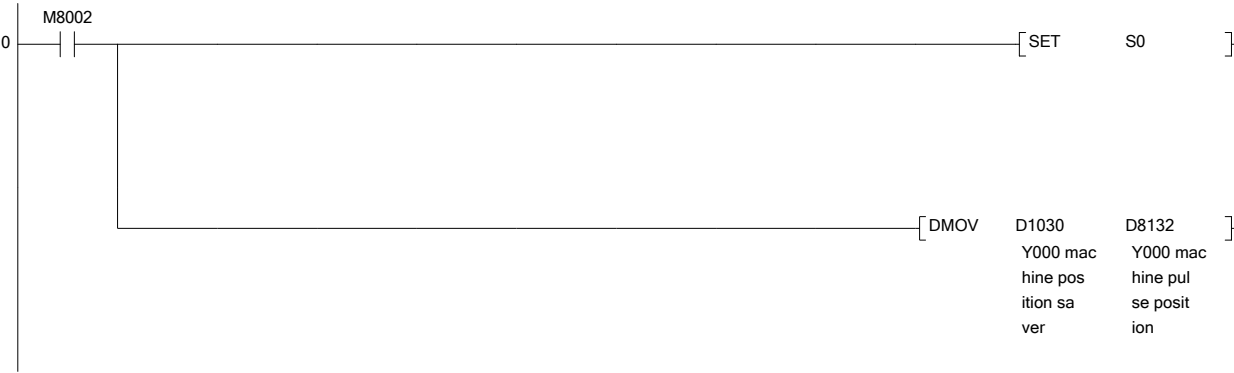
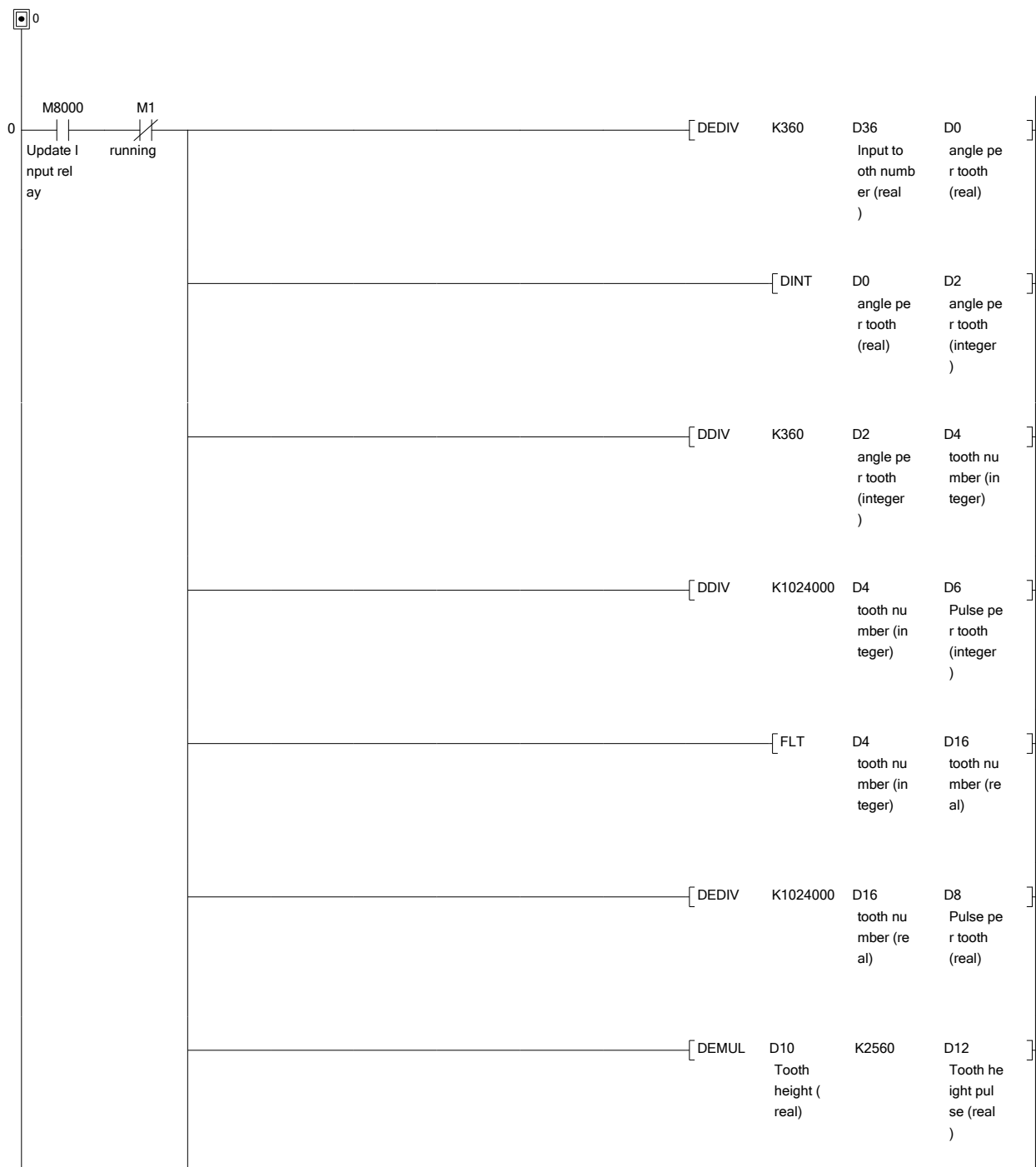


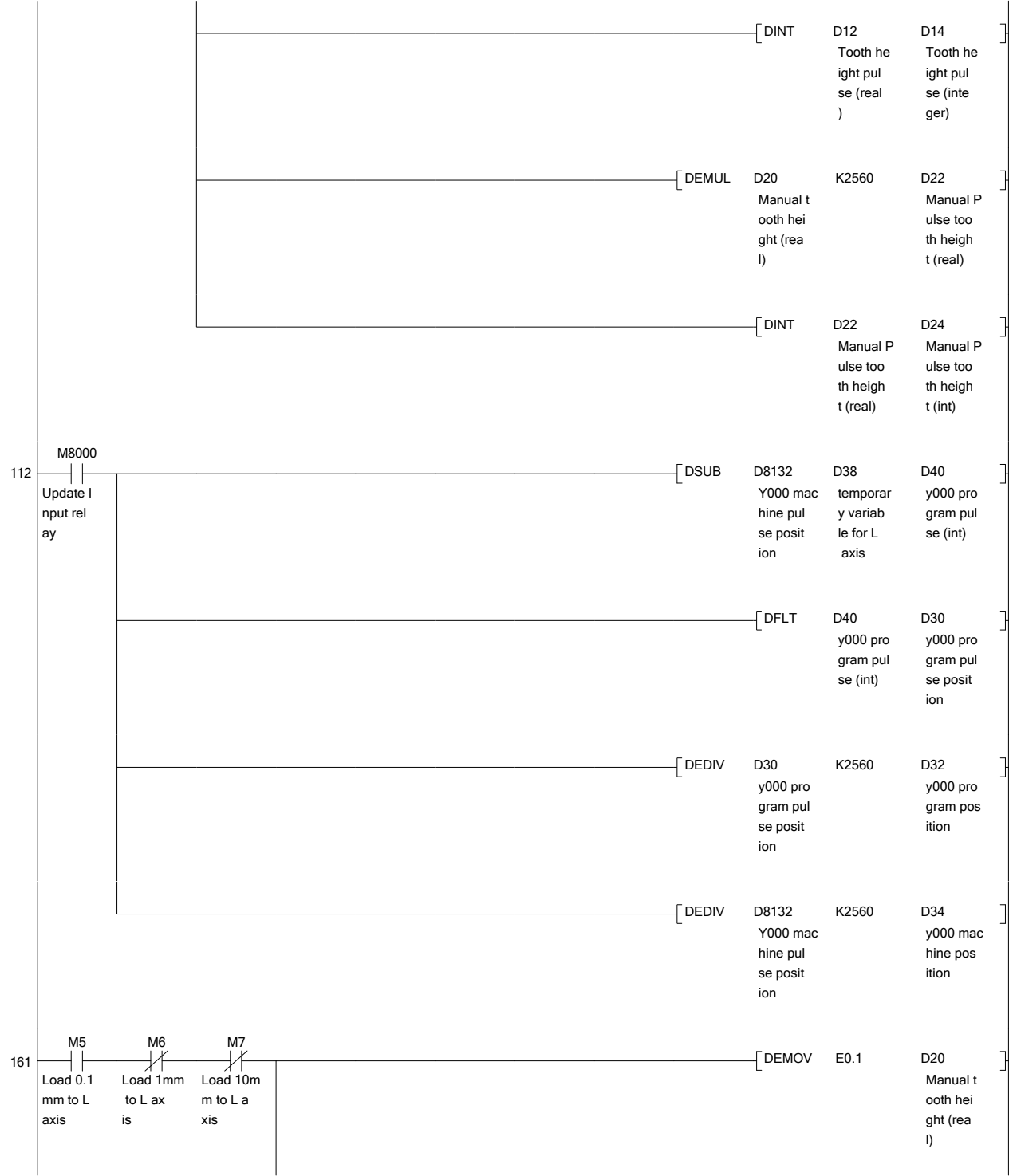
MELSAP3  
Data Name : MAIN  
SFC Block  
000:Block0

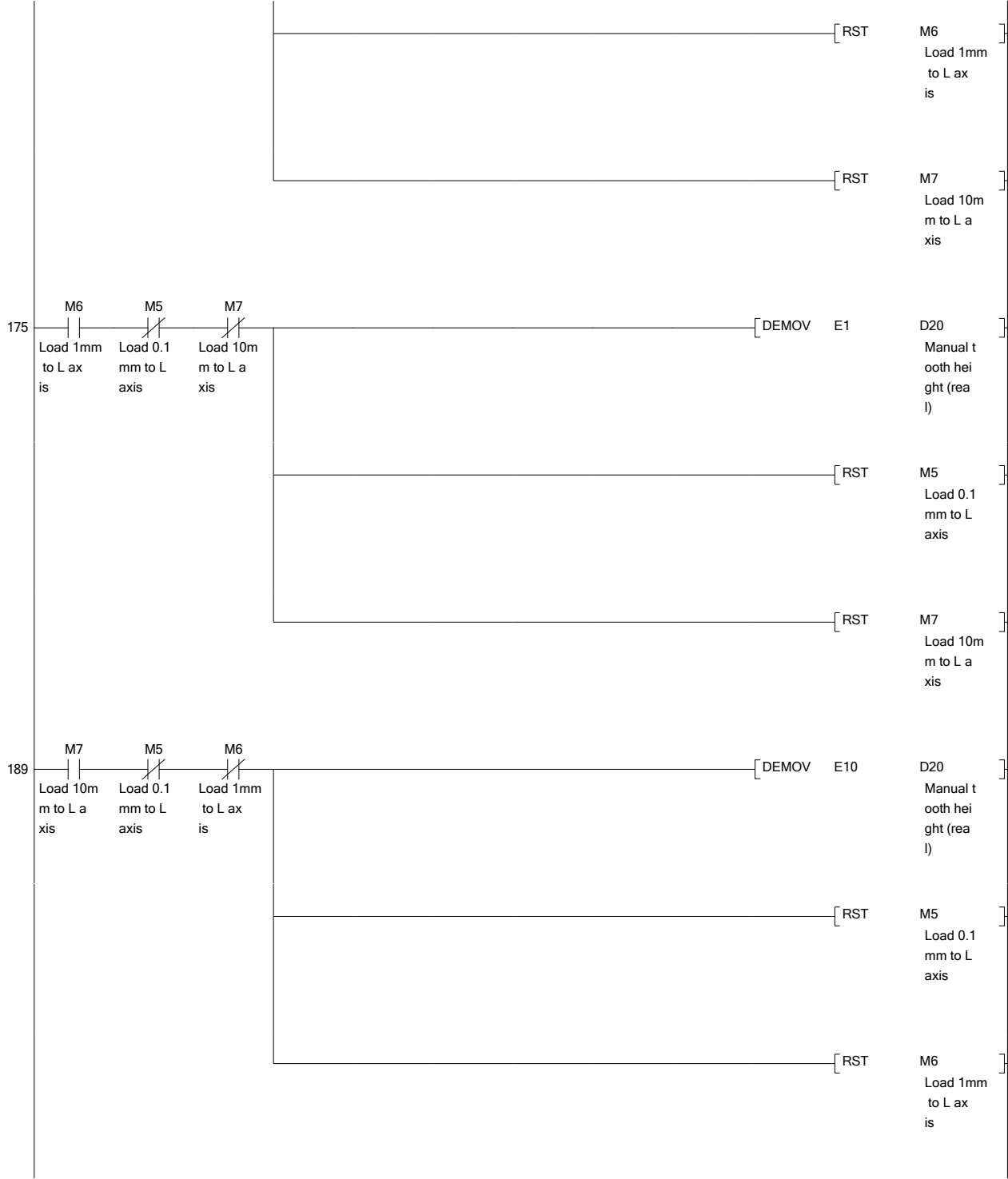
2/21/2022  
  
(1, 1)

