

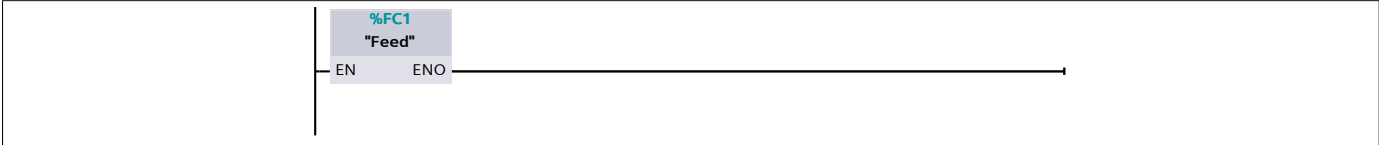
Program blocks

Main [OB1]

| Main Properties | | | | | |
|-----------------|------------------------------|---------|-----|-----------------|----|
| General | | | | | |
| Name | Main | Number | 1 | Type | OB |
| Language | LAD | | | | |
| Information | | | | | |
| Title | "Main Program Sweep (Cycle)" | Author | | Comment | |
| Family | | Version | 0.1 | User-defined ID | |

| Name | Data type | Offset | Comment |
|----------------|---------------|--------|---|
| ▼ Temp | | | |
| OB1_EV_CLASS | Byte | | Bits 0-3 = 1 (Coming event), Bits 4-7 = 1 (Event class 1) |
| OB1_SCAN_1 | Byte | | 1 (Cold restart scan 1 of OB 1), 3 (Scan 2-n of OB 1) |
| OB1_PRIORITY | Byte | | Priority of OB Execution |
| OB1_OB_NUMBR | Byte | | 1 (Organization block 1, OB1) |
| OB1_RESERVED_1 | Byte | | Reserved for system |
| OB1_RESERVED_2 | Byte | | Reserved for system |
| OB1_PREV_CYCLE | Int | | Cycle time of previous OB1 scan (milliseconds) |
| OB1_MIN_CYCLE | Int | | Minimum cycle time of OB1 (milliseconds) |
| OB1_MAX_CYCLE | Int | | Maximum cycle time of OB1 (milliseconds) |
| OB1_DATE_TIME | Date_And_Time | | Date and time OB1 started |

Network 1:



| Symbol | Address | Type | Comment |
|--------|---------|----------|---------|
| "Feed" | %FC1 | Block_FC | |

Network 2:



| Symbol | Address | Type | Comment |
|-----------------|---------|----------|---------|
| "Load_to_plate" | %FC2 | Block_FC | |

Network 3:

Totally Integrated Automation Portal

%FC3
"Plate"

EN

ENO

| Symbol | Address | Type | Comment |
|---------|---------|----------|---------|
| "Plate" | %FC3 | Block_FC | |

Network 4:

%FC4
"Evacuate"

EN

ENO

| Symbol | Address | Type | Comment |
|------------|---------|----------|---------|
| "Evacuate" | %FC4 | Block_FC | |

Network 5:

%FC5
"Unload"

EN

ENO

| Symbol | Address | Type | Comment |
|----------|---------|----------|---------|
| "Unload" | %FC5 | Block_FC | |

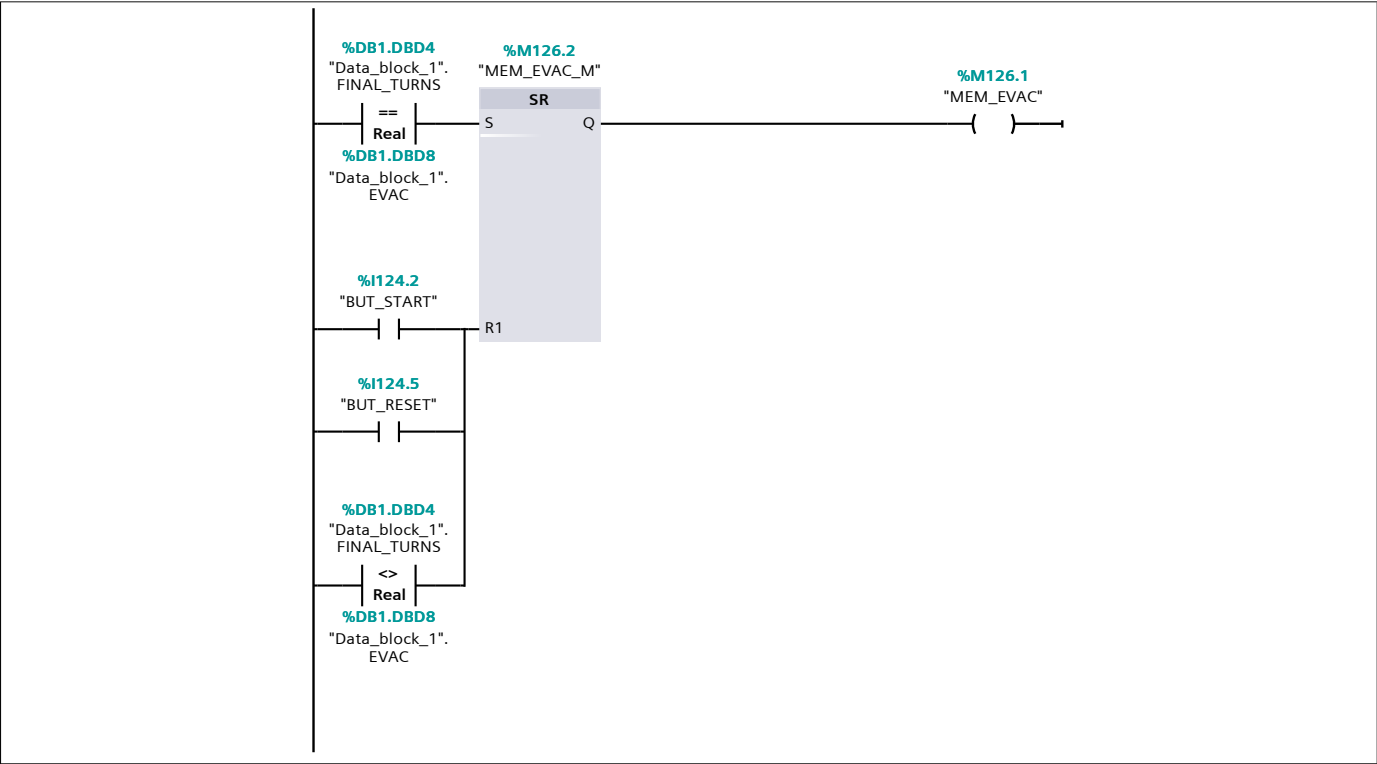
Program blocks

Evacuate [FC4]

| Evacuate Properties | | | | | |
|---------------------|----------------|---------|--------|-----------------|---|
| General | | | | | |
| Name | Evacuate | Number | 4 | Type | FC |
| Language | LAD | | | | |
| Information | | | | | |
| Title | Evakuační blok | Author | xmaly6 | Comment | Tento blok má za úkol za- jistit vyřazení nevhodné- ho krytu. |
| Family | | Version | 0.1 | User-defined ID | |

| Name | Data type | Offset | Comment |
|----------|-----------|--------|---------|
| Input | | | |
| Output | | | |
| InOut | | | |
| Temp | | | |
| ▼ Return | | | |
| Ret_Val | Void | | |

Network 1: Signalizace, že bylo rozhodnuto o vyhození krytu



| Symbol | Address | Type | Comment |
|---------------------------------|-----------|----------|---------|
| "Data_block_1" | %DB1 | Block_DB | |
| "Data_block_1".FI- NAL_TURNS | %DB1.DBD4 | Real | |
| "BUT_START" | %I124.2 | Bool | |

Totally Integrated Automation Portal

| Symbol | Address | Type | Comment |
|---------------------|-----------|------|---------|
| "MEM_EVAC_M" | %M126.2 | Bool | |
| "MEM_EVAC" | %M126.1 | Bool | |
| "BUT_RESET" | %I124.5 | Bool | |
| "Data_block_1".EVAC | %DB1.DBD8 | Real | |

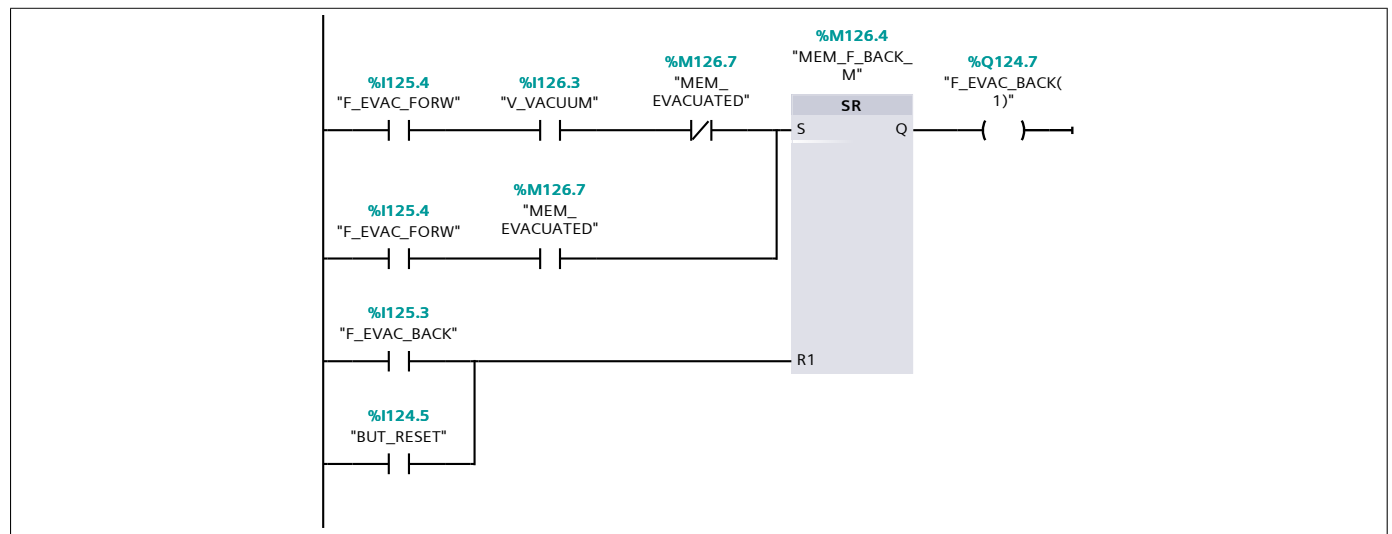
Network 2: Signalizace, že kryt čeká na pozici pro vzhození

| Symbol | Address | Type | Comment |
|--------------------------|-----------|----------|---------|
| "Data_block_1" | %DB1 | Block_DB | |
| 2538.0 | 2538.0 | LReal | |
| "BUT_START" | %I124.2 | Bool | |
| "MEM_EVAC" | %M126.1 | Bool | |
| "Data_block_1".NUM_TURNS | %DB1.DBD0 | Real | |
| 3005.0 | 3005.0 | LReal | |
| "F_EVAC_FORW" | %I125.4 | Bool | |
| "MEM_EVACUATED" | %M126.7 | Bool | |
| "MEM_COVER_EVAC_POS_M" | %M127.2 | Bool | |
| "MEM_COVER_EVAC_POS" | %M127.1 | Bool | |

