FC65 - <offline>

"FC_HMI"

Family: Name: Author: Version: 0.1

Block version: 2 11/08/2022 12:41:34 PM Time stamp Code:

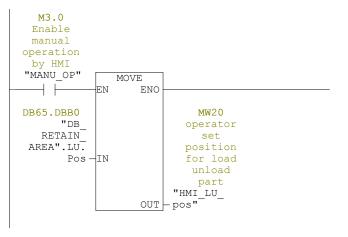
Interface: 09/29/2022 03:03:39 PM

Lengths (block/logic/data): 01286 01126 00002

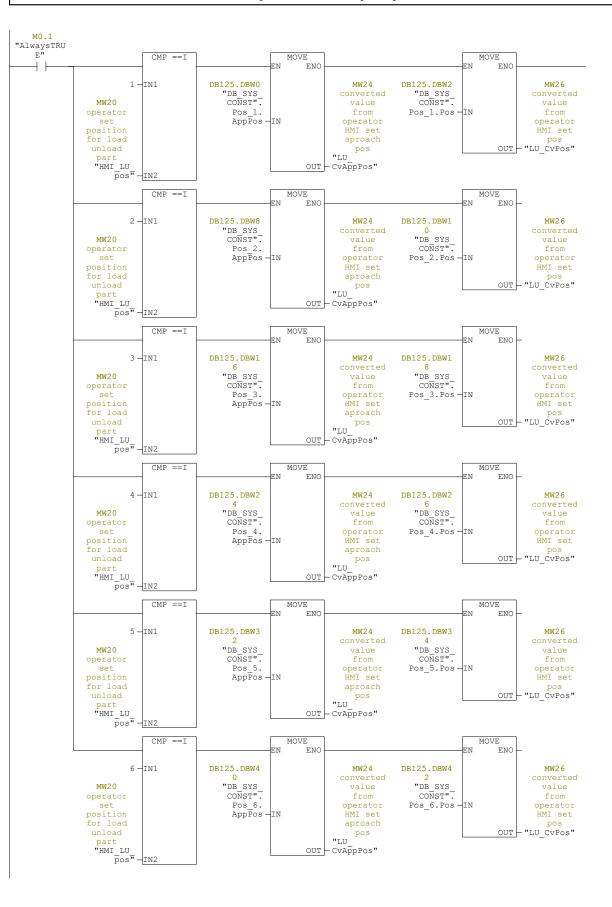
Name	Data Type	Address	Comment
IN		0.0	
OUT		0.0	
IN_OUT		0.0	
TEMP		0.0	
RETURN		0.0	
RET_VAL		0.0	

Block: FC65

Network: 1



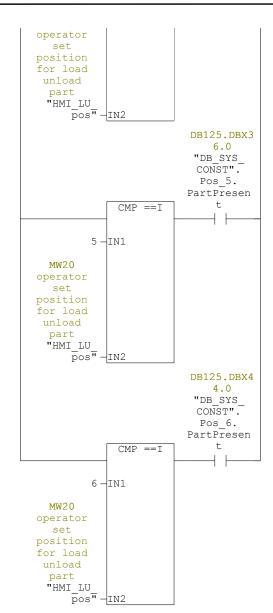
Network: 2 choose value for moving to desired adapter pos



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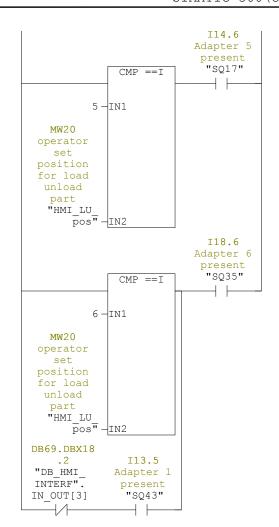
Network: 3 Part present on the selected adapter

```
M9.2
                                        DB125.DBX4
                                                         part
                                            .0
                                                       present
                                         "DB_SYS_
                                                        on the
                                         CONST".
                                                       selected
   M0.1
                                          Pos_1.
                                                       adapter
"AlwaysTRU
E"
                                                      "Part_On_
Adapter"
                                        PartPresen
                                            t
                            CMP ==I
                                                          <>>
                       1-IN1
                MW20
              operator
                 set
              position
               for load
               unload
                part
                "HMI LU
                    pos"-IN2
                                        DB125.DBX1
                                            2.0
                                         "DB_SYS_
                                         CONST".
                                          Pos 2.
                                        PartPresen
                                            t
                            CMP ==I
                       2 -IN1
                MW20
              operator
                 set
              position
               for load
               unload
                part
                "HMI LU
                    pos" -IN2
                                        DB125.DBX2
                                            0.0
                                         "DB_SYS_
                                         CONST".
                                          Pos_3.
                                        PartPresen
                                            t
                            CMP ==I
                       3 - IN1
                MW20
              operator
                 set
              position
               for load
               unload
                part
"HMI_LU_
                    pos" -IN2
                                        DB125.DBX2
                                            8.0
                                         "DB_SYS_
                                         CONST".
                                          Pos_4.
                                        PartPresen
                                            t
                            CMP ==I
                        4 -IN1
                MW20
```

