CC-Link Setting

[CC-Link Setting]

Connection Block Not Set

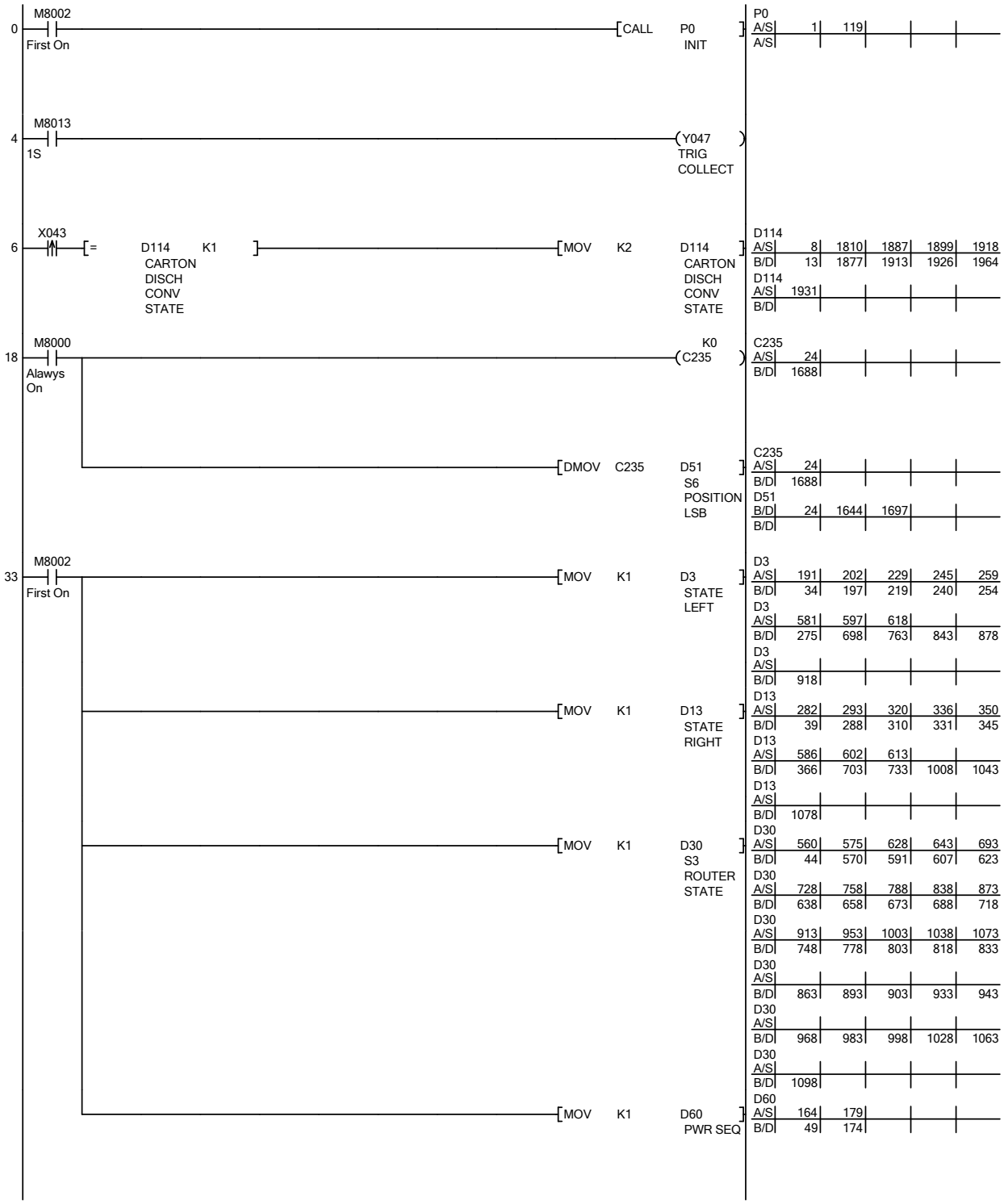
Network Parameter 11/21/2025
Data Name : CC-Link
CC-Link Setting

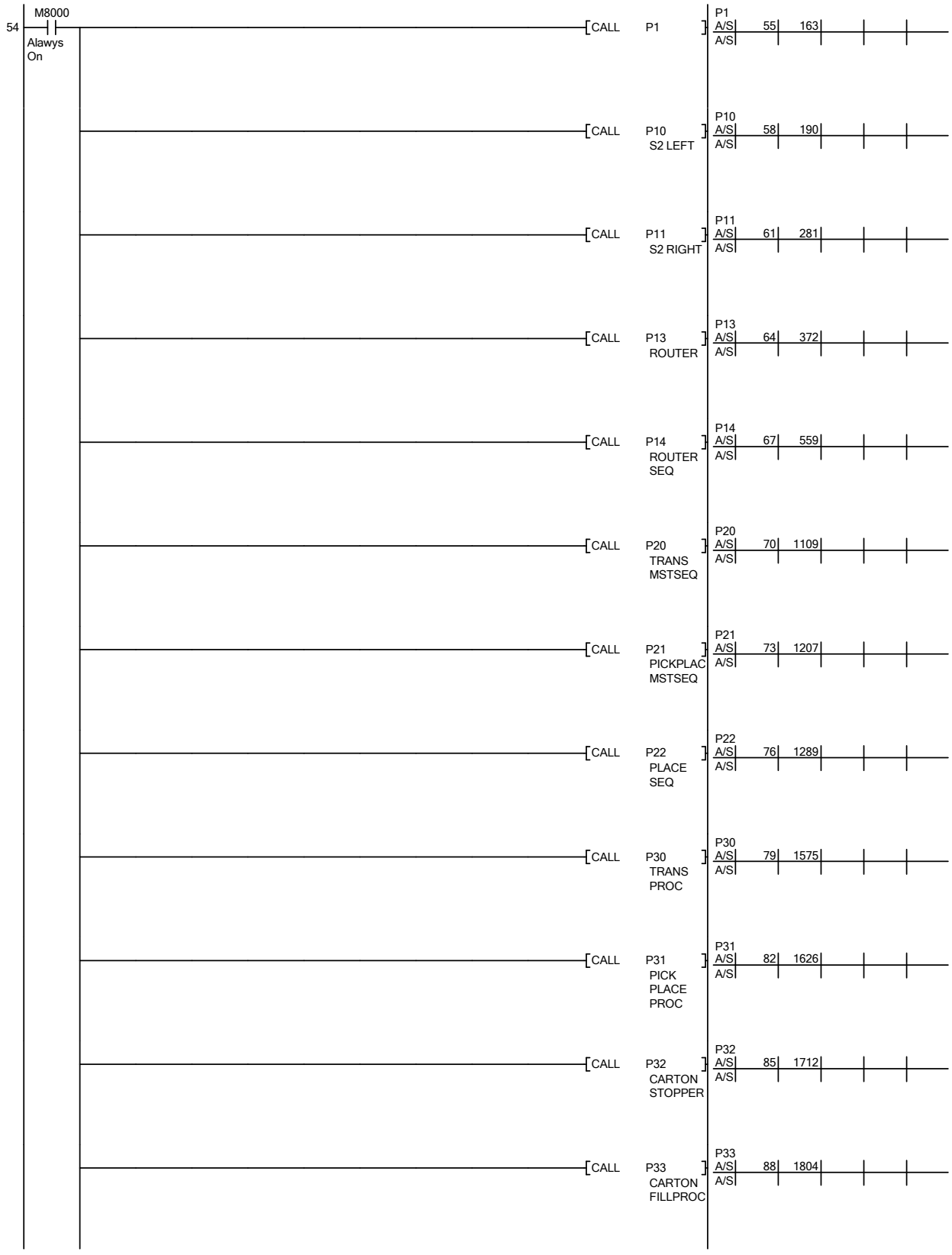
[CC-Link Setting]

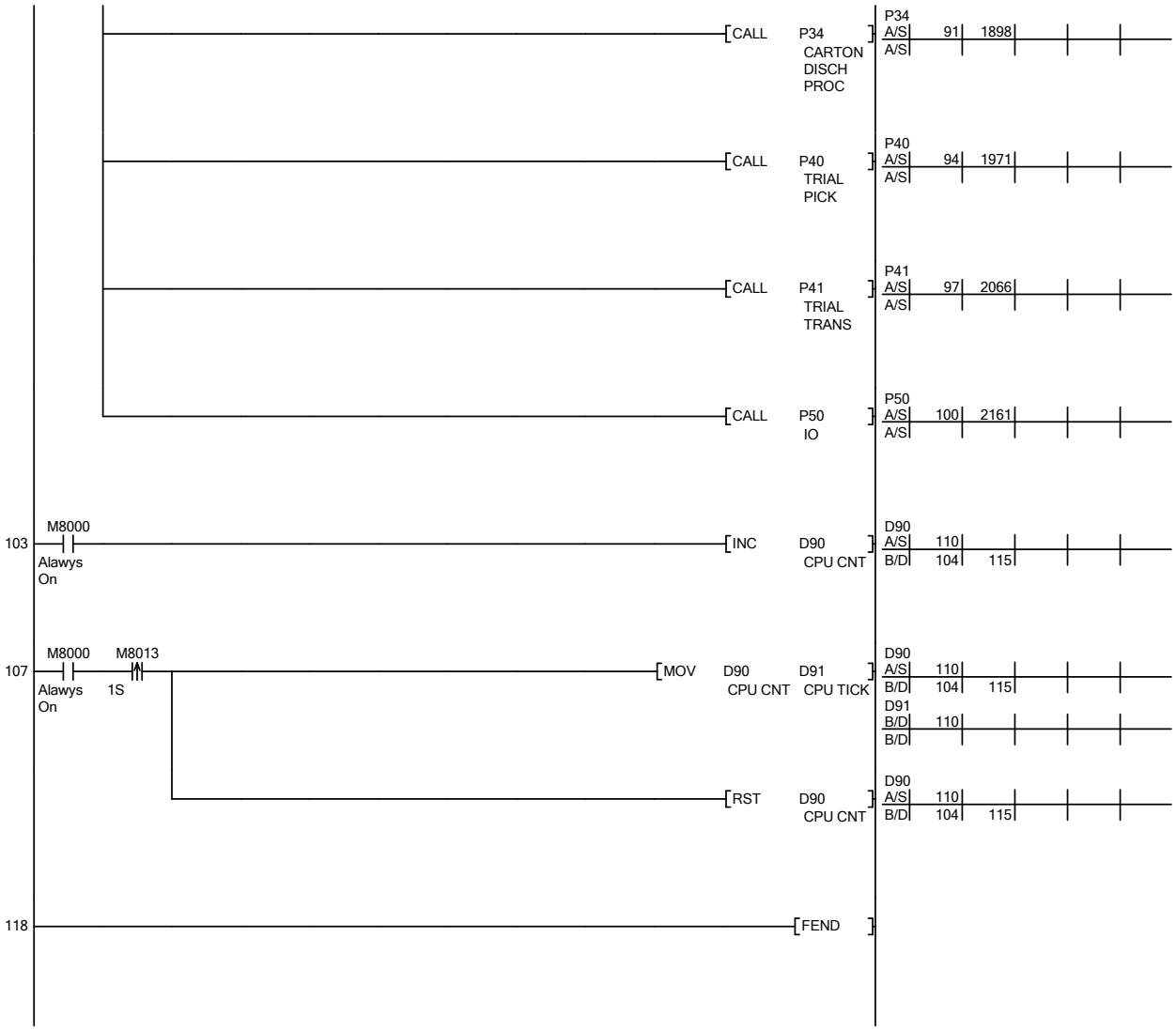
	Setting Contents
Special Function Block No.	-
Type	-
Master Station Data Link Type	Start Parameter by BFM
Mode	-
Total Module Connected	-
Remote input(RX)	-
Remote output(RY)	-
Remote register(RWr)	-
Remote register(RWw)	-
Ver.2 Remote input(RX)	-
Ver.2 Remote output(RY)	-
Ver.2 Remote register(RWr)	-
Ver.2 Remote register(RWw)	-
Special relay(SB)	-
Special register(SW)	-
Retry Count	-
Automatic Reconnection Station Count	-
Standby Master Station No.	-
PLC Down Select	-
Scan Mode Setting	-
Delay Time Setting	-
Remote Device Station Initial Setting	-
Interrupt Settings	-

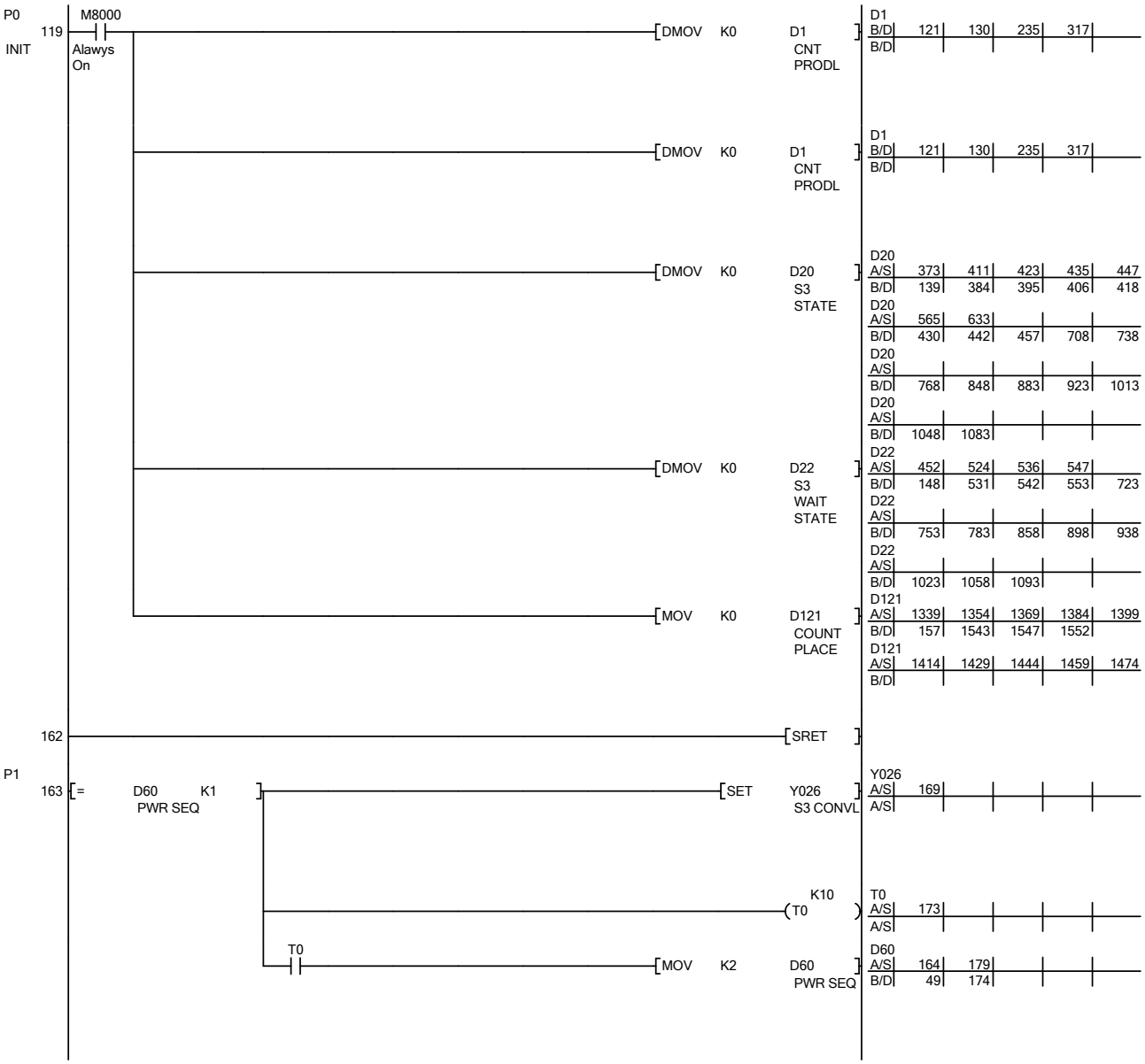
Data Name : Program setting

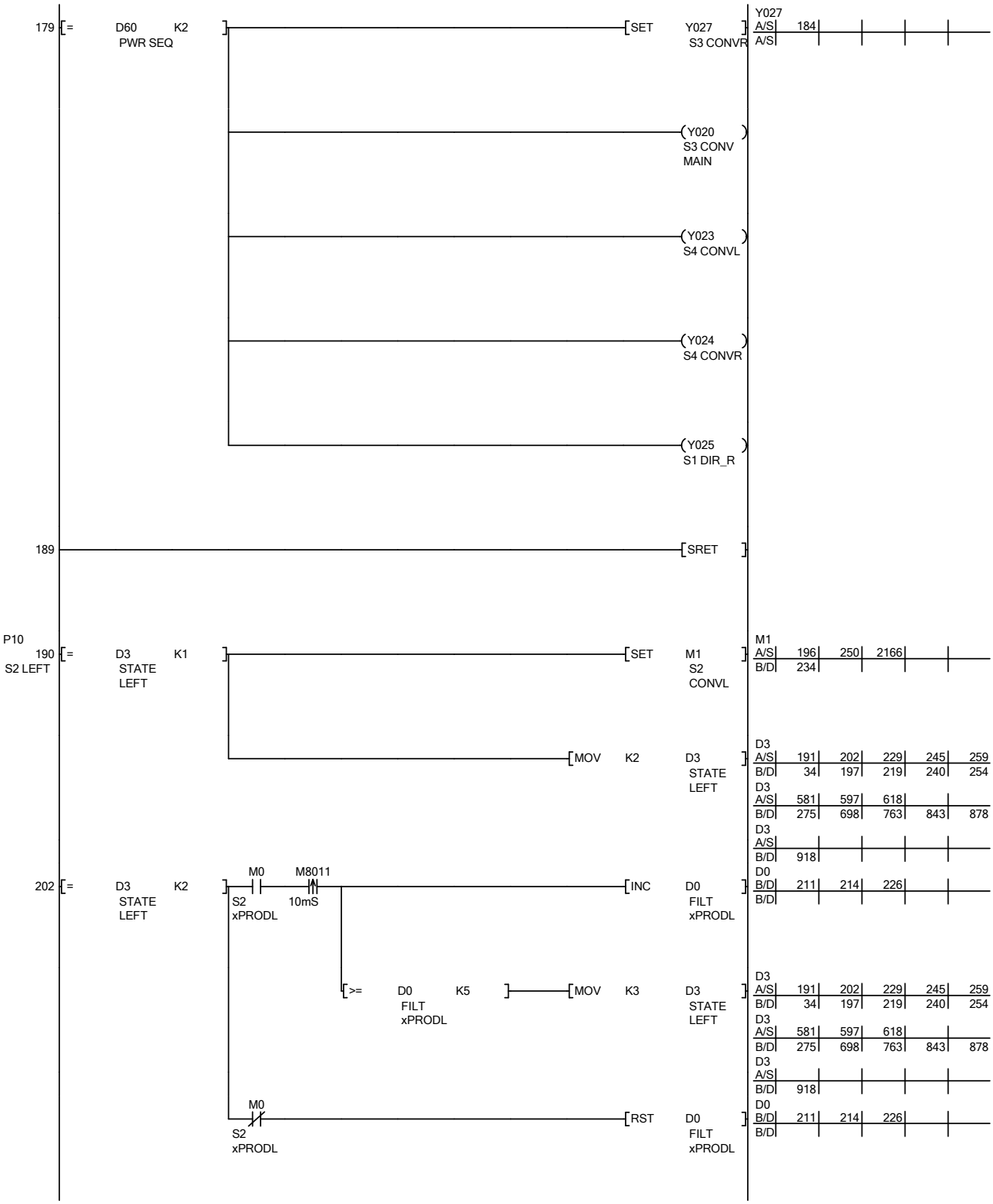
Execution type	Program file name [Title]
Execution Program	MAIN

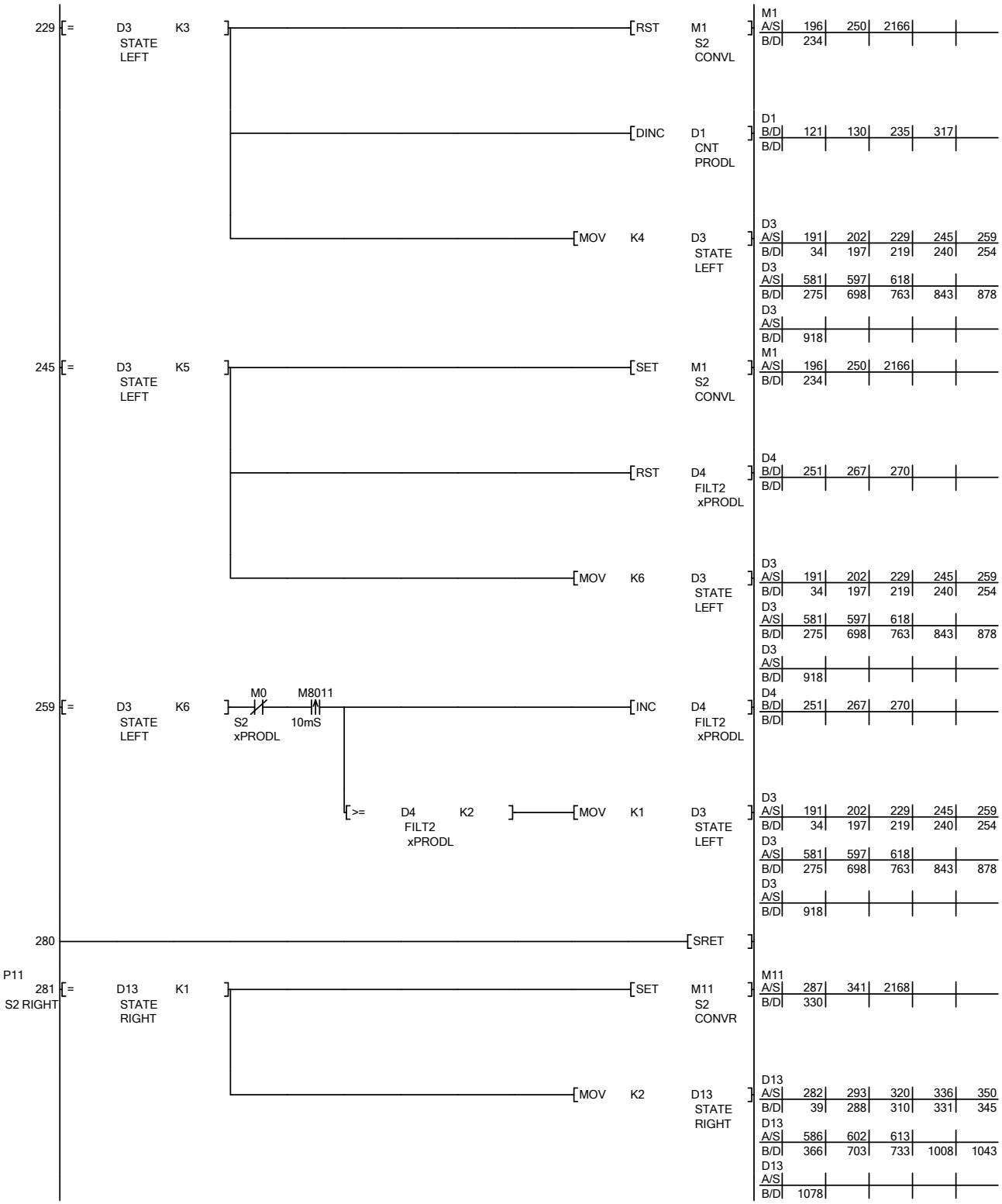

0
M8002
First On
CALL P0
P0
INIT
4
M8013
1S
Y047
TRIG
COLLECT
6
X043
= D114 K1
CARTON
DISCH
CONV
STATE
MOV K2 D114
CARTON
DISCH
CONV
STATE
18
M8000
Alawys
On
K0
C235
DMOV C235 D51
S6
POSITION
LSB
33
M8002
First On
MOV K1 D3
STATE
LEFT
MOV K1 D13
STATE
RIGHT
MOV K1 D30
S3
ROUTER
STATE
MOV K1 D60
PWR SEQ

