- Controller Controler1
- Controller Fault Handler
- Power-Up Handler

Tasks

- MainTask
  - MainProgram
    - MainRoutine
    - automatika
    - Chyby
    - inicializace
    - instrukce
    - kontrola_Gkodu
    - posuv
    - reset_ALARM
    - tlacitka
- SafetyTask
  - SafetyProgram
    - MainRoutine
- Unscheduled Programs / Phases

Motion Groups

- MotionGroup1
  - OsaX
  - OsaY
  - OsaZ
  - coordinate_axes
  - XY
- Ungrouped Axes

Add-On Instructions

Data Types

- User-Defined
  - Alarm_DATA
  - manual
  - softovertravel
- Strings
  - STRING
- Add-On-Defined
- Module-Defined
  - AB:1756_DI:C:0
  - AB:1756_DNB_496Bytes:O:0
  - AB:1756_DNB_500Bytes:I:0
  - AB:1756_DNB_CommandRegister:O:0
  - AB:1756_DNB_StatusRegister:I:0
  - AB:1756_DNB_Status_128Bytes:S:0
  - AB:1756_DO:C:0
  - AB:1756_ENET_10SLOT:I:0
  - AB:1756_ENET_10SLOT:O:0
  - AB:1756_ENET_SLOT:I:0
  - AB:1756_ENET_SLOT:O:0
  - AB:1791DS_IB8XOB8_Safety1:I:0
  - AB:1791DS_IB8XOB8_Safety1:O:0
  - AB:1791DS_IB8XOB8_Safety2:O:0
  - AB:1791DS_IB8XOB8_Safety3:I:0
  - AB:1791DS_IB8XOB8_Safety5:I:0

Trends

I/O Configuration

- 1756 Backplane, 1756-A10
  - [0] 1756-L62S Controler1
  - [1] 1756-LSP Controler1:Partner
  - [2] 1756-ENBT/A ETHERNET
    - Ethernet
      - 1756-ENBT/A ETHERNET
      - 1756-ENBT/A ethernet2
        - 1756 Backplane, 1756-A10
          - [3] 1756-ENBT/A ethernet2
          - [7] 1756-OB16D Output
          - [8] 1756-IB16 Input
  - [3] 1756-DNB devicenet
    - DeviceNet
      - 13 1791DS-IB8XOB8/A Safety
      - 63 1756-DNB devicenet
  - [6] 1756-M08SE Kinetix_com
    - SERCOS Network
      - 11 2093-AC05-MP5 osaX
      - 13 2093-AMP5 OsaY
      - 14 2093-AMP5 OsaZ

Name	Value	Data Type	Scope
Absprog	1	BOOL	Controler1
Absprog - MainProgram/automatika - 5(XIC), 6(XIC)			
*Absprog - MainProgram/instrukce - *6(OTL)*			
*Absprog - MainProgram/kontrola_Gkodu - *0(OTU), 5(XIO)*			
Alarm_DATA_reset		Alarm_DATA	Controler1
Alarm_DATA_reset - MainProgram/reset_ALARM - 2(COP), 4(COP)			
*Alarm_DATA_reset.ENABLE - MainProgram/reset_ALARM - *0(OTL)*			
*Alarm_DATA_reset.RESET - MainProgram/reset_ALARM - *1(OTL), *3(OTU)*			
alarm_Chyba_vykonavani_inst		ALARM_DIGITAL	Controler1
vykonavani instrukce selhalo			
*alarm_Chyba_vykonavani_inst - MainProgram/Chyby - *27(ALMD)*			
alarm_PROGRAM		ALARM_DIGITAL	Controler1
Chyba pri kontrole programu			
*alarm_PROGRAM - MainProgram/Chyby - *6(ALMD)*			
alarm_VRETEMO		ALARM_DIGITAL	Controler1
Porucha vretena			
*alarm_VRETEMO - MainProgram/Chyby - *5(ALMD)*			
alarm_XHome		ALARM_DIGITAL	Controler1
Chyba HOME osy X			
*alarm_XHome - MainProgram/Chyby - *21(ALMD)*			
alarm_XChyba		ALARM_DIGITAL	Controler1
Chyba osy X			
*alarm_XChyba - MainProgram/Chyby - *15(ALMD)*			
alarm_Xpres		ALARM_DIGITAL	Controler1
Osa X mimo rozsah			
*alarm_Xpres - MainProgram/Chyby - *9(ALMD)*			
alarm_YHome		ALARM_DIGITAL	Controler1
Chyba HOME osy Y			
*alarm_YHome - MainProgram/Chyby - *23(ALMD)*			
alarm_YChyba		ALARM_DIGITAL	Controler1
Chyba osy Y			
*alarm_YChyba - MainProgram/Chyby - *17(ALMD)*			
alarm_Ypres		ALARM_DIGITAL	Controler1
Osa Y mimo rozsah			
*alarm_Ypres - MainProgram/Chyby - *11(ALMD)*			
alarm_ZAVORA		ALARM_DIGITAL	Controler1
Naruseni opticke zavory			
*alarm_ZAVORA - MainProgram/Chyby - *7(ALMD)*			
alarm_ZHome		ALARM_DIGITAL	Controler1
Chyba HOME osy Z			
*alarm_ZHome - MainProgram/Chyby - *25(ALMD)*			
alarm_ZChyba		ALARM_DIGITAL	Controler1
Chyba osy Z			
*alarm_ZChyba - MainProgram/Chyby - *19(ALMD)*			
alarm_Zpres		ALARM_DIGITAL	Controler1
Osa Z mimo rozsah			
*alarm_Zpres - MainProgram/Chyby - *13(ALMD)*			
Automatika_ZAP	0	BOOL	Controler1
Automatika_ZAP - MainProgram/Chyby - 4(XIO)			
Automatika_ZAP - MainProgram/MainRoutine - 10(XIO), 11(XIO), 12(XIO), 3(XIO), 8(XIC), 9(XIO)			
*Automatika_ZAP - MainProgram/tlacitka - *5(OTE)*			
CircuitReset	0	BOOL	SafetyProgram
CircuitReset - SafetyProgram/ MainRoutine - 1(ESTOP), 2(LC)			
coordinate_axes		COORDINATE_SYSTEM	Controler1
coordinate_axes - MainProgram/automatika - 7(MCLM)			
coordinate_MCCM		MOTION_INSTRUCTION[2]	Controler1
*coordinate_MCCM[0] - MainProgram/automatika - *11(MCCM), *14(COP)*			
*coordinate_MCCM[0] - MainProgram/inicializace - *0(COP)*			
coordinate_MCCM[0].ER - MainProgram/automatika - 13(XIC)			
coordinate_MCCM[0].PC - MainProgram/automatika - 12(XIC)			
coordinate_MCLM		MOTION_INSTRUCTION[24]	Controler1
*coordinate_MCLM[0] - MainProgram/automatika - *10(COP), *7(MCLM)*			
*coordinate_MCLM[0] - MainProgram/inicializace - *0(COP)*			
coordinate_MCLM[0].ER - MainProgram/automatika - 9(XIC)			
coordinate_MCLM[0].PC - MainProgram/automatika - 8(XIC)			
data		REAL[3]	Controler1
data - MainProgram/automatika - 11(MCCM), 7(MCLM)			
*data[0] - MainProgram/inicializace - *0(MOV)*			
*data[0] - MainProgram/instrukce - *9(ADD), *9(MOV), *9(MUL), 9(ADD), 9(GRT), 9(LES)*			
*data[0] - MainProgram/kontrola_Gkodu - *12(MOV), *13(MOV), 0(MOV), 6(GRT), 6(LES)*			
*data[1] - MainProgram/inicializace - *0(MOV)*			
*data[1] - MainProgram/instrukce - *10(ADD), *10(MOV), *10(MUL), 10(ADD), 10(GRT), 10(LES)*			
*data[1] - MainProgram/kontrola_Gkodu - *12(MOV), *13(MOV), 0(MOV), 7(GRT), 7(LES)*			
*data[2] - MainProgram/inicializace - *0(MOV)*			
*data[2] - MainProgram/instrukce - *11(MOV), 11(GRT), 11(LES)*			
*data[2] - MainProgram/kontrola_Gkodu - *12(MOV), *13(MOV), 0(MOV), 8(GRT), 8(LES)*			
dekodovano	0	BOOL	Controler1

dekodovano (Continued)
*dekodovano - MainProgram/automatika - *1(OTU), 1(XIC)*
*dekodovano - MainProgram/Chyby - *1(OTU)*
*dekodovano - MainProgram/instrukce - *0(OTU), *10(OTL), *11(OTL), *13(OTL), *2(OTL), *6(OTL), *7(OTL), *9(OTL), 14(XIC), 14(XIO)*
*dekodovano - MainProgram/kontrola_Gkodu - *0(OTU), 11(XIC), 12(XIC), 2(XIO), 3(XIC), 4(XIC), 5(XIC), 6(XIC), 7(XIC), 8(XIC)*

ESTOP01 EMERGENCY_STOP SafetyProgram
*ESTOP01 - SafetyProgram/ MainRoutine - *1(ESTOP)*
ESTOP01.O1 - SafetyProgram/ MainRoutine - 3(XIC)

ethernet2:8:I AB:1756_ENET_SLOT:I:0 Controler1
AliasFor: ethernet2:I.Slot[8]
Base Tag: ethernet2:I.Slot[8]
ethernet2:8:I.Data.0 - MainProgram/tlacitka - 0(XIC)
ethernet2:8:I.Data.1 - MainProgram/tlacitka - 1(XIC)
ethernet2:8:I.Data.10 - MainProgram/tlacitka - 10(XIC)
ethernet2:8:I.Data.11 - MainProgram/tlacitka - 11(XIC)
ethernet2:8:I.Data.12 - MainProgram/tlacitka - 12(XIC)
ethernet2:8:I.Data.13 - MainProgram/tlacitka - 13(XIC)
ethernet2:8:I.Data.14 - MainProgram/tlacitka - 14(XIC)
ethernet2:8:I.Data.15 - MainProgram/tlacitka - 15(XIC)
ethernet2:8:I.Data.2 - MainProgram/tlacitka - 2(XIC)
ethernet2:8:I.Data.3 - MainProgram/tlacitka - 3(XIC)
ethernet2:8:I.Data.5 - MainProgram/tlacitka - 5(XIC)
ethernet2:8:I.Data.6 - MainProgram/tlacitka - 6(XIC)
ethernet2:8:I.Data.7 - MainProgram/tlacitka - 7(XIC)
ethernet2:8:I.Data.8 - MainProgram/tlacitka - 8(XIC)
ethernet2:8:I.Data.9 - MainProgram/tlacitka - 9(XIC)

ethernet2:I AB:1756_ENET_10SLOT:I:0 Controler1

F 'F' STRING Controler1
F - MainProgram/instrukce - 5(FIND)

FaultReset 0 BOOL SafetyProgram
FaultReset - SafetyProgram/ MainRoutine - 1(ESTOP), 2(LC)

G 'G' STRING Controler1
G - MainProgram/instrukce - 1(FIND)

Chyba_instrukce -1 INT Controler1
*Chyba_instrukce - MainProgram/kontrola_Gkodu - *0(MOV), *2(MOV), *5(MOV), *6(MOV), *7(MOV), *8(MOV)*

Chyba_prog 0 BOOL Controler1
Chyba_prog - MainProgram/Chyby - 6(ALMD)
*Chyba_prog - MainProgram/inicializace - *0(OTU)*
*Chyba_prog - MainProgram/kontrola_Gkodu - *0(OTU), *2(OTL), *5(OTL), *6(OTL), *7(OTL), *8(OTL), 11(XIO), 13(XIC)*
*Chyba_prog - MainProgram/MainRoutine - *12(OTU), 10(XIO)*

Chyba_vykonavani_inst_ALARM Alarm_DATA Controler1
*Chyba_vykonavani_inst_ALARM - MainProgram/reset_ALARM - *2(COP), *4(COP)*
*Chyba_vykonavani_inst_ALARM.ACK - MainProgram/Chyby - *26(OTE), 27(ALMD)*
Chyba_vykonavani_inst_ALARM.DISABLE - MainProgram/Chyby - 27(ALMD)
Chyba_vykonavani_inst_ALARM.ENABLE - MainProgram/Chyby - 27(ALMD)
Chyba_vykonavani_inst_ALARM.RESET - MainProgram/Chyby - 27(ALMD)

inst STRING[10] Controler1
*inst[0] - MainProgram/instrukce - *9(MID), 9(STOR)*
*inst[1] - MainProgram/instrukce - *10(MID), 10(STOR)*
*inst[2] - MainProgram/instrukce - *11(MID), 11(STOR)*
*inst[3] - MainProgram/instrukce - *7(MID), 7(STOR)*
*inst[4] - MainProgram/instrukce - *5(MID), 5(STOD)*
*inst[5] - MainProgram/instrukce - *12(MID), 12(STOR)*

instM 0 BOOL Controler1
instM - MainProgram/automatika - 2(XIC), 3(XIO), 4(XIO), 5(XIO), 6(XIO)
*instM - MainProgram/instrukce - *0(OTU), *13(OTL)*
*instM - MainProgram/kontrola_Gkodu - *0(OTU), *10(OTU), 4(XIC)*

instrukce STRING[17000] Controler1
instrukce - MainProgram/instrukce - 1(FIND), 10(MID), 11(MID), 12(MID), 3(STOR), 4(STOR), 5(FIND), 5(MID), 7(FIND), 7(MID), 8(FIND), 9(MID)
instrukce[0] - MainProgram/MainRoutine - 15(COP)

Kalibrace_OS 0 BOOL Controler1
Kalibrace_OS - MainProgram/MainRoutine - 5(XIC), 6(XIO)
*Kalibrace_OS - MainProgram/tlacitka - *2(OTE)*

komentar 0 BOOL Controler1
komentar - MainProgram/automatika - 2(XIC)
*komentar - MainProgram/instrukce - *0(OTU), *2(OTL)*
*komentar - MainProgram/kontrola_Gkodu - *0(OTU), *9(OTU), 3(XIC)*

Konec_programu 0 BOOL Controler1
Konec_programu - MainProgram/automatika - 1(XIO)
*Konec_programu - MainProgram/inicializace - *0(OTU)*
*Konec_programu - MainProgram/instrukce - *13(OTL)*
*Konec_programu - MainProgram/kontrola_Gkodu - *12(OTU), 11(XIO), 12(XIC), 5(XIO), 6(XIO), 7(XIO), 8(XIO)*
*Konec_programu - MainProgram/MainRoutine - *11(OTU), 8(XIO)*

KONTROLA_programu 0 BOOL Controler1
KONTROLA_programu - MainProgram/Chyby - 1(XIO)
KONTROLA_programu - MainProgram/instrukce - 13(XIO)
KONTROLA_programu - MainProgram/MainRoutine - 10(XIC), 11(XIO), 12(XIO), 8(XIO)
*KONTROLA_programu - MainProgram/tlacitka - *7(OTE)*

lc01 LIGHT_CURTAIN SafetyProgram
*lc01 - SafetyProgram/ MainRoutine - *2(LC)*
lc01.O1 - SafetyProgram/ MainRoutine - 3(XIC), 6(XIO)

M	'M'	STRING	Controler1
M - MainProgram/instrukce - 1(FIND)			
MASX		MOTION_INSTRUCTION	Controler1
*MASX - MainProgram/Chyby - *4(MAS)*			
*MASX - MainProgram/inicializace - *0(COP)*			
MASY		MOTION_INSTRUCTION	Controler1
*MASY - MainProgram/Chyby - *4(MAS)*			
*MASY - MainProgram/inicializace - *0(COP)*			
MASZ		MOTION_INSTRUCTION	Controler1
*MASZ - MainProgram/Chyby - *4(MAS)*			
*MASZ - MainProgram/inicializace - *0(COP)*			
MCCMReset		MOTION_INSTRUCTION	Controler1
MCCMReset - MainProgram/automatika - 14(COP)			
MCCMReset - MainProgram/inicializace - 0(COP)			
MCLMreset		MOTION_INSTRUCTION	Controler1
MCLMreset - MainProgram/automatika - 10(COP)			
MCLMreset - MainProgram/inicializace - 0(COP)			
Meritko_X	1.0	REAL	Controler1
Meritko_X - MainProgram/instrukce - 9(MUL)			
Meritko_Y	1.0	REAL	Controler1
Meritko_Y - MainProgram/instrukce - 10(MUL)			
nahlizena_instrukce	'G21'	STRING	Controler1
*nahlizena_instrukce - MainProgram/MainRoutine - *15(COP)*			
offsetX	116.73	REAL	Controler1
*offsetX - MainProgram/inicializace - *0(MOV)*			
offsetX - MainProgram/instrukce - 9(ADD)			
*offsetX - MainProgram/posuv - *10(MOV)*			
offsetY	66.78125	REAL	Controler1
*offsetY - MainProgram/inicializace - *0(MOV)*			
offsetY - MainProgram/instrukce - 10(ADD)			
*offsetY - MainProgram/posuv - *10(MOV)*			
offsetZ	39.205	REAL	Controler1
*offsetZ - MainProgram/inicializace - *0(MOV)*			
offsetZ - MainProgram/instrukce - 11(SUB)			
*offsetZ - MainProgram/posuv - *10(MOV)*			
offsetZ_log	70.795	REAL	Controler1
*offsetZ_log - MainProgram/instrukce - *11(SUB), 11(SUB)*			
OsaX		AXIS_SERVO_DRIVE	Controler1
OsaX - MainProgram/Chyby - 4(MAS)			
OsaX - MainProgram/MainRoutine - 1(MASR), 13(MSF), 14(MAS), 3(MASR), 4(MSO), 5(MAH)			
OsaX - MainProgram/posuv - 0(MAJ), 1(MAJ), 2(MAS), 9(MSF)			
OsaX.ActualPosition - MainProgram/posuv - 10(MOV)			
OsaX.ActualVelocity - MainProgram/Chyby - 3(LIM)			
OsaX.AxisFault - MainProgram/Chyby - 14(EQU)			
OsaX.AxisHomedStatus - MainProgram/Chyby - 20(XIO)			
OsaX.DriveEnableStatus - MainProgram/MainRoutine - 5(XIC), 7(XIC)			
OsaX.NegSoftOvertravelFault - MainProgram/Chyby - 8(XIC)			
OsaX.PosSoftOvertravelFault - MainProgram/Chyby - 8(XIC)			
OsaY		AXIS_SERVO_DRIVE	Controler1
OsaY - MainProgram/Chyby - 4(MAS)			
OsaY - MainProgram/MainRoutine - 1(MASR), 13(MSF), 14(MAS), 3(MASR), 4(MSO), 5(MAH)			
OsaY - MainProgram/posuv - 3(MAJ), 4(MAJ), 5(MAS), 9(MSF)			
OsaY.ActualPosition - MainProgram/posuv - 10(MOV)			
OsaY.ActualVelocity - MainProgram/Chyby - 3(LIM)			
OsaY.AxisFault - MainProgram/Chyby - 16(EQU)			
OsaY.AxisHomedStatus - MainProgram/Chyby - 22(XIO)			
OsaY.DriveEnableStatus - MainProgram/MainRoutine - 5(XIC), 7(XIC)			
OsaY.NegSoftOvertravelFault - MainProgram/Chyby - 10(XIC)			
OsaY.PosSoftOvertravelFault - MainProgram/Chyby - 10(XIC)			
OsaZ		AXIS_SERVO_DRIVE	Controler1
OsaZ - MainProgram/Chyby - 4(MAS)			
OsaZ - MainProgram/MainRoutine - 1(MASR), 13(MSF), 14(MAS), 3(MASR), 4(MSO), 5(MAH)			
OsaZ - MainProgram/posuv - 6(MAJ), 7(MAJ), 8(MAS), 9(MSF)			
OsaZ.ActualPosition - MainProgram/posuv - 10(MOV)			
OsaZ.ActualVelocity - MainProgram/Chyby - 3(LIM)			
OsaZ.AxisFault - MainProgram/Chyby - 18(EQU)			
OsaZ.AxisHomedStatus - MainProgram/Chyby - 24(XIO)			
OsaZ.DriveEnableStatus - MainProgram/MainRoutine - 5(XIC), 7(XIC)			
OsaZ.NegSoftOvertravelFault - MainProgram/Chyby - 12(XIC)			
OsaZ.PosSoftOvertravelFault - MainProgram/Chyby - 12(XIC)			
P	'P'	STRING	Controler1
P - MainProgram/instrukce - 7(FIND)			
P101DateNeg01	1	BOOL	SafetyProgram
*P101DateNeg01 - SafetyProgram/ MainRoutine - *0(OTE), 1(ESTOP)*			
pocet_instrukci	0	INT	Controler1
*pocet_instrukci - MainProgram/MainRoutine - *12(MOV)*			
pokracovat_v_prog	0	BOOL	Controler1
pokracovat_v_prog - MainProgram/Chyby - 1(XIC)			
por_proh_ins	0	INT	Controler1