Network 3: Vyjetí vyhazovače F

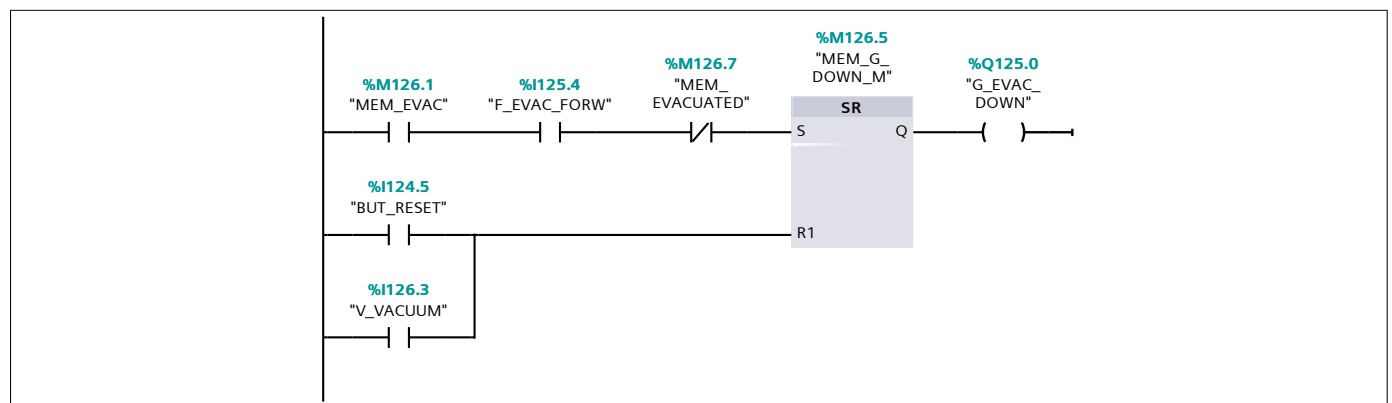
| Symbol | Address | Type | Comment |
|---------------------------|---------|------|---------|
| "MEM_EVAC" | %M126.1 | Bool | |
| "G_EVAC_UP" | %I125.5 | Bool | |
| "F_EVAC_FORW(1)" | %Q124.6 | Bool | |
| "MEM_F_FORW_M" | %M126.3 | Bool | |
| "BUT_RESET" | %I124.5 | Bool | |
| "F_EVAC_FORW" | %I125.4 | Bool | |
| "MEM_EVACUATED" | %M126.7 | Bool | |
| "MEM_COV- ER_EVAC_POS" | %M127.1 | Bool | |

Network 4: Zajetí vyhazovače F

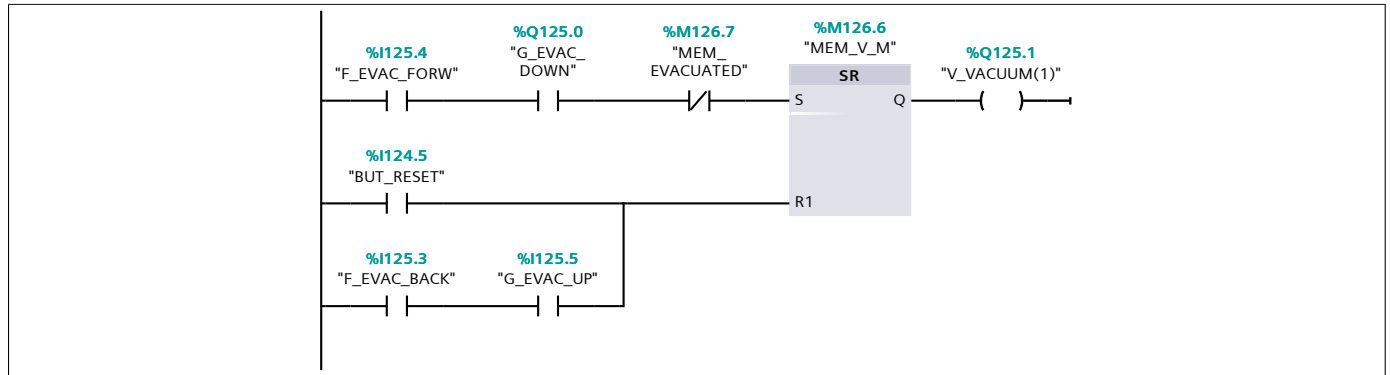


| Symbol | Address | Type | Comment |
|------------------|---------|------|---------|
| "F_EVAC_BACK" | %I125.3 | Bool | |
| "BUT_RESET" | %I124.5 | Bool | |
| "MEM_F_BACK_M" | %M126.4 | Bool | |
| "F_EVAC_BACK(1)" | %Q124.7 | Bool | |
| "F_EVAC_FORW" | %I125.4 | Bool | |
| "V_VACUUM" | %I126.3 | Bool | |
| "MEM_EVACUATED" | %M126.7 | Bool | |

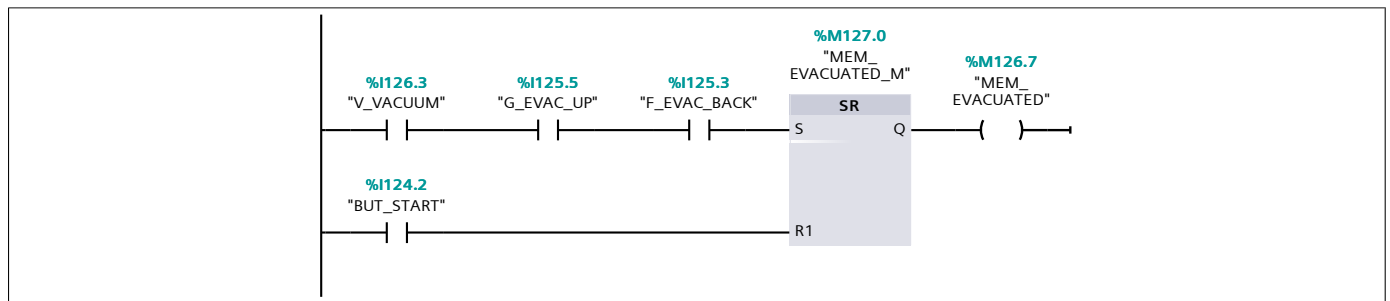
Network 5: Ovládání sjetí vyhazovače G



| Symbol | Address | Type | Comment |
|-----------------|---------|------|---------|
| "MEM_EVAC" | %M126.1 | Bool | |
| "BUT_RESET" | %I124.5 | Bool | |
| "F_EVAC_FORW" | %I125.4 | Bool | |
| "MEM_G_DOWN_M" | %M126.5 | Bool | |
| "G_EVAC_DOWN" | %Q125.0 | Bool | |
| "V_VACUUM" | %I126.3 | Bool | |
| "MEM_EVACUATED" | %M126.7 | Bool | |

Network 6: Sepnutí vakuové přísavky V

| Symbol | Address | Type | Comment |
|-----------------|---------|------|---------|
| "G_EVAC_UP" | %I125.5 | Bool | |
| "F_EVAC_BACK" | %I125.3 | Bool | |
| "BUT_RESET" | %I124.5 | Bool | |
| "F_EVAC_FORW" | %I125.4 | Bool | |
| "G_EVAC_DOWN" | %Q125.0 | Bool | |
| "MEM_V_M" | %M126.6 | Bool | |
| "V_VACUUM(1)" | %Q125.1 | Bool | |
| "MEM_EVACUATED" | %M126.7 | Bool | |

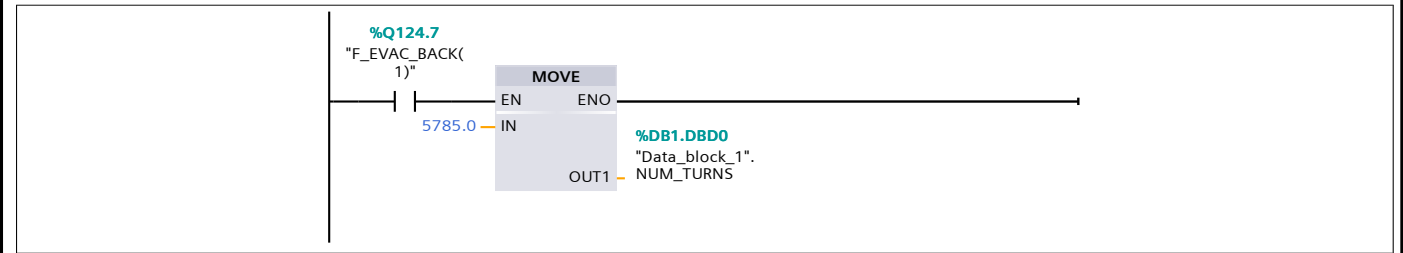
Network 7: Signalizace vyloučení krytu vyhazovačem

| Symbol | Address | Type | Comment |
|-------------------|---------|------|---------|
| "BUT_START" | %I124.2 | Bool | |
| "G_EVAC_UP" | %I125.5 | Bool | |
| "F_EVAC_BACK" | %I125.3 | Bool | |
| "V_VACUUM" | %I126.3 | Bool | |
| "MEM_EVACUATED_M" | %M127.0 | Bool | |
| "MEM_EVACUATED" | %M126.7 | Bool | |

Network 8: Signalizace že kryt byl vyzvednut

```
graph LR
    Q1247["%Q124.7  
\"F_EVAC_BACK(1)\""] --> EN
    subgraph MOVE_BLOCK [MOVE]
        direction TB
        EN --- ENO[ENO]
        IN[IN] --- OUT1[OUT1]
    end
    57850["5785.0"] --> IN
    OUT1 --> DBDO0["%DB1.DBDO0  
\"Data_block_1\".  
NUM_TURNS"]
    ENO --> RightLine[ ]
    style RightLine width:0px,height:0px
```

| Symbol | Address | Type | Comment |
|--------------------------|------------|----------|---------|
| "Data_block_1" | %DB1 | Block_DB | |
| "Data_block_1".NUM_TURNS | %DB1.DBDO0 | Real | |
| "F_EVAC_BACK(1)" | %Q124.7 | Bool | |
| 5785.0 | 5785.0 | LReal | |



| Symbol | Address | Type | Comment |
|-----------------------------------|-----------|----------|---------|
| "Data_block_1" | %DB1 | Block_DB | |
| "Da- ta_block_1".NUM_TURN S | %DB1.DBDO | Real | |
| "F_EVAC_BACK(1)" | %Q124.7 | Bool | |
| 5785.0 | 5785.0 | LReal | |

