

00 Label: Step:

VERIFICA CARICAMENTO NUOVO PROGRAMMA

X_pgm_a	Sel_man_aut	V207_4	Change_prg_a	Nuovo programma in corso area A
] [	] [	R_T	(S)	
%V531.0	%I4101.4	%V207.4	%V4034.4	
X_pgm_e				
] [				
%V531.4				
X_pgm_b	Sel_man_aut	V207_5	Change_prg_b	Nuovo programma in corso area B
] [	] [	R_T	(S)	
%V531.1	%I4101.4	%V207.5	%V4034.5	
X_pgm_f				
] [				
%V531.5				
X_pgm_c	Sel_man_aut	V207_5.6	Change_prg_c	Nuovo programma in corso area C
] [	] [	R_T	(S)	
%V531.2	%I4101.4	%V207.6	%V4034.6	
X_pgm_g				
] [				
%V531.6				

01 Label: Step:

X_pgm_d	Sel_man_aut	V207_7	Change_prg_d	Nuovo programma in corso area D
] [	] [	R_T	(S)	
%V531.3	%I4101.4	%V207.7	%V4034.7	
X_pgm_h				
] [				
%V531.7				
Start_a	Change_prg_a		Inib_start_a	Inibizione start area A
] [	] [		(S)	
%I4201.3	%V4034.4		%V4035.0	
Start_b	Change_prg_b		Inib_start_b	Inibizione start area B
] [	] [		(S)	
%I4201.4	%V4034.5		%V4035.1	
Start_c	Change_prg_c		Inib_start_c	Inibizione start area C
] [	] [		(S)	
%I4201.5	%V4034.6		%V4035.2	
Start_d	Change_prg_d		Inib_start_d	Inibizione start area D
] [	] [		(S)	
%I4201.6	%V4034.7		%V4035.3	

02 Label: Step:

<div>App_setupa</div> <div>]<div>[</div></div> <div>%V4034.0</div> <div>X_end</div> <div>]<div>[</div></div> <div>%V503.0</div> <div>Sel_man_aut</div> <div>]<div>[</div></div> <div>%I4101.4</div>		<div>Change_prg_a</div> <div>(R)</div> <div>%V4034.4</div> <div>Inib_start_a</div> <div>(R)</div> <div>%V4035.0</div>	<div>Nuovo programma in corso area A</div> <div>Inibizione start area A</div>
<div>App_setupb</div> <div>]<div>[</div></div> <div>%V4034.1</div> <div>X_end</div> <div>]<div>[</div></div> <div>%V503.0</div> <div>Sel_man_aut</div> <div>]<div>[</div></div> <div>%I4101.4</div>		<div>Change_prg_b</div> <div>(R)</div> <div>%V4034.5</div> <div>Inib_start_b</div> <div>(R)</div> <div>%V4035.1</div>	<div>Nuovo programma in corso area B</div> <div>Inibizione start area B</div>

03 Label: Step:

<div>App_setupc</div> <div>]<div>[</div></div> <div>%V4034.2</div> <div>X_end</div> <div>]<div>[</div></div> <div>%V503.0</div> <div>Sel_man_aut</div> <div>]<div>[</div></div> <div>%I4101.4</div>		<div>Change_prg_c</div> <div>(R)</div> <div>%V4034.6</div> <div>Inib_start_c</div> <div>(R)</div> <div>%V4035.2</div>	<div>Nuovo programma in corso area C</div> <div>Inibizione start area C</div>
<div>App_setupd</div> <div>]<div>[</div></div> <div>%V4034.3</div> <div>X_end</div> <div>]<div>[</div></div> <div>%V503.0</div> <div>Sel_man_aut</div> <div>]<div>[</div></div> <div>%I4101.4</div>		<div>Change_prg_d</div> <div>(R)</div> <div>%V4034.7</div> <div>Inib_start_d</div> <div>(R)</div> <div>%V4035.3</div>	<div>Nuovo programma in corso area D</div> <div>Inibizione start area D</div>

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04 Label: Step:

App_setupa, App_setupb, App_setupc, App_setupd	Raz_pv == 5	Mem_pdl_ae	Memorie A-E per move ventose
]/[ %V4034.0, %V4034.1, %V4034.2, %V4034.3	]/[ %M58.W == 0x5	(R) %V4408.0	
	Movimento_pv	Mem_pdl_bf	Memorie B-F per move ventose
	]/[ %V4032.0	(R) %V4408.1	
		Mem_pdl_cg	Memorie C-G per move ventose
		(R) %V4408.2	
		Mem_pdl_dh	Memorie D-H per move ventose
		(R) %V4408.3	

05 Label: Step:

App_setupa	goto(A)
]/[ %V4034.0	(T)
App_setupb	goto(B)
]/[ %V4034.1	(T)
App_setupc	goto(C)
]/[ %V4034.2	(T)
App_setupd	goto(D)
]/[ %V4034.3	(T)
	goto(VAI)
	(T)

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06 Label: A

Step:

Esclusione battute per movimento ventose in corso

<b>X_pgm_a</b> ] [ %V531.0		<b>Mem_pdl_ae</b> ( ) %V4408.0		Memorie A-E per move ventose
<b>X_pgm_e</b> ] [ %V531.4		<b>Mem_pdl_bf</b> ( ) %V4408.1		Memorie B-F per move ventose
<b>Abb_aree_ab</b> ] [ %V1.0				
<b>Abb_aree_ad</b> ] [ %V1.2				
<b>Abb_aree_ad</b> ] [ %V1.2		<b>Mem_pdl_cg</b> ( ) %V4408.2		Memorie C-G per move ventose
		<b>Mem_pdl_dh</b> ( ) %V4408.3		Memorie D-H per move ventose
		<b>goto(VAI)</b> (T) 		

07 Label: B

Step:

Esclusione battute per movimento ventose in corso

<b>X_pgm_b</b> ] [ %V531.1		<b>Mem_pdl_bf</b> ( ) %V4408.1		Memorie B-F per move ventose
<b>X_pgm_f</b> ] [ %V531.5		<b>Mem_pdl_ae</b> ( ) %V4408.0		Memorie A-E per move ventose
<b>Abb_aree_ab</b> ] [ %V1.0		<b>goto(VAI)</b> (T)		

08 Label: C

Step:

Esclusione battute per movimento ventose in corso

<b>X_pgm_c</b> ] [ %V531.2		<b>Mem_pdl_cg</b> ( ) %V4408.2		Memorie C-G per move ventose
<b>X_pgm_g</b> ] [ %V531.6		<b>Mem_pdl_dh</b> ( ) %V4408.3		Memorie D-H per move ventose
<b>Abb_aree_cd</b> ] [ %V1.1		<b>goto(VAI)</b> (T)		

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09 Label: D

Step:

Esclusione battute per movimento ventose in corso

<div>X_pgm_d</div> <div>]<div>[</div></div> <div>%V531.3</div>			<div>Mem_pdl_dh</div> <div>( )</div> <div>%V4408.3</div>	Memorie D-H per move ventose	
<div>X_pgm_h</div> <div>]<div>[</div></div> <div>%V531.7</div>	<div>Abb_aree_cd</div> <div>]<div>[</div></div> <div>%V1.1</div>			<div>Mem_pdl_cg</div> <div>( )</div> <div>%V4408.2</div>	Memorie C-G per move ventose
	<div>Abb_aree_ad</div> <div>]<div>[</div></div> <div>%V1.2</div>				
	<div>Abb_aree_ad</div> <div>]<div>[</div></div> <div>%V1.2</div>			<div>Mem_pdl_ae</div> <div>( )</div> <div>%V4408.0</div>	Memorie A-E per move ventose
				<div>Mem_pdl_bf</div> <div>( )</div> <div>%V4408.1</div>	Memorie B-F per move ventose