por_proh_ins (Continued)
por_proh_ins - MainProgram/MainRoutine - 15(COP)

Poradi_instrukce 0 INT Controler1
*Poradi_instrukce - MainProgram/automatika - *1(ADD), 1(ADD)*
*Poradi_instrukce - MainProgram/Chyby - *1(SUB), 1(SUB)*
*Poradi_instrukce - MainProgram/inicializace - *0(MOV)*
Poradi_instrukce - MainProgram/instrukce - 1(FIND), 10(MID), 11(MID), 12(MID), 3(STOR), 4(STOR), 5(FIND), 5(MID), 7(FIND), 7(MID), 8(FIND), 9(MID)
*Poradi_instrukce - MainProgram/kontrola_Gkodu - *0(MOV), *11(ADD), *12(MOV), *13(MOV), 0(MOV), 11(ADD), 2(MOV), 5(MOV), 6(MOV), 7(MOV), 8(MOV)*
*Poradi_instrukce - MainProgram/MainRoutine - *11(MOV), 15(COP)*

PoradiF -1 INT Controler1
*PoradiF - MainProgram/instrukce - *0(MOV), *5(FIND), 5(GRT), 5(MID)*

PoradiG 1 INT Controler1
*PoradiG - MainProgram/instrukce - *0(MOV), *1(FIND), 10(EQU), 11(EQU), 12(EQU), 4(EQU), 5(EQU), 6(EQU), 7(EQU), 8(EQU), 9(EQU)*
PoradiG - MainProgram/kontrola_Gkodu - 5(EQU)

PoradiM 0 INT Controler1
*PoradiM - MainProgram/instrukce - *0(MOV), *1(FIND), 13(EQU), 3(EQU)*

PoradiP 5 INT Controler1
*PoradiP - MainProgram/instrukce - *0(MOV), *7(FIND), 7(MID)*

PoradiR -1 INT Controler1
*PoradiR - MainProgram/instrukce - *0(MOV), *8(FIND), 12(GRT), 12(MID)*

PoradiX -1 INT Controler1
*PoradiX - MainProgram/instrukce - *0(MOV), *8(FIND), 9(GRT), 9(MID)*

PoradiY -1 INT Controler1
*PoradiY - MainProgram/instrukce - *0(MOV), *8(FIND), 10(GRT), 10(MID)*

PoradiZ -1 INT Controler1
*PoradiZ - MainProgram/instrukce - *0(MOV), *8(FIND), 11(GRT), 11(MID)*

Poradizavorka 0 INT Controler1
*Poradizavorka - MainProgram/instrukce - *0(MOV), *1(FIND), 2(EQU), 2(GRT)*

pozice_X 116.73062 REAL Controler1
AliasFor: OsaX.ActualPosition
Base Tag: OsaX.ActualPosition
pozice_X - MainProgram/posuv - 0(LES), 1(GRT), 2(GRT), 2(LES)

pozice_Y 66.780624 REAL Controler1
AliasFor: OsaY.ActualPosition
Base Tag: OsaY.ActualPosition
pozice_Y - MainProgram/posuv - 3(LES), 4(GRT), 5(GRT), 5(LES)

pozice_Z 29.215626 REAL Controler1
AliasFor: OsaZ.ActualPosition
Base Tag: OsaZ.ActualPosition
pozice_Z - MainProgram/posuv - 6(LES), 7(GRT), 8(GRT), 8(LES)

Pracpos 0 BOOL Controler1
*Pracpos - MainProgram/instrukce - *6(OTL), *6(OTU)*

pripraveno 1 BOOL Controler1
*pripraveno - MainProgram/MainRoutine - *7(OTE), 8(XIC), 9(XIC)*

probihajici_instrukce 'G21' STRING Controler1
*probihajici_instrukce - MainProgram/MainRoutine - *15(COP)*

progexel 0 BOOL Controler1
*progexel - MainProgram/MainRoutine - *12(OTE), 12(XIO)*

ProgMM 1 BOOL Controler1
ProgMM - MainProgram/automatika - 5(XIC), 6(XIC)
*ProgMM - MainProgram/instrukce - *6(OTL)*
*ProgMM - MainProgram/kontrola_Gkodu - *0(OTU), 5(XIO)*

Program_ALARM Alarm_DATA Controler1
*Program_ALARM - MainProgram/reset_ALARM - *2(COP), *4(COP)*
Program_ALARM.DISABLE - MainProgram/Chyby - 6(ALMD)
Program_ALARM.ENABLE - MainProgram/Chyby - 6(ALMD)
*Program_ALARM.ENABLE - MainProgram/kontrola_Gkodu - *0(OTL), *12(OTU)*

Program_OK 1 BOOL Controler1
Program_OK - MainProgram/Chyby - 6(ALMD)
*Program_OK - MainProgram/inicializace - *0(OTU)*
*Program_OK - MainProgram/kontrola_Gkodu - *0(OTU), *12(OTL), *13(OTU)*
*Program_OK - MainProgram/MainRoutine - *12(OTU), 10(XIO), 8(XIC)*

Programovani 0 BOOL Controler1
Programovani - MainProgram/MainRoutine - 12(XIC)
*Programovani - MainProgram/tlacitka - *4(OTU)*

R 'R' STRING Controler1
R - MainProgram/instrukce - 8(FIND)

RealG 4.0 REAL Controler1
RealG - MainProgram/automatika - 3(EQU), 4(EQU), 5(EQU), 6(EQU)
*RealG - MainProgram/instrukce - *0(MOV), *4(STOR), 10(EQU), 11(EQU), 12(EQU), 5(EQU), 6(EQU), 7(EQU), 8(EQU), 9(EQU)*
RealG - MainProgram/kontrola_Gkodu - 5(EQU), 6(EQU), 7(EQU), 8(EQU)

RealM -1.0 REAL Controler1
*RealM - MainProgram/instrukce - *0(MOV), *3(STOR), 13(EQU)*

RealR 0.0 REAL Controler1

RealR (Continued)
RealR - MainProgram/automatika - 11(MCCM)
*RealR - MainProgram/instrukce - *0(MOV), *12(STOR)*

RealX 0.0 REAL Controler1
*RealX - MainProgram/instrukce - *9(STOR), 9(MUL)*

RealY 0.0 REAL Controler1
*RealY - MainProgram/instrukce - *10(STOR), 10(MUL)*

RealZ 29.205002 REAL Controler1
*RealZ - MainProgram/instrukce - *11(STOR), *11(SUB), 11(MOV), 11(SUB)*

reset_alarms 0 BOOL Controler1
reset_alarms - MainProgram/MainRoutine - 16(XIC)

Reset_AUTOMATIKA 0 BOOL Controler1
Reset_AUTOMATIKA - MainProgram/MainRoutine - 10(XIO), 11(XIC)
*Reset_AUTOMATIKA - MainProgram/tlacitka - *6(OTE)*

Reset_OS 0 BOOL Controler1
Reset_OS - MainProgram/MainRoutine - 3(XIC)
*Reset_OS - MainProgram/tlacitka - *0(OTE)*

RUCNI_pohyb 0 BOOL Controler1
RUCNI_pohyb - MainProgram/Chyby - 4(XIO)
RUCNI_pohyb - MainProgram/MainRoutine - 14(XIO), 3(XIO), 8(XIO), 9(XIC)
*RUCNI_pohyb - MainProgram/tlacitka - *3(OTE)*

Rychlopos 1 BOOL Controler1
*Rychlopos - MainProgram/instrukce - *6(OTL), *6(OTU)*

Rychlost_posuvu 100 DINT Controler1
Rychlost_posuvu - MainProgram/automatika - 11(MCCM), 7(MCLM)
*Rychlost_posuvu - MainProgram/instrukce - *6(MOV)*
*Rychlost_posuvu - MainProgram/kontrola_Gkodu - *12(MOV), *13(MOV), 0(MOV)*

Safety:I AB:1791DS_IB8XOB8_Safety1:I:0 Controler1
Safety:I.Pt00Data - SafetyProgram/ MainRoutine - 0(XIO)
Safety:I.Pt01Data - SafetyProgram/ MainRoutine - 1(ESTOP)
Safety:I.Pt02Data - SafetyProgram/ MainRoutine - 2(LC)
Safety:I.Pt03Data - SafetyProgram/ MainRoutine - 2(LC)
Safety:I.Pt07Data - SafetyProgram/ MainRoutine - 5(XIC)

Safety:O AB:1791DS_IB8XOB8_Safety1:O:0 Controler1
Safety:O.Pt00Data - MainProgram/MainRoutine - 8(XIC)
*Safety:O.Pt00Data - SafetyProgram/ MainRoutine - *3(OTE)*
*Safety:O.Pt07Data - SafetyProgram/ MainRoutine - *4(OTE)*

smer_KI 0 INT Controler1
smer_KI - MainProgram/automatika - 11(MCCM)
*smer_KI - MainProgram/instrukce - *12(MOV)*

STAV 111 INT Controler1
*STAV - MainProgram/automatika - *10(MOV), *12(MOV), *13(MOV), *14(MOV), *2(MOV), *3(MOV), *4(MOV), *5(MOV), *6(MOV), *8(MOV), *9(MOV), 0(EQU), 1(EQU), 10(EQU), 11(EQU), 12(EQU), 13(EQU), 14(EQU), 2(EQU), 3(EQU), 4(EQU), 5(EQU), 6(EQU), 7(EQU), 8(EQU), 9(EQU)*
*STAV - MainProgram/Chyby - *1(MOV), *2(MOV), 1(EQU), 2(EQU), 26(EQU), 3(EQU)*
*STAV - MainProgram/inicializace - *0(MOV)*
*STAV - MainProgram/instrukce - *14(MOV)*
*STAV - MainProgram/kontrola_Gkodu - *12(MOV), *13(MOV)*
*STAV - MainProgram/MainRoutine - *11(MOV), *14(MOV)*

STOP_Program 0 BOOL Controler1
STOP_Program - MainProgram/automatika - 0(XIO), 10(XIO), 11(XIO), 14(XIO), 7(XIO)
STOP_Program - MainProgram/MainRoutine - 8(XIO)
*STOP_Program - MainProgram/tlacitka - *14(OTE)*

T_rozjezd TIMER Controler1
*T_rozjezd - MainProgram/Chyby - *2(TON)*
*T_rozjezd.ACC - MainProgram/Chyby - *1(MOV)*
T_rozjezd.DN - MainProgram/Chyby - 2(XIC)
*T_rozjezd.PRE - MainProgram/Chyby - *1(MOV)*

Tzpozdeni TIMER Controler1
*Tzpozdeni - MainProgram/automatika - *4(TON)*
*Tzpozdeni.ACC - MainProgram/inicializace - *0(MOV)*
*Tzpozdeni.ACC - MainProgram/MainRoutine - *11(MOV)*
Tzpozdeni.DN - MainProgram/automatika - 4(XIC)
Tzpozdeni.PRE - MainProgram/Chyby - 1(MOV)
*Tzpozdeni.PRE - MainProgram/inicializace - *0(MOV)*
*Tzpozdeni.PRE - MainProgram/instrukce - *7(MUL)*
*Tzpozdeni.PRE - MainProgram/MainRoutine - *11(MOV)*

V_pracposuv 30 DINT Controler1
*V_pracposuv - MainProgram/instrukce - *5(STOD), 6(MOV)*

V_rychloposuv 100 DINT Controler1
V_rychloposuv - MainProgram/instrukce - 6(MOV)

Vreteno 0 BOOL Controler1
*Vreteno - MainProgram/Chyby - *1(OTL), *3(OTU), *4(OTU), 0(XIC), 0(XIO), 2(XIC)*
*Vreteno - MainProgram/instrukce - *13(OTL), *13(OTU)*
*Vreteno - MainProgram/MainRoutine - *11(OTU), *13(OTU)*
Vreteno_safety - SafetyProgram/ MainRoutine - 4(XIC)

Vreteno_ALARM Alarm_DATA Controler1
*Vreteno_ALARM - MainProgram/reset_ALARM - *2(COP), *4(COP)*
*Vreteno_ALARM.ACK - MainProgram/Chyby - *0(OTE), 5(ALMD)*
Vreteno_ALARM.DISABLE - MainProgram/Chyby - 5(ALMD)

Vreteno_ALARM (Continued)
Vreteno_ALARM.ENABLE - MainProgram/Chyby - 5(ALMD)
Vreteno_ALARM.RESET - MainProgram/Chyby - 5(ALMD)

Vreteno_ON_safet 1 BOOL Controler1
Vreteno_ON_safet - MainProgram/Chyby - 0(XIC), 0(XIO)
*Vreteno_ON_safet - SafetyProgram/ MainRoutine - *5(OTE)*

Vreteno_safety 0 BOOL Controler1
Mapped With: Vreteno
Vreteno_safety - SafetyProgram/ MainRoutine - 4(XIC)
*Vreteno - MainProgram/Chyby - *1(OTL), *3(OTU), *4(OTU), 0(XIC), 0(XIO), 2(XIC)*
*Vreteno - MainProgram/instrukce - *13(OTL), *13(OTU)*
*Vreteno - MainProgram/MainRoutine - *11(OTU), *13(OTU)*

Vypnuti_OS 0 BOOL Controler1
Vypnuti_OS - MainProgram/MainRoutine - 13(XIC)
*Vypnuti_OS - MainProgram/tlacitka - *15(OTE)*

X 'X' STRING Controler1
X - MainProgram/instrukce - 8(FIND)

x_MAS MOTION_INSTRUCTION Controler1
*x_MAS - MainProgram/inicializace - *0(COP)*
*x_MAS - MainProgram/MainRoutine - *14(MAS)*

x_MI_MAH MOTION_INSTRUCTION[3] Controler1
*x_MI_MAH[0] - MainProgram/inicializace - *0(COP)*
*x_MI_MAH[0] - MainProgram/MainRoutine - *5(MAH)*
x_MI_MAH[0].DN - MainProgram/MainRoutine - 6(XIC)

x_MI_MAJ MOTION_INSTRUCTION[2] Controler1
*x_MI_MAJ[0] - MainProgram/posuv - *1(MAJ)*
x_MI_MAJ[0].ER - MainProgram/posuv - 2(XIC)
x_MI_MAJ[0].IP - MainProgram/posuv - 2(XIC)
*x_MI_MAJ[1] - MainProgram/posuv - *0(MAJ)*
x_MI_MAJ[1].ER - MainProgram/posuv - 2(XIC)
x_MI_MAJ[1].IP - MainProgram/posuv - 2(XIC)

x_MI_MAS MOTION_INSTRUCTION Controler1
*x_MI_MAS - MainProgram/posuv - *2(MAS)*
x_MI_MAS.EN - MainProgram/posuv - 0(XIO), 1(XIO)
x_MI_MAS.ER - MainProgram/posuv - 9(XIC)

x_MI_MSF MOTION_INSTRUCTION[4] Controler1
*x_MI_MSF[0] - MainProgram/posuv - *9(MSF)*
*x_MI_MSF[1] - MainProgram/inicializace - *0(COP)*
*x_MI_MSF[1] - MainProgram/MainRoutine - *13(MSF)*

x_MI_MSO MOTION_INSTRUCTION[4] Controler1
*x_MI_MSO[0] - MainProgram/MainRoutine - *4(MSO)*

