Totally Integrated
Automation Porta

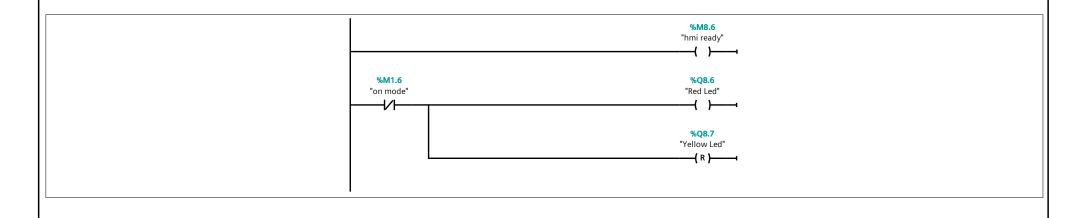
fix_plc / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks

Main [OB1]

Main Properties	lain Properties						
General	eneral						
Name Main Number 1 Type OB Language LAD						LAD	
Numbering	lumbering Automatic						
Information	Information						
Title "Main Program Sweep (Cy-cle)" Comment Family							
Version	· · · · · · · · · · · · · · · · · · ·						

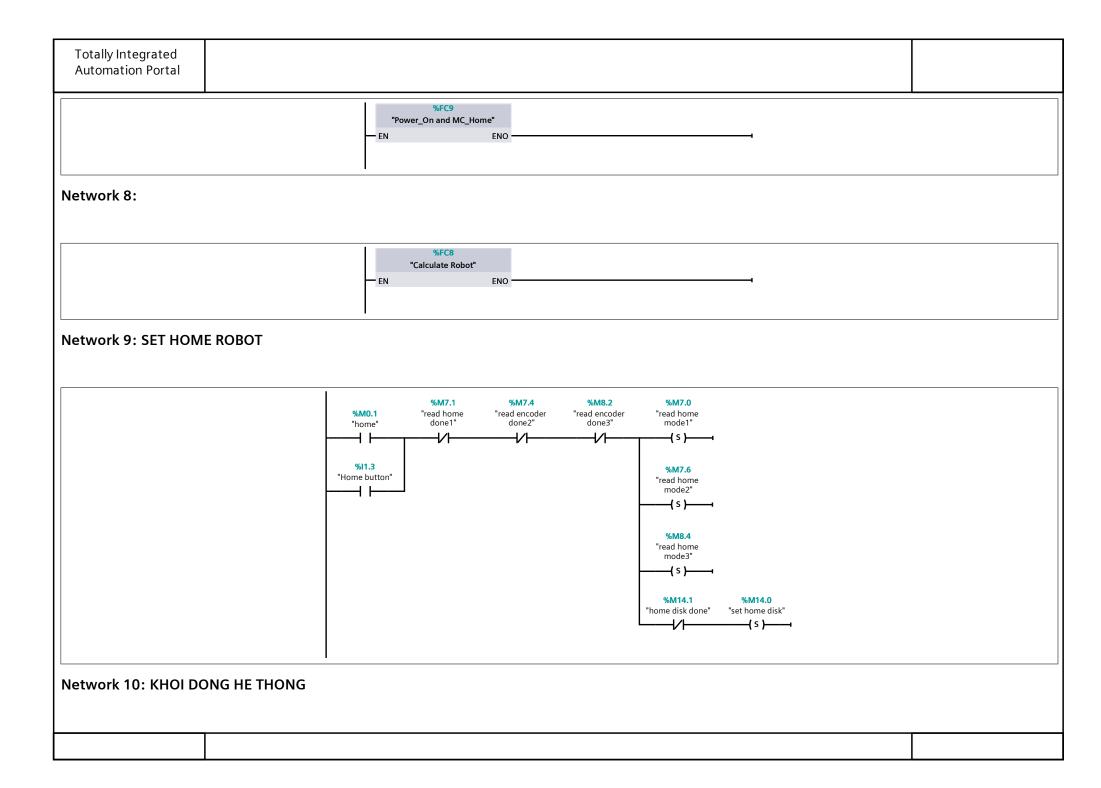
Main Main			
Name	Data type	Default value	Comment
▼ Input			
Initial_Call	Bool		Initial call of this OB
Remanence	Bool		=True, if remanent data are available
Тетр			
Constant			

