

000000  
(000000)

[Nombre de programa : General]

[Nombre de sección : \_Inicio\_Salto]

Salto (si el PLC de seguridad no esta OK )

I: 3.03

OLD\_X16

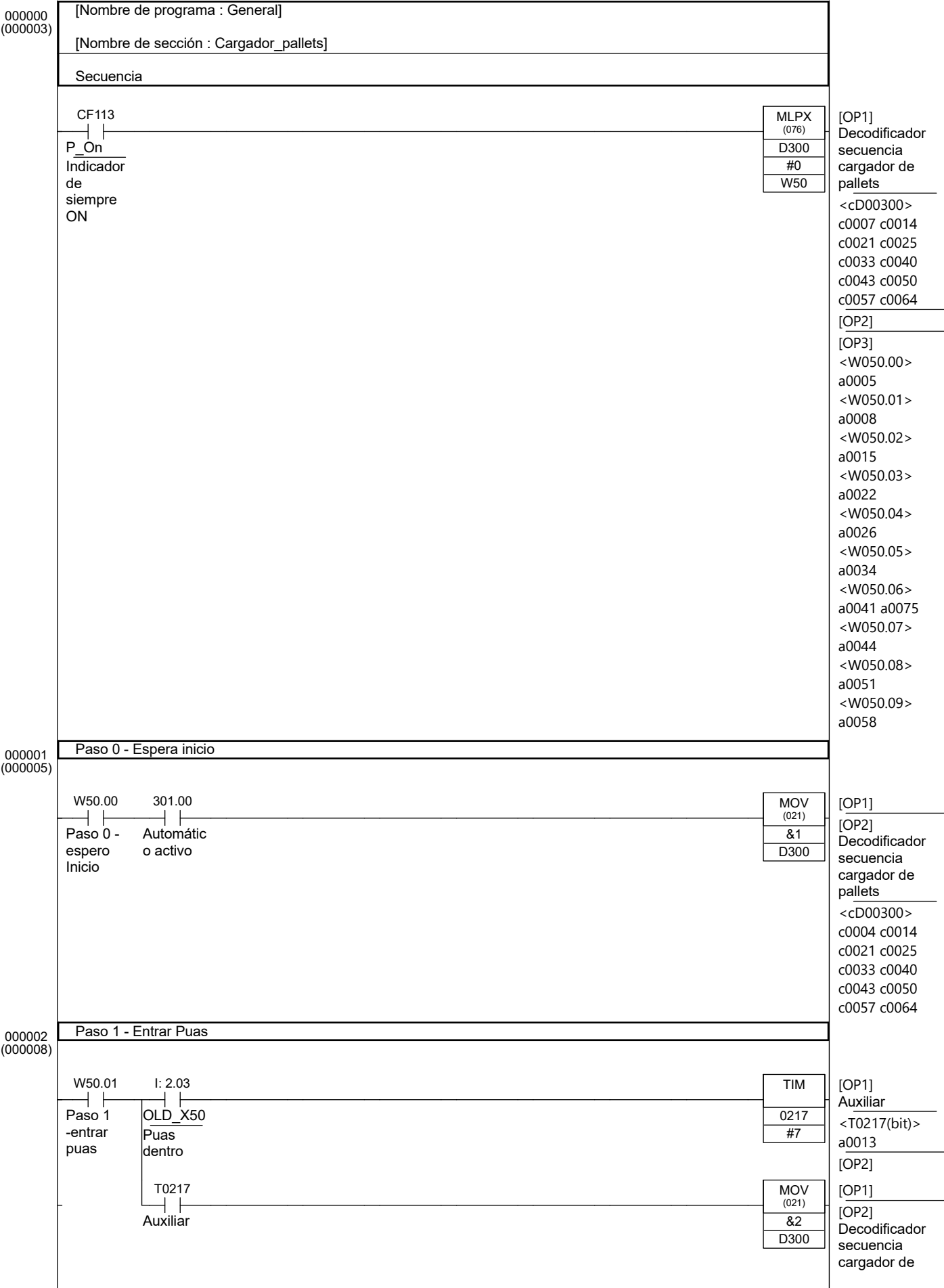
PLC

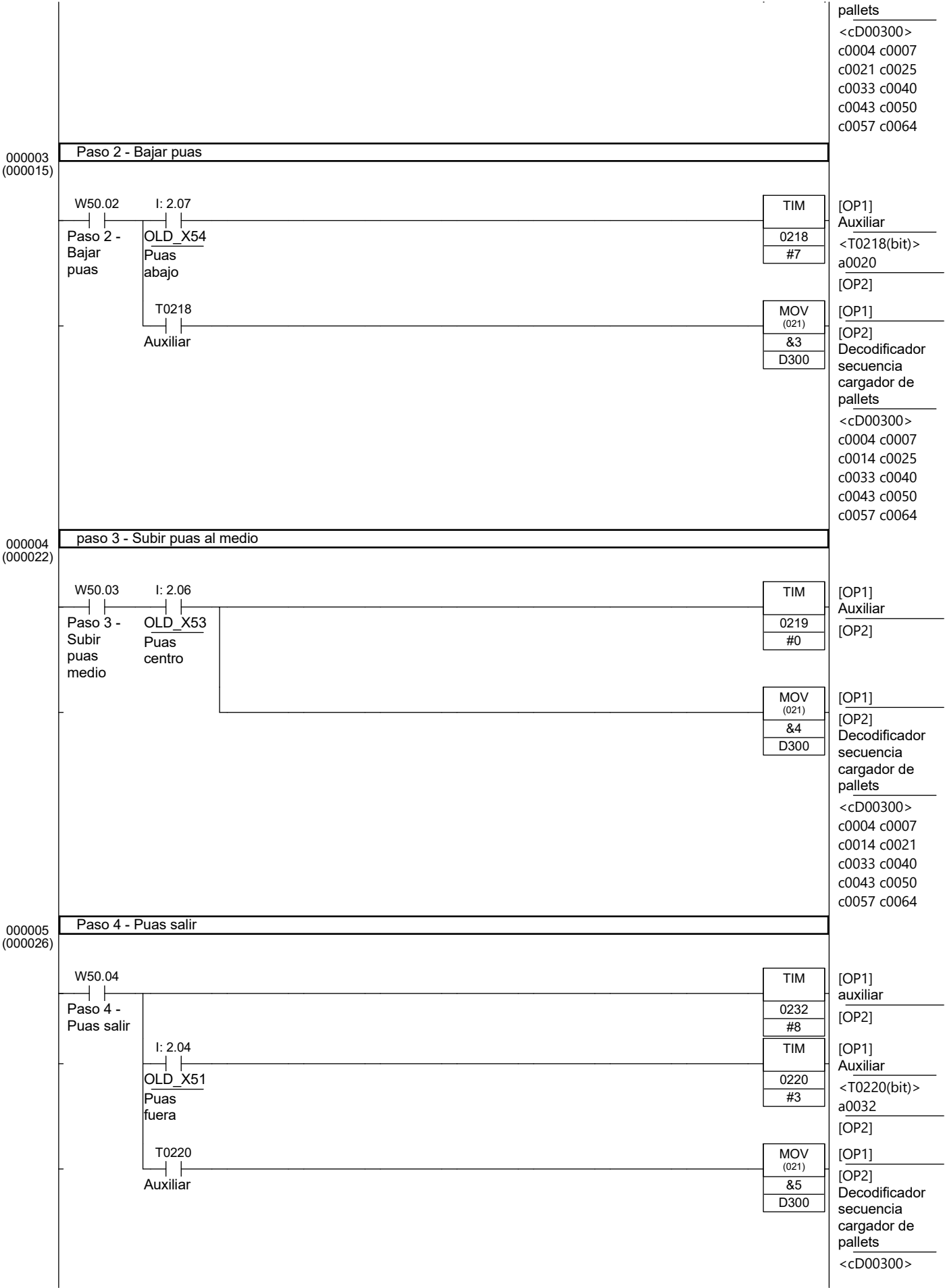
seguridad

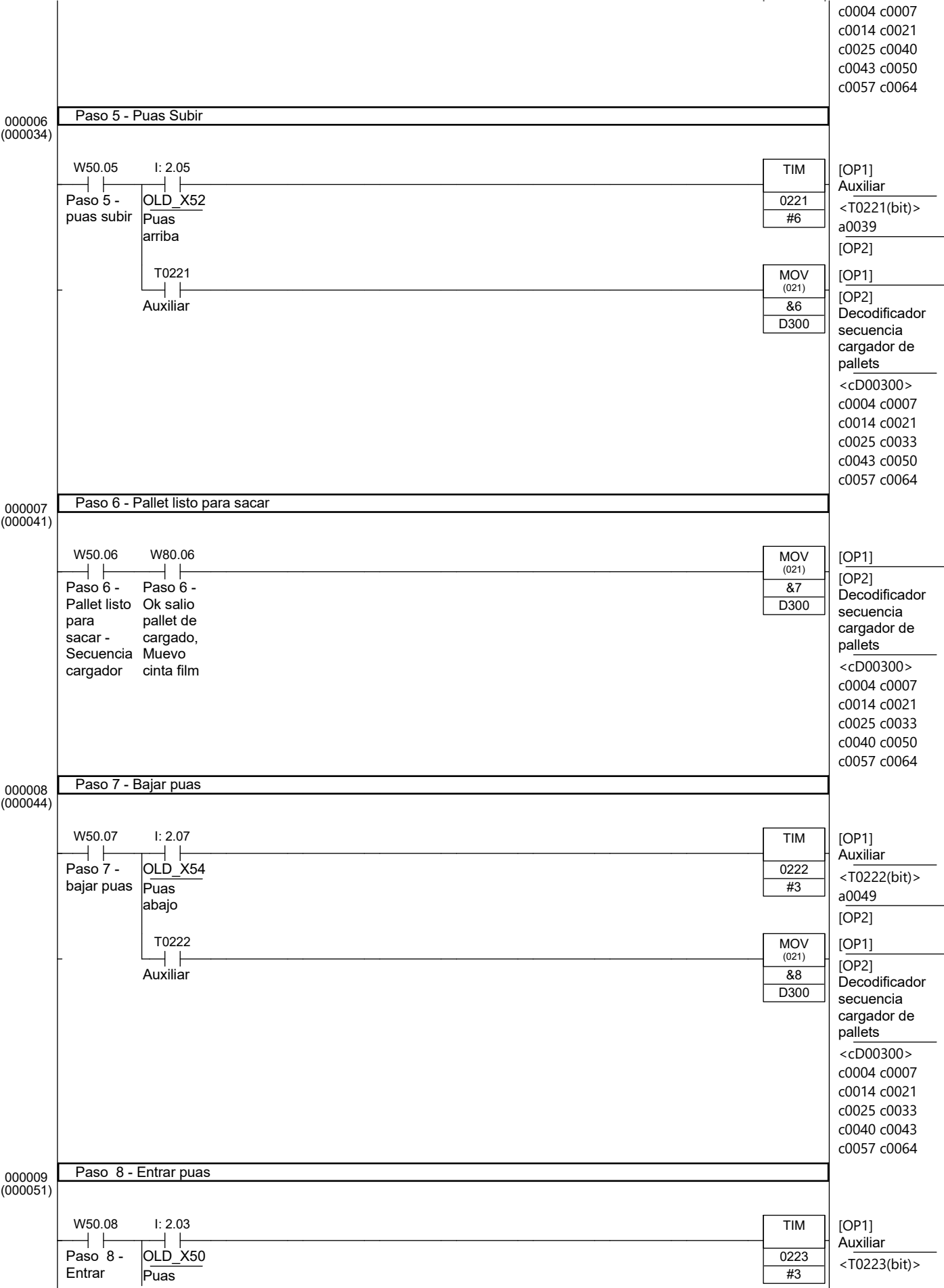
OK=1

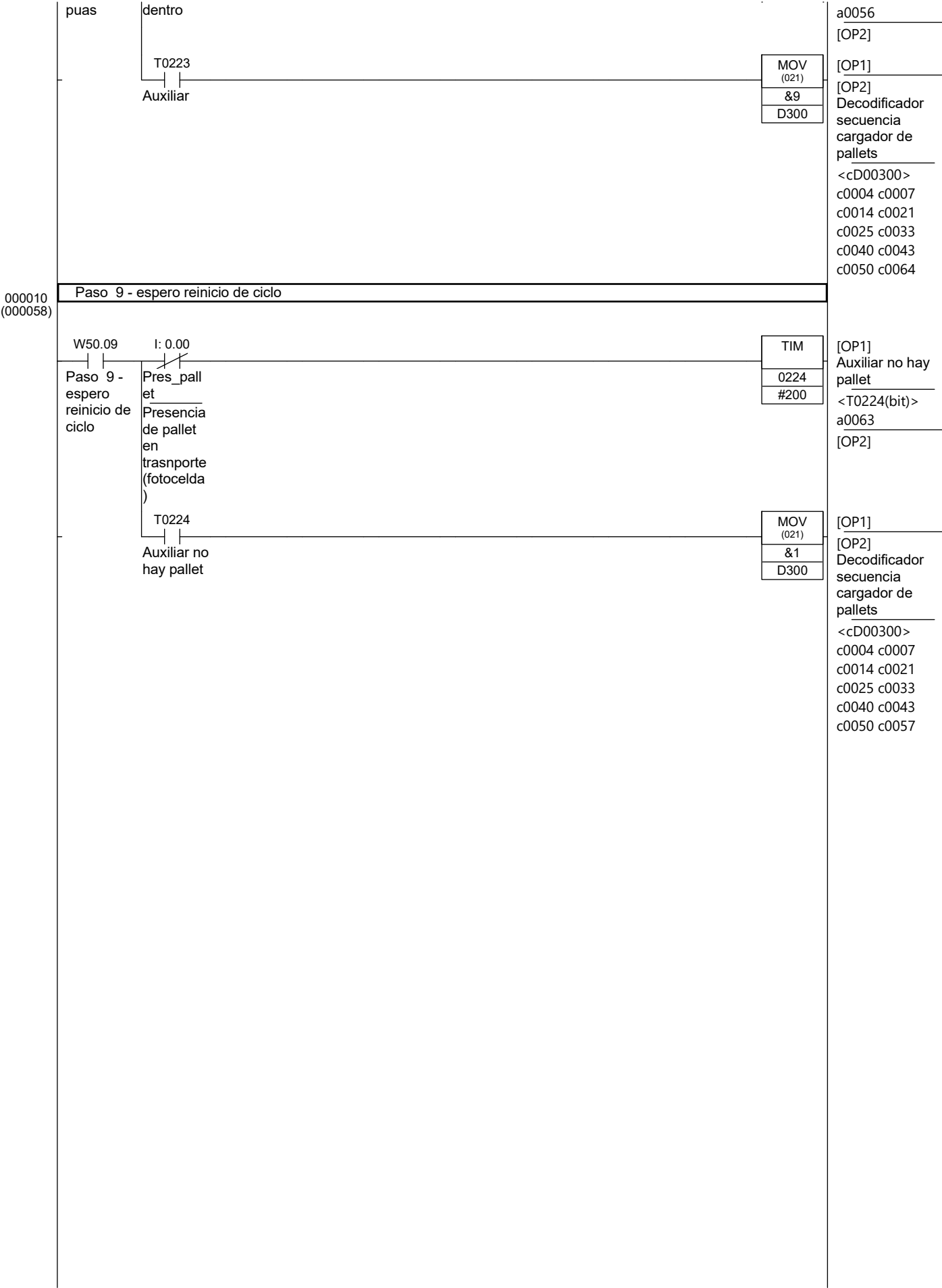
JMP  
(004)

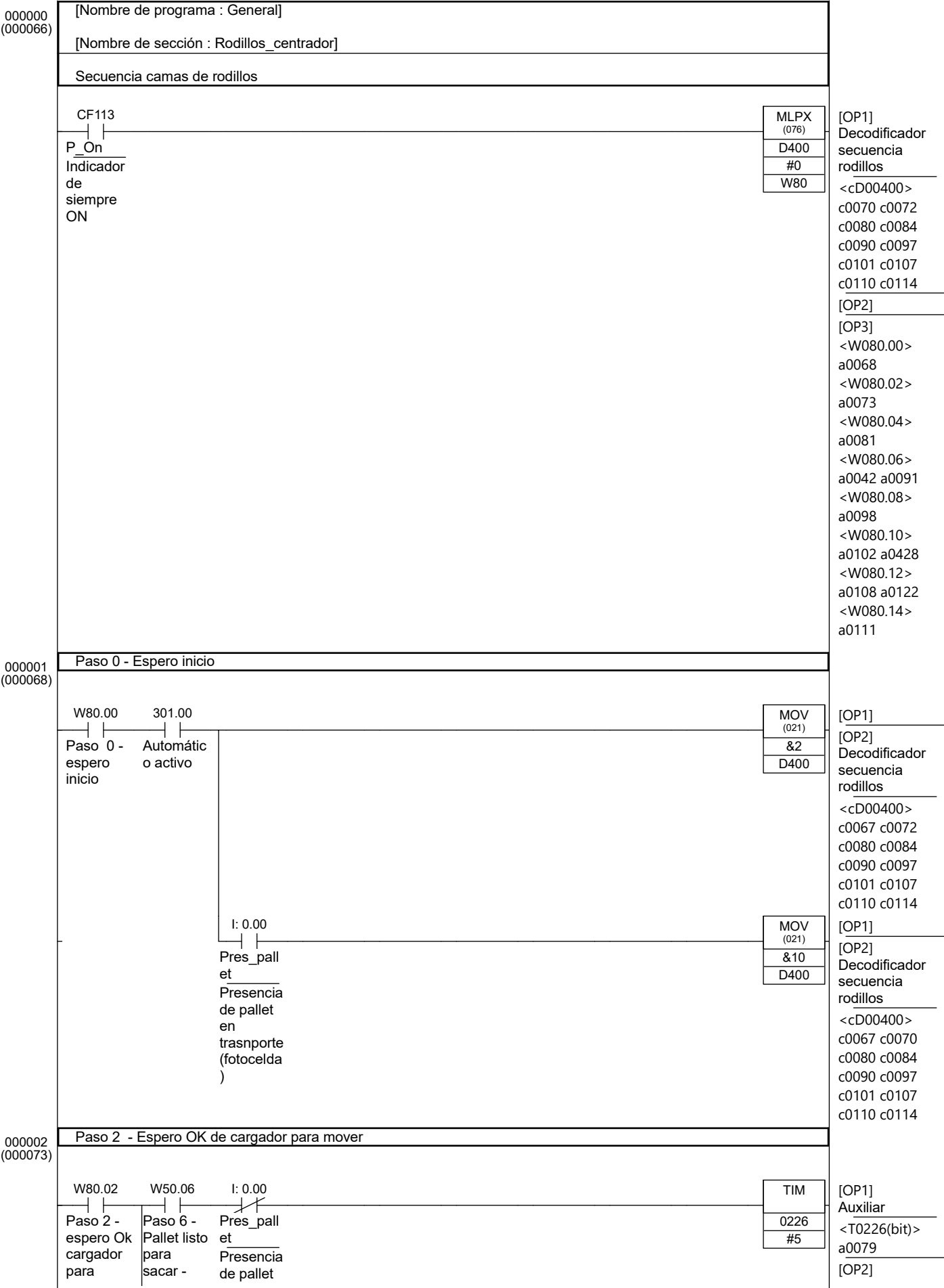
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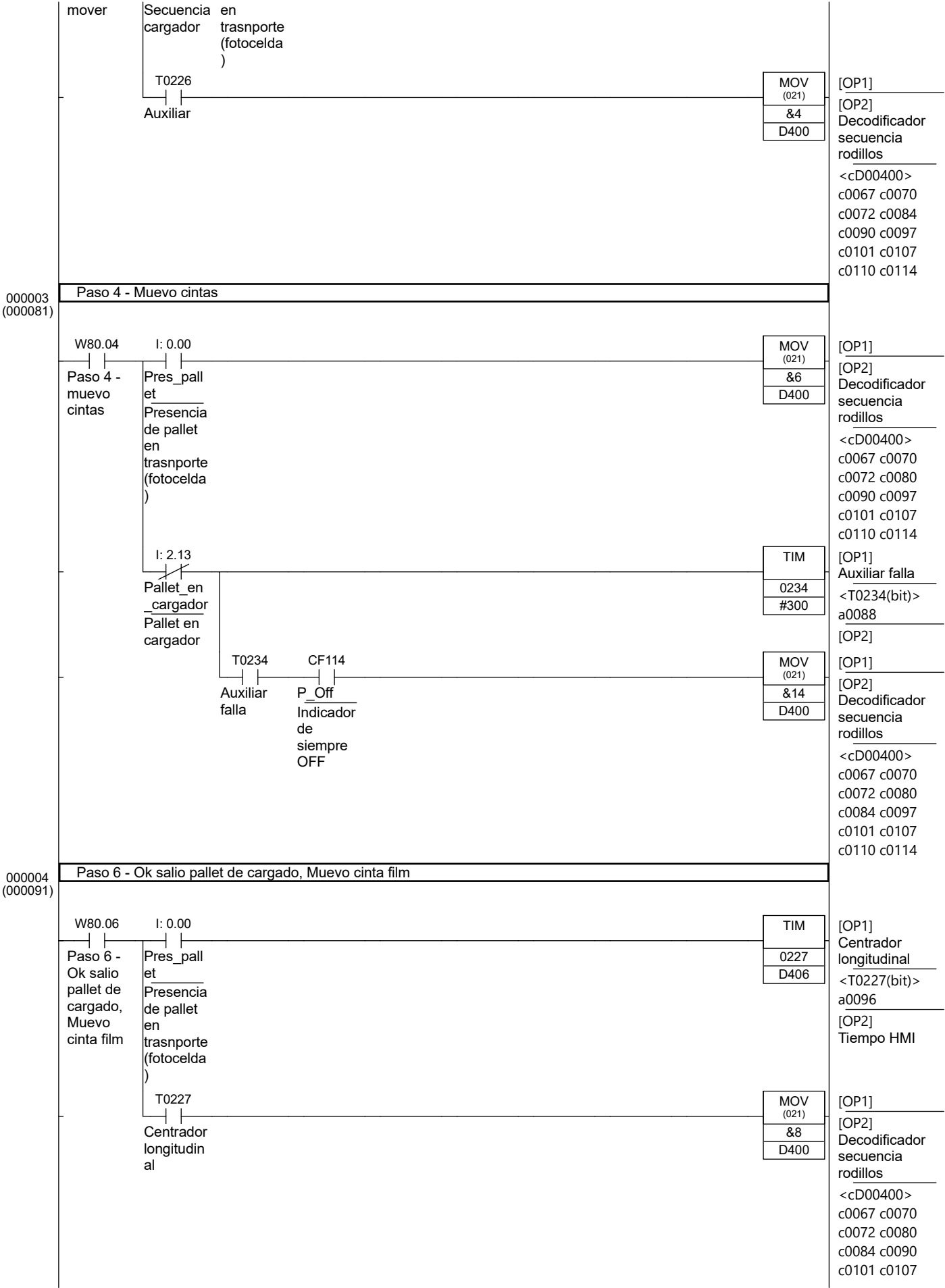












Paso 6 - Ok salio pallet de cargado, Muevo cinta film

W80.06

I: 0.00

Paso 6 -  
Ok salio  
pallet de  
cargado,  
Muevo  
cinta film

Pres\_pall  
et

Presencia  
de pallet  
en  
trasnporte  
(fotocelda  
)

T0227

Centrador  
longitudin  
al

TIM

0227

D406

MOV  
(021)

&8

D400

[OP1]

Centrador  
longitudinal

<T0227(bit)>

a0096

[OP2]

Tiempo HMI

[OP1]

[OP2]

Decodificador  
secuencia  
rodillos

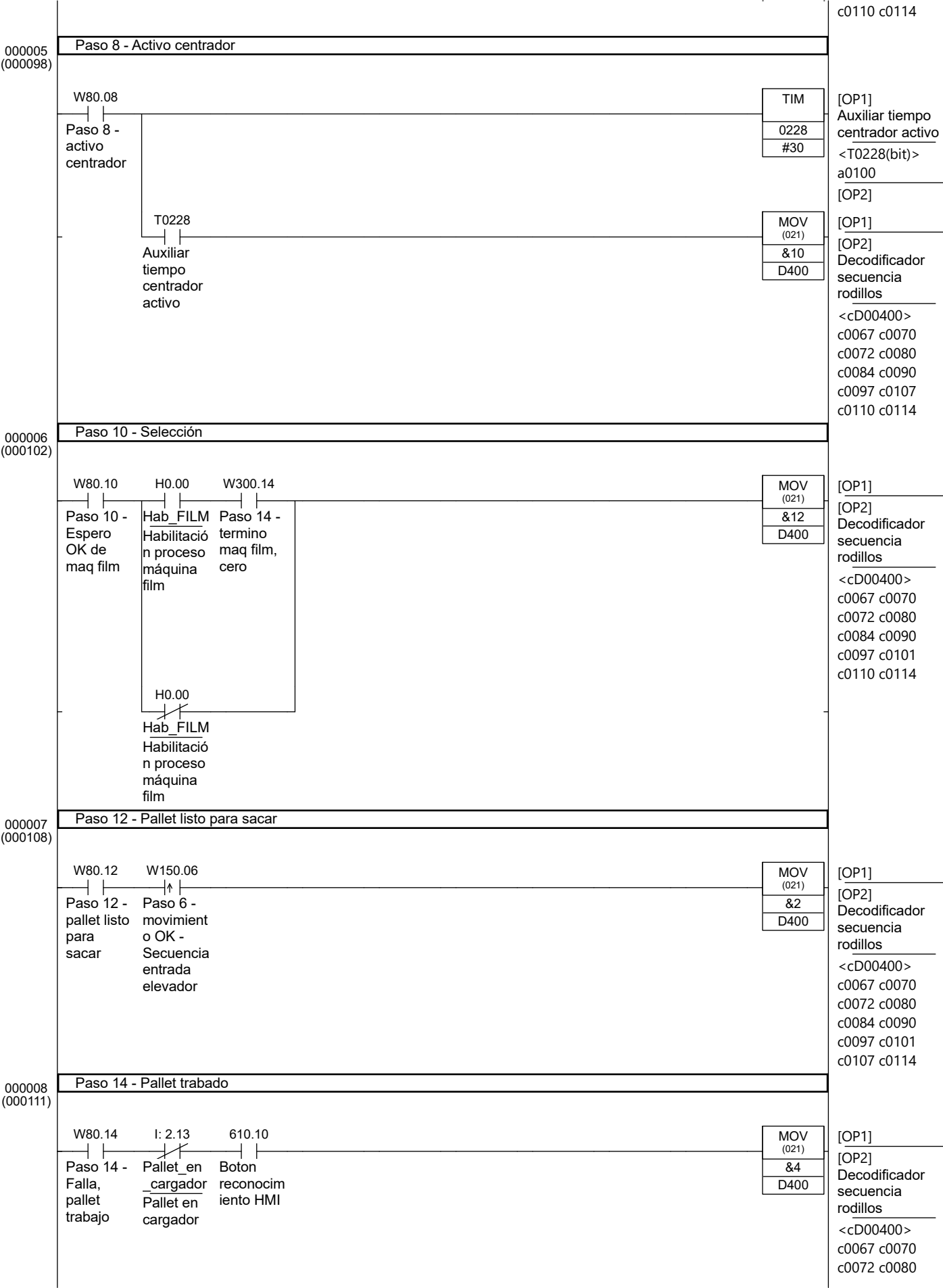
<cD00400>

c0067 c0070

c0072 c0080

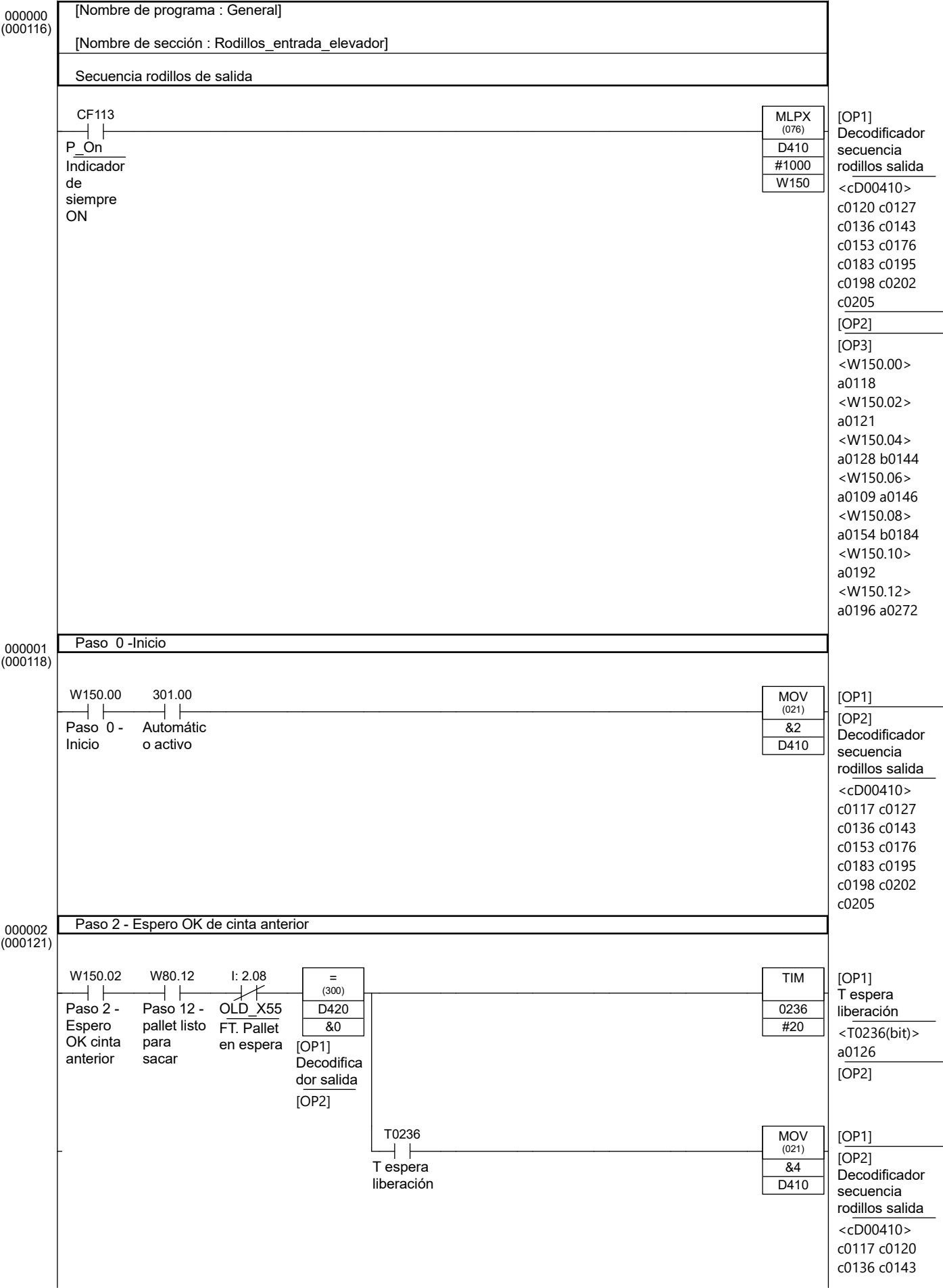
c0084 c0090

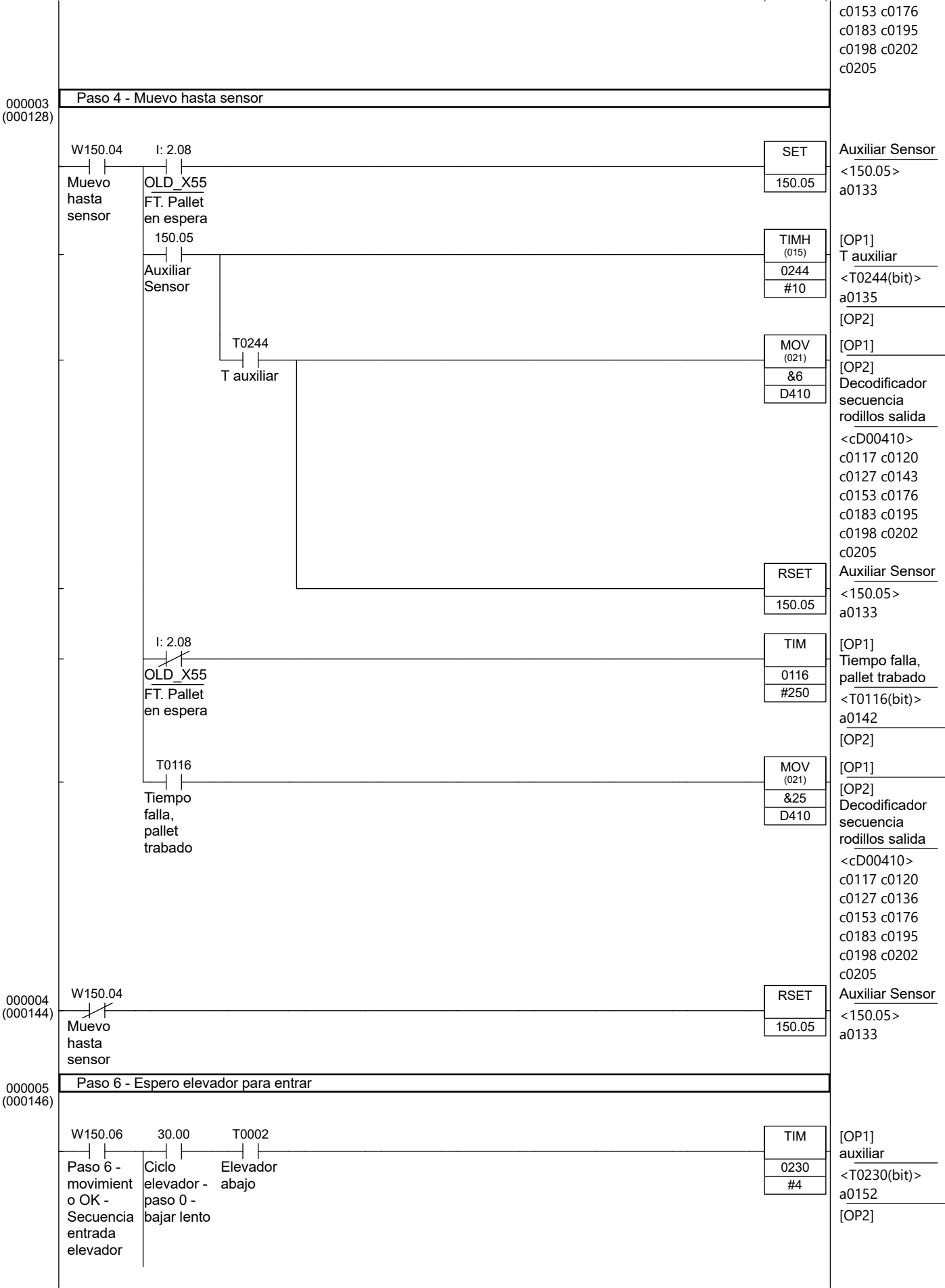
c0101 c0107

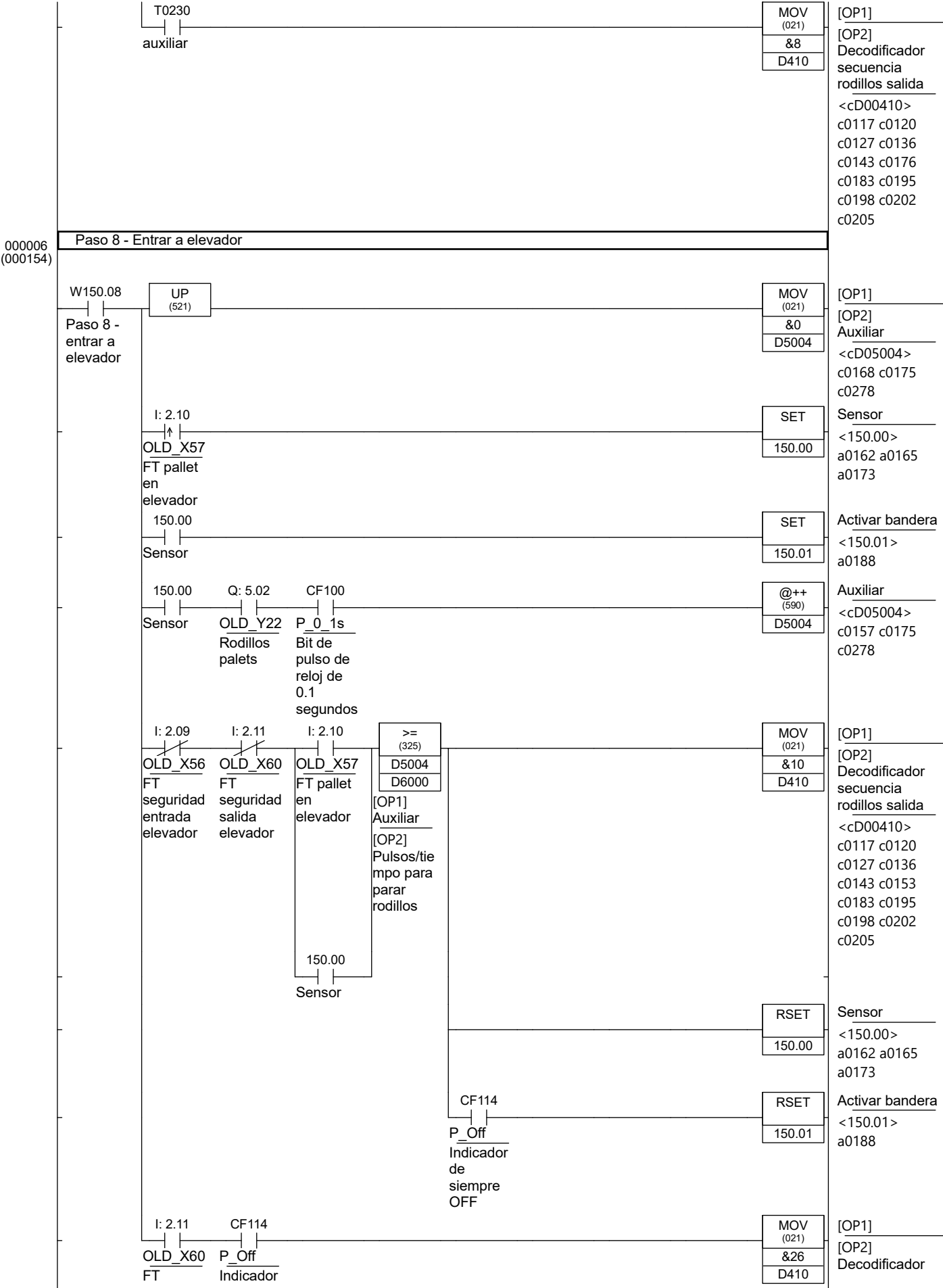


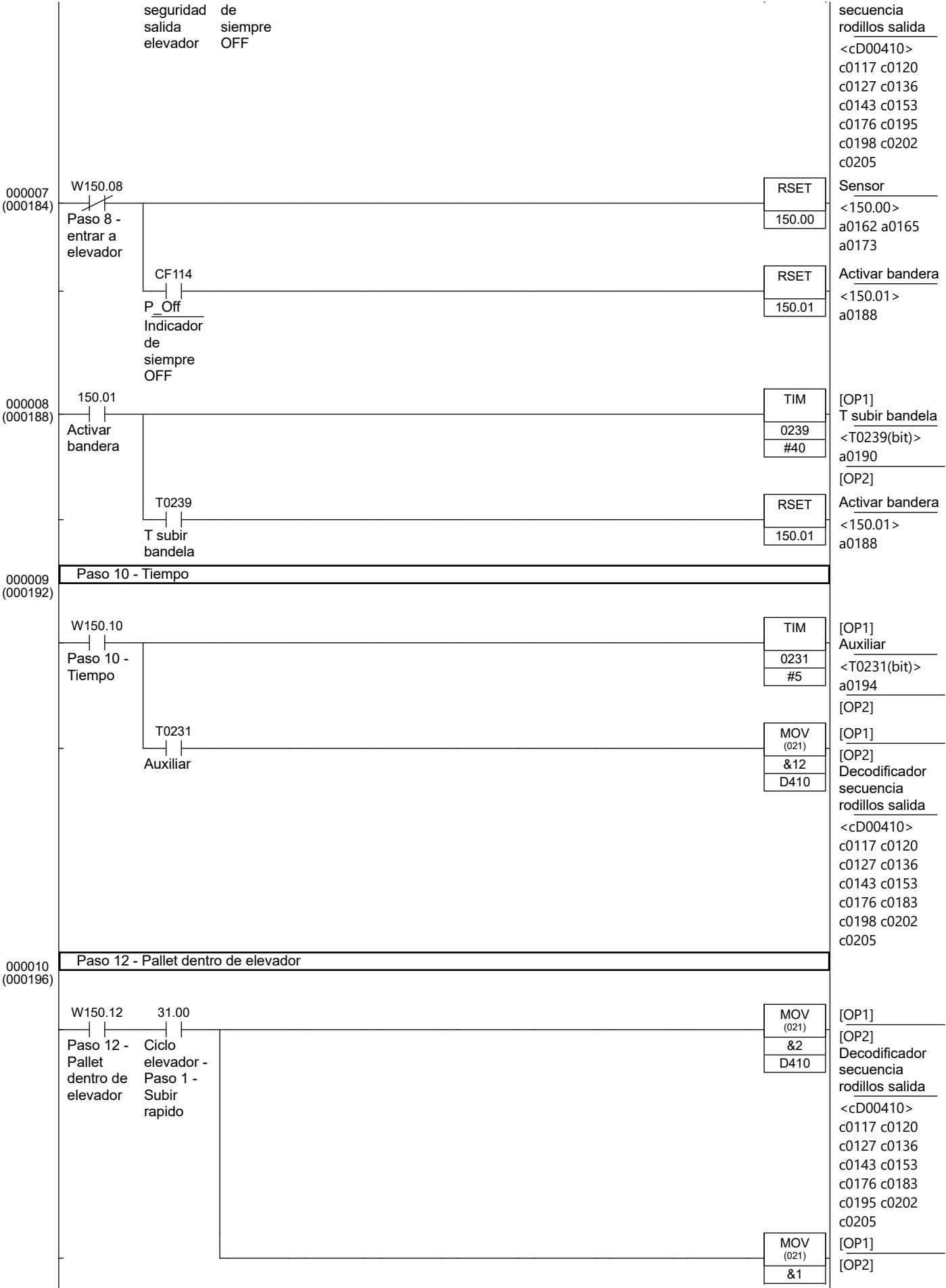


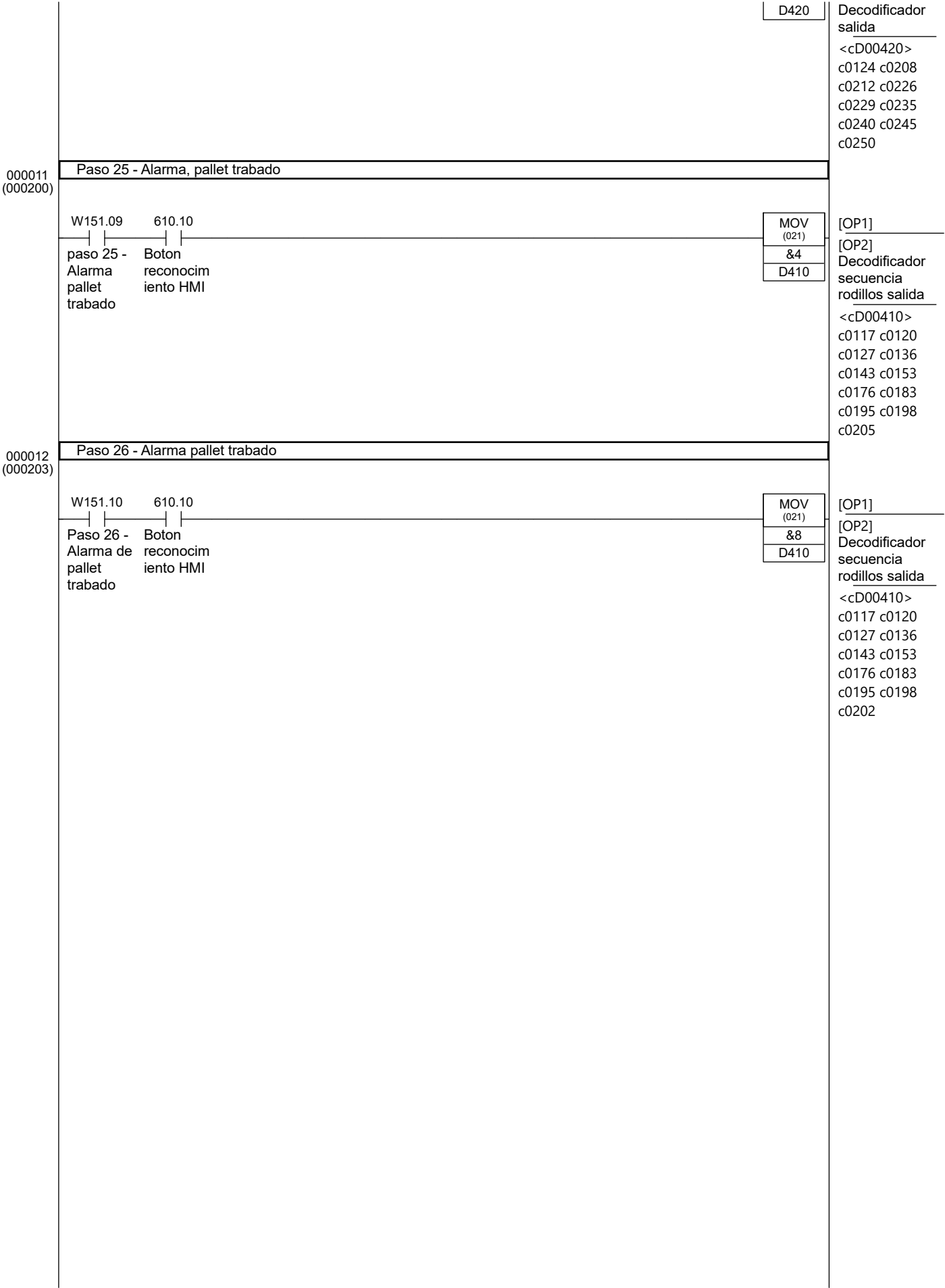
c0084 c0090  
c0097 c0101  
c0107 c0110

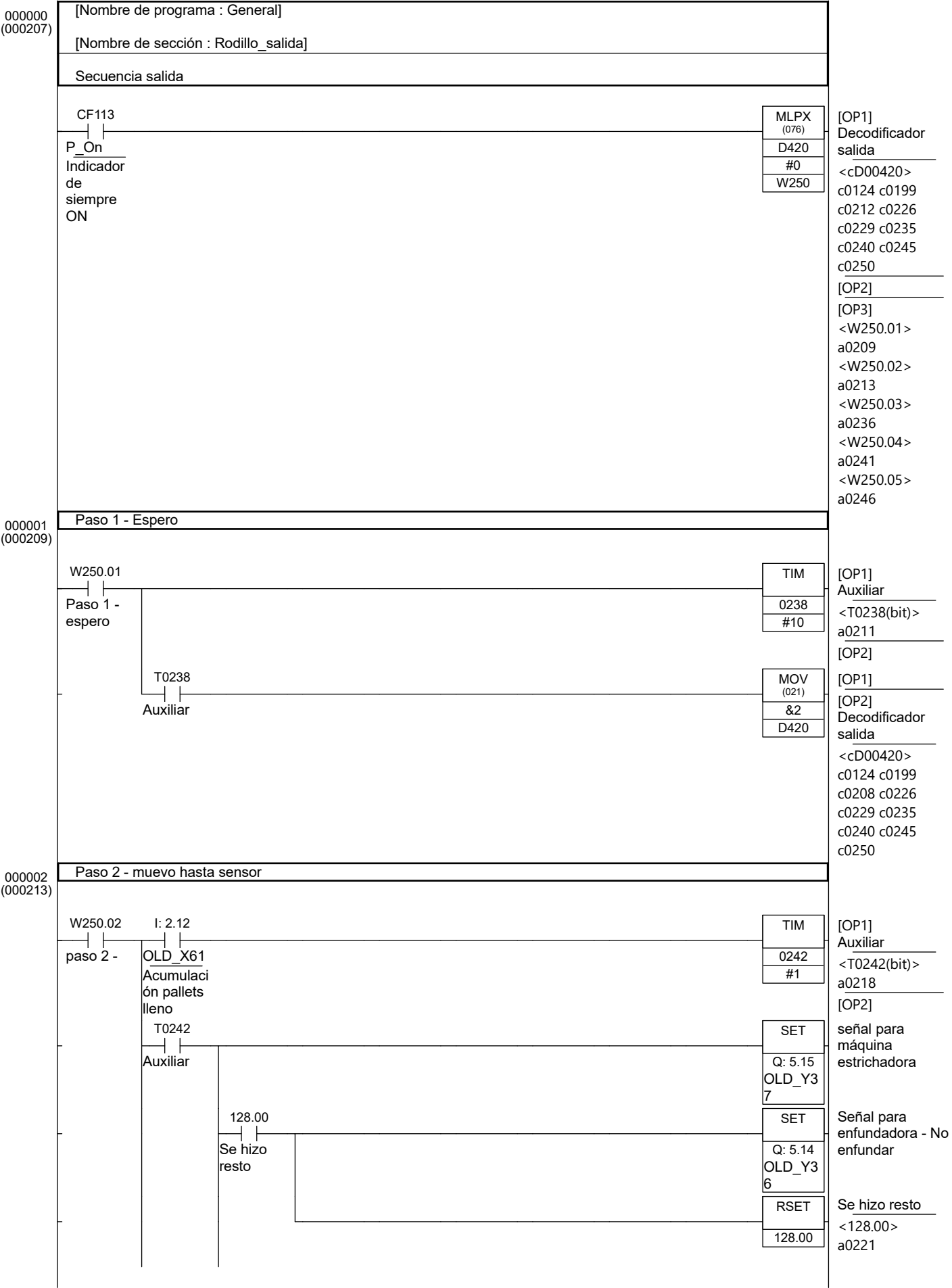


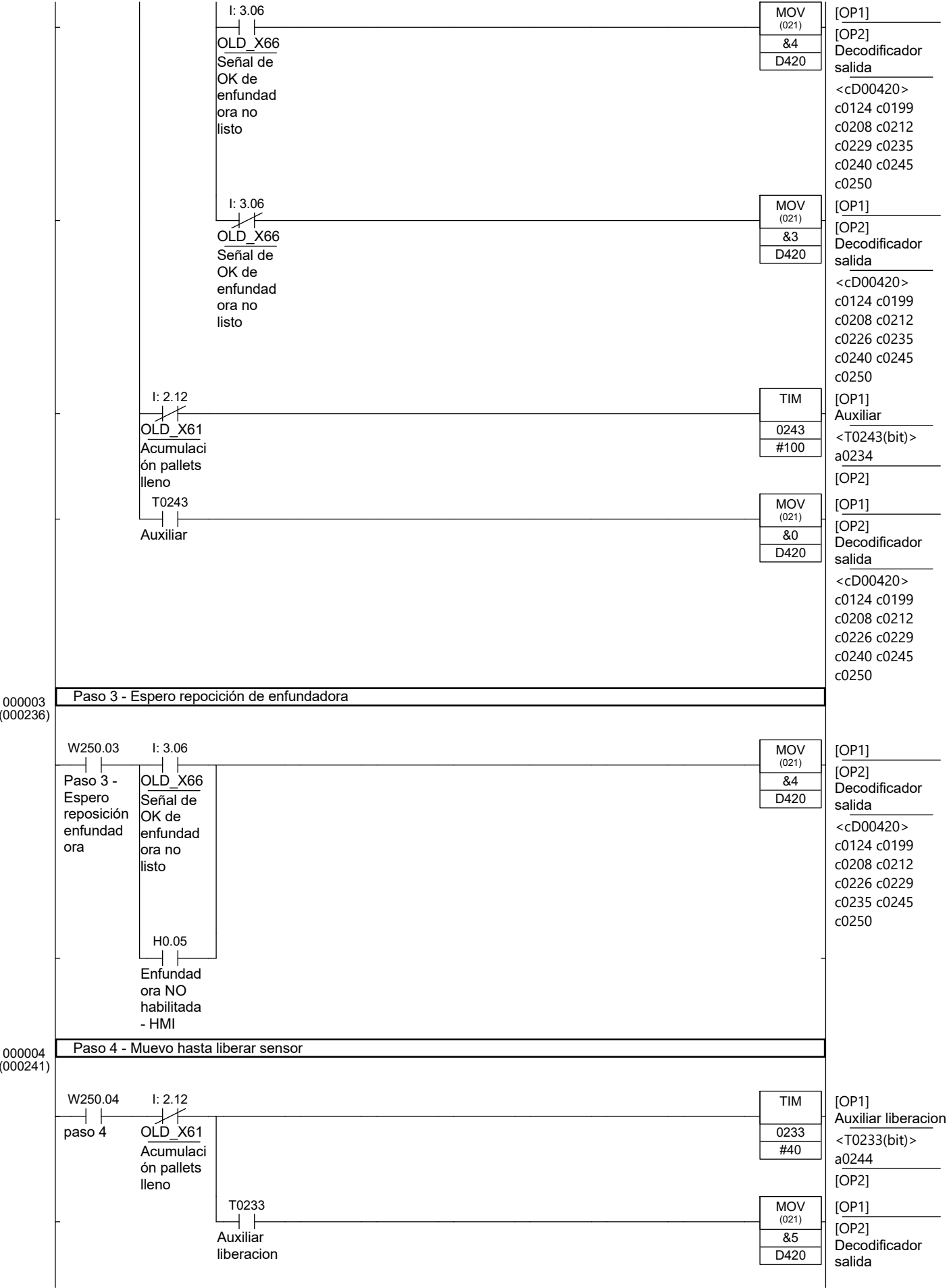








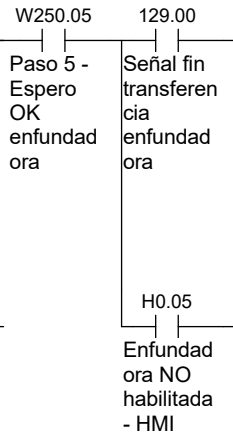






000005  
(000246)

Paso 5 - Espero fin de traslado enfundadora



MOV  
(021)  
&0  
D420

<cD00420>  
c0124 c0199  
c0208 c0212  
c0226 c0229  
c0235 c0240  
c0250

[OP1]  
[OP2]  
Decodificador  
salida

<cD00420>  
c0124 c0199  
c0208 c0212  
c0226 c0229  
c0235 c0240  
c0245

RSET  
Q: 5.15  
OLD\_Y3  
7

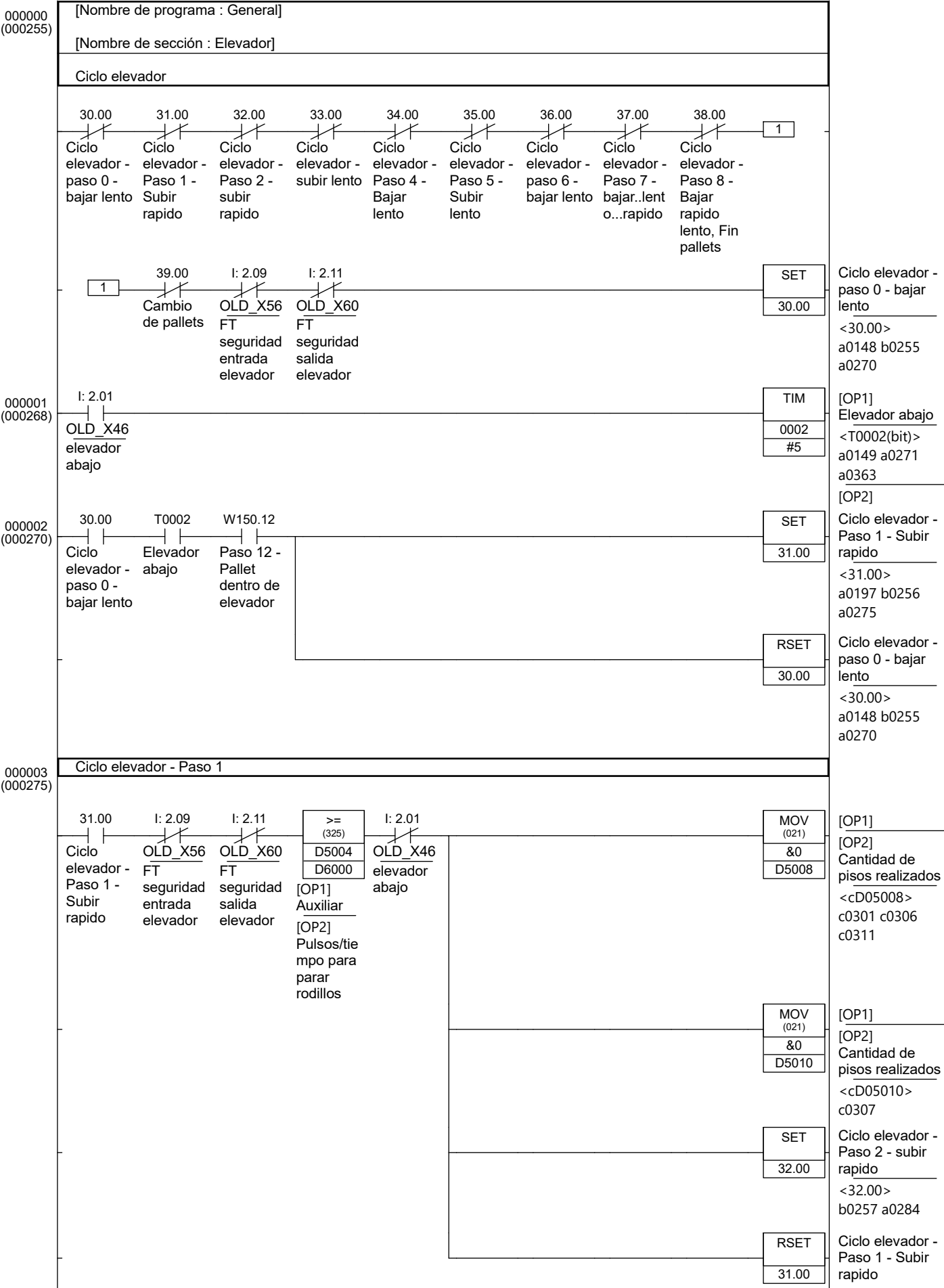
señal para  
máquina  
estrichadora

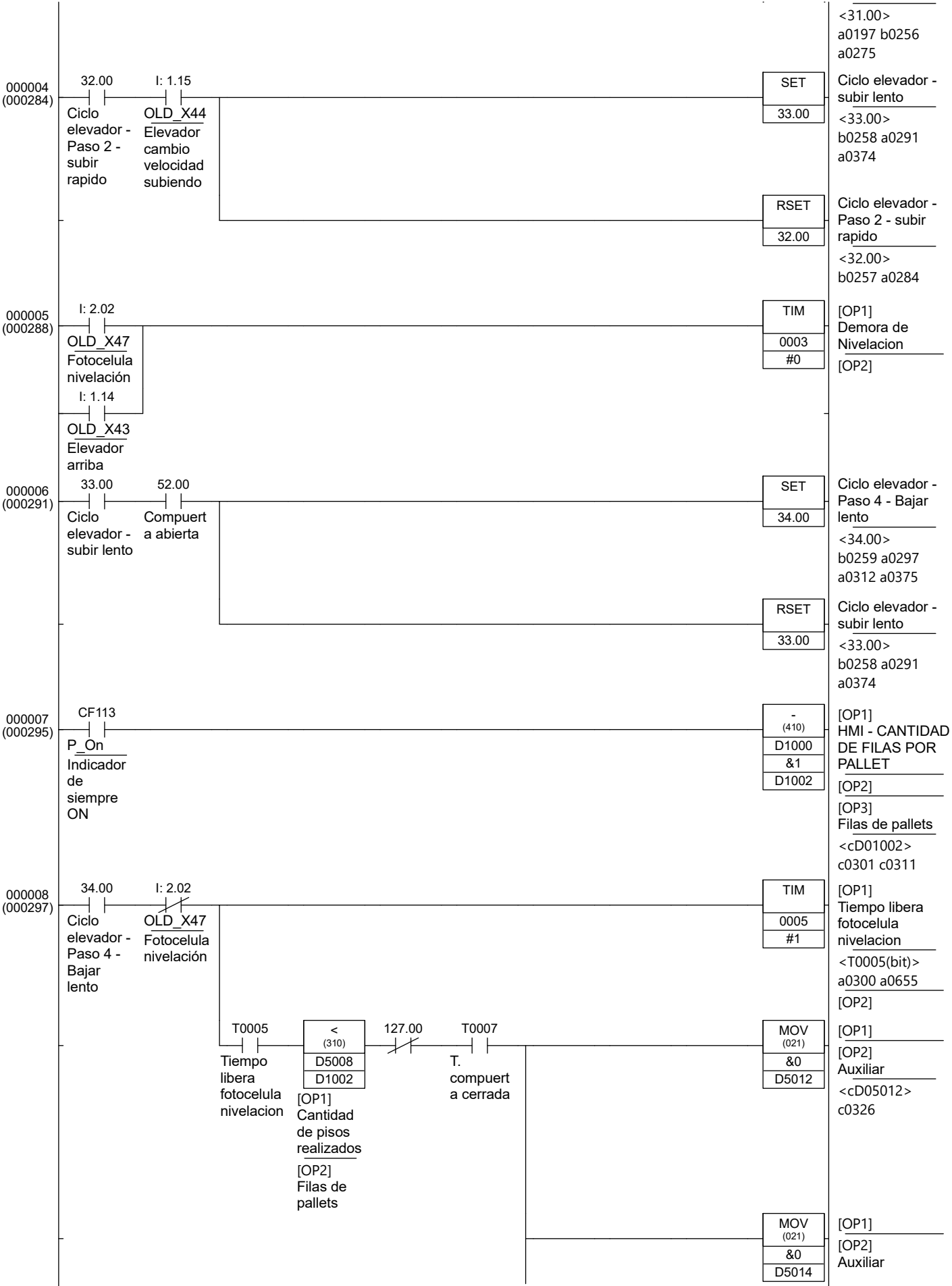
RSET  
Q: 5.14  
OLD\_Y3  
6

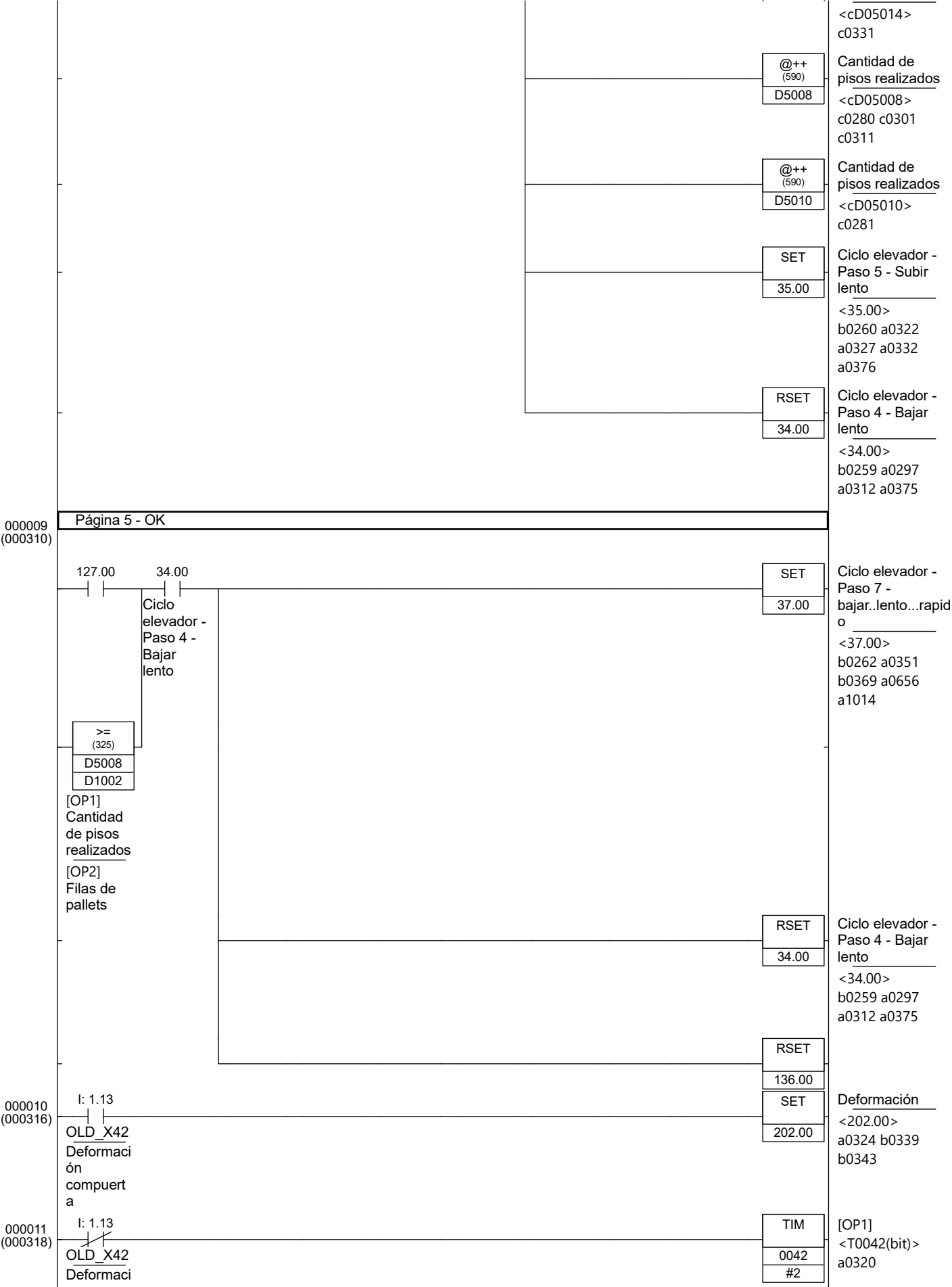
Señal para  
enfundadora - No  
enfundar

