FC50 - <offline>

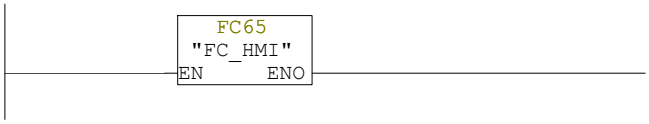
"FC_CYCLES"

Name: **Family:**
Author: **Version:** 0.1
Block version: 2
Time stamp Code: 11/21/2022 04:44:50 PM
Interface: 11/01/2022 04:29:05 PM
Lengths (block/logic/data): 01316 01136 00002

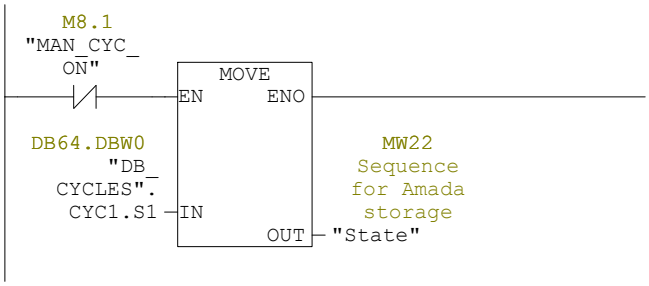
Name	Data Type	Address	Comment
IN		0.0	
OUT		0.0	
IN_OUT		0.0	
TEMP		0.0	
RETURN		0.0	
RET_VAL		0.0	

