

- Controller xviate00\_DP
- Controller Fault Handler
- Power-Up Handler

Tasks

- MainTask
  - MainProgram
  - MainRoutine
    - generovanie\_paliet
    - paletizer
    - paletizer\_vykladanie
    - paletizer\_zakladanie
    - simulacia
    - vykladanie\_paliet
    - zakoncenie\_vykladania
- SafetyTask
  - SafetyProgram
  - MainRoutine
- Unscheduled

Motion Groups

- Ungrouped Axes

Add-On Instructions













Data Types












- User-Defined
- Strings
- Add-On-Defined
- Module-Defined













Trends












I/O Configuration











- 1769 Bus
  - [0] 1769-L33ERMS xviate00\_DP
- Ethernet
  - 1769-L33ERMS xviate00\_DP












Name	Value	Data Type	Scope
 <b>belt</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_0		
Base Tag:	BOOL_OUT_0		
Constant	No		
External Access:	Read/Write		
<i>belt - MainProgram/paletizer - *#32, *#55</i>			
<i>belt - MainProgram/simulacia - *#65, *#94</i>			
 <b>BOOL_IN_0</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>dif_sen0 - MainProgram/generovanie_paliet - #19</i>			
 <b>BOOL_IN_1</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>dif_sen1 - MainProgram/paletizer_zakladanie - #16</i>			
 <b>BOOL_IN_2</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>dif_sen2 - MainProgram/zakoncenie_vykladania - #41</i>			
 <b>BOOL_IN_3</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>dif_sen3 - MainProgram/zakoncenie_vykladania - #32, #41</i>			
 <b>BOOL_IN_4</b>	1	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>Emergency_stop - MainProgram/simulacia - #54</i>			
 <b>BOOL_IN_8</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_clamped - MainProgram/paletizer - #85</i>			
 <b>BOOL_IN_9</b>	1	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_PL - MainProgram/paletizer - #109, #120, #133, #89, #93</i>			
 <b>BOOL_IN_10</b>	1	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_push_lim - MainProgram/paletizer - #31, #62, #73, #77, #81, #85</i>			
 <b>BOOL_IN_11</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_ele_mov - MainProgram/paletizer - #104, #141, #146, #31, #99</i>			
 <b>BOOL_IN_12</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_elev_back - MainProgram/paletizer - #19</i>			
 <b>BOOL_IN_13</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_elev_front - MainProgram/paletizer - #152, #22</i>			
<i>palet_elev_front - MainProgram/simulacia - *#108</i>			











 <b>BOOL_IN_15</b>	1	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>retro0 - MainProgram/paletizer - #19</i>			
 <b>BOOL_IN_16</b>	1	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>retro1 - MainProgram/paletizer - #124, #36</i>			
 <b>BOOL_IN_17</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>safety_door - MainProgram/MainRoutine - 2(XIC)</i>			
 <b>BOOL_IN_18</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>safety_door1 - MainProgram/MainRoutine - 2(XIC)</i>			
 <b>BOOL_IN_19</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>safety_door2 - MainProgram/MainRoutine - 2(XIC)</i>			
 <b>BOOL_IN_23</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>stacker0_MX - MainProgram/generovanie_paliet - #121, #125, #68, #72, #83</i>			
<i>stacker0_MX - MainProgram/simulacia - #157</i>			
<i>stacker0_MX - MainProgram/vykladanie_paliet - #36, #40, #43, #73, #77</i>			
 <b>BOOL_IN_24</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>stacker0_MZ - MainProgram/generovanie_paliet - #100, #105, #44, #48, #72, #83</i>			
<i>stacker0_MZ - MainProgram/simulacia - #157</i>			
<i>stacker0_MZ - MainProgram/vykladanie_paliet - #40, #43, #53, #57, #89, #93</i>			
 <b>BOOL_IN_25</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>stacker1_MX - MainProgram/paletizer_vykladanie - #34, #38, #40, #68, #72</i>			
<i>stacker1_MX - MainProgram/paletizer_zakladanie - #114, #118, #61, #65, #76</i>			
<i>stacker1_MX - MainProgram/simulacia - #163</i>			
 <b>BOOL_IN_26</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>stacker1_MZ - MainProgram/paletizer_vykladanie - #38, #40, #48, #52, #84, #88</i>			
<i>stacker1_MZ - MainProgram/paletizer_zakladanie - #38, #42, #65, #76, #93, #98</i>			
<i>stacker1_MZ - MainProgram/simulacia - #163</i>			
 <b>BOOL_IN_27</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>stacker0_LL - MainProgram/generovanie_paliet - #100, #112, #96</i>			
<i>stacker0_LL - MainProgram/vykladanie_paliet - #48, #53, #85, #89</i>			
 <b>BOOL_IN_28</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>stacker1_LL - MainProgram/paletizer_vykladanie - #44, #48, #80, #84</i>			
<i>stacker1_LL - MainProgram/paletizer_zakladanie - #105, #89, #93</i>			

 <b>BOOL_IN_29</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>stacker0_RL - MainProgram/generovanie_paliet - #100, #109, #40, #44, #96</i>			
<i>stacker0_RL - MainProgram/vykladanie_paliet - #48, #53</i>			
 <b>BOOL_IN_30</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>stacker1_RL - MainProgram/paletizer_vykladanie - #44, #48</i>			
<i>stacker1_RL - MainProgram/paletizer_zakladanie - #102, #34, #38, #89, #93</i>			
 <b>BOOL_IN_31</b>	1	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>stacker0_M - MainProgram/generovanie_paliet - #117, #53</i>			
<i>stacker0_M - MainProgram/vykladanie_paliet - #69</i>			
 <b>BOOL_IN_32</b>	1	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>stacker1_M - MainProgram/paletizer_vykladanie - #64</i>			
<i>stacker1_M - MainProgram/paletizer_zakladanie - #110, #47</i>			
 <b>BOOL_IN_33</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>start - MainProgram/MainRoutine - 0(XIC)</i>			
 <b>BOOL_IN_34</b>	1	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>stop - MainProgram/MainRoutine - 0(XIC), 1(XIC)</i>			
 <b>BOOL_IN_35</b>	1	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>turn_L0 - MainProgram/zakoncenie_vykladania - #63</i>			
 <b>BOOL_IN_36</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>turn_L90 - MainProgram/zakoncenie_vykladania - #53</i>			
 <b>BOOL_IN_37</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>turn_back - MainProgram/zakoncenie_vykladania - #57</i>			
 <b>BOOL_IN_39</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>dif_sen4 - MainProgram/zakoncenie_vykladania - #41</i>			
 <b>BOOL_OUT_0</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>belt - MainProgram/paletizer - *#32, *#55</i>			
<i>belt - MainProgram/simulacia - *#65, *#94</i>			
 <b>BOOL_OUT_1</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pas0CW - MainProgram/generovanie_paliet - *#15, *#21, *#32</i>			









<b>BOOL_OUT_1 (Continued)</b>				
<i>pas0CW - MainProgram/simulacia - *#11, *#74</i>				
 <b>BOOL_OUT_2</b>	0	BOOL	xviate00_DP	
Constant	No			
External Access:	Read/Write			
<i>pas1CCW - MainProgram/generovanie_paliet - *#16, *#24, *#35</i>				
<i>pas1CCW - MainProgram/simulacia - *#75</i>				
 <b>BOOL_OUT_3</b>	1	BOOL	xviate00_DP	
Constant	No			
External Access:	Read/Write			
<i>pas2CW - MainProgram/simulacia - *#144, *#30</i>				
<i>pas2CW - MainProgram/zakoncenie_vykladania - *#17, *#42</i>				
 <b>BOOL_OUT_4</b>	1	BOOL	xviate00_DP	
Constant	No			
External Access:	Read/Write			
<i>pas3CCW - MainProgram/simulacia - *#145, *#31</i>				
<i>pas3CCW - MainProgram/zakoncenie_vykladania - *#18, *#43</i>				
 <b>BOOL_OUT_5</b>	0	BOOL	xviate00_DP	
Constant	No			
External Access:	Read/Write			
<i>pas4CCW - MainProgram/paletizer_zakladanie - *#13, *#19, *#28</i>				
<i>pas4CCW - MainProgram/simulacia - *#123, *#20</i>				
 <b>BOOL_OUT_6</b>	0	BOOL	xviate00_DP	
Constant	No			
External Access:	Read/Write			
<i>pas5CW - MainProgram/simulacia - *#41</i>				
<i>pas5CW - MainProgram/zakoncenie_vykladania - *#28, *#34</i>				
 <b>BOOL_OUT_7</b>	1	BOOL	xviate00_DP	
Constant	No			
External Access:	Read/Write			
<i>emitor0 - MainProgram/generovanie_paliet - *#12</i>				
 <b>BOOL_OUT_8</b>	0	BOOL	xviate00_DP	
Constant	No			
External Access:	Read/Write			
<i>emitor1 - MainProgram/paletizer - *#30</i>				
<i>emitor1 - MainProgram/simulacia - *#92</i>				
 <b>BOOL_OUT_9</b>	0	BOOL	xviate00_DP	
Constant	No			
External Access:	Read/Write			
<i>emitor2 - MainProgram/paletizer - *#13, *#138</i>				
<i>emitor2 - MainProgram/simulacia - *#93</i>				
 <b>BOOL_OUT_13</b>	0	BOOL	xviate00_DP	
Constant	No			
External Access:	Read/Write			
<i>load0 - MainProgram/generovanie_paliet - *#17, *#20, *#31</i>				
<i>load0 - MainProgram/simulacia - *#12, *#76</i>				
 <b>BOOL_OUT_14</b>	1	BOOL	xviate00_DP	
Constant	No			
External Access:	Read/Write			
<i>load1 - MainProgram/simulacia - *#143, *#29</i>				
<i>load1 - MainProgram/zakoncenie_vykladania - *#16</i>				
 <b>BOOL_OUT_15</b>	1	BOOL	xviate00_DP	
Constant	No			







<b>BOOL_OUT_15 (Continued)</b>			
External Access:	Read/Write		
<i>load2 - MainProgram/paletizer_zakladanie - *#14, *#17, *#26, *#33</i>			
<i>load2 - MainProgram/simulacia - *#124, *#21</i>			
 <b>BOOL_OUT_16</b>	1	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>load3 - MainProgram/simulacia - *#40</i>			
<i>load3 - MainProgram/zakoncenie_vykladania - *#27, *#33</i>			
 <b>BOOL_OUT_17</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_push - MainProgram/paletizer - #62, #77, *#57, *#74, *#96</i>			
<i>palet_push - MainProgram/simulacia - *#104</i>			
 <b>BOOL_OUT_18</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_turn - MainProgram/paletizer - *#121, *#137</i>			
<i>palet_turn - MainProgram/simulacia - *#106</i>			
 <b>BOOL_OUT_19</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_clamp - MainProgram/paletizer - *#82, *#95</i>			
<i>palet_clamp - MainProgram/simulacia - *#103</i>			
 <b>BOOL_OUT_20</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_belt - MainProgram/paletizer - *#33, *#56</i>			
<i>palet_belt - MainProgram/simulacia - *#64, *#95</i>			
 <b>BOOL_OUT_21</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_beltm - MainProgram/paletizer - *#122, *#128</i>			
<i>palet_beltm - MainProgram/simulacia - *#96</i>			
 <b>BOOL_OUT_22</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_chain - MainProgram/paletizer - *#149, *#15, *#25</i>			
<i>palet_chain - MainProgram/simulacia - *#62, *#98</i>			
 <b>BOOL_OUT_23</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_open - MainProgram/paletizer - #109, *#106, *#86</i>			
<i>palet_open - MainProgram/simulacia - *#105, *#99</i>			
 <b>BOOL_OUT_24</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_elev_up - MainProgram/paletizer - *#26, *#59</i>			
<i>palet_elev_up - MainProgram/simulacia - *#100</i>			
 <b>BOOL_OUT_25</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_elev_down - MainProgram/paletizer - *#105, *#140, *#148, *#94</i>			
<i>palet_elev_down - MainProgram/simulacia - *#101</i>			

