FC72 - <offline>

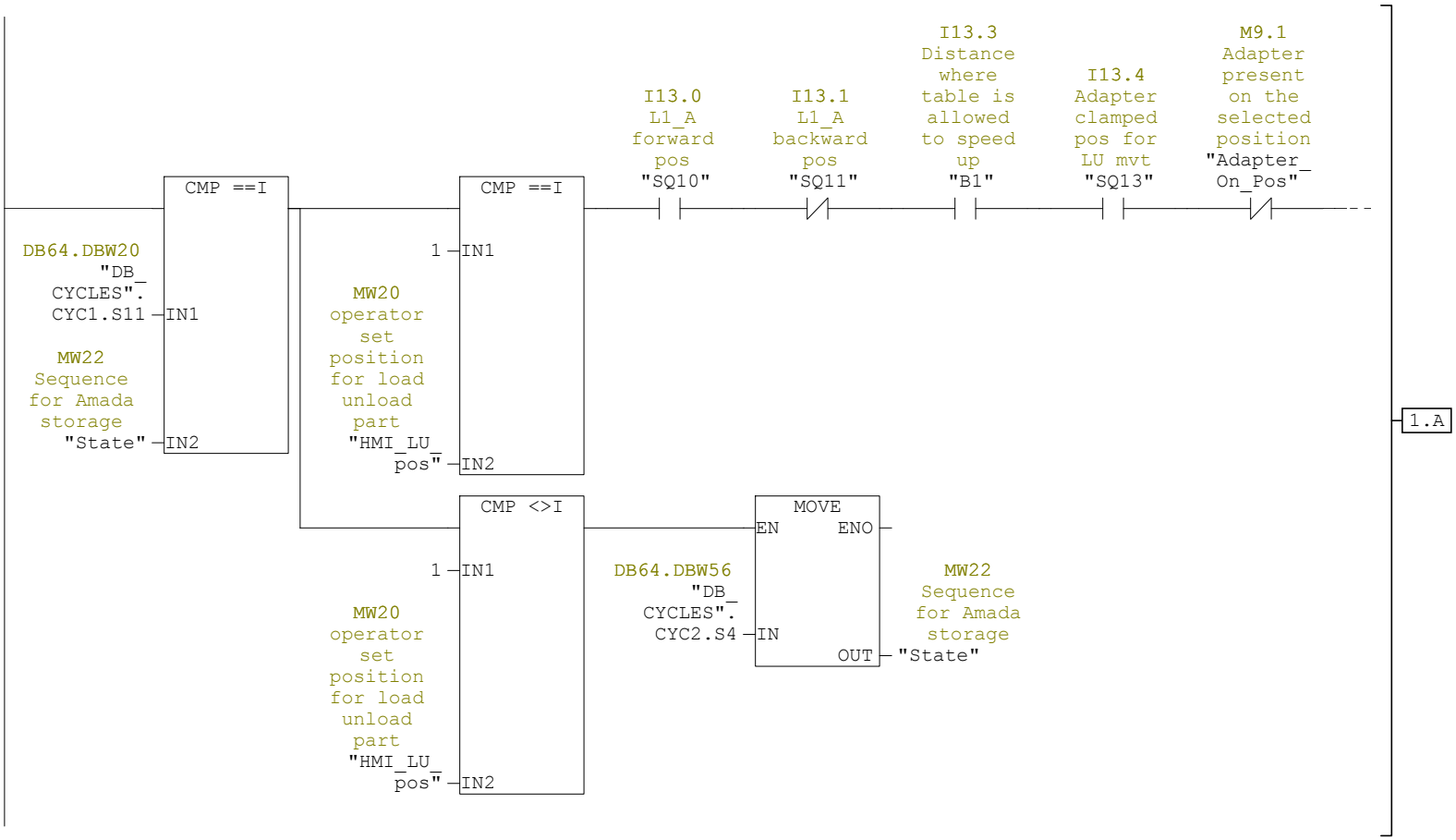
"FC_MAN_LOAD"

