FC61 - <offline>

"FC_OP_MODE"

Name: **Family:**
Author: **Version:** 0.1
                                   Block version: 2
Time stamp Code: 11/21/2022 05:21:44 PM
          Interface: 09/09/2022 01:05:21 PM
Lengths (block/logic/data): 00244 00134 00000

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: FC61

Network: 1

```
    M0.0                              M0.0
 "AlwaysFAL                        "AlwaysFAL
    SE"                               SE"
 ───┤ ├──────────────────────────────(R)───┤
```

Network: 2

```
    M0.1                              M0.1
 "AlwaysTRU                        "AlwaysTRU
    E"                                E"
 ───┤/├──────────────────────────────(S)───┤
```

Network: 3

```
                  I17.0        I16.7
    M0.1         Man SW       Auto SW
 "AlwaysTRU     operator     operator       M0.3
    E"           "SA2:2"      "SA2:1"      "MAN_EN"
                                             SR
 ───┤ ├──────────┤ ├──────────┤/├────────S        Q├──
                                        │            │
                              I16.7     │            │
                             Auto SW    │            │
                             operator   │            │
                              "SA2:1"───R            │
                                        └────────────┘
```

Network: 4

```
   I17.0         I16.7
  Man SW        Auto SW          M0.4
 operator      operator       "AUTO_EN"
 "SA2:2"       "SA2:1"            SR
 ──┤/├──────────┤ ├─────────┤S        Q├──────────────
                               │         │
                I17.0          │         │
               Man SW          │         │
              operator         │         │
               "SA2:2" ────────┤R        │
                               └─────────┘
```
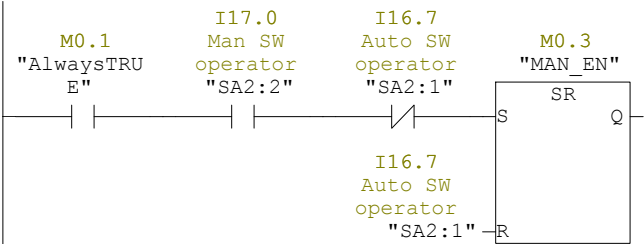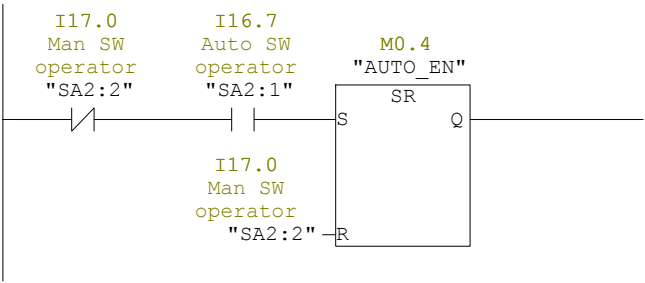
Network: 5   Enable for running full cycle in man mode

```
                                   M4.7
                                 Movement       M9.3        M9.0
                                 allowed       Fault       Enable
                                 memory       prior 1       for
    M0.1                         for all    (imidietly    manual
 "AlwaysTRU      M0.3             axes         stop)       cycle
    E"         "MAN_EN"         "MVT_EN"      "FLT1"       "MANU"
 ──┤ ├───┬──────┤ ├──────┬───────┤ ├──────────┤/├──────────( )──
         │               │
         │    M0.3      M8.1
         │  "MAN_EN"  "MAN_CYC_
         │              ON"
         └───┤/├────────┤ ├──────┘
```