 <b>BOOL_OUT_26</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>palet_elev_limit - MainProgram/paletizer - *#139, *#147, *#24, *#58</i>			
<i>palet_elev_limit - MainProgram/simulacia - *#102</i>			
 <b>BOOL_OUT_27</b>	1	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>remover0 - MainProgram/simulacia - *#38</i>			
<i>remover0 - MainProgram/zakoncenie_vykladania - *#25</i>			
 <b>BOOL_OUT_29</b>	1	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>turn_rollm - MainProgram/simulacia - *#152</i>			
<i>turn_rollm - MainProgram/zakoncenie_vykladania - *#49, *#58</i>			
 <b>BOOL_OUT_30</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pas2_0 - MainProgram/generovanie_paliet - *#13, *#22, *#33</i>			
<i>pas2_0 - MainProgram/simulacia - *#72, *#9</i>			
 <b>BOOL_OUT_31</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pas2_1 - MainProgram/generovanie_paliet - *#14, *#23, *#34</i>			
<i>pas2_1 - MainProgram/simulacia - *#10, *#73</i>			
 <b>BOOL_OUT_32</b>	1	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pas2_2 - MainProgram/simulacia - *#32</i>			
<i>pas2_2 - MainProgram/zakoncenie_vykladania - *#19</i>			
 <b>BOOL_OUT_33</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pas4_5 - MainProgram/paletizer - *#14, *#20, *#23</i>			
<i>pas4_5 - MainProgram/simulacia - *#61, *#97</i>			
 <b>BOOL_OUT_34</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pas4_0 - MainProgram/simulacia - *#146, *#33</i>			
<i>pas4_0 - MainProgram/zakoncenie_vykladania - *#20, *#44</i>			
 <b>BOOL_OUT_35</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pas4_1 - MainProgram/simulacia - *#147, *#34</i>			
<i>pas4_1 - MainProgram/zakoncenie_vykladania - *#21, *#45</i>			
 <b>BOOL_OUT_36</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pas4_2 - MainProgram/paletizer_zakladanie - *#12, *#18, *#27</i>			
<i>pas4_2 - MainProgram/simulacia - *#122, *#19</i>			
 <b>BOOL_OUT_37</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pas4_3 - MainProgram/simulacia - *#42</i>			









<b>BOOL_OUT_37 (Continued)</b>						
<i>pas4_3 - MainProgram/zakoncenie_vykladania - *#29, *#35, *#54, *#59</i>						
 <b>BOOL_OUT_38</b>	1	BOOL	xviate00_DP			
Constant No						
External Access: Read/Write						
<i>pas4_4 - MainProgram/simulacia - *#148, *#35</i>						
<i>pas4_4 - MainProgram/zakoncenie_vykladania - *#22</i>						
 <b>BOOL_OUT_39</b>	1	BOOL	xviate00_DP			
Constant No						
External Access: Read/Write						
<i>pas6_0 - MainProgram/simulacia - *#149, *#36</i>						
<i>pas6_0 - MainProgram/zakoncenie_vykladania - *#23, *#46</i>						
 <b>BOOL_OUT_40</b>	0	BOOL	xviate00_DP			
Constant No						
External Access: Read/Write						
<i>pas6_1 - MainProgram/simulacia - *#43</i>						
<i>pas6_1 - MainProgram/zakoncenie_vykladania - *#30, *#36</i>						
 <b>BOOL_OUT_41</b>	0	BOOL	xviate00_DP			
Constant No						
External Access: Read/Write						
<i>stacker0_lift - MainProgram/generovanie_paliet - *#41, *#97</i>						
<i>stacker0_lift - MainProgram/simulacia - *#79</i>						
<i>stacker0_lift - MainProgram/vykladanie_paliet - *#49, *#86</i>						
 <b>BOOL_OUT_42</b>	1	BOOL	xviate00_DP			
Constant No						
External Access: Read/Write						
<i>stacker1_lift - MainProgram/paletizer_vykladanie - *#45, *#81</i>						
<i>stacker1_lift - MainProgram/paletizer_zakladanie - *#35, *#90</i>						
<i>stacker1_lift - MainProgram/simulacia - *#127</i>						
 <b>BOOL_OUT_43</b>	0	BOOL	xviate00_DP			
Constant No						
External Access: Read/Write						
<i>stacker0_L - MainProgram/generovanie_paliet - *#113, *#84</i>						
<i>stacker0_L - MainProgram/simulacia - *#78</i>						
<i>stacker0_L - MainProgram/vykladanie_paliet - *#45, *#65, *#81, *#94</i>						
 <b>BOOL_OUT_44</b>	1	BOOL	xviate00_DP			
Constant No						
External Access: Read/Write						
<i>stacker1_L - MainProgram/paletizer_vykladanie - *#41, *#60, *#76, *#89</i>						
<i>stacker1_L - MainProgram/paletizer_zakladanie - *#106, *#77</i>						
<i>stacker1_L - MainProgram/simulacia - *#126</i>						
 <b>BOOL_OUT_45</b>	0	BOOL	xviate00_DP			
Constant No						
External Access: Read/Write						
<i>stacker0_R - MainProgram/generovanie_paliet - *#110, *#25, *#49, *#73</i>						
<i>stacker0_R - MainProgram/simulacia - *#77</i>						
<i>stacker0_R - MainProgram/vykladanie_paliet - *#42, *#62</i>						
 <b>BOOL_OUT_46</b>	1	BOOL	xviate00_DP			
Constant No						
External Access: Read/Write						
<i>stacker1_R - MainProgram/paletizer_vykladanie - *#39, *#57</i>						
<i>stacker1_R - MainProgram/paletizer_zakladanie - *#103, *#20, *#43, *#66</i>						
<i>stacker1_R - MainProgram/simulacia - *#125</i>						
 <b>BOOL_OUT_47</b>	0	BOOL	xviate00_DP			




















<b>BOOL_OUT_47 (Continued)</b>				
Constant	No			
External Access:	Read/Write			
<i>start_but - MainProgram/simulacia - #54</i>				
 <b>BOOL_OUT_48</b>	1	BOOL		xviate00_DP
Constant	No			
External Access:	Read/Write			
<i>stop_but - MainProgram/simulacia - #54</i>				
 <b>BOOL_OUT_49</b>	1	BOOL		xviate00_DP
Constant	No			
External Access:	Read/Write			
<i>turn_turn - MainProgram/simulacia - *#151</i>				
<i>turn_turn - MainProgram/zakoncenie_vykladania - *#48, *#60</i>				
 <b>BOOL_OUT_50</b>	0	BOOL		xviate00_DP
Constant	No			
External Access:	Read/Write			
<i>turn_roll - MainProgram/simulacia - *#150, *#37</i>				
<i>turn_roll - MainProgram/zakoncenie_vykladania - *#24, *#47, *#64</i>				
<b>box</b>	-1	INT		MainProgram
Constant	No			
External Access:	Read/Write			
<i>box - MainProgram/paletizer - #39, #44, #44, #44, #46, #46, #46, #48, #48, #48, #50, #50, *#134, *#39</i>				
<i>box - MainProgram/simulacia - *#109</i>				
<b>count</b>	0	INT		MainProgram
Constant	No			
External Access:	Read/Write			
<i>count - MainProgram/paletizer - #63, #67, #69, *#135, *#63</i>				
<i>count - MainProgram/simulacia - *#110</i>				
 <b>dif_sen0</b>	0	BOOL		xviate00_DP
AliasFor:	BOOL_IN_0			
Base Tag:	BOOL_IN_0			
Constant	No			
External Access:	Read/Write			
<i>dif_sen0 - MainProgram/generovanie_palieta - #19</i>				
 <b>dif_sen1</b>	0	BOOL		xviate00_DP
AliasFor:	BOOL_IN_1			
Base Tag:	BOOL_IN_1			
Constant	No			
External Access:	Read/Write			
<i>dif_sen1 - MainProgram/paletizer_zakladanie - #16</i>				
 <b>dif_sen2</b>	0	BOOL		xviate00_DP
AliasFor:	BOOL_IN_2			
Base Tag:	BOOL_IN_2			
Constant	No			
External Access:	Read/Write			
<i>dif_sen2 - MainProgram/zakoncenie_vykladania - #41</i>				
 <b>dif_sen3</b>	0	BOOL		xviate00_DP
AliasFor:	BOOL_IN_3			
Base Tag:	BOOL_IN_3			
Constant	No			
External Access:	Read/Write			
<i>dif_sen3 - MainProgram/zakoncenie_vykladania - #32, #41</i>				
 <b>dif_sen4</b>	0	BOOL		xviate00_DP
AliasFor:	BOOL_IN_39			








<b>dif_sen4 (Continued)</b>			
Base Tag:	BOOL_IN_39		
Constant	No		
External Access:	Read/Write		
<i>dif_sen4 - MainProgram/zakoncenie_vykladania - #41</i>			
 <b>Emergency_stop</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_IN_4		
Base Tag:	BOOL_IN_4		
Constant	No		
External Access:	Read/Write		
<i>Emergency_stop - MainProgram/simulacia - #54</i>			
 <b>emitor0</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_7		
Base Tag:	BOOL_OUT_7		
Constant	No		
External Access:	Read/Write		
<i>emitor0 - MainProgram/generovanie_palieta - #12</i>			
 <b>emitor1</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_8		
Base Tag:	BOOL_OUT_8		
Constant	No		
External Access:	Read/Write		
<i>emitor1 - MainProgram/paletizer - #30</i>			
<i>emitor1 - MainProgram/simulacia - #92</i>			
 <b>emitor2</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_9		
Base Tag:	BOOL_OUT_9		
Constant	No		
External Access:	Read/Write		
<i>emitor2 - MainProgram/paletizer - #13, #138</i>			
<i>emitor2 - MainProgram/simulacia - #93</i>			
 <b>ENTER</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>ENTER - MainProgram/vykladanie_palieta - #15, #9</i>			
 <b>ENTER1</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>ENTER1 - MainProgram/paletizer_vykladanie - #14</i>			
<b>fall</b>		FBD_ONESHOT	MainProgram
Constant	No		
External Access:	Read/Write		
<i>fall - MainProgram/paletizer - #2</i>			
<b>fall.EnableIn</b>	1	BOOL	
<i>fall.EnableIn - MainProgram/paletizer - #125</i>			
<b>fall.InputBit</b>	0	BOOL	
<i>fall.InputBit - MainProgram/paletizer - #124</i>			
<b>fall.OutputBit</b>	0	BOOL	
<i>fall.OutputBit - MainProgram/paletizer - #127</i>			
<b>hold</b>	0	BOOL	MainProgram
Constant	No		
External Access:	Read/Write		
<i>hold - MainProgram/generovanie_palieta - #134, #30</i>			
<i>hold - MainProgram/simulacia - #140</i>			
<i>hold - MainProgram/vykladanie_palieta - #18, #20, #7</i>			