Block: FC50

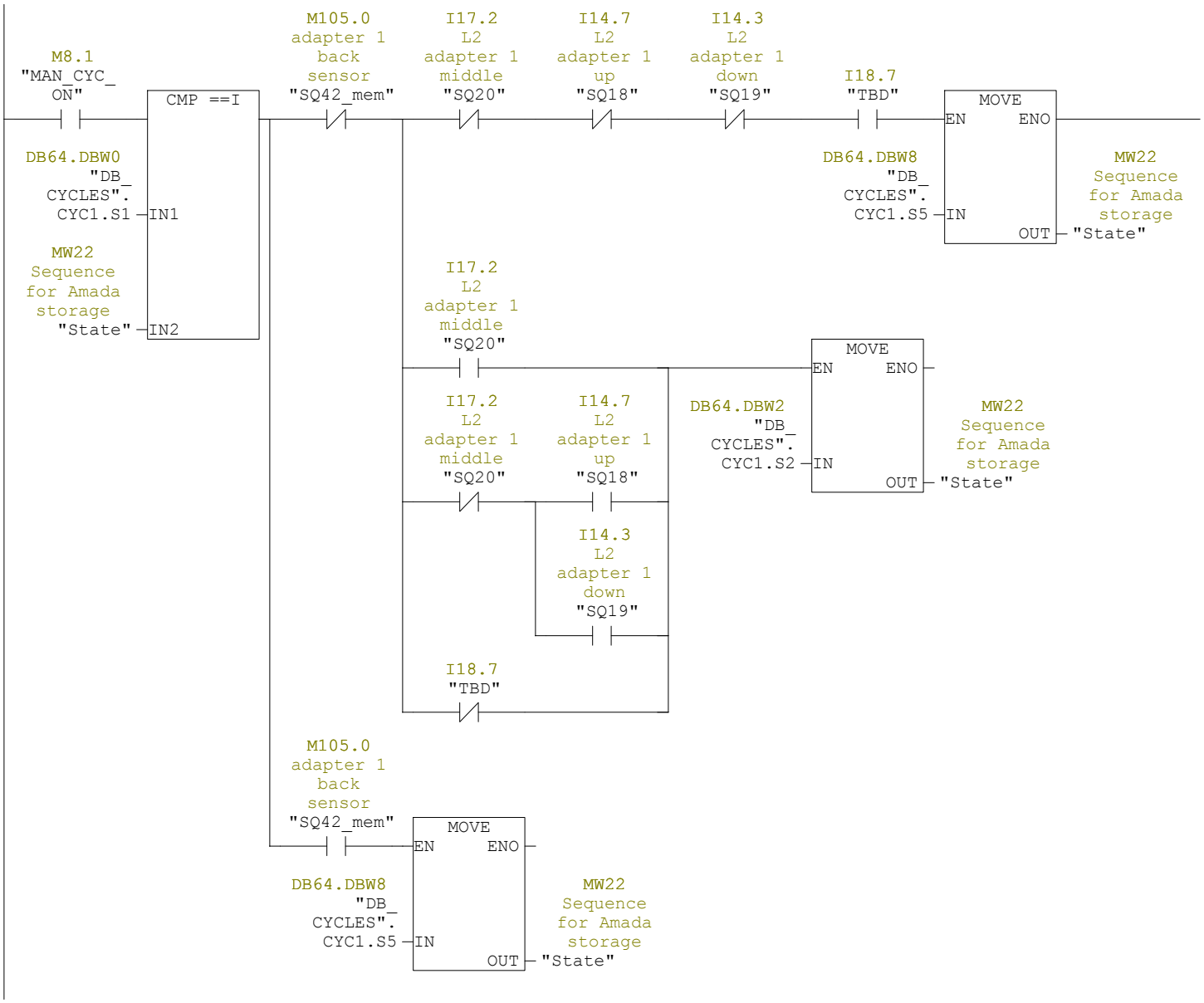
Network: 1



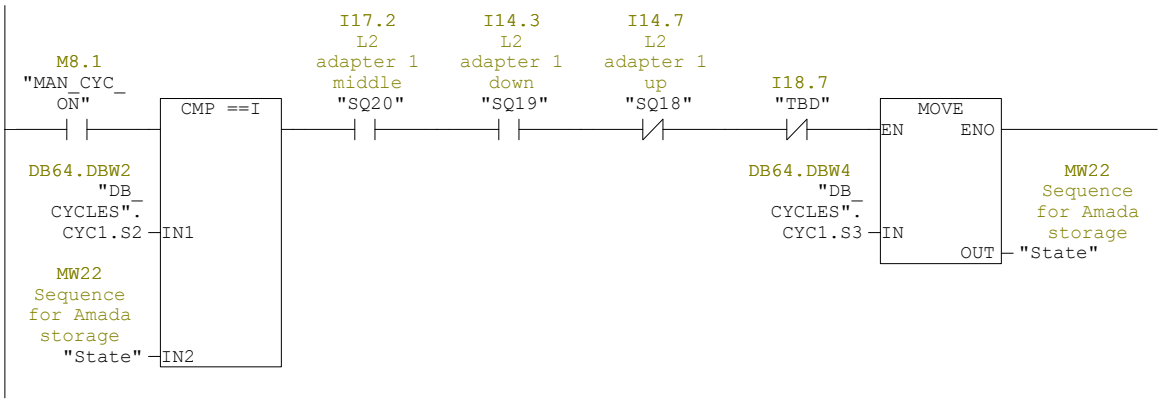
Network: 2 reset



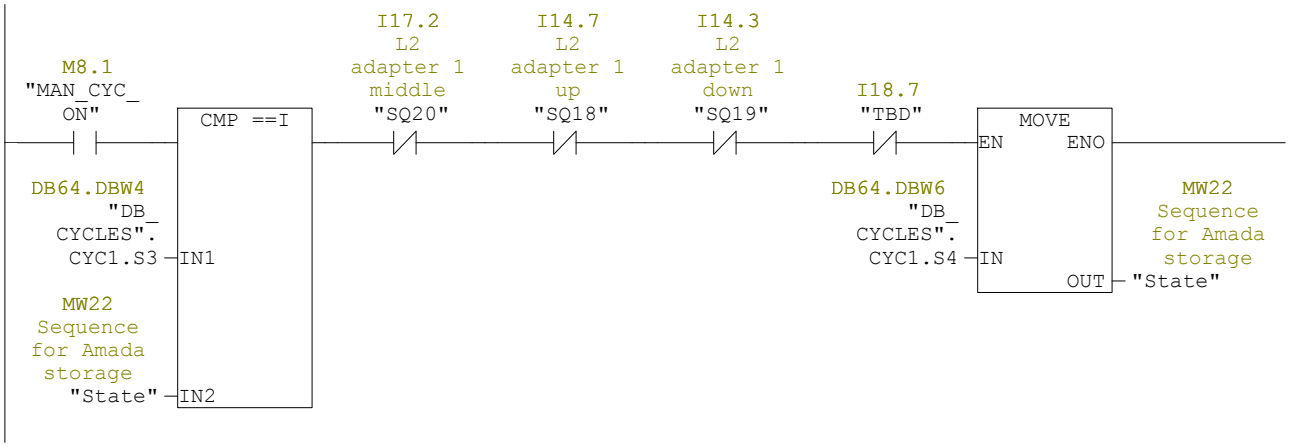
Network: 3 init system state



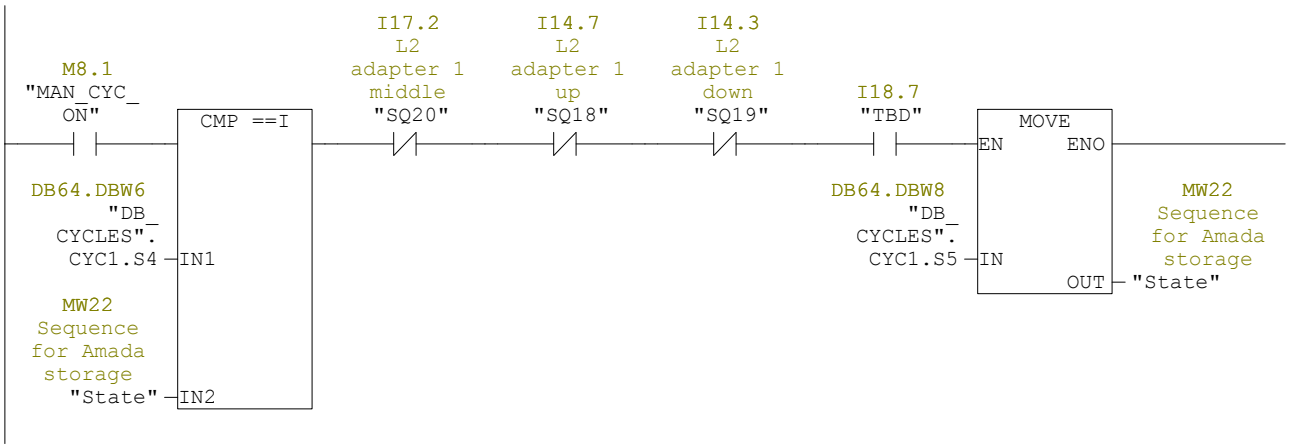
Network: 4



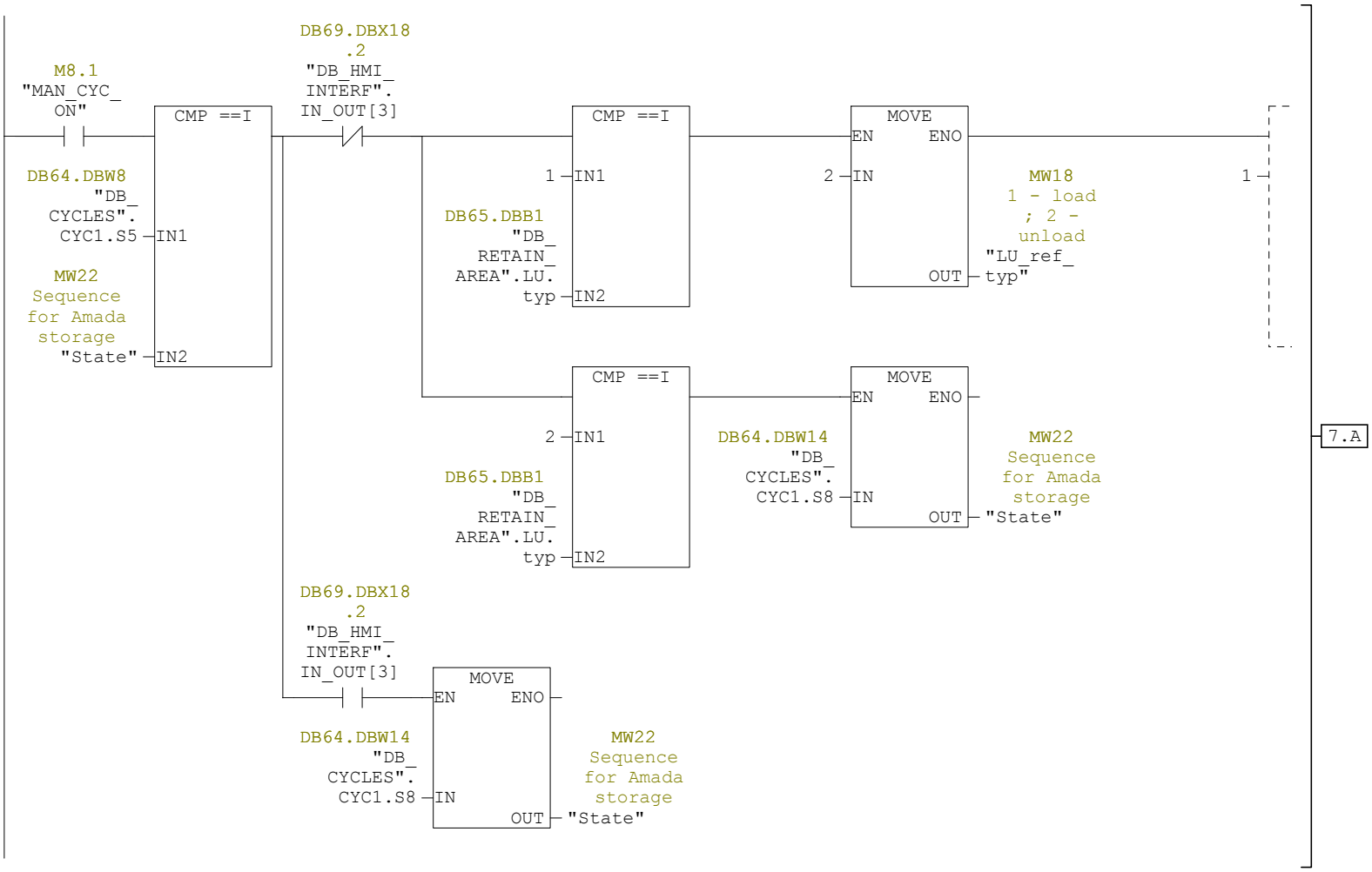
Network: 5