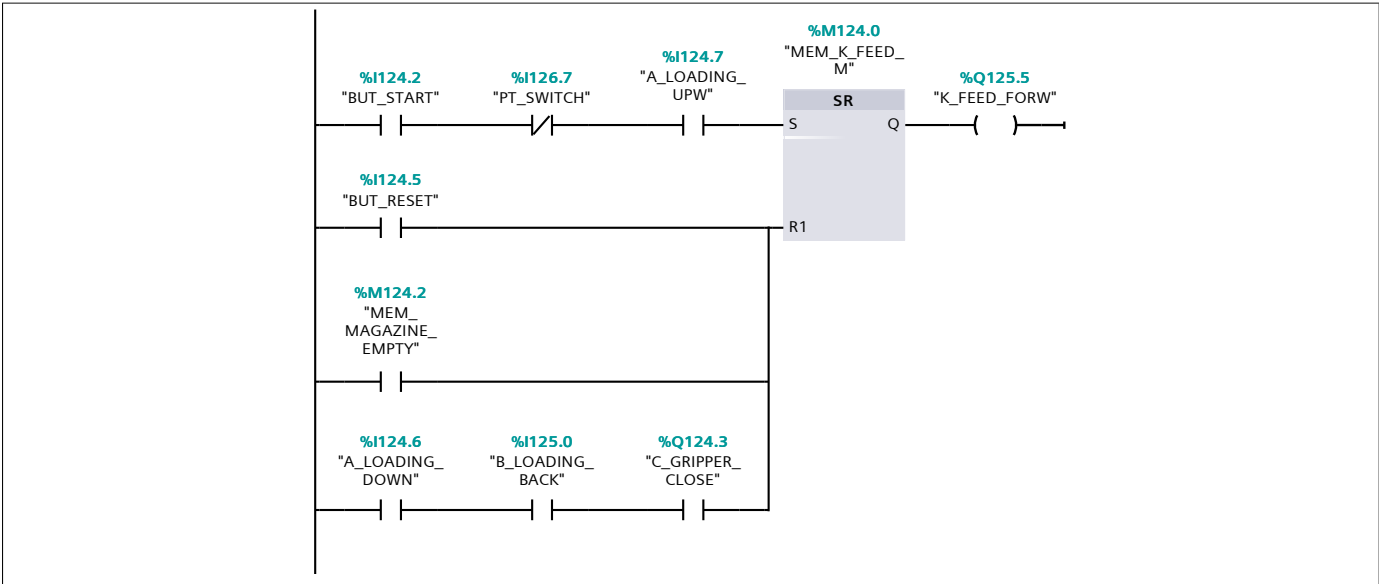
Program blocks

Feed [FC1]

| Feed Properties | | | | | |
|-----------------|-----------|---------|--------|-----------------|--|
| General | | | | | |
| Name | Feed | Number | 1 | Type | FC |
| Language | LAD | | | | |
| Information | | | | | |
| Title | Feed blok | Author | xmaly6 | Comment | Tento funkční blok má za úkol zajistit podání krytu ze zásobníku, ověřit jeho podání či případně signalizovat prázdný zásobník |
| Family | | Version | 0.1 | User-defined ID | |

| Name | Data type | Offset | Comment |
|----------|-----------|--------|---------|
| Input | | | |
| Output | | | |
| InOut | | | |
| Temp | | | |
| ▼ Return | | | |
| Ret_Val | Void | | |

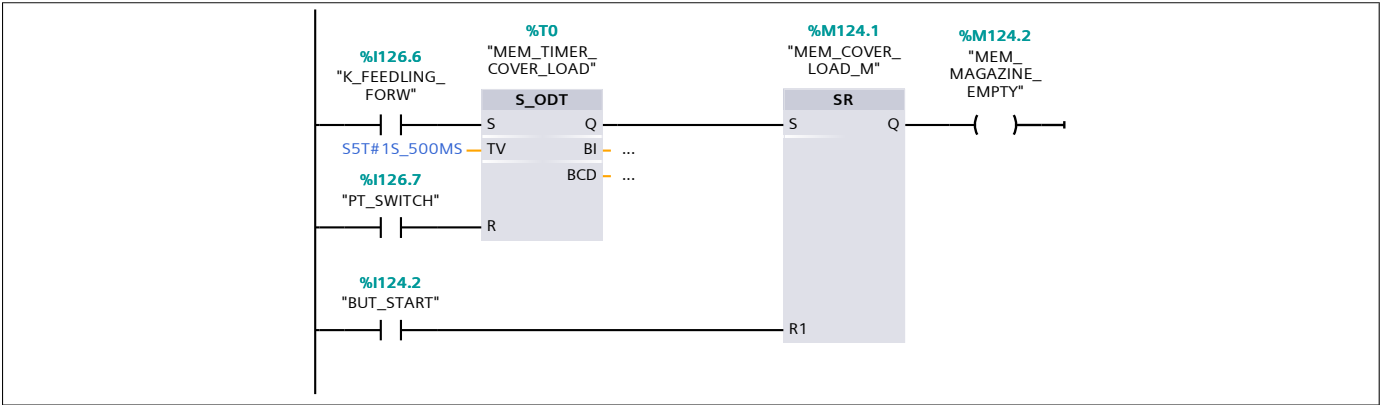
Network 1: Podání krytu ze zásobníku pomocí podavače krytů K



| Symbol | Address | Type | Comment |
|-----------------|---------|------|---------|
| "BUT_START" | %I124.2 | Bool | |
| "BUT_RESET" | %I124.5 | Bool | |
| "MEM_K_FEED_M" | %M124.0 | Bool | |
| "K_FEED_FORW" | %Q125.5 | Bool | |
| "PT_SWITCH" | %I126.7 | Bool | |
| "A_LOADING_UPW" | %I124.7 | Bool | |

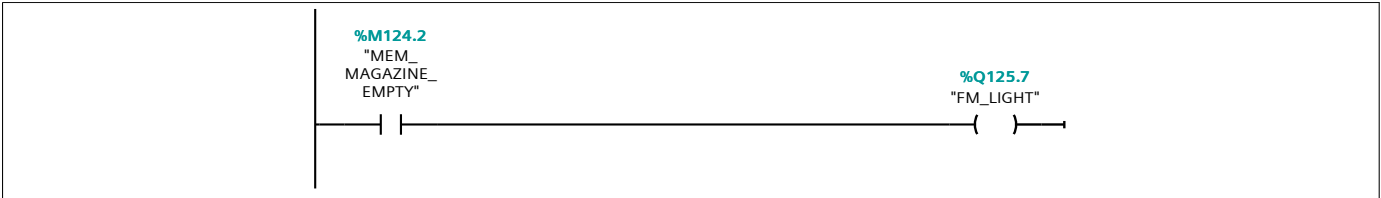
| Symbol | Address | Type | Comment |
|----------------------|---------|------|---------|
| "MEM_MAGAZINE_EMPTY" | %M124.2 | Bool | |
| "A_LOADING_DOWN" | %I124.6 | Bool | |
| "B_LOADING_BACK" | %I125.0 | Bool | |
| "C_GRIPPER_CLOSE" | %Q124.3 | Bool | |

Network 2: Detekce nepodání krytu



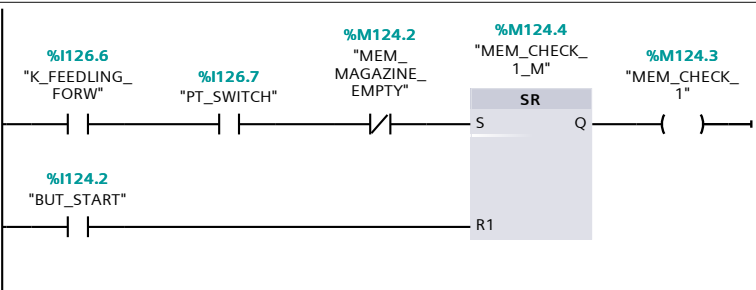
| Symbol | Address | Type | Comment |
|------------------------|--------------|--------|---------|
| "BUT_START" | %I124.2 | Bool | |
| "PT_SWITCH" | %I126.7 | Bool | |
| "MEM_TIMER_COVER_LOAD" | %T0 | Timer | |
| S5T#1S_500MS | S5T#1S_500MS | S5Time | |
| "K_FEEDLING_FORW" | %I126.6 | Bool | |
| "MEM_COVER_LOAD_M" | %M124.1 | Bool | |
| "MEM_MAGAZINE_EMPTY" | %M124.2 | Bool | |

Network 3: Signalizace prázdného zásobníku pomocí FM světla



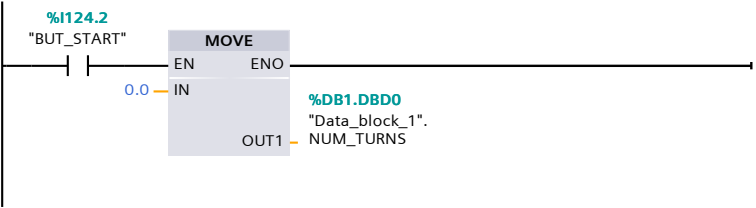
| Symbol | Address | Type | Comment |
|----------------------|---------|------|---------|
| "MEM_MAGAZINE_EMPTY" | %M124.2 | Bool | |
| "FM_LIGHT" | %Q125.7 | Bool | |

Network 4: Kontrolní bod I. signalizující podání krytu ze zásobníku a připravení na přenos



| Symbol | Address | Type | Comment |
|----------------------|---------|------|---------|
| "BUT_START" | %I124.2 | Bool | |
| "PT_SWITCH" | %I126.7 | Bool | |
| "K_FEEDLING_FORW" | %I126.6 | Bool | |
| "MEM_MAGAZINE_EMPTY" | %M124.2 | Bool | |
| "MEM_CHECK_1_M" | %M124.4 | Bool | |
| "MEM_CHECK_1" | %M124.3 | Bool | |

Network 5: Vynulování čítače pro počet otoček stolu



| Symbol | Address | Type | Comment |
|--------------------------|-----------|----------|---------|
| "BUT_START" | %I124.2 | Bool | |
| "Data_block_1" | %DB1 | Block_DB | |
| 0.0 | 0.0 | LReal | |
| "Data_block_1".NUM_TURNS | %DB1.DBDO | Real | |

Program blocks

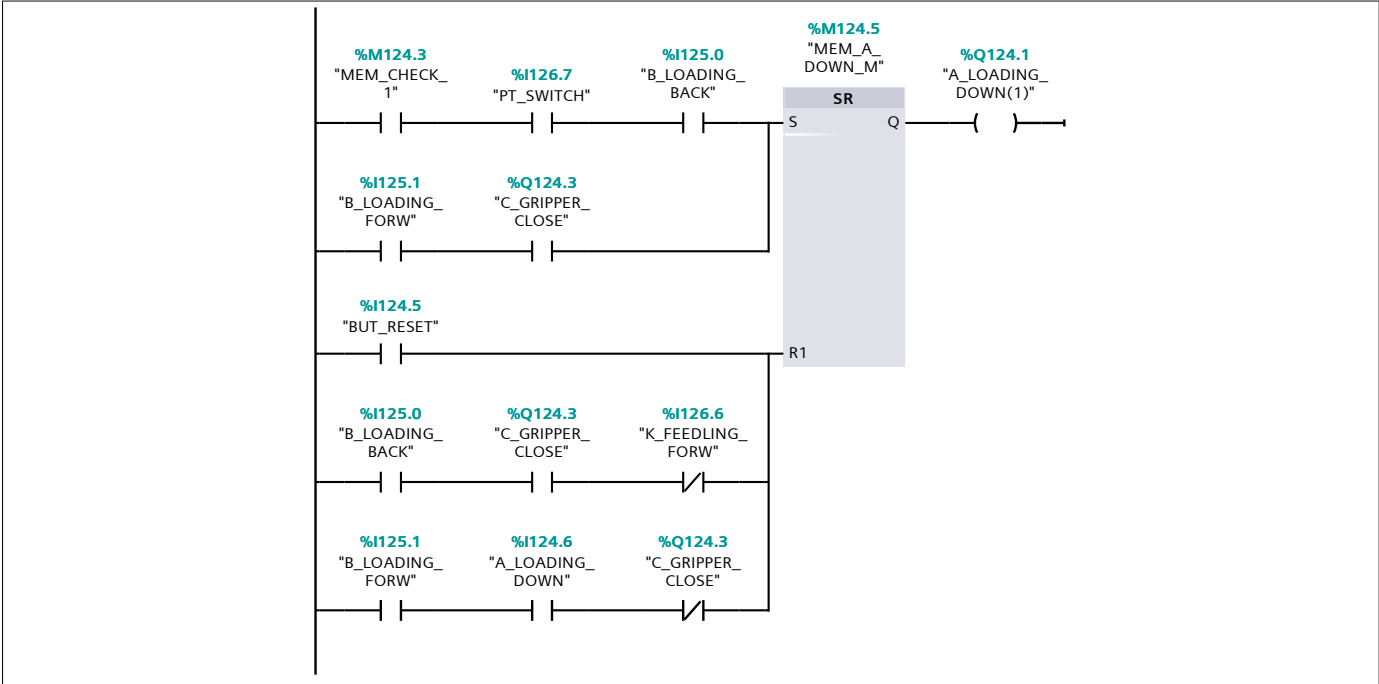
Load_to_plate [FC2]

Load_to_plate Properties

| General | | | | | |
|-------------|--------------------|---------|--------|-----------------|---|
| Name | Load_to_plate | Number | 2 | Type | FC |
| Language | LAD | | | | |
| Information | | | | | |
| Title | Load to plate blok | Author | xmaly6 | Comment | Cílem toho bloku je po úspěšném podání krytu ze zásobníku zajistit jeho dopravení na otočný stůl. |
| Family | | Version | 0.1 | User-defined ID | |

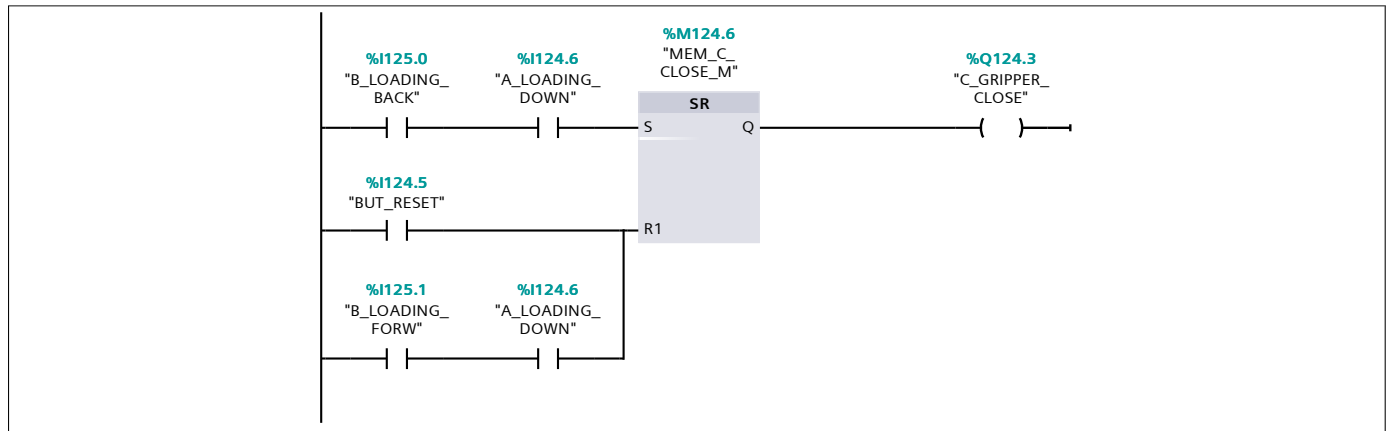
| Name | Data type | Offset | Comment |
|----------|-----------|--------|---------|
| Input | | | |
| Output | | | |
| InOut | | | |
| Temp | | | |
| ▼ Return | | | |
| Ret_Val | Void | | |

Network 1: Ovládání sjetí podavače krytu A

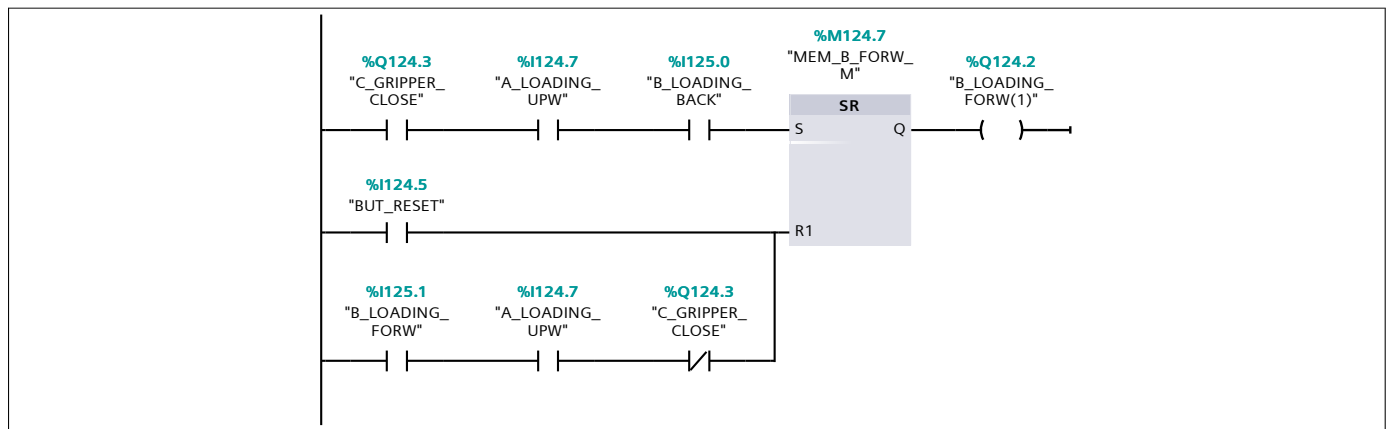


| Symbol | Address | Type | Comment |
|---------------------|---------|------|---------|
| "BUT_RESET" | %I124.5 | Bool | |
| "MEM_A_DOWN_M" | %M124.5 | Bool | |
| "A_LOADING_DOWN(1)" | %Q124.1 | Bool | |
| "MEM_CHECK_1" | %M124.3 | Bool | |
| "PT_SWITCH" | %I126.7 | Bool | |
| "B_LOADING_BACK" | %I125.0 | Bool | |

| Symbol | Address | Type | Comment |
|-------------------|---------|------|---------|
| "C_GRIPPER_CLOSE" | %Q124.3 | Bool | |
| "A_LOADING_DOWN" | %I124.6 | Bool | |
| "K_FEEDLING_FORW" | %I126.6 | Bool | |
| "B_LOADING_FORW" | %I125.1 | Bool | |

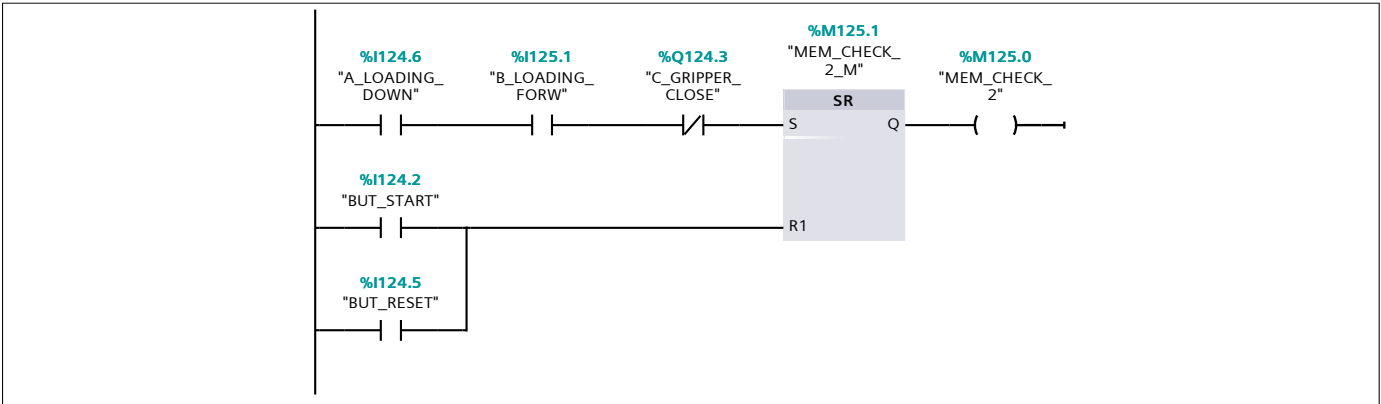
Network 2: Ovládání sevření cvakače C

| Symbol | Address | Type | Comment |
|-------------------|---------|------|---------|
| "BUT_RESET" | %I124.5 | Bool | |
| "B_LOADING_BACK" | %I125.0 | Bool | |
| "C_GRIPPER_CLOSE" | %Q124.3 | Bool | |
| "MEM_C_CLOSE_M" | %M124.6 | Bool | |
| "A_LOADING_DOWN" | %I124.6 | Bool | |
| "B_LOADING_FORW" | %I125.1 | Bool | |