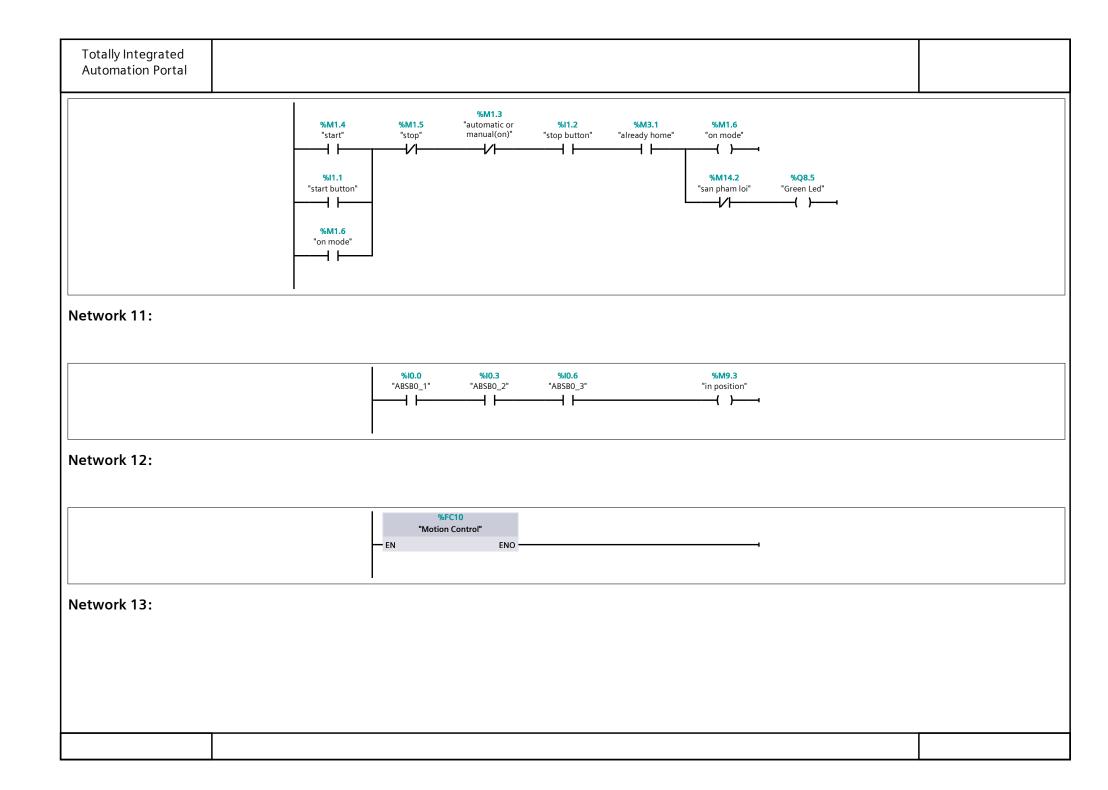
Network 1:



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Network 2:		
	%FC4 "the rest of the system" — EN ENO	
Network 3:		
	MB60 **CTRL_HSC_0_DB CTRL_HSC EN BUSY — False **BOC_HSC*.DIR — DIR **DOC_HSC*.NEW DIR **DOC_HSC*.NEW DIR **DOC_HSC*.NEW CV — NEW_CV **DOC_HSC*.NEW_ RV **D	
Network 4:		