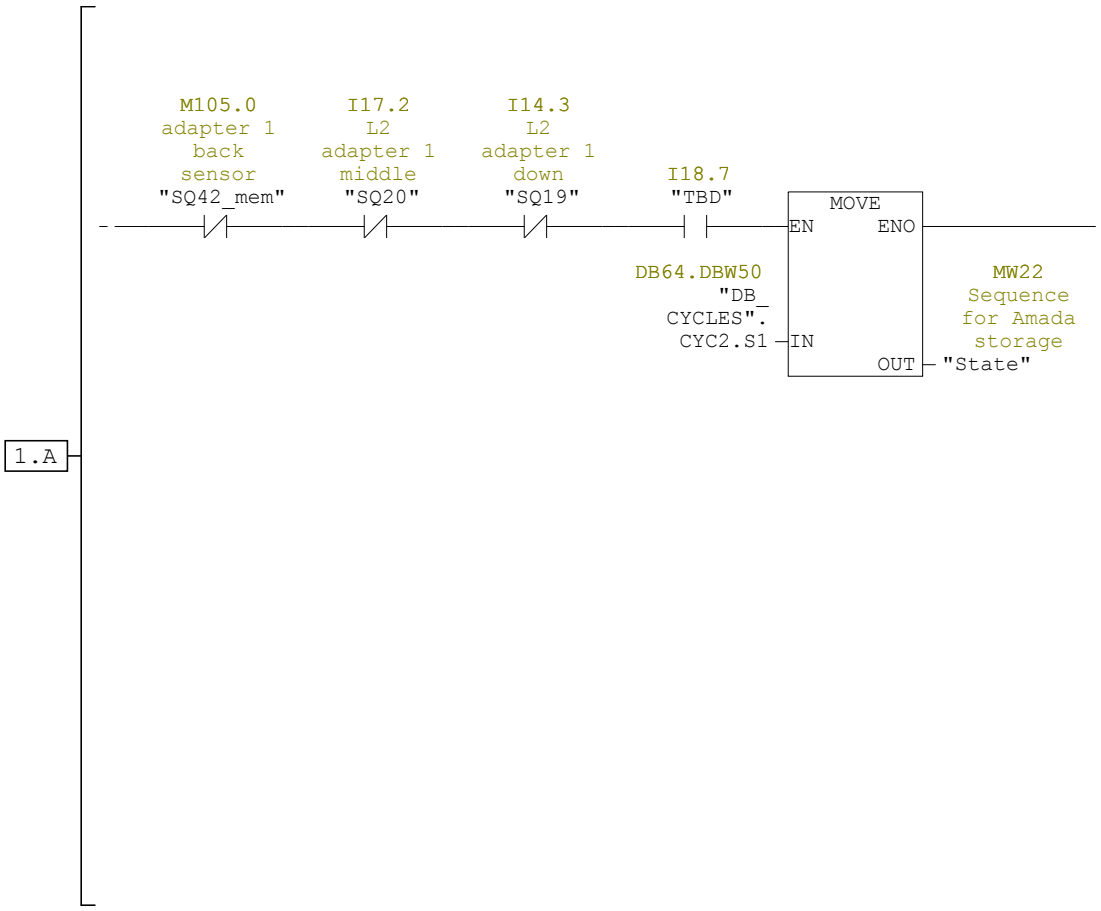
Name: **Family:**
Author: **Version:** 0.1
Block version: 2
Time stamp Code: 11/21/2022 04:35:12 PM
Interface: 11/07/2022 08:54:22 AM
Lengths (block/logic/data): 00744 00606 00002

Name	Data Type	Address	Comment
IN		0.0	
OUT		0.0	
IN_OUT		0.0	
TEMP		0.0	
RETURN		0.0	
RET_VAL		0.0	

