

00 Label: Step:

Gestione modi da Xilog a Cn

Xil_modo == 2	Modatt_0	Modedem = 0
] > [(T)
%V506.W == 0x2	%V24.0	%W14.B = 0x0
Xil_modo == 5	Modatt_1	Modedem = 1
] > [(T)
%V506.W == 0x5	%V24.1	%W14.B = 0x1
Xil_modo == 4	Modatt_2	Modedem = 2
] > [(T)
%V506.W == 0x4	%V24.2	%W14.B = 0x2
Xil_modo == 1	Modatt_7	Modedem = 7
] > [(T)
%V506.W == 0x1	%V24.3	%W14.B = 0x7
Xil_modo == 3	Modatt_8	Modedem = 8
] > [(T)
%V506.W == 0x3	%V24.4	%W14.B = 0x8
Xil_modo == 0	Modatt_11	Modedem = 11
] > [(T)
%V506.W == 0x0	%V24.5	%W14.B = 0xb

01 Label: Step:

Selezione dei modi

Modcour != Modedem	Modpup
] > [
(S)	
%R16.B != %W14.B	
%W5.1	
Modcour == Modedem	Modpup
] > [
(R)	
%R16.B == %W14.B	
%W5.1	

Selezione dei modi CN da plc

Selezione dei modi CN da plc

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02 Label: Step:

Gestione modi da Cn a Xilog

Modcour == 0	Modatt_0	Mem. per modo in corso (Cont)
]>[()	
%R16.B == 0x0	%V24.0	
Modcour == 1	Modatt_1	Mem. per modo in corso (Seq)
]>[()	
%R16.B == 0x1	%V24.1	
Modcour == 2	Modatt_2	Mem. per modo in corso (Mdi)
]>[()	
%R16.B == 0x2	%V24.2	
Modcour == 7	Modatt_7	Mem. per modo in corso (Man)
]>[()	
%R16.B == 0x7	%V24.3	
Modcour == 8	Modatt_8	Mem. per modo in corso (Pom)
]>[()	
%R16.B == 0x8	%V24.4	
Modcour == 11	Modatt_11	Mem. per modo in corso (senza mo
]>[()	
%R16.B == 0xb	%V24.5	

03 Label: Step:

Gestione modi da Cn a Xilog

Modatt_7	Modo_xil = 1
] [(T)
%V24.3	%V514.W = 0x1
Modatt_0	Modo_xil = 2
] [(T)
%V24.0	%V514.W = 0x2
Modatt_8	Modo_xil = 3
] [(T)
%V24.4	%V514.W = 0x3
Modatt_2	Modo_xil = 4
] [(T)
%V24.2	%V514.W = 0x4
Modatt_11	Modo_xil = 0
] [(T)
%V24.5	%V514.W = 0x0
Modatt_1	Modo_xil = 5
] [(T)
%V24.1	%V514.W = 0x5

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04 Label: Step:

Gestione jog da Xilog a Cn

X_j1	E_incjog != 1	C_incjog = 1
]	[]>[(T)
%V500.4	%R15.B != 0x1	%W13.B = 0x1
X_j10	E_incjog != 2	C_incjog = 2
]	[]>[(T)
%V500.5	%R15.B != 0x2	%W13.B = 0x2
X_j100	E_incjog != 3	C_incjog = 3
]	[]>[(T)
%V500.6	%R15.B != 0x3	%W13.B = 0x3
X_j1000	E_incjog != 4	C_incjog = 4
]	[]>[(T)
%V500.7	%R15.B != 0x4	%W13.B = 0x4
X_j10000	E_incjog != 5	C_incjog = 5
]	[]>[(T)
%V501.0	%R15.B != 0x5	%W13.B = 0x5
X_jogill	E_incjog != 6	C_incjog = 6
]	[]>[(T)
%V500.3	%R15.B != 0x6	%W13.B = 0x6

05 Label: Step:

Gestione jog da Cn a Xilog

E_incjog == 1	J1_x	Jog 1
]	()	
%R15.B == 0x1	%V510.6	
E_incjog == 2	J10_x	Jog 10
]	()	
%R15.B == 0x2	%V510.7	
E_incjog == 3	J100_x	Jog 100
]	()	
%R15.B == 0x3	%V511.0	
E_incjog == 4	J1000_x	Jog 1000
]	()	
%R15.B == 0x4	%V511.1	
E_incjog == 5	J10000_x	Jog 10000
]	()	
%R15.B == 0x5	%V511.2	
E_incjog == 6	Jogill_x	Jog illimitato
]	()	
%R15.B == 0x6	%V510.5	

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06 Label: Step:

Selezione del tipo di jog

E_incjog != C_incjog	Jogpup
] > [(S)
%R15.B != %W13.B	%W5.2
E_incjog == C_incjog	Jogpup
] > [(R)
%R15.B == %W13.B	%W5.2

Selezione del tipo di Jog da plc

Selezione del tipo di Jog da plc

07 Label: Step:

Emergenza, no mode, no edit a Xilog

Emer_gen	Dron_x
] [()
%I4000.6	%V513.2
Ps_nomode	Nomode_x
] [()
%V202b.7	%V511.3
Ps_noedit	Noedit_x
] [()
%V202b.6	%V513.7

Macchina accesa (1=si 0=no)

