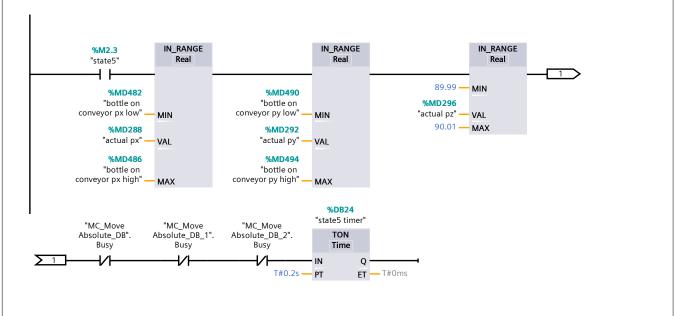
Network 10:



Network 11:

Totally Integrated **Automation Portal** %M1.3 "automatic or manual(on)" %M9.3 %M2.3 %M1.6 %M2.2 "state3 timer".Q "in position" "state5" "on mode" "state4" -1/}-**4** F 4 F -(}-%M2.2 "state4" +Network 12: %M1.3 %MD296 %M2.2 %M2.4 %M1.6 "automatic or manual(on)" %M2.3 "actual pz" "state4" "state6" "on mode" "state5" | <= | | Real -1/1- \dashv \vdash +**-(**)-90.0 %M2.3 "state5" **H** F Network 13: **%M2.3** "state5" MOVE +EN - ENO %MD100 %MD474 "bottle on conveyor px" — IN COUT1 MOVE EN - ENO %MD104 %MD478 **OUT1** — "py" "bottle on conveyor py" -MOVE EN - ENO 90.0 -IN %MD108 👸 OUT1 — "pz" Network 14:





Network 15:

```
%M1.3
                                                %M2.6
                                                                                         "automatic or
manual(on)"
                                                                                                                   %M2.4
                          %M9.3
                                                                      %M1.6
"state5 timer".Q
                        "in position"
                                                "state7"
                                                                     "on mode"
                                                                                                                  "state6"
                                                  <del>1</del>/}
                                                                                                                    ( )
      1  
                            4 F
                                                                        1 F
    %M2.4
    "state6"
     4 F
```

Network 16:

```
%M1.3
                   %MD296
%M2.4
                                        %M2.7
                                                            %M1.6
                                                                             "automatic or
                                                                                                    %M2.6
                  "actual pz"
"state6"
                                        "state8"
                                                          "on mode"
                                                                             manual(on)"
                                                                                                   "state7"
 4 F
                                         <del>1</del>/}
                                                                                                     ( )-
                                                             1 H
                    Real
%M2.6
"state7"
 + +
```

Network 17:

Totally Integrated Automation Portal %M2.6 "state7" MOVE +EN - ENO %MD100 "array position". "bottle position x"["bottle <mark>--</mark> "рх" OUT1 ── position order"] _ MOVE EN -— ENO %MD104 "array position". "bottle position y"["bottle position order"] **OUT1** — "py" MOVE

EN - ENO

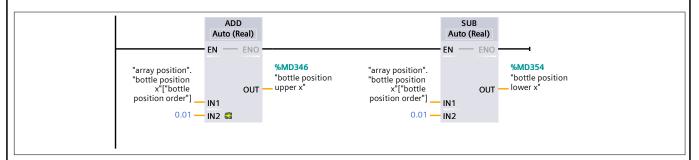
😃 OUT1 -

%MD108

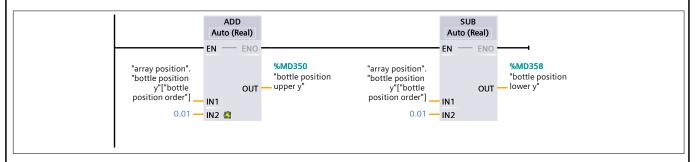
– "pz"

160.0 — IN

Network 18:



Network 19:



Network 20:

Totally Integrated
Automation Portal

"M2.6 "state7" Real IN_RANGE Real Real

"MD354 %MD358

MIN

VAL

MAX

· IN

PT

%DB26 "state8 timer"

TON

Time

Q ·

ET -

__ T#0ms

%MD296 "actual pz" –

tual pz" — VAL 160.01 — MAX

"bottle position lower y"

"bottle position upper y"

"MC_Move Absolute_DB_2".