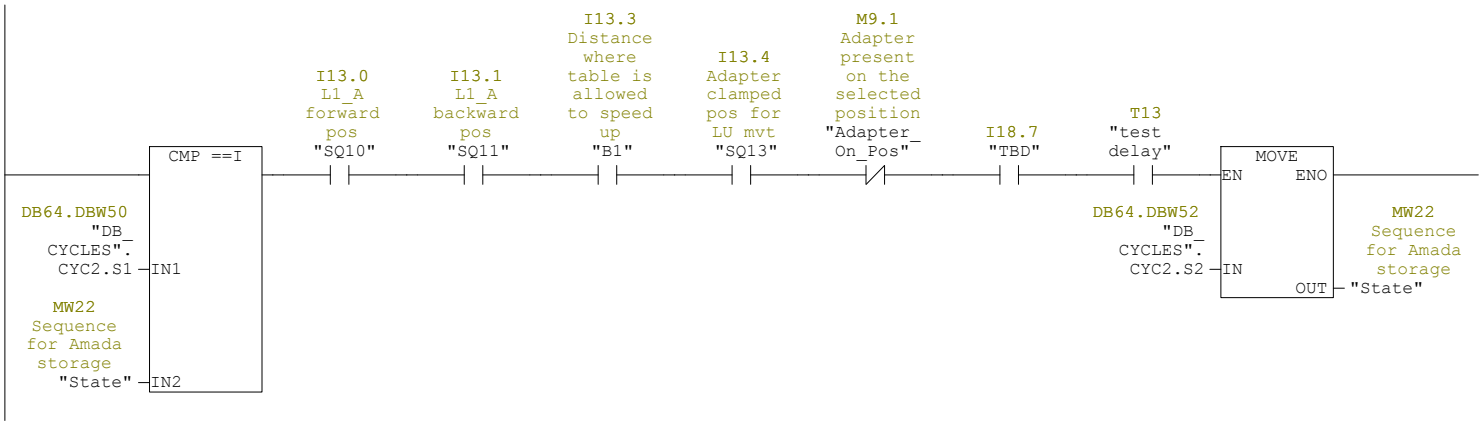
Block: FC72

Network: 1

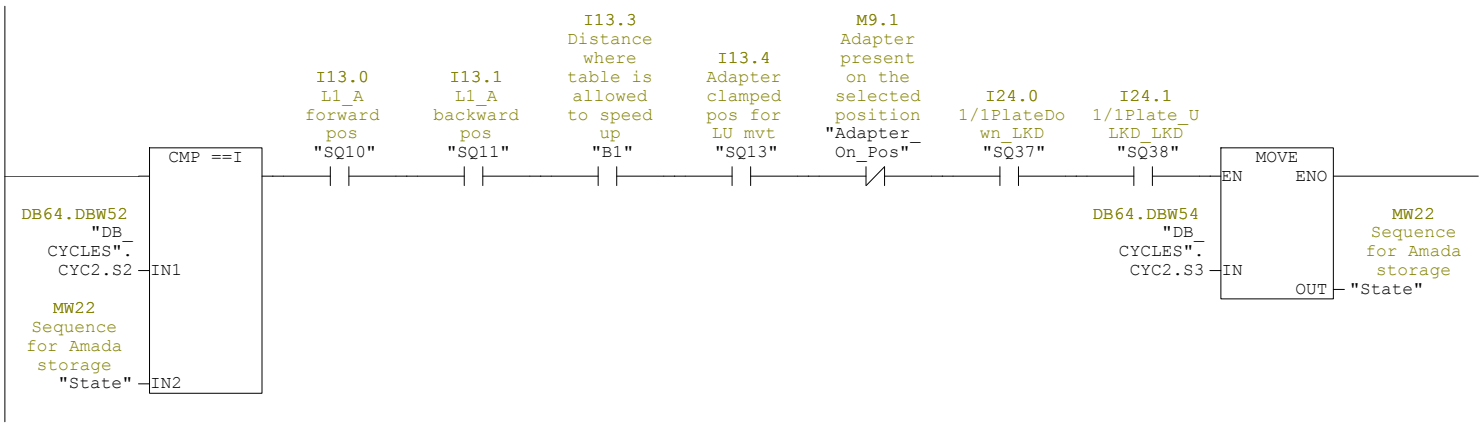

I13.0
L1_A
forward
pos
"SQ10"
I13.1
L1_A
backward
pos
"SQ11"
I13.3
Distance
where
table is
allowed
to speed
up
"B1"
I13.4
Adapter
clamped
pos for
LU mvt
"SQ13"
M9.1
Adapter
present
on the
selected
position
"Adapter_
On_Pos"
CMP ==I
DB64.DBW20
"DB_
CYCLES".
CYC1.S11
IN1
MW22
Sequence
for Amada
storage
"State"
IN2
CMP ==I
1
IN1
MW20
operator
set
position
for load
unload
part
"HMI_LU_
pos"
IN2
1.A
CMP <>I
1
IN1
MW20
operator
set
position
for load
unload
part
"HMI_LU_
pos"
IN2
MOVE
EN
ENO
DB64.DBW56
"DB_
CYCLES".
CYC2.S4
IN
OUT
MW22
Sequence
for Amada
storage
"State"


M105.0
adapter 1
back
sensor
"SQ42_mem"
I17.2
L2
adapter 1
middle
"SQ20"
I14.3
L2
adapter 1
down
"SQ19"
I18.7
"TBD"
MOVE
EN
ENO
DB64.DBW50
"DB_
CYCLES".
CYC2.S1
IN
OUT
MW22
Sequence
for Amada
storage
"State"
1.A

