Totally Integrated Automation Portal		
	1	

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

Startup [OB100]

Startup Properties							
General							
Name	Startup	Number	100	Туре	OB	Language	LAD
Numbering	Automatic						
Information							
Title	"Complete Restart"	Author		Comment		Family	
Version	0.1	User-defined ID					

Startup					
Name	Data type	Default value	Comment		
▼ Input					
LostRetentive	Bool		True if retentive data are lost		
LostRTC	Bool		True if date and time are lost		
Тетр					
Constant					

Network 1:

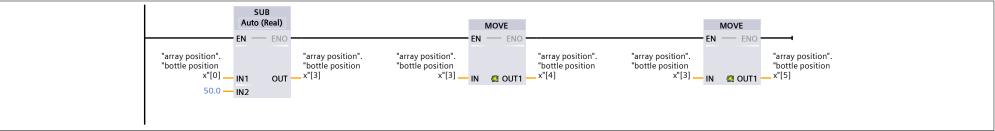


Network 2:

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	59.5 — IN	
Network 3:		
	MOVE EN ENO N MD136 "a3"	
Network 4:		
	MOVE EN ENO IN %MD140 **a4"	
Network 5:		
	MOVE EN ENO	

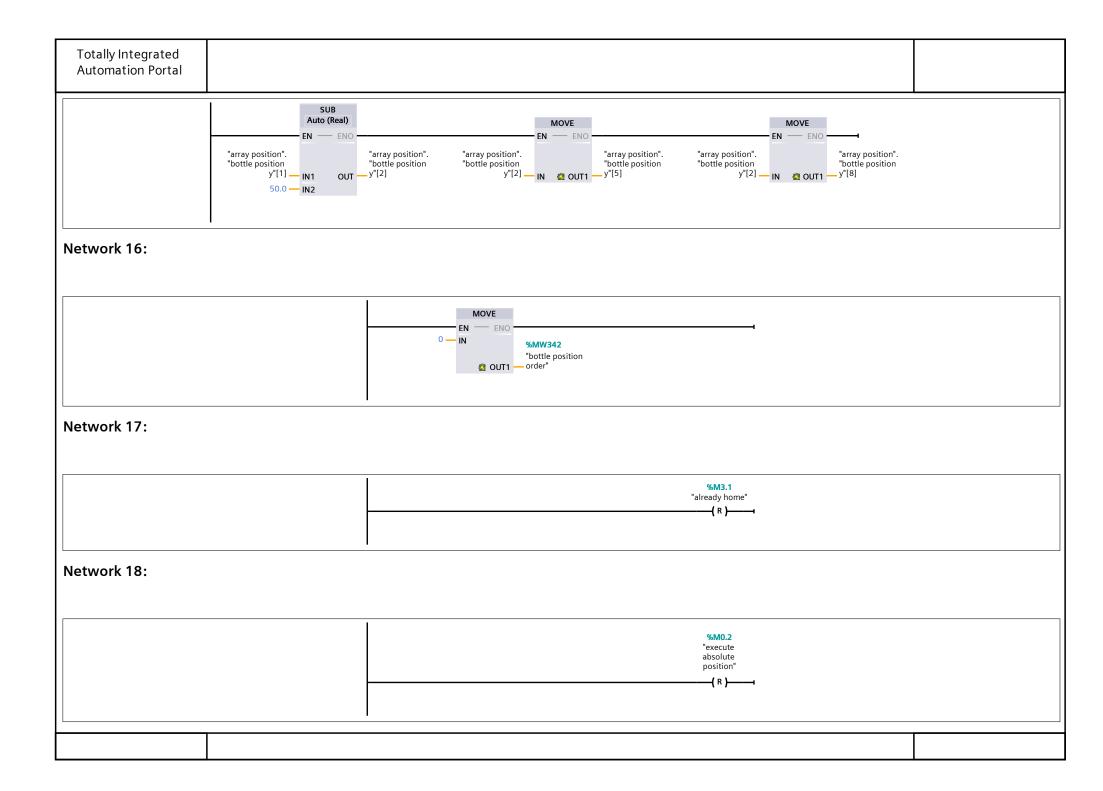
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Network 6:		
	MOVE EN — ENO IN MMD148 MMD148 MMD148	
Network 7:		
	O.0 — EN — ENO — %MD172 OUT1 — "home position 1"	
Network 8:		
	MOVE EN ENO 9.00—IN WMD176 COUT1—"home position 2"	
Network 9:		

Totally Integrated **Automation Portal** MOVE EN - ENO -90.0 — IN %MD180 # OUT1 — "home position 3" Network 10: MOVE MOVE MOVE EN - ENO -EN - ENO -EN - ENO -450.0 — IN "array position". "bottle position x"[0] IN OUT1 -x"[1] "array position". "bottle position x"[0] — IN OUT1 — x"[2] "array position". "bottle position " " " [0] Network 11: SUB Auto (Real) MOVE MOVE EN --- ENO -EN - ENO -EN - ENO -



Network 12:

Totally Integrated **Automation Portal** SUB Auto (Real) MOVE MOVE EN - ENO -- EN --- ENO -- EN --- ENO -"array position". "bottle position "array position". "bottle position x"[4] — IN1 OUT — x"[6] x"[6] — IN 🙇 OUT1 — x"[8] x"[6] — IN 🏻 👛 OUT1 — x"[7] 50.0 — IN2 Network 13: MOVE MOVE MOVE EN --- ENO -EN - ENO EN - ENO 90.0 — IN "array position". "bottle position **₫** OUT1 — y"[0] y"[0] — IN 🚜 OUT1 — y"[3] y"[0] — IN 🚜 OUT1 — y"[6] Network 14: SUB Auto (Real) MOVE MOVE EN - ENO -EN - ENO EN - ENO "array position". "bottle position "array position". "array position". "bottle position "array position". "bottle position "array position". "array position". "bottle position "bottle position "bottle position OUT — y"[1] y"[0] — IN1 y"[1] — IN 🚜 OUT1 — y"[7] 50.0 — IN2 Network 15:



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Network 19:		
	%M0.5 "position control or velocity (on)" ———————————————————————————————————	
Network 20:		
	%M6.5 "read phase done1" { S }	
Network 21:		
	%M7.3 "read phase done2" (S)	
Network 22:		
	%M8.1 "read phase done3" (S)	

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Network 23:		
	"the rest". "cylinder free" (S)	
Network 24:		
	"the rest"."output free" (S)	
Network 25:	·	
	"the rest". "entrance free" ———————————————————————————————————	
Network 26:	<u> </u>	
	SUB Auto (Real) EN ENO OUT Conveyor px low" Outle on conveyor px low" Outle on conveyor px high" Outle on conveyor px high"	

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Network 27:		•
	MOVE SUB Auto (Real)	ADD Auto (Real)
	EN ENO WMD478 "bottle on conveyor py" Outline to the conveyor py" EN ENO WMD478 "bottle on conveyor py" IN1 Outline to the conveyor py" Outline to the conveyor py" Outline to the conveyor py" Note: The conveyor py to the conveyor	on "bottle on "bottle on
Network 28:		
	MOVE EN ENO WMD500 "defective bottle "defective bottle px" px" IN1 OUT px low"	ive bottle "defective bottle "defective bottle
Network 29:	0.01 — IN2	0.01 — IN2 🚜
	SUB And (D. IV)	ADD And (Day)
	MOVE EN ENO -321.0 IN *MD504	ive bottle "defective bottle "defective bottle

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Network 30:				
		"number of bottle".R		