Busy

%MD292 "actual py"

%MD350

T#5MS -

Network 21:

"bottle position lower x"

%MD288

"actual px"

%MD346

"bottle position upper x"

"MC_Move Absolute_DB". Busy MIN

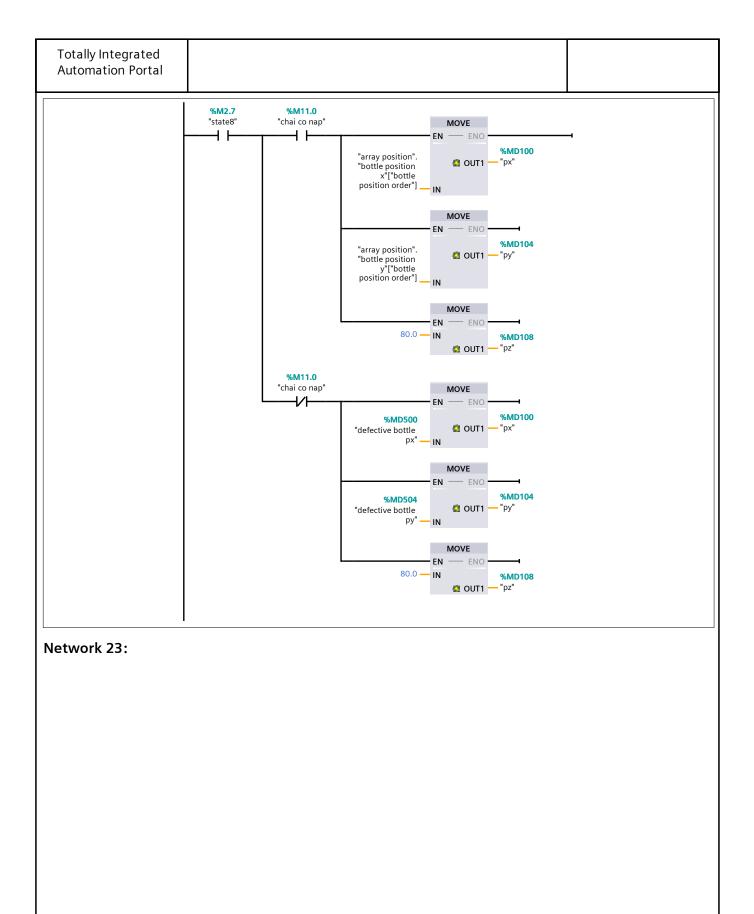
VAL

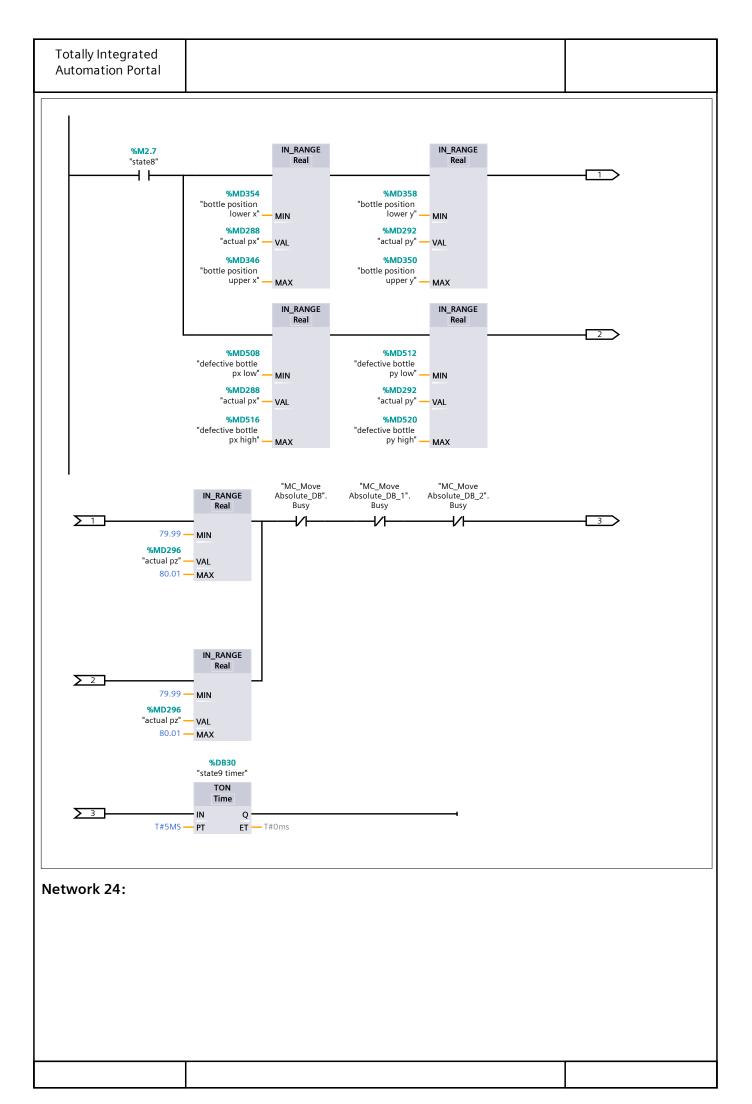
MAX

"MC_Move Absolute_DB_1". Busy

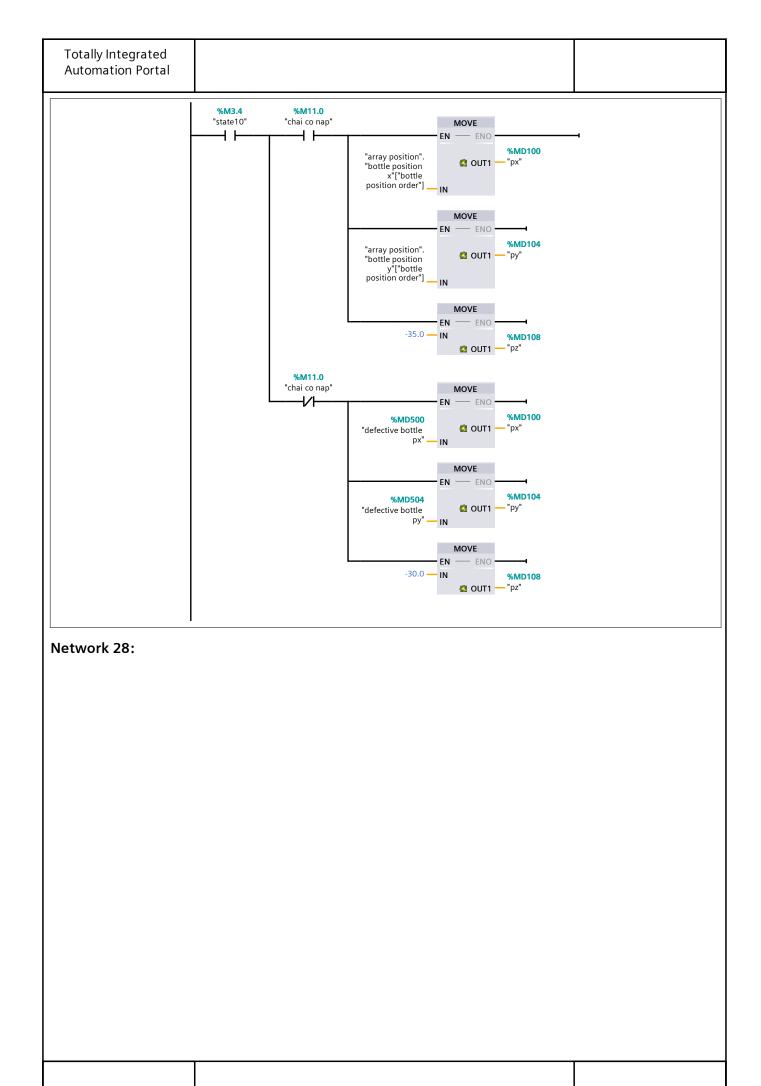
```
%M1.3
                                                                                                                       %M2.7 "state8"
                            %M9.3
                                                  %M1.6
                                                                          %M3.0
                                                                                            "automatic or
manual(on)"
"state8 timer".Q
                         "in position"
                                                 "on mode"
                                                                         "state9"
                                                    H F
                                                                           <del>1</del>/}
                                                                                                                         ( )-
       1  
                             4 F
     %M2.7
    "state8"
      4 F
```

