Data Name: MAIN

SFC Block (1, 1) 000:Block0

LD

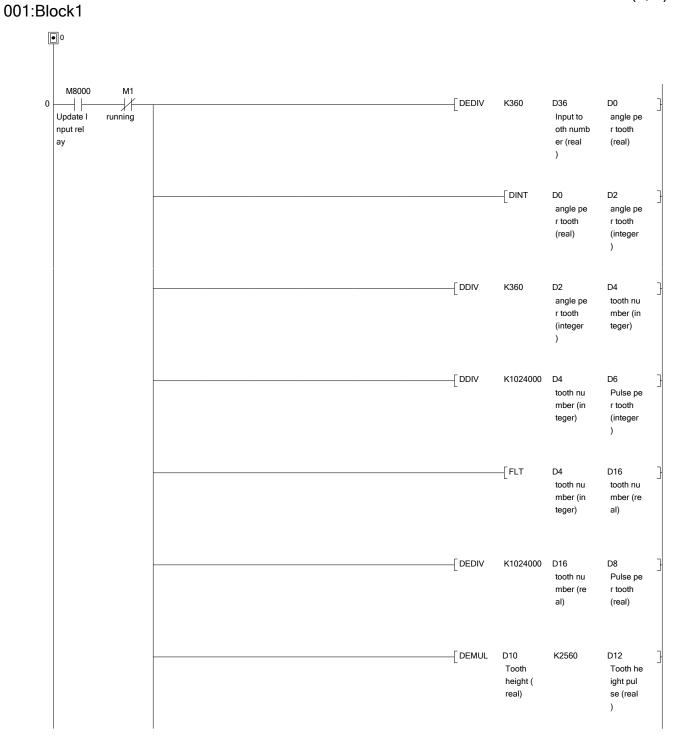
```
M8002

SET S0

DMOV D1030 D8132
Y000 mac Y000 mac hine pos hine pul ition sa se posit ver ion
```

Data Name: MAIN

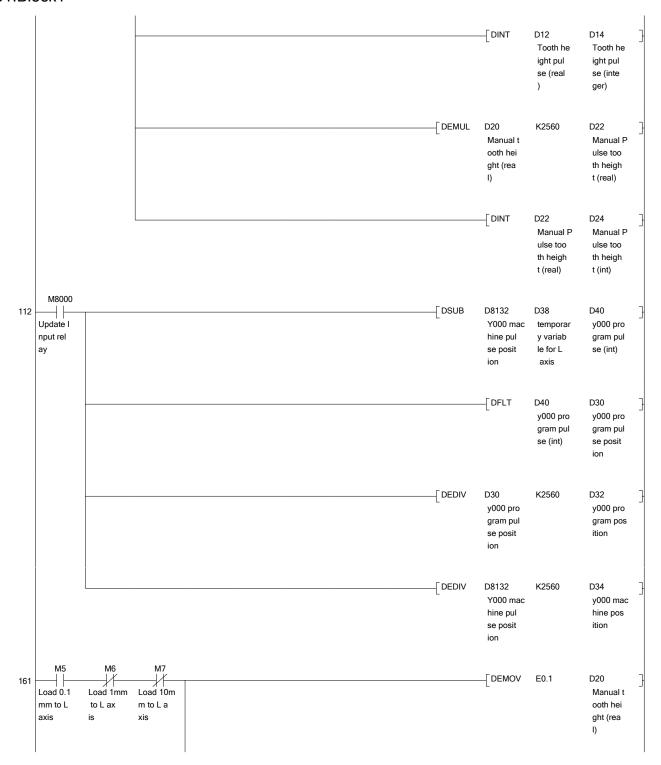
SFC Block (1, 1)



Data Name: MAIN

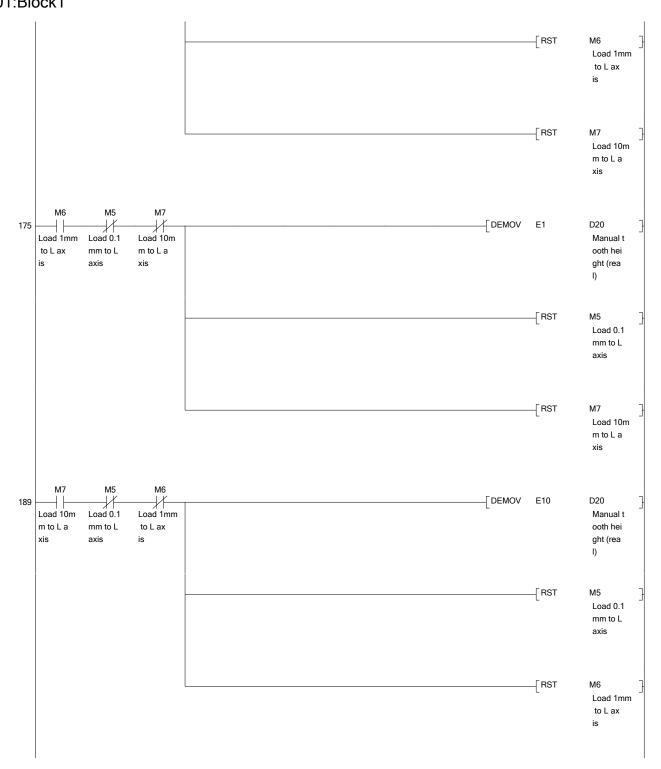
SFC Block 001:Block1

(2, 1)



