FC66 - <offline>

"FC_POS_AZ"

Family: Name: Author: Version: 0.1

Block version: 2 11/08/2022 08:26:08 AM Time stamp Code:

Interface: 09/29/2022 01:38:59 PM Lengths (block/logic/data): 00672 00524 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	

В	Block: FC66	 	
_			

Network: 1 FC71 "GRAY_TO_dEC2"

ENO ΕN

Network: 2 ====== stopper adapter 1 =======

Page 1 of 10

Network: 3 cyl stoppers of adapter 1 - up

```
M8.1
"MAN_CYC_
ON"
                                                 Q29.0
"YA1"
                                                                 Q28.7
"YV10"
                                CMP ==I
                                                                  \leftarrow
               DB64.DBW10
                    8 "DB_
                  CYCLES".
                   CYC3.S5-IN1
                  MW22
                Sequence
for Amada
                 storage
                   "State"-IN2
                                CMP ==I
               DB64.DBW6
"DB_
CYCLES".
                   CYC1.S4 -IN1
                  MW22
                Sequence
                for Amada
                 storage
                   "State" -IN2
                  Q28.7
"YV10"
                                  I18.7
"TBD"
                  + \vdash
   M3.0
               DB69.DBX10
  Enable
  manual
                "DB_HMI_
INTERF".
operation
  by HMI
 "MANU OP"
                 IN[8]
```

```
Network: 4 cyl stoppers of adapter 1 - down
```

```
M8.1
"MAN_CYC_
                                             Q28.7
                                                            Q29.0
"YA1"
   o∏"
                                             "YV10"
                              CMP ==I
                                                             <del>-()-</del>
              DB64.DBW52
                "DB_
CYCLES".
                 CYC2.S2 -IN1
                 MW22
               Sequence
              for Amada
               storage
                  "State" -IN2
                             CMP ==I
              DB64.DBW2
                "DB_
CYCLES".
                 CYC1.S2 -IN1
                MW22
               Sequence
              for Amada
               storage
                  "State" -IN2
                               I24.0
                            1/1PlateDo
                Q29.0
                              wn LKD
                 "YA1"
                               "sQ37"
  M3.0
              DB69.DBX10
 Enable
 manual
                 . 6
              "DB_HMI_
INTERF".
operation
 by HMI
"MANU_OP"
                IN[7]
```

```
Network: 5 ===== ADAPTER 1 HYDRAULIC LIFT 2 ======
```

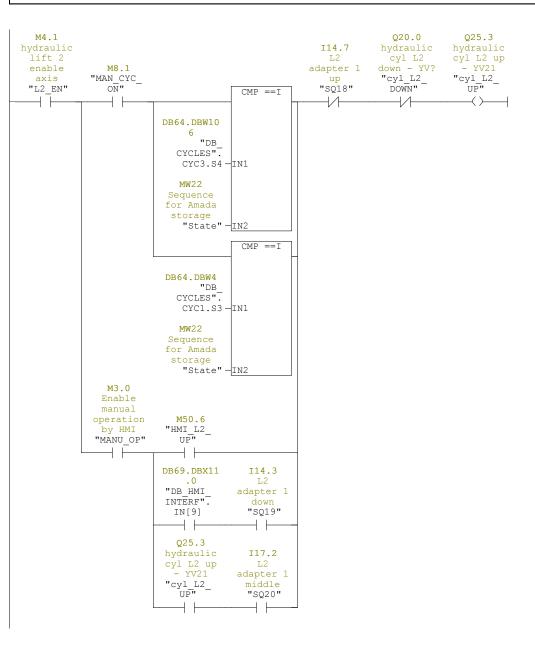
Network: 6 hydraulic lift 2 enable axis

```
I19.1
                                             M4.1
  I13.0
                 I13.1
                            Presostate
                                          hydraulic
                             pressure
   L1_A
                 L1_A
                                            lift 2
  forward
               backward
                             - 6bar -
                                            enable
  pos
"SQ10"
                pos
"SQ11"
                                            axis
"L2_EN"
                                OK
                               "BP1"
   +
                 1/1-
                                             -( }-
   M0.1
"AlwaysTRU
   Ε"
```

