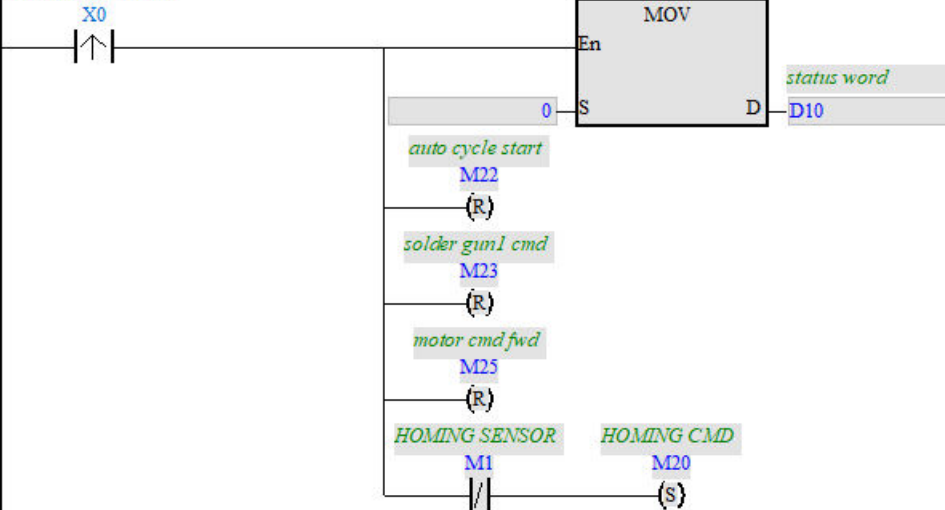


No.	Declaration Type	Identifiers	Address	Type	Initial Value	Identifier Comments
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Network 1