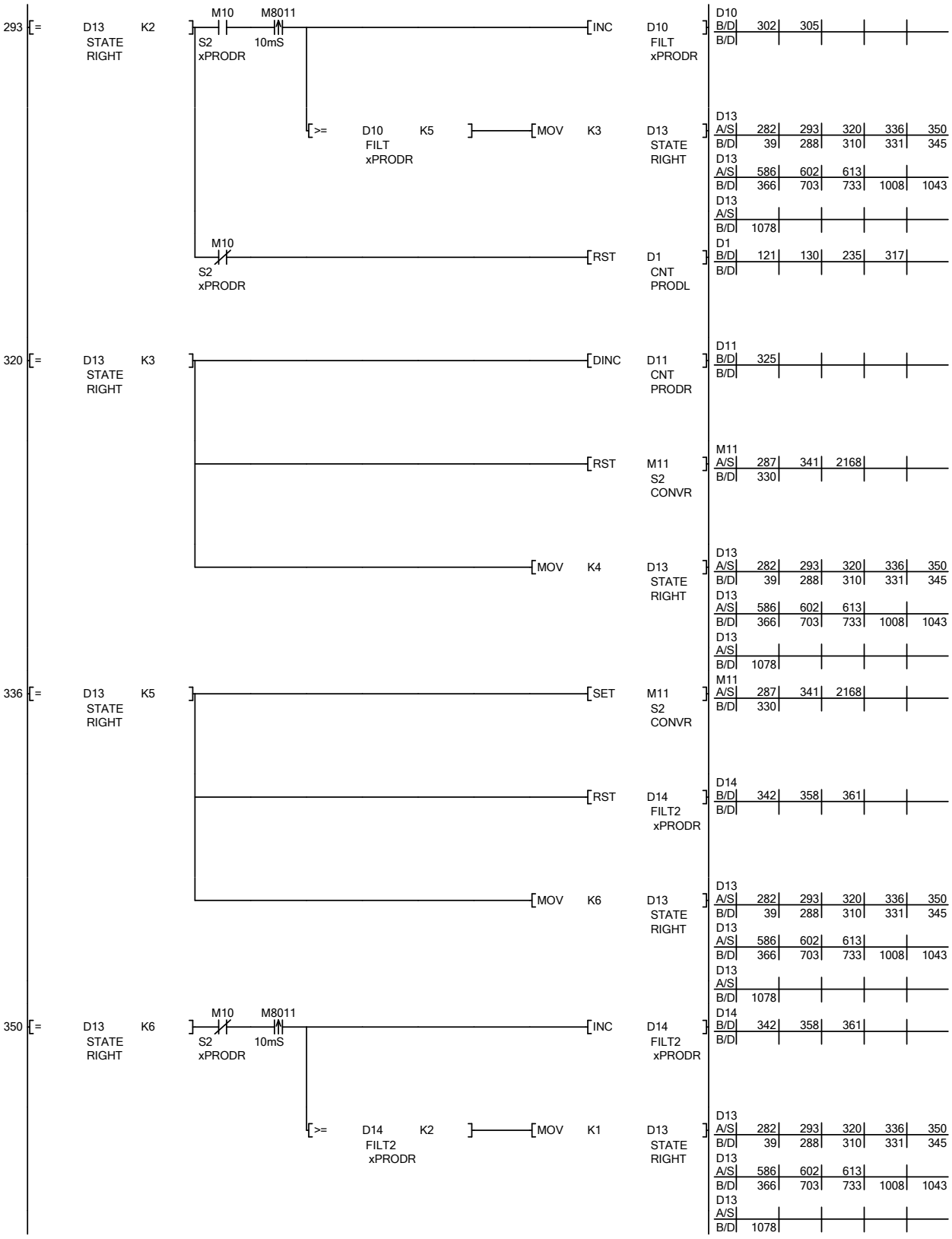

54
M8000
Alawys
On
CALL P1
P1
A/S 55 163
A/S
CALL P10
S2 LEFT
P10
A/S 58 190
A/S
CALL P11
S2 RIGHT
P11
A/S 61 281
A/S
CALL P13
ROUTER
P13
A/S 64 372
A/S
CALL P14
ROUTER
SEQ
P14
A/S 67 559
A/S
CALL P20
TRANS
MSTSEQ
P20
A/S 70 1109
A/S
CALL P21
PICKPLAC
MSTSEQ
P21
A/S 73 1207
A/S
CALL P22
PLACE
SEQ
P22
A/S 76 1289
A/S
CALL P30
TRANS
PROC
P30
A/S 79 1575
A/S
CALL P31
PICK
PLACE
PROC
P31
A/S 82 1626
A/S
CALL P32
CARTON
STOPPER
P32
A/S 85 1712
A/S
CALL P33
CARTON
FILLPROC
P33
A/S 88 1804
A/S

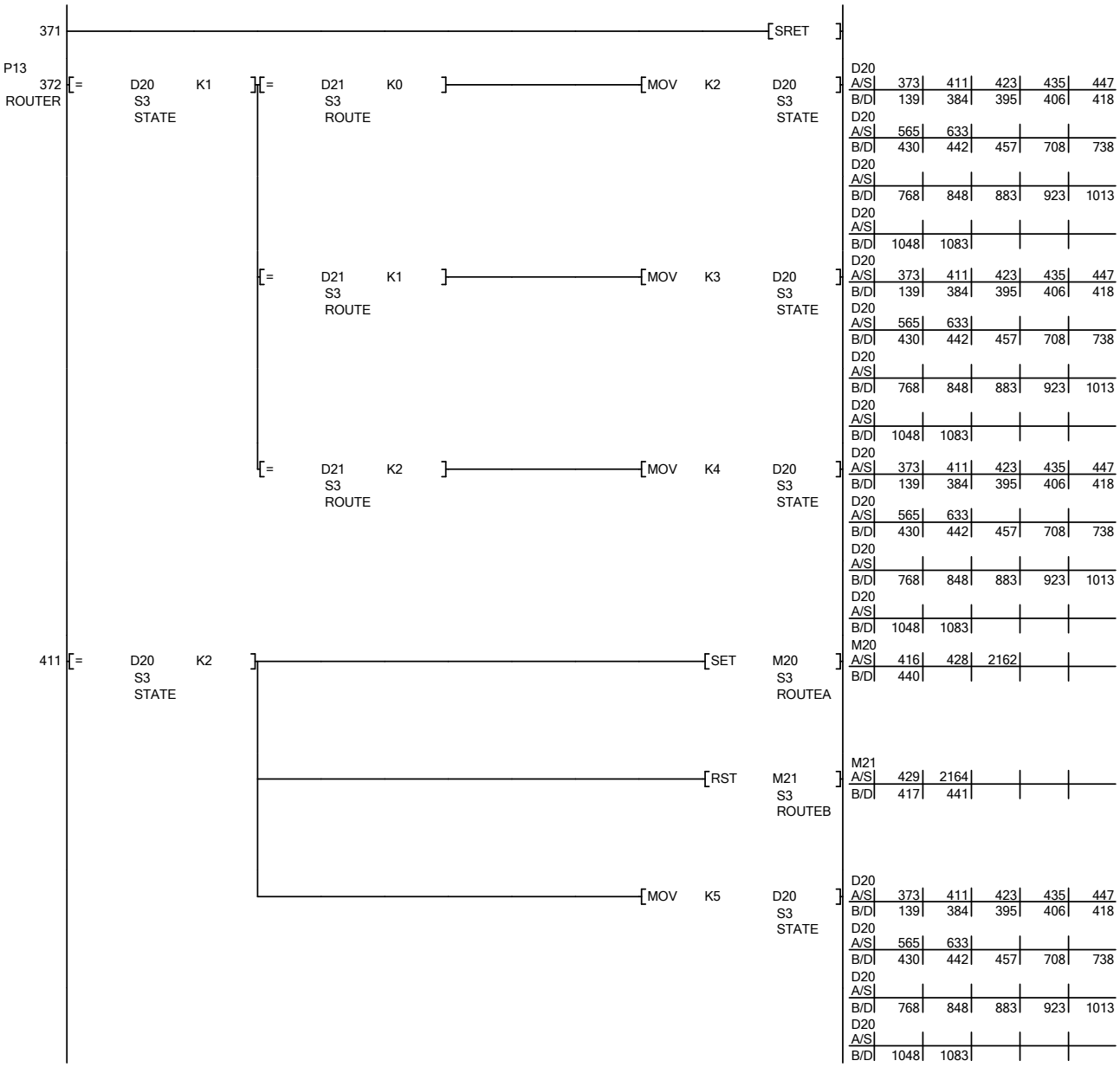

CALL P34 CARTON DISCH PROC
P34 A/S 91 1898 A/S
CALL P40 TRIAL PICK
P40 A/S 94 1971 A/S
CALL P41 TRIAL TRANS
P41 A/S 97 2066 A/S
CALL P50 IO
P50 A/S 100 2161 A/S
103 M8000 Alawys On
INC D90 CPU CNT
D90 A/S 110 B/D 104 115
107 M8000 Alawys On M8013 1S
MOV D90 CPU CNT D91 CPU TICK
D90 A/S 110 B/D 104 115
D91 B/D 110 B/D
RST D90 CPU CNT
D90 A/S 110 B/D 104 115
118 FEND

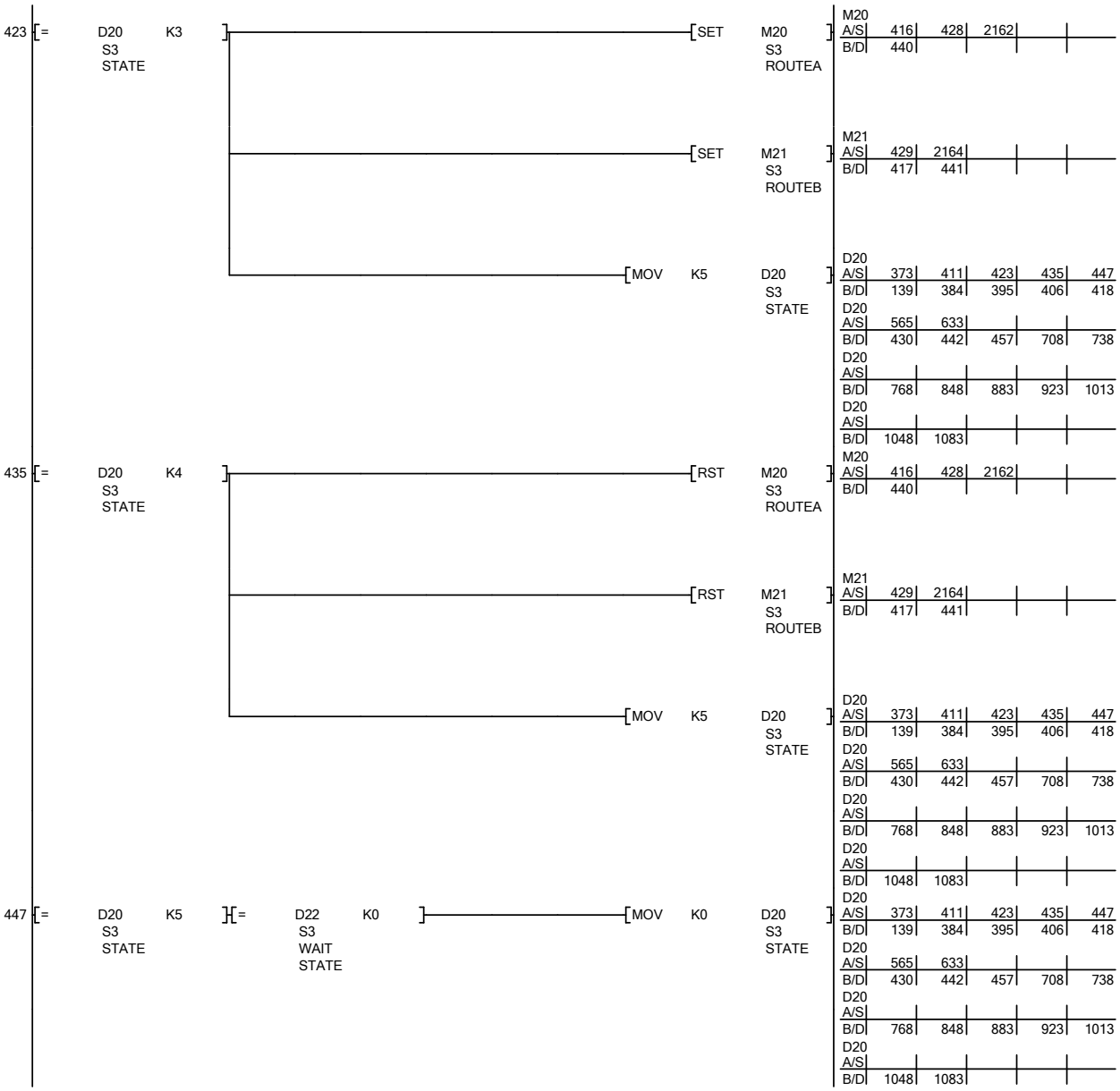

P0
119
M8000
Alawys On
INIT
DMOV K0 D1 CNT PRODL
D1 B/D 121 130 235 317 B/D
DMOV K0 D1 CNT PRODL
D1 B/D 121 130 235 317 B/D
DMOV K0 D20 S3 STATE
D20 A/S 373 411 423 435 447 B/D 139 384 395 406 418
D20 A/S 565 633 B/D 430 442 457 708 738
D20 A/S B/D 768 848 883 923 1013
D20 A/S B/D 1048 1083
DMOV K0 D22 S3 WAIT STATE
D22 A/S 452 524 536 547 B/D 148 531 542 553 723
D22 A/S B/D 753 783 858 898 938
D22 A/S B/D 1023 1058 1093
MOV K0 D121 COUNT PLACE
D121 A/S 1339 1354 1369 1384 1399 B/D 157 1543 1547 1552
D121 A/S 1414 1429 1444 1459 1474 B/D
162
SRET
P1
163
= D60 K1 PWR SEQ
SET Y026 S3 CONVL
Y026 A/S 169 A/S
K10 T0
T0 A/S 173 A/S
T0
MOV K2 D60 PWR SEQ
D60 A/S 164 179 B/D 49 174

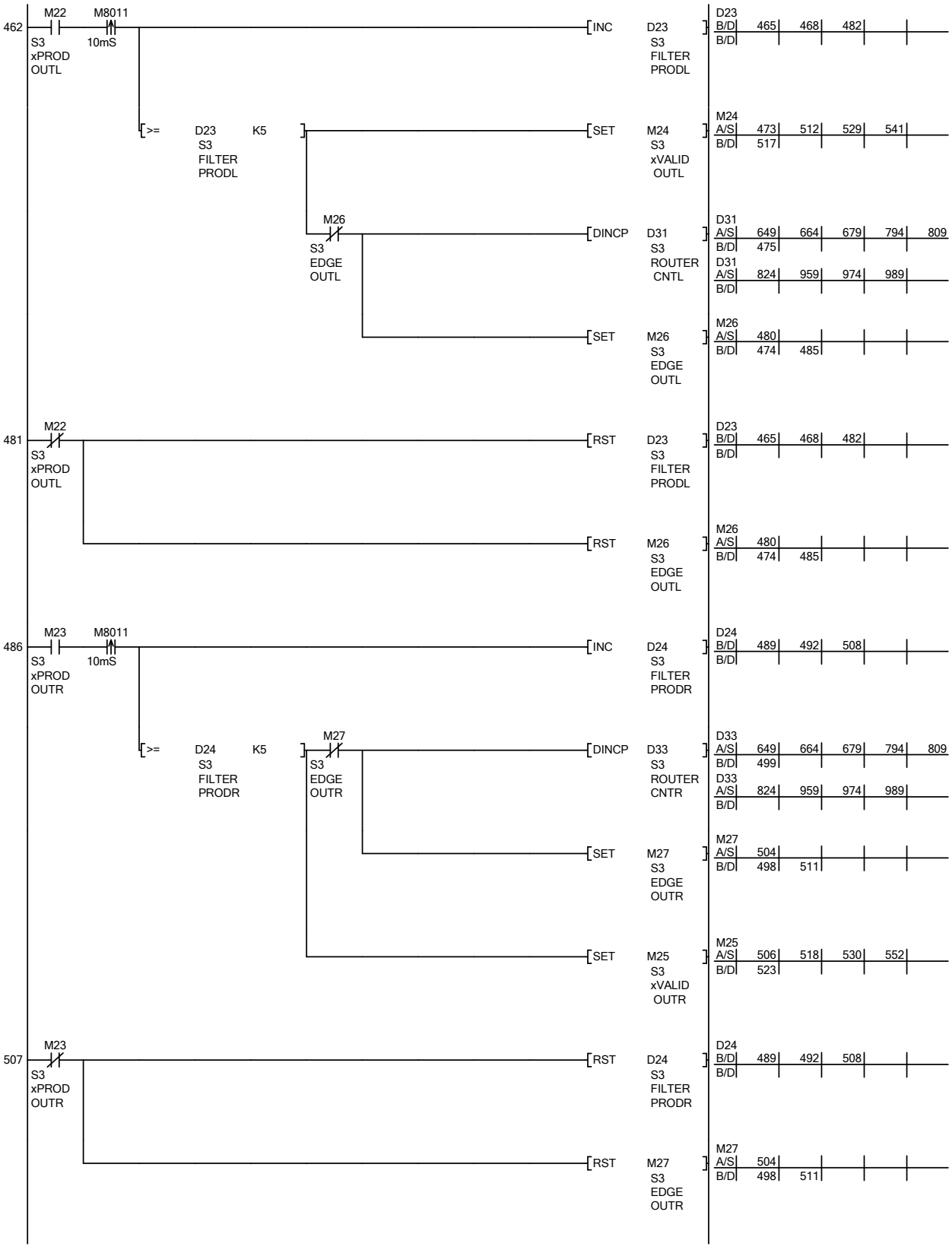

179
=
D60
K2
PWR SEQ
SET
Y027
S3 CONVR
Y027
A/S
184
A/S
Y020
S3 CONV
MAIN
Y023
S4 CONVL
Y024
S4 CONVR
Y025
S1 DIR_R
189
SRET
P10
190
=
D3
K1
S2 LEFT
STATE
LEFT
SET
M1
S2
CONVL
M1
A/S
196
250
2166
B/D
234
MOV
K2
D3
STATE
LEFT
D3
A/S
191
202
229
245
259
B/D
34
197
219
240
254
D3
A/S
581
597
618
B/D
275
698
763
843
878
D3
A/S
B/D
918
202
=
D3
K2
STATE
LEFT
M0
S2
xPRODL
M8011
10mS
INC
D0
FILT
xPRODL
D0
B/D
211
214
226
B/D
>=
D0
K5
FILT
xPRODL
MOV
K3
D3
STATE
LEFT
D3
A/S
191
202
229
245
259
B/D
34
197
219
240
254
D3
A/S
581
597
618
B/D
275
698
763
843
878
D3
A/S
B/D
918
M0
S2
xPRODL
RST
D0
FILT
xPRODL
D0
B/D
211
214
226
B/D

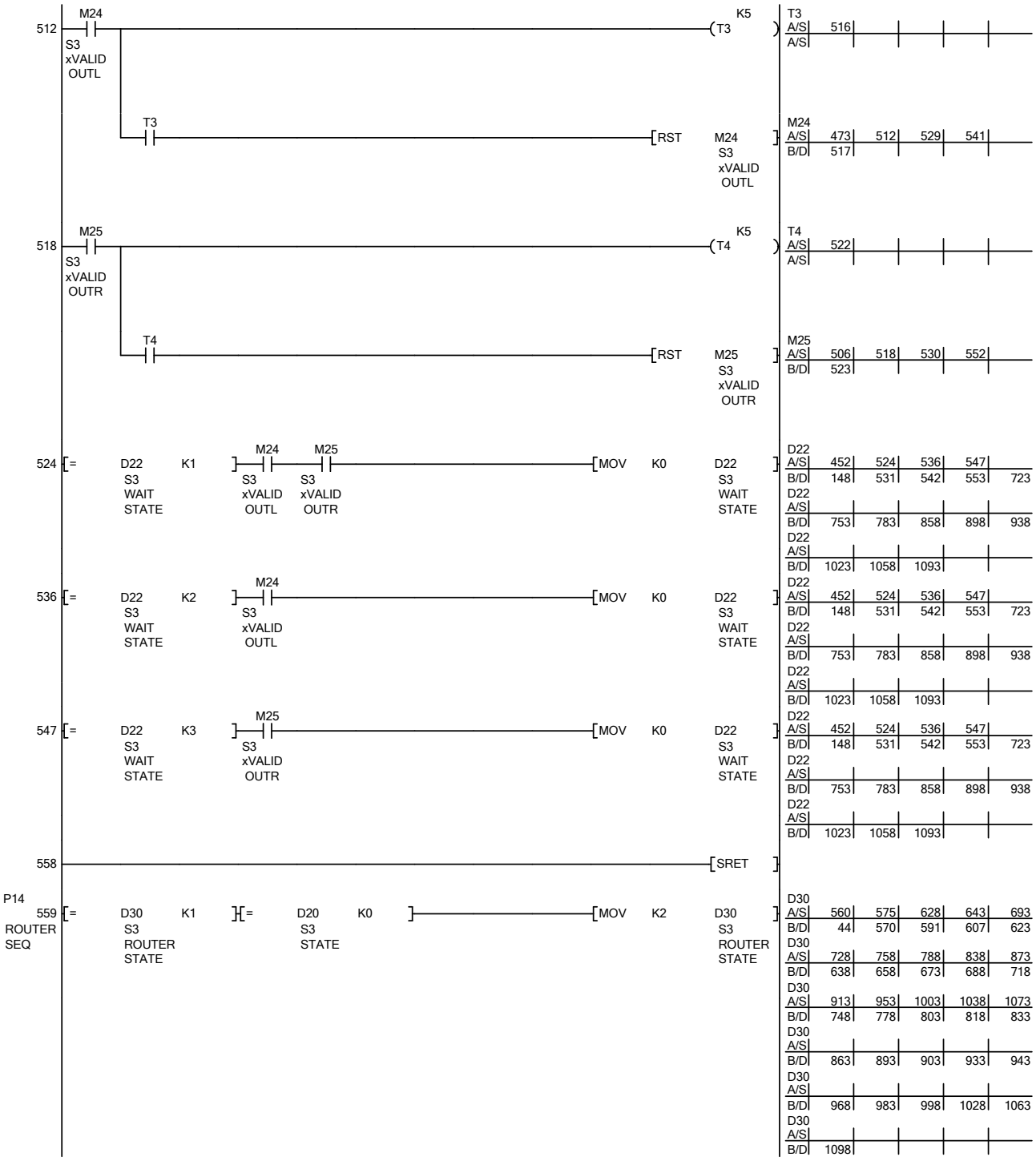

229 [= D3 STATE LEFT K3
RST M1 S2 CONVL
DINC D1 CNT PRODL
MOV K4 D3 STATE LEFT
245 [= D3 STATE LEFT K5
SET M1 S2 CONVL
RST D4 FILT2 xPRODL
MOV K6 D3 STATE LEFT
259 [= D3 STATE LEFT K6
M0 S2 xPRODL
M8011 10mS
INC D4 FILT2 xPRODL
>= D4 FILT2 xPRODL K2
MOV K1 D3 STATE LEFT
280 SRET
P11
281 [= D13 STATE RIGHT K1
S2 RIGHT
SET M11 S2 CONVR
MOV K2 D13 STATE RIGHT

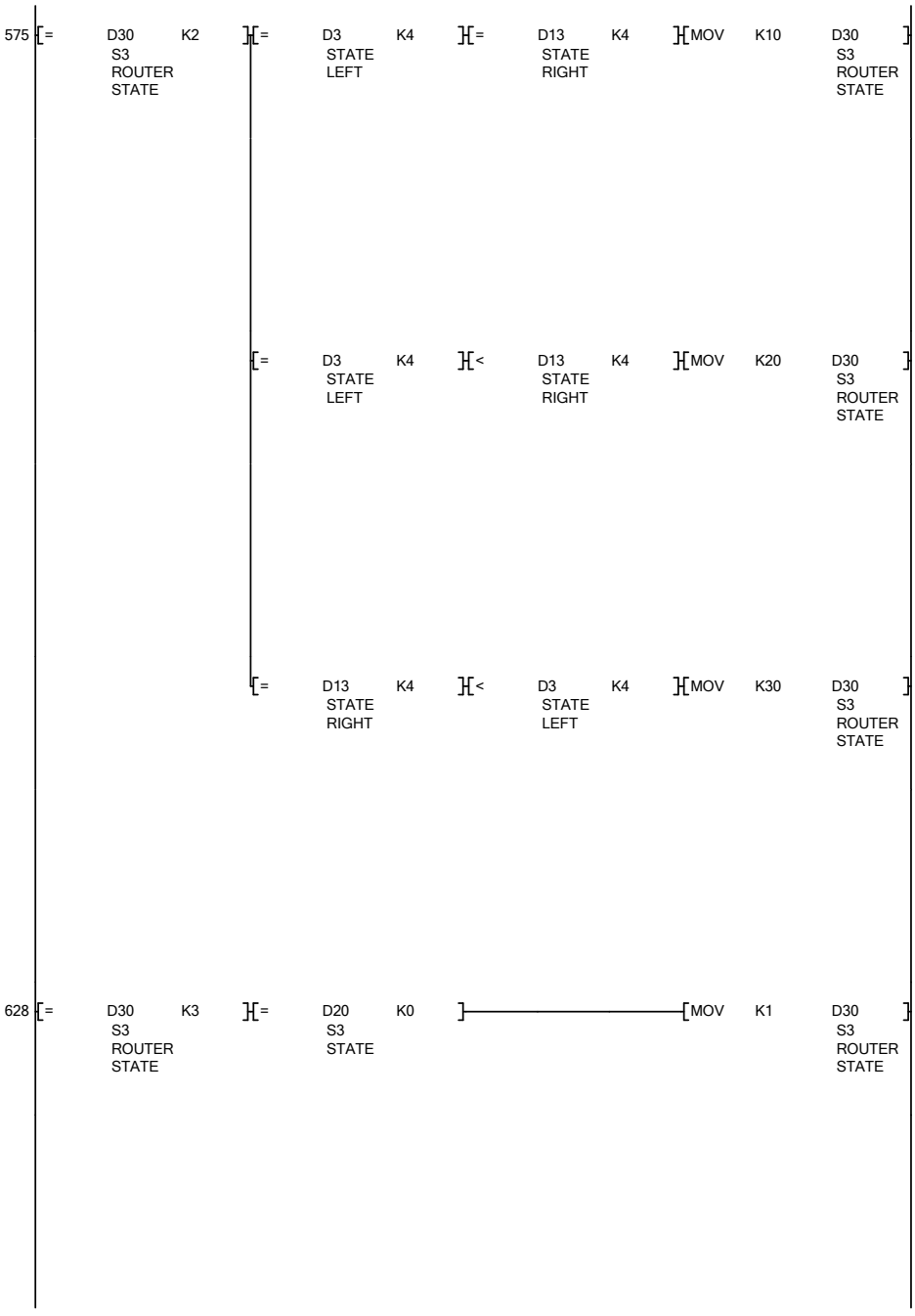

293 [= D13 STATE RIGHT K2
M10 S2 xPRODR
M8011 10mS
[INC D10 FILT xPRODR
[>= D10 FILT xPRODR K5
[MOV K3 D13 STATE RIGHT
M10 S2 xPRODR
[RST D1 CNT PRODL
320 [= D13 STATE RIGHT K3
[DINC D11 CNT PRODR
[RST M11 S2 CONVR
[MOV K4 D13 STATE RIGHT
336 [= D13 STATE RIGHT K5
[SET M11 S2 CONVR
[RST D14 FILT2 xPRODR
[MOV K6 D13 STATE RIGHT
350 [= D13 STATE RIGHT K6
M10 S2 xPRODR
M8011 10mS
[INC D14 FILT2 xPRODR
[>= D14 FILT2 xPRODR K2
[MOV K1 D13 STATE RIGHT

