Lifter_Amada\ SIMATIC 300\CPU 315\...\FC57 - <offline>

FC57 - <offline>

"FC_KEB_SPEED"

Family: Name: Author: Version: 0.1 Block version: 2 Code: 11/10/2022 09:07:03 AM Interface: 11/03/2022 04:11:47 PM Time stamp Code:

Lengths (block/logic/data): 00842 00712 00008

Name	Data Type	Address	Comment
IN		0.0	
OUT		0.0	
IN_OUT		0.0	
TEMP		0.0	
val_tmp_2	Word	0.0	
val_tmp	Word	2.0	
abs_val_tmp	Word	4.0	
abs_val_tmp_2	Word	6.0	
RETURN		0.0	
RET_VAL		0.0	

Block: FC57

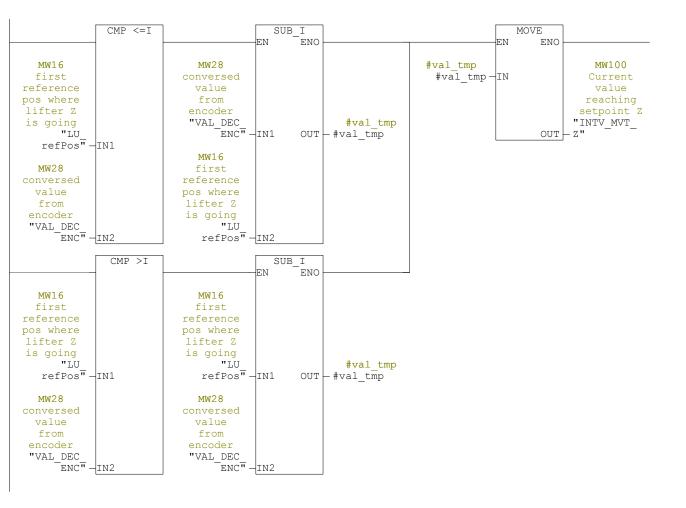
Network: 1 ====== Set axes speed =======

3 fixed speeds from inverter:

For L1_A/Z: S1 - 10Hz S2 - 20Hz

For L1_Z: S3=S1+S2 - 30Hz

Network: 2

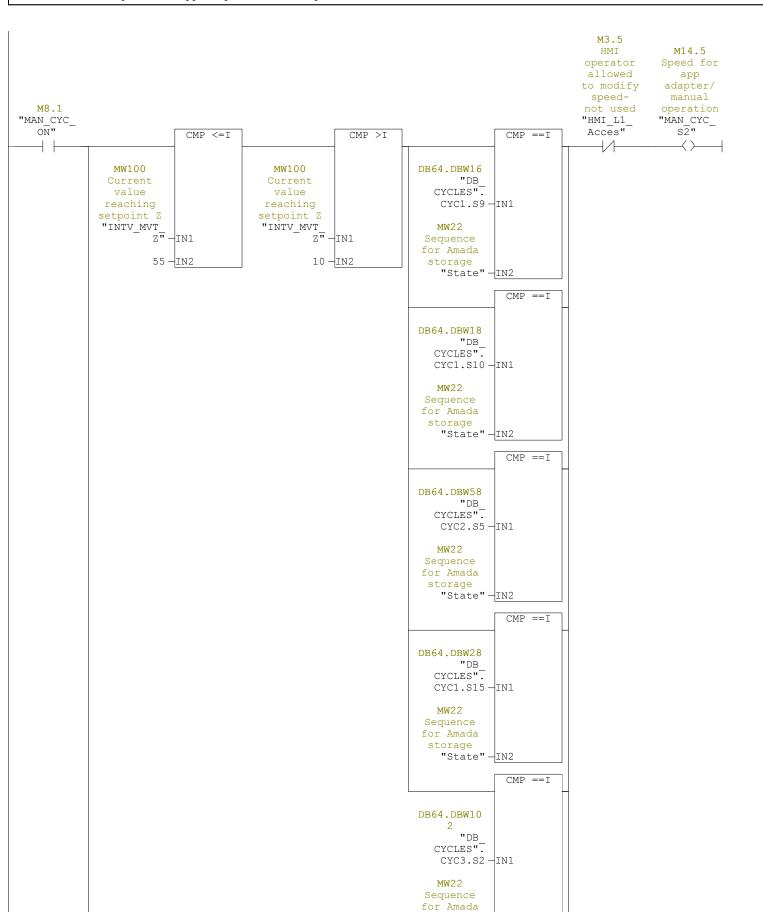


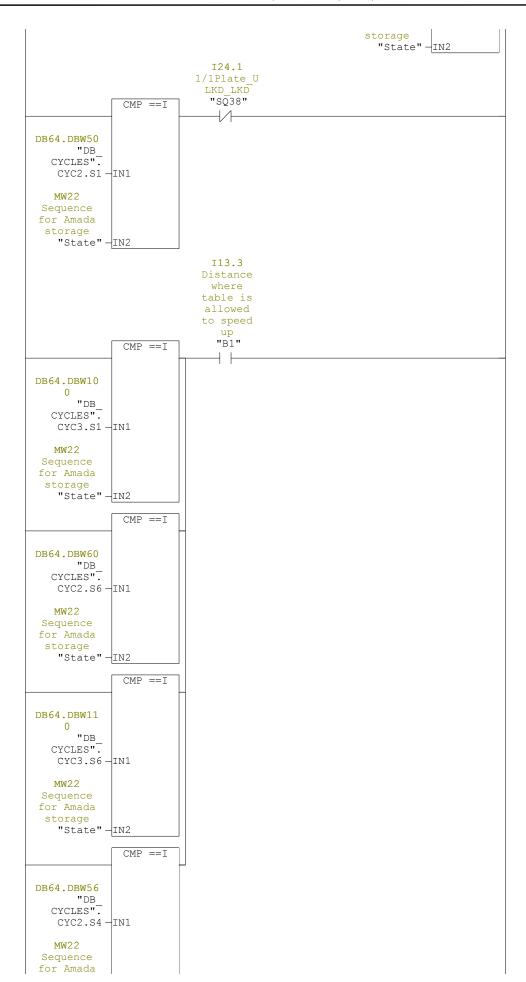
Network: 3 Speed for reaching Z setpoint M3.5 м3.6 HMI operator HMI prog. allowed allowed M14.6 to modify to modify Speed for speedreaching speed not used not used Z setpoint "MAN_CYC_ "HMI_L1_ Acces" "HMI_L2_ Acces" s1" <> M8.1 "MAN_CYC_ ON" CMP <=I CMP ==I MW100 DB64.DBW16 "DB_ CYCLES". Current value reaching CYC1.S9 -IN1 setpoint Z "INTV_MVT MW22 z" –IN1 Sequence for Amada 10 - IN2 storage "State"-IN2 CMP ==I DB64.DBW18 "DB_CYCLES". CYC1.S10 -IN1 MW22 Sequence for Amada storage "State" -IN2 CMP ==I DB64.DBW58 "DB_ CYCLES". CYC2.S5 -IN1 MW22 Sequence for Amada storage "State" -IN2 CMP ==I DB64.DBW28 "DB CYCLES". CYC1.S15 -IN1 MW22 Sequence for Amada storage "State" -IN2 CMP ==I DB64.DBW10

"DB_ CYCLES".

```
CYC3.S2 -IN1
                                           MW22
                                         Sequence
                                        for Amada
                                         storage
                                           "State" -IN2
                                          I24.1
                                        1/1Plate U
                                         LKD LKD
                                          "sQ38"
                           CMP ==I
             DB64.DBW50
               "DB_
CYCLES".
                CYC2.S1 -IN1
               MW22
             Sequence
             for Amada
              storage
                "State" -IN2
  M3.0
 Enable
             DB69.DBX8.
                          DB69.DBX8.
 manual
                0
             "DB_HMI_
INTERF".
                          "DB_HMI_
INTERF".
operation
 by HMI
"MANU_OP"
            MOV_SEL[1]
                         MOV_SEL[2]
                                           I13.3
                                         Distance
                                          where
                                         table is
                                         allowed
                                         to speed
                                           up
"B1"
                            CMP <=I
               MW100
              Current
               value
             reaching
             setpoint Z
             "INTV_MVT
                      z"-IN1
                      40 -IN2
                           CMP <=I
               MW100
              Current
               value
             reaching
             setpoint Z
             "INTV_MVT_
                      z"-IN1
                       4 -IN2
```

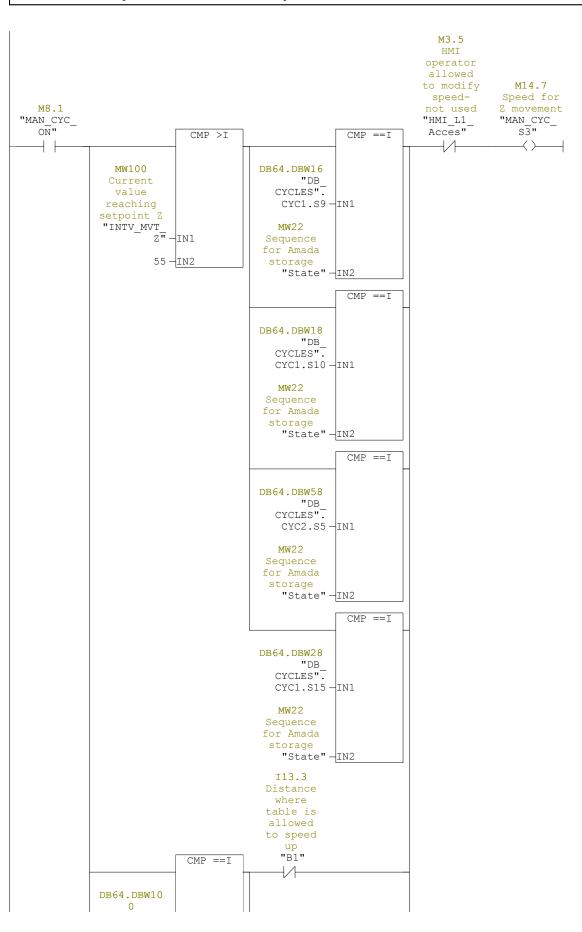
Network: 4 Speed for app adapter/ manual operation

