

Totally Integrated Automation Portal

Main [OB1]

Main Properties

General

Name	Main	Number	1	Type	OB
Language	LAD	Numbering	Automatic		

Information

Title	"Main Program Sweep (Cycle)"	Author		Comment	
Family		Version	0.1	User-defined ID	

Name	Data type	Default value	Supervision	Comment
▼ Input				
Initial_Call	Bool			Initial call of this OB
Remanence	Bool			=True, if remanent data are available
Temp				
Constant				

Network 1:

%FC3
"Initial"

EN

ENO

%FC2
"Feeding"

EN

ENO

%FC4
"Identification"

EN

ENO

%FC1
"Sorting"

EN

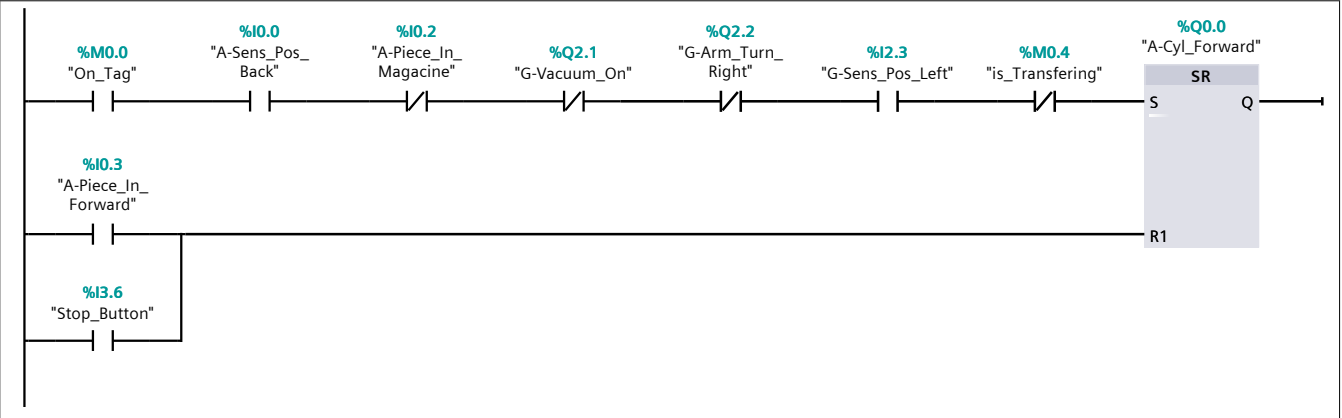
ENO

Feeding [FC2]

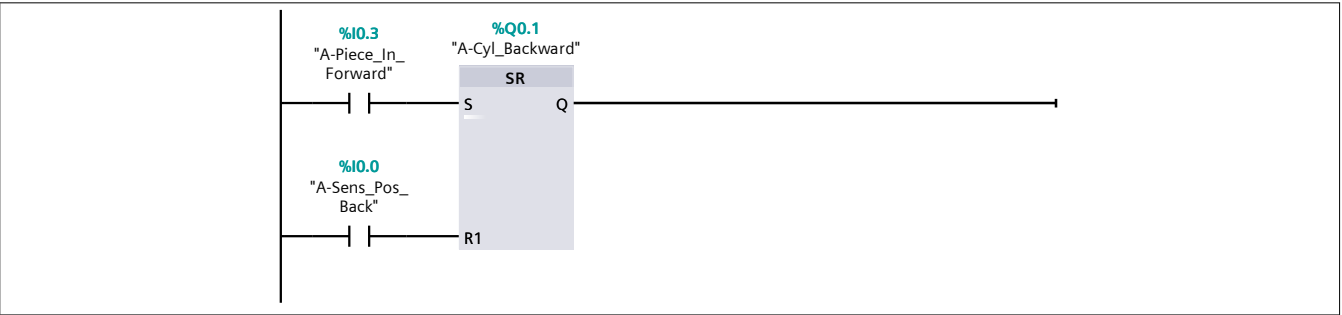
Feeding Properties					
General					
Name	Feeding	Number	2	Type	FC
Language	LAD	Numbering	Automatic		
Information					
Title		Author		Comment	
Family		Version	0.1	User-defined ID	

