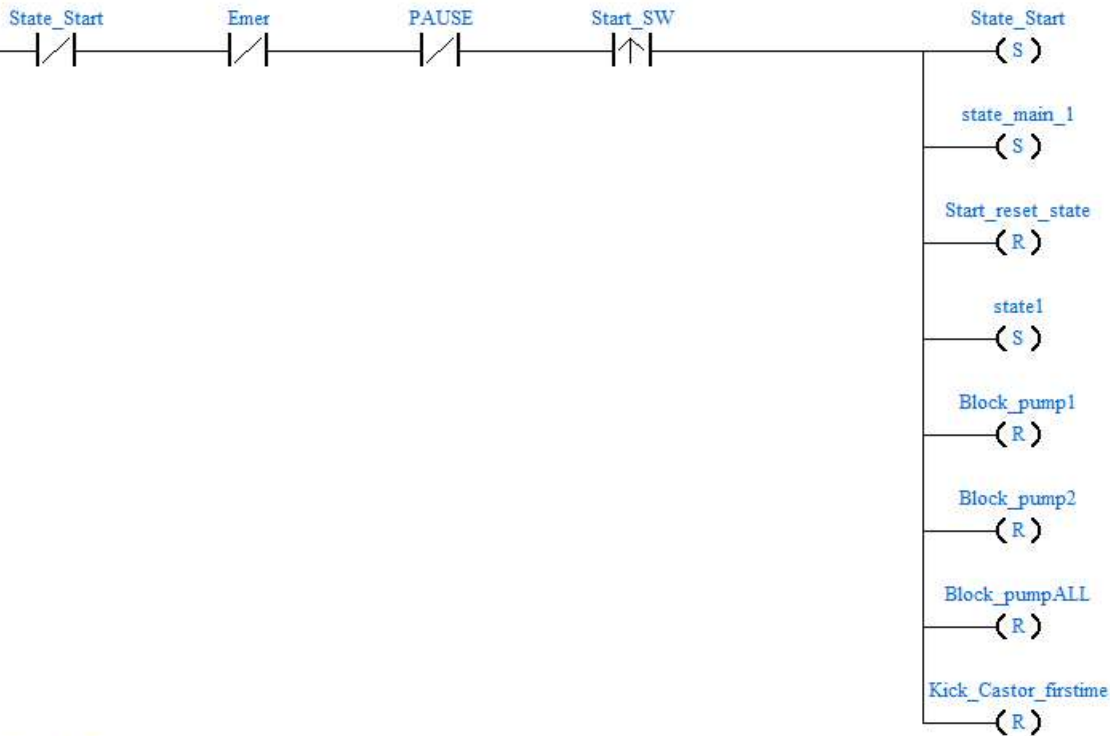


Declaration Type	Identifiers	Address	Type	Initial Value	Identifier Comments
VAR	state1	M101	BOOL	FALSE	
VAR	state2	M102	BOOL	FALSE	
VAR	state3	M103	BOOL	FALSE	
VAR	state4	M104	BOOL	FALSE	
VAR	state5	M105	BOOL	FALSE	
VAR	state6	M106	BOOL	FALSE	
VAR	state7	M107	BOOL	FALSE	
VAR	state8	M108	BOOL	FALSE	
VAR	state9	M109	BOOL	FALSE	
VAR	state10	M110	BOOL	TRUE	
VAR	state_main_1	M111	BOOL	FALSE	
VAR	state11	M112	BOOL	FALSE	
VAR	state12	M113	BOOL	FALSE	
VAR	state13	M114	BOOL	FALSE	
VAR	state14	M115	BOOL	FALSE	
VAR	state15	M116	BOOL	FALSE	
VAR	state16	M117	BOOL	FALSE	
VAR	state17	M118	BOOL	FALSE	
VAR	state18	M119	BOOL	FALSE	
VAR	state19	M120	BOOL	FALSE	
VAR	state20	M121	BOOL	FALSE	
VAR	state21	M122	BOOL	FALSE	
VAR	state22	M123	BOOL	FALSE	
VAR	state_main_2	M130	BOOL	FALSE	
VAR	state_main_3	M131	BOOL	FALSE	
VAR	state_pumpAll up	M140	BOOL	FALSE	
VAR	state_pumpAll down	M141	BOOL	FALSE	
VAR	state_run_pump	M142	BOOL	FALSE	
VAR	is_pump_All_Down	M143	BOOL	FALSE	
VAR	state_pump1_down	M144	BOOL	FALSE	
VAR	state_pump2_down	M145	BOOL	FALSE	
VAR	state_pump1 up	M146	BOOL	FALSE	
VAR	state_pump2 up	M147	BOOL	FALSE	
VAR	is_pump1_Down	M148	BOOL	FALSE	
VAR	is_pump2_Down	M149	BOOL	FALSE	
VAR	Block_pump1	M150	BOOL	FALSE	
VAR	Block_pump2	M151	BOOL	FALSE	
VAR	Block_pumpALL	M152	BOOL	FALSE	
VAR	State_Emer	M200	BOOL	FALSE	
VAR	Reset_State	M202	BOOL	FALSE	
VAR	Start_reset_state	M203	BOOL	FALSE	
VAR	reset state main	M204	BOOL	FALSE	
VAR	reset state_1	M205	BOOL	FALSE	
VAR	reset state_2	M206	BOOL	FALSE	
VAR	reset state_3	M207	BOOL	FALSE	
VAR	reset state_4	M208	BOOL	FALSE	
VAR	reset state_5	M209	BOOL	FALSE	
VAR	EMER_pump_UP	M210	BOOL	FALSE	
VAR	PAUSE	M211	BOOL	FALSE	
VAR	State_Start	M212	BOOL	FALSE	
VAR	Set_Drive_belt	M214	BOOL	FALSE	
VAR	Kick_Castor_firsttime	M213	BOOL	FALSE	
VAR	TIMER_KeeperS1	T10	TIMER	N/A	
VAR	TIMER_KeeperS2	T11	TIMER	N/A	
VAR	TIMER_KeeperS3	T12	TIMER	N/A	
VAR	arm2_slide back	X0	BOOL	FALSE	
VAR	arm1_slide back	X1	BOOL	FALSE	
VAR	arm2_Lift_Down	X2	BOOL	FALSE	
VAR	arm2_Lift_UP	X3	BOOL	FALSE	
VAR	arm1_Lift_UP	X4	BOOL	FALSE	
VAR	arm2_slide font	X5	BOOL	FALSE	
VAR	arm1_slide font	X6	BOOL	FALSE	
VAR	arm1_Lift_Down	X7	BOOL	FALSE	
VAR	pump1_Top	X10	BOOL	FALSE	
VAR	pump2_Button_Heavy	X11	BOOL	FALSE	
VAR	pump2_Button_Thin	X12	BOOL	FALSE	
VAR	pump1_Button_Thin	X13	BOOL	FALSE	
VAR	pump1_Button_Heavy	X14	BOOL	FALSE	
VAR	pump2_Top	X15	BOOL	FALSE	
VAR	arm2_Turn_Rotate	X16	BOOL	FALSE	
VAR	arm2_Turn_Normal	X17	BOOL	FALSE	
VAR	arm2_keep_close	X20	BOOL	FALSE	
VAR	arm2_keep_open	X21	BOOL	FALSE	
VAR	arm1_Turn_Rotate	X22	BOOL	FALSE	
VAR	arm1_Turn_Normal	X23	BOOL	FALSE	
VAR	arm1_keep_close	X24	BOOL	FALSE	
VAR	arm1_keep_open	X25	BOOL	FALSE	
VAR	Main_Slide_LEFT	X26	BOOL	FALSE	
VAR	Main_Slide_RIGHT	X27	BOOL	FALSE	

VAR	Start_SW	X31	BOOL	FALSE	
VAR	is_castor	X32	BOOL	FALSE	
VAR	Emer	X34	BOOL	FALSE	
VAR	PAUSE_SW	X35	BOOL	FALSE	
VAR	pump_type	X36	BOOL	FALSE	
VAR	is_slide_get_bering	X37	BOOL	FALSE	
VAR	is_slide_bering	X40	BOOL	FALSE	
VAR	is_bearing_thin_ON	X42	BOOL	FALSE	
VAR	is_bearing_heavyON	X43	BOOL	FALSE	
VAR	Main_Slide	Y0	BOOL	FALSE	
VAR	arm1_Turn	Y1	BOOL	FALSE	
VAR	arm1_Lift	Y2	BOOL	FALSE	
VAR	arm1_Slide	Y3	BOOL	FALSE	
VAR	arm2_Slide	Y4	BOOL	FALSE	
VAR	arm2_Turn	Y5	BOOL	FALSE	
VAR	arm1_Keep	Y6	BOOL	FALSE	
VAR	arm2_Lift	Y7	BOOL	FALSE	
VAR	pump1_UP	Y11	BOOL	FALSE	
VAR	pump2_DOWN	Y12	BOOL	FALSE	
VAR	pump_Run	Y13	BOOL	FALSE	
VAR	pump1_DOWN	Y14	BOOL	FALSE	
VAR	pump2_UP	Y15	BOOL	FALSE	
VAR	arm2_Keep	Y20	BOOL	FALSE	
VAR	pump_Motor_1	Y21	BOOL	FALSE	
VAR	Drive_belt	Y22	BOOL	FALSE	
VAR	Drive_kick_castor	Y23	BOOL	FALSE	
VAR	Drive_bering_last	Y24	BOOL	FALSE	
VAR	pump_Motor_2	Y25	BOOL	FALSE	
VAR	Drive_get_bering	Y26	BOOL	FALSE	
VAR	Drive_slide_bearing_in	Y27	BOOL	FALSE	

