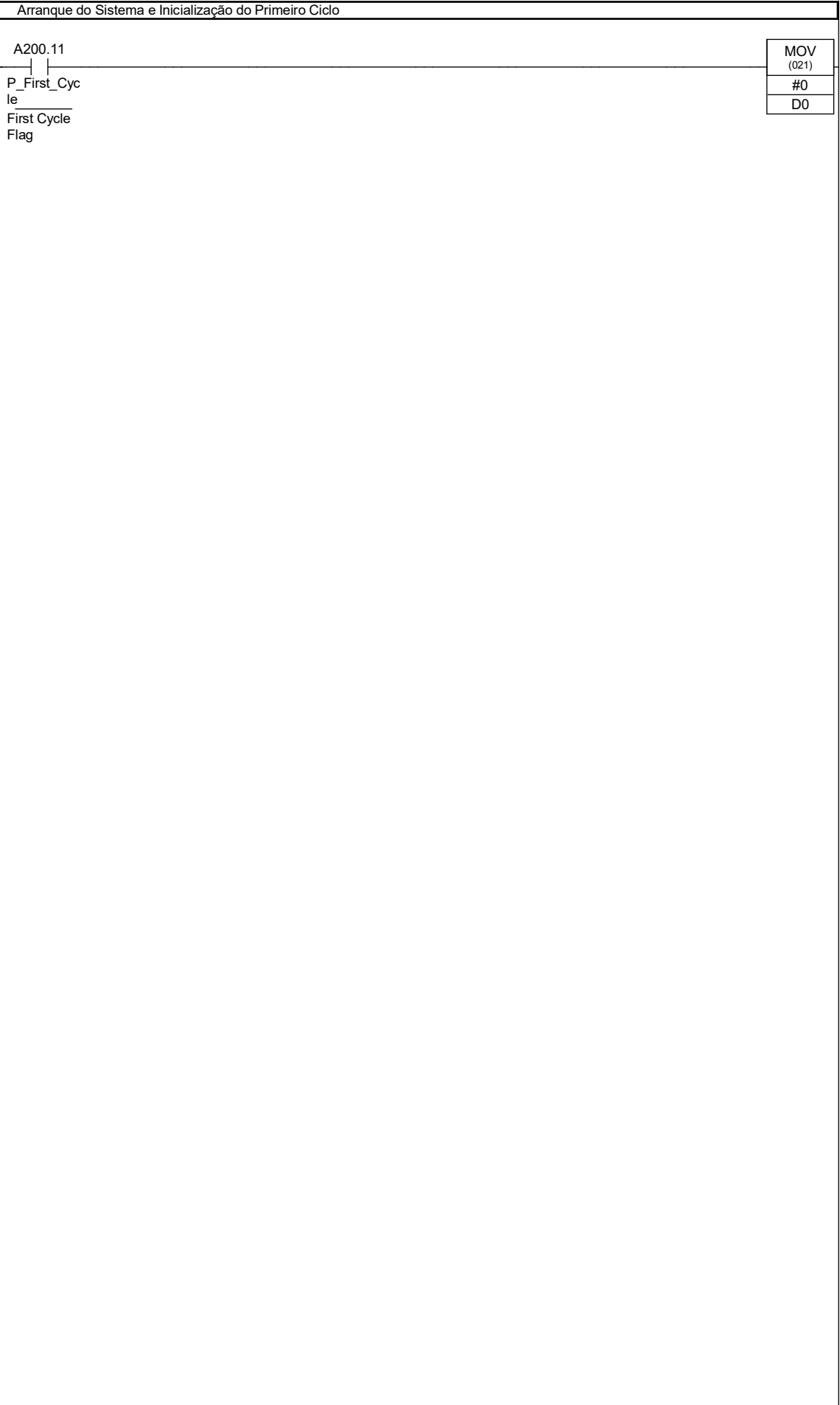


000000
(000000)



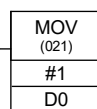
[OP1]

[OP2]
Controlo Modo Automatico

<cD00000>

c003 c011 c012
c019 c020 c022
c023 c026 c027
c029 c030 c033
c034 c036 c037
c045 c051 c052
c054 c055 c057
c058 c062 c064
c065 c067 c070
c071 c076 c077
c079 c117 c120
c130 c135 c136
c137 c138 c149
c150 c153 c156
c157 c158 c161
c162 c165 c166
c167 c168 c174
c175 c176 c177
c178 c179 c188
c189 c190 c191
c194 c197 c199
c200 c203 c205
c208 c210 c212
c214 c217 c221
c262 c280 c285
c290 c292 c294
c295 c297 c301
c302

Etapa 0: Aguardar Condições Iniciais

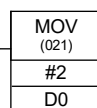


[OP2]
Controlo Modo
Automatico

[OP2]

c001 c003 c012
c019 c020 c022
c023 c026 c027
c029 c030 c033
c034 c036 c037
c045 c051 c052
c054 c055 c057
c058 c062 c064
c065 c067 c070
c071 c076 c077
c079 c117 c120
c130 c135 c136
c137 c138 c149
c150 c153 c156
c157 c158 c161
c162 c165 c166
c167 c168 c174
c175 c176 c177
c178 c179 c188
c189 c190 c191
c194 c197 c199
c200 c203 c205
c208 c210 c212
c214 c217 c221
c262 c280 c285
c290 c292 c294
c295 c297 c301
c302

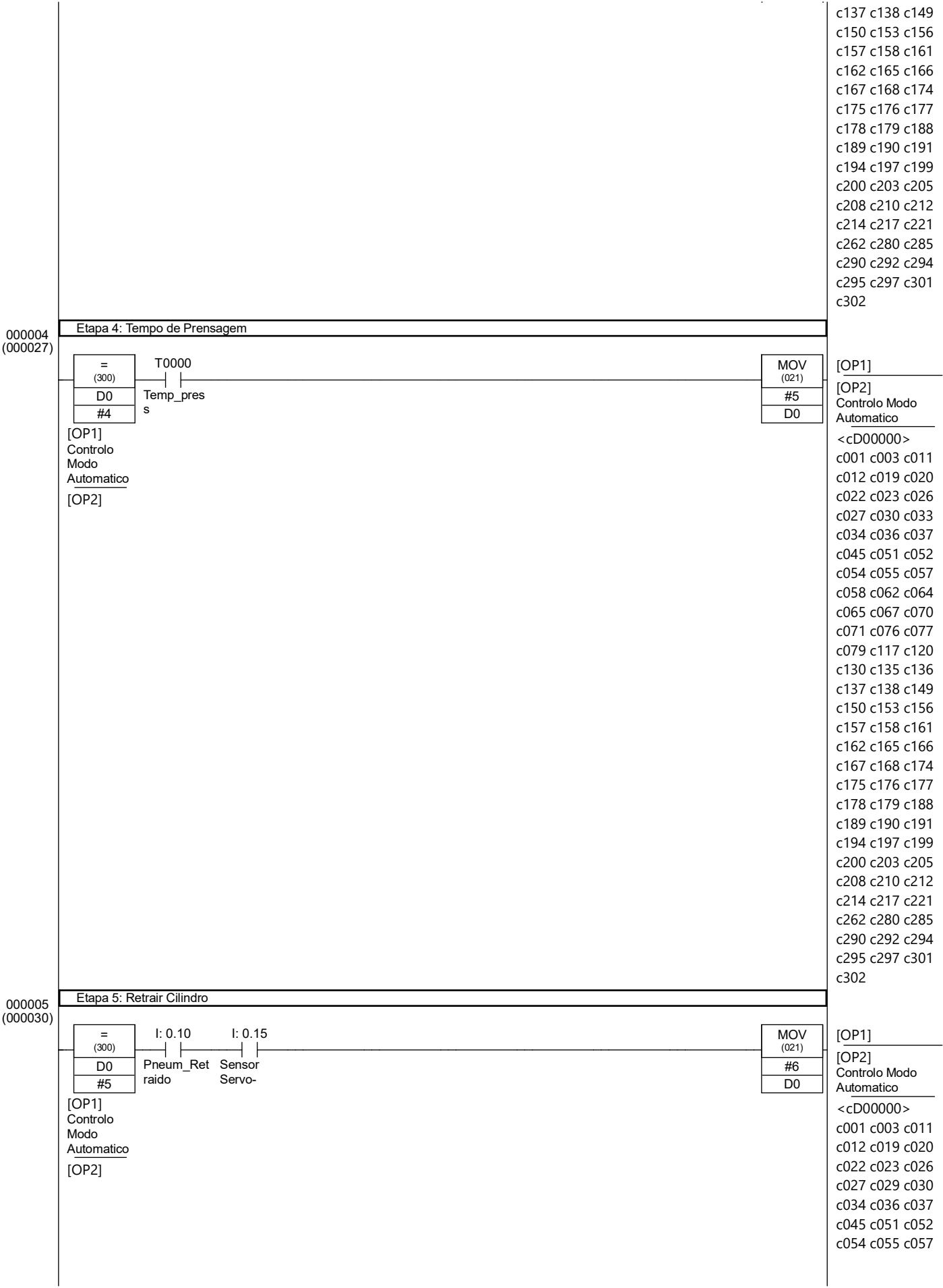
Etapas 1: Aguardar Robot



[OP2]
Controlo Modo
Automatico

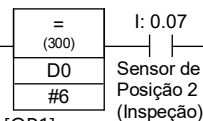
[OP2]

c001 c003 c011
c012 c020 c022
c023 c026 c027
c029 c030 c033
c034 c036 c037
c045 c051 c052
c054 c055 c057
c058 c062 c064
c065 c067 c070
c071 c076 c077
c079 c117 c120
c130 c135 c136
c137 c138 c149
c150 c153 c156
c157 c158 c161
c162 c165 c166
c167 c168 c174
c175 c176 c177
c178 c179 c188
c189 c190 c191
c194 c197 c199