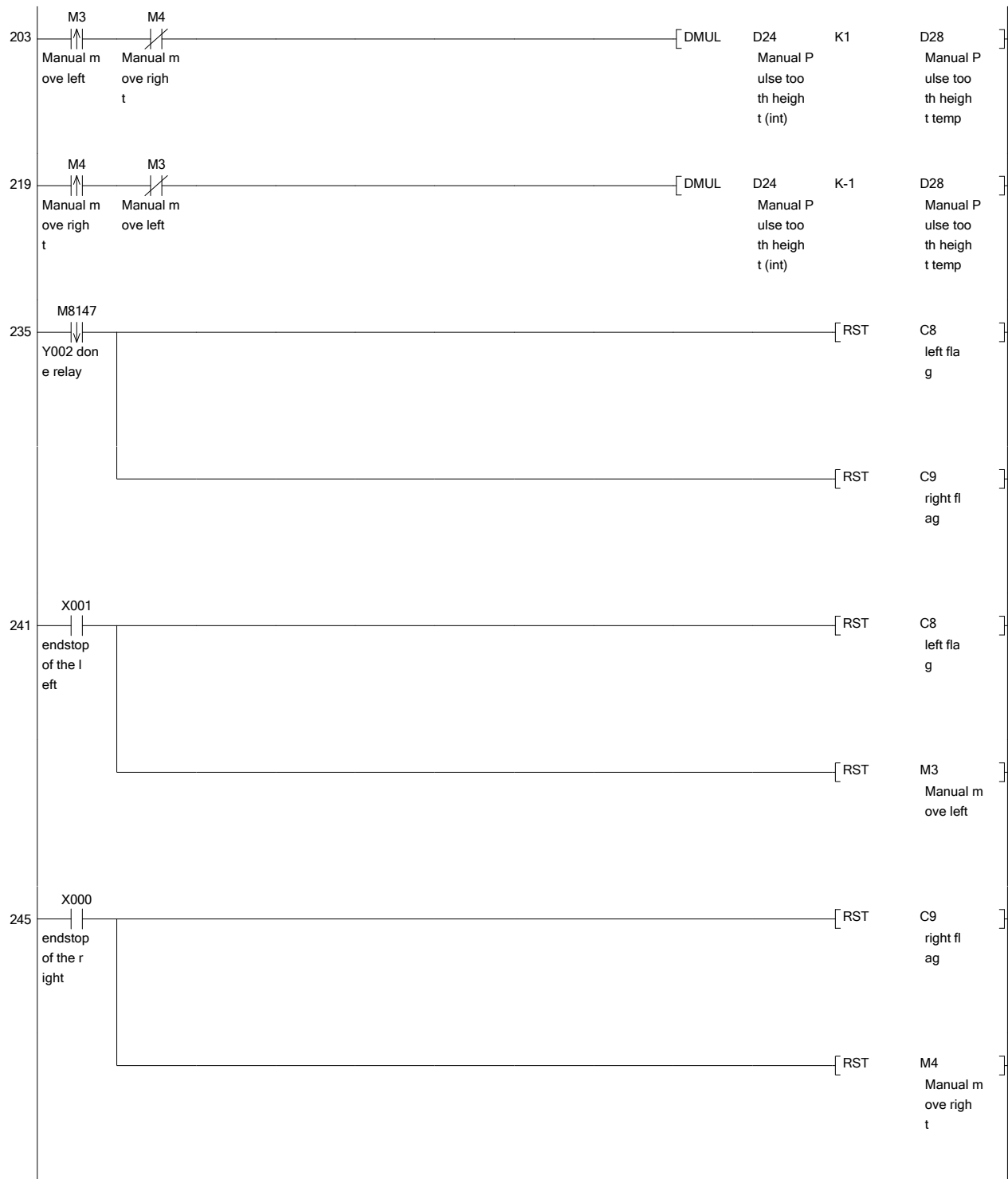
☐LD







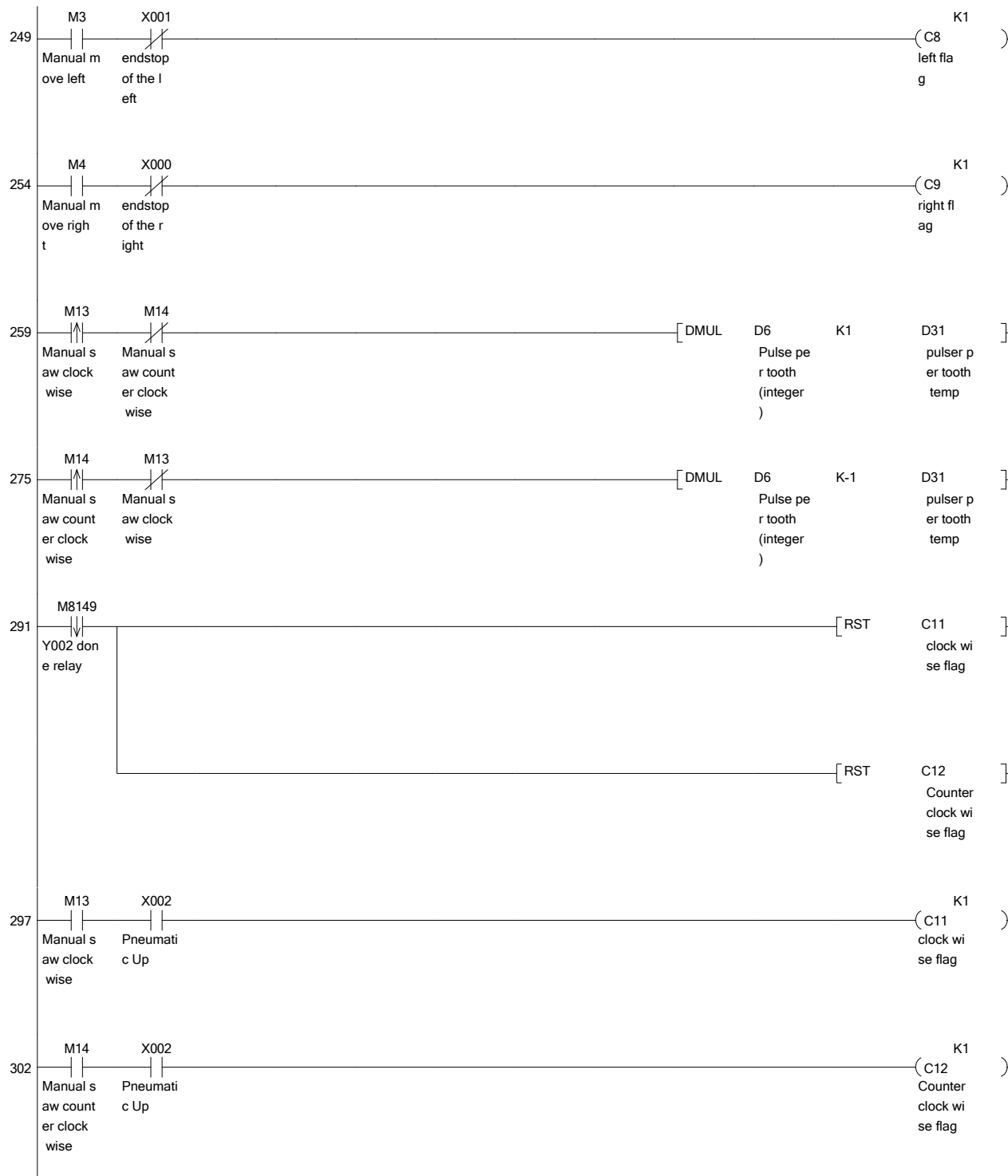




MELSAP3  
Data Name : MAIN  
SFC Block  
001:Block1

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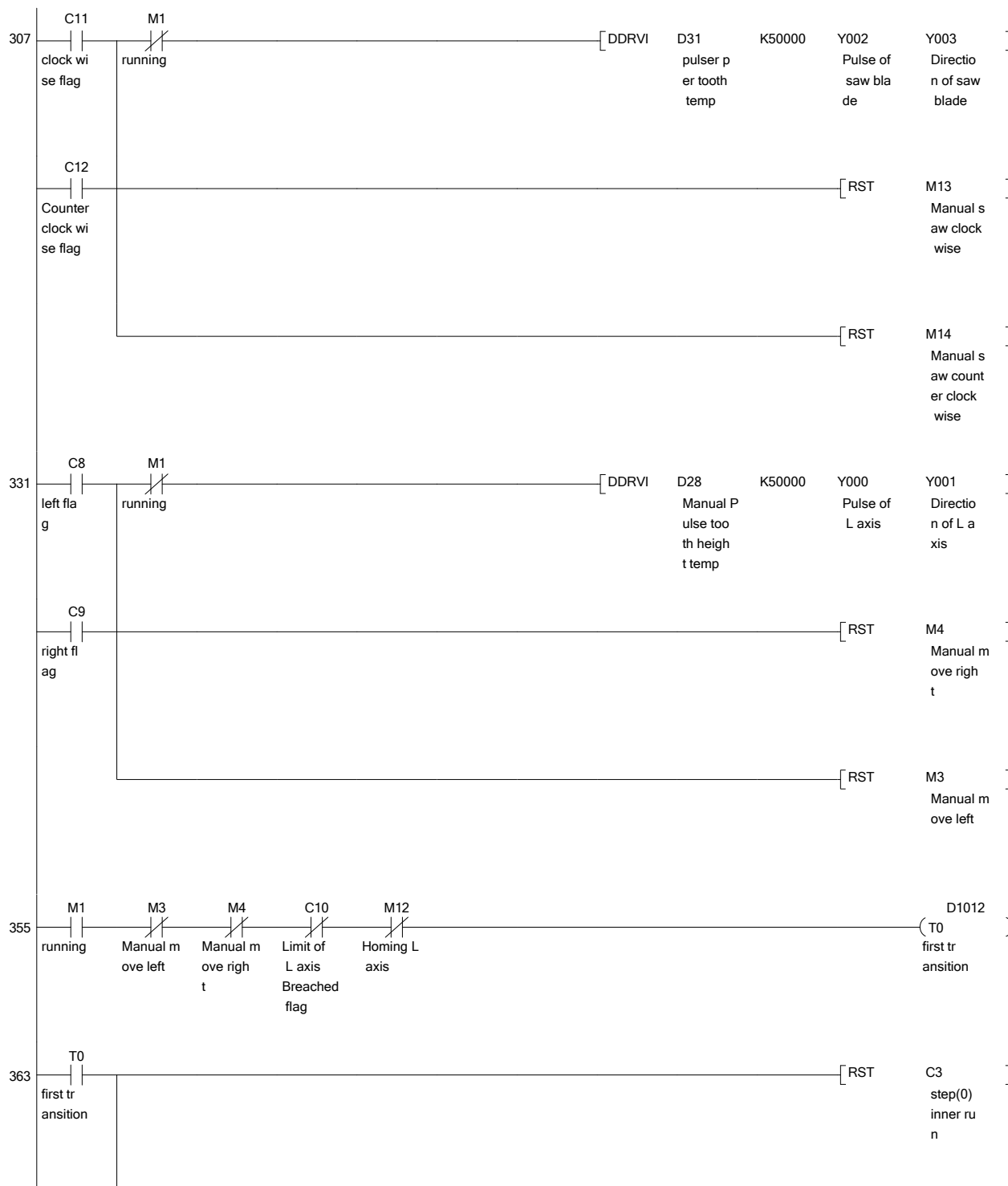
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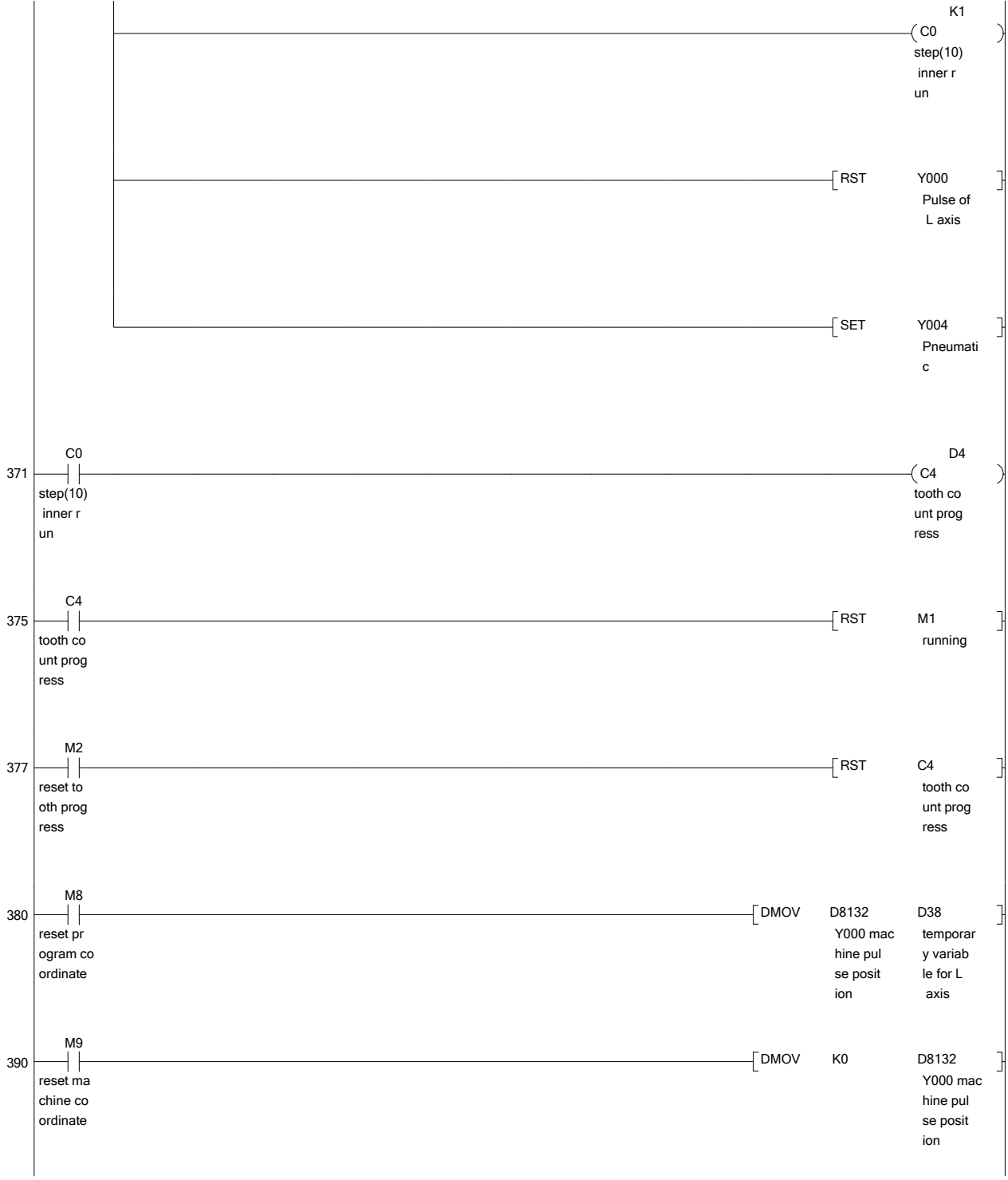