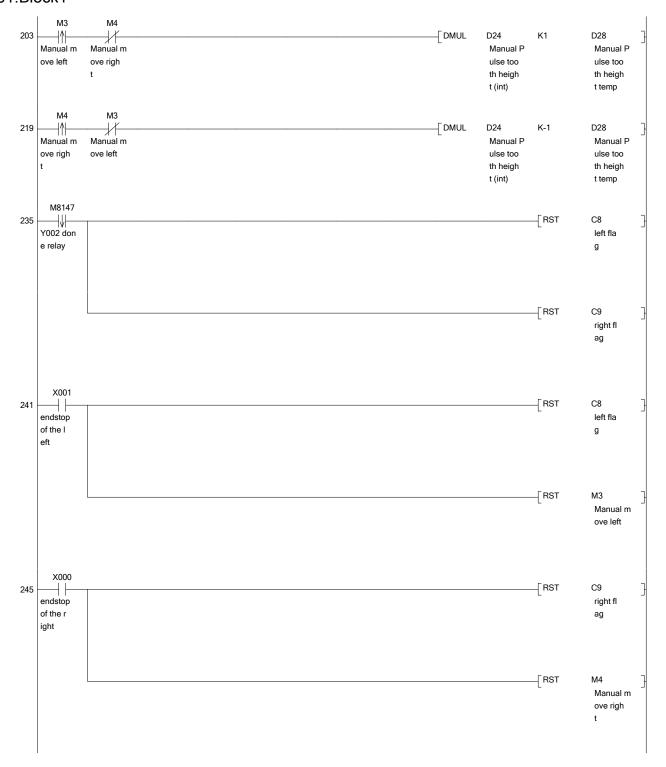
Data Name: MAIN

SFC Block (3, 1) 001:Block1



Data Name: MAIN

SFC Block (4, 1) 001:Block1



Data Name: MAIN

SFC Block (5, 1) 001:Block1

```
X001
                                                                                                                                              K1
                endstop
249
                                                                                                                                        -( C8
                                                                                                                                        left fla
     Manual m
     ove left
                of the I
                                                                                                                                        g
                 eft
                   X000
                                                                                                                                              K1
254
                                                                                                                                        (C9
     Manual m
                 endstop
                                                                                                                                        right fl
     ove righ
                of the r
                                                                                                                                        ag
                 ight
                   M14
       M13
259
       --|↑|-
                    #
                                                                                                    - DMUL
                                                                                                                D6
                                                                                                                            K1
                                                                                                                                         D31
     Manual s
                                                                                                                Pulse pe
                                                                                                                                         pulser p
     aw clock
                aw count
                                                                                                                r tooth
                                                                                                                                         er tooth
     wise
                er clock
                                                                                                                (integer
                                                                                                                                          temp
                 wise
                                                                                                                )
       M14
                    M13
      ---|↑|
                    #
                                                                                                    DMUL
                                                                                                                D6
                                                                                                                            K-1
                                                                                                                                         D31
275
     Manual s
                 Manual s
                                                                                                                Pulse pe
                                                                                                                                         pulser p
     aw count
                aw clock
                                                                                                                r tooth
                                                                                                                                         er tooth
     er clock
                 wise
                                                                                                                (integer
                                                                                                                                          temp
     wise
                                                                                                                )
      M8149
                                                                                                                           RST
       \dashv \downarrow \vdash
                                                                                                                                         C11
291
                                                                                                                                         clock wi
     Y002 don
                                                                                                                                         se flag
     e relay
                                                                                                                           RST
                                                                                                                                         C12
                                                                                                                                         Counter
                                                                                                                                         clock wi
                                                                                                                                         se flag
                   X002
       M13
                                                                                                                                             K1
297
                                                                                                                                        (C11
     Manual s
                Pneumati
                                                                                                                                        clock wi
     aw clock
                                                                                                                                        se flag
     wise
                   X002
        M14
302
                                                                                                                                        (C12
     Manual s
                Pneumati
                                                                                                                                        Counter
     aw count
                c Up
                                                                                                                                        clock wi
     er clock
                                                                                                                                        se flag
     wise
```

Data Name: MAIN

SFC Block (6, 1) 001:Block1

M1 running 307 DDRVI D31 K50000 Y002 Y003 Pulse of Directio clock wi pulser p se flag n of saw er tooth saw bla blade temp de C12 -[RST M13 Counter Manual s clock wi aw clock se flag wise RST M14 Manual s aw count er clock wise M1 C8 running 331 DDRVI D28 K50000 Y000 Y001 left fla Manual P Pulse of Directio ulse too L axis n of L \boldsymbol{a} th heigh xis t temp C9 RST M4 right fl Manual m ove righ RST М3 Manual m ove left C10 D1012 M1 М3 M4 M12 Manual m Limit of Homing L 355 (T0 running Manual m first tr ove left ove righ L axis axis ansition Breached flag RST 363 C3 first tr step(0) ansition inner ru

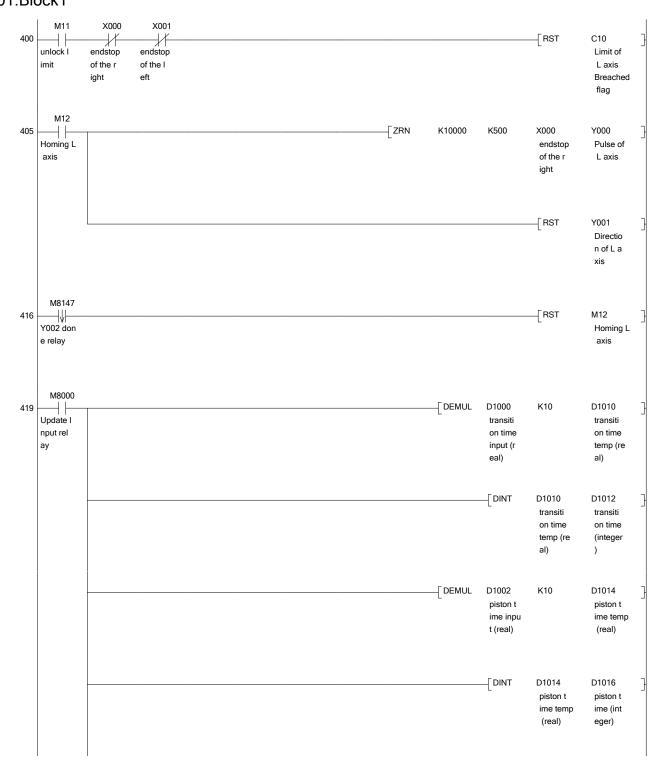
Data Name: MAIN

SFC Block (7, 1) 001:Block1

K1 (C0 step(10) inner r un _[RST Y000 Pulse of L axis _[SET Y004 Pneumati D4 371 -(C4 step(10) tooth co inner r unt prog un ress RST 375 M1 tooth co running unt prog ress M2 RST C4 377 reset to tooth co oth prog unt prog ress ress M8 DMOV 380 D8132 D38 Y000 mac reset pr temporar ogram co hine pul y variab ordinate se posit le for L ion axis DMOV K0 D8132 390 Y000 mac reset ma chine co hine pul ordinate se posit ion

