

00 Label:	Step:	Gestione accensione macchina		
		Setting	El_1_on	Em_setting
] [()
		%I4101.3	%Q4100.2	%V1e.4
				Emergenza per setting

01 Label:	Step:	Gestione accensione macchina			
		Abilitazione accensione macchina			

02 Label:	Step:	Gestione accensione macchina		
	(1)	(2)	Axmvt == 0	Mstop
]	[]	[
]	[
			%R9.B == 0x0	%Q4100.1
			%R8.B == 0	
]	[
			%R8.B == 0x0	
			Pul_um1, Pul_um2	
]	[
			%I4001.3, %I4100.7	
			Setting	
]	[
			%I4101.3	
				Accensione macchina
	(1) %V1e.5, %I4201.0, %R5.0 : Mmstop, Emer_ar, E_cnpret			
	(2) %I4000.7, %V28.7, %V1e.4, %V1e.6 : Emer_ter, Em_pznbl, Em_setting, Emer10perc			

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03 Label: Step:

Non arresto a fine blocco, validazione Gr1/2/3, pot. mandrini

	Narfib	
	— () —	
	%W4.3	
	Valid1	
	— () —	
	%W100.2	
	Valid2	
	— () —	
	%W200.2	
	Valid3	
	— () —	
	%W300.2	
	Potbr1 = 255	
	— (T) —	
	%W1e.B = 0xff	
	Potbr2 = 255	
	— (T) —	
	%W1f.B = 0xff	

Non arresto a fine blocco

Validazione gr.1

Validazione gr.2

Validazione gr.3

04 Label: Step:

Comando fine movimenti esterni Gr1/2/3

	C_fmext1	
	— () —	
	%W100.1	
	C_fmext2	
	— () —	
	%W200.1	
	C_fmext3	
	— () —	
	%W300.1	

Commando fine mvt. esterni gr.1

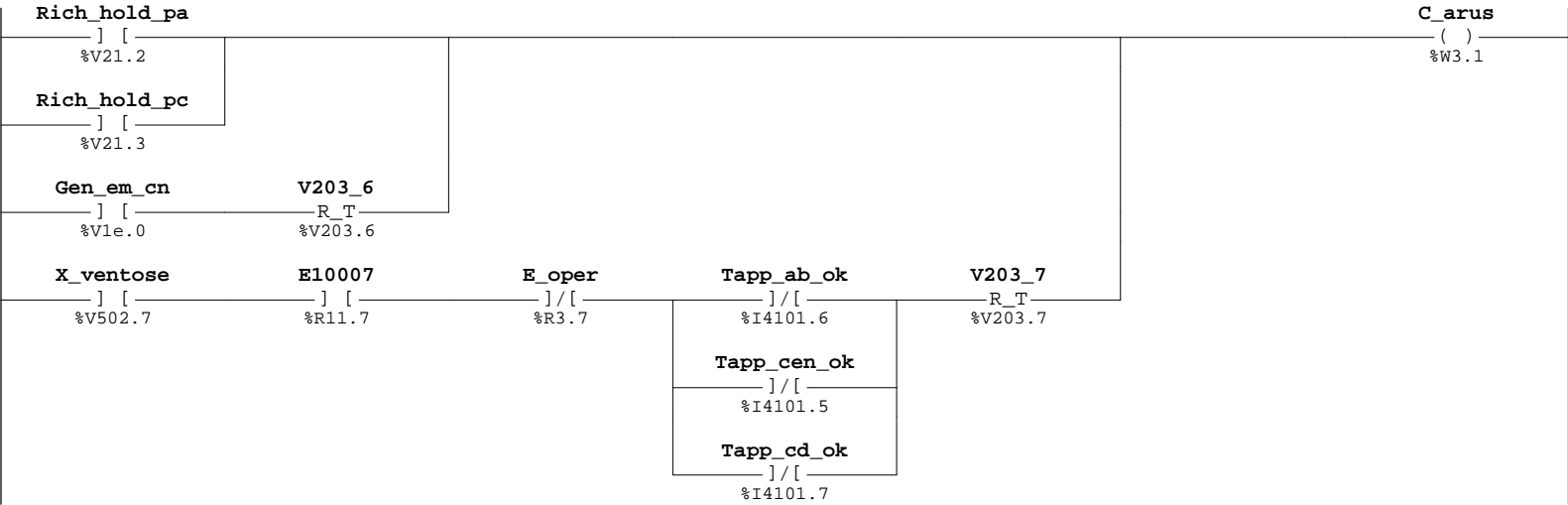
Commando fine mvt. esterni gr.2

Commando fine mvt. esterni gr.3

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05 Label: Step:

Abilitazione HOLD



Richiesta sospensione lavoro (Ho

06 Label: Step:

Abilitazione manipolatori assi in HOLD



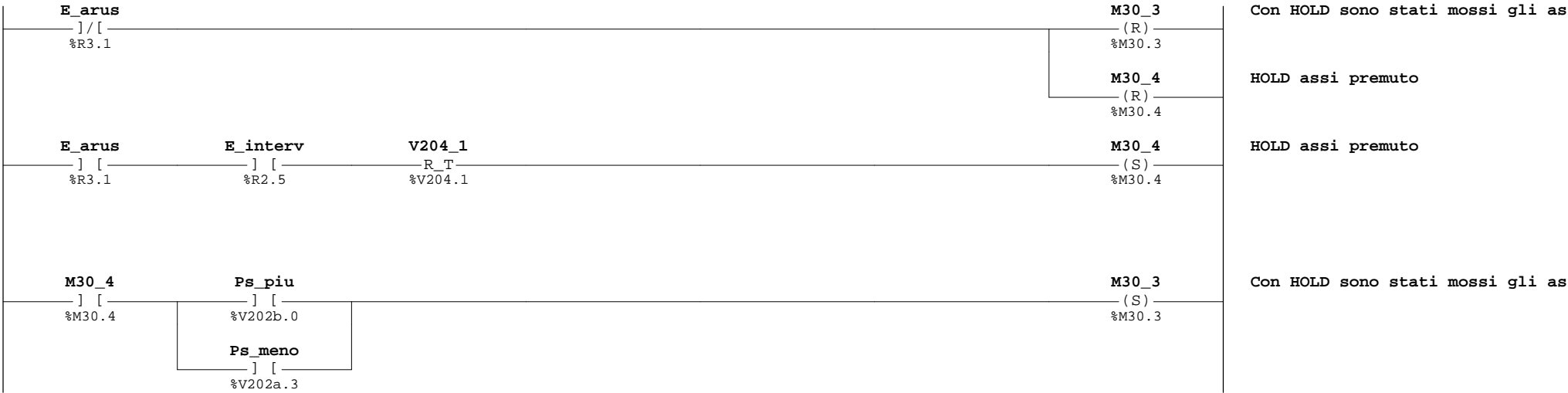
Selezione del richiamo assi

(1) %R3.1, %V9.1 : E_arus, Freq_0_all

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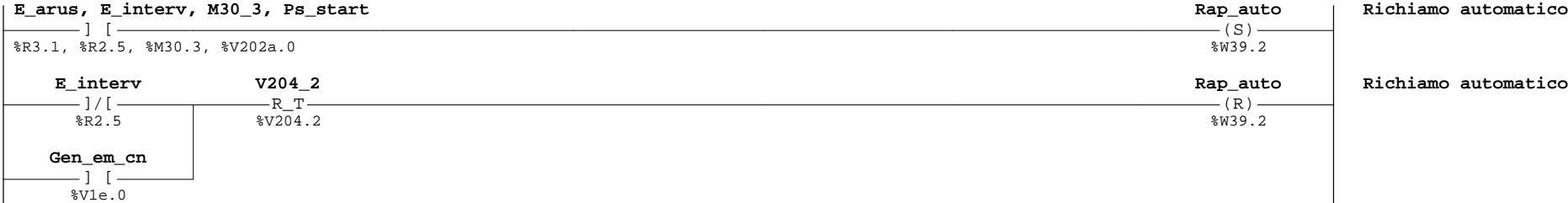
07 Label: Step:

Verifica se macchina in HOLD e se assi movimentati



08 Label: Step:

Abilitazione recupero automatico assi in HOLD





10 Label:

Step:

Abilitazione reset CN

Gen_em_cn

]

[

%V1e.0

TON_17(1000)

E

Q

Rich_raz_pan

]

[

%V21.0

V204_3

F_T

%V204.3

V204_4

R_T

%V204.4

C_raz

()

%W3.0

C_raz2

()

%W201.0

C_raz3

()

%W301.0

Res_x

()

%V510.4

Richiesta reset CN

Richesta reset gr.2

Richesta reset gr.3

Reset eseguito

[T] TON_17(0x3e8) : TON_17(1000)

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