X_SOT softovertravel Controler1
*X_SOT.MASR - MainProgram/MainRoutine - *1(MASR), *3(MASR)*
X_SOT.MASR.DN - MainProgram/MainRoutine - 4(XIC)

XHome_ALARM Alarm_DATA Controler1
*XHome_ALARM - MainProgram/reset_ALARM - *2(COP), *4(COP)*
*XHome_ALARM.ACK - MainProgram/Chyby - *20(OTE), 21(ALMD)*
XHome_ALARM.DISABLE - MainProgram/Chyby - 21(ALMD)
XHome_ALARM.ENABLE - MainProgram/Chyby - 21(ALMD)
XHome_ALARM.RESET - MainProgram/Chyby - 21(ALMD)

XChyba_ALARM Alarm_DATA Controler1
*XChyba_ALARM - MainProgram/reset_ALARM - *2(COP), *4(COP)*
*XChyba_ALARM.ACK - MainProgram/Chyby - *14(OTE), 15(ALMD)*
XChyba_ALARM.DISABLE - MainProgram/Chyby - 15(ALMD)
XChyba_ALARM.ENABLE - MainProgram/Chyby - 15(ALMD)
XChyba_ALARM.RESET - MainProgram/Chyby - 15(ALMD)

xJOGminus 0 BOOL Controler1
xJOGminus - MainProgram/posuv - 1(XIC), 2(XIC), 2(XIO)
*xJOGminus - MainProgram/tlacitka - *9(OTE)*

xJOGplus 0 BOOL Controler1
xJOGplus - MainProgram/posuv - 0(XIC), 2(XIC), 2(XIO)
*xJOGplus - MainProgram/tlacitka - *8(OTE)*

Xpres_ALARM Alarm_DATA Controler1
*Xpres_ALARM - MainProgram/reset_ALARM - *2(COP), *4(COP)*
*Xpres_ALARM.ACK - MainProgram/Chyby - *8(OTE), 9(ALMD)*
Xpres_ALARM.DISABLE - MainProgram/Chyby - 9(ALMD)
Xpres_ALARM.ENABLE - MainProgram/Chyby - 9(ALMD)
Xpres_ALARM.RESET - MainProgram/Chyby - 9(ALMD)

XY COORDINATE_SYSTEM Controler1
XY - MainProgram/automatika - 11(MCCM)

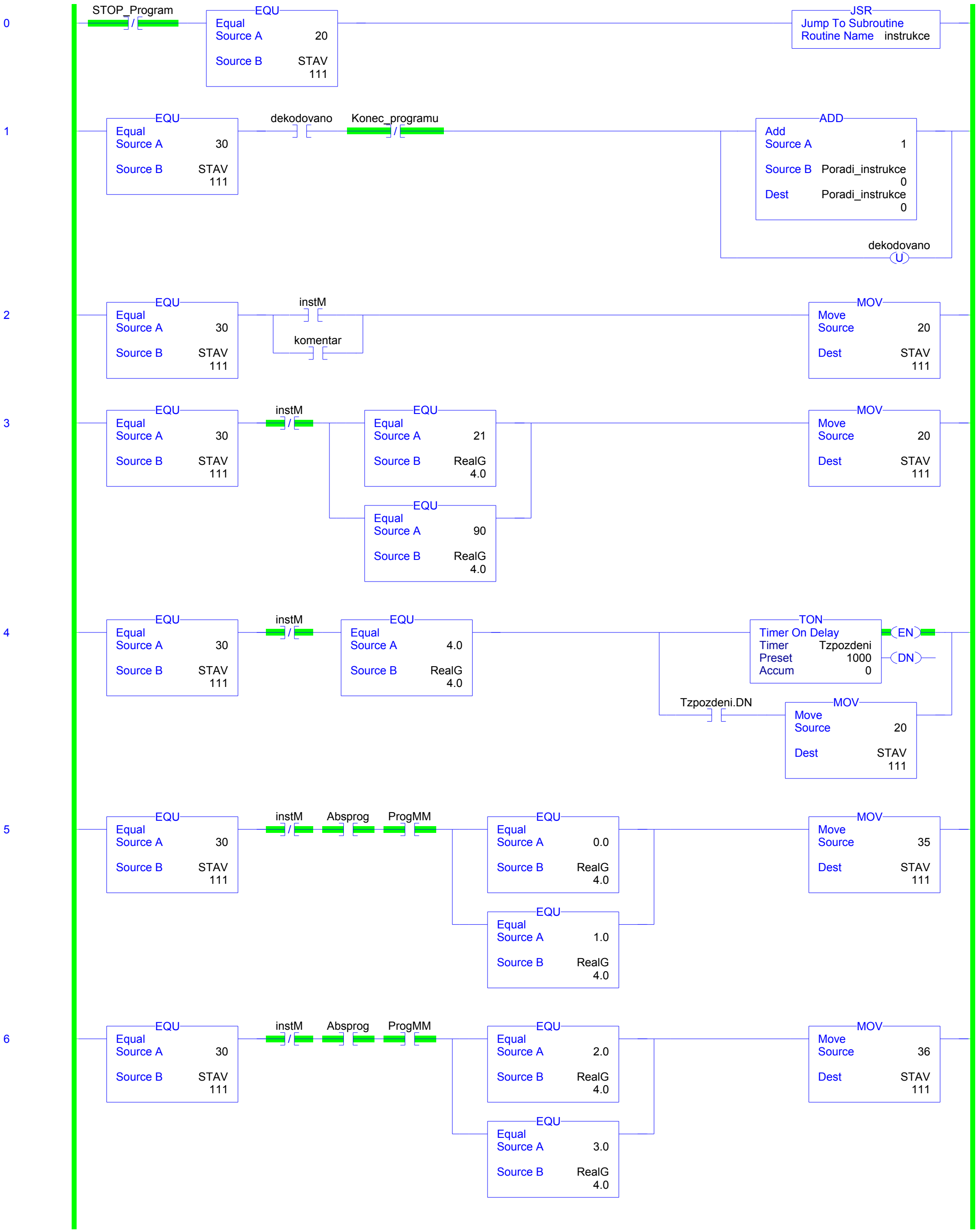
Y 'Y' STRING Controler1
Y - MainProgram/instrukce - 8(FIND)

y_MAS MOTION_INSTRUCTION Controler1
*y_MAS - MainProgram/inicializace - *0(COP)*
*y_MAS - MainProgram/MainRoutine - *14(MAS)*

y_MI_MAH MOTION_INSTRUCTION[2] Controler1
*y_MI_MAH[0] - MainProgram/inicializace - *0(COP)*
*y_MI_MAH[0] - MainProgram/MainRoutine - *5(MAH)*
y_MI_MAH[0].DN - MainProgram/MainRoutine - 6(XIC)

y_MI_MAJ		MOTION_INSTRUCTION[2]	Controler1
*y_MI_MAJ[0] - MainProgram/posuv - *3(MAJ)*			
y_MI_MAJ[0].ER - MainProgram/posuv - 5(XIC)			
y_MI_MAJ[0].IP - MainProgram/posuv - 5(XIC)			
*y_MI_MAJ[1] - MainProgram/posuv - *4(MAJ)*			
y_MI_MAJ[1].ER - MainProgram/posuv - 5(XIC)			
y_MI_MAJ[1].IP - MainProgram/posuv - 5(XIC)			
y_MI_MAS		MOTION_INSTRUCTION	Controler1
*y_MI_MAS - MainProgram/posuv - *5(MAS)*			
y_MI_MAS.EN - MainProgram/posuv - 3(XIO), 4(XIO)			
y_MI_MAS.ER - MainProgram/posuv - 9(XIC)			
y_MI_MSF		MOTION_INSTRUCTION[2]	Controler1
*y_MI_MSF[0] - MainProgram/posuv - *9(MSF)*			
*y_MI_MSF[1] - MainProgram/inicializace - *0(COP)*			
*y_MI_MSF[1] - MainProgram/MainRoutine - *13(MSF)*			
y_MI_MSO		MOTION_INSTRUCTION[2]	Controler1
*y_MI_MSO[0] - MainProgram/MainRoutine - *4(MSO)*			
Y_SOT		softovertravel	Controler1
*Y_SOT.MASR - MainProgram/MainRoutine - *1(MASR), *3(MASR)*			
Y_SOT.MASR.DN - MainProgram/MainRoutine - 4(XIC)			
YHome_ALARM		Alarm_DATA	Controler1
*YHome_ALARM - MainProgram/reset_ALARM - *2(COP), *4(COP)*			
*YHome_ALARM.ACK - MainProgram/Chyby - *22(OTE), 23(ALMD)*			
YHome_ALARM.DISABLE - MainProgram/Chyby - 23(ALMD)			
YHome_ALARM.ENABLE - MainProgram/Chyby - 23(ALMD)			
YHome_ALARM.RESET - MainProgram/Chyby - 23(ALMD)			
YChyba_ALARM		Alarm_DATA	Controler1
*YChyba_ALARM - MainProgram/reset_ALARM - *2(COP), *4(COP)*			
*YChyba_ALARM.ACK - MainProgram/Chyby - *16(OTE), 17(ALMD)*			
YChyba_ALARM.DISABLE - MainProgram/Chyby - 17(ALMD)			
YChyba_ALARM.ENABLE - MainProgram/Chyby - 17(ALMD)			
YChyba_ALARM.RESET - MainProgram/Chyby - 17(ALMD)			
yJOGminus	0	BOOL	Controler1
yJOGminus - MainProgram/posuv - 4(XIC), 5(XIC), 5(XIO)			
*yJOGminus - MainProgram/tlacitka - *11(OTE)*			
yJOGplus	0	BOOL	Controler1
yJOGplus - MainProgram/posuv - 3(XIC), 5(XIC), 5(XIO)			
*yJOGplus - MainProgram/tlacitka - *10(OTE)*			
Ypres_ALARM		Alarm_DATA	Controler1
*Ypres_ALARM - MainProgram/reset_ALARM - *2(COP), *4(COP)*			
*Ypres_ALARM.ACK - MainProgram/Chyby - *10(OTE), 11(ALMD)*			
Ypres_ALARM.DISABLE - MainProgram/Chyby - 11(ALMD)			
Ypres_ALARM.ENABLE - MainProgram/Chyby - 11(ALMD)			
Ypres_ALARM.RESET - MainProgram/Chyby - 11(ALMD)			
Z	'Z'	STRING	Controler1
Z - MainProgram/instrukce - 8(FIND)			
z_MAS		MOTION_INSTRUCTION	Controler1
*z_MAS - MainProgram/inicializace - *0(COP)*			
*z_MAS - MainProgram/MainRoutine - *14(MAS)*			
z_MI_MAH		MOTION_INSTRUCTION[2]	Controler1
*z_MI_MAH[0] - MainProgram/inicializace - *0(COP)*			
*z_MI_MAH[0] - MainProgram/MainRoutine - *5(MAH)*			
z_MI_MAH[0].DN - MainProgram/MainRoutine - 6(XIC)			
z_MI_MAJ		MOTION_INSTRUCTION[2]	Controler1
*z_MI_MAJ[0] - MainProgram/posuv - *6(MAJ)*			
z_MI_MAJ[0].ER - MainProgram/posuv - 8(XIC)			
z_MI_MAJ[0].IP - MainProgram/posuv - 8(XIC)			
*z_MI_MAJ[1] - MainProgram/posuv - *7(MAJ)*			
z_MI_MAJ[1].ER - MainProgram/posuv - 8(XIC)			
z_MI_MAJ[1].IP - MainProgram/posuv - 8(XIC)			
z_MI_MAS		MOTION_INSTRUCTION	Controler1
*z_MI_MAS - MainProgram/posuv - *8(MAS)*			
z_MI_MAS.EN - MainProgram/posuv - 6(XIO), 7(XIO)			
z_MI_MAS.ER - MainProgram/posuv - 9(XIC)			
z_MI_MSF		MOTION_INSTRUCTION[2]	Controler1
*z_MI_MSF[0] - MainProgram/posuv - *9(MSF)*			
*z_MI_MSF[1] - MainProgram/inicializace - *0(COP)*			
*z_MI_MSF[1] - MainProgram/MainRoutine - *13(MSF)*			
z_MI_MSO		MOTION_INSTRUCTION[2]	Controler1
*z_MI_MSO[0] - MainProgram/MainRoutine - *4(MSO)*			
Z_SOT		softovertravel	Controler1
*Z_SOT.MASR - MainProgram/MainRoutine - *1(MASR), *3(MASR)*			
Z_SOT.MASR.DN - MainProgram/MainRoutine - 4(XIC)			
Zaloha_data		REAL[3]	Controler1
*Zaloha_data[0] - MainProgram/kontrola_Gkodu - *0(MOV), 12(MOV), 13(MOV)*			
*Zaloha_data[1] - MainProgram/kontrola_Gkodu - *0(MOV), 12(MOV), 13(MOV)*			
*Zaloha_data[2] - MainProgram/kontrola_Gkodu - *0(MOV), 12(MOV), 13(MOV)*			
Zaloha_poradi_instrukce	0	INT	Controler1
*Zaloha_poradi_instrukce - MainProgram/kontrola_Gkodu - *0(MOV), 12(MOV), 13(MOV)*			

Zaloha_Rychlost_posuvu	100	INT	Controler1
*Zaloha_Rychlost_posuvu - MainProgram/kontrola_Gkodu - *0(MOV), 12(MOV), 13(MOV)*			
Zalohovani	1	BOOL	Controler1
*Zalohovani - MainProgram/inicializace - *0(OTL)*			
*Zalohovani - MainProgram/kontrola_Gkodu - *0(OTU), *12(OTL), *13(OTL), 0(XIC)*			
Zapis_offset	0	BOOL	Controler1
Zapis_offset - MainProgram/posuv - 10(XIC)			
Zapnuti_os	0	BOOL	Controler1
Zapnuti_os - MainProgram/MainRoutine - 4(XIC), 5(XIO)			
*Zapnuti_os - MainProgram/tlacitka - *1(OTE)*			
zavora	0	BOOL	Controler1
zavora - MainProgram/Chyby - 7(ALMD)			
zavora - MainProgram/MainRoutine - 14(XIC)			
*zavora - SafetyProgram/ MainRoutine - *6(OTE)*			
Zavora_ALARM		Alarm_DATA	Controler1
Zavora_ALARM.DISABLE - MainProgram/Chyby - 7(ALMD)			
Zavora_ALARM.ENABLE - MainProgram/Chyby - 7(ALMD)			
Zavora_ALARM.RESET - MainProgram/Chyby - 7(ALMD)			
zavorka	'('	STRING	Controler1
zavorka - MainProgram/instrukce - 1(FIND)			
ZHome_ALARM		Alarm_DATA	Controler1
*ZHome_ALARM - MainProgram/reset_ALARM - *2(COP), *4(COP)*			
*ZHome_ALARM.ACK - MainProgram/Chyby - *24(OTE), 25(ALMD)*			
ZHome_ALARM.DISABLE - MainProgram/Chyby - 25(ALMD)			
ZHome_ALARM.ENABLE - MainProgram/Chyby - 25(ALMD)			
ZHome_ALARM.RESET - MainProgram/Chyby - 25(ALMD)			
ZChyba_ALARM		Alarm_DATA	Controler1
*ZChyba_ALARM - MainProgram/reset_ALARM - *2(COP), *4(COP)*			
*ZChyba_ALARM.ACK - MainProgram/Chyby - *18(OTE), 19(ALMD)*			
ZChyba_ALARM.DISABLE - MainProgram/Chyby - 19(ALMD)			
ZChyba_ALARM.ENABLE - MainProgram/Chyby - 19(ALMD)			
ZChyba_ALARM.RESET - MainProgram/Chyby - 19(ALMD)			
zJOGminus	0	BOOL	Controler1
zJOGminus - MainProgram/posuv - 7(XIC), 8(XIC), 8(XIO)			
*zJOGminus - MainProgram/tlacitka - *13(OTE)*			
zJOGplus	0	BOOL	Controler1
zJOGplus - MainProgram/posuv - 6(XIC), 8(XIC), 8(XIO)			
*zJOGplus - MainProgram/tlacitka - *12(OTE)*			
zkalibrovano	1	BOOL	Controler1
zkalibrovano - MainProgram/Chyby - 4(XIC)			
*zkalibrovano - MainProgram/MainRoutine - *6(OTE), 2(XIC), 7(XIC)*			
zpozdeni_vereteno	5.0	REAL	Controler1
*zpozdeni_vereteno - MainProgram/instrukce - *7(STOR), 7(MUL)*			
Zpres_ALARM		Alarm_DATA	Controler1
*Zpres_ALARM - MainProgram/reset_ALARM - *2(COP), *4(COP)*			
*Zpres_ALARM.ACK - MainProgram/Chyby - *12(OTE), 13(ALMD)*			
Zpres_ALARM.DISABLE - MainProgram/Chyby - 13(ALMD)			
Zpres_ALARM.ENABLE - MainProgram/Chyby - 13(ALMD)			
Zpres_ALARM.RESET - MainProgram/Chyby - 13(ALMD)			


0
STOP_Program
EQU
Equal
Source A 20
Source B STAV 111
JSR
Jump To Subroutine
Routine Name instrukce
1
EQU
Equal
Source A 30
Source B STAV 111
dekodovano
Konec_programu
ADD
Add
Source A 1
Source B Poradi_instrukce 0
Dest Poradi_instrukce 0
dekodovano
U
2
EQU
Equal
Source A 30
Source B STAV 111
instM
komentar
MOV
Move
Source 20
Dest STAV 111
3
EQU
Equal
Source A 30
Source B STAV 111
instM
EQU
Equal
Source A 21
Source B RealG 4.0
EQU
Equal
Source A 90
Source B RealG 4.0
MOV
Move
Source 20
Dest STAV 111
4
EQU
Equal
Source A 30
Source B STAV 111
instM
EQU
Equal
Source A 4.0
Source B RealG 4.0
TON
Timer On Delay
Timer Tzpozdeni
Preset 1000
Accum 0
EN
DN
Tzpozdeni.DN
MOV
Move
Source 20
Dest STAV 111
5
EQU
Equal
Source A 30
Source B STAV 111
instM
Absprog
ProgMM
EQU
Equal
Source A 0.0
Source B RealG 4.0
EQU
Equal
Source A 1.0
Source B RealG 4.0
MOV
Move
Source 35
Dest STAV 111
6
EQU
Equal
Source A 30
Source B STAV 111
instM
Absprog
ProgMM
EQU
Equal
Source A 2.0
Source B RealG 4.0
EQU
Equal
Source A 3.0
Source B RealG 4.0
MOV
Move
Source 36
Dest STAV 111