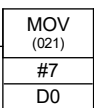


000006
(000034)

Etapa 6: Movimento para Posição 2 (Inspeção)



[OP1]
Controlo
Modo
Automatico
[OP2]

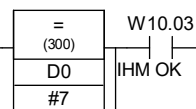


c058 c062 c064
c065 c067 c070
c071 c076 c077
c079 c117 c120
c130 c135 c136
c137 c138 c149
c150 c153 c156
c157 c158 c161
c162 c165 c166
c167 c168 c174
c175 c176 c177
c178 c179 c188
c189 c190 c191
c194 c197 c199
c200 c203 c205
c208 c210 c212
c214 c217 c221
c262 c280 c285
c290 c292 c294
c295 c297 c301
c302

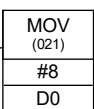
[OP1]
[OP2]
Controlo Modo
Automatico
<cD00000>
c001 c003 c011
c012 c019 c020
c022 c023 c026
c027 c029 c030
c033 c034 c037
c045 c051 c052
c054 c055 c057
c058 c062 c064
c065 c067 c070
c071 c076 c077
c079 c117 c120
c130 c135 c136
c137 c138 c149
c150 c153 c156
c157 c158 c161
c162 c165 c166
c167 c168 c174
c175 c176 c177
c178 c179 c188
c189 c190 c191
c194 c197 c199
c200 c203 c205
c208 c210 c212
c214 c217 c221
c262 c280 c285
c290 c292 c294
c295 c297 c301
c302

000007
(000037)

Etapa 7: Aguardar Resultado da Inspeção



[OP1]
Controlo
Modo
Automatico



[OP1]
[OP2]
Controlo Modo
Automatico
<cD00000>
c001 c003 c011
c012 c019 c020

[OP2]

T0002
Temp_Visã
o
Sinal
Inspeção
OK
I: 0.11
I: 0.12
Sinal
Inspeção
NOK

W10.02

MOV (021)
#9
D0

c022 c023 c026
c027 c029 c030
c033 c034 c036
c037 c051 c052
c054 c055 c057
c058 c062 c064
c065 c067 c070
c071 c076 c077
c079 c117 c120
c130 c135 c136
c137 c138 c149
c150 c153 c156
c157 c158 c161
c162 c165 c166
c167 c168 c174
c175 c176 c177
c178 c179 c188
c189 c190 c191
c194 c197 c199
c200 c203 c205
c208 c210 c212
c214 c217 c221
c262 c280 c285
c290 c292 c294
c295 c297 c301
c302

[OP1]

[OP2]

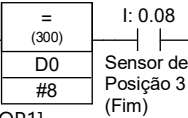
Controlo Modo
Automatico

<cD00000>

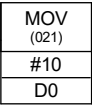
c001 c003 c011
c012 c019 c020
c022 c023 c026
c027 c029 c030
c033 c034 c036
c037 c045 c052
c054 c055 c057
c058 c062 c064
c065 c067 c070
c071 c076 c077
c079 c117 c120
c130 c135 c136
c137 c138 c149
c150 c153 c156
c157 c158 c161
c162 c165 c166
c167 c168 c174
c175 c176 c177
c178 c179 c188
c189 c190 c191
c194 c197 c199
c200 c203 c205
c208 c210 c212
c214 c217 c221
c262 c280 c285
c290 c292 c294
c295 c297 c301
c302

000008
(000052)

Etapa 8: Peça OK - Movimento para Posição 3



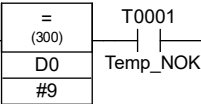
[OP1]
Controlo
Modo
Automatico
[OP2]



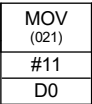
[OP1]
[OP2]
Controlo Modo Automatico
<cD00000>
c001 c003 c011
c012 c019 c020
c022 c023 c026
c027 c029 c030
c033 c034 c036
c037 c045 c051
c052 c055 c057
c058 c062 c064
c065 c067 c070
c071 c076 c077
c079 c117 c120
c130 c135 c136
c137 c138 c149
c150 c153 c156
c157 c158 c161
c162 c165 c166
c167 c168 c174
c175 c176 c177
c178 c179 c188
c189 c190 c191
c194 c197 c199
c200 c203 c205
c208 c210 c212
c214 c217 c221
c262 c280 c285
c290 c292 c294
c295 c297 c301
c302

000009
(000055)

Etapa 9: Peça NOK - Movimento para Posição Final



[OP1]
Controlo
Modo
Automatico
[OP2]



[OP1]
[OP2]
Controlo Modo Automatico
<cD00000>
c001 c003 c011
c012 c019 c020
c022 c023 c026
c027 c029 c030
c033 c034 c036
c037 c045 c051
c052 c054 c055
c058 c062 c064
c065 c067 c070
c071 c076 c077
c079 c117 c120
c130 c135 c136
c137 c138 c149
c150 c153 c156
c157 c158 c161
c162 c165 c166
c167 c168 c174
c175 c176 c177
c178 c179 c188
c189 c190 c191
c194 c197 c199
c200 c203 c205

000010
(000058)

Etapa 10: Pausa na Posição 3 (Peça OK)

=
(300)
D0
#10

[OP1]
Controlo
Modo
Automatico
[OP2]

I: 0.13

Confirmação
o Remoção
de Peça

MOV
(021)
#12
D0

[OP1]

[OP2]

Controlo Modo
Automatico

<cD00000>

c001 c003 c011
c012 c019 c020
c022 c023 c026
c027 c029 c030
c033 c034 c036
c037 c045 c051
c052 c054 c055
c057 c058 c064
c065 c067 c070
c071 c076 c077
c079 c117 c120
c130 c135 c136
c137 c138 c149
c150 c153 c156
c157 c158 c161
c162 c165 c166
c167 c168 c174
c175 c176 c177
c178 c179 c188
c189 c190 c191
c194 c197 c199
c200 c203 c205
c208 c210 c212
c214 c217 c221
c262 c280 c285
c290 c292 c294
c295 c297 c301
c302

W10.04

Robot 2
Fim

000011
(000063)

Etapa 11: Retorno à Posição Inicial

W0.13
Stop Ciclo

=
(300)
D0
#11

[OP1]
Controlo
Modo
Automatico
[OP2]

MOV
(021)
#1
D0

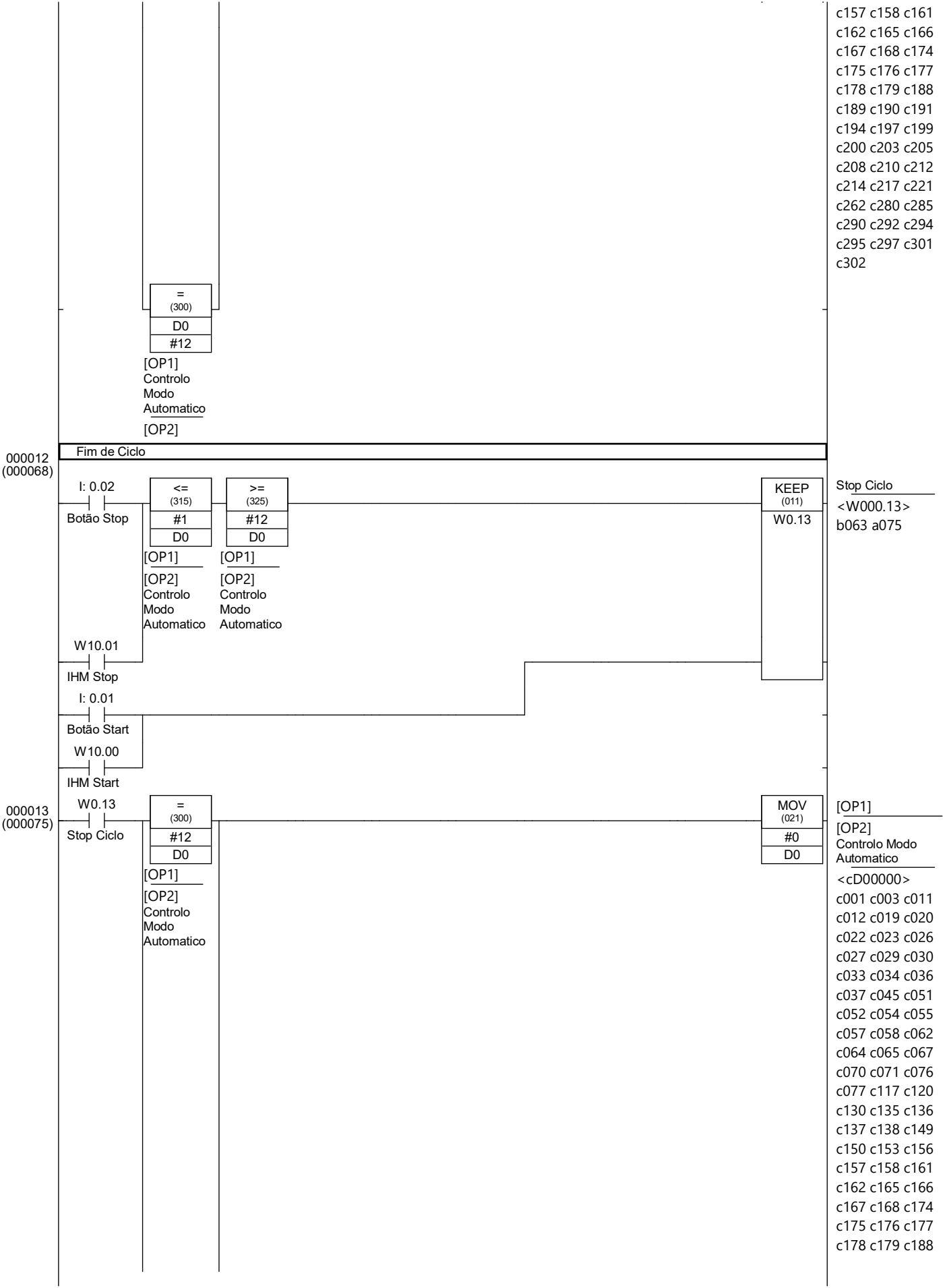
[OP1]

