

Blower Assembly Bench - Rev06 / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks

Fix_1 [FC1]

Fix_1 Properties

General

Name	Fix_1	Number	1	Type	FC	Language	LAD
------	-------	--------	---	------	----	----------	-----

Numbering	automatic
-----------	-----------

Information

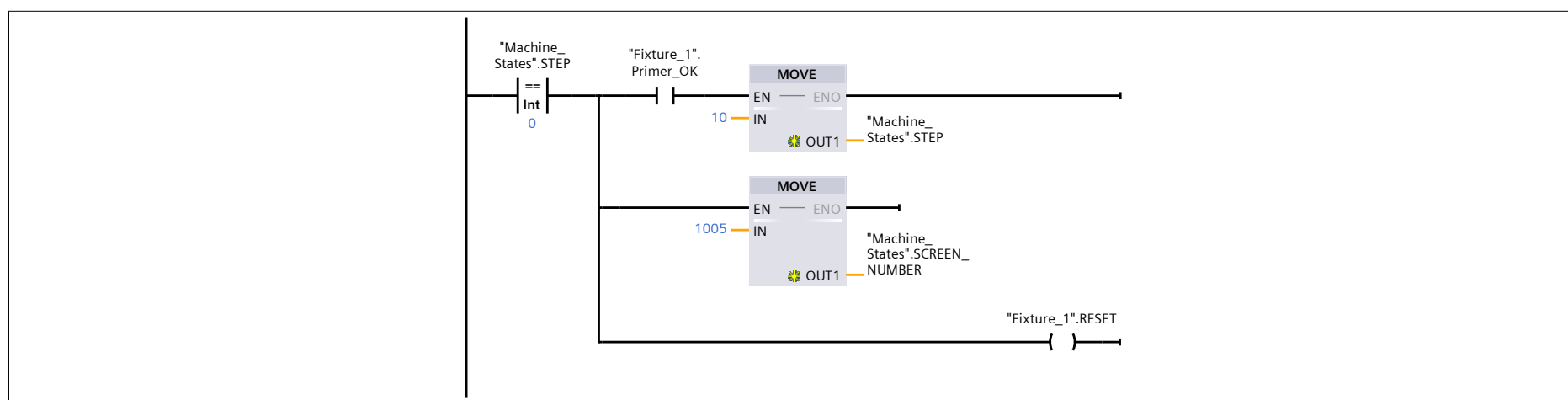
Title		Author		Comment		Family	
-------	--	--------	--	---------	--	--------	--

Version	0.1	User-defined ID	
---------	-----	-----------------	--

Fix_1

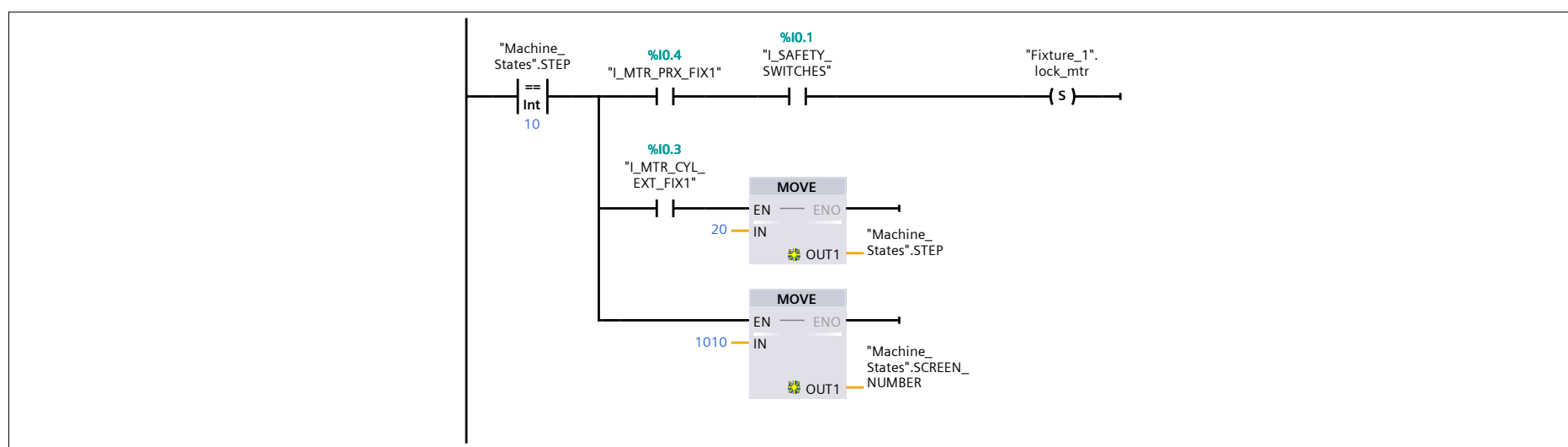
Name	Data type	Default value	Comment
Input			
Output			
▼ InOut			
state	Int		
▼ Temp			
step	Int		
screw_done	Bool		
Constant			
▼ Return			
Fix_1	Void		

Network 1: Primer



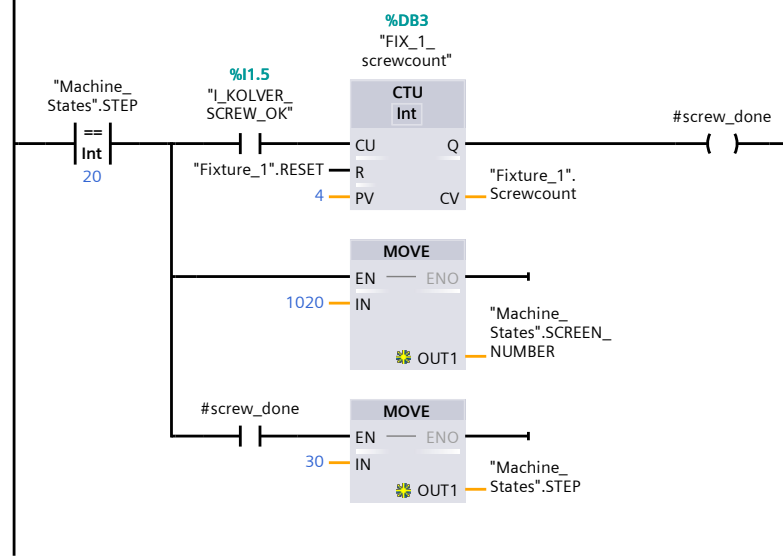
Symbol	Address	Type	Comment
"Fixture_1".Primer_OK		Bool	
"Fixture_1".RESET		Bool	
"Machine_States".SCREEN_NUMBER		Int	
"Machine_States".STEP		Int	

Network 2: Loading



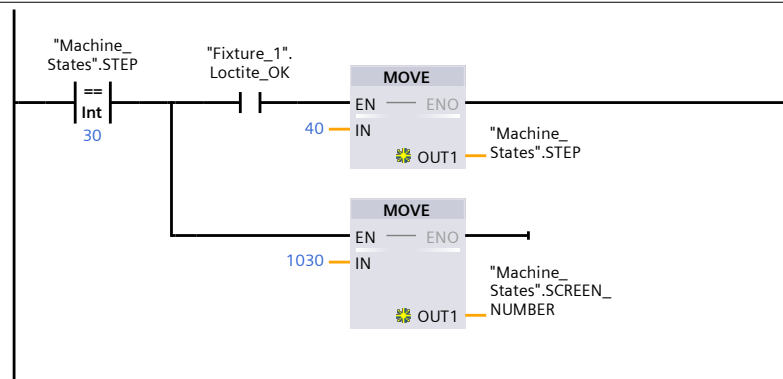
Symbol	Address	Type	Comment
"Fixture_1".lock_mtr		Bool	
"L_MTR_CYL_EXT_FIX1"	%I0.3	Bool	
"L_MTR_PRX_FIX1"	%I0.4	Bool	
"I_SAFETY_SWITCHES"	%I0.1	Bool	
"Machine_States".SCREEN_NUMBER		Int	
"Machine_States".STEP		Int	

Network 3: Kolver



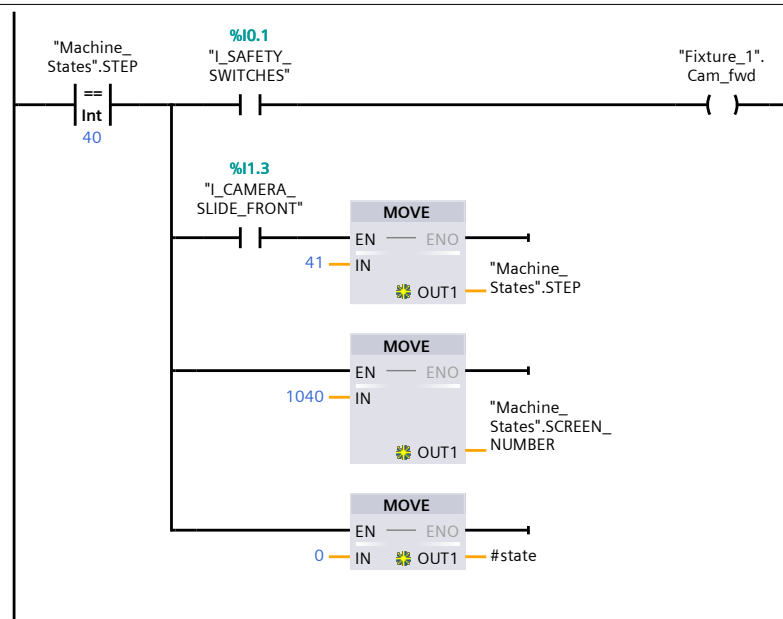
Symbol	Address	Type	Comment
"Fixture_1".RESET		Bool	
"Fixture_1".Screwcount		Int	
"I_KOLVER_SCREW_OK"	%I1.5	Bool	
"Machine_States".SCREEN_NUMBER		Int	
"Machine_States".STEP		Int	
#screw_done		Bool	

Network 4: loctite



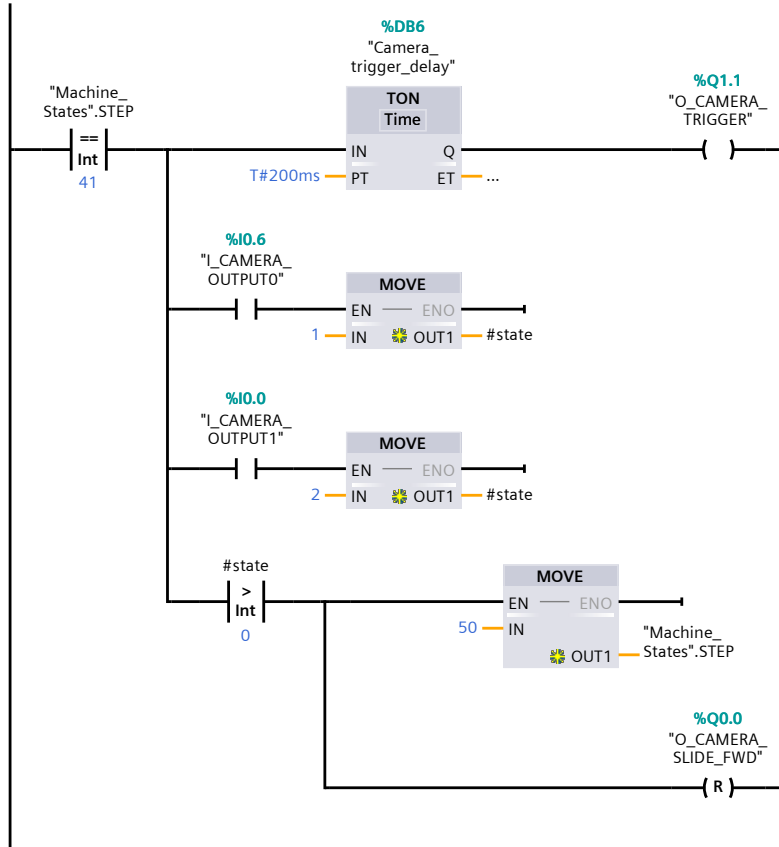
Symbol	Address	Type	Comment
"Fixture_1".Loctite_OK		Bool	
"Machine_States".SCREEN_NUMBER		Int	
"Machine_States".STEP		Int	

Network 5: Camera slide FWD



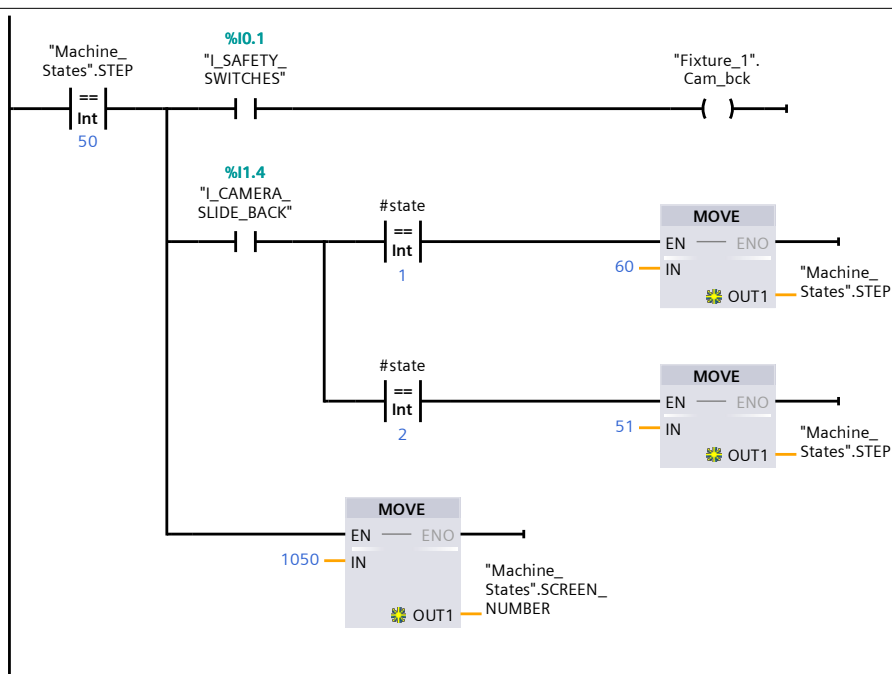
Symbol	Address	Type	Comment
"Fixture_1".Cam_fwd		Bool	
"I_CAMERA_SLIDE_FRONT"	%I1.3	Bool	
"I_SAFETY_SWITCHES"	%I0.1	Bool	
"Machine_States".SCREEN_NUMBER		Int	
"Machine_States".STEP		Int	
#state		Int	

Network 6: Cam Check



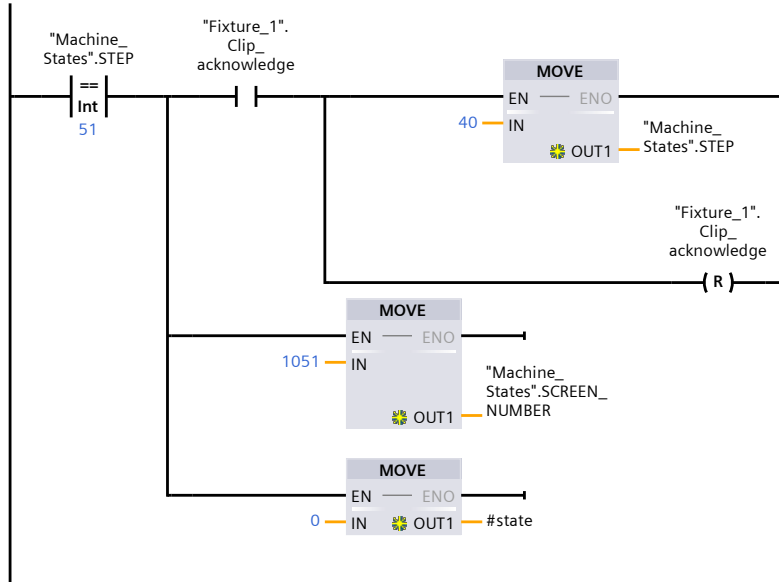
Symbol	Address	Type	Comment
"I_CAMERA_OUTPUT0"	%I0.6	Bool	
"I_CAMERA_OUTPUT1"	%I0.0	Bool	
"Machine_States".STEP		Int	
"O_CAMERA_SLIDE_FWD"	%Q0.0	Bool	
"O_CAMERA_TRIGGER"	%Q1.1	Bool	
#state		Int	

Network 7: Cam slide back



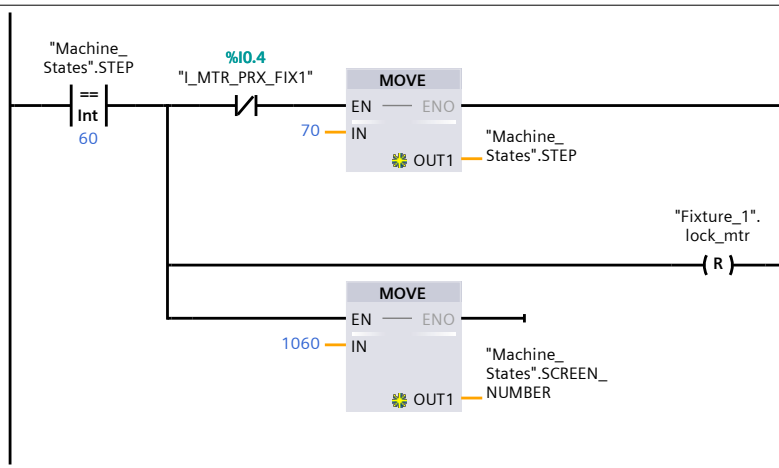
Symbol	Address	Type	Comment
"Fixture_1".Cam_bck		Bool	
"I_CAMERA_SLIDE_BACK"	%I1.4	Bool	
"I_SAFETY_SWITCHES"	%I0.1	Bool	
"Machine_States".SCREEN_NUMBER		Int	
"Machine_States".STEP		Int	
#state		Int	

Network 8: Clip re-check



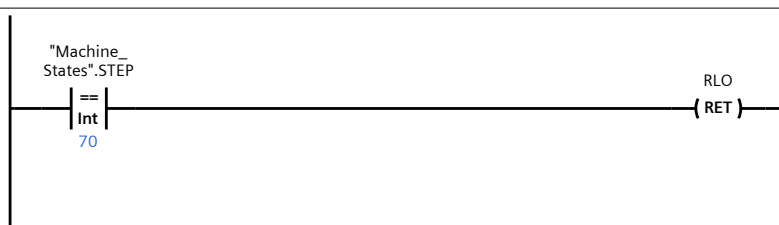
Symbol	Address	Type	Comment
"Fixture_1".Clip_acknowledge		Bool	
"Machine_States".SCREEN_NUMBER		Int	
"Machine_States".STEP		Int	
#state		Int	

Network 9: remove part



Symbol	Address	Type	Comment
"Fixture_1".lock_mtr		Bool	
"I_MTR_PRX_FIX1"	%I0.4	Bool	
"Machine_States".SCREEN_NUMBER		Int	
"Machine_States".STEP		Int	

Network 10: end



Symbol	Address	Type	Comment
"Machine_States".STEP		Int	