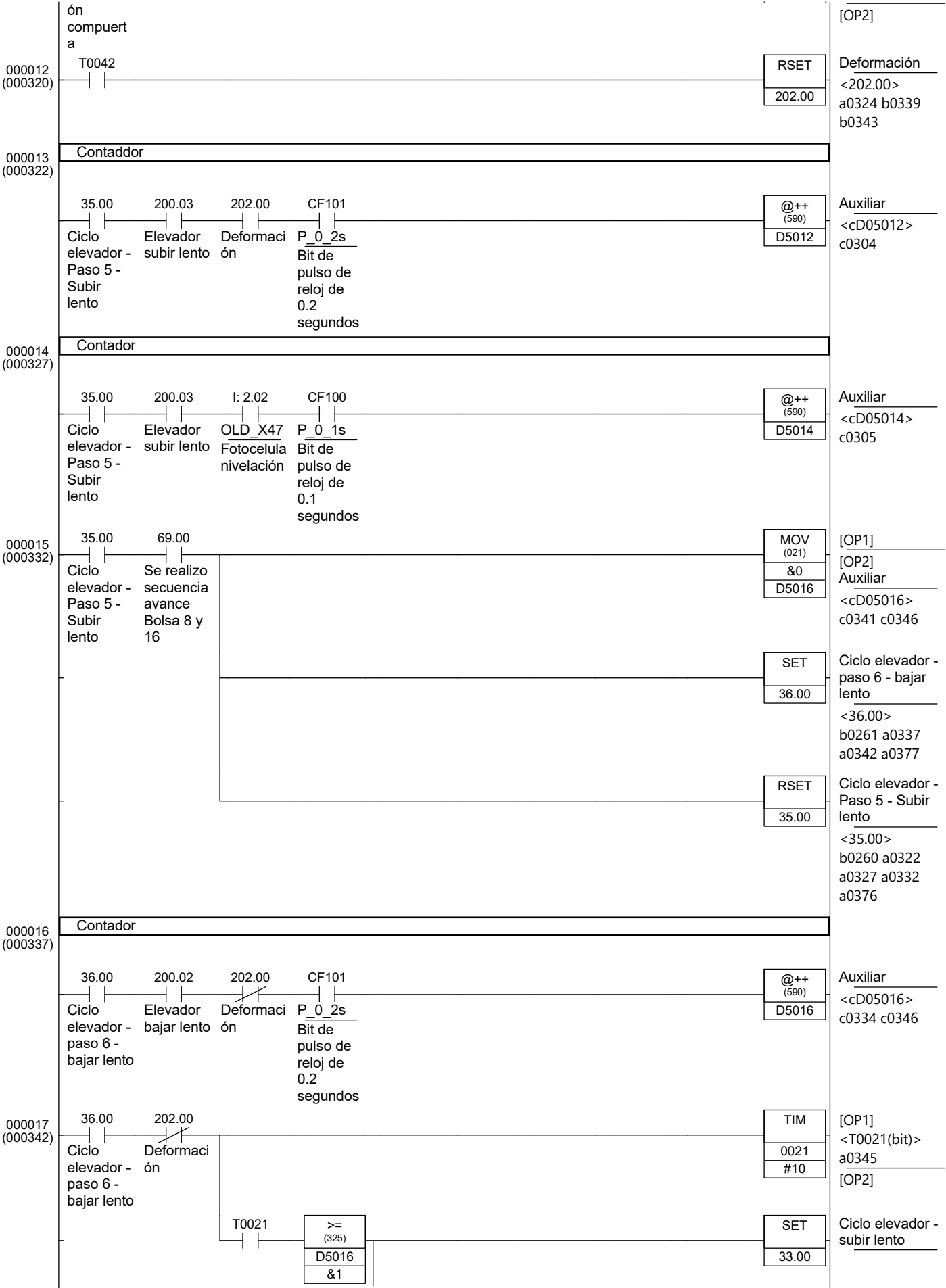
RSET  
129.00

Señal fin  
transferencia  
enfundadora  
<129.00>  
a0247

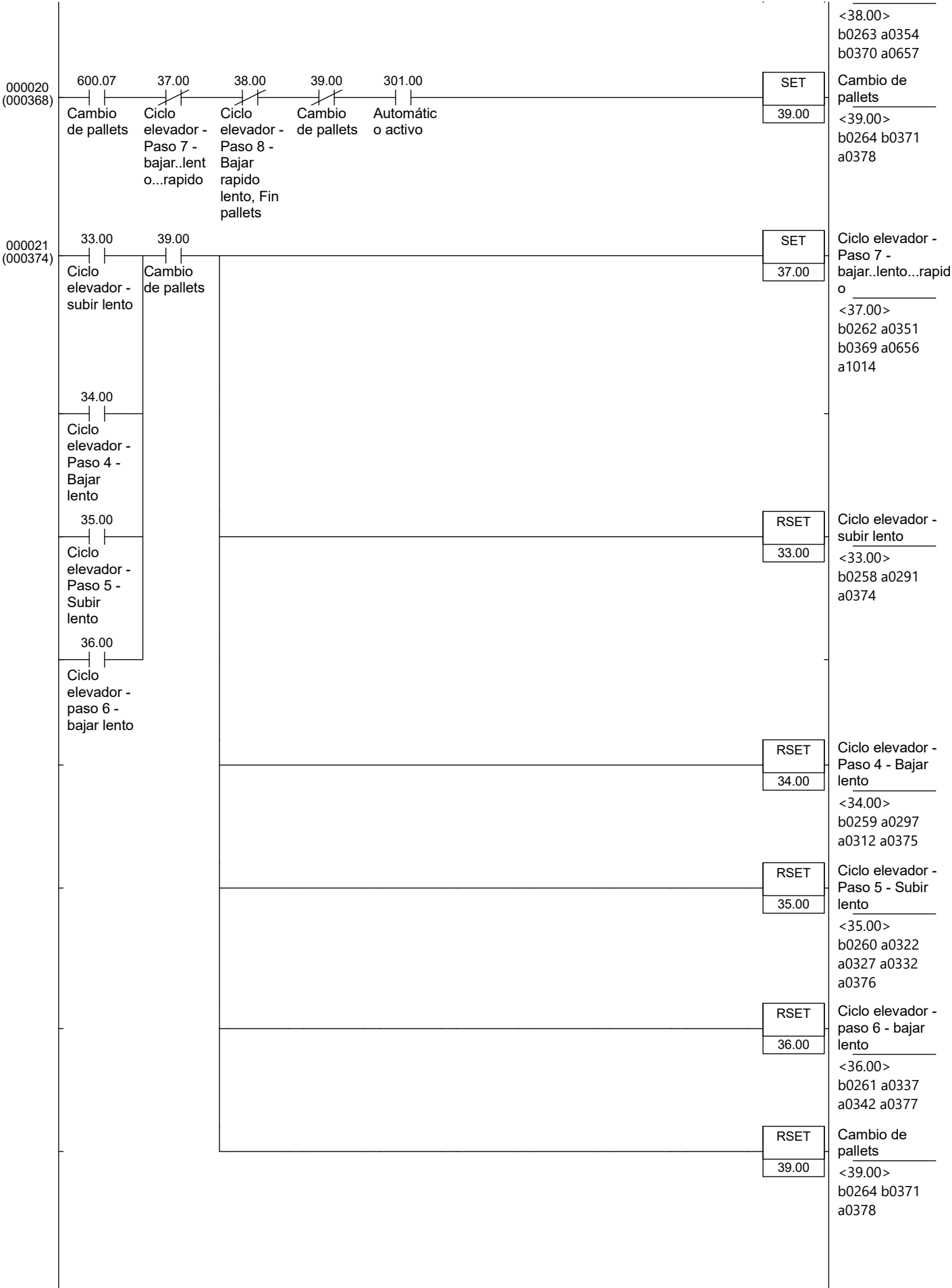


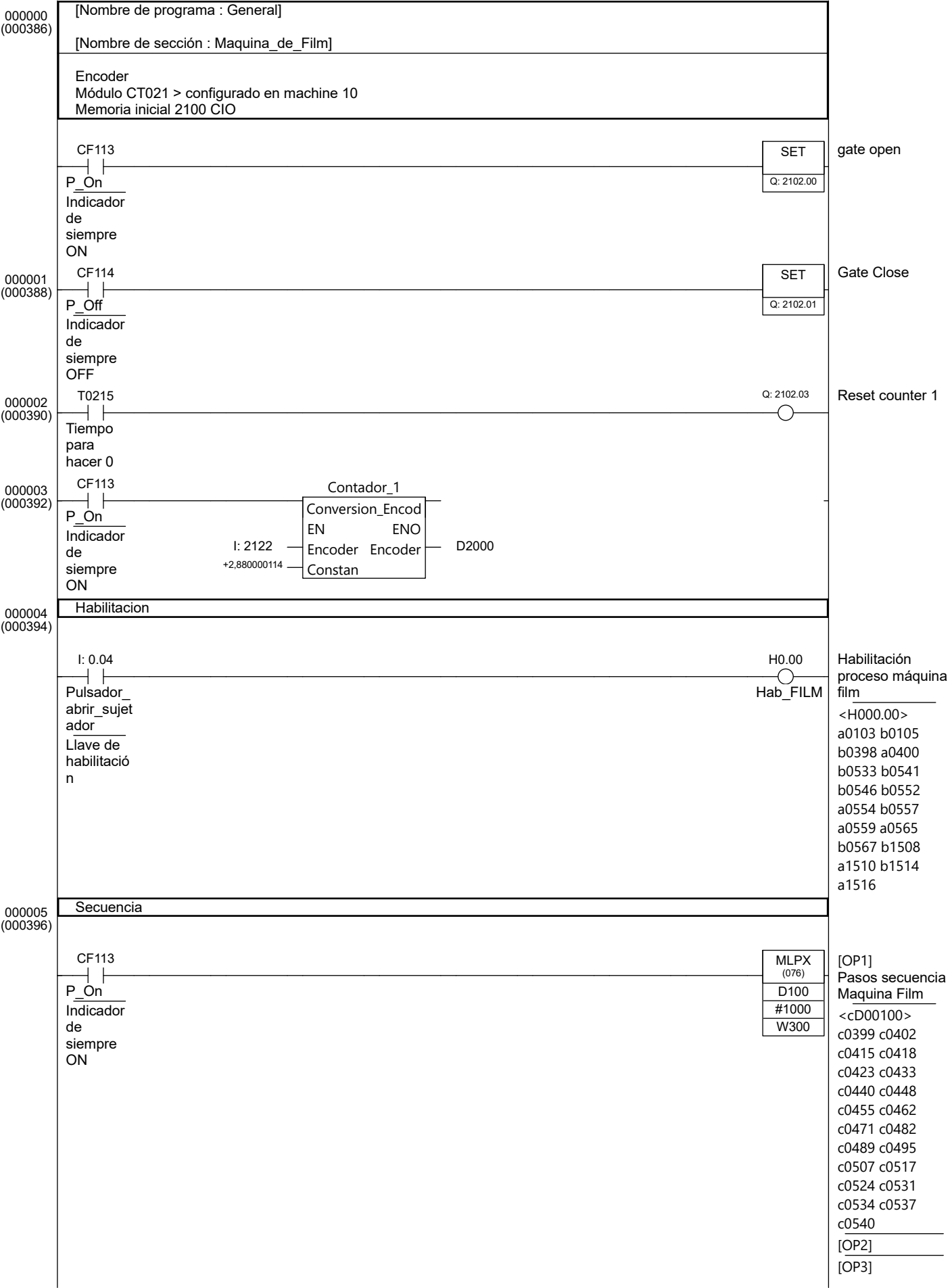




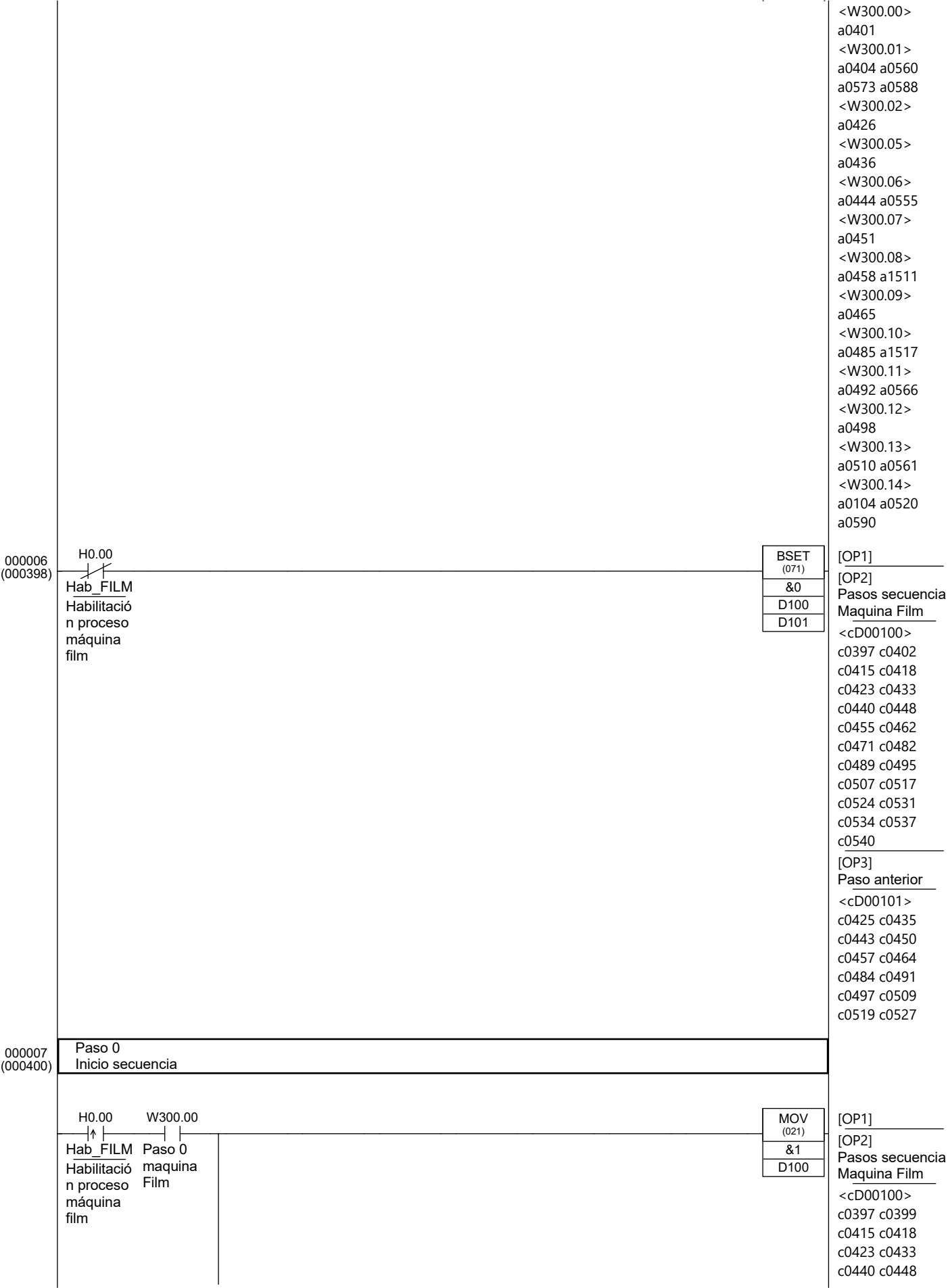


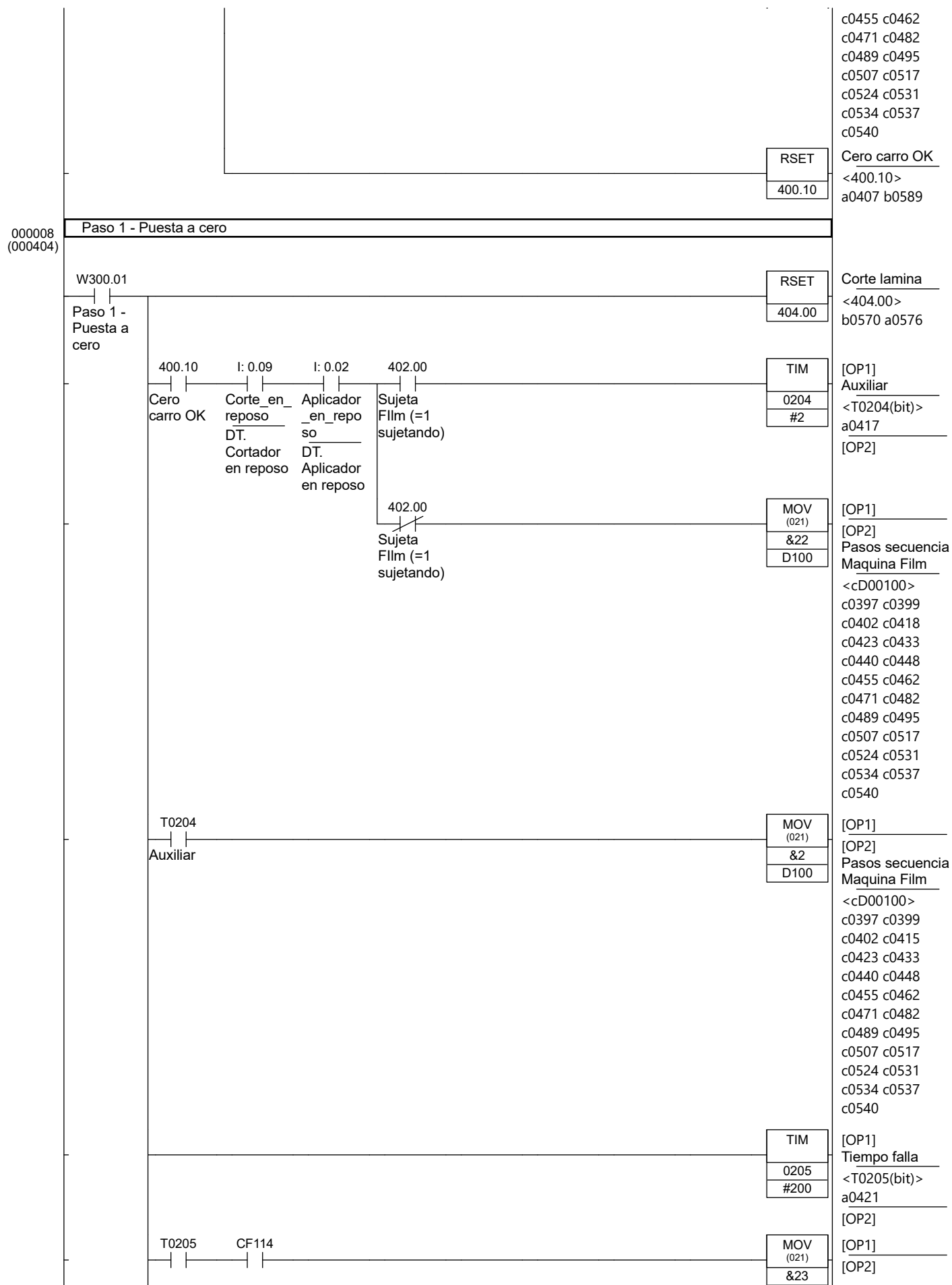


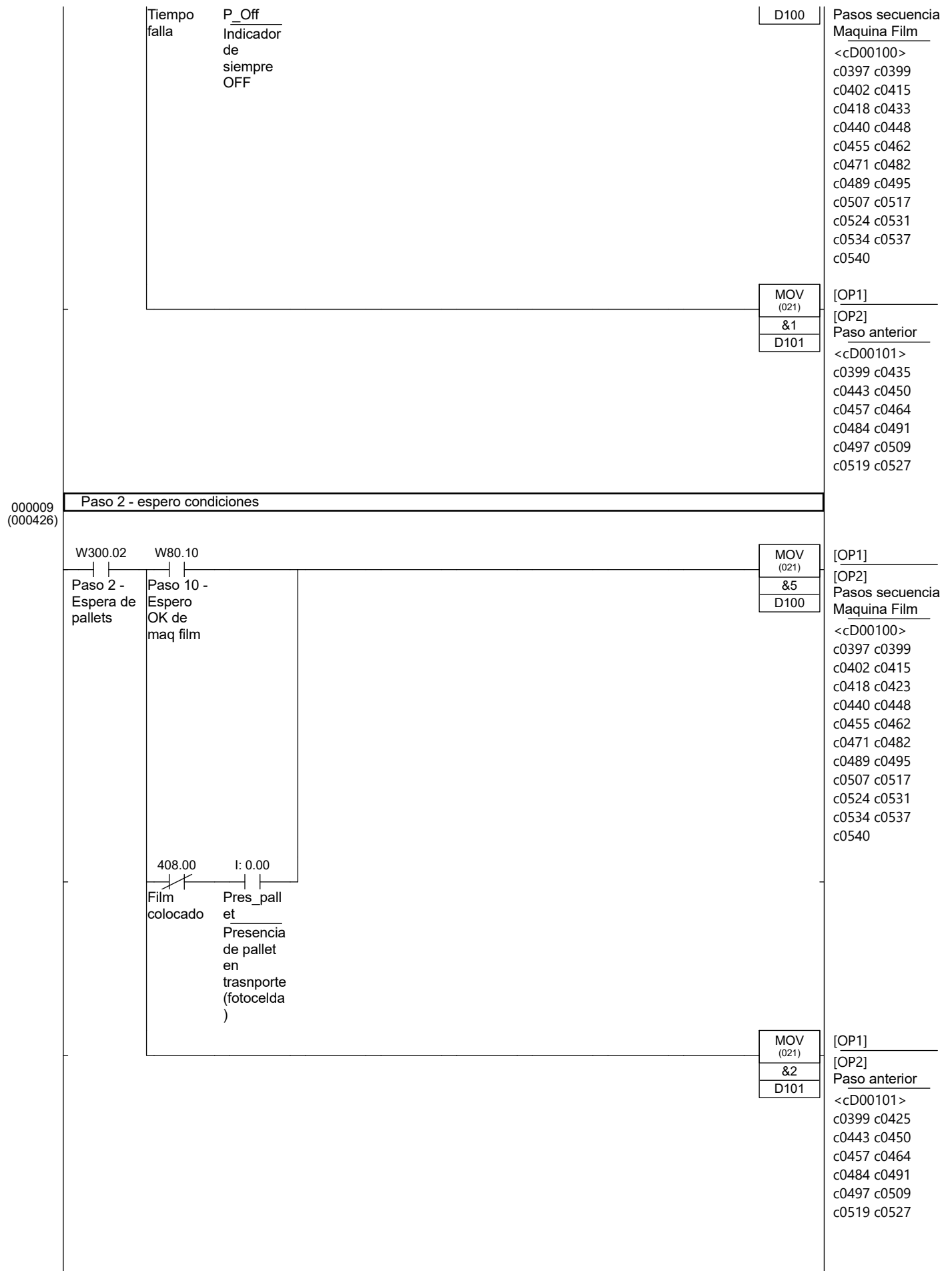


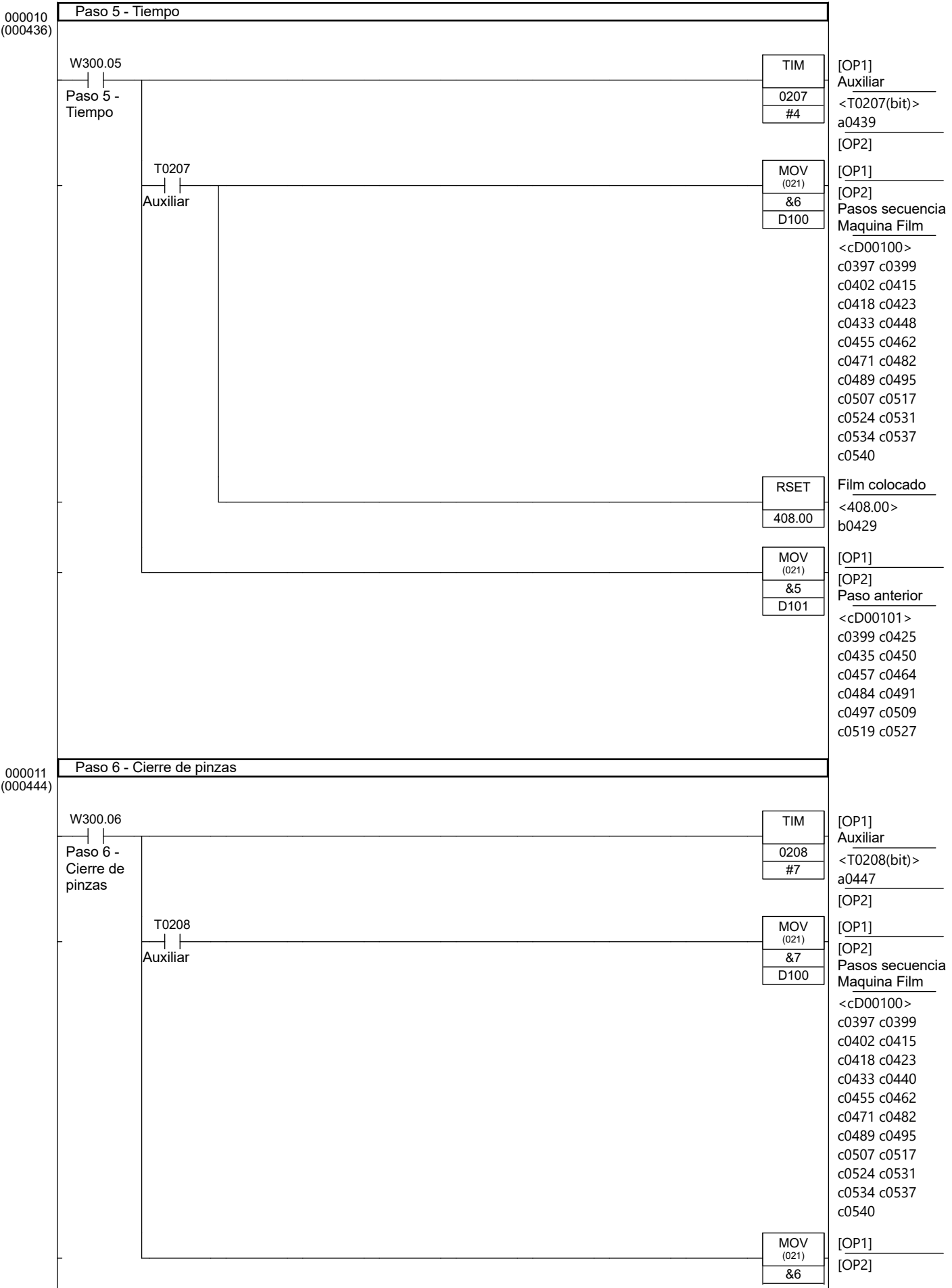


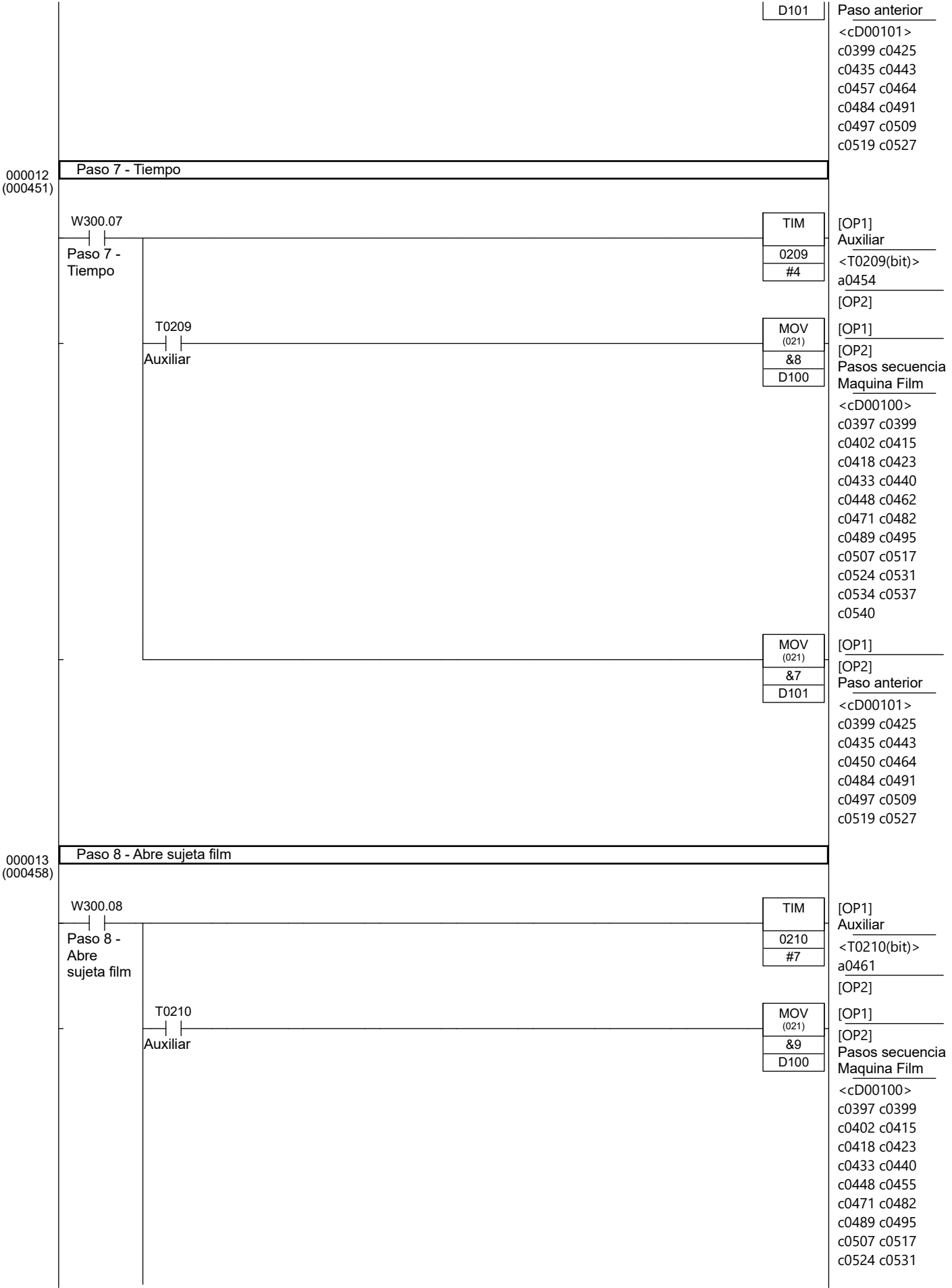


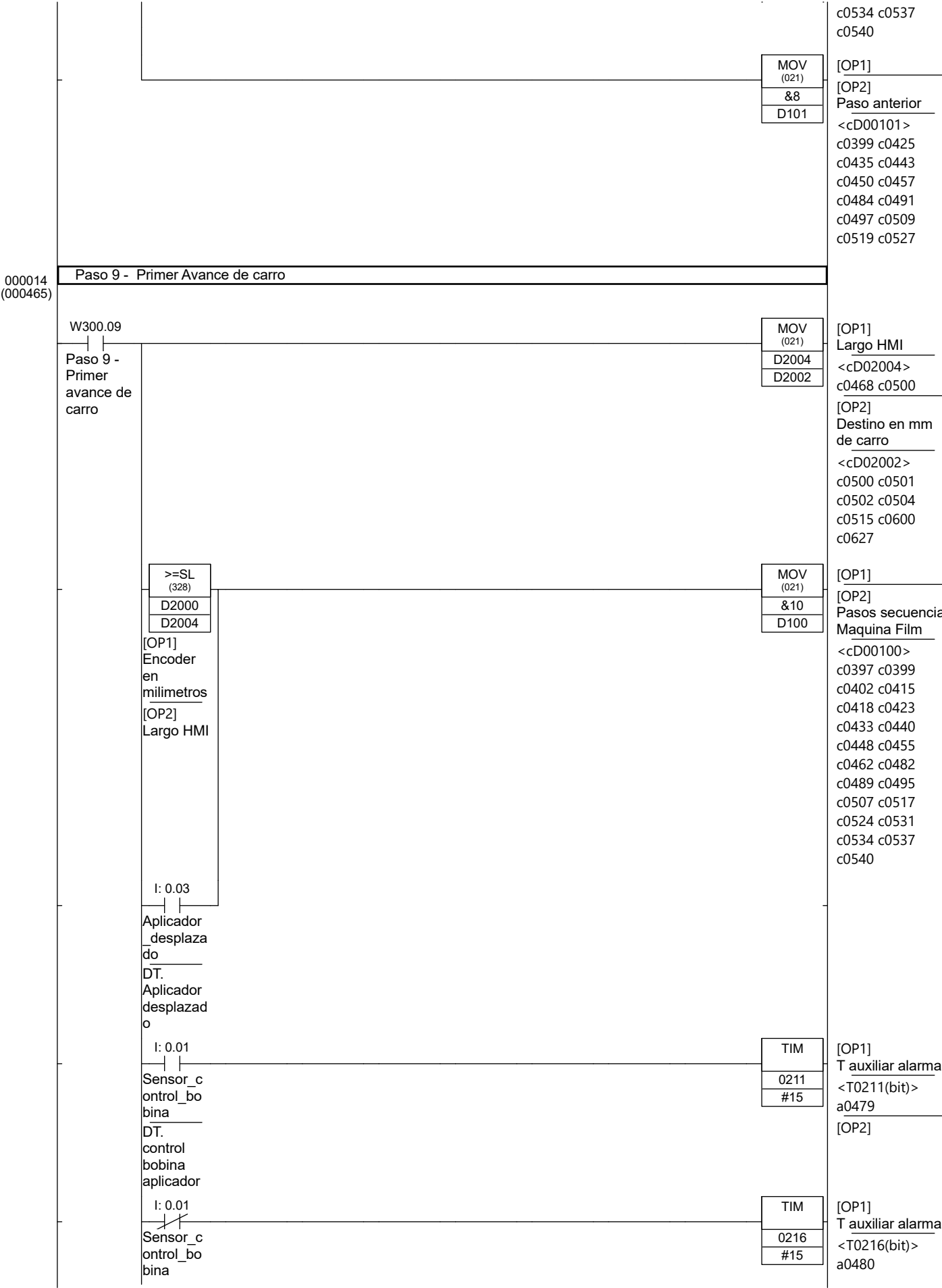


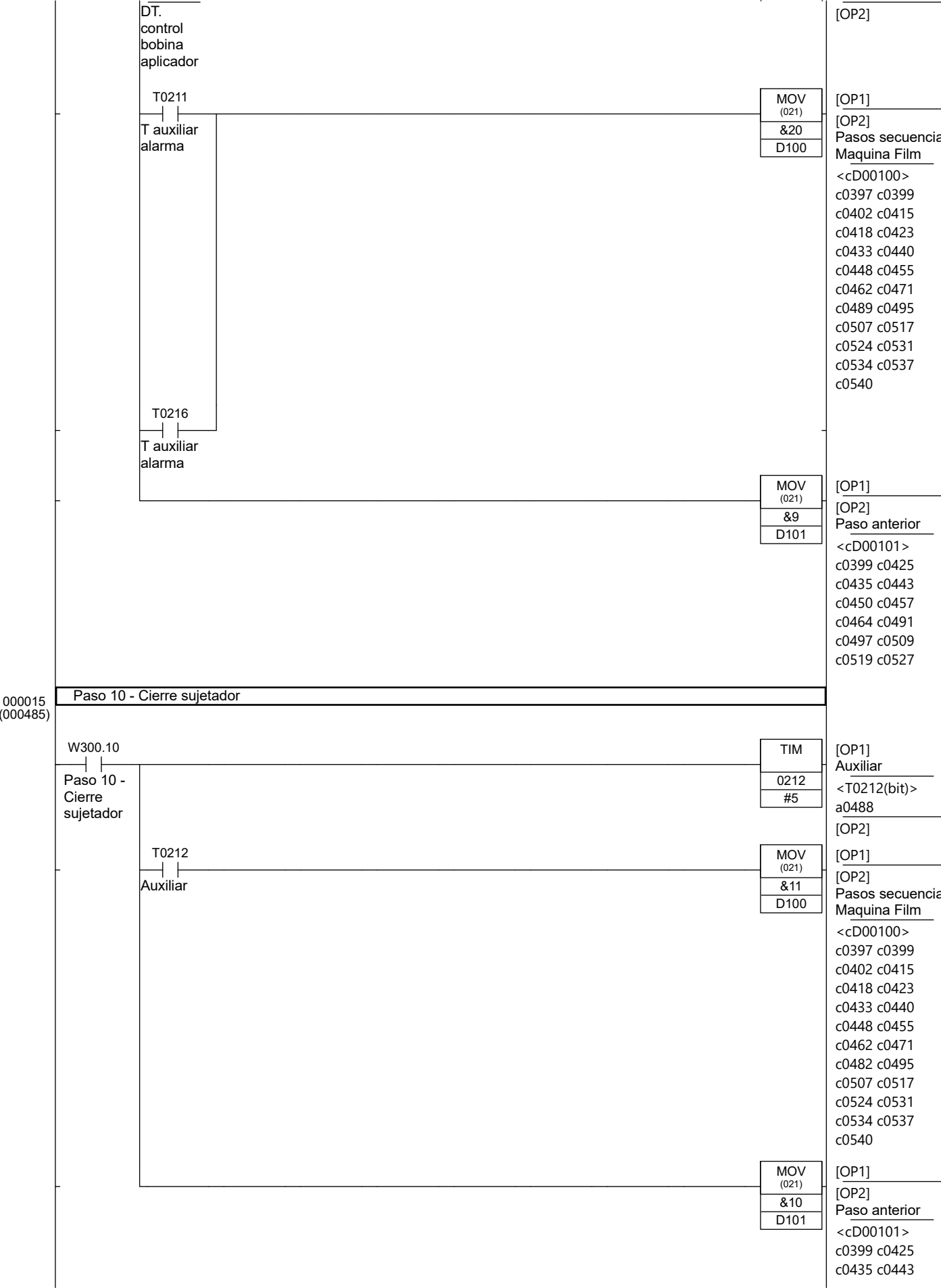


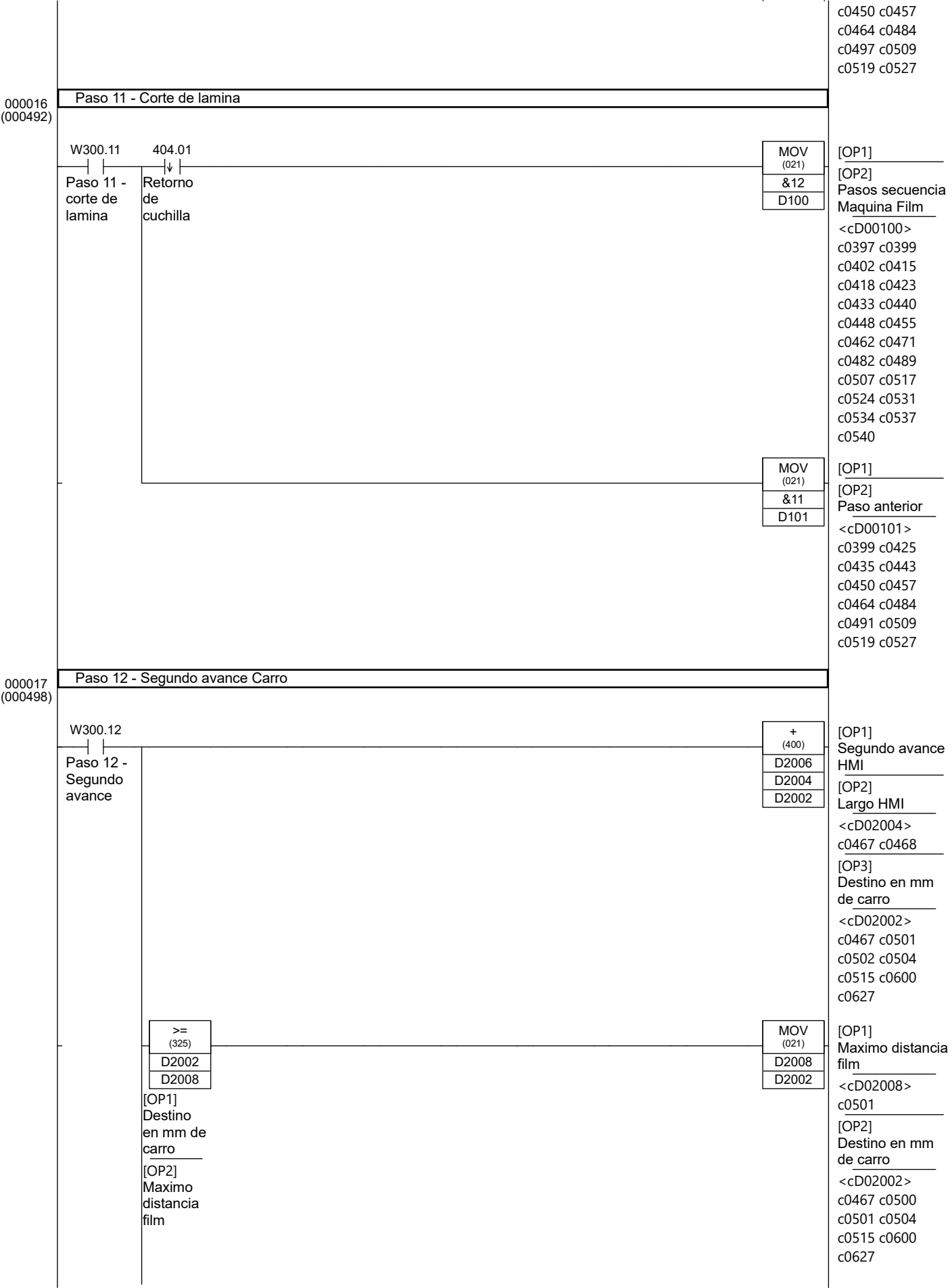




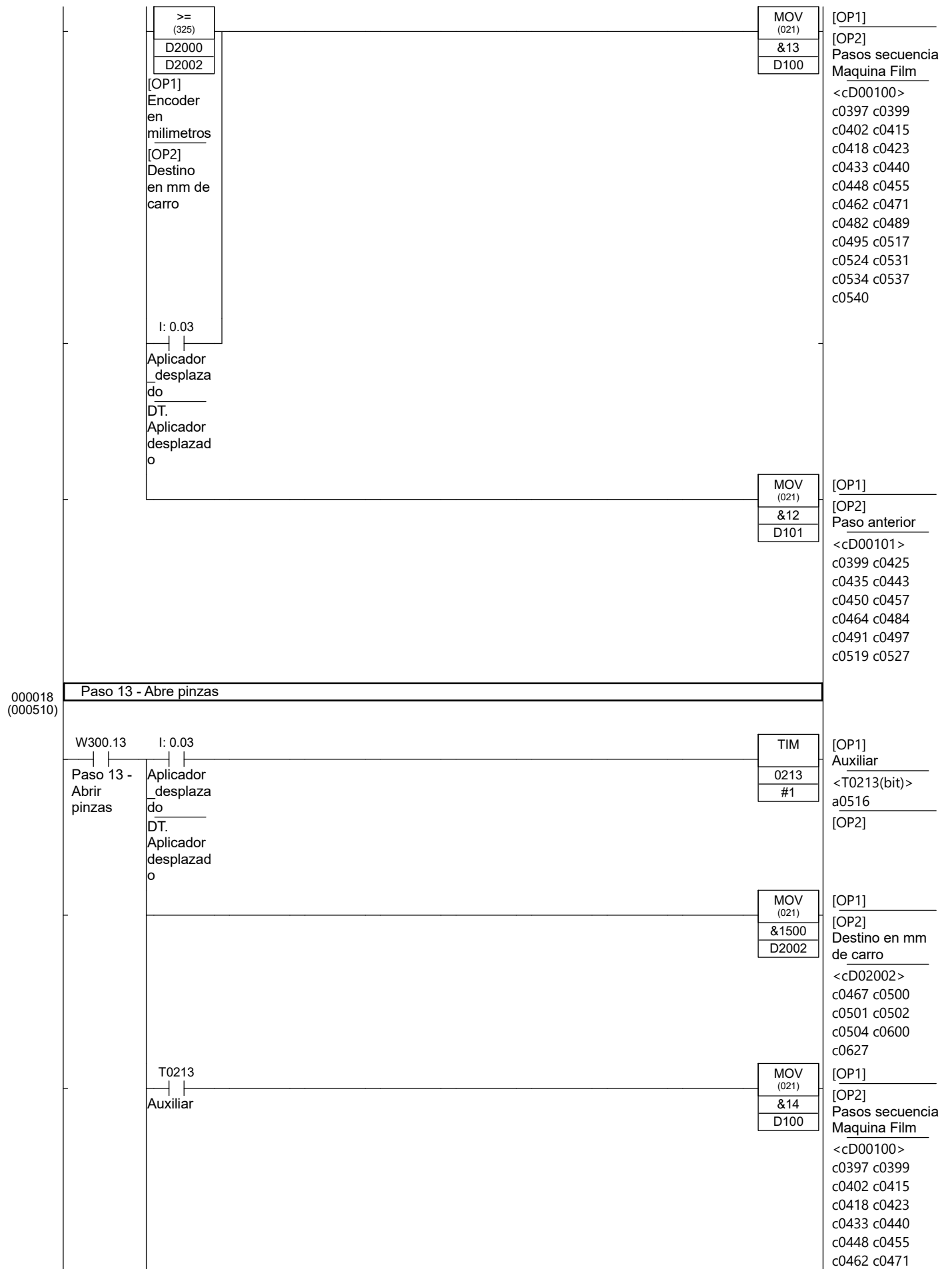


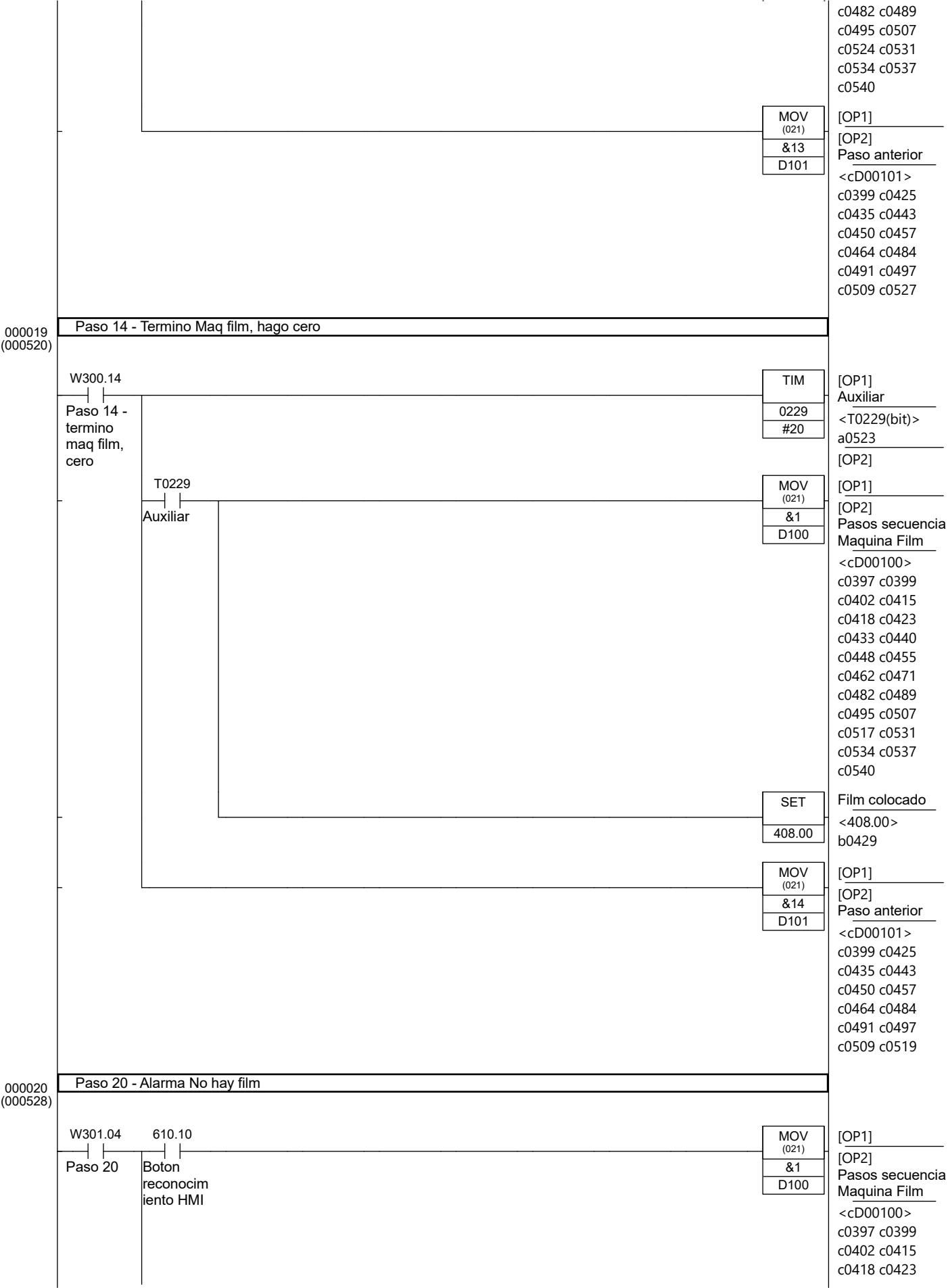