MELSAP3  
Data Name : MAIN  
SFC Block  
001:Block1

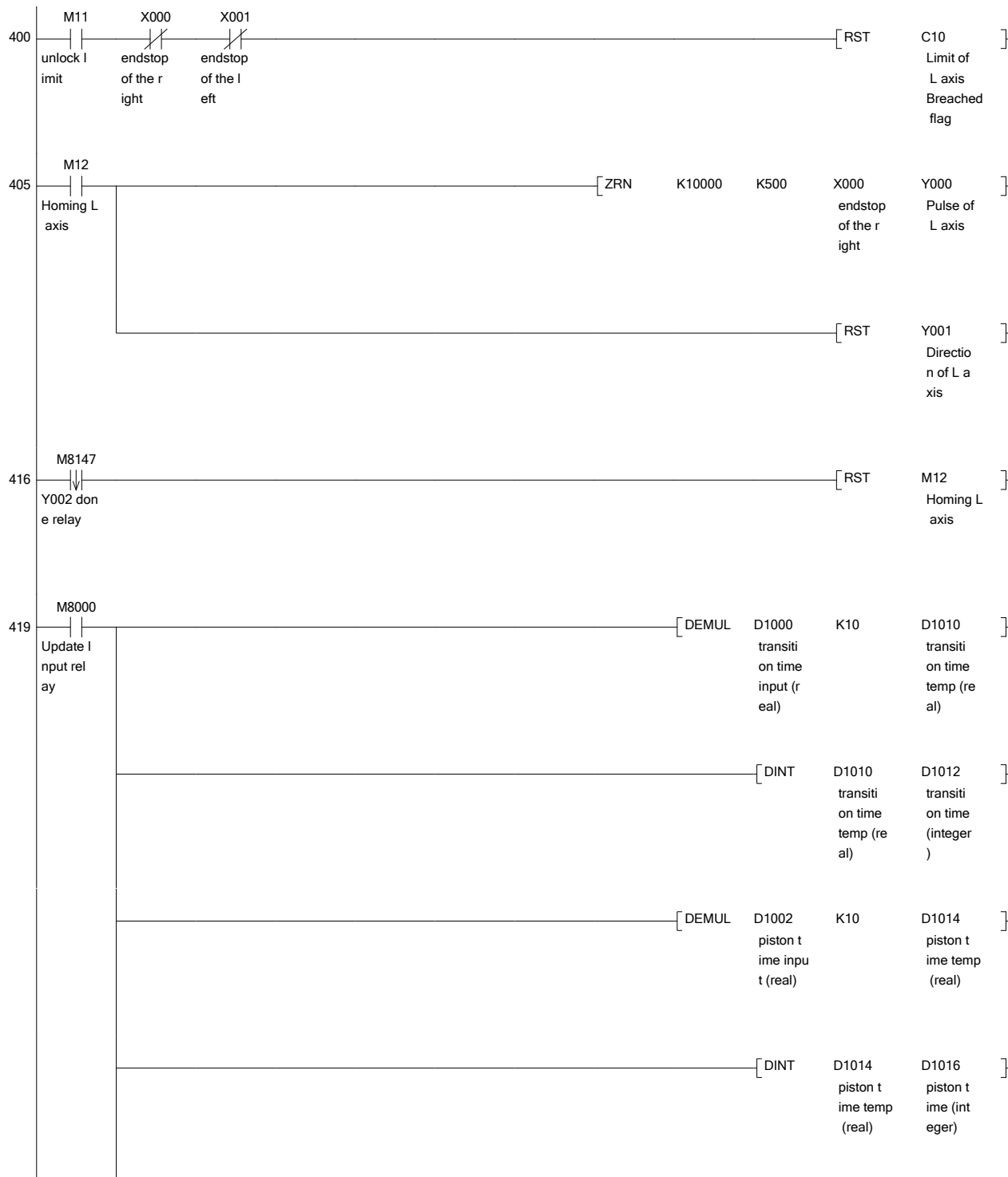
2/21/2022

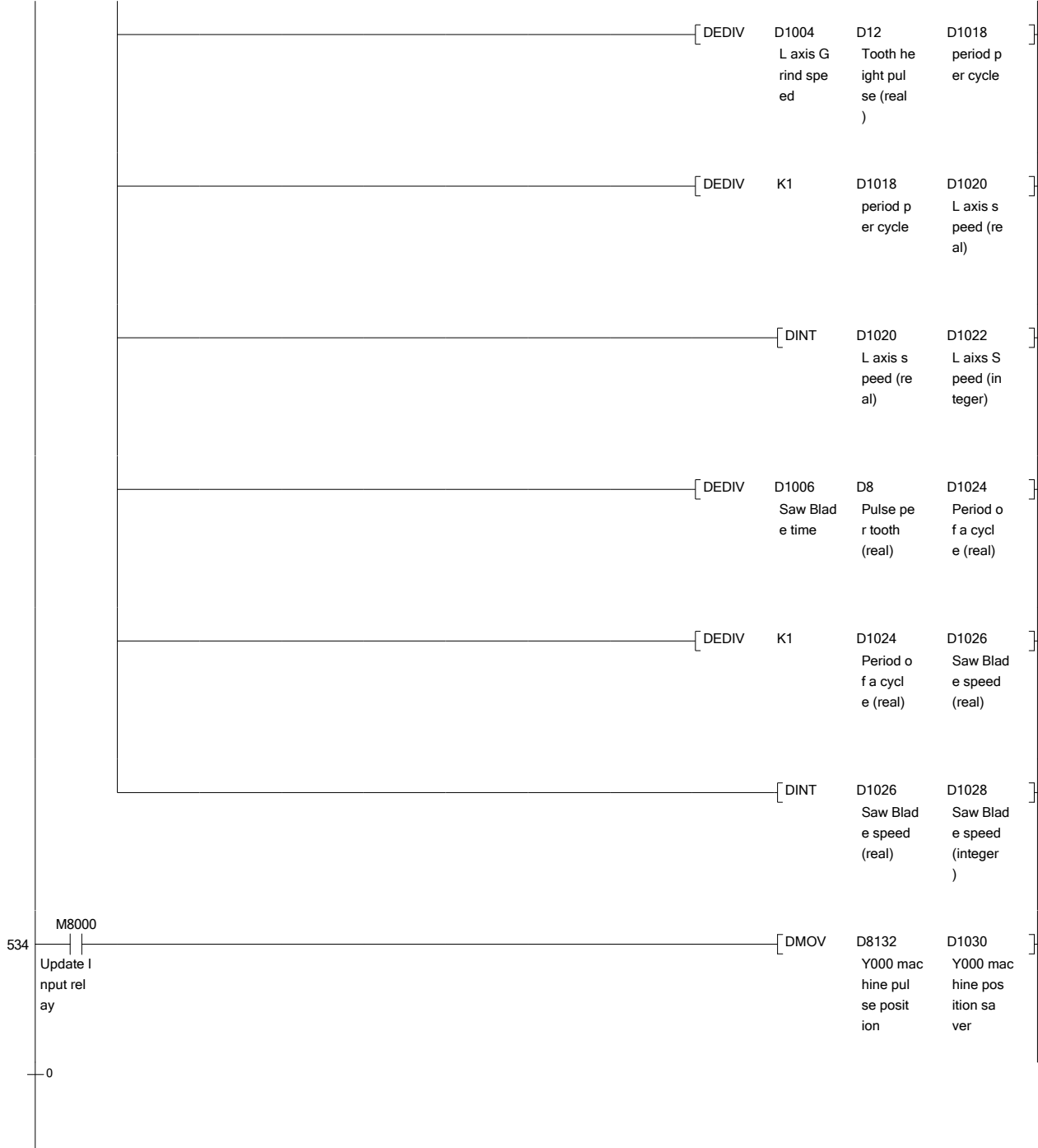
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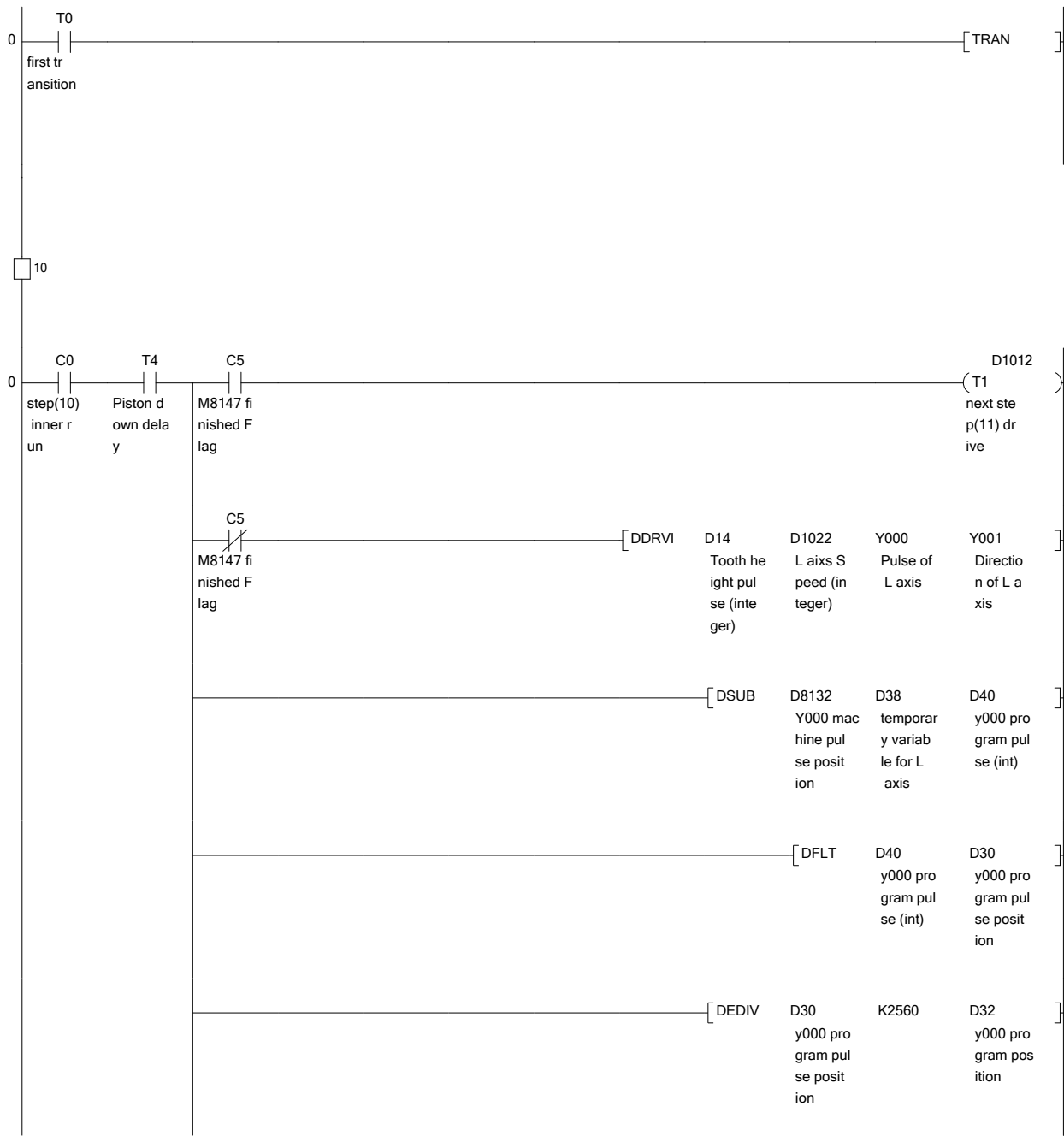