<b>hold1</b>	0	BOOL	MainProgram
Constant	No		
External Access:	Read/Write		
<i>hold1 - MainProgram/paletizer_vykladanie - *#16, *#18, *#22, *#7</i>			
<i>hold1 - MainProgram/paletizer_zakladanie - #127, #25</i>			
<i>hold1 - MainProgram/simulacia - *#117</i>			
<b>holding</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>holding - MainProgram/generovanie_paliet - *#133, *#135</i>			
<i>holding - MainProgram/simulacia - *#89</i>			
<i>holding - MainProgram/vykladanie_paliet - #28, *#8</i>			
<b>holding1</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>holding1 - MainProgram/paletizer_vykladanie - #26, *#8</i>			
<i>holding1 - MainProgram/paletizer_zakladanie - *#126, *#128</i>			
<i>holding1 - MainProgram/simulacia - *#134</i>			
<b>INT_OUT_0</b>	21474	INT	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>stacker0_targ - MainProgram/generovanie_paliet - #63, #64, *#118, *#127, *#54, *#6, *#64</i>			
<i>stacker0_targ - MainProgram/paletizer_vykladanie - *#6, *#92</i>			
<i>stacker0_targ - MainProgram/simulacia - *#81</i>			
<i>stacker0_targ - MainProgram/vykladanie_paliet - #32, *#33, *#6, *#70, *#80</i>			
<b>INT_OUT_1</b>	0	INT	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>stacker1_targ - MainProgram/paletizer_vykladanie - #30, *#31, *#65, *#75</i>			
<i>stacker1_targ - MainProgram/paletizer_zakladanie - #56, #57, *#111, *#120, *#48, *#57, *#6</i>			
<i>stacker1_targ - MainProgram/simulacia - *#129</i>			
<b>load0</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_13		
Base Tag:	BOOL_OUT_13		
Constant	No		
External Access:	Read/Write		
<i>load0 - MainProgram/generovanie_paliet - *#17, *#20, *#31</i>			
<i>load0 - MainProgram/simulacia - *#12, *#76</i>			
<b>load1</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_14		
Base Tag:	BOOL_OUT_14		
Constant	No		
External Access:	Read/Write		
<i>load1 - MainProgram/simulacia - *#143, *#29</i>			
<i>load1 - MainProgram/zakoncenie_vykladania - *#16</i>			
<b>load2</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_15		
Base Tag:	BOOL_OUT_15		
Constant	No		
External Access:	Read/Write		
<i>load2 - MainProgram/paletizer_zakladanie - *#14, *#17, *#26, *#33</i>			
<i>load2 - MainProgram/simulacia - *#124, *#21</i>			
<b>load3</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_16		
Base Tag:	BOOL_OUT_16		
Constant	No		

<b>load3 (Continued)</b>			
External Access:	Read/Write		
<i>load3 - MainProgram/simulacia - *#40</i>			
<i>load3 - MainProgram/zakoncenie_vykladania - *#27, *#33</i>			
 <b>pal_running</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pal_running - MainProgram/paletizer - #104, #12, #120, #133, #146, #22, #31, #54, #67, #69, #73, #81, #85, #93</i>			
<i>pal_running - MainProgram/simulacia - #60, #63, *#55, *#57, *#70</i>			
 <b>palet_belt</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_20		
Base Tag:	BOOL_OUT_20		
Constant	No		
External Access:	Read/Write		
<i>palet_belt - MainProgram/paletizer - *#33, *#56</i>			
<i>palet_belt - MainProgram/simulacia - *#64, *#95</i>			
 <b>palet_beltm</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_21		
Base Tag:	BOOL_OUT_21		
Constant	No		
External Access:	Read/Write		
<i>palet_beltm - MainProgram/paletizer - *#122, *#128</i>			
<i>palet_beltm - MainProgram/simulacia - *#96</i>			
 <b>palet_chain</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_22		
Base Tag:	BOOL_OUT_22		
Constant	No		
External Access:	Read/Write		
<i>palet_chain - MainProgram/paletizer - *#149, *#15, *#25</i>			
<i>palet_chain - MainProgram/simulacia - *#62, *#98</i>			
 <b>palet_clamp</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_19		
Base Tag:	BOOL_OUT_19		
Constant	No		
External Access:	Read/Write		
<i>palet_clamp - MainProgram/paletizer - *#82, *#95</i>			
<i>palet_clamp - MainProgram/simulacia - *#103</i>			
 <b>palet_clamped</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_8		
Base Tag:	BOOL_IN_8		
Constant	No		
External Access:	Read/Write		
<i>palet_clamped - MainProgram/paletizer - #85</i>			
 <b>palet_ele_mov</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_11		
Base Tag:	BOOL_IN_11		
Constant	No		
External Access:	Read/Write		
<i>palet_ele_mov - MainProgram/paletizer - #104, #141, #146, #31, #99</i>			
 <b>palet_elev_back</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_12		
Base Tag:	BOOL_IN_12		
Constant	No		
External Access:	Read/Write		
<i>palet_elev_back - MainProgram/paletizer - #19</i>			








 <b>palet_elev_down</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_25		
Base Tag:	BOOL_OUT_25		
Constant	No		
External Access:	Read/Write		
<i>palet_elev_down - MainProgram/paletizer - *#105, *#140, *#148, *#94</i>			
<i>palet_elev_down - MainProgram/simulacia - *#101</i>			
 <b>palet_elev_front</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_13		
Base Tag:	BOOL_IN_13		
Constant	No		
External Access:	Read/Write		
<i>palet_elev_front - MainProgram/paletizer - #152, #22</i>			
<i>palet_elev_front - MainProgram/simulacia - *#108</i>			
 <b>palet_elev_limit</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_26		
Base Tag:	BOOL_OUT_26		
Constant	No		
External Access:	Read/Write		
<i>palet_elev_limit - MainProgram/paletizer - *#139, *#147, *#24, *#58</i>			
<i>palet_elev_limit - MainProgram/simulacia - *#102</i>			
 <b>palet_elev_up</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_24		
Base Tag:	BOOL_OUT_24		
Constant	No		
External Access:	Read/Write		
<i>palet_elev_up - MainProgram/paletizer - *#26, *#59</i>			
<i>palet_elev_up - MainProgram/simulacia - *#100</i>			
 <b>palet_open</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_23		
Base Tag:	BOOL_OUT_23		
Constant	No		
External Access:	Read/Write		
<i>palet_open - MainProgram/paletizer - #109, *#106, *#86</i>			
<i>palet_open - MainProgram/simulacia - *#105, *#99</i>			
 <b>palet_PL</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_IN_9		
Base Tag:	BOOL_IN_9		
Constant	No		
External Access:	Read/Write		
<i>palet_PL - MainProgram/paletizer - #109, #120, #133, #89, #93</i>			
 <b>palet_push</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_17		
Base Tag:	BOOL_OUT_17		
Constant	No		
External Access:	Read/Write		
<i>palet_push - MainProgram/paletizer - #62, #77, *#57, *#74, *#96</i>			
<i>palet_push - MainProgram/simulacia - *#104</i>			
 <b>palet_push_lim</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_IN_10		
Base Tag:	BOOL_IN_10		
Constant	No		
External Access:	Read/Write		
<i>palet_push_lim - MainProgram/paletizer - #31, #62, #73, #77, #81, #85</i>			
 <b>palet_turn</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_18		










<b>palet_turn (Continued)</b>			
Base Tag:	BOOL_OUT_18		
Constant	No		
External Access:	Read/Write		
<i>palet_turn - MainProgram/paletizer - *#121, *#137</i>			
<i>palet_turn - MainProgram/simulacia - *#106</i>			
 <b>pas0CW</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_1		
Base Tag:	BOOL_OUT_1		
Constant	No		
External Access:	Read/Write		
<i>pas0CW - MainProgram/generovanie_paliet - *#15, *#21, *#32</i>			
<i>pas0CW - MainProgram/simulacia - *#11, *#74</i>			
 <b>pas1CCW</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_2		
Base Tag:	BOOL_OUT_2		
Constant	No		
External Access:	Read/Write		
<i>pas1CCW - MainProgram/generovanie_paliet - *#16, *#24, *#35</i>			
<i>pas1CCW - MainProgram/simulacia - *#75</i>			
 <b>pas2_0</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_30		
Base Tag:	BOOL_OUT_30		
Constant	No		
External Access:	Read/Write		
<i>pas2_0 - MainProgram/generovanie_paliet - *#13, *#22, *#33</i>			
<i>pas2_0 - MainProgram/simulacia - *#72, *#9</i>			
 <b>pas2_1</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_31		
Base Tag:	BOOL_OUT_31		
Constant	No		
External Access:	Read/Write		
<i>pas2_1 - MainProgram/generovanie_paliet - *#14, *#23, *#34</i>			
<i>pas2_1 - MainProgram/simulacia - *#10, *#73</i>			
 <b>pas2_2</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_32		
Base Tag:	BOOL_OUT_32		
Constant	No		
External Access:	Read/Write		
<i>pas2_2 - MainProgram/simulacia - *#32</i>			
<i>pas2_2 - MainProgram/zakoncenie_vykladania - *#19</i>			
 <b>pas2CW</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_3		
Base Tag:	BOOL_OUT_3		
Constant	No		
External Access:	Read/Write		
<i>pas2CW - MainProgram/simulacia - *#144, *#30</i>			
<i>pas2CW - MainProgram/zakoncenie_vykladania - *#17, *#42</i>			
 <b>pas3CCW</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_4		
Base Tag:	BOOL_OUT_4		
Constant	No		
External Access:	Read/Write		
<i>pas3CCW - MainProgram/simulacia - *#145, *#31</i>			
<i>pas3CCW - MainProgram/zakoncenie_vykladania - *#18, *#43</i>			
 <b>pas4_0</b>	0	BOOL	xviate00_DP