7

STOP_Program

EQU
Equal
Source A 35
Source B STAV 111

MCLM
Motion Coordinated Linear Move
Coordinate System coordinate_axes ...
Motion Control coordinate_MCLM[0]
Move Type 0
Position data[0] ...
OsaX 116.73
OsaY 66.78125
OsaZ 29.205002
Speed Rychlost_posuvu 100
Speed Units Units per sec
Accel Rate 100
Accel Units Units per sec2
Decel Rate 100
Decel Units Units per sec2
Profile Trapezoidal
Accel Jerk 100
Decel Jerk 100
Jerk Units % of Time
Termination Type 1
Merge Coordinated Motion
Merge Speed Programmed
<< Less

EN DN ER IP AC PC

8

coordinate_MCLM[0].PC

EQU
Equal
Source A 35
Source B STAV 111

MOV
Move
Source 40
Dest STAV 111

9

coordinate_MCLM[0].ER

EQU
Equal
Source A 35
Source B STAV 111

MOV
Move
Source 100
Dest STAV 111

10

EQU
Equal
Source A 40
Source B STAV 111

STOP_Program

COP
Copy File
Source MCLMreset
Dest coordinate_MCLM[0]
Length 1

MOV
Move
Source 20
Dest STAV 111

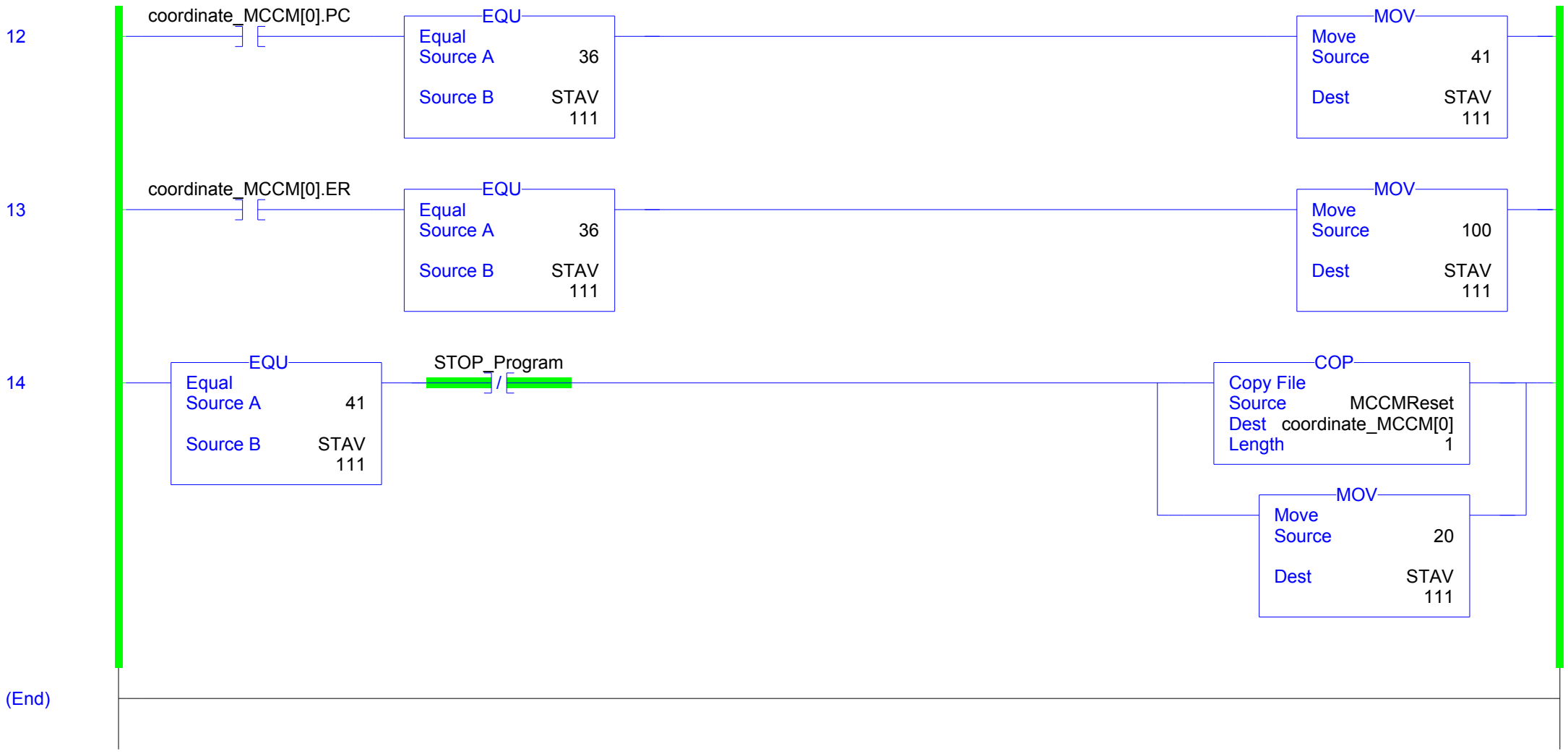
11

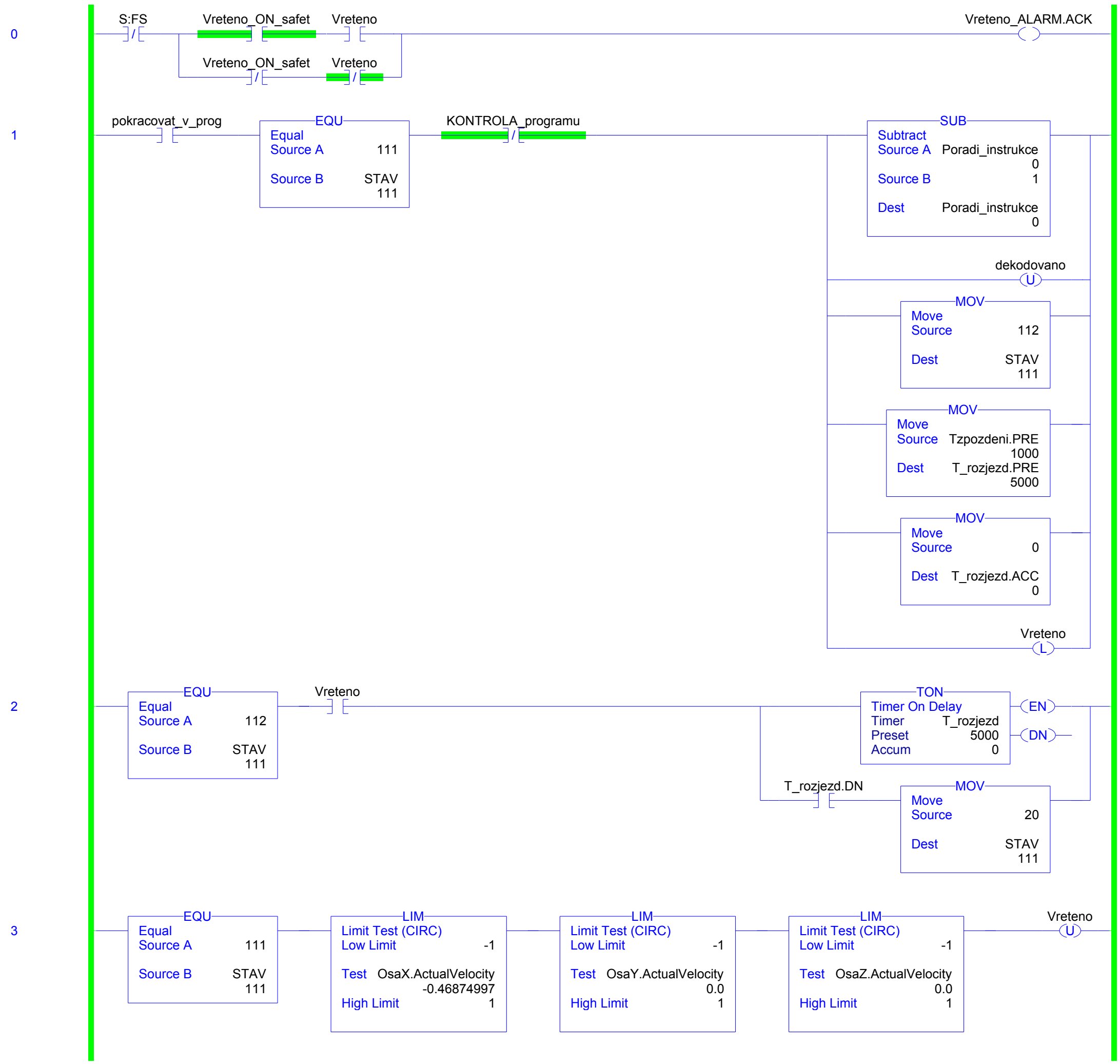
STOP_Program

EQU
Equal
Source A 36
Source B STAV 111

MCCM
Motion Coordinated Circular Move
Coordinate System XY ...
Motion Control coordinate_MCCM[0]
Move Type 0
Position data[0] ...
OsaX 116.73
OsaY 66.78125
Circle Type 2
Via/Center/Radius RealR
Direction smer_KI 0
Speed Rychlost_posuvu 100
Speed Units Units per sec
Accel Rate 100
Accel Units Units per sec2
Decel Rate 100
Decel Units Units per sec2
Profile Trapezoidal
Accel Jerk 100
Decel Jerk 100
Jerk Units % of Time
Termination Type 1
Merge Coordinated Motion
Merge Speed Programmed
<< Less

EN DN ER IP AC PC


12
coordinate_MCCM[0].PC
EQU
Equal
Source A 36
Source B STAV 111
MOV
Move
Source 41
Dest STAV 111
13
coordinate_MCCM[0].ER
EQU
Equal
Source A 36
Source B STAV 111
MOV
Move
Source 100
Dest STAV 111
14
EQU
Equal
Source A 41
Source B STAV 111
STOP_Program
COP
Copy File
Source MCCMReset
Dest coordinate_MCCM[0]
Length 1
MOV
Move
Source 20
Dest STAV 111
(End)


0
S:FS
Vreteno_ON_safet
Vreteno
Vreteno_ON_safet
Vreteno
Vreteno_ALARM.ACK
1
pokracovat_v_prog
EQU
Equal
Source A 111
Source B STAV 111
KONTROLA_programu
SUB
Subtract
Source A Poradi_instrukce 0
Source B 1
Dest Poradi_instrukce 0
dekodovano
U
MOV
Move
Source 112
Dest STAV 111
MOV
Move
Source Tzpozdeni.PRE 1000
Dest T_rozjezd.PRE 5000
MOV
Move
Source 0
Dest T_rozjezd.ACC 0
Vreteno
L
2
EQU
Equal
Source A 112
Source B STAV 111
Vreteno
TON
Timer On Delay
Timer T_rozjezd
Preset 5000
Accum 0
EN
DN
T_rozjezd.DN
MOV
Move
Source 20
Dest STAV 111
3
EQU
Equal
Source A 111
Source B STAV 111
LIM
Limit Test (CIRC)
Low Limit -1
Test OsaX.ActualVelocity -0.46874997
High Limit 1
LIM
Limit Test (CIRC)
Low Limit -1
Test OsaY.ActualVelocity 0.0
High Limit 1
LIM
Limit Test (CIRC)
Low Limit -1
Test OsaZ.ActualVelocity 0.0
High Limit 1
Vreteno
U

4

RUCNI_pohyb / Automatika_ZAP / zkalibrovano

MAS
Motion Axis Stop
Axis OsaX ...
Motion Control MASX
Stop Type All
Change Decel No
Decel Rate 100
Decel Units % of Maximum
Change Decel Jerk No
Decel Jerk 100
Jerk Units % of Maximum
<< Less
EN DN ER IP PC

MAS
Motion Axis Stop
Axis OsaY ...
Motion Control MASY
Stop Type All
Change Decel No
Decel Rate 100
Decel Units % of Maximum
Change Decel Jerk No
Decel Jerk 100
Jerk Units % of Maximum
<< Less
EN DN ER IP PC

MAS
Motion Axis Stop
Axis OsaZ ...
Motion Control MASZ
Stop Type All
Change Decel No
Decel Rate 100
Decel Units % of Maximum
Change Decel Jerk No
Decel Jerk 100
Jerk Units % of Maximum
<< Less
EN DN ER IP PC

Vreteno
U

5

Porucha vretena
ALMD
Digital Alarm
ALMD alarm_VRETEMO ...
ProgAck Vreteno_ALARM.ACK
0
ProgReset Vreteno_ALARM.RESET
0
ProgDisable Vreteno_ALARM.DISABLE
0
ProgEnable Vreteno_ALARM.ENABLE
1
MinDurationPRE 1000
MinDurationACC 1000
InAlarm Acked Suppressed Disabled InstructFault

6

Chyba pri kontrole programu
ALMD
Digital Alarm
ALMD alarm_PROGRAM ...
ProgAck Chyba_prog
0
ProgReset Program_OK
1
ProgDisable Program_ALARM.DISABLE
0
ProgEnable Program_ALARM.ENABLE
0
MinDurationPRE 100
MinDurationACC 100
InAlarm Acked Suppressed Disabled InstructFault

7

Naruseni opticke zavory
ALMD
Digital Alarm
ALMD alarm_ZAVORA ...
ProgAck zavora
0
ProgReset Zavora_ALARM.RESET
0
ProgDisable Zavora_ALARM.DISABLE
0
ProgEnable Zavora_ALARM.ENABLE
1
MinDurationPRE 100
MinDurationACC 100
InAlarm Acked Suppressed Disabled InstructFault

8
OsaX.PosSoftOvertravelFault
OsaX.NegSoftOvertravelFault
Xpres_ALARM.ACK

9
Osa X mimo rozsah
ALMD
Digital Alarm
ALMD alarm_Xpres ...
ProgAck Xpres_ALARM.ACK
0
ProgReset Xpres_ALARM.RESET
0
ProgDisable Xpres_ALARM.DISABLE
0
ProgEnable Xpres_ALARM.ENABLE
1
MinDurationPRE 100
MinDurationACC 100
InAlarm
Acked
Suppressed
Disabled
InstructFault

10
OsaY.PosSoftOvertravelFault
OsaY.NegSoftOvertravelFault
Ypres_ALARM.ACK

11
Osa Y mimo rozsah
ALMD
Digital Alarm
ALMD alarm_Ypres ...
ProgAck Ypres_ALARM.ACK
0
ProgReset Ypres_ALARM.RESET
0
ProgDisable Ypres_ALARM.DISABLE
0
ProgEnable Ypres_ALARM.ENABLE
1
MinDurationPRE 100
MinDurationACC 100
InAlarm
Acked
Suppressed
Disabled
InstructFault

12
OsaZ.PosSoftOvertravelFault
OsaZ.NegSoftOvertravelFault
Zpres_ALARM.ACK

13
Osa Z mimo rozsah
ALMD
Digital Alarm
ALMD alarm_Zpres ...
ProgAck Zpres_ALARM.ACK
0
ProgReset Zpres_ALARM.RESET
0
ProgDisable Zpres_ALARM.DISABLE
0
ProgEnable Zpres_ALARM.ENABLE
1
MinDurationPRE 100
MinDurationACC 100
InAlarm
Acked
Suppressed
Disabled
InstructFault

14
EQU
Equal
Source A OsaX.AxisFault
16#0000_0000
Source B 0
XChyba_ALARM.ACK

15
Chyba osy X
ALMD
Digital Alarm
ALMD alarm_XChyba ...
ProgAck XChyba_ALARM.ACK
1
ProgReset XChyba_ALARM.RESET
0
ProgDisable XChyba_ALARM.DISABLE
0
ProgEnable XChyba_ALARM.ENABLE
1
MinDurationPRE 100
MinDurationACC 100
InAlarm
Acked
Suppressed
Disabled
InstructFault

16
EQU
Equal
Source A OsaY.AxisFault
16#0000_0000
Source B 0
YChyba_ALARM.ACK

17 Chyba osy Y

ALMD
Digital Alarm
ALMD alarm_YChyba ...
ProgAck YChyba_ALARM.ACK 1
ProgReset YChyba_ALARM.RESET 0
ProgDisable YChyba_ALARM.DISABLE 0
ProgEnable YChyba_ALARM.ENABLE 1
MinDurationPRE 100
MinDurationACC 100
InAlarm, Acked, Suppressed, Disabled, InstructFault

18 EQU
Equal
Source A OsaZ.AxisFault 16#0000_0000
Source B 0
ZChyba_ALARM.ACK

19 Chyba osy Z

ALMD
Digital Alarm
ALMD alarm_ZChyba ...
ProgAck ZChyba_ALARM.ACK 1
ProgReset ZChyba_ALARM.RESET 0
ProgDisable ZChyba_ALARM.DISABLE 0
ProgEnable ZChyba_ALARM.ENABLE 1
MinDurationPRE 100
MinDurationACC 100
InAlarm, Acked, Suppressed, Disabled, InstructFault

20 OsaX.AxisHomedStatus]/[XHome_ALARM.ACK

21 Chyba HOME osy X

ALMD
Digital Alarm
ALMD alarm_XHome ...
ProgAck XHome_ALARM.ACK 0
ProgReset XHome_ALARM.RESET 0
ProgDisable XHome_ALARM.DISABLE 0
ProgEnable XHome_ALARM.ENABLE 1
MinDurationPRE 100
MinDurationACC 100
InAlarm, Acked, Suppressed, Disabled, InstructFault

