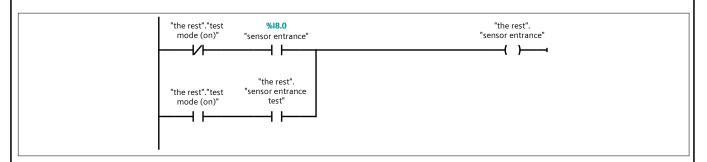
|--|

the rest of the system [FC4]

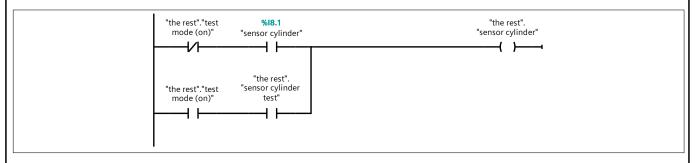
the rest of the system Properties								
General								
Name	the rest of the system	Number	4	Туре	FC			
Language	LAD	Numbering	Automatic					
Information								
Title		Author		Comment				
Family		Version	0.1	User-defined				
				ID				

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
the rest of the system	Void		

Network 1:



Network 2:



Network 3:

Totally Integrated Automation Portal "the rest"."test mode (on)" %I8.3 "sensor out" "the rest". "sensor output" -1/1- \dashv \vdash ()-"the rest". "sensor output test" "the rest"."test mode (on)" \dashv \vdash **-**| |-Network 4: "the rest". "onmode the rest" "the rest"."start the rest" "the rest"."stop the rest" **%I1.2** %M3.1 "stop button" "already home" -1/|- $\dashv \vdash$ ()-%M1.6 "on mode" $\dashv \vdash$ "the rest". "onmode the rest" | | | Network 5: "the rest". "onmode the rest" **%M12.5** "not conveyor in" %Q8.3 "conveyor in" **→**)— Network 6:

Totally Integrated **Automation Portal** %DB47 "number of bottle" "MC_Move Relative_DB_3". CTUD "the rest". "the rest". "sensor entrance" "entrance free" Busy Int CU **QD →**false **cv** — 0 "number of "the rest"."output free" bottle".CV > Int **⊣**բ Ի CD "the rest"."output free ons" "the rest". "manual reset the rest" false — LD 4 — PV "the rest". "onmode the rest" Network 7: "the rest"."output free" "the rest". "cylinder free" "the rest". "entrance free" "the rest".free +4 F ()-Network 8: "MC_Move Relative_DB_3". %M13.1 "het chai trong "number of bottle".CV "delay mam xoay".Q "the rest". "the rest". "the rest". "the rest".free "execute relative" "sensor output" Busy dia" "execute relative" -1/1--1/1- $\dashv \vdash$ -(s)-┨╟ Int 0 Network 9: %DB53 "delay mam xoay" "MC_Move Relative_DB_3". TON Busy Time ET — T#0ms T#5s — **PT** Network 10:

```
Totally Integrated
   Automation Portal
                                          "MC_Move
Relative_DB_3".
                                                                                                                                  "the rest".
"execute relative"
                                               Done
                                                                                                                                         -( R )-
Network 11:
                                                                                                                 %DB50
                                                                                                           "IEC_Timer_0_DB_
1"
                                                               "the rest"."bottle
at output"
                                                                                       "the rest".
"sensor output"
                                                                                                                  TONR
                                               %Q8.2
                                           "conveyor out"
                                                +
                                                                                                              IN
                                                                                                                          ET — T#0ms
                                          "MC_Move
Relative_DB_3".
Busy
                                                                                                    T#1s — PT
Network 12:
                                                                "MC_Move
Relative_DB_3".
Busy
                                                                                                                                  "the rest"."bottle
at output"
                                             "the rest".
                                          "sensor output"
                                                                                       P_TRIG
                                                H F
                                                                                                                                         -( s )-
                                                                                       CLK Q
                                                                                       "the rest"."ons
for bottle at
output"
Network 13:
                                         "IEC_Timer_0_DB_
1".Q
                                                                                                                                  "the rest"."bottle
at output"
                                                 4 F
                                                                                                                                         -( R )-
Network 14:
                                          "the rest"."bottle
at output"
                                                                                                                                 "the rest"."output
free"
                                                <del>-</del>1/1-
                                                                                                                                         ( )-
Network 15:
```

Totally Integrated **Automation Portal** "MC_Move Relative_DB_3". "the rest". "cylinder free" "the rest". "sensor cylinder" Busy P_TRIG _(R)_ CLK Q "the rest". "cylinder free ons" Network 16: %DB51 "cylinder timer" "the rest". "cylinder free" TP Time Q T#5s — **PT** ET — T#0ms Network 17: "the rest". %Q8.0 "cylinder timer".ET "cylinder timer".ET "cylinder free" "cylinder" > Time < Time T#1s T#3.5s Network 18: "the rest". "cylinder free" "cylinder timer".Q $\exists N \vdash$ -(s)--"the rest". "cylinder timer ons" Network 19: "MC_Move Relative_DB_3". Busy "the rest". "sensor entrance" "the rest". "entrance free" P_TRIG _(R)_ +CLK Q "the rest". "sensor entrance ons" Network 20:

Totally Integrated **Automation Portal** %DB25 "timer entrance" "MC_Move Relative_DB_3". Busy "the rest". "sensor entrance" Time - IN Q· ET — T#0ms Network 21: "the rest". "onmode the rest" "timer entrance". ET "timer entrance". ET %Q8.1 "water valve" <= 4 + Time Time **%Q8.4** "pump" **-()**-%M12.5 "not conveyor in" Network 22: "the rest". "entrance free" "timer entrance". Q **-(** s **)-**4 N F "the rest"."timer entrance ons" Network 23: %M9.4 **%M2.3** "state5" "conveyor out not" **H** F **(**)-**%M2.4** "state6" | | | %M2.6 "state7" Network 24:

Totally Integrated **Automation Portal** "the rest". %M9.4 "onmode the rest" "conveyor out not" %Q8.2 "conveyor out" ()-Network 25: %M13.1 %18.3 %18.0 **%I8.1** "het chai trong dia" "sensor out" "sensor entrance" "sensor cylinder" $\exists N \vdash$ ()-%M13.0 "Tag_6" Network 26: **%DB49**"MC_Move Relative_DB_3" MC_MoveRelative **₽** ENO -EN Done → false %DB42 "Axis_4" — Axis Error —false "the rest". "execute relative" \dashv \vdash Execute 90.0 — Distance 30.0 — Velocity Network 27: %DB55 "MC_ReadParam_ DB_5" MC_ReadParam Real <u>∞</u> 8 ENO -- EN 1 — Enable Valid → false Error —false "Axis_4".Actual Position — Parameter %MD452 "actual theta4" — Value Network 28: