

X30PCMFixture_rev3 / PLC_1 [CPU 1215C DC/DC/DC] / Program blocks

Primary_operation [FC1]

Primary_operation Properties

General

Name	Primary_operation	Number	1	Type	FC	Language	LAD
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Numbering	automatic
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Information

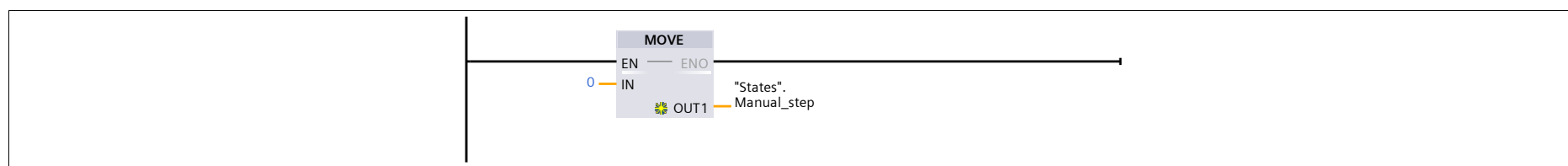
Title		Author		Comment		Family	
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Version	0.1	User-defined ID	
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Primary_operation

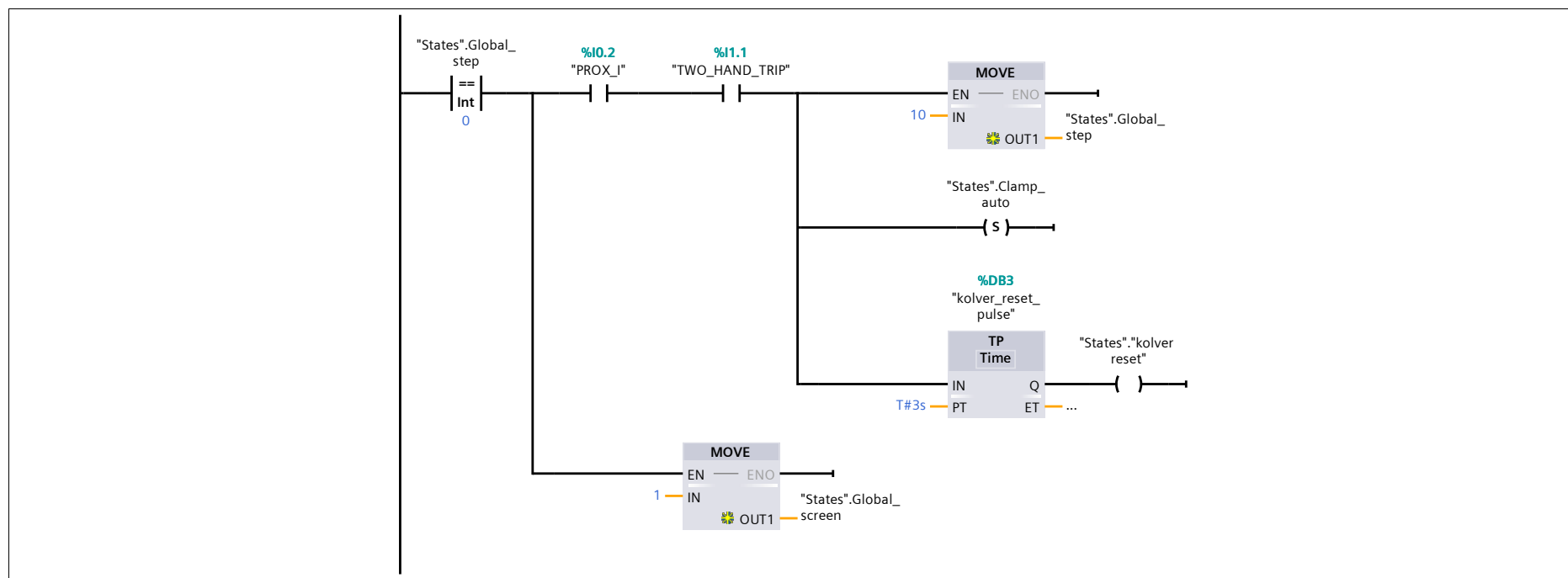
Name	Data type	Default value	Comment
Input			
Output			
InOut			
Temp			
Constant			
Return			
Primary_operation	Void		

Network 1:



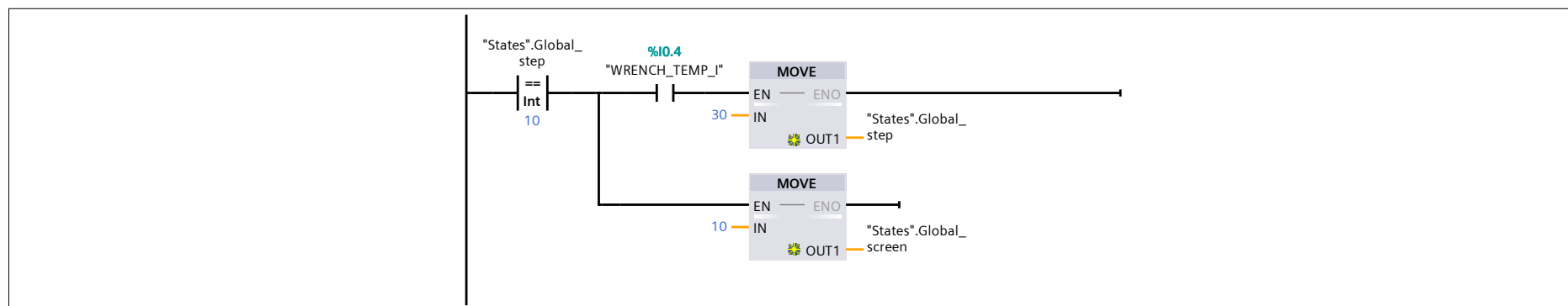
Symbol	Address	Type	Comment
"States".Manual_step		Int	

Network 2: Loading



Symbol	Address	Type	Comment
"PROX_I"	%I0.2	Bool	Input
"States".kolver reset"		Bool	
"States".Clamp_auto		Bool	
"States".Global_step		Int	
"States".Global_screen		Int	
"TWO_HAND_TRIP"	%I1.1	Bool	Input - Guess placeholder for now

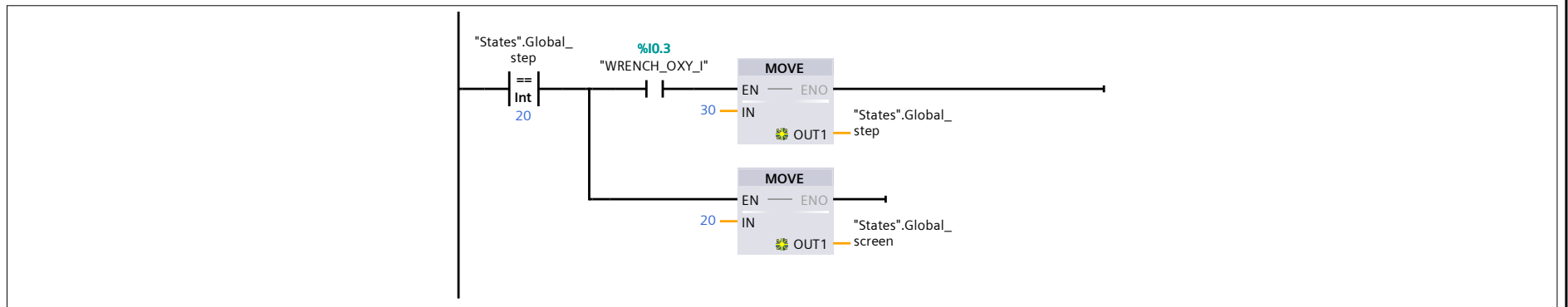
Network 3: Temp Sensor



Symbol	Address	Type	Comment
"States".Global_screen		Int	
"States".Global_step		Int	
"WRENCH_TEMP_I"	%I0.4	Bool	Input

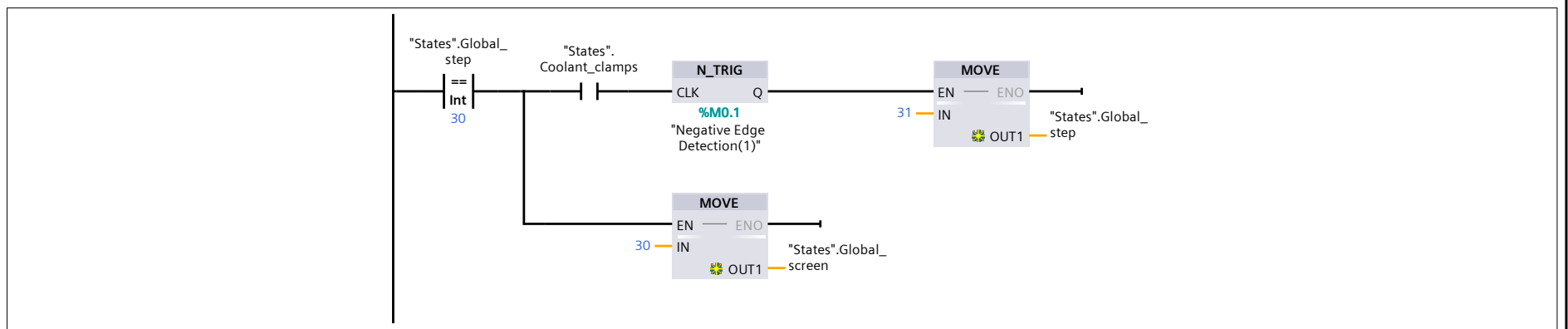
Network 4: plug torque

Omit



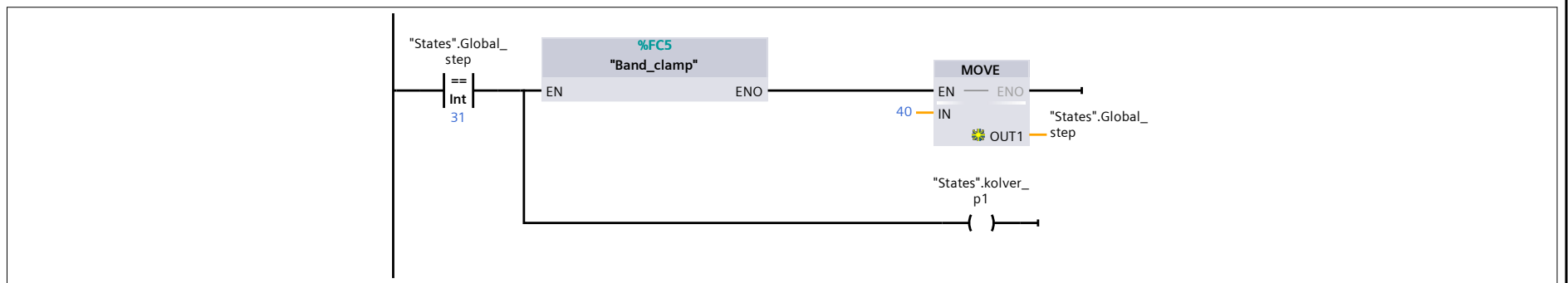
Symbol	Address	Type	Comment
"States".Global_screen		Int	
"States".Global_step		Int	
"WRENCH_OXY_I"	%I0.3	Bool	Input

Network 5: Coolant hose clamps



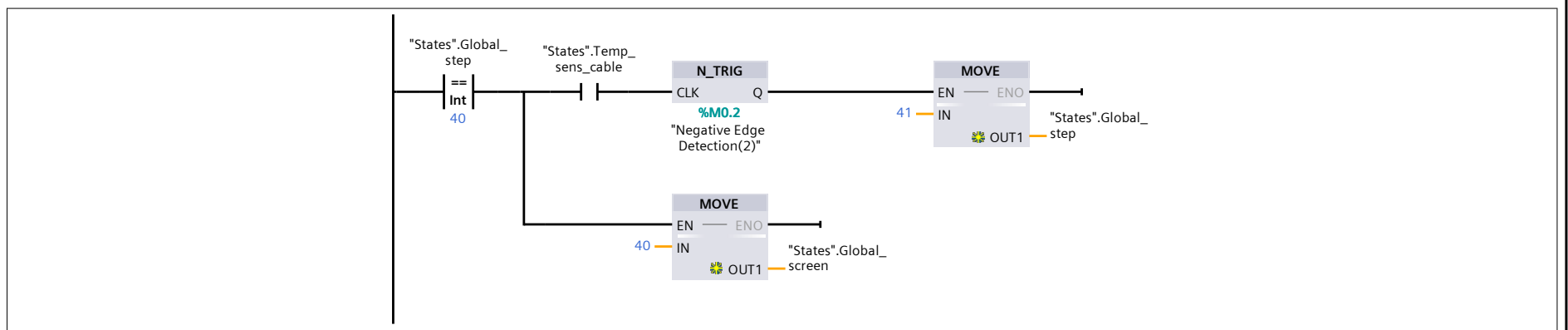
Symbol	Address	Type	Comment
"Negative Edge Detection(1)"	%M0.1	Bool	
"States".Coolant_clamps		Bool	
"States".Global_screen		Int	
"States".Global_step		Int	

Network 6: Band Clamp screw



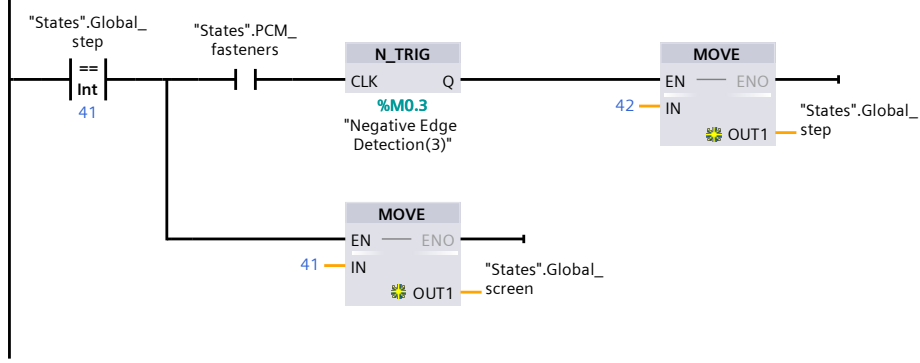
Symbol	Address	Type	Comment
"States".Global_step		Int	
"States".kolver_p1		Bool	

Network 7: Temp sensor cable tie



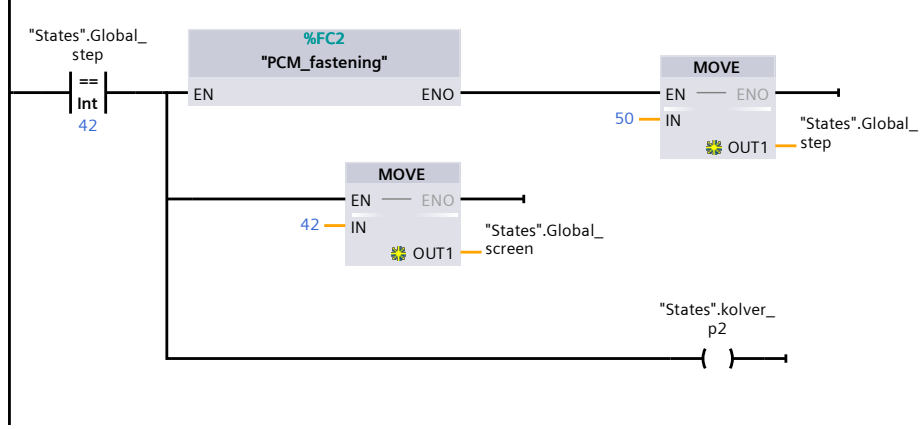
Symbol	Address	Type	Comment
"Negative Edge Detection(2)"	%M0.2	Bool	
"States".Global_screen		Int	
"States".Global_step		Int	
"States".Temp_sens_cable		Bool	

Network 8: Prepare PCM fasteners



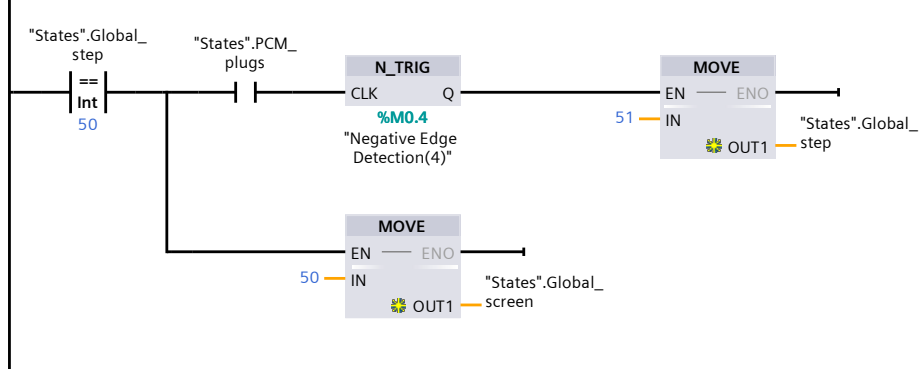
Symbol	Address	Type	Comment
"Negative Edge Detection(3)"	%M0.3	Bool	
"States".Global_screen		Int	
"States".Global_step		Int	
"States".PCM_fasteners		Bool	

Network 9: Fasten PCM



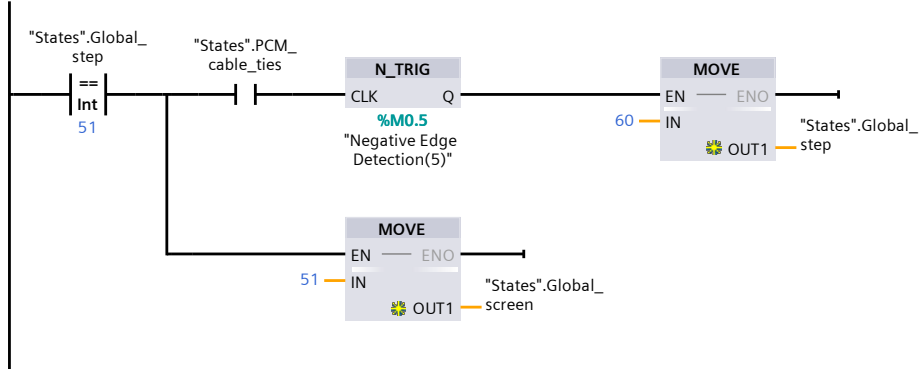
Symbol	Address	Type	Comment
"States".Global_screen		Int	
"States".Global_step		Int	
"States".kolver_p2		Bool	

Network 10: Plugs connected



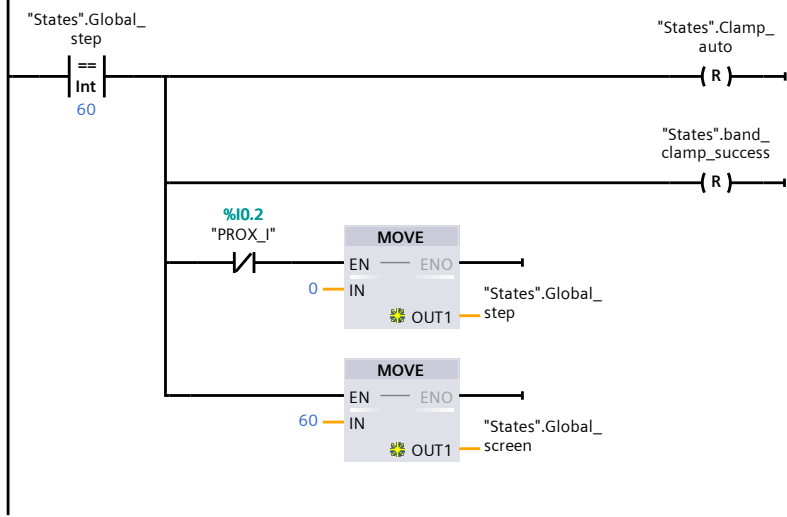
Symbol	Address	Type	Comment
"Negative Edge Detection(4)"	%M0.4	Bool	
"States".Global_screen		Int	
"States".Global_step		Int	
"States".PCM_plugs		Bool	

Network 11: PCM cable ties



Symbol	Address	Type	Comment
"Negative Edge Detection(5)"	%M0.5	Bool	
"States".Global_screen		Int	
"States".Global_step		Int	
"States".PCM_cable_ties		Bool	

Network 12: Unclamp, Remove part



Symbol	Address	Type	Comment
"PROX_I"	%I0.2	Bool	Input
"States".band_clamp_success		Bool	
"States".Clamp_auto		Bool	
"States".Global_screen		Int	
"States".Global_step		Int	