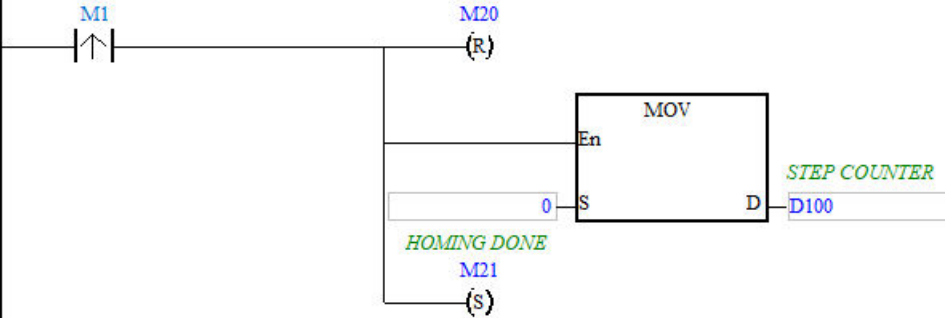
HOMING BUTTON



Network 2

HOMING SENSOR

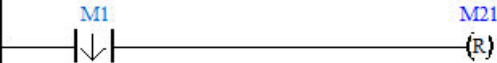
HOMING CMD



Network 3

HOMING SENSOR

HOMING DONE

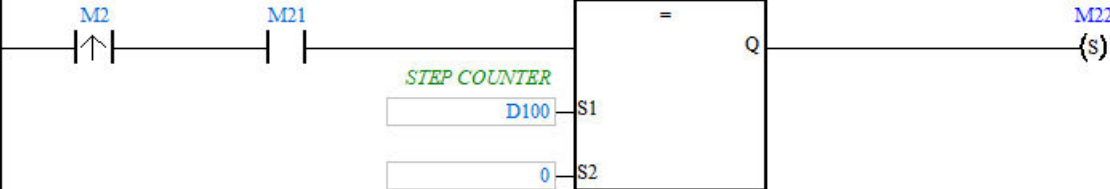


Network 4

START BUTTON

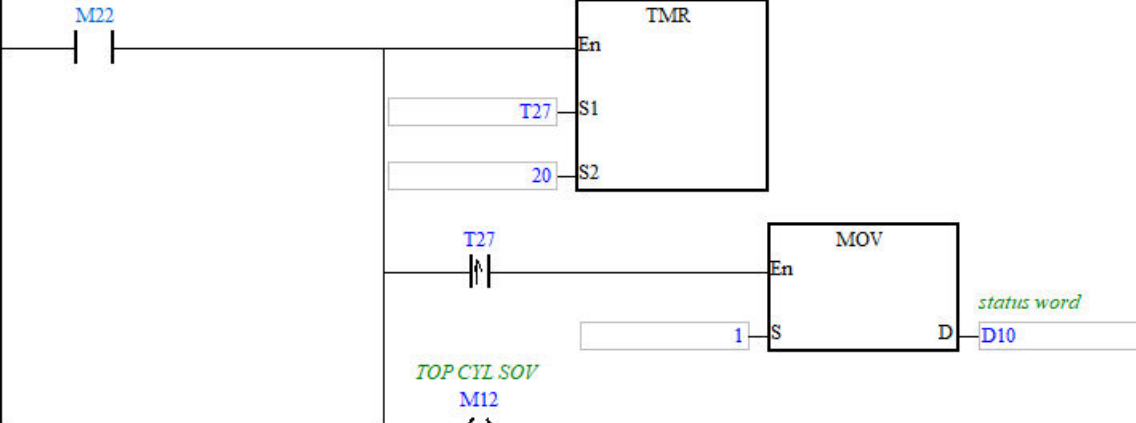
HOMING DONE

auto cycle start

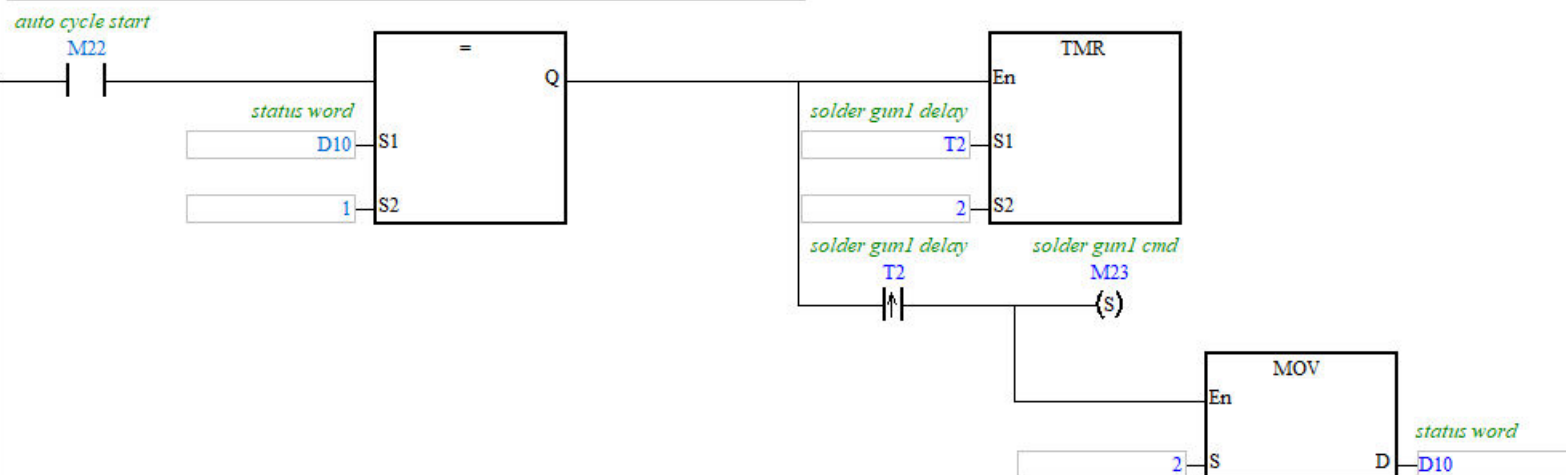


Network 5

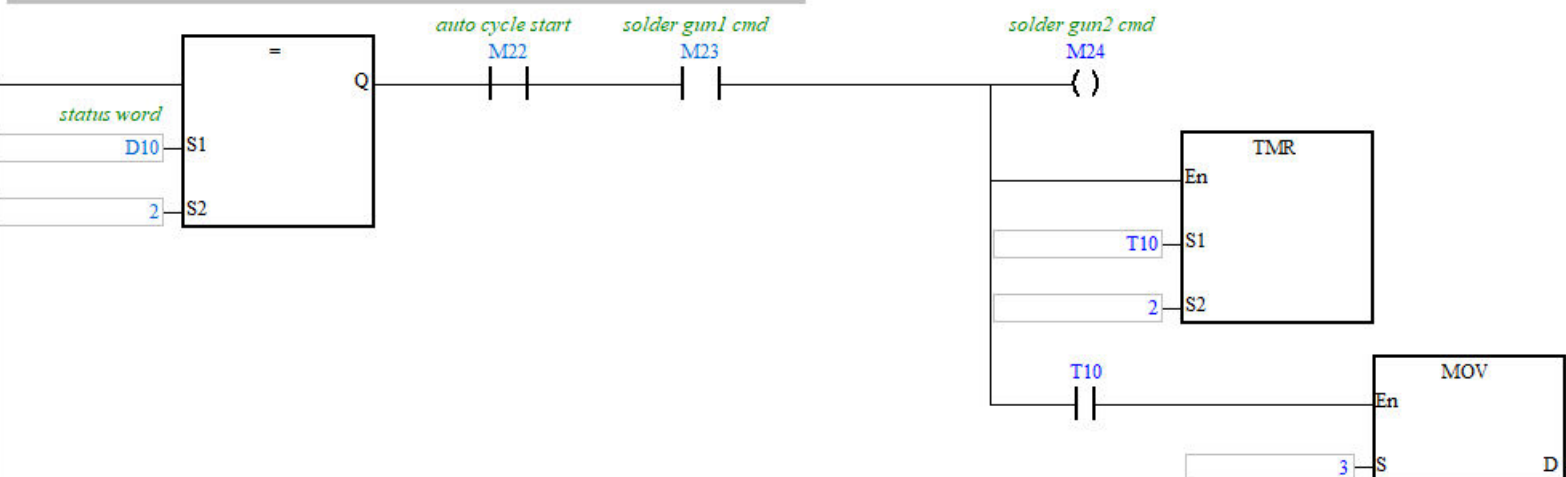
auto cycle start



