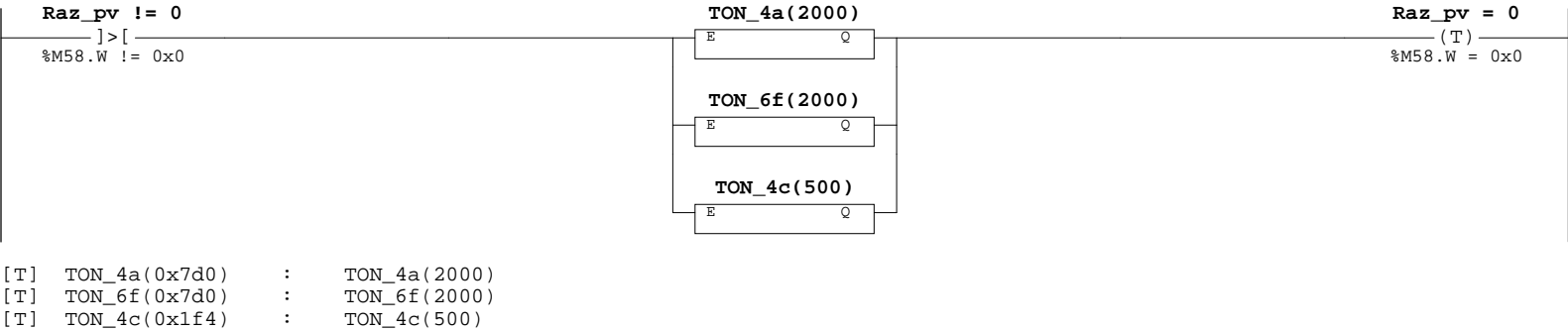
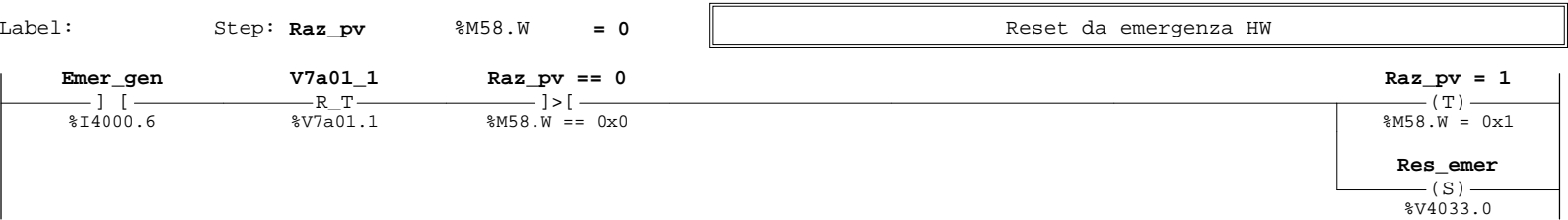


00 Label: Step: Raz_pv %M58.W = 0



01 Label: Step: Raz_pv %M58.W = 0



03 Label: Step: Raz_pv %M58.W = 0

Reset a fine posizionamento

Movimento_pv	Ps_f2	V200_1.2	Raz_pv == 0	Raz_pv = 1
]/[]/[R_T]/[(T)
%V4032.0	%V202b.1	%V200.2	%M58.W == 0x0	%M58.W = 0x1
	X_end	V211_2.6		
]/[R_T		
	%V503.0	%V211.6		
	Sel_man_aut	V20f_3.5		
]/[R_T		
	%I4101.4	%V20f.5		
Raz_icla		V211_2.7		
]/[R_T		
%V4031.2		%V211.7		
				goto(END)
				(T)

04 Label: Step: Raz_pv %M58.W = 1

Reset memorie

Res_emer	Vent_pdl_std != 0	Vacu_a	Sb_vent_a	Blocco/sblocco ventose area A
]/[]/[]/[(S)	
%V4033.0	%I5200.B != 0x0	%I4200.4	%Q5201.2	
	Vent_pdl_add != 0	Vacu_bi	Sb_vent_b	Blocco/sblocco ventose area B
]/[]/[(S)	
	%I5400.B != 0x0	%I4200.5	%Q5201.3	
		Vacu_cl	Sb_vent_c	Blocco/sblocco ventose area C
]/[(S)	
		%I4200.6	%Q5201.4	
		Vacu_d	Sb_vent_d	Blocco/sblocco ventose area D
]/[(S)	
		%I4200.7	%Q5201.5	

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05 Label: Step: Raz_pv %M58.W = 1

I_i_init = 0	I_biterr = 0	I_r_syst1 = 0	I_r_maskerr = 0	I_r_syst = 0
T	T	T	T	(T)
%M1532.W = 0x0	%M151a.W = 0x0	%M7154.W = 0x0	%M153e.W = 0x0	%M7110.W = 0x0
Init_can				Init ICLA
(/)				%V700d.0
Raz_pv = 22				(T)
				%M58.W = 0x16
goto(END)				
(T)				

06 Label: Step: Raz_pv %M58.W = 22

Init_can	Raz_pv = 2
] [(T)
%V700d.0	%M58.W = 0x2
Emer_gen	
] / [
%I4000.6	
	goto(END)
	(T)

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07 Label: LO Step: Raz_pv %M58.W = 2