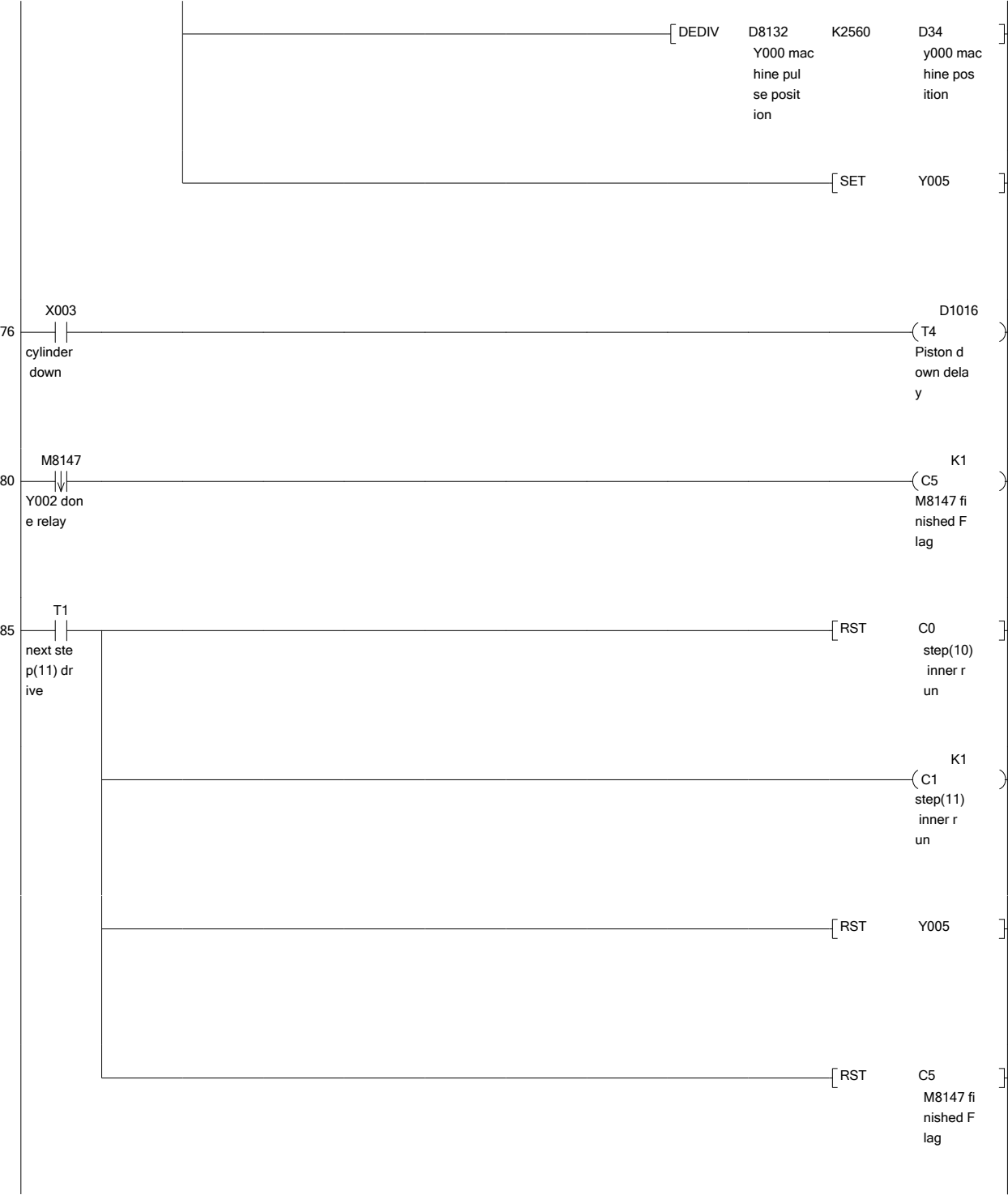


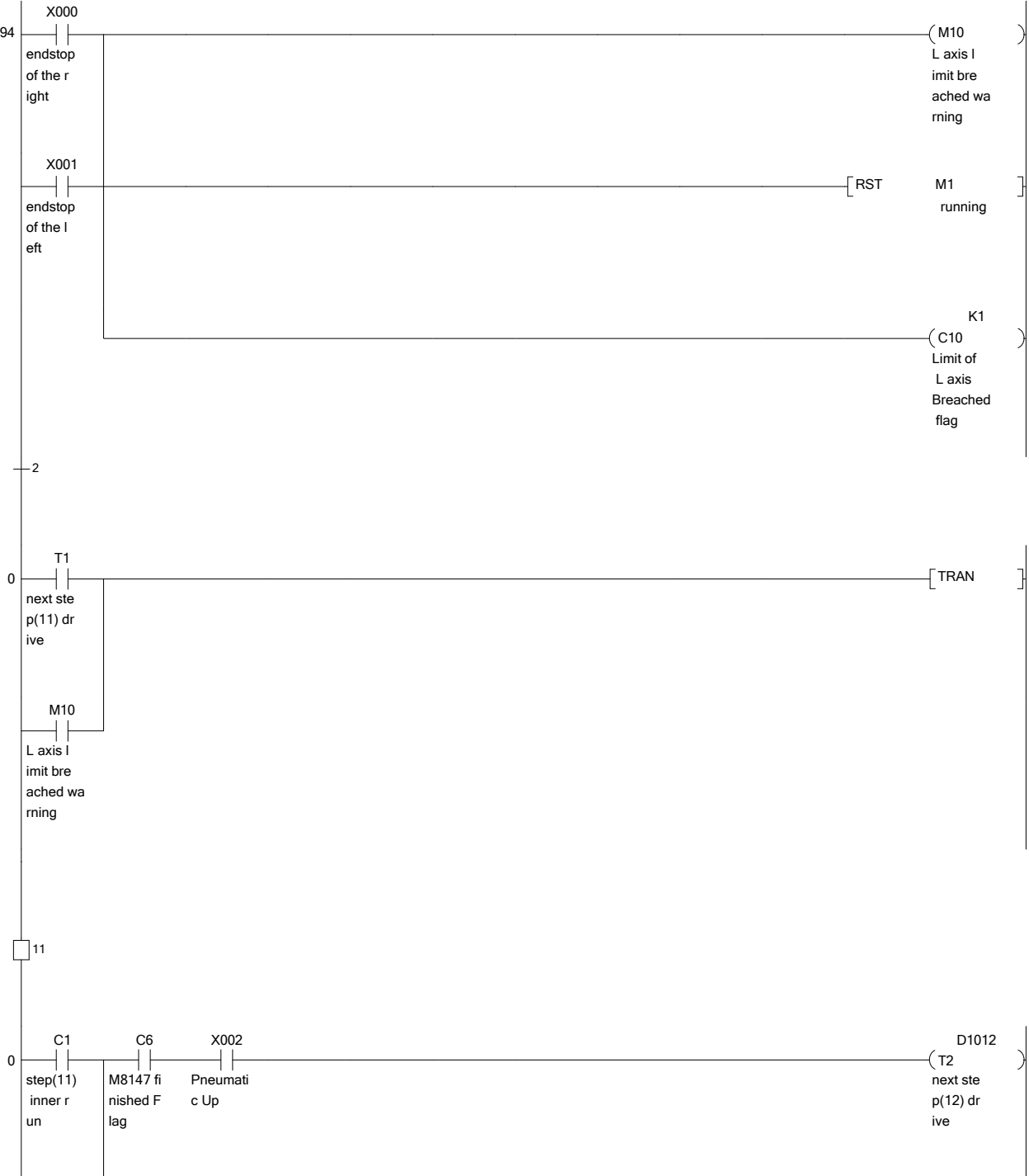






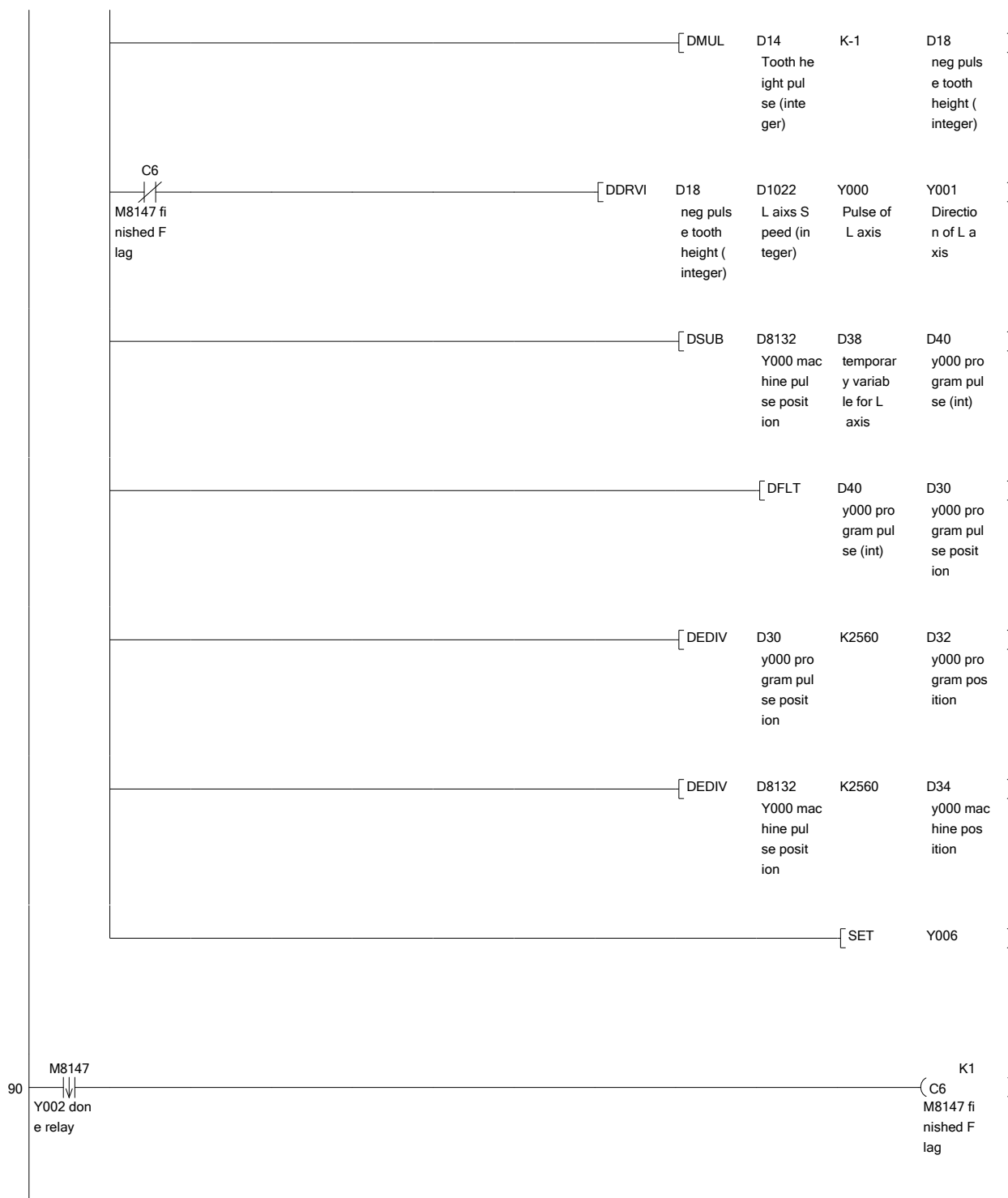


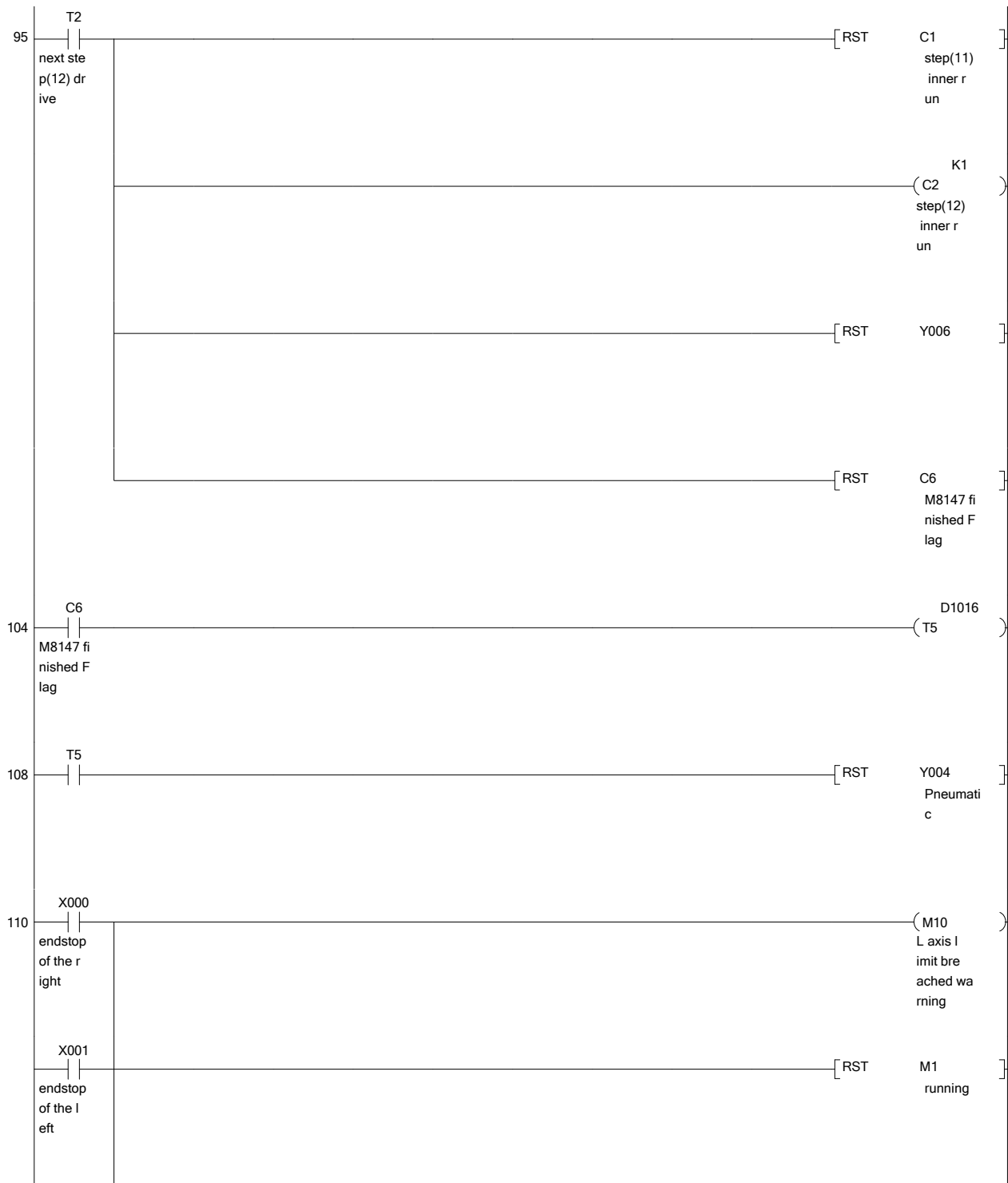


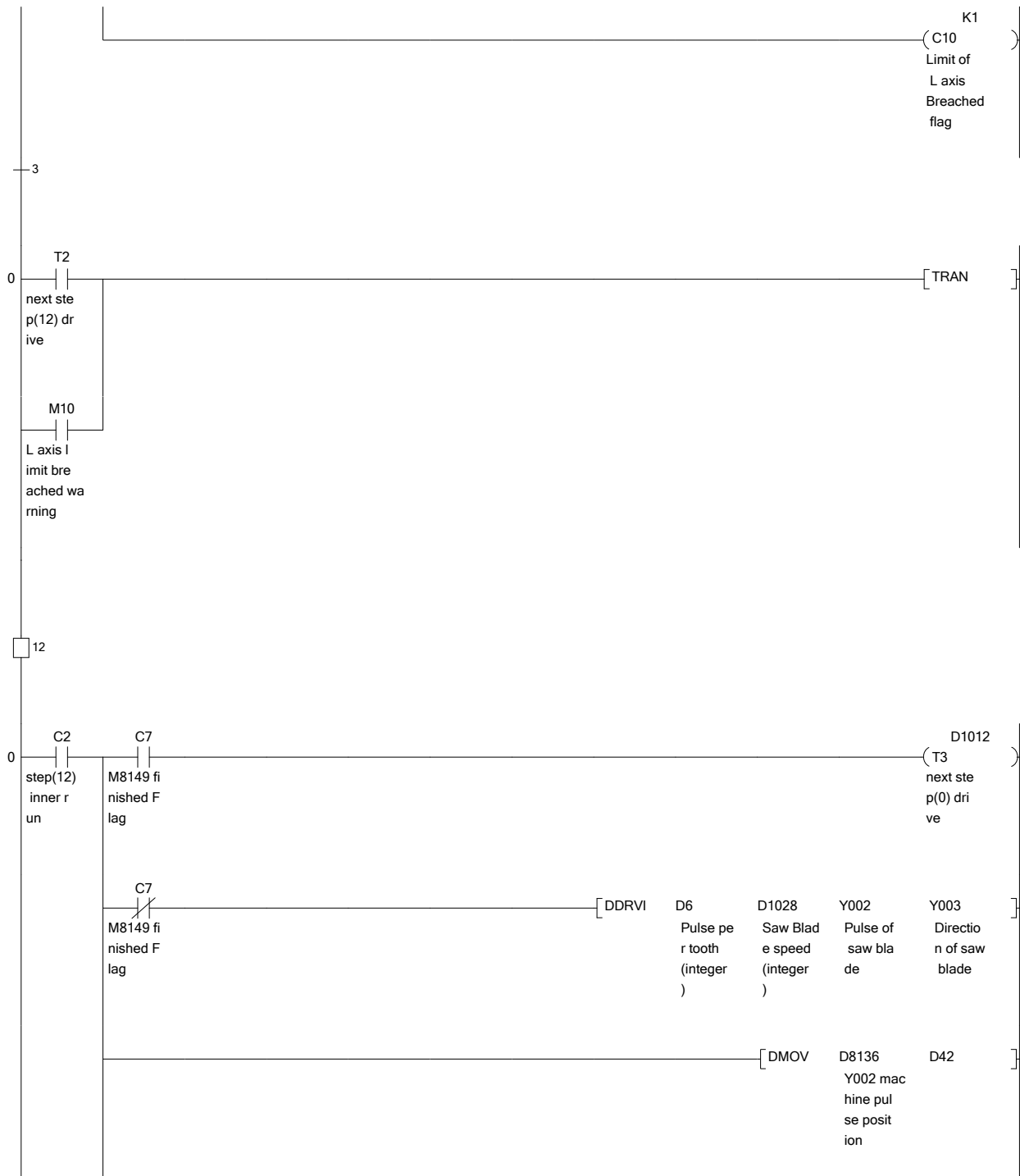


2/21/2022

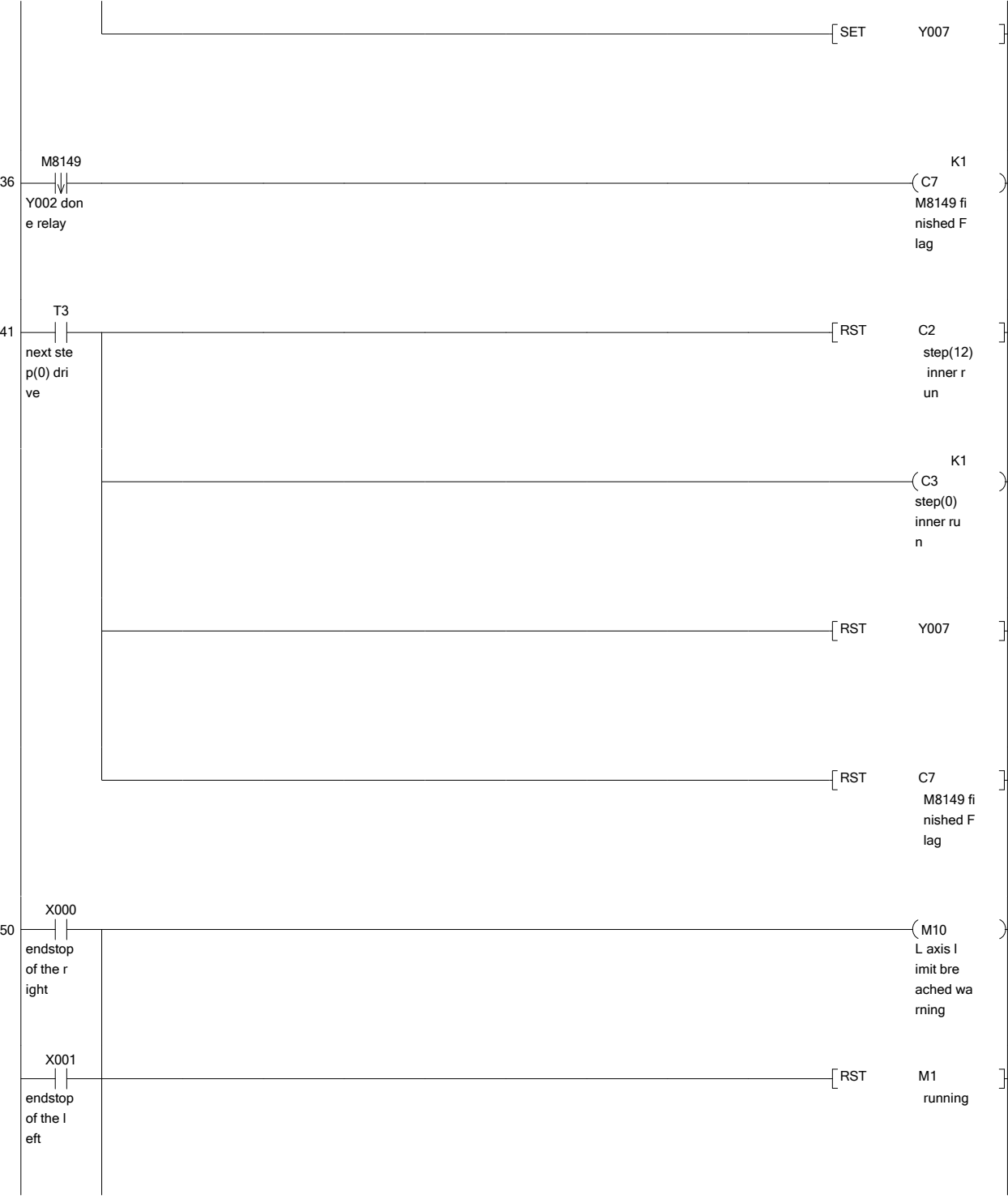
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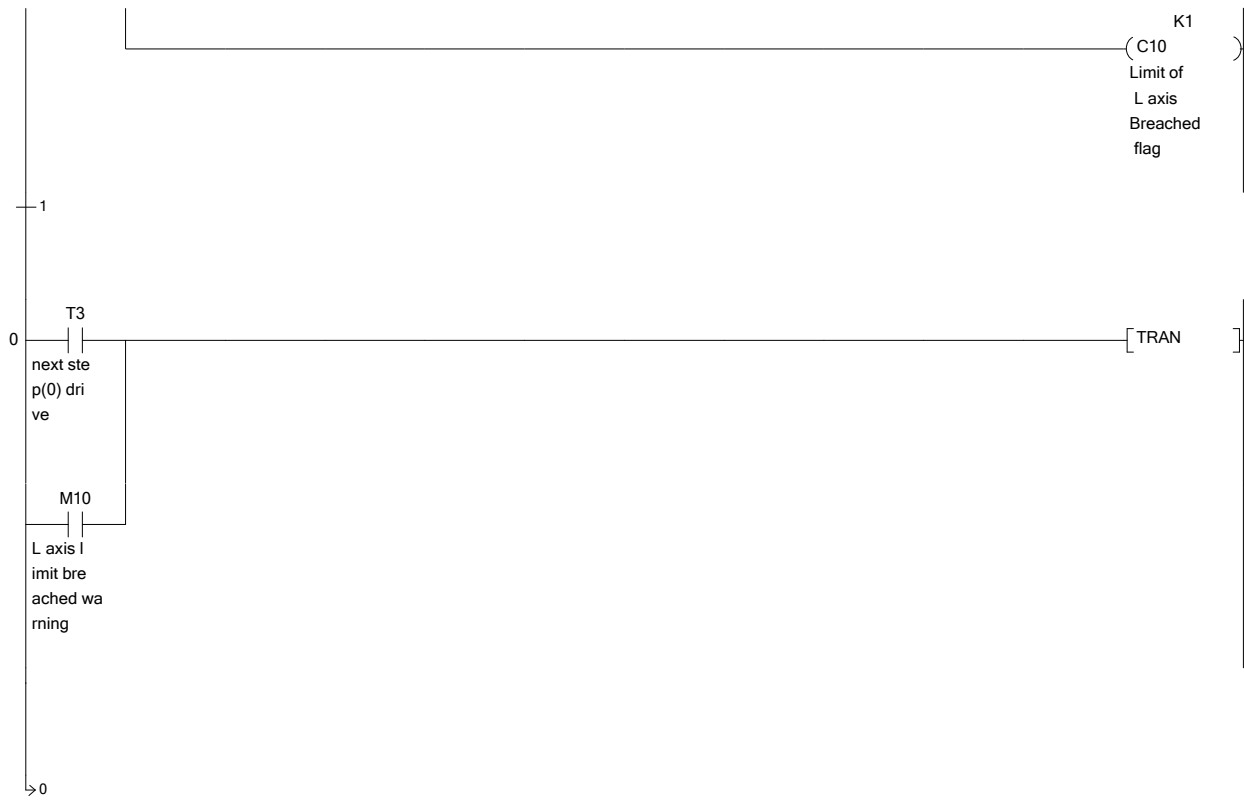






MELSAP3  
Data Name : MAIN  
SFC Block  
001:Block1

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(17, 1)



MELSAP3  
Data Name : MAIN  
SFC Block List

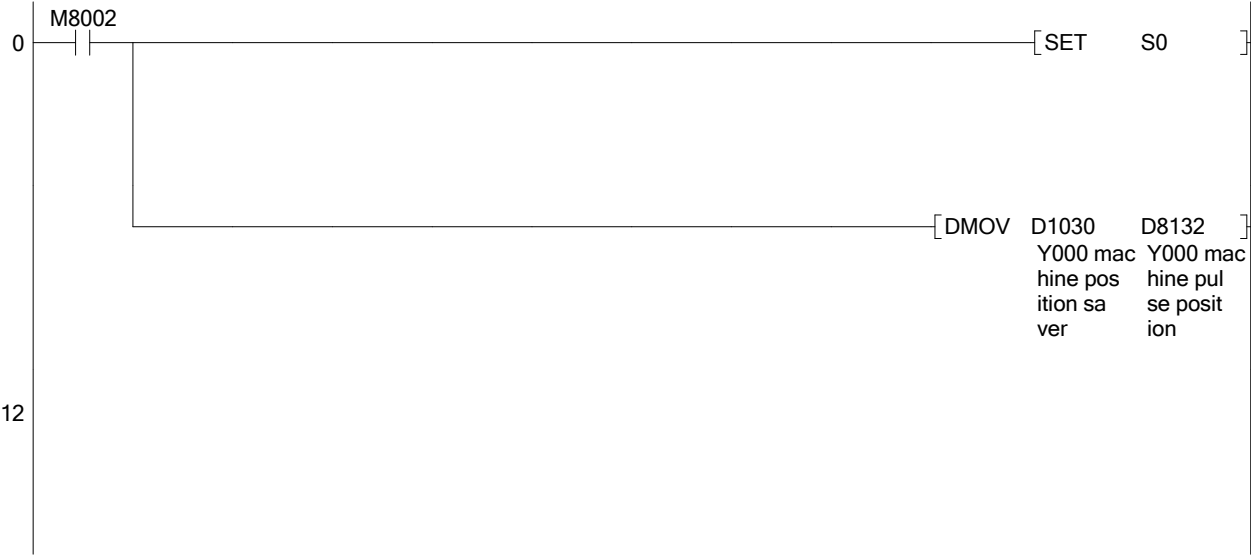
2/21/2022

No.	Data Name	Title	Conversion Status	Block Type
0	Block0	start	-	Ladder Block
1	Block1	b1	-	SFC Block
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				
22				
23				
24				