Totally Integrated **Automation Portal** MOVE EN - ENO -**OUT1** — "DOC_HSC".XUNG %ID1000 "hsc counter" — IN Network 5: NORM_X SCALE_X Int to Real Real to Real - ENO -- EN - EN -0 — MIN 0.0 — MIN %MD800 %MD804 OUT — "Temp mass" OUT — "Tag_5" %IW66 %MD800 "Tag_4" — VALUE "Tag_5" — VALUE 27648 — MAX 5000.0 — MAX MUL Auto (Real) EN - ENO -%MD804 "Temp mass" — IN1 OUT — "KL bottle in box" 2.0 — IN2 🕌 Network 6: %FC5 "Set Home Position for Robot" - EN ENO -Network 7:

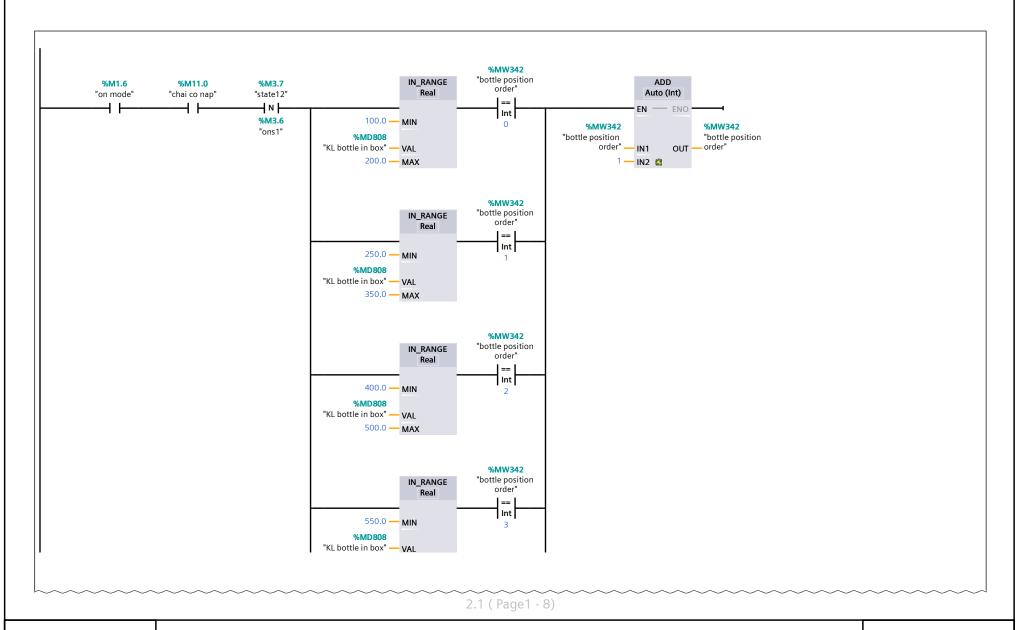




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	%FC6 "Change Position of Robot" — EN ENO	
Network 14:		
	%FC7 "Change Velocity of Robot" — EN ENO	
Network 15:		

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Automation Portal

Network 15: (1.1 / 3.1)