22 OsaY.AxisHomedStatus]/[YHome_ALARM.ACK

23 Chyba HOME osy Y

ALMD
Digital Alarm
ALMD alarm_YHome ...
ProgAck YHome_ALARM.ACK 0
ProgReset YHome_ALARM.RESET 0
ProgDisable YHome_ALARM.DISABLE 0
ProgEnable YHome_ALARM.ENABLE 1
MinDurationPRE 100
MinDurationACC 100
InAlarm, Acked, Suppressed, Disabled, InstructFault

24 OsaZ.AxisHomedStatus]/[ZHome_ALARM.ACK

25 Chyba HOME osy Z

ALMD
Digital Alarm
ALMD alarm_ZHome ...
ProgAck ZHome_ALARM.ACK 0
ProgReset ZHome_ALARM.RESET 0
ProgDisable ZHome_ALARM.DISABLE 0
ProgEnable ZHome_ALARM.ENABLE 1
MinDurationPRE 100
MinDurationACC 100
InAlarm, Acked, Suppressed, Disabled, InstructFault

26

EQU
Equal
Source A STAV
111
Source B 100

Chyba_vykonavani_inst_ALARM.ACK

27

vykonavani instrukce
selhalo

ALMD
Digital Alarm
ALMD alarm_Chyba_vykonavani_inst ...
ProgAck Chyba_vykonavani_inst_ALARM.ACK
0
ProgReset Chyba_vykonavani_inst_ALARM.RESET
0
ProgDisable Chyba_vykonavani_inst_ALARM.DISABLE
0
ProgEnable Chyba_vykonavani_inst_ALARM.ENABLE
1
MinDurationPRE 0
MinDurationACC 0

InAlarm
Acked
Suppressed
Disabled
InstructFault

(End)

0

MOV
Move
Source 20
Dest STAV
111

MOV
Move
Source 0
Dest Poradi_instrukce
0

MOV
Move
Source 1000
Dest Tzpozdeni.PRE
1000

MOV
Move
Source 0
Dest Tzpozdeni.ACC
0

MOV
Move
Source 0
Dest data[0]
116.73

MOV
Move
Source 0
Dest data[1]
66.78125

MOV
Move
Source 0
Dest data[2]
29.205002

Konec_programu
(U)

Zalohovani
(L)

Chyba_prog
(U)

Program_OK
(U)

COP
Copy File
Source MCCMReset
Dest coordinate_MCCM[0]
Length 1

COP
Copy File
Source MCLMreset
Dest coordinate_MCLM[0]
Length 1

MOV
Move
Source 110
Dest offsetZ
39.205

MOV
Move
Source 0
Dest offsetX
116.73

MOV
Move
Source 0
Dest offsetY
66.78125

COP
Copy File
Source MCCMReset
Dest MASX
Length 1

COP
Copy File
Source MCCMReset
Dest MASY
Length 1
COP
Copy File
Source MCCMReset
Dest MASZ
Length 1
COP
Copy File
Source MCCMReset
Dest x_MAS
Length 1
COP
Copy File
Source MCCMReset
Dest y_MAS
Length 1
COP
Copy File
Source MCCMReset
Dest z_MAS
Length 1
COP
Copy File
Source MCCMReset
Dest x_MI_MSF[1]
Length 1
COP
Copy File
Source MCCMReset
Dest y_MI_MSF[1]
Length 1
COP
Copy File
Source MCCMReset
Dest z_MI_MSF[1]
Length 1
COP
Copy File
Source MCCMReset
Dest x_MI_MAH[0]
Length 1
COP
Copy File
Source MCCMReset
Dest y_MI_MAH[0]
Length 1
COP
Copy File
Source MCCMReset
Dest z_MI_MAH[0]
Length 1
(End)

0

MOV
Move Source -1
Dest PoradiG 1

MOV
Move Source -1
Dest PoradiM 0

MOV
Move Source -1
Dest PoradiX -1

MOV
Move Source -1
Dest PoradiY -1

MOV
Move Source -1
Dest PoradiZ -1

MOV
Move Source -1
Dest RealM -1.0

MOV
Move Source -1
Dest RealG 4.0

MOV
Move Source -1
Dest PoradiP 5

MOV
Move Source -1
Dest PoradiF -1

MOV
Move Source -1
Dest Poradizavorka 0

MOV
Move Source -1
Dest PoradiR -1

MOV
Move Source 0
Dest RealR 0.0

dekodovano
U

instM
U

komentar
U

1

FIND
Find String
Source instrukce[Poradi_instrukce] ??
Search G 'G'
Start 1
Result PoradiG 1

FIND
Find String
Source instrukce[Poradi_instrukce] ??
Search M 'M'
Start 1
Result PoradiM 0

FIND
Find String
Source instrukce[Poradi_instrukce] ??
Search zavorka '('
Start 1
Result Poradizavorka 0

2

EQU
Equal
Source A Poradizavorka 0
Source B 1

GRT
Greater Than (A>B)
Source A Poradizavorka 0
Source B 1

dekodovano (L)
komentar (L)
skok_M (JMP)

3

EQU
Equal
Source A PoradiM 0
Source B 1

STOR
String to Real
Source instrukce[Poradi_instrukce] ??
Dest RealM -1.0

skok_M (JMP)

4

EQU
Equal
Source A PoradiG 1
Source B 1

STOR
String to Real
Source instrukce[Poradi_instrukce] ??
Dest RealG 4.0

5

EQU
Equal
Source A PoradiG 1
Source B 1

EQU
Equal
Source A RealG 4.0
Source B 1.0

EQU
Equal
Source A RealG 4.0
Source B 2.0

EQU
Equal
Source A RealG 4.0
Source B 3.0

FIND
Find String
Source instrukce[Poradi_instrukce] ??
Search F 'F'
Start 1
Result PoradiF -1

GRT
Greater Than (A>B)
Source A PoradiF -1
Source B 4

MID
Middle String
Source instrukce[Poradi_instrukce] ??
Qty 8
Start PoradiF -1
Dest inst[4] 'F30.00 '

GRT
Greater Than (A>B)
Source A PoradiF -1
Source B 4

STOD
String To DINT
Source inst[4] 'F30.00 '
Dest V_pracposuv 30

6

EQU
Equal
Source A PoradiG
1
Source B 1
1

EQU
Equal
Source A RealG
4.0
Source B 90.0

Absprog
L
dekodovano
L

EQU
Equal
Source A RealG
4.0
Source B 21.0

ProgMM
L
dekodovano
L

EQU
Equal
Source A RealG
4.0
Source B 0.0

Rychlopos
L
Pracpos
U

MOV
Move
Source V_rychloposuv
100
Dest Rychlost_posuvu
100

EQU
Equal
Source A RealG
4.0
Source B 1.0

Rychlopos
U
Pracpos
L

MOV
Move
Source V_pracposuv
30
Dest Rychlost_posuvu
100

EQU
Equal
Source A RealG
4.0
Source B 2.0

EQU
Equal
Source A RealG
4.0
Source B 3.0

7

EQU
Equal
Source A PoradiG
1
Source B 1

EQU
Equal
Source A RealG
4.0
Source B 4.0

FIND
Find String
Source instrukce[Poradi_instrukce]
??
Search P
'P'
Start 1
Result PoradiP
5

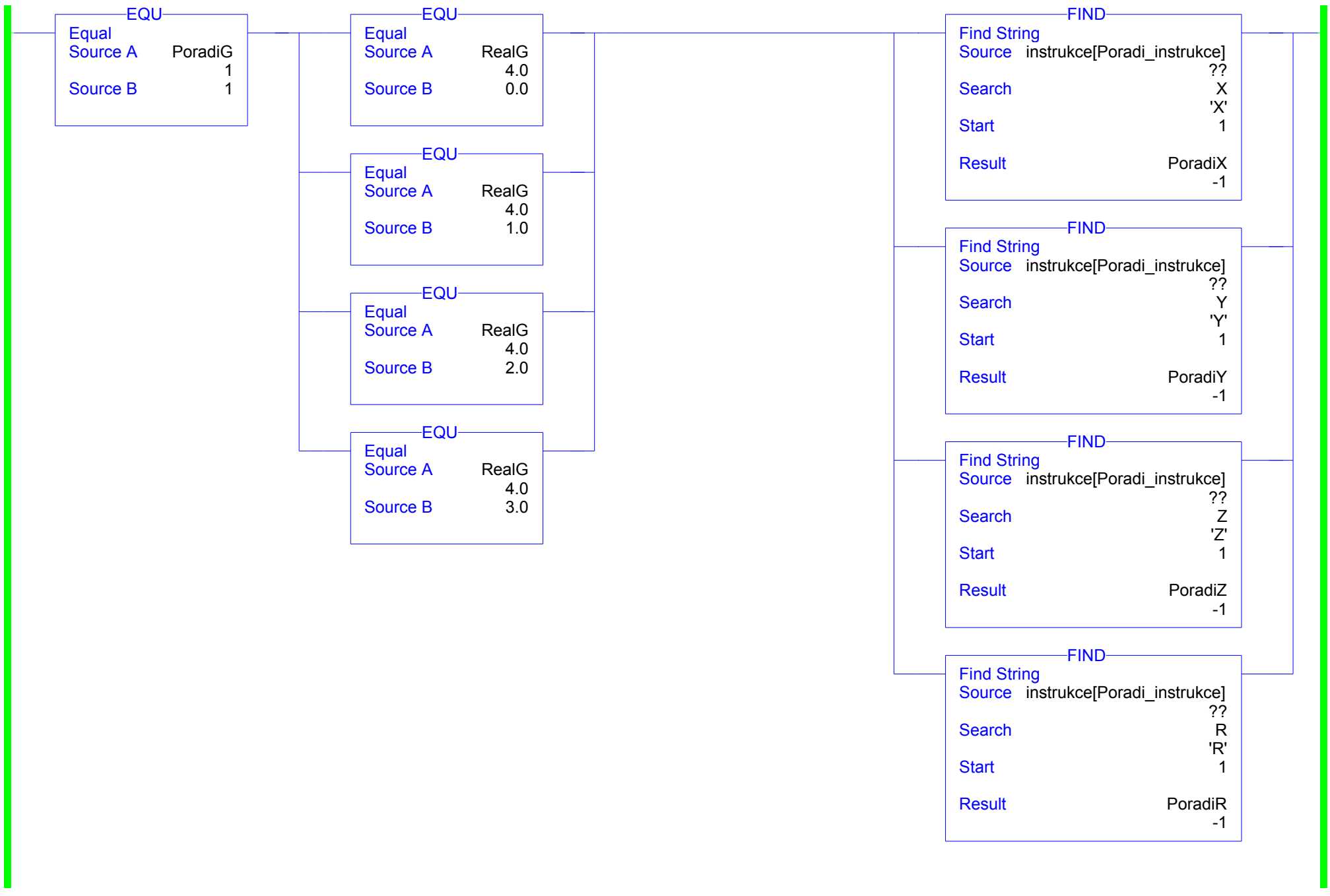
MID
Middle String
Source instrukce[Poradi_instrukce]
??
Qty 8
Start PoradiP
5
Dest inst[3]
'P5.00000'

STOR
String to Real
Source inst[3]
'P5.00000'
Dest zpozdeni_vereteno
5.0

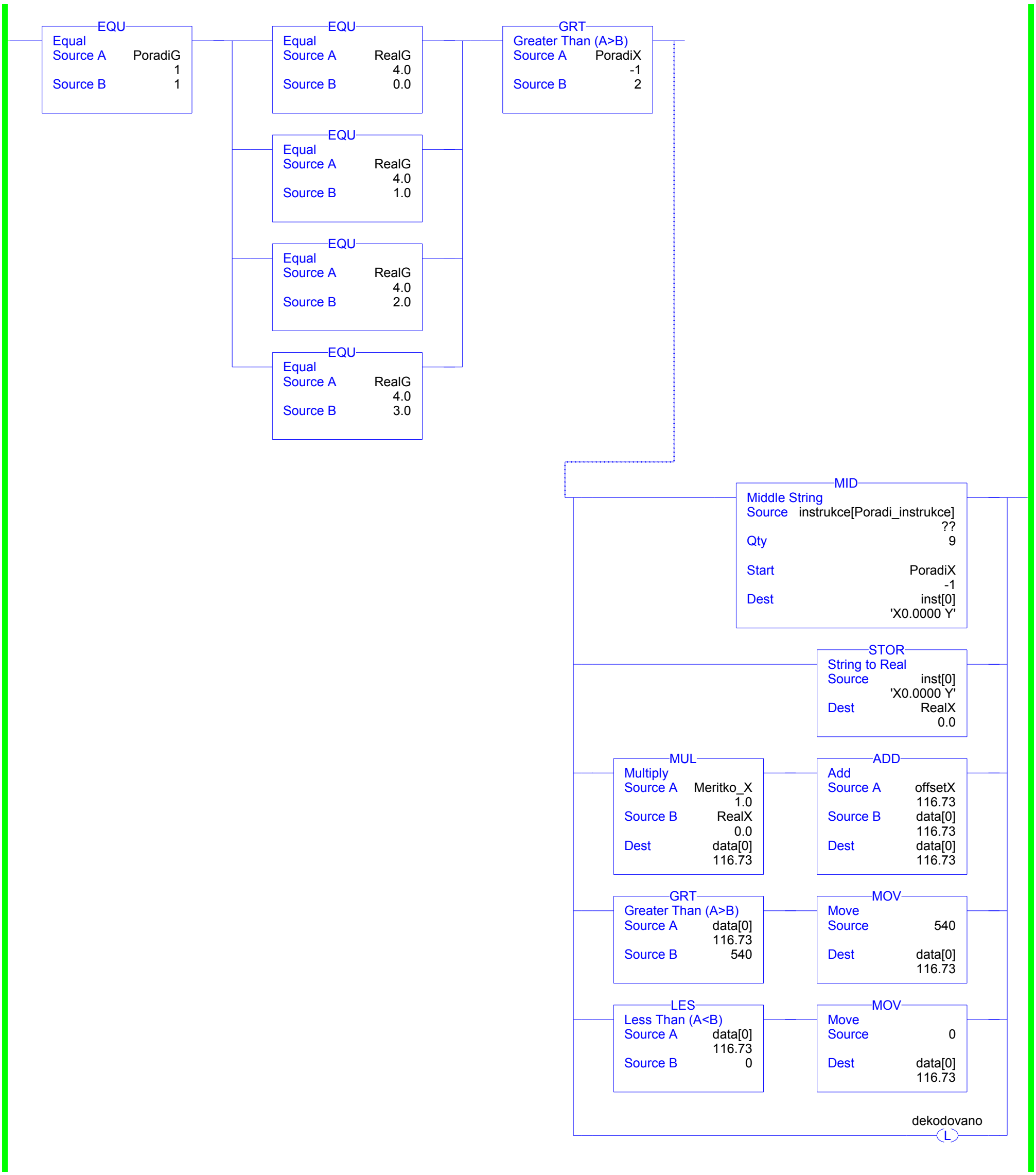
MUL
Multiply
Source A 1000
Source B zpozdeni_vereteno
5.0
Dest Tzpozdeni.PRE
1000

dekodovano
L

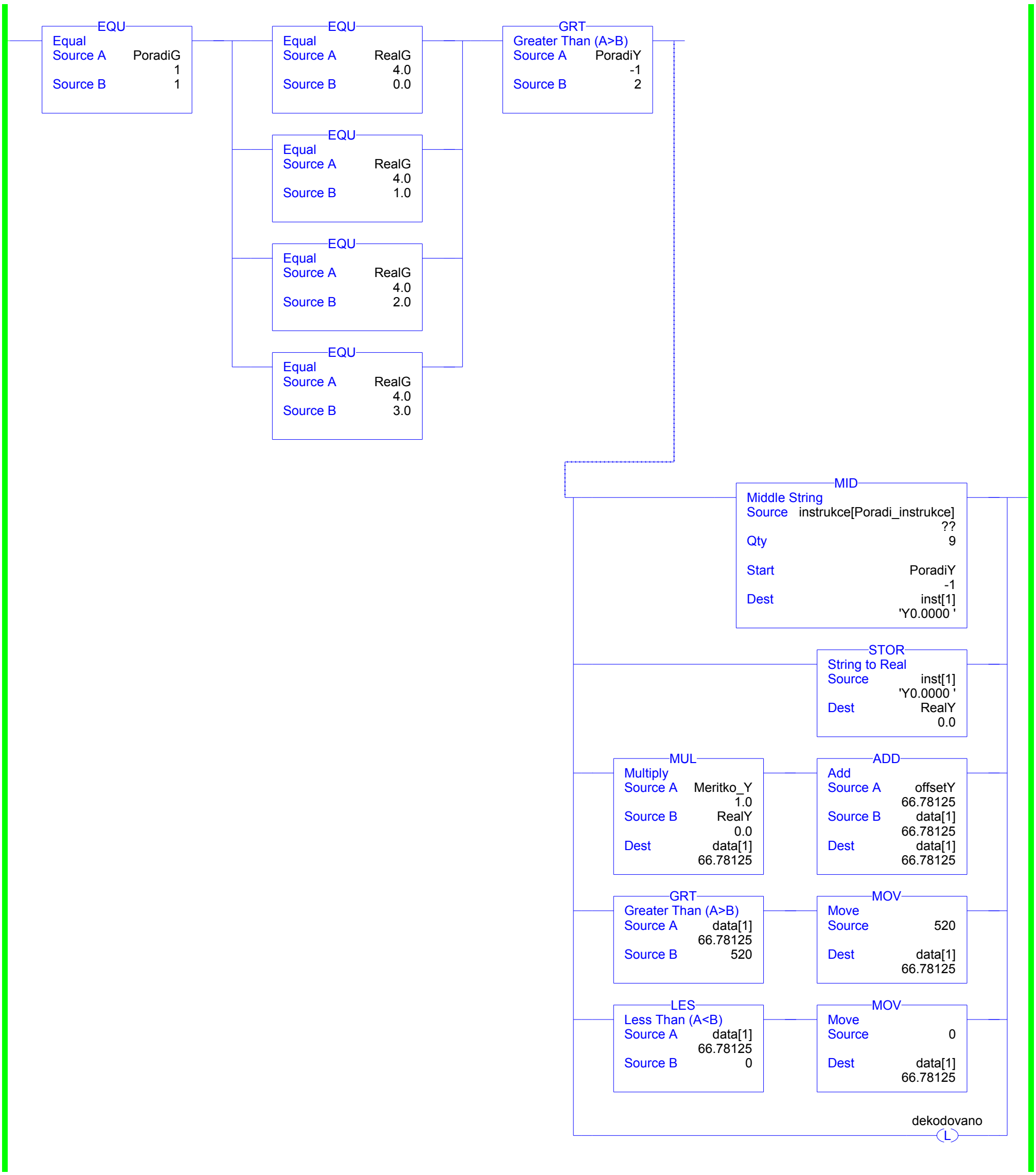
8


EQU
Equal
Source A PoradiG
1
Source B 1
EQU
Equal
Source A RealG
4.0
Source B 0.0
EQU
Equal
Source A RealG
4.0
Source B 1.0
EQU
Equal
Source A RealG
4.0
Source B 2.0
EQU
Equal
Source A RealG
4.0
Source B 3.0
FIND
Find String
Source instrukce[Poradi_instrukce]
??
Search X
'X'
Start 1
Result PoradiX
-1
FIND
Find String
Source instrukce[Poradi_instrukce]
??
Search Y
'Y'
Start 1
Result PoradiY
-1
FIND
Find String
Source instrukce[Poradi_instrukce]
??
Search Z
'Z'
Start 1
Result PoradiZ
-1
FIND
Find String
Source instrukce[Poradi_instrukce]
??
Search R
'R'
Start 1
Result PoradiR
-1