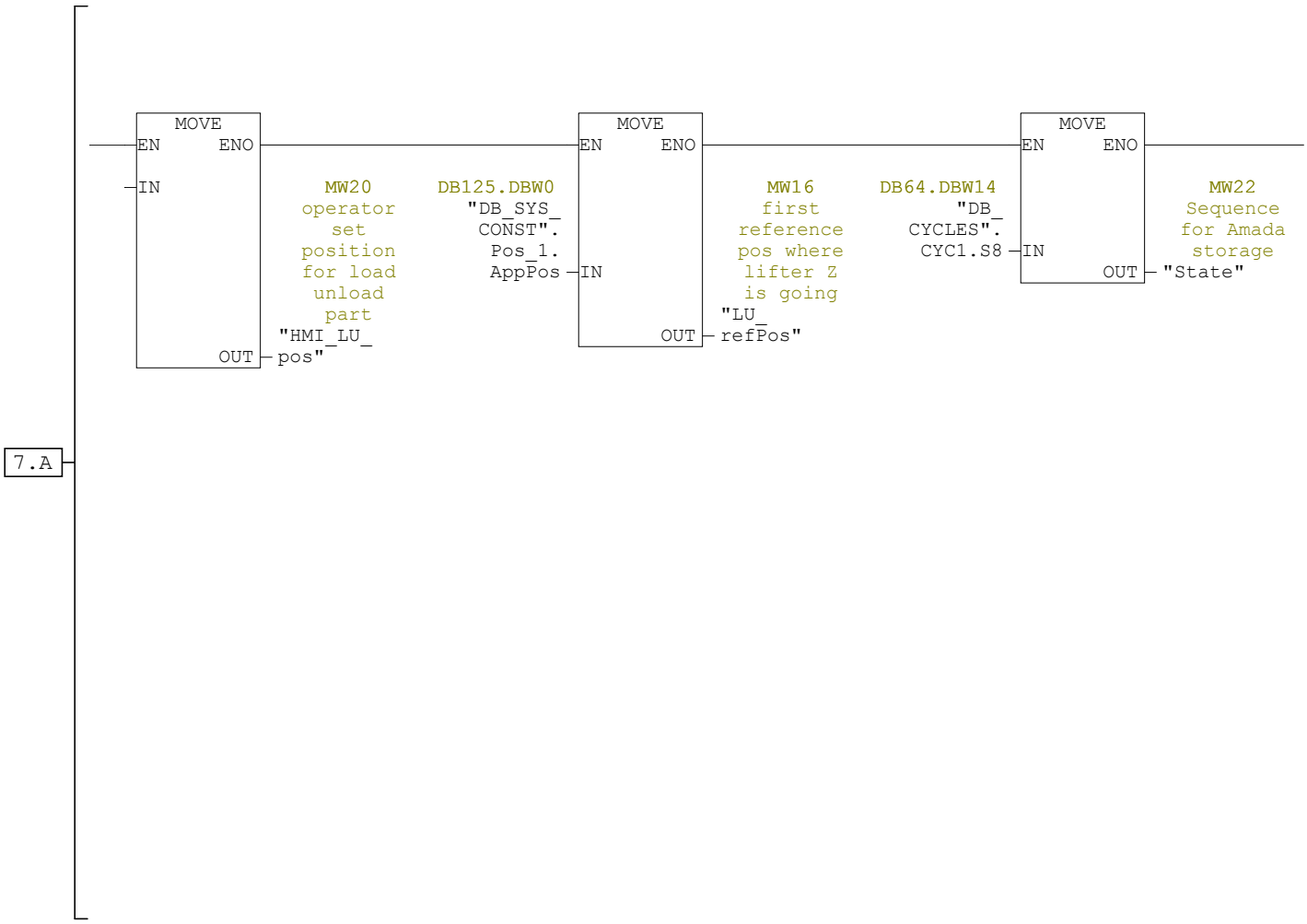


Network: 6



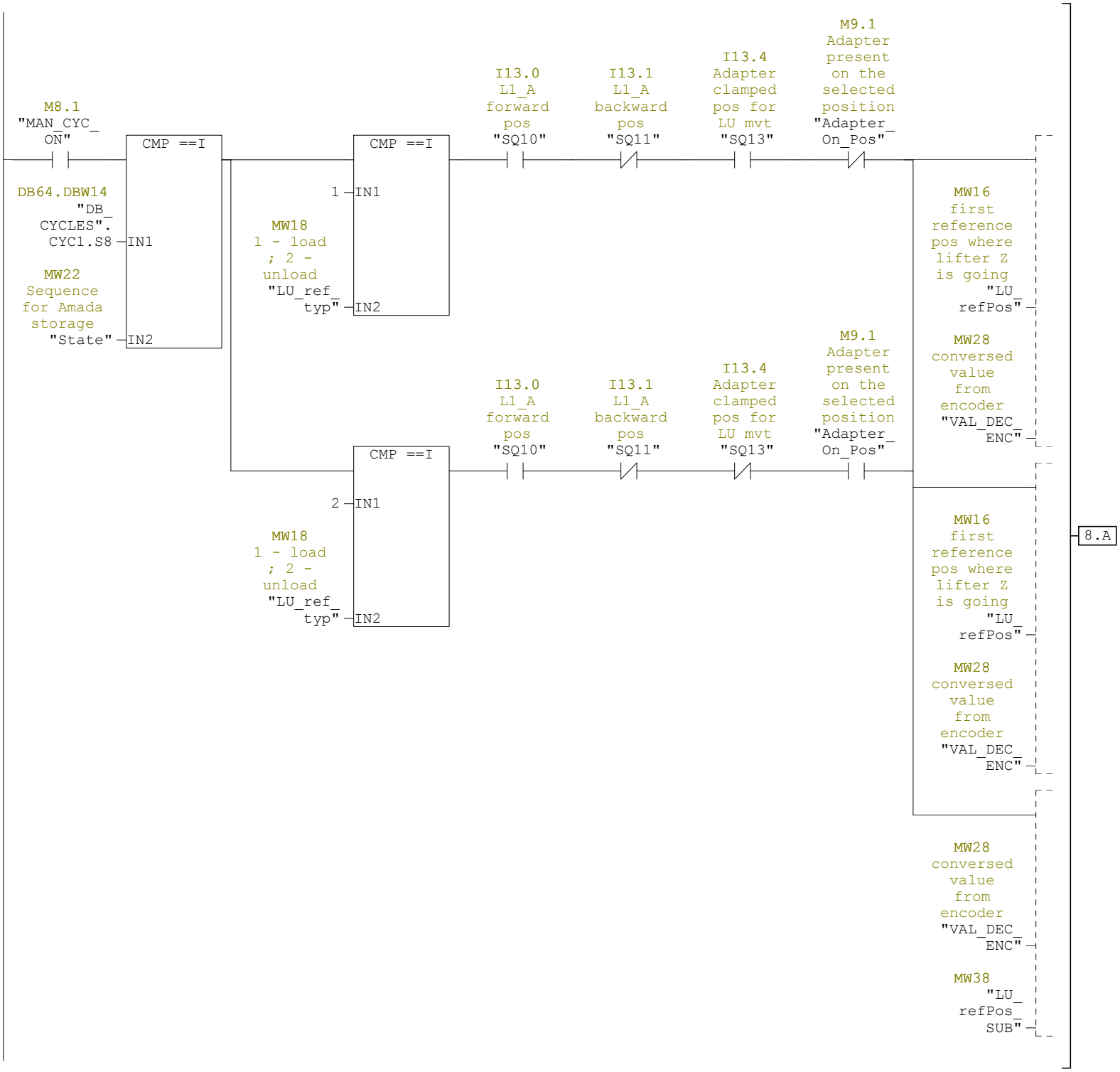
Network: 7

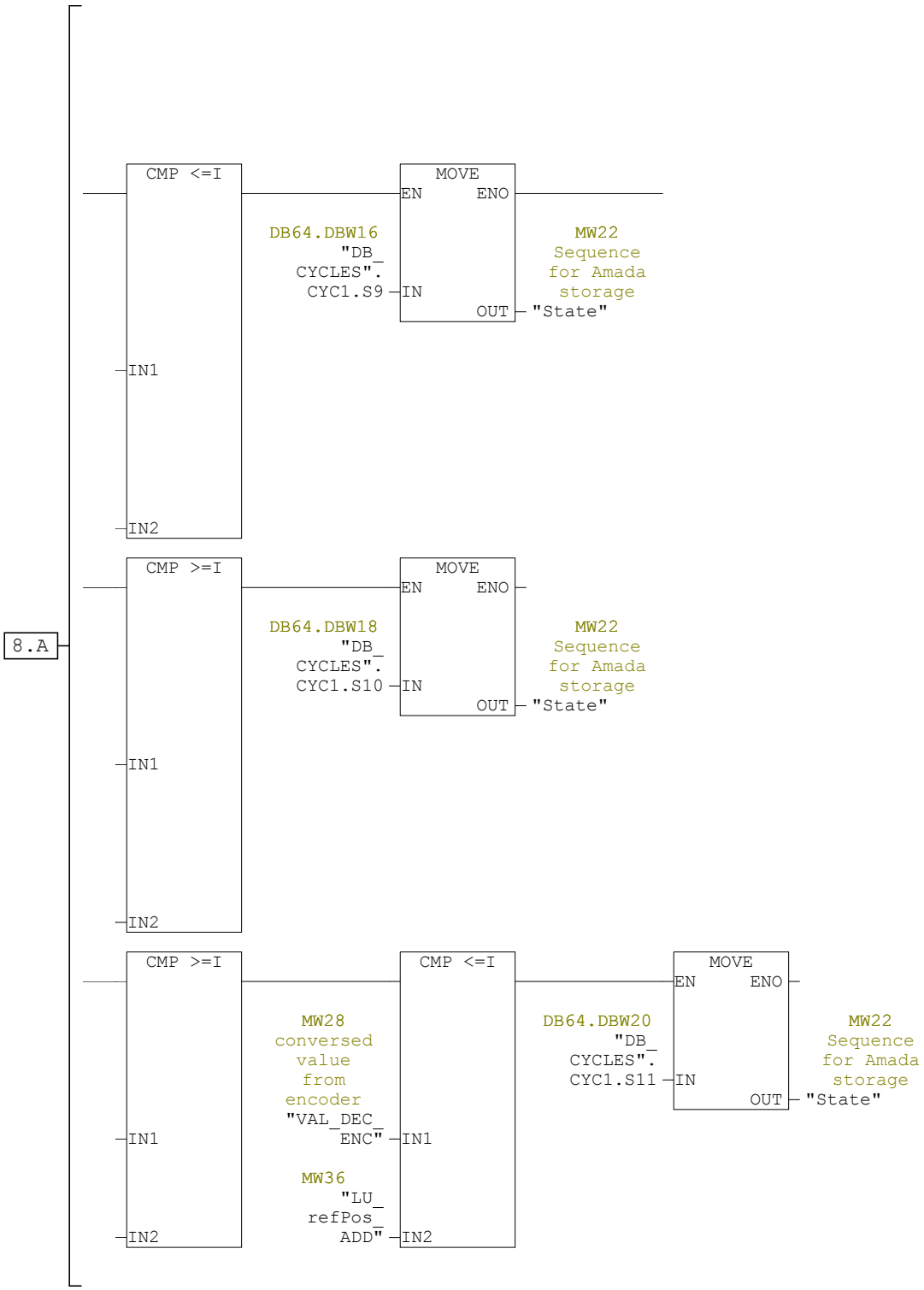

M8.1
"MAN_CYC_ON"
DB69.DBX18.2
"DB_HMI_INTERF".IN_OUT[3]
CMP ==I
DB64.DBW8
"DB_CYCLES".CYC1.S5
IN1
MW22
Sequence for Amada storage
"State"
IN2
CMP ==I
1
IN1
DB65.DBB1
"DB_RETAIN_AREA".LU.typ
IN2
MOVE
EN
ENO
2
IN
MW18
1 - load ; 2 - unload
"LU_ref_typ"
OUT
1
CMP ==I
2
IN1
DB65.DBB1
"DB_RETAIN_AREA".LU.typ
IN2
MOVE
EN
ENO
DB64.DBW14
"DB_CYCLES".CYC1.S8
IN
MW22
Sequence for Amada storage
"State"
OUT
7.A
DB69.DBX18.2
"DB_HMI_INTERF".IN_OUT[3]
MOVE
EN
ENO
DB64.DBW14
"DB_CYCLES".CYC1.S8
IN
MW22
Sequence for Amada storage
"State"
OUT


MOVE
EN
ENO
IN
OUT
MW20
operator
set
position
for load
unload
part
"HMI_LU_
pos"
DB125.DBW0
"DB_SYS_
CONST".
Pos_1.
AppPos
MOVE
EN
ENO
IN
OUT
MW16
first
reference
pos where
lifter Z
is going
"LU_
refPos"
DB64.DBW14
"DB_
CYCLES".
CYC1.S8
MOVE
EN
ENO
IN
OUT
MW22
Sequence
for Amada
storage
"State"
7.A