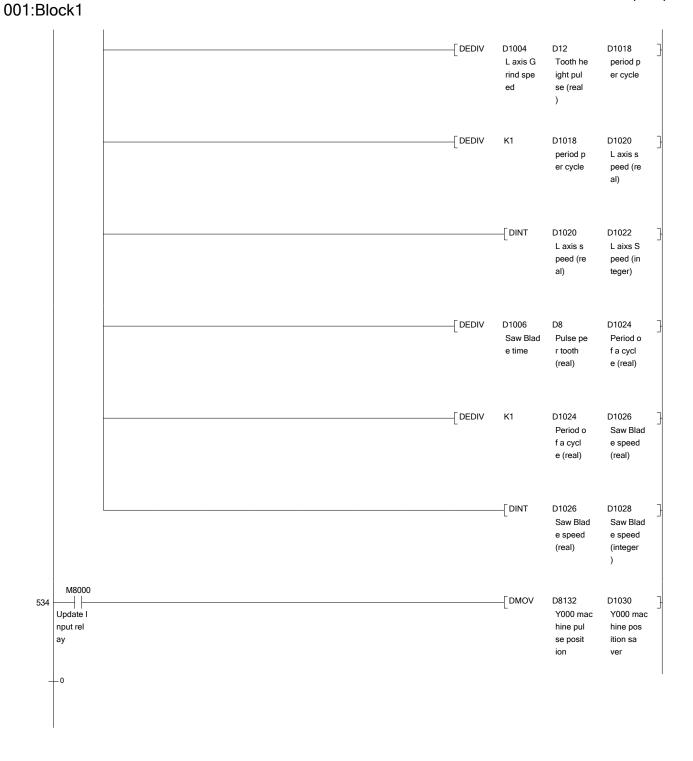
Data Name: MAIN

SFC Block (8, 1) 001:Block1



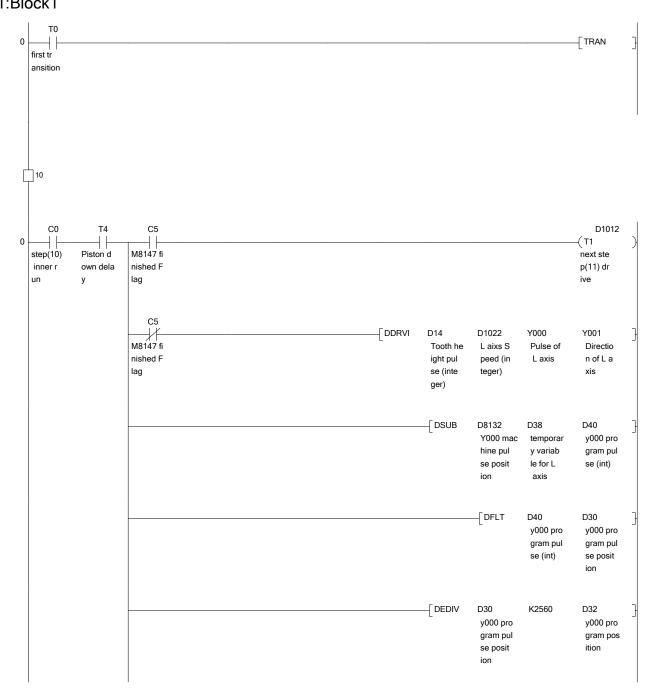
Data Name: MAIN

SFC Block (9, 1)



Data Name: MAIN

SFC Block (10, 1) 001:Block1



Data Name: MAIN

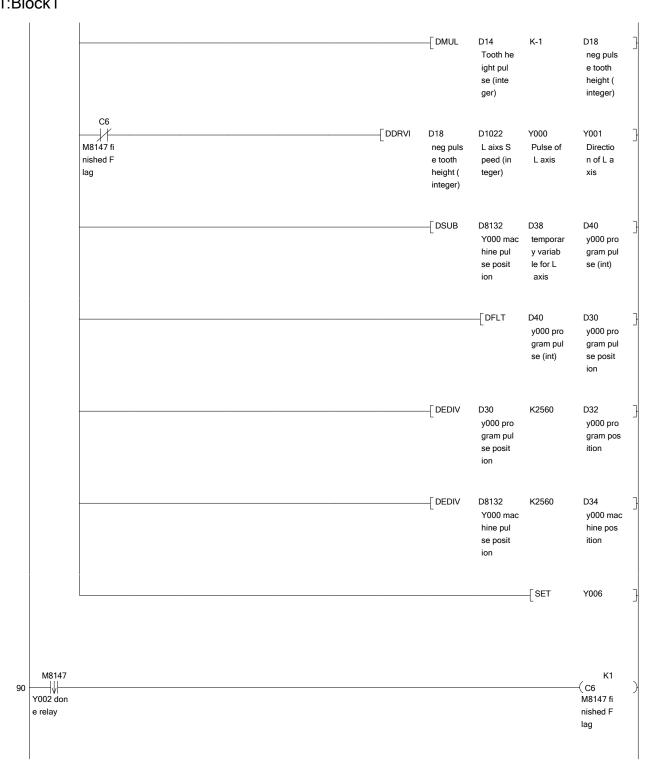
SFC Block (11, 1) 001:Block1

```
DEDIV
                                                                                                          D8132
                                                                                                                     K2560
                                                                                                                                  D34
                                                                                                                                  y000 mac
                                                                                                          Y000 mac
                                                                                                          hine pul
                                                                                                                                  hine pos
                                                                                                          se posit
                                                                                                                                  ition
                                                                                                          ion
                                                                                                                     _[ SET
                                                                                                                                 Y005
      X003
                                                                                                                                    D1016
76
                                                                                                                                 -( T4
   cylinder
                                                                                                                                 Piston d
    down
                                                                                                                                 own dela
                                                                                                                                 у
     M8147
   Y002 don
                                                                                                                                 -( C5
                                                                                                                                 M8147 fi
                                                                                                                                 nished F
   e relay
                                                                                                                                 lag
                                                                                                                     RST
85
                                                                                                                                 C0
   next ste
                                                                                                                                  step(10)
   p(11) dr
                                                                                                                                  inner r
   ive
                                                                                                                                  un
                                                                                                                                 (C1
                                                                                                                                 step(11)
                                                                                                                                 inner r
                                                                                                                                 un
                                                                                                                     RST
                                                                                                                                 Y005
                                                                                                                     -[RST
                                                                                                                                 C5
                                                                                                                                  M8147 fi
                                                                                                                                  nished F
                                                                                                                                  lag
```

MELSAP3 2/21/2022 Data Name: MAIN (12, 1)SFC Block 001:Block1 X000 (M10 L axis I endstop of the r imit bre ight ached wa rning X001 _[RST M1 \dashv endstop running of the I eft K1 (C10 Limit of L axis Breached flag TRAN next ste p(11) dr ive M10 L axis I imit bre ached wa rning 11 C6 X002 D1012 -(T2 step(11) M8147 fi Pneumati next ste nished F inner r с Up p(12) dr un lag ive