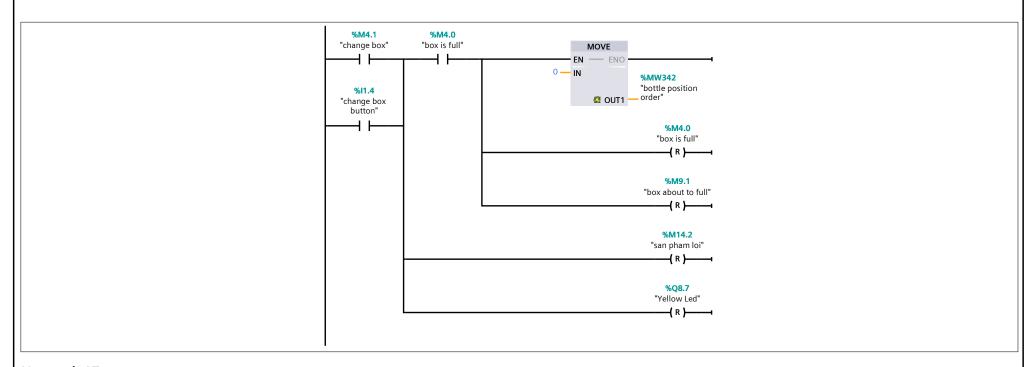


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etwork 15: (2.1 / 3.1)	1.1 (Page1 - 7)	
	650.0 — MAX	
	N_RANGE "bottle position order" == Int 4 4	
	## WMW MWW MA2 IN_RANGE	
	IN_RANGE "bottle position order" == Int 6	
	MW342 IN_RANGE	
	3.1 (Page1 - 9)	

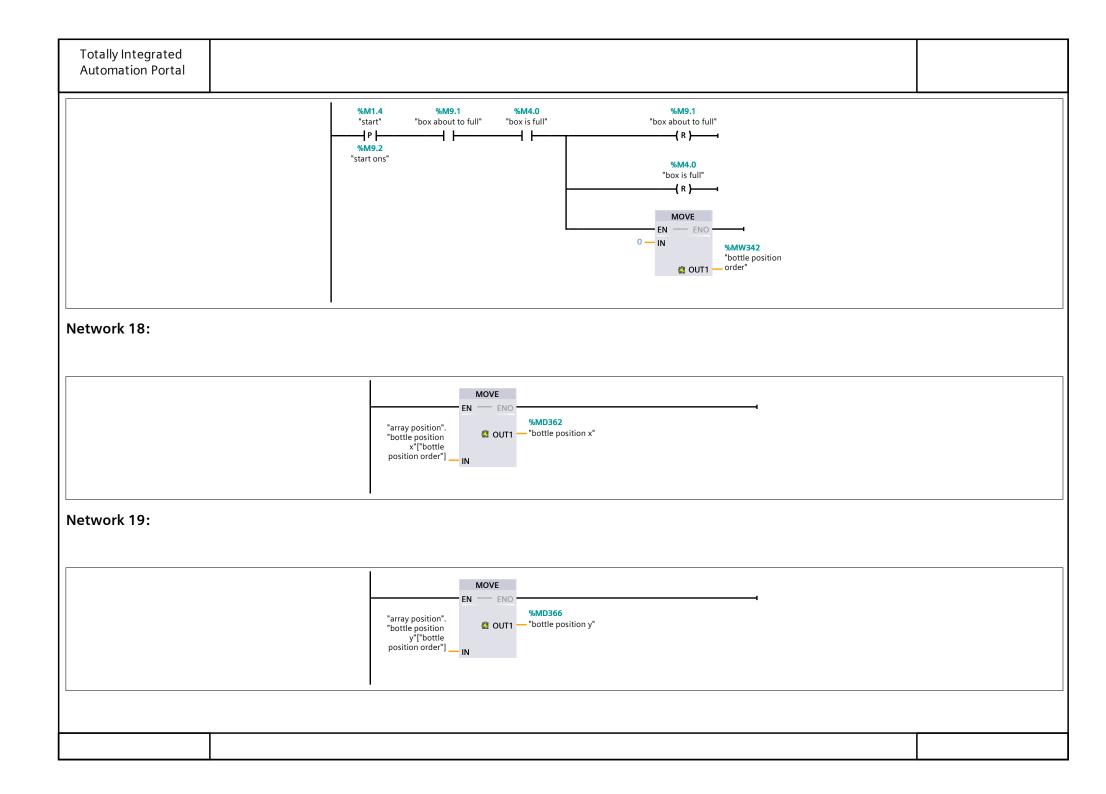
"KL bottle in box" — VAL 1250.0 — MAX IN_RANGE Real 1290.0 — MIN %MD808 "KL bottle in box" — VAL 1400.0 — MAX %MW342 "bottle position order" "box about to full" 8 %MW342 "bottle position order" "box about to full" 8 %MW342 "bottle position order" "box about to full" 8 %MW342 "bottle position order" "box about to full" 8	
"KL bottle in box" VAL 1250.0 — MAX "MW342 "bottle position order" "box about to full"	
%MW342 "bottle position order" "box about to full"	

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Network 16:



Network 17:

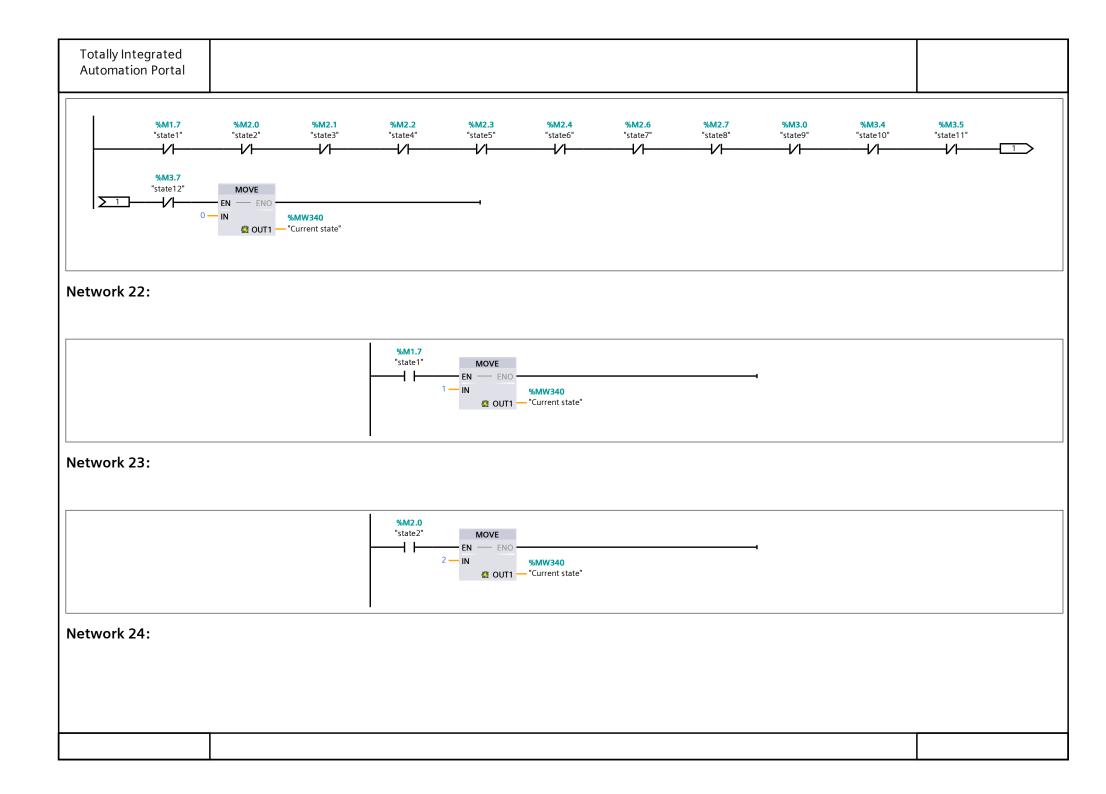


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Network 20:

```
%Q1.1
"pneumatic valve"
                      %M1.3
   %M2.3
                   "automatic or
                   manual(on)"
   "state5"
   %M2.4
   "state6"
   %M2.6
   "state7"
   %M2.7
   "state8"
   %M3.0
   "state9"
                      %M1.3
   %M8.7
                   "automatic or
"valve manual"
                   manual(on)"
                      %M1.3
   %M1.6
                   "automatic or
 "on mode"
                   manual(on)"
```