10 Label: VAI

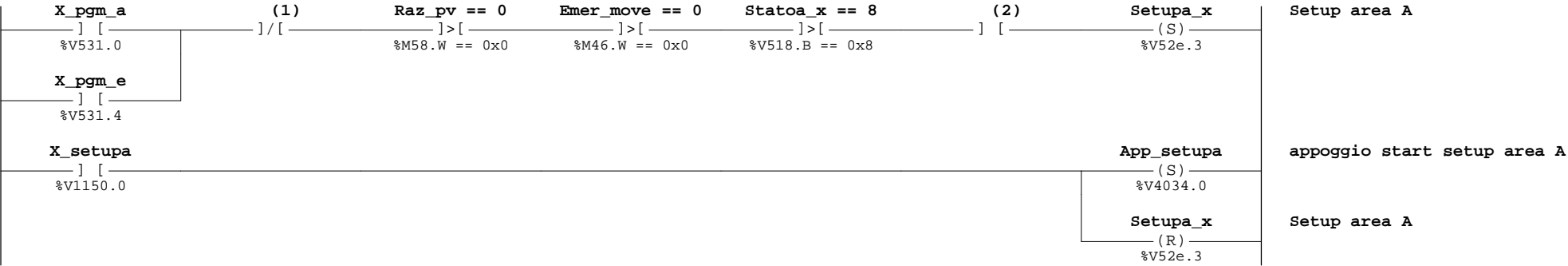
Step:

<b>Msg_184</b> ] [ %V3037.0	<b>Setup_a</b> ] [ %I5201.2	<b>V211_2.3</b> F_T %V211.3	<b>App_setupa</b> (R) %V4034.0	appoggio start setup area A
	<b>Setup_b</b> ] [ %I5201.3		<b>App_setupb</b> (R) %V4034.1	appoggio start setup area B
	<b>Setup_c</b> ] [ %I5201.4		<b>App_setupc</b> (R) %V4034.2	appoggio start setup area C
	<b>Setup_d</b> ] [ %I5201.5		<b>App_setupd</b> (R) %V4034.3	appoggio start setup area D
	<b>Ps_f2</b> ] [ %V202b.1		<b>Test_pgm = 0</b> (T) %M48.W = 0x0	
			<b>No_setup</b> (R) %V4030.2	bit setup non programmato

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11 Label: Step:

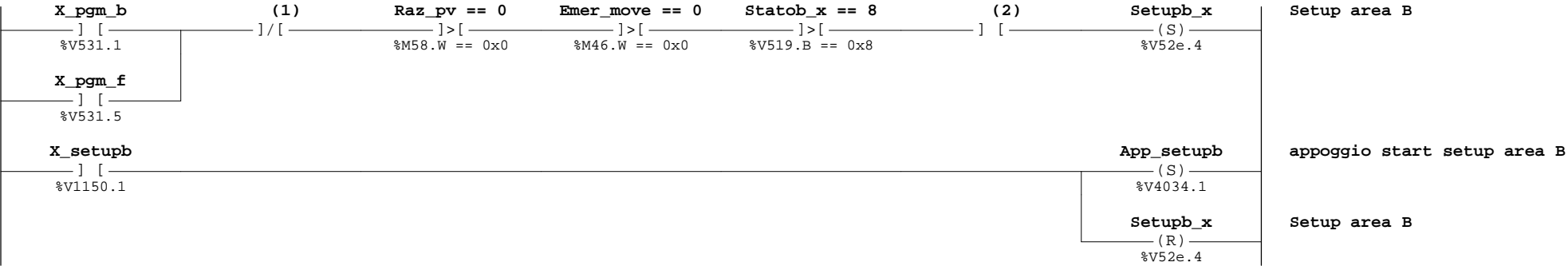
Start setup area A



(1) %V5b4.0, %V5b4.4, %V5b5.0, %V5b5.4, %V4034.0, %V4034.1, %V4034.2, %V4034.3 : X\_exec\_a, X\_exec\_e, X\_next\_a, X\_next\_e, App\_setupa, App\_setupb, App\_setupc, App\_setupd  
(2) %I5201.2, %I4101.4, %I4000.6 : Setup\_a, Sel\_man\_aut, Emer\_gen