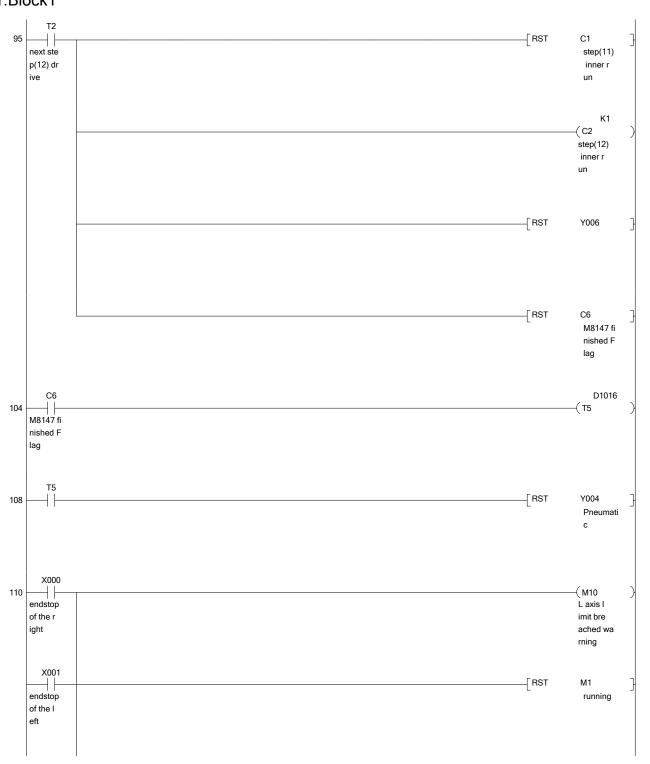
Data Name: MAIN

SFC Block (13, 1) 001:Block1



Data Name: MAIN

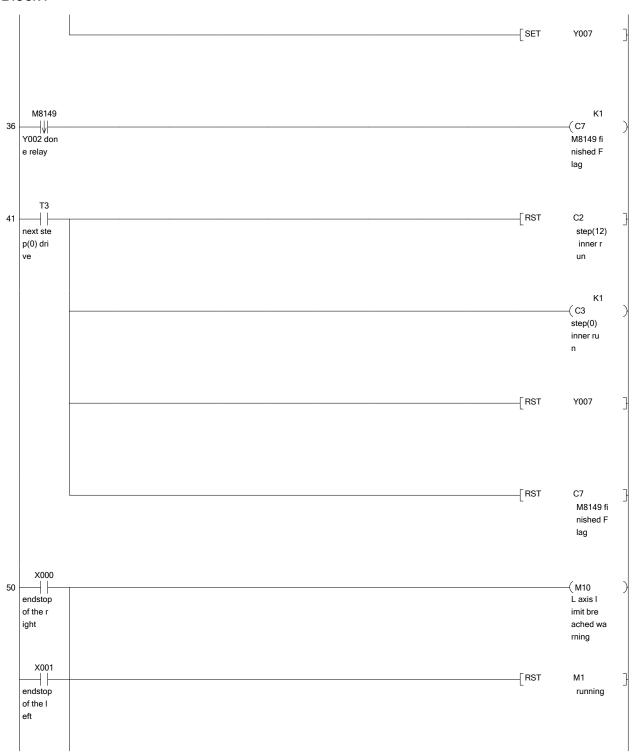
SFC Block (14, 1) 001:Block1



MELSAP3 2/21/2022 Data Name: MAIN (15, 1)SFC Block 001:Block1 K1 (C10 Limit of L axis Breached flag TRAN next ste p(12) dr ive M10 L axis I imit bre ached wa rning 12 D1012 M8149 fi (T3 step(12) next ste inner r nished F p(0) dri lag ve C7 M8149 fi DDRVI D6 D1028 Y002 Y003 Pulse pe Saw Blad Pulse of Directio nished F n of saw r tooth e speed saw bla lag (integer (integer de blade DMOV D8136 D42 Y002 mac hine pul se posit ion

MELSAP3 2/21/2022
Data Name : MAIN
SFC Block (16, 1)

001:Block1



```
MELSAP3
                                                                                                      2/21/2022
Data Name : MAIN
                                                                                                           (17, 1)
SFC Block
001:Block1
                                                                                                            K1
                                                                                                        (C10
                                                                                                        Limit of
                                                                                                        L axis
                                                                                                        Breached
                                                                                                        flag
         next ste
                                                                                                        TRAN
         p(0) dri
         ve
           M10
         L axis I
         imit bre
         ached wa
         rning
```