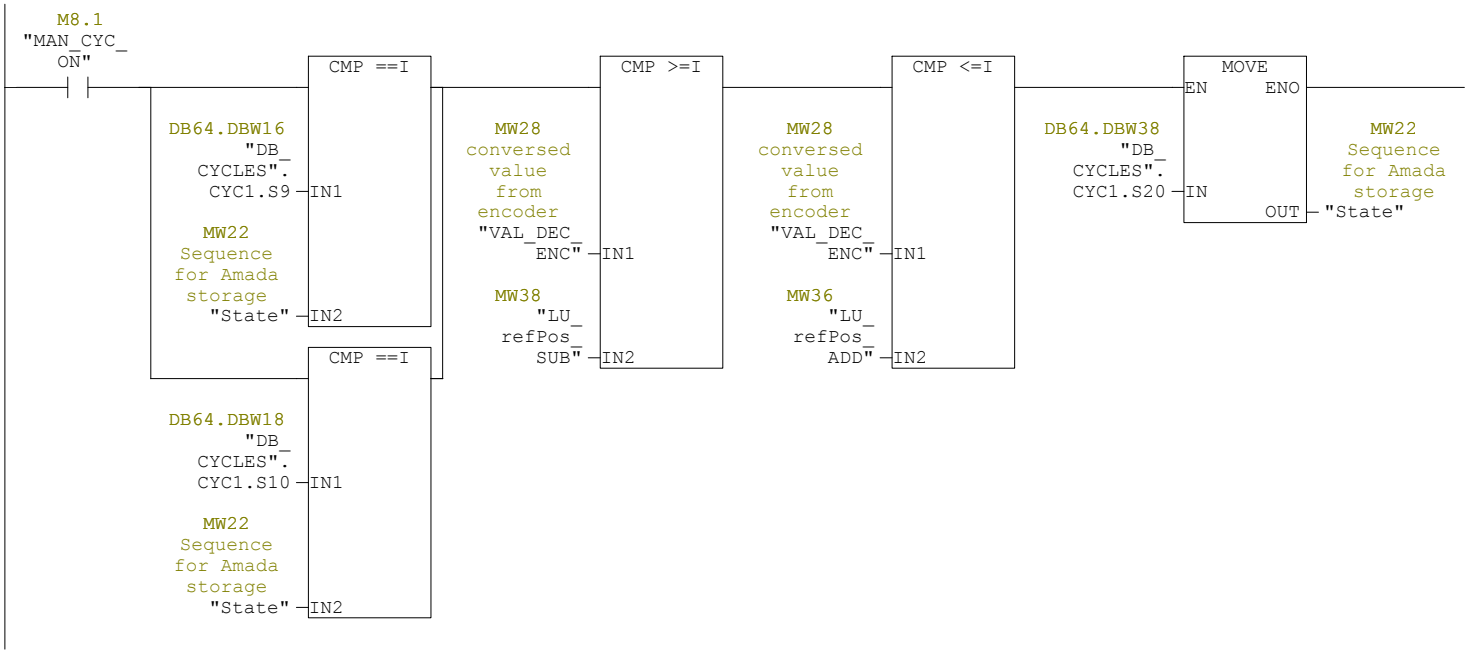
Network: 8 move Z to desired position

S4 - set bit for going up
S3 - set bit for going down
2 -

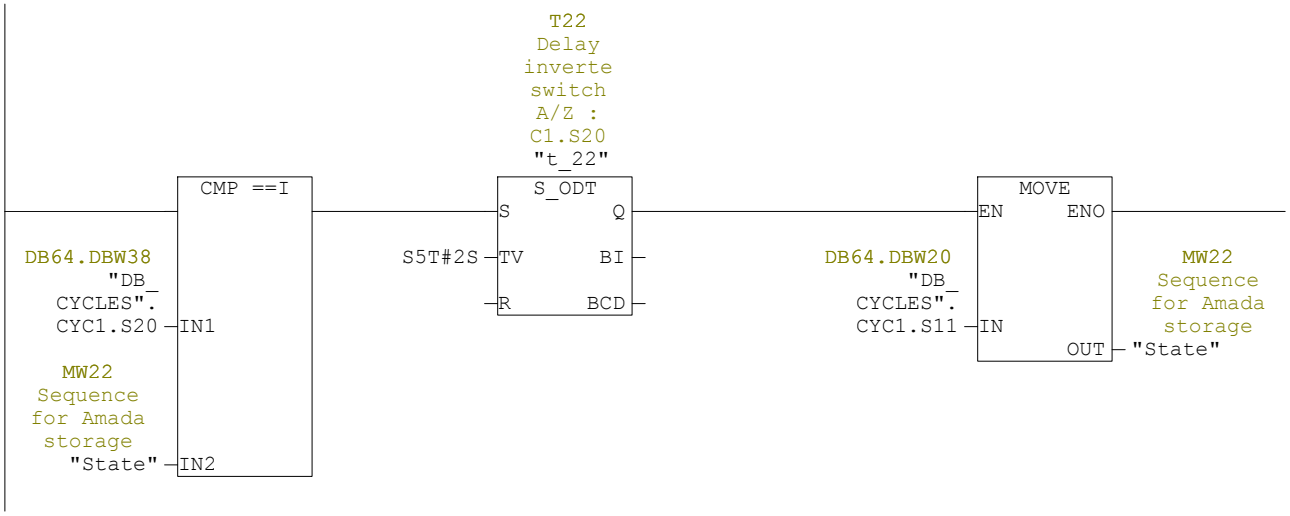



8.A
CMP <=I
IN1
IN2
MOVE
EN
ENO
DB64.DBW16
"DB_
CYCLES".
CYC1.S9
IN
OUT
MW22
Sequence
for Amada
storage
"State"
CMP >=I
IN1
IN2
MOVE
EN
ENO
DB64.DBW18
"DB_
CYCLES".
CYC1.S10
IN
OUT
MW22
Sequence
for Amada
storage
"State"
CMP >=I
IN1
IN2
MW28
conversed
value
from
encoder
"VAL_DEC_
ENC"
MW36
"LU_
refPos_
ADD"
CMP <=I
IN1
IN2
MOVE
EN
ENO
DB64.DBW20
"DB_
CYCLES".
CYC1.S11
IN
OUT
MW22
Sequence
for Amada
storage
"State"