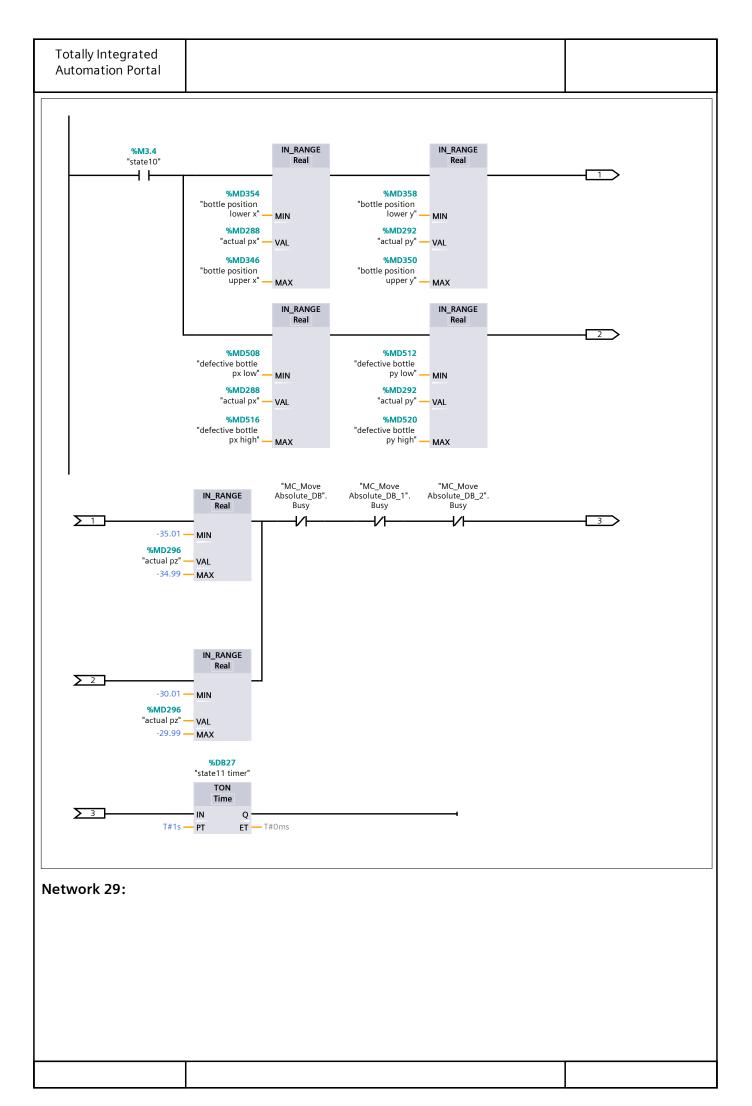
Network 22:





Totally Integrated **Automation Portal** %M1.3 **%M3.4** "state10" "automatic or manual(on)" %M9.3 %M1.6 %M3.0 "state9 timer".Q "in position" "on mode" "state9" -1/}-**4** F ()-┨┞ %M3.0 "state9" **-**| |-Network 25: %M1.3 %MD296 "automatic or manual(on)" %M3.0 %M11.0 %M3.5 %M1.6 %M3.4 "actual pz" "state9" "chai co nap" "state11" "on mode" "state10" <= | Real //|-| | |- \dashv \vdash ()--35.0 %M3.4 "state10" **H** F Network 26: %M1.3 %MD296 **%M3.5** "state11" "automatic or manual(on)" %M3.0 %M3.4 %M11.0 %M1.6 "actual pz" "chai co nap" "state9" "on mode" "state10" <= Real 1/} 1 ()-1 %M3.4 "state10" Network 27:





Totally Integrated Automation Portal %M1.3 **%M3.7** "state12" "automatic or manual(on)" **%M3.5** "state11" %M1.6 "state11 timer".Q "on mode" 1/|-()- $\dashv \vdash$ ┨┞ %M3.5 "state11" +Network 30: **%M1.3**"automatic or manual(on)" %MD296 **%M3.5** "state11" **%M1.7** "state1" **%M3.7** "state12" %M1.6 "actual pz" "on mode" >= Real //|- \dashv \vdash | | |-**-**()--15.0 %M3.7 "state12" Network 31:

