

### Příloha č.3 Zdrojový kód zdění

```
&ACCESS RVO
&REL 178
&PARAM EDITMASK = *
&PARAM TEMPLATE = C:\KRC\Roboter\Template\vorgabe
&PARAM DISKPATH = KRC:\R1\Program\TACR\_Faze_2_Zdeni_na_vazbu
DEF Predvadeni_Zdeni()
  DECL REAL rVelPTP

  rVelPTP = 30.0

  $ADVANCE = 3

  ;FOLD PTP HOME14 Vel=2 % DEFAULT Tool[14]:Grip changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:HOME14,
3:, 5:2, 7:DEFAULT
  $BWDSTART=FALSE
  PDAT_ACT=PDEFAULT
  FDAT_ACT=FHOME14
  BAS(#PTP_PARAMS,rVelPTP)
  PTP XHOME14
;ENDFOLD

  ; Vypnutí dmychadla
  ;FOLD OUT 28 'Vystup 220V - KV 2 - Dmych' State=FALSE ;{%PE}%R
8.3.44,%MKUKATPBASIS,%COUT,%VOUTX,%P 2:28, 3:Vystup 220V - KV 2 - Dmych,
5:FALSE,
6:
  $OUT[28]=FALSE
;ENDFOLD
  ;FOLD OUT 22 'Vystup Ventil Dmychadlo ON' State=TRUE ;{%PE}%R
8.3.44,%MKUKATPBASIS,%COUT,%VOUTX,%P 2:22, 3:Vystup Ventil Dmychadlo ON,
5:TRUE,
6:
  $OUT[22]=FALSE
;ENDFOLD

takeGripVakuum()

Predvadeni_vazba(1,8,1,1)
Predvadeni_vazba(1,8,1,2)
Predvadeni_vazba(1,8,1,3)
Predvadeni_vazba(1,8,1,4)

Predvadeni_vazba(2,7,2,1)
Predvadeni_vazba(2,7,2,2)
Predvadeni_vazba(2,7,2,3)
Predvadeni_vazba(2,7,2,4)

Predvadeni_vazba(3,6,1,1)
Predvadeni_vazba(3,6,1,2)
Predvadeni_vazba(3,6,1,3)
Predvadeni_vazba(3,6,1,4)

Predvadeni_vazba(4,5,2,1)
Predvadeni_vazba(4,5,2,2)
Predvadeni_vazba(4,5,2,3)
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Predvadeni_vazba(4,5,2,4)

Predvadeni_vazba(5,4,1,1)
Predvadeni_vazba(5,4,1,2)
Predvadeni_vazba(5,4,1,3)
Predvadeni_vazba(5,4,1,4)

Predvadeni_vazba(6,3,2,1)
Predvadeni_vazba(6,3,2,2)
Predvadeni_vazba(6,3,2,3)
Predvadeni_vazba(6,3,2,4)

Predvadeni_vazba(7,2,1,1)
Predvadeni_vazba(7,2,1,2)
Predvadeni_vazba(7,2,1,3)
Predvadeni_vazba(7,2,1,4)

Predvadeni_vazba(8,1,2,1)
Predvadeni_vazba(8,1,2,2)
Predvadeni_vazba(8,1,2,3)
Predvadeni_vazba(8,1,2,4)

giveGripVakuum()

; Vypnuti dmychadla
;FOLD OUT 28 'Vystup 220V - KV 2 - Dmych' State=FALSE ;%{PE}%R
8.3.44,%MKUKATPBASIS,%COUT,%VOUTX,%P 2:28, 3:Vystup 220V - KV 2 - Dmych,
5:FALSE,
6:
$OUT[28]=FALSE
;ENDFOLD
;FOLD OUT 22 'Vystup Ventil Dmychadlo ON' State=TRUE ;%{PE}%R
8.3.44,%MKUKATPBASIS,%COUT,%VOUTX,%P 2:22, 3:Vystup Ventil Dmychadlo ON,
5:TRUE,
6:
$OUT[22]=FALSE
;ENDFOLD

;FOLD PTP HOME14 Vel=2 % DEFAULT Tool[14]:Grip changable
Base[1]:Plocha001;%{PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:HOME14,
3:, 5:2, 7:DEFAULT
$BWDSTART=FALSE
PDAT_ACT=PDEFAULT
FDAT_ACT=FHOME14
BAS(#PTP_PARAMS,rVelPTP)
PTP XHOME14
;ENDFOLD

END

DEF Vycentrovani_Prisku()

DECL REAL rVelPTP,rVelLIN

rVelPTP = 30.0
rVelLIN = 0.6