Network 1

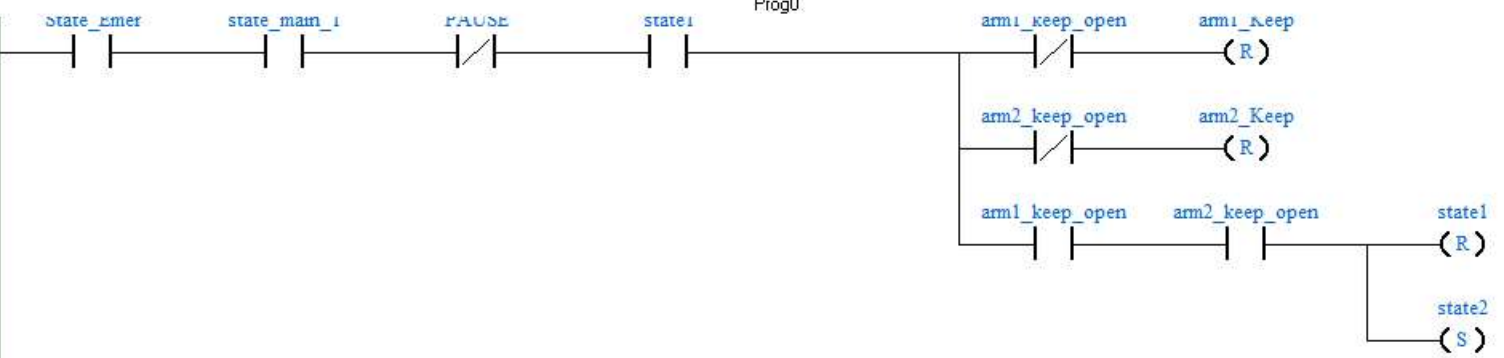


Network 2

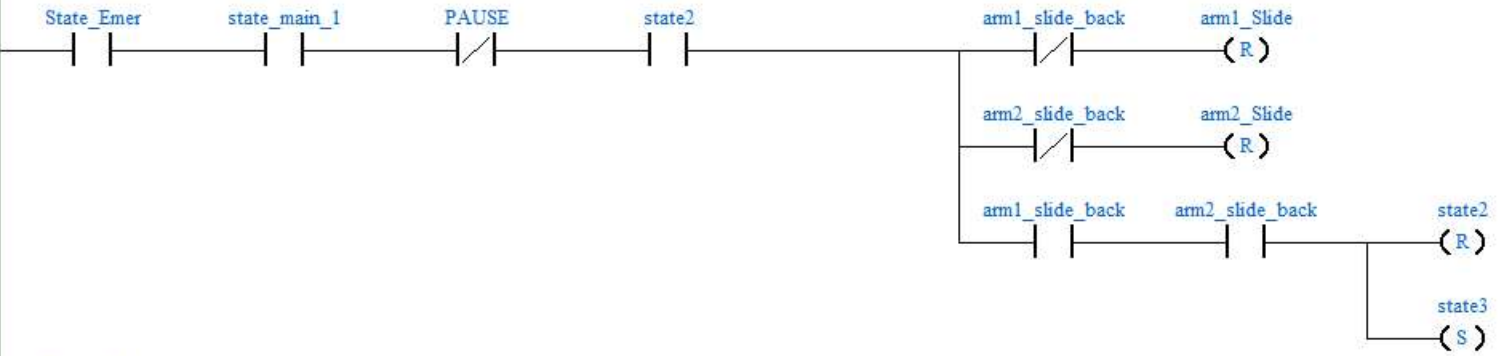


Network 3

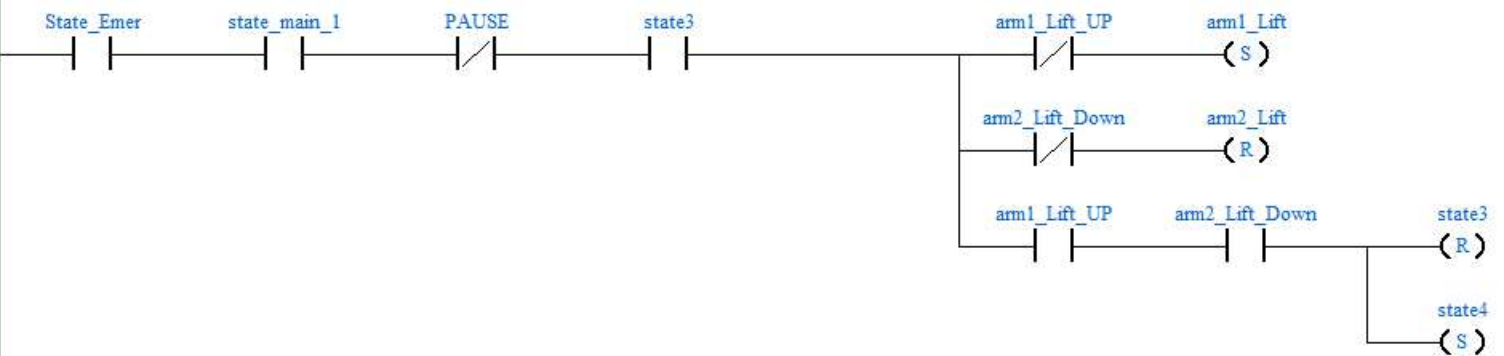
STATE ----- START----->



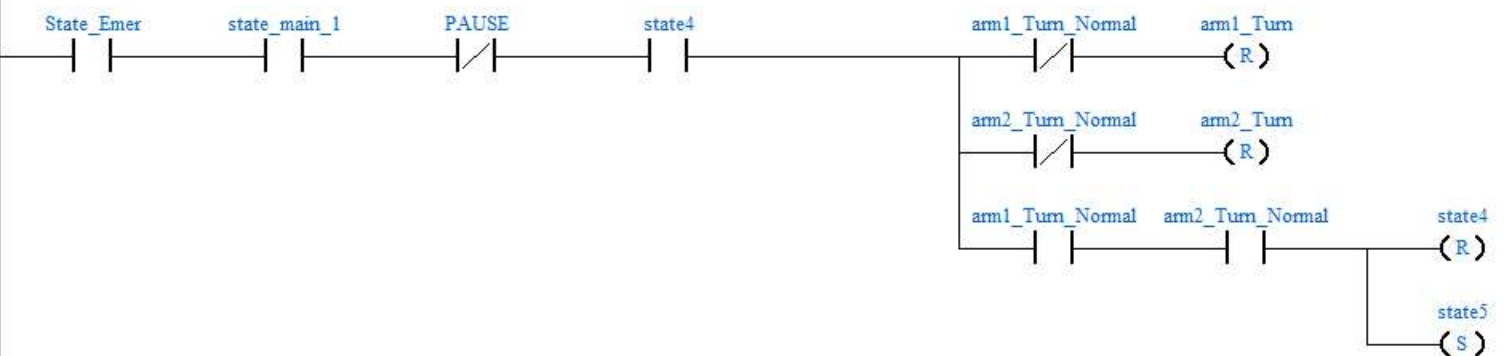
Network 4



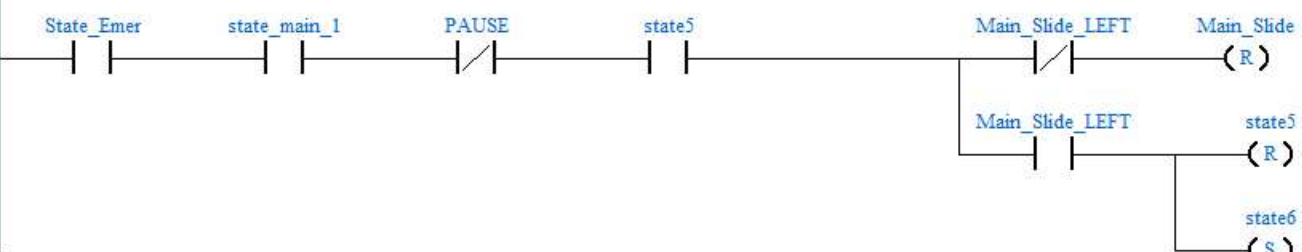
Network 5



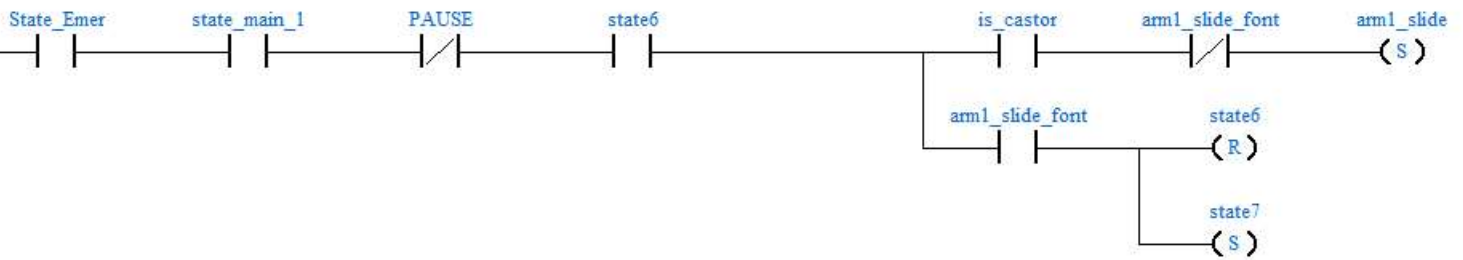
Network 6



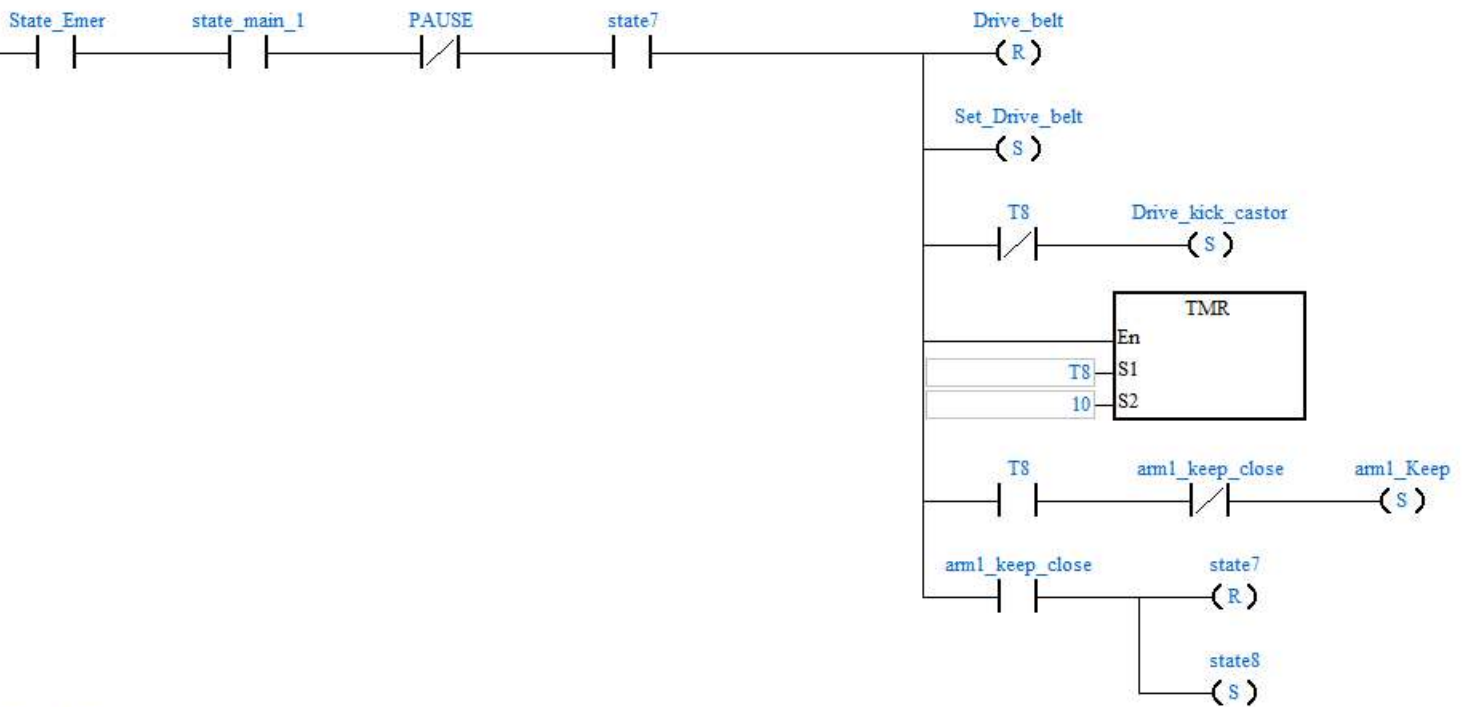
Network 7



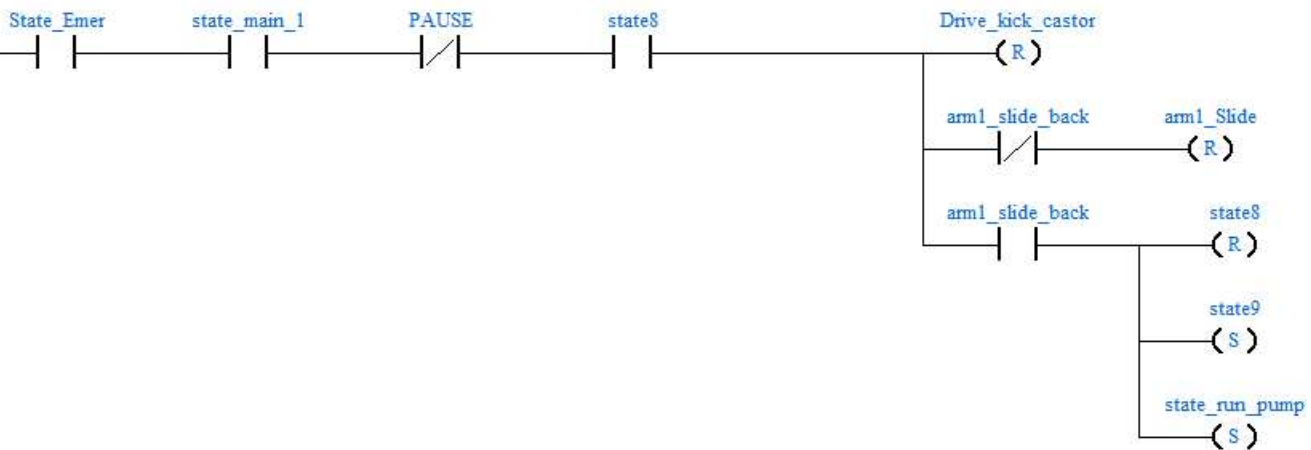
Network 8



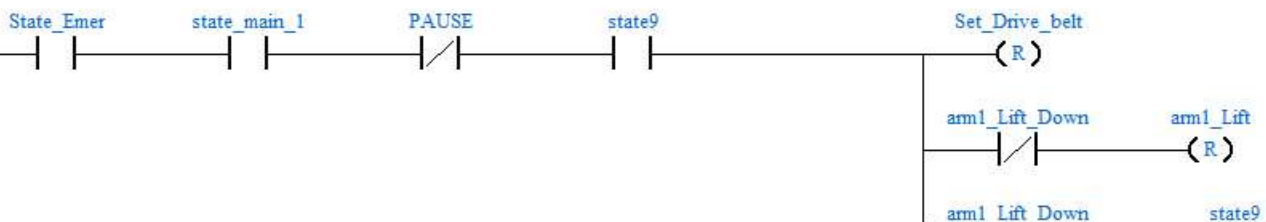
Network 9

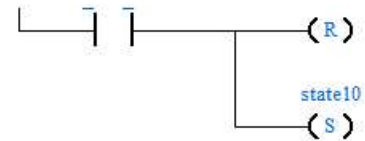


Network 10

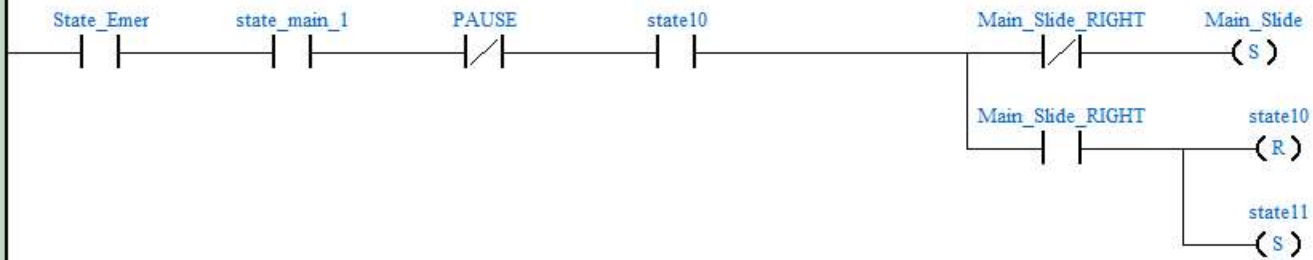


