

00 Label: Step:

Gen_em_cn	Graf_tr24 = 0
]	(T)
%V1e.0	%M44.W = 0x0
	Rich_tr24 = 0
	(T)
	%M78.L = 0x0

01 Label: Step: Graf_tr24 %M44.W = 0

	R24_start	Start movimento
	(R)	
	%Q5300.2	
	R24enrif	Scambio dati fine-corsa taratura
	(R)	
	%Q5300.5	

02 Label: Step: Graf_tr24 %M44.W = 0

(1)	V200_1	X_end	(2)	Rich_tr24 > 24	Rich_tr24 = 1
]	R_T]/[T]	(T)
	%V200.1	%V503.0		%M78.L > 0x18	%M78.L = 0x1
				Graf_tr24 = 1	
				(T)	%M44.W = 0x1
M38_ok	M16_1	Rich_tr24 != Tr24_pos		Graf_tr24 = 1	
]]]		(T)	%M44.W = 0x1
%V8c.5	%V610.0	%M78.L != %M7c.L			
X_test_magaz	M12_1	R24_refok		Graf_tr24 = 50	
]]]/[(T)	%M44.W = 0x32
%V503.3	%V60c.0	%I5300.4		goto(END)	
				(T)	

(1) %V202b.3, %I4101.3, %I4000.6, %I4001.3, %I4100.7 : Ps_f6, Setting, Emer_gen, Pul_um1, Pul_um2
(2) %M78.L = %M7c.L + 0x1 : Rich_tr24 = Tr24_pos + 1

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03 Label: Step: Graf_tr24 %M44.W = 1

Ricerca direzione di rotazione magazzino



(1) %V70.L = %M78.L : N_r24 = Rich_tr24

04 Label: Step: Graf_tr24 %M44.W = 2

Bit 5



Scambio dati O5

Scambio dati O5

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05 Label:

Step: Graf_tr24

%M44.W

= 2

Bit 4

N_r24 > 7	R24_o4	Scambio dati 04
]>[(S)	
%V70.L > 0x7	%Q5301.1	
	N_r24 = N_r24 - 8	
	(T)	
	%V70.L = %V70.L - 0x8	
N_r24 <= 7	R24_o4	Scambio dati 04
]>[(R)	
%V70.L <= 0x7	%Q5301.1	

06 Label:

Step: Graf_tr24

%M44.W

= 2

Bit 3

N_r24 > 3	R24_o3	Scambio dati 03
]>[(S)	
%V70.L > 0x3	%Q5301.0	
	N_r24 = N_r24 - 4	
	(T)	
	%V70.L = %V70.L - 0x4	
N_r24 <= 3	R24_o3	Scambio dati 03
]>[(R)	
%V70.L <= 0x3	%Q5301.0	

07 Label:

Step: Graf_tr24

%M44.W

= 2

BIT 2

N_r24 > 1	R24_o2	Scambio dati 02
]>[(S)	
%V70.L > 0x1	%Q5300.7	
	N_r24 = N_r24 - 2	
	(T)	
	%V70.L = %V70.L - 0x2	
N_r24 <= 1	R24_o2	Scambio dati 02
]>[(R)	
%V70.L <= 0x1	%Q5300.7	

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BIT 1

N_r24 == 1]>[%V70.L == 0x1	R24_o1 (S) %Q5300.6	Scambio dati O1
N_r24 == 0]>[%V70.L == 0x0	R24_o1 (R) %Q5300.6	Scambio dati O1
	Graf_tr24 = 3 (T) %M44.W = 0x3	
	goto(END) (T)	

Start movimentazione

R24_start		Start movimento
(S)	%Q5300.2	
R24_inpos	Graf_tr24 = 4	
]/[(T)	
%I5300.3	%M44.W = 0x4	
	goto(END)	
	(T)	

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10 Label: Step: Graf_tr24 %M44.W = 4

Attesa fine posizionamento

Start movimento

	R24_start (R) %Q5300.2	
R24_inpos] [%I5300.3	Graf_tr24 = 5 (T) %M44.W = 0x5 goto(END) (T)	

11 Label: Step: Graf_tr24 %M44.W = 5

Fine posizionamento

	(1) (T)	
	Graf_tr24 = 0 (T) %M44.W = 0x0 goto(END) (T)	

(1) %M7c.L = %M78.L : Tr24_pos = Rich_tr24

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12 Label: Step: Graf_tr24 %M44.W = 50

Ciclo taratura tool-room 24 posizioni

	R24enrif	Scambio dati fine-corsa taratura
	(S)	
	%Q5300.5	
	R24_o1	Scambio dati O1
	(R)	
	%Q5300.6	
	R24_o2	Scambio dati O2
	(R)	
	%Q5300.7	
	R24_o3	Scambio dati O3
	(R)	
	%Q5301.0	
	R24_o4	Scambio dati O4
	(R)	
	%Q5301.1	
	R24_o5	Scambio dati O5
	(R)	
	%Q5301.2	

13 Label: Step: Graf_tr24 %M44.W = 50

	E40014 = 0
	(T)
	%Wa38.L = 0x0
	Graf_tr24 = 51
	(T)
	%M44.W = 0x33
	goto(END)
	(T)

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14 Label: Step: Graf_tr24 %M44.W = 51

	R24_start (S) %Q5300.2	Start movimento
R24_inpos] / [%I5300.3	Graf_tr24 = 52 (T) %M44.W = 0x34 goto(END) (T)	

15 Label: Step: Graf_tr24 %M44.W = 52

	R24_start (R) %Q5300.2	Start movimento
R24_refok] [%I5300.4	Graf_tr24 = 53 (T) %M44.W = 0x35 goto(END) (T)	

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16 Label: Step: Graf_tr24 %M44.W = 53

	R24enrif
	(R)
	%Q5300.5
	E40014 = 1
	(T)
	%Wa38.L = 0x1
	Tr24_pos = 0
	(T)
	%M7c.L = 0x0
	Graf_tr24 = 0
	(T)
	%M44.W = 0x0
	goto(END)
	(T)

Scambio dati fine-corsa taratura

17 Label: END Step:

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