```

```
;FOLD PTP vycentrovaniOkZhod4 CONT Vel=100 % PDAT38 Tool[1]:Nastroj001
Base[0];{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:vycentrovaniOkZhod4, 3:C_DIS, 5:100, 7:PDAT38
$BWDSTART=FALSE
PDAT_ACT=PPDAT38
FDAT_ACT=FvycentrovaniOkZhod4
BAS(#PTP_PARAMS,rVelPTP)
PTP XvycentrovaniOkZhod4 C_DIS
;ENDFOLD
```

```
;FOLD PTP vycentrovaniOkZhod3 CONT Vel=100 % PDAT37 Tool[1]:Nastroj001
Base[0];{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:vycentrovaniOkZhod3, 3:C_DIS, 5:100, 7:PDAT37
$BWDSTART=FALSE
PDAT_ACT=PPDAT37
FDAT_ACT=FvycentrovaniOkZhod3
BAS(#PTP_PARAMS,rVelPTP)
PTP XvycentrovaniOkZhod3 C_DIS
;ENDFOLD
```

```
;FOLD PTP vycentrovaniOkZhod2 CONT Vel=100 % PDAT36 Tool[1]:Nastroj001
Base[0];{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:vycentrovaniOkZhod2, 3:C_DIS, 5:100, 7:PDAT36
$BWDSTART=FALSE
PDAT_ACT=PPDAT36
FDAT_ACT=FvycentrovaniOkZhod2
BAS(#PTP_PARAMS,rVelPTP)
PTP XvycentrovaniOkZhod2 C_DIS
;ENDFOLD
```

```
;FOLD LIN vycentrovaniOkZhod CONT Vel=2 m/s CPDAT36 Tool[1]:Nastroj001
Base[0];{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN,
2:vycentrovaniOkZhod,
3:C_DIS C_DIS, 5:2, 7:CPDAT36
$BWDSTART=FALSE
LDAT_ACT=LCPDAT36
FDAT_ACT=FvycentrovaniOkZhod
BAS(#CP_PARAMS,rVelLIN)
LIN XvycentrovaniOkZhod C_DIS C_DIS
;ENDFOLD
```

```
; Vypnuti dmychadla
;FOLD OUT 28 'Vystup 220V - KV 2 - Dmych' State=FALSE ;{%PE}%R
8.3.44,%MKUKATPBASIS,%COUT,%VOUTX,%P 2:28, 3:Vystup 220V - KV 2 - Dmych,
5:FALSE,
6:
$OUT[28]=FALSE
;ENDFOLD
;FOLD OUT 22 'Vystup Ventil Dmychadlo ON' State=TRUE ;{%PE}%R
8.3.44,%MKUKATPBASIS,%COUT,%VOUTX,%P 2:22, 3:Vystup Ventil Dmychadlo ON,
5:TRUE,
6:
$OUT[22]=TRUE
;ENDFOLD
;FOLD WAIT Time=2 sec;{%PE}%R 8.3.44,%MKUKATPBASIS,%CWAIT,%VWAIT,%P
3:2
WAIT SEC 4
;ENDFOLD
```

```
;FOLD LIN vycentrovaniOkZhod6 CONT Vel=2 m/s CPDAT36 Tool[1]:Nastroj001
Base[0];%{PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN,
2:vycentrovaniOkZhod6,
3:C_DIS C_DIS, 5:2, 7:CPDAT36
$BWDSTART=FALSE
LDAT_ACT=LCPDAT36
FDAT_ACT=FvycentrovaniOkZhod6
BAS(#CP_PARAMS,2)
LIN XvycentrovaniOkZhod6 C_DIS C_DIS
;ENDFOLD
```

```