Network 11

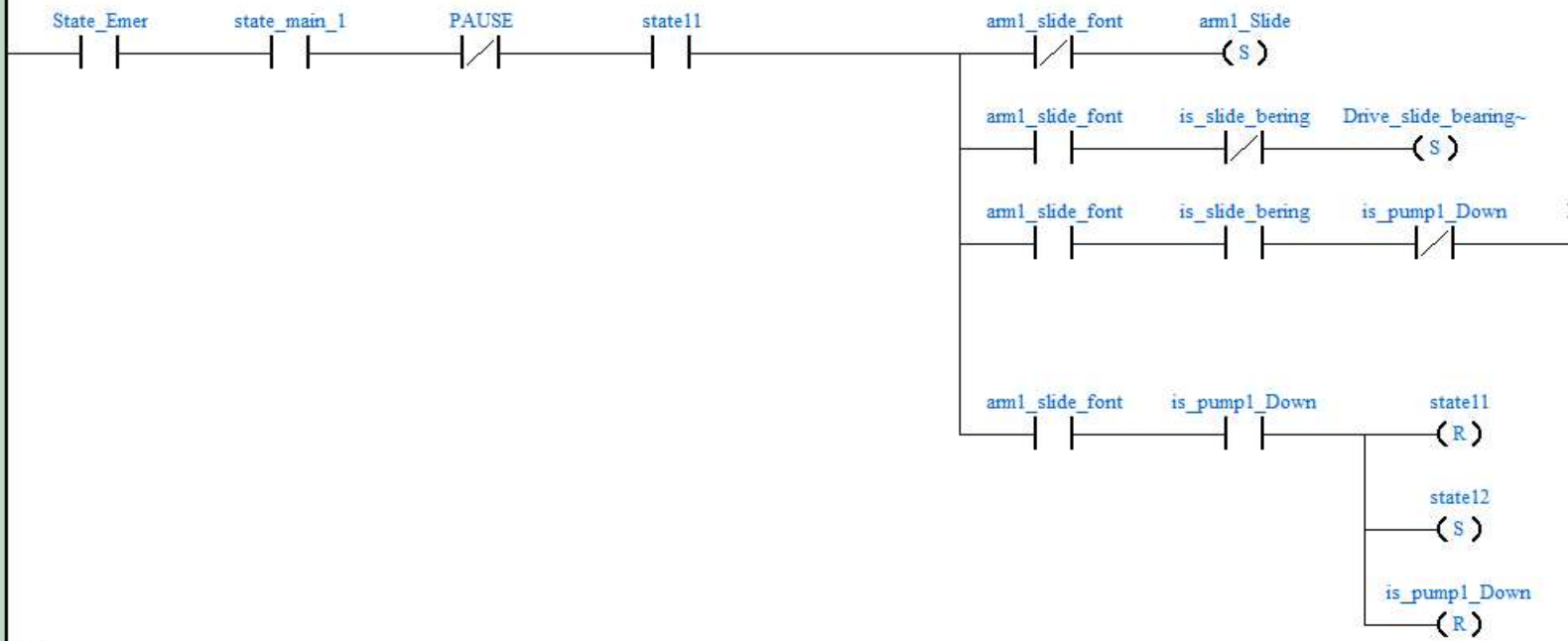




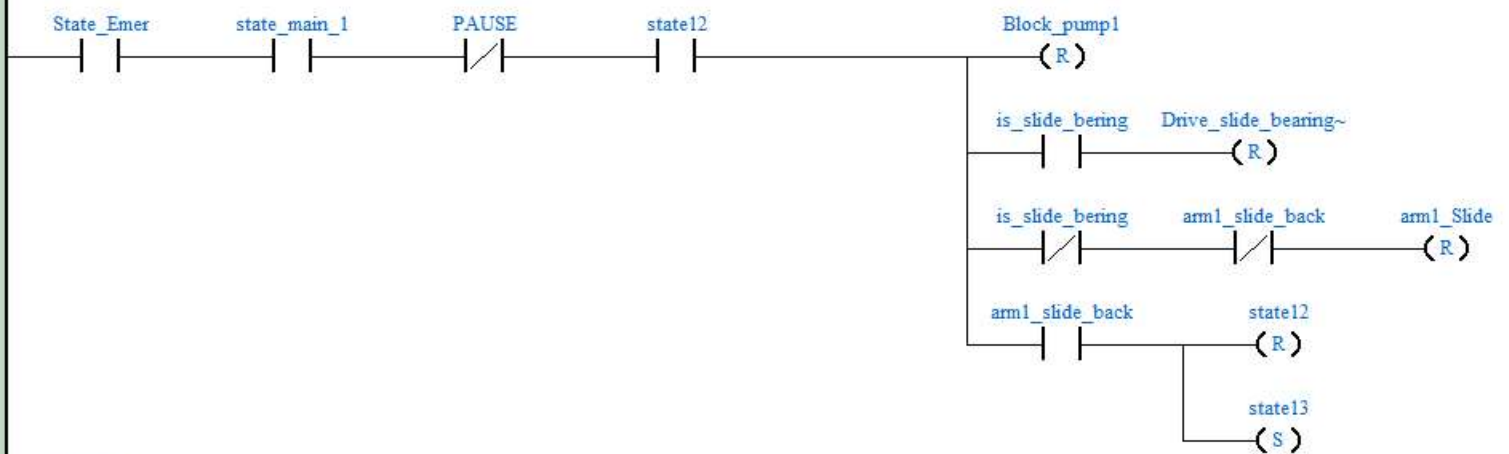
Network 12



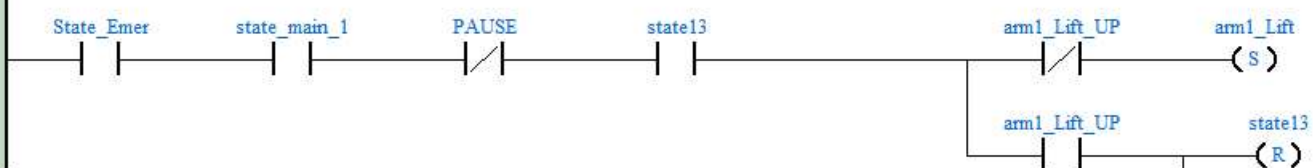
Network 13

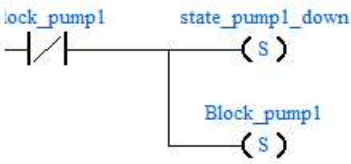


Network 14



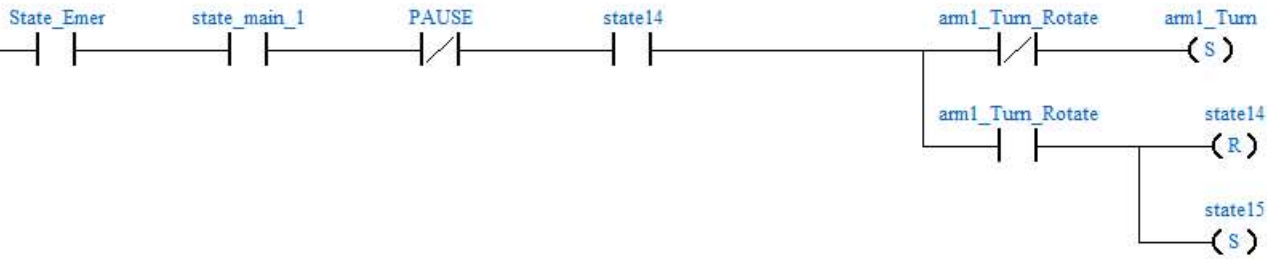
Network 15



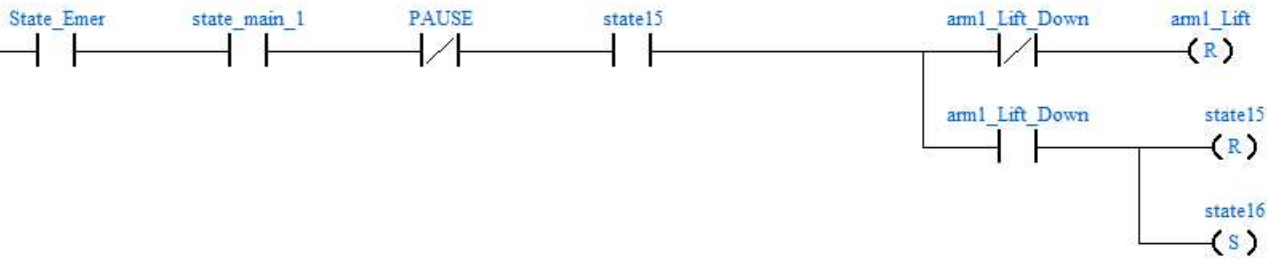


state14
(S)

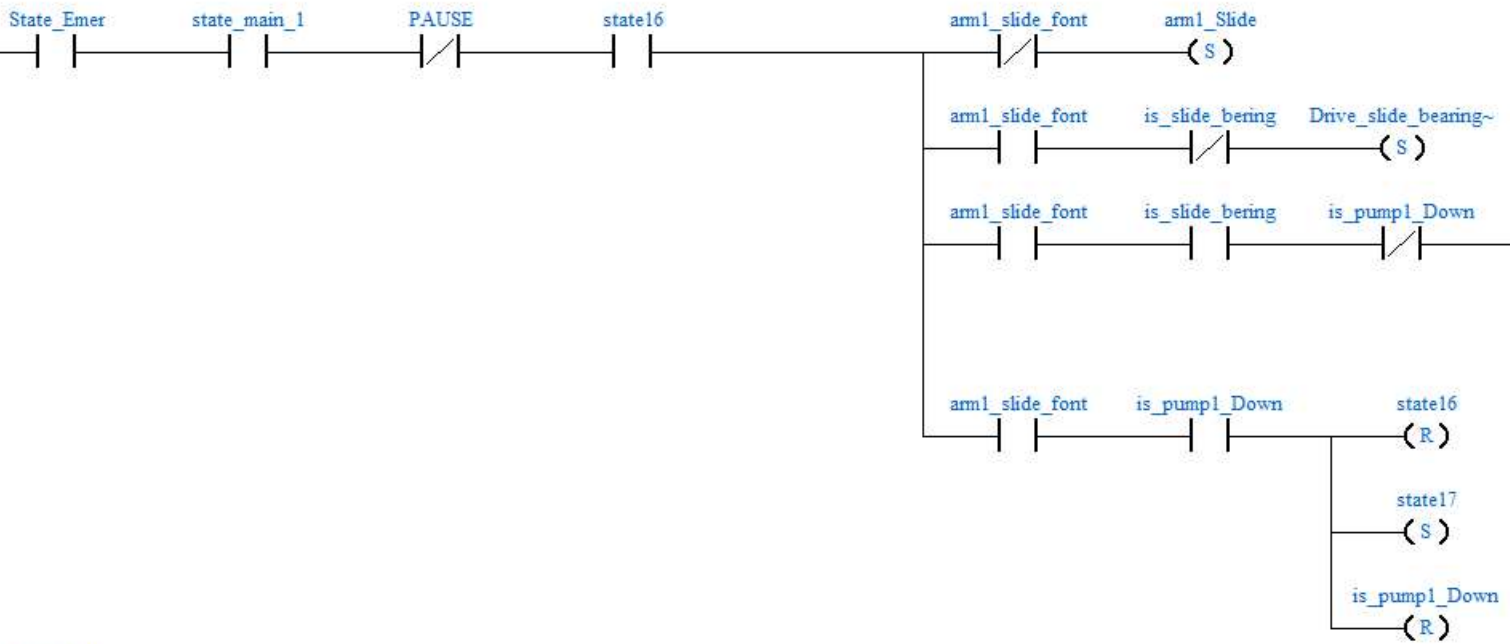
Network 16



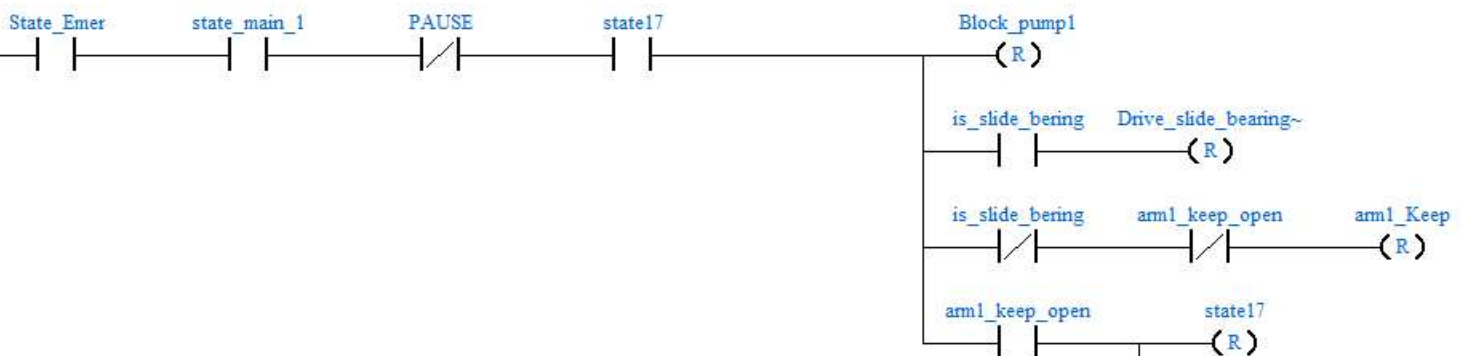
Network 17

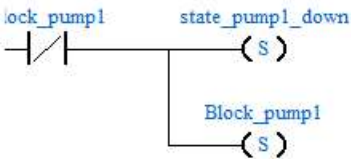


Network 18



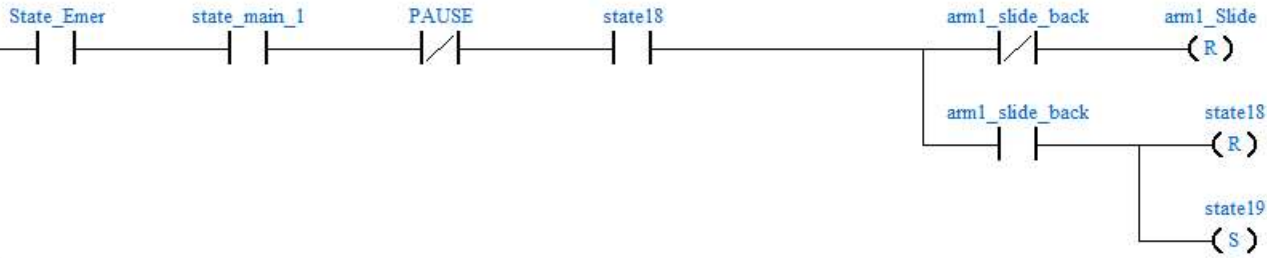
Network 19



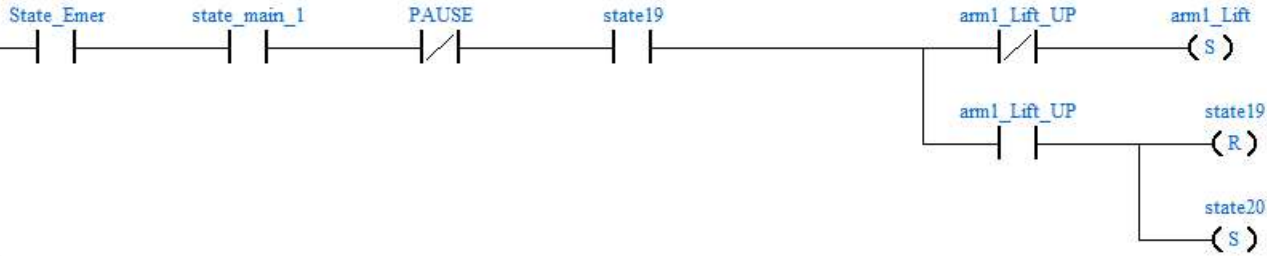


state18
(S)