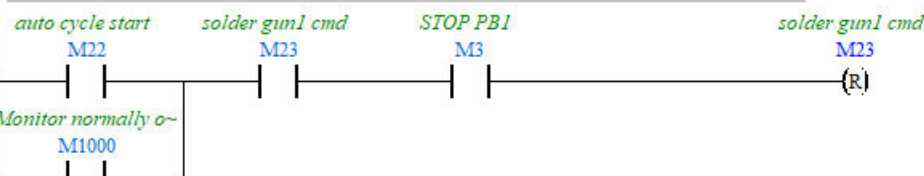
[-] Network 6



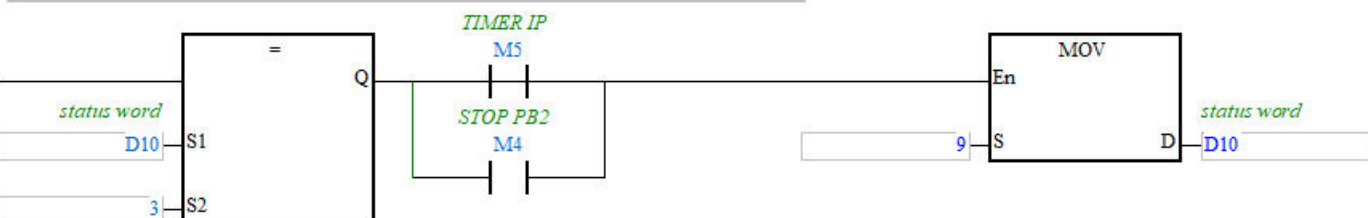
Network 7



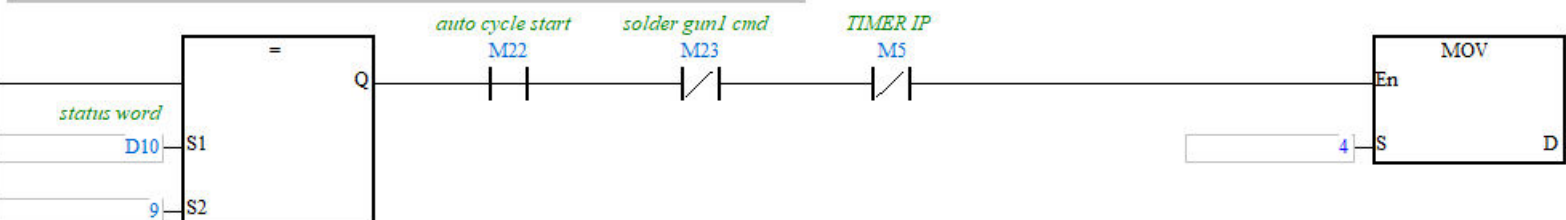
Network 8



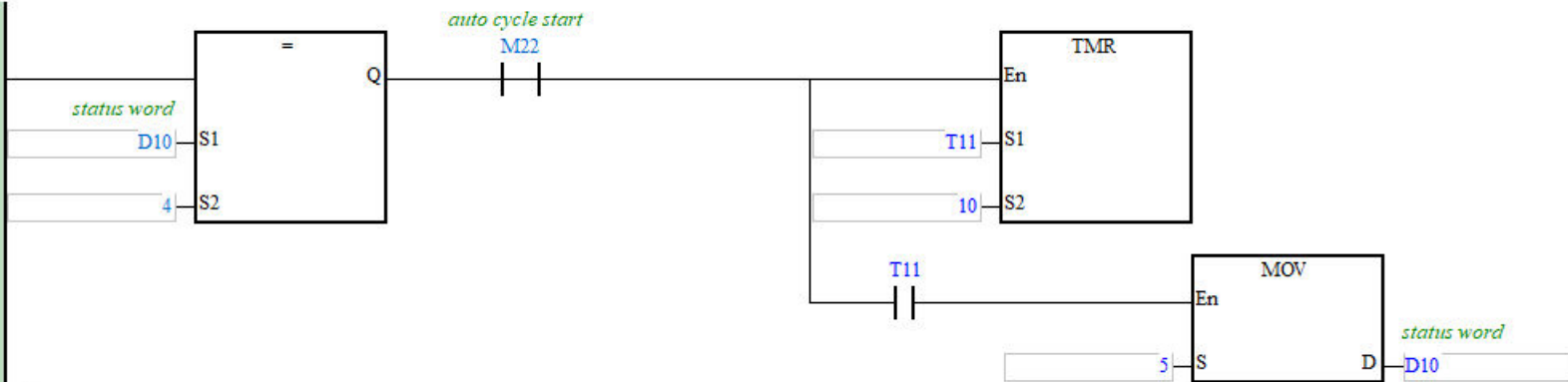
Network 9



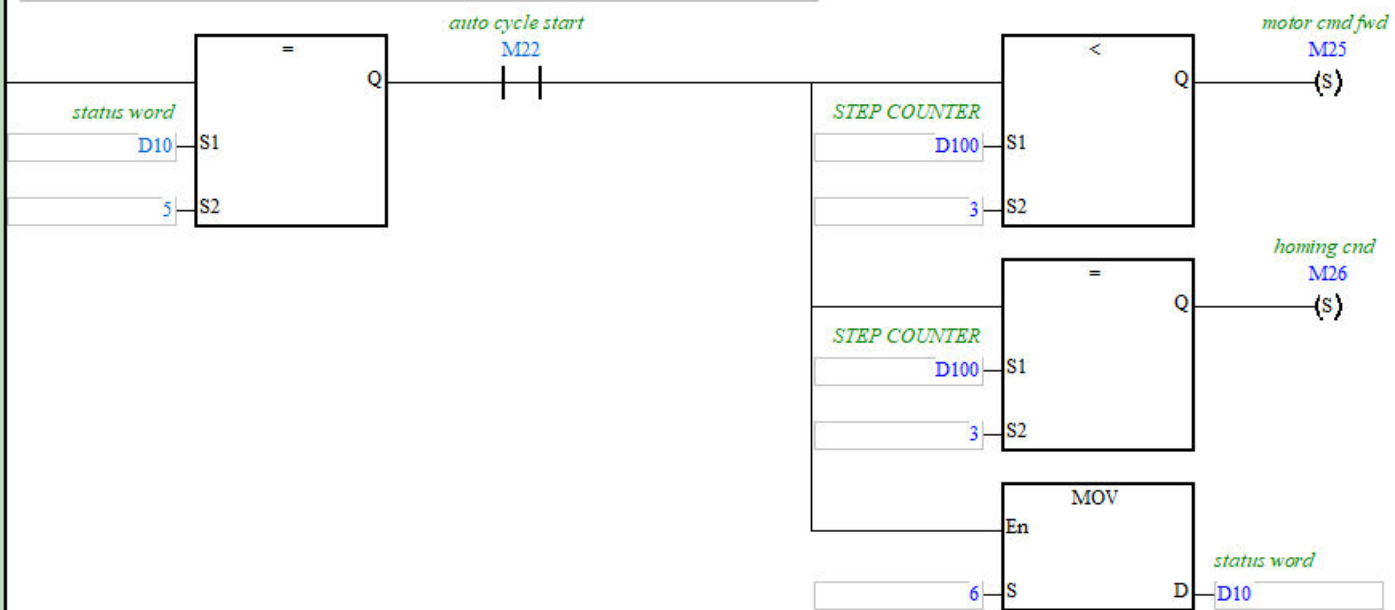
[-] Network 10



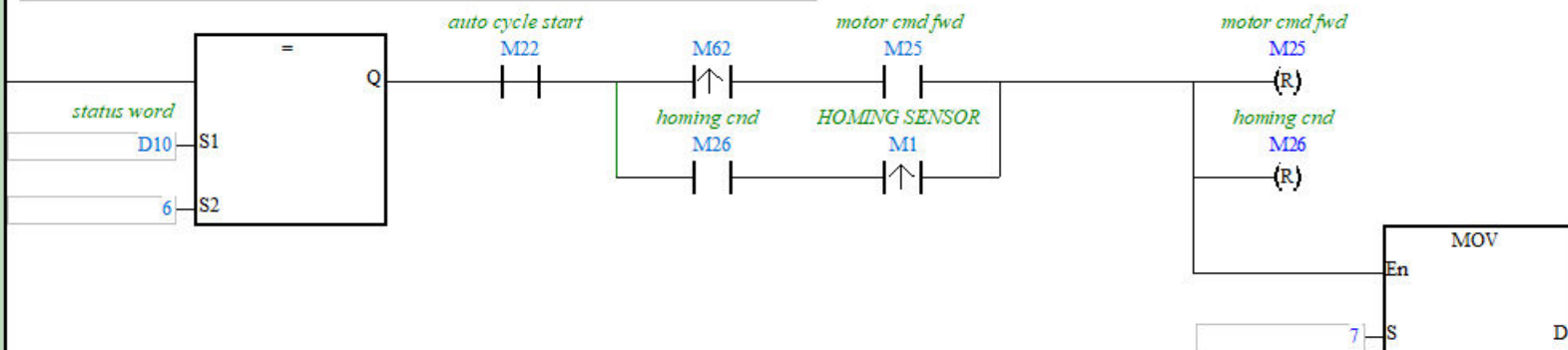
[-] Network 11



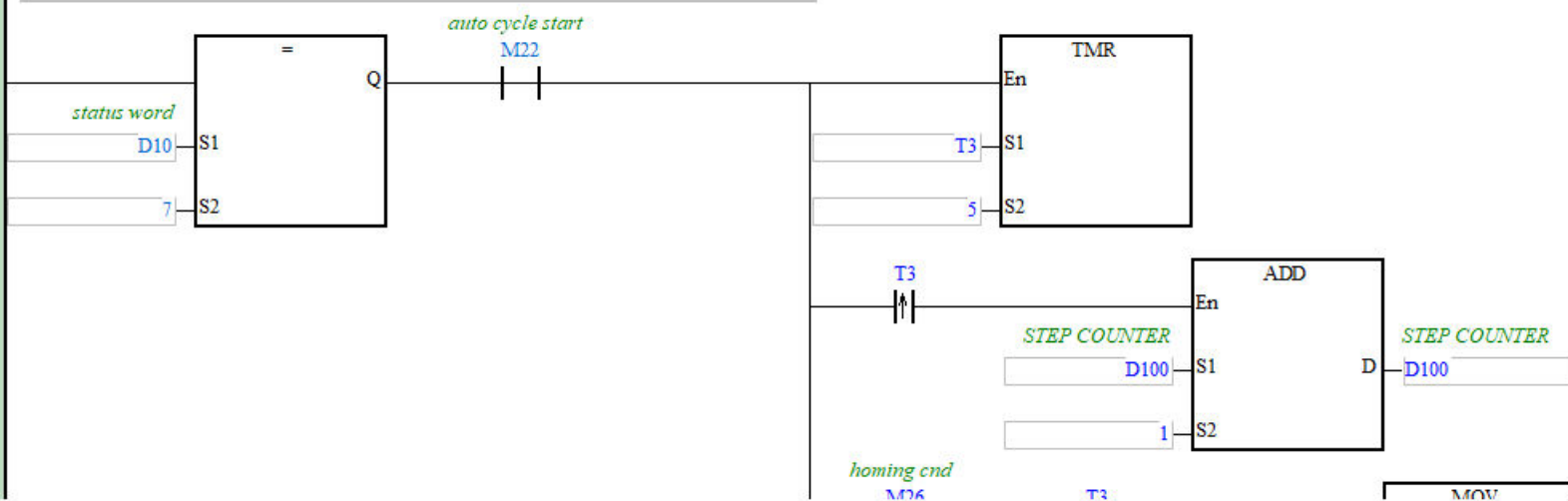
Network 12



Network 13



Network 14



MAIN

START

STOP

En