;FOLD LIN vycentrovaniOkOdeber CONT Vel=2 m/s CPDAT35
Tool[1]:Nastroj001
Base[0];%{PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN,
2:vycentrovaniOkOdeber, 3:C_DIS C_DIS, 5:2, 7:CPDAT35
$BWDSTART=FALSE
LDAT_ACT=LCPDAT35
FDAT_ACT=FvycentrovaniOkOdeber
BAS(#CP_PARAMS,rVelLIN)
LIN XvycentrovaniOkOdeber C_DIS C_DIS
;ENDFOLD
```

```
;FOLD LIN vycentrovaniOk CONT Vel=2 m/s CPDAT34 Tool[1]:Nastroj001
Base[0];%{PE}%R
8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN, 2:vycentrovaniOk, 3:C_DIS
C_DIS, 5:2,
7:CPDAT34
$BWDSTART=FALSE
LDAT_ACT=LCPDAT34
FDAT_ACT=FvycentrovaniOk
BAS(#CP_PARAMS,rVelLIN)
LIN XvycentrovaniOk C_DIS C_DIS
;ENDFOLD
```

```
; Zapnuti dmychadla
;FOLD OUT 22 'Vystup Ventil Dmychadlo ON' State=FALSE ;%{PE}%R
8.3.44,%MKUKATPBASIS,%COUT,%VOUTX,%P 2:22, 3:Vystup Ventil Dmychadlo ON,
5:FALSE,
6:
$OUT[22]=FALSE
;ENDFOLD
;FOLD OUT 28 'Vystup 220V - KV 2 - Dmych' State=TRUE ;%{PE}%R
8.3.44,%MKUKATPBASIS,%COUT,%VOUTX,%P 2:28, 3:Vystup 220V - KV 2 - Dmych,
5:TRUE,
6:
$OUT[28]=TRUE
;ENDFOLD
;FOLD WAIT Time=3 sec;%{PE}%R 8.3.44,%MKUKATPBASIS,%CWAIT,%VWAIT,%P
3:3
WAIT SEC 3
;ENDFOLD
```

```
;FOLD LIN vycentrovaniOkOdeber CONT Vel=2 m/s CPDAT35
Tool[1]:Nastroj001
Base[0];%{PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN,
2:vycentrovaniOkOdeber, 3:C_DIS C_DIS, 5:2, 7:CPDAT35
$BWDSTART=FALSE
LDAT_ACT=LCPDAT35
FDAT_ACT=FvycentrovaniOkOdeber
BAS(#CP_PARAMS,rVelLIN)
```

```

LIN XvycentrovaniOkOdeber C_DIS C_DIS
;ENDFOLD
;FOLD PTP vycentrovaniOkZhod3 CONT Vel=100 % PDAT37 Tool[1]:Nastroj001
Base[0];%{PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:vycentrovaniOkZhod3, 3:C_DIS, 5:100, 7:PDAT37
$BWDSTART=FALSE
PDAT_ACT=PPDAT37
FDAT_ACT=FvycentrovaniOkZhod3
BAS(#PTP_PARAMS,rVelPTP)
PTP XvycentrovaniOkZhod3 C_DIS
;ENDFOLD
;FOLD PTP vycentrovaniOkZhod4 CONT Vel=100 % PDAT38 Tool[1]:Nastroj001
Base[0];%{PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:vycentrovaniOkZhod4, 3:C_DIS, 5:100, 7:PDAT38
$BWDSTART=FALSE
PDAT_ACT=PPDAT38
FDAT_ACT=FvycentrovaniOkZhod4
BAS(#PTP_PARAMS,rVelPTP)
PTP XvycentrovaniOkZhod4 C_DIS
;ENDFOLD