Network 3: Ovládání přenašeče B krytů na stůl

| Symbol | Address | Type | Comment |
|---------------------|---------|------|---------|
| "BUT_RESET" | %I124.5 | Bool | |
| "B_LOADING_BACK" | %I125.0 | Bool | |
| "C_GRIPPER_CLOSE" | %Q124.3 | Bool | |
| "MEM_B_FORW_M" | %M124.7 | Bool | |
| "B_LOADING_FORW(1)" | %Q124.2 | Bool | |
| "B_LOADING_FORW" | %I125.1 | Bool | |
| "A_LOADING_UPW" | %I124.7 | Bool | |

Network 4: Kontrolní bod II. signalizující umístění ložiska na stůl



| Symbol | Address | Type | Comment |
|-------------------|---------|------|---------|
| "BUT_RESET" | %I124.5 | Bool | |
| "C_GRIPPER_CLOSE" | %Q124.3 | Bool | |
| "A_LOADING_DOWN" | %I124.6 | Bool | |
| "B_LOADING_FORW" | %I125.1 | Bool | |
| "MEM_CHECK_2" | %M125.0 | Bool | |
| "MEM_CHECK_2_M" | %M125.1 | Bool | |
| "BUT_START" | %I124.2 | Bool | |

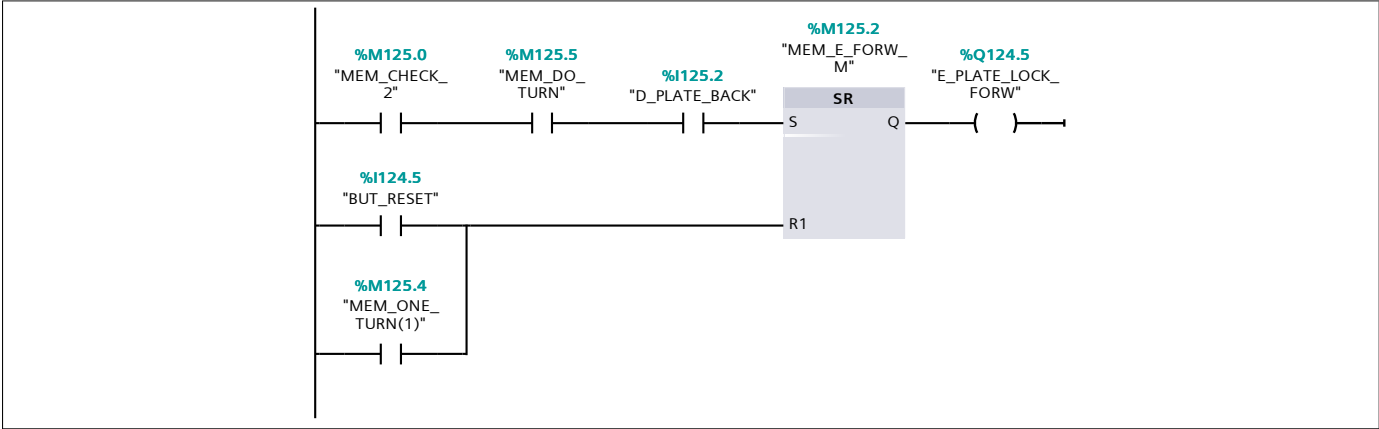
Program blocks

Plate [FC3]

| Plate Properties | | | | | |
|------------------|--------------------|---------|--------|-----------------|--|
| General | | | | | |
| Name | Plate | Number | 3 | Type | FC |
| Language | LAD | | | | |
| Information | | | | | |
| Title | Plate funkční blok | Author | xmaly6 | Comment | Tento blok řídí ovládání otočného stolu, kde zároveň i probíhá měření vlastností podaného krytu. |
| Family | | Version | 0.1 | User-defined ID | |

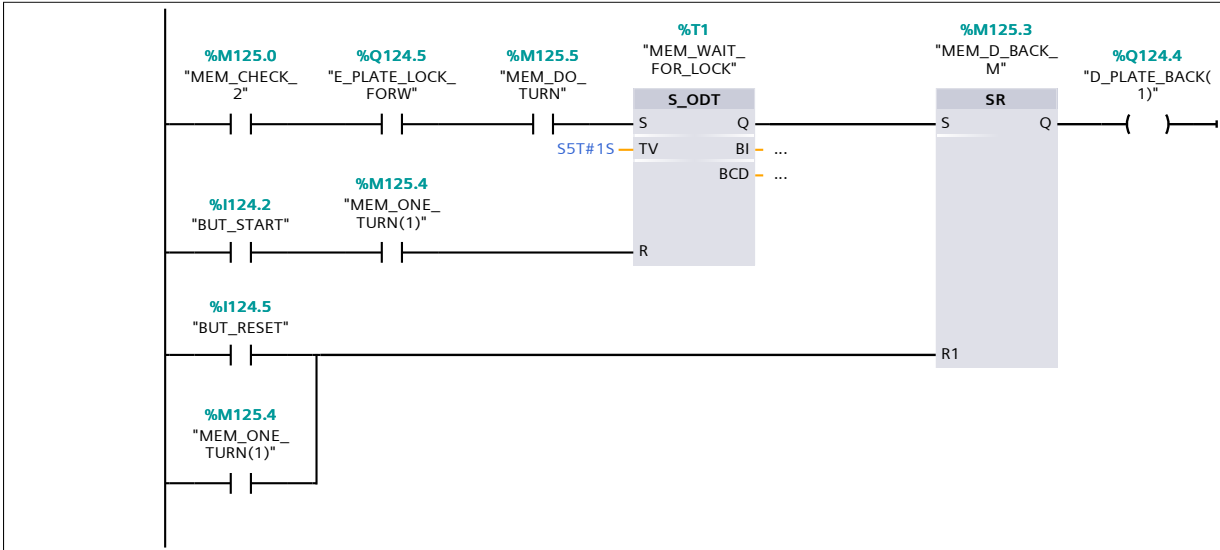
| Name | Data type | Offset | Comment |
|----------|-----------|--------|---------|
| Input | | | |
| Output | | | |
| InOut | | | |
| Temp | | | |
| ▼ Return | | | |
| Ret_Val | Void | | |

Network 1: Ovládání vysunutí cylindru E pro uchycení stolu pro pohyb



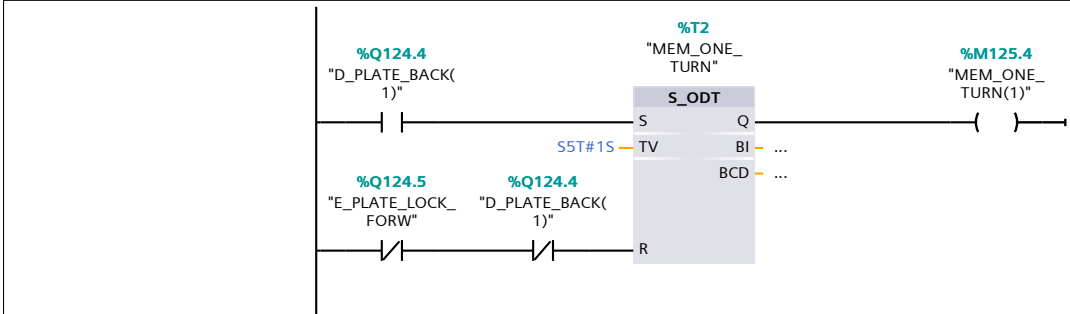
| Symbol | Address | Type | Comment |
|---------------------|---------|------|---------|
| "MEM_CHECK_2" | %M125.0 | Bool | |
| "BUT_RESET" | %I124.5 | Bool | |
| "MEM_E_FORW_M" | %M125.2 | Bool | |
| "E_PLATE_LOCK_FORW" | %Q124.5 | Bool | |
| "MEM_ONE_TURN(1)" | %M125.4 | Bool | |
| "MEM_DO_TURN" | %M125.5 | Bool | |
| "D_PLATE_BACK" | %I125.2 | Bool | |

Network 2: Ovládání otáčení stolu D



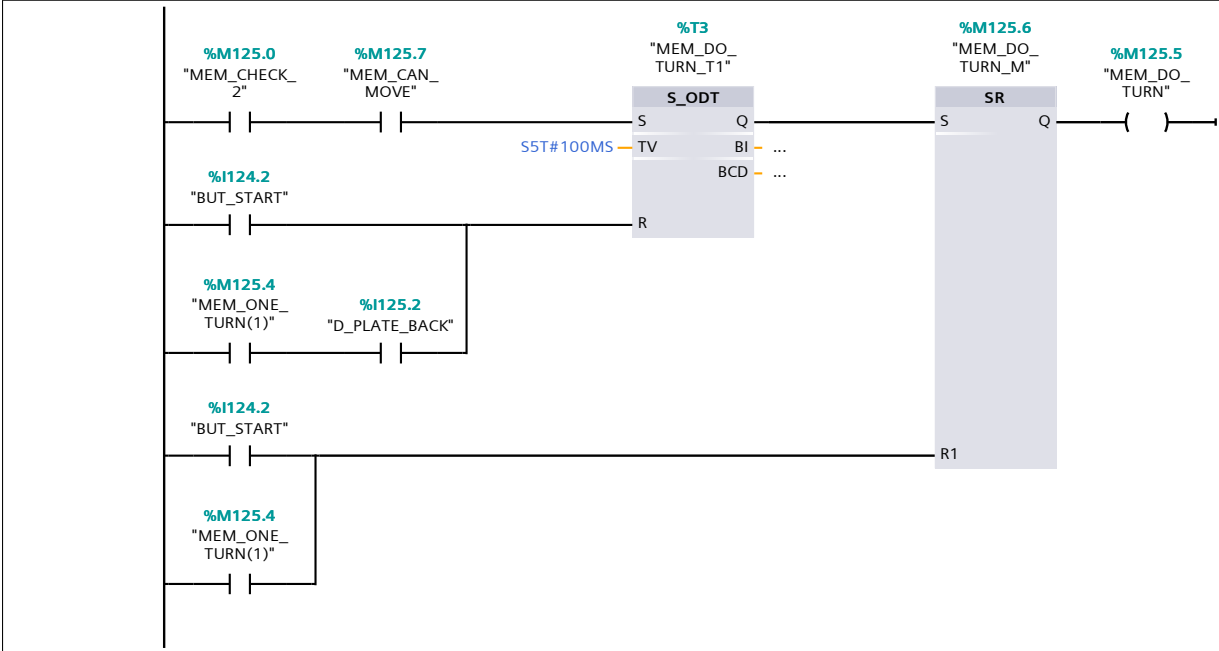
| Symbol | Address | Type | Comment |
|---------------------|---------|--------|---------|
| "MEM_CHECK_2" | %M125.0 | Bool | |
| "BUT_RESET" | %I124.5 | Bool | |
| "E_PLATE_LOCK_FORW" | %Q124.5 | Bool | |
| "MEM_D_BACK_M" | %M125.3 | Bool | |
| "D_PLATE_BACK(1)" | %Q124.4 | Bool | |
| "BUT_START" | %I124.2 | Bool | |
| "MEM_WAIT_FOR_LOCK" | %T1 | Timer | |
| S5T#1S | S5T#1S | S5Time | |
| "MEM_ONE_TURN(1)" | %M125.4 | Bool | |
| "MEM_DO_TURN" | %M125.5 | Bool | |