Network: 7

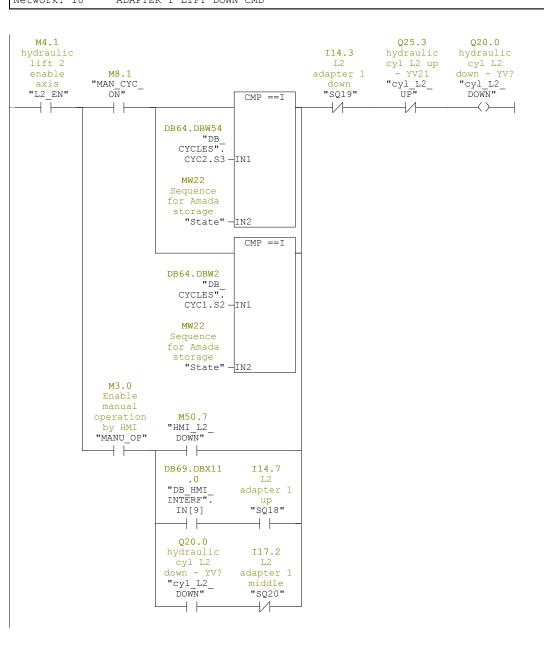
```
M4.1
               M3.0
hydraulic
                          DB69.DBX11
               Enable
 lift 2
               manual
                              .1
 enable
             operation
                           "DB HMI
                                                        M50.7
                                                                      M50.6
                                                      "HMI_L2_
                                                                    "HMI_L2_
                           INTERF".
              by HMI
  axis
                                                        DOWN"
 "L2 EN"
                                                                      UP"
              "MANU OP"
                            IN[10]
                \dashv \bar{\vdash}
                                                                       <>─
                                           I14.7
                                            L2
                             M50.6
                                         adapter 1
                           "HMI_L2_
                                            up
                             UP"
                                           "SQ18"
```

Network: 8 ADAPTER 1 LIFT UP CMD



Network: 9 M4.1 M3.0 DB69.DBX11 hydraulic Enable lift 2 manual . 2 enable operation "DB HMI M50.6 M50.7 "HMI_L2_ "HMI_L2_ INTERF". by HMI axis DOWN" "L2 EN" UP" "MANU OP" IN[11] $\dashv \bar{\vdash}$ ΗĒ -()-

Network: 10 ADAPTER 1 LIFT DOWN CMD



I14.3

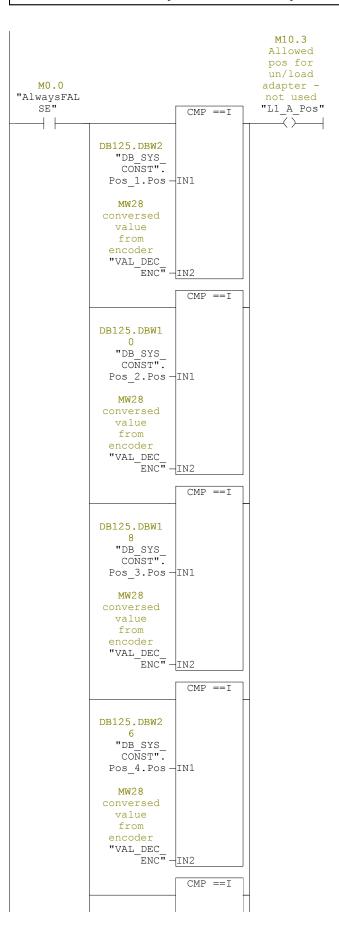
adapter 1

down "SQ19"

M50.7

"HMI_L2_ DOWN" Lifter_Amada\
SIMATIC 300\CPU 315\...\FC66 - <offline>

Network: 11 Allowed pos for un/load adapter



```
DB125.DBW3
    4
  "DB_SYS_
CONST".
 Pos_5.Pos -IN1
  MW28
conversed
  value
  from
 encoder
 "VAL_DEC_
      ENC" -IN2
              CMP ==I
DB125.DBW4
    2
  "DB_SYS_
CONST".
 Pos_6.Pos -IN1
   MW28
conversed
  value
  from
 encoder
 "VAL_DEC_
ENC" -IN2
```

Network: 12 Allowed pos for approach to load unload on B axis

```
M10.2
                                           Allowed
                                           approach
                                             pos
                                            un/load
                                          adapter-no
   M0.0
                                            t used
"AlwaysFAL
                                            "L1 A_
                                           AppPos"
   SE"
                             CMP ==I
                                              \leftarrow
              DB125.DBW0
                 "DB_SYS_
CONST".
                   Pos 1.
                   AppPos -IN1
                 MW28
              conversed
                 value
                 from
                encoder
                "VAL DEC
                     ENC" -IN2
                             CMP ==I
              DB125.DBW8
                 "DB_SYS_
CONST".
                   Pos 2.
                   AppPos -IN1
                 MW28
              conversed
                 value
                 from
                encoder
                "VAL_DEC
                     ENC" -IN2
                             CMP ==I
              DB125.DBW1
                  6
                 "DB_SYS_
CONST".
                   Pos_3.
                   AppPos -IN1
                 MW28
              conversed
                 value
                 from
                encoder
                "VAL_DEC
                     ENC"-IN2
                             CMP ==I
              DB125.DBW2
                   4
                 "DB_SYS_
CONST".
                   Pos\_4.
                   AppPos -IN1
                 MW28
               conversed
                 value
                 from
                encoder
                "VAL DEC
```

Lifter_Amada\
SIMATIC 300\CPU 315\...\FC66 - <offline>