Network 21:



```
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  Automation Portal
                                                     %M2.1
                                                     "state3"
                                                                  MOVE
                                                                - EN --- ENO -
                                                            3 — IN %MW340
                                                                   OUT1 — "Current state"
Network 25:
                                                     %M2.2
                                                     "state4"
                                                                  MOVE
                                                                EN - ENO -
                                                             4 — IN %MW340
                                                                   OUT1 — "Current state"
Network 26:
                                                     %M2.3
                                                     "state5"
                                                                EN - ENO -
                                                            5 — IN %MW340
                                                                 OUT1 — "Current state"
Network 27:
                                                     %M2.4
                                                     "state6"
                                                                  MOVE
                                                                - EN --- ENO -
                                                            6 — IN %MW340
                                                                👸 OUT1 — "Current state"
```

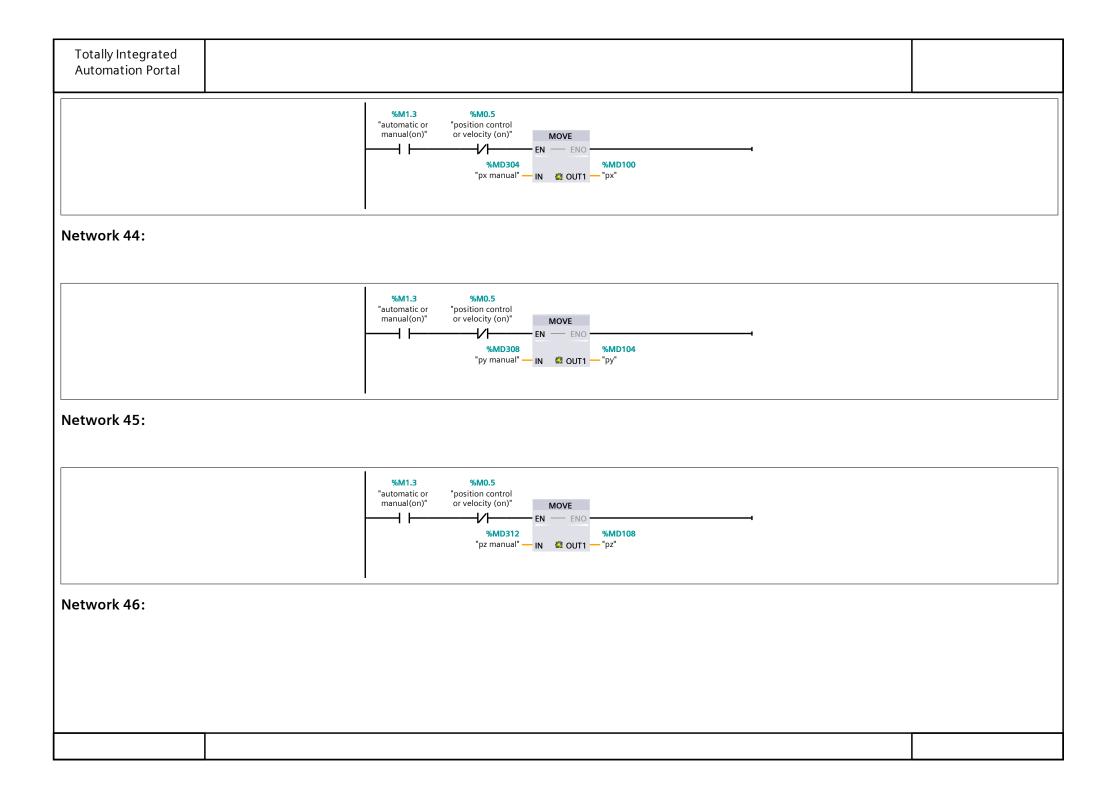
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Network 28:		
	%M2.6 "state7" EN — ENO 7 — IN	
Network 29:		
	"state8" BN EN EN EN WW340 WMW340 "Current state"	
Network 30:		
	"state9" Solution in the state of the state	
Network 31:		