ا ک

Data Name : MAIN SFC Block List

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				

Data Name : MAIN SFC Comment List

001:Block1

Step	Comment
S0	
S10	
S11	
S12	

Data Name : MAIN

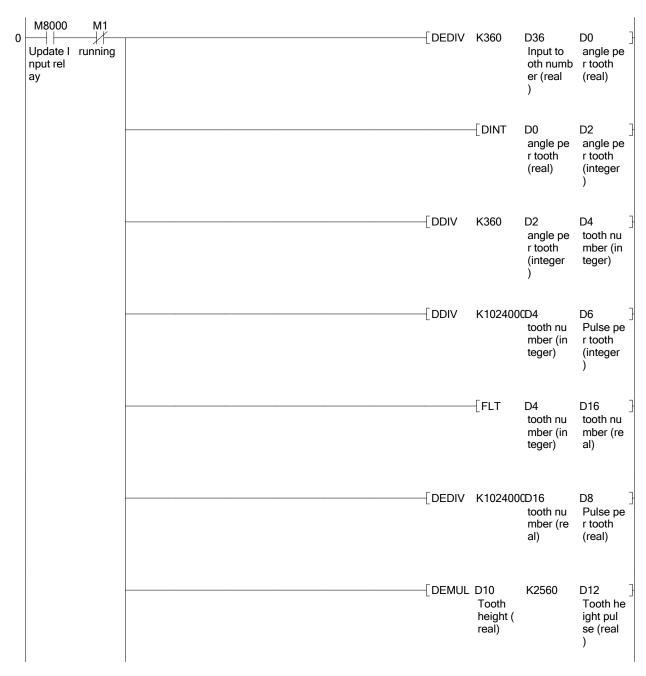
SFC Zoom 000:Block0

```
M8002

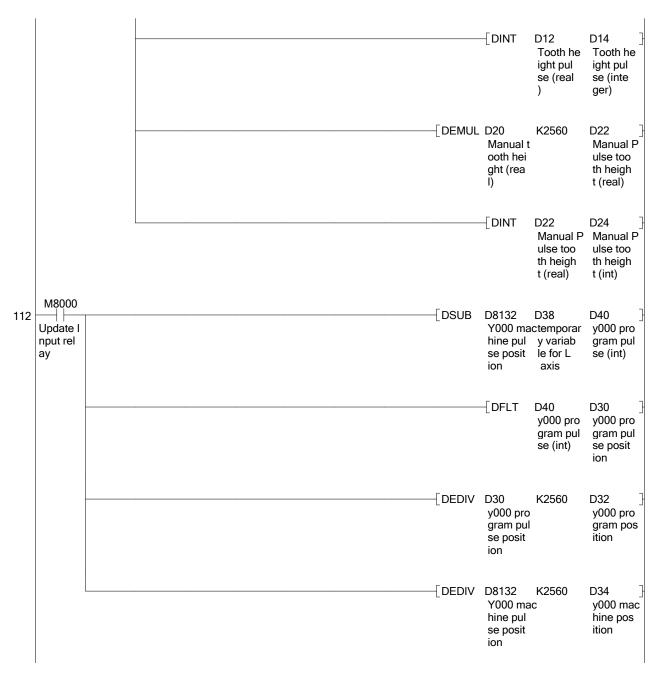
[SET S0]

[DMOV D1030 D8132]
Y000 mac Y000 mac hine pos hine pul ition sa se posit ver ion
```