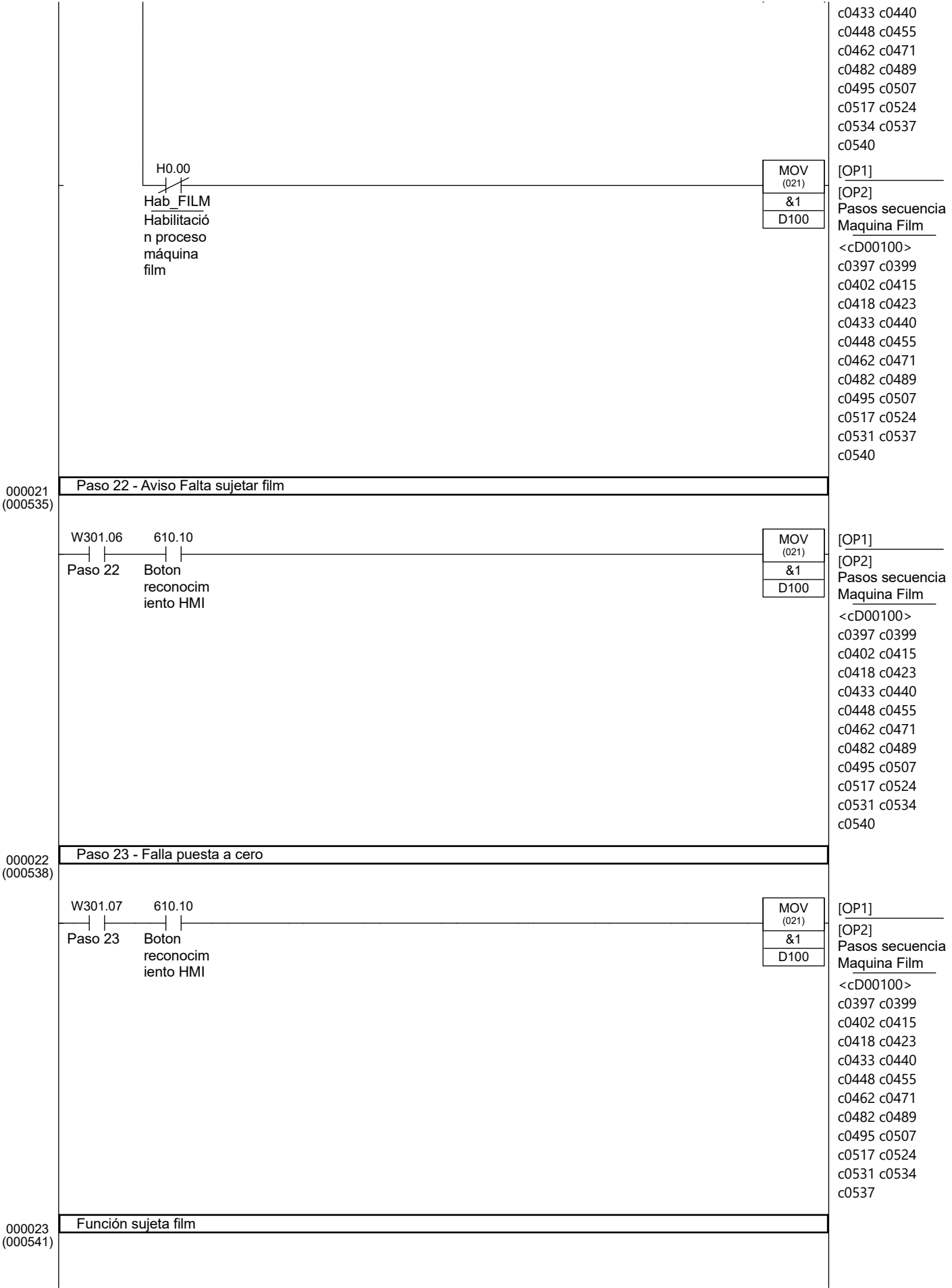


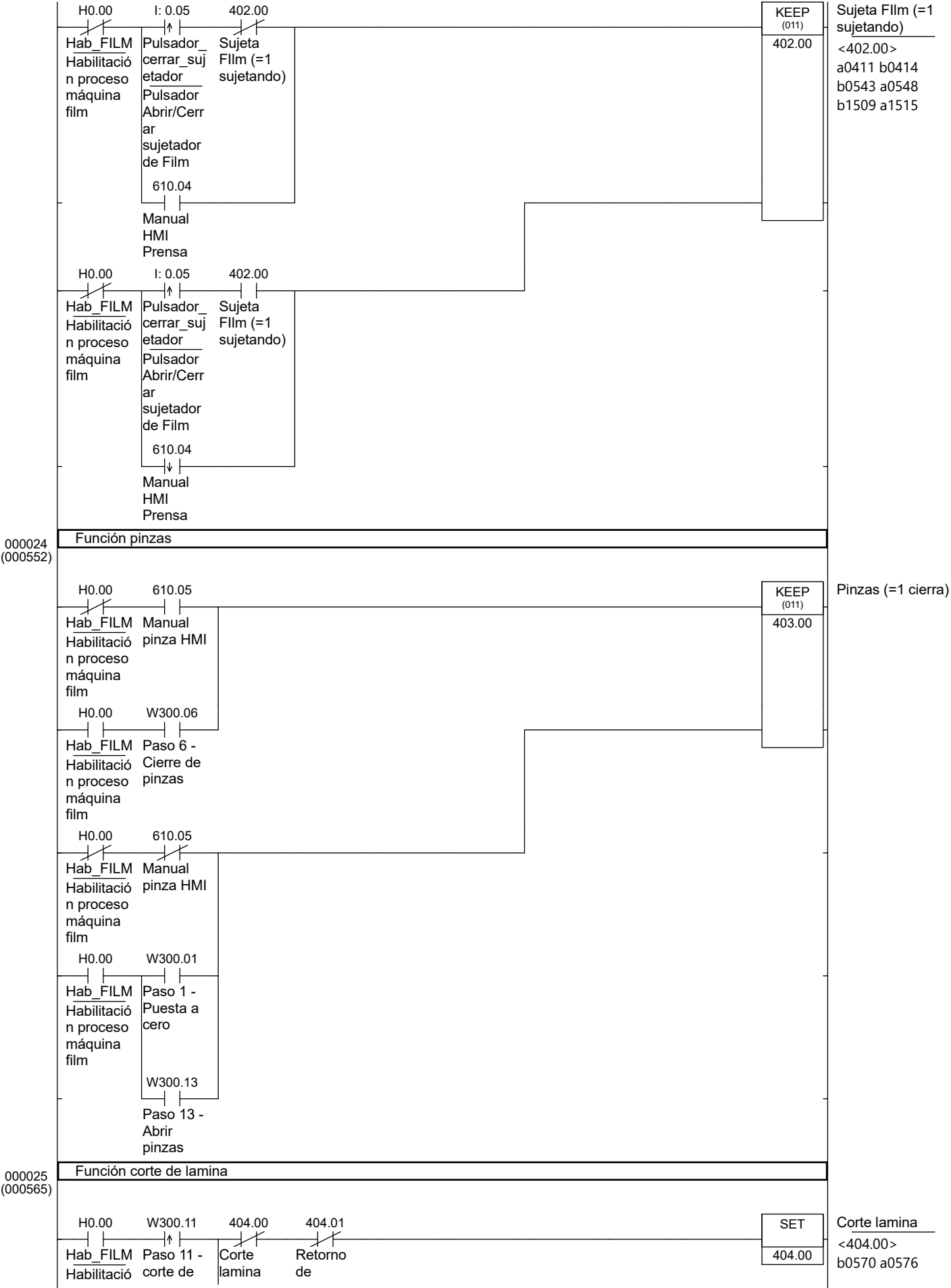


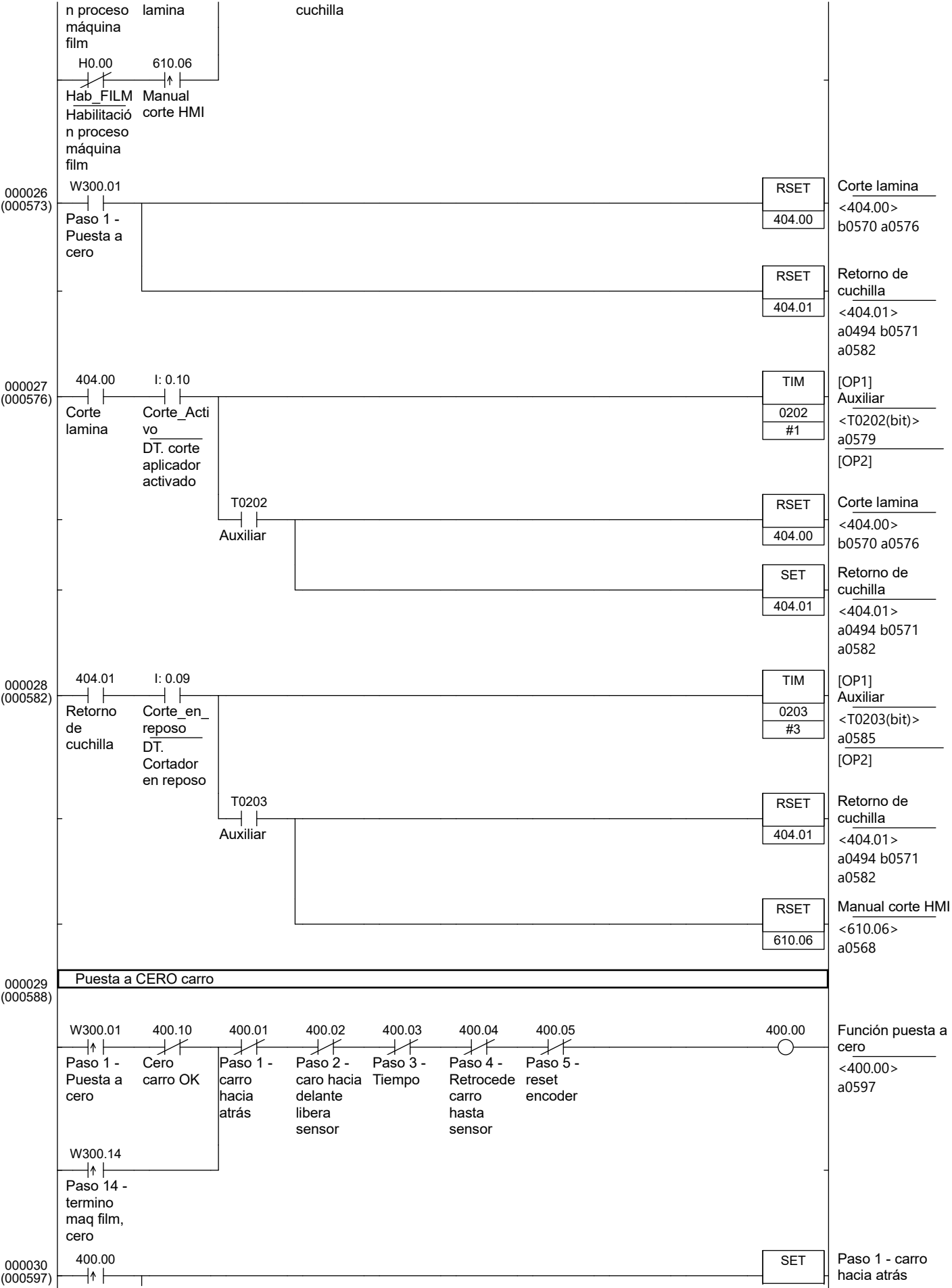


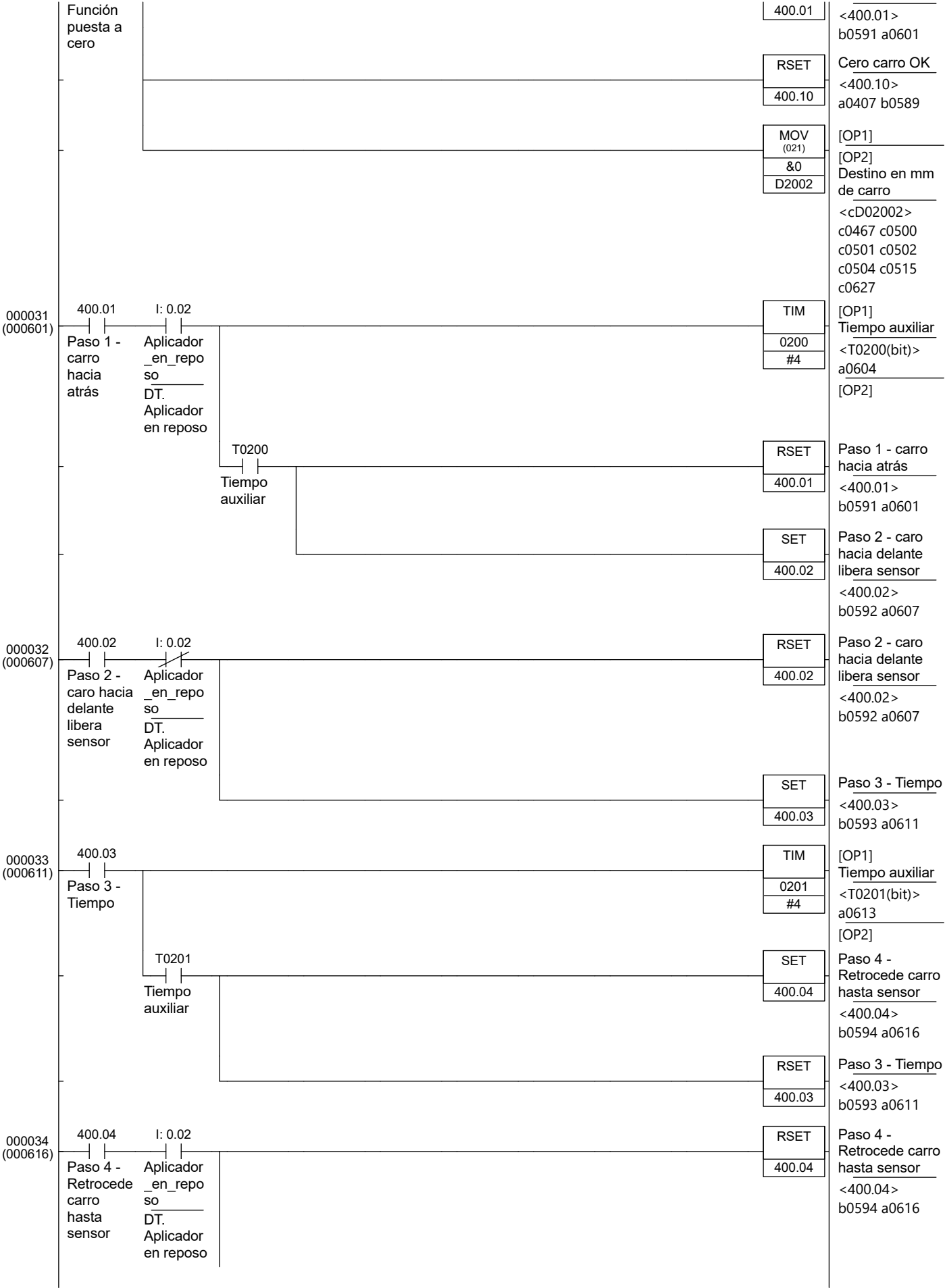


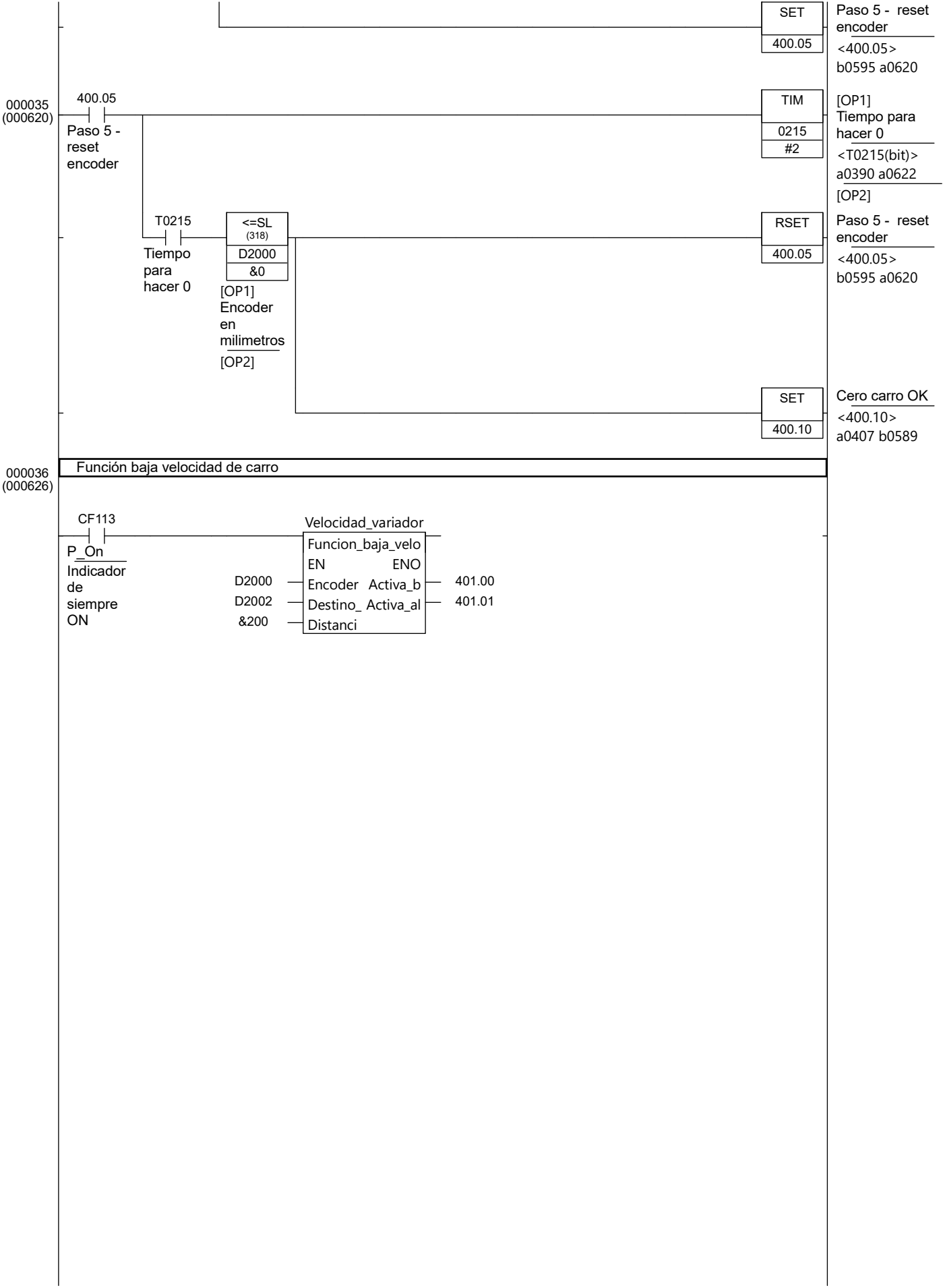


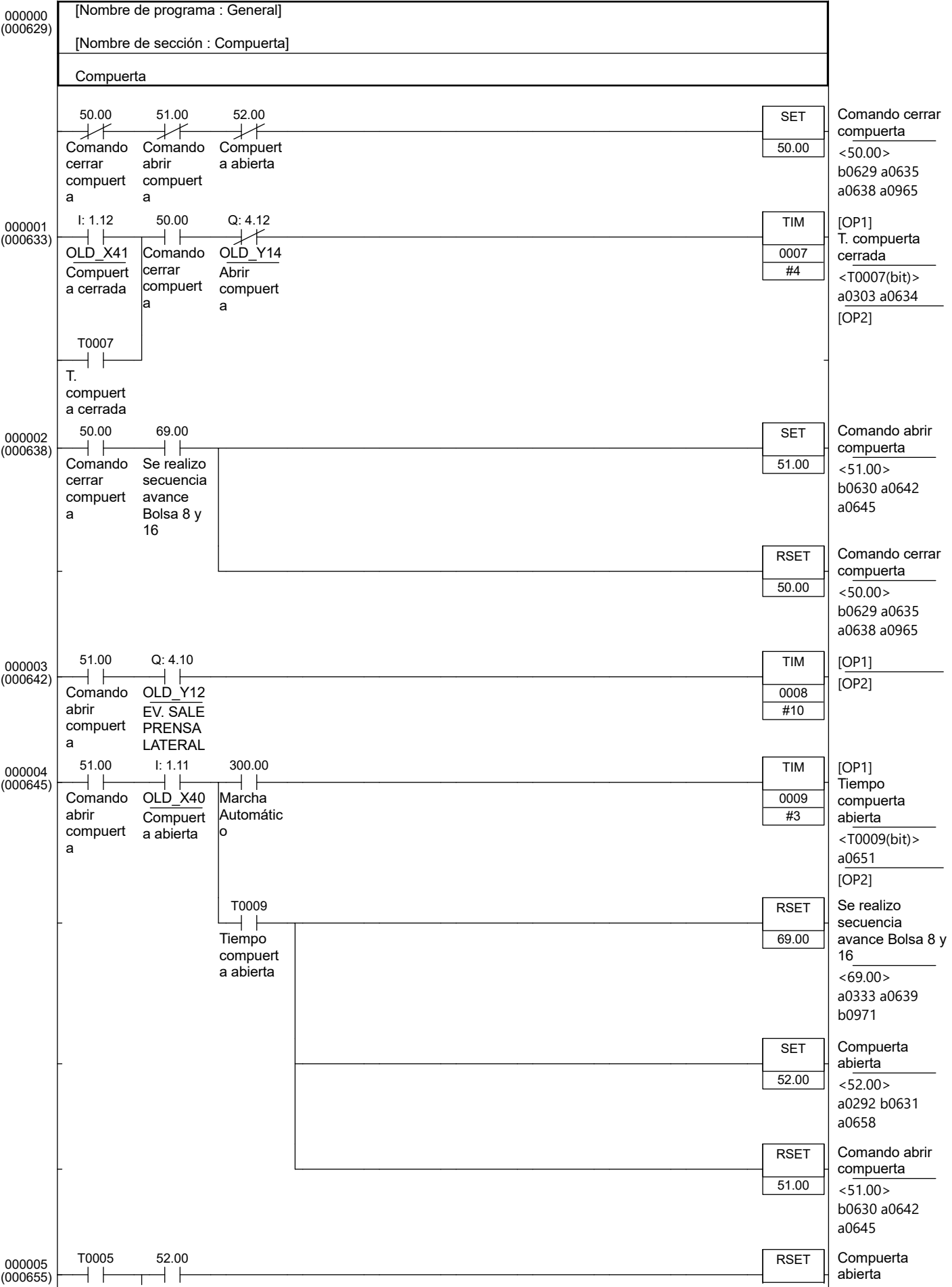






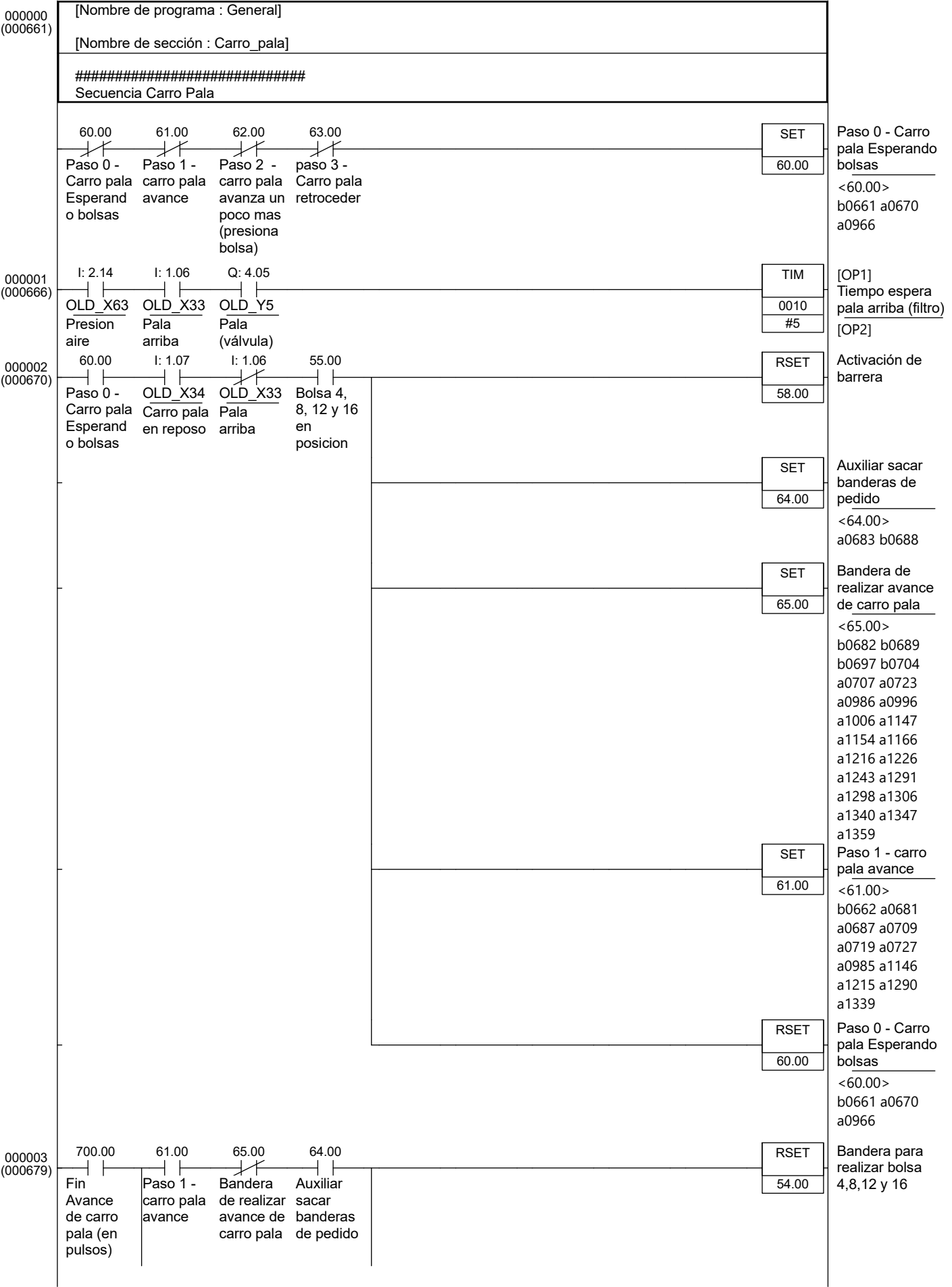


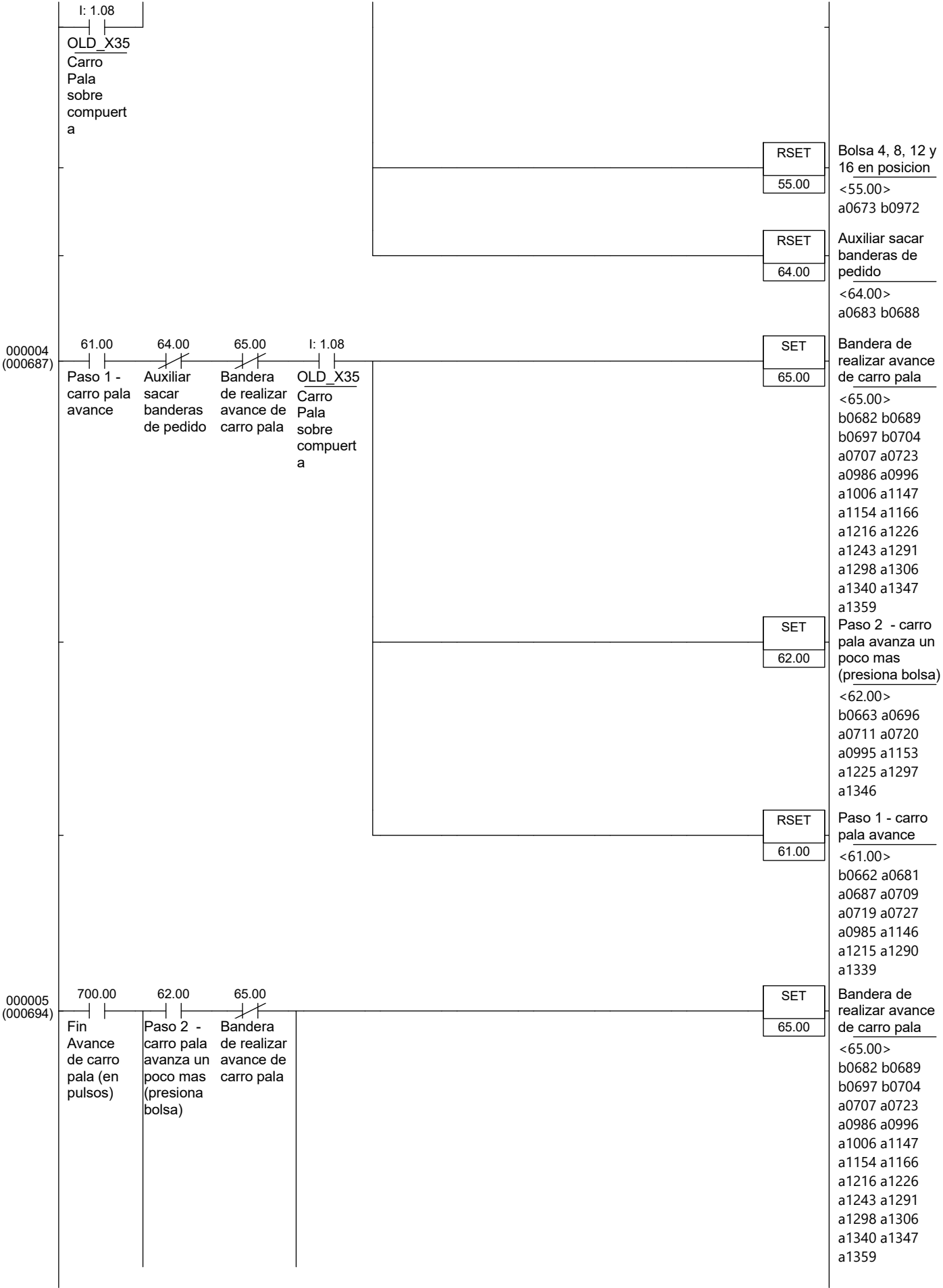


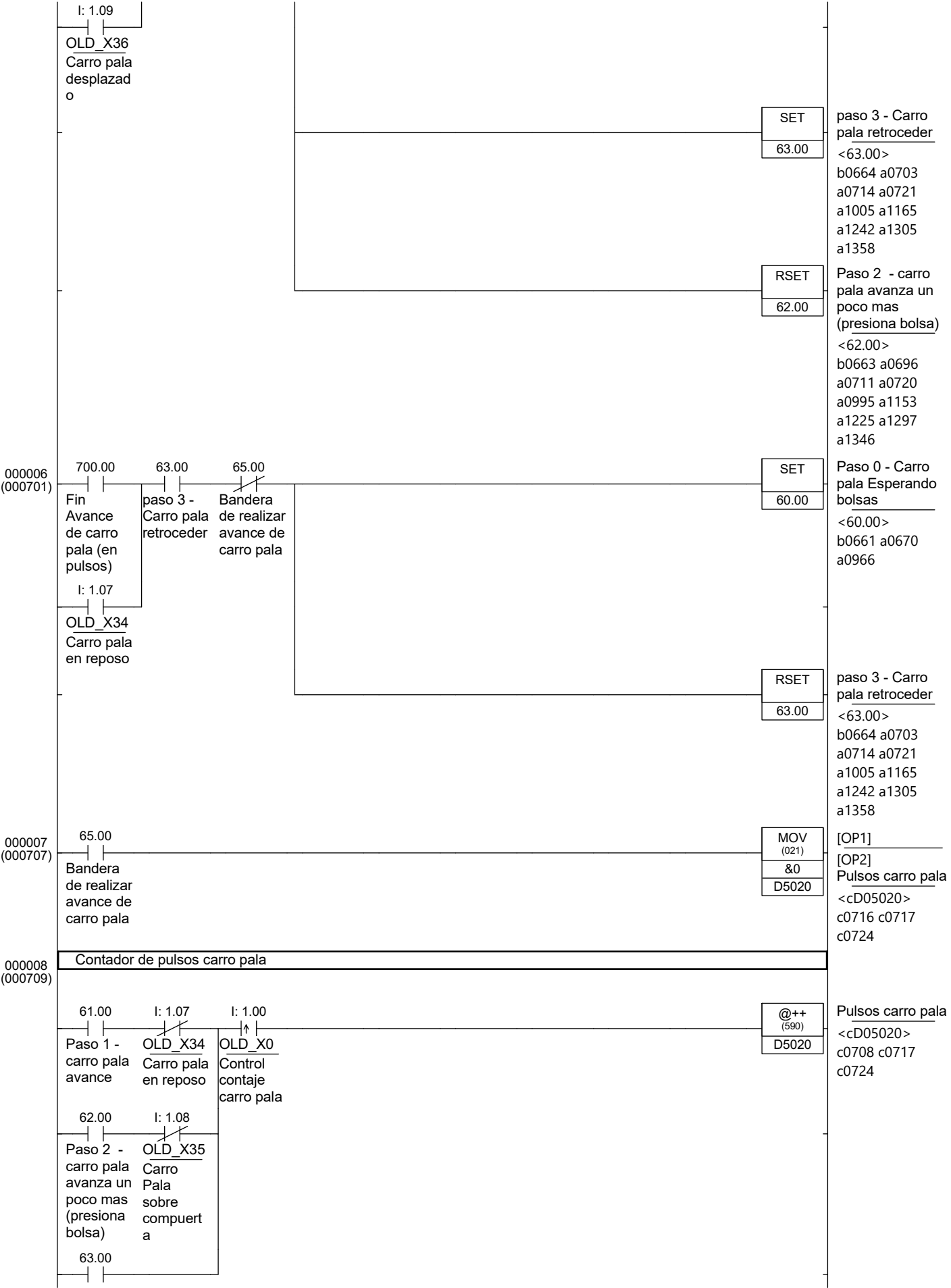


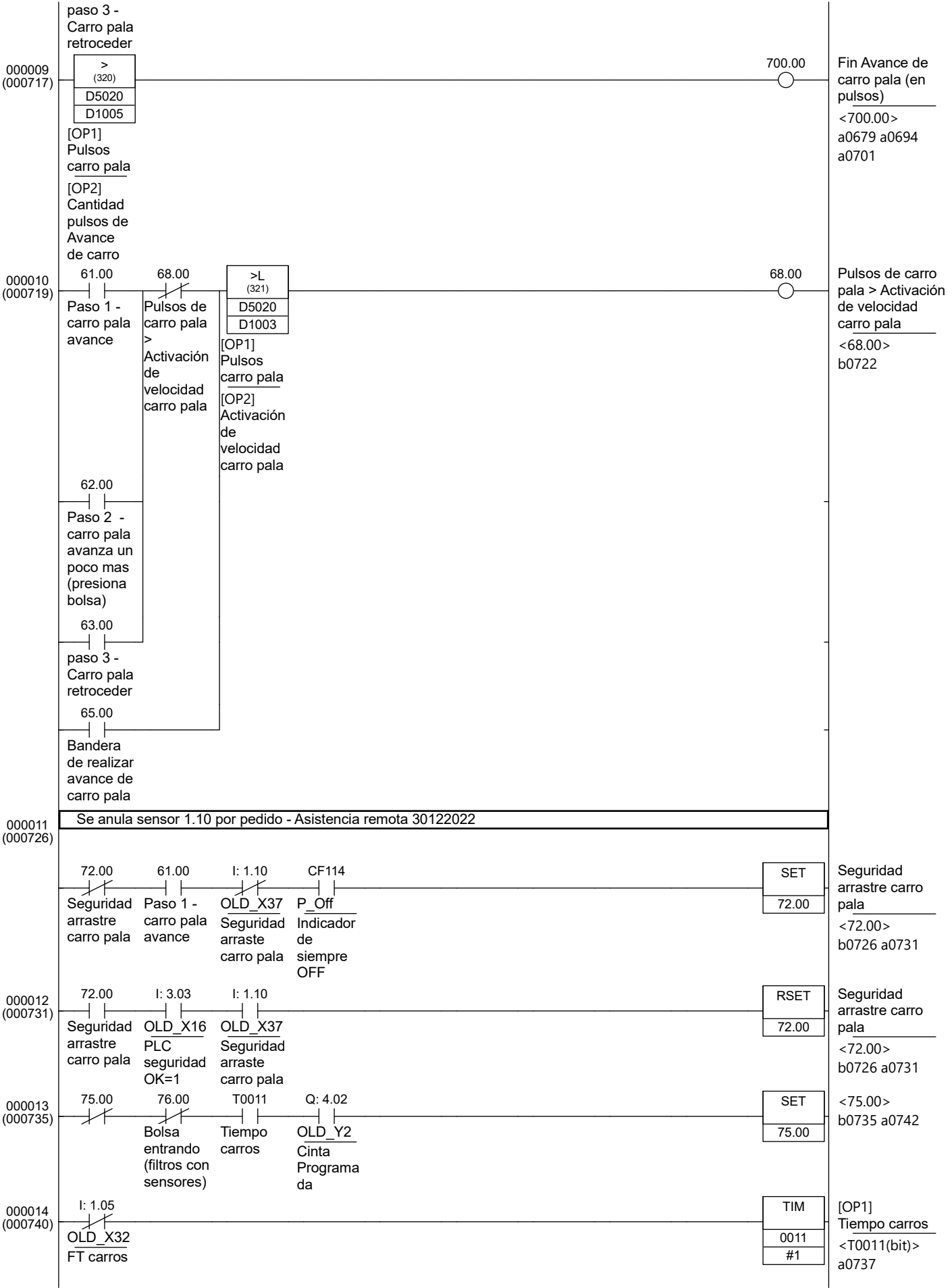


Tiempo libera fotocelula nivelacion 37.00	Compuert a abierta	52.00	<52.00> a0292 b0631 a0658
Ciclo elevador - Paso 7 - bajar..lent o...rapido 38.00			
Ciclo elevador - Paso 8 - Bajar rapido lento, Fin pallets			