<b>pas4_0 (Continued)</b>			
AliasFor:	BOOL_OUT_34		
Base Tag:	BOOL_OUT_34		
Constant	No		
External Access:	Read/Write		
<i>pas4_0 - MainProgram/simulacia - *#146, *#33</i>			
<i>pas4_0 - MainProgram/zakoncenie_vykladania - *#20, *#44</i>			
 <b>pas4_1</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_35		
Base Tag:	BOOL_OUT_35		
Constant	No		
External Access:	Read/Write		
<i>pas4_1 - MainProgram/simulacia - *#147, *#34</i>			
<i>pas4_1 - MainProgram/zakoncenie_vykladania - *#21, *#45</i>			
 <b>pas4_2</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_36		
Base Tag:	BOOL_OUT_36		
Constant	No		
External Access:	Read/Write		
<i>pas4_2 - MainProgram/paletizer_zakladanie - *#12, *#18, *#27</i>			
<i>pas4_2 - MainProgram/simulacia - *#122, *#19</i>			
 <b>pas4_3</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_37		
Base Tag:	BOOL_OUT_37		
Constant	No		
External Access:	Read/Write		
<i>pas4_3 - MainProgram/simulacia - *#42</i>			
<i>pas4_3 - MainProgram/zakoncenie_vykladania - *#29, *#35, *#54, *#59</i>			
 <b>pas4_4</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_38		
Base Tag:	BOOL_OUT_38		
Constant	No		
External Access:	Read/Write		
<i>pas4_4 - MainProgram/simulacia - *#148, *#35</i>			
<i>pas4_4 - MainProgram/zakoncenie_vykladania - *#22</i>			
 <b>pas4_5</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_33		
Base Tag:	BOOL_OUT_33		
Constant	No		
External Access:	Read/Write		
<i>pas4_5 - MainProgram/paletizer - *#14, *#20, *#23</i>			
<i>pas4_5 - MainProgram/simulacia - *#61, *#97</i>			
 <b>pas4CCW</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_5		
Base Tag:	BOOL_OUT_5		
Constant	No		
External Access:	Read/Write		
<i>pas4CCW - MainProgram/paletizer_zakladanie - *#13, *#19, *#28</i>			
<i>pas4CCW - MainProgram/simulacia - *#123, *#20</i>			
 <b>pas5CW</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_6		
Base Tag:	BOOL_OUT_6		
Constant	No		
External Access:	Read/Write		
<i>pas5CW - MainProgram/simulacia - *#41</i>			
<i>pas5CW - MainProgram/zakoncenie_vykladania - *#28, *#34</i>			








 <b>pas6_0</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_39		
Base Tag:	BOOL_OUT_39		
Constant	No		
External Access:	Read/Write		
<i>pas6_0 - MainProgram/simulacia - *#149, *#36</i>			
<i>pas6_0 - MainProgram/zakoncenie_vykladania - *#23, *#46</i>			
 <b>pas6_1</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_40		
Base Tag:	BOOL_OUT_40		
Constant	No		
External Access:	Read/Write		
<i>pas6_1 - MainProgram/simulacia - *#43</i>			
<i>pas6_1 - MainProgram/zakoncenie_vykladania - *#30, *#36</i>			
 <b>pole_nul</b>		INT[9,6]	xviate00_DP
Constant	No		
External Access:	Read/Write		
<b>pole_nul[0,0]</b>	0	INT	
<i>pole_nul[0,0] - MainProgram/simulacia - #118, #119, #86, #87</i>			
 <b>pozicia_x</b>	0	INT	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pozicia_x - MainProgram/simulacia - *#138</i>			
<i>pozicia_x - MainProgram/vykladanie_paliet - #17, #19, #33, #41, #44, *#22, *#4</i>			
 <b>pozicia_x1</b>	0	INT	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pozicia_x1 - MainProgram/paletizer_vykladanie - #15, #17, #31, *#20, *#4</i>			
<i>pozicia_x1 - MainProgram/simulacia - *#115</i>			
 <b>pozicia_y</b>	0	INT	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pozicia_y - MainProgram/vykladanie_paliet - #17, #19, #33, #41, #44, *#23, *#5</i>			
 <b>pozicia_y1</b>	0	INT	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pozicia_y1 - MainProgram/paletizer_vykladanie - #15, #17, #31, *#21, *#5</i>			
 <b>pozicia0</b>	2	INT	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pozicia0 - MainProgram/generovanie_paliet - #128, #141, #153, #161, #175, #54, #57, *#128, *#144, *#153, *#175</i>			
<i>pozicia0 - MainProgram/simulacia - *#82</i>			
 <b>pozicia1</b>	0	INT	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>pozicia1 - MainProgram/paletizer_zakladanie - #121, #48, #51, *#121</i>			
<i>pozicia1 - MainProgram/simulacia - *#130</i>			
 <b>remover0</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_27		
Base Tag:	BOOL_OUT_27		
Constant	No		
External Access:	Read/Write		
<i>remover0 - MainProgram/simulacia - *#38</i>			
<i>remover0 - MainProgram/zakoncenie_vykladania - *#25</i>			




 <b>reset</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>reset - MainProgram/MainRoutine - 4(JSR)</i>			
<i>reset - MainProgram/simulacia - #68</i>			
 <b>retro0</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_IN_15		
Base Tag:	BOOL_IN_15		
Constant	No		
External Access:	Read/Write		
<i>retro0 - MainProgram/paletizer - #19</i>			
 <b>retro1</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_IN_16		
Base Tag:	BOOL_IN_16		
Constant	No		
External Access:	Read/Write		
<i>retro1 - MainProgram/paletizer - #124, #36</i>			
<b>rise</b>		FBD_ONESHOT	MainProgram
Constant	No		
External Access:	Read/Write		
<i>rise - MainProgram/paletizer - *#1</i>			
<b>rise.EnableIn</b>	0	BOOL	
<i>rise.EnableIn - MainProgram/paletizer - *#37, *#43</i>			
<i>rise.EnableIn - MainProgram/simulacia - *#107</i>			
<b>rise.InputBit</b>	1	BOOL	
<i>rise.InputBit - MainProgram/paletizer - *#18, *#36</i>			
<b>rise.OutputBit</b>	0	BOOL	
<i>rise.OutputBit - MainProgram/paletizer - #38</i>			
<b>row</b>	0	INT	MainProgram
Constant	No		
External Access:	Read/Write		
<i>row - MainProgram/paletizer - #113, #114, *#113, *#136</i>			
<i>row - MainProgram/simulacia - *#111</i>			
 <b>run</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>run - MainProgram/simulacia - #2, #50, #6</i>			
 <b>running</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>running - MainProgram/generovanie_paliat - #5</i>			
<i>running - MainProgram/MainRoutine - 3(JSR), 3(JSR), 3(JSR), 3(JSR), 3(JSR)</i>			
<i>running - MainProgram/paletizer - #7</i>			
<i>running - MainProgram/paletizer_vykladanie - #9</i>			
<i>running - MainProgram/paletizer_zakladanie - #5</i>			
<i>running - MainProgram/simulacia - *#3, *#69</i>			
<i>running - MainProgram/vykladanie_paliat - #10</i>			
<i>running - MainProgram/zakoncenie_vykladania - #5</i>			
 <b>S0_moving</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>S0_moving - MainProgram/simulacia - *#158, *#160</i>			
 <b>S1_moving</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>S1_moving - MainProgram/simulacia - *#164, *#166</i>			


 <b>safety_door</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_17		
Base Tag:	BOOL_IN_17		
Constant	No		
External Access:	Read/Write		
<i>safety_door - MainProgram/MainRoutine - 2(XIC)</i>			
 <b>safety_door_OK</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>safety_door_OK - MainProgram/MainRoutine - *2(OTE), 3(XIC)</i>			
<i>safety_door_OK - MainProgram/simulacia - #6</i>			
 <b>safety_door1</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_18		
Base Tag:	BOOL_IN_18		
Constant	No		
External Access:	Read/Write		
<i>safety_door1 - MainProgram/MainRoutine - 2(XIC)</i>			
 <b>safety_door2</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_19		
Base Tag:	BOOL_IN_19		
Constant	No		
External Access:	Read/Write		
<i>safety_door2 - MainProgram/MainRoutine - 2(XIC)</i>			
 <b>safety_reset</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>safety_reset - MainProgram/simulacia - #50</i>			
 <b>sklad0L</b>		INT[9,6]	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>sklad0L - MainProgram/generovanie_paliet - #171, *#87</i>			
<i>sklad0L - MainProgram/vykladanie_paliet - #19, *#44</i>			
<b>sklad0L[0,0]</b>	0	INT	
<i>sklad0L[0,0] - MainProgram/simulacia - *#87</i>			
 <b>sklad0P</b>		INT[9,6]	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>sklad0P - MainProgram/generovanie_paliet - #149, *#76, *#80, *#91</i>			
<i>sklad0P - MainProgram/paletizer_zakladanie - *#73, *#84</i>			
<i>sklad0P - MainProgram/vykladanie_paliet - #17, *#41</i>			
<b>sklad0P[0,0]</b>	0	INT	
<i>sklad0P[0,0] - MainProgram/simulacia - *#86</i>			
 <b>sklad1L</b>		INT[9,6]	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>sklad1L - MainProgram/paletizer_vykladanie - #17</i>			
<i>sklad1L - MainProgram/paletizer_zakladanie - *#80</i>			
<b>sklad1L[0,0]</b>	0	INT	
<i>sklad1L[0,0] - MainProgram/simulacia - *#119</i>			
 <b>sklad1P</b>		INT[9,6]	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>sklad1P - MainProgram/paletizer_vykladanie - #15</i>			
<i>sklad1P - MainProgram/paletizer_zakladanie - *#69</i>			
<b>sklad1P[0,0]</b>	0	INT	
<i>sklad1P[0,0] - MainProgram/simulacia - *#118</i>			


 <b>stacker0_L</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_43		
Base Tag:	BOOL_OUT_43		
Constant	No		
External Access:	Read/Write		
<i>stacker0_L - MainProgram/generovanie_paliet - *#113, *#84</i>			
<i>stacker0_L - MainProgram/simulacia - *#78</i>			
<i>stacker0_L - MainProgram/vykladanie_paliet - *#45, *#65, *#81, *#94</i>			
 <b>stacker0_lift</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_41		
Base Tag:	BOOL_OUT_41		
Constant	No		
External Access:	Read/Write		
<i>stacker0_lift - MainProgram/generovanie_paliet - *#41, *#97</i>			
<i>stacker0_lift - MainProgram/simulacia - *#79</i>			
<i>stacker0_lift - MainProgram/vykladanie_paliet - *#49, *#86</i>			
 <b>stacker0_LL</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_27		
Base Tag:	BOOL_IN_27		
Constant	No		
External Access:	Read/Write		
<i>stacker0_LL - MainProgram/generovanie_paliet - #100, #112, #96</i>			
<i>stacker0_LL - MainProgram/vykladanie_paliet - #48, #53, #85, #89</i>			
 <b>stacker0_M</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_IN_31		
Base Tag:	BOOL_IN_31		
Constant	No		
External Access:	Read/Write		
<i>stacker0_M - MainProgram/generovanie_paliet - #117, #53</i>			
<i>stacker0_M - MainProgram/vykladanie_paliet - #69</i>			
 <b>stacker0_MX</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_23		
Base Tag:	BOOL_IN_23		
Constant	No		
External Access:	Read/Write		
<i>stacker0_MX - MainProgram/generovanie_paliet - #121, #125, #68, #72, #83</i>			
<i>stacker0_MX - MainProgram/simulacia - #157</i>			
<i>stacker0_MX - MainProgram/vykladanie_paliet - #36, #40, #43, #73, #77</i>			
 <b>stacker0_MZ</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_24		
Base Tag:	BOOL_IN_24		
Constant	No		
External Access:	Read/Write		
<i>stacker0_MZ - MainProgram/generovanie_paliet - #100, #105, #44, #48, #72, #83</i>			
<i>stacker0_MZ - MainProgram/simulacia - #157</i>			
<i>stacker0_MZ - MainProgram/vykladanie_paliet - #40, #43, #53, #57, #89, #93</i>			
 <b>stacker0_R</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_45		
Base Tag:	BOOL_OUT_45		
Constant	No		
External Access:	Read/Write		
<i>stacker0_R - MainProgram/generovanie_paliet - *#110, *#25, *#49, *#73</i>			
<i>stacker0_R - MainProgram/simulacia - *#77</i>			
<i>stacker0_R - MainProgram/vykladanie_paliet - *#42, *#62</i>			
 <b>stacker0_RL</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_29		
Base Tag:	BOOL_IN_29		