MELSAP3  
Data Name : MAIN  
SFC Comment List  
001:Block1

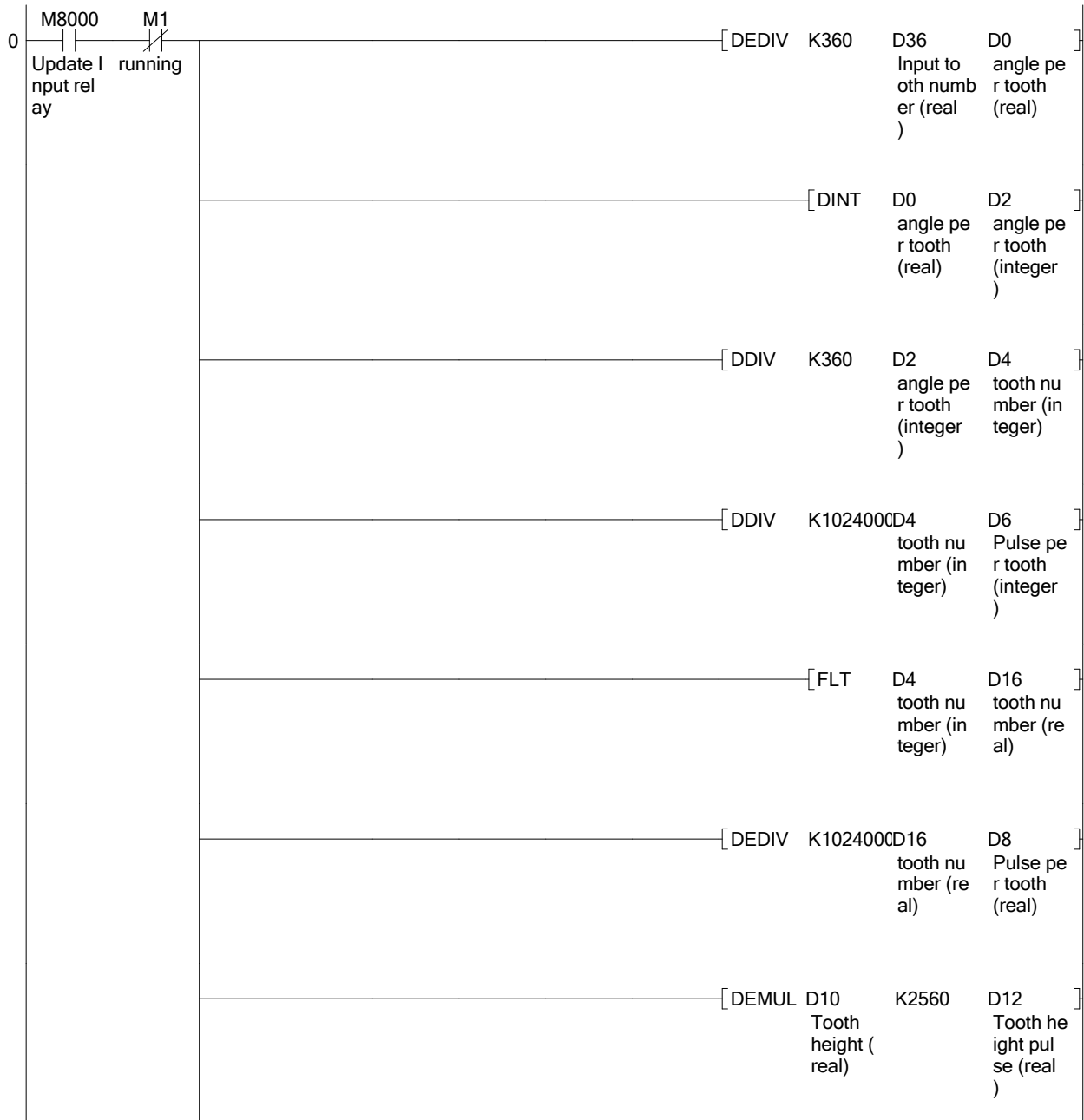
2/21/2022

Step	Comment
S0	
S10	
S11	
S12	



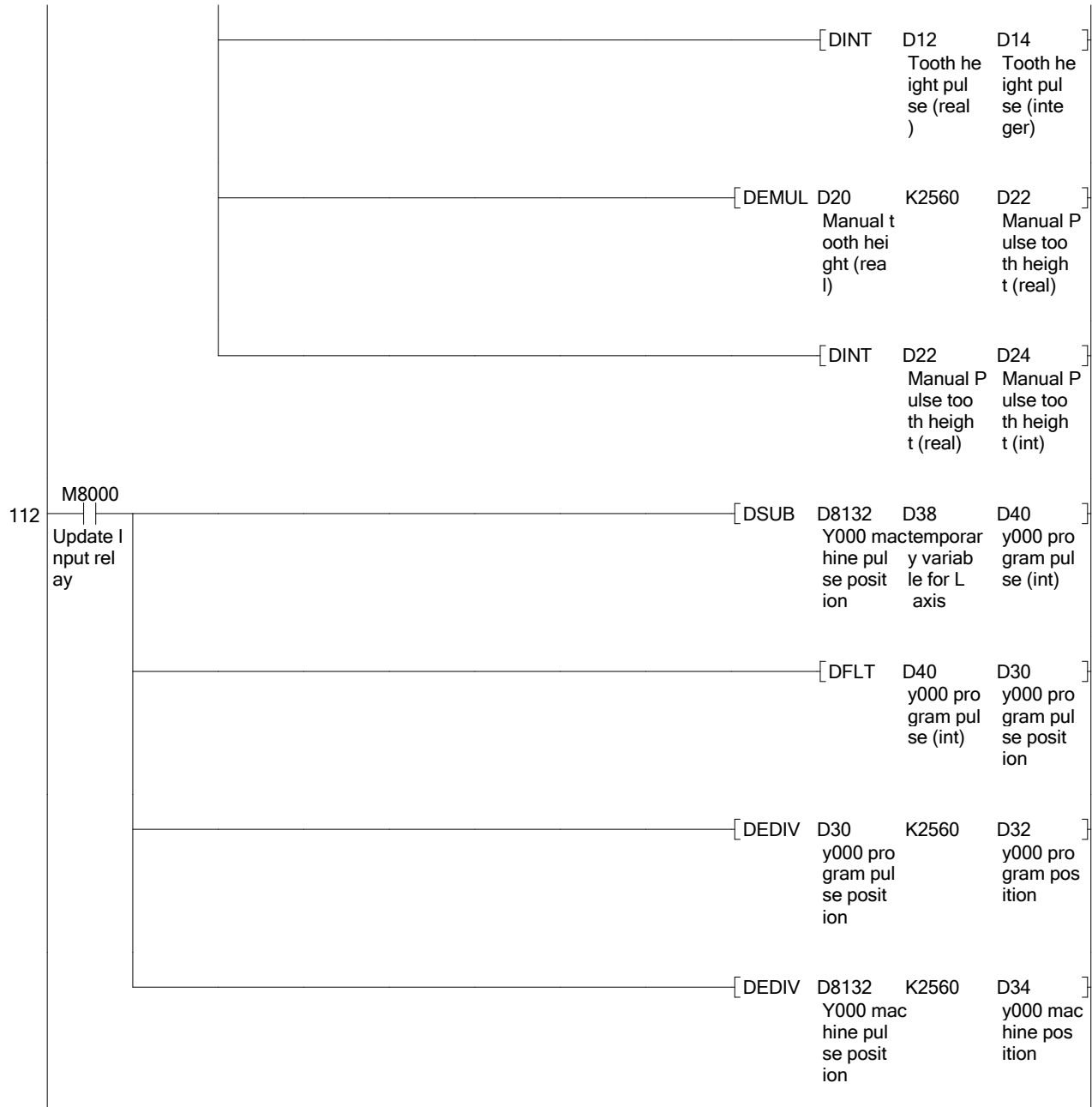
MELSAP3  
Data Name : MAIN  
SFC Zoom  
001:Block1  
Step No.0

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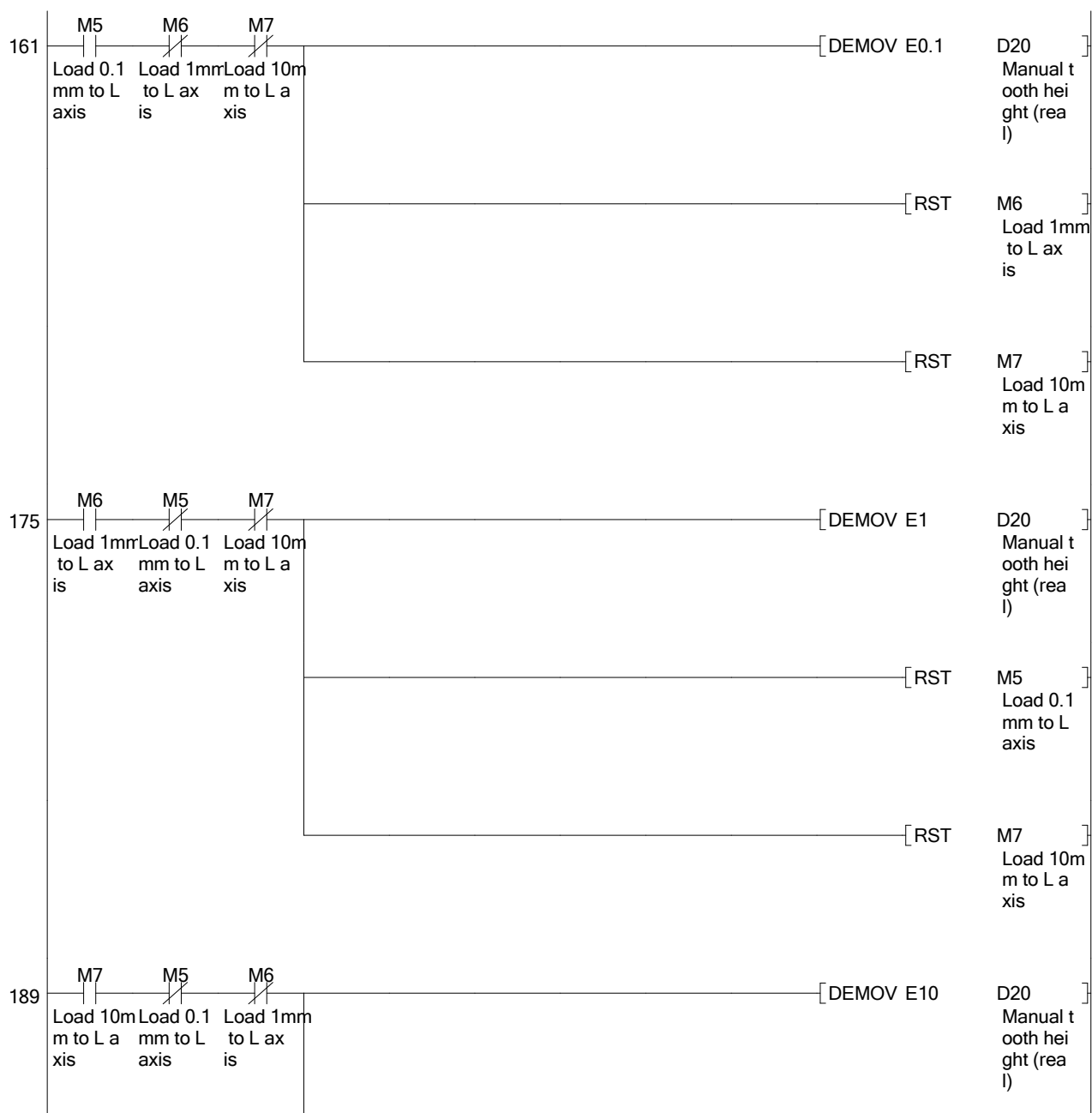
MELSAP3  
 Data Name : MAIN  
 SFC Zoom  
 001:Block1  
 Step No.0

2/21/2022



MELSAP3  
 Data Name : MAIN  
 SFC Zoom  
 001:Block1  
 Step No.0

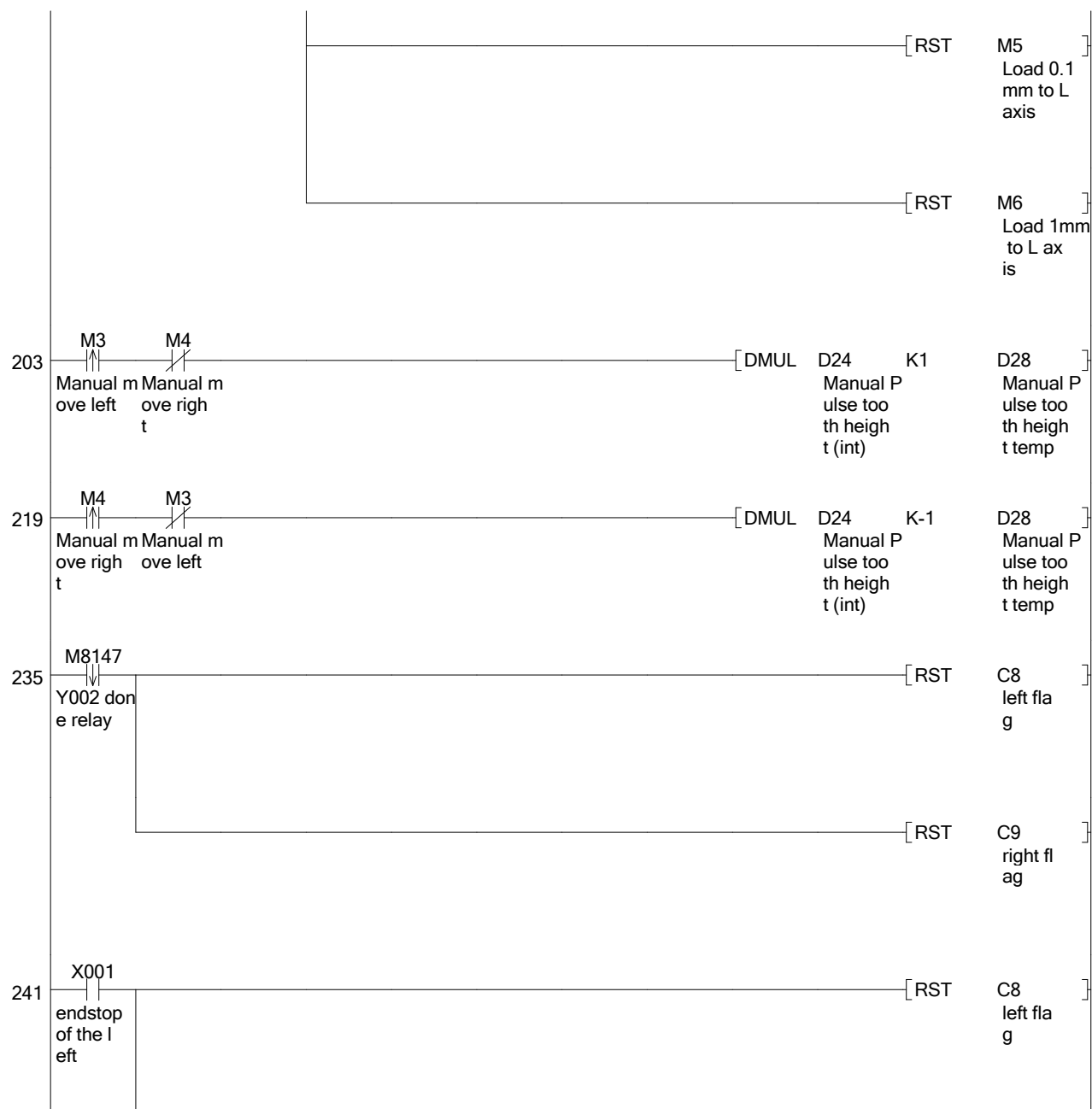
2/21/2022





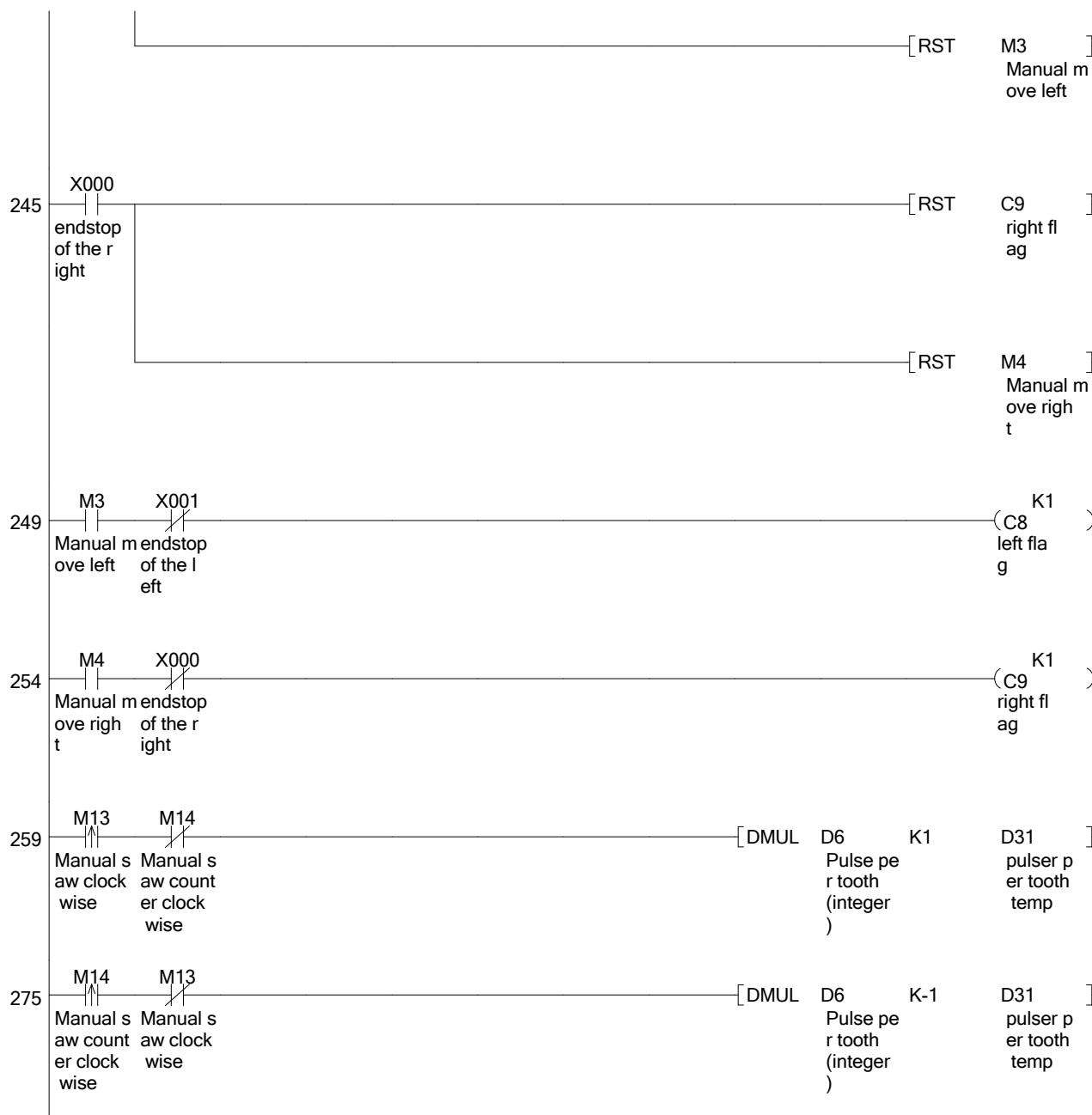
MELSAP3  
 Data Name : MAIN  
 SFC Zoom  
 001:Block1  
 Step No.0