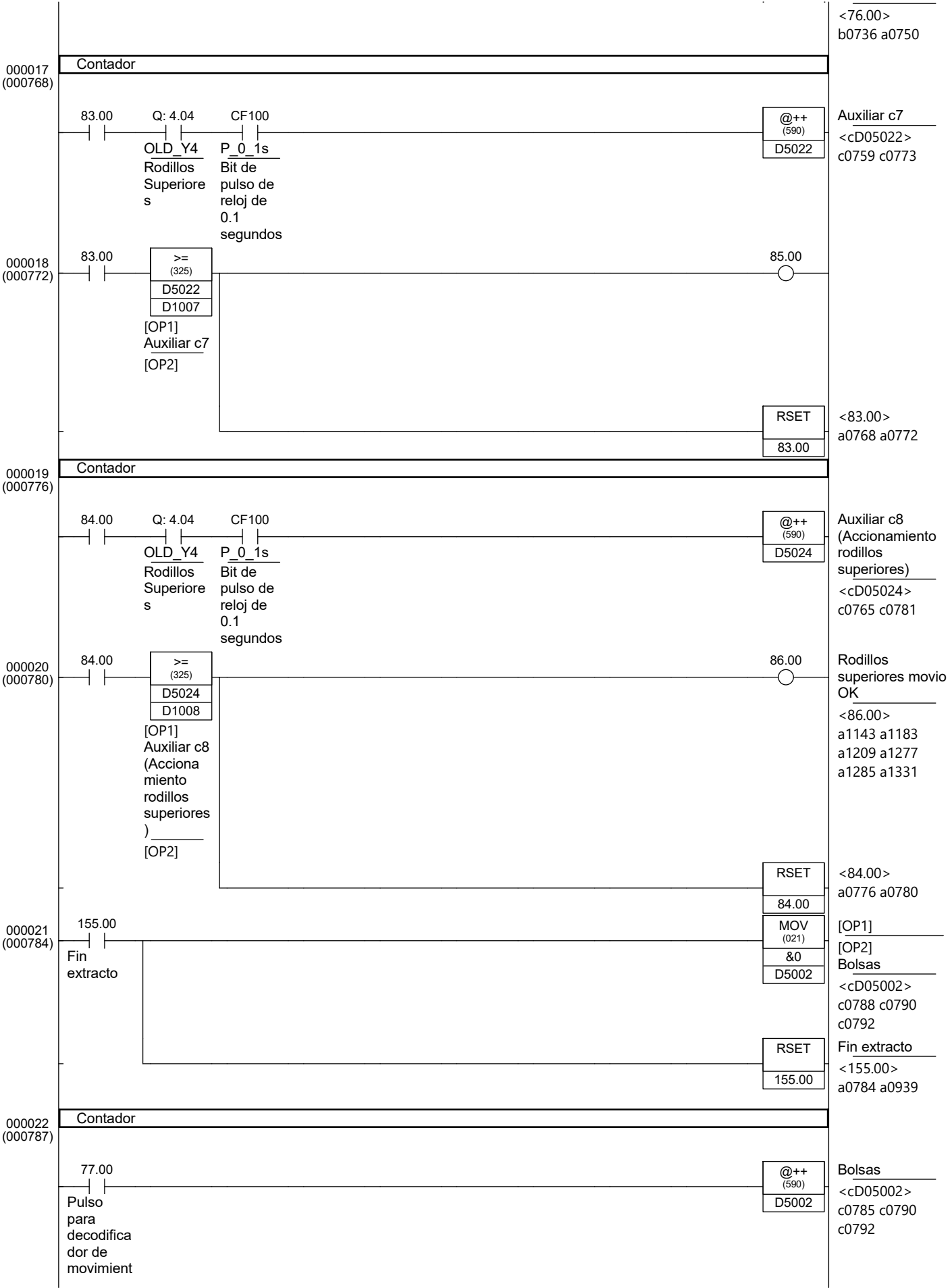


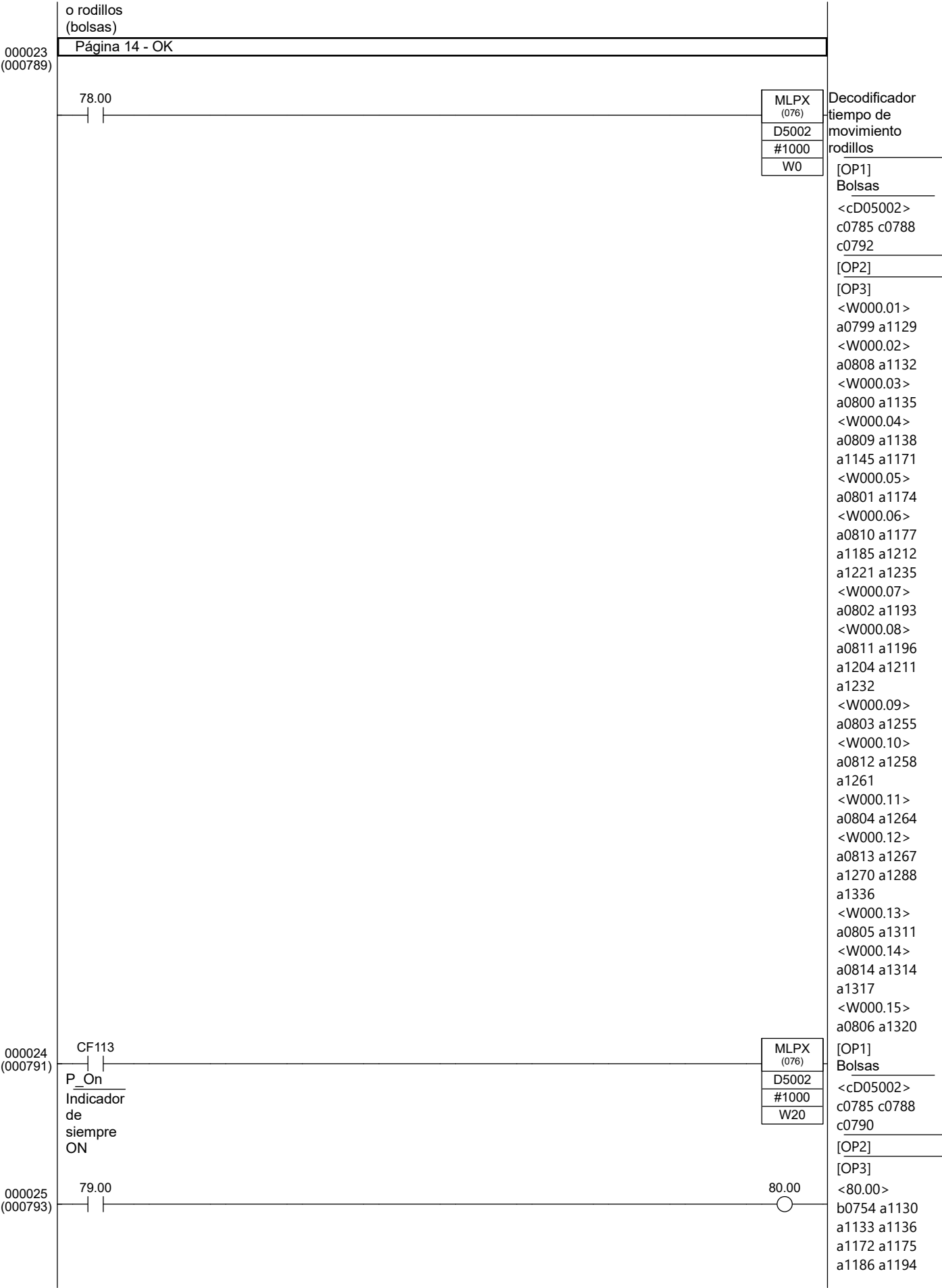




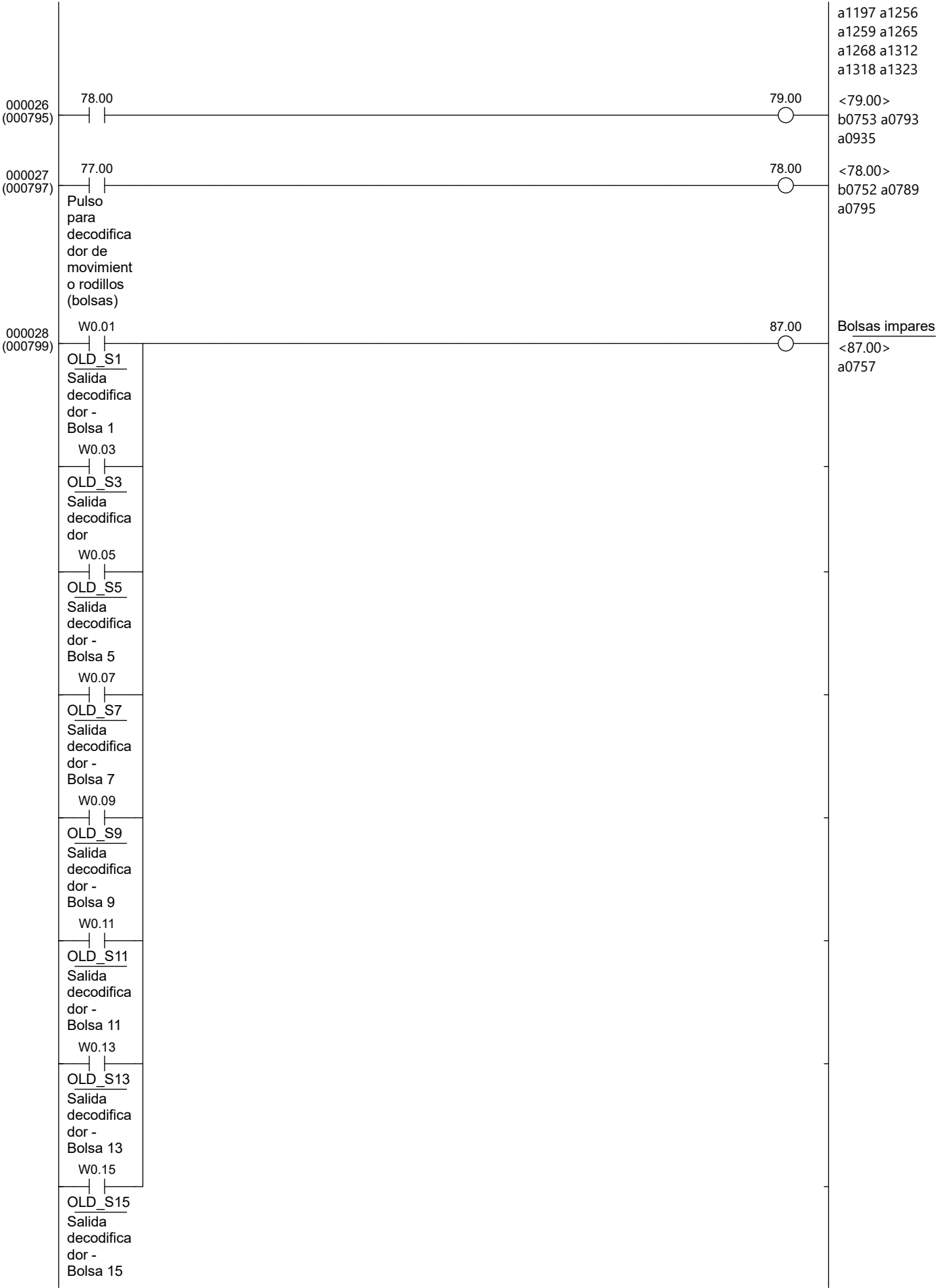


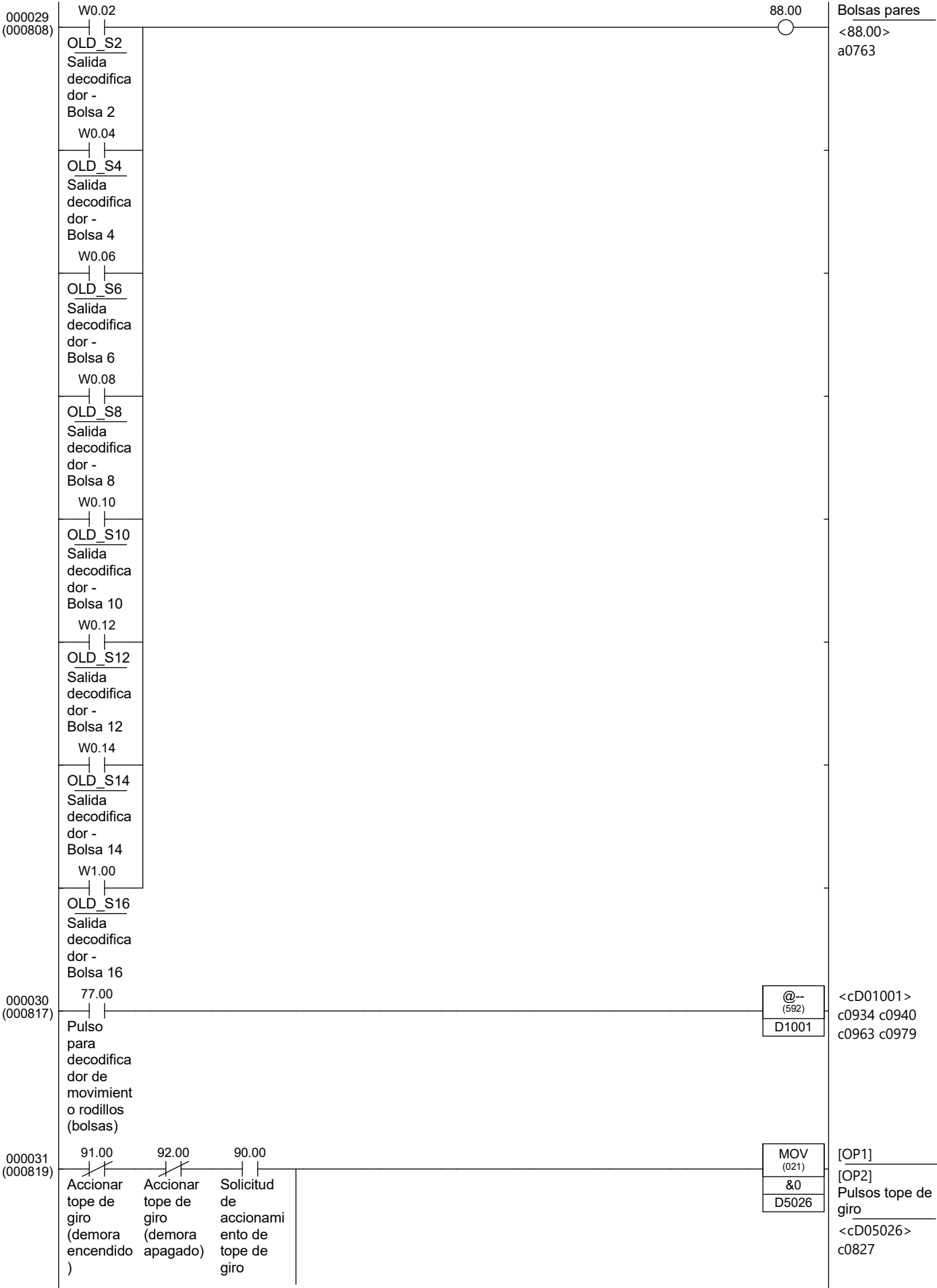


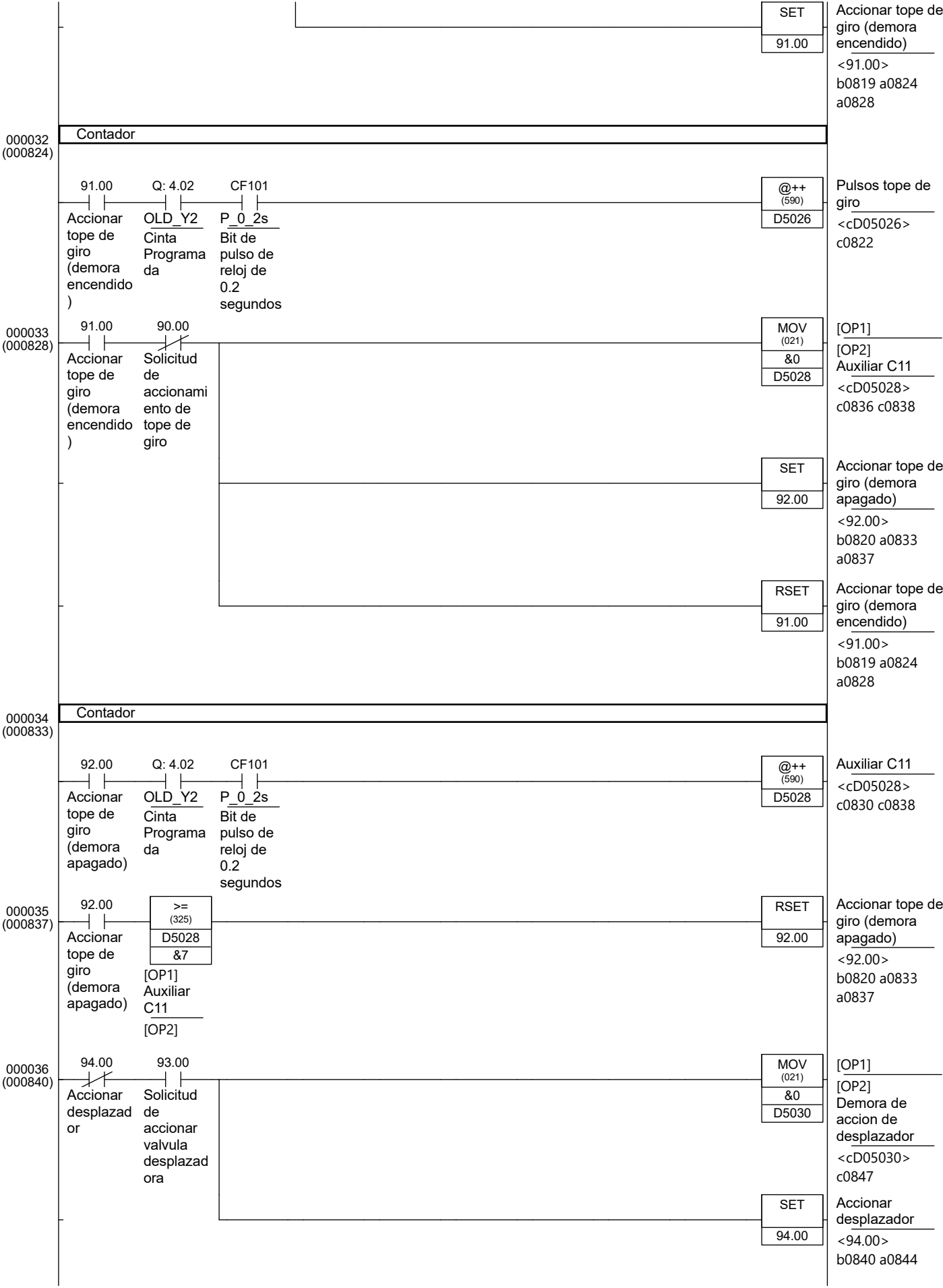


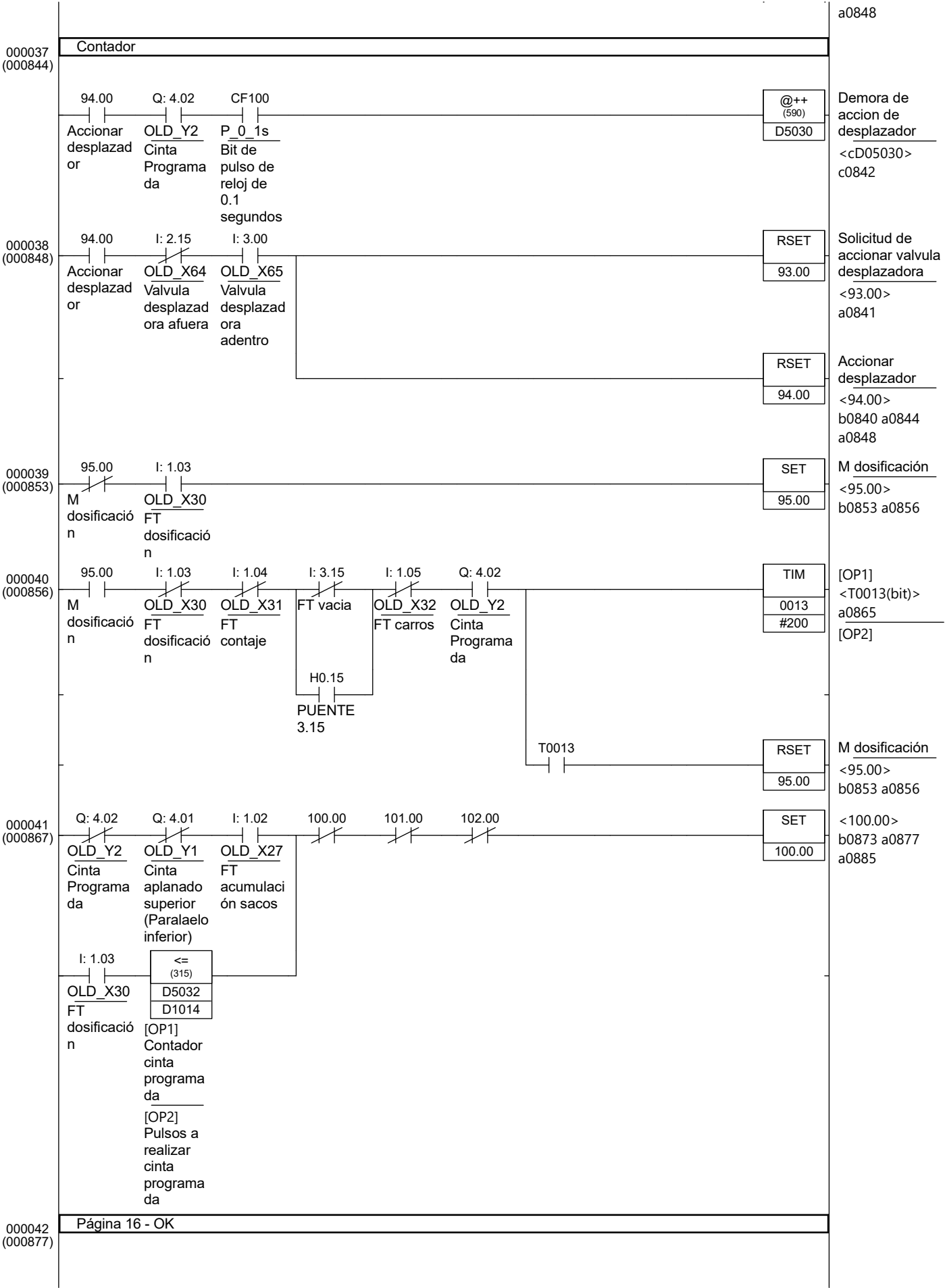


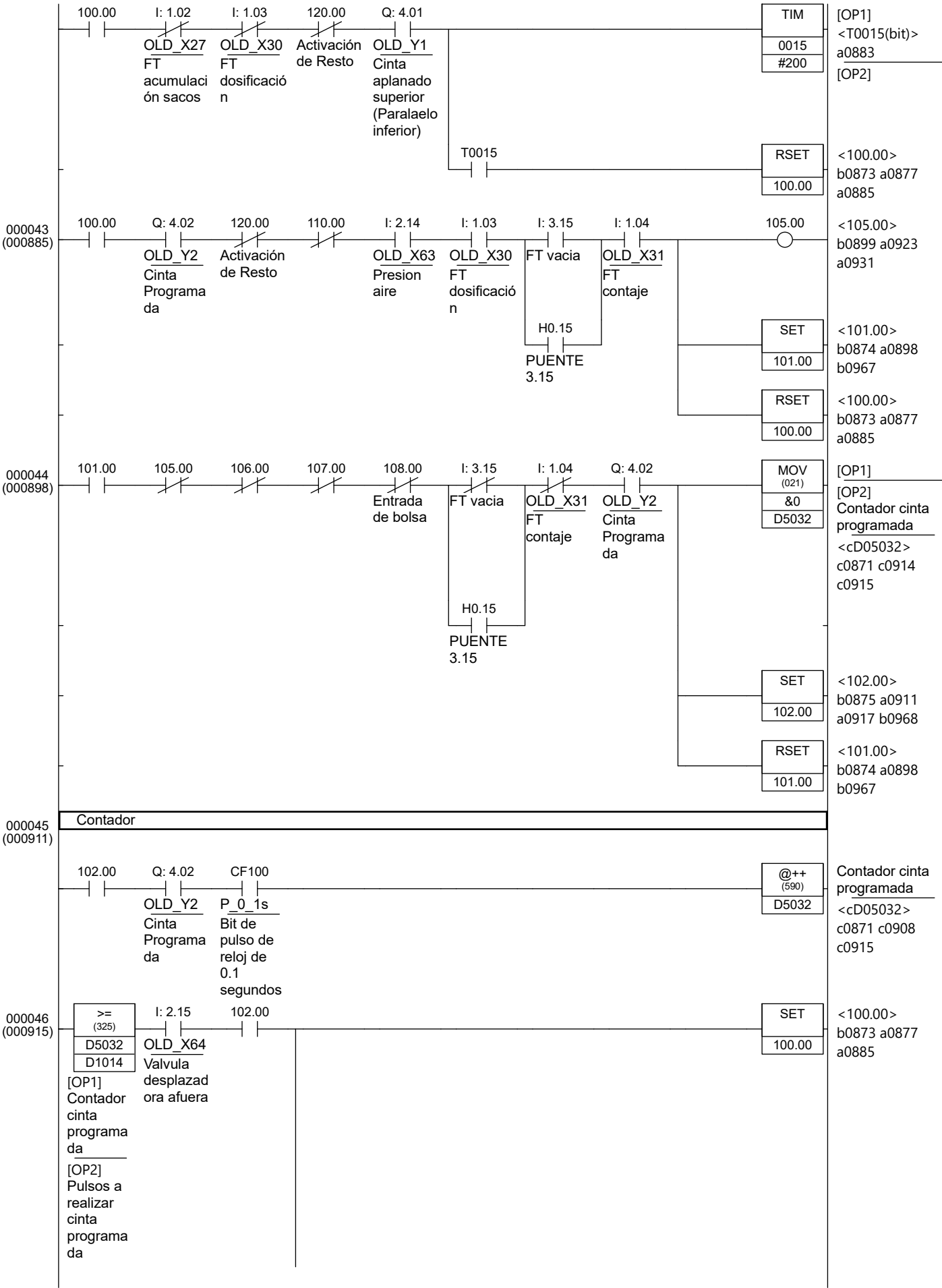


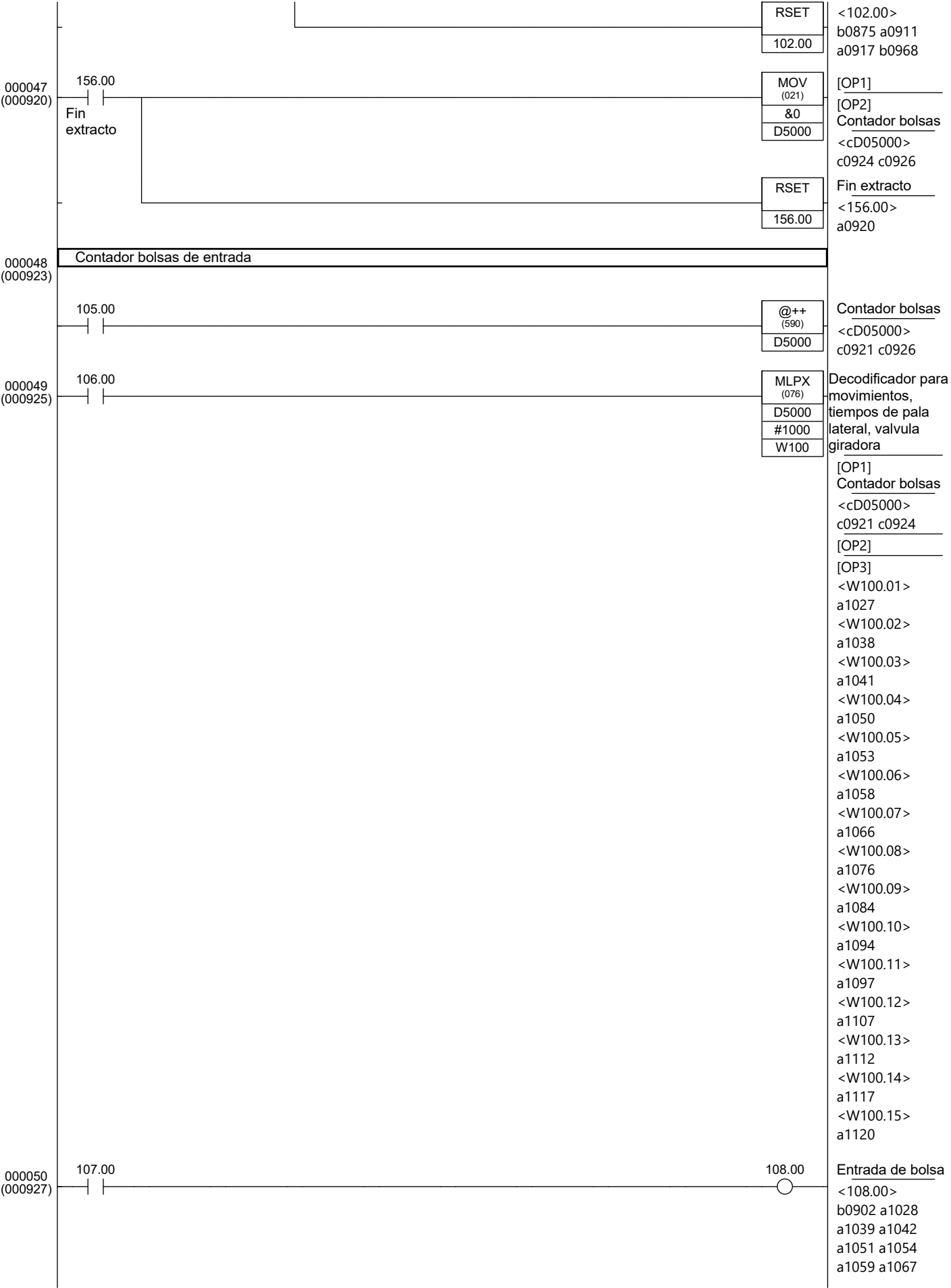


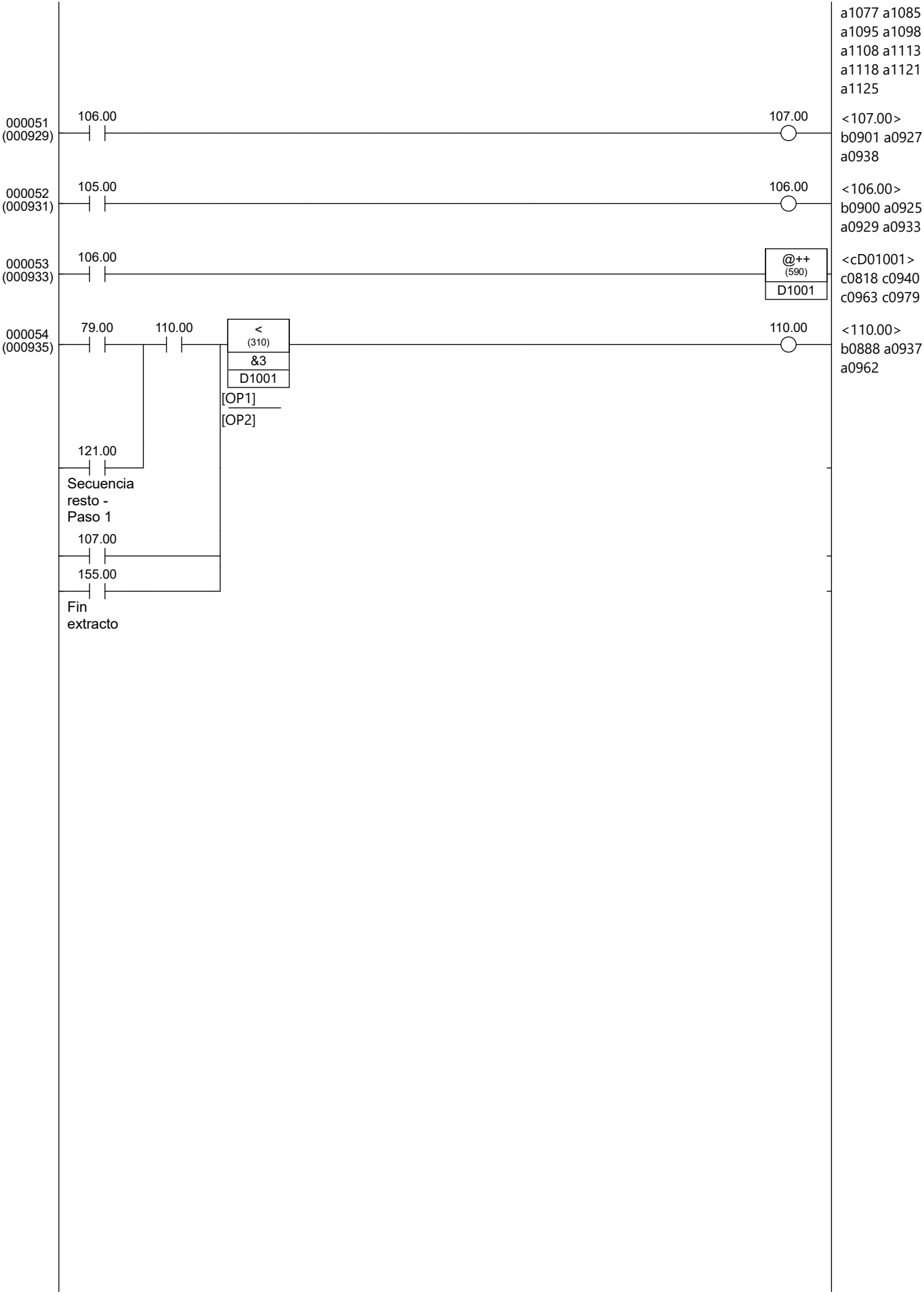


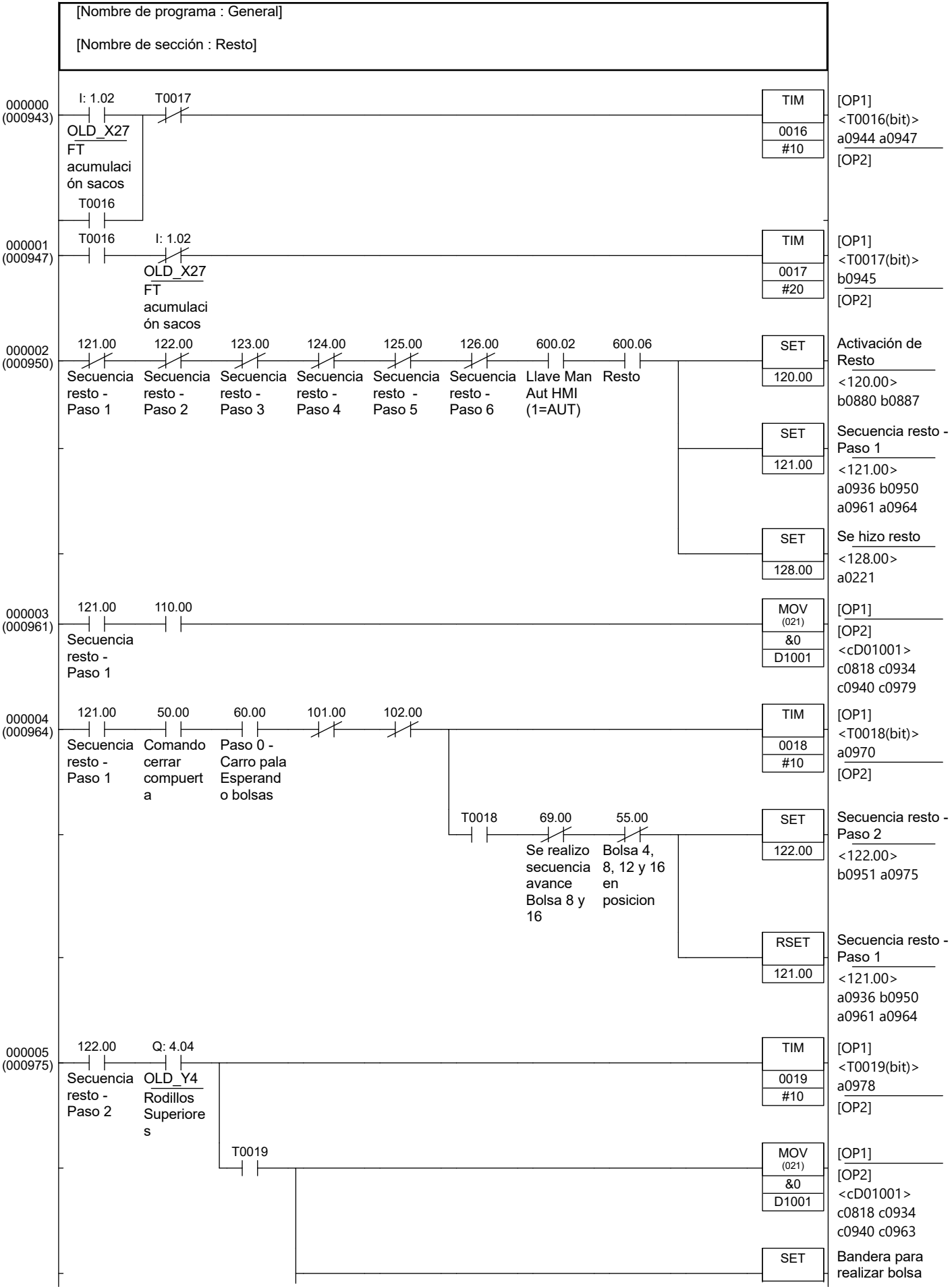














000006 (000984)				54.00	4,8,12 y 16
				SET	Bolsa 4, 8, 12 y 16 en posicion
				55.00	<55.00> a0673 b0972
				SET	Secuencia resto - Paso 3
				123.00	<123.00> b0952 a0984
				RSET	Secuencia resto - Paso 2
				122.00	<122.00> b0951 a0975
	123.00	61.00	65.00	SET	Fin extracto
	Secuencia resto - Paso 3	Paso 1 - carro pala avance	Bandera de realizar avance de carro pala	155.00	<155.00> a0784 a0939
				SET	Fin extracto
				156.00	<156.00> a0920
				MOV (021)	[OP1]
				&5 D1003	[OP2] Activación de velocidad carro pala
					<cD01003> c0724 c0997 c1008 c1148 c1156 c1167 c1217 c1228 c1245 c1292 c1299 c1307 c1341 c1349 c1360
				MOV (021)	[OP1]
				&40 D1005	[OP2] Cantidad pulsos de Avance de carro
					<cD01005> c0717 c0998 c1009 c1149 c1157 c1159 c1168 c1218 c1229 c1233 c1236 c1246 c1293 c1300 c1308 c1342 c1350 c1352 c1361
				RSET	Bandera de realizar avance de carro pala
				65.00	<65.00> b0682 b0689 b0697 b0704 a0707 a0723 a0986 a0996 a1006 a1147 a1154 a1166 a1216 a1226

000007  
(000994)

124.00	62.00	65.00
Secuencia resto - Paso 4	Paso 2 - carro pala avanza un poco mas (presiona bolsa)	Bandera de realizar avance de carro pala

SET
124.00

a1243 a1291  
a1298 a1306  
a1340 a1347  
a1359

Secuencia resto - Paso 4

<124.00>

b0953 a0994

RSET
123.00

Secuencia resto - Paso 3

<123.00>

b0952 a0984

MOV (021)
&11
D1003

[OP1]

[OP2]

Activación de velocidad carro pala

<cD01003>

c0724 c0989  
c1008 c1148  
c1156 c1167  
c1217 c1228  
c1245 c1292  
c1299 c1307  
c1341 c1349  
c1360

MOV (021)
&26
D1005

[OP1]

[OP2]

Cantidad pulsos de Avance de carro

<cD01005>

c0717 c0990  
c1009 c1149  
c1157 c1159  
c1168 c1218  
c1229 c1233  
c1236 c1246  
c1293 c1300  
c1308 c1342  
c1350 c1352  
c1361

RSET
65.00

Bandera de realizar avance de carro pala

<65.00>

b0682 b0689  
b0697 b0704  
a0707 a0723  
a0986 a0996  
a1006 a1147  
a1154 a1166  
a1216 a1226  
a1243 a1291  
a1298 a1306  
a1340 a1347  
a1359