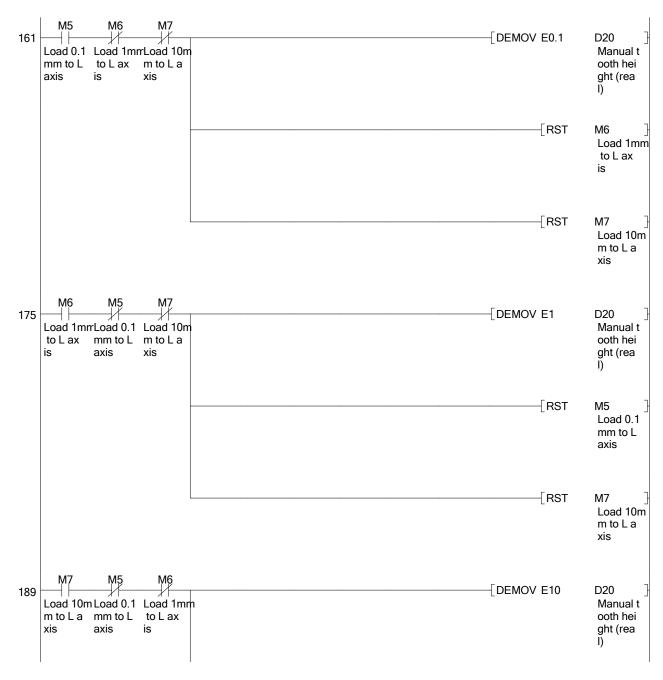
Data Name: MAIN



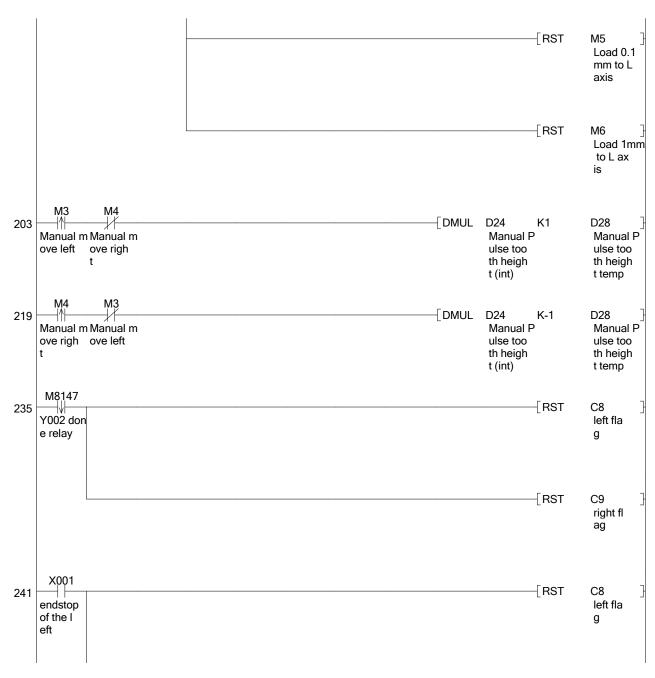
Data Name: MAIN



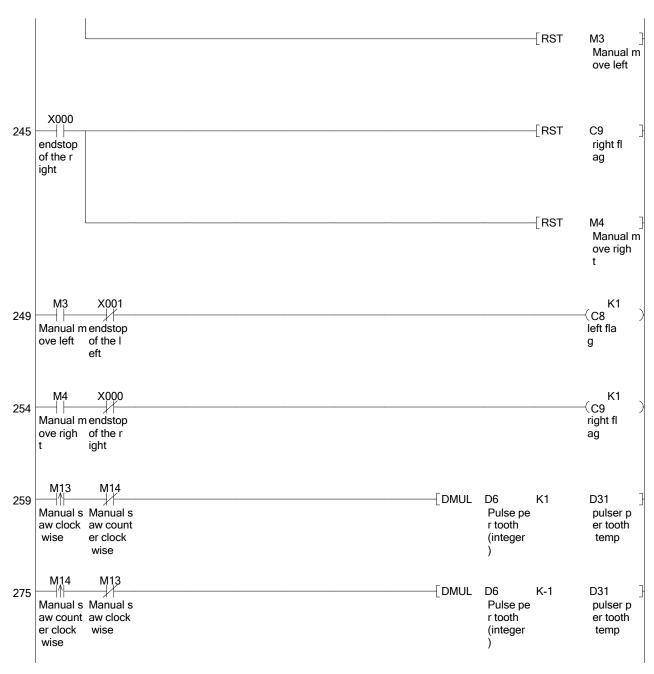
Data Name: MAIN



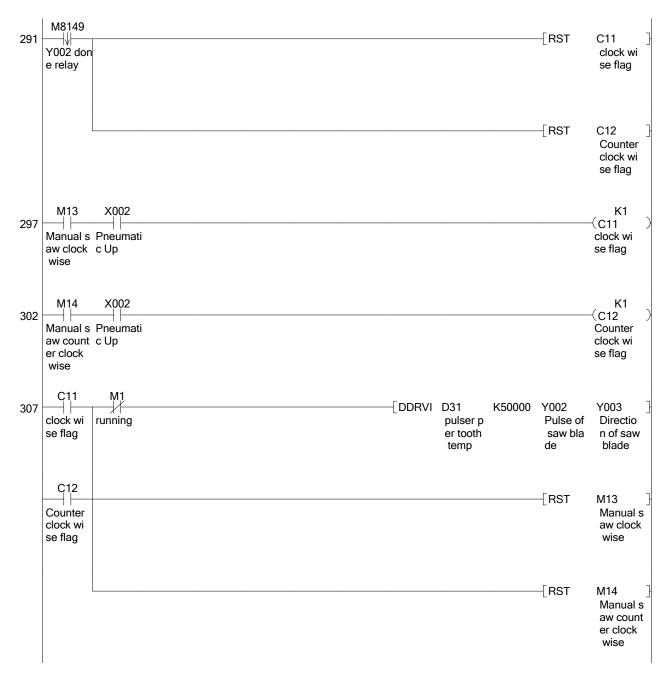
Data Name: MAIN



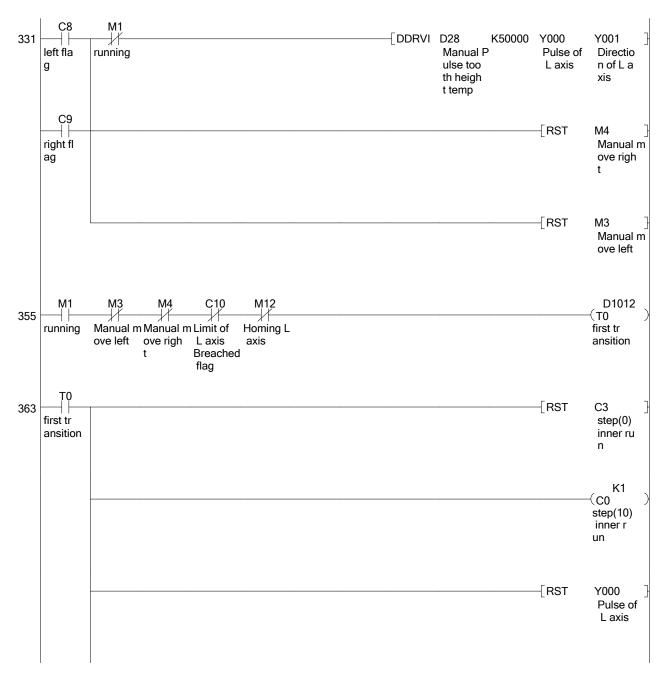
Data Name: MAIN



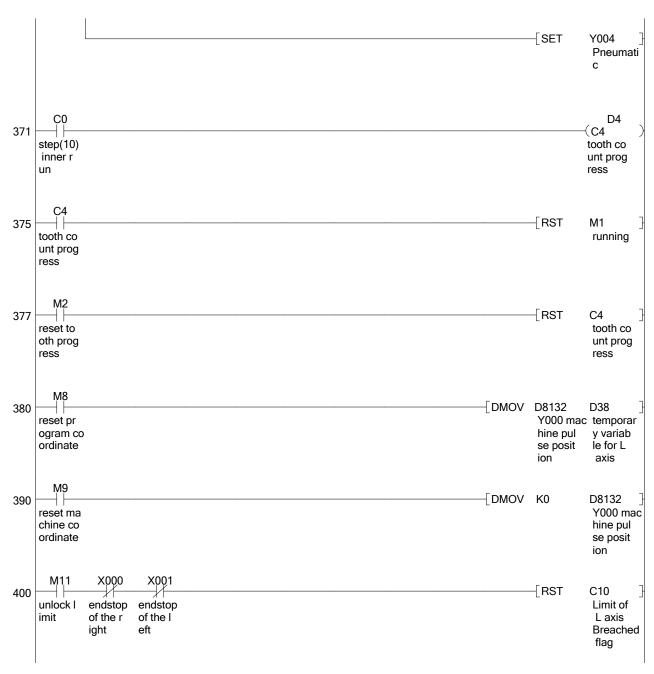
Data Name: MAIN



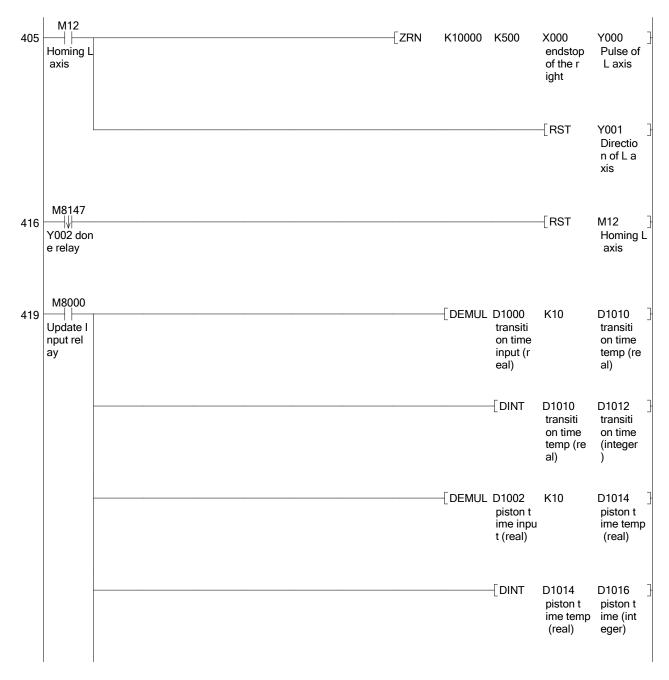
Data Name: MAIN



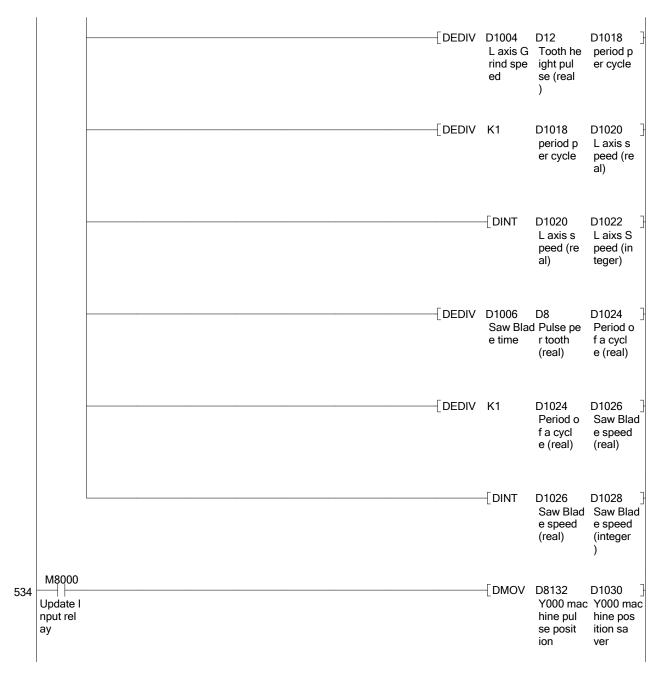
Data Name: MAIN



Data Name: MAIN



Data Name: MAIN

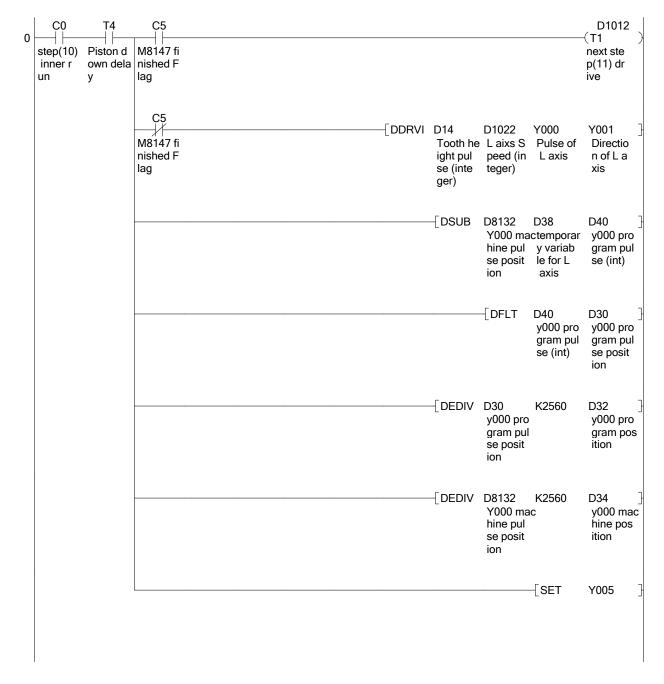


Data Name : MAIN

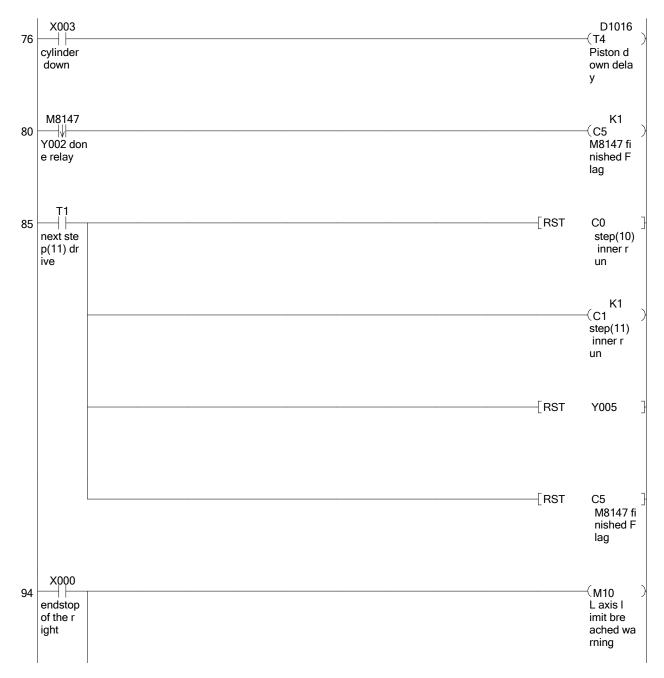
SFC Zoom 001:Block1 Step No.0

544

Data Name: MAIN

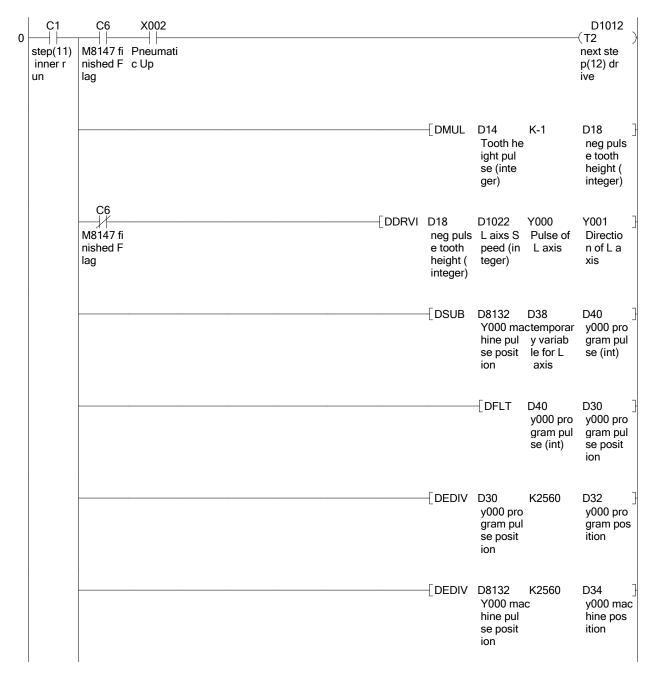


Data Name: MAIN

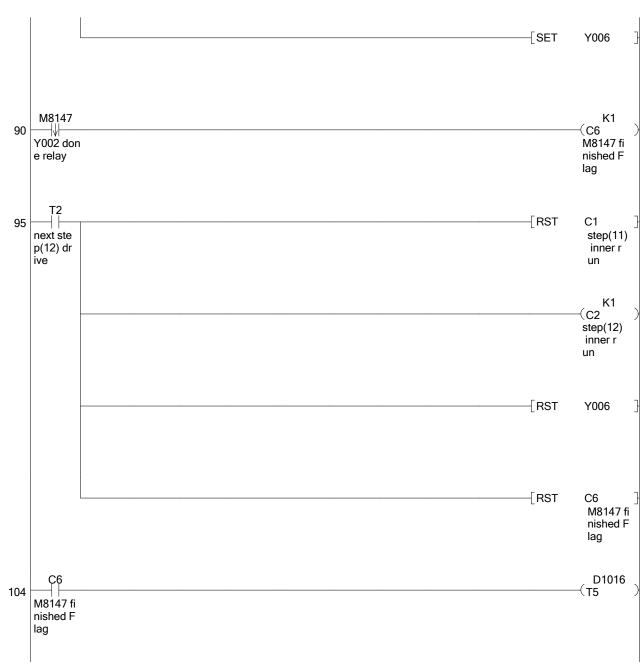


Data Name: MAIN

Data Name: MAIN



Data Name: MAIN



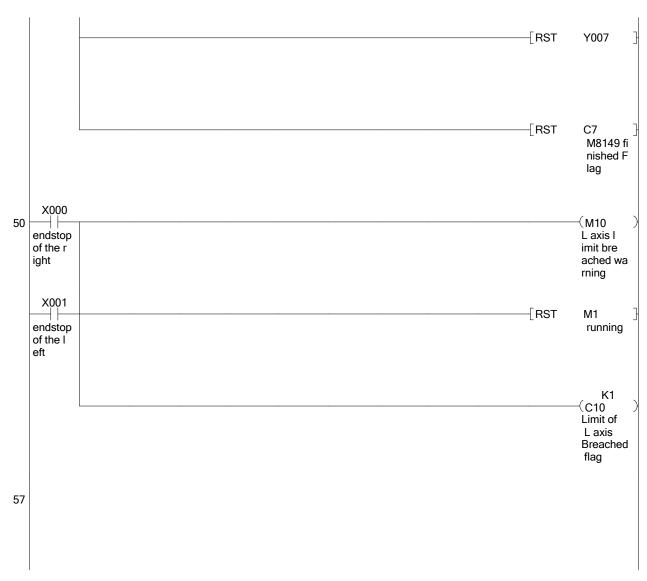
Data Name: MAIN

```
108
                                                                                                        RST
                                                                                                                   Y004
                                                                                                                   Pneumati
      X000
110
                                                                                                                  (M10
     endstop
                                                                                                                  L axis I
    of the r
                                                                                                                  imit bre
                                                                                                                  ached wa
                                                                                                                  rning
      X001
                                                                                                        -[RST
    endstop
                                                                                                                   M1
                                                                                                                   running
    of the I
                                                                                                                  K1
C10
Limit of
                                                                                                                  L axis
Breached
                                                                                                                   flag
117
```

Data Name: MAIN

```
D1012
                                                                                                           (T3
   step(12) M8149 fi
                                                                                                           next ste
    inner r
             nished F
                                                                                                           p(0) dri