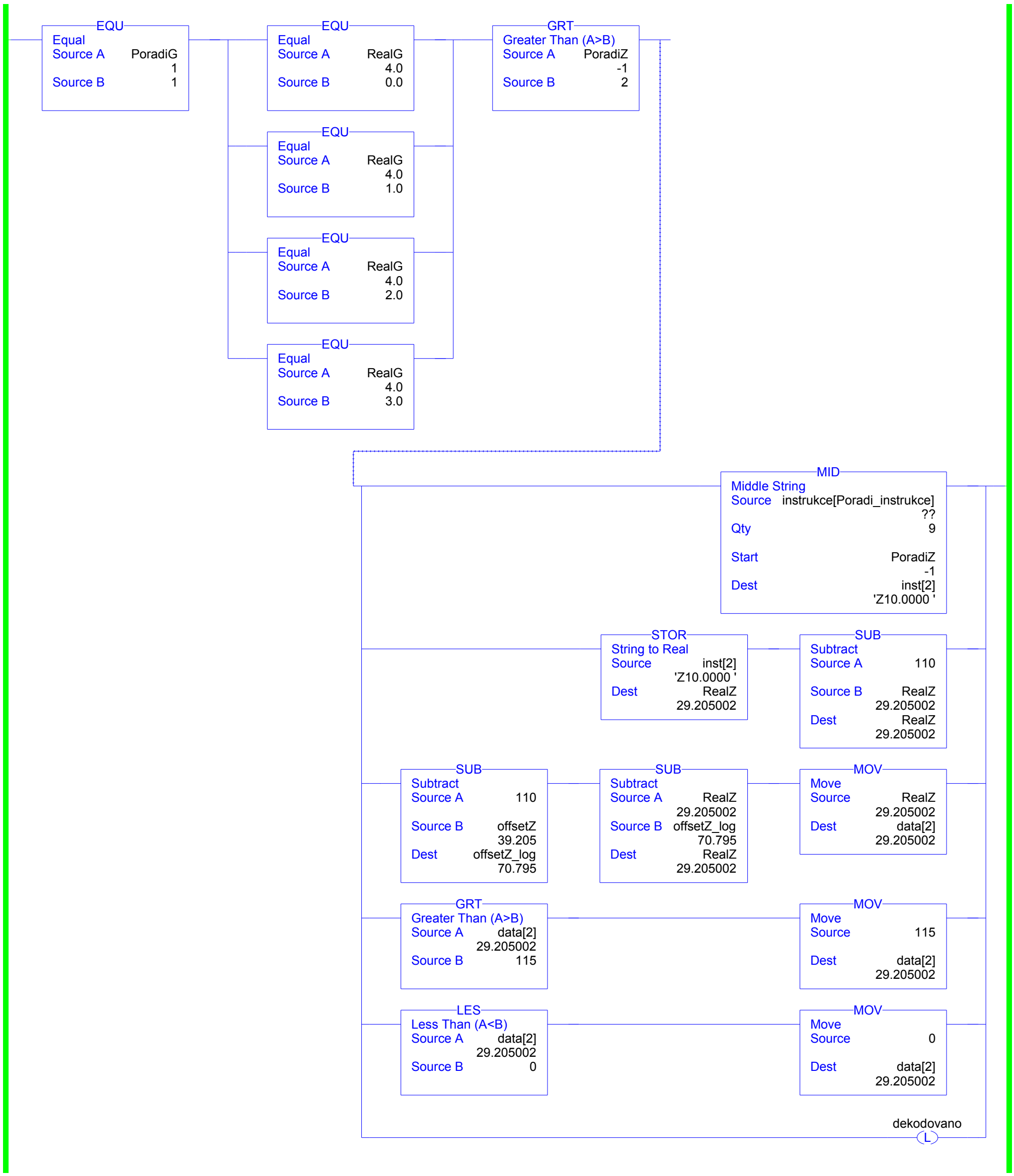
9


EQU
Equal
Source A PoradiG
1
Source B 1
EQU
Equal
Source A RealG
4.0
Source B 0.0
GRT
Greater Than (A>B)
Source A PoradiX
-1
Source B 2
EQU
Equal
Source A RealG
4.0
Source B 1.0
EQU
Equal
Source A RealG
4.0
Source B 2.0
EQU
Equal
Source A RealG
4.0
Source B 3.0
MID
Middle String
Source instrukce[Poradi_instrukce]
??
Qty 9
Start PoradiX
-1
Dest inst[0]
'X0.0000 Y'
STOR
String to Real
Source inst[0]
'X0.0000 Y'
Dest RealX
0.0
MUL
Multiply
Source A Meritko_X
1.0
Source B RealX
0.0
Dest data[0]
116.73
ADD
Add
Source A offsetX
116.73
Source B data[0]
116.73
Dest data[0]
116.73
GRT
Greater Than (A>B)
Source A data[0]
116.73
Source B 540
MOV
Move
Source 540
Dest data[0]
116.73
LES
Less Than (A<B)
Source A data[0]
116.73
Source B 0
MOV
Move
Source 0
Dest data[0]
116.73
dekodovano
L

10


EQU
Equal
Source A PoradiG
1
Source B 1
EQU
Equal
Source A RealG
4.0
Source B 0.0
GRT
Greater Than (A>B)
Source A PoradiY
-1
Source B 2
EQU
Equal
Source A RealG
4.0
Source B 1.0
EQU
Equal
Source A RealG
4.0
Source B 2.0
EQU
Equal
Source A RealG
4.0
Source B 3.0
MID
Middle String
Source instrukce[Poradi_instrukce]
??
Qty 9
Start PoradiY
-1
Dest inst[1]
'Y0.0000 '
STOR
String to Real
Source inst[1]
'Y0.0000 '
Dest RealY
0.0
MUL
Multiply
Source A Meritko_Y
1.0
Source B RealY
0.0
Dest data[1]
66.78125
ADD
Add
Source A offsetY
66.78125
Source B data[1]
66.78125
Dest data[1]
66.78125
GRT
Greater Than (A>B)
Source A data[1]
66.78125
Source B 520
MOV
Move
Source 520
Dest data[1]
66.78125
LES
Less Than (A<B)
Source A data[1]
66.78125
Source B 0
MOV
Move
Source 0
Dest data[1]
66.78125
dekodovano
L

11


EQU
Equal
Source A PoradiG
1
Source B 1
EQU
Equal
Source A RealG
4.0
Source B 0.0
GRT
Greater Than (A>B)
Source A PoradiZ
-1
Source B 2
EQU
Equal
Source A RealG
4.0
Source B 1.0
EQU
Equal
Source A RealG
4.0
Source B 2.0
EQU
Equal
Source A RealG
4.0
Source B 3.0
MID
Middle String
Source instrukce[Poradi_instrukce]
??
Qty 9
Start PoradiZ
-1
Dest inst[2]
'Z10.0000 '
STOR
String to Real
Source inst[2]
'Z10.0000 '
Dest RealZ
29.205002
SUB
Subtract
Source A 110
Source B RealZ
29.205002
Dest RealZ
29.205002
SUB
Subtract
Source A 110
Source B offsetZ
39.205
Dest offsetZ_log
70.795
SUB
Subtract
Source A RealZ
29.205002
Source B offsetZ_log
70.795
Dest RealZ
29.205002
MOV
Move
Source RealZ
29.205002
Dest data[2]
29.205002
GRT
Greater Than (A>B)
Source A data[2]
29.205002
Source B 115
MOV
Move
Source 115
Dest data[2]
29.205002
LES
Less Than (A<B)
Source A data[2]
29.205002
Source B 0
MOV
Move
Source 0
Dest data[2]
29.205002
dekodovano
L

12

EQU
Equal
Source A PoradiG 1
Source B 1

EQU
Equal
Source A RealG 4.0
Source B 2.0

EQU
Equal
Source A RealG 4.0
Source B 3.0

GRT
Greater Than (A>B)
Source A PoradiR -1
Source B 2

MID
Middle String
Source instrukce[Poradi_instrukce] ??
Qty 9
Start PoradiR -1
Dest inst[5] 'R60.00'

STOR
String to Real
Source inst[5] 'R60.00'
Dest RealR 0.0

EQU
Equal
Source A RealG 4.0
Source B 2.0

MOV
Move
Source 0
Dest smer_KI 0

EQU
Equal
Source A RealG 4.0
Source B 3.0

MOV
Move
Source 1
Dest smer_KI 0

13

skok_M
LBL

EQU
Equal
Source A PoradiM 0
Source B 1

instM
L

EQU
Equal
Source A RealM -1.0
Source B 3.0

KONTROLA_programu
Vreteno
L

dekodovano
L

EQU
Equal
Source A RealM -1.0
Source B 2.0

Konec_programu
L

dekodovano
L

EQU
Equal
Source A RealM -1.0
Source B 5.0

Vreteno
U

dekodovano
L

14

dekodovano

MOV
Move
Source 30
Dest STAV 111

dekodovano

MOV
Move
Source 101
Dest STAV 111

(End)

0

Zalohovani

MOV
Move
Source Poradi_instrukce
0
Dest Zaloha_poradi_instrukce
0

MOV
Move
Source 0
Dest Poradi_instrukce
0

MOV
Move
Source data[0]
116.73
Dest Zaloha_data[0]
0.0

MOV
Move
Source data[1]
66.78125
Dest Zaloha_data[1]
0.0

MOV
Move
Source data[2]
29.205002
Dest Zaloha_data[2]
0.0

MOV
Move
Source Rychlost_posuvu
100
Dest Zaloha_Rychlost_posuvu
100

MOV
Move
Source -1
Dest Chyba_instrukce
-1

dekodovano (U)

instM (U)

komentar (U)

Absprog (U)

ProgMM (U)

Chyba_prog (U)

Program_OK (U)

Zalohovani (U)

Program_ALARM.ENABLE (L)

1

JSR
Jump To Subroutine
Routine Name instrukce

2

dekodovano /

MOV
Move
Source Poradi_instrukce
0
Dest Chyba_instrukce
-1

Chyba_prog (L)

skok_Chyba (JMP)

3

dekodovano komentar

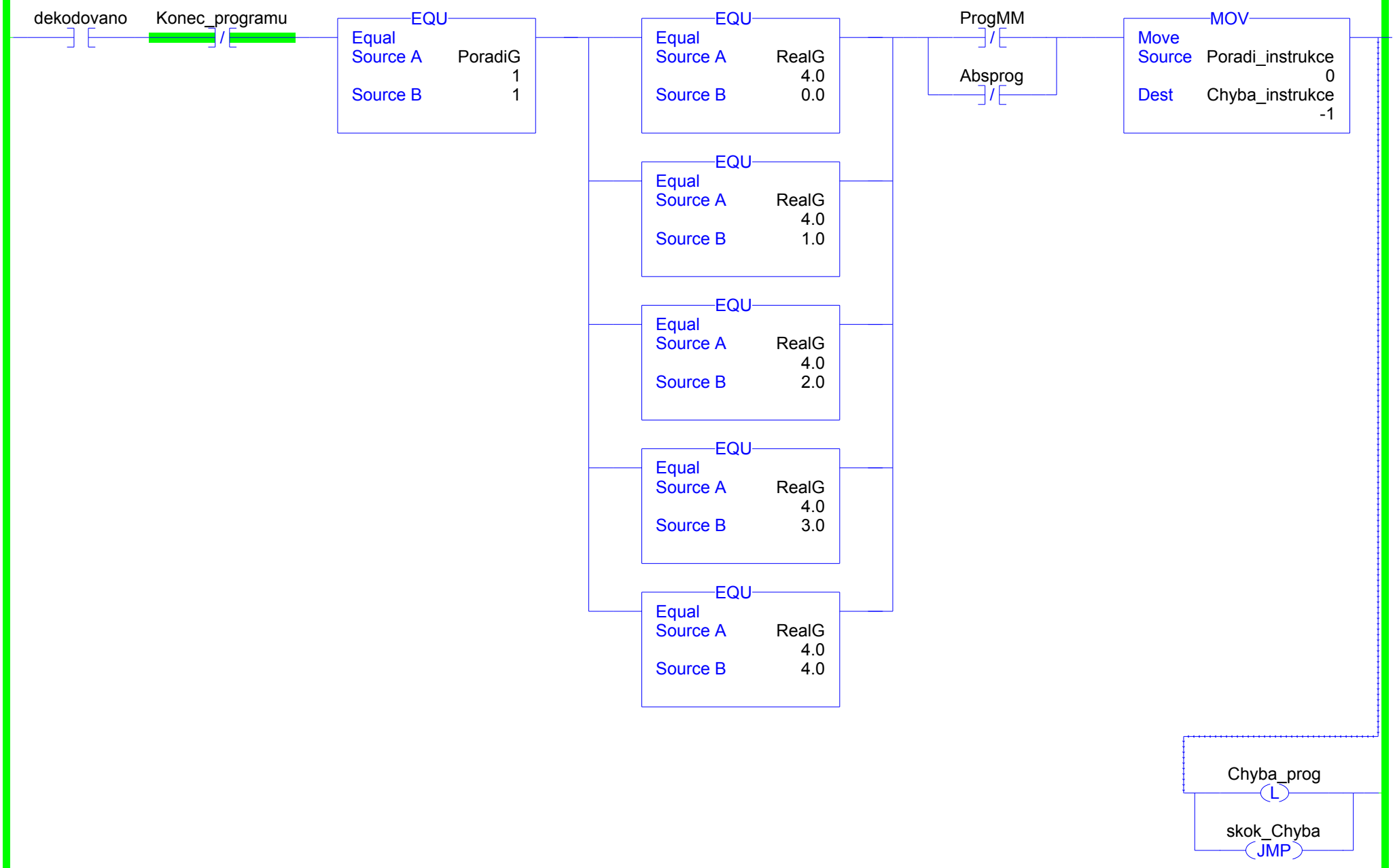
skok_Kom (JMP)

4

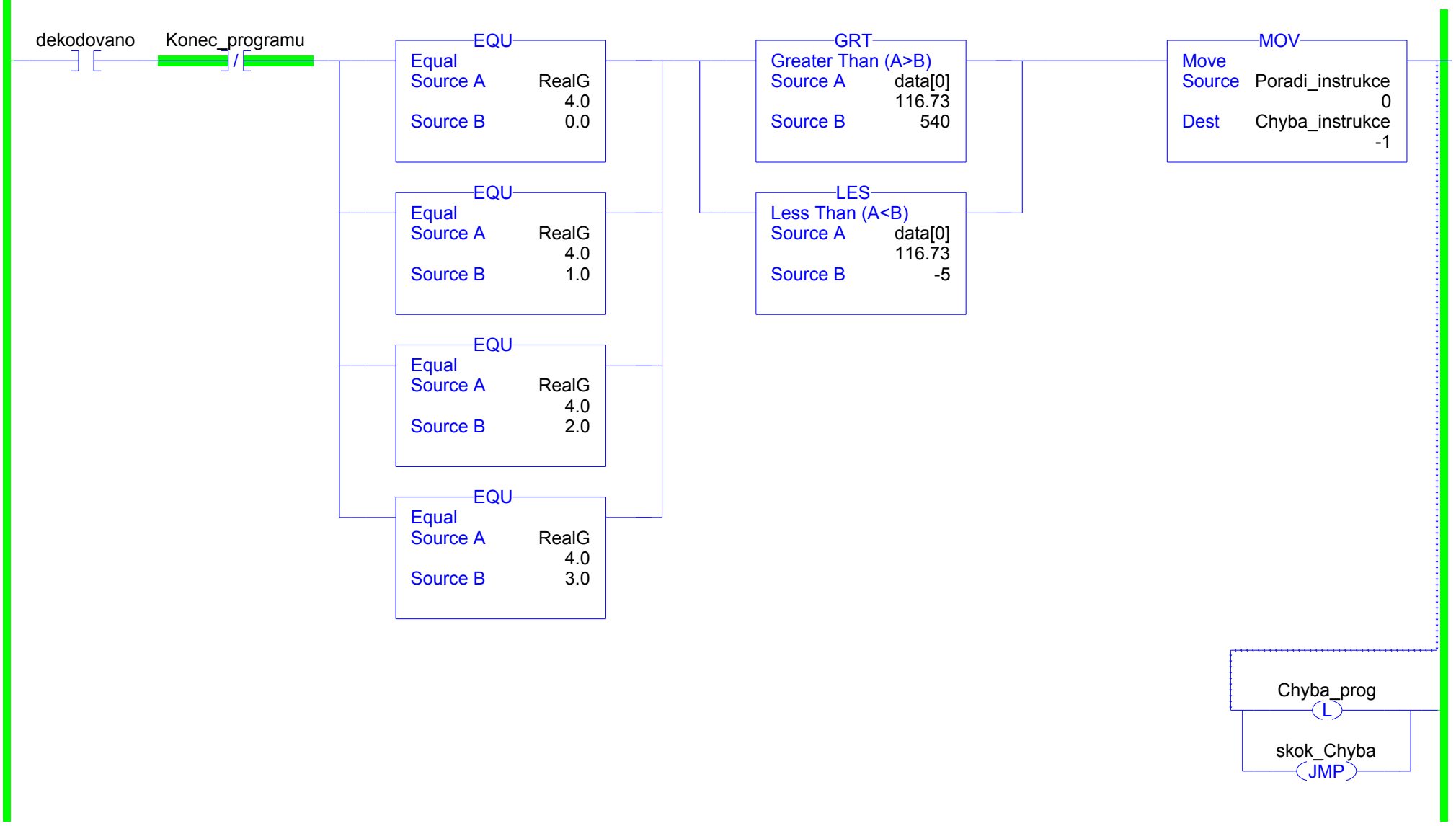
dekodovano instM

skok_Minst (JMP)

