Totally Integrated Automation Portal	

triedenie [FC5]

triedenie Properties									
General									
Name	triedenie	Number	5	Туре	FC	Language	LAD		
Numbering	Automatic								
Information									
Title		Author		Comment		Family			
Version	0.1	User-defined ID							

Name	Data type	Default value	Supervision	Comment
Input				
Output				
InOut				
Temp				
Constant				
▼ Return				
triedenie	Void			

Network 1: Ak sú všetky stavy v 0 setni stav INIT

```
%MB13
                                                                                      %MB14
                                                                                   "stavy_vyloz_
stredne"
%MB10
"stavy"
                                                             "stavy_vyloz_
male"
                     %MB11
                                           %MB12
                  "stavy_mala"
                                        "stavy_velka"
                                                                                                          "stav_INIT"
                                          ==
Byte
==
Byte
                      ==
Byte
                                                                ==
Byte
                                                                                      ==
Byte
                                                                                                            -( s )-
```

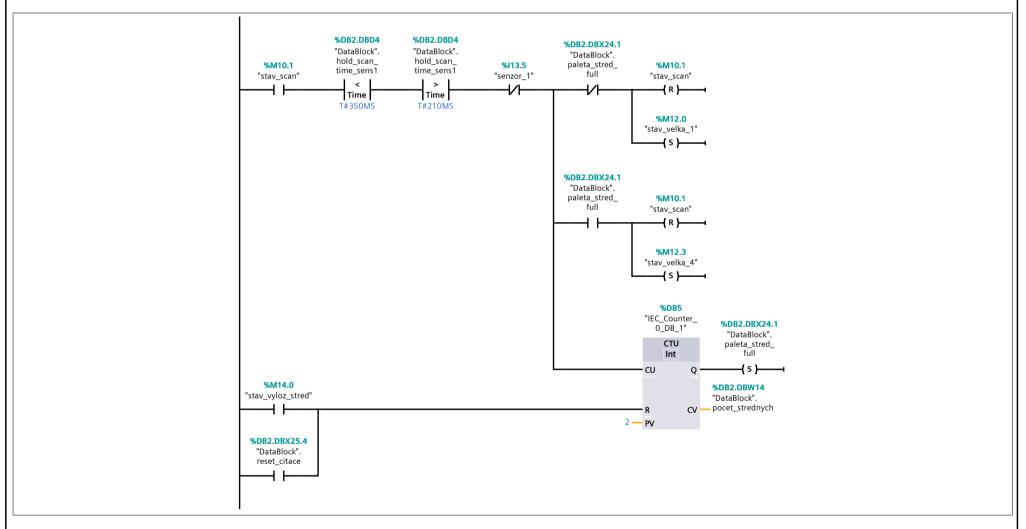
Network 2: Po stlačení tlačítka štart sa rozbehne pás

Network 3: Stav scan: v tomto stave scanujú oba snímače

Network 4: scan - malá bednička

```
"DataBlock".
hold_scan_
time_sens1
                                                  "DataBlock".
hold_scan_
time_sens1
                                                                                                 "DataBlock".
paleta_male_
full
                                                                           %l13.5 "senzor_1"
                                                                                                                          %M10.1
"stav_scan"
     %M10.1
   "stav_scan"
                                                     >
Time
                             | <
                                                                               -1∕1-
                                                                                                                              -( R )-
                            Time
                                                                                                                             %M11.0
                                                                                                                         "stav_mala_1"
                                                                                                                              (s)_
                                                                                                                         %DB2.DBX25.5
                                                                                                                        "DataBlock".mala
                                                                                                                              _( s )_
                                                                                                %DB2.DBX24.0
                                                                                                 "DataBlock".
paleta_male_
full
                                                                                                                             %M10.1
                                                                                                                          "stav_scan"
                                                                                                                              -( R )-
                                                                                                                             %M11.2
                                                                                                                          "stav_mala_3"
                                                                                                                              -( s )-
                                                                                                                              %DB4
                                                                                                                         "IEC_Counter_
O_DB"
                                                                                                                                                %DB2.DBX24.0
"DataBlock".
                                                                                                                                                 paleta_male_
full
                                                                                                                               CTU
                                                                                                                               Int
                                                                                                                         CU
     %M13.0
                                                                                                                                              %DB2.DBW8
"stav_vyloz_male"
                                                                                                                                              "DataBlock".
                                                                                                                                              pocet_malych
                                                                                                                   4 — PV
 %DB2.DBX25.4
  "DataBlock".
reset_citace
```

Network 5: scan - stredná bednička



Network 6: scan - dlhá bednička

Totally Integrated **Automation Portal** %DB2.DBD4 "DataBlock". hold_scan_ time_sens1 **%I13.5** "senzor_1" **%M10.2** "stav_dlha" %M10.1 "stav_scan" -1/1-**-(** s **)**-Time MOVE T#0MS — IN %DB2.DBD4 "DataBlock". hold_scan_ time_sens1 d OUT1 %DB23 "IEC_Counter_ 0_DB_6" CTU Int · CU %DB2.DBX25.4 "DataBlock". "DataBlock". reset_citace __ pocet_dlhych