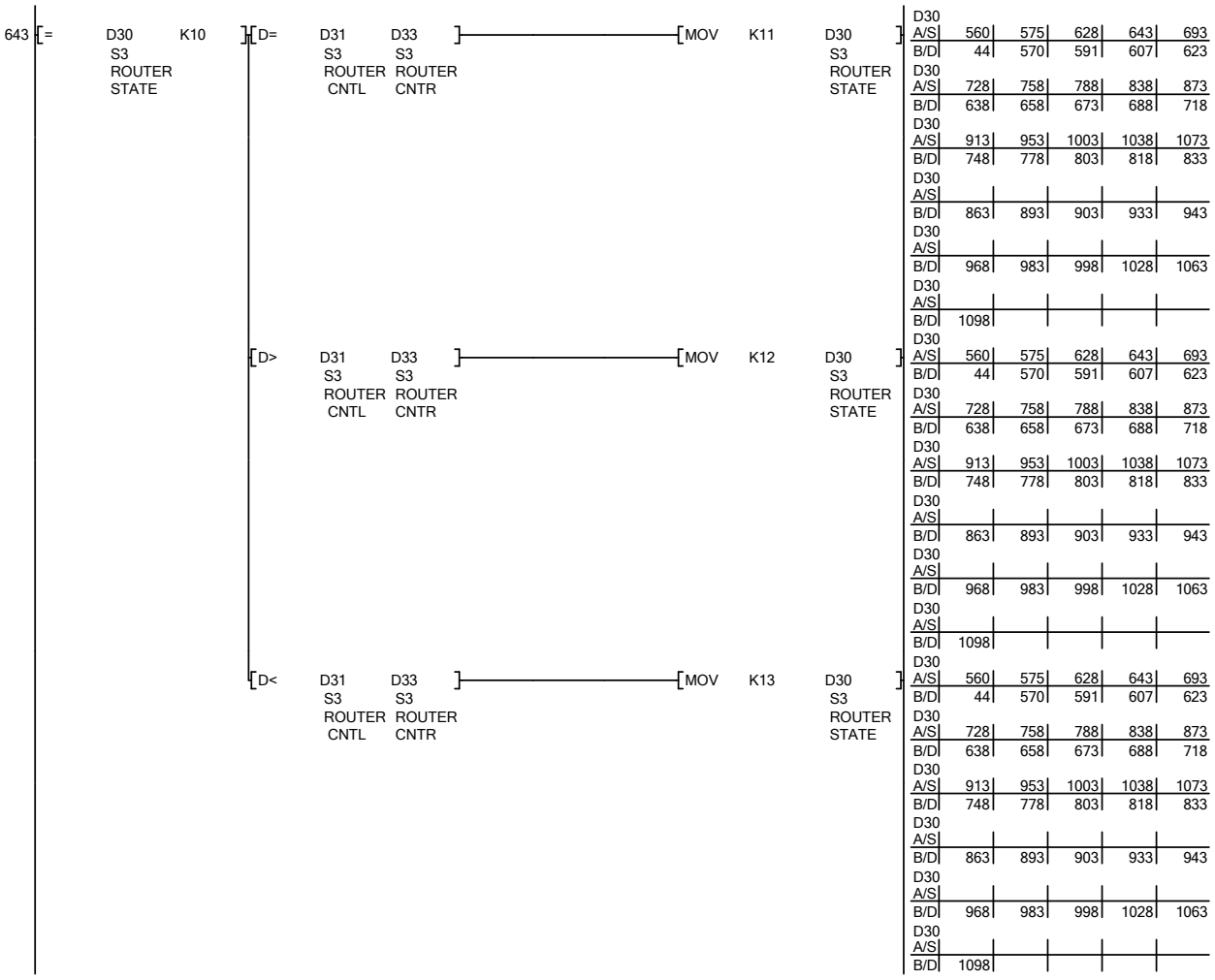

371
SRET
P13
372
ROUTER
= D20 S3 STATE K1
= D21 S3 ROUTE K0
MOV K2 D20 S3 STATE
= D21 S3 ROUTE K1
MOV K3 D20 S3 STATE
= D21 S3 ROUTE K2
MOV K4 D20 S3 STATE
411
= D20 S3 STATE K2
SET M20 S3 ROUTEA
RST M21 S3 ROUTEB
MOV K5 D20 S3 STATE
D20 A/S 373 411 423 435 447 B/D 139 384 395 406 418
D20 A/S 565 633 B/D 430 442 457 708 738
D20 A/S B/D 768 848 883 923 1013
D20 A/S B/D 1048 1083
M20 A/S 416 428 2162 B/D 440
M21 A/S 429 2164 B/D 417 441

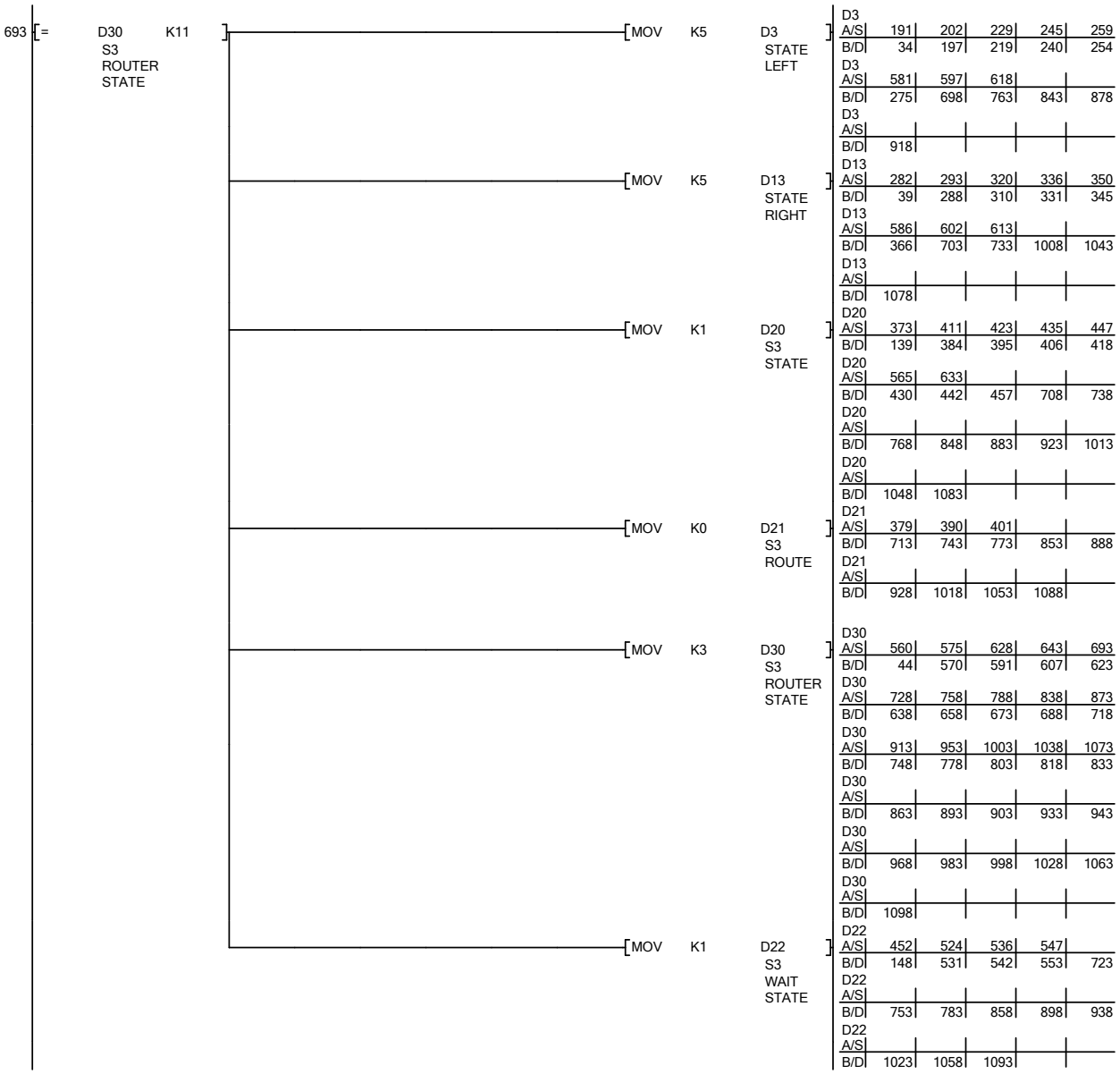

423 [= D20 S3 STATE K3]
[SET M20 S3 ROUTEA]
M20 A/S 416 428 2162
B/D 440
[SET M21 S3 ROUTEB]
M21 A/S 429 2164
B/D 417 441
[MOV K5 D20 S3 STATE]
D20 A/S 373 411 423 435 447
B/D 139 384 395 406 418
D20 A/S 565 633
B/D 430 442 457 708 738
D20 A/S
B/D 768 848 883 923 1013
D20 A/S
B/D 1048 1083
435 [= D20 S3 STATE K4]
[RST M20 S3 ROUTEA]
M20 A/S 416 428 2162
B/D 440
[RST M21 S3 ROUTEB]
M21 A/S 429 2164
B/D 417 441
[MOV K5 D20 S3 STATE]
D20 A/S 373 411 423 435 447
B/D 139 384 395 406 418
D20 A/S 565 633
B/D 430 442 457 708 738
D20 A/S
B/D 768 848 883 923 1013
D20 A/S
B/D 1048 1083
447 [= D20 S3 STATE K5][= D22 S3 WAIT STATE K0]
[MOV K0 D20 S3 STATE]
D20 A/S 373 411 423 435 447
B/D 139 384 395 406 418
D20 A/S 565 633
B/D 430 442 457 708 738
D20 A/S
B/D 768 848 883 923 1013
D20 A/S
B/D 1048 1083

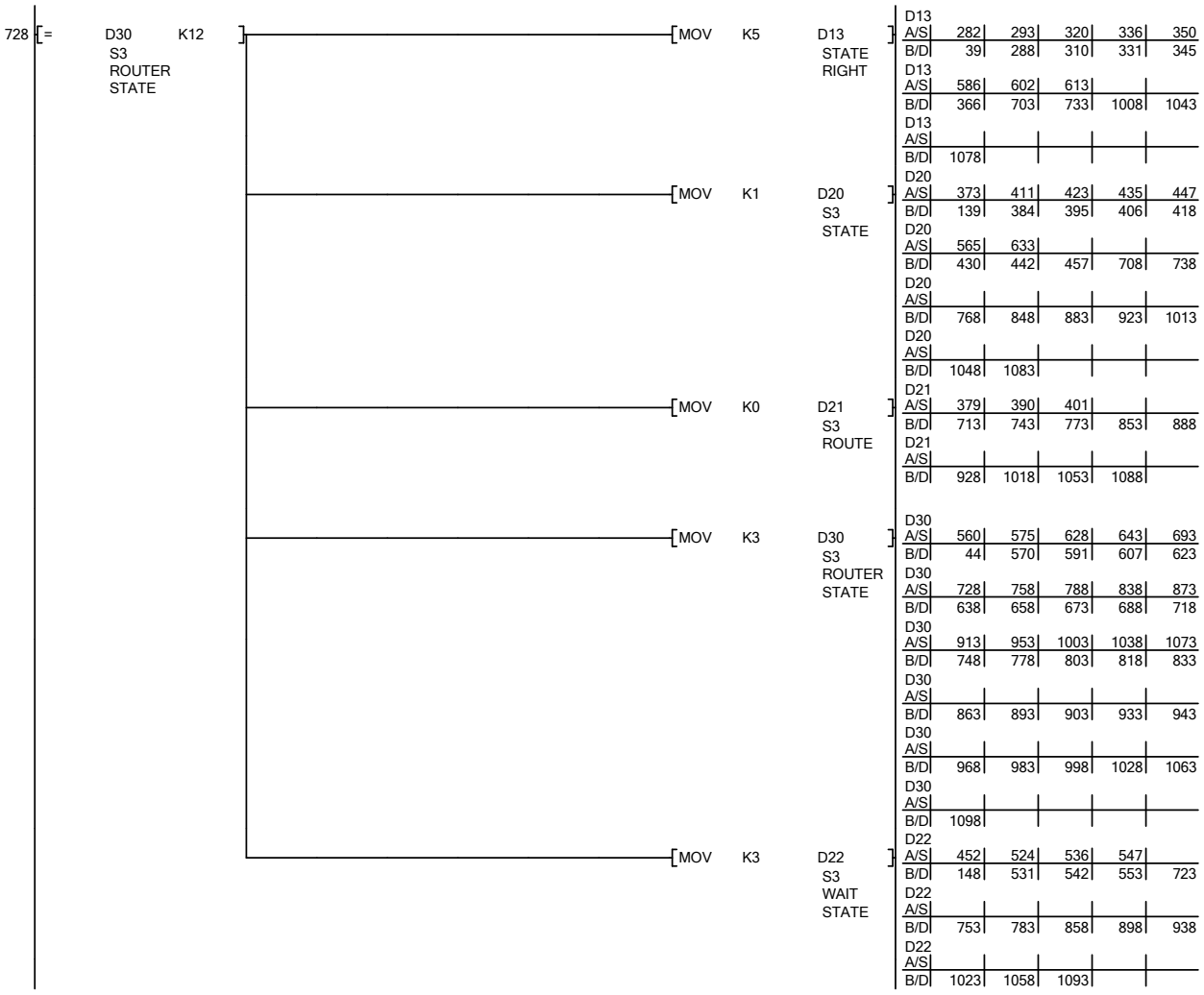

462
M22
S3 xPROD OUTL
M8011
10mS
INC
D23
S3 FILTER PRODL
D23 B/D 465 468 482
B/D
>=
D23
S3 FILTER PRODL
K5
SET
M24
S3 xVALID OUTL
M24 A/S 473 512 529 541
B/D 517
M26
S3 EDGE OUTL
DINCP
D31
S3 ROUTER CNTL
D31 A/S 649 664 679 794 809
B/D 475
D31 A/S 824 959 974 989
B/D
SET
M26
S3 EDGE OUTL
M26 A/S 480
B/D 474 485
481
M22
S3 xPROD OUTL
RST
D23
S3 FILTER PRODL
D23 B/D 465 468 482
B/D
RST
M26
S3 EDGE OUTL
M26 A/S 480
B/D 474 485
486
M23
S3 xPROD OUTR
M8011
10mS
INC
D24
S3 FILTER PRODR
D24 B/D 489 492 508
B/D
>=
D24
S3 FILTER PRODR
K5
M27
S3 EDGE OUTR
DINCP
D33
S3 ROUTER CNTR
D33 A/S 649 664 679 794 809
B/D 499
D33 A/S 824 959 974 989
B/D
SET
M27
S3 EDGE OUTR
M27 A/S 504
B/D 498 511
SET
M25
S3 xVALID OUTR
M25 A/S 506 518 530 552
B/D 523
507
M23
S3 xPROD OUTR
RST
D24
S3 FILTER PRODR
D24 B/D 489 492 508
B/D
RST
M27
S3 EDGE OUTR
M27 A/S 504
B/D 498 511

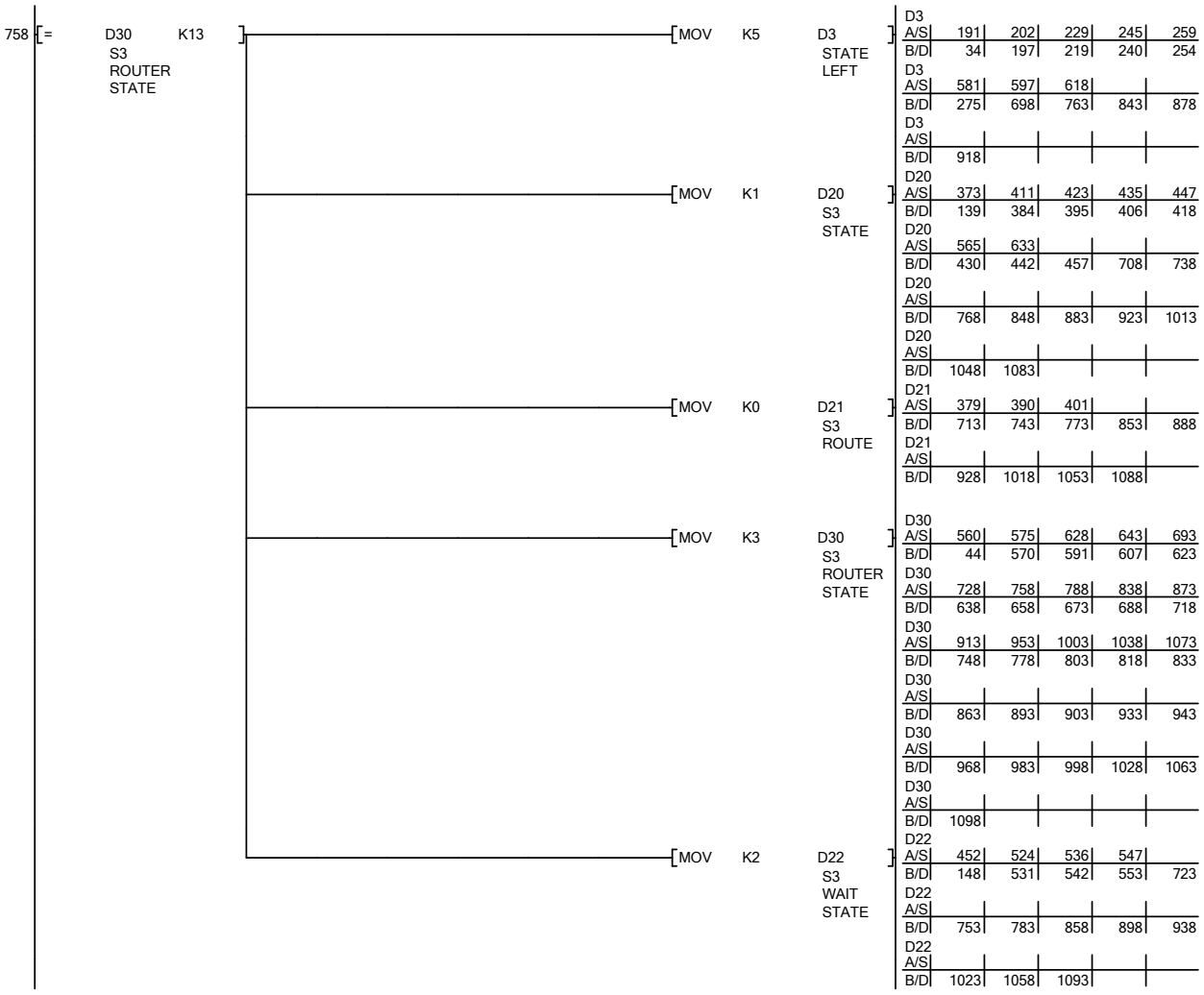

512 M24 S3 xVALID OUTL
K5 T3
T3 A/S 516 A/S
T3
RST M24 S3 xVALID OUTL
M24 A/S 473 512 529 541 B/D 517
518 M25 S3 xVALID OUTR
K5 T4
T4 A/S 522 A/S
T4
RST M25 S3 xVALID OUTR
M25 A/S 506 518 530 552 B/D 523
524 = D22 S3 WAIT STATE K1 M24 S3 xVALID OUTL M25 S3 xVALID OUTR MOV K0 D22 S3 WAIT STATE
D22 A/S 452 524 536 547 B/D 148 531 542 553 723
D22 A/S B/D 753 783 858 898 938
D22 A/S B/D 1023 1058 1093
536 = D22 S3 WAIT STATE K2 M24 S3 xVALID OUTL MOV K0 D22 S3 WAIT STATE
D22 A/S 452 524 536 547 B/D 148 531 542 553 723
D22 A/S B/D 753 783 858 898 938
D22 A/S B/D 1023 1058 1093
547 = D22 S3 WAIT STATE K3 M25 S3 xVALID OUTR MOV K0 D22 S3 WAIT STATE
D22 A/S 452 524 536 547 B/D 148 531 542 553 723
D22 A/S B/D 753 783 858 898 938
D22 A/S B/D 1023 1058 1093
558 SRET
P14 ROUTER SEQ
559 = D30 S3 ROUTER STATE K1 = D20 S3 STATE K0 MOV K2 D30 S3 ROUTER STATE
D30 A/S 560 575 628 643 693 B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873 B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073 B/D 748 778 803 818 833
D30 A/S B/D 863 893 903 933 943
D30 A/S B/D 968 983 998 1028 1063
D30 A/S B/D 1098

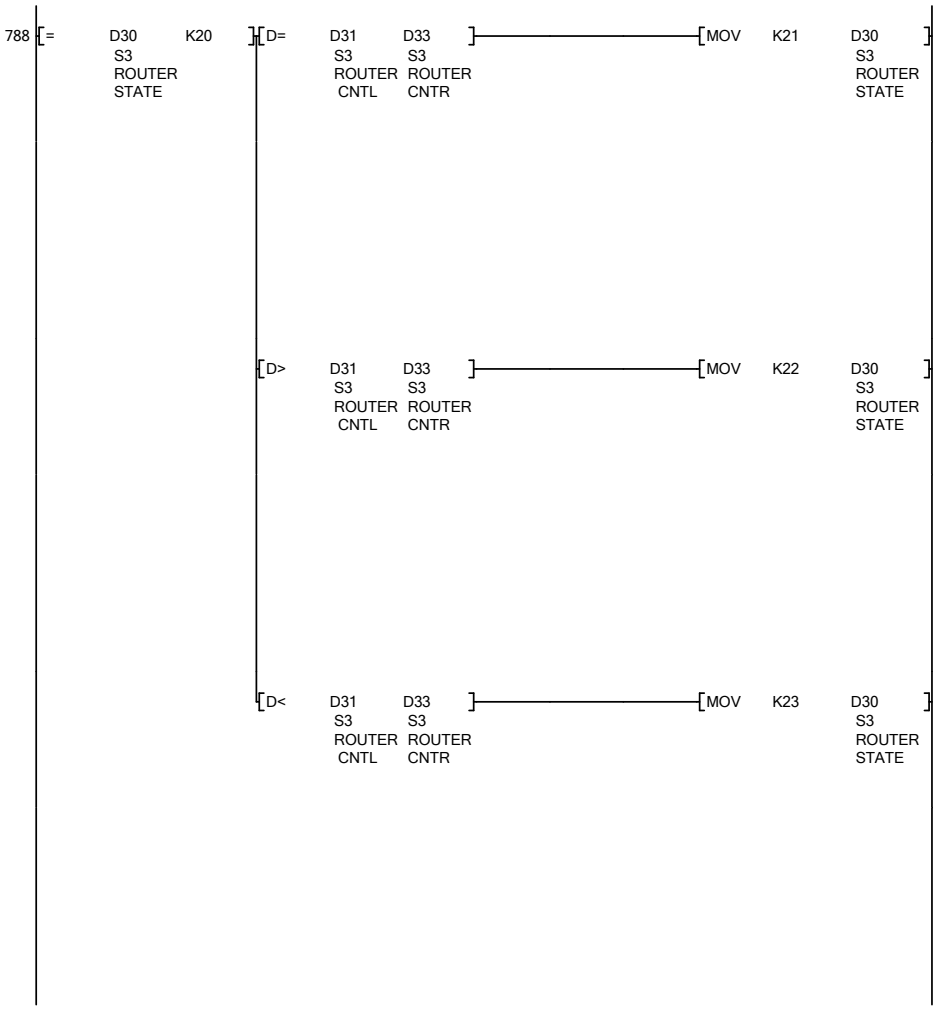

575
= D30 S3 ROUTER STATE K2
= D3 STATE LEFT K4
= D13 STATE RIGHT K4
MOV K10 D30 S3 ROUTER STATE
= D3 STATE LEFT K4
< D13 STATE RIGHT K4
MOV K20 D30 S3 ROUTER STATE
= D13 STATE RIGHT K4
< D3 STATE LEFT K4
MOV K30 D30 S3 ROUTER STATE
628
= D30 S3 ROUTER STATE K3
= D20 S3 STATE K0
MOV K1 D30 S3 ROUTER STATE
D30
A/S 560 575 628 643 693
B/D 44 570 591 607 623
A/S 728 758 788 838 873
B/D 638 658 673 688 718
A/S 913 953 1003 1038 1073
B/D 748 778 803 818 833
A/S
B/D 863 893 903 933 943
A/S
B/D 968 983 998 1028 1063
A/S
B/D 1098