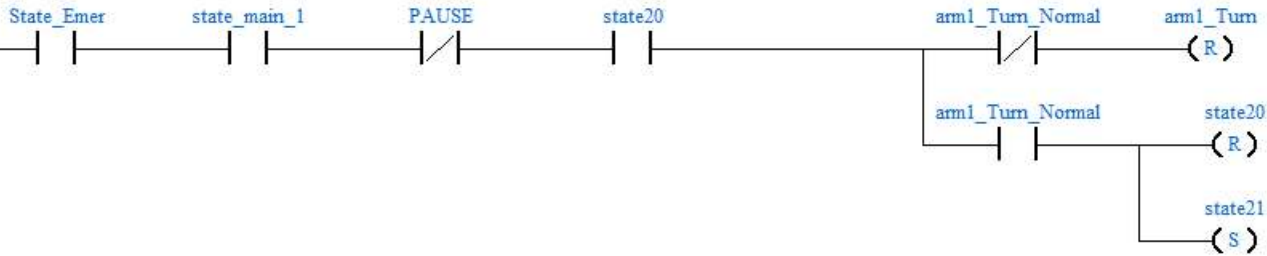
Network 20



Network 21

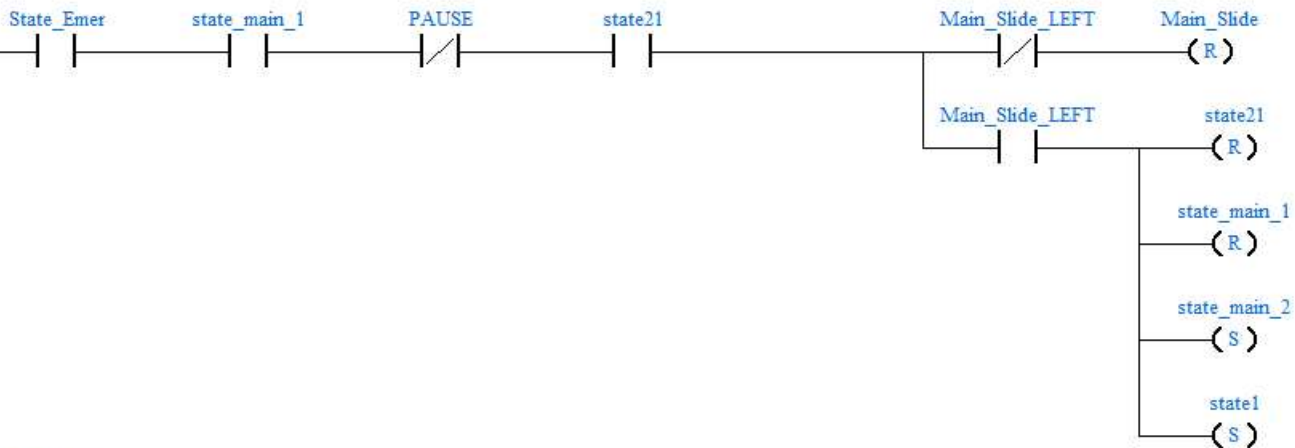


Network 22



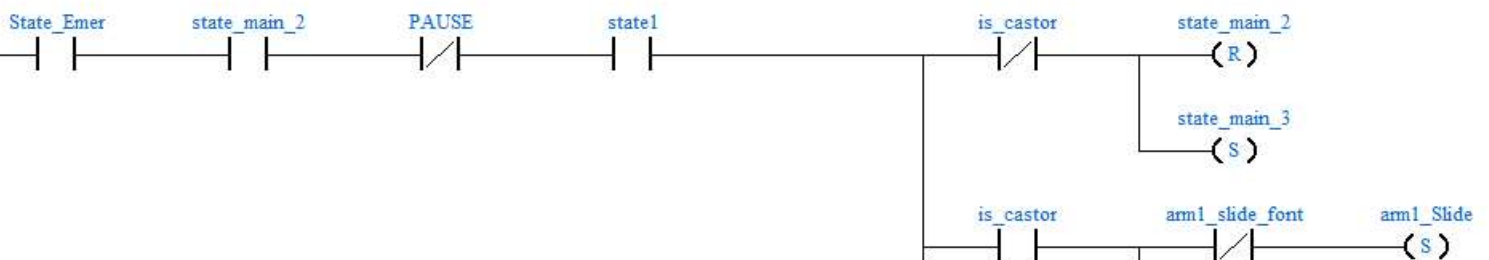
Network 23

STATE START <<<

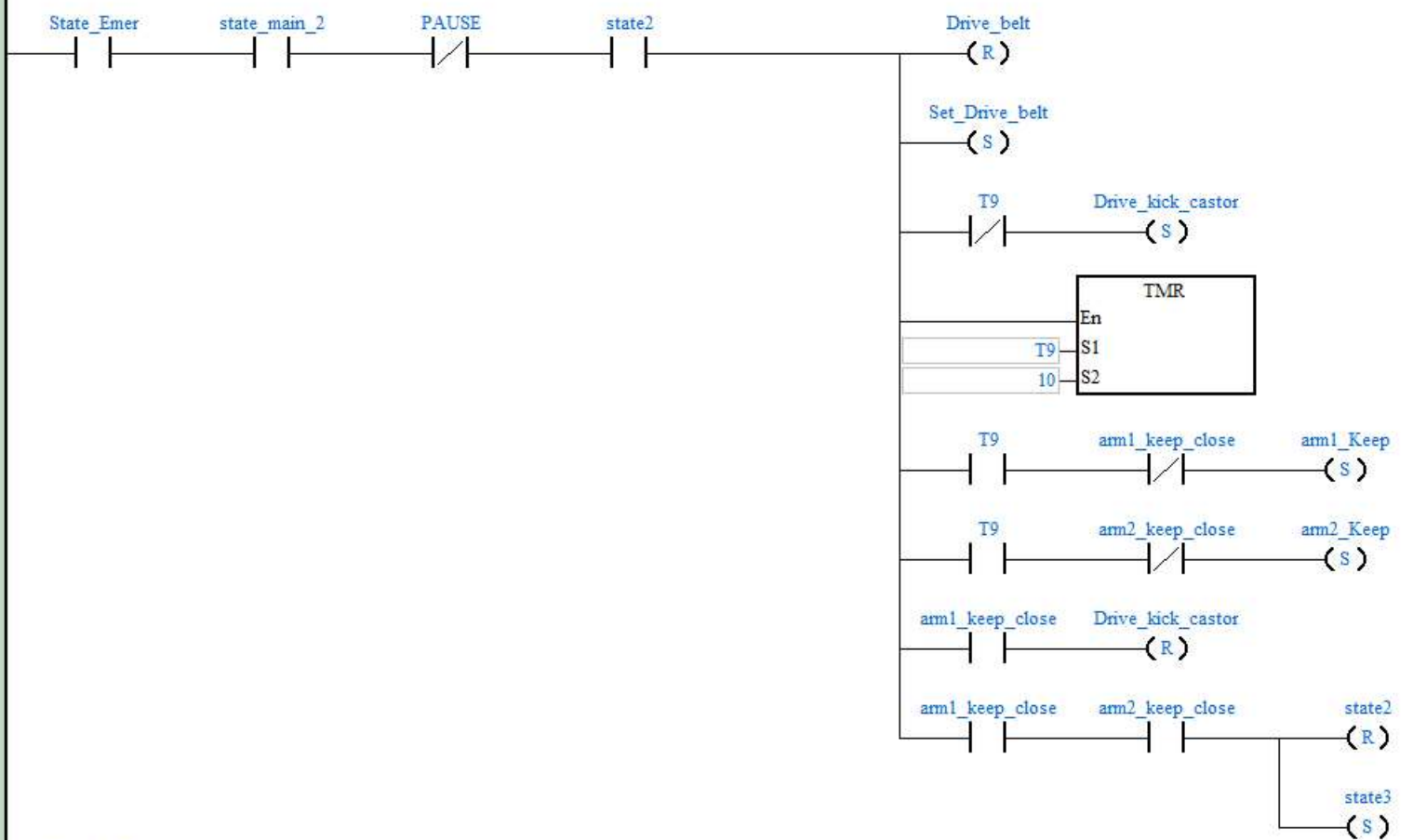


Network 24

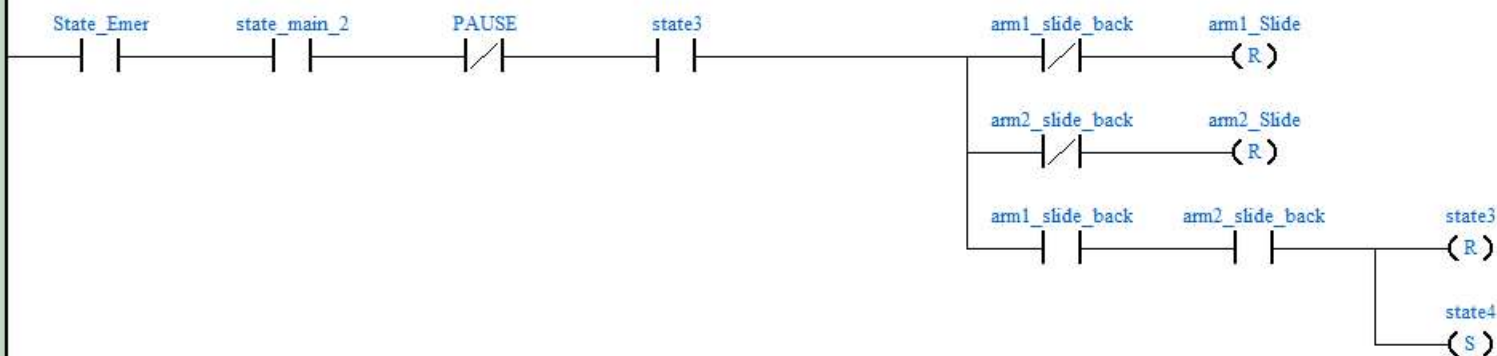
STATE CENTER >



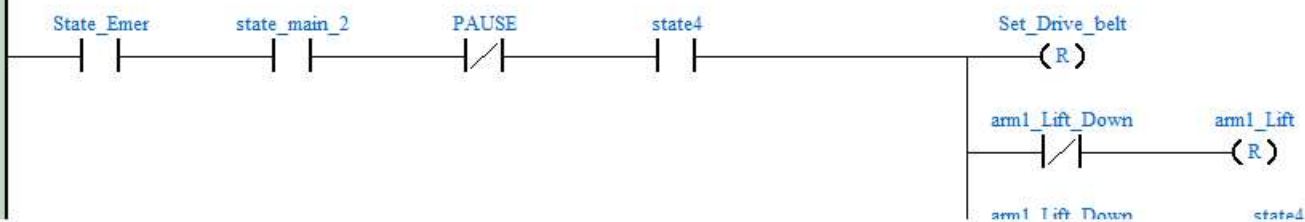
Network 25



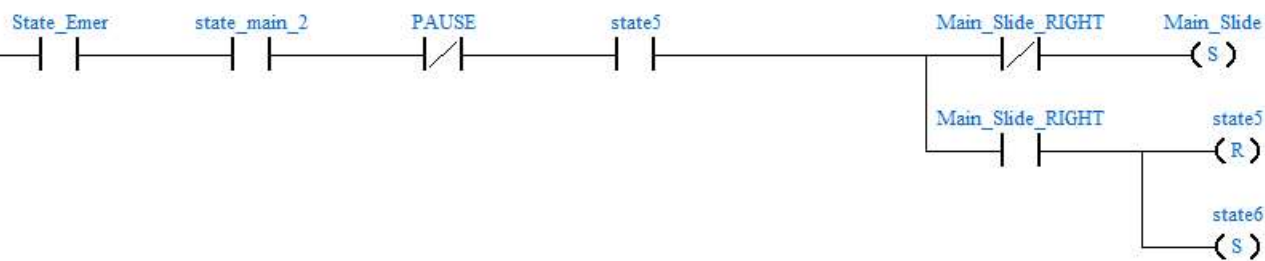
Network 26



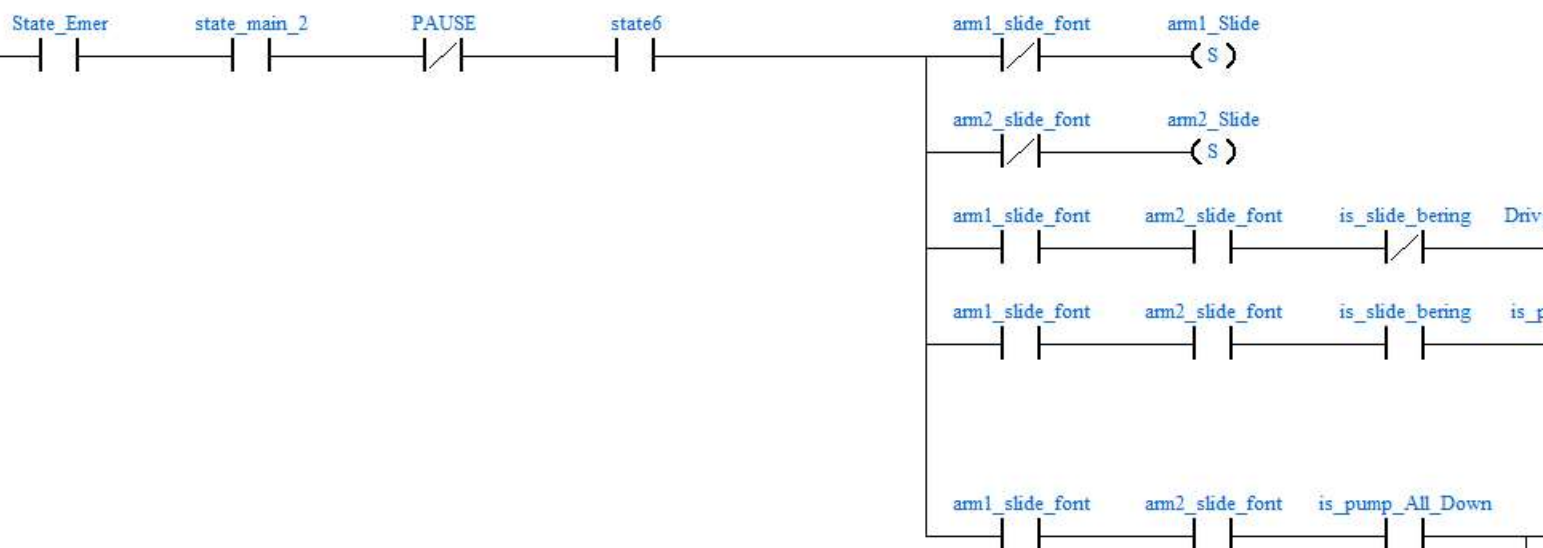
Network 27



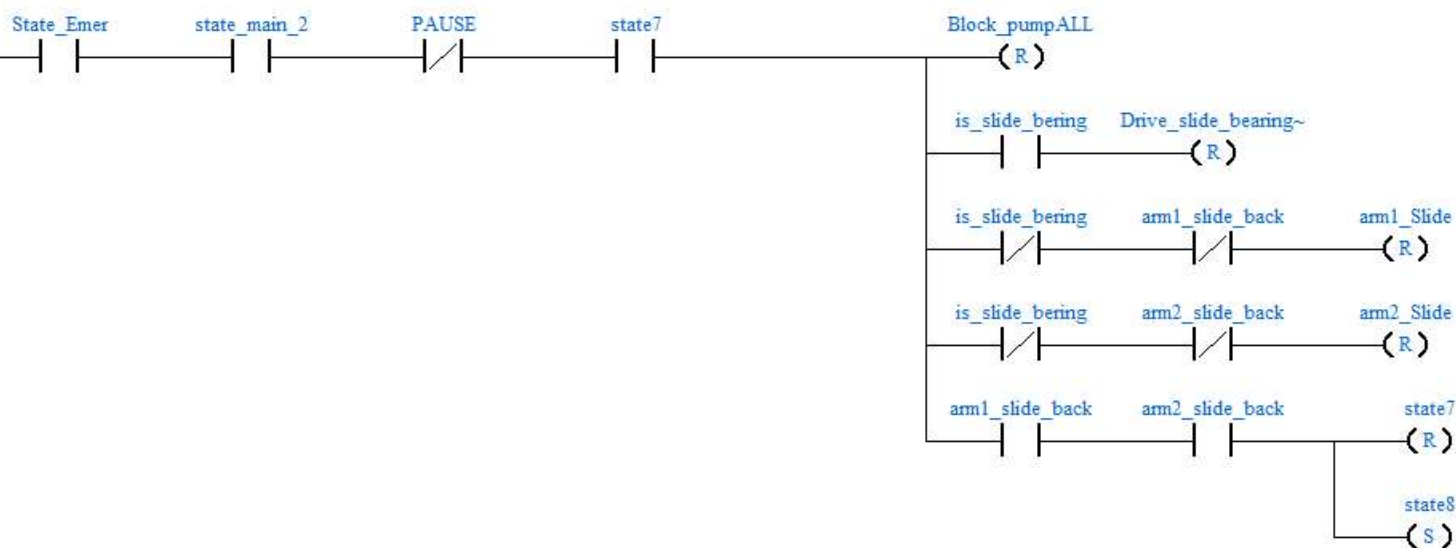
Network 28



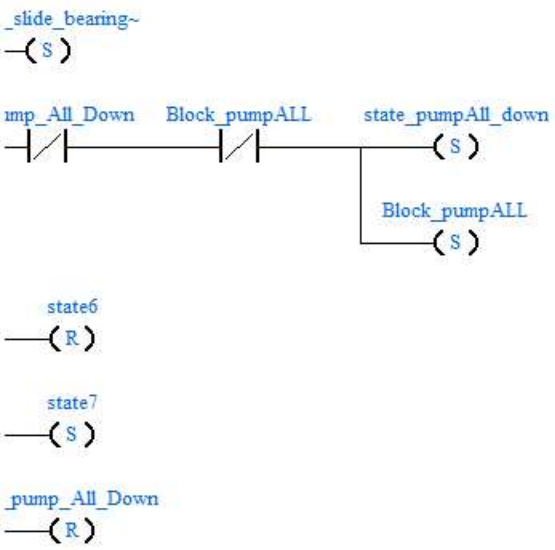
Network 29