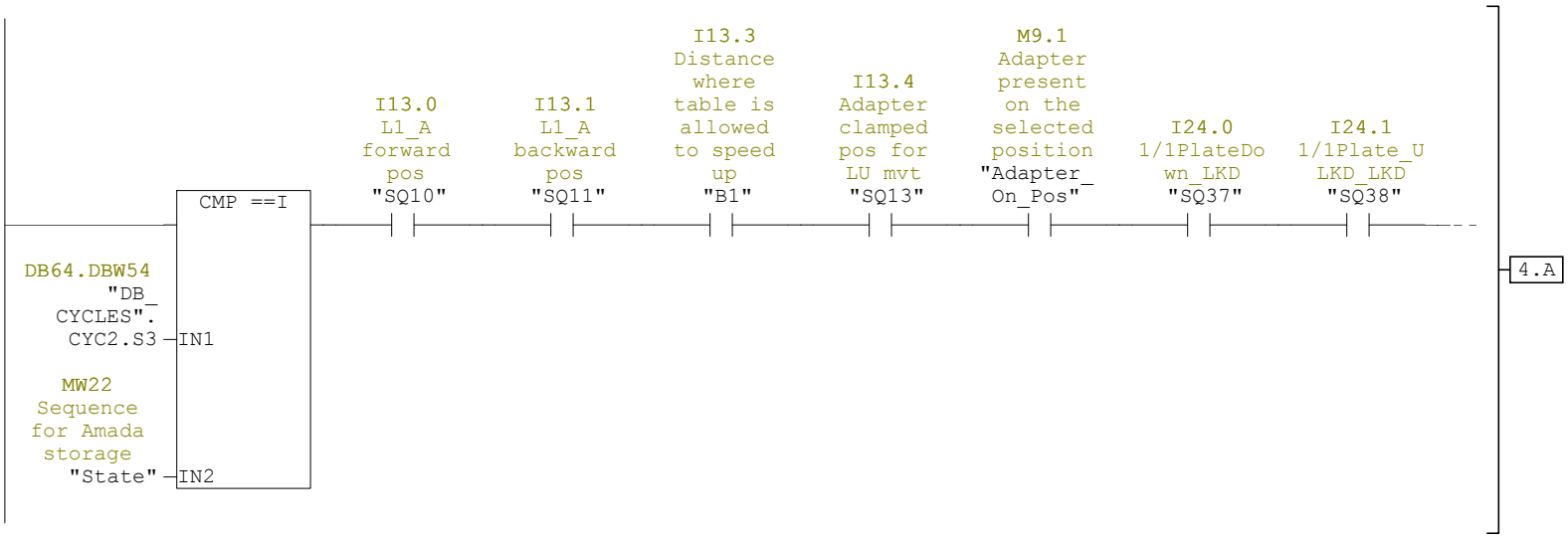
Network: 2

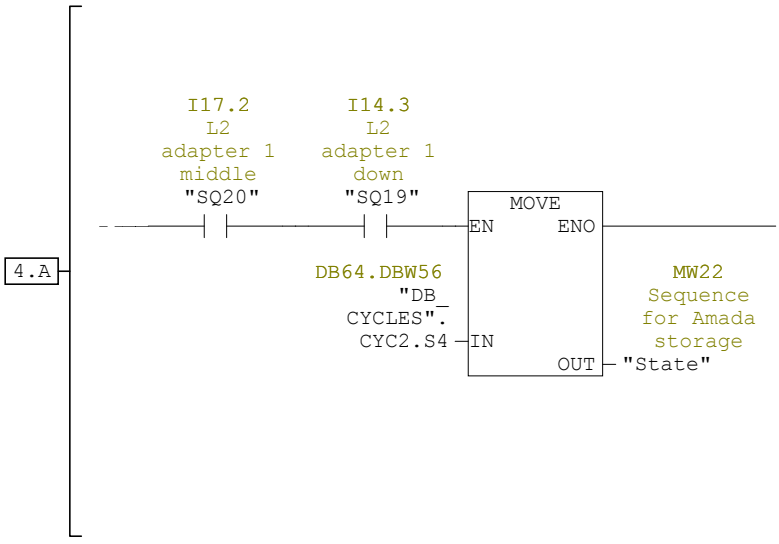

CMP ==I
DB64.DBW50
"DB_
CYCLES".
CYC2.S1
IN1
MW22
Sequence
for Amada
storage
"State"
IN2
I13.0
L1_A
forward
pos
"SQ10"
I13.1
L1_A
backward
pos
"SQ11"
I13.3
Distance
where
table is
allowed
to speed
up
"B1"
I13.4
Adapter
clamped
pos for
LU mvt
"SQ13"
M9.1
Adapter
present
on the
selected
position
"Adapter_
On_Pos"
I18.7
"TBD"
T13
"test
delay"
MOVE
EN
ENO
DB64.DBW52
"DB_
CYCLES".
CYC2.S2
IN
OUT
MW22
Sequence
for Amada
storage
"State"