5


dekodovano
Konec_programu
EQU
Equal
Source A PoradiG 1
Source B 1
EQU
Equal
Source A RealG 4.0
Source B 0.0
EQU
Equal
Source A RealG 4.0
Source B 1.0
EQU
Equal
Source A RealG 4.0
Source B 2.0
EQU
Equal
Source A RealG 4.0
Source B 3.0
EQU
Equal
Source A RealG 4.0
Source B 4.0
ProgMM
Absprog
MOV
Move
Source Poradi_instrukce 0
Dest Chyba_instrukce -1
Chyba_prog
L
skok_Chyba
JMP

6


dekodovano
Konec_programu
EQU
Equal
Source A RealG 4.0
Source B 0.0
EQU
Equal
Source A RealG 4.0
Source B 1.0
EQU
Equal
Source A RealG 4.0
Source B 2.0
EQU
Equal
Source A RealG 4.0
Source B 3.0
GRT
Greater Than (A>B)
Source A data[0] 116.73
Source B 540
LES
Less Than (A<B)
Source A data[0] 116.73
Source B -5
MOV
Move
Source Poradi_instrukce 0
Dest Chyba_instrukce -1
Chyba_prog
L
skok_Chyba
JMP

7

dekodovano — Konec_programu /

EQU Equal Source A RealG 4.0 Source B 0.0

EQU Equal Source A RealG 4.0 Source B 1.0

EQU Equal Source A RealG 4.0 Source B 2.0

EQU Equal Source A RealG 4.0 Source B 3.0

GRT Greater Than (A>B) Source A data[1] 66.78125 Source B 520

LES Less Than (A<B) Source A data[1] 66.78125 Source B -10

MOV Move Source Poradi_instrukce 0 Dest Chyba_instrukce -1

Chyba_prog (L)

skok_Chyba (JMP)

8

dekodovano — Konec_programu /

EQU Equal Source A RealG 4.0 Source B 0.0

EQU Equal Source A RealG 4.0 Source B 1.0

EQU Equal Source A RealG 4.0 Source B 2.0

EQU Equal Source A RealG 4.0 Source B 3.0

GRT Greater Than (A>B) Source A data[2] 29.205002 Source B 115

LES Less Than (A<B) Source A data[2] 29.205002 Source B -1

MOV Move Source Poradi_instrukce 0 Dest Chyba_instrukce -1

Chyba_prog (L)

skok_Chyba (JMP)

9

skok_Kom [LBL] — komentar (U)

10

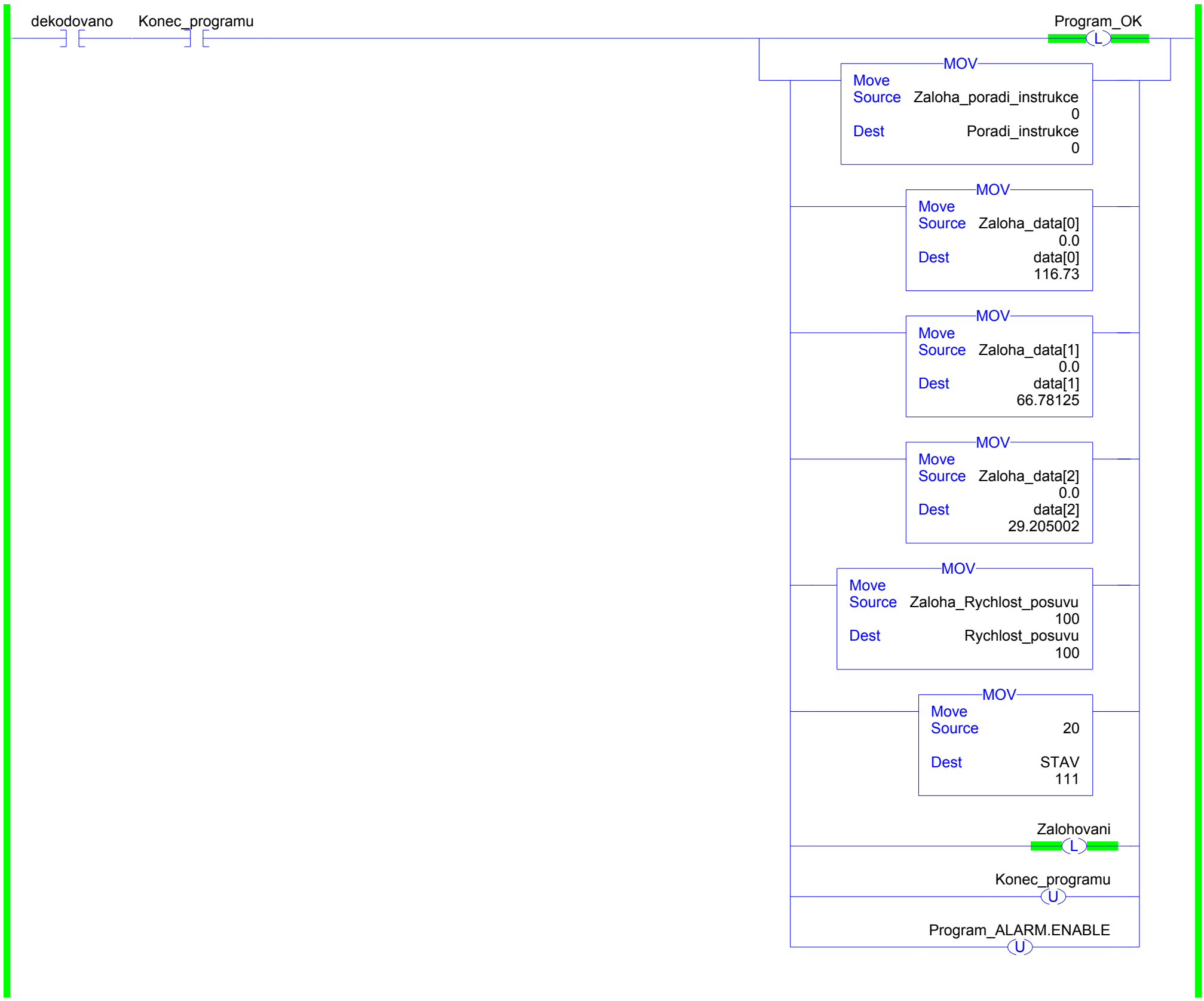
skok_Minst [LBL] — instM (U)

11

dekodovano — Chyba_prog / — Konec_programu /

ADD Add Source A 1 Source B Poradi_instrukce 0 Dest Poradi_instrukce 0

12


dekodovano
Konec_programu
Program_OK
L
MOV
Move
Source Zaloha_poradi_instrukce
0
Dest Poradi_instrukce
0
MOV
Move
Source Zaloha_data[0]
0.0
Dest data[0]
116.73
MOV
Move
Source Zaloha_data[1]
0.0
Dest data[1]
66.78125
MOV
Move
Source Zaloha_data[2]
0.0
Dest data[2]
29.205002
MOV
Move
Source Zaloha_Rychlost_posuvu
100
Dest Rychlost_posuvu
100
MOV
Move
Source 20
Dest STAV
111
Zalohovani
L
Konec_programu
U
Program_ALARM.ENABLE
U

13

skok_Chyba LBL — Chyba_prog

Program_OK U

MOV
Move
Source Zaloha_poradi_instrukce 0
Dest Poradi_instrukce 0

MOV
Move
Source Zaloha_data[0] 0.0
Dest data[0] 116.73

MOV
Move
Source Zaloha_data[1] 0.0
Dest data[1] 66.78125

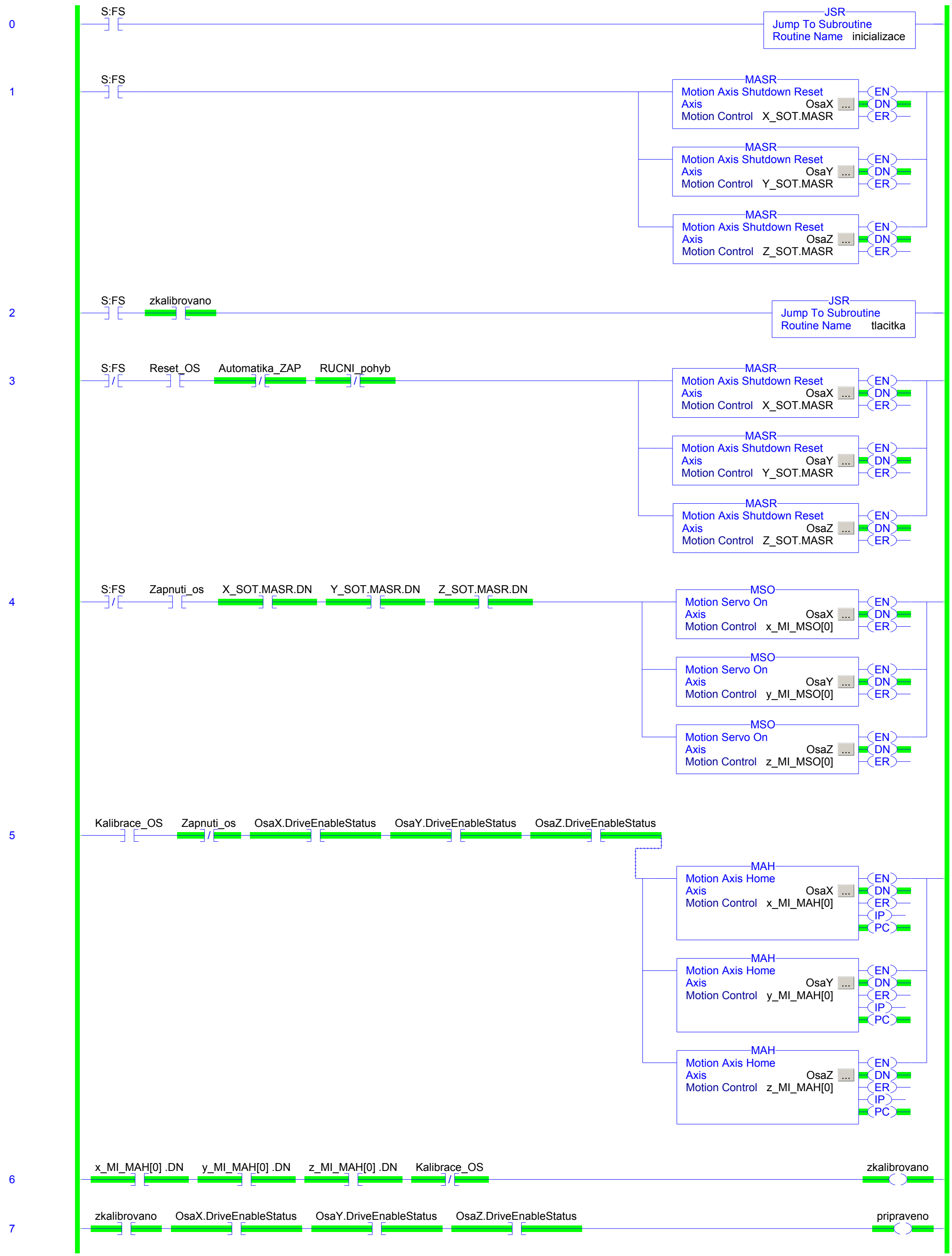
MOV
Move
Source Zaloha_data[2] 0.0
Dest data[2] 29.205002

MOV
Move
Source Zaloha_Rychlost_posuvu 100
Dest Rychlost_posuvu 100

MOV
Move
Source 20
Dest STAV 111

Zalohovani L

(End)


0
S:FS
JSR
Jump To Subroutine
Routine Name inicializace
1
S:FS
MASR
Motion Axis Shutdown Reset
Axis OsaX
Motion Control X_SOT.MASR
EN
DN
ER
MASR
Motion Axis Shutdown Reset
Axis OsaY
Motion Control Y_SOT.MASR
MASR
Motion Axis Shutdown Reset
Axis OsaZ
Motion Control Z_SOT.MASR
2
S:FS
zkalibrovano
JSR
Jump To Subroutine
Routine Name tlacitka
3
S:FS
Reset_OS
Automatika_ZAP
RUCNI_pohyb
MASR
Motion Axis Shutdown Reset
Axis OsaX
Motion Control X_SOT.MASR
MASR
Motion Axis Shutdown Reset
Axis OsaY
Motion Control Y_SOT.MASR
MASR
Motion Axis Shutdown Reset
Axis OsaZ
Motion Control Z_SOT.MASR
4
S:FS
Zapnuti_os
X_SOT.MASR.DN
Y_SOT.MASR.DN
Z_SOT.MASR.DN
MSO
Motion Servo On
Axis OsaX
Motion Control x_MI_MSO[0]
MSO
Motion Servo On
Axis OsaY
Motion Control y_MI_MSO[0]
MSO
Motion Servo On
Axis OsaZ
Motion Control z_MI_MSO[0]
5
Kalibrace_OS
Zapnuti_os
OsaX.DriveEnableStatus
OsaY.DriveEnableStatus
OsaZ.DriveEnableStatus
MAH
Motion Axis Home
Axis OsaX
Motion Control x_MI_MAH[0]
EN
DN
ER
IP
PC
MAH
Motion Axis Home
Axis OsaY
Motion Control y_MI_MAH[0]
MAH
Motion Axis Home
Axis OsaZ
Motion Control z_MI_MAH[0]
6
x_MI_MAH[0] .DN
y_MI_MAH[0] .DN
z_MI_MAH[0] .DN
Kalibrace_OS
zkalibrovano
7
zkalibrovano
OsaX.DriveEnableStatus
OsaY.DriveEnableStatus
OsaZ.DriveEnableStatus
pripraveno

8
pripraveno Automatika_ZAP Konec_programu KONTROLA_programu Program_OK RUCNI_pohyb STOP_Program Safety:O.Pt00Data
JSR
Jump To Subroutine
Routine Name automatika

9
pripraveno Automatika_ZAP RUCNI_pohyb
JSR
Jump To Subroutine
Routine Name posuv

10
Automatika_ZAP Reset_AUTOMATIKA KONTROLA_programu Program_OK Chyba_prog
JSR
Jump To Subroutine
Routine Name kontrola_Gkodu

11
Reset_AUTOMATIKA Automatika_ZAP KONTROLA_programu
MOV
Move
Source 20
Dest STAV
111
MOV
Move
Source 0
Dest Poradi_instrukce
0
MOV
Move
Source 1000
Dest Tzpozdeni.PRE
1000
MOV
Move
Source 0
Dest Tzpozdeni.ACC
0
Konec_programu
U
Vreteno
U

12
Programovani Automatika_ZAP KONTROLA_programu
progexel
MOV
Move
Source 0
Dest pocet_instrukci
0
Program_OK
U
Chyba_prog
U
progexel

13
Vypnuti_OS
MSF
Motion Servo Off
Axis OsaX ...
Motion Control x_MI_MSF[1]
EN
DN
ER
MSF
Motion Servo Off
Axis OsaY ...
Motion Control y_MI_MSF[1]
EN
DN
ER
MSF
Motion Servo Off
Axis OsaZ ...
Motion Control z_MI_MSF[1]
EN
DN
ER
Vreteno
U

14

zavora RUCNI_pohyb

MAS
Motion Axis Stop
Axis OsaX ...
Motion Control x_MAS
Stop Type All
Change Decel No
Decel Rate 100
Decel Units % of Maximum
Change Decel Jerk No
Decel Jerk 100
Jerk Units % of Maximum
<< Less
EN DN ER IP PC

MAS
Motion Axis Stop
Axis OsaY ...
Motion Control y_MAS
Stop Type All
Change Decel No
Decel Rate 100
Decel Units % of Maximum
Change Decel Jerk No
Decel Jerk 100
Jerk Units % of Maximum
<< Less
EN DN ER IP PC

MAS
Motion Axis Stop
Axis OsaZ ...
Motion Control z_MAS
Stop Type All
Change Decel No
Decel Rate 100
Decel Units % of Maximum
Change Decel Jerk No
Decel Jerk 100
Jerk Units % of Maximum
<< Less
EN DN ER IP PC

MOV
Move
Source 111
Dest STAV
111

15

COP
Copy File
Source instrukce[Poradi_instrukce]
Dest probihajici_instrukce
Length 1

COP
Copy File
Source instrukce[por_proh_ins]
Dest nahlizena_instrukce
Length 1

16

reset_alarms

JSR
Jump To Subroutine
Routine Name reset_ALARM

17

S:FS

JSR
Jump To Subroutine
Routine Name Chyby

(End)

0

xJOGplus x_MI_MAS.EN

LES
Less Than (A<B)
Source A pozice_X
<OsaX.ActualPosition>
116.72938
Source B 540

MAJ
Motion Axis Jog
Axis OsaX ...
Motion Control x_MI_MAJ[1]
Direction 0
Speed 20
Speed Units Units per sec
Accel Rate 10
Accel Units Units per sec2
Decel Rate 10
Decel Units Units per sec2
Profile Trapezoidal
Accel Jerk 10
Decel Jerk 10
Jerk Units Units per sec3
Merge Enabled
Merge Speed Programmed
<< Less