SET
127.00

<127.00>

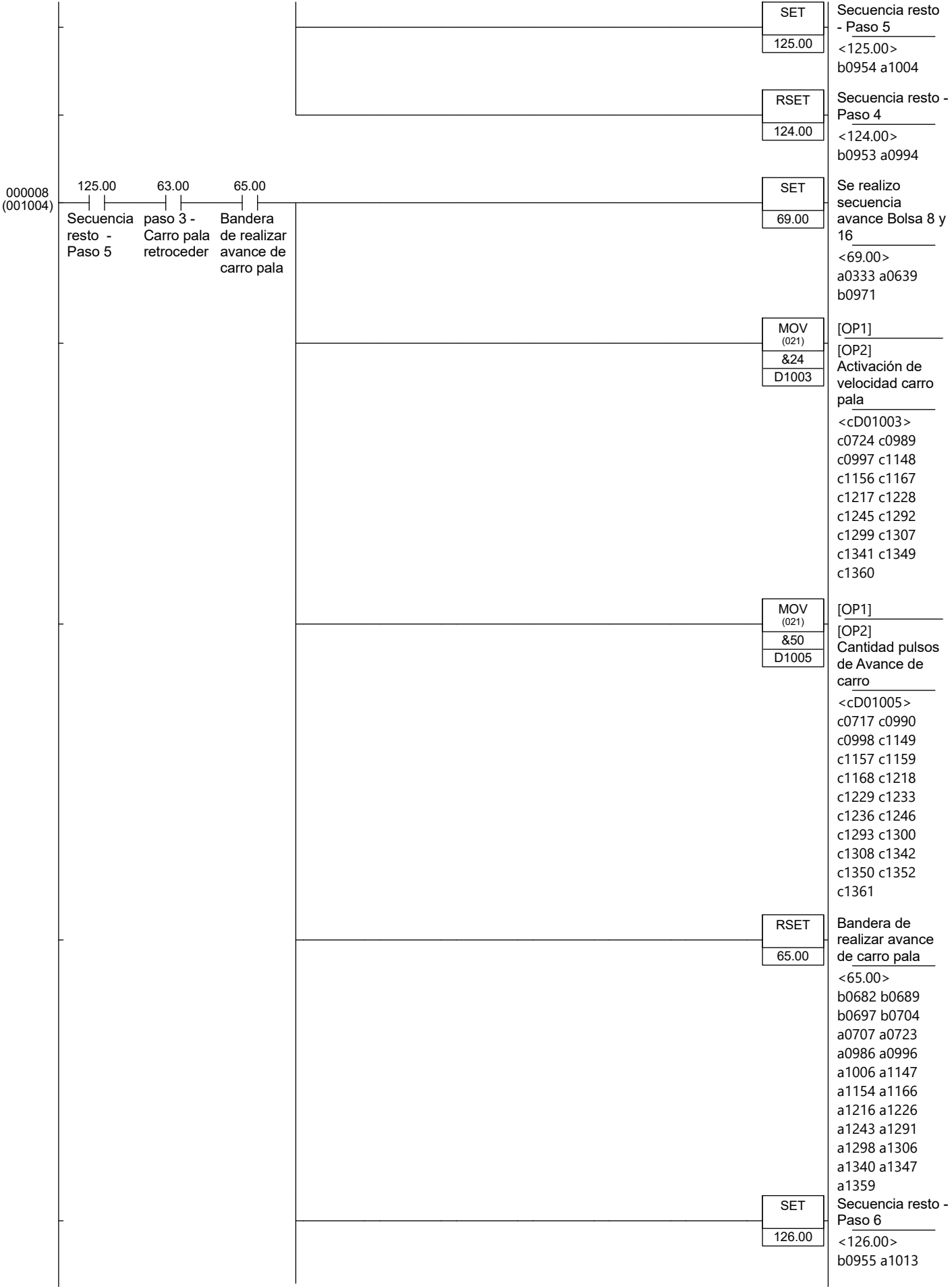
b0302 a0310

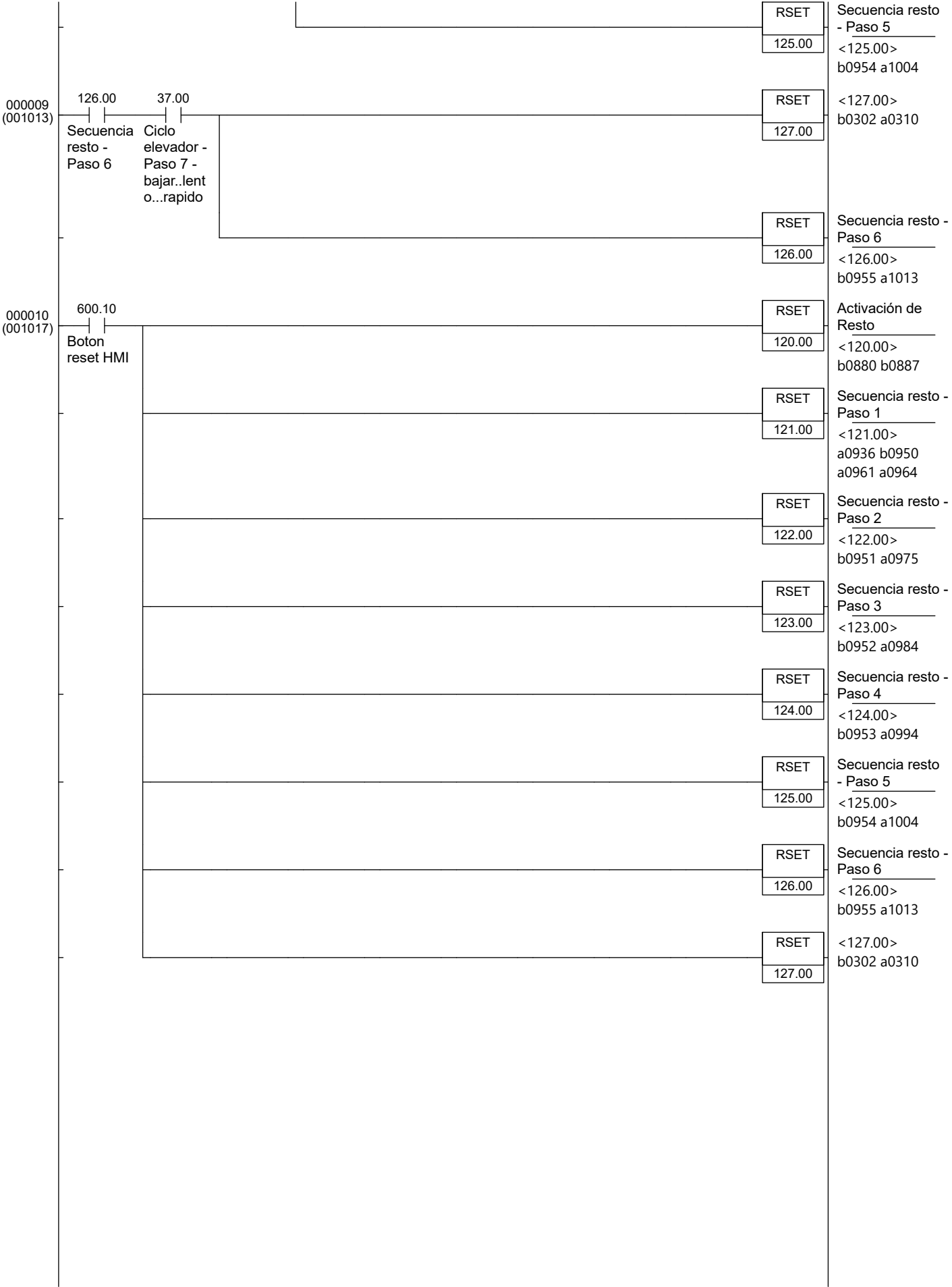
RSET
120.00

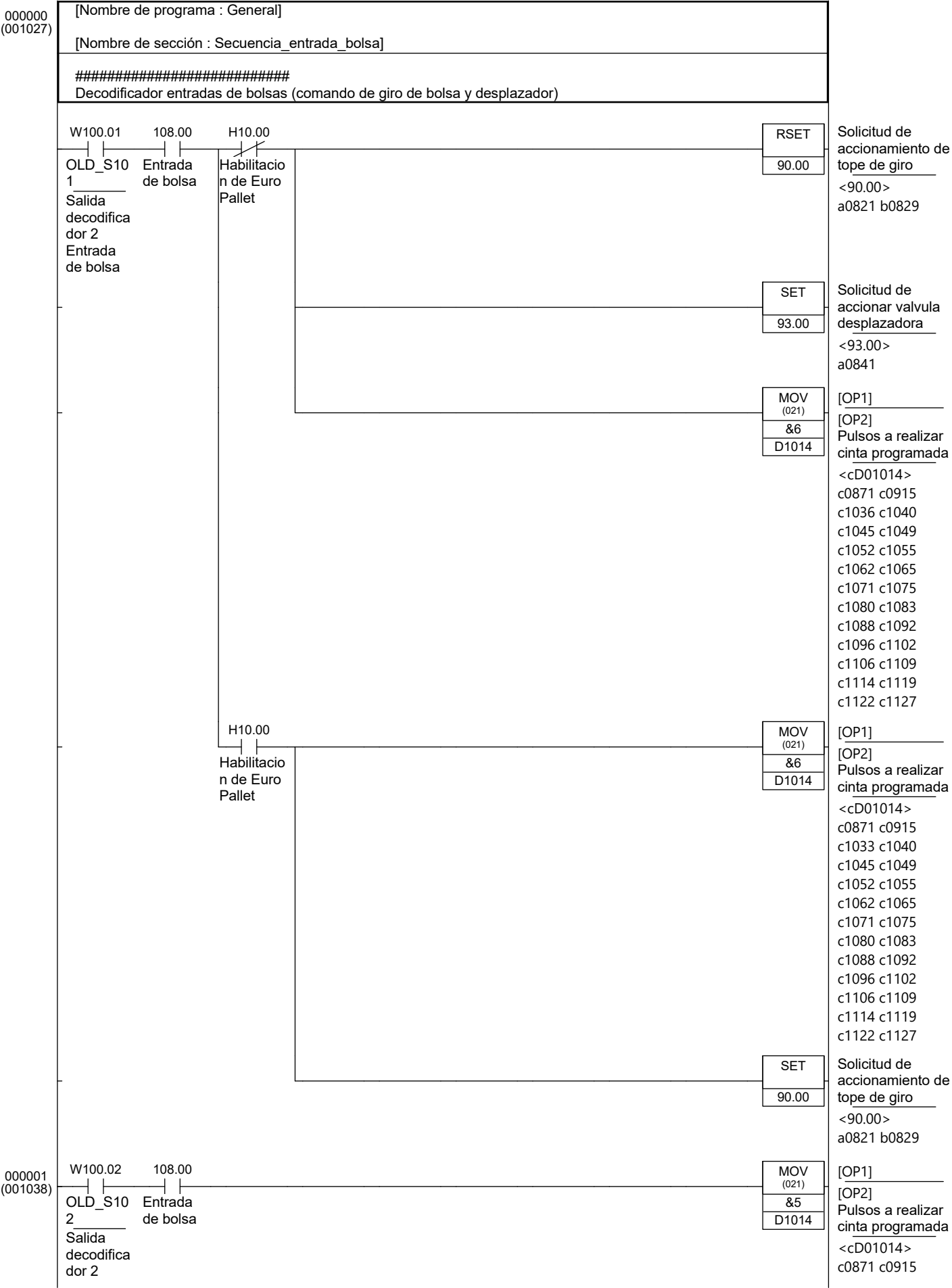
Activación de Resto

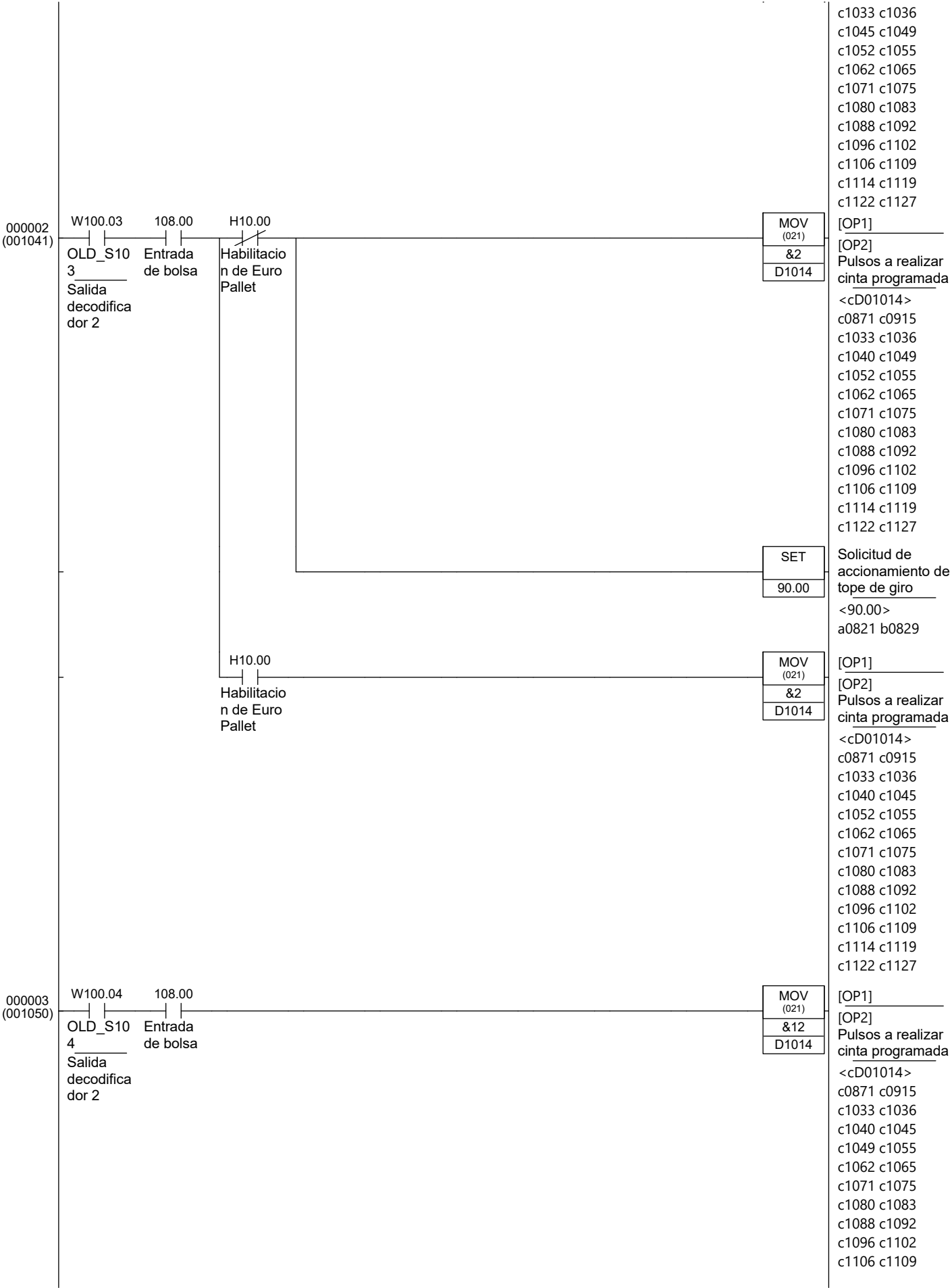
<120.00>

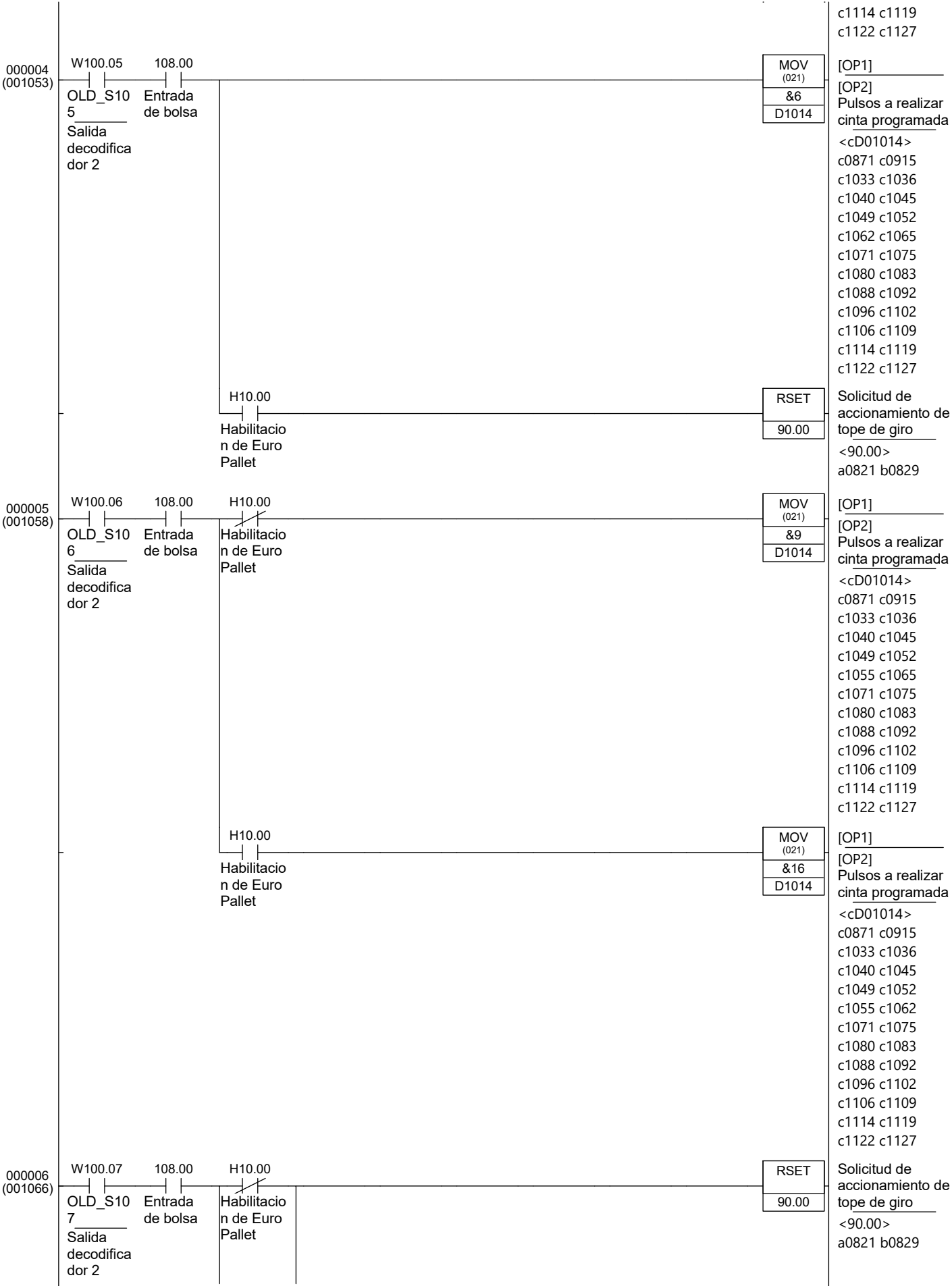
b0880 b0887

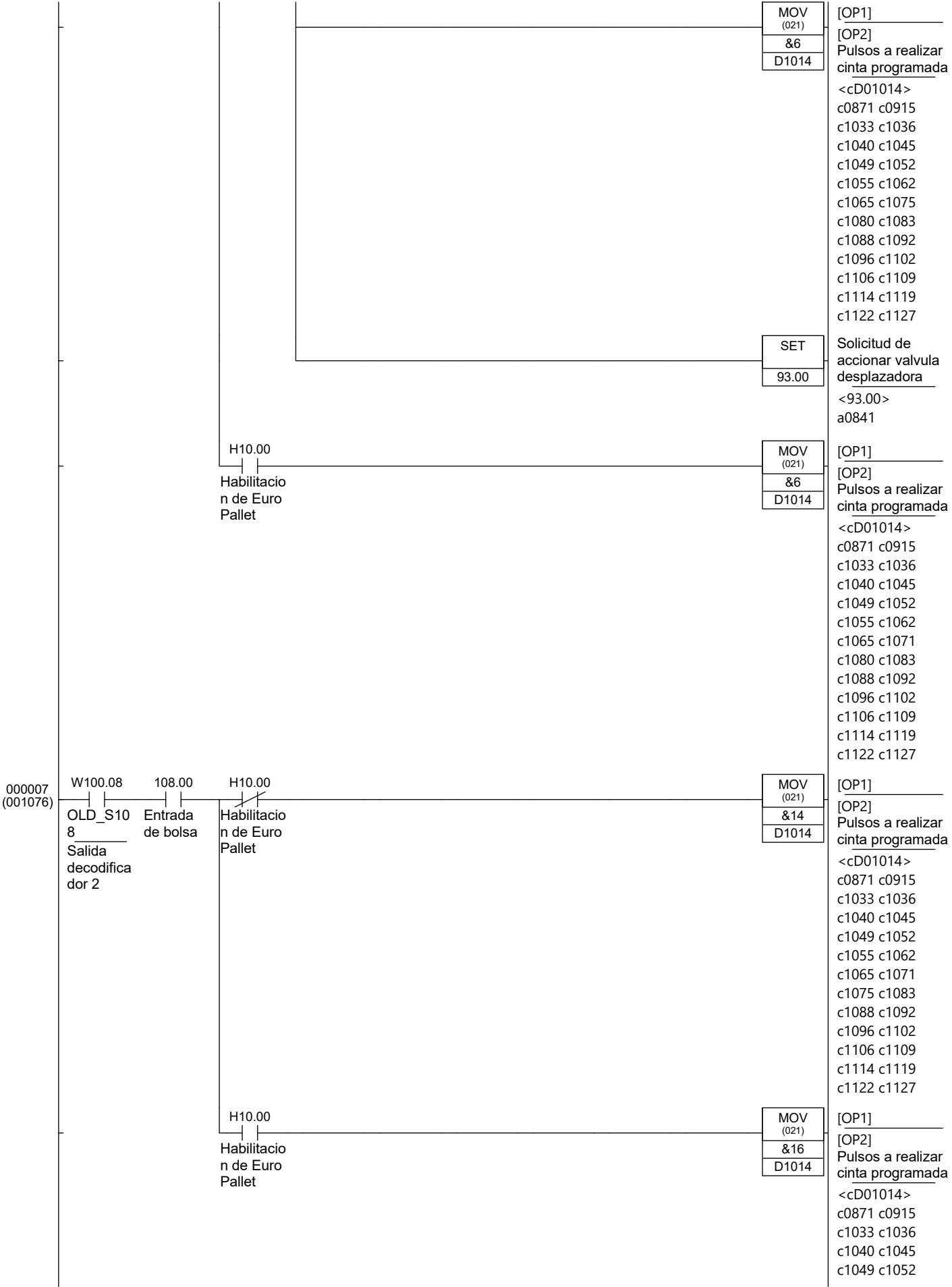




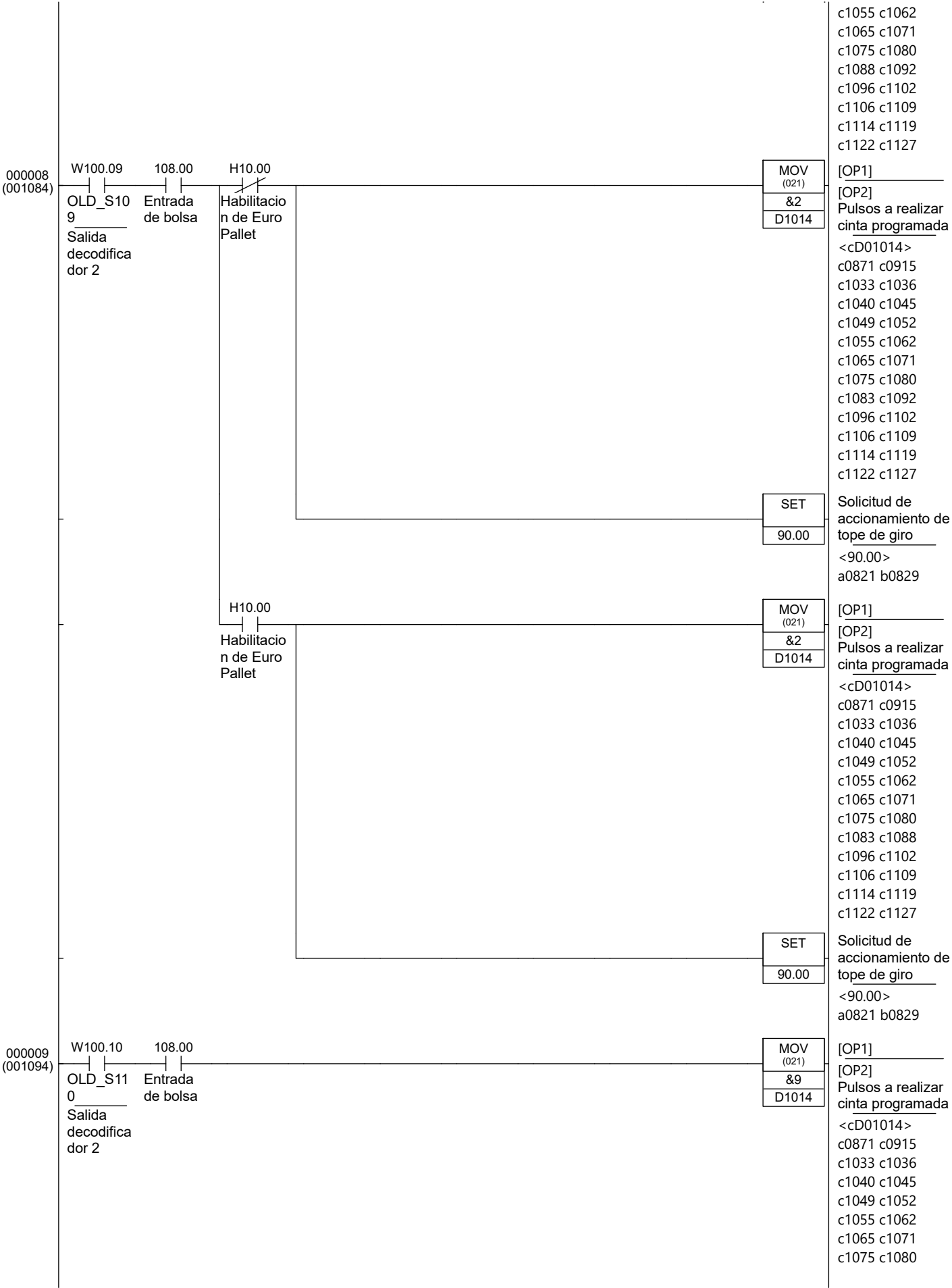


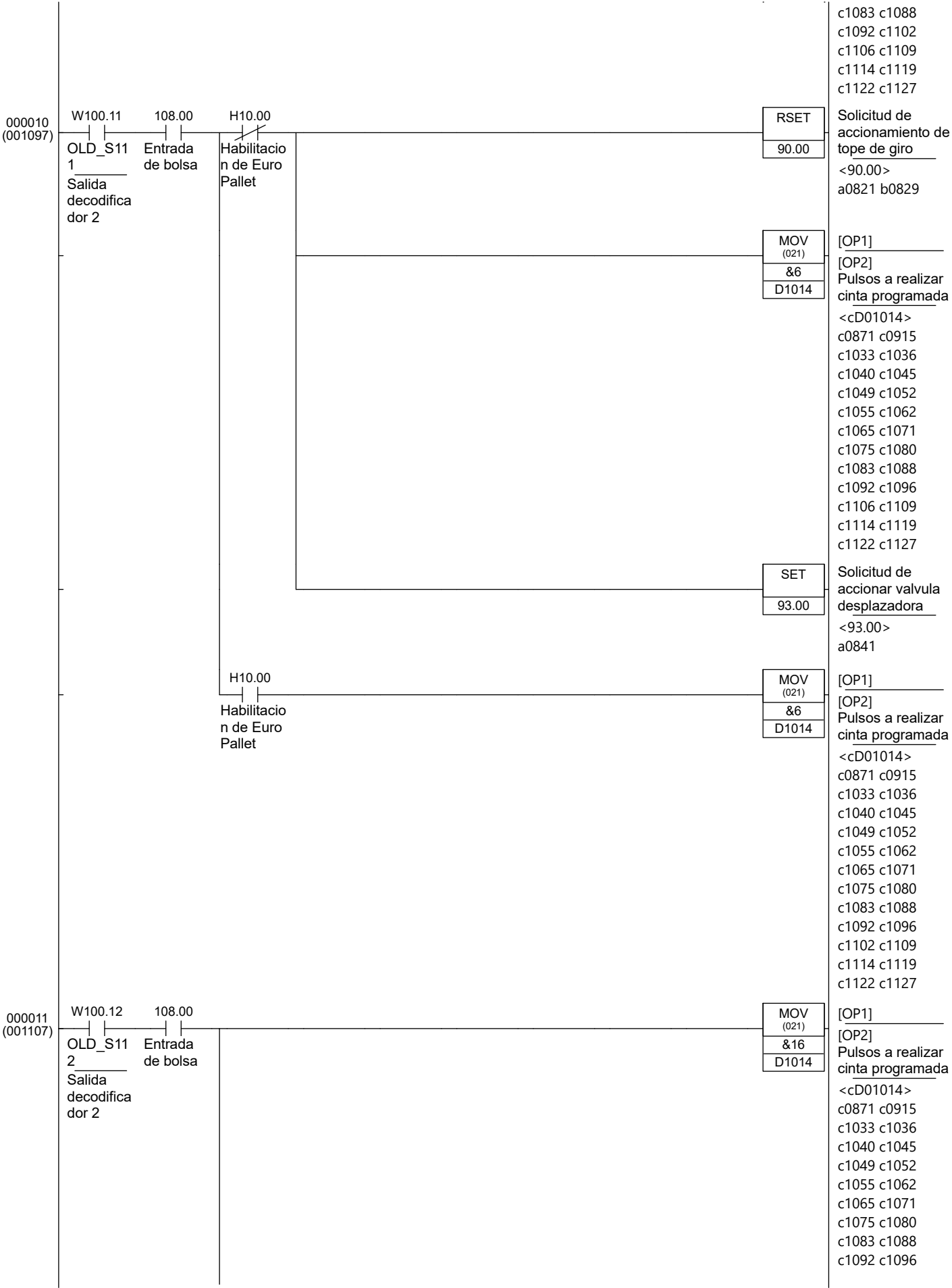


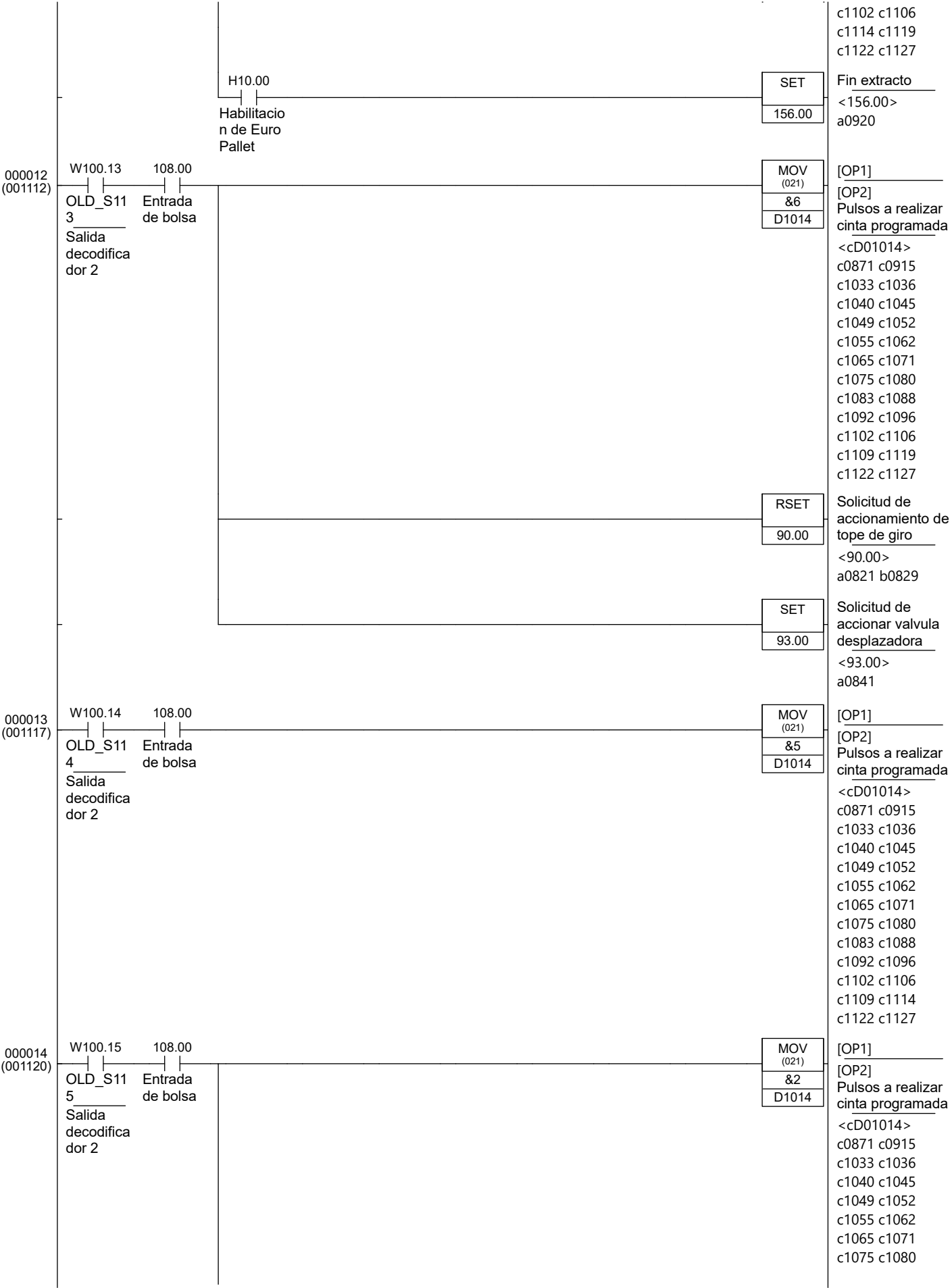


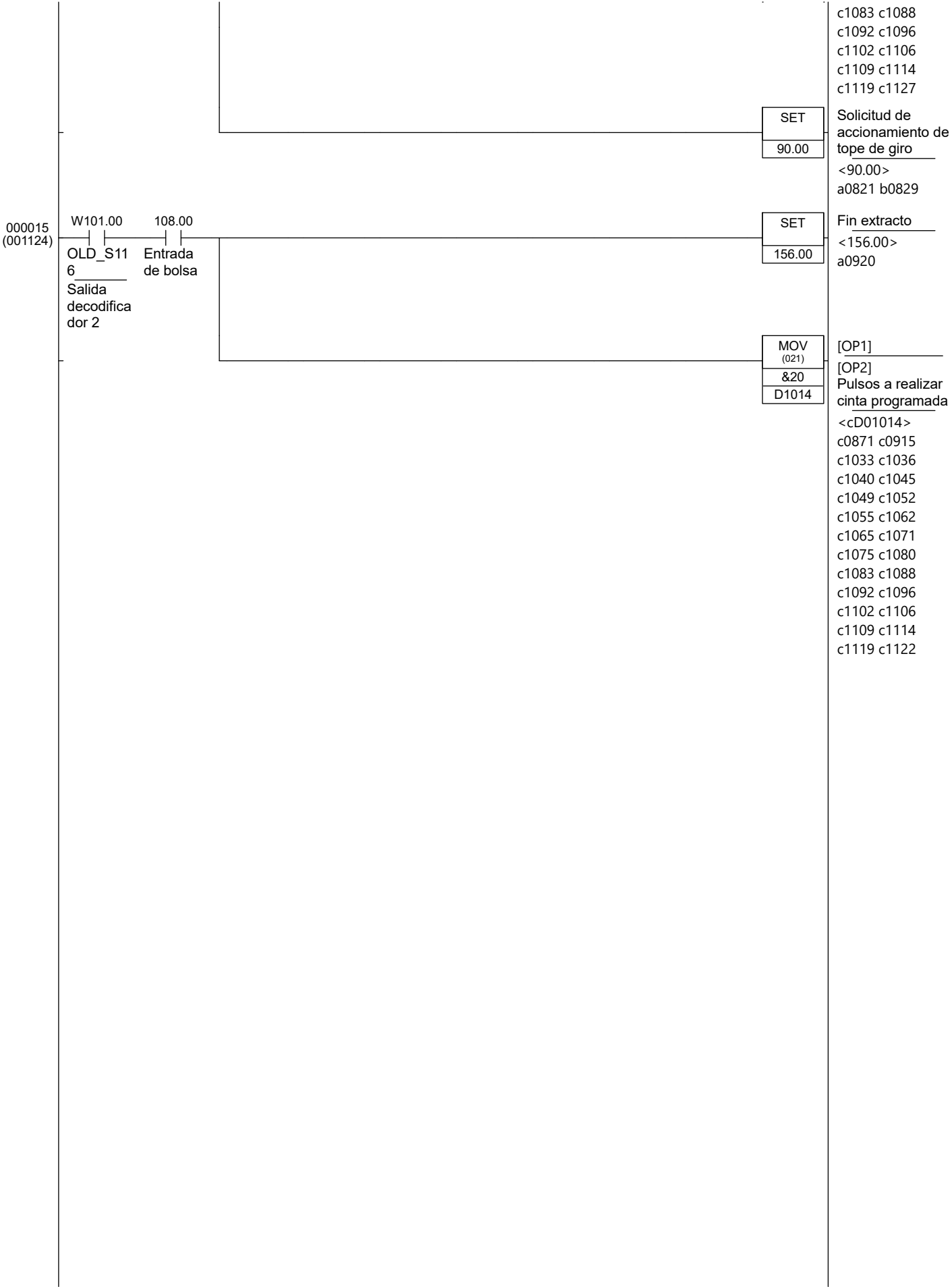


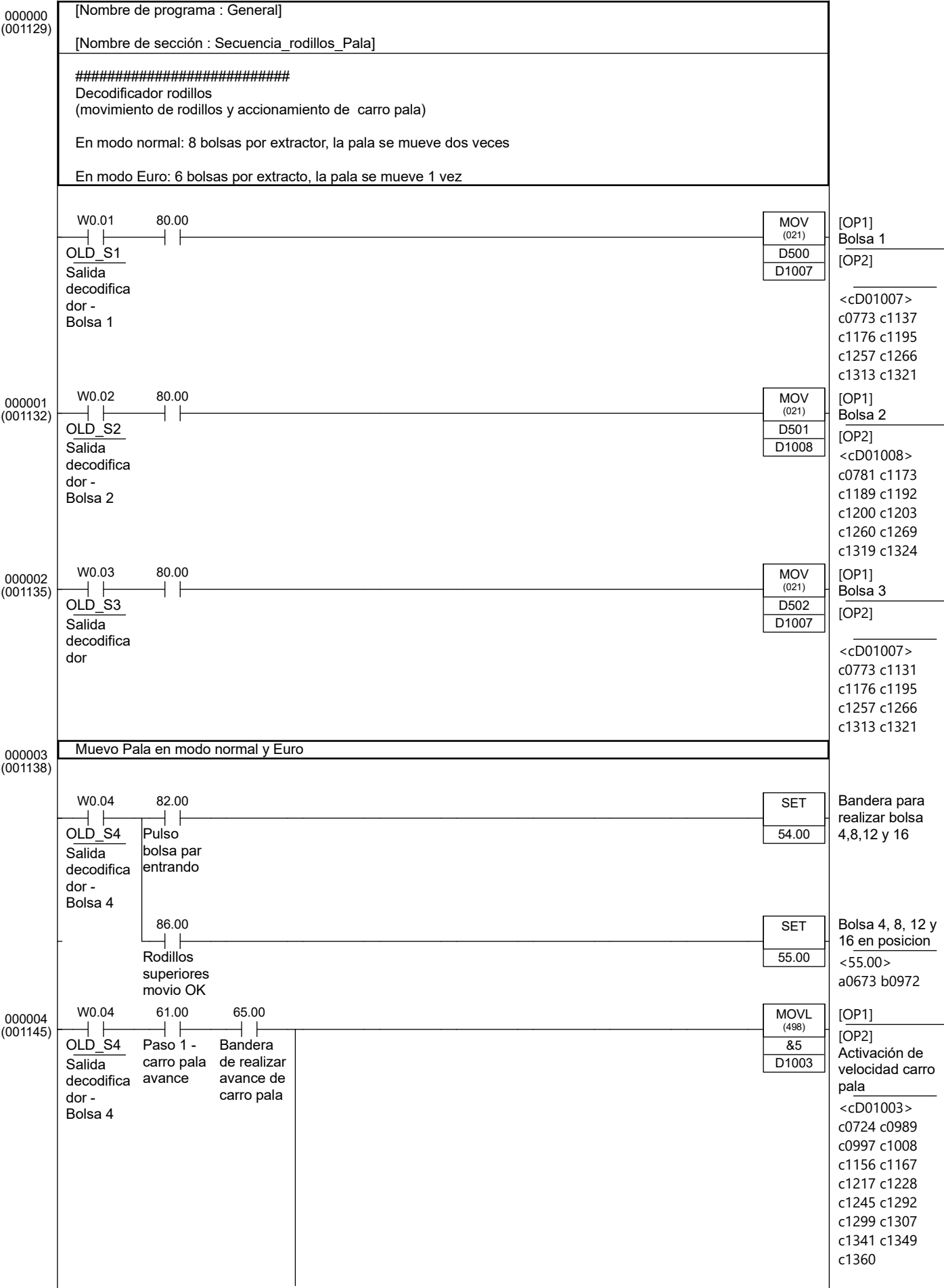












000005  
(001152)

138.00	62.00	65.00
Carro pala fin avance	Paso 2 - carro pala avanza un poco mas (presiona bolsa)	Bandera de realizar avance de carro pala

MOVL
(498)
&40
D1005

[OP1]  
[OP2]  
Cantidad pulsos  
de Avance de  
carro  
<cD01005>  
c0717 c0990  
c0998 c1009  
c1157 c1159  
c1168 c1218  
c1229 c1233  
c1236 c1246  
c1293 c1300  
c1308 c1342  
c1350 c1352  
c1361

RSET
65.00

Bandera de  
realizar avance  
de carro pala  
<65.00>  
b0682 b0689  
b0697 b0704  
a0707 a0723  
a0986 a0996  
a1006 a1147  
a1154 a1166  
a1216 a1226  
a1243 a1291  
a1298 a1306  
a1340 a1347  
a1359

SET
138.00

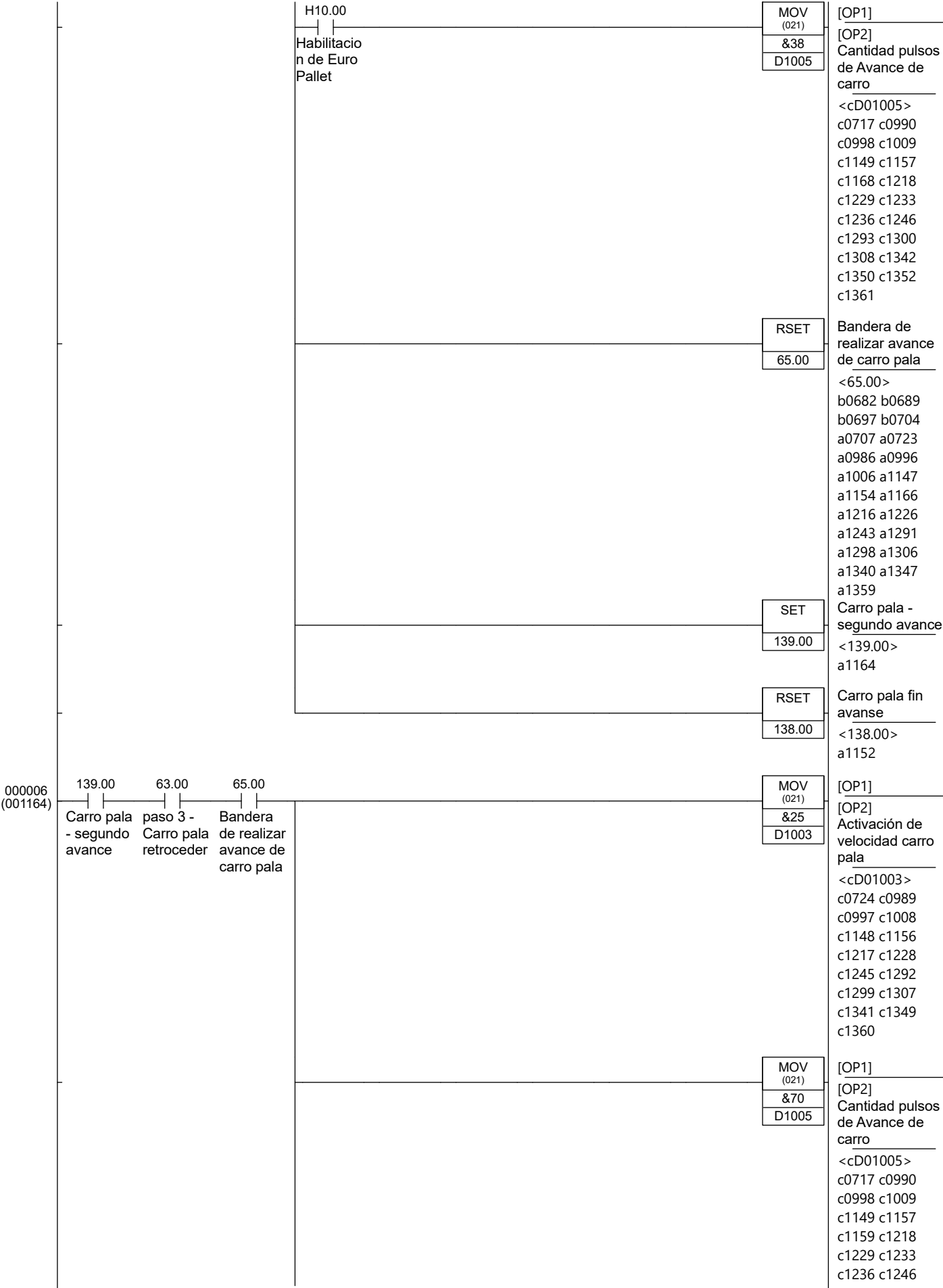
Carro pala fin  
avance  
<138.00>  
a1152