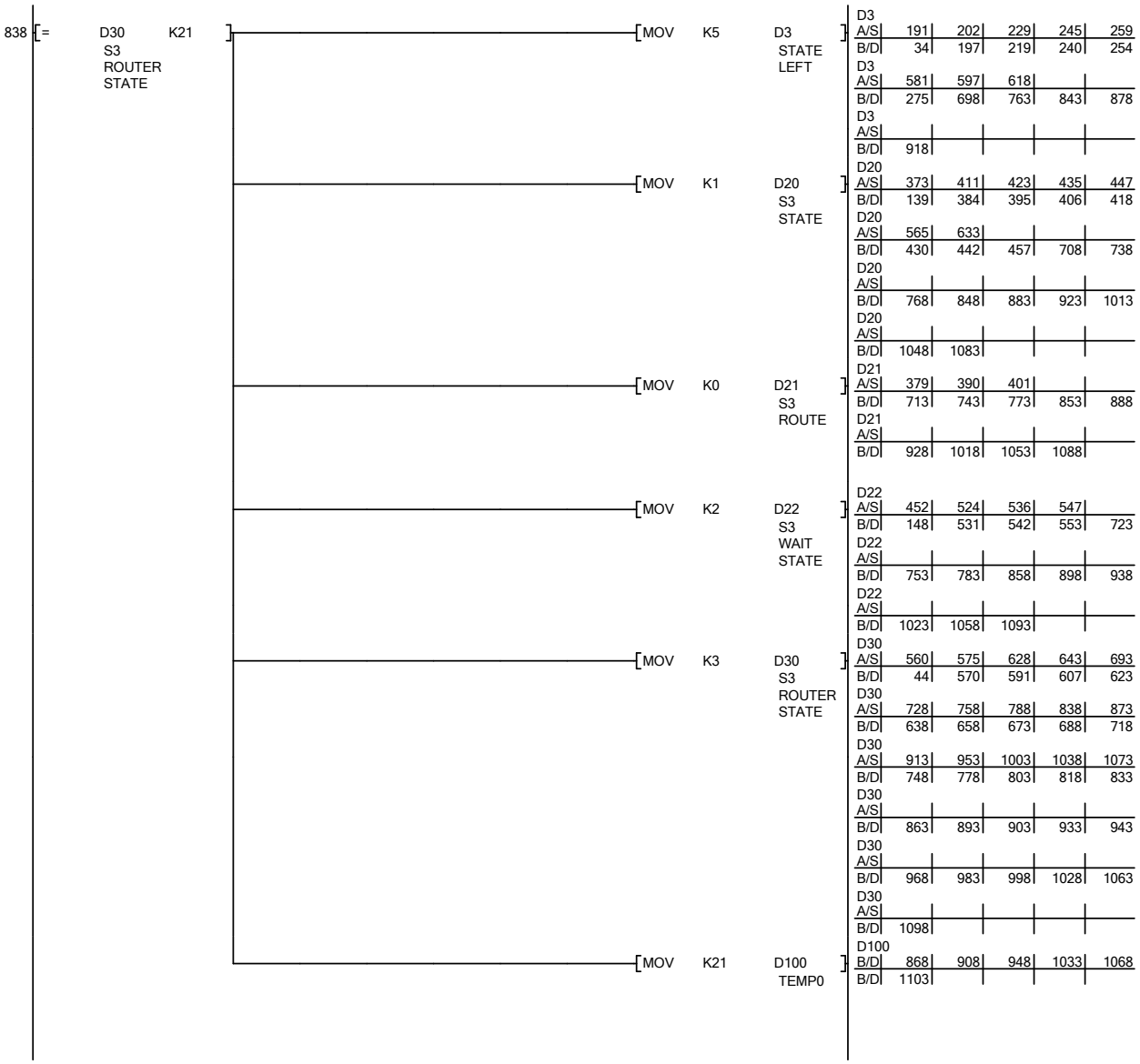

643
[= D30 K10 S3 ROUTER STATE]
[D= D31 S3 ROUTER CNTL D33 S3 ROUTER CNTR]
[MOV K11 D30 S3 ROUTER STATE]
[D> D31 S3 ROUTER CNTL D33 S3 ROUTER CNTR]
[MOV K12 D30 S3 ROUTER STATE]
[D< D31 S3 ROUTER CNTL D33 S3 ROUTER CNTR]
[MOV K13 D30 S3 ROUTER STATE]
D30 A/S 560 575 628 643 693 B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873 B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073 B/D 748 778 803 818 833
D30 A/S B/D 863 893 903 933 943
D30 A/S B/D 968 983 998 1028 1063
D30 A/S B/D 1098

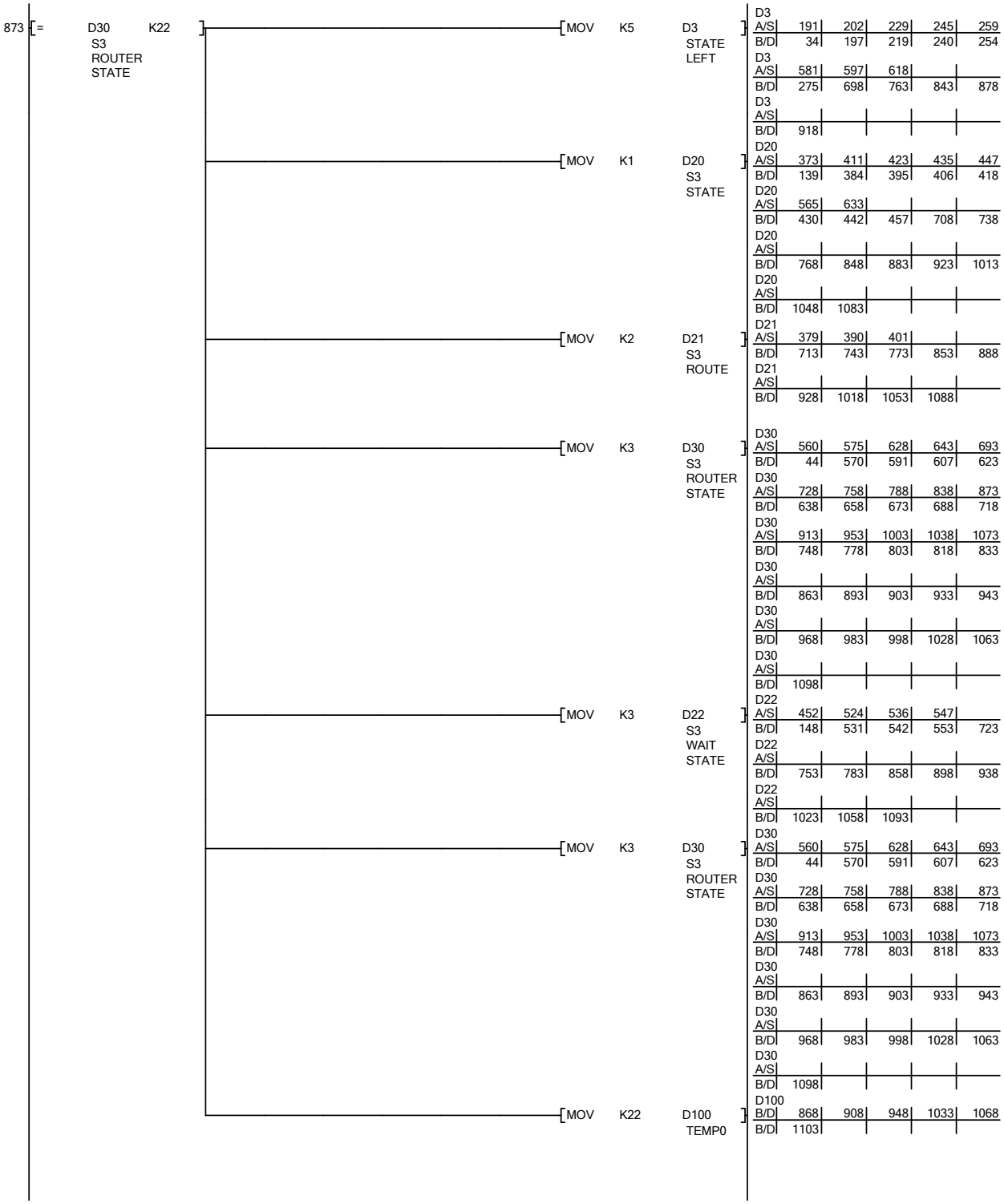

693 [= D30 K11 S3 ROUTER STATE
[MOV K5 D3 STATE LEFT
[MOV K5 D13 STATE RIGHT
[MOV K1 D20 S3 STATE
[MOV K0 D21 S3 ROUTE
[MOV K3 D30 S3 ROUTER STATE
[MOV K1 D22 S3 WAIT STATE
D3 A/S 191 202 229 245 259 B/D 34 197 219 240 254
D3 A/S 581 597 618 B/D 275 698 763 843 878
D3 A/S B/D 918
D13 A/S 282 293 320 336 350 B/D 39 288 310 331 345
D13 A/S 586 602 613 B/D 366 703 733 1008 1043
D13 A/S B/D 1078
D20 A/S 373 411 423 435 447 B/D 139 384 395 406 418
D20 A/S 565 633 B/D 430 442 457 708 738
D20 A/S B/D 768 848 883 923 1013
D20 A/S B/D 1048 1083
D21 A/S 379 390 401 B/D 713 743 773 853 888
D21 A/S B/D 928 1018 1053 1088
D30 A/S 560 575 628 643 693 B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873 B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073 B/D 748 778 803 818 833
D30 A/S B/D 863 893 903 933 943
D30 A/S B/D 968 983 998 1028 1063
D30 A/S B/D 1098
D22 A/S 452 524 536 547 B/D 148 531 542 553 723
D22 A/S B/D 753 783 858 898 938
D22 A/S B/D 1023 1058 1093

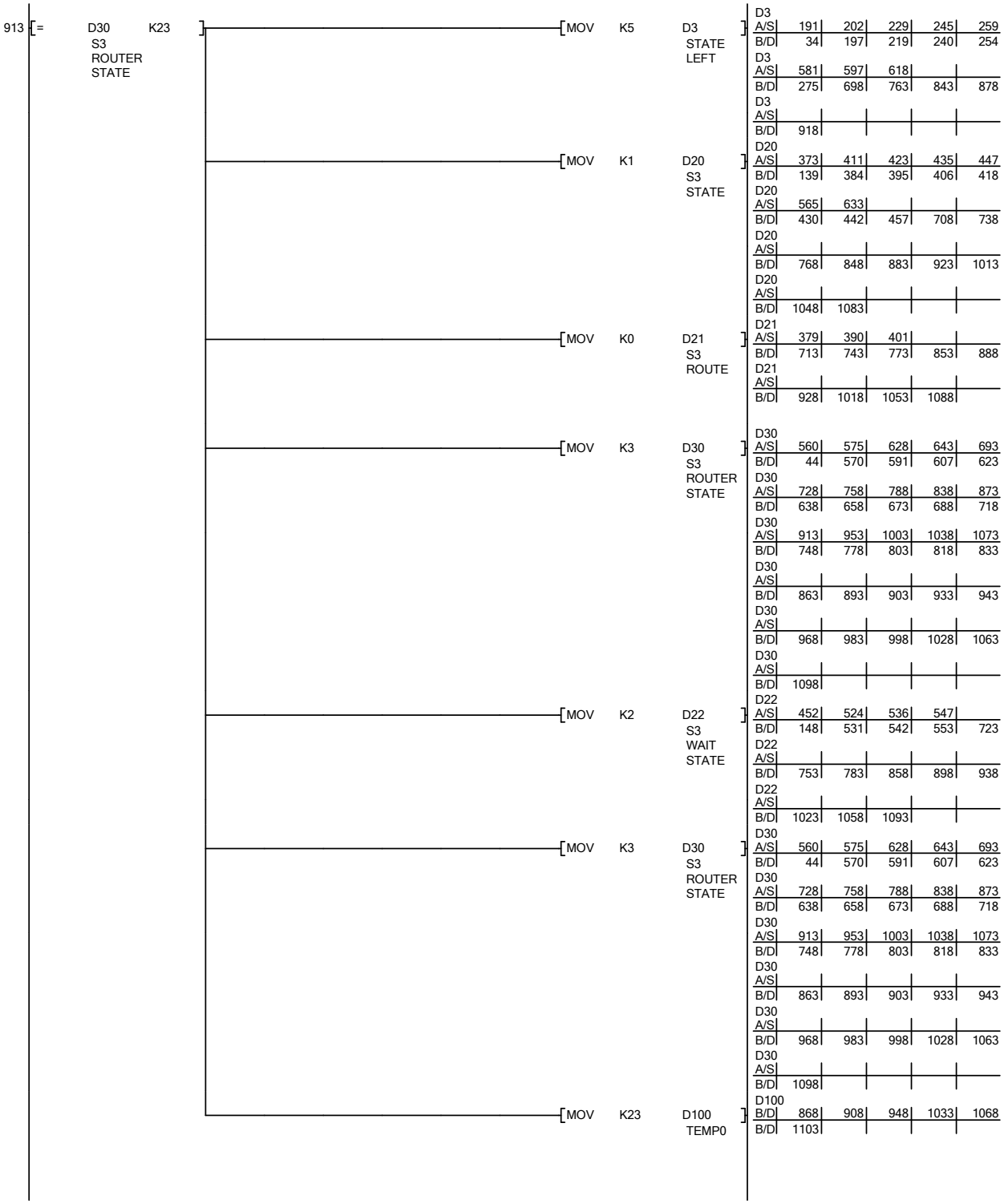

728 [= D30 K12 S3 ROUTER STATE
[MOV K5 D13 STATE RIGHT
[MOV K1 D20 S3 STATE
[MOV K0 D21 S3 ROUTE
[MOV K3 D30 S3 ROUTER STATE
[MOV K3 D22 S3 WAIT STATE
D13 A/S 282 293 320 336 350 B/D 39 288 310 331 345
D13 A/S 586 602 613 B/D 366 703 733 1008 1043
D13 A/S B/D 1078
D20 A/S 373 411 423 435 447 B/D 139 384 395 406 418
D20 A/S 565 633 B/D 430 442 457 708 738
D20 A/S B/D 768 848 883 923 1013
D20 A/S B/D 1048 1083
D21 A/S 379 390 401 B/D 713 743 773 853 888
D21 A/S B/D 928 1018 1053 1088
D30 A/S 560 575 628 643 693 B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873 B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073 B/D 748 778 803 818 833
D30 A/S B/D 863 893 903 933 943
D30 A/S B/D 968 983 998 1028 1063
D30 A/S B/D 1098
D22 A/S 452 524 536 547 B/D 148 531 542 553 723
D22 A/S B/D 753 783 858 898 938
D22 A/S B/D 1023 1058 1093

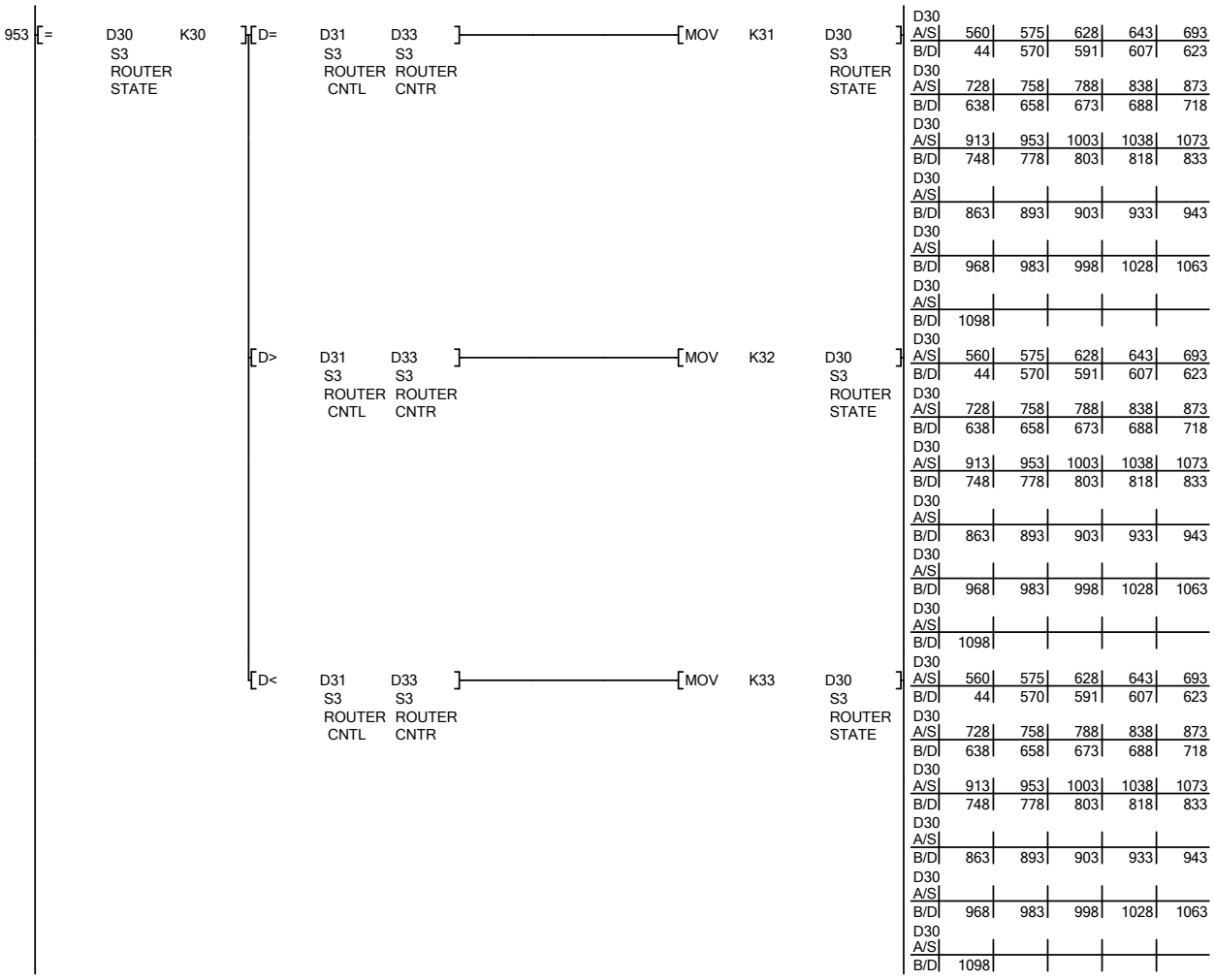

758 [= D30 K13 S3 ROUTER STATE
[MOV K5 D3 STATE LEFT
[MOV K1 D20 S3 STATE
[MOV K0 D21 S3 ROUTE
[MOV K3 D30 S3 ROUTER STATE
[MOV K2 D22 S3 WAIT STATE
D3 A/S 191 202 229 245 259 B/D 34 197 219 240 254
D3 A/S 581 597 618 B/D 275 698 763 843 878
D3 A/S B/D 918
D20 A/S 373 411 423 435 447 B/D 139 384 395 406 418
D20 A/S 565 633 B/D 430 442 457 708 738
D20 A/S B/D 768 848 883 923 1013
D20 A/S B/D 1048 1083
D21 A/S 379 390 401 B/D 713 743 773 853 888
D21 A/S B/D 928 1018 1053 1088
D30 A/S 560 575 628 643 693 B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873 B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073 B/D 748 778 803 818 833
D30 A/S B/D 863 893 903 933 943
D30 A/S B/D 968 983 998 1028 1063
D30 A/S B/D 1098
D22 A/S 452 524 536 547 B/D 148 531 542 553 723
D22 A/S B/D 753 783 858 898 938
D22 A/S B/D 1023 1058 1093

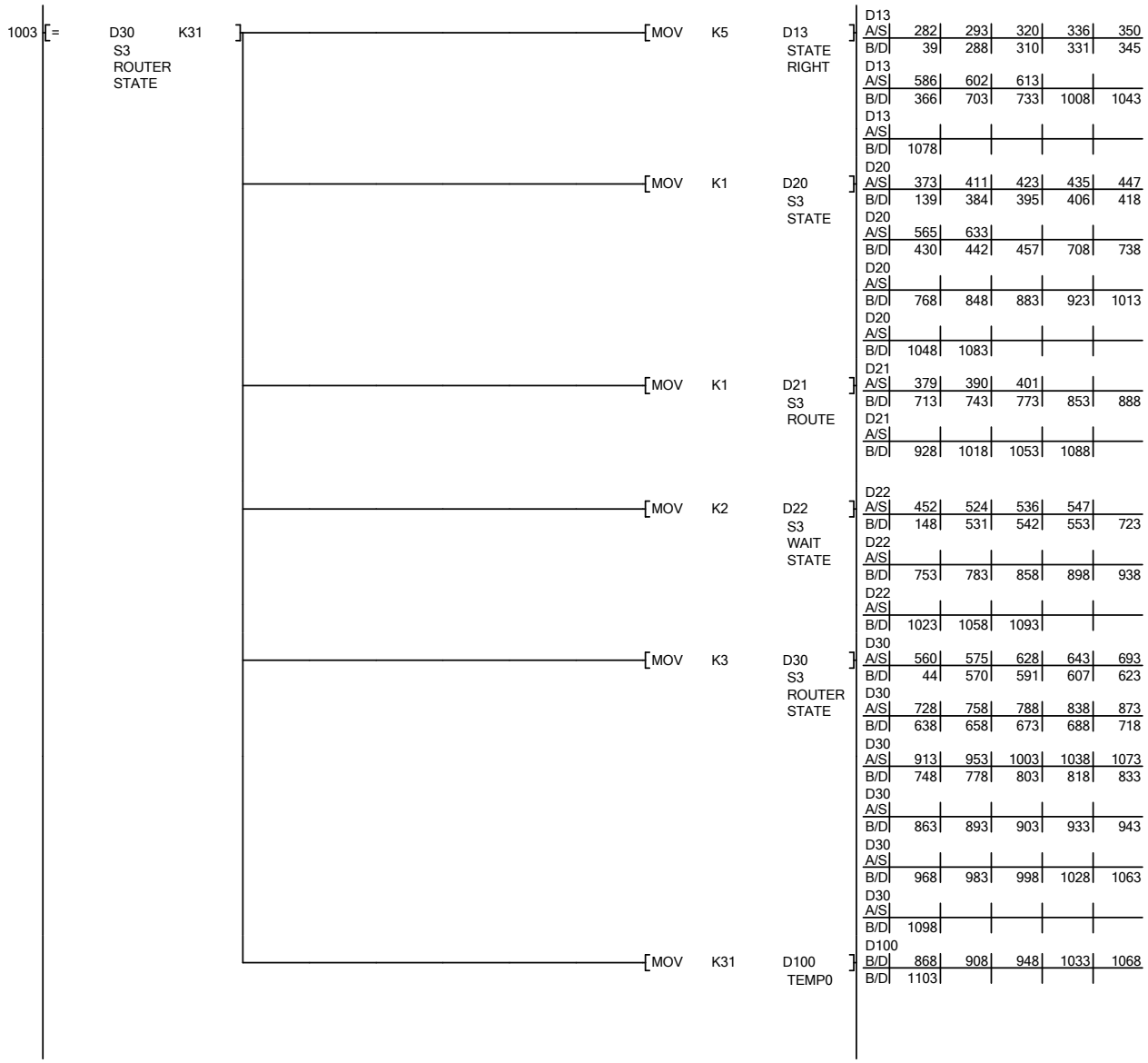

788
[= D30 K20 S3 ROUTER STATE]
[D= D31 S3 ROUTER CNTL D33 S3 ROUTER CNTR]
[MOV K21 D30 S3 ROUTER STATE]
[D> D31 S3 ROUTER CNTL D33 S3 ROUTER CNTR]
[MOV K22 D30 S3 ROUTER STATE]
[D< D31 S3 ROUTER CNTL D33 S3 ROUTER CNTR]
[MOV K23 D30 S3 ROUTER STATE]
D30 A/S 560 575 628 643 693
B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873
B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073
B/D 748 778 803 818 833
D30 A/S
B/D 863 893 903 933 943
D30 A/S
B/D 968 983 998 1028 1063
D30 A/S
B/D 1098

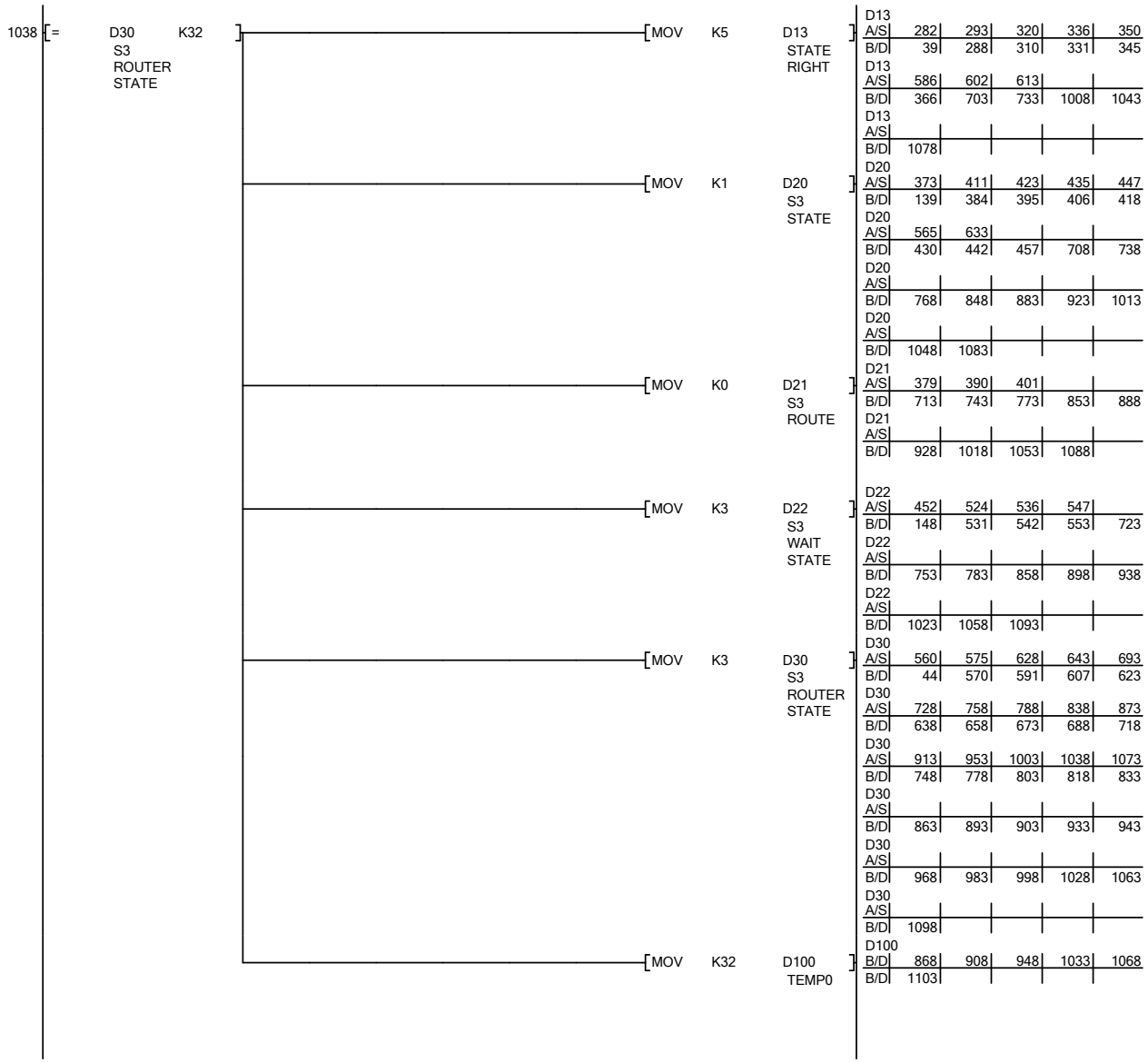

838 [= D30 K21 S3 ROUTER STATE
[MOV K5 D3 STATE LEFT
[MOV K1 D20 S3 STATE
[MOV K0 D21 S3 ROUTE
[MOV K2 D22 S3 WAIT STATE
[MOV K3 D30 S3 ROUTER STATE
[MOV K21 D100 TEMP0
D3 A/S 191 202 229 245 259
B/D 34 197 219 240 254
D3 A/S 581 597 618
B/D 275 698 763 843 878
D3 A/S
B/D 918
D20 A/S 373 411 423 435 447
B/D 139 384 395 406 418
D20 A/S 565 633
B/D 430 442 457 708 738
D20 A/S
B/D 768 848 883 923 1013
D20 A/S
B/D 1048 1083
D21 A/S 379 390 401
B/D 713 743 773 853 888
D21 A/S
B/D 928 1018 1053 1088
D22 A/S 452 524 536 547
B/D 148 531 542 553 723
D22 A/S
B/D 753 783 858 898 938
D22 A/S
B/D 1023 1058 1093
D30 A/S 560 575 628 643 693
B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873
B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073
B/D 748 778 803 818 833
D30 A/S
B/D 863 893 903 933 943
D30 A/S
B/D 968 983 998 1028 1063
D30 A/S
B/D 1098
D100 B/D 868 908 948 1033 1068
B/D 1103