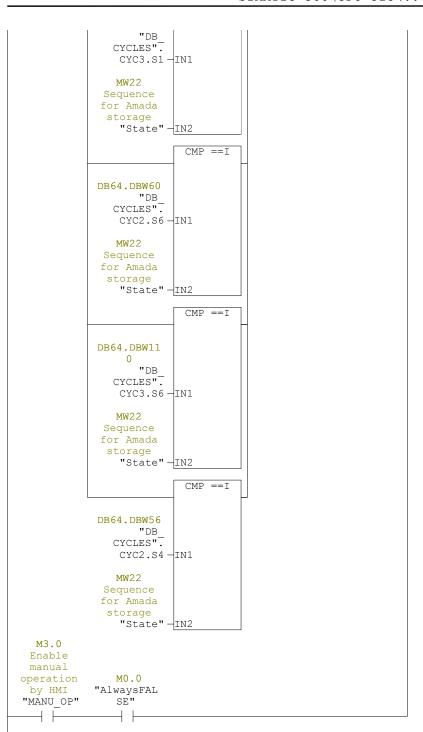




```
storage
"State" -IN2
                           CMP ==I
            DB64.DBW10
                .
4
"DB_
               CYCLES".
                CYC3.S3 -IN1
               MW22
             Sequence
             for Amada
              storage
                "State" -IN2
                                                       I13.3
                                                      Distance
  M3.0
                                                       where
            DB69.DBX8.
                                          I13.0
 Enable
                                                      table is
                                                                     I13.1
 manual
                 0
                                          L1_A
                                                      allowed
                                                                     L1_A
             "DB_HMI_
INTERF".
operation
                                         forward
                                                      to speed
                                                                   backward
 by HMI
                                           pos
                                                                     pos
                                                        up
"MANU OP"
                                          "SQ10"
                                                        "B1"
                                                                     "SQ11"
            MOV_SEL[1]
                            CMP >I
               MW100
              Current
               value
             reaching
            setpoint Z
             "INTV_MVT_
                     z"-IN1
                     40 -IN2
                                          I13.3
                                        Distance
                                          where
            DB69.DBX8.
                                        table is
                                         allowed
             "DB HMI
                                        to speed
             INTERF".
                                           up
"B1"
            MOV_SEL[2]
                           CMP <=I
               1/-
                                           1/1
              MW100
              Current
              value
             reaching
            setpoint Z
             "INTV_MVT_
                     z - IN1
                       4 -IN2
```

Network: 5 Speed for Z movement-max speed





```
Network: 6 Inverter KEB slowdown bit - CP11
```

```
M14.6
                                            Q24.7
Speed for
                                           Inverter
reaching
                                             KEB
Z setpoint
                                           slowdown
"MAN_CYC_
                                          bit - CP11
  s<u>1</u>"
                                            "KA10"
                                             \leftarrow
                M14.5
              Speed for
  M14.6
                 app
              adapter/
Speed for
                              M14.7
                            Speed for
reaching
               manual
Z setpoint
              operation
                            Z movement
"MAN CYC_
              "MAN CYC_
                            "MAN_CYC_
  s<del>1</del>"
                 s2"
                               s3"
  M14.5
Speed for
                M14.6
   app
adapter/
              Speed for
                              M14.7
              reaching
                            Speed for
 manual
operation
              Z setpoint
                            Z movement
"MAN_CYC_
                            "MAN_CYC_
              "MAN_CYC_
  s2"
                 s<del>1</del>"
                               s3"
```

Network: 7 Inverter KEB max. speed bit - CP12

```
M14.6
                                             Q25.0
              Speed for
  M14.7
                                           Inverter
Speed for
                                           KEB max.
              reaching
Z movement
              Z setpoint
                                          speed bit
"MAN_CYC_
              "MAN_CYC_
                                            - CP12
                 s1"
   s<del>3</del>"
                                            "KA11"
                                             <>
  M14.5
Speed for
   app
                M14.6
 adapter/
              Speed for
                              M14.7
              reaching
                            Speed for
 manual
operation
              Z setpoint
                            Z movement
"MAN_CYC_
s2"
              "MAN_CYC_
S1"
                            "MAN_CYC_
s3"
```