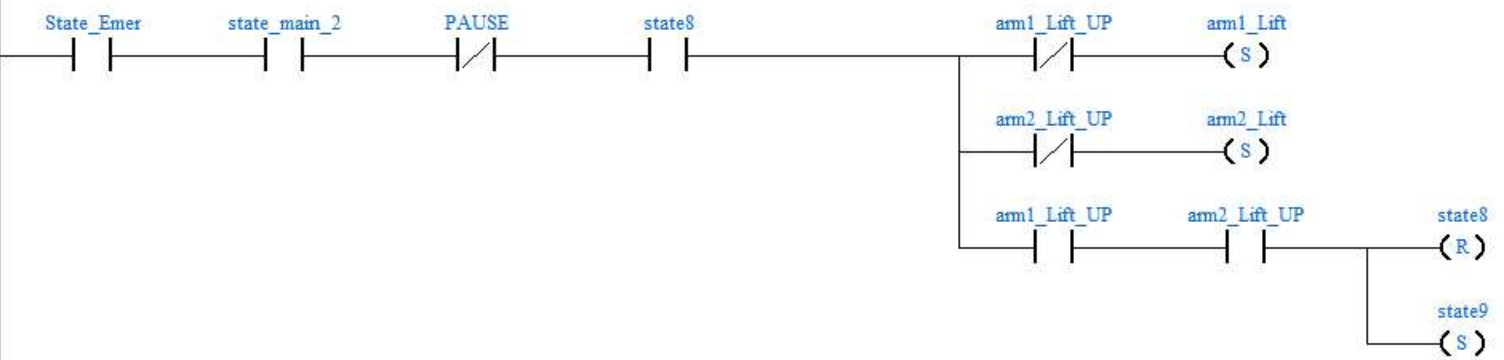


Network 30

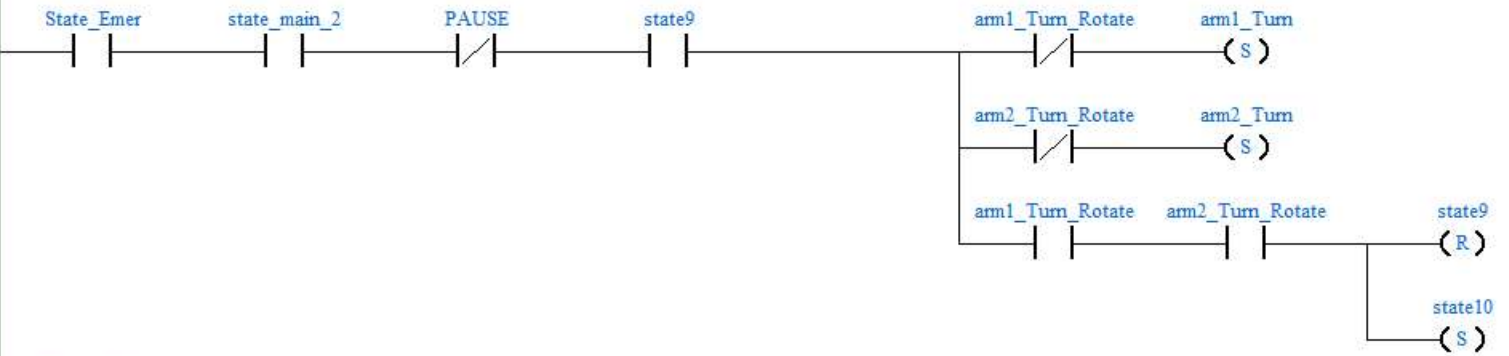


Network 31

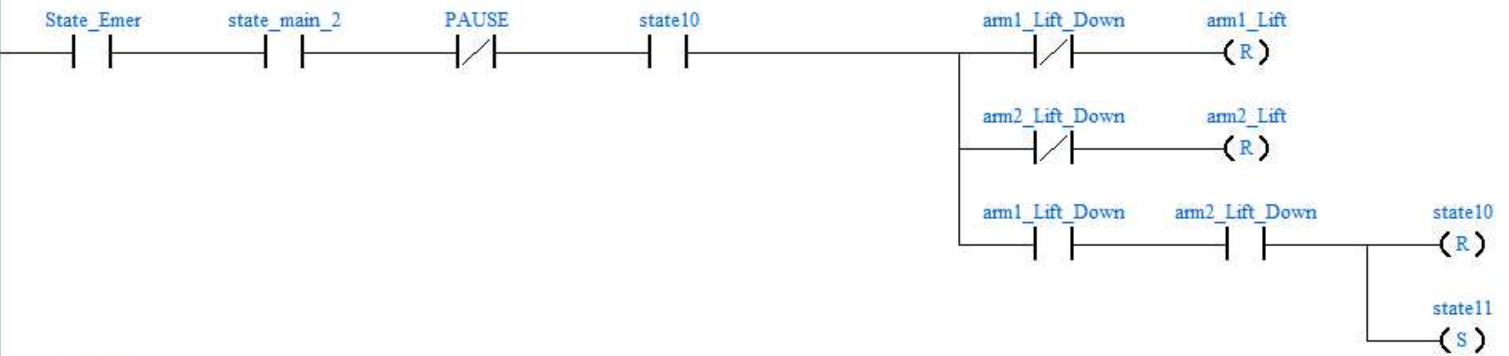




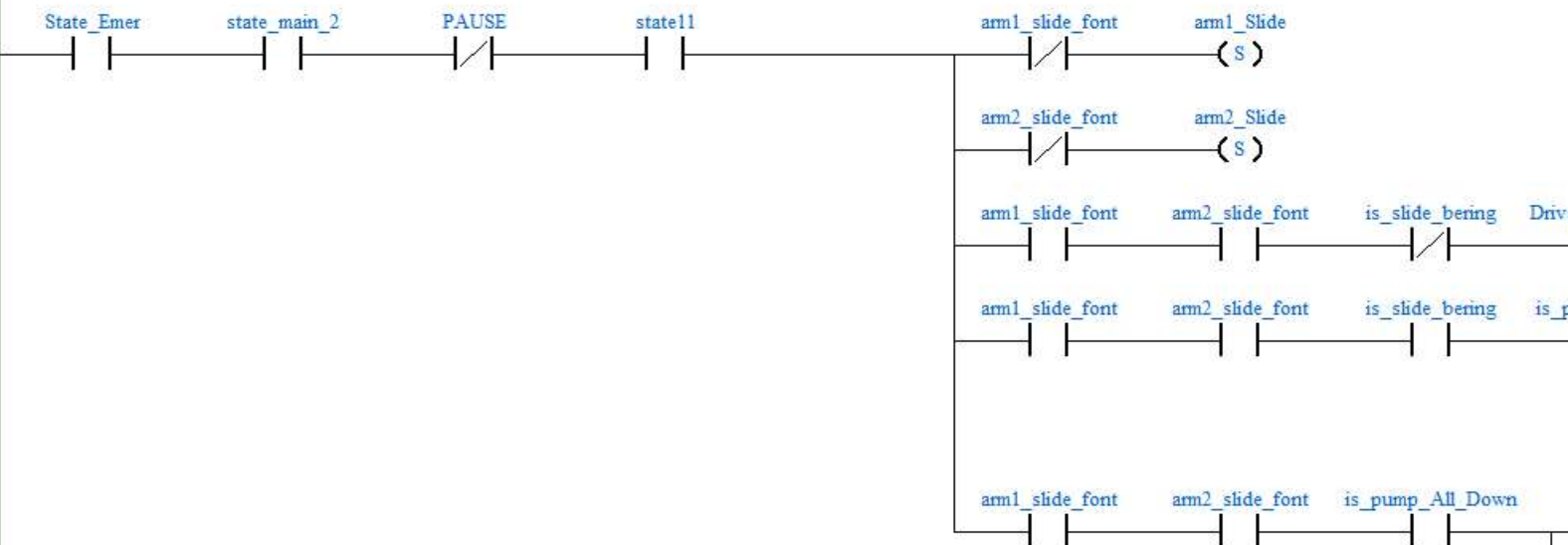
Network 32

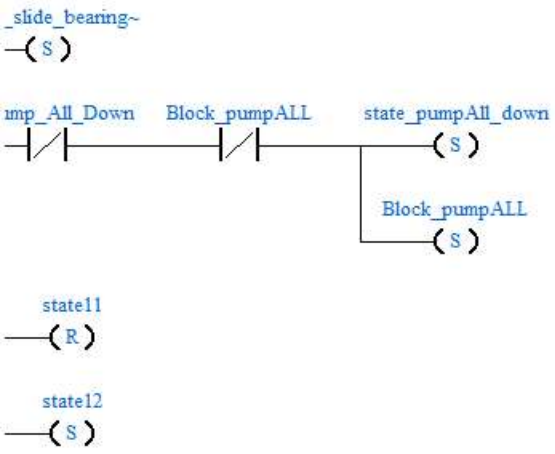


Network 33



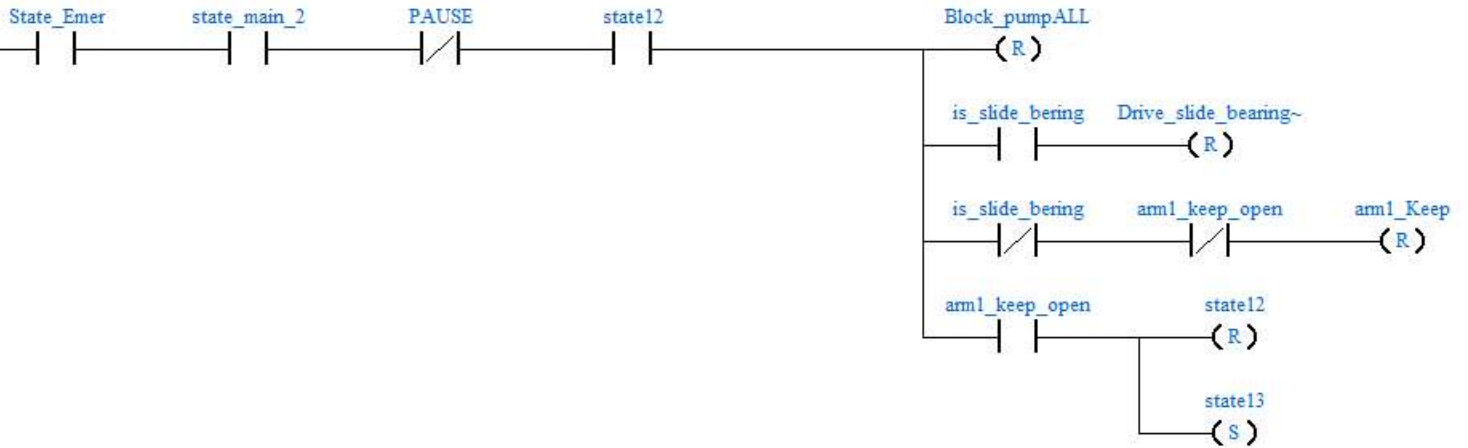
Network 34



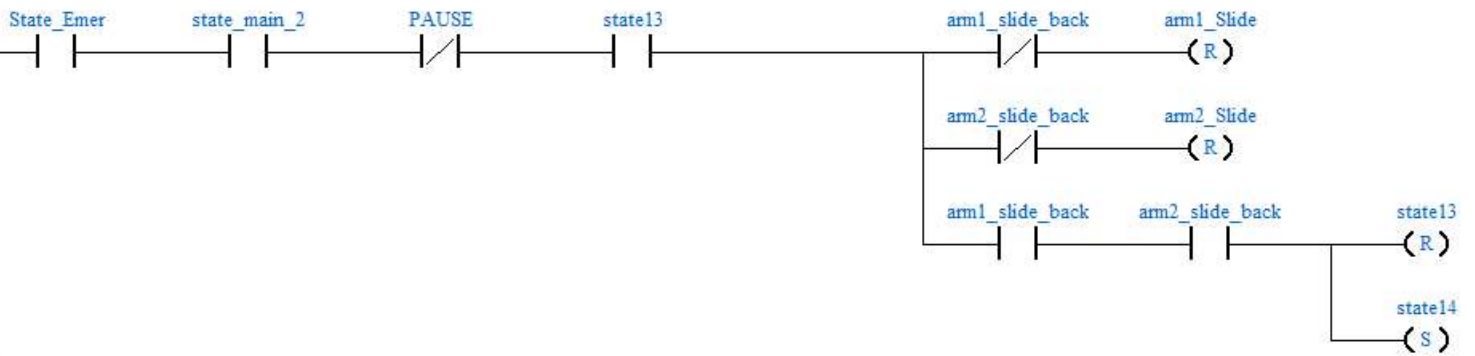


Network 35

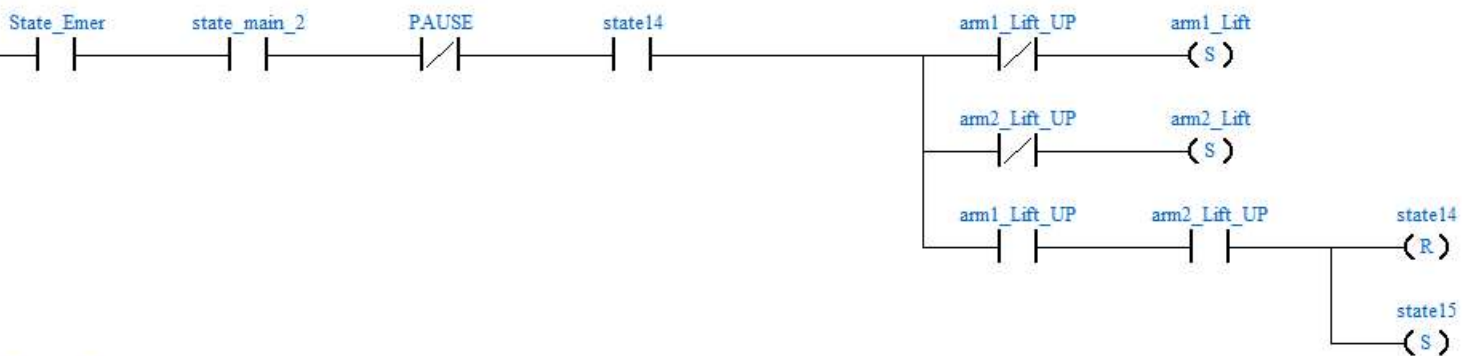
Network 36



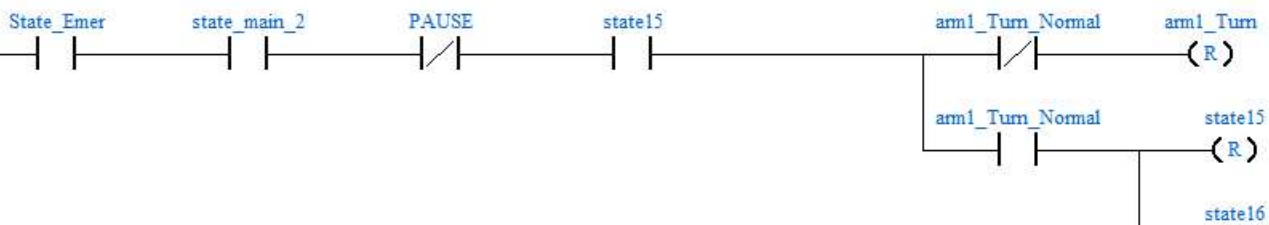
Network 37



Network 38

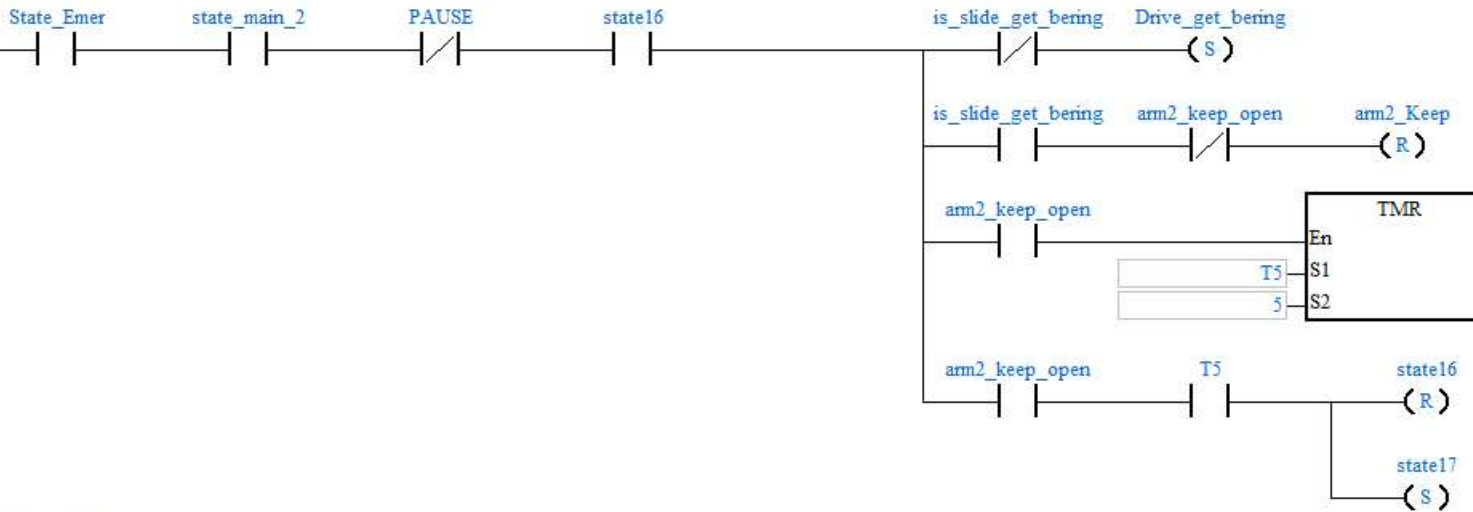


Network 39

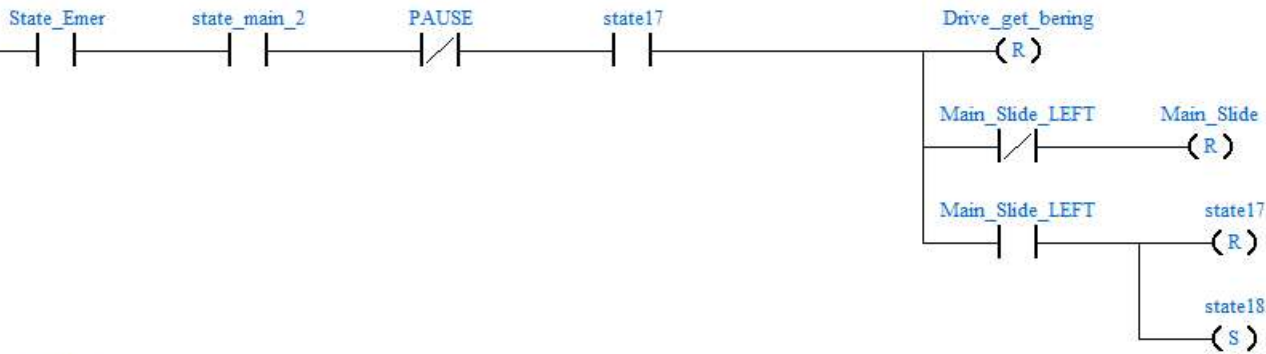


pump_All_Down
—(R)