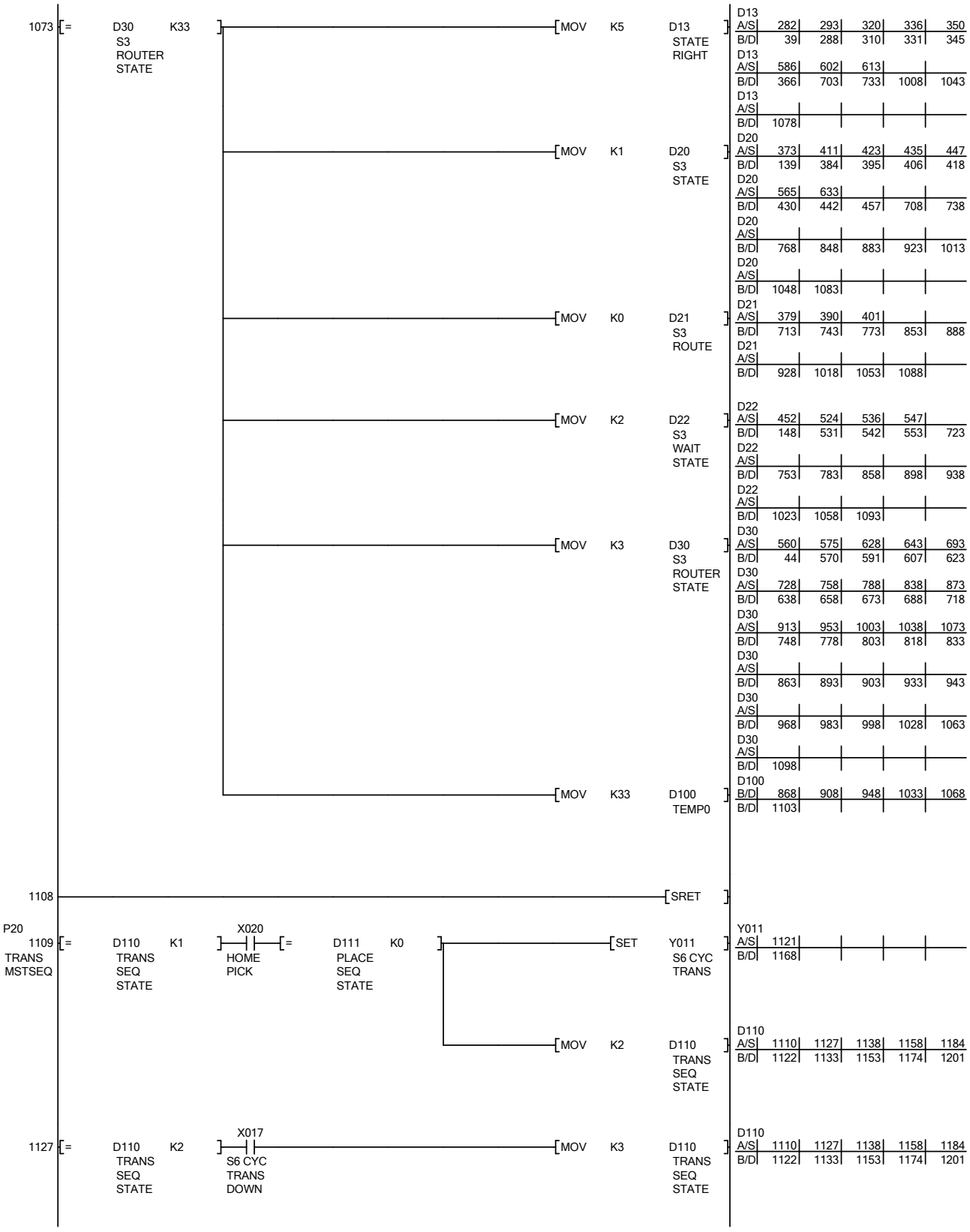

873 [= D30 K22 S3 ROUTER STATE
[MOV K5 D3 STATE LEFT
[MOV K1 D20 S3 STATE
[MOV K2 D21 S3 ROUTE
[MOV K3 D30 S3 ROUTER STATE
[MOV K3 D22 S3 WAIT STATE
[MOV K3 D30 S3 ROUTER STATE
[MOV K22 D100 TEMP0
D3 A/S 191 202 229 245 259 B/D 34 197 219 240 254
D3 A/S 581 597 618 B/D 275 698 763 843 878
D3 A/S B/D 918
D20 A/S 373 411 423 435 447 B/D 139 384 395 406 418
D20 A/S 565 633 B/D 430 442 457 708 738
D20 A/S B/D 768 848 883 923 1013
D20 A/S B/D 1048 1083
D21 A/S 379 390 401 B/D 713 743 773 853 888
D21 A/S B/D 928 1018 1053 1088
D30 A/S 560 575 628 643 693 B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873 B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073 B/D 748 778 803 818 833
D30 A/S B/D 863 893 903 933 943
D30 A/S B/D 968 983 998 1028 1063
D30 A/S B/D 1098
D22 A/S 452 524 536 547 B/D 148 531 542 553 723
D22 A/S B/D 753 783 858 898 938
D22 A/S B/D 1023 1058 1093
D30 A/S 560 575 628 643 693 B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873 B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073 B/D 748 778 803 818 833
D30 A/S B/D 863 893 903 933 943
D30 A/S B/D 968 983 998 1028 1063
D30 A/S B/D 1098
D100 B/D 868 908 948 1033 1068 B/D 1103

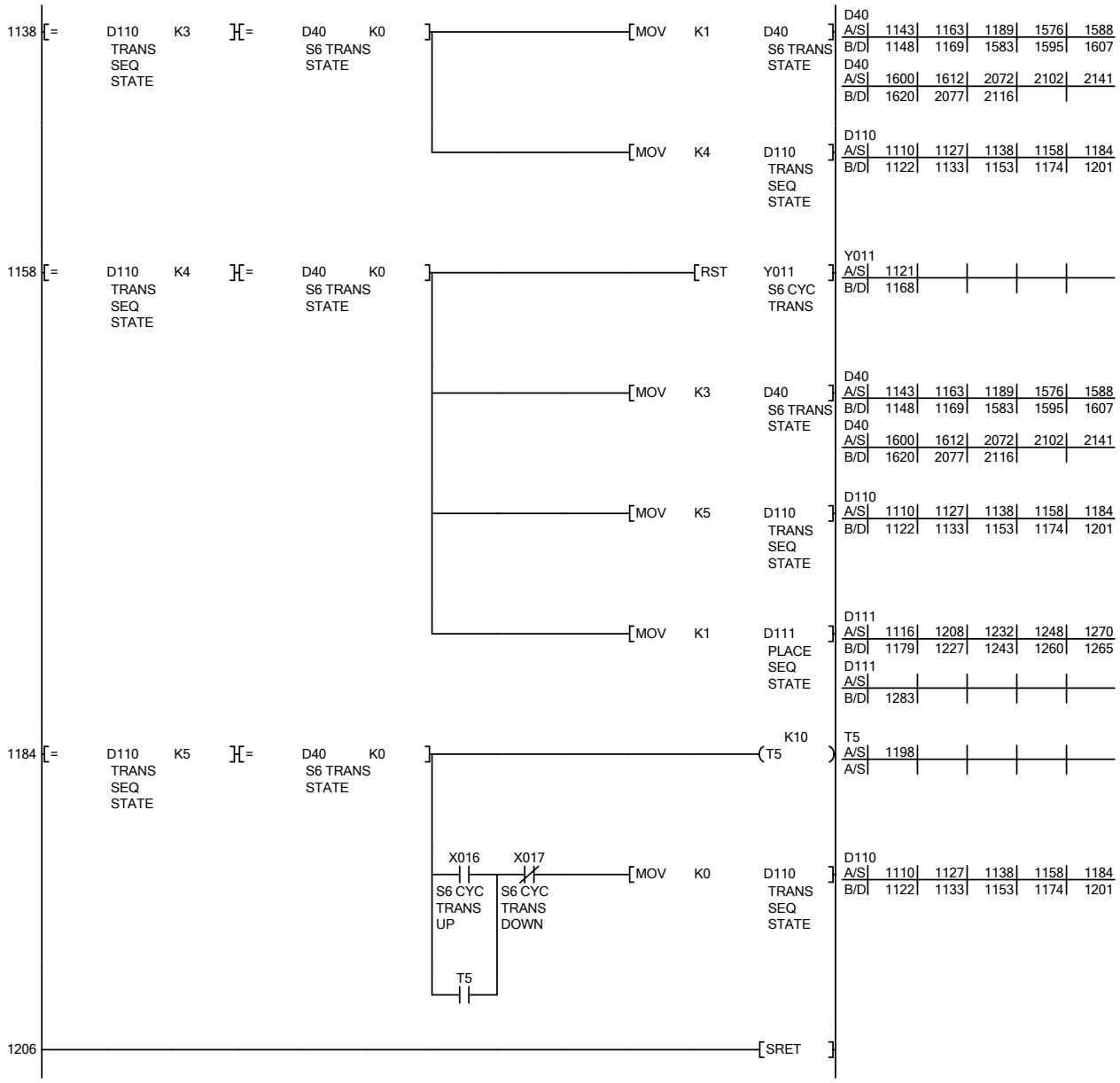

913 [= D30 K23 S3 ROUTER STATE]
[MOV K5 D3 STATE LEFT]
[MOV K1 D20 S3 STATE]
[MOV K0 D21 S3 ROUTE]
[MOV K3 D30 S3 ROUTER STATE]
[MOV K2 D22 S3 WAIT STATE]
[MOV K3 D30 S3 ROUTER STATE]
[MOV K23 D100 TEMP0]
D3 A/S 191 202 229 245 259 B/D 34 197 219 240 254
D3 A/S 581 597 618 B/D 275 698 763 843 878
D3 A/S B/D 918
D20 A/S 373 411 423 435 447 B/D 139 384 395 406 418
D20 A/S 565 633 B/D 430 442 457 708 738
D20 A/S B/D 768 848 883 923 1013
D20 A/S B/D 1048 1083
D21 A/S 379 390 401 B/D 713 743 773 853 888
D21 A/S B/D 928 1018 1053 1088
D30 A/S 560 575 628 643 693 B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873 B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073 B/D 748 778 803 818 833
D30 A/S B/D 863 893 903 933 943
D30 A/S B/D 968 983 998 1028 1063
D30 A/S B/D 1098
D22 A/S 452 524 536 547 B/D 148 531 542 553 723
D22 A/S B/D 753 783 858 898 938
D22 A/S B/D 1023 1058 1093
D30 A/S 560 575 628 643 693 B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873 B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073 B/D 748 778 803 818 833
D30 A/S B/D 863 893 903 933 943
D30 A/S B/D 968 983 998 1028 1063
D30 A/S B/D 1098
D100 B/D 868 908 948 1033 1068 B/D 1103

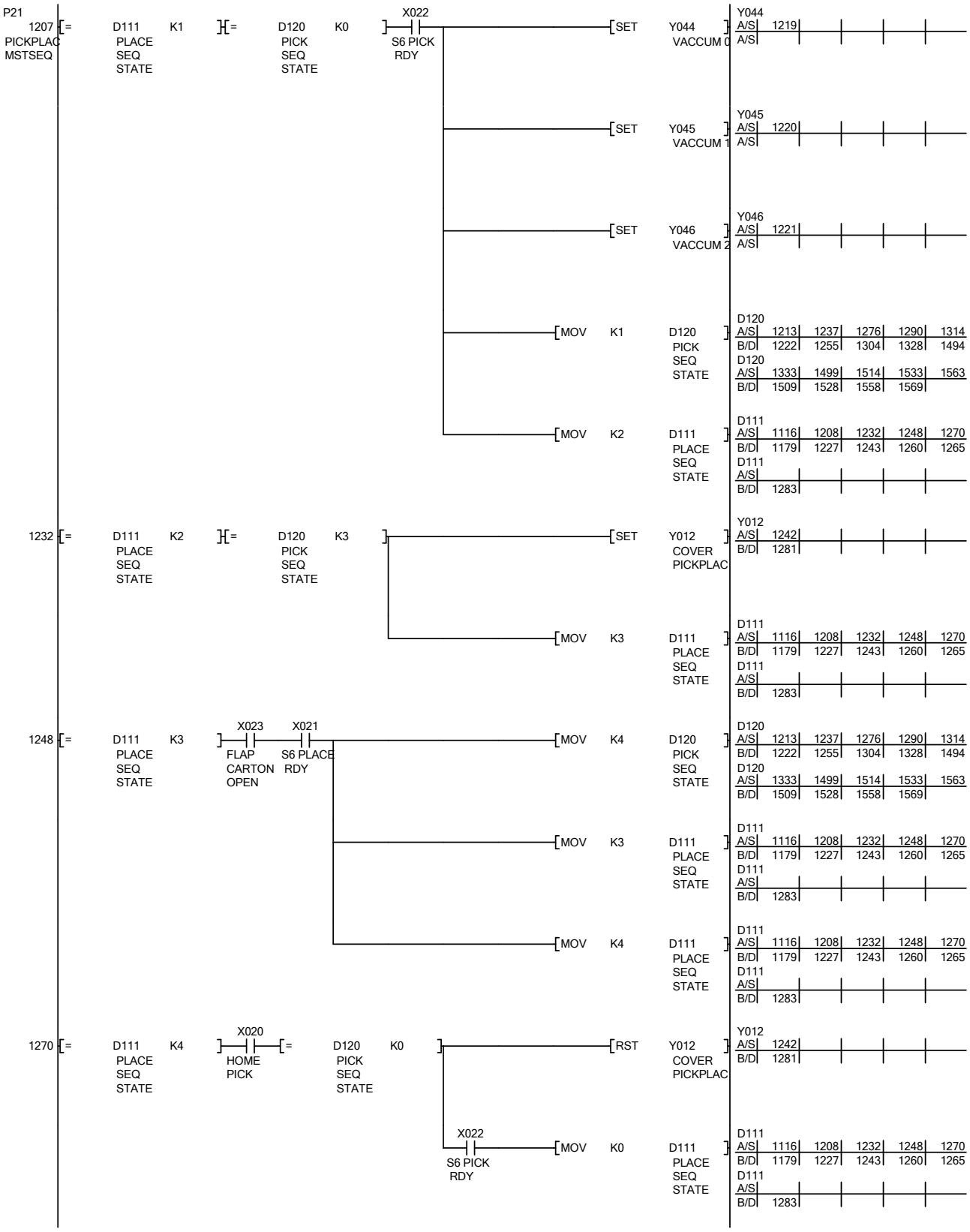

953
= D30 K30
S3 ROUTER STATE
D= D31 D33
S3 ROUTER CNTL
S3 ROUTER CNTR
MOV K31 D30
S3 ROUTER STATE
D30 A/S 560 575 628 643 693
B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873
B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073
B/D 748 778 803 818 833
D30 A/S
B/D 863 893 903 933 943
D30 A/S
B/D 968 983 998 1028 1063
D30 A/S
B/D 1098
D> D31 D33
S3 ROUTER CNTL
S3 ROUTER CNTR
MOV K32 D30
S3 ROUTER STATE
D30 A/S 560 575 628 643 693
B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873
B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073
B/D 748 778 803 818 833
D30 A/S
B/D 863 893 903 933 943
D30 A/S
B/D 968 983 998 1028 1063
D30 A/S
B/D 1098
D< D31 D33
S3 ROUTER CNTL
S3 ROUTER CNTR
MOV K33 D30
S3 ROUTER STATE
D30 A/S 560 575 628 643 693
B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873
B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073
B/D 748 778 803 818 833
D30 A/S
B/D 863 893 903 933 943
D30 A/S
B/D 968 983 998 1028 1063
D30 A/S
B/D 1098

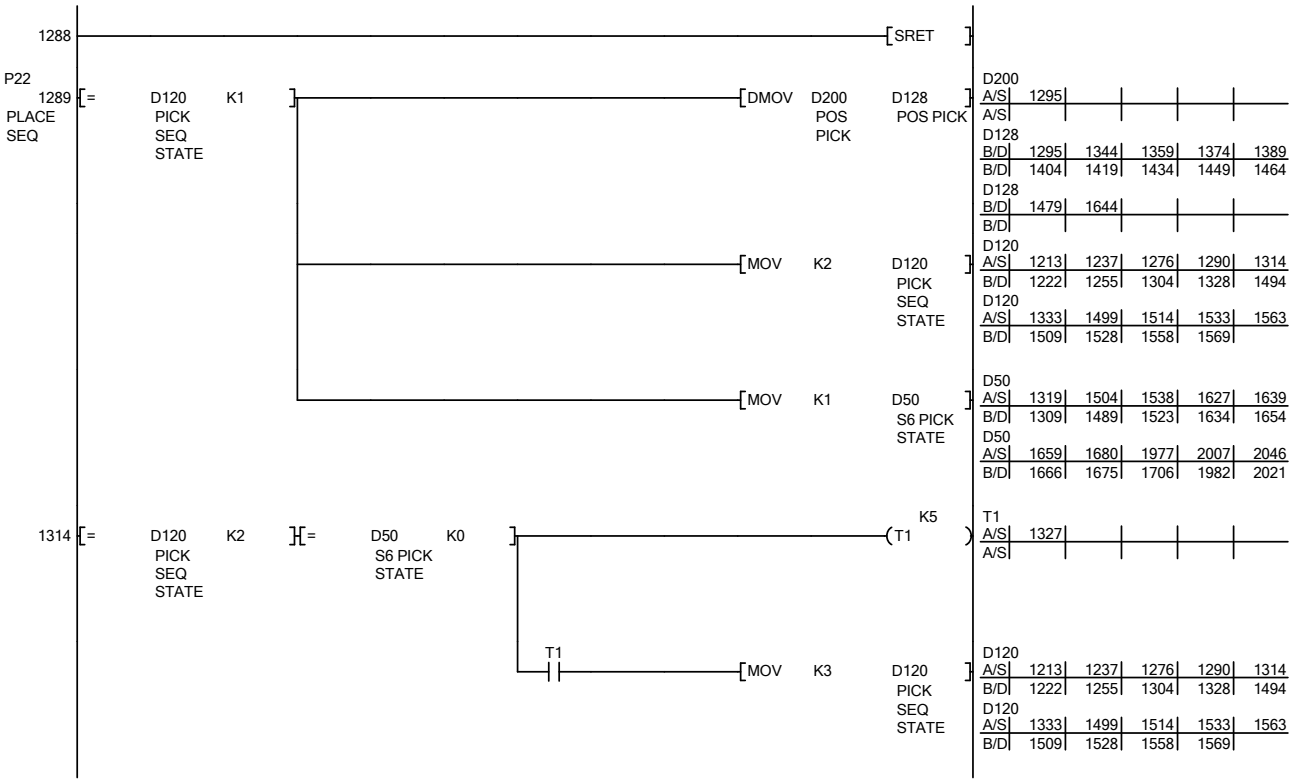

1003 [= D30 K31 S3 ROUTER STATE
[MOV K5 D13 STATE RIGHT
[MOV K1 D20 S3 STATE
[MOV K1 D21 S3 ROUTE
[MOV K2 D22 S3 WAIT STATE
[MOV K3 D30 S3 ROUTER STATE
[MOV K31 D100 TEMP0
D13 A/S 282 293 320 336 350 B/D 39 288 310 331 345
D13 A/S 586 602 613 B/D 366 703 733 1008 1043
D13 A/S B/D 1078
D20 A/S 373 411 423 435 447 B/D 139 384 395 406 418
D20 A/S 565 633 B/D 430 442 457 708 738
D20 A/S B/D 768 848 883 923 1013
D20 A/S B/D 1048 1083
D21 A/S 379 390 401 B/D 713 743 773 853 888
D21 A/S B/D 928 1018 1053 1088
D22 A/S 452 524 536 547 B/D 148 531 542 553 723
D22 A/S B/D 753 783 858 898 938
D22 A/S B/D 1023 1058 1093
D30 A/S 560 575 628 643 693 B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873 B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073 B/D 748 778 803 818 833
D30 A/S B/D 863 893 903 933 943
D30 A/S B/D 968 983 998 1028 1063
D30 A/S B/D 1098
D100 B/D 868 908 948 1033 1068 B/D 1103

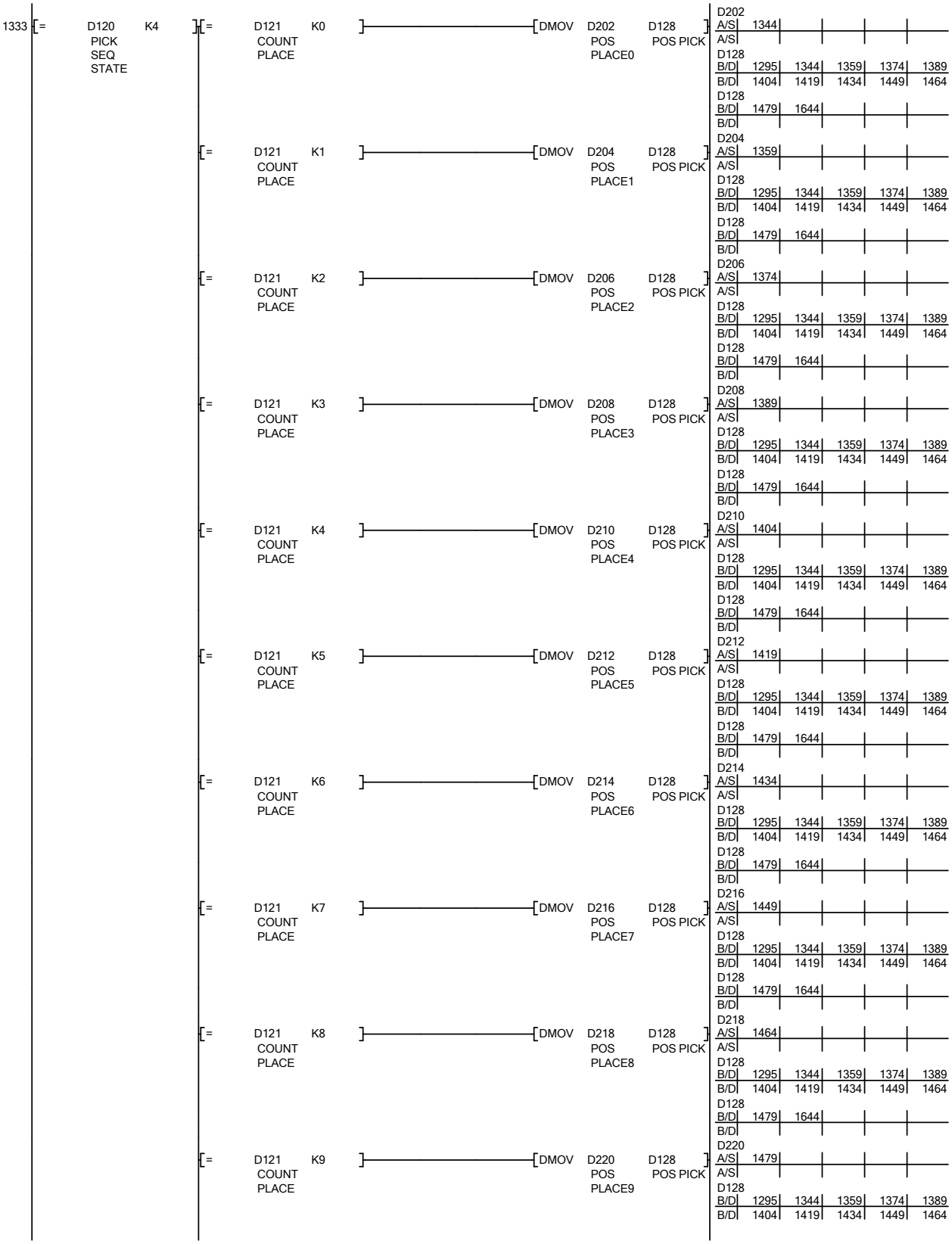

1038 [= D30 K32 S3 ROUTER STATE
[MOV K5 D13 STATE RIGHT
[MOV K1 D20 S3 STATE
[MOV K0 D21 S3 ROUTE
[MOV K3 D22 S3 WAIT STATE
[MOV K3 D30 S3 ROUTER STATE
[MOV K32 D100 TEMP0
D13 A/S 282 293 320 336 350
B/D 39 288 310 331 345
D13 A/S 586 602 613
B/D 366 703 733 1008 1043
D13 A/S
B/D 1078
D20 A/S 373 411 423 435 447
B/D 139 384 395 406 418
D20 A/S 565 633
B/D 430 442 457 708 738
D20 A/S
B/D 768 848 883 923 1013
D20 A/S
B/D 1048 1083
D21 A/S 379 390 401
B/D 713 743 773 853 888
D21 A/S
B/D 928 1018 1053 1088
D22 A/S 452 524 536 547
B/D 148 531 542 553 723
D22 A/S
B/D 753 783 858 898 938
D22 A/S
B/D 1023 1058 1093
D30 A/S 560 575 628 643 693
B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873
B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073
B/D 748 778 803 818 833
D30 A/S
B/D 863 893 903 933 943
D30 A/S
B/D 968 983 998 1028 1063
D30 A/S
B/D 1098
D100 B/D 868 908 948 1033 1068
B/D 1103