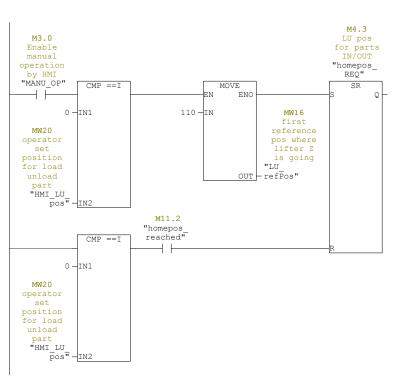


Network: 4 part present on the selected adapter

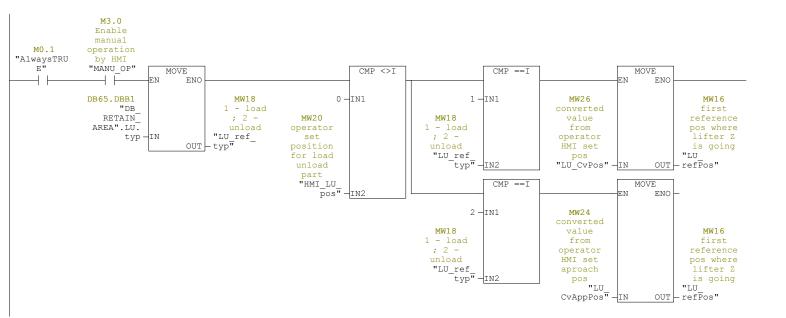
```
M9.1
                                                        Adapter
                                                        present
                                                         on the
                                            I13.5
                                                        selected
   M0.1
                                         Adapter 1
                                                        position
"AlwaysTRU
E"
                                                       "Adapter_
On_Pos"
                                           present
"SQ43"
                             CMP ==I
                                                           <>>
                        1-IN1
                 MW20
               operator
                 set
               position
               for load
                unload
                 part
                "HMI LU
                     pos"-IN2
                                            I13.6
                                          Adapter 2
                                           present
                                            "SQ14"
                             CMP ==I
                                             4 F
                        2 - IN1
                 MW20
               operator
                 set
               position
               for load
                unload
                 part
                "HMI_LU_
pos" -IN2
                                            I13.7
                                          Adapter 3
                                           present
"SQ15"
                             CMP ==I
                        3 -IN1
                 MW20
               operator
                 set
               position
               for load
                unload
                 part
                "HMI LU
                     pos"-IN2
                                            I14.5
                                         Adapter 4
                                           present
                                            "SQ16"
                             CMP ==I
                                             +
                        4 -IN1
                 MW20
               operator
                 set
               position
               for load
                unload
                 part
                 "HMI LU
                     pos" -IN2
```