Network 3: Časovač pro signalizaci otočení stolu o jednu pozici



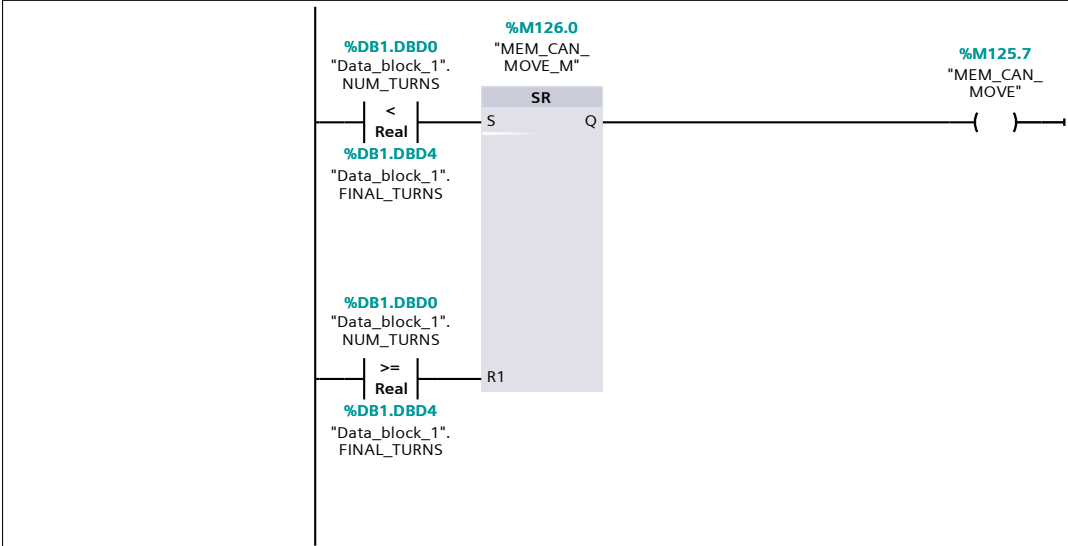
| Symbol | Address | Type | Comment |
|---------------------|---------|--------|---------|
| "E_PLATE_LOCK_FORW" | %Q124.5 | Bool | |
| "D_PLATE_BACK(1)" | %Q124.4 | Bool | |
| S5T#1S | S5T#1S | S5Time | |
| "MEM_ONE_TURN" | %T2 | Timer | |
| "MEM_ONE_TURN(1)" | %M125.4 | Bool | |

Network 4: Signalizace, že se stůl má otočit



| Symbol | Address | Type | Comment |
|-------------------|-----------|--------|---------|
| "MEM_CHECK_2" | %M125.0 | Bool | |
| "BUT_START" | %I124.2 | Bool | |
| "MEM_ONE_TURN(1)" | %M125.4 | Bool | |
| "MEM_DO_TURN" | %M125.5 | Bool | |
| "MEM_CAN_MOVE" | %M125.7 | Bool | |
| "MEM_DO_TURN_T1" | %T3 | Timer | |
| S5T#100MS | S5T#100MS | S5Time | |
| "MEM_DO_TURN_M" | %M125.6 | Bool | |
| "D_PLATE_BACK" | %I125.2 | Bool | |

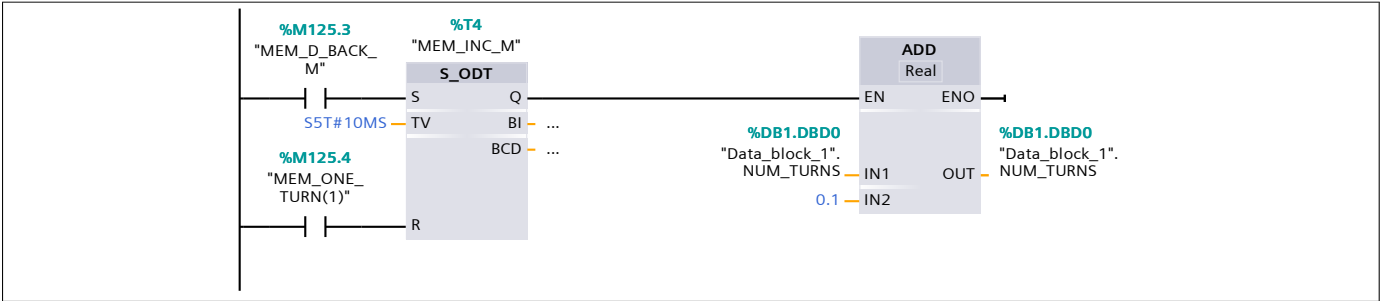
Network 5: Signalizace, že se stůl může otočit



| Symbol | Address | Type | Comment |
|----------------|---------|----------|---------|
| "Data_block_1" | %DB1 | Block_DB | |

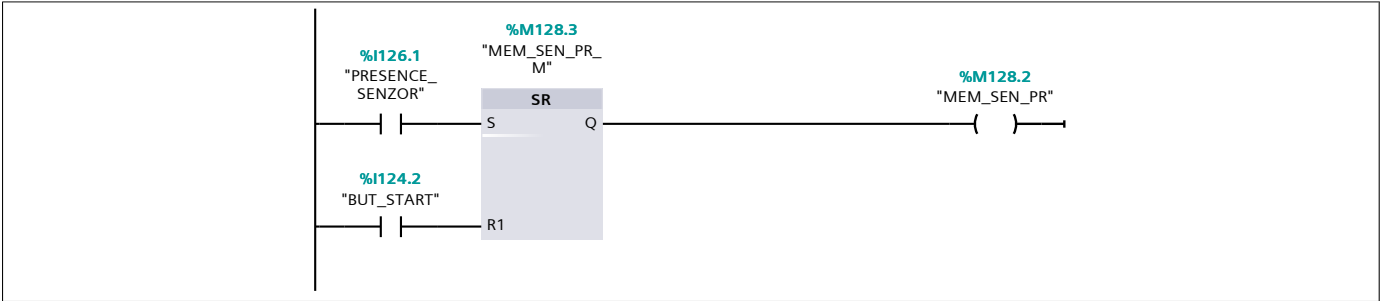
| Symbol | Address | Type | Comment |
|-----------------------------|-----------|------|---------|
| "Data_block_1".NUM_TURNS | %DB1.DBD0 | Real | |
| "Data_block_1".FICIAL_TURNS | %DB1.DBD4 | Real | |
| "MEM_CAN_MOVE" | %M125.7 | Bool | |
| "MEM_CAN_MOVE_M" | %M126.0 | Bool | |

Network 6: Počítadlo, které nám měří posunutí stolu o jedno pole



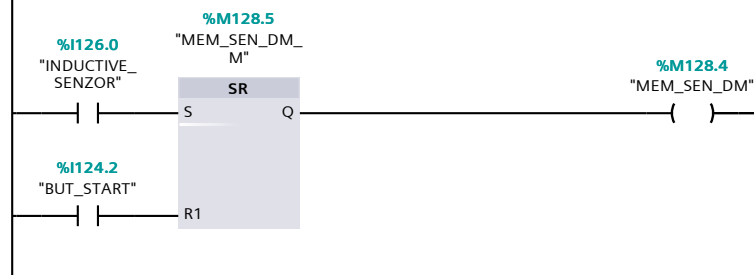
| Symbol | Address | Type | Comment |
|--------------------------|-----------|----------|---------|
| "MEM_D_BACK_M" | %M125.3 | Bool | |
| "MEM_ONE_TURN(1)" | %M125.4 | Bool | |
| "Data_block_1" | %DB1 | Block_DB | |
| "Data_block_1".NUM_TURNS | %DB1.DBD0 | Real | |
| "MEM_INC_M" | %T4 | Timer | |
| S5T#10MS | S5T#10MS | S5Time | |
| 0.1 | 0.1 | LReal | |

Network 7: Signalizace, že kryt se nachází na stole pomocí PR senzoru



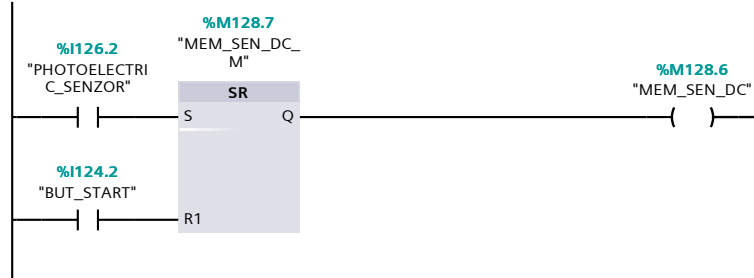
| Symbol | Address | Type | Comment |
|-------------------|---------|------|---------|
| "BUT_START" | %I124.2 | Bool | |
| "PRESENCE_SENZOR" | %I126.1 | Bool | |
| "MEM_SEN_PR_M" | %M128.3 | Bool | |
| "MEM_SEN_PR" | %M128.2 | Bool | |