```

END

```

DEF Predvadeni_vazba(stenaCihla: IN, paletaCihla: IN, LichaSuda: IN,
poradiPrvku: IN)

```

```

DECL INT stenaCihla,paletaCihla,LichaSuda,poradiPrvku
DECL INT stena_objektu
DECL REAL rVelPTP, rVelLIN,rVelLIN2
DECL REAL vyskaCihly,vyskaRady,vyskaRadyPalety

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```

DECL REAL sirkaCihly, delkaCihly, delkaOrez

```

```

DECL REAL pracovniZ,pracovniZPrvek

```

```

DECL REAL umisteniPaletyX, umisteniPaletyY
DECL REAL umisteniCihlyX_1, umisteniCihlyY_1
DECL REAL umisteniCihlyX_2, umisteniCihlyY_2
DECL REAL umisteniCihlyX_3, umisteniCihlyY_3

```

```

DECL REAL odstupNadCihlou, odstupVedleCihly
DECL REAL odstupNadCihlouZdeni, odstupVedleCihlyZdeni

```

```

DECL REAL vyskaPrisavky

```

```

DECL REAL pritlak_x, pritlak_y, pritlak_z

```

```

; rychlost pohybu robota
rVelPTP = 30.0
rVelLIN = 0.6
rVelLIN2 = 0.2

```

```

; nastaveni predstihu
$ADVANCE = 3

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```

; parametry zdicich prvku
vyskaCihly = 50.0
sirkaCihly = 200.0

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delkaCihly = 500.0
delkaOrez = 310.0

; umisteni stredy prvnioho prvku na palete
umisteniPaletyX = 1400.0
umisteniPaletyY = 53.2858315

; umisteni objektu sten

; Stena 1: 2 objekty
umisteniCihlyX_1 = 220.15
umisteniCihlyY_1 = 33.39

; Stena 2: 1 objekt
umisteniCihlyX_2 = 70.015
umisteniCihlyY_2 = 383.39

; Stena 3: 1 objekt (posledni prvek za patou robota)

umisteniCihlyX_3 = 70.015
umisteniCihlyY_3 = 883.39

; Parametry prisavky
vyskaPrisavky = 156.0

; nastaveni vysky rady
vyskaRadyPalety = (paletaCihla * vyskaCihly) + vyskaPrisavky
vyskaRady = (stenaCihla * vyskaCihly) + vyskaPrisavky

; nad paletou
odstupNadCihlou = 50.0
odstupVedleCihly = 50.0

; parametry zdeni
odstupNadCihlouZdeni = 50.0
odstupVedleCihlyZdeni = 50.0

; *****
; proces odebrani prvku y palety
; *****

; Pohybova instrukce k palete

;FOLD PTP HOME14 Vel=2 % DEFAULT Tool[14]:Grip changable
Base[1]:Plocha001;%{PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:HOME14,
3:, 5:2, 7:DEFAULT
    $BWDSTART=FALSE
    PDAT_ACT=PDEFAULT
    FDAT_ACT=FHOME14
    BAS(#PTP_PARAMS,rVelPTP)
    PTP XHOME14 C_DIS
;ENDFOLD

; bezpecni vyskova hladina
pracovniZ = 770.0

; nulta hladina + aktualni vyska palety

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pracovniZPrvek = vyskaRadyPalety

; souradnice sloupu palety
Xpaleta_1_sloupec.X = umisteniPaletyX
Xpaleta_1_sloupec.Y = umisteniPaletyY + sirkaCihly * (poradiPrvku-1)

; hruby dojezd nad sloupec palety

Xpaleta_1_sloupec.Z = pracovniZ

;FOLD PTP paleta_1_sloupec CONT Vel=100 % PDAT31 Tool[14]:Grip
changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:paleta_1_sloupec, 3:C_DIS, 5:100, 7:PDAT31
$BWDSTART=FALSE
PDAT_ACT=PPDAT31
FDAT_ACT=Fpaleta_1_sloupec
BAS(#PTP_PARAMS,rVelPTP)
PTP Xpaleta_1_sloupec C_DIS
;ENDFOLD

; presny dojezd nad sloupec palety
Xpaleta_1_sloupec_presne.X = Xpaleta_1_sloupec.X
Xpaleta_1_sloupec_presne.Y = Xpaleta_1_sloupec.Y
Xpaleta_1_sloupec_presne.Z = pracovniZPrvek

;FOLD LIN paleta_1_sloupec_presne CONT Vel=2 m/s CPDAT31 Tool[14]:Grip
changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN,
2:paleta_1_sloupec_presne, 3:C_DIS C_DIS, 5:2, 7:CPDAT31
$BWDSTART=FALSE
LDAT_ACT=LCPDAT31
FDAT_ACT=Fpaleta_1_sloupec_presne
BAS(#CP_PARAMS,rVelLIN)
LIN Xpaleta_1_sloupec_presne C_DIS C_DIS
;ENDFOLD

; Zapnuti dmychadla
;FOLD OUT 22 'Vystup Ventil Dmychadlo ON' State=FALSE ;{%PE}%R
8.3.44,%MKUKATPBASIS,%COUT,%VOUTX,%P 2:22, 3:Vystup Ventil Dmychadlo ON,
5:FALSE,
6:
$OUT[22]=FALSE
;ENDFOLD
;FOLD OUT 28 'Vystup 220V - KV 2 - Dmych' State=TRUE ;{%PE}%R
8.3.44,%MKUKATPBASIS,%COUT,%VOUTX,%P 2:28, 3:Vystup 220V - KV 2 - Dmych,
5:TRUE,
6:
$OUT[28]=TRUE
;ENDFOLD
;FOLD WAIT Time=3 sec;{%PE}%R 8.3.44,%MKUKATPBASIS,%CWAIT,%VWAIT,%P
3:3
WAIT SEC 3
;ENDFOLD

; Nadzvednuti cihly

Xpaleta_1_sloupec_presne.X = Xpaleta_1_sloupec.X
Xpaleta_1_sloupec_presne.Y = Xpaleta_1_sloupec.Y - odstupVedleCihly
Xpaleta_1_sloupec_presne.Z = pracovniZPrvek + odstupNadCihlou

```

```

;FOLD LIN paleta_1_sloupec_presne CONT Vel=2 m/s CPDAT31 Tool[14]:Grip
changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN,
2:paleta_1_sloupec_presne, 3:C_DIS C_DIS, 5:2, 7:CPDAT31
$BWDSTART=FALSE
LDAT_ACT=LCPDAT31
FDAT_ACT=Fpaleta_1_sloupec_presne
BAS(#CP_PARAMS,rVelLIN)
LIN Xpaleta_1_sloupec_presne C_DIS C_DIS
;ENDFOLD

```

```

Xpaleta_1_sloupec.X = umisteniPaletyX
Xpaleta_1_sloupec.Y = umisteniPaletyY + sirkaCihly * (poradiPrvku-1)
Xpaleta_1_sloupec.Z = pracovniZ

