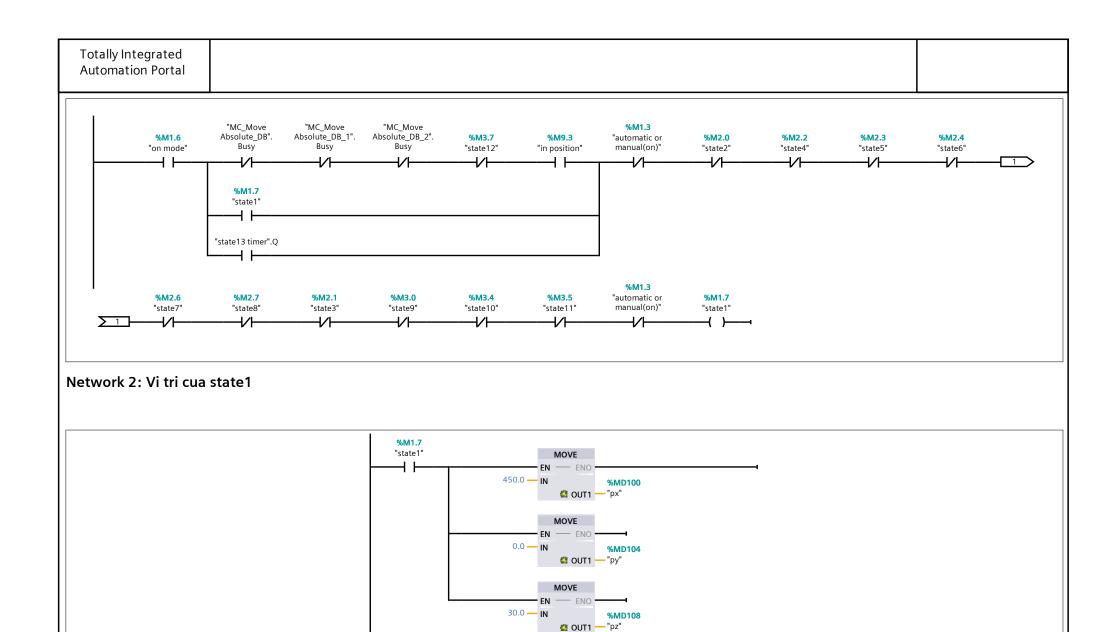
Totally Integrated Automation Portal					
Change Position of Robot [FC6]					
Change Position of Robot	Properties				
General					

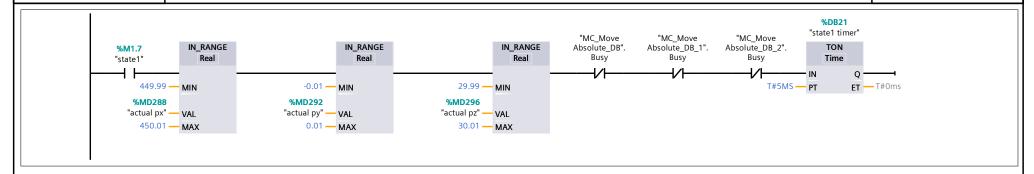
Change Position	of Robot Properties						
General							
Name	Change Position of Robot	Number	6	Type	FC	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
▼ Return			
Change Position of Robot	Void		

Network 1: STATE 1 ON



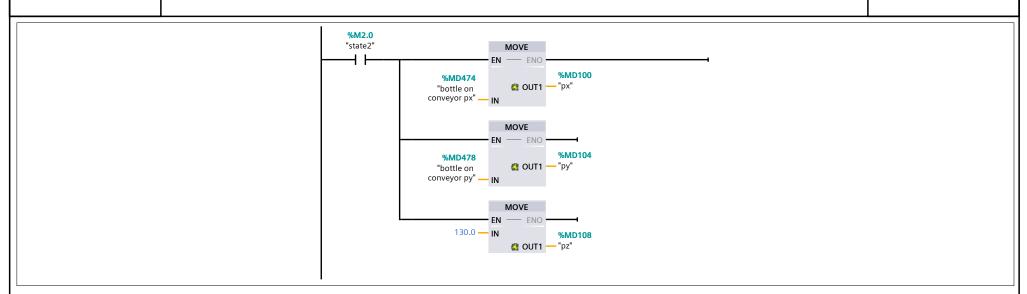
Network 3:



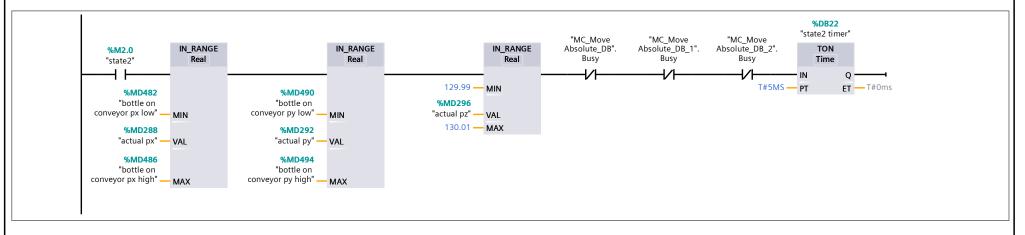
Network 4:

```
%M1.3
                      %M9.3
                                        %M4.0
                                                          %M14.2
                                                                             %M2.1
                                                                                                %M1.6
                                                                                                               "automatic or
                                                                                                                                    %M2.0
"state1 timer".Q
                   "in position"
                                      "box is full"
                                                       "san pham loi"
                                                                             "state3"
                                                                                                               manual(on)"
                                                                                                                                    "state2"
                                                                                              "on mode"
   %M2.0
                                                                                                                                    %M11.0
   "state2"
                                                                                                                                  "chai co nap"
                                                                                                                                     -(R)------
```

Network 5:

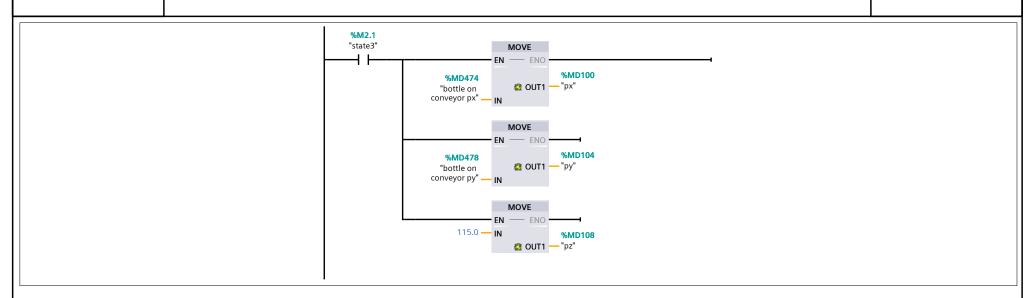


Network 6:

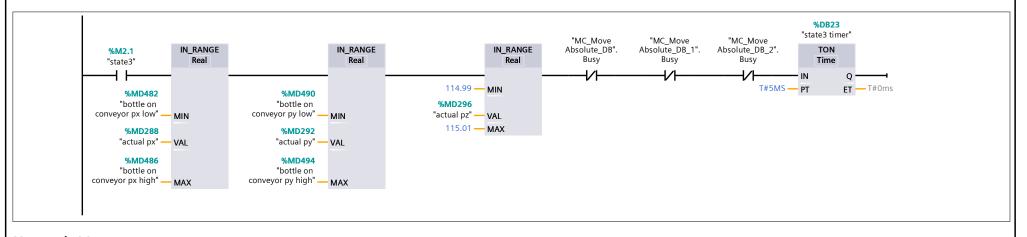


Network 7:

Totally Integrated **Automation Portal** %DB54 "end timer" %18.2 TON %M2.0 "sensor end of "state2" Time conveyor" T#2s — PT ET — T#0ms **%M3.4** "state10" **%M3.7** "state12" %M11.7 %M2.7 %M3.0 %M3.5 %M11.0 "camera detect" "state8" "state9" "state11" "chai co nap" _(s)___ Network 8: %M1.3 %M9.3 %M2.2 %M1.6 "automatic or %M2.1 manual(on)" "state3" "state2 timer".Q "in position" "end timer".Q "state4" "on mode" %M2.1 "state3" Network 9:

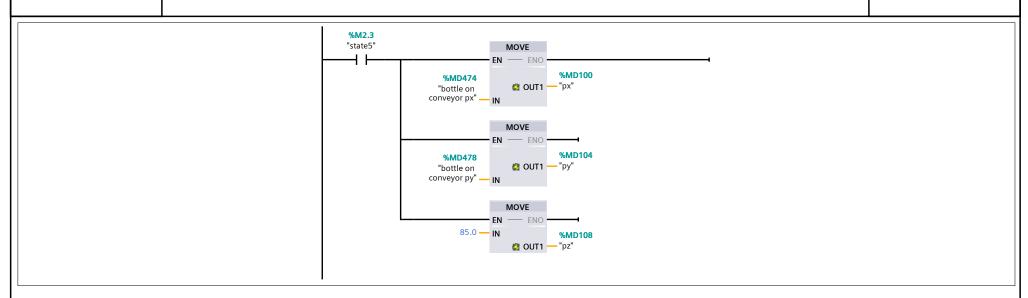


Network 10:

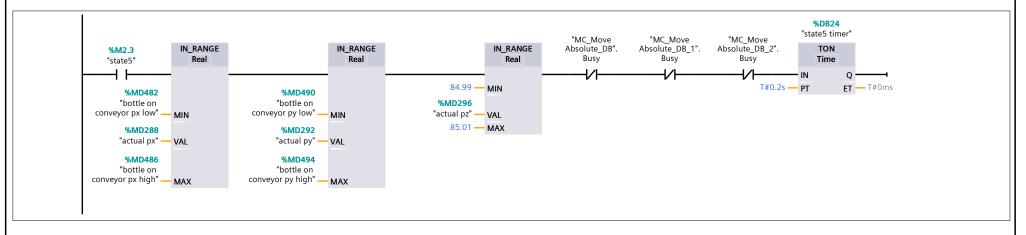


Network 11:

Totally Integrated Automation Portal %M1.3 %M9.3 "in position" "automatic or manual(on)" %M2.3 %M1.6 %M2.2 "state3 timer".Q "state5" "on mode" "state4" %M2.2 "state4" Network 12: %M1.3 %MD296 "automatic or manual(on)" %M2.2 %M2.4 %M1.6 %M2.3 "actual pz" "state4" "state6" "on mode" "state5" <= Real %M2.3 "state5" Network 13:

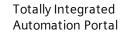


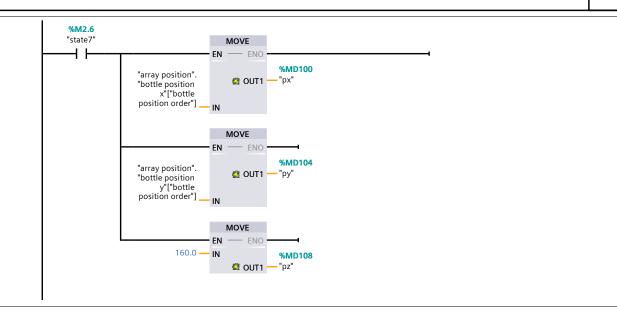
Network 14:



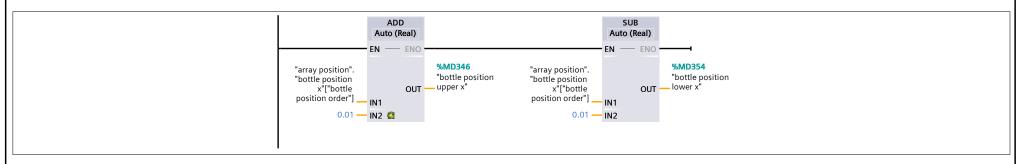
Network 15:

Totally Integrated Automation Portal %M1.3 %M9.3 "in position" "automatic or manual(on)" %M2.6 %M1.6 %M2.4 "state5 timer".Q "state7" "state6" "on mode" %M2.4 "state6" Network 16: %M1.3 %MD296 "automatic or manual(on)" %M2.4 %M2.7 %M1.6 %M2.6 "actual pz" "state6" "state8" "on mode" "state7" >= Real 160.0 %M2.6 "state7" Network 17:

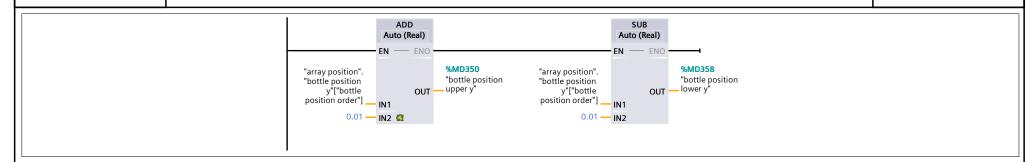




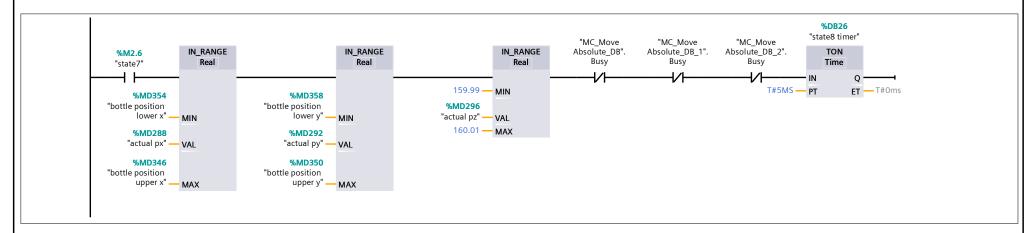
Network 18:



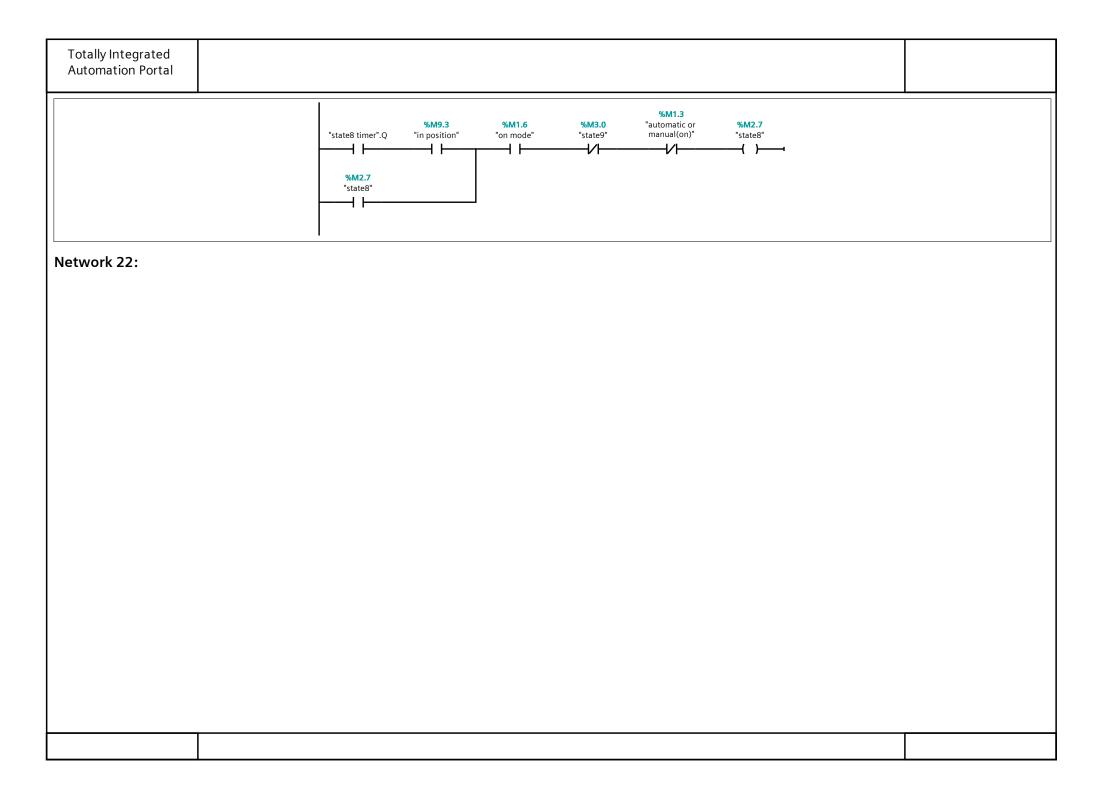
Network 19:

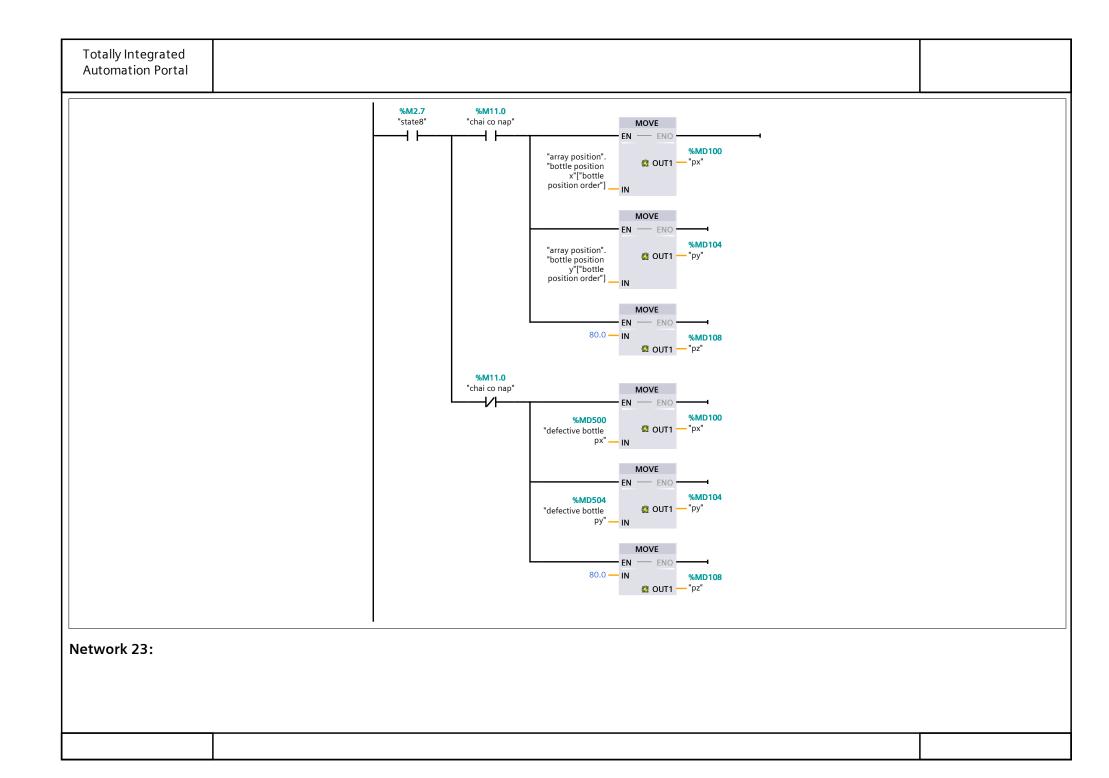


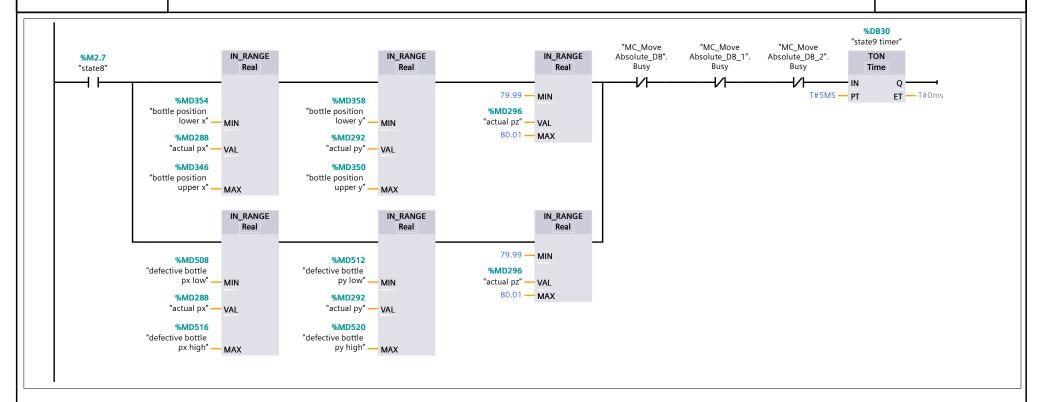
Network 20:



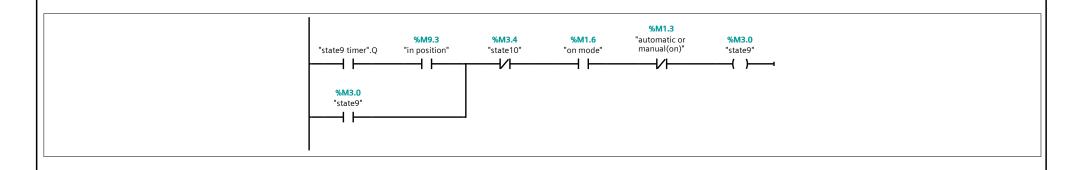
Network 21:



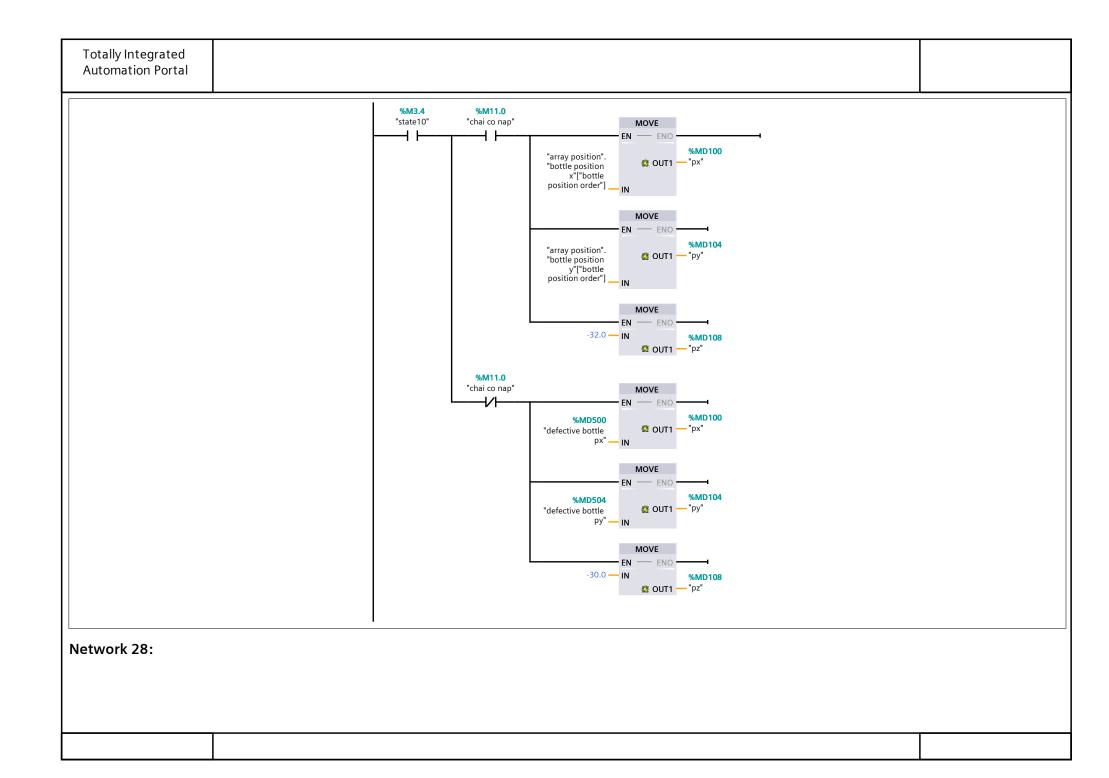


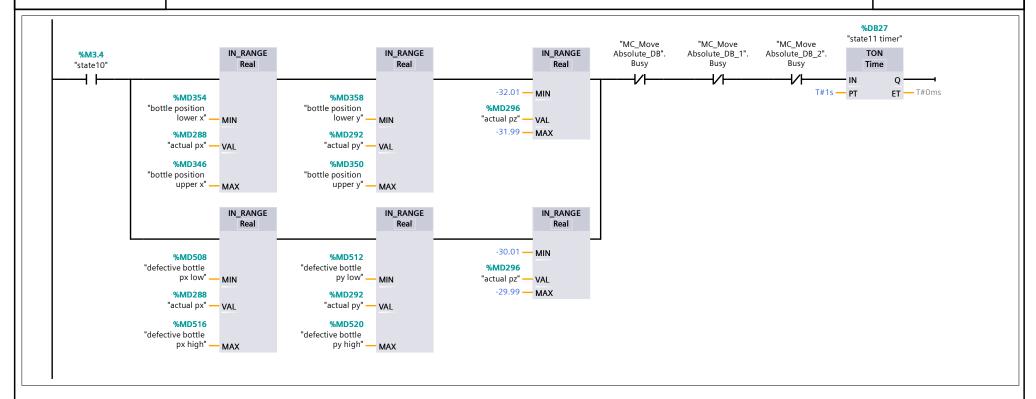


Network 24:

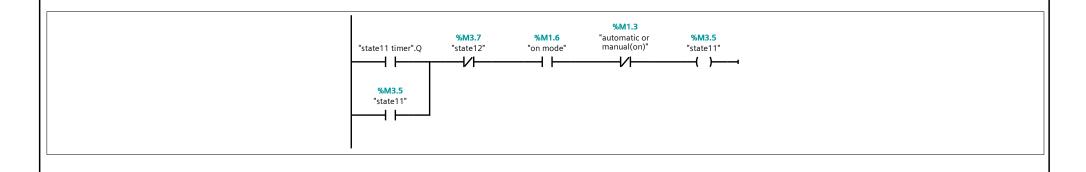


Totally Integrated **Automation Portal** Network 25: %M1.3 %MD296 "automatic or manual(on)" %M11.0 %M3.5 %M3.4 %M3.0 %M1.6 "actual pz" "state9" "chai co nap" "state11" "on mode" "state10" <= Real -32.0 %M3.4 "state10" Network 26: %M1.3 "automatic or manual(on)" %MD296 %M3.0 %M11.0 %M3.5 %M1.6 %M3.4 "actual pz" "state11" "state9" "chai co nap" "on mode" "state10" <= Real -30.0 %M3.4 "state10" Network 27:

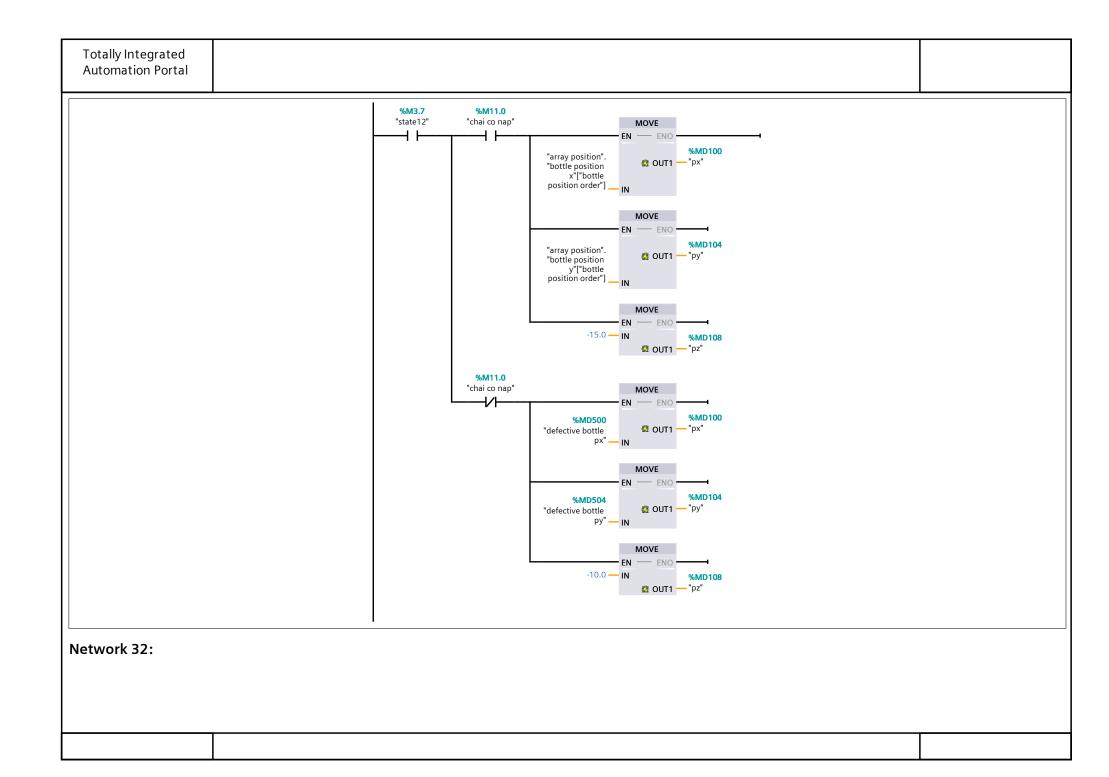


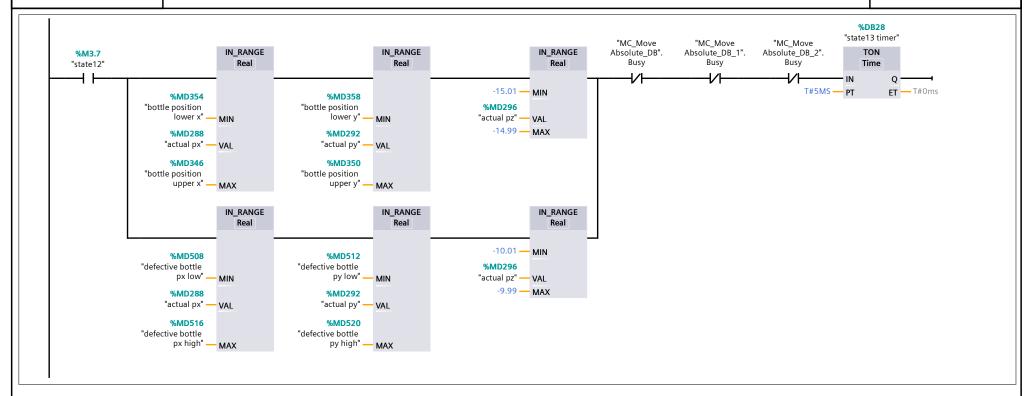


Network 29:



otally Integrated automation Portal					
twork 30:					
			%M1.3		
	%M3.5 "state11"	%MD296 "actual pz" "state1"	%M1.3 %M1.6 "automatic or manual(on)"	%M3.7 "state12"	
		-15.0			
	%M3.7 "state12"				
twork 31:					





Network 33:

Network 34:

Totally Integrated Automation Portal %DB59
"timer yellow led" TON %M1.6 %M14.2 %M14.3 "san pham loi" "Tag_7" Time "on mode" Q-T#2s — PT ET — T#0ms **%M14.3** "Tag_7" "timer yellow led". Q "timer yellow led". ET %Q8.7 "Yellow Led" <= Time -(s)-----T#1s "timer yellow led". ET %Q8.7 "Yellow Led" _(R)____ Time T#1s