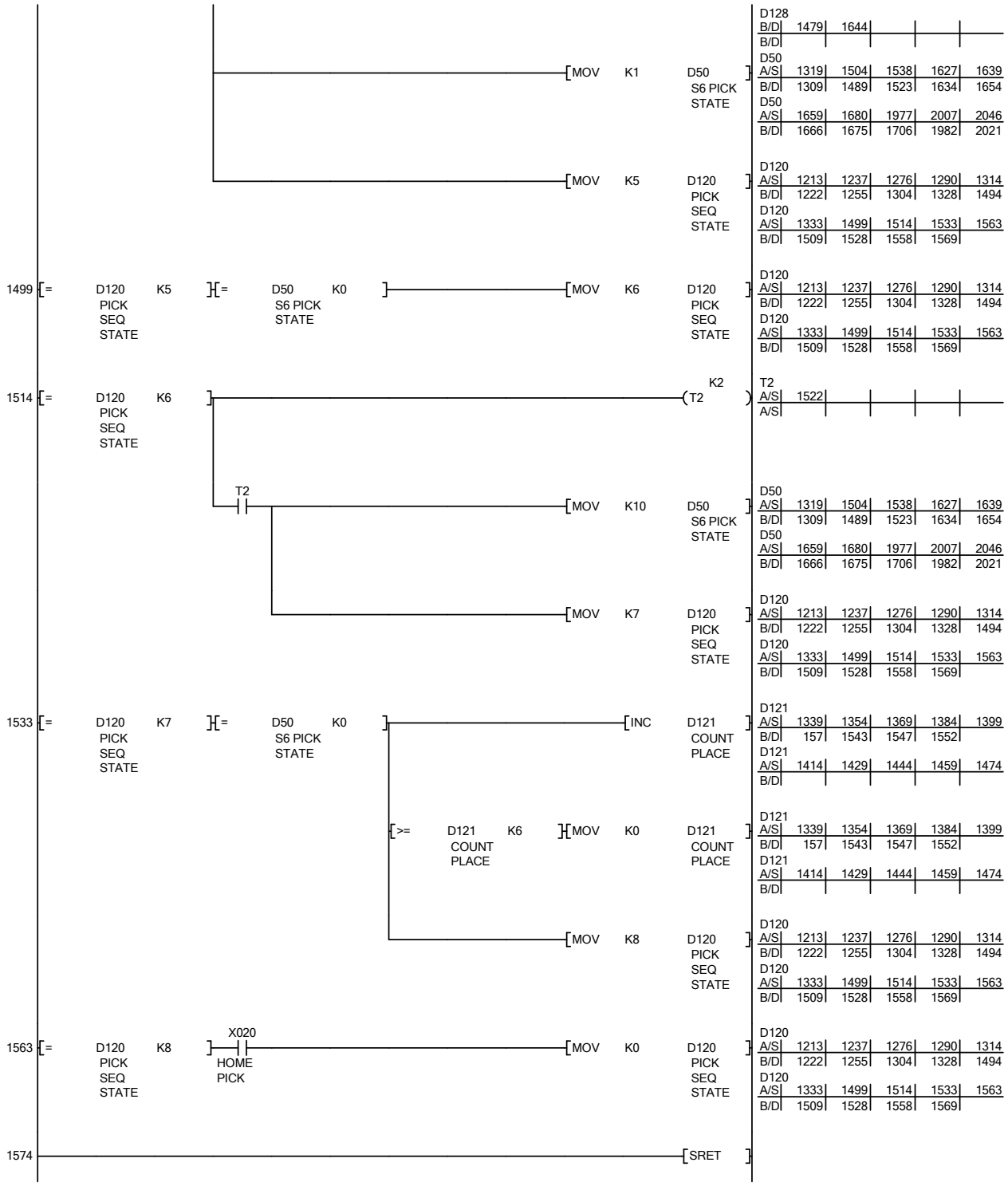

1073 [= D30 K33 S3 ROUTER STATE
[MOV K5 D13 STATE RIGHT]
[MOV K1 D20 S3 STATE]
[MOV K0 D21 S3 ROUTE]
[MOV K2 D22 S3 WAIT STATE]
[MOV K3 D30 S3 ROUTER STATE]
[MOV K33 D100 TEMP0]
D13 A/S 282 293 320 336 350 B/D 39 288 310 331 345
D13 A/S 586 602 613 B/D 366 703 733 1008 1043
D13 A/S B/D 1078
D20 A/S 373 411 423 435 447 B/D 139 384 395 406 418
D20 A/S 565 633 B/D 430 442 457 708 738
D20 A/S B/D 768 848 883 923 1013
D20 A/S B/D 1048 1083
D21 A/S 379 390 401 B/D 713 743 773 853 888
D21 A/S B/D 928 1018 1053 1088
D22 A/S 452 524 536 547 B/D 148 531 542 553 723
D22 A/S B/D 753 783 858 898 938
D22 A/S B/D 1023 1058 1093
D30 A/S 560 575 628 643 693 B/D 44 570 591 607 623
D30 A/S 728 758 788 838 873 B/D 638 658 673 688 718
D30 A/S 913 953 1003 1038 1073 B/D 748 778 803 818 833
D30 A/S B/D 863 893 903 933 943
D30 A/S B/D 968 983 998 1028 1063
D30 A/S B/D 1098
D100 B/D 868 908 948 1033 1068 B/D 1103
1108 [SRET]
P20
1109 TRANS MSTSEQ [= D110 K1 TRANS SEQ STATE]
X020 HOME PICK
[= D111 K0 PLACE SEQ STATE]
[SET Y011 S6 CYC TRANS]
[MOV K2 D110 TRANS SEQ STATE]
Y011 A/S 1121 B/D 1168
D110 A/S 1110 1127 1138 1158 1184 B/D 1122 1133 1153 1174 1201
1127 [= D110 K2 TRANS SEQ STATE]
X017 S6 CYC TRANS DOWN
[MOV K3 D110 TRANS SEQ STATE]
D110 A/S 1110 1127 1138 1158 1184 B/D 1122 1133 1153 1174 1201

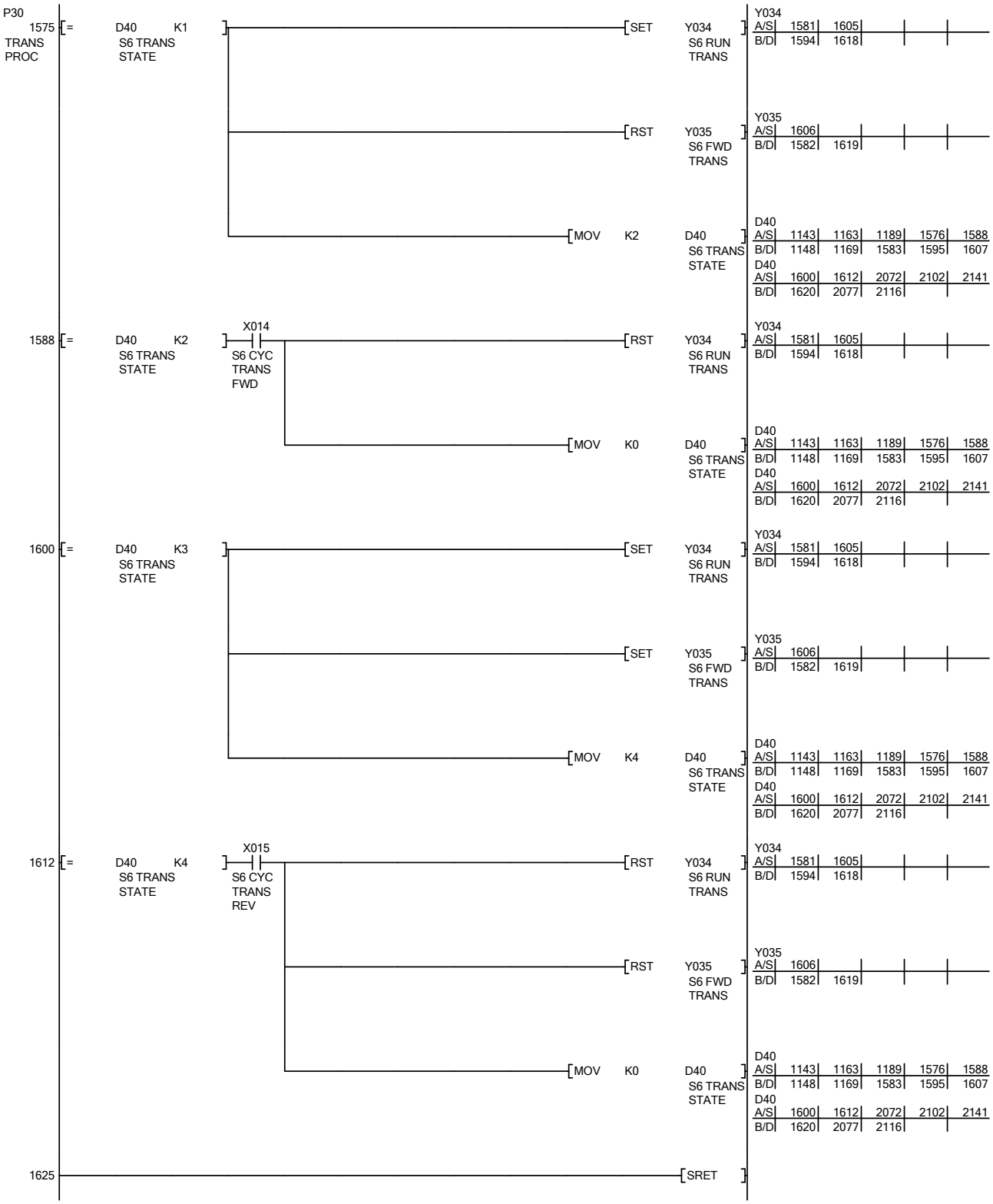

1138
= D110 K3 TRANS SEQ STATE
= D40 K0 S6 TRANS STATE
MOV K1 D40 S6 TRANS STATE
MOV K4 D110 TRANS SEQ STATE
D40 A/S 1143 1163 1189 1576 1588 B/D 1148 1169 1583 1595 1607
D40 A/S 1600 1612 2072 2102 2141 B/D 1620 2077 2116
D110 A/S 1110 1127 1138 1158 1184 B/D 1122 1133 1153 1174 1201
1158
= D110 K4 TRANS SEQ STATE
= D40 K0 S6 TRANS STATE
RST Y011 S6 CYC TRANS
MOV K3 D40 S6 TRANS STATE
MOV K5 D110 TRANS SEQ STATE
MOV K1 D111 PLACE SEQ STATE
Y011 A/S 1121 B/D 1168
D40 A/S 1143 1163 1189 1576 1588 B/D 1148 1169 1583 1595 1607
D40 A/S 1600 1612 2072 2102 2141 B/D 1620 2077 2116
D110 A/S 1110 1127 1138 1158 1184 B/D 1122 1133 1153 1174 1201
D111 A/S 1116 1208 1232 1248 1270 B/D 1179 1227 1243 1260 1265
D111 A/S B/D 1283
1184
= D110 K5 TRANS SEQ STATE
= D40 K0 S6 TRANS STATE
K10 T5
T5 A/S 1198 A/S
X016 S6 CYC TRANS UP
X017 S6 CYC TRANS DOWN
T5
MOV K0 D110 TRANS SEQ STATE
D110 A/S 1110 1127 1138 1158 1184 B/D 1122 1133 1153 1174 1201
1206
SRET

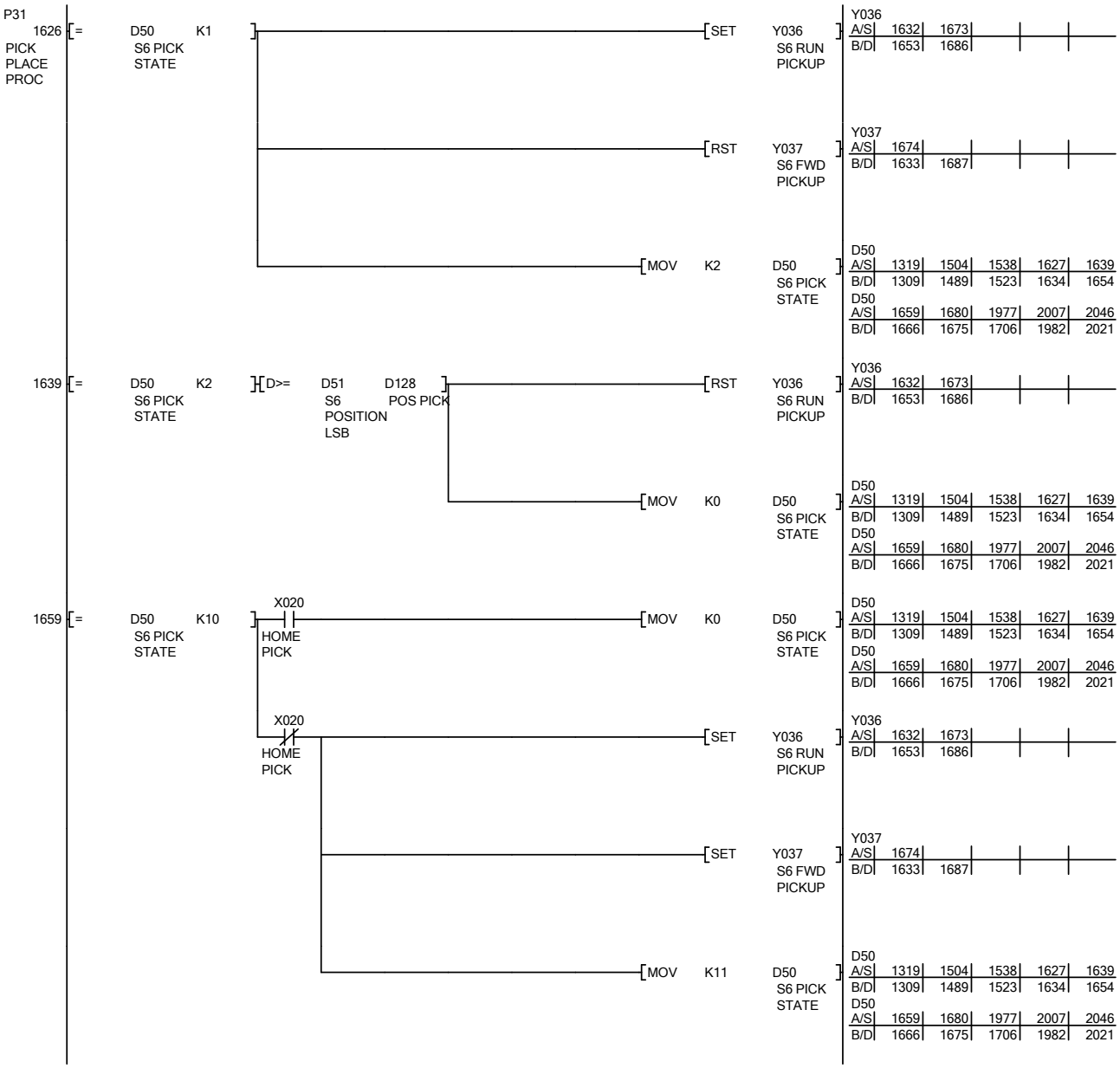

P21
1207
PICKPLAC MSTSEQ
= D111 PLACE SEQ STATE K1
= D120 PICK SEQ STATE K0
X022 S6 PICK RDY
SET Y044 VACCUM 0
SET Y045 VACCUM 1
SET Y046 VACCUM 2
MOV K1 D120 PICK SEQ STATE
MOV K2 D111 PLACE SEQ STATE
Y044 A/S 1219
Y045 A/S 1220
Y046 A/S 1221
D120 A/S 1213 1237 1276 1290 1314 B/D 1222 1255 1304 1328 1494
D120 A/S 1333 1499 1514 1533 1563 B/D 1509 1528 1558 1569
D111 A/S 1116 1208 1232 1248 1270 B/D 1179 1227 1243 1260 1265
D111 A/S B/D 1283
1232
= D111 PLACE SEQ STATE K2
= D120 PICK SEQ STATE K3
SET Y012 COVER PICKPLAC
MOV K3 D111 PLACE SEQ STATE
Y012 A/S 1242 B/D 1281
1248
= D111 PLACE SEQ STATE K3
X023 FLAP CARTON OPEN
X021 S6 PLACE RDY
MOV K4 D120 PICK SEQ STATE
MOV K3 D111 PLACE SEQ STATE
MOV K4 D111 PLACE SEQ STATE
1270
= D111 PLACE SEQ STATE K4
X020 HOME PICK
= D120 PICK SEQ STATE K0
RST Y012 COVER PICKPLAC
X022 S6 PICK RDY
MOV K0 D111 PLACE SEQ STATE

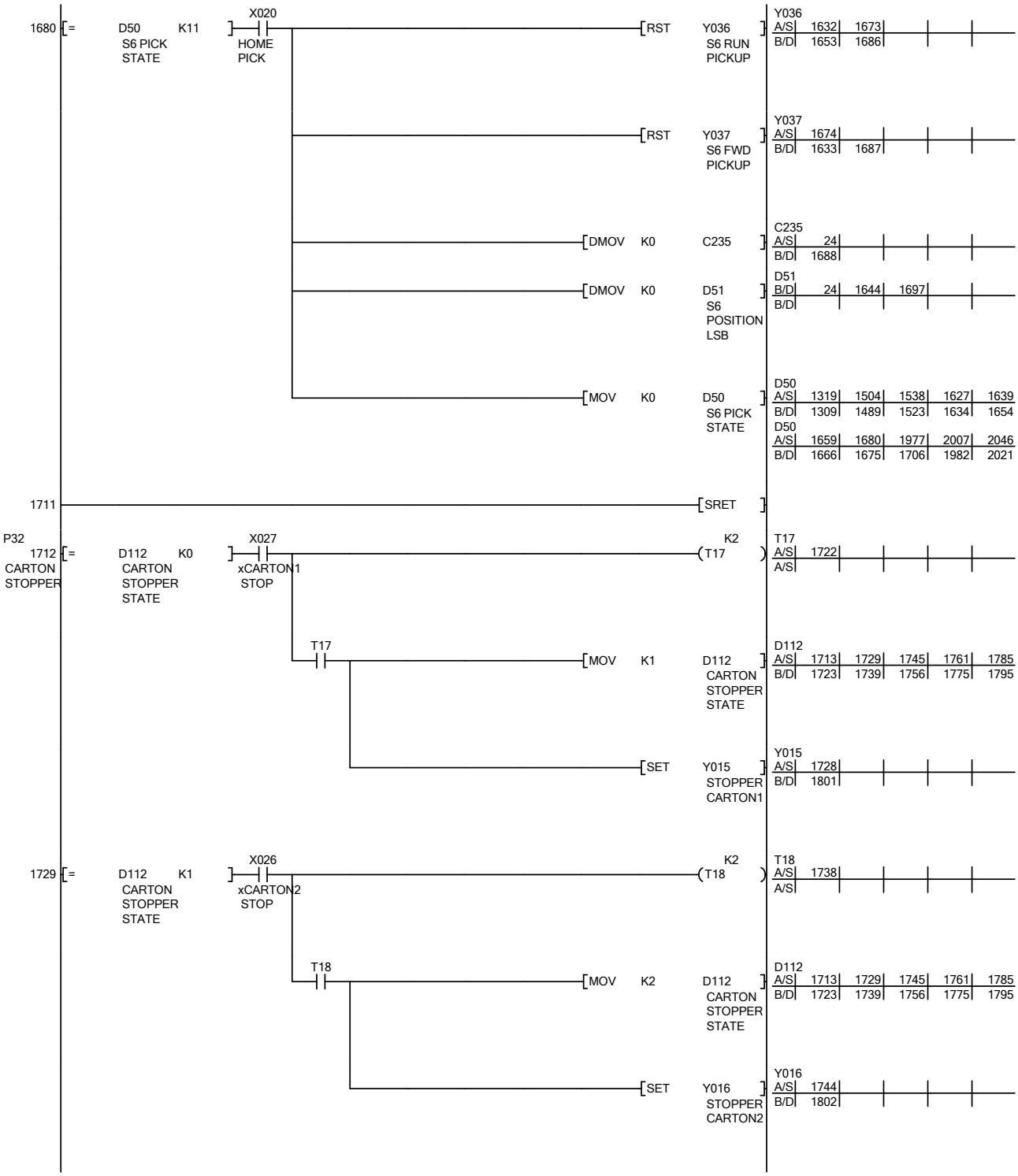

1288
SRET
P22
1289
PLACE SEQ
= D120 PICK SEQ STATE K1
DMOV D200 POS PICK D128 POS PICK
MOV K2 D120 PICK SEQ STATE
MOV K1 D50 S6 PICK STATE
1314
= D120 PICK SEQ STATE K2
= D50 S6 PICK STATE K0
K5 T1
T1
MOV K3 D120 PICK SEQ STATE
D200 A/S 1295
D128 B/D 1295 1344 1359 1374 1389 1404 1419 1434 1449 1464
D128 B/D 1479 1644
D120 A/S 1213 1237 1276 1290 1314 B/D 1222 1255 1304 1328 1494
D120 A/S 1333 1499 1514 1533 1563 B/D 1509 1528 1558 1569
D50 A/S 1319 1504 1538 1627 1639 B/D 1309 1489 1523 1634 1654
D50 A/S 1659 1680 1977 2007 2046 B/D 1666 1675 1706 1982 2021
T1 A/S 1327
D120 A/S 1213 1237 1276 1290 1314 B/D 1222 1255 1304 1328 1494
D120 A/S 1333 1499 1514 1533 1563 B/D 1509 1528 1558 1569

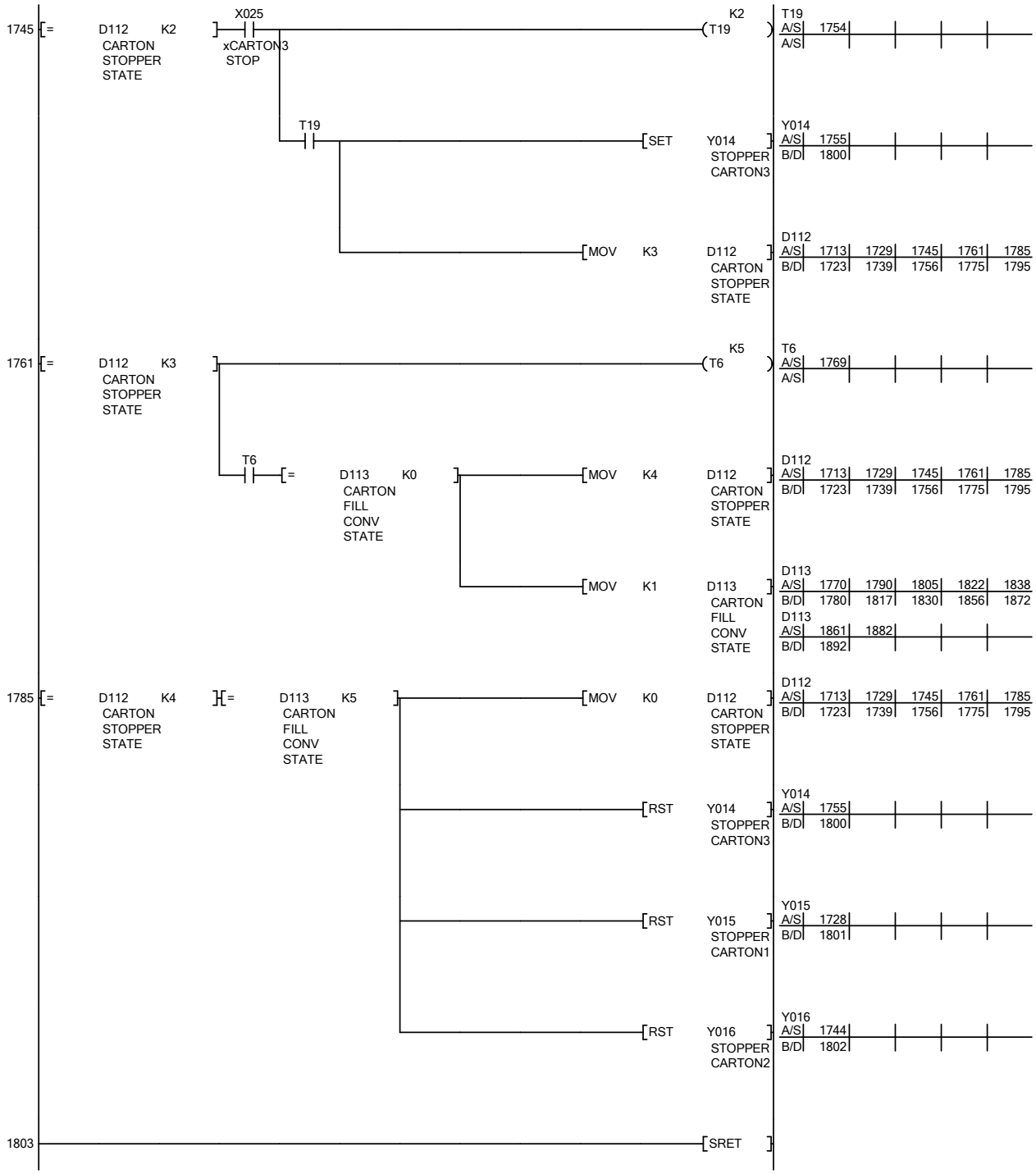

1333
[= D120 K4]
PICK SEQ STATE
[= D121 K0] [DMOV D202 D128]
[= D121 K1] [DMOV D204 D128]
[= D121 K2] [DMOV D206 D128]
[= D121 K3] [DMOV D208 D128]
[= D121 K4] [DMOV D210 D128]
[= D121 K5] [DMOV D212 D128]
[= D121 K6] [DMOV D214 D128]
[= D121 K7] [DMOV D216 D128]
[= D121 K8] [DMOV D218 D128]
[= D121 K9] [DMOV D220 D128]
COUNT PLACE
POS PLACE0
POS PLACE1
POS PLACE2
POS PLACE3
POS PLACE4
POS PLACE5
POS PLACE6
POS PLACE7
POS PLACE8
POS PLACE9
POS PICK
D202 A/S 1344
D204 A/S 1359
D206 A/S 1374
D208 A/S 1389
D210 A/S 1404
D212 A/S 1419
D214 A/S 1434
D216 A/S 1449
D218 A/S 1464
D220 A/S 1479
D128 B/D 1295 1344 1359 1374 1389 1404 1419 1434 1449 1464 1479 1644