```

```

;FOLD PTP paleta_1_sloupec CONT Vel=100 % PDAT31 Tool[14]:Grip
changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:paleta_1_sloupec, 3:C_DIS, 5:100, 7:PDAT31
$BWDSTART=FALSE
PDAT_ACT=PPDAT31
FDAT_ACT=Fpaleta_1_sloupec
BAS(#PTP_PARAMS,rVelPTP)
PTP Xpaleta_1_sloupec C_DIS
;ENDFOLD

```

```

;FOLD PTP HOME14 Vel=2 % DEFAULT Tool[14]:Grip changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:HOME14,
3:, 5:2, 7:DEFAULT
$BWDSTART=FALSE
PDAT_ACT=PDEFAULT
FDAT_ACT=FHOME14
BAS(#PTP_PARAMS,rVelPTP)
PTP XHOME14 C_DIS
;ENDFOLD

```

```

; *****
; proces umisteni cihly
; *****

```

```

; Licha Rada
IF LichaSuda == 1 THEN
; Prvni prvek objektu
IF (poradiPrvku == 1) THEN
stena_objektu = 1
pritlak_x = 0
pritlak_y = 0
pritlak_z = odstupNadCihlouZdeni
ENDIF

; Druhy prvek objektu
IF (poradiPrvku == 2) THEN
stena_objektu = 1
pritlak_x = odstupVedleCihlyZdeni
pritlak_y = 0

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    pritlak_z = odstupNadCihlouZdeni
ENDIF

; Treti prvek objektu
IF (poradiPrvku == 3) THEN
    stena_objektu = 2
    pritlak_x = 0
    pritlak_y = odstupVedleCihlyZdeni
    pritlak_z = odstupNadCihlouZdeni
ENDIF

; Ctvrtý prvek objektu
IF (poradiPrvku == 4) THEN
    stena_objektu = 3
    pritlak_x = 0
    pritlak_y = odstupVedleCihlyZdeni
    pritlak_z = odstupNadCihlouZdeni
ENDIF
ENDIF

; Suda Rada
IF LichaSuda == 2 THEN
    ; Prvni prvek objektu
    IF (poradiPrvku == 1) THEN
        stena_objektu = 2
        pritlak_x = 0
        pritlak_y = 0
        pritlak_z = odstupNadCihlouZdeni
    ENDIF

    ; Druhy prvek objektu
    IF (poradiPrvku == 2) THEN
        stena_objektu = 3
        pritlak_x = 0
        pritlak_y = odstupVedleCihlyZdeni
        pritlak_z = odstupNadCihlouZdeni
    ENDIF

    ; Treti prvek objektu
    IF (poradiPrvku == 3) THEN
        stena_objektu = 1
        pritlak_x = odstupVedleCihlyZdeni
        pritlak_y = 0
        pritlak_z = odstupNadCihlouZdeni
    ENDIF

    ; Ctvrtý prvek objektu
    IF (poradiPrvku == 4) THEN
        stena_objektu = 1
        pritlak_x = odstupVedleCihlyZdeni
        pritlak_y = 0
        pritlak_z = odstupNadCihlouZdeni
    ENDIF
ENDIF

IF (stena_objektu == 1) THEN

    ; licha - 1
    IF (poradiPrvku == 1) THEN
        Xobjekt_stena_1.X = umisteniCihlyX_1
        Xobjekt_stena_1.Y = umisteniCihlyY_1
    ENDIF
ENDIF

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        Xobjekt_stena_1.Z = pracovniZ
ENDIF
; licha - 2
IF (poradiPrvku == 2) THEN
    Xobjekt_stena_1.X = umisteniCihlyX_1 + delkaCihly + 3
    Xobjekt_stena_1.Y = umisteniCihlyY_1 + 9
    Xobjekt_stena_1.Z = pracovniZ
ENDIF
; suda 3
IF (poradiPrvku == 3) THEN
    Xobjekt_stena_1.X = umisteniCihlyX_1 + sirkaCihly + 3
    Xobjekt_stena_1.Y = umisteniCihlyY_1 + 3
    Xobjekt_stena_1.Z = pracovniZ
ENDIF

; suda 4
IF (poradiPrvku == 4) THEN
6 - 2    Xobjekt_stena_1.X = umisteniCihlyX_1 + sirkaCihly + delkaOrez +
        Xobjekt_stena_1.Y = umisteniCihlyY_1 + 8
        Xobjekt_stena_1.Z = pracovniZ
ENDIF

; Hrubá pohybová instrukce k objektu
;!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!

Vycentrovani_Prvku()

;FOLD PTP objekt_stena_1 CONT Vel=100 % PDAT32 Tool[14]:Grip
changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:objekt_stena_1, 3:C_DIS, 5:100, 7:PDAT32
$BWDSTART=FALSE
PDAT_ACT=PPDAT32
FDAT_ACT=Fobjekt_stena_1
BAS(#PTP_PARAMS,rVelPTP)
PTP Xobjekt_stena_1 C_DIS
;ENDFOLD

; Presná pohybová instrukce k objektu
;!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!
Xobjekt_stena_1_presna.X = Xobjekt_stena_1.X + pritlak_x
Xobjekt_stena_1_presna.Y = Xobjekt_stena_1.Y + pritlak_y
Xobjekt_stena_1_presna.Z = vyskaRady + pritlak_z

;FOLD LIN objekt_stena_1_presna CONT Vel=2 m/s CPDAT30
Tool[14]:Grip changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN,
2:objekt_stena_1_presna, 3:C_DIS C_DIS, 5:2, 7:CPDAT30
$BWDSTART=FALSE
LDAT_ACT=LCPDAT30
FDAT_ACT=Fobjekt_stena_1_presna
BAS(#CP_PARAMS,rVelLIN)
LIN Xobjekt_stena_1_presna C_DIS C_DIS
;ENDFOLD

; Dotlačení cihly
;!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!
Xobjekt_stena_1_presna.X = Xobjekt_stena_1.X
Xobjekt_stena_1_presna.Y = Xobjekt_stena_1.Y
Xobjekt_stena_1_presna.Z = vyskaRady