D

1

Network 15

auto cycle start

HOMING SENSOR

M22

M1

MOV

En

status word

status word

D10

S1

7

S2

0

S

D

D10

auto cycle start

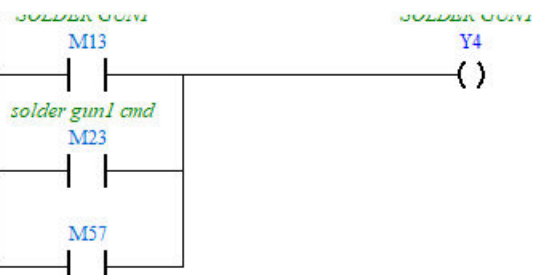
M22

(R)

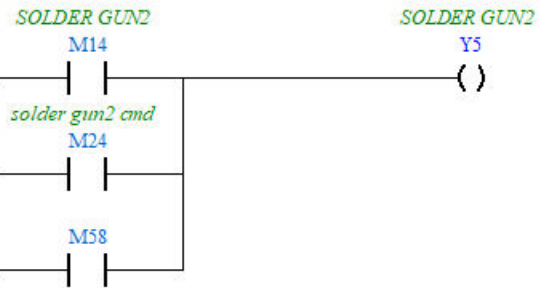
Q

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No.	Declaration Type	Identifiers	Address	Type	Initial Value	Identifier Comments
Network 1						
		<i>HOMING BUTTON</i>	<i>HOMING BUTTON</i>			