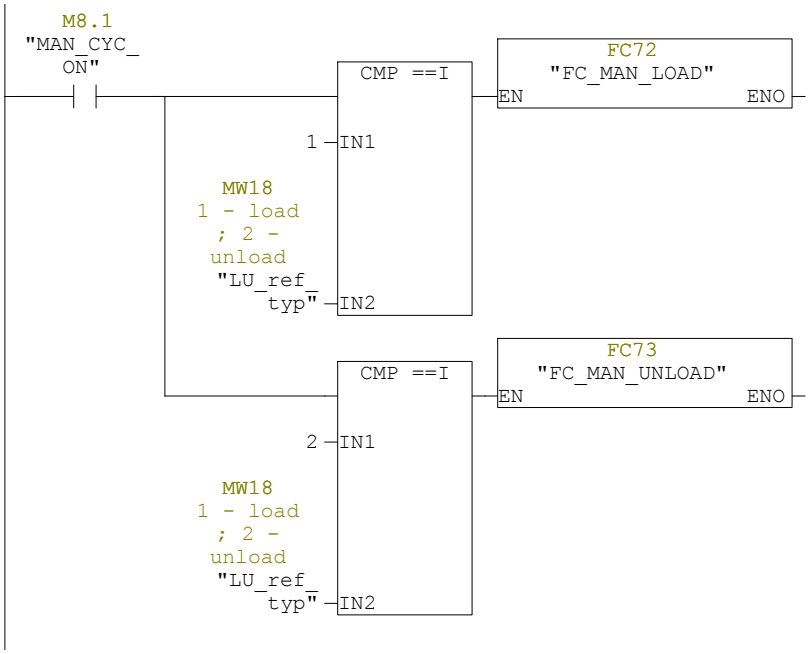
Network: 9 check Z position



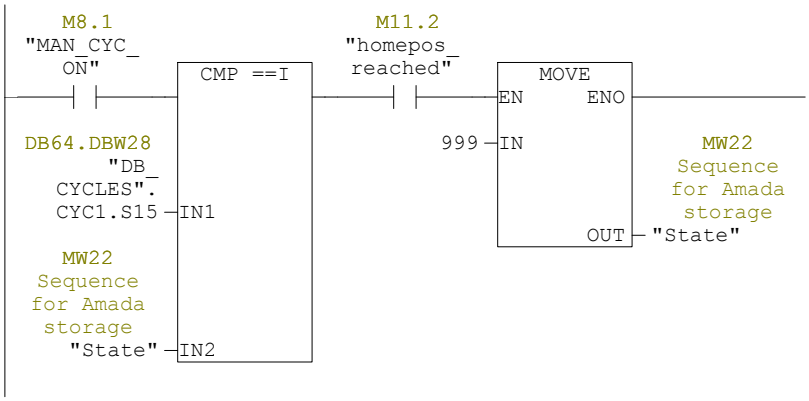
Network: 10 Delay inverte switch A/Z



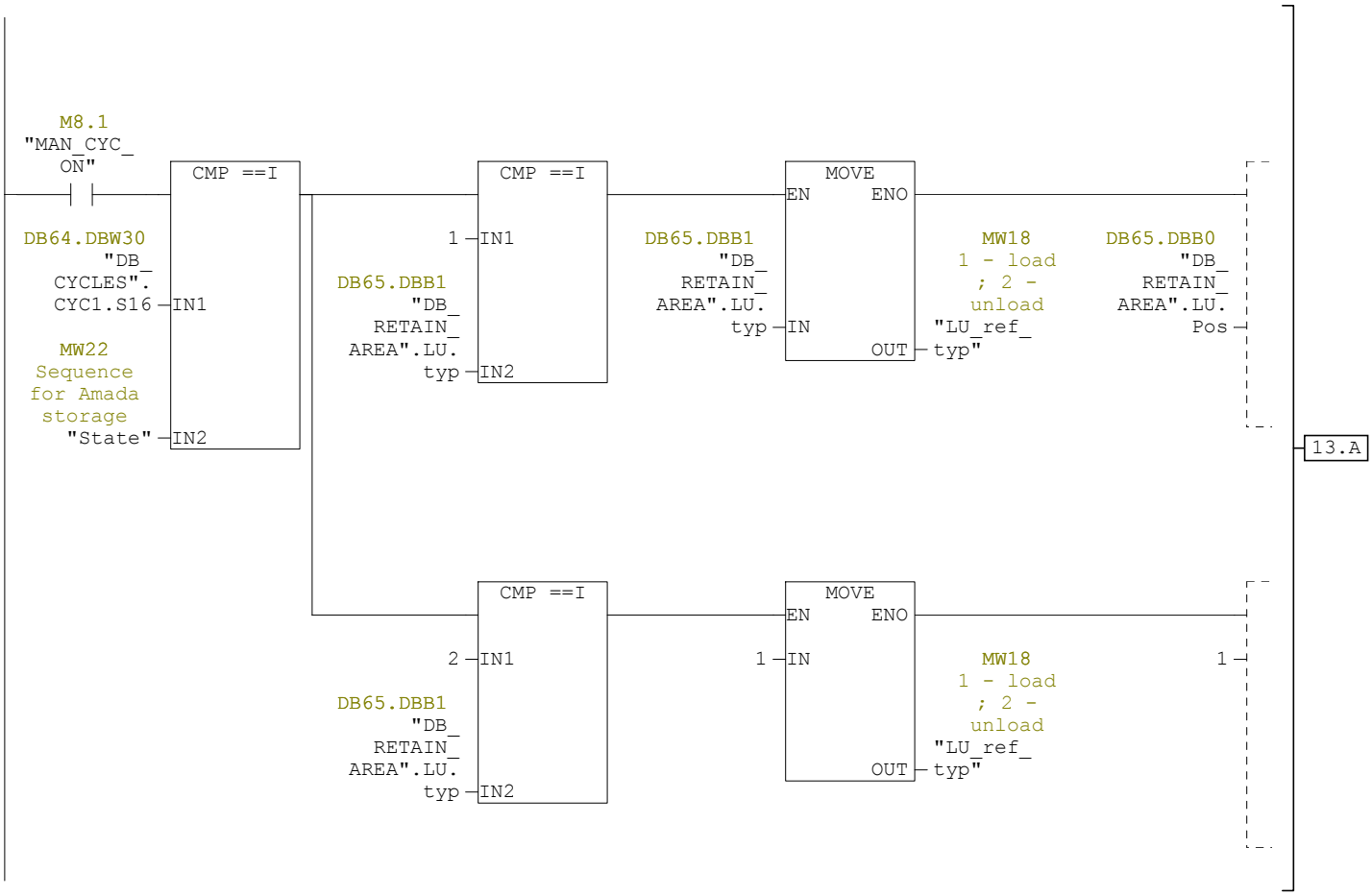
Network: 11

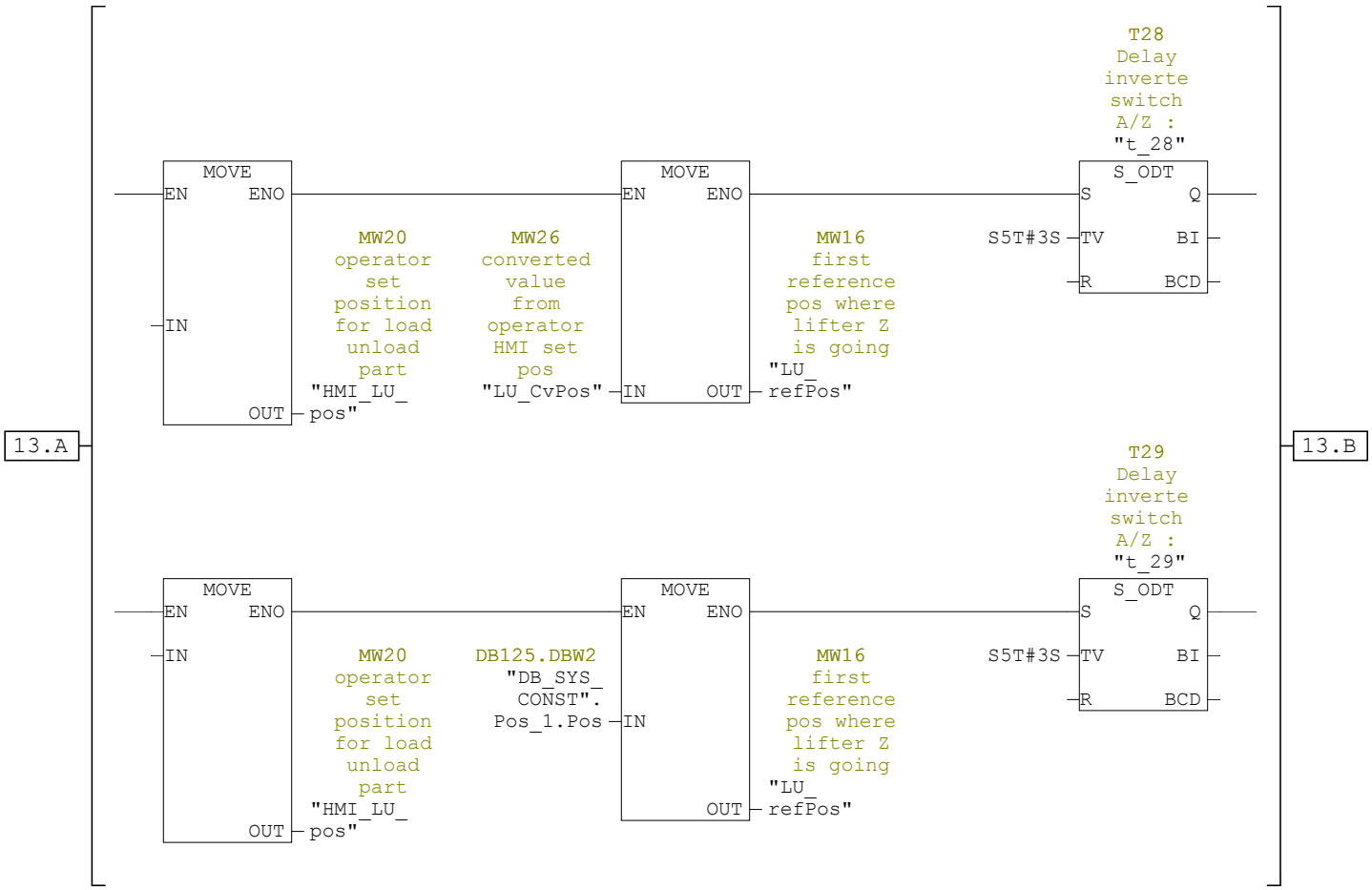


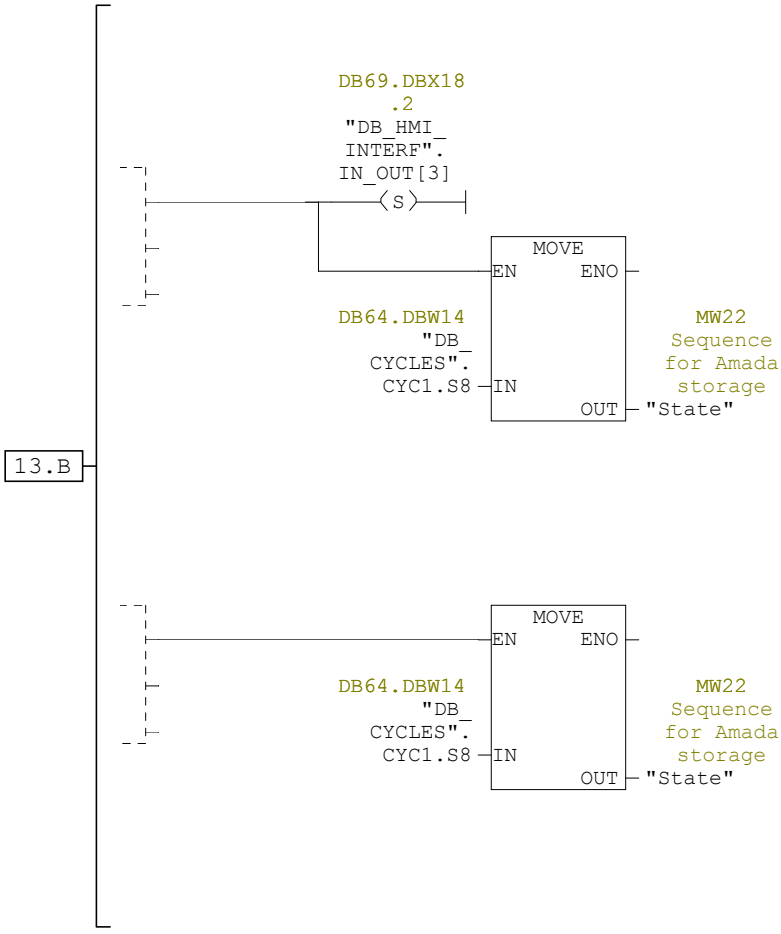
Network: 12



Network: 13 delay transfer adapter 1 mode




T28
Delay
inverte
switch
A/Z :
"t_28"
MOVE
EN
ENO
IN
OUT
pos"
MW20
operator
set
position
for load
unload
part
"HMI_LU_
MW26
converted
value
from
operator
HMI set
pos
"LU_CvPos"
MOVE
EN
ENO
IN
OUT
MW16
first
reference
pos where
lifter Z
is going
"LU_
refPos"
S_ODT
S
Q
S5T#3S
TV
BI
R
BCD
13.A
13.B
T29
Delay
inverte
switch
A/Z :
"t_29"
MOVE
EN
ENO
IN
OUT
pos"
MW20
operator
set
position
for load
unload
part
"HMI_LU_
DB125.DBW2
"DB_SYS_
CONST".
Pos_1.Pos
MOVE
EN
ENO
IN
OUT
MW16
first
reference
pos where
lifter Z
is going
"LU_
refPos"
S_ODT
S
Q
S5T#3S
TV
BI
R
BCD


DB69.DBX18
.2
"DB_HMI_
INTERF".
IN_OUT[3]
S
MOVE
EN
ENO
DB64.DBW14
"DB_
CYCLES".
CYC1.S8
IN
OUT
MW22
Sequence
for Amada
storage
"State"
13.B
MOVE
EN
ENO
DB64.DBW14
"DB_
CYCLES".
CYC1.S8
IN
OUT
MW22
Sequence
for Amada
storage
"State"

Network: 14 Manual cycle done