```

```

;FOLD LIN objekt_stena_1_presna CONT Vel=2 m/s CPDAT30
Tool[14]:Grip changable
Base[1]:Plocha001;%{PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN,
2:objekt_stena_1_presna, 3:C_DIS C_DIS, 5:2, 7:CPDAT30
$BWDSTART=FALSE
LDAT_ACT=LCPDAT30
FDAT_ACT=Fobjekt_stena_1_presna
BAS(#CP_PARAMS,rVelLIN2)
LIN Xobjekt_stena_1_presna C_DIS C_DIS
;ENDFOLD

```

ENDIF

IF (stena\_objektu == 2) THEN

```

; suda - 1
IF (poradiPrvku == 1) THEN
  Xobjekt_stena_2.X = umisteniCihlyX_2 + 2
  Xobjekt_stena_2.Y = umisteniCihlyY_2 - sirkaCihly
  Xobjekt_stena_2.Z = pracovniZ
ENDIF

```

```

; licha - 3
IF (poradiPrvku == 3) THEN
  Xobjekt_stena_2.X = umisteniCihlyX_2 - 2
  Xobjekt_stena_2.Y = umisteniCihlyY_2 + 2
  Xobjekt_stena_2.Z = pracovniZ
ENDIF

```

```

; Hrubá pohybová instrukce k objektu
;;;;;;;;;;;;;

```

Vycentrovani\_Pravku()

```

;FOLD PTP objekt_stena_2 CONT Vel=100 % PDAT40 Tool[14]:Grip
changable
Base[1]:Plocha001;%{PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:objekt_stena_2, 3:C_DIS, 5:100, 7:PDAT40
$BWDSTART=FALSE
PDAT_ACT=PPDAT40
FDAT_ACT=Fobjekt_stena_2
BAS(#PTP_PARAMS,rVelPTP)
PTP Xobjekt_stena_2 C_DIS
;ENDFOLD

```

```

; Presna pohybová instrukce k objektu
;;;;;;;;;;;;;
Xobjekt_stena_2_presna.X = Xobjekt_stena_2.X + pritlak_x
Xobjekt_stena_2_presna.Y = Xobjekt_stena_2.Y + pritlak_y
Xobjekt_stena_2_presna.Z = vyskaRady + pritlak_z

```

```

;FOLD LIN objekt_stena_2_presna CONT Vel=2 m/s CPDAT32
Tool[14]:Grip changable
Base[1]:Plocha001;%{PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN,
2:objekt_stena_2_presna, 3:C_DIS C_DIS, 5:2, 7:CPDAT32
$BWDSTART=FALSE
LDAT_ACT=LCPDAT32