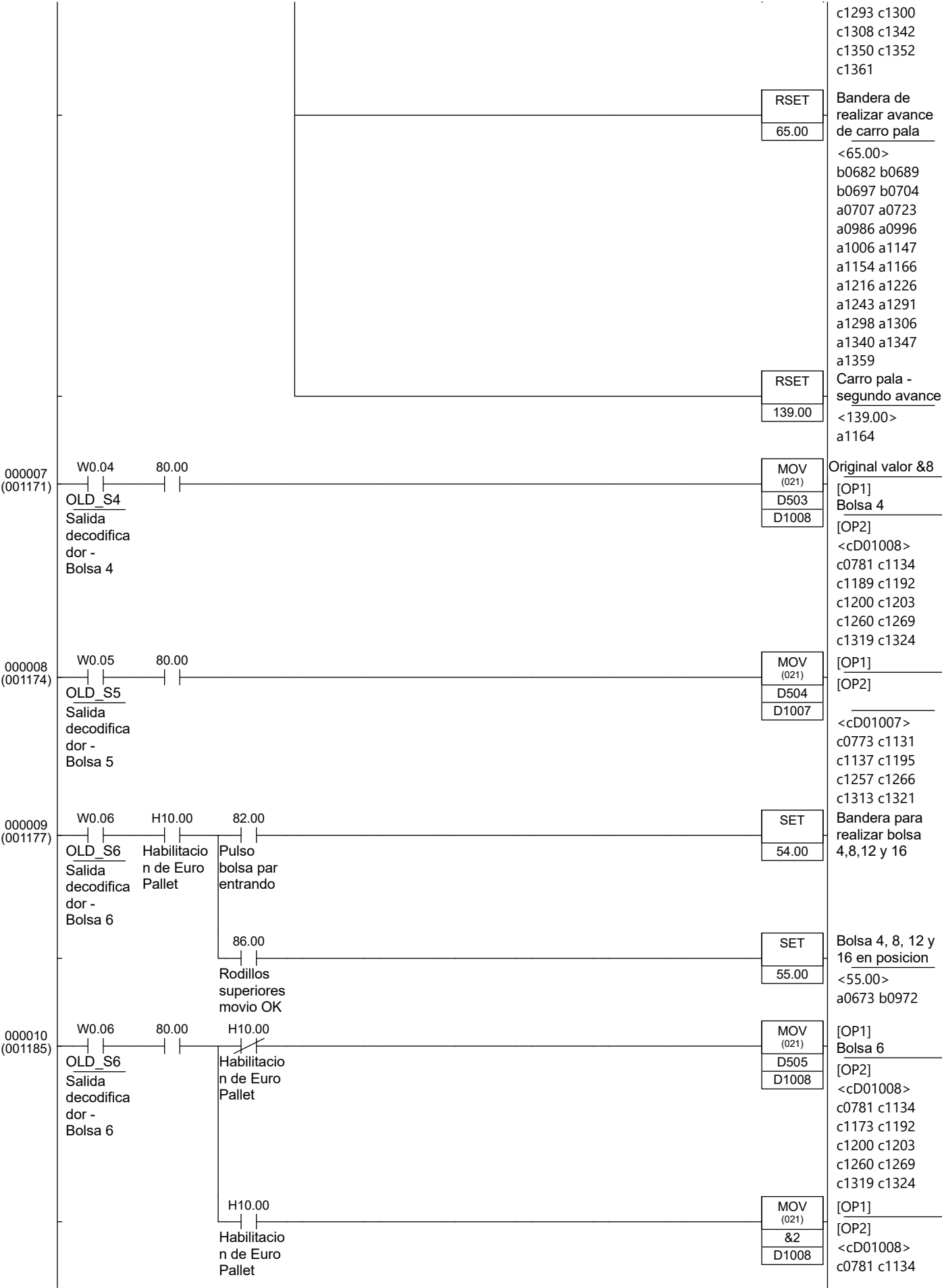
MOV
(021)
&35
D1003

[OP1]  
[OP2]  
Activación de  
velocidad carro  
pala  
<cD01003>  
c0724 c0989  
c0997 c1008  
c1148 c1167  
c1217 c1228  
c1245 c1292  
c1299 c1307  
c1341 c1349  
c1360

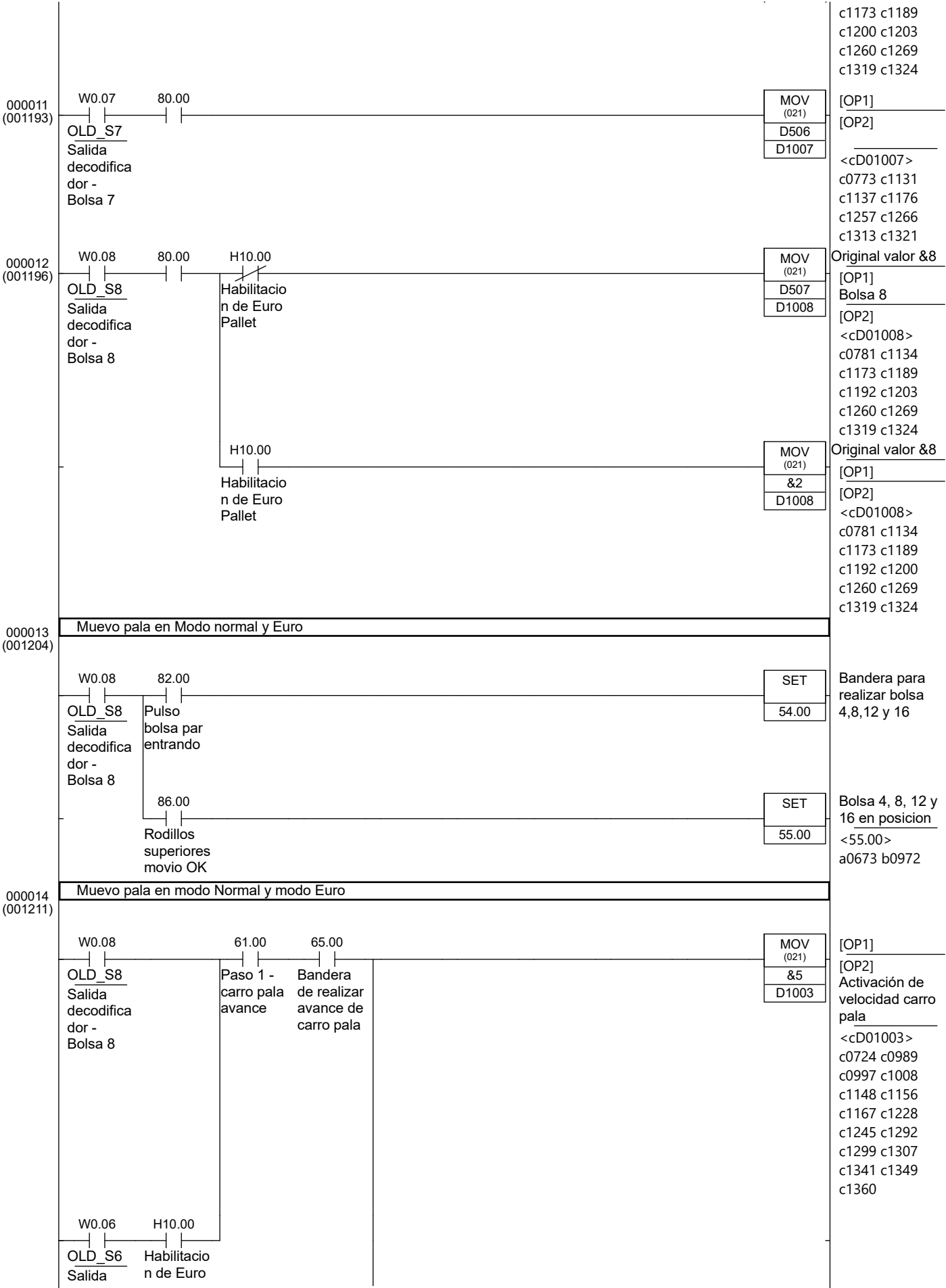
MOV
(021)
&48
D1005

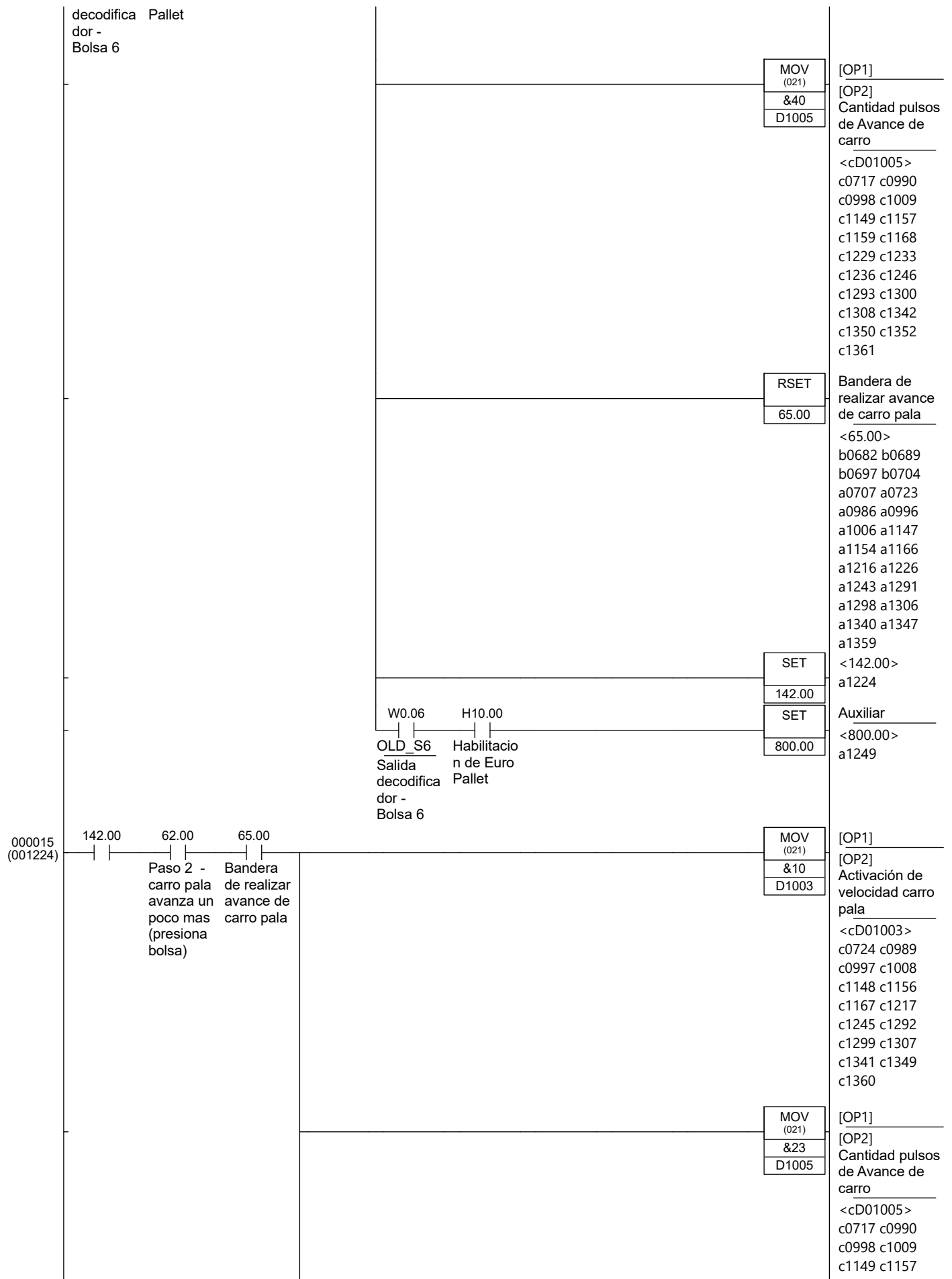
[OP1]  
[OP2]  
Cantidad pulsos  
de Avance de  
carro  
<cD01005>  
c0717 c0990  
c0998 c1009  
c1149 c1159  
c1168 c1218  
c1229 c1233  
c1236 c1246  
c1293 c1300  
c1308 c1342  
c1350 c1352  
c1361

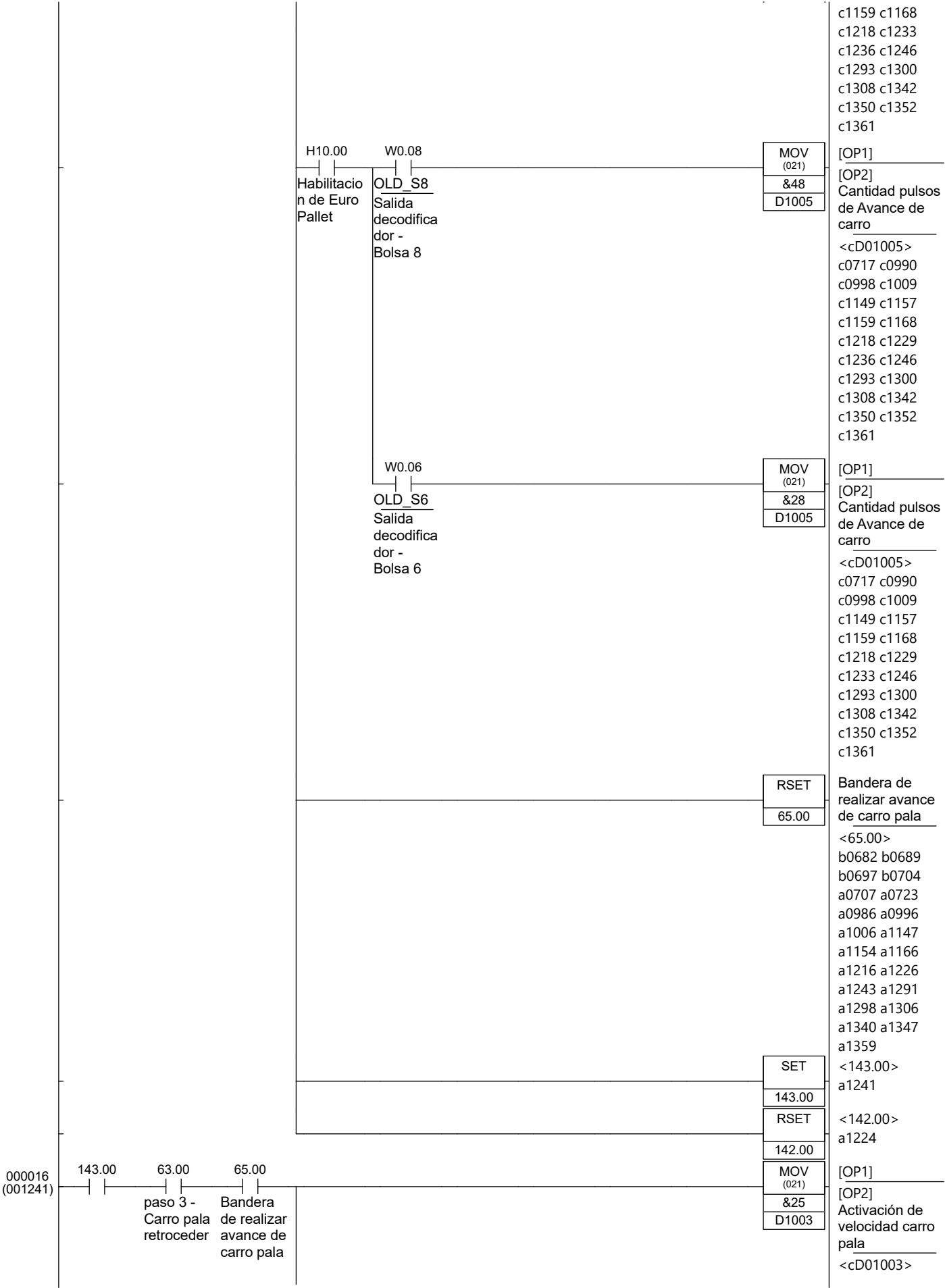


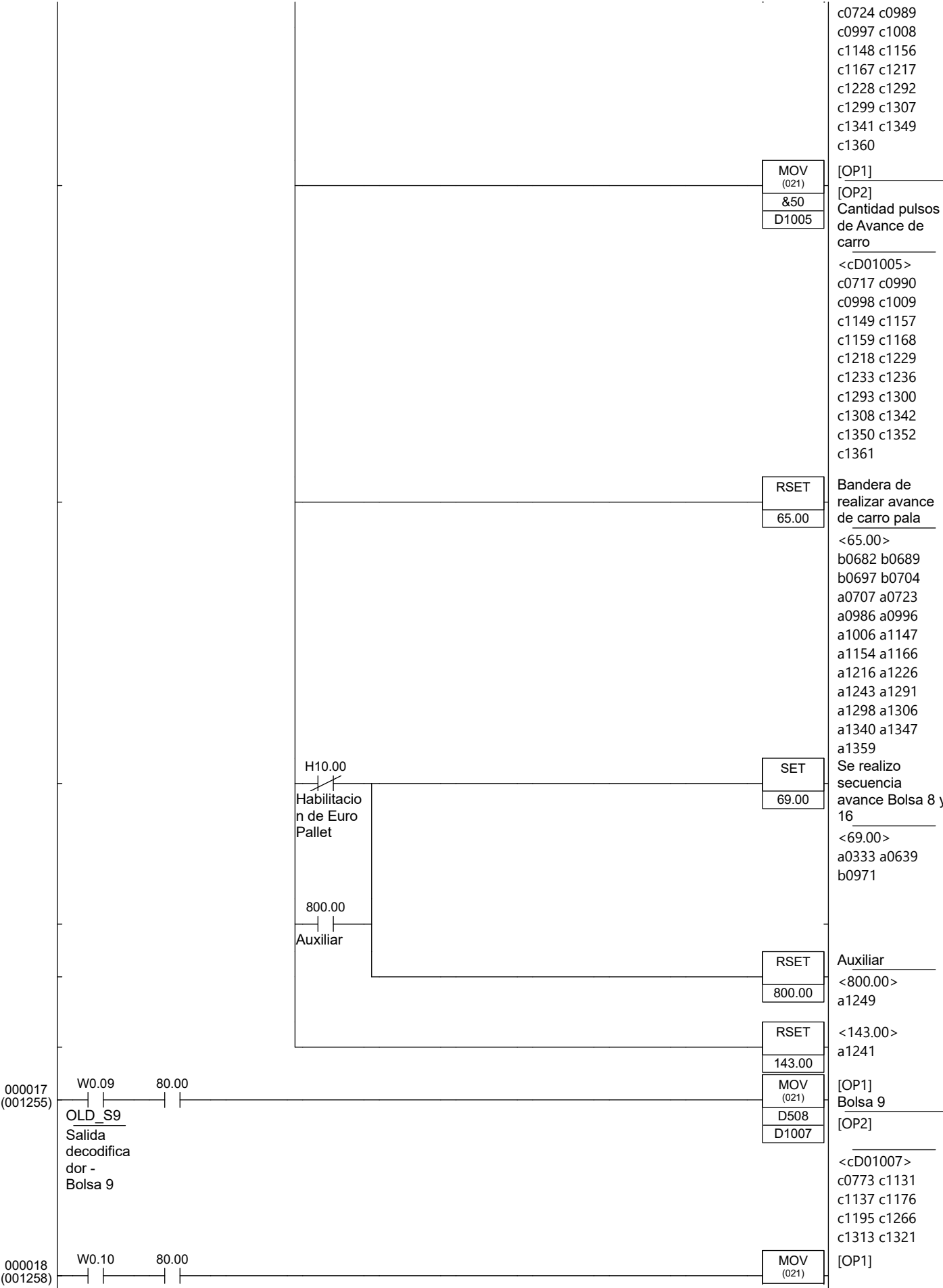


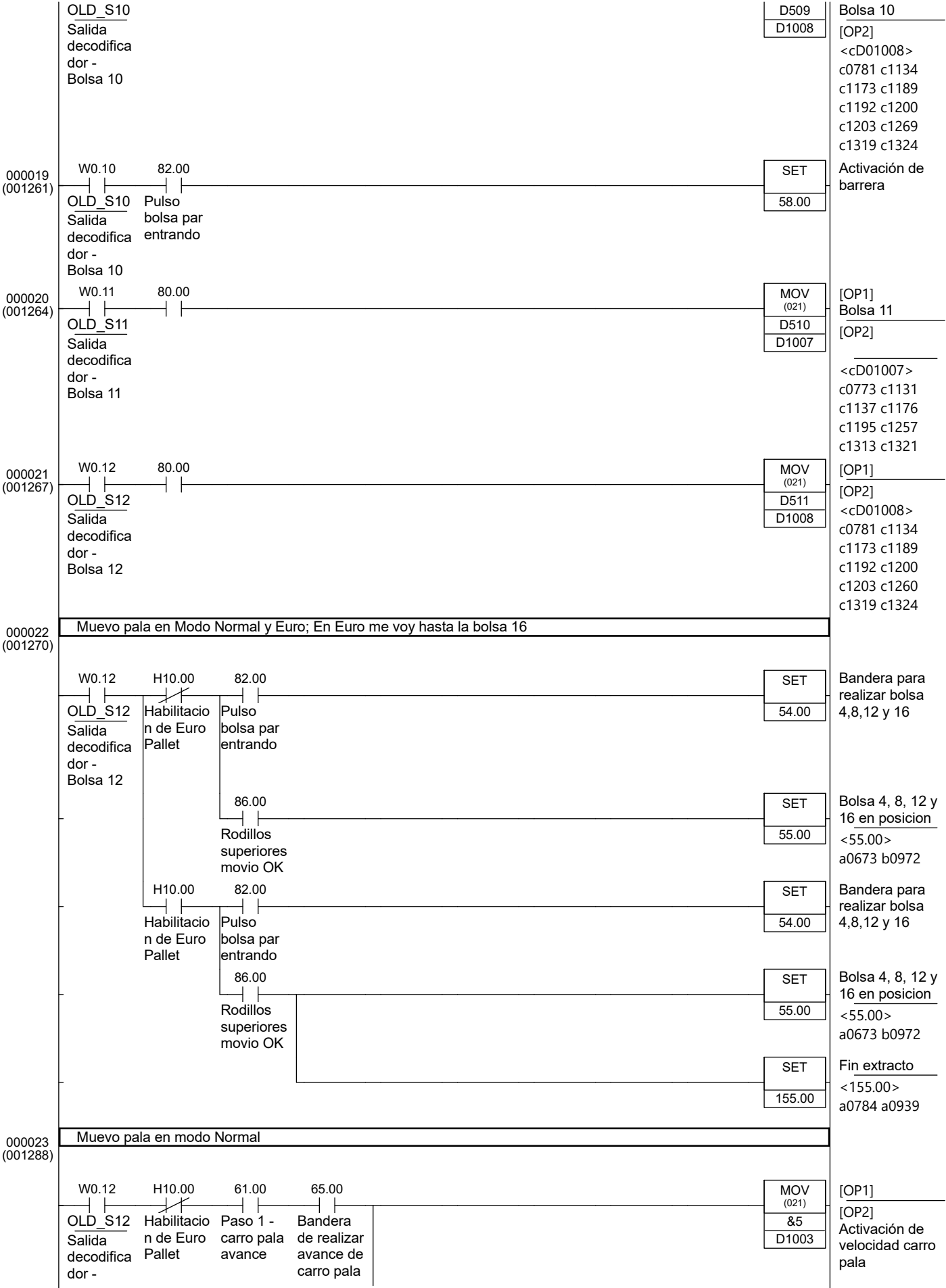


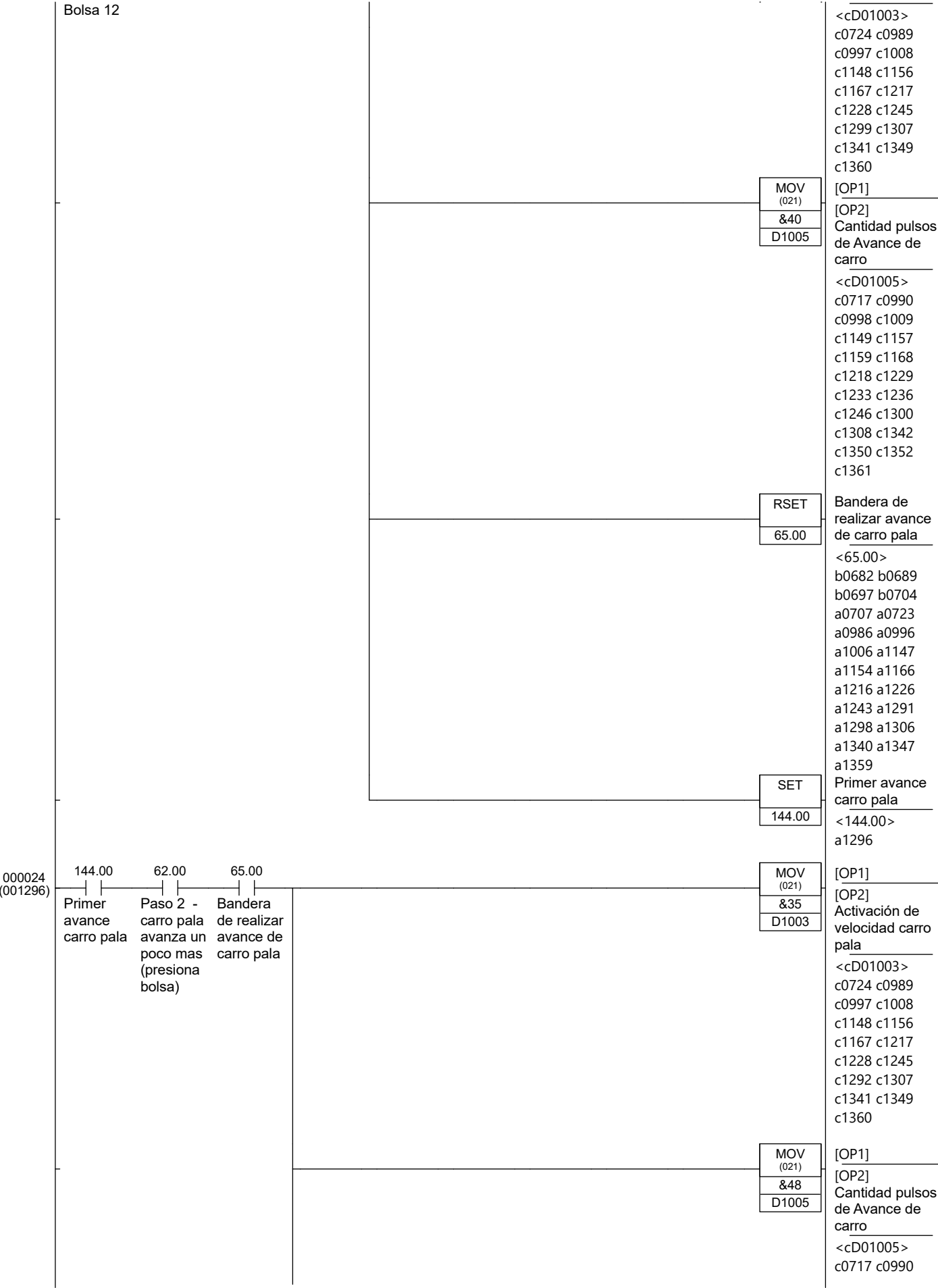


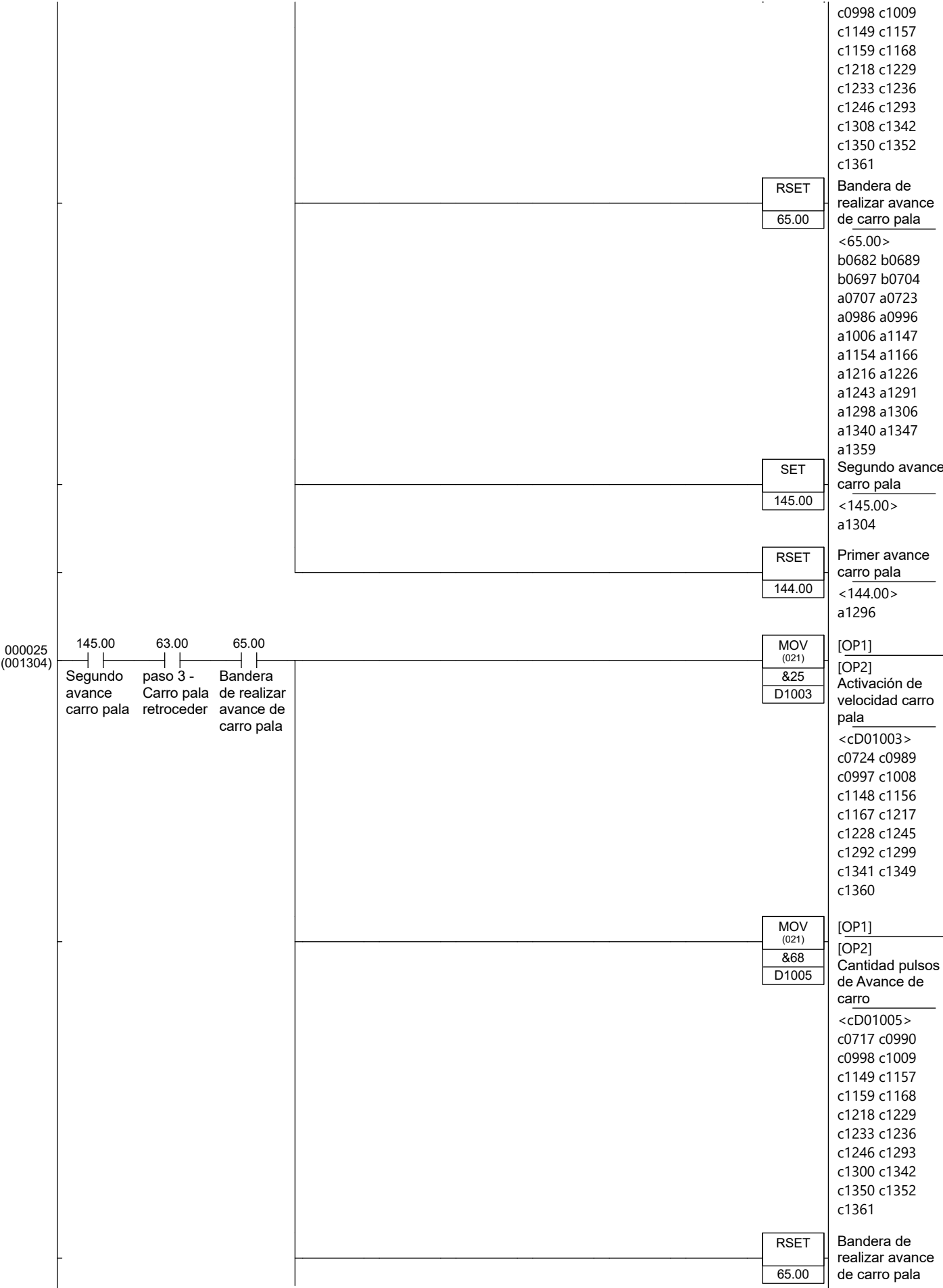


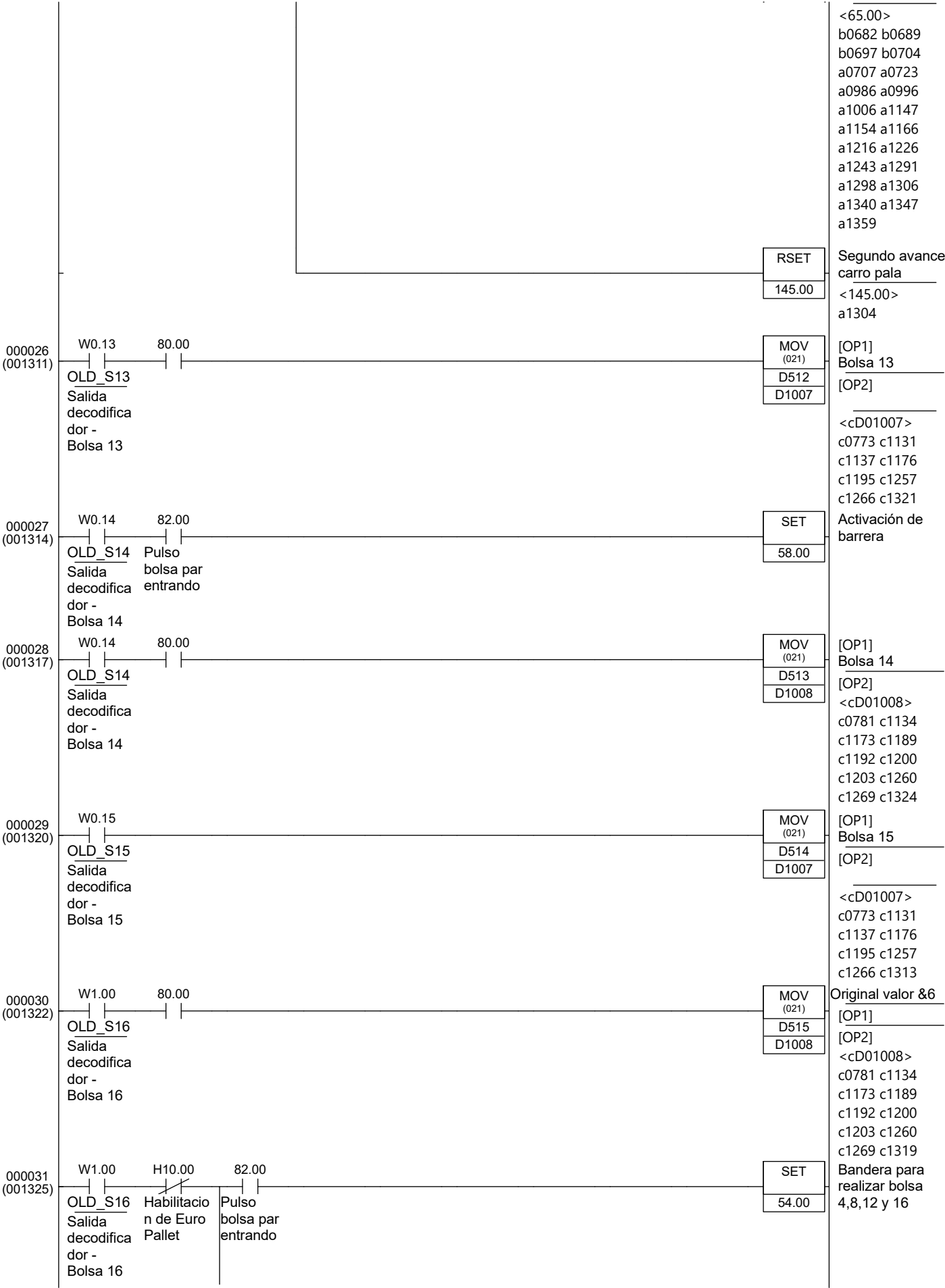




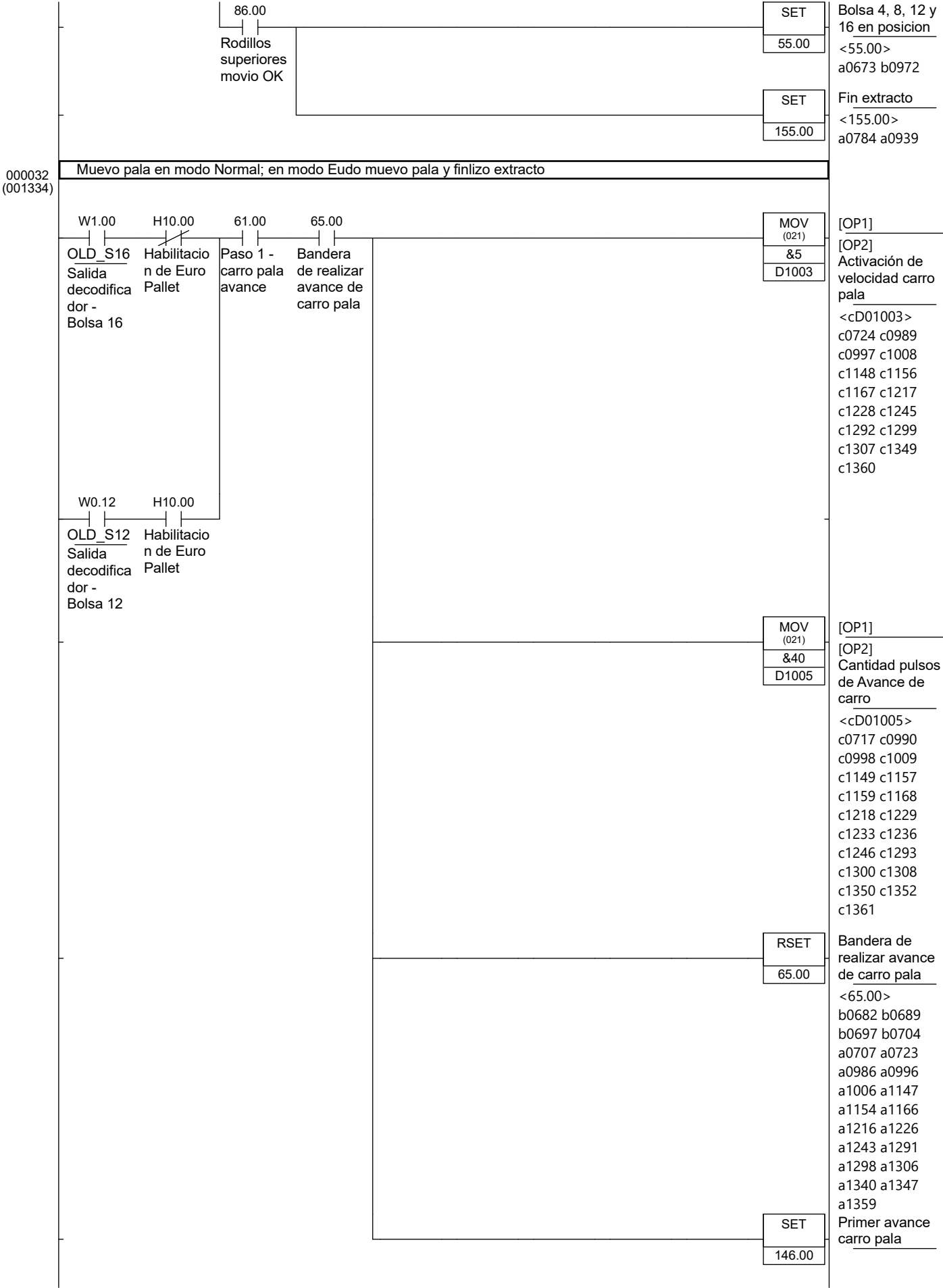












000033  
(001345)

146.00

62.00

65.00

Primer avance  
carro pala

Paso 2 -  
carro pala  
avanza un  
poco mas  
(presiona  
bolsa)

Bandera  
de realizar  
avance de  
carro pala

H10.00

Habilitacio  
n de Euro  
Pallet

MOV  
(021)

&10

D1003

MOV  
(021)

&23

D1005

MOV  
(021)

&25

D1005

RSET

65.00

SET

<146.00>  
a1345

[OP1]

[OP2]

Activación de  
velocidad carro  
pala

<cD01003>  
c0724 c0989  
c0997 c1008  
c1148 c1156  
c1167 c1217  
c1228 c1245  
c1292 c1299  
c1307 c1341  
c1360

[OP1]

[OP2]

Cantidad pulsos  
de Avance de  
carro

<cD01005>  
c0717 c0990  
c0998 c1009  
c1149 c1157  
c1159 c1168  
c1218 c1229  
c1233 c1236  
c1246 c1293  
c1300 c1308  
c1342 c1352  
c1361

[OP1]

[OP2]