2/21/2022



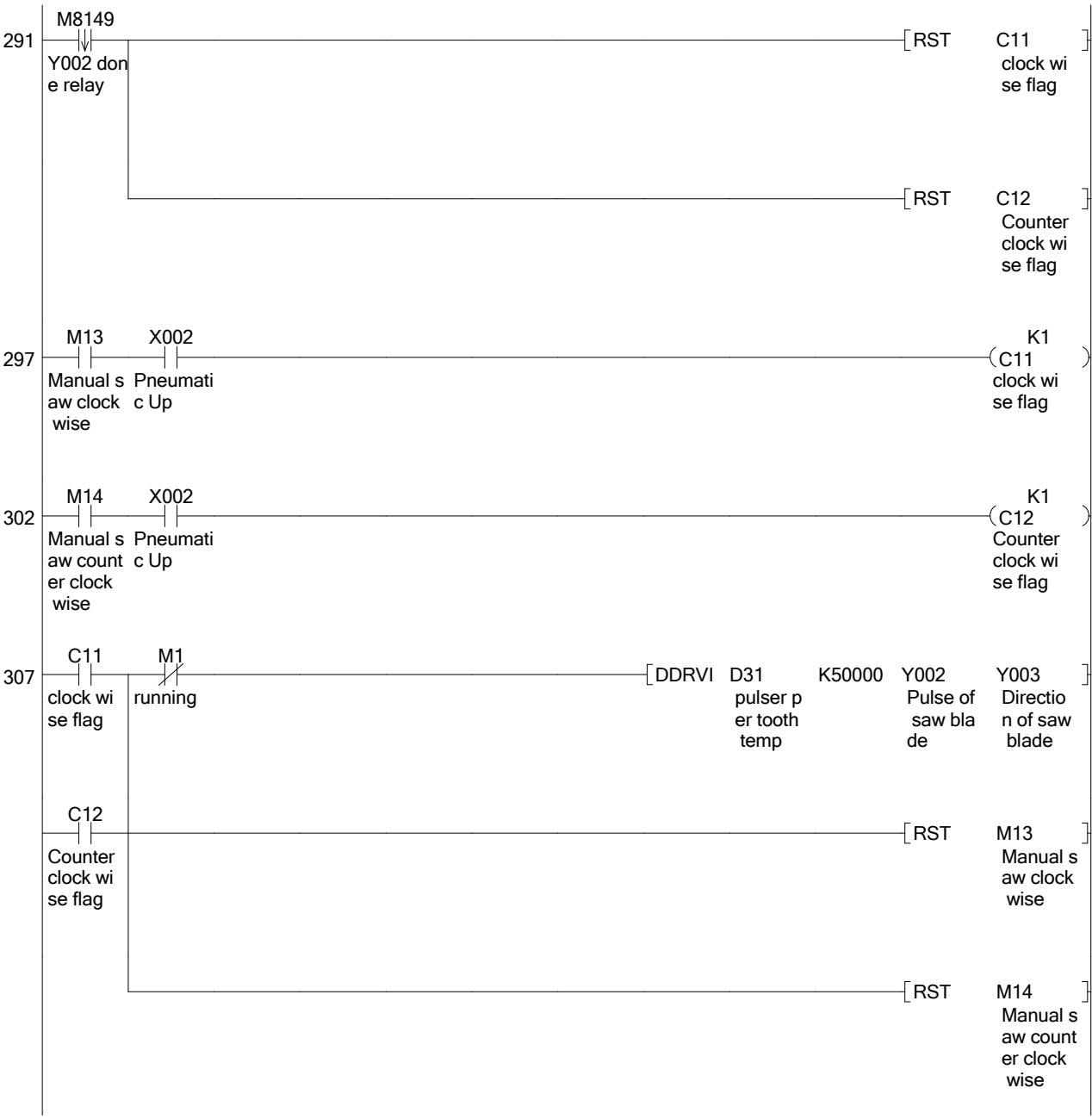
MELSAP3  
 Data Name : MAIN  
 SFC Zoom  
 001:Block1  
 Step No.0

2/21/2022



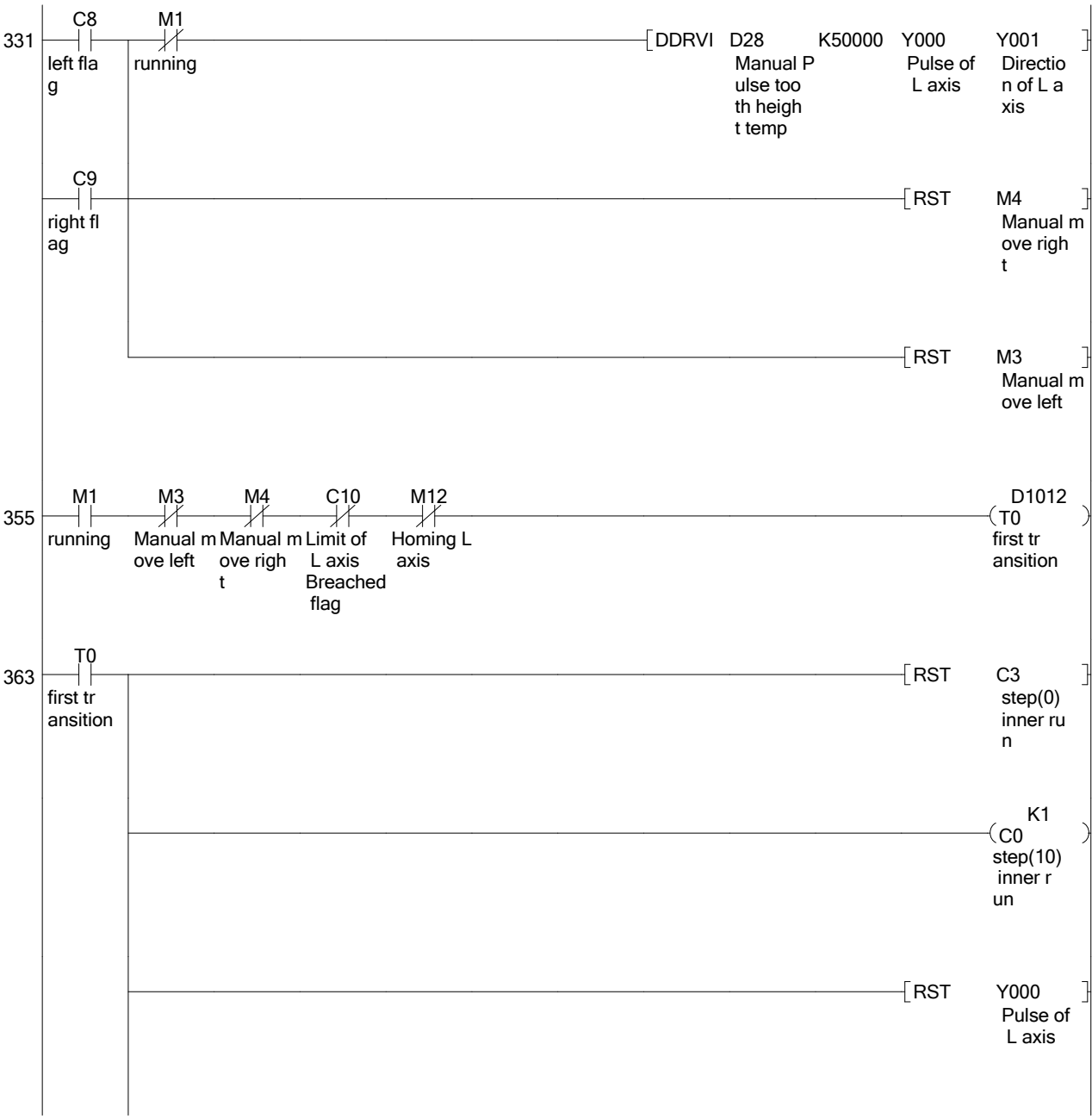
MELSAP3  
Data Name : MAIN  
SFC Zoom  
001:Block1  
Step No.0

2/21/2022



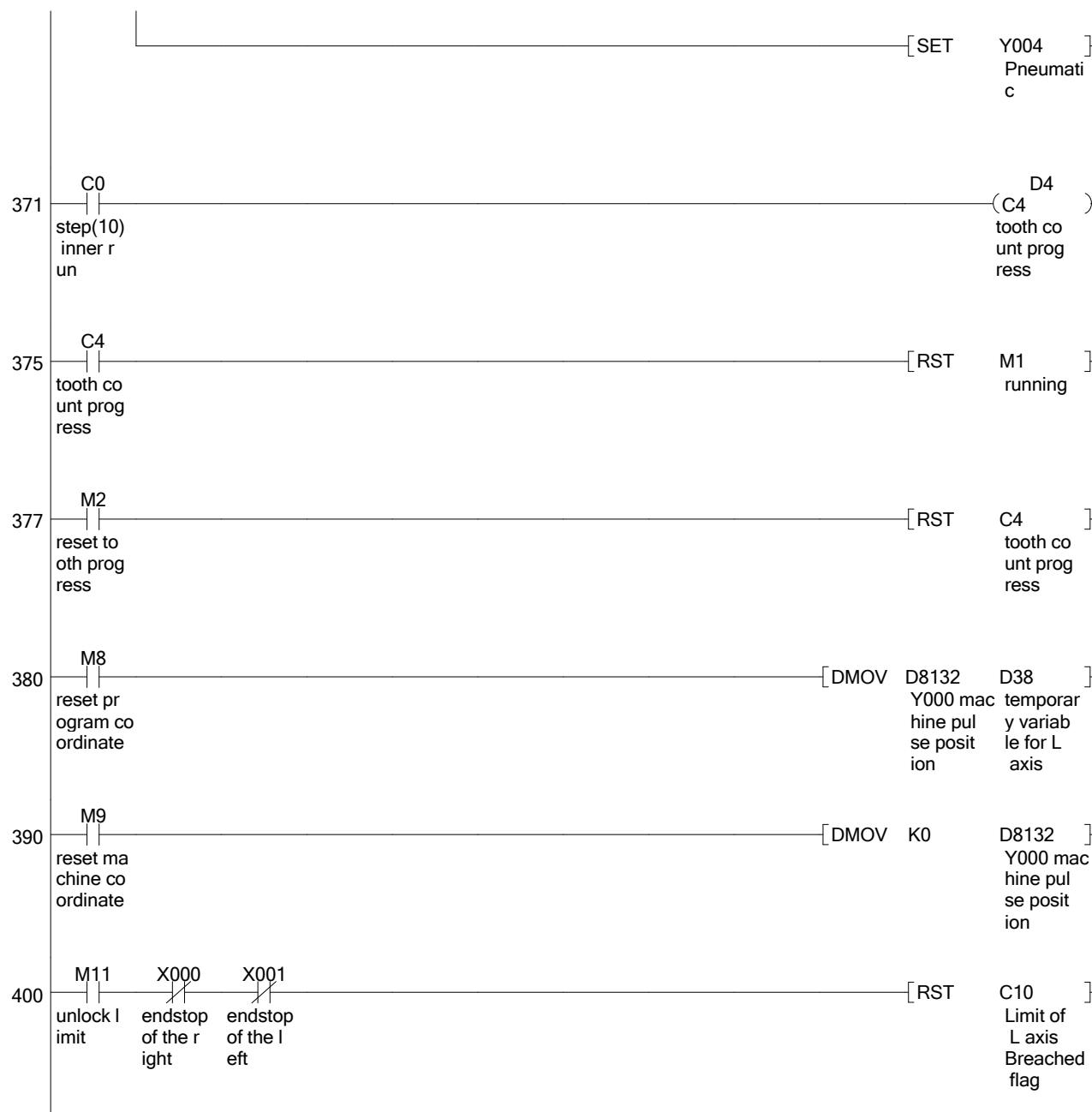
MELSAP3  
Data Name : MAIN  
SFC Zoom  
001:Block1  
Step No.0

2/21/2022



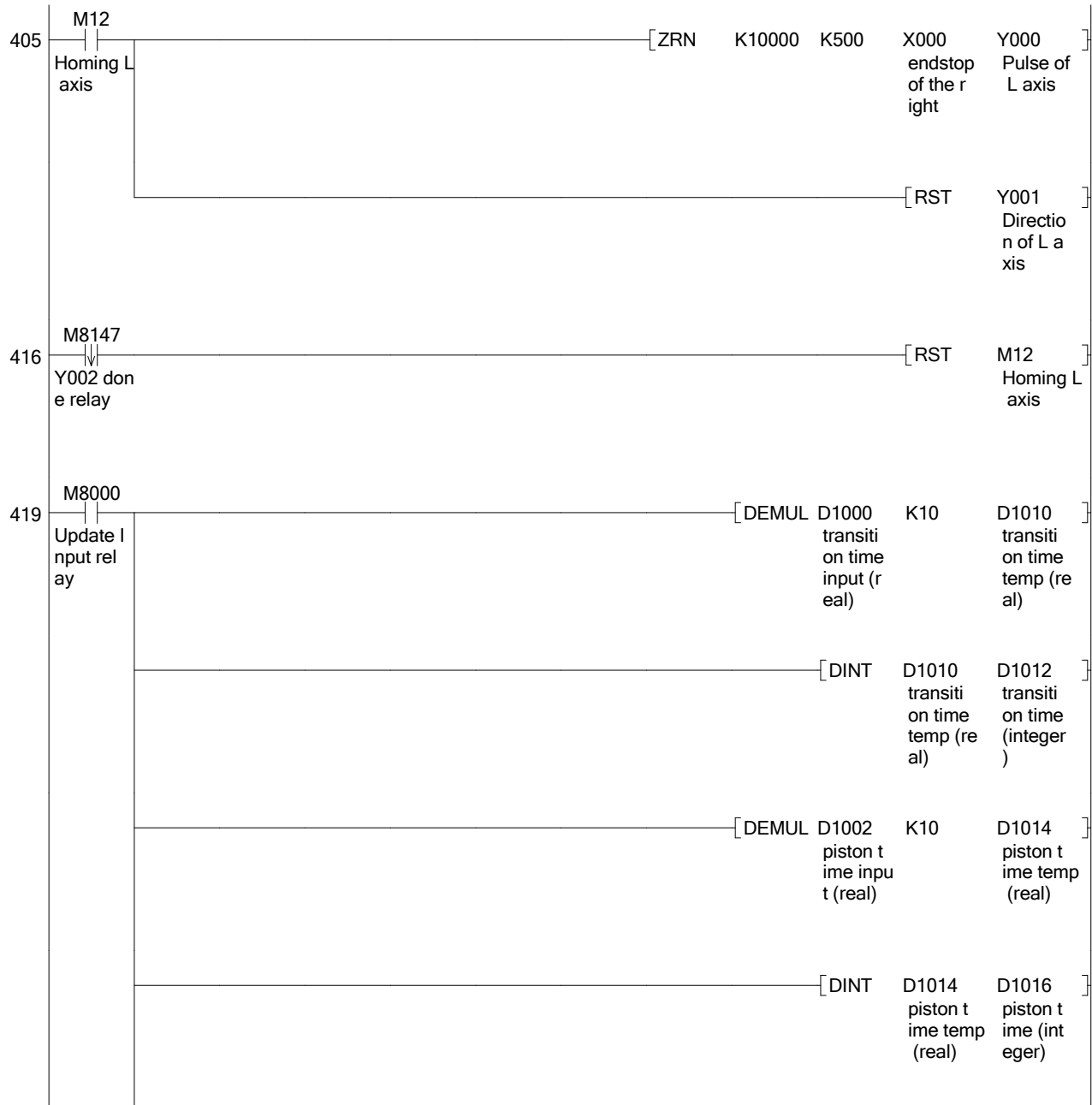
MELSAP3  
Data Name : MAIN  
SFC Zoom  
001:Block1  
Step No.0

2/21/2022



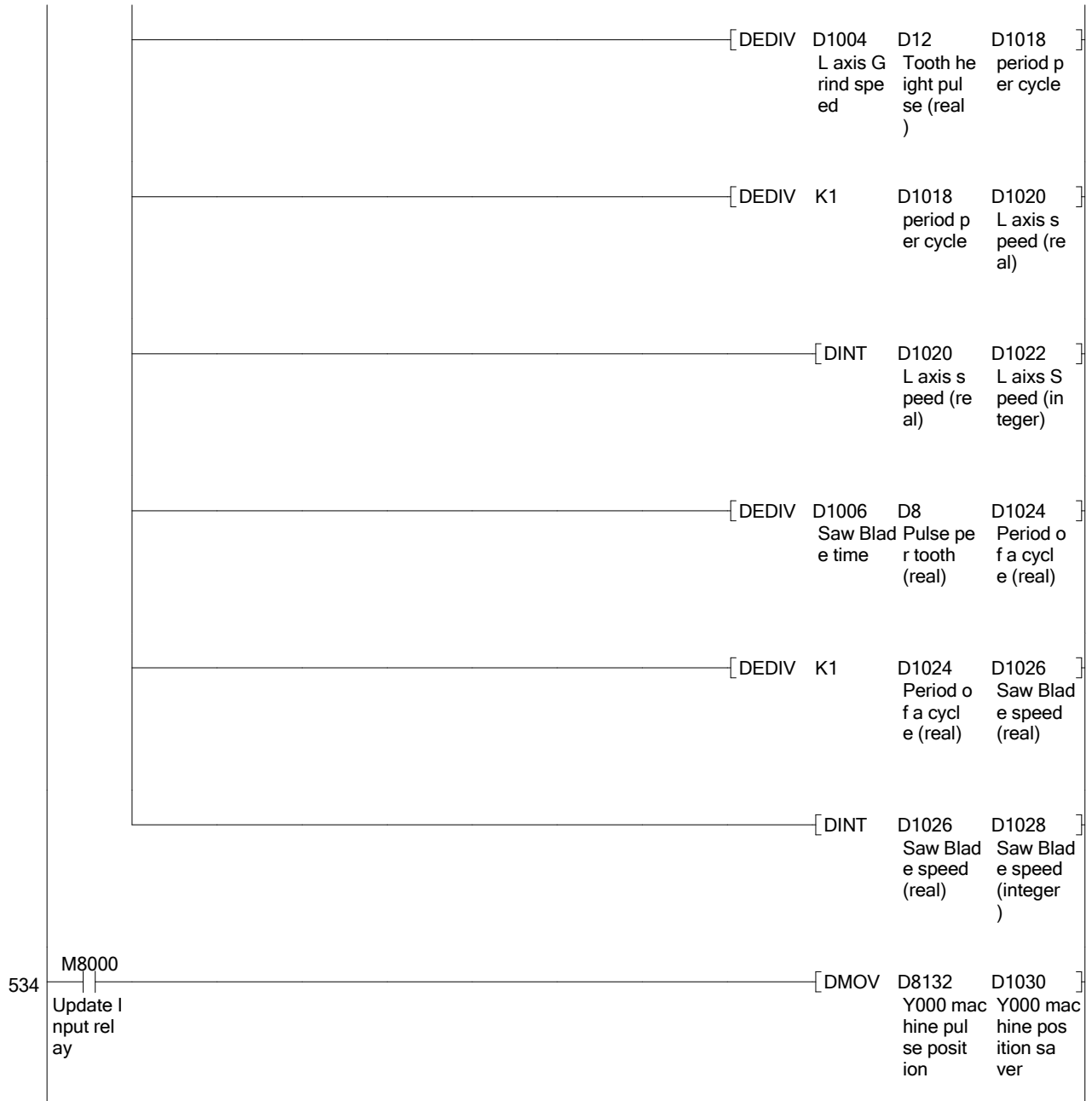
MELSAP3  
 Data Name : MAIN  
 SFC Zoom  
 001:Block1  
 Step No.0