<b>stacker0_RL (Continued)</b>			
Constant	No		
External Access:	Read/Write		
<i>stacker0_RL - MainProgram/generovanie_paliet - #100, #109, #40, #44, #96</i>			
<i>stacker0_RL - MainProgram/vykladanie_paliet - #48, #53</i>			
 <b>stacker0_targ</b>	21474	INT	xviate00_DP
AliasFor:	INT_OUT_0		
Base Tag:	INT_OUT_0		
Constant	No		
External Access:	Read/Write		
<i>stacker0_targ - MainProgram/generovanie_paliet - #63, #64, *#118, *#127, *#54, *#6, *#64</i>			
<i>stacker0_targ - MainProgram/paletizer_vykladanie - *#6, *#92</i>			
<i>stacker0_targ - MainProgram/simulacia - *#81</i>			
<i>stacker0_targ - MainProgram/vykladanie_paliet - #32, *#33, *#6, *#70, *#80</i>			
 <b>stacker1_L</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_44		
Base Tag:	BOOL_OUT_44		
Constant	No		
External Access:	Read/Write		
<i>stacker1_L - MainProgram/paletizer_vykladanie - *#41, *#60, *#76, *#89</i>			
<i>stacker1_L - MainProgram/paletizer_zakladanie - *#106, *#77</i>			
<i>stacker1_L - MainProgram/simulacia - *#126</i>			
 <b>stacker1_lift</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_42		
Base Tag:	BOOL_OUT_42		
Constant	No		
External Access:	Read/Write		
<i>stacker1_lift - MainProgram/paletizer_vykladanie - *#45, *#81</i>			
<i>stacker1_lift - MainProgram/paletizer_zakladanie - *#35, *#90</i>			
<i>stacker1_lift - MainProgram/simulacia - *#127</i>			
 <b>stacker1_LL</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_28		
Base Tag:	BOOL_IN_28		
Constant	No		
External Access:	Read/Write		
<i>stacker1_LL - MainProgram/paletizer_vykladanie - #44, #48, #80, #84</i>			
<i>stacker1_LL - MainProgram/paletizer_zakladanie - #105, #89, #93</i>			
 <b>stacker1_M</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_IN_32		
Base Tag:	BOOL_IN_32		
Constant	No		
External Access:	Read/Write		
<i>stacker1_M - MainProgram/paletizer_vykladanie - #64</i>			
<i>stacker1_M - MainProgram/paletizer_zakladanie - #110, #47</i>			
 <b>stacker1_MX</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_25		
Base Tag:	BOOL_IN_25		
Constant	No		
External Access:	Read/Write		
<i>stacker1_MX - MainProgram/paletizer_vykladanie - #34, #38, #40, #68, #72</i>			
<i>stacker1_MX - MainProgram/paletizer_zakladanie - #114, #118, #61, #65, #76</i>			
<i>stacker1_MX - MainProgram/simulacia - #163</i>			
 <b>stacker1_MZ</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_26		
Base Tag:	BOOL_IN_26		
Constant	No		
External Access:	Read/Write		


**stacker1\_MZ (Continued)***stacker1\_MZ - MainProgram/paletizer\_vykladanie - #38, #40, #48, #52, #84, #88**stacker1\_MZ - MainProgram/paletizer\_zakladanie - #38, #42, #65, #76, #93, #98**stacker1\_MZ - MainProgram/simulacia - #163*

 <b>stacker1_R</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_46		
Base Tag:	BOOL_OUT_46		
Constant	No		
External Access:	Read/Write		
<i>stacker1_R - MainProgram/paletizer_vykladanie - *#39, *#57</i>			
<i>stacker1_R - MainProgram/paletizer_zakladanie - *#103, *#20, *#43, *#66</i>			
<i>stacker1_R - MainProgram/simulacia - *#125</i>			

 <b>stacker1_RL</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_30		
Base Tag:	BOOL_IN_30		
Constant	No		
External Access:	Read/Write		
<i>stacker1_RL - MainProgram/paletizer_vykladanie - #44, #48</i>			
<i>stacker1_RL - MainProgram/paletizer_zakladanie - #102, #34, #38, #89, #93</i>			

 <b>stacker1_targ</b>	0	INT	xviate00_DP
AliasFor:	INT_OUT_1		
Base Tag:	INT_OUT_1		
Constant	No		
External Access:	Read/Write		
<i>stacker1_targ - MainProgram/paletizer_vykladanie - #30, *#31, *#65, *#75</i>			
<i>stacker1_targ - MainProgram/paletizer_zakladanie - #56, #57, *#111, *#120, *#48, *#57, *#6</i>			
<i>stacker1_targ - MainProgram/simulacia - *#129</i>			







 <b>start</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_33		
Base Tag:	BOOL_IN_33		
Constant	No		
External Access:	Read/Write		
<i>start - MainProgram/MainRoutine - 0(XIC)</i>			





 <b>start_but</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_47		
Base Tag:	BOOL_OUT_47		
Constant	No		
External Access:	Read/Write		
<i>start_but - MainProgram/simulacia - #54</i>			

<b>start_pal</b>	1	BOOL	MainProgram
Constant	No		
External Access:	Read/Write		
<i>start_pal - MainProgram/MainRoutine - *0(OTL), 1(JSR), 1(XIC)</i>			




<b>stav_gen</b>	9	INT	MainProgram
Constant	No		
External Access:	Read/Write		
<i>stav_gen - MainProgram/generovanie_paliet - #2, *#101, *#106, *#111, *#114, *#122, *#130, *#136, *#150, *#172, *#26, *#36, *#45, *#50, *#69, *#7</i>			
<i>stav_gen - MainProgram/simulacia - #8, *#90</i>			

<b>stav_pal</b>	0	INT	MainProgram
Constant	No		
External Access:	Read/Write		
<i>stav_pal - MainProgram/paletizer - #4, *#100, *#110, *#115, *#117, *#129, *#142, *#153, *#27, *#40, *#45, *#47, *#49, *#51, *#64, *#68, *#70, *#78, *#8, *#90</i>			
<i>stav_pal - MainProgram/simulacia - #60, #63, *#112</i>			

<b>stav_pal_vyk</b>	0	INT	MainProgram
Constant	No		
External Access:	Read/Write		
<i>stav_pal_vyk - MainProgram/paletizer_vykladanie - #2, #10, #27, #35, #49, #53, #58, #61, #69, #77, #85, #90</i>			
<i>stav_pal_vyk - MainProgram/simulacia - #120</i>			
<b>stav_pal_zak</b>	0	INT	MainProgram
Constant	No		
External Access:	Read/Write		
<i>stav_pal_zak - MainProgram/paletizer_zakladanie - #2, #104, #107, #115, #123, #129, #21, #29, #39, #44, #62, #7, #94, #99</i>			
<i>stav_pal_zak - MainProgram/simulacia - #18, #135</i>			
<b>stav_vyk</b>	1	INT	MainProgram
Constant	No		
External Access:	Read/Write		
<i>stav_vyk - MainProgram/simulacia - #141</i>			
<i>stav_vyk - MainProgram/vykladanie_paliet - #2, #11, #24, #29, #37, #54, #58, #63, #66, #74, #82, #90, #95</i>			
<b>stav_zak</b>	0	INT	MainProgram
Constant	No		
External Access:	Read/Write		
<i>stav_zak - MainProgram/simulacia - #28, #153</i>			
<i>stav_zak - MainProgram/zakoncenie_vykladania - #2, #11, #37, #50, #6, #65</i>			
 <b>stop</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_IN_34		
Base Tag:	BOOL_IN_34		
Constant	No		
External Access:	Read/Write		
<i>stop - MainProgram/MainRoutine - 0(XIC), 1(XIC)</i>			
 <b>stop_but</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_OUT_48		
Base Tag:	BOOL_OUT_48		
Constant	No		
External Access:	Read/Write		
<i>stop_but - MainProgram/simulacia - #54</i>			
 <b>stop_sim</b>	0	BOOL	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>stop_sim - MainProgram/generovanie_paliet - #105, #109, #11, #112, #117, #40, #48, #53, #72, #83</i>			
<i>stop_sim - MainProgram/paletizer_vykladanie - #30, #38, #40, #52, #56, #64, #72, #80</i>			
<i>stop_sim - MainProgram/paletizer_zakladanie - #102, #105, #11, #110, #34, #42, #47, #65, #76, #98</i>			
<i>stop_sim - MainProgram/simulacia - #2, #13, #15, #22, #24, #44, #46, #51</i>			
<i>stop_sim - MainProgram/vykladanie_paliet - #32, #40, #43, #57, #61, #64, #69, #77, #85</i>			
<i>stop_sim - MainProgram/zakoncenie_vykladania - #14, #41, #53</i>			
 <b>turn_back</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_37		
Base Tag:	BOOL_IN_37		
Constant	No		
External Access:	Read/Write		
<i>turn_back - MainProgram/zakoncenie_vykladania - #57</i>			
 <b>turn_L0</b>	1	BOOL	xviate00_DP
AliasFor:	BOOL_IN_35		
Base Tag:	BOOL_IN_35		
Constant	No		
External Access:	Read/Write		
<i>turn_L0 - MainProgram/zakoncenie_vykladania - #63</i>			
 <b>turn_L90</b>	0	BOOL	xviate00_DP
AliasFor:	BOOL_IN_36		