Network 8: Signalizace, že kryt je kovové pomocí indukčního senzoru



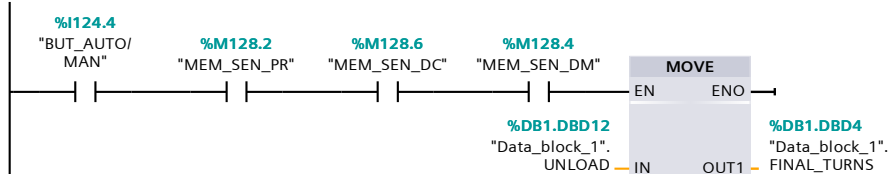
| Symbol | Address | Type | Comment |
|--------------------|---------|------|---------|
| "BUT_START" | %I124.2 | Bool | |
| "MEM_SEN_DM" | %M128.4 | Bool | |
| "MEM_SEN_DM_M" | %M128.5 | Bool | |
| "INDUCTIVE_SENZOR" | %I126.0 | Bool | |

Network 9: Signalizace, že kryt má bavu jaká je fyzicky nastavená na photoelektrickém senzoru



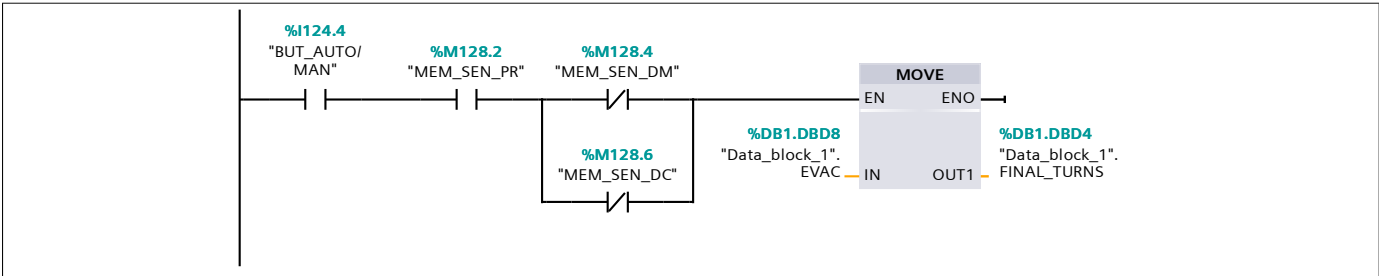
| Symbol | Address | Type | Comment |
|------------------------|---------|------|---------|
| "BUT_START" | %I124.2 | Bool | |
| "MEM_SEN_DC_M" | %M128.7 | Bool | |
| "MEM_SEN_DC" | %M128.6 | Bool | |
| "PHOTOELECTRIC_SENZOR" | %I126.2 | Bool | |

Network 10: Rozhodnutí o přijetí krytu I.



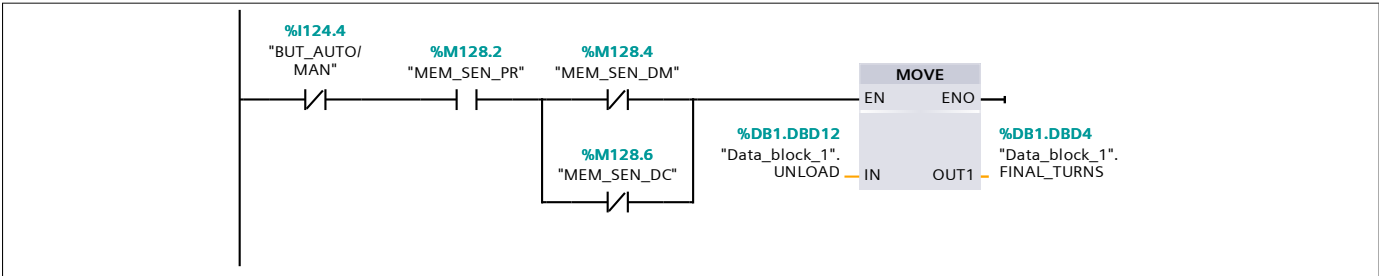
| Symbol | Address | Type | Comment |
|----------------------------|------------|----------|---------|
| "Data_block_1" | %DB1 | Block_DB | |
| "Data_block_1".FINAL_TURNS | %DB1.DBD4 | Real | |
| "MEM_SEN_PR" | %M128.2 | Bool | |
| "MEM_SEN_DM" | %M128.4 | Bool | |
| "MEM_SEN_DC" | %M128.6 | Bool | |
| "BUT_AUTO/MAN" | %I124.4 | Bool | |
| "Data_block_1".UNLOAD | %DB1.DBD12 | Real | |

Network 11: Rozhodnutí o vyloučení krytu I.



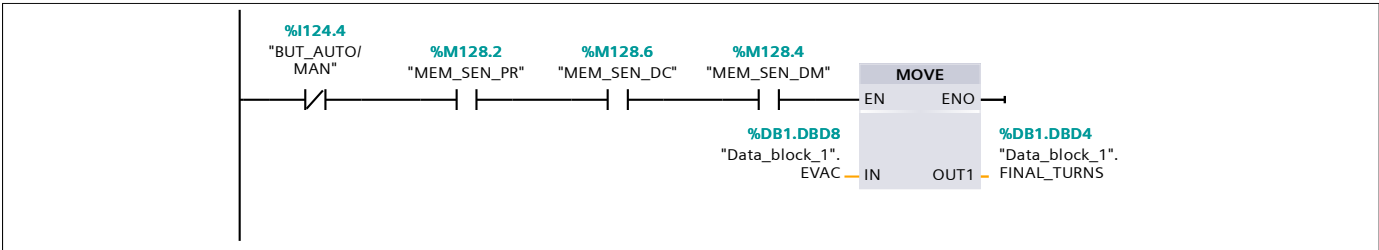
| Symbol | Address | Type | Comment |
|-----------------------------|-----------|----------|---------|
| "Data_block_1" | %DB1 | Block_DB | |
| "Data_block_1".FI-NAL_TURNS | %DB1.DBD4 | Real | |
| "MEM_SEN_PR" | %M128.2 | Bool | |
| "MEM_SEN_DM" | %M128.4 | Bool | |
| "MEM_SEN_DC" | %M128.6 | Bool | |
| "BUT_AUTO/MAN" | %I124.4 | Bool | |
| "Data_block_1".EVAC | %DB1.DBD8 | Real | |

Network 12: Rozhodnutí o vyloučení krytu II.



| Symbol | Address | Type | Comment |
|-----------------------------|------------|----------|---------|
| "Data_block_1" | %DB1 | Block_DB | |
| "Data_block_1".FI-NAL_TURNS | %DB1.DBD4 | Real | |
| "MEM_SEN_PR" | %M128.2 | Bool | |
| "MEM_SEN_DM" | %M128.4 | Bool | |
| "MEM_SEN_DC" | %M128.6 | Bool | |
| "BUT_AUTO/MAN" | %I124.4 | Bool | |
| "Data_block_1".UNLOAD | %DB1.DBD12 | Real | |

Network 13: Rozhodnutí o přijetí krytu II.



| | | | |
|--------------------------------------|-----------|----------|---------|
| Totally Integrated Automation Portal | | | |
| Symbol | Address | Type | Comment |
| "Data_block_1" | %DB1 | Block_DB | |
| "Data_block_1".FI-NAL_TURNS | %DB1.DBD4 | Real | |
| "MEM_SEN_PR" | %M128.2 | Bool | |
| "MEM_SEN_DM" | %M128.4 | Bool | |
| "MEM_SEN_DC" | %M128.6 | Bool | |
| "BUT_AUTO/MAN" | %I124.4 | Bool | |
| "Data_block_1".EVAC | %DB1.DBD8 | Real | |
| | | | |
| | | | |

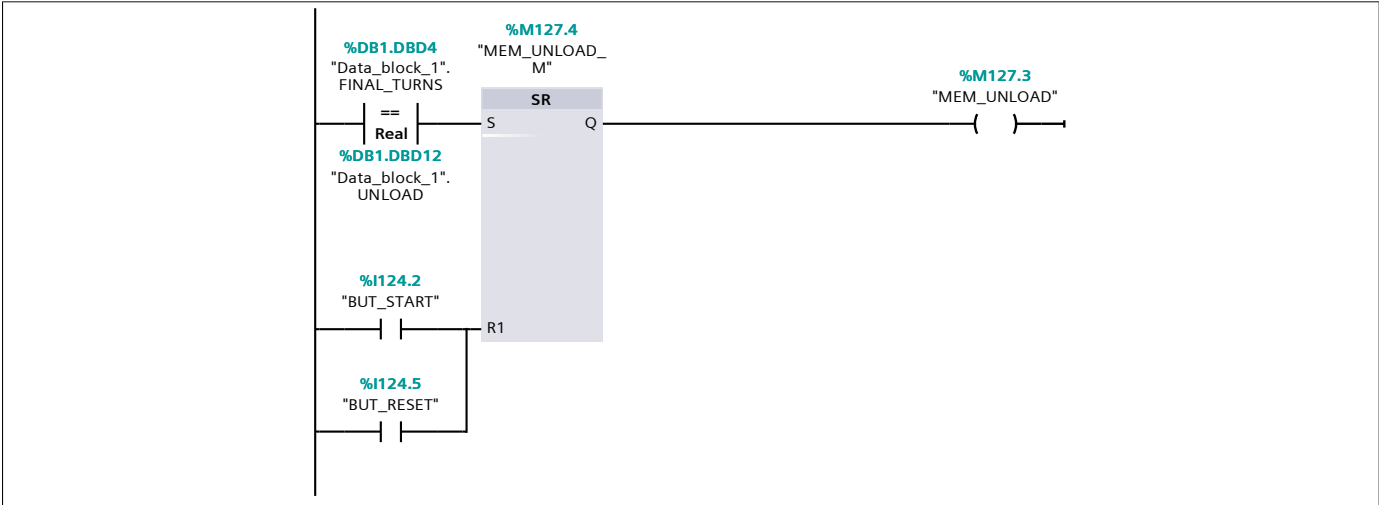
Program blocks

Unload [FC5]

| Unload Properties | | | | | |
|-------------------|---------------------|---------|--------|-----------------|---|
| General | | | | | |
| Name | Unload | Number | 5 | Type | FC |
| Language | LAD | | | | |
| Information | | | | | |
| Title | Funkční blok unload | Author | xmaly6 | Comment | Tento funkční blok má za úkol dopravit vyhovující kryt do tělesa. |
| Family | | Version | 0.1 | User-defined ID | |