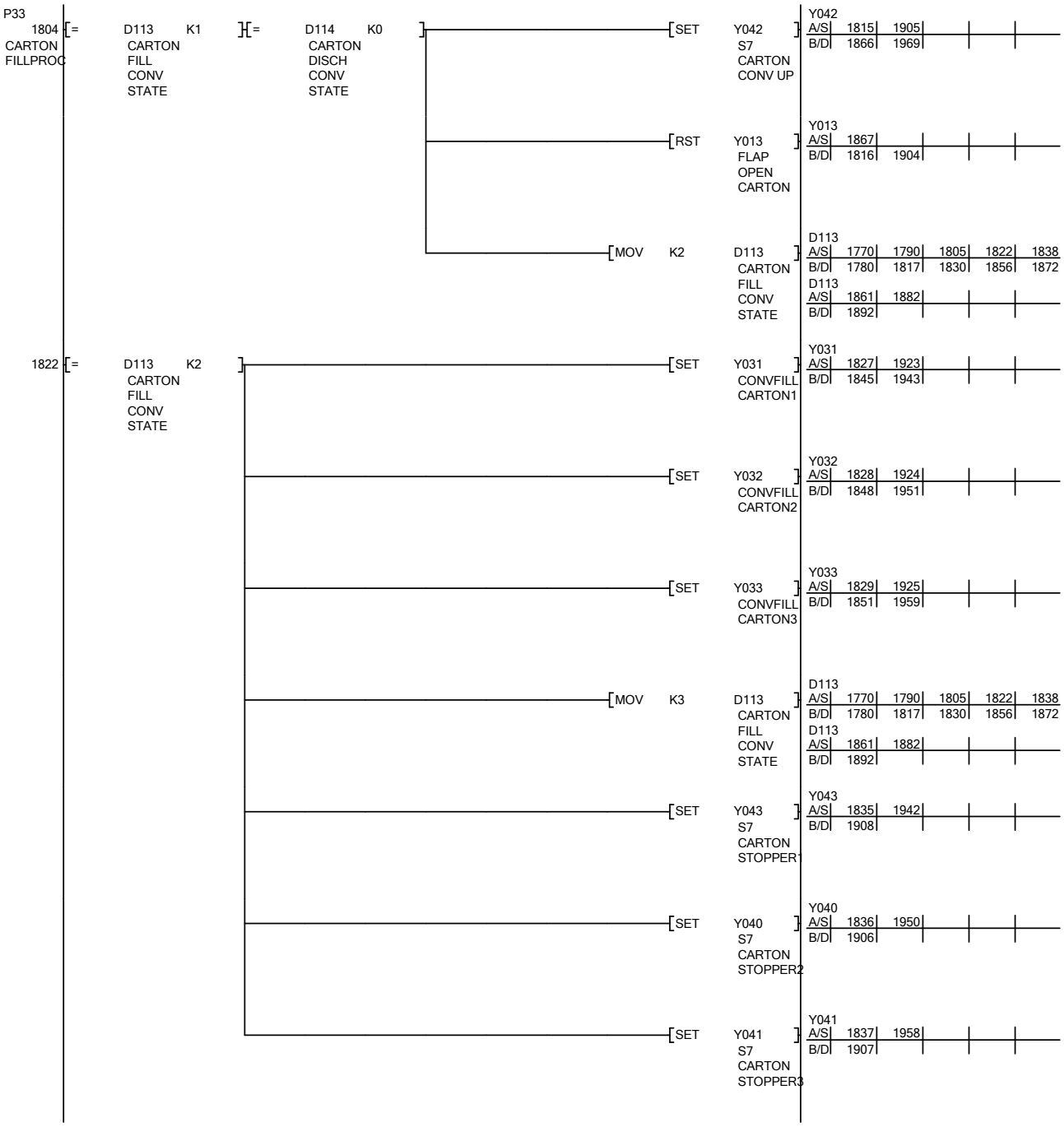

MOV K1 D50 S6 PICK STATE
MOV K5 D120 PICK SEQ STATE
1499 = D120 PICK SEQ STATE K5 = D50 S6 PICK STATE K0
MOV K6 D120 PICK SEQ STATE
1514 = D120 PICK SEQ STATE K6
K2 T2
T2
MOV K10 D50 S6 PICK STATE
MOV K7 D120 PICK SEQ STATE
1533 = D120 PICK SEQ STATE K7 = D50 S6 PICK STATE K0
INC D121 COUNT PLACE
>= D121 COUNT PLACE K6
MOV K0 D121 COUNT PLACE
MOV K8 D120 PICK SEQ STATE
1563 = D120 PICK SEQ STATE K8
X020 HOME PICK
MOV K0 D120 PICK SEQ STATE
1574
SRET

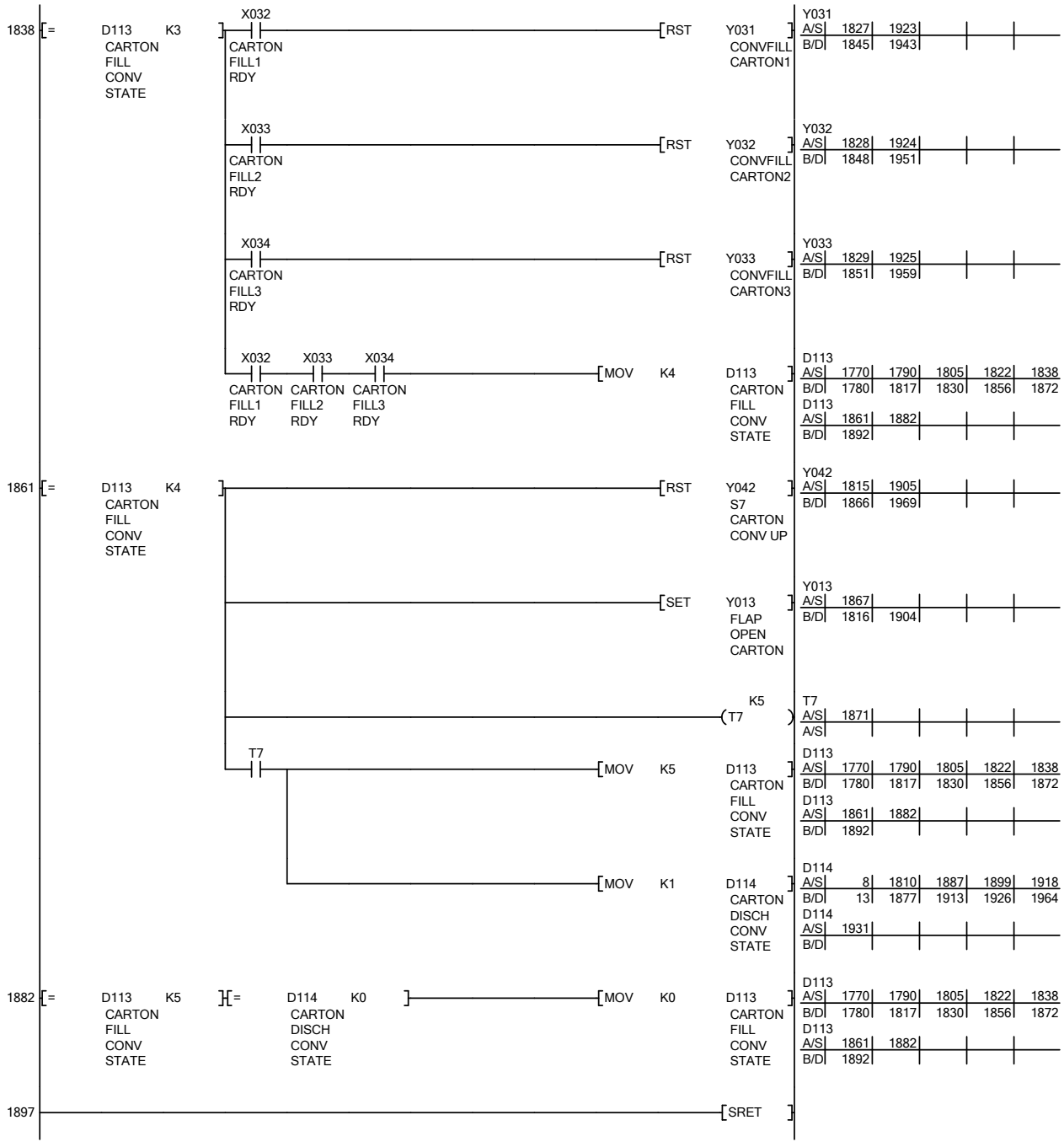

P30
1575
TRANS PROC
= D40 K1
S6 TRANS STATE
SET Y034
S6 RUN TRANS
Y034 A/S 1581 1605 B/D 1594 1618
RST Y035
S6 FWD TRANS
Y035 A/S 1606 B/D 1582 1619
MOV K2 D40
S6 TRANS STATE
D40 A/S 1143 1163 1189 1576 1588 B/D 1148 1169 1583 1595 1607
D40 A/S 1600 1612 2072 2102 2141 B/D 1620 2077 2116
1588
= D40 K2
S6 TRANS STATE
X014
S6 CYC TRANS FWD
RST Y034
S6 RUN TRANS
MOV K0 D40
S6 TRANS STATE
1600
= D40 K3
S6 TRANS STATE
SET Y034
S6 RUN TRANS
SET Y035
S6 FWD TRANS
MOV K4 D40
S6 TRANS STATE
1612
= D40 K4
S6 TRANS STATE
X015
S6 CYC TRANS REV
RST Y034
S6 RUN TRANS
RST Y035
S6 FWD TRANS
MOV K0 D40
S6 TRANS STATE
1625
SRET

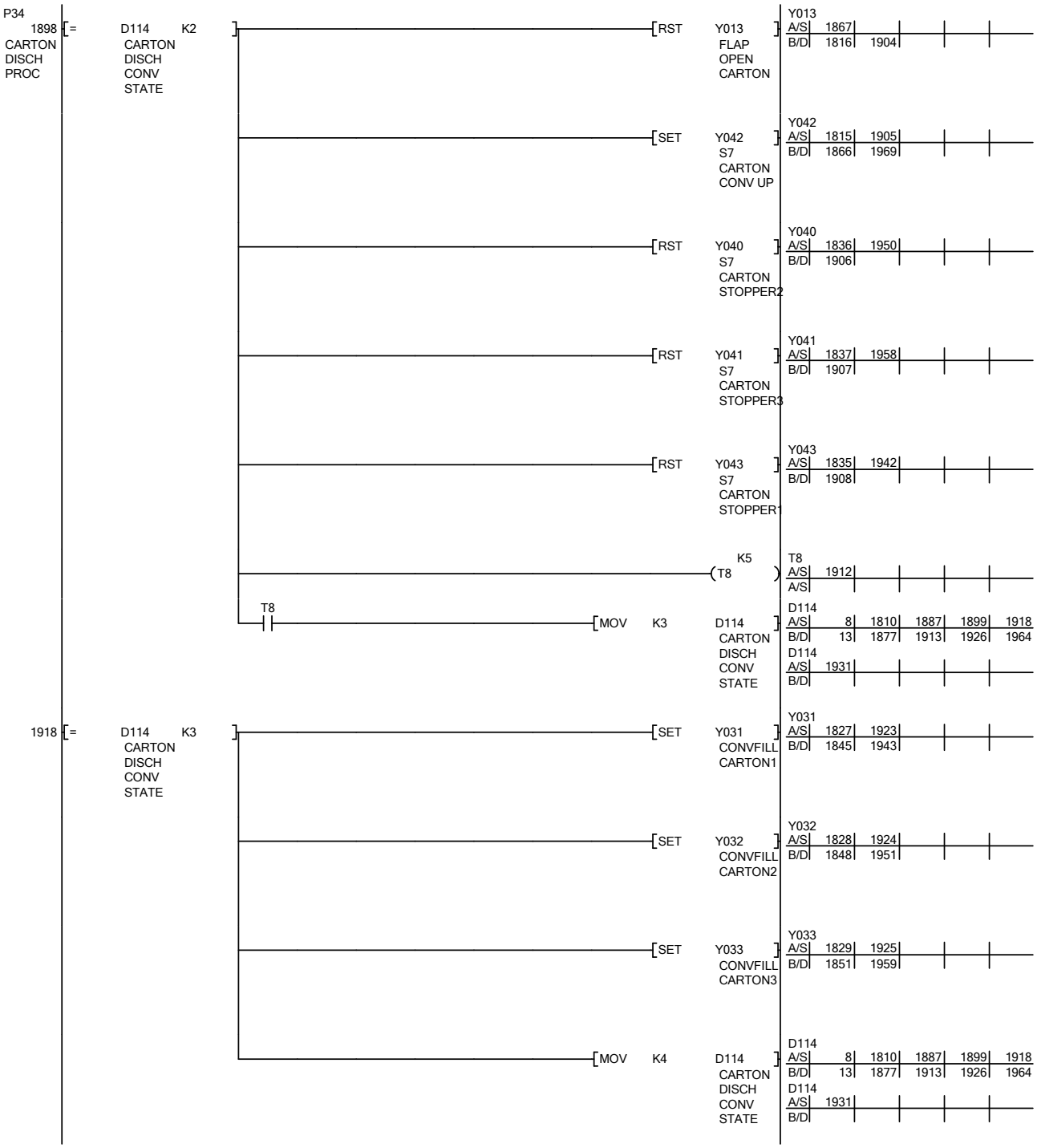

P31
1626
PICK PLACE PROC
= D50 S6 PICK STATE K1
SET Y036 S6 RUN PICKUP
RST Y037 S6 FWD PICKUP
MOV K2 D50 S6 PICK STATE
1639
= D50 S6 PICK STATE K2
D>= D51 S6 POSITION LSB D128 POS PICK
RST Y036 S6 RUN PICKUP
MOV K0 D50 S6 PICK STATE
1659
= D50 S6 PICK STATE K10
X020 HOME PICK
MOV K0 D50 S6 PICK STATE
X020 HOME PICK
SET Y036 S6 RUN PICKUP
SET Y037 S6 FWD PICKUP
MOV K11 D50 S6 PICK STATE
Y036 A/S 1632 1673 B/D 1653 1686
Y037 A/S 1674 B/D 1633 1687
D50 A/S 1319 1504 1538 1627 1639 B/D 1309 1489 1523 1634 1654
D50 A/S 1659 1680 1977 2007 2046 B/D 1666 1675 1706 1982 2021

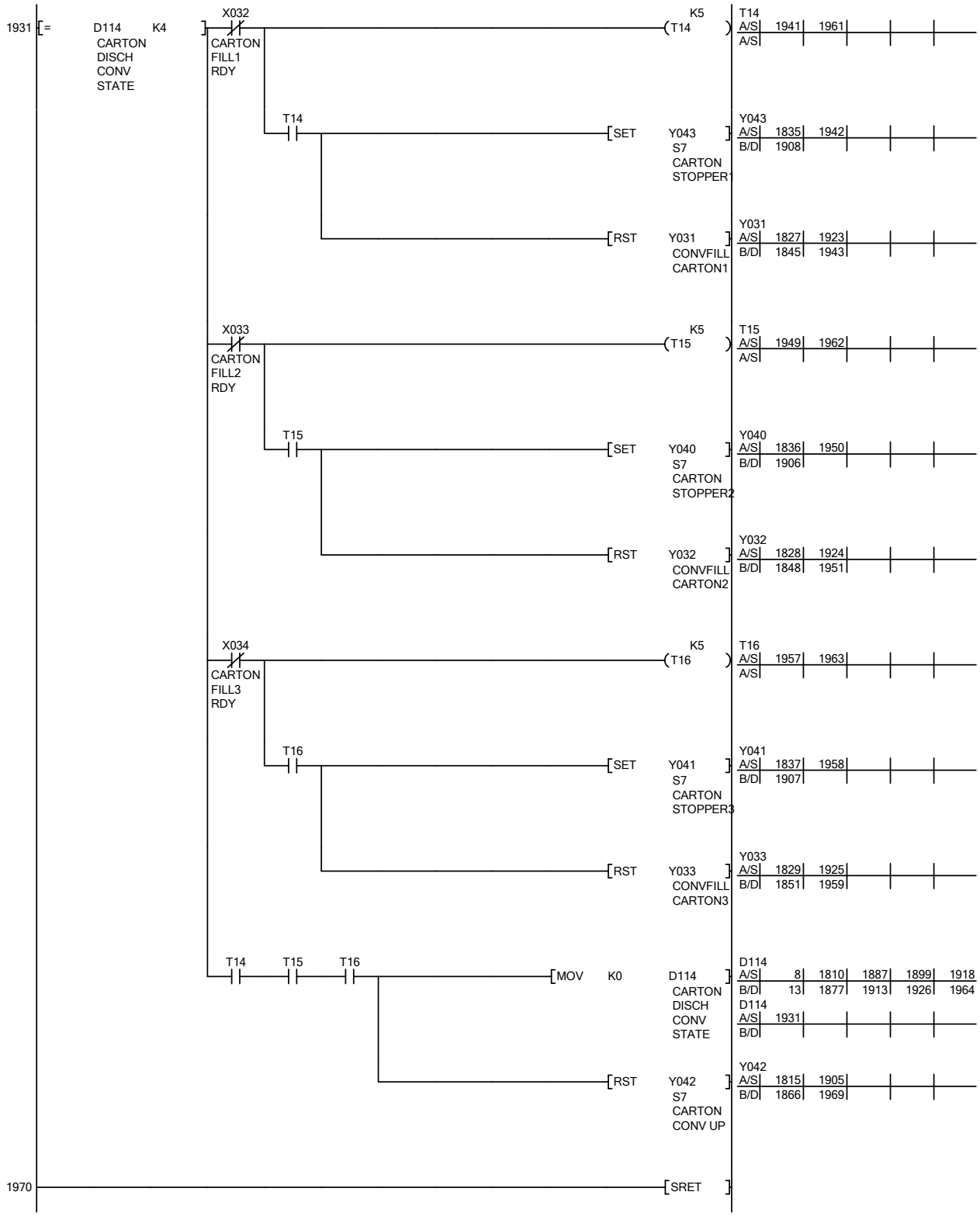

1680
[=
D50
S6 PICK
STATE
K11
X020
HOME
PICK
[RST
Y036
S6 RUN
PICKUP
Y036
A/S 1632 1673
B/D 1653 1686
[RST
Y037
S6 FWD
PICKUP
Y037
A/S 1674
B/D 1633 1687
[DMOV K0 C235
C235
A/S 24
B/D 1688
[DMOV K0 D51
S6
POSITION
LSB
D51
B/D 24 1644 1697
[MOV K0 D50
S6 PICK
STATE
D50
A/S 1319 1504 1538 1627 1639
B/D 1309 1489 1523 1634 1654
D50
A/S 1659 1680 1977 2007 2046
B/D 1666 1675 1706 1982 2021
1711
[SRET
P32
1712
[=
CARTON
STOPPER
D112
CARTON
STOPPER
STATE
K0
X027
xCARTON1
STOP
K2
(T17
T17
A/S 1722
A/S
T17
MOV K1
D112
CARTON
STOPPER
STATE
D112
A/S 1713 1729 1745 1761 1785
B/D 1723 1739 1756 1775 1795
[SET
Y015
STOPPER
CARTON1
Y015
A/S 1728
B/D 1801
1729
[=
D112
CARTON
STOPPER
STATE
K1
X026
xCARTON2
STOP
K2
(T18
T18
A/S 1738
A/S
T18
MOV K2
D112
CARTON
STOPPER
STATE
D112
A/S 1713 1729 1745 1761 1785
B/D 1723 1739 1756 1775 1795
[SET
Y016
STOPPER
CARTON2
Y016
A/S 1744
B/D 1802

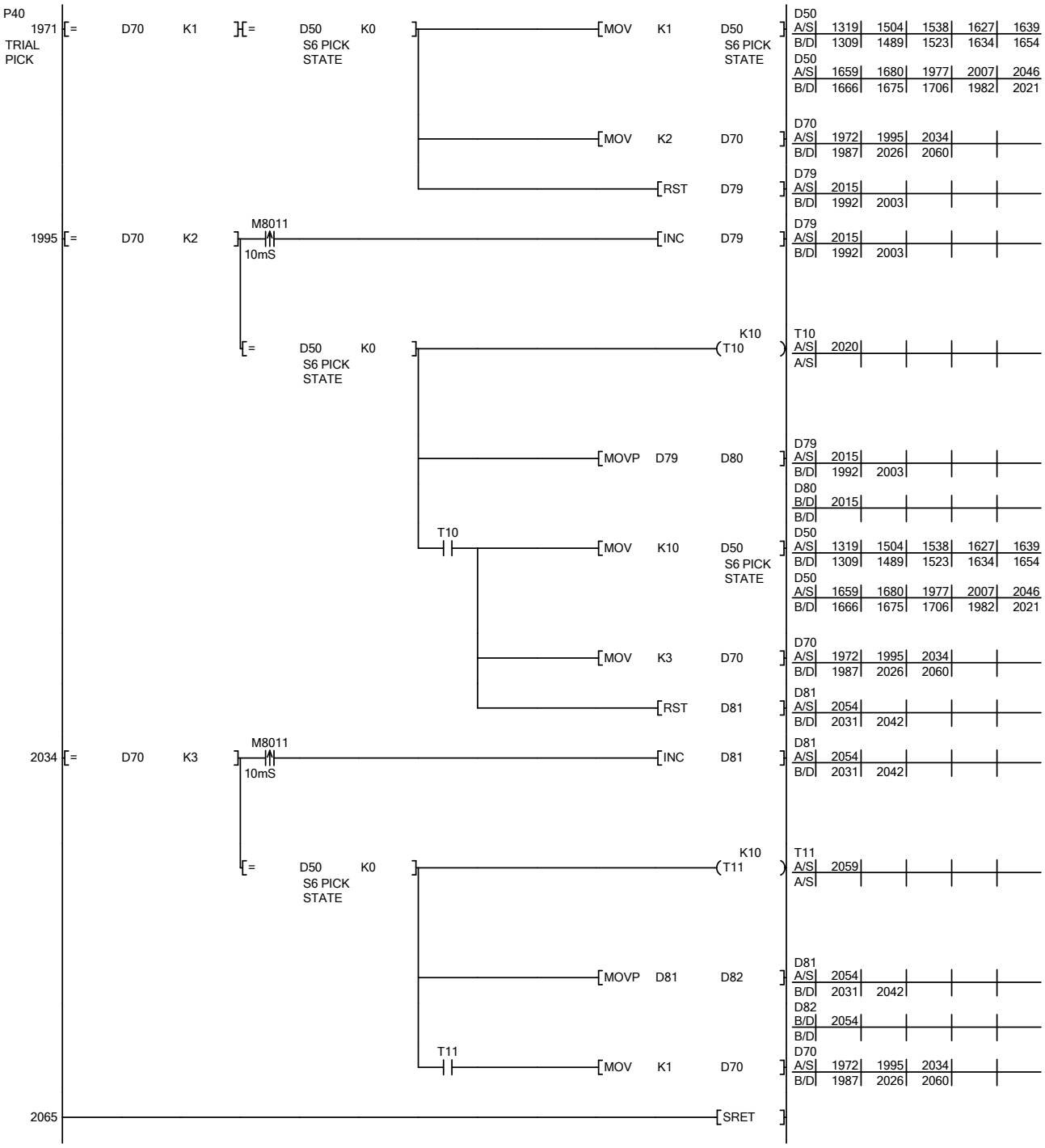

1745
=
D112 K2
CARTON STOPPER STATE
X025
xCARTON3 STOP
K2
T19
T19
A/S 1754
A/S
T19
SET
Y014
STOPPER CARTON3
Y014
A/S 1755
B/D 1800
MOV K3
D112
CARTON STOPPER STATE
D112
A/S 1713 1729 1745 1761 1785
B/D 1723 1739 1756 1775 1795
1761
=
D112 K3
CARTON STOPPER STATE
K5
T6
T6
A/S 1769
A/S
T6
=
D113 K0
CARTON FILL CONV STATE
MOV K4
D112
CARTON STOPPER STATE
D112
A/S 1713 1729 1745 1761 1785
B/D 1723 1739 1756 1775 1795
MOV K1
D113
CARTON FILL CONV STATE
D113
A/S 1770 1790 1805 1822 1838
B/D 1780 1817 1830 1856 1872
D113
A/S 1861 1882
B/D 1892
1785
=
D112 K4
CARTON STOPPER STATE
=
D113 K5
CARTON FILL CONV STATE
MOV K0
D112
CARTON STOPPER STATE
D112
A/S 1713 1729 1745 1761 1785
B/D 1723 1739 1756 1775 1795
RST
Y014
STOPPER CARTON3
Y014
A/S 1755
B/D 1800
RST
Y015
STOPPER CARTON1
Y015
A/S 1728
B/D 1801
RST
Y016
STOPPER CARTON2
Y016
A/S 1744
B/D 1802
1803
SRET