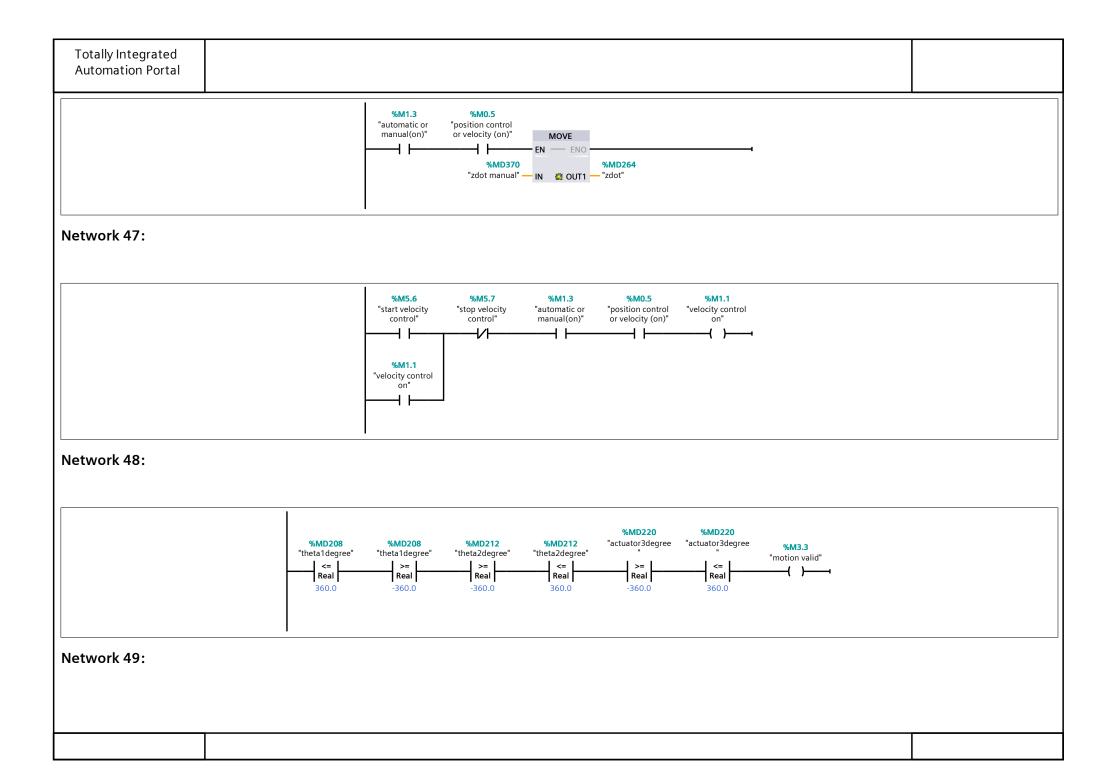
```
Totally Integrated
  Automation Portal
                                                      %M3.4
                                                     "state10"
                                                                  MOVE
                                                                - EN --- ENO -
                                                            10 — IN %MW340
                                                                   😃 OUT1 — "Current state"
Network 32:
                                                      %M3.5
                                                     "state11"
                                                                  MOVE
                                                                EN - ENO -
                                                            11 — IN %MW340
                                                                   © OUT1 — "Current state"
Network 33:
                                                      %M3.7
                                                     "state12"
                                                                   MOVE
                                                                EN - ENO -
                                                            12 — IN
                                                                           %MW340
                                                                  OUT1 — "Current state"
Network 34:
```

```
Totally Integrated
  Automation Portal
                                                                    %MW342
                                                                 "bottle position
order"
                                                                                                                                       %M4.3
                                                                                                                                      "bottle0"
                                                                     >
Int
Network 35:
                                                                    %MW342
                                                                 "bottle position
order"
                                                                                                                                      %M4.4
                                                                                                                                      "bottle1"
                                                                      >
Int
Network 36:
                                                                    %MW342
                                                                 "bottle position order"
                                                                                                                                       %M4.5
                                                                                                                                      "bottle2"
                                                                     >
Int
Network 37:
```

```
Totally Integrated
  Automation Portal
                                                                    %MW342
                                                                 "bottle position
order"
                                                                                                                                       %M4.6
                                                                                                                                      "bottle3"
                                                                     >
Int
Network 38:
                                                                    %MW342
                                                                 "bottle position
order"
                                                                                                                                      %M4.7
                                                                                                                                      "bottle4"
                                                                      >
Int
Network 39:
                                                                    %MW342
                                                                 "bottle position order"
                                                                                                                                       %M5.0
                                                                                                                                      "bottle5"
                                                                     >
Int
Network 40:
```