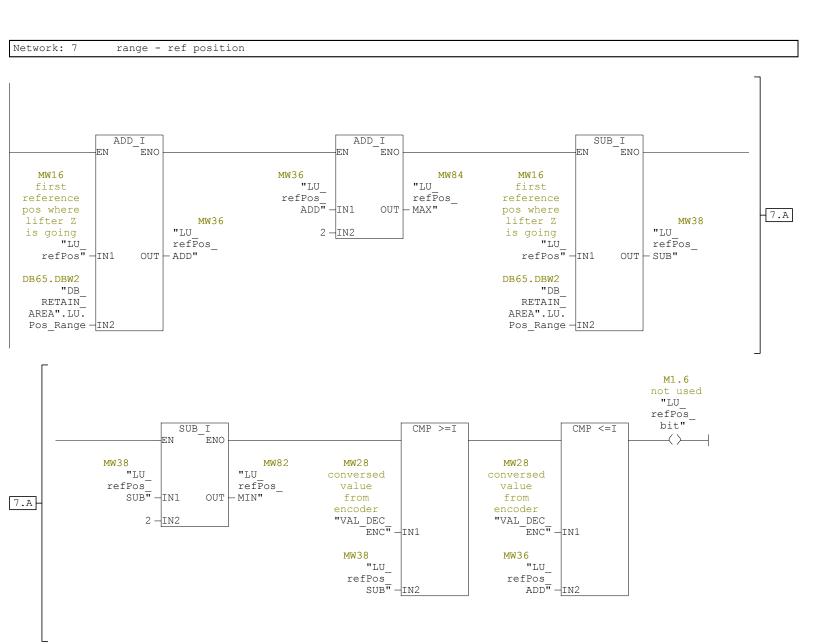


Network: 5 homepos value from HMI

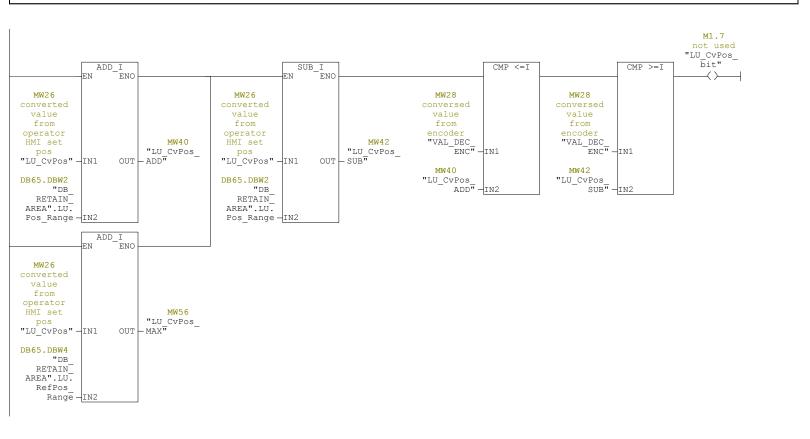


Network: 6 choose mode: load/unload first position going to

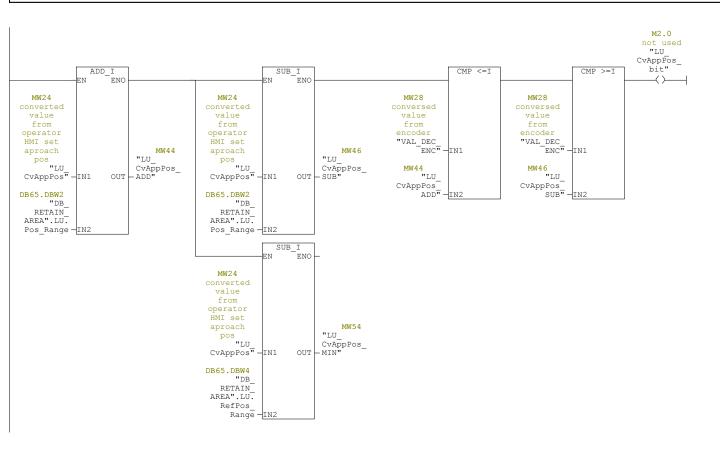




Network: 8 range - load position



Network: 9 range - unload position



```
Network: 10 axis reached set pos
```

```
M4.4
                                                           axis
                                                         reached
   M0.0
                                                         set pos
"AlwaysFAL
SE"
                                                        "reached_
                                                         pos_Z"
               CMP >=I
                                           CMP <=I
                                                           ~<u>`</u>—
   MW28
                               MW28
 conversed
                            conversed
   value
                              value
   from
                               from
  encoder
                              encoder
                              "VAL_DEC_
ENC" -IN1
  "VAL_DEC
       ENC"-IN1
   MW38 "LU_
                               MW36
    refPos_
SUB"-IN2
                                refPos_
ADD"-IN2
```

Network: 11 Operator not allowed to run manual cycle

```
M50.0
                                          Operator
                                            not
                                           allowed
                                           to run
                             M0.0
                                           manual
                          "AlwaysFAL
                                           cycle
                              SE"
                                          "PB OFF"
              CMP <>I
                                             \leftarrow \succ
 MW50
"HMI_CMD
      W1"-IN1
         0 -IN2
```

Network: 12

```
FC69
"FC_HMI_INTERF"
EN ENO
```