Name	Data type	Default value	Supervi- sion	Comment
Input				
Output				
InOut				
Temp				
Constant				
▼ Return				
Feeding	Void			

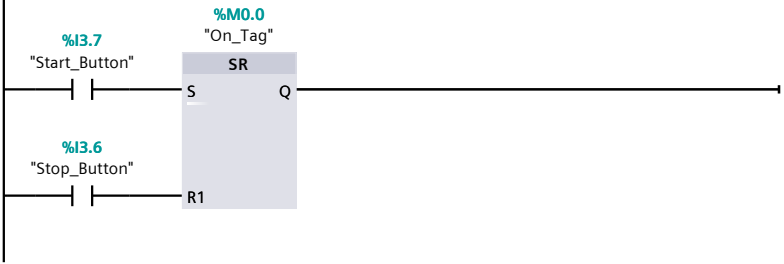
Network 1:



Network 2:



Network 3:

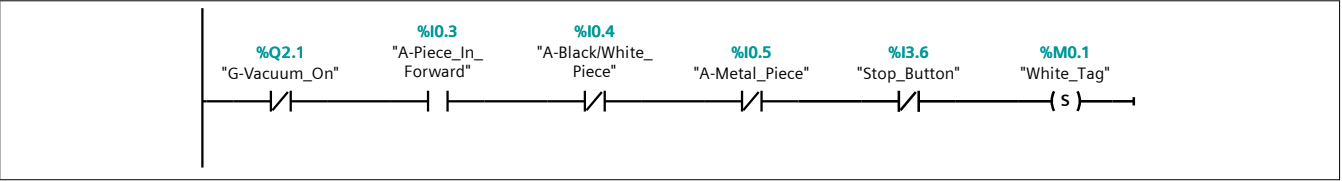


Identification [FC4]

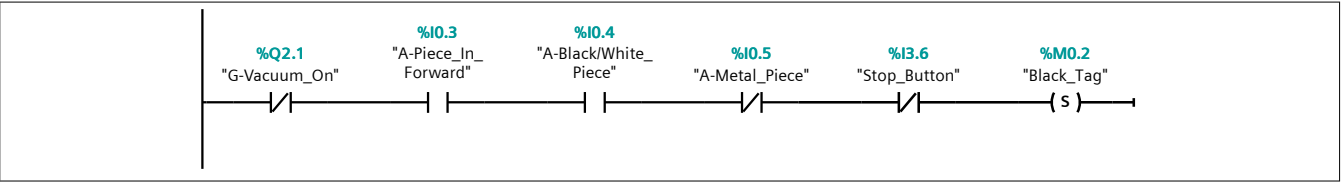
Identification Properties					
General					
Name	Identification	Number	4	Type	FC
Language	LAD	Numbering	Automatic		
Information					
Title		Author		Comment	
Family		Version	0.1	User-defined ID	

Name	Data type	Default value	Supervision	Comment
Input				
Output				
InOut				
Temp				
Constant				
▼ Return				
Identification	Void			

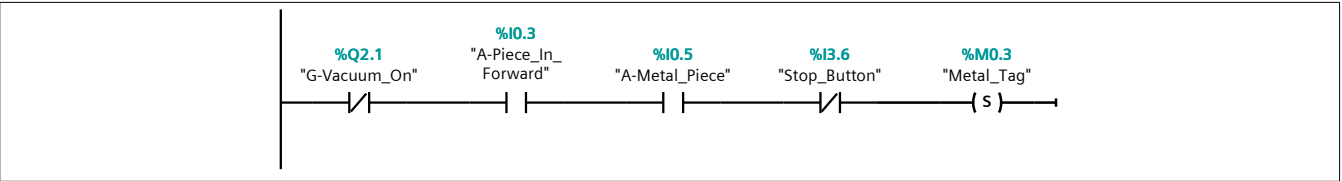
Network 1: Set White_Tag for White piece



Network 2: Set Black_Tag for Black Piece



Network 3: Set Metal_Tag for metallic piece



Network 4: Reset tag

Totally Integrated Automation Portal		
	<div><div><div><div><div>%Q2.1</div><div>"G-Vacuum_On"</div></div><div><div>%M1.1</div><div>"is_at_Dropoff_Location"</div></div><div><div>%M0.2</div><div>"Black_Tag"</div></div><div><div>%M0.1</div><div>"White_Tag"</div></div><div><div>%M0.3</div><div>"Metal_Tag"</div></div></div><div><div><div></div><div></div><div></div><div></div><div></div></div><div><div></div><div></div><div></div><div></div><div></div></div><div><div></div><div></div><div></div><div></div><div></div></div><div><div></div><div></div><div></div><div></div><div></div></div><div><div></div><div></div><div></div><div></div><div></div></div></div></div></div>	

Initial [FC3]	
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Initial Properties

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100	General

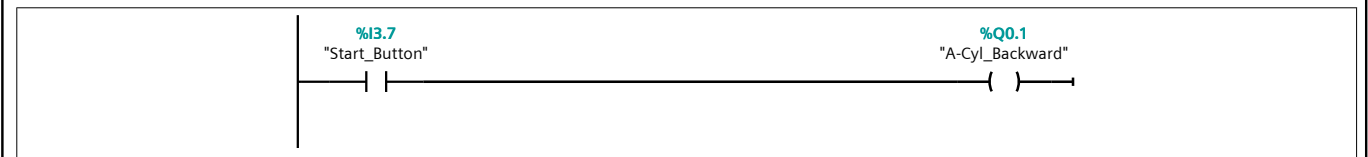
Name	Initial	Number	3	Type	FC
Language	LAD	Numbering	Automatic		

Information	
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100	100

Title		Author		Comment	
Family		Version	0.1	User-defined ID	

Name	Data type	Default value	Supervi- sion	Comment
Input				
Output				
InOut				
Temp				
Constant				
▼ Return				
Initial	Void			

Network 1:



Totally Integrated Automation Portal		
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Sorting [FC1]