Raz motori icla

I_r_syst >= 0	I_r_syst <= 16 * (N_assi - 1)	Raz_1[I_r_syst]
] > [] > []		()
%M7110.W >= 0x0	%M7110.W <= 0x10 * (%V7002.B - 0x1)	%V7010.6[%M7110.W]
		Prog_1[I_r_syst]
		(R)
		%V7010.2[%M7110.W]
		P_syncro_1[I_r_syst]
		(R)
		%V7010.3[%M7110.W]
		Jog_1[I_r_syst]
		(R)
		%V7010.5[%M7110.W]
		I_r_syst += 16
		(T)
		%M7110.W += 0x10
		goto(LO)
		(T)

08 Label: Step: Raz_pv %M58.W = 2

I_r_syst = 0
(T)
%M7110.W = 0x0
Raz_pv = 3
(T)
%M58.W = 0x3
goto(END)
(T)

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09 Label: LOOP3 Step: Raz_pv %M58.W = 3

Reset maschere errori

<div>I_r_syst1 >= 0 I_r_syst1 <= 16 * (N_assi - 1)</div> <div>%M7154.W >= 0x0 %M7154.W <= 0x10 * (%V7002.B - 0x1)</div>	(1)		(2)
	T		(T)
	I_r_maskerr = I_r_syst1 / 16		(3)
	%M153e.W = %M7154.W / 0x10		(T)
	I_r_syst1 += 16		(T)
		%M7154.W += 0x10	
		goto(LOOP3)	
		(T)	

(1) %M1530.W = %M7154.W / 0x10 * 0x2 : I_r_biterr = I_r_syst1 / 16 * 2
(2) %V1202.W[%M1530.W] = 0x0 : Tab_errr1[I_r_biterr] = 0
(3) %V1401.B[%M153e.W] = 0x0 : Mask_errr1[I_r_maskerr] = 0

10 Label: Step: Raz_pv %M58.W = 3

		C_syncstart	start assi sincronizzato
		(R)	
		%V700c.0	
		Raz_pv = 4	
		(T)	
		%M58.W = 0x4	
		goto(END)	
		(T)	

11 Label: L1 Step: Raz_pv %M58.W = 4

Abilitazione Prog motori Icla

<div>I_r_syst >= 0 I_r_syst <= 16 * (N_assi - 1)</div> <div>%M7110.W >= 0x0 %M7110.W <= 0x10 * (%V7002.B - 0x1)</div>	Raz_1[I_r_syst]	
	(/)	
	%V7010.6[%M7110.W]	
	Prog_1[I_r_syst]	
	(S)	
		%V7010.2[%M7110.W]
	I_r_syst += 16	
		(T)
		%M7110.W += 0x10
		goto(L1)
		(T)

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12 Label: Step: Raz_pv %M58.W = 4

TON_4a(2000)	Cil_std = 0	Cil_add = 0	B_sb_vent = 0	Raz_pv = 44
E Q	T %Q5200.B = 0x0	T %Q5400.B = 0x0	T %V4040.B = 0x0	(T) %M58.W = 0x2c
				Cil_pdl_ab
				(R) %Q5201.0
				Cil_pdl_cd
				(R) %Q5201.1
				goto(END)
				(T)

Abil. cilindro aggancio area AB

Abil. cilindro aggancio area CD

[T] TON_4a(0x7d0) : TON_4a(2000)

13 Label: Step: Raz_pv %M58.W = 44

TON_4c(500)	Raz_pv = 5
E Q	(T) %M58.W = 0x5
	Sb_vent_a
	(R) %Q5201.2
	Sb_vent_b
	(R) %Q5201.3
	Sb_vent_c
	(R) %Q5201.4
	Sb_vent_d
	(R) %Q5201.5
	goto(END)
	(T)

Blocco/sblocco ventose area A

Blocco/sblocco ventose area B

Blocco/sblocco ventose area C

Blocco/sblocco ventose area D

[T] TON_4c(0x1f4) : TON_4c(500)

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14 Label: Step: Raz_pv %M58.W = 5

Cil_std = 0	Cil_pv = 0	Sb_pdl_ab
T	T	(R)
%Q5200.B = 0x0	%Q5201.B = 0x0	%Q5201.6
I_i_init = 0	I_biterr = 0	I_r_syst1 = 0
T	T	T
%M1532.W = 0x0	%M151a.W = 0x0	%M7154.W = 0x0
I_r_maskerr = 0	I_r_syst = 0	Cil_add = 0
T	T	T
%M153e.W = 0x0	%M7110.W = 0x0	%Q5400.B = 0x0
Sb_pdl_cd		
		(R)
		%Q5201.7
Msg_183		
		(R)
		%V3036.0
App_msg129		
		(R)
		%V4033.5
Time_agg		
		(R)
		%V4033.6

sblocco pdl area AB

sblocco pdl area CD

Setup piani e ventose in corso

Appoggio MSG 129

bit per timer di attesa aggancio

15 Label: Step: Raz_pv %M58.W = 5

	Raz_icla
	(R)
	%V4031.2
Res_emer	Raz_pv = 0
]/[(T)
%V4033.0	%M58.W = 0x0
Res_emer	Raz_pv = 1
]/[(T)
%V4033.0	%M58.W = 0x1
TON_6f(2000)	Res_emer
E Q	(R)
	%V4033.0
	Msg_psf2
	(R)
	%V4031.3
	goto(END)
	(T)

Reset a fine posizionamento moto

[T] TON_6f(0x7d0) : TON_6f(2000)

16 Label: END Step:

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