                                                                                                           vè
   un
             lag
                                                                     DDRVI D6
                                                                                       D1028 Y002
                                                                                                            Y003
             M8149 fi
                                                                               Pulse pe Saw Blad Pulse of
                                                                                                            Directio
             nished F
                                                                               r tooth
                                                                                        e speed saw bla
                                                                                                            n of saw
                                                                                                             blade
                                                                               (integer
                                                                                        (integer de
             lag
                                                                                        -√DMOV D8136
                                                                                                            D42
                                                                                                  Y002 mac
                                                                                                  hine pul
                                                                                                  se posit
                                                                                                  ion
                                                                                                 -[SET
                                                                                                            Y007
    M8149
36
                                                                                                           (C7
    Y002 don
                                                                                                           M8149 fi
                                                                                                           nished F
   e relay
                                                                                                           lag
                                                                                                 RST
                                                                                                            C2
   next ste
p(0) dri
                                                                                                            step(12)
inner r
   ve
                                                                                                            un
                                                                                                               K1
                                                                                                           (C3
                                                                                                           step(0)
                                                                                                           inner ru
                                                                                                           n
```

Data Name: MAIN



Data Name: MAIN

```
TO TRAN

first tr
ansition
```

Data Name: MAIN

```
T3

next ste p(0) dri ve

M10

L axis I imit bre ached wa rning

2
```

Data Name: MAIN

```
T1
next ste
p(11) dr
ive

M10
L axis I
imit bre
ached wa
ming

2
```

Data Name : MAIN

```
T2
next ste
p(12) dr
ive

M10
L axis I
imit bre
ached wa
rning

2
```

Data Name : MAIN SFC Note List

SFC Block SFC Step Step	Note
-------------------------	------

Device Comment Data Name : COMMENT

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 Laxis
M6	Load 1mm to Laxis
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 Laxis
M13	Manual saw clock wise
M14	Manual saw counter clock wise
M8000	Update Input relay
M8147	Y002 done relay
M8149	Y002 done relay
	endstop of the right
X001	endstop of the left
X002	Pneumatic Up
	cylinder down
	Pulse of Laxis
Y001	Direction of L axis
Y002	Pulse of saw blade
	Direction of saw blade
Y004	Pneumatic
	angle per tooth (real)
	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 toath height (integer)
D20	Manual tooth height (real)
D22	Manual Pulse tooth height (real)
D24	Manual Pulse tooth height (int)
	Manual Pulse tooth height temp
D30	y000 program pulse position
D31 D32	pulser per tooth temp
D34	y000 program position
D36	y000 machine position
D38	Input tooth number (real)
D36 D40	temporary variable for L axis y000 program pulse (int)
D1000	transition time fruit (real)
D1000	tradistructure input (real)
D1002	pssort uniterripor (real) Laxis Grind speed
D1006	Lans comma speed
	God nation unit
	transition time (integer)
D1014	transmort more (megger) piston time temp (real)
	pason into earry (reary piston time (integer)
D1018	pisori unire (integler) periori per cycle
D1020	perior per cycles Laxis Speed (real)
D1022	Laks Speed (tell)
D1024	L axis opecu (mingur) Period of a cycle (real)
D1026	Samo Blade speed (real)
D1028	Saw Blade speed (integer)
D1030	Y000 machine position saver
D8132	Y000 machine pulse position
	Y002 machine pulse position
	first transition
T1	next step(11) drive
T2	next step(12) drive
T3	next step(0) drive
	Piston down delay
C0	step(10) inner run
	step(11) inner run
C2	step(12) inner run
C3	step(0) inner run
C4	tooth count progress
	M8147 finished Flag
C6	M8147 finished Flag
	M8149 finished Flag
C8	left flag
C9	right flag
	Limit of Laxis Breached flag
C11	clock wise flag
C12	Counter clock wise flag
_	