```

```

FDAT_ACT=Fobjekt_stena_2_presna
BAS(#CP_PARAMS,rVelLIN)
LIN Xobjekt_stena_2_presna C_DIS C_DIS
;ENDFOLD

; Dotlaceni cihly
;;;;;;;;;;;;;
Xobjekt_stena_2_presna.X = Xobjekt_stena_2.X
Xobjekt_stena_2_presna.Y = Xobjekt_stena_2.Y
Xobjekt_stena_2_presna.Z = vyskaRady

;FOLD LIN objekt_stena_2_presna CONT Vel=2 m/s CPDAT32
Tool[14]:Grip changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN,
2:objekt_stena_2_presna, 3:C_DIS C_DIS, 5:2, 7:CPDAT32
$BWDSTART=FALSE
LDAT_ACT=LCPDAT32
FDAT_ACT=Fobjekt_stena_2_presna
BAS(#CP_PARAMS,rVelLIN2)
LIN Xobjekt_stena_2_presna C_DIS C_DIS
;ENDFOLD
ENDIF

IF (stena_objektu == 3) THEN

; suda 2
IF (poradiPrvku == 2) THEN
Xobjekt_stena_3.X = umisteniCihlyX_3 - 8
Xobjekt_stena_3.Y = umisteniCihlyY_3 - sirkaCihly + 2
Xobjekt_stena_3.Z = pracovniZ
ENDIF

; licha - 4
IF (poradiPrvku == 4) THEN
Xobjekt_stena_3.X = umisteniCihlyX_3 - 11
Xobjekt_stena_3.Y = umisteniCihlyY_3 + 6
Xobjekt_stena_3.Z = pracovniZ
ENDIF

; Hrubá pohybová instrukce k objektu
;;;;;;;;;;;;;

Vycentrovani_Prvku()

;FOLD PTP objekt_stena_3_0 CONT Vel=100 % PDAT40 Tool[14]:Grip changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:objekt_stena_3_0, 3:C_DIS, 5:100, 7:PDAT40
;$BWDSTART=FALSE
;PDAT_ACT=PPDAT40
;FDAT_ACT=Fobjekt_stena_3_0
;BAS(#PTP_PARAMS,rVelPTP)
;PTP Xobjekt_stena_3_0 C_DIS
;ENDFOLD

;FOLD PTP objekt_stena_3 CONT Vel=100 % PDAT41 Tool[14]:Grip
changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:objekt_stena_3, 3:C_DIS, 5:100, 7:PDAT41
$BWDSTART=FALSE
PDAT_ACT=PPDAT41

```

```

FDAT_ACT=Fobjekt_stena_3
BAS(#PTP_PARAMS,rVelPTP)
PTP Xobjekt_stena_3 C_DIS
;ENDFOLD

; Presna pohybova instrukce k objektu
;;;;;;;;;;;;;
Xobjekt_stena_3_presna.X = Xobjekt_stena_3.X + pritlak_x
Xobjekt_stena_3_presna.Y = Xobjekt_stena_3.Y + pritlak_y
Xobjekt_stena_3_presna.Z = vyskaRady + pritlak_z

;FOLD LIN objekt_stena_3_presna CONT Vel=2 m/s CPDAT33
Tool[14]:Grip changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN,
2:objekt_stena_3_presna, 3:C_DIS C_DIS, 5:2, 7:CPDAT33
$BWDSTART=FALSE
LDAT_ACT=LCPDAT33
FDAT_ACT=Fobjekt_stena_3_presna
BAS(#CP_PARAMS,rVelLIN)
LIN Xobjekt_stena_3_presna C_DIS C_DIS
;ENDFOLD

; Dotlaceni cihly
;;;;;;;;;;;;;
Xobjekt_stena_3_presna.X = Xobjekt_stena_3.X
Xobjekt_stena_3_presna.Y = Xobjekt_stena_3.Y
Xobjekt_stena_3_presna.Z = vyskaRady

;FOLD LIN objekt_stena_3_presna CONT Vel=2 m/s CPDAT33
Tool[14]:Grip changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN,
2:objekt_stena_3_presna, 3:C_DIS C_DIS, 5:2, 7:CPDAT33
$BWDSTART=FALSE
LDAT_ACT=LCPDAT33
FDAT_ACT=Fobjekt_stena_3_presna
BAS(#CP_PARAMS,rVelLIN2)
LIN Xobjekt_stena_3_presna C_DIS C_DIS
;ENDFOLD

ENDIF

; Vypnuti dmychadla
;FOLD OUT 28 'Vystup 220V - KV 2 - Dmych' State=FALSE ;{%PE}%R
8.3.44,%MKUKATPBASIS,%COUT,%VOUTX,%P 2:28, 3:Vystup 220V - KV 2 - Dmych,
5:FALSE,
6:
$OUT[28]=FALSE
;ENDFOLD
;FOLD OUT 22 'Vystup Ventil Dmychadlo ON' State=TRUE ;{%PE}%R
8.3.44,%MKUKATPBASIS,%COUT,%VOUTX,%P 2:22, 3:Vystup Ventil Dmychadlo ON,
5:TRUE,
6:
$OUT[22]=TRUE
;ENDFOLD
;FOLD WAIT Time=2 sec;{%PE}%R 8.3.44,%MKUKATPBASIS,%CWAIT,%VWAIT,%P
3:2
WAIT SEC 2
;ENDFOLD