[OP2]

Controlo Modo
Automatico

<cD00000>

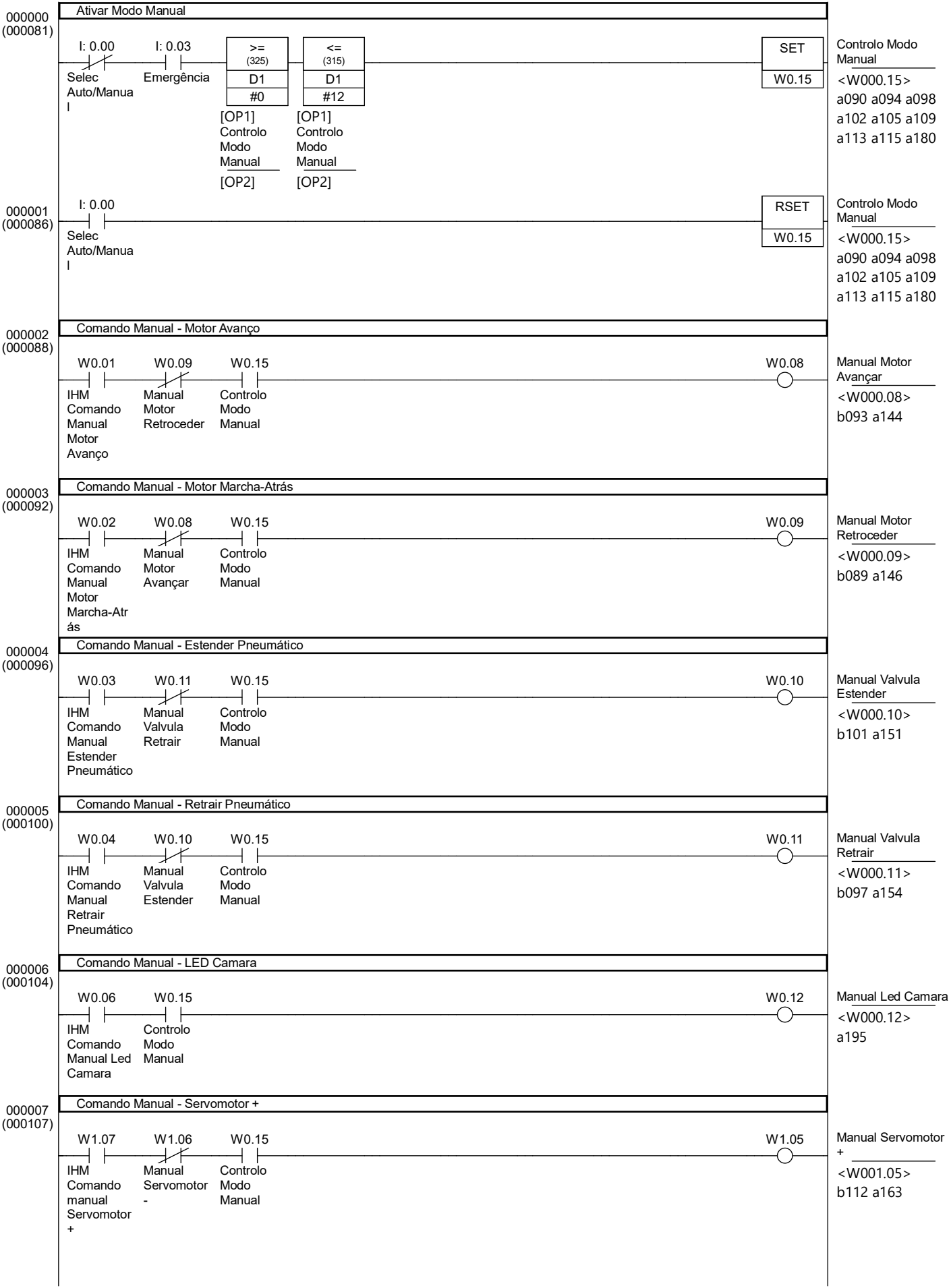
c001 c003 c011
c012 c019 c020
c022 c023 c026
c027 c029 c030
c033 c034 c036
c037 c045 c051
c052 c054 c055
c057 c058 c062
c064 c065 c070
c071 c076 c077
c079 c117 c120
c130 c135 c136
c137 c138 c149
c150 c153 c156