Sorting Properties

General

Name	Sorting	Number	1	Type	FC
Language	LAD	Numbering	Automatic		

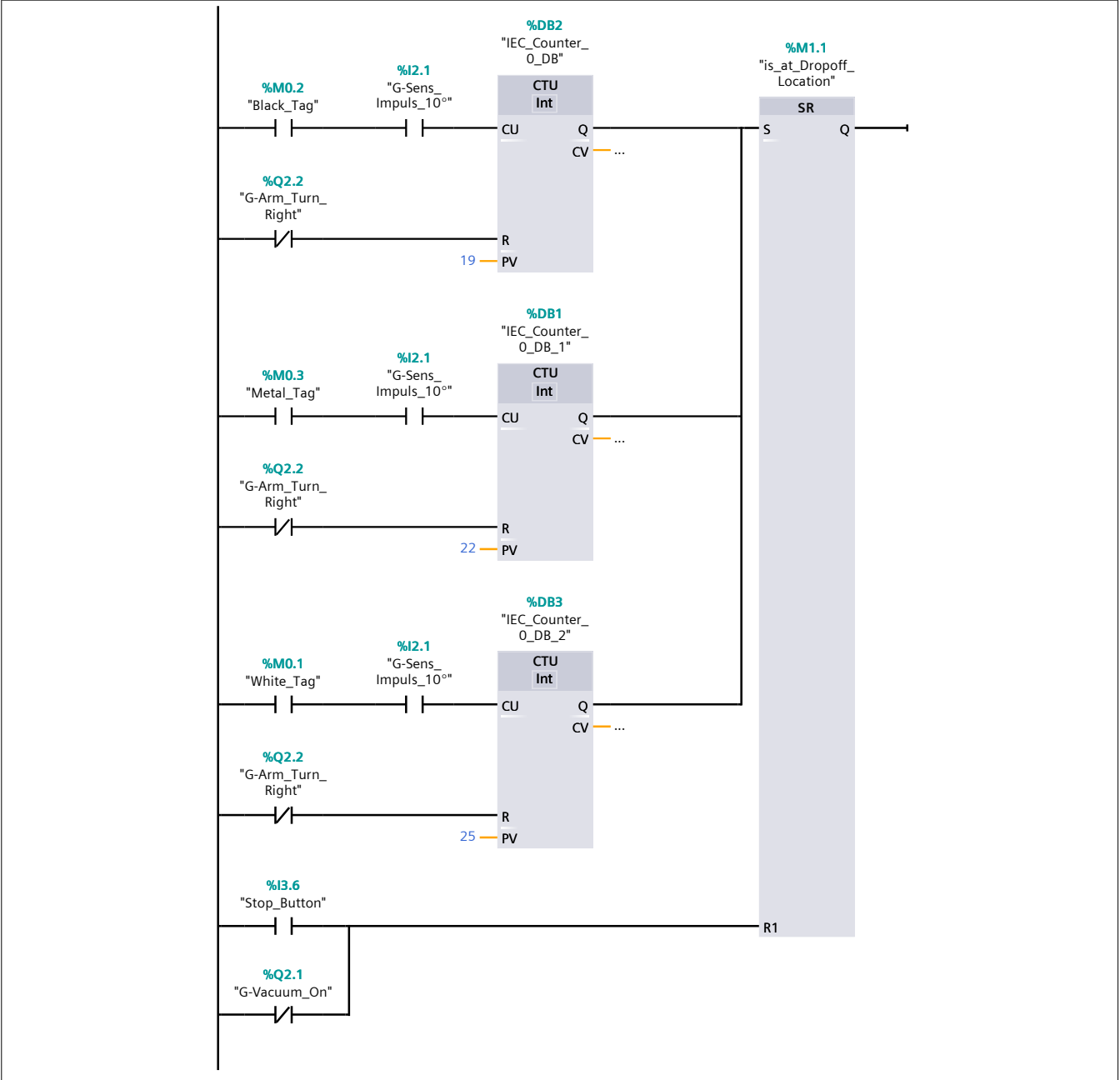
Information

Title		Author		Comment	
Family		Version	0.1	User-defined ID	

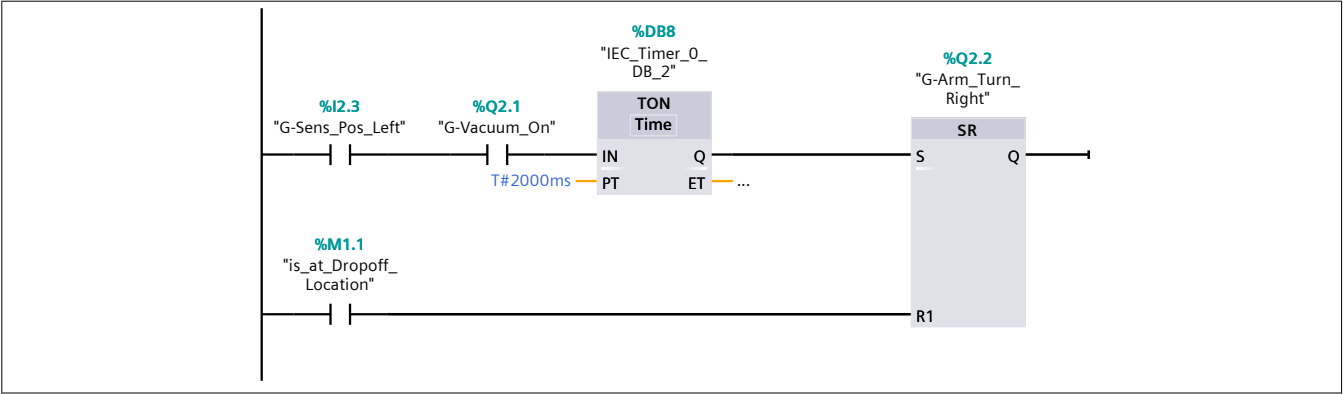
Name	Data type	Default value	Supervi- sion	Comment
Input				
Output				
InOut				
Temp				
Constant				
▼ Return				
Sorting	Void			