```

```

; Zvednuti TCP nad objekt
IF (stena_objektu == 1) THEN
  Xobjekt_stena_1_presna.Z = vyskaRady + pritlak_z*2

  ;FOLD LIN objekt_stena_1_presna CONT Vel=2 m/s CPDAT30
Tool[14]:Grip changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN,
2:objekt_stena_1_presna, 3:C_DIS C_DIS, 5:2, 7:CPDAT30
  $BWDSTART=FALSE
  LDAT_ACT=LCPDAT30
  FDAT_ACT=Fobjekt_stena_1_presna
  BAS(#CP_PARAMS,rVelLIN)
  LIN Xobjekt_stena_1_presna C_DIS C_DIS
  ;ENDFOLD

  ;FOLD PTP objekt_stena_1 CONT Vel=100 % PDAT32 Tool[14]:Grip
changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:objekt_stena_1, 3:C_DIS, 5:100, 7:PDAT32
  $BWDSTART=FALSE
  PDAT_ACT=PPDAT32
  FDAT_ACT=Fobjekt_stena_1
  BAS(#PTP_PARAMS,rVelPTP)
  PTP Xobjekt_stena_1 C_DIS
  ;ENDFOLD

ENDIF

IF (stena_objektu == 2) THEN
  Xobjekt_stena_2_presna.Z = vyskaRady + pritlak_z*2

  ;FOLD LIN objekt_stena_2_presna CONT Vel=2 m/s CPDAT32
Tool[14]:Grip changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN,
2:objekt_stena_2_presna, 3:C_DIS C_DIS, 5:2, 7:CPDAT32
  $BWDSTART=FALSE
  LDAT_ACT=LCPDAT32
  FDAT_ACT=Fobjekt_stena_2_presna
  BAS(#CP_PARAMS,rVelLIN)
  LIN Xobjekt_stena_2_presna C_DIS C_DIS
  ;ENDFOLD

  ;FOLD PTP objekt_stena_2 CONT Vel=100 % PDAT33 Tool[14]:Grip
changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:objekt_stena_2, 3:C_DIS, 5:100, 7:PDAT33
  $BWDSTART=FALSE
  PDAT_ACT=PPDAT33
  FDAT_ACT=Fobjekt_stena_2
  BAS(#PTP_PARAMS,rVelPTP)
  PTP Xobjekt_stena_2 C_DIS
  ;ENDFOLD

ENDIF

IF (stena_objektu == 3) THEN
  Xobjekt_stena_3_presna.Z = vyskaRady + pritlak_z*2

```

```

;FOLD LIN objekt_stena_3_presna CONT Vel=2 m/s CPDAT33
Tool[14]:Grip changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VLIN,%P 1:LIN,
2:objekt_stena_3_presna, 3:C_DIS C_DIS, 5:2, 7:CPDAT33
$BWDSTART=FALSE
LDAT_ACT=LCPDAT33
FDAT_ACT=Fobjekt_stena_3_presna
BAS(#CP_PARAMS,rVelLIN)
LIN Xobjekt_stena_3_presna C_DIS C_DIS
;ENDFOLD

;FOLD PTP objekt_stena_3 CONT Vel=100 % PDAT42 Tool[14]:Grip
changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:objekt_stena_3, 3:C_DIS, 5:100, 7:PDAT42
$BWDSTART=FALSE
PDAT_ACT=PPDAT42
FDAT_ACT=Fobjekt_stena_3
BAS(#PTP_PARAMS,rVelPTP)
PTP Xobjekt_stena_3 C_DIS
;ENDFOLD
ENDIF

; Pohybova instrukce k home
;FOLD PTP HOME14 Vel=2 % DEFAULT Tool[14]:Grip changable
Base[1]:Plocha001;{%PE}%R 8.3.44,%MKUKATPBASIS,%CMOVE,%VPTP,%P 1:PTP,
2:HOME14,
3:., 5:2, 7:DEFAULT
$BWDSTART=FALSE
PDAT_ACT=PDEFAULT
FDAT_ACT=FHOME14
BAS(#PTP_PARAMS,rVelPTP)
PTP XHOME14 C_DIS
;ENDFOLD

; Vypnuti dmychadla
;FOLD OUT 28 'Vystup 220V - KV 2 - Dmych' State=FALSE ;{%PE}%R
8.3.44,%MKUKATPBASIS,%COUT,%VOUTX,%P 2:28, 3:Vystup 220V - KV 2 - Dmych,
5:FALSE,
6:
;$OUT[28]=FALSE
;ENDFOLD
;FOLD OUT 22 'Vystup Ventil Dmychadlo ON' State=TRUE ;{%PE}%R
8.3.44,%MKUKATPBASIS,%COUT,%VOUTX,%P 2:22, 3:Vystup Ventil Dmychadlo ON,
5:TRUE,
6:
;$OUT[22]=FALSE
;ENDFOLD

END

```