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MELSAP3  
 Data Name : MAIN  
 SFC Zoom  
 001:Block1  
 Step No.0

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MELSAP3  
Data Name : MAIN  
SFC Zoom  
001:Block1  
Step No.0

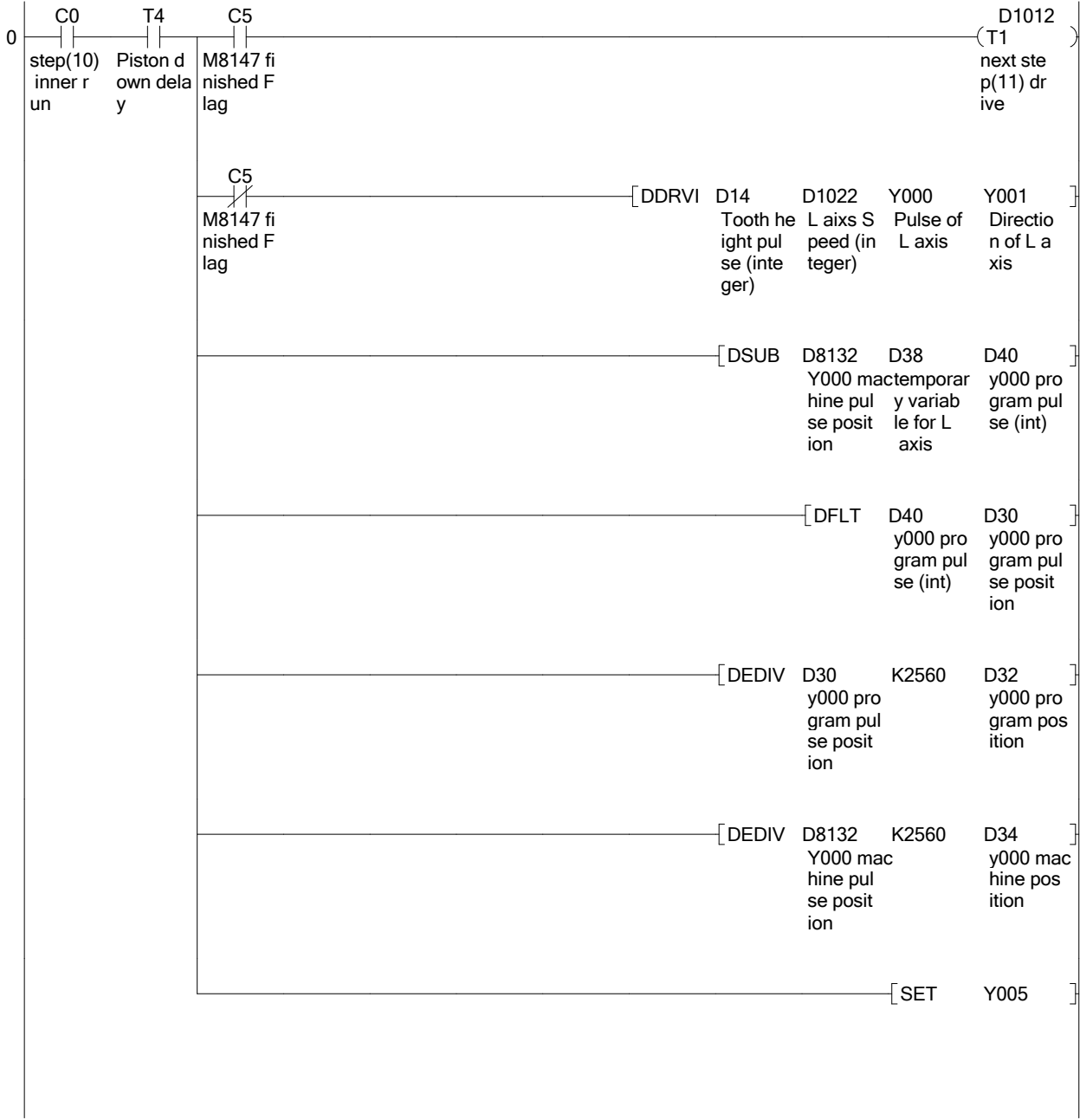
2/21/2022

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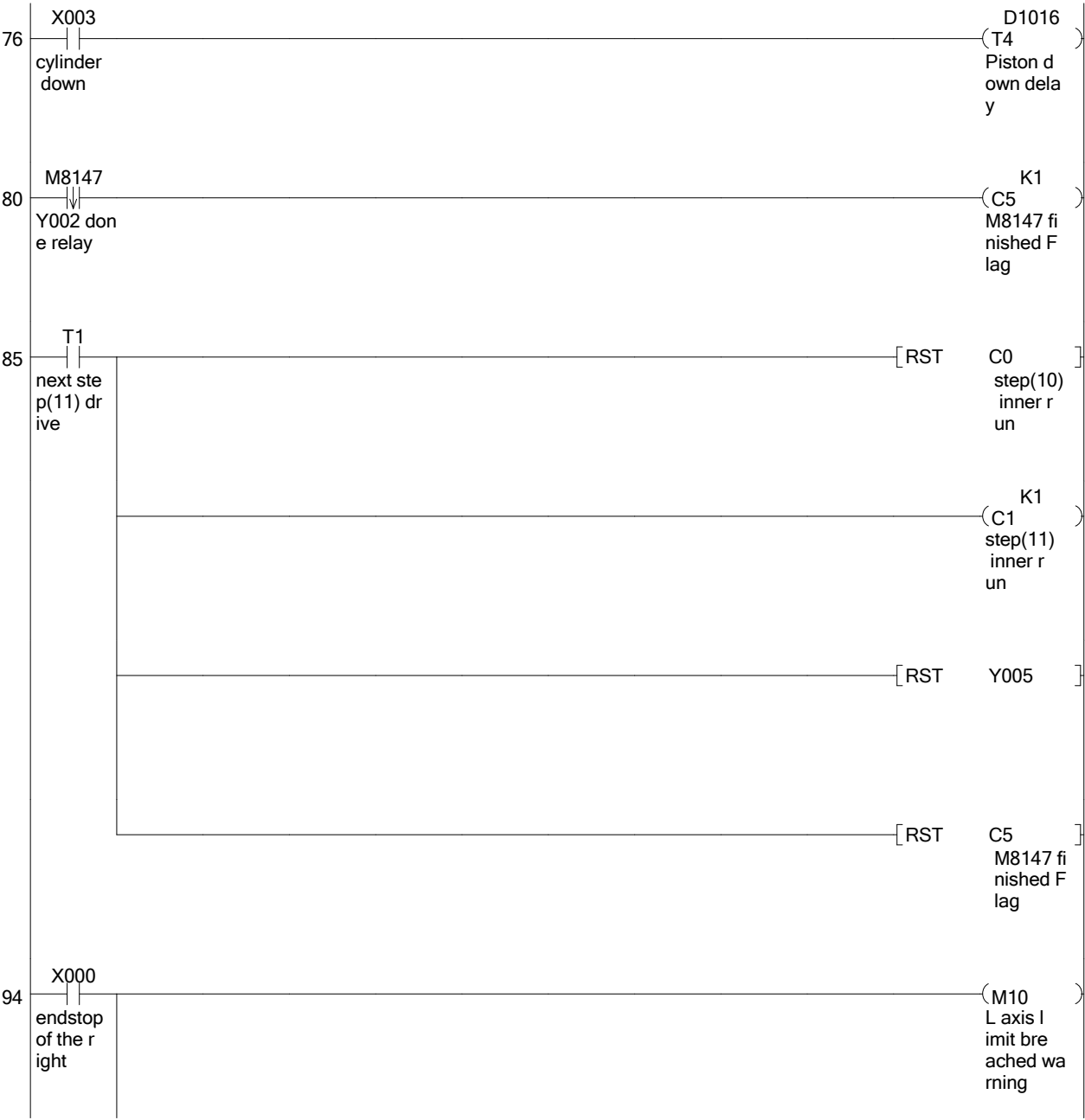
MELSAP3  
Data Name : MAIN  
SFC Zoom  
001:Block1  
Step No.10

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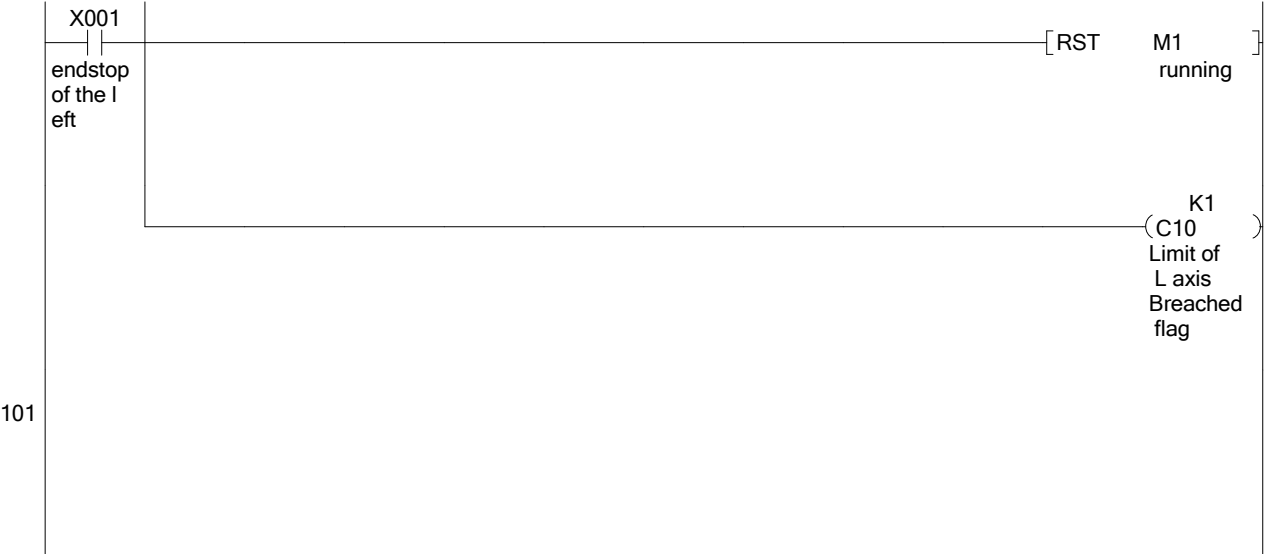
MELSAP3  
Data Name : MAIN  
SFC Zoom  
001:Block1  
Step No.10

2/21/2022



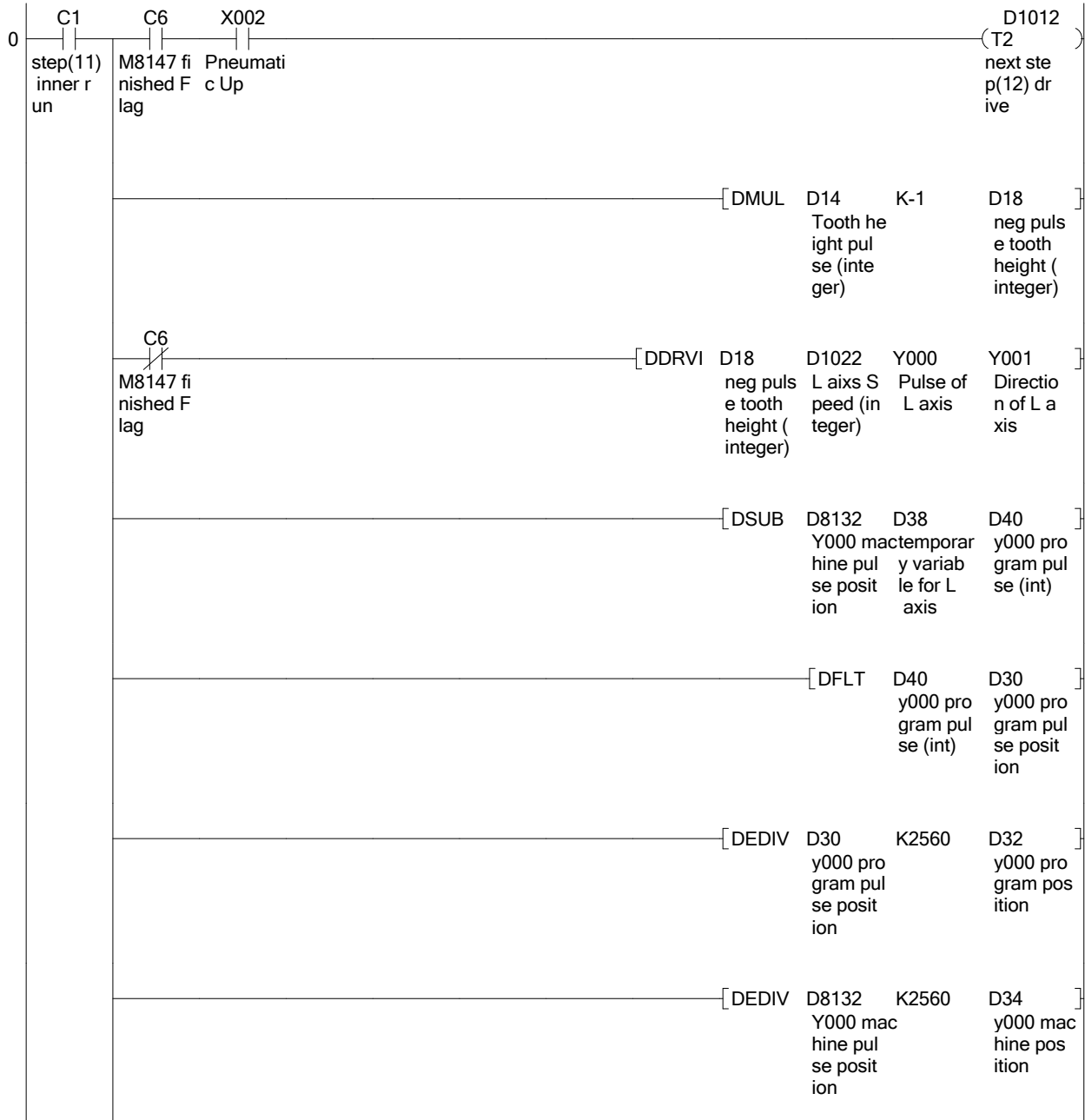
MELSAP3  
Data Name : MAIN  
SFC Zoom  
001:Block1  
Step No.10

2/21/2022



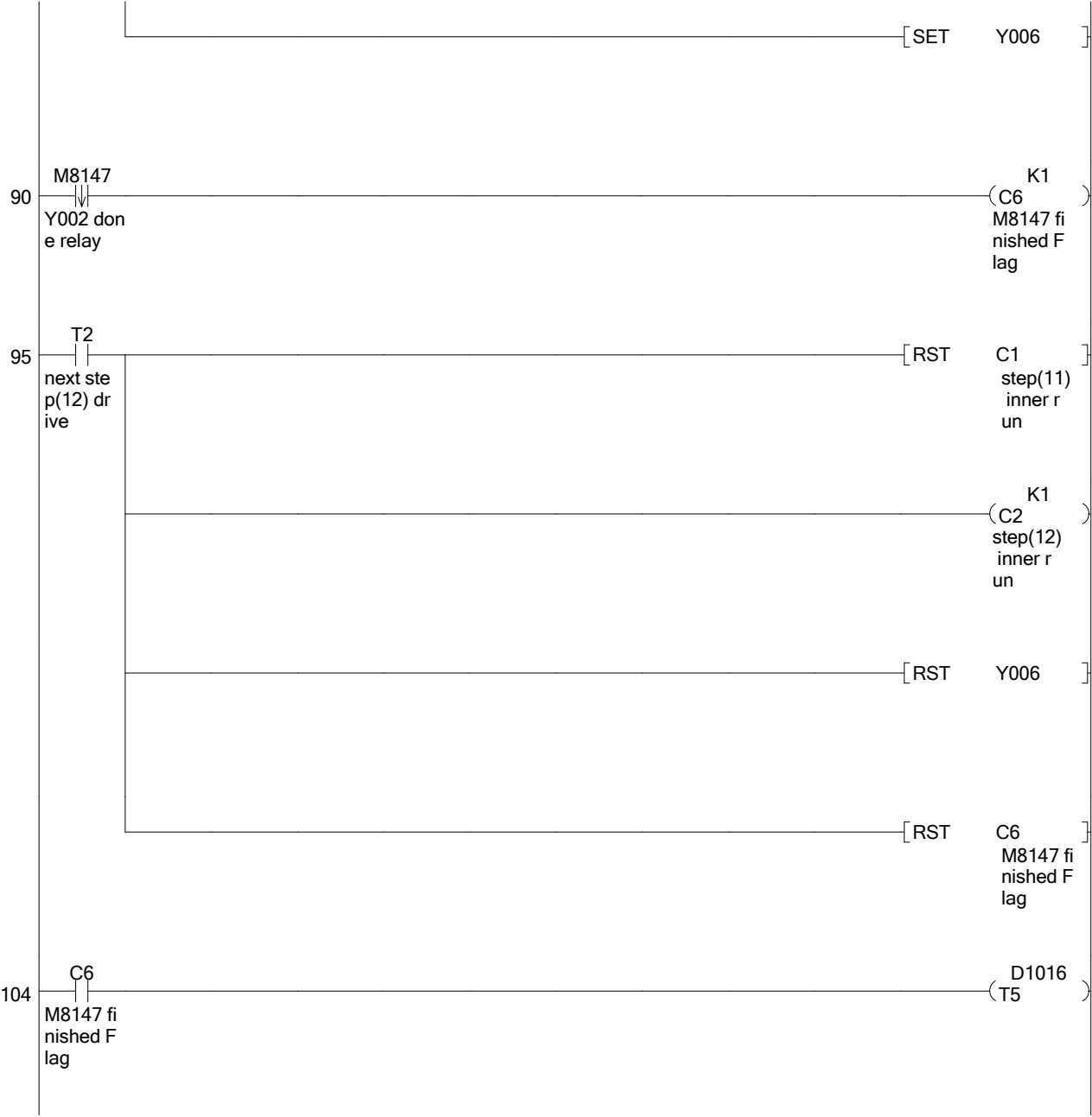
MELSAP3  
 Data Name : MAIN  
 SFC Zoom  
 001:Block1  
 Step No.11