Network: 3 lift 2 down - adapter 1 allowed to mov back - for adapter 1 load

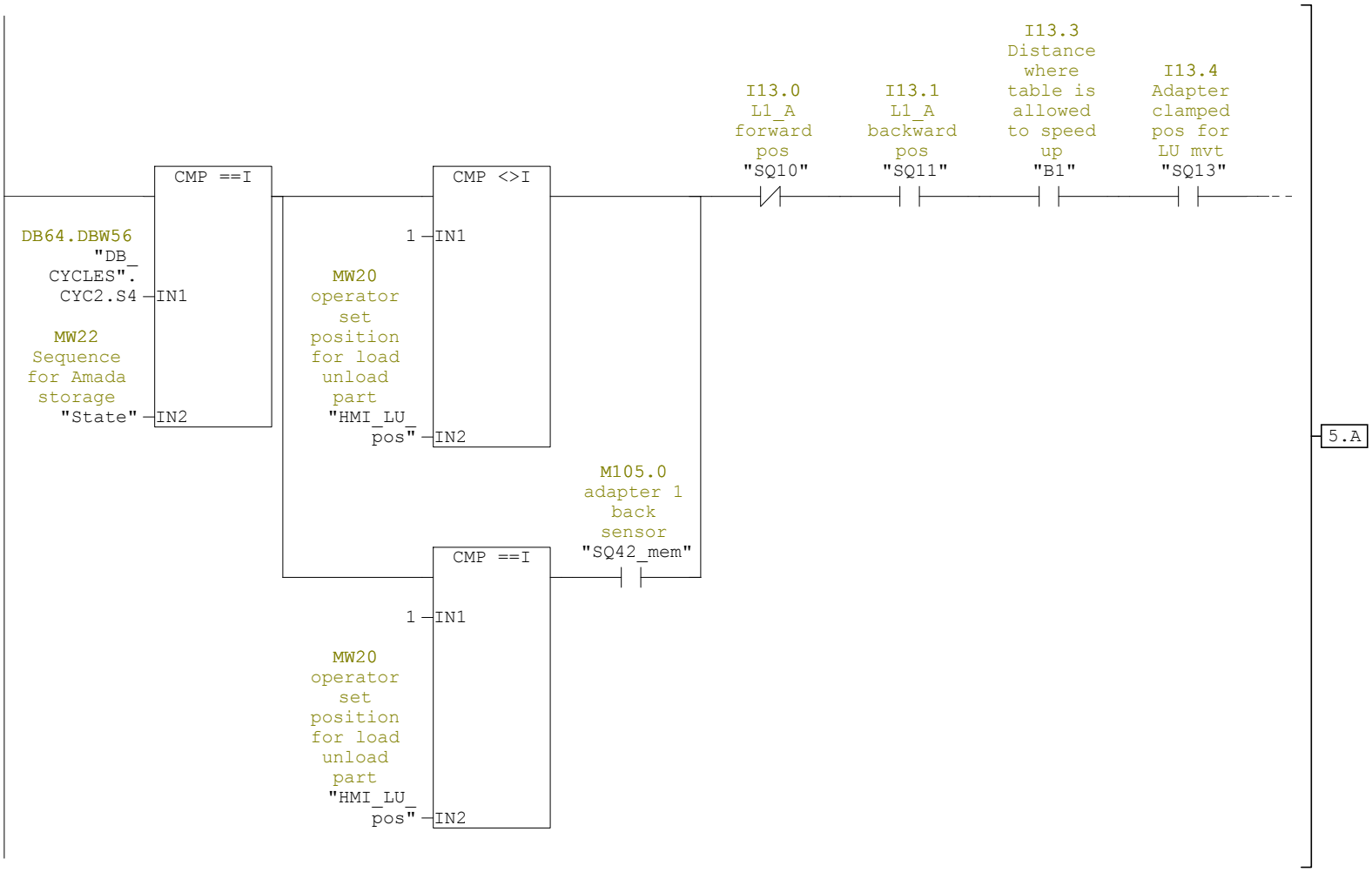


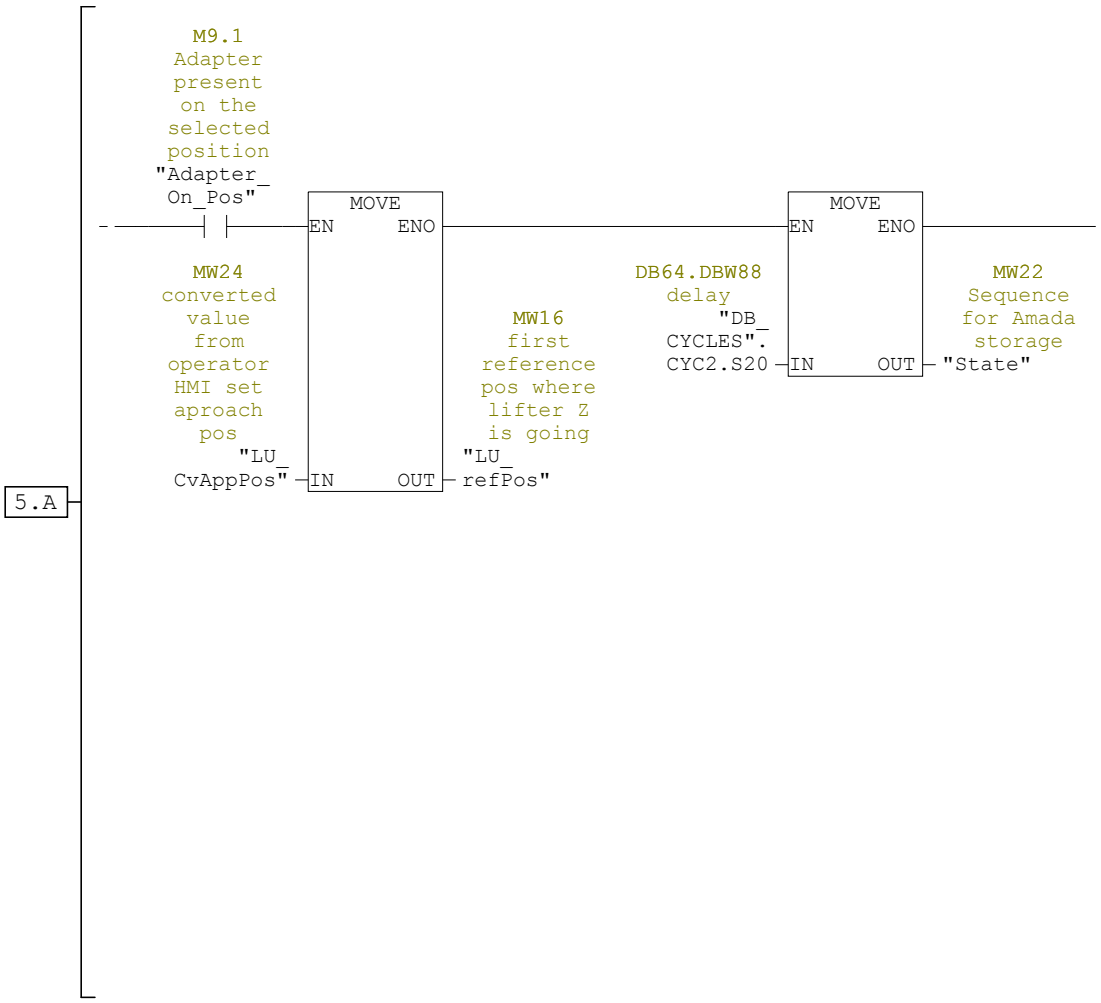
Network: 4



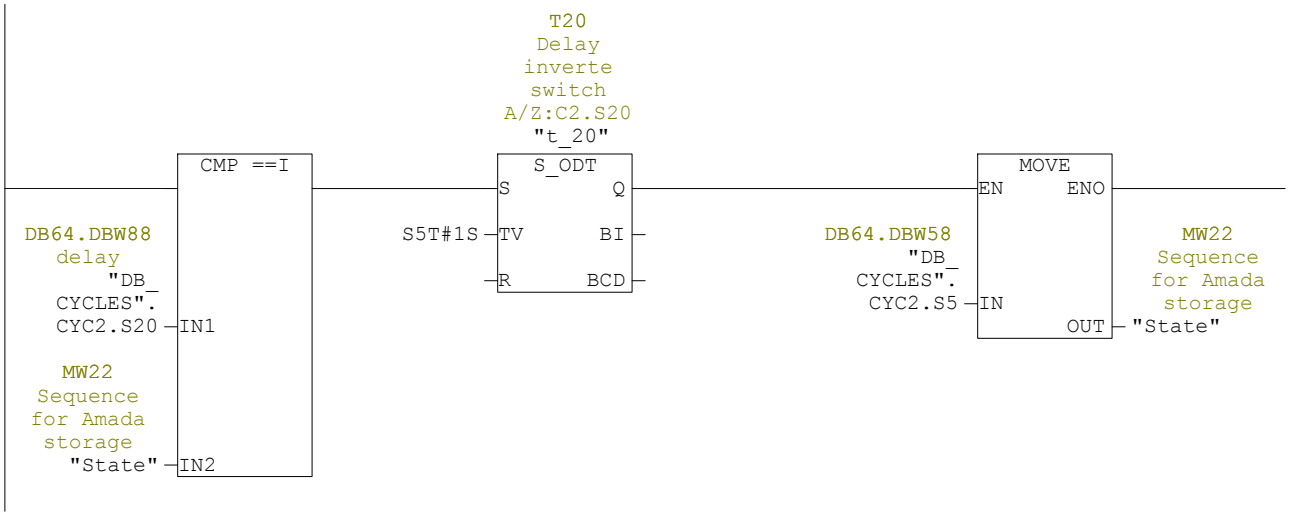


Network: 5

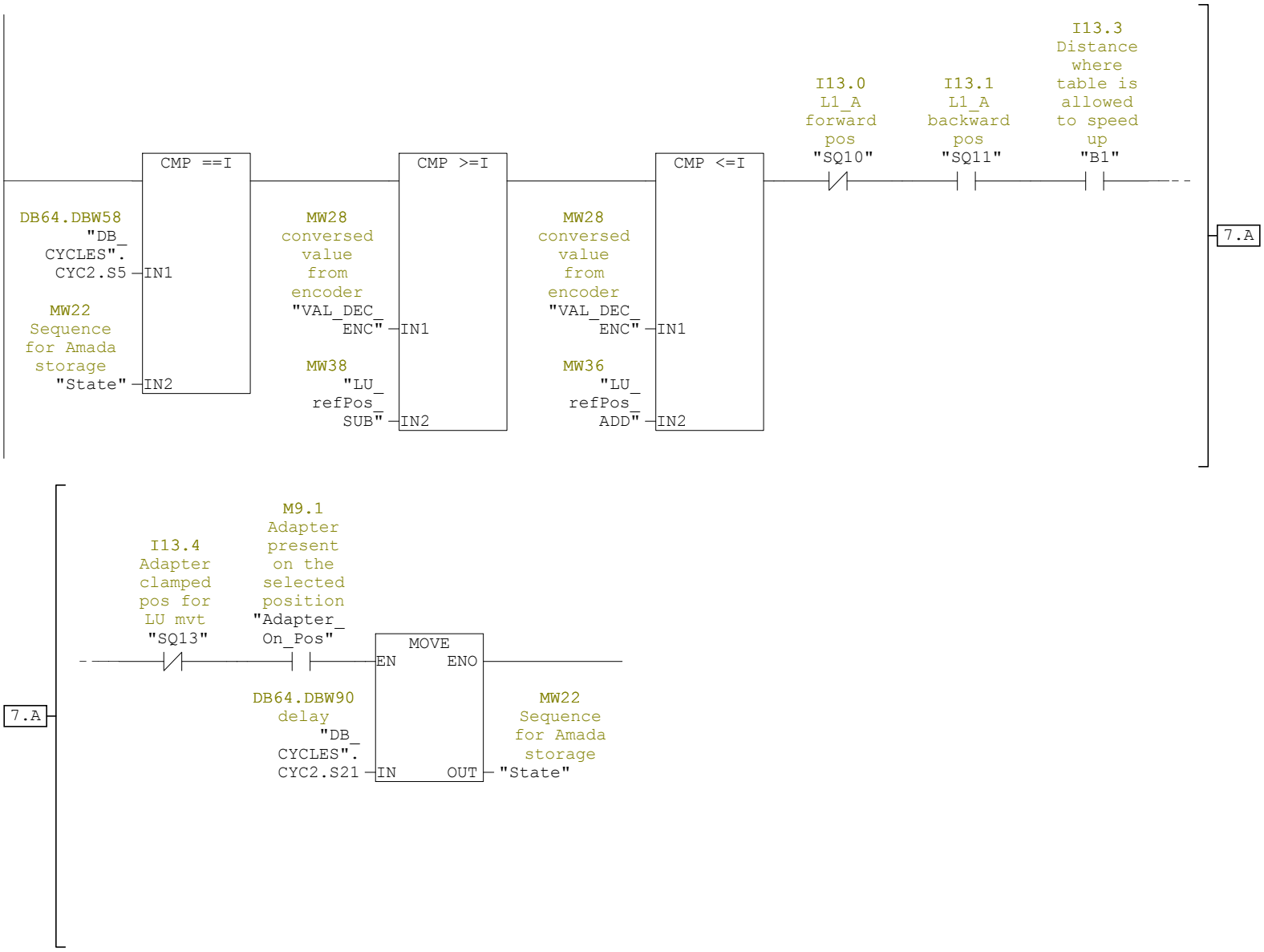

I13.0
L1_A
forward
pos
"SQ10"
I13.1
L1_A
backward
pos
"SQ11"
I13.3
Distance
where
table is
allowed
to speed
up
"B1"
I13.4
Adapter
clamped
pos for
LU mvt
"SQ13"
CMP ==I
DB64.DBW56
"DB_
CYCLES".
CYC2.S4
IN1
MW22
Sequence
for Amada
storage
"State"
IN2
CMP <>I
1
IN1
MW20
operator
set
position
for load
unload
part
"HMI_LU_
pos"
IN2
M105.0
adapter 1
back
sensor
"SQ42_mem"
CMP ==I
1
IN1
MW20
operator
set
position
for load
unload
part
"HMI_LU_
pos"
IN2
5.A