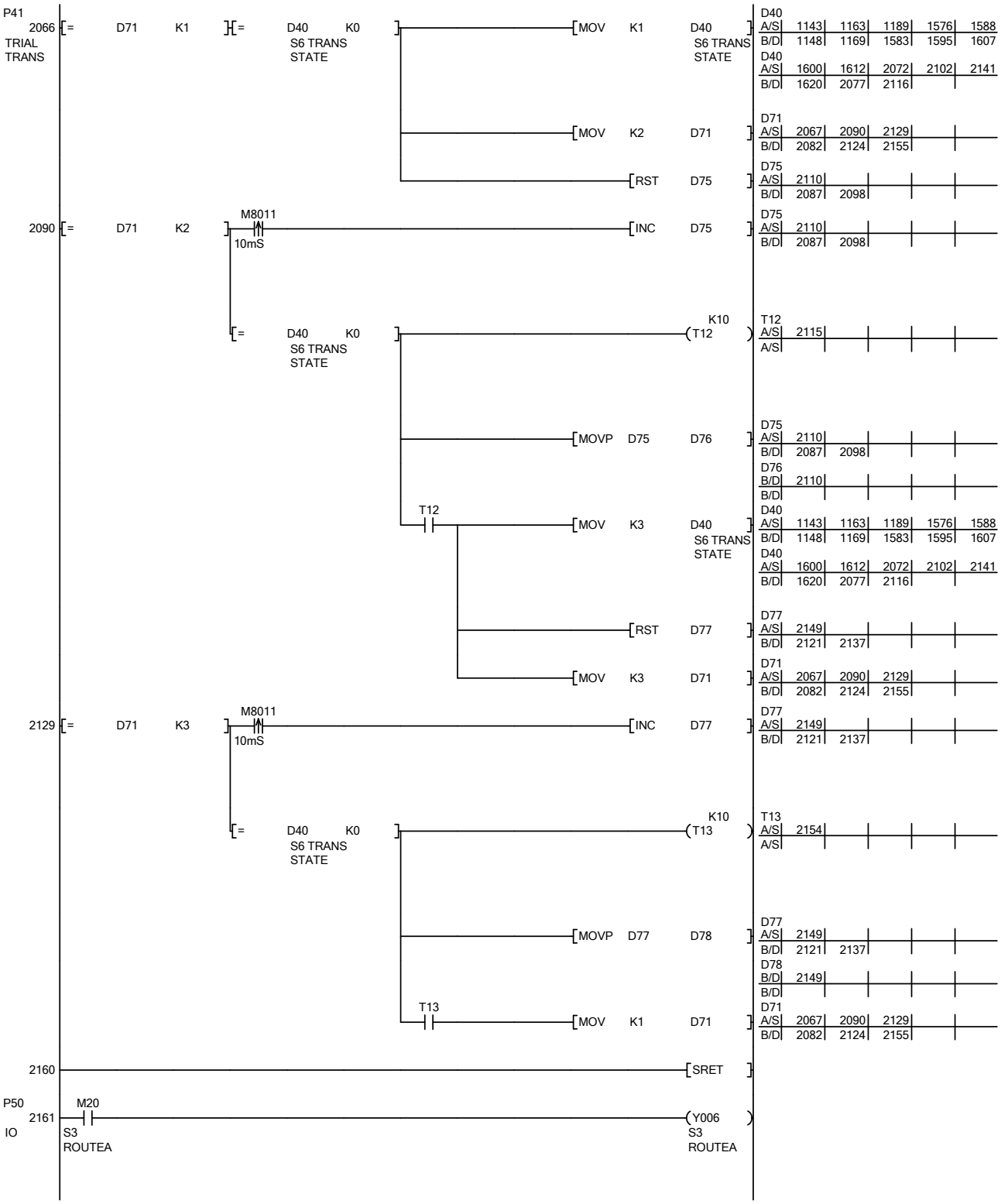

P33
1804
CARTON FILLPROC
= D113 K1
CARTON FILL CONV STATE
= D114 K0
CARTON DISCH CONV STATE
SET Y042
S7 CARTON CONV UP
Y042
A/S 1815 1905
B/D 1866 1969
RST Y013
FLAP OPEN CARTON
Y013
A/S 1867
B/D 1816 1904
MOV K2
D113
CARTON FILL CONV STATE
D113
A/S 1770 1790 1805 1822 1838
B/D 1780 1817 1830 1856 1872
D113
A/S 1861 1882
B/D 1892
1822
= D113 K2
CARTON FILL CONV STATE
SET Y031
CONVFILL CARTON1
Y031
A/S 1827 1923
B/D 1845 1943
SET Y032
CONVFILL CARTON2
Y032
A/S 1828 1924
B/D 1848 1951
SET Y033
CONVFILL CARTON3
Y033
A/S 1829 1925
B/D 1851 1959
MOV K3
D113
CARTON FILL CONV STATE
D113
A/S 1770 1790 1805 1822 1838
B/D 1780 1817 1830 1856 1872
D113
A/S 1861 1882
B/D 1892
SET Y043
S7 CARTON STOPPER1
Y043
A/S 1835 1942
B/D 1908
SET Y040
S7 CARTON STOPPER2
Y040
A/S 1836 1950
B/D 1906
SET Y041
S7 CARTON STOPPER3
Y041
A/S 1837 1958
B/D 1907

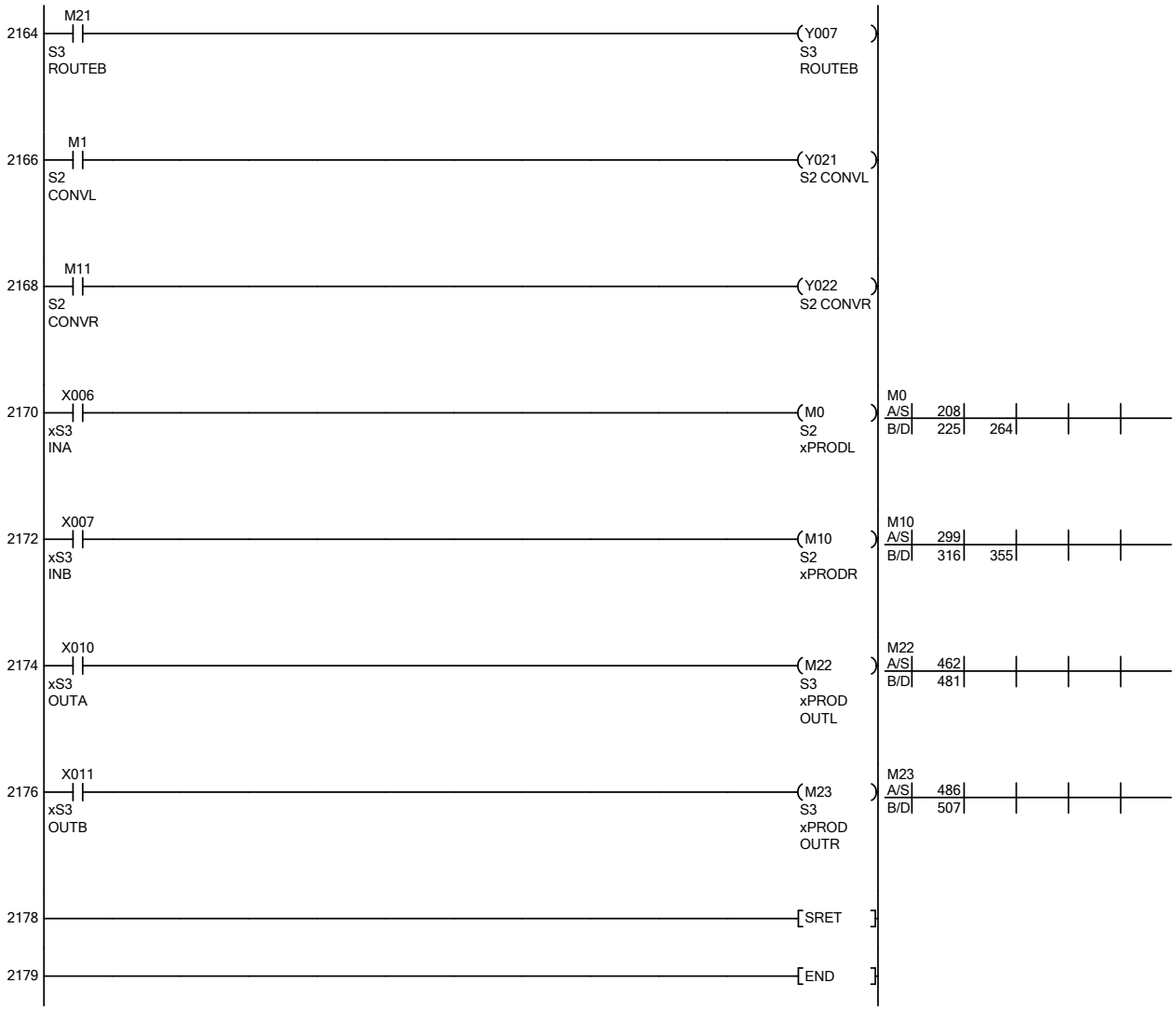

1838
[=
D113
K3
CARTON
FILL
CONV
STATE
X032
CARTON
FILL1
RDY
[RST
Y031
CONVFILL
CARTON1
Y031
A/S 1827 1923
B/D 1845 1943
X033
CARTON
FILL2
RDY
[RST
Y032
CONVFILL
CARTON2
Y032
A/S 1828 1924
B/D 1848 1951
X034
CARTON
FILL3
RDY
[RST
Y033
CONVFILL
CARTON3
Y033
A/S 1829 1925
B/D 1851 1959
X032
X033
X034
CARTON
FILL1
RDY
CARTON
FILL2
RDY
CARTON
FILL3
RDY
[MOV
K4
D113
CARTON
FILL
CONV
STATE
D113
A/S 1770 1790 1805 1822 1838
B/D 1780 1817 1830 1856 1872
D113
A/S 1861 1882
B/D 1892
1861
[=
D113
K4
CARTON
FILL
CONV
STATE
[RST
Y042
S7
CARTON
CONV UP
Y042
A/S 1815 1905
B/D 1866 1969
[SET
Y013
FLAP
OPEN
CARTON
Y013
A/S 1867
B/D 1816 1904
K5
(T7
T7
A/S 1871
A/S
T7
[MOV
K5
D113
CARTON
FILL
CONV
STATE
D113
A/S 1770 1790 1805 1822 1838
B/D 1780 1817 1830 1856 1872
D113
A/S 1861 1882
B/D 1892
[MOV
K1
D114
CARTON
DISCH
CONV
STATE
D114
A/S 8 1810 1887 1899 1918
B/D 13 1877 1913 1926 1964
D114
A/S 1931
B/D
1882
[=
D113
K5
CARTON
FILL
CONV
STATE
[=
D114
K0
CARTON
DISCH
CONV
STATE
[MOV
K0
D113
CARTON
FILL
CONV
STATE
D113
A/S 1770 1790 1805 1822 1838
B/D 1780 1817 1830 1856 1872
D113
A/S 1861 1882
B/D 1892
1897
[SRET


P34
1898
CARTON DISCH PROC
= D114 K2
CARTON DISCH CONV STATE
RST Y013
FLAP OPEN CARTON
Y013 A/S 1867 B/D 1816 1904
SET Y042
S7 CARTON CONV UP
Y042 A/S 1815 1905 B/D 1866 1969
RST Y040
S7 CARTON STOPPER2
Y040 A/S 1836 1950 B/D 1906
RST Y041
S7 CARTON STOPPER3
Y041 A/S 1837 1958 B/D 1907
RST Y043
S7 CARTON STOPPER1
Y043 A/S 1835 1942 B/D 1908
K5
T8
T8 A/S 1912 A/S
T8
MOV K3 D114
CARTON DISCH CONV STATE
D114 A/S 8 1810 1887 1899 1918 B/D 13 1877 1913 1926 1964
D114 A/S 1931 B/D
1918
= D114 K3
CARTON DISCH CONV STATE
SET Y031
CONVFILL CARTON1
Y031 A/S 1827 1923 B/D 1845 1943
SET Y032
CONVFILL CARTON2
Y032 A/S 1828 1924 B/D 1848 1951
SET Y033
CONVFILL CARTON3
Y033 A/S 1829 1925 B/D 1851 1959
MOV K4 D114
CARTON DISCH CONV STATE
D114 A/S 8 1810 1887 1899 1918 B/D 13 1877 1913 1926 1964
D114 A/S 1931 B/D


1931
[= D114 K4
CARTON DISCH CONV STATE
X032
CARTON FILL1 RDY
K5
(T14)
T14
A/S 1941 1961
A/S
T14
[SET Y043
Y043
S7 CARTON STOPPER1
A/S 1835 1942
B/D 1908
[RST Y031
Y031
CONVFILL CARTON1
A/S 1827 1923
B/D 1845 1943
X033
CARTON FILL2 RDY
K5
(T15)
T15
A/S 1949 1962
A/S
T15
[SET Y040
Y040
S7 CARTON STOPPER2
A/S 1836 1950
B/D 1906
[RST Y032
Y032
CONVFILL CARTON2
A/S 1828 1924
B/D 1848 1951
X034
CARTON FILL3 RDY
K5
(T16)
T16
A/S 1957 1963
A/S
T16
[SET Y041
Y041
S7 CARTON STOPPER3
A/S 1837 1958
B/D 1907
[RST Y033
Y033
CONVFILL CARTON3
A/S 1829 1925
B/D 1851 1959
T14 T15 T16
[MOV K0 D114
D114
CARTON DISCH CONV STATE
A/S 8 1810 1887 1899 1918
B/D 13 1877 1913 1926 1964
D114
A/S 1931
B/D
[RST Y042
Y042
S7 CARTON CONV UP
A/S 1815 1905
B/D 1866 1969
1970
[SRET]


P40
1971
TRIAL
PICK
= D70 K1
= D50 K0
S6 PICK
STATE
MOV K1 D50
S6 PICK
STATE
MOV K2 D70
RST D79
1995
= D70 K2
M8011
10mS
INC D79
= D50 K0
S6 PICK
STATE
K10
T10
MOVP D79 D80
T10
MOV K10 D50
S6 PICK
STATE
MOV K3 D70
RST D81
2034
= D70 K3
M8011
10mS
INC D81
= D50 K0
S6 PICK
STATE
K10
T11
MOVP D81 D82
T11
MOV K1 D70
2065
SRET
D50 A/S 1319 1504 1538 1627 1639
B/D 1309 1489 1523 1634 1654
D50 A/S 1659 1680 1977 2007 2046
B/D 1666 1675 1706 1982 2021
D70 A/S 1972 1995 2034
B/D 1987 2026 2060
D79 A/S 2015
B/D 1992 2003
T10 A/S 2020
A/S
D80 B/D 2015
B/D
D81 A/S 2054
B/D 2031 2042
T11 A/S 2059
A/S
D82 B/D 2054
B/D


P41
2066
TRIAL
TRANS
= D71 K1
= D40 K0
S6 TRANS
STATE
MOV K1 D40
S6 TRANS
STATE
MOV K2 D71
RST D75
2090
= D71 K2
M8011
10mS
INC D75
= D40 K0
S6 TRANS
STATE
K10
T12
MOVP D75 D76
T12
MOV K3 D40
S6 TRANS
STATE
RST D77
MOV K3 D71
2129
= D71 K3
M8011
10mS
INC D77
= D40 K0
S6 TRANS
STATE
K10
T13
MOVP D77 D78
T13
MOV K1 D71
2160
SRET
P50
IO
2161
M20
S3
ROUTEA
Y006
S3
ROUTEA
D40 A/S 1143 1163 1189 1576 1588
B/D 1148 1169 1583 1595 1607
D40 A/S 1600 1612 2072 2102 2141
B/D 1620 2077 2116
D71 A/S 2067 2090 2129
B/D 2082 2124 2155
D75 A/S 2110
B/D 2087 2098
T12 A/S 2115
A/S
D76 B/D 2110
B/D
D77 A/S 2149
B/D 2121 2137
T13 A/S 2154
A/S
D78 B/D 2149
B/D


2164
M21
S3
ROUTEB
Y007
S3
ROUTEB
2166
M1
S2
CONVL
Y021
S2 CONVL
2168
M11
S2
CONVR
Y022
S2 CONVR
2170
X006
xS3
INA
M0
S2
xPRODL
M0
A/S 208
B/D 225 264
2172
X007
xS3
INB
M10
S2
xPRODR
M10
A/S 299
B/D 316 355
2174
X010
xS3
OUTA
M22
S3
xPROD
OUTL
M22
A/S 462
B/D 481
2176
X011
xS3
OUTB
M23
S3
xPROD
OUTR
M23
A/S 486
B/D 507
2178
SRET
2179
END

Device Name	Comment
M0	S2 xPRODL
M1	S2 CONVL
M10	S2 xPRODR
M11	S2 CONVR
M20	S3 ROUTEA
M21	S3 ROUTEB
M22	S3 xPROD OUTL
M23	S3 xPROD OUTR
M24	S3 xVALID OUTL
M25	S3 xVALID OUTR
M26	S3 EDGE OUTL
M27	S3 EDGE OUTR
M8000	Alawys On
M8002	First On
M8011	10mS
M8012	100mS
M8013	1S
X005	COLLECT RDY
X006	xS3 INA
X007	xS3 INB
X010	xS3 OUTA
X011	xS3 OUTB
X014	S6 CYC TRANS FWD
X015	S6 CYC TRANS REV
X016	S6 CYC TRANS UP
X017	S6 CYC TRANS DOWN
X020	HOME PICK
X021	S6 PLACE RDY
X022	S6 PICK RDY
X023	FLAP CARTON OPEN
X024	FLAP CARTON CLOSE
X025	xCARTON3 STOP
X026	xCARTON2 STOP
X027	xCARTON1 STOP
X032	CARTON FILL1 RDY
X033	CARTON FILL2 RDY
X034	CARTON FILL3 RDY
Y006	S3 ROUTEA
Y007	S3 ROUTEB
Y011	S6 CYC TRANS
Y012	COVER PICKPLAC
Y013	FLAP OPEN CARTON
Y014	STOPPER CARTON3
Y015	STOPPER CARTON1
Y016	STOPPER CARTON2
Y020	S3 CONV MAIN
Y021	S2 CONVL
Y022	S2 CONVR
Y023	S4 CONVL
Y024	S4 CONVR
Y025	S1 DIR_R
Y026	S3 CONVL
Y027	S3 CONVR
Y031	CONVFILLCARTON1
Y032	CONVFILLCARTON2
Y033	CONVFILLCARTON3
Y034	S6 RUN TRANS
Y035	S6 FWD TRANS
Y036	S6 RUN PICKUP
Y037	S6 FWD PICKUP
Y040	S7 CARTON STOPPER2
Y041	S7 CARTON STOPPER3
Y042	S7 CARTON CONV UP
Y043	S7 CARTON STOPPER1
Y044	VACCUM 0
Y045	VACCUM 1
Y046	VACCUM 2
Y047	TRIG COLLECT
D0	FILT xPRODL
D1	CNT PRODL
D3	STATE LEFT
D4	FILT2 xPRODL
D10	FILT xPRODR
D11	CNT PRODR
D13	STATE RIGHT
D14	FILT2 xPRODR
D20	S3 STATE
D21	S3 ROUTE
D22	S3 WAIT STATE
D23	S3 FILTER PRODL
D24	S3 FILTER PRODR
D30	S3 ROUTER STATE
D31	S3 ROUTER CNTL
D33	S3 ROUTER CNTR
D40	S6 TRANSSTATE
D50	S6 PICK STATE
D51	S6 POSITIONLSB
D60	PWR SEQ
D90	CPU CNT
D91	CPU TICK
D92	MIN CPU TICK
D100	TEMP0
D101	TEMP1
D102	TEMP2
D103	TEMP3
D104	TEMP4
D105	TEMP5
D106	TEMP6
D107	TEMP7
D108	TEMP8
D109	TEMP9
D110	TRANS SEQ STATE
D111	PLACE SEQ STATE
D112	CARTON STOPPER STATE
D113	CARTON FILL CONV STATE
D114	CARTON DISCH CONV STATE
D120	PICK SEQ STATE
D121	COUNT PLACE
D128	POS PICK
D200	POS PICK
D202	POS PLACE0
D204	POS PLACE1
D206	POS PLACE2
D208	POS PLACE3
D210	POS PLACE4
D212	POS PLACE5
D214	POS PLACE6
D216	POS PLACE7
D218	POS PLACE8
D220	POS PLACE9

Device Name	Comment
P0	INIT
P10	S2 LEFT
P11	S2 RIGHT
P13	ROUTER
P14	ROUTER SEQ
P20	TRANS MSTSEQ
P21	PICKPLACMSTSEQ
P22	PLACE SEQ
P30	TRANS PROC
P31	PICK PLACE PROC
P32	CARTON STOPPER
P33	CARTON FILLPROC
P34	CARTON DISCH PROC
P40	TRIAL PICK
P41	TRIAL TRANS
P50	IO

Position	Device	Setting Value
(19)	C235	K0
(170)	T0	K10
(513)	T3	K5
(519)	T4	K5
(1194)	T5	K10
(1324)	T1	K5
(1519)	T2	K2
(1719)	T17	K2
(1735)	T18	K2
(1751)	T19	K2
(1766)	T6	K5
(1868)	T7	K5
(1909)	T8	K5
(1938)	T14	K5
(1946)	T15	K5
(1954)	T16	K5
(2012)	T10	K10
(2051)	T11	K10
(2107)	T12	K10
(2146)	T13	K10

Find In:(Entire project)
Find What:Used Device (Contact & Coil)
Print Range:Whole Range

*:in use, (counts): the number of coil uses

Device	Contact	Coil (counts)	Parameter	Comment
M0	*	*(1)		S2 xPRODL
M1	*	*(3)		S2 CONVL
M10	*	*(1)		S2 xPRODR
M11	*	*(3)		S2 CONVR
M20	*	*(3)		S3 ROUTEA
M21	*	*(3)		S3 ROUTEB
M22	*	*(1)		S3 xPROD OUTL
M23	*	*(1)		S3 xPROD OUTR
M24	*	*(2)		S3 xVALID OUTL
M25	*	*(2)		S3 xVALID OUTR
M26	*	*(2)		S3 EDGE OUTL
M27	*	*(2)		S3 EDGE OUTR
D0	*	*(2)		FILT xPRODL
D3	*	*(11)		STATE LEFT
D4	*	*(2)		FILT2 xPRODL
D10	*	*(1)		FILT xPRODR
D13	*	*(11)		STATE RIGHT
D14	*	*(2)		FILT2 xPRODR
D20	*	*(17)		S3 STATE
D21	*	*(10)		S3 ROUTE
D22	*	*(13)		S3 WAIT STATE
D23	*	*(3)		S3 FILTER PRODL
D24	*	*(2)		S3 FILTER PRODR
D30	*	*(26)		S3 ROUTER STATE
D31	*	*(1)		S3 ROUTER CNTL
D32	*	*(1)		
D33	*	*(1)		S3 ROUTER CNTR
D34	*	*(1)		
D40	*	*(8)		S6 TRANSSTATE
D50	*	*(10)		S6 PICK STATE
D51	*	*(2)		S6 POSITIONLSB
D52	*	*(2)		
D60	*	*(2)		PWR SEQ
D70	*	*(3)		
D71	*	*(3)		
D75	*	*(2)		
D77	*	*(2)		
D79	*	*(2)		
D81	*	*(2)		
D90	*	*(2)		CPU CNT
D110	*	*(5)		TRANS SEQ STATE

Find In:(Entire project)
Find What:Used Device (Contact & Coil)
Print Range:Whole Range

*:in use, (counts): the number of coil uses

Device	Contact	Coil (counts)	Parameter	Comment
D111	*	*(6)		PLACE SEQ STATE
D112	*	*(5)		CARTON STOPPER STATE
D113	*	*(6)		CARTON FILL CONV STATE
D114	*	*(5)		CARTON DISCH CONV STATE
D120	*	*(9)		PICK SEQ STATE
D121	*	*(3)		COUNT PLACE
D128	*	*(11)		POS PICK
D129	*	*(11)		
T0	*	*(1)		
T1	*	*(1)		
T2	*	*(1)		
T3	*	*(1)		
T4	*	*(1)		
T5	*	*(1)		
T6	*	*(1)		
T7	*	*(1)		
T8	*	*(1)		
T10	*	*(1)		
T11	*	*(1)		
T12	*	*(1)		
T13	*	*(1)		
T14	*	*(1)		
T15	*	*(1)		
T16	*	*(1)		
T17	*	*(1)		
T18	*	*(1)		
T19	*	*(1)		
C235	*	*(2)		
P0	*	*(1)		INIT
P1	*	*(1)		
P10	*	*(1)		S2 LEFT
P11	*	*(1)		S2 RIGHT
P13	*	*(1)		ROUTER
P14	*	*(1)		ROUTER SEQ
P20	*	*(1)		TRANS MSTSEQ
P21	*	*(1)		PICKPLACMSTSEQ
P22	*	*(1)		PLACE SEQ
P30	*	*(1)		TRANS PROC
P31	*	*(1)		PICK PLACE PROC
P32	*	*(1)		CARTON STOPPER
P33	*	*(1)		CARTON FILLPROC

Find In:(Entire project)
Find What:Used Device (Contact & Coil)
Print Range:Whole Range

*:in use, (counts): the number of coil uses

Device	Contact	Coil (counts)	Parameter	Comment
P34	*	*(1)		CARTON DISCH PROC
P40	*	*(1)		TRIAL PICK
P41	*	*(1)		TRIAL TRANS
P50	*	*(1)		IO

[Line Statement List]

Step	Line Statement
411	STRAIGHT
423	LEFT
435	RIGHT

Project Contents List 11/21/2025
Data Name : Project Contents List

Workspace Name :
Project Name : main
Title :

Data Name	Last Change	Title
Parameter	04/09/2022 14:41:48	
PLC Parameter	04/09/2022 14:41:48	
Network Parameter	04/09/2022 14:41:48	
CC-Link	04/09/2022 14:41:48	
Special Module(Intelligent Function Module)	04/09/2022 14:41:48	
Global Device Comment	15/11/2022 11:39:26	
Program Setting		
Execution Program		
MAIN	04/09/2022 14:41:48	
MAIN	15/11/2022 11:39:49	
POU		
Program	04/09/2022 14:41:48	
MAIN	15/11/2022 11:39:49	
Local Device Comment		
Device Memory	04/09/2022 14:41:48	
MAIN	04/09/2022 14:41:48	