Totally Integrated
Automation Porta

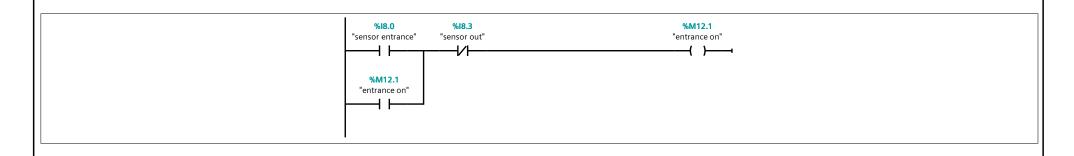
fix_plc / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks

Chiet rot va Dong nap [FC12]

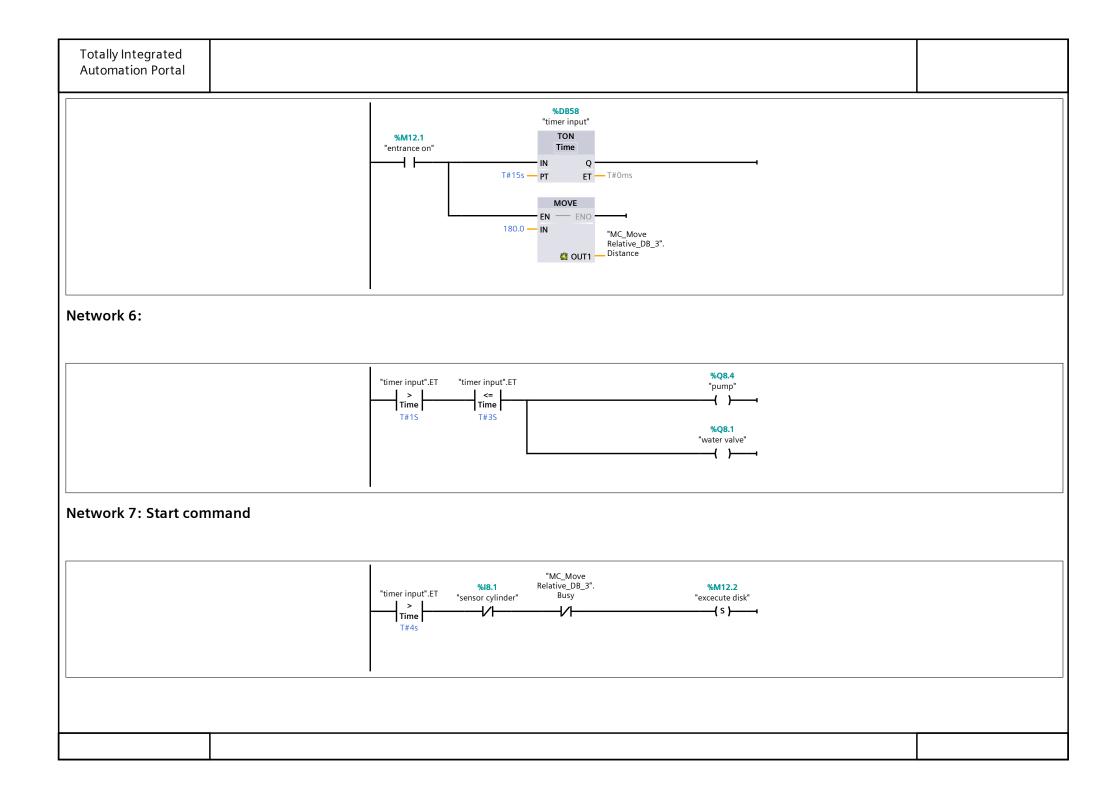
Chiet rot va Dong nap Properties							
General							
Name	Chiet rot va Dong nap	Number	12	Туре	FC	Language	LAD
Numbering	Automatic						
Information							
Title		Author		Comment		Family	
Version	0.1	User-defined ID			'		·

Chiet rot va Dong nap						
Name	Data type	Default value	Comment			
Input						
Output						
InOut						
Тетр						
Constant						
▼ Return						
Chiet rot va Dong nap	Void					

Network 1:



```
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Network 2:
                                                                 %M1.6
                                                                                                                               %Q8.3
                                                                "on mode"
                                                                                                                            "conveyor out"
Network 3:
                                                                                %M9.4
                                                                                                                            %Q8.2
"conveyor in"
                                                                 %M1.6
                                                                             "conveyor out
not"
                                                                "on mode"
Network 4:
                                                                                                                               %M9.4
                                                                                                                            "conveyor out
not"
                                                                 %M2.3
                                                                 "state5"
                                                                 %M2.4
                                                                 "state6"
                                                                 %M2.6
                                                                 "state7"
Network 5:
```



```
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Network 8:
                                                                    "MC_Move
Relative_DB_3".
Done
                                                                                                                                          %M12.2
                                                                                                                                        "excecute disk"
                                                                                                                                           —( R )——
Network 9:
                                                                                                                                          %Q8.0 "cylinder"
                                                                        %18.1
                                                                                     "timer input".ET
                                                                                                     "timer input".ET
                                                                    "sensor cylinder"
                                                                                        >
Time
                                                                                                           <=
                                                                                                          Time
                                                                                        T#11s
                                                                                                         T#13s
                                                                                                         MOVE
                                                                                                      EN - ENO
                                                                                               90.0 — IN
                                                                                                                     "MC_Move
Relative_DB_3".
                                                                                                          OUT1 — Distance
Network 10: Start command
                                                                                     "MC_Move
Relative_DB_3".
                                                                       %Q8.0
                                                                                                          %18.3
                                                                                                                                          %M12.2
                                                                                         Busy
                                                                       "cylinder"
                                                                                                       "sensor out"
                                                                                                                                        "excecute disk"
                                                                        ⊣ N ⊢
                                                                       %M12.0
                                                                       "Tag_1"
```

Totally Integrated Automation Portal		
letwork 11:		
	%DB49 "MC_Move Relative_DB_3"	
	MC_MoveRelative □□□□□□□□□□□□□□□□□□□□□□□□□□□□□□□□□□□	
	*DB42 Busy → false	
	%M12.2 Command "excecute disk" Aborted — false	
	Execute Error — false ErrorID — 16#0	
	Relative_DB_3". Distance Distance	
	30.0 — Velocity	
	<u> </u>	