Network 1: Position control

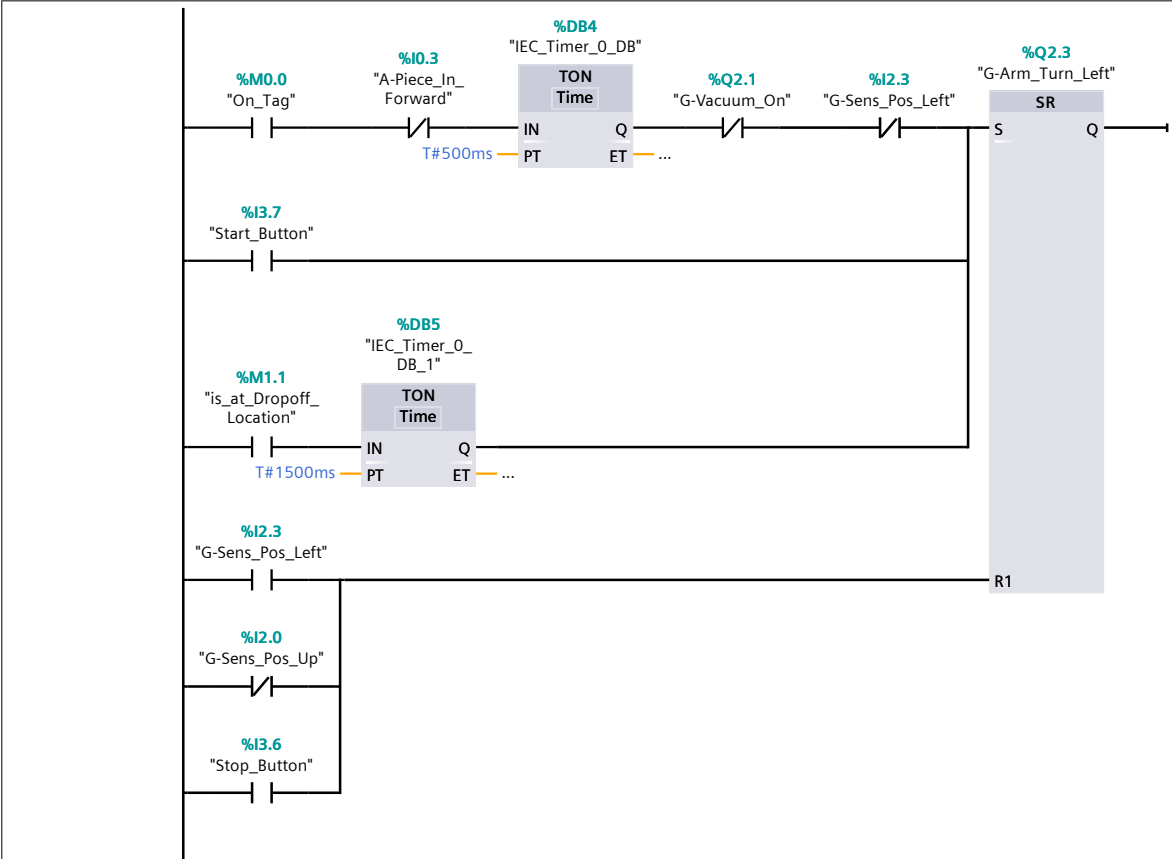
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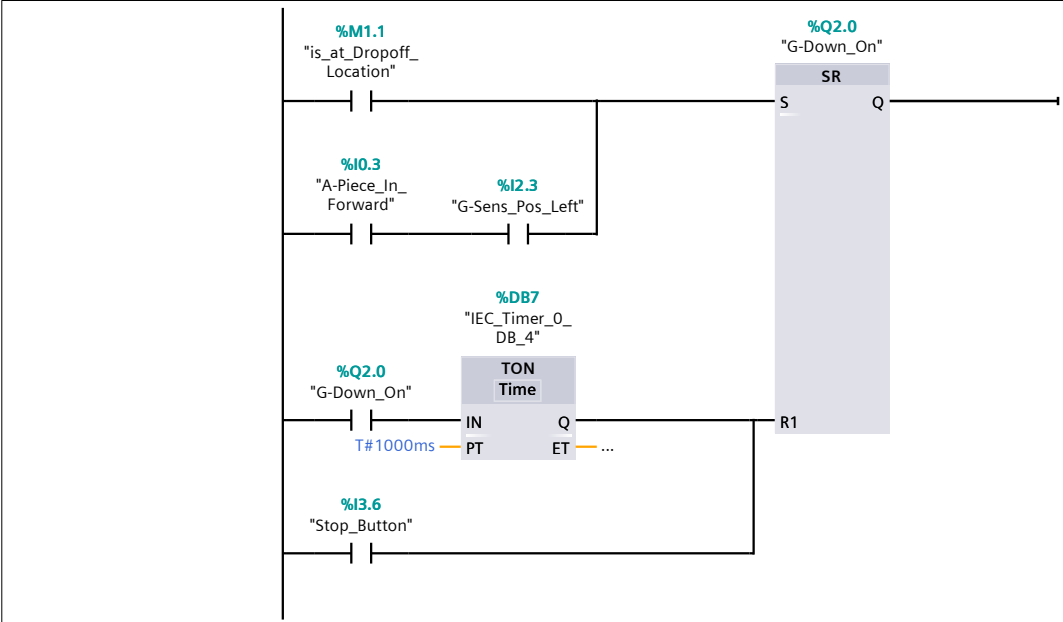
Network 2: Arm goes right