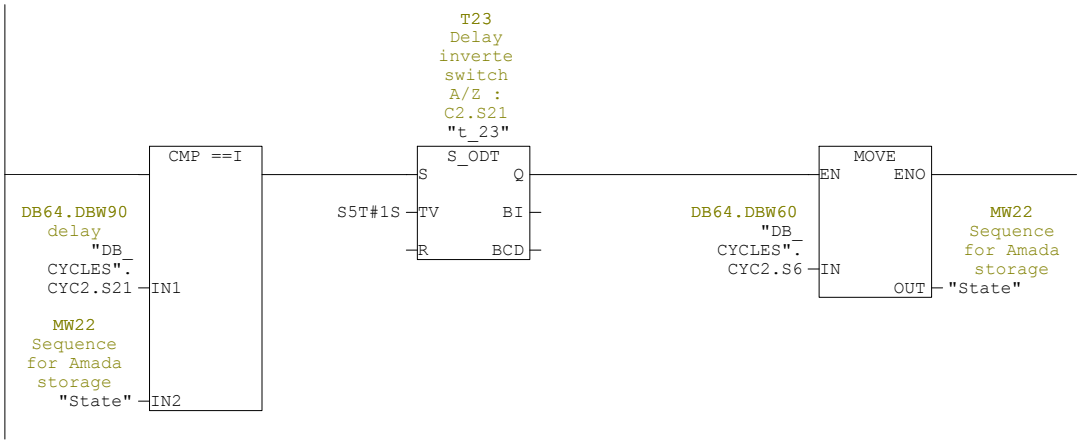
Network: 6 Delay inverte switch A/Z



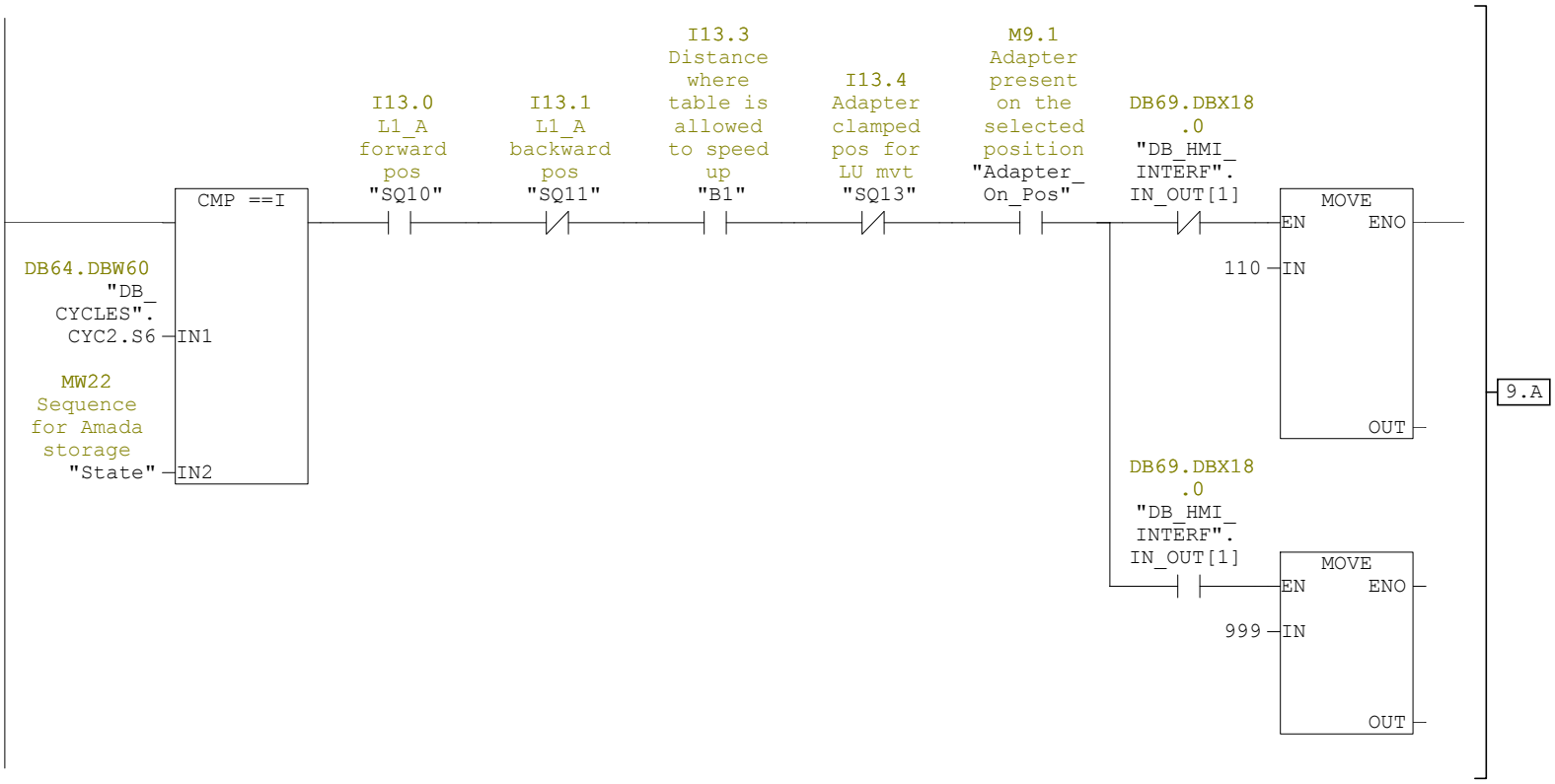
Network: 7

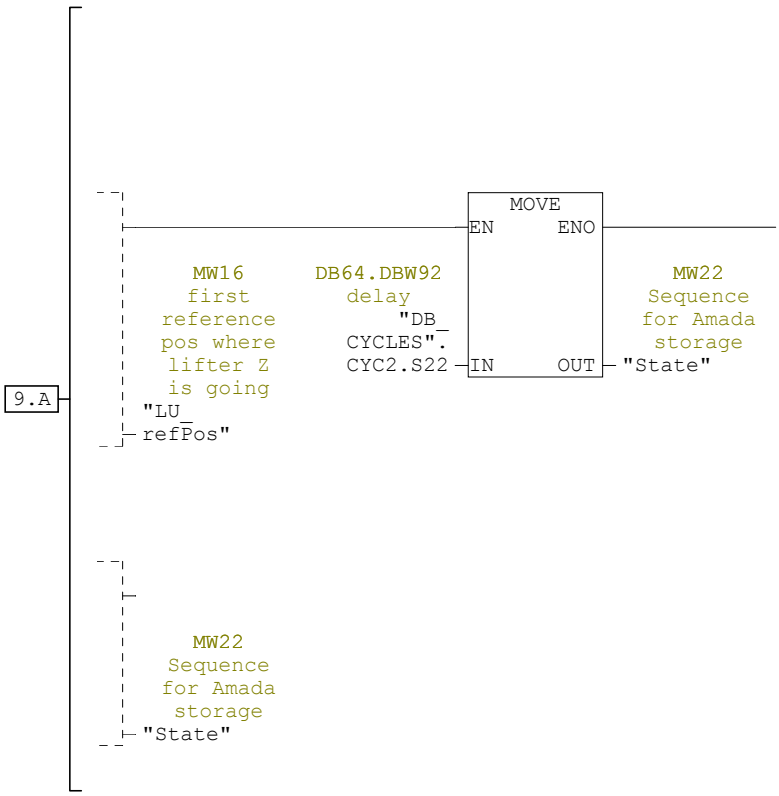
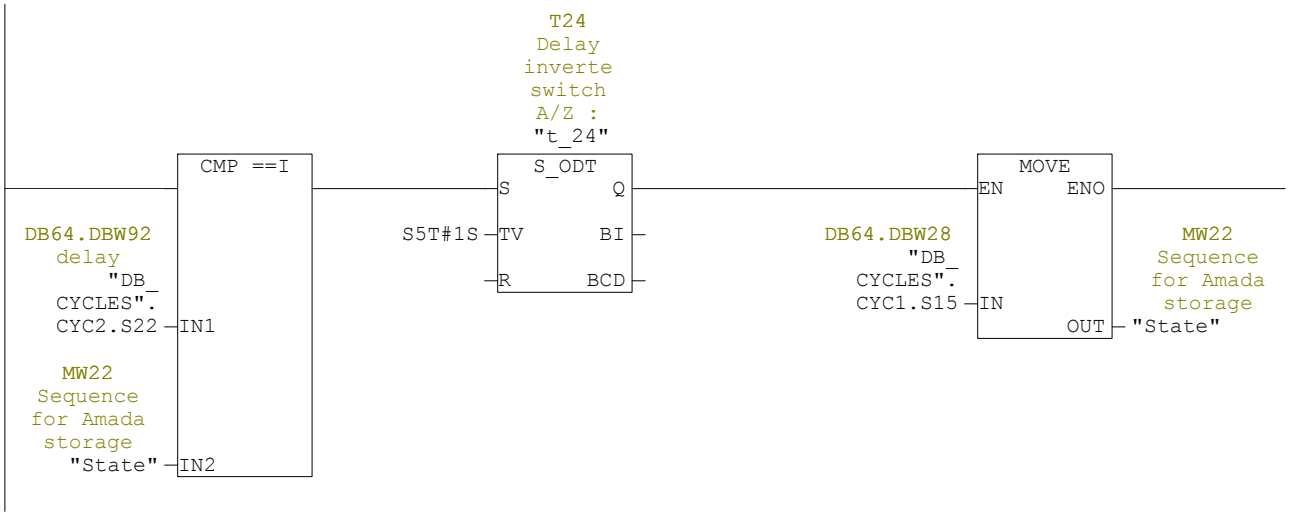


Network: 8 Delay inverte switch A/Z



Network: 9


I13.0
L1_A
forward
pos
"SQ10"
I13.1
L1_A
backward
pos
"SQ11"
I13.3
Distance
where
table is
allowed
to speed
up
"B1"
I13.4
Adapter
clamped
pos for
LU mvt
"SQ13"
M9.1
Adapter
present
on the
selected
position
"Adapter_
On_Pos"
DB69.DBX18
.0
"DB_HMI_
INTERF".
IN_OUT[1]
CMP ==I
DB64.DBW60
"DB_
CYCLES".
CYC2.S6
IN1
MW22
Sequence
for Amada
storage
"State"
IN2
MOVE
EN
ENO
110
IN
OUT
DB69.DBX18
.0
"DB_HMI_
INTERF".
IN_OUT[1]
MOVE
EN
ENO
999
IN
OUT
9.A


9.A
MW16
first
reference
pos where
lifter Z
is going
"LU_
refPos"
DB64.DBW92
delay
"DB_
CYCLES".
CYC2.S22
MOVE
EN
ENO
IN
OUT
MW22
Sequence
for Amada
storage
"State"
MW22
Sequence
for Amada
storage
"State"

Network: 10 Delay inverte switch A/Z