Selettore NO-Mode

Modalità noedit (0=no 1=si)

08 Label: Step:

Ciclo in corso, richiamo assi , mm/inch a Xilog

E_cycle	Cyst_x
] [()
%R3.2	%V510.2
E_rax	Rapax_x
] [()
%R3.3	%V510.0
E_arus	
] [
%R3.1	
S_recul	
] [
%R2.4	

Cycle start eseguito

Rappel d'axe eseguito

09 Label: Step:

Gestione unità di misura

X_incm	C_unit
] [()
%V502.5	%W4.5
C_unit	Incmm_x
] [()
%W4.5	%V510.1

Unità di misura (metrico o inch)

Inch/mm eseguito

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10 Label: Step:

Cnc in errore, hold assi

E_defcn] [%R3.6	Errcn_x () %V513.1	Messaggio da CN (0=no 1=si)
	(1) (T)	
E_arus] [%R3.1	Fh_x () %V510.3	Feed-Hold illimitato
C_fmext1]/[%W100.1		
C_autav1]/[%W100.0		

(1) %V521.B = %R18.B : Cn_all_x = Errmach

11 Label: Step:

Gestione assi in movimento a Xilog

Axmvt0] [%R9.0	Axmvt_x () %V511.6	Almeno un asse in moto (0=no 1=s
Axmvt1] [%R9.1		
Axmvt2] [%R9.2		
Axmvt4] [%R9.4		
Axmvt7] [%R9.7		

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Label:

Step:

Gestione assi tarati a Xilog

Axini0 -]/[- %Rd.0	Axini1 -]/[- %Rd.1	Axini2 -]/[- %Rd.2	E20007 -]/[- %W11.7	E20008 -]/[- %W10.0	Pom_x - () - %V511.4
			Axini4 -]/[- %Rd.4	Axini7 -]/[- %Rd.7	

Assi tarati (0=no 1=si)

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Label:

Step:

Gestione selettore assi a Xilog

Ps_selax == 1 -]>[- %V202d.B == 0x1					Selasse_x = 1 - (T) - %V516.B = 0x1
Ps_selax == 12 -]>[- %V202d.B == 0xc					Selasse_x = 2 - (T) - %V516.B = 0x2
Ps_selax == 10 -]>[- %V202d.B == 0xa					Selasse_x = 3 - (T) - %V516.B = 0x3
Ps_selax == 3 -]>[- %V202d.B == 0x3					Selasse_x = 8 - (T) - %V516.B = 0x8
Ps_selax == 4 -]>[- %V202d.B == 0x4					Selasse_x = 9 - (T) - %V516.B = 0x9
Ps_selax != 1 -]>[- %V202d.B != 0x1	Ps_selax != 12 -]>[- %V202d.B != 0xc	Ps_selax != 10 -]>[- %V202d.B != 0xa	Ps_selax != 3 -]>[- %V202d.B != 0x3	Ps_selax != 4 -]>[- %V202d.B != 0x4	Selasse_x = 4 - (T) - %V516.B = 0x4

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Label:

Step:

Gestione richiesta manuale in modo automatico

X_end -] [- %V503.0	V5b4_b == 0 -]>[- %V5b4.B == 0x0	V5b5_b == 0 -]>[- %V5b5.B == 0x0	X_ventose -]/[- %V502.7	V200_0 - R_T - %V200.0	Ps_nomode -]/[- %V202b.7	Manen_x - (S) - %V513.3
Gen_em_cn -] [- %V1e.0						
X_test_fora -] [- %V503.2						

Richiesta abil. funzioni manuali

15 Label: Step:

Gestione richiesta manuale in modo automatico

Mstart_a] [%V6.3	Manen_x (R) %V513.3
Mstart_b] [%V6.4	
Mstart_c] [%V6.5	
Mstart_d] [%V6.6	
X_end, X_test_fora]/[%V503.0, %V503.2	
X_ventose] [%V502.7	

Richiesta abil. funzioni manuali

16 Label: Step:

Gestione valore potenziometri a Xilog

Ps_pot2 < 254]>[%V202f.B < 0xfe	(1) (T) Potax_x = 255 (F) %V51c.B = 0xff
Ps_pot1 < 254]>[%V202e.B < 0xfe	(2) (T) Potbr_x = 255 (F) %V51d.B = 0xff
Vitbr1 > 0]>[%R1c.W > 0x0	X_modosim]/[%V503.1 (3) (T) Vitbr_x = 0 (F) %V51e.W = 0x0

- (1) %V51c.B = %V202f.B : Potax_x = Ps_pot2
- (2) %V51d.B = %V202e.B : Potbr_x = Ps_pot1
- (3) %V51e.W = %R1c.W * 0xc350 / 0x7fff + 0x1 : Vitbr_x = Vitbr1 * 50000 / 32767 + 1

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17 Label: Step:

Gestione tastatore

X_modo_sim] [%V503.1	E40020 = 1 (T) %Wa50.L = 0x1	
E30127 == 1]>[%Rd7c.L == 0x1	E40020 = 0 (F) %Wa50.L = 0x0	Fine tastatura / messaggio
X_tastaok] [%V503.7	Tasta_x (S) %V513.0	
	E30127 = 0 (T) %Rd7c.L = 0x0	
	Tasta_x (R) %V513.0	Fine tastatura / messaggio

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