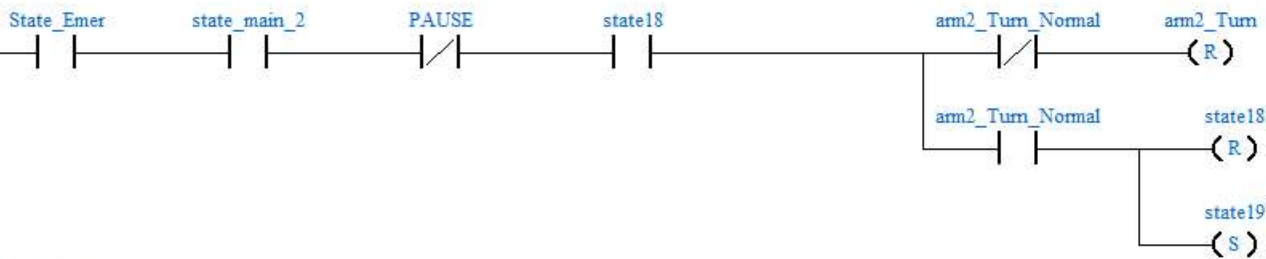
Network 40



Network 41

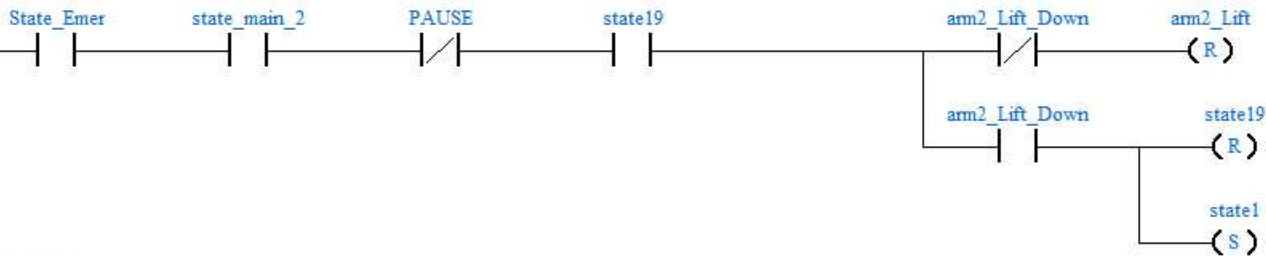


Network 42



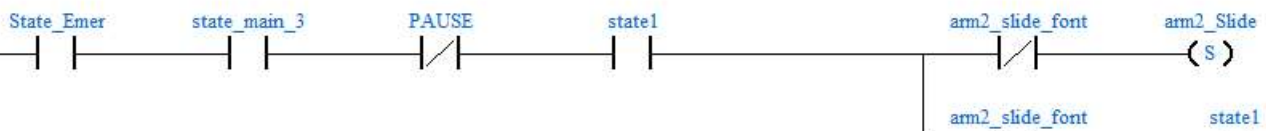
Network 43

STATE CENTER>

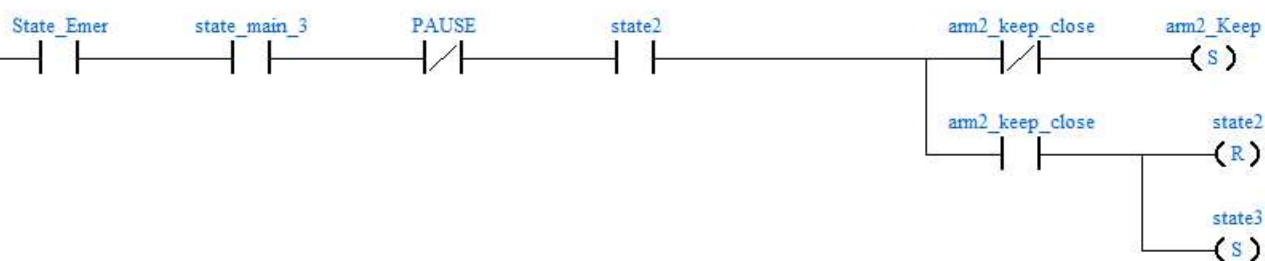


Network 44

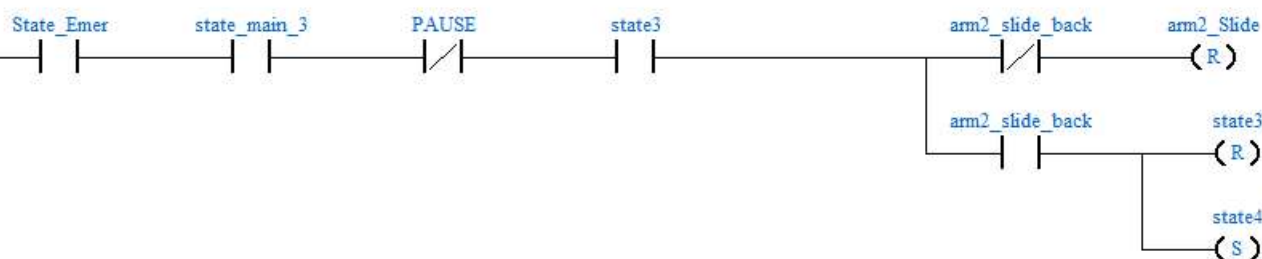
STATE END>



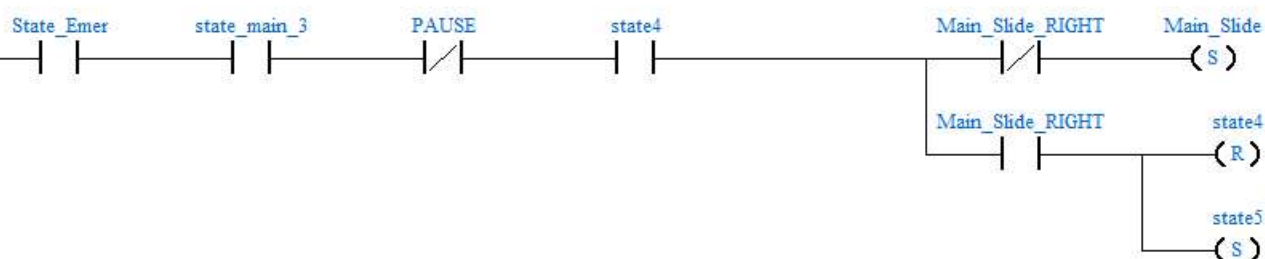
Network 45



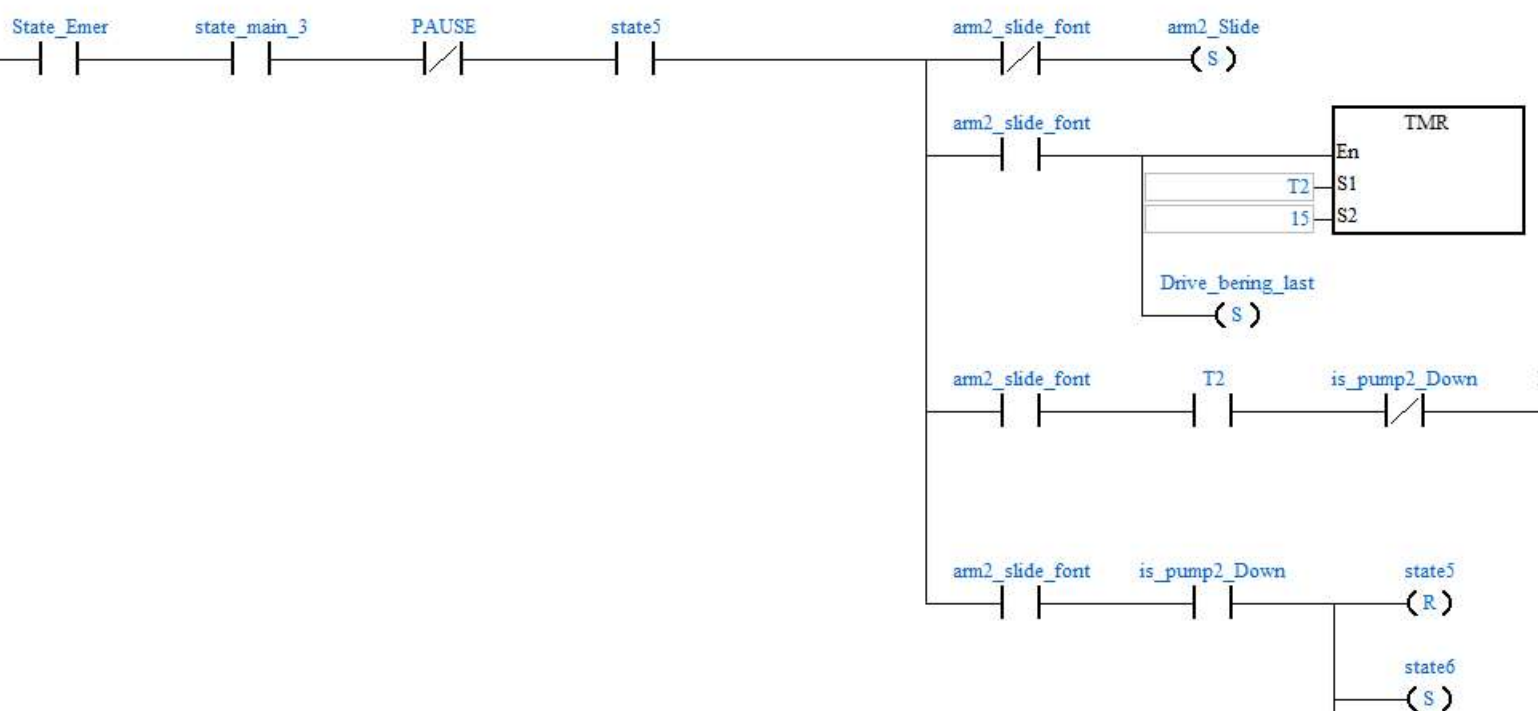
Network 46

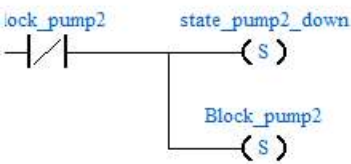


Network 47

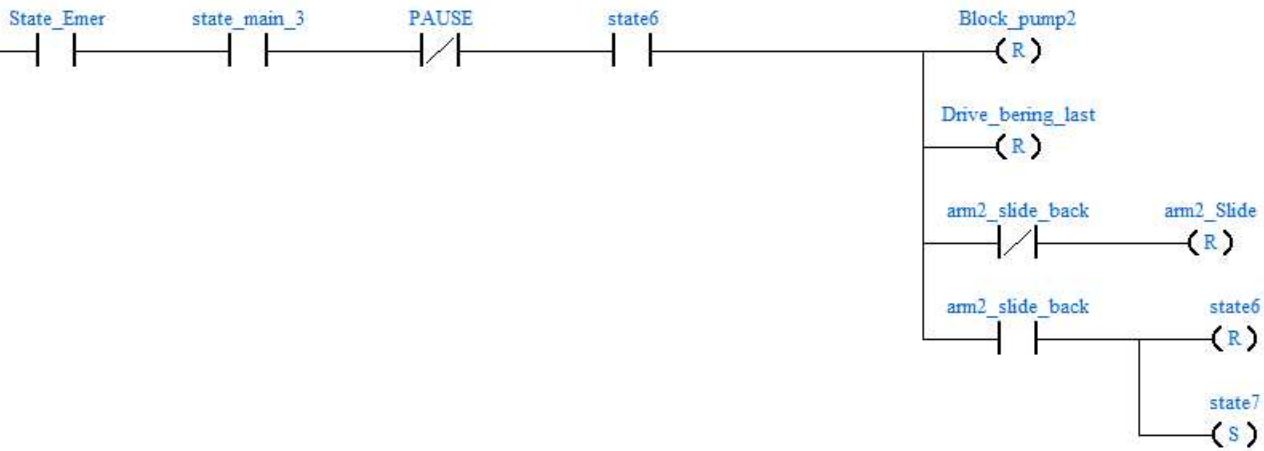


Network 48

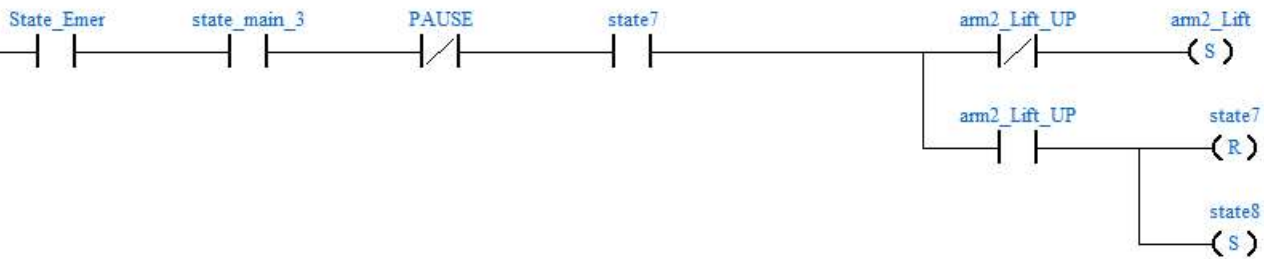




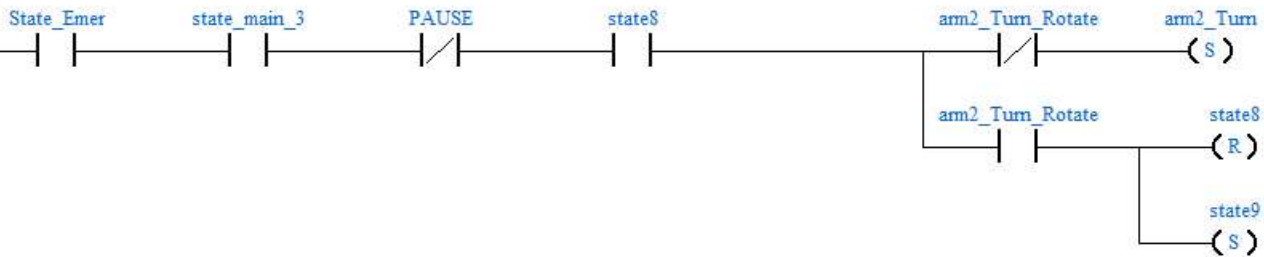
Network 49



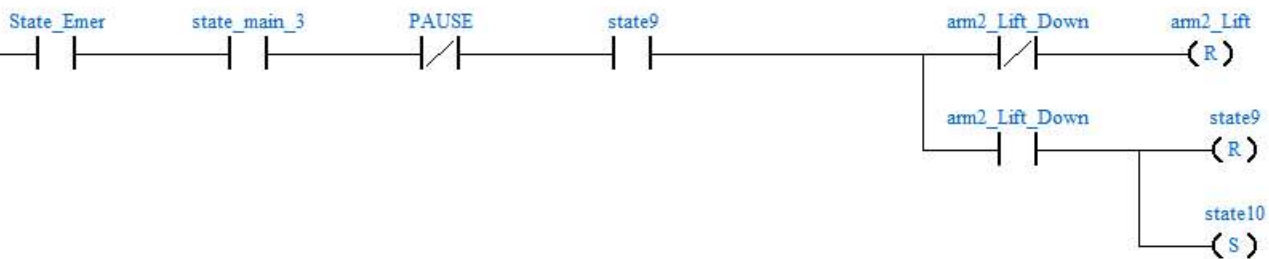
Network 50



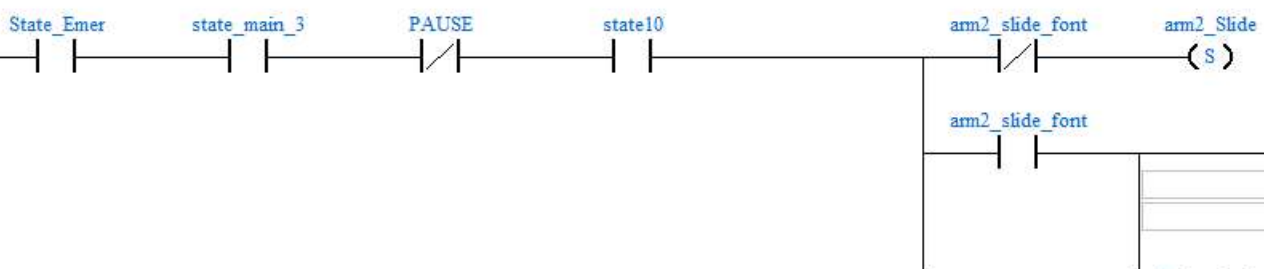
Network 51

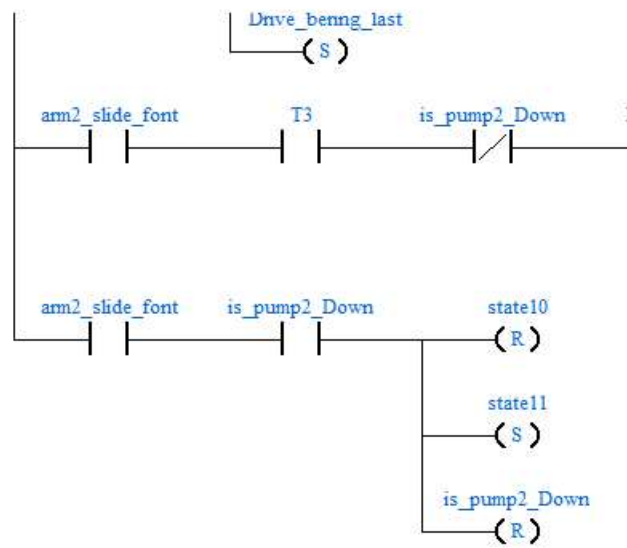


Network 52

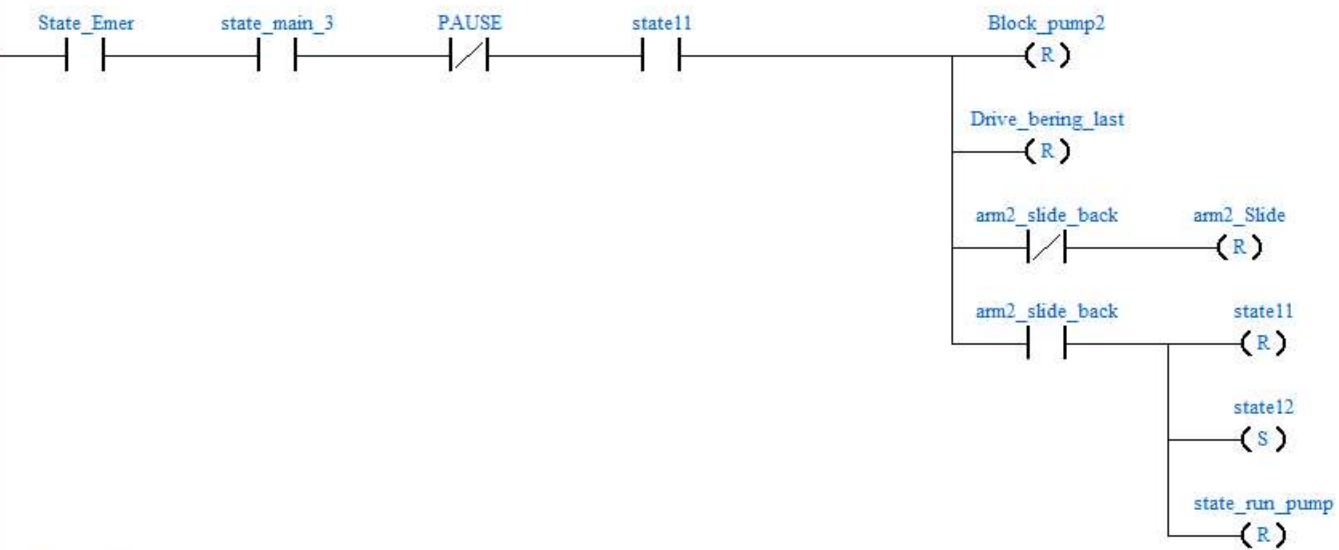


Network 53

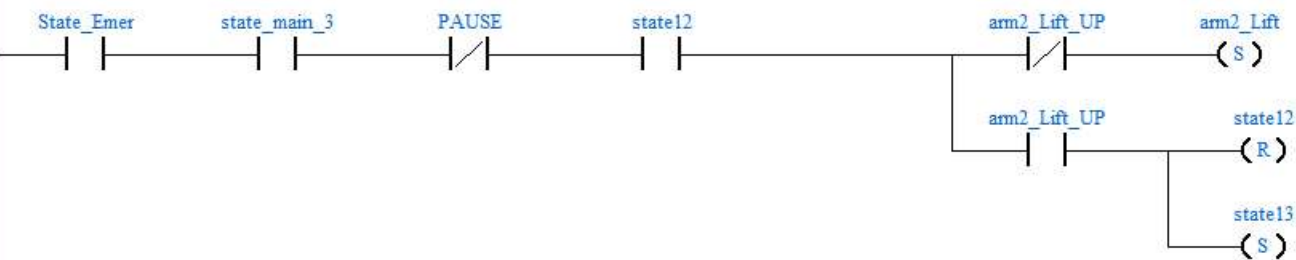




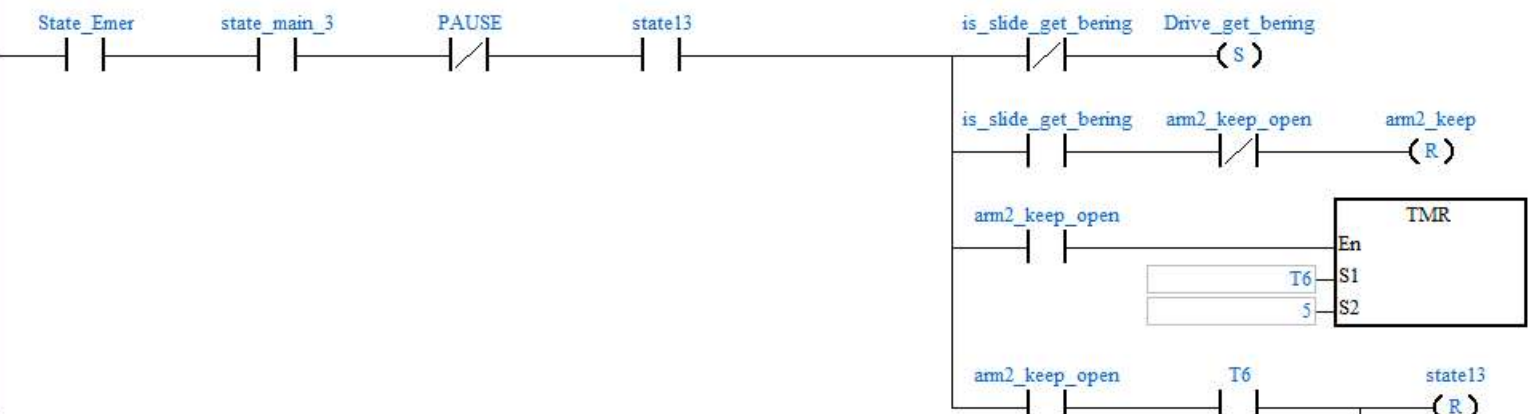