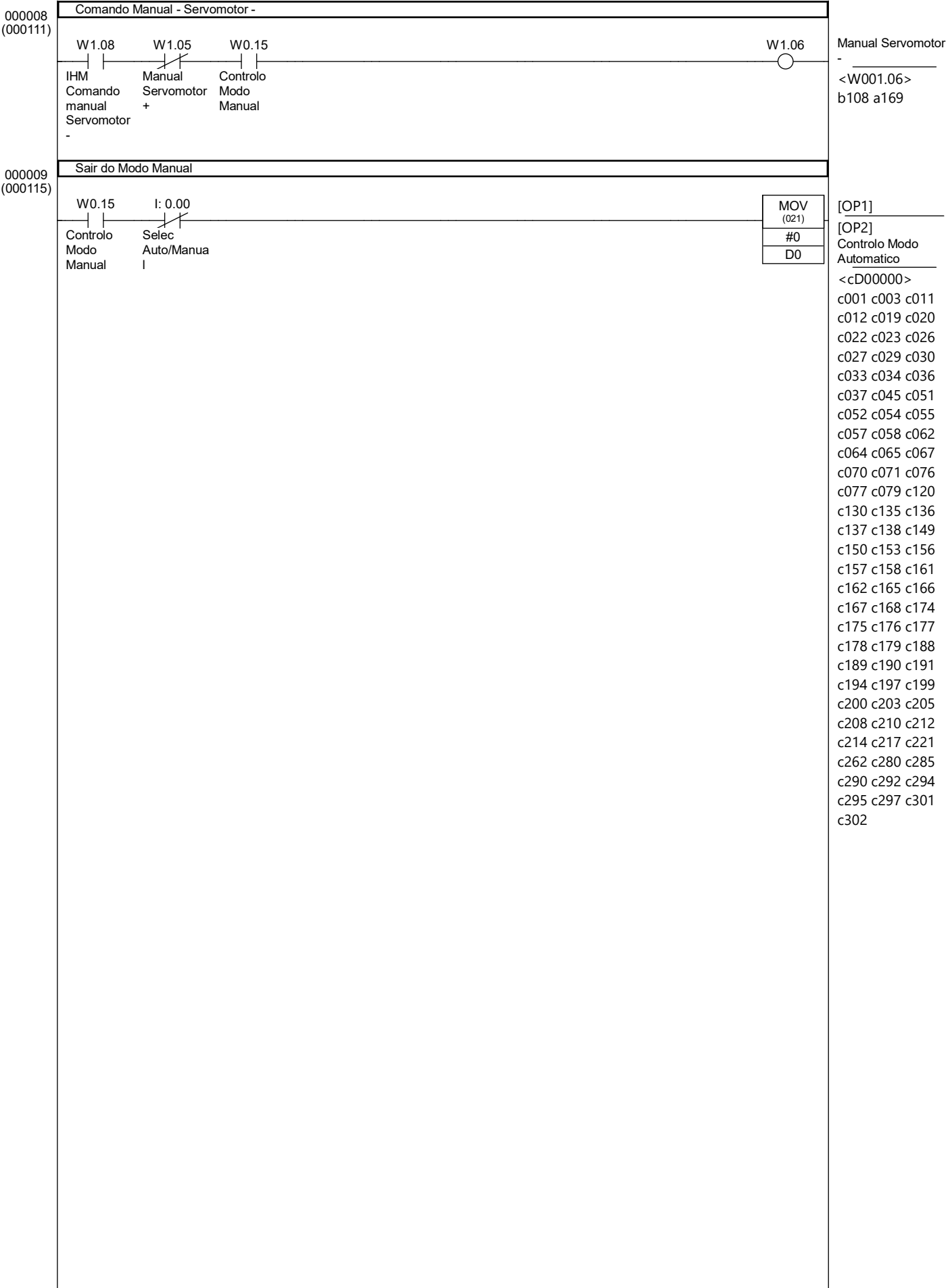


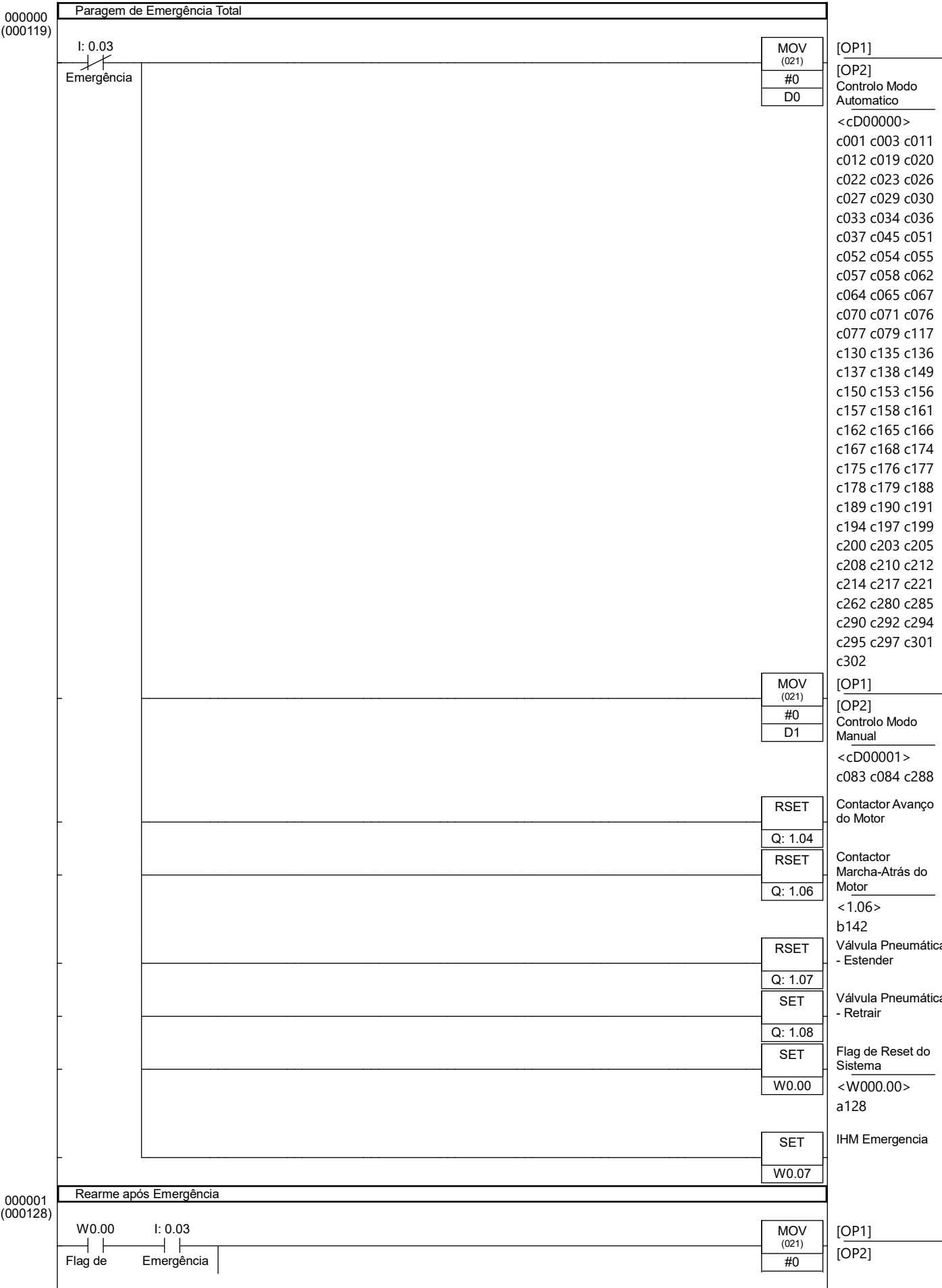


[OP1]
[OP2]
Controlo
Modo
Automatico

c189 c190 c191
c194 c197 c199
c200 c203 c205
c208 c210 c212
c214 c217 c221
c262 c280 c285
c290 c292 c294
c295 c297 c301
c302







Reset do Sistema

D0

Controlo Modo Automatico

<cD00000>
c001 c003 c011
c012 c019 c020
c022 c023 c026
c027 c029 c030
c033 c034 c036
c037 c045 c051
c052 c054 c055
c057 c058 c062
c064 c065 c067
c070 c071 c076
c077 c079 c117
c120 c135 c136
c137 c138 c149
c150 c153 c156
c157 c158 c161
c162 c165 c166
c167 c168 c174
c175 c176 c177
c178 c179 c188
c189 c190 c191
c194 c197 c199
c200 c203 c205
c208 c210 c212
c214 c217 c221
c262 c280 c285
c290 c292 c294
c295 c297 c301
c302

RSET

Flag de Reset do Sistema

W0.00

<W000.00>
a128

RSET

Válvula Pneumática
- Retrain

Q: 1.08

RSET

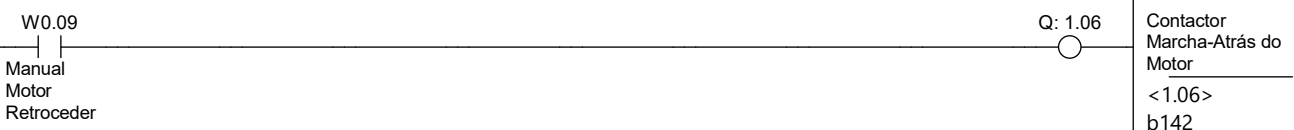
IHM Emergencia

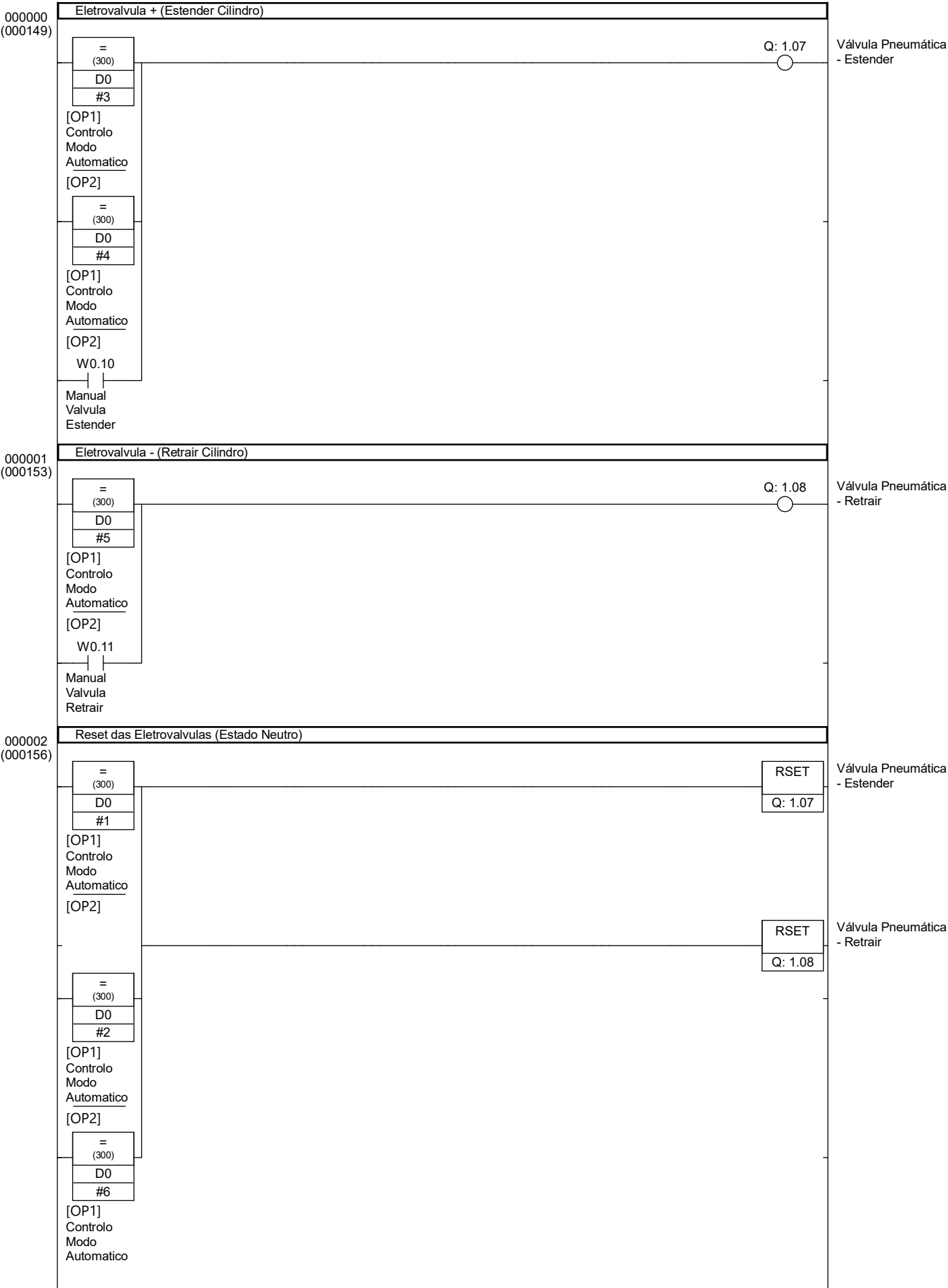
W0.07

Motor Avanço (Etapas de Movimento)



Motor Marcha-Atrás (Modo Manual)





000002
(000156)

Reset das Eletrovalvulas (Estado Neutro)

=

(300)

D0

#1

[OP1]
Controlo
Modo
Automatico

[OP2]

=

(300)

D0

#2

[OP1]
Controlo
Modo
Automatico

[OP2]

=

(300)

D0

#6

[OP1]
Controlo
Modo
Automatico

RSET

Q: 1.07

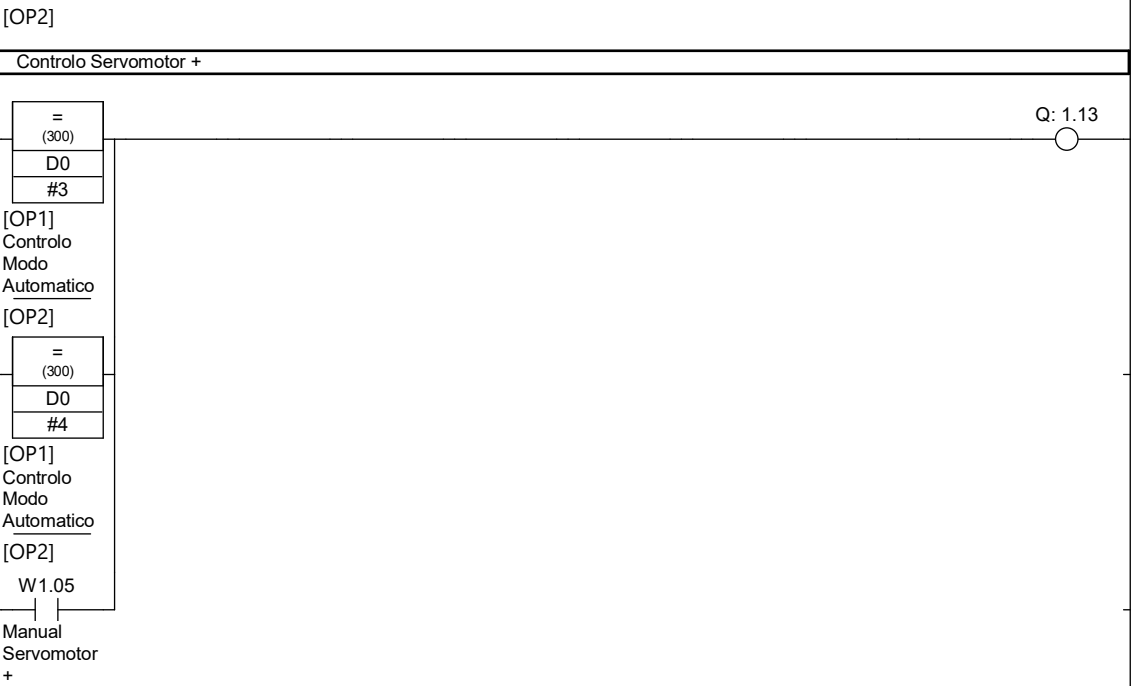
Válvula Pneumática
- Estender

RSET

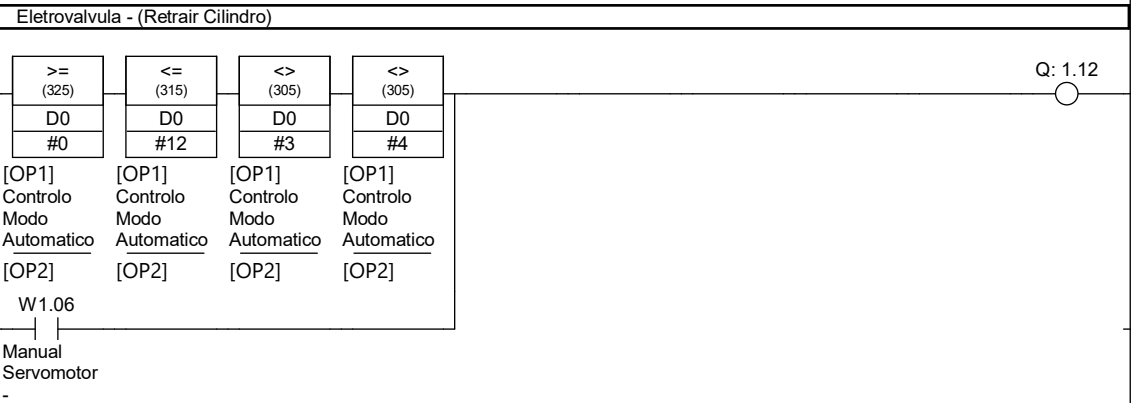
Q: 1.08

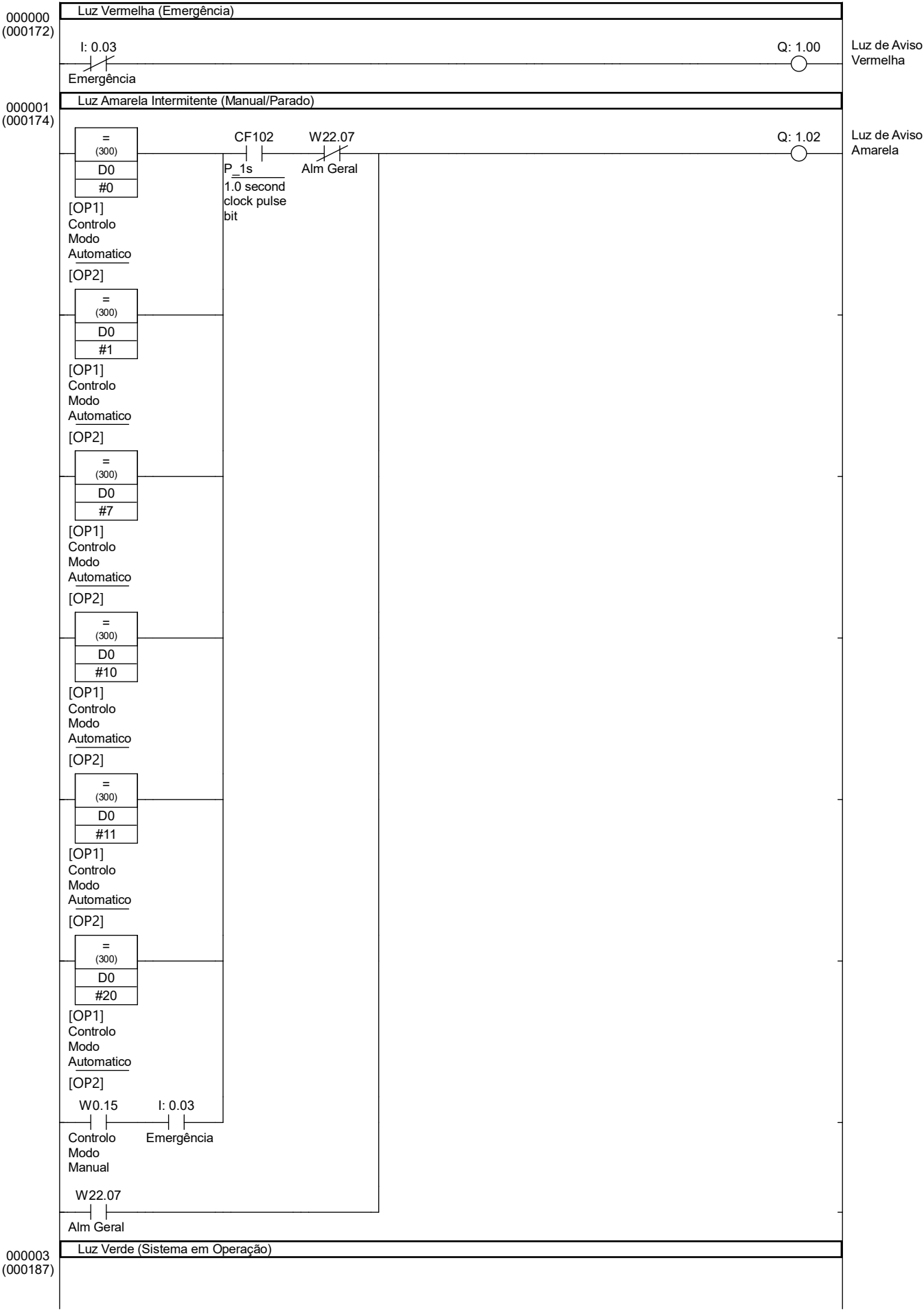
Válvula Pneumática
- Retrair

000003
(000161)



000004
(000165)





=

(300)

D0

#11

[OP1]
Controlo
Modo
Automatico

[OP2]

=

(300)

D0

#20

[OP1]
Controlo
Modo
Automatico

[OP2]

W0.15

I: 0.03

Controlo
Modo
Manual

Emergência

W22.07

Alm Geral

CF102

W22.07

P_1s
1.0 second
clock pulse
bit

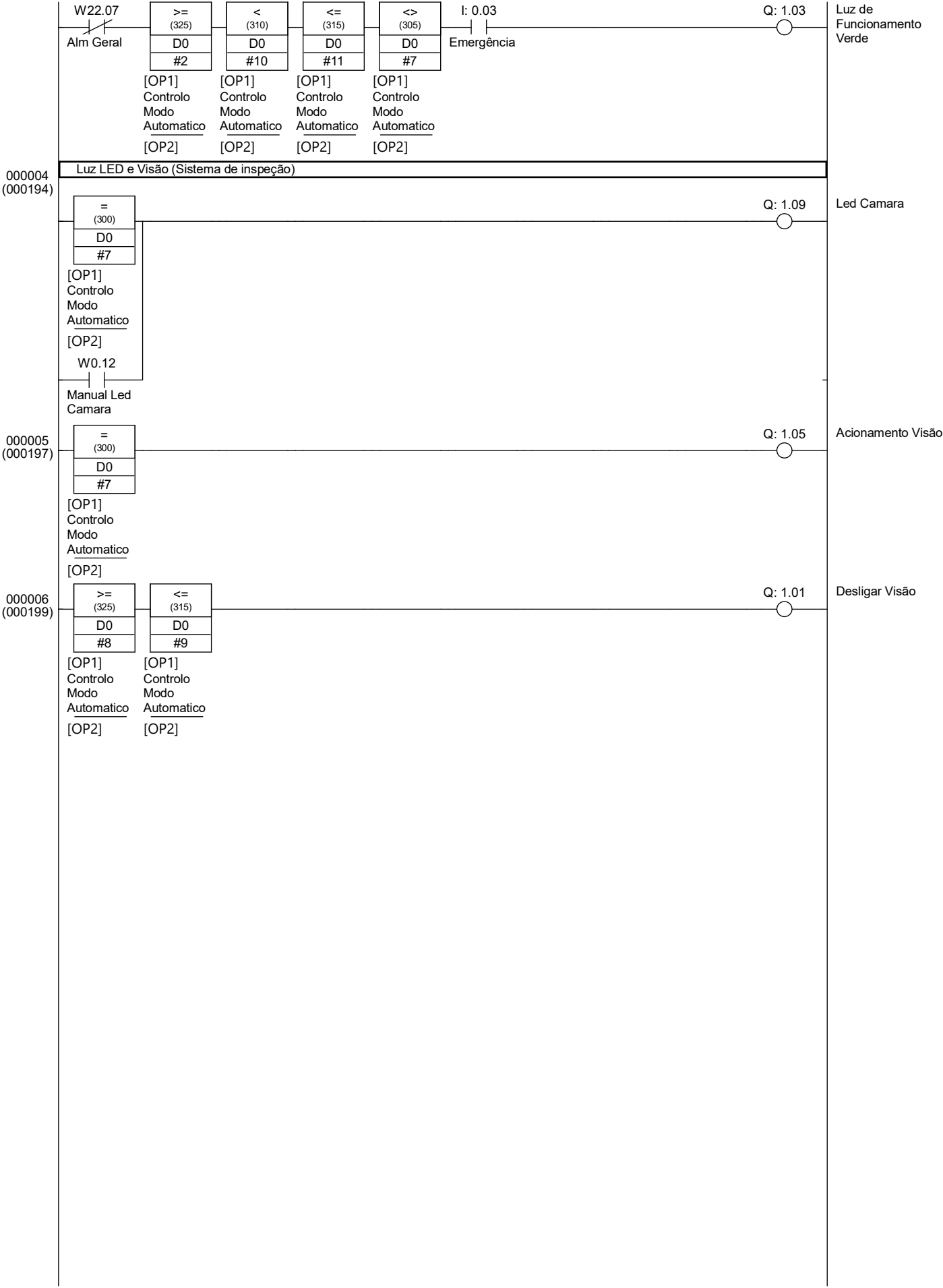
Alm Geral

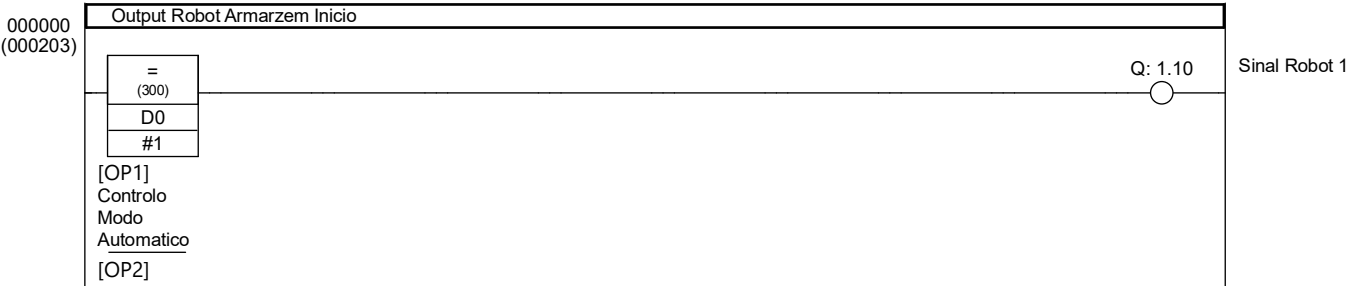
Q: 1.02

Luz de Aviso Amarela

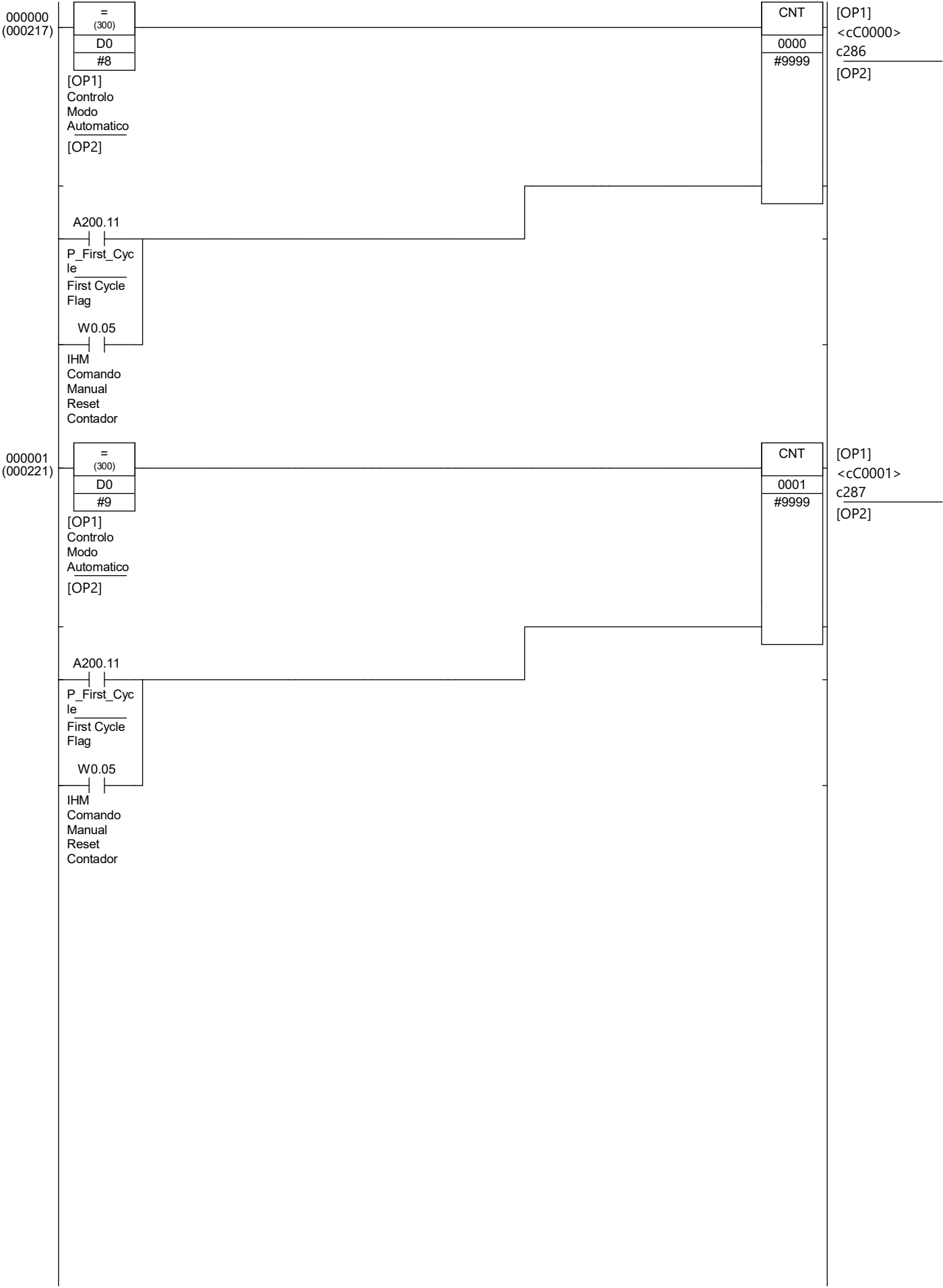
000003
(000187)