EN DN ER IP

1

xJOGminus x_MI_MAS.EN

GRT
Greater Than (A>B)
Source A pozice_X
<OsaX.ActualPosition>
116.72938
Source B -5

MAJ
Motion Axis Jog
Axis OsaX ...
Motion Control x_MI_MAJ[0]
Direction 1
Speed 20
Speed Units Units per sec
Accel Rate 10
Accel Units Units per sec2
Decel Rate 10
Decel Units Units per sec2
Profile Trapezoidal
Accel Jerk 10
Decel Jerk 10
Jerk Units Units per sec3
Merge Enabled
Merge Speed Programmed
<< Less

EN DN ER IP

2

xJOGplus x_MI_MAJ[1].IP

xJOGminus x_MI_MAJ[0].IP

xJOGminus

GRT
Greater Than (A>B)
Source A pozice_X
<OsaX.ActualPosition>
116.72938
Source B 541

xJOGplus

LES
Less Than (A<B)
Source A pozice_X
<OsaX.ActualPosition>
116.72938
Source B -6

xJOGplus xJOGminus

x_MI_MAJ[0].ER

x_MI_MAJ[1].ER

MAS
Motion Axis Stop
Axis OsaX ...
Motion Control x_MI_MAS
Stop Type Jog
Change Decel No
Decel Rate 100
Decel Units % of Maximum
Change Decel Jerk No
Decel Jerk 100
Jerk Units % of Maximum
<< Less

EN DN ER IP PC

3

yJOGplus y_MI_MAS.EN

LES
Less Than (A<B)
Source A pozice_Y <OsaY.ActualPosition> 66.78125
Source B 520

MAJ
Motion Axis Jog
Axis OsaY ...
Motion Control y_MI_MAJ[0]
Direction 0
Speed 20
Speed Units Units per sec
Accel Rate 10
Accel Units Units per sec2
Decel Rate 10
Decel Units Units per sec2
Profile Trapezoidal
Accel Jerk 10
Decel Jerk 10
Jerk Units Units per sec3
Merge Enabled
Merge Speed Programmed
<< Less

EN DN ER IP

4

yJOGminus y_MI_MAS.EN

GRT
Greater Than (A>B)
Source A pozice_Y <OsaY.ActualPosition> 66.78125
Source B -10

MAJ
Motion Axis Jog
Axis OsaY ...
Motion Control y_MI_MAJ[1]
Direction 1
Speed 20
Speed Units Units per sec
Accel Rate 10
Accel Units Units per sec2
Decel Rate 10
Decel Units Units per sec2
Profile Trapezoidal
Accel Jerk 10
Decel Jerk 10
Jerk Units Units per sec3
Merge Enabled
Merge Speed Programmed
<< Less

EN DN ER IP

5

yJOGplus y_MI_MAJ[0].IP

yJOGminus y_MI_MAJ[1].IP

yJOGminus

GRT
Greater Than (A>B)
Source A pozice_Y <OsaY.ActualPosition> 66.78125
Source B 521

yJOGplus

LES
Less Than (A<B)
Source A pozice_Y <OsaY.ActualPosition> 66.78125
Source B -11

yJOGplus yJOGminus

y_MI_MAJ[0].ER

y_MI_MAJ[1].ER

MAS
Motion Axis Stop
Axis OsaY ...
Motion Control y_MI_MAS
Stop Type Jog
Change Decel No
Decel Rate 100
Decel Units % of Maximum
Change Decel Jerk No
Decel Jerk 100
Jerk Units % of Maximum
<< Less

EN DN ER IP PC

6

zJOGplus z_MI_MAS.EN

LES
Less Than (A<B)
Source A pozice_Z <OsaZ.ActualPosition> 29.215626
Source B 130

MAJ
Motion Axis Jog
Axis OsaZ
Motion Control z_MI_MAJ[0]
Direction 0
Speed 20
Speed Units Units per sec
Accel Rate 10
Accel Units Units per sec2
Decel Rate 10
Decel Units Units per sec2
Profile Trapezoidal
Accel Jerk 10
Decel Jerk 10
Jerk Units Units per sec3
Merge Enabled
Merge Speed Programmed
<< Less

EN DN ER IP

7

zJOGminus z_MI_MAS.EN

GRT
Greater Than (A>B)
Source A pozice_Z <OsaZ.ActualPosition> 29.215626
Source B -1

MAJ
Motion Axis Jog
Axis OsaZ
Motion Control z_MI_MAJ[1]
Direction 1
Speed 20
Speed Units Units per sec
Accel Rate 10
Accel Units Units per sec2
Decel Rate 10
Decel Units Units per sec2
Profile Trapezoidal
Accel Jerk 10
Decel Jerk 10
Jerk Units Units per sec3
Merge Enabled
Merge Speed Programmed
<< Less

EN DN ER IP

8

zJOGplus z_MI_MAJ[0].IP

zJOGminus z_MI_MAJ[1].IP

zJOGminus

GRT
Greater Than (A>B)
Source A pozice_Z <OsaZ.ActualPosition> 29.215626
Source B 131

zJOGplus

LES
Less Than (A<B)
Source A pozice_Z <OsaZ.ActualPosition> 29.215626
Source B -2

zJOGplus zJOGminus

z_MI_MAJ[0].ER

z_MI_MAJ[1].ER

MAS
Motion Axis Stop
Axis OsaZ
Motion Control z_MI_MAS
Stop Type Jog
Change Decel No
Decel Rate 100
Decel Units % of Maximum
Change Decel Jerk No
Decel Jerk 100
Jerk Units % of Maximum
<< Less

EN DN ER IP PC

9

z_MI_MAS.ER

x_MI_MAS.ER

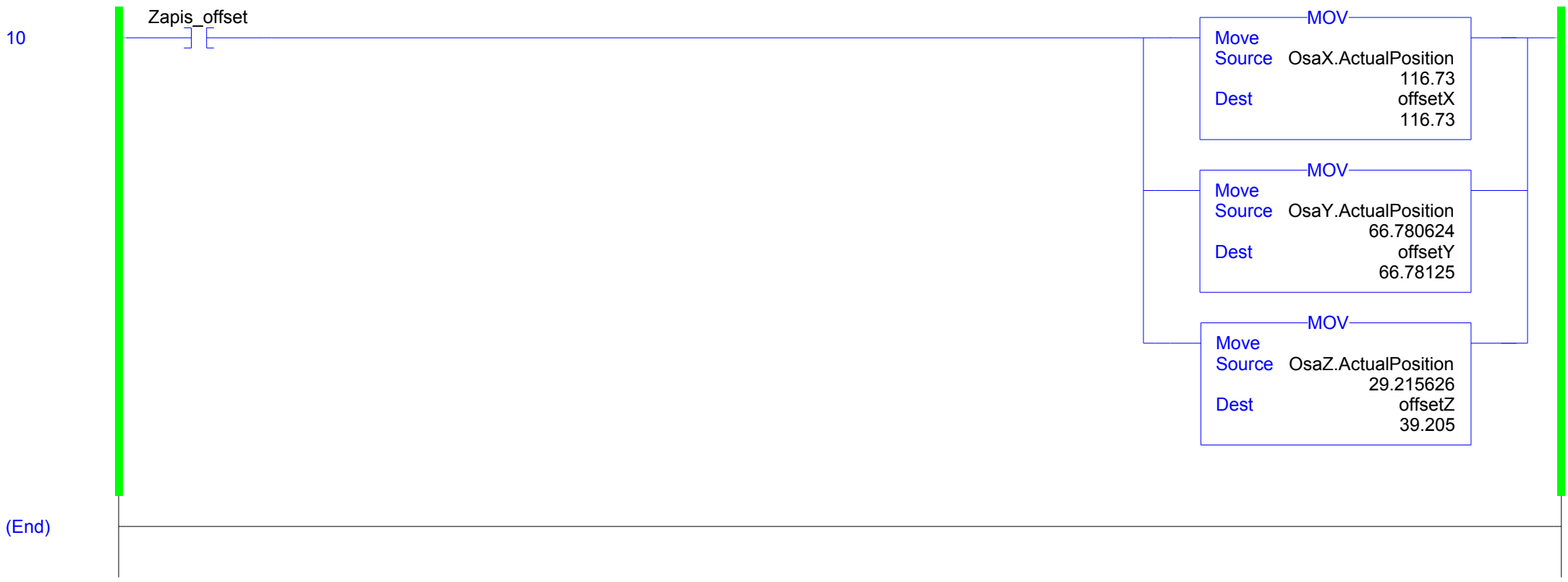
y_MI_MAS.ER

MSF
Motion Servo Off
Axis OsaX
Motion Control x_MI_MSF[0]

MSF
Motion Servo Off
Axis OsaY
Motion Control y_MI_MSF[0]

MSF
Motion Servo Off
Axis OsaZ
Motion Control z_MI_MSF[0]

EN DN ER


10
Zapis_offset
MOV
Move
Source OsaX.ActualPosition
116.73
Dest offsetX
116.73
MOV
Move
Source OsaY.ActualPosition
66.780624
Dest offsetY
66.78125
MOV
Move
Source OsaZ.ActualPosition
29.215626
Dest offsetZ
39.205
(End)

0 Alarm_DATA_reset.ENABLE (L)

1 Alarm_DATA_reset.RESET (L)

2

COP
Copy File
Source Alarm_DATA_reset
Dest Chyba_vykonavani_inst_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest Program_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest Vreteno_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest XHome_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest XChyba_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest Xpres_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest YHome_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest YChyba_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest Ypres_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest ZHome_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest ZChyba_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest Zpres_ALARM
Length 1

3 Alarm_DATA_reset.RESET (U)

4

COP
Copy File
Source Alarm_DATA_reset
Dest Chyba_vykonavani_inst_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest Program_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest Vreteno_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest XHome_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest XChyba_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest Xpres_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest YHome_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest YChyba_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest Ypres_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest ZHome_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest ZChyba_ALARM
Length 1

COP
Copy File
Source Alarm_DATA_reset
Dest Zpres_ALARM
Length 1

(End)

0 ethernet2:8:I.Data.0 <ethernet2:I.Slot[8].Data.0> — Reset_OS

1 ethernet2:8:I.Data.1 <ethernet2:I.Slot[8].Data.1> — Zapnuti_os

2 ethernet2:8:I.Data.2 <ethernet2:I.Slot[8].Data.2> — Kalibrace_OS

3 ethernet2:8:I.Data.3 <ethernet2:I.Slot[8].Data.3> — RUCNI_pohyb

4 — Programovani (U)

5 ethernet2:8:I.Data.5 <ethernet2:I.Slot[8].Data.5> — Automatika_ZAP

6 ethernet2:8:I.Data.6 <ethernet2:I.Slot[8].Data.6> — Reset_AUTOMATIKA

7 ethernet2:8:I.Data.7 <ethernet2:I.Slot[8].Data.7> — KONTROLA_programu

8 ethernet2:8:I.Data.8 <ethernet2:I.Slot[8].Data.8> — xJOGplus

9 ethernet2:8:I.Data.9 <ethernet2:I.Slot[8].Data.9> — xJOGminus

10 ethernet2:8:I.Data.10 <ethernet2:I.Slot[8].Data.10> — yJOGplus

11 ethernet2:8:I.Data.11 <ethernet2:I.Slot[8].Data.11> — yJOGminus

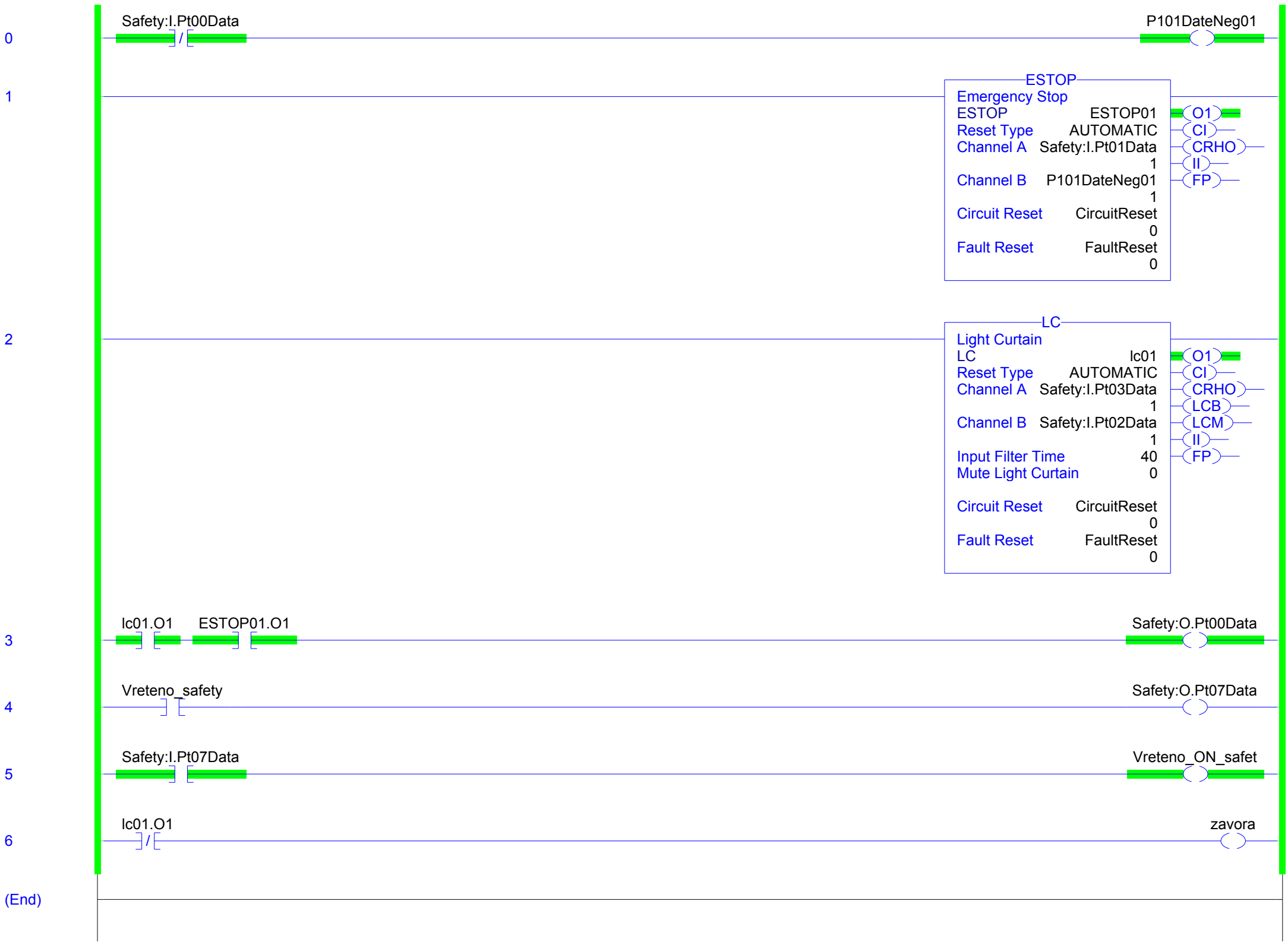
12 ethernet2:8:I.Data.12 <ethernet2:I.Slot[8].Data.12> — zJOGplus

13 ethernet2:8:I.Data.13 <ethernet2:I.Slot[8].Data.13> — zJOGminus

14 ethernet2:8:I.Data.14 <ethernet2:I.Slot[8].Data.14> — STOP_Program

15 ethernet2:8:I.Data.15 <ethernet2:I.Slot[8].Data.15> — Vypnuti_OS

(End)


0
Safety:I.Pt00Data
P101DateNeg01
1
ESTOP
Emergency Stop
ESTOP ESTOP01
Reset Type AUTOMATIC
Channel A Safety:I.Pt01Data
1
Channel B P101DateNeg01
1
Circuit Reset CircuitReset
0
Fault Reset FaultReset
0
O1
CI
CRHO
II
FP
2
LC
Light Curtain
LC lc01
Reset Type AUTOMATIC
Channel A Safety:I.Pt03Data
1
Channel B Safety:I.Pt02Data
1
Input Filter Time 40
Mute Light Curtain 0
Circuit Reset CircuitReset
0
Fault Reset FaultReset
0
O1
CI
CRHO
LCB
LCM
II
FP
3
lc01.O1
ESTOP01.O1
Safety:O.Pt00Data
4
Vreteno_safety
Safety:O.Pt07Data
5
Safety:I.Pt07Data
Vreteno_ON_safet
6
lc01.O1
zavora
(End)

Data type Name: Alarm_DATA

Description:

Size: 4 byte(s)

Name	Data Type	Style	Description
ACK	BOOL	Decimal	
RESET	BOOL	Decimal	
DISABLE	BOOL	Decimal	
ENABLE	BOOL	Decimal	

Data type Name: manual

Description:

Size: 20 byte(s)

Name	Data Type	Style	Description
HOME	BOOL	Decimal	
ACCEL	REAL	Float	
DECCEL	REAL	Float	
LEFT	BOOL	Decimal	
RIGHT	BOOL	Decimal	
SPEED	REAL	Float	

Data type Name: softovertravel

Description:

Size: 104 byte(s)

Name	Data Type	Style	Description
ClearSoftBits	DINT	Decimal	
⊞ MAJ_OFF_SOT	MOTION_INSTRUCTION		
⊞ MAS	MOTION_INSTRUCTION[2]		
⊞ MASR	MOTION_INSTRUCTION		
⊞ MSO	MOTION_INSTRUCTION		
NegMemory	BOOL	Decimal	
Ok_to_override	BOOL	Decimal	
OvertravelResetState	DINT	Decimal	
PosMemory	BOOL	Decimal	
SavedConfigFaults	DINT	Decimal	
SetSoft	DINT	Decimal	

Data type Name: STRING

Description:

Size: 88 byte(s)

Name	Data Type	Style	Description
LEN	DINT	Decimal	
DATA	SINT[82]	ASCII	