Network 54

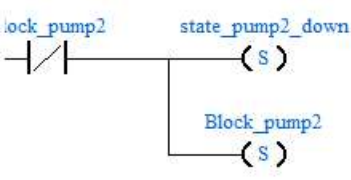


Network 55

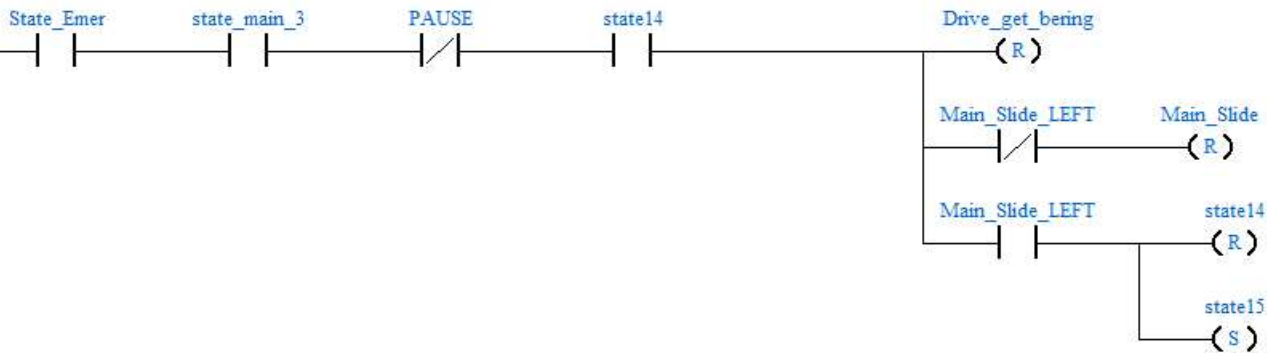


Network 56

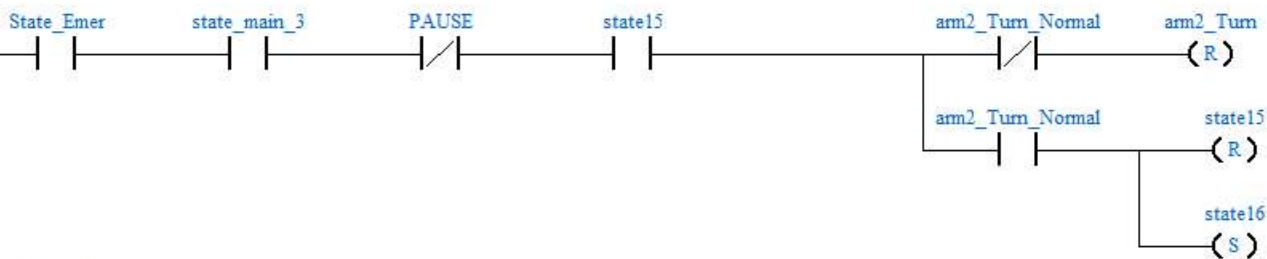




Network 57

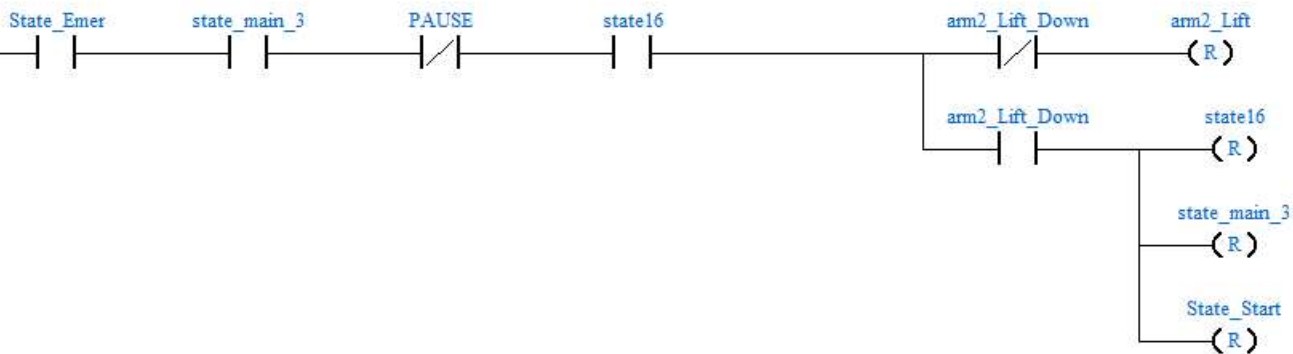


Network 58



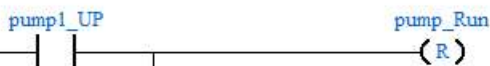
Network 59

STATE ----- END ----->



Network 60

STATE PUMP -----> Dent Oli -----<



Network 61

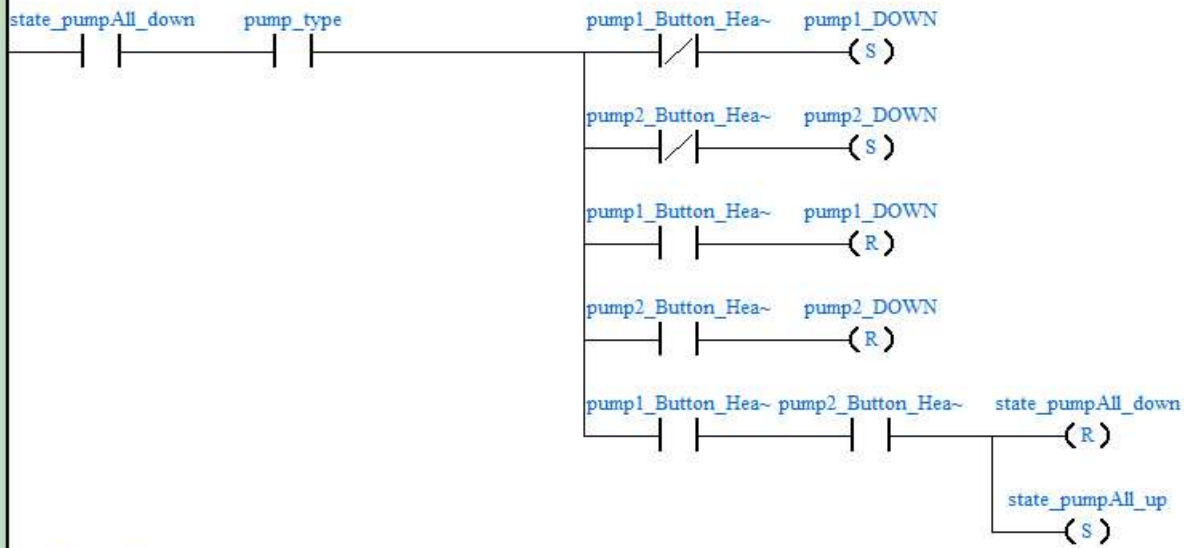
STATE PUMP -----> Dent Oli ----->



Network 62

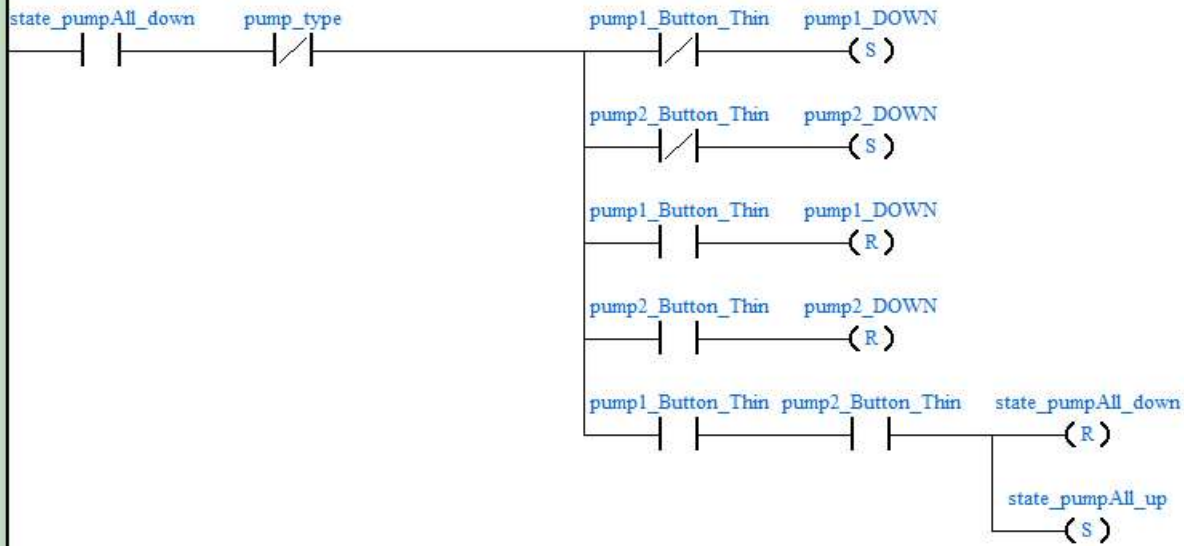
STATE PUMP DOWN -----> ALL PUMP

STATE PUMP DOWN ALL PUMP ----->



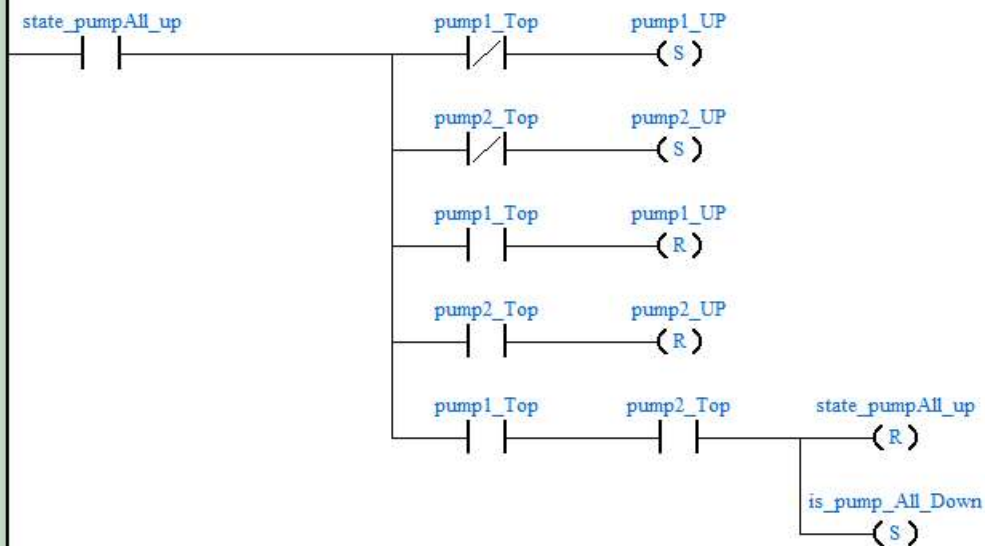
Network 63

STATE PUMP DOWN ALL PUMP -----<



Network 64

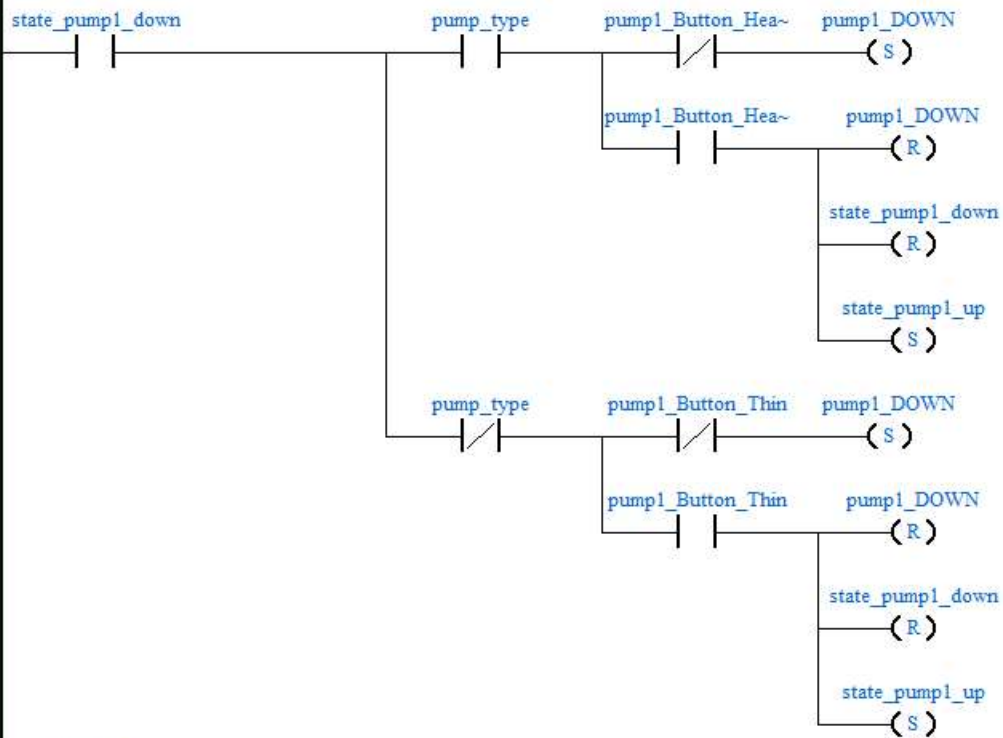
STATE PUMP UP 2 PUMP -----> backup



Network 65

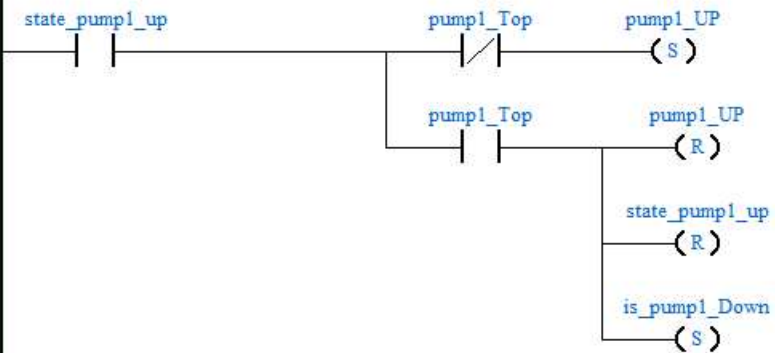
Network 66

STATE PUMP 1 DOWN PUMP ----- <



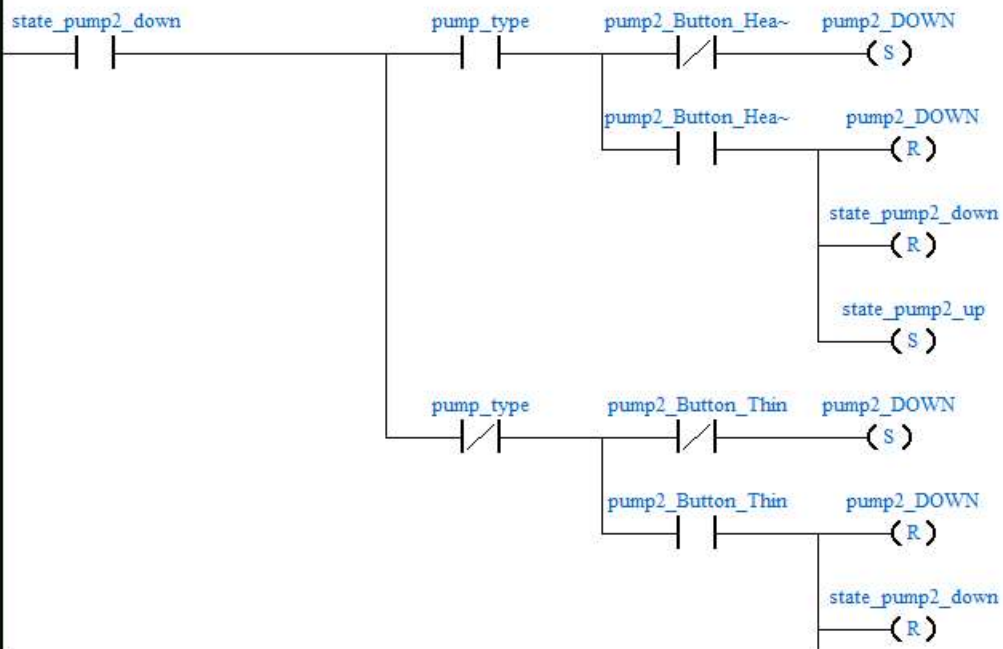
Network 67

