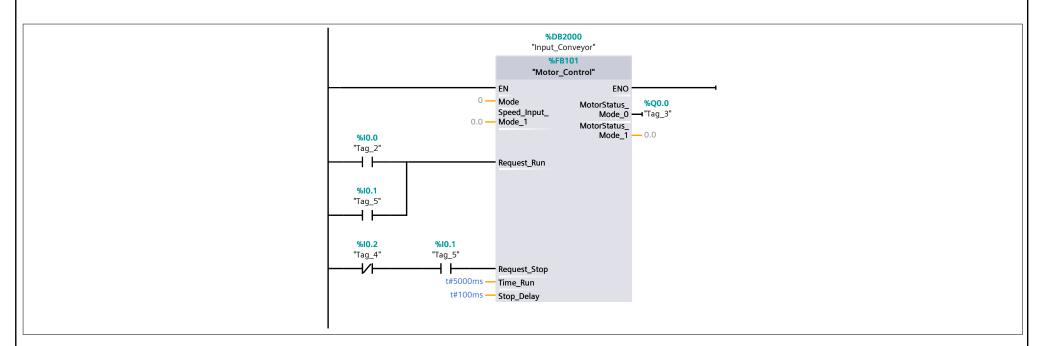
Totally Integrated	
tomation Portal	

Palletizer_FC [FC10]

Palletizer_FC Properties							
General							
Name	Palletizer_FC	Number	10	Туре	FC	Language	LAD
Numbering	Manual						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID					

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

Network 1: Entrance_Motor



Network 2: Rotation_Motor_1

```
%DB2001
                                                                                                         "Motor_Control_
3_DB"
                                                                                                              %FB102
                                                                                                   \hbox{\tt "Motor\_Control\_Rotation"}
                                                                                              EN
                                                                                                                                 ENO ·
                                                                                                                       MotorStatus_ %Q0.2
Mode_0 → "Tag_9"
 %I0.1
"Tag_5"
                          %10.2
                         "Tag_4"
                                                                                                                           Rotation_ %Q0.1
Outuput — "Tag_8"
                                                                                              Request_Run
 %I0.3
"Tag_6"
                          %10.4
                         "Tag_7"
%Q0.1
"Tag_8"
                         %I0.3
"Tag_6"
                                                                                              Request_Stop
%Q0.4
"Tag_12"
                          %10.6
                                                  %10.3
                         "Tag_14"
                                                  "Tag_6"
 %I0.4
"Tag_7"
                         %10.3
"Tag_6"
                                                                                              Rotation_
Request
                                                                              t#5000ms — Time_Run
                                                                                t#50ms — Stop_Delay
%I0.3
"Tag_6"
                         %I0.5 "Tag_11"
```

Network 3: Palletizing_Motor

Totally Integrated **Automation Portal** %DB2002 "Motor_Control_ Pall_DB" %FB103 "Motor_Control_Pall" MotorStatus_ Mode_0 "Tag_12" MotorStatus_ Mode_1 — 0.0 Mode Speed_Input_ - Mode_1 %10.5 %10.3 "Tag_11" "Tag_6" **DB200.DBX0.0
"FANUC_SIGNA
Ls".Pallet_Rdy_
For_Palletizer Request_Run Palletizing_ Ready_Fanuc **%DB200.DBX0.1**"FANUC_SIGNA
Ls".Pallet_
Finished **%Q0.5** "Tag_13" **%Q0.5** "Tag_13" Request_Stop **%Q0.5** "Tag_13" %10.6 "Tag_14" false — Pallet_Ready t#5000ms — Time_Run t#100ms — Stop_Delay Network 4: Stoper %DB2003 "Stoper_DB" %FB200 "Stoper" ENO StopBlade_ %Q0.5 Status — "Tag_13" %DB200.DBX0.1
"FANUC_SIGNA
Ls".Pallet_
Finished %10.6 "Tag_14" Work_Request t#100ms — Blade_Delay t#500ms — Rest_Delay Network 5: Rotation_Motor_2 %DB2004 "Motor_Control_ 4_DB" %FB102 ${\tt "Motor_Control_Rotation"}$ ENO %Q0.7 MotorStatus_ %Q0.7 Mode_0 "Tag_18" %DB200.DBX0.1 "FANUC_SIGNA Ls".Pallet_ Finished **%Q0.5** "Tag_13" Rotation_ %Q0.6
Outuput — "Tag_19" Request_Run **%Q0.6** "Tag_19" **%I1.0** "Tag_16" 4 F Request_Stop %I1.0 **%I1.1** "Tag_15" "Tag_16" Rotation_ Request Time_Run t#5000ms t#50ms — Stop_Delay **%I1.0** "Tag_16" **%I1.2** "Tag_17" Network 6: Exit_Robot %DB2005 "Output_ Conveyor" %FB101 "Motor_Control" ENO 0 — Mode MotorStatus_ %Q1.1 Mode_0 → "Tag_20" Speed_Input_ 0.0 — Mode_1 MotorStatus_ Mode_1 — 0.0 %I1.0 %I1.2 "Tag_17" "Tag_16" Request_Run false — Request_Stop t#5000ms — Time_Run t#100ms — Stop_Delay