<b>turn_L90 (Continued)</b>				
Base Tag:	BOOL_IN_36			
Constant	No			
External Access:	Read/Write			
<i>turn_L90 - MainProgram/zakoncenie_vykladania - #53</i>				
 <b>turn_roll</b>	0	BOOL		xviate00_DP
AliasFor:	BOOL_OUT_50			
Base Tag:	BOOL_OUT_50			
Constant	No			
External Access:	Read/Write			
<i>turn_roll - MainProgram/simulacia - *#150, *#37</i>				
<i>turn_roll - MainProgram/zakoncenie_vykladania - *#24, *#47, *#64</i>				
 <b>turn_rollm</b>	1	BOOL		xviate00_DP
AliasFor:	BOOL_OUT_29			
Base Tag:	BOOL_OUT_29			
Constant	No			
External Access:	Read/Write			
<i>turn_rollm - MainProgram/simulacia - *#152</i>				
<i>turn_rollm - MainProgram/zakoncenie_vykladania - *#49, *#58</i>				
 <b>turn_turn</b>	1	BOOL		xviate00_DP
AliasFor:	BOOL_OUT_49			
Base Tag:	BOOL_OUT_49			
Constant	No			
External Access:	Read/Write			
<i>turn_turn - MainProgram/simulacia - *#151</i>				
<i>turn_turn - MainProgram/zakoncenie_vykladania - *#48, *#60</i>				
<b>vlavo0</b>	0	BOOL		MainProgram
Constant	No			
External Access:	Read/Write			
<i>vlavo0 - MainProgram/generovanie_paliet - #72, #83, *#65</i>				
<i>vlavo0 - MainProgram/simulacia - *#88</i>				
<b>vlavo0_vyk</b>	0	BOOL		MainProgram
Constant	No			
External Access:	Read/Write			
<i>vlavo0_vyk - MainProgram/simulacia - *#139</i>				
<i>vlavo0_vyk - MainProgram/vykladanie_paliet - #17, #19, #40, #43, #61, #64</i>				
<b>vlavo1</b>	0	BOOL		MainProgram
Constant	No			
External Access:	Read/Write			
<i>vlavo1 - MainProgram/paletizer_zakladanie - #65, #76, *#58</i>				
<i>vlavo1 - MainProgram/simulacia - *#133</i>				
<b>vlavo1_vyk</b>	0	BOOL		MainProgram
Constant	No			
External Access:	Read/Write			
<i>vlavo1_vyk - MainProgram/paletizer_vykladanie - #15, #17, #38, #40, #56, #59</i>				
<i>vlavo1_vyk - MainProgram/simulacia - *#116</i>				
<b>vyloz</b>	1	BOOL		MainProgram
Constant	No			
External Access:	Read/Write			
<i>vyloz - MainProgram/paletizer_vykladanie - *#73</i>				
<i>vyloz - MainProgram/simulacia - *#114, *#137</i>				
<i>vyloz - MainProgram/vykladanie_paliet - *#78</i>				
<i>vyloz - MainProgram/zakoncenie_vykladania - #10</i>				
 <b>x</b>	0	INT		xviate00_DP
Constant	No			



<b>x (Continued)</b>			
External Access:	Read/Write		
<i>x - MainProgram/generovanie_paliet - #129, #149, #152, #156, #171, #174, #178, #75, #76, #80, #86, #87, #91, *#129, *#142, *#152, *#157, *#162, *#174, *#179, *#58, *#78, *#89</i>			
<i>x - MainProgram/simulacia - *#84</i>			
 <b>x1</b>	0	INT	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>x1 - MainProgram/paletizer_zakladanie - #122, #68, #69, #73, #79, #80, #84, *#122, *#52, *#71, *#82</i>			
<i>x1 - MainProgram/simulacia - *#131</i>			
 <b>y</b>	0	INT	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>y - MainProgram/generovanie_paliet - #149, #158, #171, #180, #76, #79, #80, #87, #90, #91, *#143, *#158, *#163, *#180, *#59, *#79, *#90</i>			
<i>y - MainProgram/simulacia - *#85</i>			
 <b>y1</b>	0	INT	xviate00_DP
Constant	No		
External Access:	Read/Write		
<i>y1 - MainProgram/paletizer_zakladanie - #69, #72, #73, #80, #83, #84, *#53, *#72, *#83</i>			
<i>y1 - MainProgram/simulacia - *#132</i>			
<b>zapln</b>	0	BOOL	MainProgram
Constant	No		
External Access:	Read/Write		
<i>zapln - MainProgram/generovanie_paliet - #148, *#145, *#169</i>			
<i>zapln - MainProgram/simulacia - *#83</i>			
<b>zapln_L</b>	0	BOOL	MainProgram
Constant	No		
External Access:	Read/Write		
<i>zapln_L - MainProgram/generovanie_paliet - #168, *#164</i>			