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MELSAP3  
Data Name : MAIN  
SFC Zoom  
001:Block1  
Step No.11

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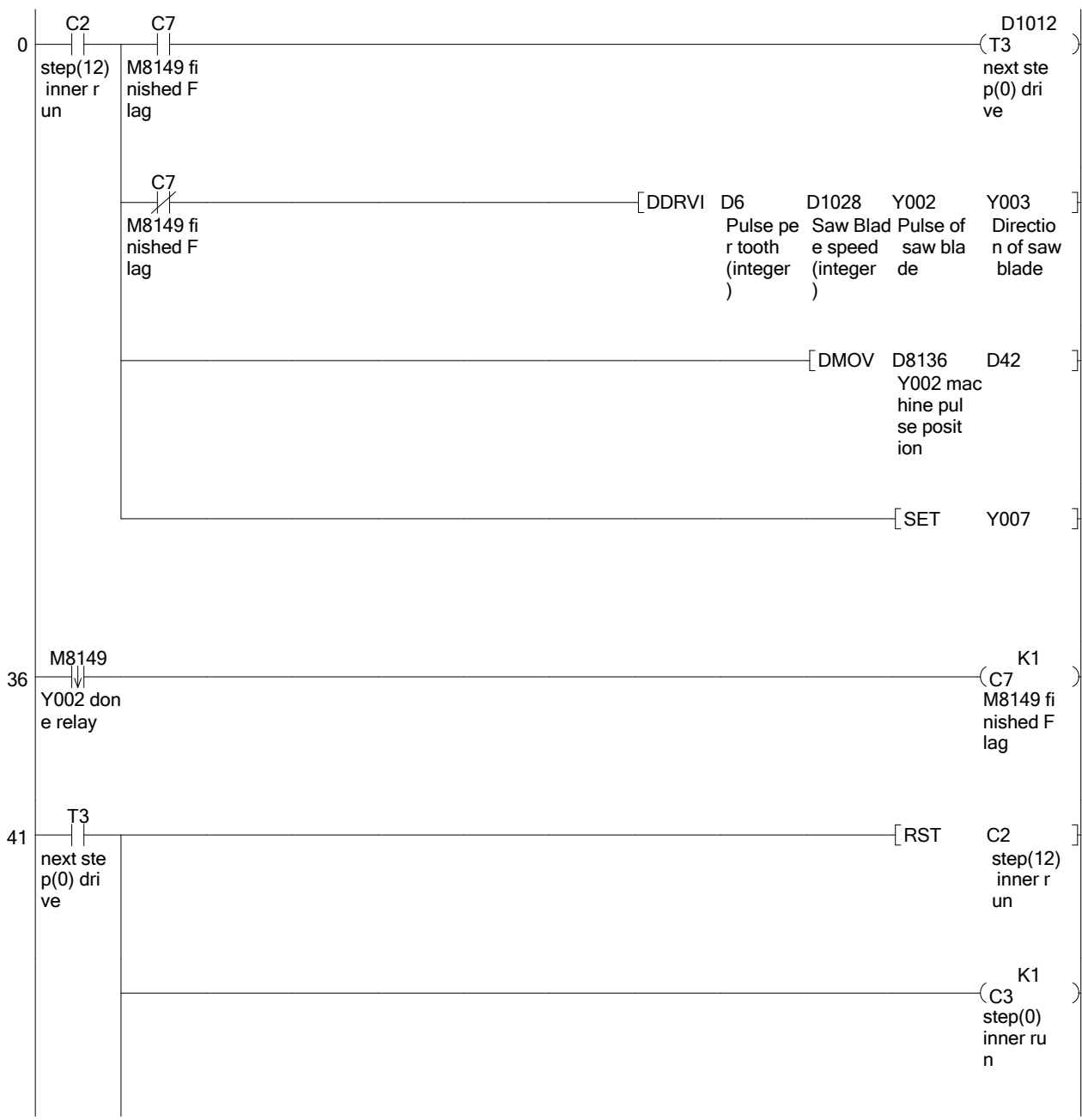
MELSAP3  
Data Name : MAIN  
SFC Zoom  
001:Block1  
Step No.11

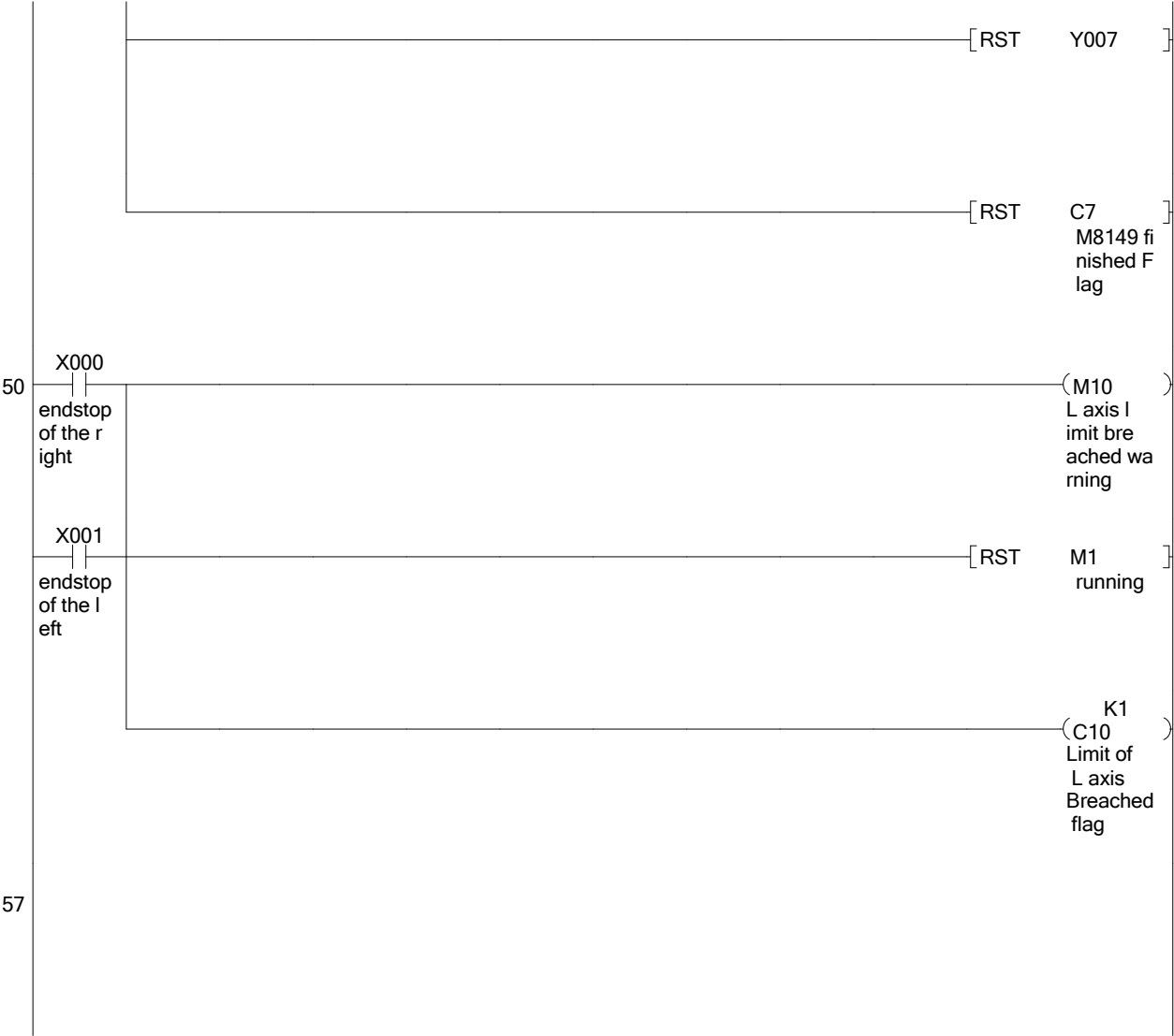
2/21/2022



MELSAP3  
Data Name : MAIN  
SFC Zoom  
001:Block1  
Step No.12

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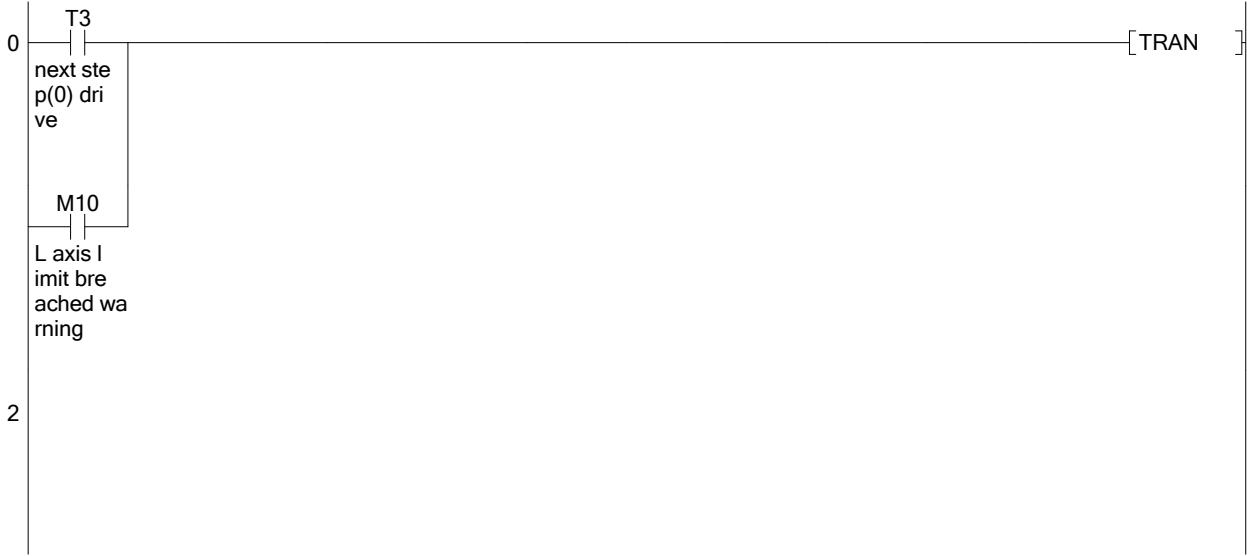
MELSAP3  
Data Name : MAIN  
SFC Zoom  
001:Block1  
Transition No.0

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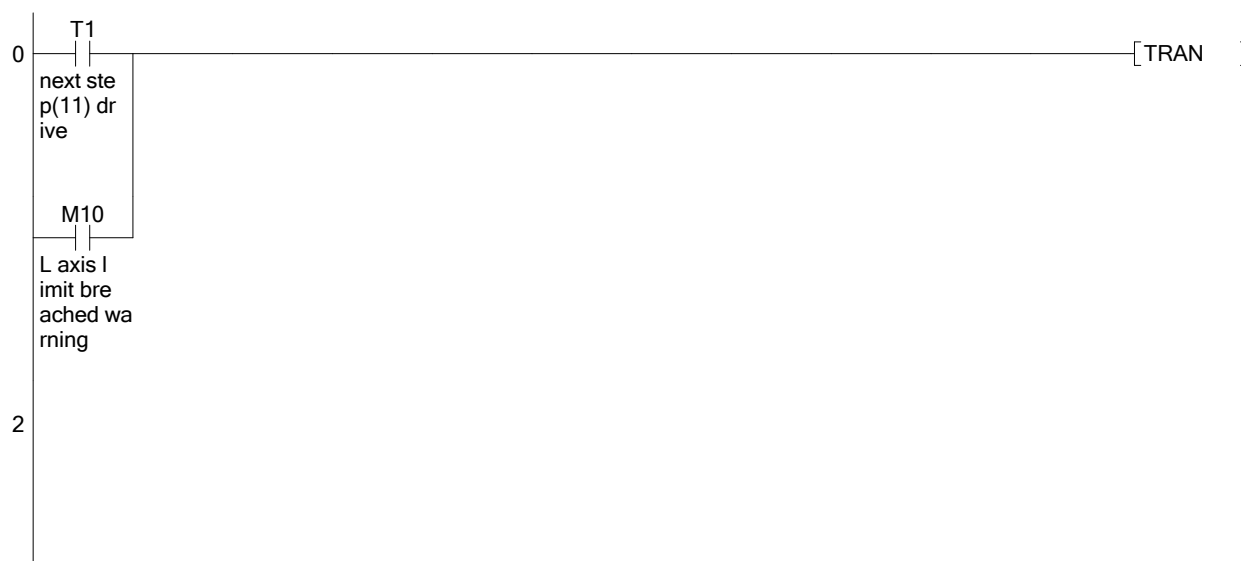
MELSAP3  
Data Name : MAIN  
SFC Zoom  
001:Block1  
Transition No.1

2/21/2022



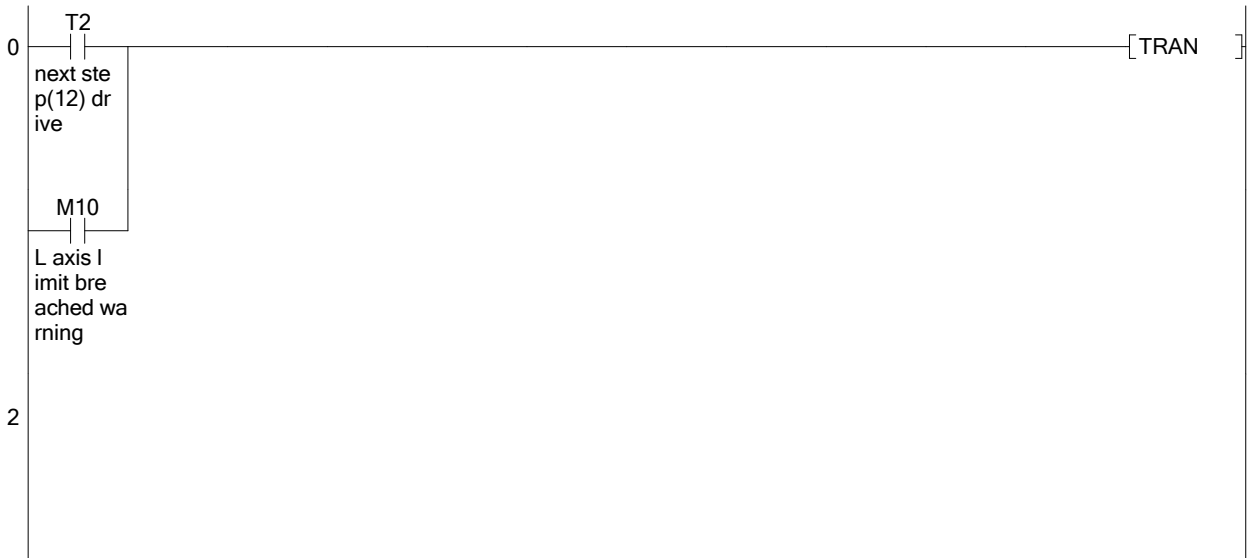
MELSAP3  
Data Name : MAIN  
SFC Zoom  
001:Block1  
Transition No.2

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MELSAP3  
Data Name : MAIN  
SFC Zoom  
001:Block1  
Transition No.3

2/21/2022



SFC Block	SFC Step	Step	Note
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Device Comment  
Data Name : COMMENT

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Device Name	Comment
M0	Update setting
M1	running
M2	reset tooth progress
M3	Manual move left
M4	Manual move right
M5	Load 0.1mm to L axis
M6	Load 1mm to L axis
M7	Load 10mm to L axis
M8	reset program coordinate
M9	reset machine coordinate
M10	L axis limit breached warning
M11	unlock limit
M12	Homing L axis
M13	Manual saw clock wise
M14	Manual saw counter clock wise
M8000	Update Input relay
M8147	Y002 done relay
M8149	Y002 done relay
X000	endstop of the right
X001	endstop of the left
X002	Pneumatic Up
X003	cylinder down
Y000	Pulse of L axis
Y001	Direction of L axis
Y002	Pulse of saw blade
Y003	Direction of saw blade
Y004	Pneumatic
D0	angle per tooth (real)
D2	angle per tooth (integer)
D4	tooth number (integer)
D6	Pulse per tooth (integer)
D8	Pulse per tooth (real)
D10	Tooth height (real)
D12	Tooth height pulse (real)
D14	Tooth height pulse (integer)
D16	tooth number (real)
D18	neg pulse tooth height (integer)
D20	Manual tooth height (real)
D22	Manual Pulse tooth height (real)
D24	Manual Pulse tooth height (int)
D28	Manual Pulse tooth height temp
D30	y000 program pulse position
D31	pulser per tooth temp
D32	y000 program position
D34	y000 machine position
D36	Input tooth number (real)
D38	temporary variable for L axis
D40	y000 program pulse (int)
D1000	transition time input (real)
D1002	piston time input (real)
D1004	L axis Grind speed
D1006	Saw Blade time
D1010	transition time temp (real)
D1012	transition time (integer)
D1014	piston time temp (real)
D1016	piston time (integer)
D1018	period per cycle
D1020	L axis speed (real)
D1022	L axis Speed (integer)
D1024	Period of a cycle (real)
D1026	Saw Blade speed (real)
D1028	Saw Blade speed (integer)
D1030	Y000 machine position saver
D8132	Y000 machine pulse position
D8136	Y002 machine pulse position
T0	first transition
T1	next step(11) drive
T2	next step(12) drive
T3	next step(0) drive
T4	Piston down delay
C0	step(10) inner run
C1	step(11) inner run
C2	step(12) inner run
C3	step(0) inner run
C4	tooth count progress
C5	M8147 finished Flag
C6	M8147 finished Flag
C7	M8149 finished Flag
C8	left flag
C9	right flag
C10	Limit of L axis Breached flag
C11	clock wise flag
C12	Counter clock wise flag