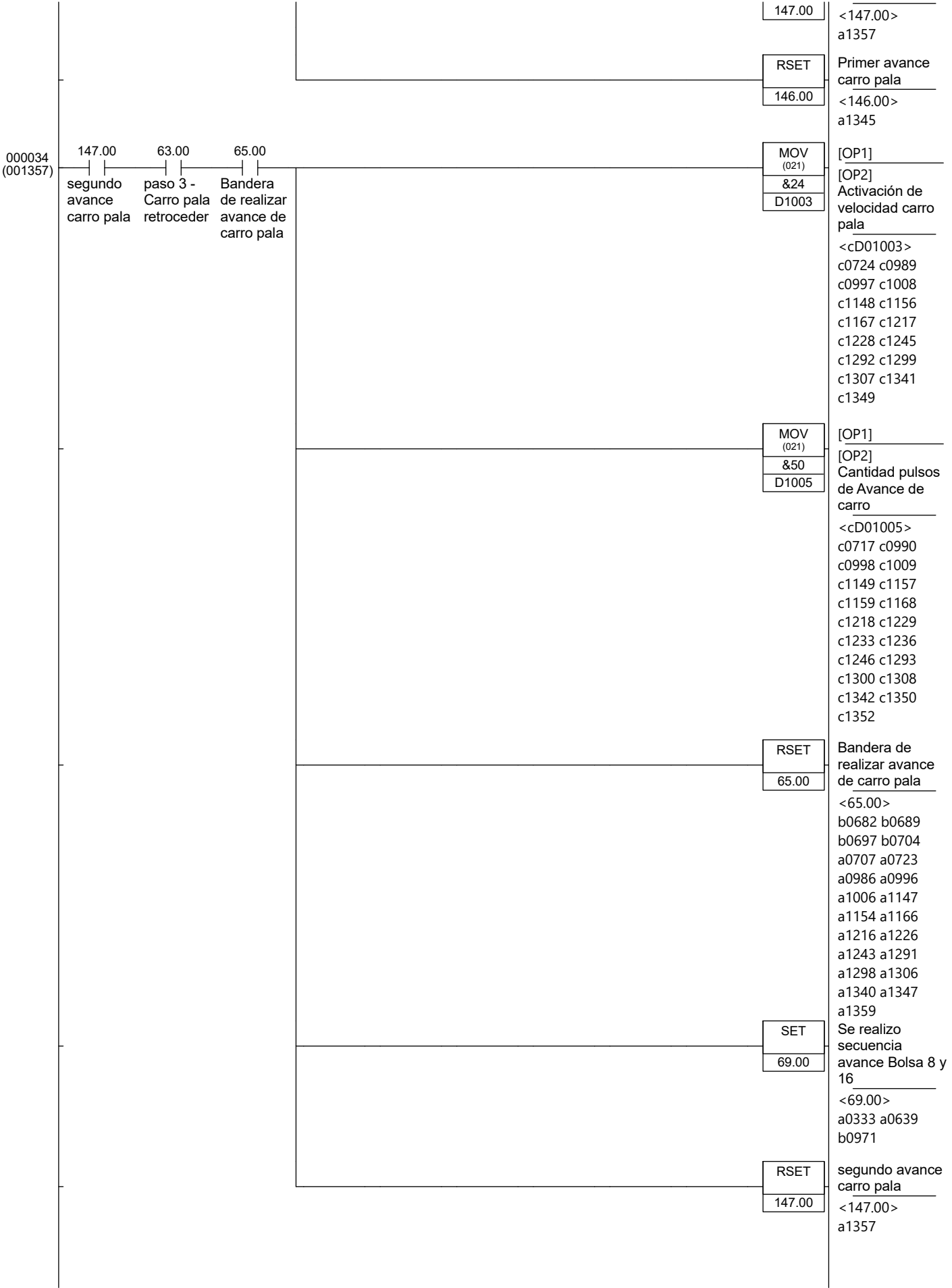
Cantidad pulsos  
de Avance de  
carro

<cD01005>  
c0717 c0990  
c0998 c1009  
c1149 c1157  
c1159 c1168  
c1218 c1229  
c1233 c1236  
c1246 c1293  
c1300 c1308  
c1342 c1350  
c1361

Bandera de  
realizar avance  
de carro pala

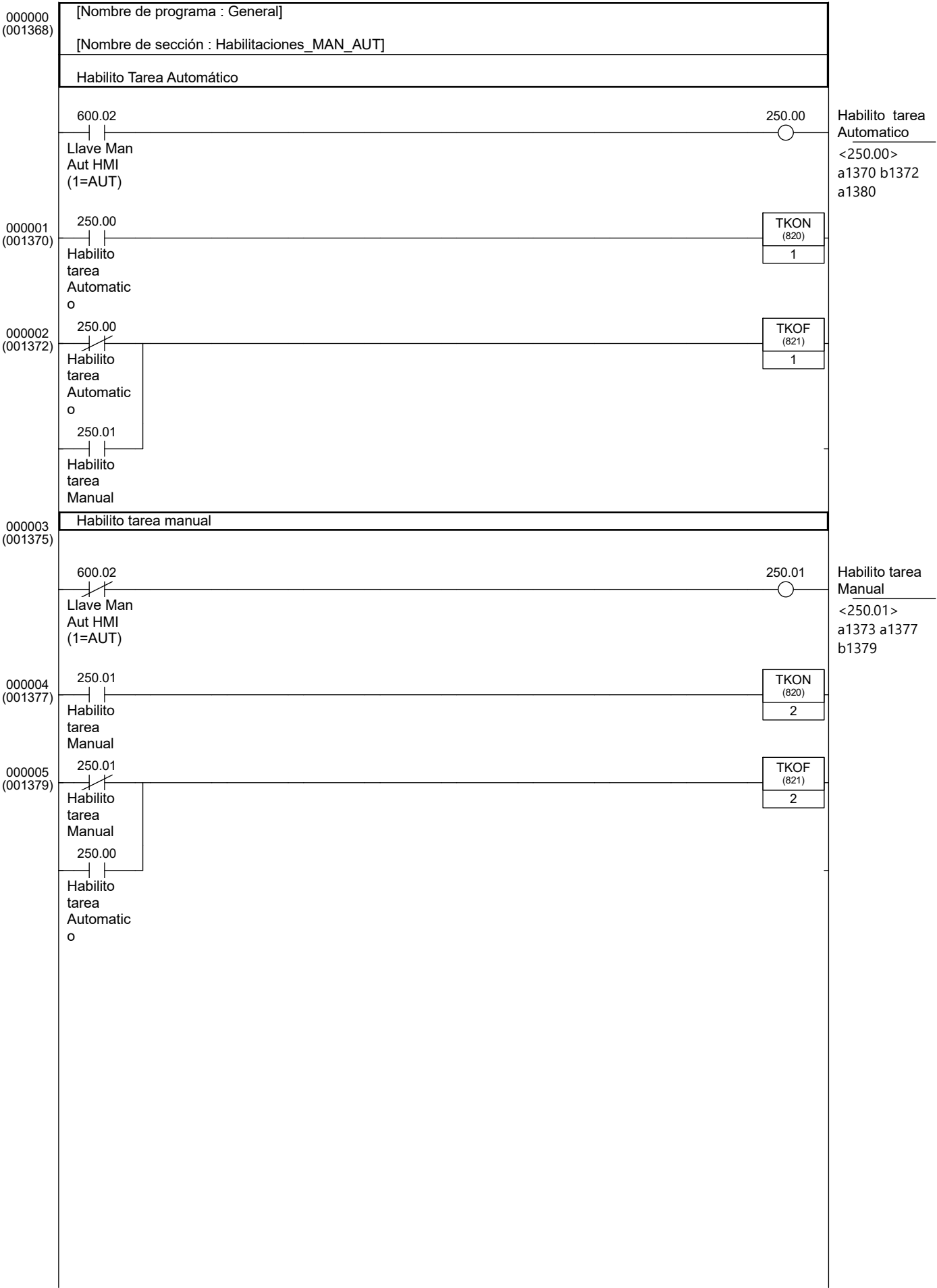
<65.00>  
b0682 b0689  
b0697 b0704  
a0707 a0723  
a0986 a0996  
a1006 a1147  
a1154 a1166  
a1216 a1226  
a1243 a1291  
a1298 a1306  
a1340 a1347  
a1359

segundo avance  
carro pala



000000  
(001366)

[Nombre de programa : General]	
[Nombre de sección : _Fin_Salto]	
Fin de salto	
<div>JME (005)</div>	
<div>#0</div>	

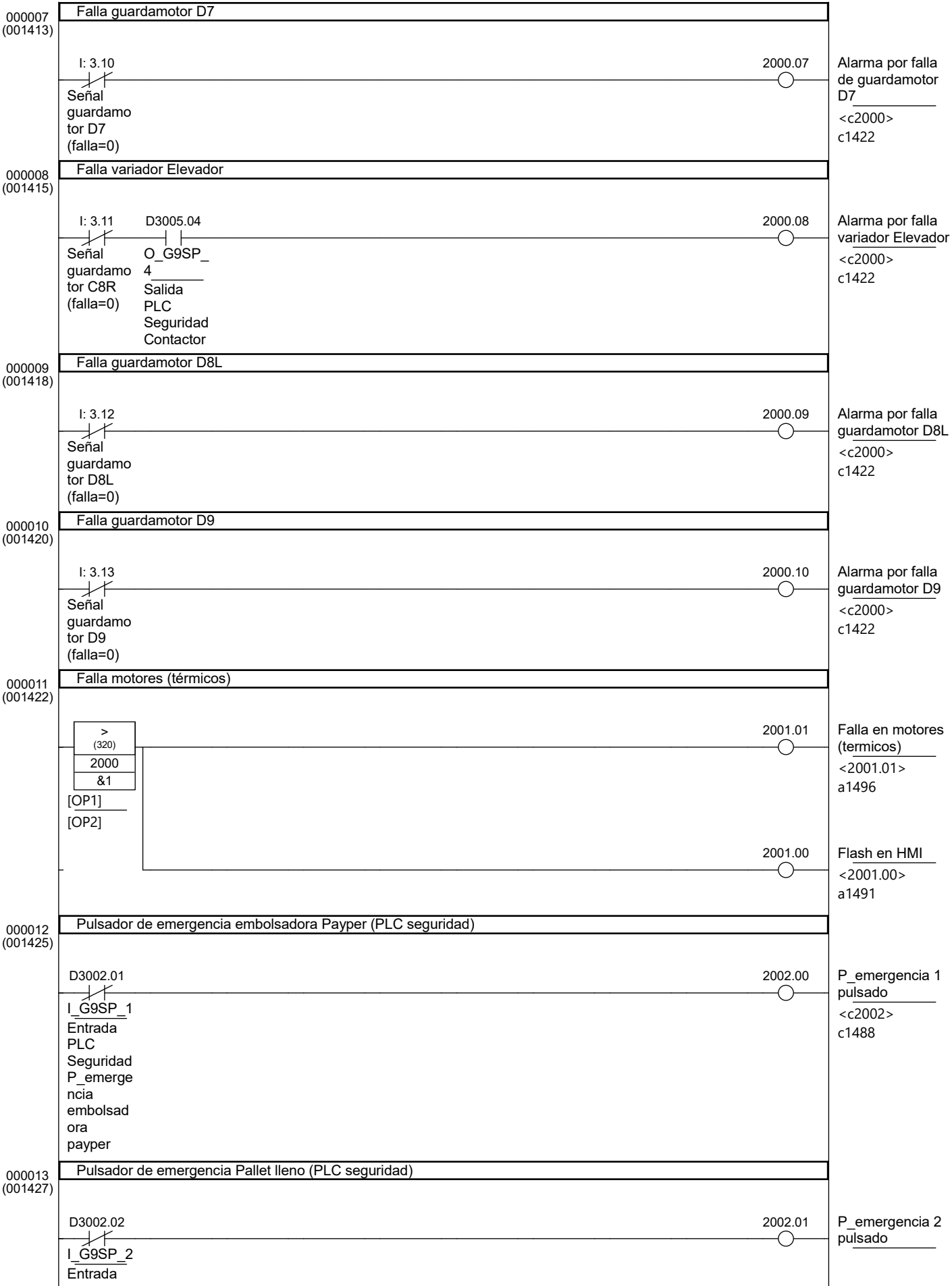


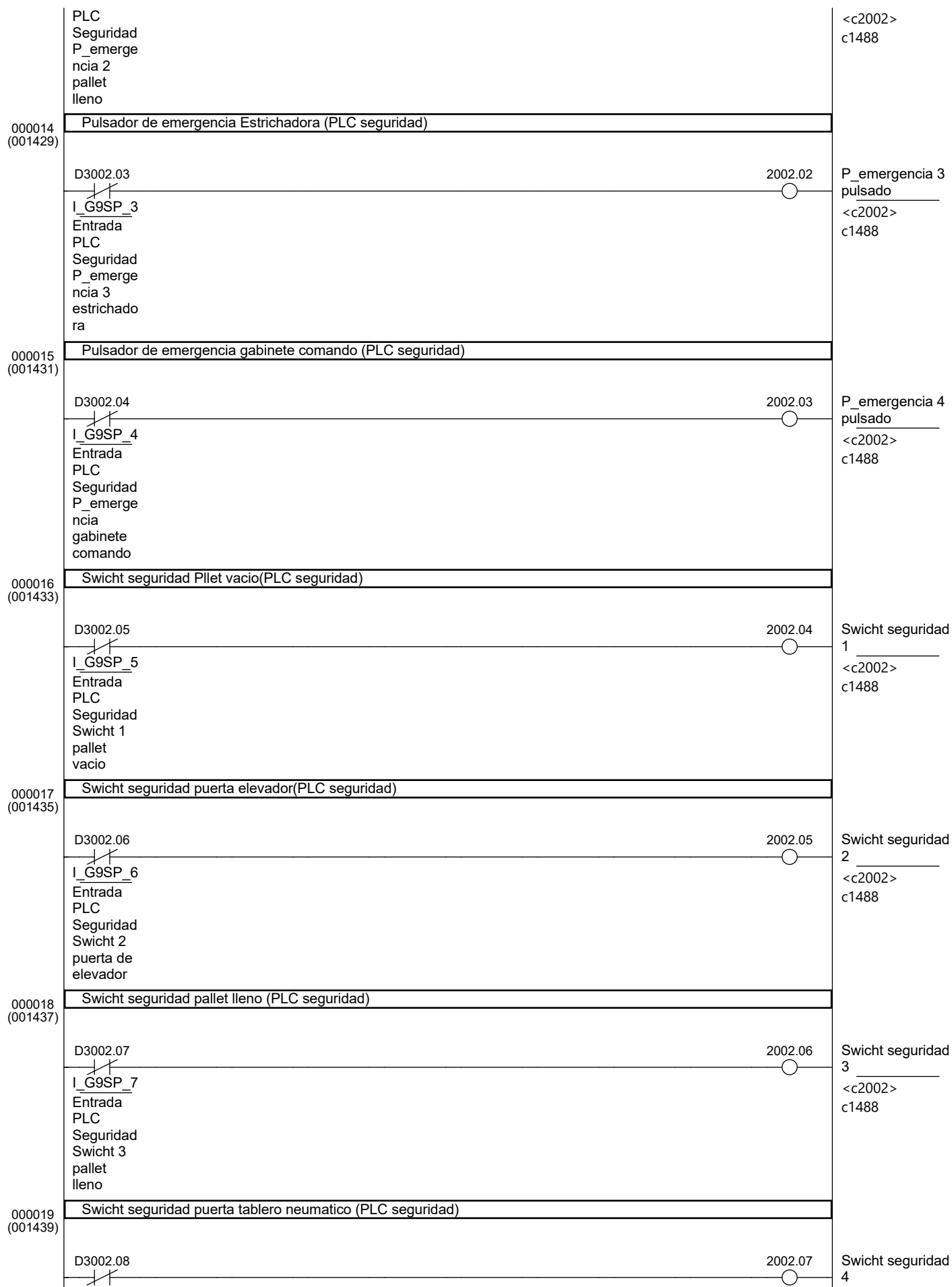
000000 (001383)	[Nombre de programa : General]		
	[Nombre de sección : Seleccion_pallet]		
	Aumento los pulsos que se mueve el rodillo en Europallet		
	H10.00	MOV (021)	[OP1]
	Habilitacion de Euro Pallet	&16	[OP2]
		D6000	Pulsos/tiempo para parar rodillos
	<cD06000>		
	c0175 c0278		
	c1386		
000001 (001385)	H10.00	MOV (021)	[OP1]
	Habilitacion de Euro Pallet	&16	[OP2]
		D6000	Pulsos/tiempo para parar rodillos
	<cD06000>		
	c0175 c0278		
	c1384		

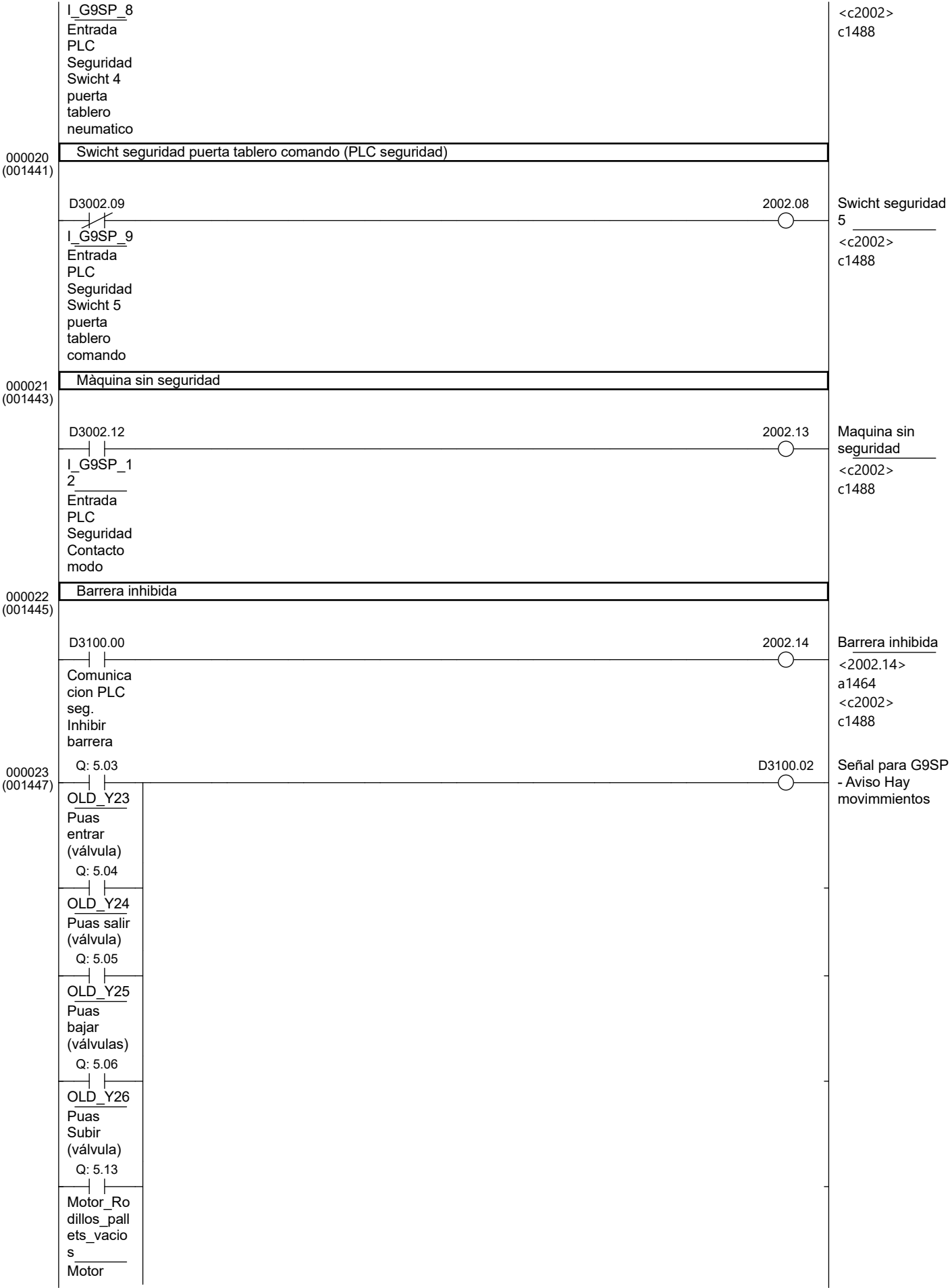


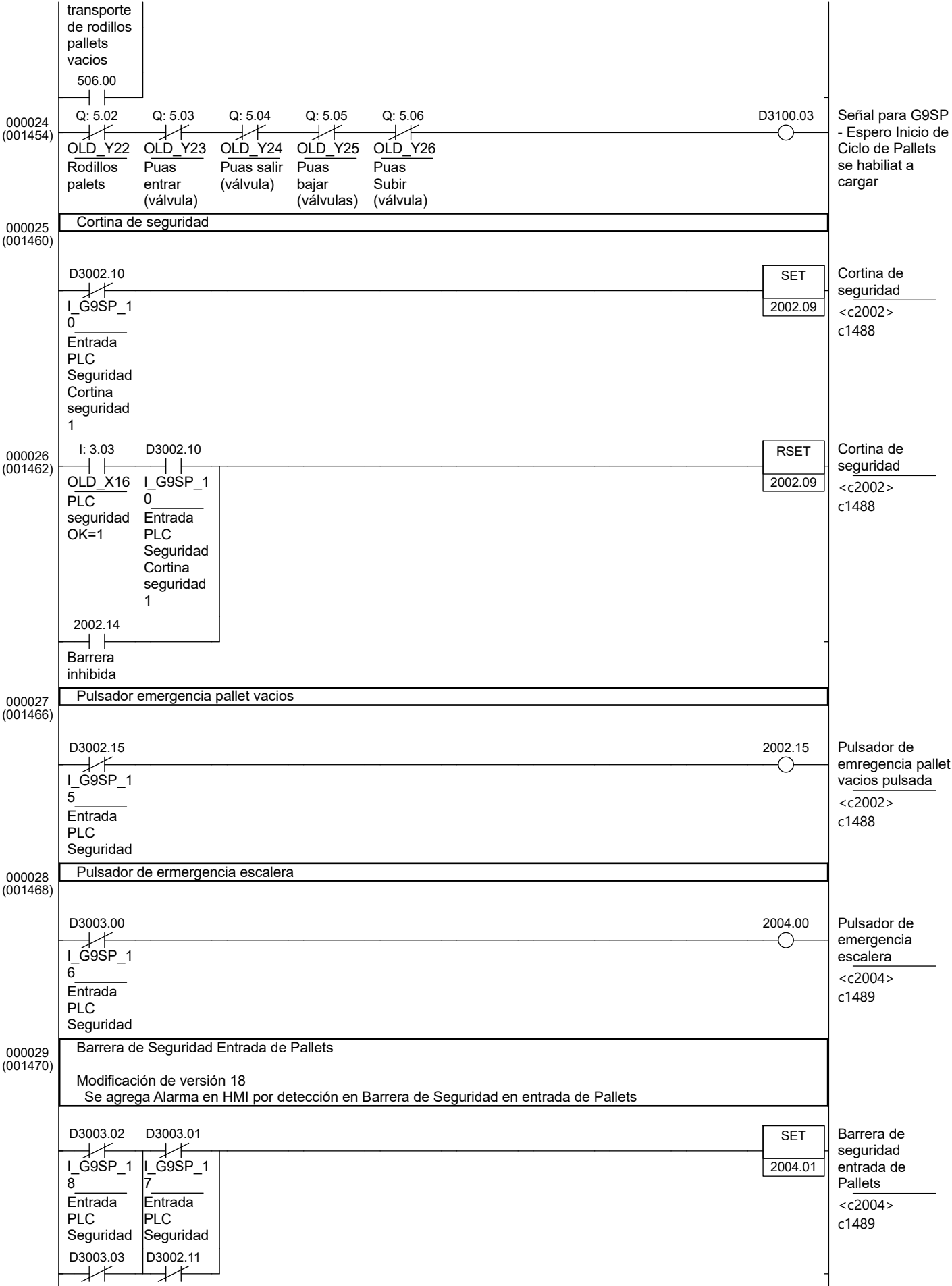
000000 (001396)	[Nombre de programa : General]		
	[Nombre de sección : Alarmas]		
	Run variador V1 (carro pala)		
000001 (001399)	I: 0.12	D3005.04	2000.00
	Run Variador V1 (falla=0)	O_G9SP_4 Salida PLC Seguridad Contactor	Alarma por falta de run V1 <c2000> c1422
	Run variador V2 (cinta programada)		
000002 (001402)	I: 0.13	D3005.04	2000.01
	Run variador V2 (falla=0)	O_G9SP_4 Salida PLC Seguridad Contactor	alarma por falta de run V2 <c2000> c1422
	Run carro V3 (cinta aplanado Inferior)		
000003 (001405)	I: 0.14	D3005.04	2000.02
	run variador V3 (falla=0)	O_G9SP_4 Salida PLC Seguridad Contactor	Alarma por falta de run V3 <c2000> c1422
	Falla de monitor de alimentación		
000004 (001407)	I: 0.15		2000.03
	Señal monitor de tensión (falla=0)		Alarma por falla en alimentación <c2000> c1422
	Falla Guardamotor D1		
000005 (001409)	I: 3.07		2000.04
	Señal guardamotor D1 (falla=0)		Alarma por falla de guardamotor D1 <c2000> c1422
	Falla guardamotor D2		
000006 (001411)	I: 3.08		2000.05
	Señal guardamotor D2 (falla=0)		Alarma por falla de guardamotor D2 <c2000> c1422
	Falla guardamotor D5		
	I: 3.09		2000.06
	Señal guardamotor D5 (falla=0)		Alarma por falla de gaurdamotor D5 <c2000> c1422

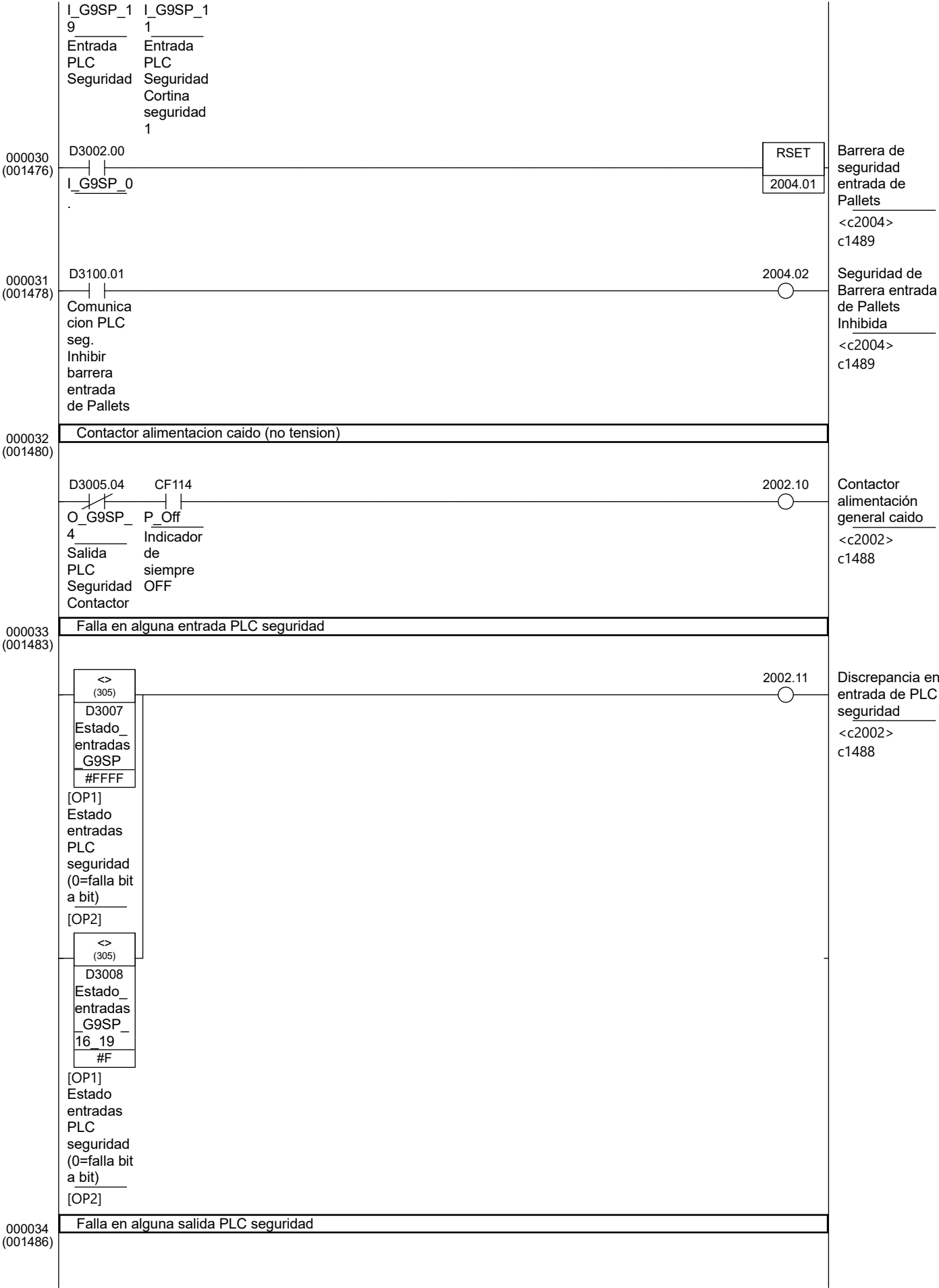


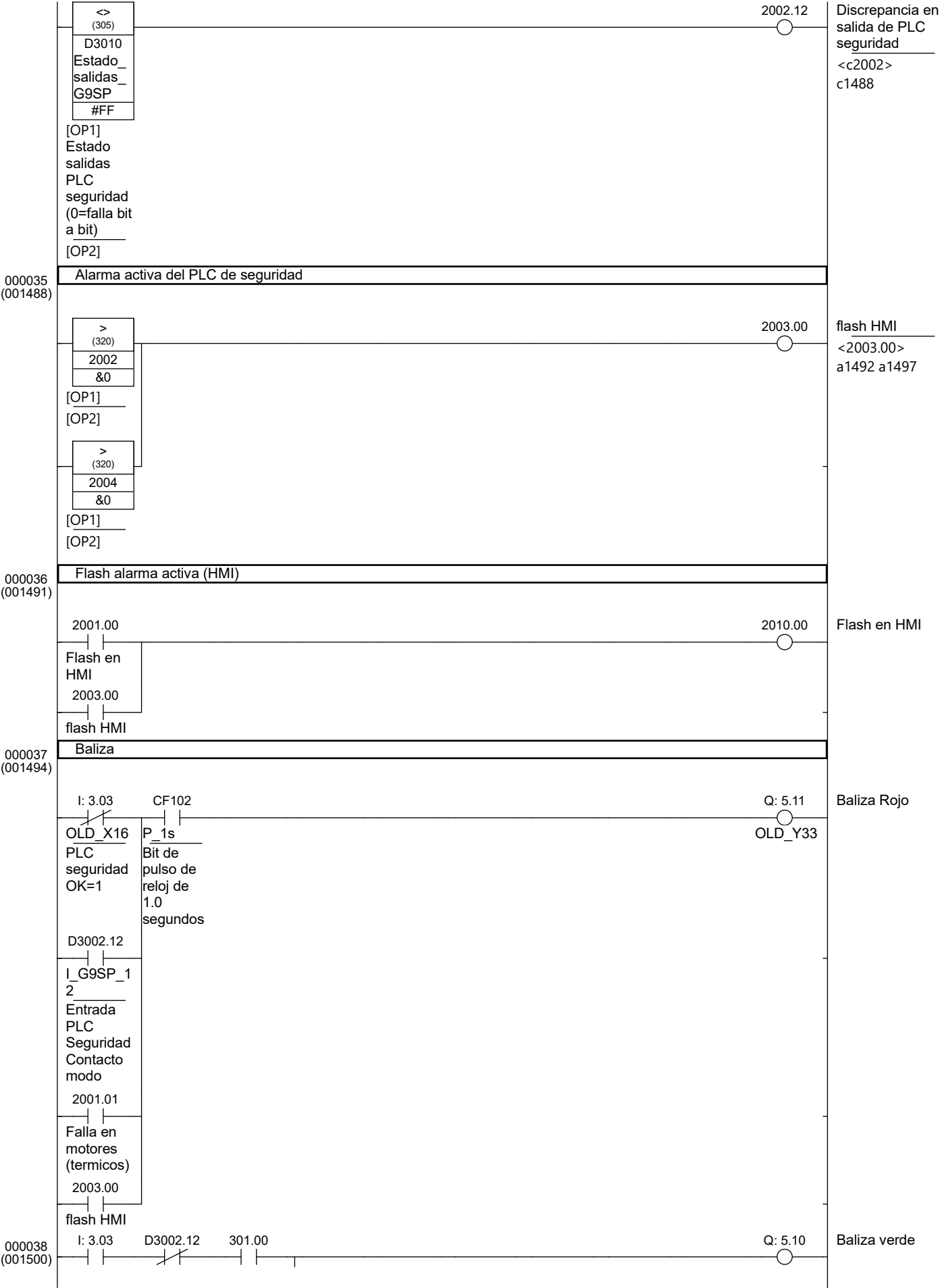


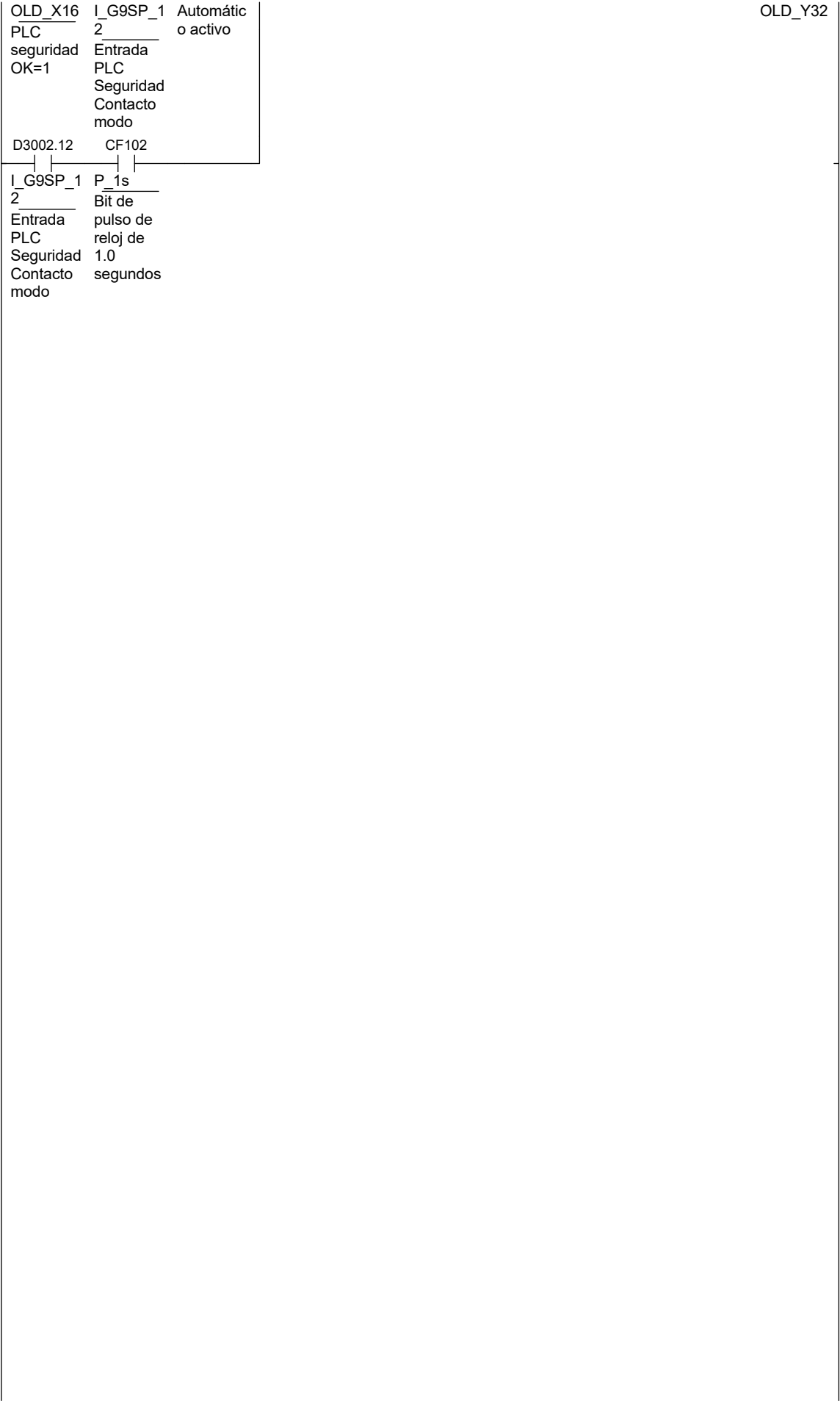


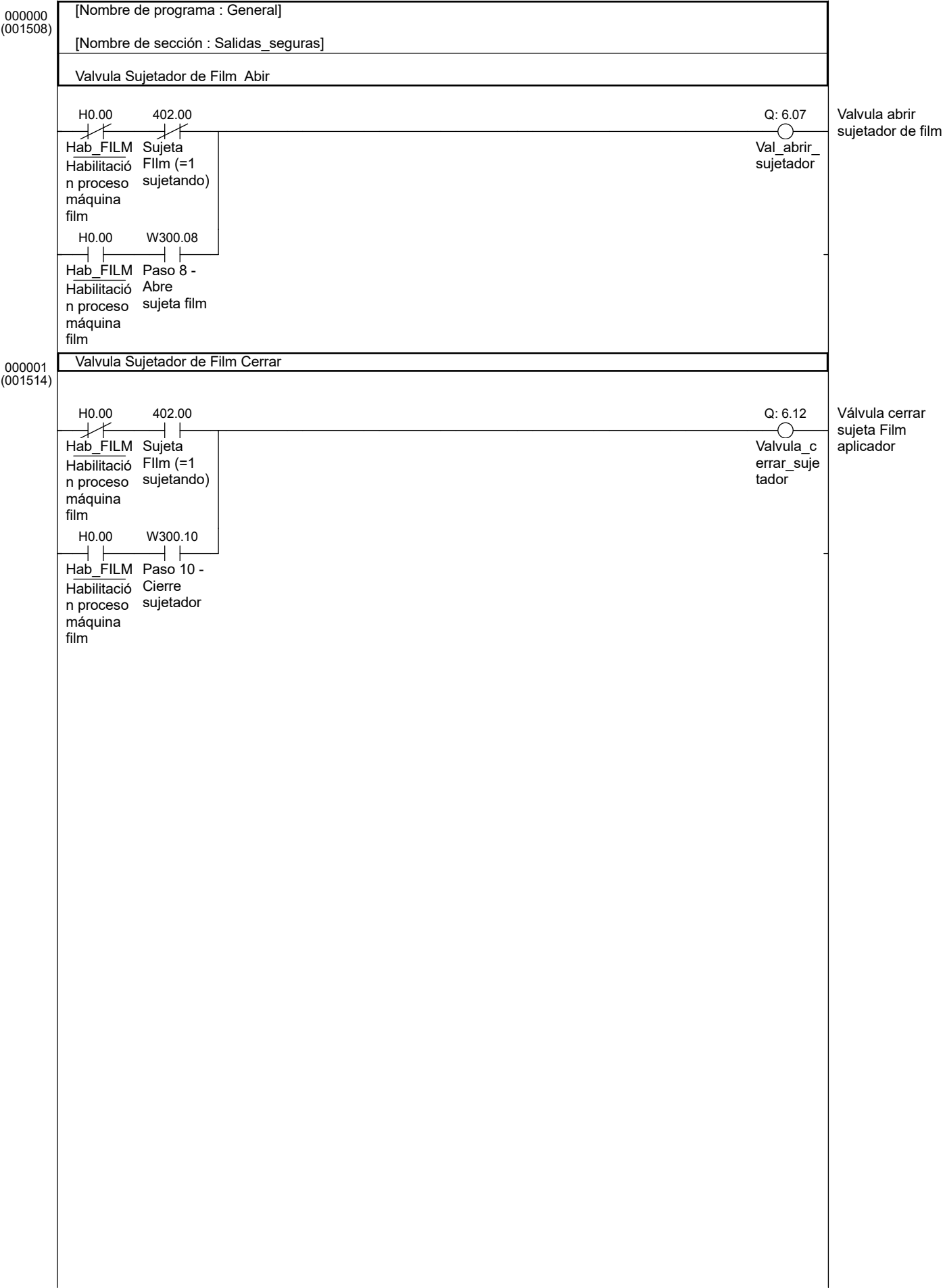














[Nombre de programa : General]	
[Nombre de sección : END]	
000000 (001521)	END (001)