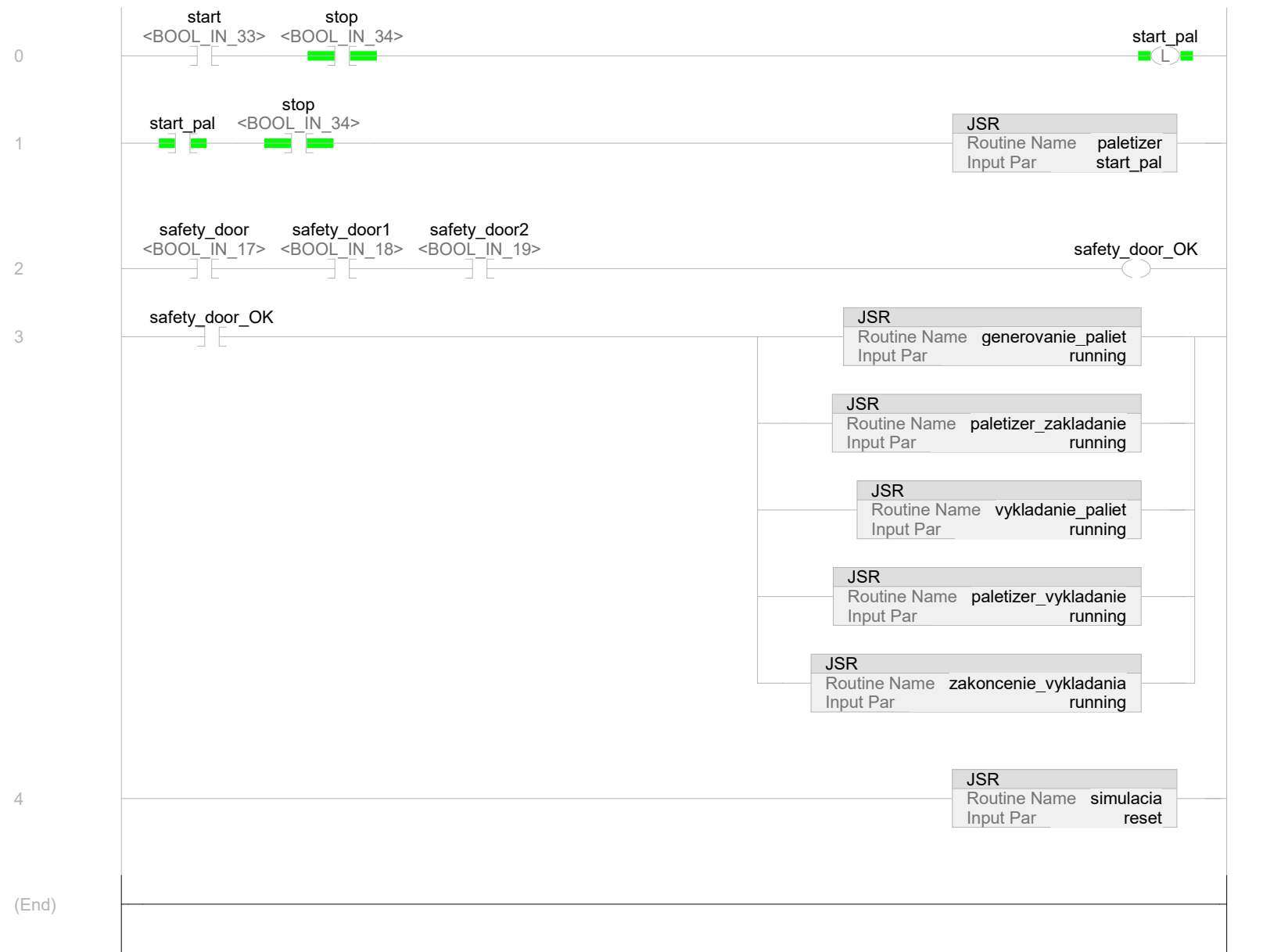


```
1
2 case stav_gen of
3
4     0:
5         if running then
6             stacker0_targ:=0;
7             stav_gen:=1;
8         end_if;
9
10    1:
11        if NOT stop_sim then
12            emit0:=1;
13            pas2_0:=1;
14            pas2_1:=1;
15            pas0CW:=1;
16            pas1CCW:=1;
17            load0:=1;
18
19            if dif_sen0 then
20                load0:=0;
21                pas0CW:=0;
22                pas2_0:=0;
23                pas2_1:=0;
24                pas1CCW:=0;
25                stacker0_R:=1;
26                stav_gen:=2;
27            end_if;
28        end_if;
29
30        if hold then
31            load0:=0;
32            pas0CW:=0;
33            pas2_0:=0;
34            pas2_1:=0;
35            pas1CCW:=0;
36            stav_gen:=20;
37        end_if;
38
39    2:
40        if stacker0_RL AND NOT stop_sim then
41            stacker0_lift:=1;
42        end_if;
43
44        if stacker0_RL AND stacker0_MZ then
45            stav_gen:=3;
46        end_if;
47
48    3:
49        if NOT stacker0_MZ AND NOT stop_sim then
50            stacker0_R:=0;
51            stav_gen:=4;
52        end_if;
53
54    4:
55        if stacker0_M AND NOT stop_sim then
56            stacker0_targ:=pozicia0;
57        end_if;
58
59        if pozicia0=55 then
60            x:=0;
61            y:=0;
```

```
60         end_if;
61
62
63         if stacker0_targ>54 then
64             stacker0_targ:= stacker0_targ - 54;
65             vlavo0:=1;
66         end_if;
67
68         if stacker0_MX then
69             stav_gen:=5;
70         end_if;
71     5:
72     if NOT stacker0_MX AND NOT stacker0_MZ AND NOT vlavo0 AND NOT stop_sim then
73         stacker0_R:=1;
74         //
75         if x<9 then
76             sklad0P[x,y]:=1;
77         else
78             x:=0;
79             y:=y+1;
80             sklad0P[x,y]:=1;
81         end_if;
82         //
83     elsif NOT stacker0_MX AND NOT stacker0_MZ AND vlavo0 AND NOT stop_sim then
84         stacker0_L:=1;
85         //
86         if x<9 then
87             sklad0L[x,y]:=1;
88         else
89             x:=0;
90             y:=y+1;
91             sklad0P[x,y]:=1;
92         end_if;
93         //
94     end_if;
95
96     if stacker0_LL OR stacker0_RL then
97         stacker0_lift:=0;
98     end_if;
99
100    if (stacker0_LL OR stacker0_RL) AND stacker0_MZ then
101        stav_gen:=6;
102    end_if;
103
104    6:
105    if NOT stacker0_MZ AND NOT stop_sim then
106        stav_gen:=7;
107    end_if;
108    7:
109    if stacker0_RL AND NOT stop_sim then
110        stacker0_R:=0;
111        stav_gen:=8;
112    elsif stacker0_LL AND NOT stop_sim then
113        stacker0_L:=0;
114        stav_gen:=8;
115    end_if;
116    8:
117    if stacker0_M AND NOT stop_sim then
118        stacker0_targ:=21474;
```

```
119         end_if;
120
121         if stacker0_MX then
122             stav_gen:=9;
123         end_if;
124     9:
125         if NOT stacker0_MX then
126
127             stacker0_targ:=0;
128             pozicia0:=pozicia0+1;
129             x:=x+1;
130             stav_gen:=1;
131         end_if;
132     20:
133         holding:=1;
134         if NOT hold then
135             holding:=0;
136             stav_gen:=1;
137         end_if;
138
139 end_case;
140
141 if pozicia0>108 then
142     x:=0;
143     y:=0;
144     pozicia0:=1;
145     zapln:=1;
146 end_if;
147
148 if zapln then
149     if sklad0P[x,y]=0 then
150         stav_gen:=1;
151     else
152         x:=x+1;
153         pozicia0:=pozicia0+1;
154     end_if;
155
156     if x>8 then
157         x:=0;
158         y:=y+1;
159     end_if;
160
161     if pozicia0>54 then
162         x:=0;
163         y:=0;
164         zapln_L:=1;
165     end_if;
166 end_if;
167
168 if zapln_L then
169     zapln:=0;
170
171     if sklad0L[x,y]=0 then
172         stav_gen:=1;
173     else
174         x:=x+1;
175         pozicia0:=pozicia0+1;
176     end_if;
177
```

```
178     if x>8 then
179         x:=0;
180         y:=y+1;
181     end_if;
182 end_if;
```



```
1 OSRI(rise);
2 OSFI(fall);
3
4 case stav_pal of
5     0:
6
7         if running then
8             stav_pal:=1;
9         end_if;
10
11     1:
12         if pal_running then
13             emitor2:=1;
14             pas4_5:=1;
15             palet_chain:=1;
16         end_if;
17
18         rise.InputBit:=0;
19         if retro0 AND palet_elev_back then
20             pas4_5:=0;
21         end_if;
22         if palet_elev_front AND pal_running then
23             pas4_5:=0;
24             palet_elev_limit:=1;
25             palet_chain:=0;
26             palet_elev_up:=1;
27             stav_pal:=2;
28         end_if;
29     2:
30         emitor1:=1;
31         if palet_push_lim AND NOT palet_ele_mov AND pal_running then
32             belt:=1;
33             palet_belt:=1;
34         end_if;
35
36         rise.InputBit:=retro1;
37         rise.EnableIn:=1;
38         if rise.OutputBit then
39             box:=box+1;
40             stav_pal:=3;
41         end_if;
42     3:
43         rise.EnableIn:=0;
44         if box<7 AND box<>3 AND box<>5 then
45             stav_pal:=2;
46         elsif box=3 OR box=5 OR box=7 then
47             stav_pal:=4;
48         elsif box>7 AND box<>11 AND box<>14 then
49             stav_pal:=2;
50         elsif box=11 OR box=14 then
51             stav_pal:=4;
52         end_if;
53     4:
54         if pal_running then
55             belt:=0;
56             palet_belt:=0;
57             palet_push:=1;
58             palet_elev_limit:=0;
59             palet_elev_up:=0;
```

```
60         end_if;
61
62         if palet_push AND NOT palet_push_lim then
63             count:=count+1;
64             stav_pal:=5;
65         end_if;
66     5:
67         if count=3 AND pal_running then
68             stav_pal:=6;
69         elsif count=5 AND pal_running then
70             stav_pal:=6;
71         end_if;
72
73         if palet_push_lim AND pal_running then
74             palet_push:=0;
75         end_if;
76
77         if NOT palet_push AND NOT palet_push_lim then
78             stav_pal:=2;
79         end_if;
80     6:
81         if palet_push_lim AND pal_running then
82             palet_clamp:=1;
83         end_if;
84
85         if palet_push_lim AND palet_clamped AND pal_running then
86             palet_open:=1;
87         end_if;
88
89         if NOT palet_PL then
90             stav_pal:=7;
91         end_if;
92     7:
93         if palet_PL AND pal_running then
94             palet_elev_down:=1;
95             palet_clamp:=0;
96             palet_push:=0;
97         end_if;
98
99         if palet_ele_mov then
100             stav_pal:=8;
101         end_if;
102
103     8:
104         if NOT palet_ele_mov AND pal_running then
105             palet_elev_down:=0;
106             palet_open:=0;
107         end_if;
108
109         if NOT palet_open AND NOT palet_PL then
110             stav_pal:=9;
111         end_if;
112     9:
113         row:=row+1;
114         if row<2 then
115             stav_pal:=10;
116         else
117             stav_pal:=11;
118         end_if;
```

```
119 10:
120   if palet_PL AND pal_running then
121     palet_turn:=1;
122     palet_beltm:=1;
123
124     fall.InputBit:=retrol;
125     fall.EnableIn:=1;
126
127     if fall.OutputBit then
128       palet_beltm:=0;
129       stav_pal:=2;
130   end_if;
131 end_if;
132 11:
133   if palet_PL AND pal_running then
134     box:=0;
135     count:=0;
136     row:=0;
137     palet_turn:=0;
138     emitor2:=0;
139     palet_elev_limit:=1;
140     palet_elev_down:=1;
141     if palet_ele_mov then
142       stav_pal:=12;
143   end_if;
144 end_if;
145 12:
146   if NOT palet_ele_mov AND pal_running then
147     palet_elev_limit:=0;
148     palet_elev_down:=0;
149     palet_chain:=1;
150   end_if;
151
152   if NOT palet_elev_front then
153     stav_pal:=1;
154   end_if;
155
156 end_case;
157
```



```
1
2 case stav_pal_vyk of
3     0:
4         pozicia_x1:=0;
5         pozicia_y1:=0;
6         stacker0_targ:=0;
7         hold1:=0;
8         holding1:=0;
9         if running then
10             stav_pal_vyk:=1;
11         end_if;
12
13     1:
14         if ENTER1 then
15             if sklad1P[pozicia_x1,pozicia_y1]=1 AND NOT vlavo1_vyk then
16                 hold1:=1;
17             elsif sklad1L[pozicia_x1,pozicia_y1]=1 AND vlavo1_vyk then
18                 hold1:=1;
19             else
20                 pozicia_x1:=0;
21                 pozicia_y1:=0;
22                 hold1:=0;
23             end_if;
24         end_if;
25
26         if holding1 then
27             stav_pal_vyk:=2;
28         end_if;
29
30     2:
31         if stacker1_targ = 0 AND NOT stop_sim then
32             stacker1_targ:=(pozicia_x1+1)+(pozicia_y1*9);
33         end_if;
34
35         if stacker1_MX then
36             stav_pal_vyk:=3;
37         end_if;
38
39     3:
40         if NOT stacker1_MX AND NOT stacker1_MZ AND NOT vlavo1_vyk AND NOT stop_sim then
41             stacker1_R:=1;
42         elsif NOT stacker1_MX AND NOT stacker1_MZ AND vlavo1_vyk AND NOT stop_sim then
43             stacker1_L:=1;
44         end_if;
45
46         if stacker1_LL OR stacker1_RL then
47             stacker1_lift:=1;
48         end_if;
49
50         if stacker1_LL OR stacker1_RL AND stacker1_MZ then
51             stav_pal_vyk:=4;
52         end_if;
53
54     4:
55         if NOT stacker1_MZ AND NOT stop_sim then
56             stav_pal_vyk:=5;
57         end_if;
58
59     5:
60         if NOT vlavo1_vyk AND NOT stop_sim then
61             stacker1_R:=0;
62             stav_pal_vyk:=6;
63         elsif vlavo1_vyk then
```

```
60         stacker1_L:=0;
61         stav_pal_vyk:=6;
62     end_if;
63 6:
64     if stacker1_M AND NOT stop_sim then
65         stacker1_targ:=21474;
66     end_if;
67
68     if stacker1_MX then
69         stav_pal_vyk:=7;
70     end_if;
71 7:
72     if NOT stacker1_MX AND NOT stop_sim then
73         vyloz:=1;
74
75         stacker1_targ:=0;
76         stacker1_L:=1;
77         stav_pal_vyk:=8;
78     end_if;
79 8:
80     if stacker1_LL AND NOT stop_sim then
81         stacker1_lift:=0;
82     end_if;
83
84     if stacker1_LL AND stacker1_MZ then
85         stav_pal_vyk:=9;
86     end_if;
87 9:
88     if NOT stacker1_MZ then
89         stacker1_L:=0;
90         stav_pal_vyk:=0;
91     end_if;
92     stacker0_targ:=21474;
93
94 end_case;
```

```
1
2 case stav_pal_zak of
3
4     0:
5         if running then
6             stacker1_targ:=0;
7             stav_pal_zak:=1;
8         end_if;
9
10    1:
11        if NOT stop_sim then
12            pas4_2:=1;
13            pas4CCW:=1;
14            load2:=1;
15
16            if dif_sen1 then
17                load2:=0;
18                pas4_2:=0;
19                pas4CCW:=0;
20                stacker1_R:=1;
21                stav_pal_zak:=2;
22            end_if;
23        end_if;
24
25        if hold1 then
26            load2:=0;
27            pas4_2:=0;
28            pas4CCW:=0;
29            stav_pal_zak:=20;