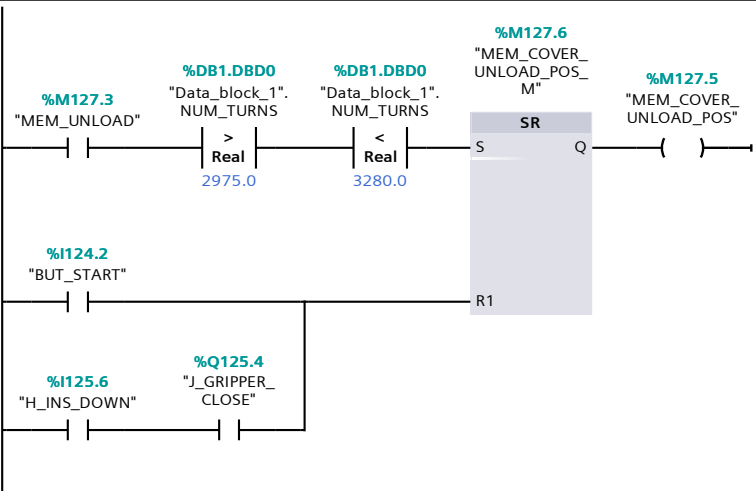
| Name | Data type | Offset | Comment |
|----------|-----------|--------|---------|
| Input | | | |
| Output | | | |
| InOut | | | |
| Temp | | | |
| ▼ Return | | | |
| Ret_Val | Void | | |

Network 1: Signalizace, že má být kryt vložen do tělesa



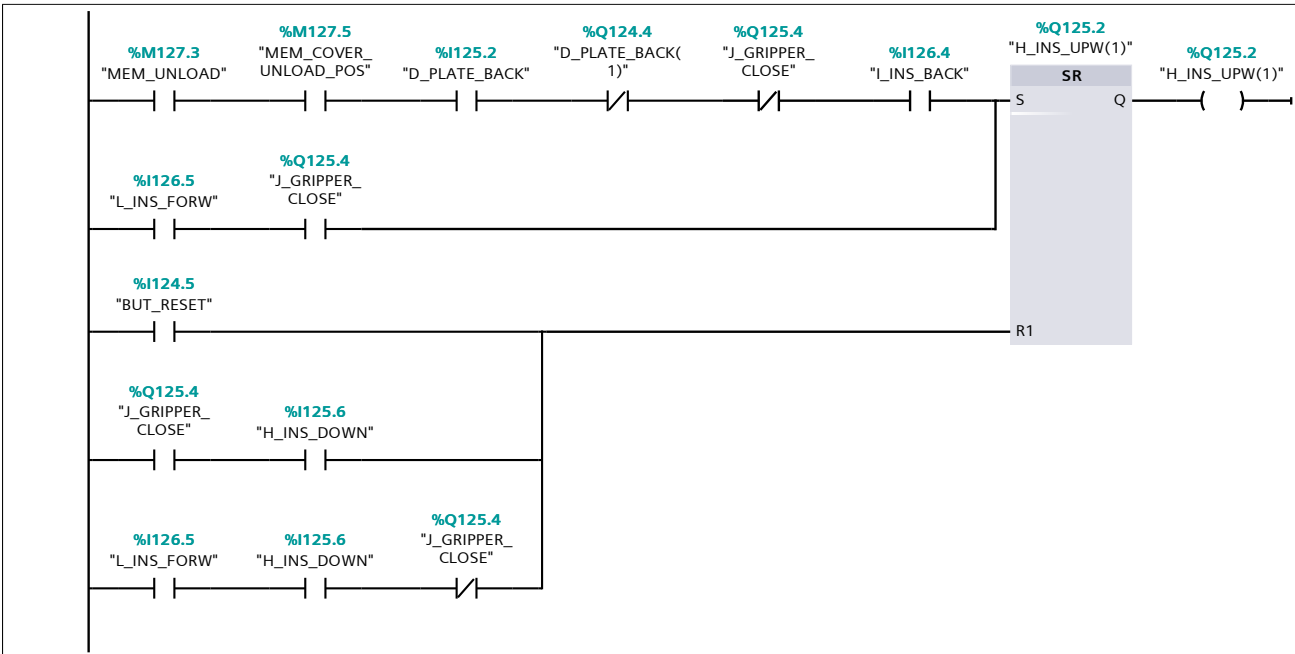
| Symbol | Address | Type | Comment |
|----------------------------|------------|----------|---------|
| "Data_block_1" | %DB1 | Block_DB | |
| "Data_block_1".FINAL_TURNS | %DB1.DBD4 | Real | |
| "BUT_START" | %I124.2 | Bool | |
| "MEM_UNLOAD_M" | %M127.4 | Bool | |
| "MEM_UNLOAD" | %M127.3 | Bool | |
| "BUT_RESET" | %I124.5 | Bool | |
| "Data_block_1".UNLOAD | %DB1.DBD12 | Real | |

Network 2: Kontola, zdali kryt dojel do pozice pro vyzvednutí



| Symbol | Address | Type | Comment |
|--------------------------|-----------|----------|---------|
| "Data_block_1" | %DB1 | Block_DB | |
| "BUT_START" | %I124.2 | Bool | |
| "MEM_UNLOAD" | %M127.3 | Bool | |
| "Data_block_1".NUM_TURNS | %DB1.DBDO | Real | |
| "MEM_COVER_UNLOAD_POS" | %M127.5 | Bool | |
| "MEM_COVER_UNLOAD_POS_M" | %M127.6 | Bool | |
| "H_INS_DOWN" | %I125.6 | Bool | |
| "J_GRIPPER_CLOSE" | %Q125.4 | Bool | |
| 3280.0 | 3280.0 | LReal | |
| 2975.0 | 2975.0 | LReal | |

Network 3: Ovládání sjetí vkladače H



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| Symbol | Address | Type | Comment |
|------------------------|---------|------|---------|
| "MEM_UNLOAD" | %M127.3 | Bool | |
| "BUT_RESET" | %I124.5 | Bool | |
| "MEM_COVER_UNLOAD_POS" | %M127.5 | Bool | |
| "H_INS_DOWN" | %I125.6 | Bool | |
| "J_GRIPPER_CLOSE" | %Q125.4 | Bool | |
| "D_PLATE_BACK" | %I125.2 | Bool | |
| "D_PLATE_BACK(1)" | %Q124.4 | Bool | |
| "H_INS_UPW(1)" | %Q125.2 | Bool | |
| "I_INS_BACK" | %I126.4 | Bool | |
| "L_INS_FORW" | %I126.5 | Bool | |

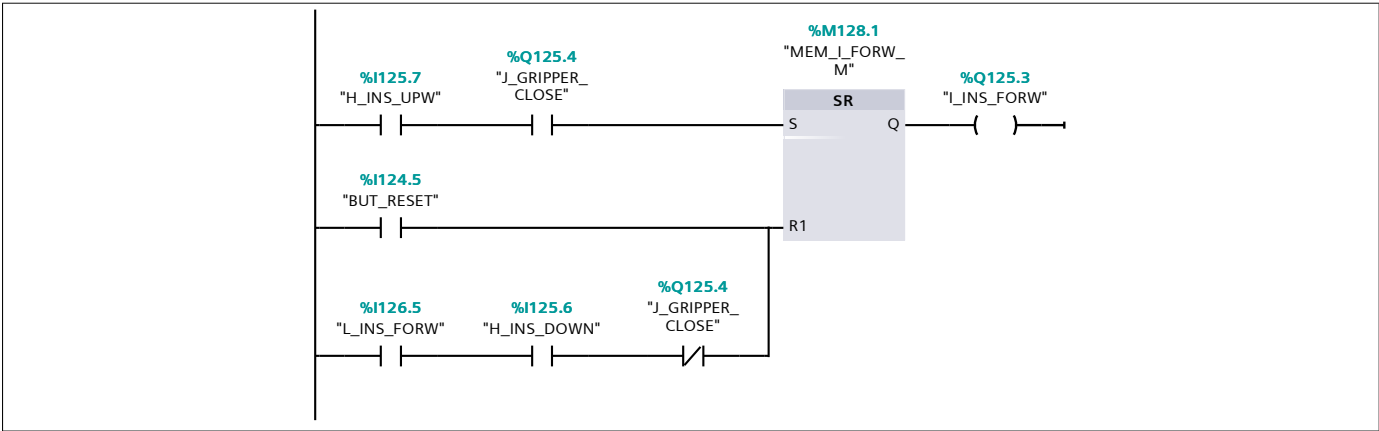
Network 4: Ovládání sevření cvakače J

| Symbol | Address | Type | Comment |
|-------------------|---------|------|---------|
| "MEM_UNLOAD" | %M127.3 | Bool | |
| "BUT_RESET" | %I124.5 | Bool | |
| "H_INS_DOWN" | %I125.6 | Bool | |
| "J_GRIPPER_CLOSE" | %Q125.4 | Bool | |
| "MEM_J_CLOSE_M" | %M128.0 | Bool | |
| "L_INS_FORW" | %I126.5 | Bool | |

Network 5: Signalizace že bylo těleso uchopeno

| Symbol | Address | Type | Comment |
|--------------------------|-----------|----------|---------|
| "Data_block_1" | %DB1 | Block_DB | |
| "Data_block_1".NUM_TURNS | %DB1.DBDO | Real | |
| "J_GRIPPER_CLOSE" | %Q125.4 | Bool | |
| 5780.0 | 5780.0 | LReal | |

Network 6: Ovládání vkladače I



| Symbol | Address | Type | Comment |
|-------------------|---------|------|---------|
| "BUT_RESET" | %I124.5 | Bool | |
| "H_INS_DOWN" | %I125.6 | Bool | |
| "J_GRIPPER_CLOSE" | %Q125.4 | Bool | |
| "H_INS_UPW" | %I125.7 | Bool | |
| "MEM_I_FORW_M" | %M128.1 | Bool | |
| "I_INS_FORW" | %Q125.3 | Bool | |
| "L_INS_FORW" | %I126.5 | Bool | |

Totally Integrated Automation Portal

Program blocks

Data_block_1 [DB1]

Data_block_1 Properties

General

| | | | | | |
|----------|--------------|--------|---|------|----|
| Name | Data_block_1 | Number | 1 | Type | DB |
| Language | DB | | | | |

Information

| | | | | | |
|--------|--|---------|-----|-----------------|--|
| Title | | Author | | Comment | |
| Family | | Version | 0.1 | User-defined ID | |

| Name | Data type | Offset | Start value | Retain | Access-ible from HMI | Visible in HMI | Comment |
|---------------|-----------|--------|-------------|--------|----------------------|----------------|---------|
| ▼ Static | | | | | | | |
| NUM_TURNS | Real | 0.0 | 5478.0 | True | True | True | |
| FINAL_TURNS | Real | 4.0 | 2000.0 | True | True | True | |
| EVAC | Real | 8.0 | 2475.0 | True | True | True | |
| UNLOAD | Real | 12.0 | 2975.0 | True | True | True | |
| FINAL_TURNS_T | S5Time | 16.0 | S5T#20ms | True | True | True | |