Network 7: Stavy pre malú bedničku - počká 300MS pokial príde malá bednička pri solenoid

```
**M11.0

"stav_mala_1"

Time

T#300MS

PT

**ET

**M11.1

"stav_mala_2"

(s)

**M11.1

"stav_mala_2"
```

Network 8: Spustenie solenoidu 1 na 500MS a návrat do stavu SCAN

```
"IEC_Timer_0_
DB_3"
  %M11.1
                                                                             %M11.1
"stav_mala_2"
                     Time
                                                                           "stav_mala_2"
                                                                               -( R )-
                  · IN
                             Q
     T#500MS — PT
                                                                             %M10.1
                                                                            "stav_scan"
                                                                               -( s )-
                                                                          %DB2.DBX25.5
                                                                          "DataBlock".mala
                                                                          MOVE
                                                                          - EN
                                                                 T#0MS -
                                                                          - IN
                                                                                           %DB2.DBD4
                                                                                           hold_scan_
                                                                                OUT1 — time_sens1
                                                        %DB2.DBX24.0
                                                                             %M13.3
                                                         "DataBlock".
                                                        paleta_male_
full
                                                                          "stav_vyloz_
male_trigger"
                                                                               -( s )-
```

Network 9: Spustenie funkcie pre vykladanie malej palety

```
*M13.3

"stav_vyloz_
male_trigger"

EN ENO
```

Network 10: V tomto stave čakám na malú paletu

```
Totally Integrated
  Automation Portal
                                                                                  %DB2.DBX24.4
                                                                                  "DataBlock".
paleta_male_
                                                                    %M11.2
                                                                                                                                      %M11.2
                                                                  "stav_mala_3"
                                                                                      spat
                                                                                                                                    "stav_mala_3"
                                                                                                                                      %M11.0
                                                                                                                                    "stav_mala_1"
                                                                                                                                       -( s )-
Network 11: Stavy pre strednú bedničku - zdetekovanie velkej bedničky pri senzore 2
                                                                                    %l13.4 "senzor_2"
                                                                                                                                    %M12.0 "stav_velka_1"
                                                                    %M12.0
                                                                  "stav_velka_1"
                                                                                                                                       -( R )−
                                                                                                                                      %M12.1
                                                                                                                                    "stav_velka_2"
                                                                                                                                       -( s )-
Network 12: počká 500MS pokial príde stredná bednička pri solenoid
                                                                                      %DB7
                                                                                  "IEC_Timer_0_
DB_2"
                                                                                      TON
                                                                    %M12.1
                                                                  "stav_velka_2"
                                                                                      Time
                                                                                                                                    "stav_velka_2"
                                                                                                                                       -( R )-
                                                                       T#550MS — PT
                                                                                           ET --- ...
                                                                                                                                      %M12.2
                                                                                                                                    "stav_velka_3"
                                                                                                                                       -( s )-
Network 13: Spustenie solenoidu 2 na 500MS a návrat do stavu SCAN
                                                                             %DB9
                                                                          "IEC_Timer_0_
DB_4"
                                                            %M12.2
                                                                                                                              %M12.2
                                                          "stav_velka_3"
                                                                                                                           "stav_velka_3"
                                                                                    Q
                                                               T#500MS -
                                                                          PT
                                                                                   ET -----
                                                                                                                              %M10.1
                                                                                                                             "stav_scan"
                                                                                                                               -( s }-
                                                                                                                           MOVE
                                                                                                                           EN
                                                                                                                   T#0MS — IN
                                                                                                                                          %DB2.DBD4
                                                                                                                                         "DataBlock".
hold_scan_
time_sens1
                                                                                                                               d OUT1
                                                                                                           %DB2.DBX24.1
                                                                                                            "DataBlock".
                                                                                                                              %M14.3
                                                                                                           paleta_stred_
full
                                                                                                                          "stav_vyloz_
stredne_trigger"
                                                                                                                               (s)
Network 14: Spustenie funkcie pre vykladanie velkej palety
                                                                    %M14.3
                                                                                              %FC2
                                                                 "stav_vyloz_
stredne_trigger"
                                                                                  "vykladanie_palety_stred"
Network 15: V tomto stave čakám na velkú paletu
                                                                                  %DB2.DBX24.7
                                                                                   "DataBlock".
                                                                                  paleta_stred_
spat
                                                                    %M12.3
                                                                                                                                      %M12.3
                                                                  "stav_velka_4"
                                                                                                                                    "stav_velka_4"
                                                                                                                                       -( R )-
                                                                                                                                      %M12.0
                                                                                                                                    "stav_velka_1"
                                                                                                                                       -( s )-
```