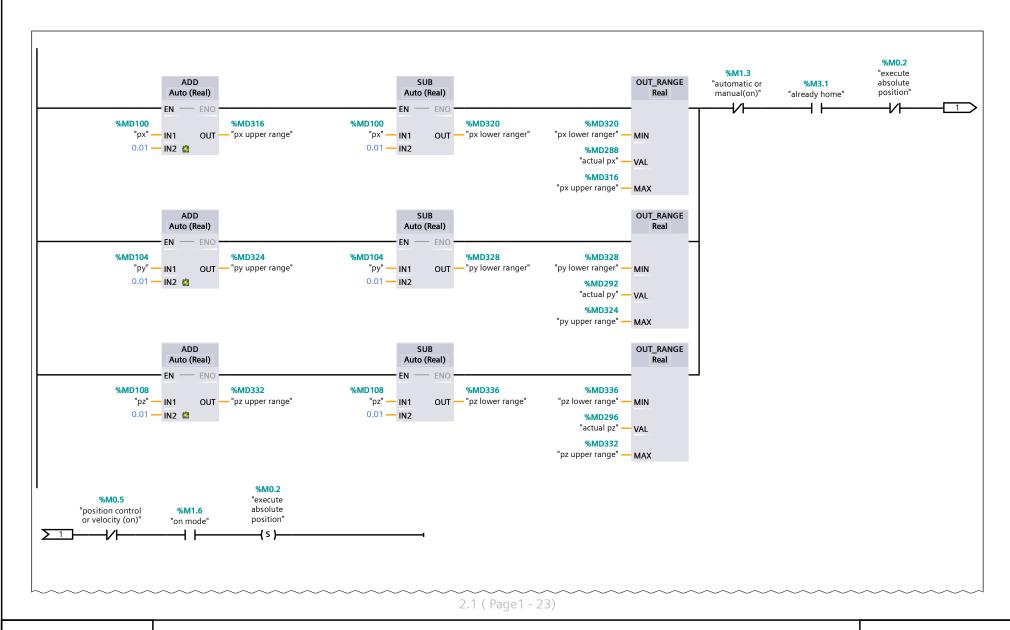
```
Totally Integrated
  Automation Portal
                                                                    %MW342
                                                                 "bottle position
order"
                                                                                                                                     %M5.1 "bottle6"
                                                                     >
Int
Network 41:
                                                                    %MW342
                                                                 "bottle position
order"
                                                                                                                                      %M5.2
                                                                                                                                     "bottle7"
                                                                      >
Int
Network 42:
                                                                     %M4.0
                                                                                                                                      %M5.3
                                                                   "box is full"
                                                                                                                                      "bottle8"
Network 43:
```





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Network 49: (1.1 / 2.1)



T A	otally Integrated automation Portal		
Net	twork 49: (2.1 / 2.1)	1.1 (Page1 - 22)	

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Network 50:		
	"MC_Move "MC_Move "MC_Move %M1.3 "execute Absolute_DB". Absolute_DB_1". Absolute_DB_2". "automatic or absolute Done Done manual(on)" position"	
Network 51:		
	*M1.3	
Network 52:	·	
	*M1.3 *M0.3 "automatic or "inverse or manual(on)" forward" MOVE EN EN EN ENO *MD240 "theta2forward" IN OUT1 ** Theta2degree"	
Network 53:		