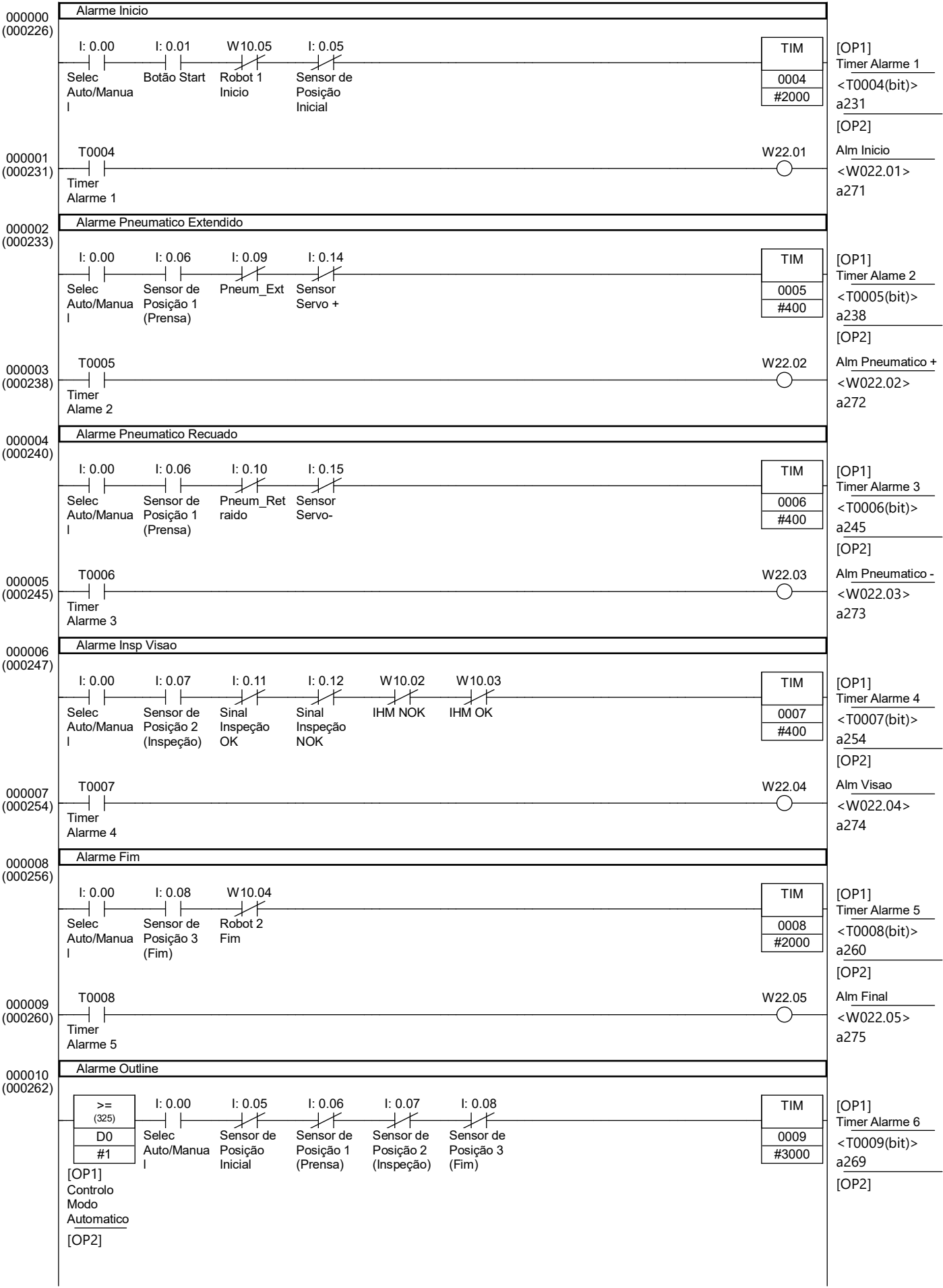
Luz Verde (Sistema em Operação)

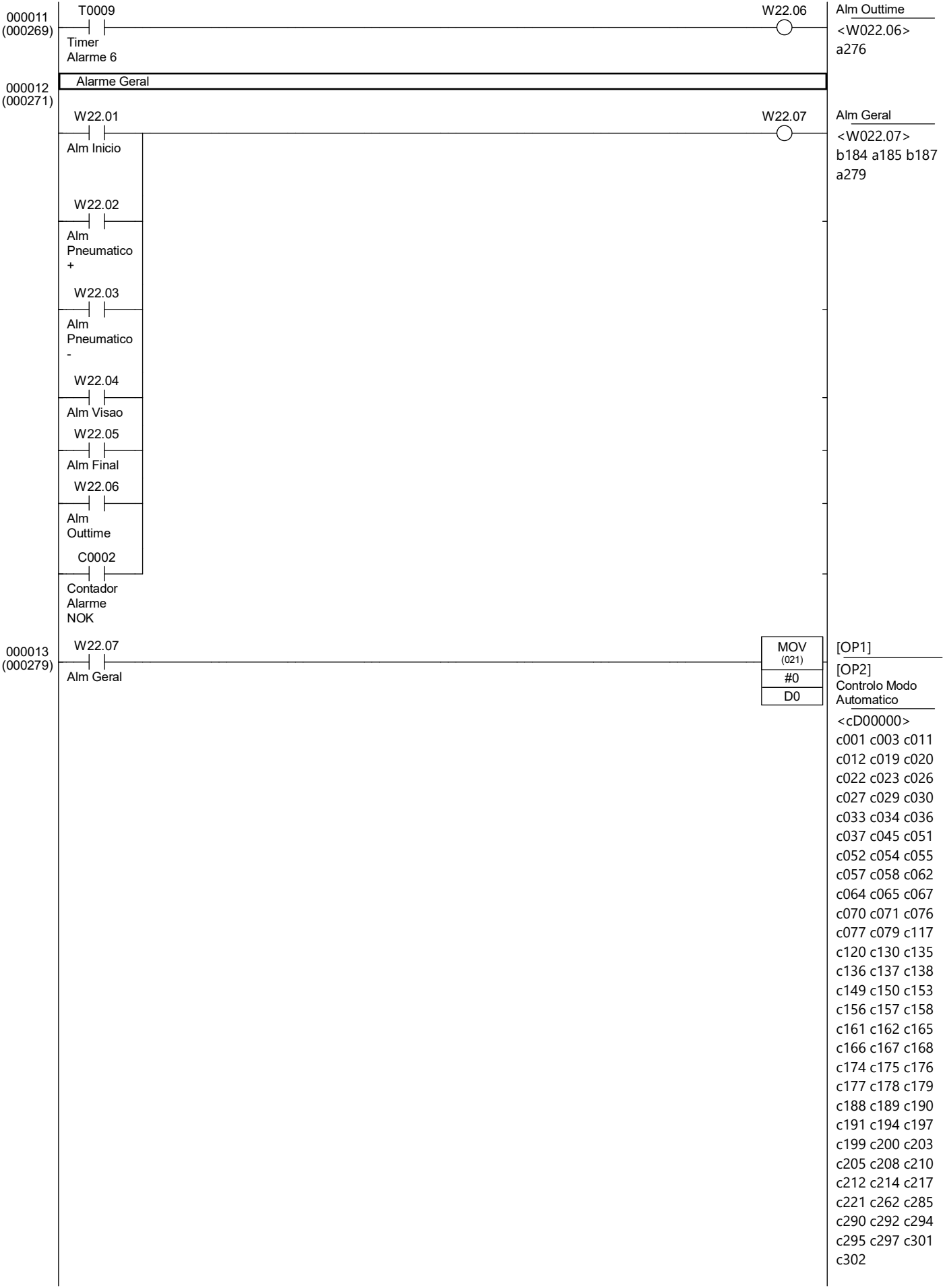




000000 (000208)	<div>Temporizador de Prensagem</div> <div><div><div><div>=</div><div>(300)</div></div><div>D0</div><div>#4</div></div><div><div>[OP1]</div><div>Controlo</div><div>Modo</div><div>Automatico</div><div>[OP2]</div></div></div> <div><div>TIM</div><div>0000</div><div>#30</div></div> <div><div>[OP1]</div><div>Temp_press</div><div><T0000(bit)></div><div>a028</div><div>[OP2]</div></div>
000001 (000210)	<div>Temporizador Posição Final</div> <div><div><div><div>=</div><div>(300)</div></div><div>D0</div><div>#9</div></div><div><div>[OP1]</div><div>Controlo</div><div>Modo</div><div>Automatico</div><div>[OP2]</div></div></div> <div><div>TIM</div><div>0001</div><div>#30</div></div> <div><div>[OP1]</div><div>Temp_NOK</div><div><T0001(bit)></div><div>a056</div><div>[OP2]</div></div>
000002 (000212)	<div>Temporizador Visão</div> <div><div><div><div>=</div><div>(300)</div></div><div>D0</div><div>#7</div></div><div><div>[OP1]</div><div>Controlo</div><div>Modo</div><div>Automatico</div><div>[OP2]</div></div></div> <div><div>TIM</div><div>0002</div><div>#100</div></div> <div><div>[OP1]</div><div>Temp_Visão</div><div><T0002(bit)></div><div>a041</div><div>[OP2]</div></div>
000003 (000214)	<div>Temporizador Visão</div> <div><div><div><div>=</div><div>(300)</div></div><div>D0</div><div>#7</div></div><div><div>[OP1]</div><div>Controlo</div><div>Modo</div><div>Automatico</div><div>[OP2]</div></div></div> <div><div>TIM</div><div>0003</div><div>#20</div></div> <div><div>[OP1]</div><div>Temp_Fim_Visão</div><div><T0003(bit)></div><div>a139</div><div>[OP2]</div></div>