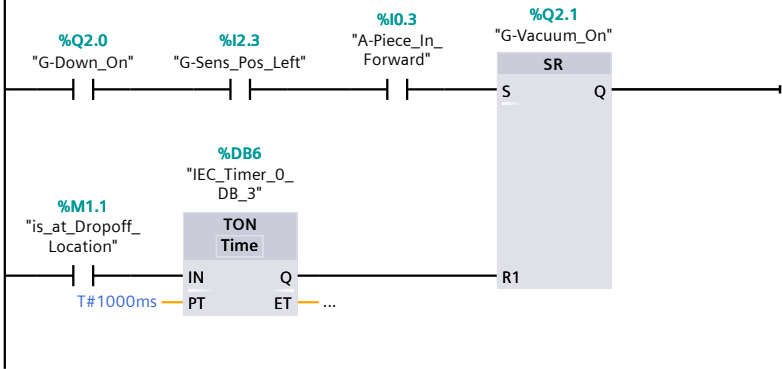
Network 3: G arm left



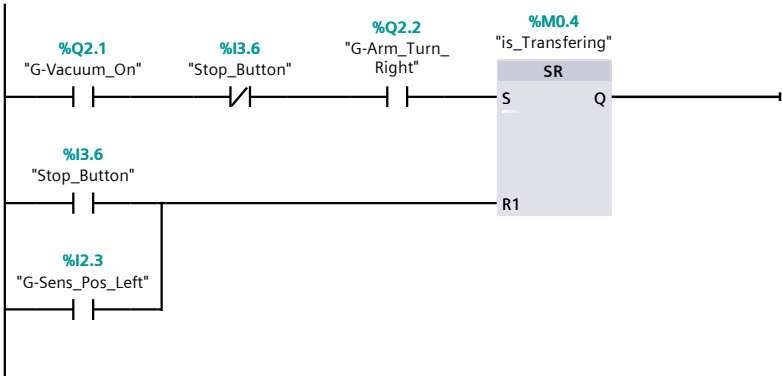
Network 4: G down



Network 5: G vacuum on



Network 6: Transferring



Network 7: 1 cycle of sorting