		X0	M0			
			()			
Network 2						
		<i>HOMING SENSOR</i>	<i>HOMING SENSOR</i>			
		X1	M1			
			()			
Network 3						
		<i>START BUTTON</i>	<i>START BUTTON</i>			
		X2	M2			
			()			
Network 4						
		<i>STOP PB1</i>	<i>STOP PB1</i>			
		X3	M3			
			()			
Network 5						
		<i>STOP PB2</i>	<i>STOP PB2</i>			
		X4	M4			
			()			
Network 6						
		<i>TIMER IP</i>	<i>TIMER IP</i>			
		X5	M5			
			()			
Network 7						
		<i>X6</i>	<i>end limit sen</i>			
		X6	M6			
			()			
Network 8						
		<i>X7</i>	<i>X7</i>			
		X7	M7			
			()			
Network 9						
		<i>STEPPER DIR</i>	<i>STEPPER DIR OP</i>			
		M10	Y1			
			()			
Network 10						
		<i>STEPPER EN</i>	<i>STEPPER EN OP</i>			
		M11	Y2			
			()			
Network 11						
		<i>TOP CYL SOV</i>	<i>TOP CYL SOV</i>			
		M12	Y3			
			()			
		M56				
Network 12						
		<i>SOLDER GEAR</i>	<i>SOLDER GEAR</i>			



Network 13



Network 14