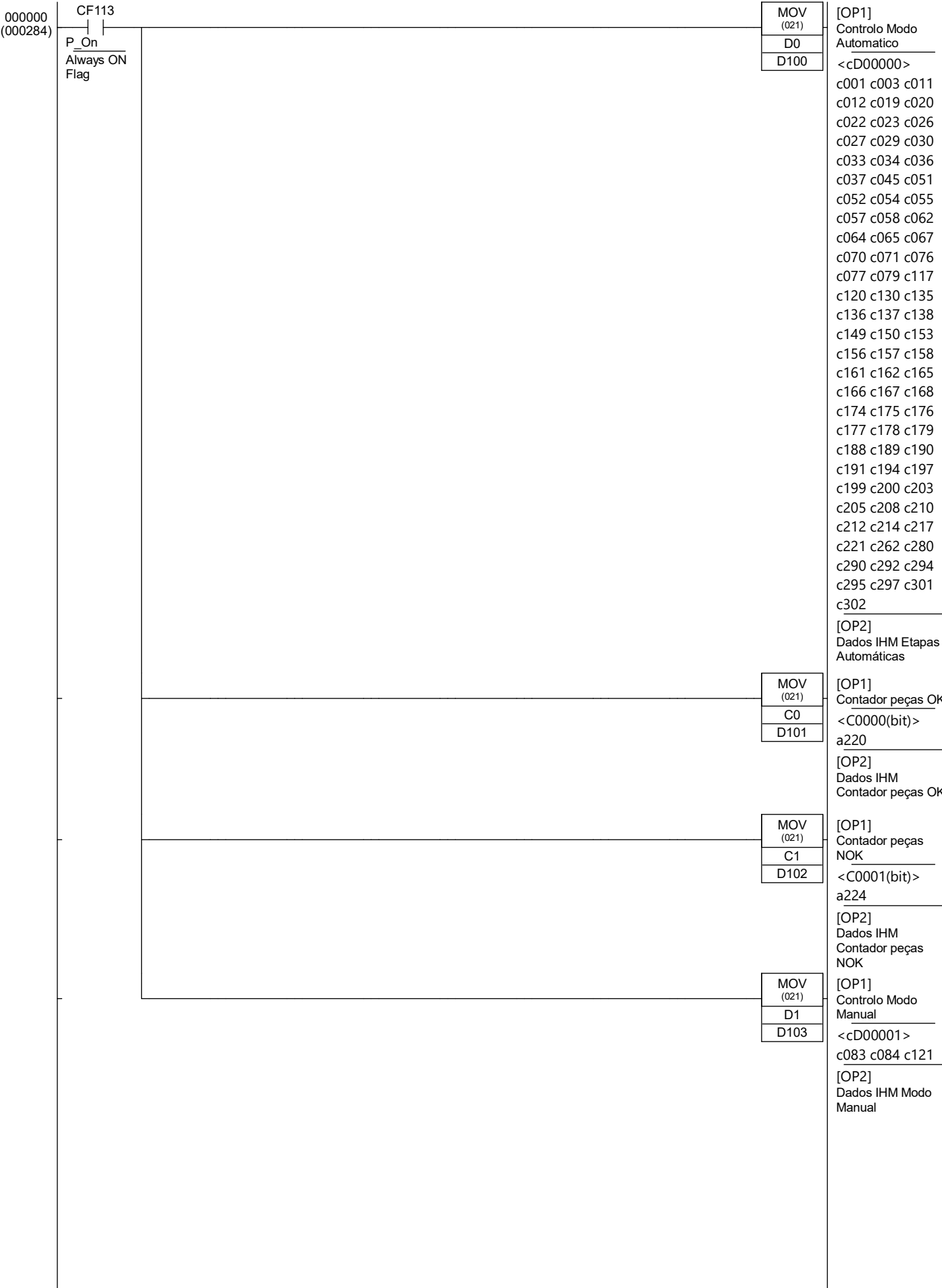


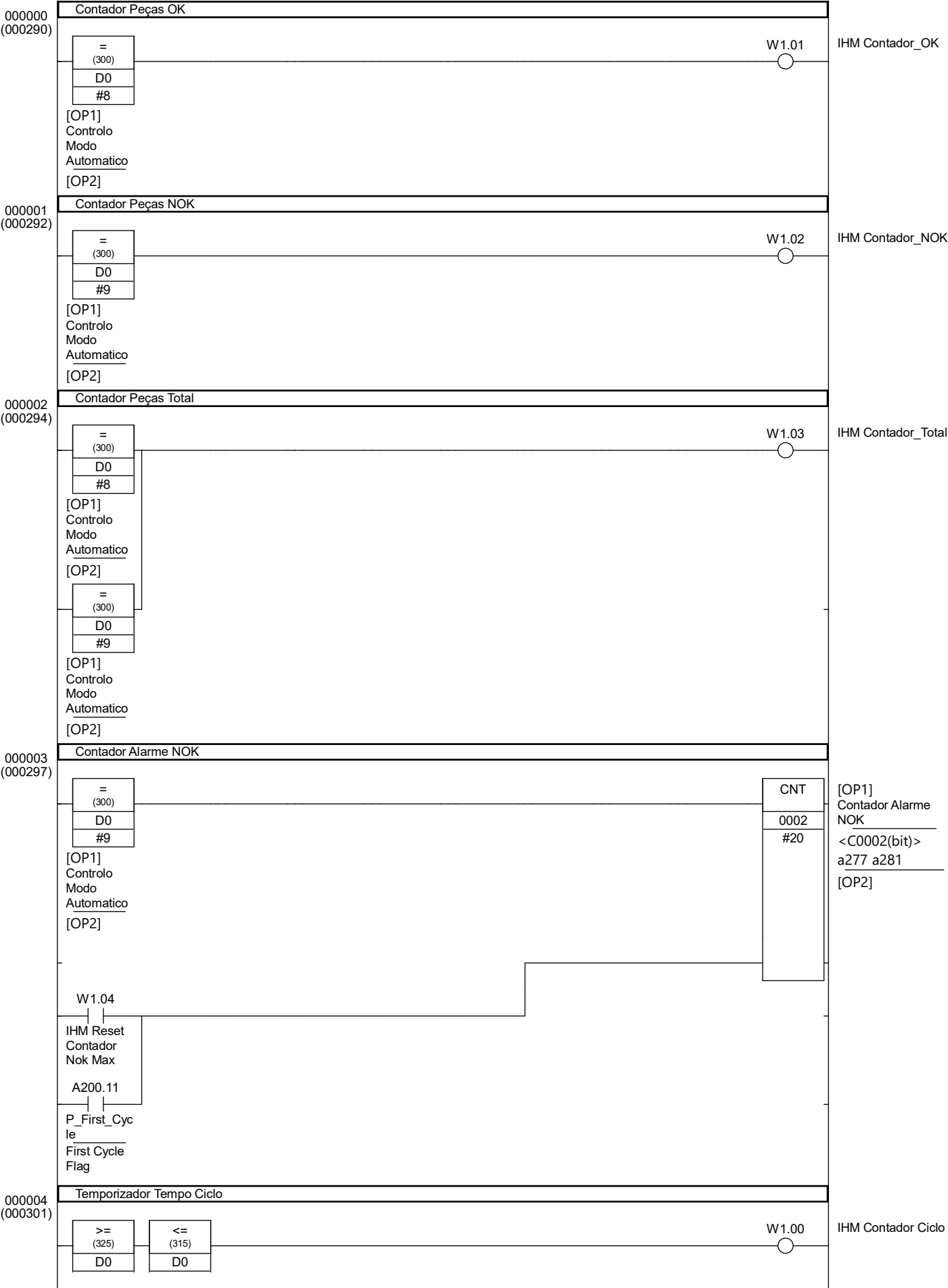
000014
(000281)

C0002
| |
Contador
Alarme
NOK

W22.08

Alm Contador Nok
Max





#1	#11
[OP1]	[OP1]
Controlo	Controlo
Modo	Modo
<u>Automatico</u>	<u>Automatico</u>
[OP2]	[OP2]

000000
(000305)

END
(001)