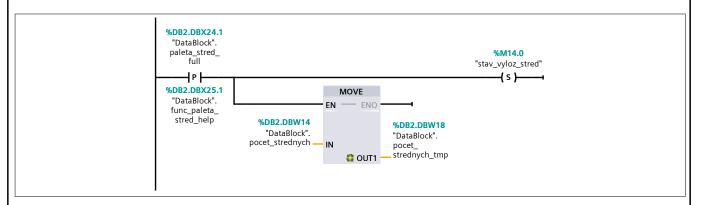
Totally Integrated	
Automation Portal	

vykladanie_palety_stred [FC2]

vykladanie_palety_stred Properties								
General								
Name	vykladanie_palety_stred	Number	2	Type	FC			
Language	LAD	Numbering	Automatic					
Information								
Title		Author		Comment				
Family		Version	0.1	User-defined				
				ID				

Name	Data type	Default value	Supervi- sion	Comment
Input				
Output				
InOut				
Temp				
Constant				
▼ Return				
vykladanie_palety_stred	Void			

Network 1:

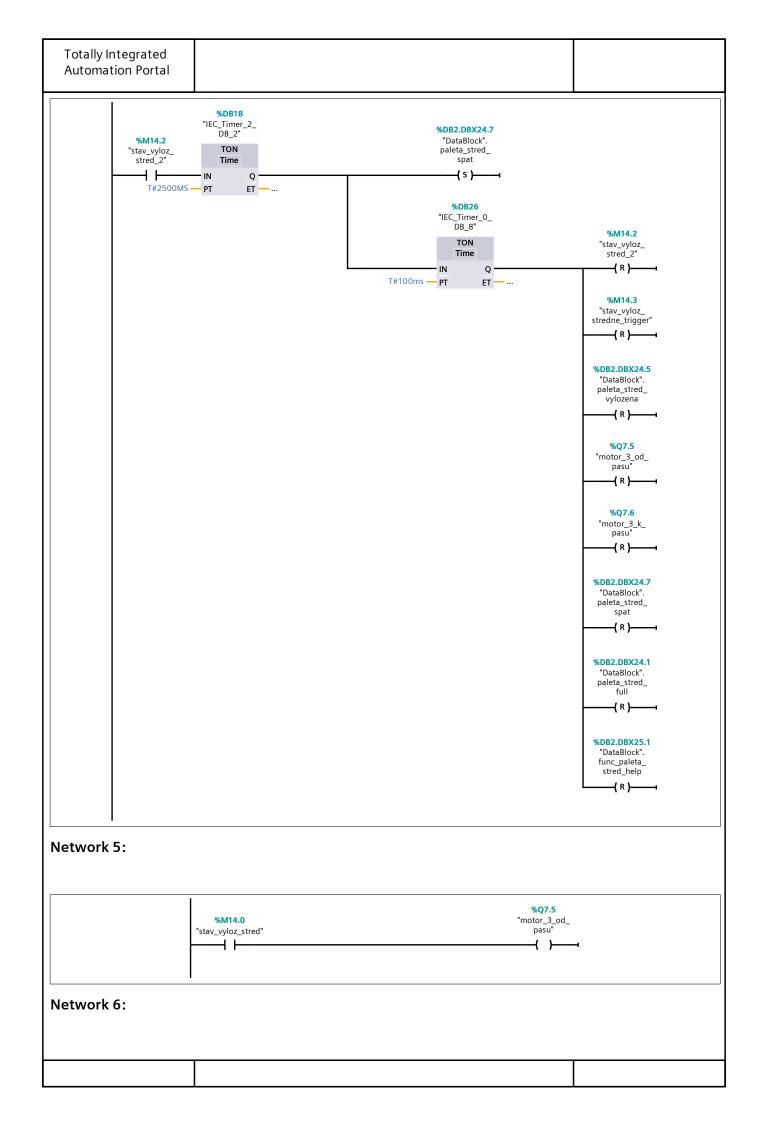


Network 2: Stav vykladania bední - v prvom stave sme pokial nepríde paleta na koniec

```
%DB16
                   "IEC_Timer_2_DB"
                         TON
    %M14.0
                                                                                   %M14.0
"stav_vyloz_stred"
                      Time
                                                                              "stav_vyloz_stred"
                                                                                     -( R )-
                    - IN
                                Q·
       T#2500MS — PT
                               ET --- ...
                                                                                   %M14.1
                                                                                 "stav_vyloz_
stred_1"
                                                                                    -( s )-
```

Network 3: V tomto stave čaká 5sekúnd na vyloženie

Totally Integrated **Automation Portal %DB17**"IEC_Timer_2_
DB_1" **%DB2.DBX24.5**"DataBlock".
paleta_stred_
vylozena %M14.1 "stav_vyloz_ stred_1" TON Time Q T#5s — PT ET -MOVE EN --- ENO 0 — - IN %DB2.DBW18 "DataBlock". pocet_ strednych_tmp 😃 OUT1 %DB19 "IEC_Timer_2_ DB_3" %M14.1 TON "stav_vyloz_ stred_1" Time (R)-Q IN T#100MS — PT ET -%M14.2 "stav_vyloz_ stred_2" -(s)-Network 4: V tomto stave sme pokial nepríde paleta naspať



Totally Integrated Automation Portal		
-	%M14.2 %Q7.6 "stav_vyloz_ stred_2" "motor_3_k_ pasu"	