Network: 6

```
                      M50.0
                    Operator
                      not
                    allowed
                    to run
    M0.1     I16.5   manual
 "AlwaysTRU  Run PB   cycle        M8.0
    E"      operator "PB_OFF"    "START_
            "SB3"                  CYC"
 ──┤ ├───────┤ ├──────┤/├──────────( )──
```
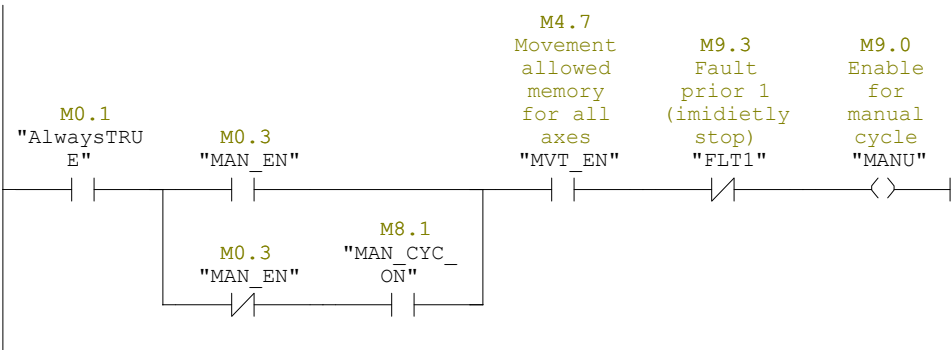
Network: 7   Stop at the end of cycle request

```
                                  M4.5
                                Stop at
                                the end
                                of cycle
                                request
    M0.1      M8.1     I16.6   "EOCY_REQ"
 "AlwaysTRU "MAN_CYC_ Stop PB     SR
    E"        ON"    operator  ┌─────────┐
                     "SB4"     │         │
 ──┤ ├───────┤ ├──────┬────────┤S        Q├──
                      │        │         │
                    M9.5       │         │
                   Fault       │         │
                   prior 3     │         │
                  (Stop at     │         │
                   the end   M5.0        │
                   of the   Axis in      │
                   cycle)   position     │
                   "FLT3"    for         │
                           stopping      │
                   ┌────────cycle        │
                   │       "EOCY         │
                   └─┤ ├─── DONE" ───────┤R        │
                                         └─────────┘
```
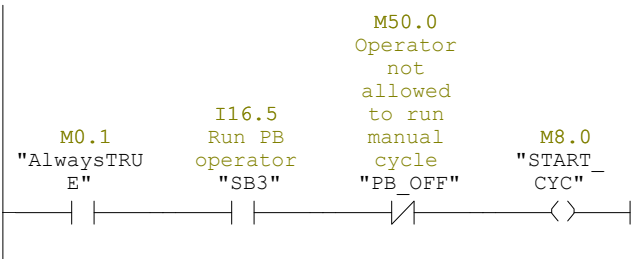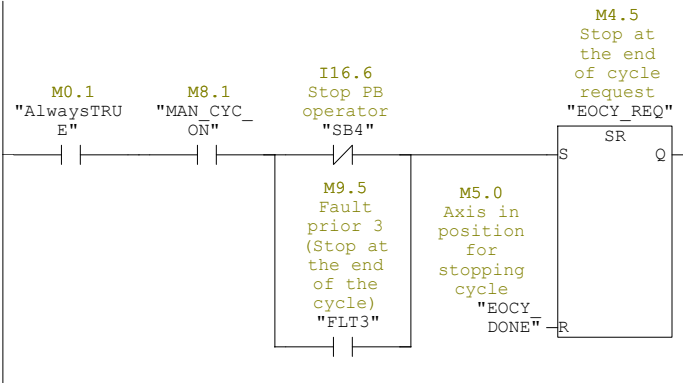

Network: 8   Axis in position for stopping cycle

```
                                        M5.0
                       I13.3            Axis in
                       Distance         position
    M4.5               where            for
    Stop at   I13.0    table is         stopping
    the end   L1_A     allowed  I13.1   cycle
    of cycle  forward  to speed L1_A    "EOCY_
    request   pos      up       backward DONE"
    "EOCY_REQ" "SQ10"  "B1"     pos            SR
                                "SQ11"   ┌───────────┐
  ───┤ ├───────┤ ├──────┤ ├──────┤/├────┤S        Q├──
                                         │           │
    M8.1      M105.1                     │           │
    "MAN_CYC_ "RST_EOCY_                 │           │
    ON"        P"                        │           │
  ───┤/├───────( P )────────────────────┤R          │
                                         └───────────┘
```
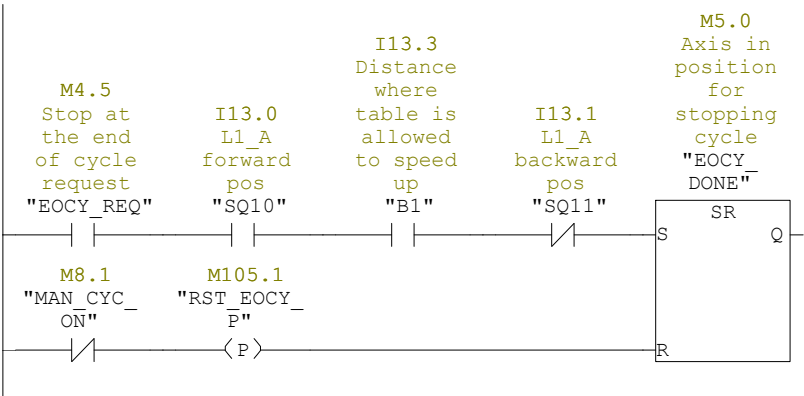
Network: 9   Enable manual operation by HMI

```
    M9.0                          M3.0
    Enable                        Enable
    for                           manual
    manual      M8.1              operation
    cycle       "MAN_CYC_         by HMI
    "MANU"      ON"               "MANU_OP"
  ───┤ ├─────────┤/├─────────────────( )───────
```

Network: 10

```
                M9.5
                Fault
                prior 3
    M9.0        (Stop at              M9.3      M9.4
    Enable      the end               Fault     Fault
    for         of the                prior 1   prior 2
    manual  M8.0 cycle)               (imidietly (Manual  M8.1
    cycle  "START_ "FLT3"             stop)      cycle)   "MAN_CYC_
    "MANU"  CYC"                       "FLT1"    "FLT2"   ON"
  ───┤ ├──┬──┤ ├────┤/├──────┬──────────┤/├───────┤/├──────( )───
          │                  │
          │       M5.0       │
          │       Axis in    │
          │       position   │
          │       for        │
          │ M8.1  stopping   M2.1
          │"MAN_CYC_ cycle   Manual
          │ ON"   "EOCY_    cycle done
          │        DONE"    "LU_Done"
          └──┤ ├────┤/├──────┤/├──┘
```