STATE PUMP 1 UP PUMP ----- <



Network 68

STATE PUMP 2 DOWN PUMP ----- <

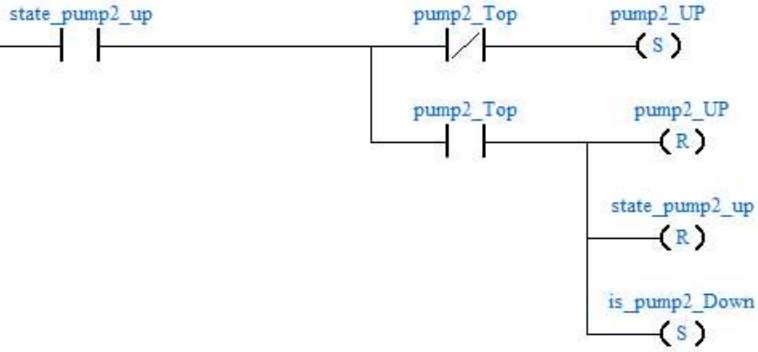


state_pump2_up
(S)

Network 69

Network 70

STATE PUMP 2 UP PUMP -----<



Network 71

STATE RUN PUMP -----<



Network 72

STATE RUN PUMP ----->



Network 73

EMER STATE

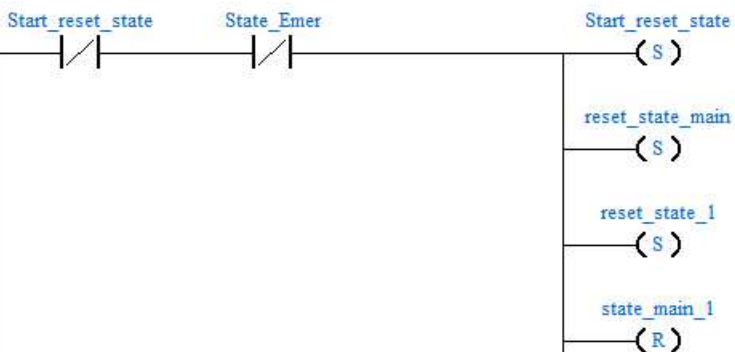


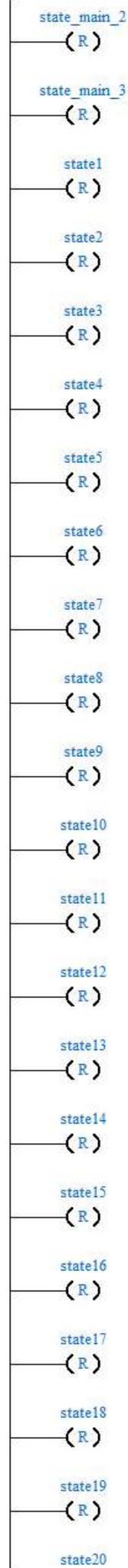
Network 74

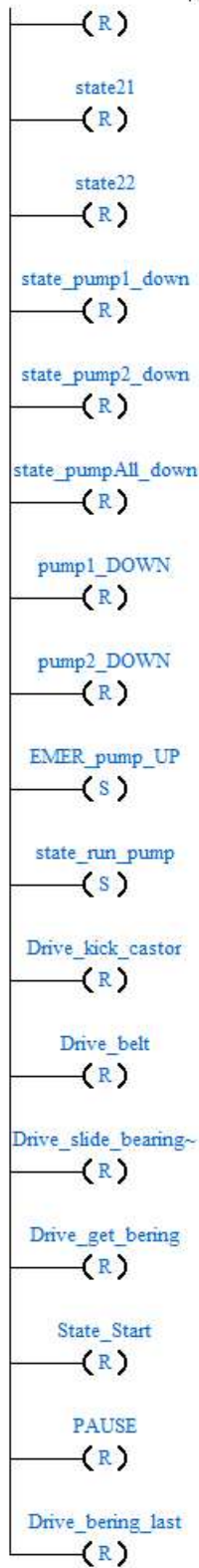
EMER STATE



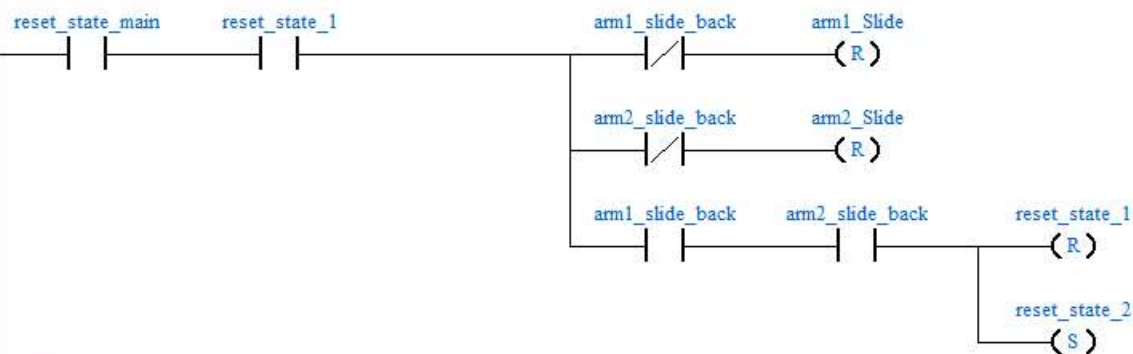
Network 75



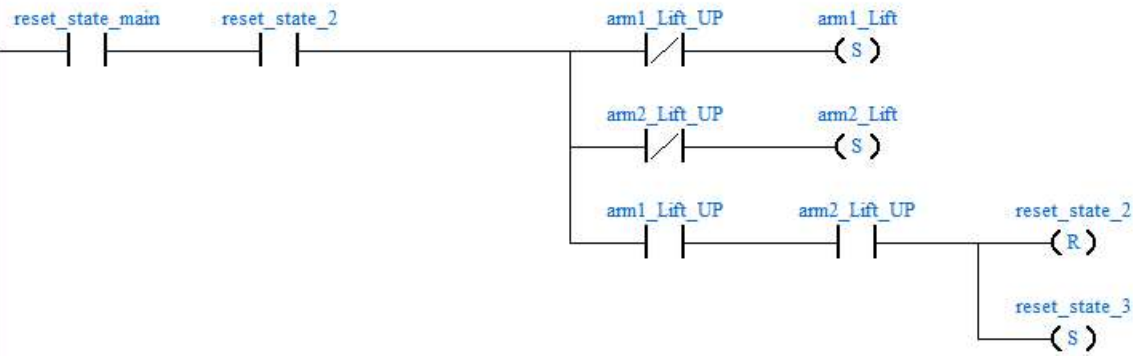




Network 76

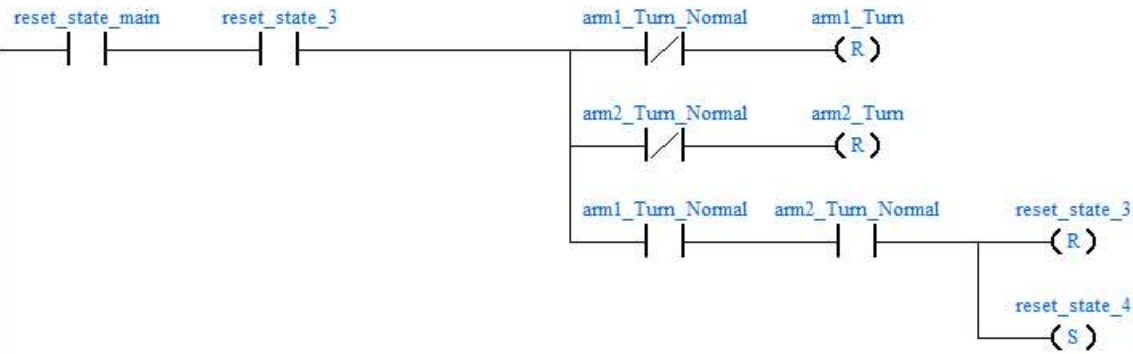


Network 77



Network 78

Stop State -----<



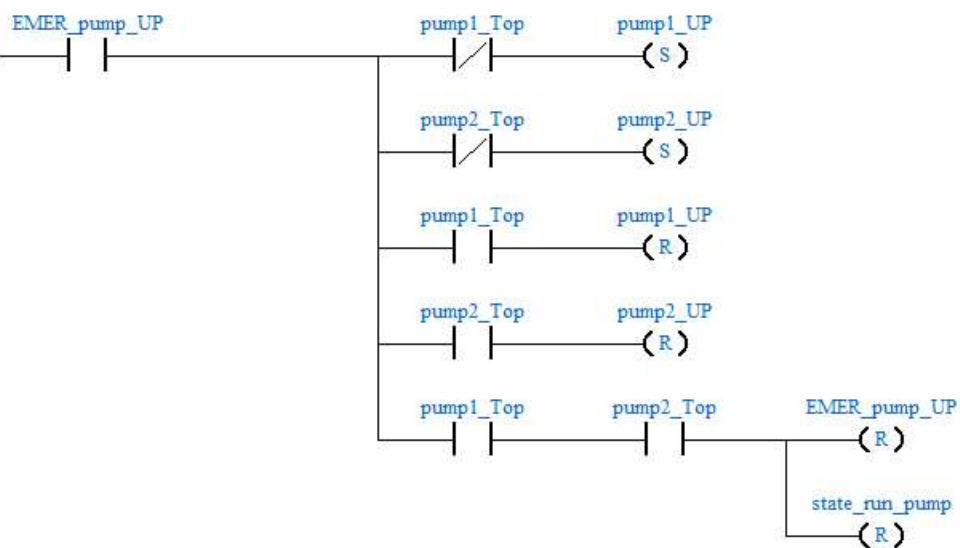
Network 79

Stop State -----<



Network 80

STATE PUMP UP



Network 81

STATE Control Beh -----<



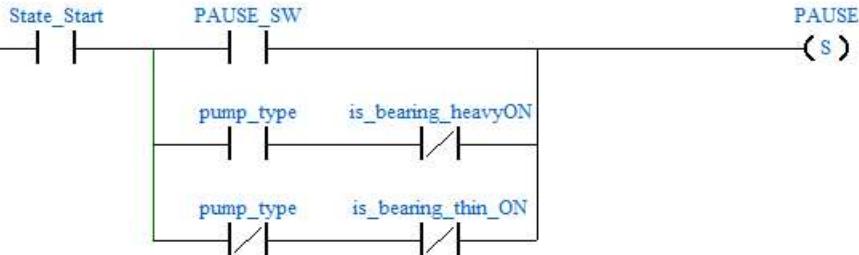
Network 82



Network 83

STATE Control Belt ----->

Network 84

PAUSE SW

Network 85