30        end_if;
31
32    2:
33        load2:=0;
34        if stacker1_RL AND NOT stop_sim then
35            stacker1_lift:=1;
36        end_if;
37
38        if stacker1_RL AND stacker1_MZ then
39            stav_pal_zak:=3;
40        end_if;
41
42    3:
43        if NOT stacker1_MZ AND NOT stop_sim then
44            stacker1_R:=0;
45            stav_pal_zak:=4;
46        end_if;
47
48    4:
49        if stacker1_M AND NOT stop_sim then
50            stacker1_targ:=pozicia1;
51        end_if;
52
53        if pozicia1=55 then
54            x1:=0;
55            y1:=0;
56        end_if;
57
58        if stacker1_targ>54 then
59            stacker1_targ:= stacker1_targ - 54;
60            vlavo1:=1;
61        end_if;
```

```
60
61     if stacker1_MX then
62         stav_pal_zak:=5;
63     end_if;
64 5:
65     if NOT stacker1_MX AND NOT stacker1_MZ AND NOT vlavo1 AND NOT stop_sim then
66         stacker1_R:=1;
67         //
68         if x1<9 then
69             sklad1P[x1,y1]:=1;
70         else
71             x1:=0;
72             y1:=y1+1;
73             sklad0P[x1,y1]:=1;
74         end_if;
75         //
76     elsif NOT stacker1_MX AND NOT stacker1_MZ AND vlavo1 AND NOT stop_sim then
77         stacker1_L:=1;
78         //
79         if x1<9 then
80             sklad1L[x1,y1]:=1;
81         else
82             x1:=0;
83             y1:=y1+1;
84             sklad0P[x1,y1]:=1;
85         end_if;
86         //
87     end_if;
88
89     if stacker1_LL OR stacker1_RL then
90         stacker1_lift:=0;
91     end_if;
92
93     if (stacker1_LL OR stacker1_RL) AND stacker1_MZ then
94         stav_pal_zak:=6;
95     end_if;
96
97 6:
98     if NOT stacker1_MZ AND NOT stop_sim then
99         stav_pal_zak:=7;
100    end_if;
101 7:
102     if stacker1_RL AND NOT stop_sim then
103         stacker1_R:=0;
104         stav_pal_zak:=8;
105     elsif stacker1_LL AND NOT stop_sim then
106         stacker1_L:=0;
107         stav_pal_zak:=8;
108     end_if;
109 8:
110     if stacker1_M AND NOT stop_sim then
111         stacker1_targ:=21474;
112     end_if;
113
114     if stacker1_MX then
115         stav_pal_zak:=9;
116     end_if;
117 9:
118     if NOT stacker1_MX then
```

```
119
120     stacker1_targ:=0;
121     pozicial:=pozicial+1;
122     x1:=x1+1;
123     stav_pal_zak:=1;
124 end_if;
125 20:
126     holding1:=1;
127 if NOT hold1 then
128     holding1:=0;
129     stav_pal_zak:=1;
130 end_if;
131
132 end_case;
```

```
1
2 if run AND NOT stop_sim then
3     running:=1;
4 end_if;
5
6 if NOT run OR NOT safety_door_OK then
7     //stop generovania paliet
8     if stav_gen=1 then
9         pas2_0:=0;
10        pas2_1:=0;
11        pas0CW:=0;
12        load0:=0;
13        stop_sim:=1;
14    else
15        stop_sim:=1;
16    end_if;
17    //stop paletizer zakladanie
18    if stav_pal_zak=1 then
19        pas4_2:=0;
20        pas4CCW:=0;
21        load2:=0;
22        stop_sim:=1;
23    else
24        stop_sim:=1;
25    end_if;
26
27    //stop vykladania
28    if stav_zak=2 then
29        load1:=0;
30        pas2CW:=0;
31        pas3CCW:=0;
32        pas2_2:=0;
33        pas4_0:=0;
34        pas4_1:=0;
35        pas4_4:=0;
36        pas6_0:=0;
37        turn_roll:=0;
38        remover0:=0;
39        //vzkladanie z druheho skaldu
40        load3:=0;
41        pas5CW:=0;
42        pas4_3:=0;
43        pas6_1:=0;
44        stop_sim:=1;
45    else
46        stop_sim:=1;
47    end_if;
48 end_if;
49
50 if run AND safety_reset then
51     stop_sim:=0;
52 end_if;
53
54 if start_but AND stop_but AND Emergency_stop then
55     pal_running:=1;
56 else
57     pal_running:=0;
58 end_if;
59
```

```
60 if NOT pal_running AND stav_pal=1 then
61     pas4_5:=0;
62     palet_chain:=0;
63 elsif NOT pal_running AND stav_pal=2 then
64     palet_belt:=0;
65     belt:=0;
66 end_if;
67
68 if reset then
69     running:=0;
70     pal_running:=0;
71     //reset generovania paliet
72     pas2_0:=0;
73     pas2_1:=0;
74     pas0CW:=0;
75     pas1CCW:=0;
76     load0:=0;
77     stacker0_R:=0;
78     stacker0_L:=0;
79     stacker0_lift:=0;
80
81     stacker0_targ:=21474;
82     pozicia0:=1;
83     zapln:=0;
84     x:=0;
85     y:=0;
86     COP(pole_nul[0,0],sklad0P[0,0],54);
87     COP(pole_nul[0,0],sklad0L[0,0],54);
88     vlavo0:=0;
89     holding:=0;
90     stav_gen:=0;
91     //reset paletizer
92     emit01:=0;
93     emit02:=0;
94     belt:=0;
95     palet_belt:=0;
96     palet_beltm:=0;
97     pas4_5:=0;
98     palet_chain:=0;
99     palet_open:=0;
100    palet_elev_up:=0;
101    palet_elev_down:=0;
102    palet_elev_limit:=0;
103    palet_clamp:=0;
104    palet_push:=0;
105    palet_open:=0;
106    palet_turn:=0;
107    rise.EnableIn:=0;
108    palet_elev_front:=0;
109    box:=-1;
110    count:=0;
111    row:=0;
112    stav_pal:=0;
113    //reset paletizer vykladanie
114    vyloz:=0;
115    pozicia_x1:=0;
116    vlavo1_vyk:=0;
117    hold1:=0;
118    COP(pole_nul[0,0],sklad1P[0,0],54);
```

```
119     COP(pole_nul[0,0],sklad1L[0,0],54);
120     stav_pal_vyk:=0;
121     //reset paletizer zakladanie
122     pas4_2:=0;
123     pas4CCW:=0;
124     load2:=0;
125     stacker1_R:=0;
126     stacker1_L:=0;
127     stacker1_lift:=0;
128
129     stacker1_targ:=21474;
130     pozicia1:=1;
131     x1:=0;
132     y1:=0;
133     vlavo1:=0;
134     holding1:=0;
135     stav_pal_zak:=0;
136     // reset vykladania paliet
137     vyloz:=0;
138     pozicia_x:=0;
139     vlavo0_vyk:=0;
140     hold:=0;
141     stav_vyk:=0;
142     //reset zakoncenie vzkladania
143     load1:=0;
144     pas2CW:=0;
145     pas3CCW:=0;
146     pas4_0:=0;
147     pas4_1:=0;
148     pas4_4:=0;
149     pas6_0:=0;
150     turn_roll:=0;
151     turn_turn:=0;
152     turn_rollm:=0;
153     stav_zak:=0;
154 end_if;
155
156 //pre visu
157 if stacker0_MZ OR stacker0_MX then
158     S0_moving:=1;
159 else
160     S0_moving:=0;
161 end_if;
162
163 if stacker1_MZ OR stacker1_MX then
164     S1_moving:=1;
165 else
166     S1_moving:=0;
167 end_if;
168
```



```
1
2 case stav_vyk of
3     0:
4         pozicia_x:=0;
5         pozicia_y:=0;
6         stacker0_targ:=0;
7         hold:=0;
8         holding:=0;
9         ENTER:=0;
10        if running then
11            stav_vyk:=1;
12        end_if;
13
14    1:
15        if ENTER then
16
17            if sklad0P[pozicia_x,pozicia_y]=1 AND NOT vlavo0_vyk then
18                hold:=1;
19            elsif sklad0L[pozicia_x,pozicia_y]=1 AND vlavo0_vyk then
20                hold:=1;
21            else
22                pozicia_x:=0;
23                pozicia_y:=0;
24                stav_vyk:=0;
25            end_if;
26        end_if;
27
28        if holding then
29            stav_vyk:=2;
30        end_if;
31
32    2:
33        if stacker0_targ = 0 AND NOT stop_sim then
34            stacker0_targ:=(pozicia_x+1)+(pozicia_y*9);
35        end_if;
36
37        if stacker0_MX then
38            stav_vyk:=3;
39        end_if;
40
41    3:
42        if NOT stacker0_MX AND NOT stacker0_MZ AND NOT vlavo0_vyk AND NOT stop_sim then
43            sklad0P[pozicia_x,pozicia_y]:=0;
44            stacker0_R:=1;
45        elsif NOT stacker0_MX AND NOT stacker0_MZ AND vlavo0_vyk AND NOT stop_sim then
46            sklad0L[pozicia_x,pozicia_y]:=0;
47            stacker0_L:=1;
48        end_if;
49
50        if stacker0_LL OR stacker0_RL then
51            stacker0_lift:=1;
52        end_if;
53
54        if stacker0_LL OR stacker0_RL AND stacker0_MZ then
55            stav_vyk:=4;
56        end_if;
57
58    4:
59        if NOT stacker0_MZ AND NOT stop_sim then
60            stav_vyk:=5;
61        end_if;
```

```
60     5:
61         if NOT vlavo0_vyk AND NOT stop_sim then
62             stacker0_R:=0;
63             stav_vyk:=6;
64         elsif vlavo0_vyk AND NOT stop_sim then
65             stacker0_L:=0;
66             stav_vyk:=6;
67         end_if;
68     6:
69         if stacker0_M AND NOT stop_sim then
70             stacker0_targ:=21474;
71         end_if;
72
73         if stacker0_MX then
74             stav_vyk:=7;
75         end_if;
76     7:
77         if NOT stacker0_MX AND NOT stop_sim then
78             vyloz:=1;
79
80             stacker0_targ:=0;
81             stacker0_L:=1;
82             stav_vyk:=8;
83         end_if;
84     8:
85         if stacker0_LL AND NOT stop_sim then
86             stacker0_lift:=0;
87         end_if;
88
89         if stacker0_LL AND stacker0_MZ then
90             stav_vyk:=9;
91         end_if;
92     9:
93         if NOT stacker0_MZ then
94             stacker0_L:=0;
95             stav_vyk:=0;
96         end_if;
97
98 end_case;
```

```
1
2 case stav_zak of
3     0:
4
5         if running then
6             stav_zak:=1;
7         end_if;
8
9     1:
10        if vyloz then
11            stav_zak:=2;
12        end_if;
13    2:
14        if NOT stop_sim then
15            //vykladanie prvy sklad
16            load1:=1;
17            pas2CW:=1;
18            pas3CCW:=1;
19            pas2_2:=1;
20            pas4_0:=1;
21            pas4_1:=1;
22            pas4_4:=1;
23            pas6_0:=1;
24            turn_roll:=1;
25            remover0:=1;
26            //vzkladanie z druheho skaldu
27            load3:=1;
28            pas5CW:=1;
29            pas4_3:=1;
30            pas6_1:=1;
31
32            if dif_sen3 then
33                load3:=0;
34                pas5CW:=0;
35                pas4_3:=0;
36                pas6_1:=0;
37                stav_zak:=3;
38            end_if;
39        end_if;
40    3:
41        if dif_sen3 AND NOT dif_sen2 AND NOT dif_sen4 AND NOT stop_sim then
42            pas2CW:=0;
43            pas3CCW:=0;
44            pas4_0:=0;
45            pas4_1:=0;
46            pas6_0:=0;
47            turn_roll:=0;
48            turn_turn:=1;
49            turn_rollm:=1;
50            stav_zak:=4;
51        end_if;
52    4:
53        if turn_L90 AND NOT stop_sim then
54            pas4_3:=1;
55        end_if;
56
57        if turn_back then
58            turn_rollm:=0;
59            pas4_3:=0;
```

```
60         turn_turn:=0;
61     end_if;
62
63     if turn_L0 then
64         turn_roll:=1;
65         stav_zak:=2;
66     end_if;
67
68 end_case;
```

1769 Bus : Local Modules



Local: [0] 1769-L33ERMS xviate00\_DP

Type:	1769-L33ERMS Compact GuardLogix® 5370 Safety Controller	Parent:	Local
Vendor:	Rockwell Automation/Allen-Bradley	Vendor ID:	1
Slot:	0	Safety Network Number:	4935_026C_16C8
Electronic Keying:	Disabled	Revision:	33.12
Status:	Standby	Module Fault:	Offline
Inhibit Flag	Off		

<b>xviate00_DP</b>	
Label does not exist .....	1
Tag Listing .....	2
<b>MainTask</b>	
<b>MainProgram</b>	
<b>generovanie_paliet</b>	
Structured Text .....	25
<b>MainRoutine</b>	
Ladder Diagram .....	29
<b>paletizer</b>	
Structured Text .....	30
<b>paletizer_vykladanie</b>	
Structured Text .....	33
<b>paletizer_zakladanie</b>	
Structured Text .....	35
<b>simulacia</b>	
Structured Text .....	38
<b>vykladanie_paliet</b>	
Structured Text .....	41
<b>zakoncenie_vykladania</b>	
Structured Text .....	43
<b>Module Properties</b>	
1769 Bus : Local Modules .....	45