12 Label: Step:

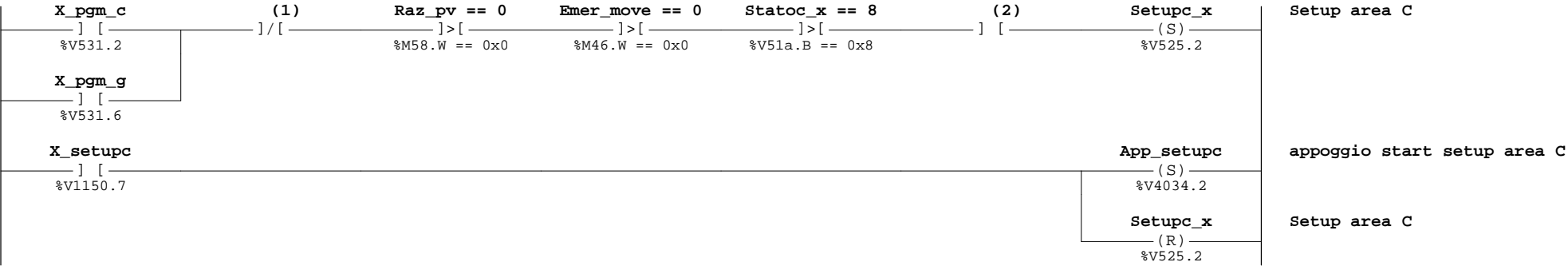
Start setup area B



(1) %V5b4.1, %V5b4.5, %V5b5.1, %V5b5.5, %V4034.0, %V4034.1, %V4034.2, %V4034.3 : X\_exec\_b, X\_exec\_f, X\_next\_b, X\_next\_f, App\_setupa, App\_setupb, App\_setupc, App\_setupd  
(2) %I5201.3, %I4101.4, %I4000.6 : Setup\_b, Sel\_man\_aut, Emer\_gen

13 Label: Step:

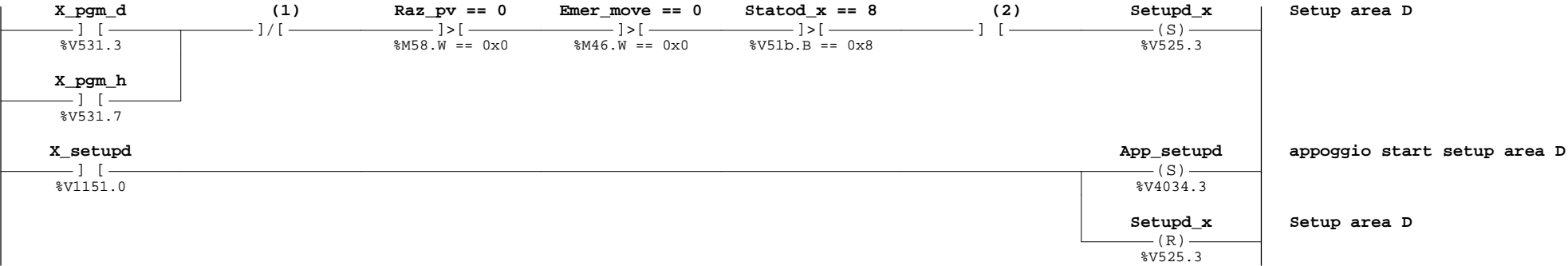
Start setup area C



- (1) %V5b4.2, %V5b4.6, %V5b5.2, %V5b5.6, %V4034.0, %V4034.1, %V4034.2, %V4034.3 : X\_exec\_c, X\_exec\_g, X\_next\_c, X\_next\_g, App\_setupa, App\_setupb, App\_setupc, App\_setupd
- (2) %I5201.4, %I4101.4, %I4000.6 : Setup\_c, Sel\_man\_aut, Emer\_gen

14 Label: Step:

Start setup area D



- (1) %V5b4.3, %V5b4.7, %V5b5.3, %V5b5.7, %V4034.0, %V4034.1, %V4034.2, %V4034.3 : X\_exec\_d, X\_exec\_h, X\_next\_d, X\_next\_h, App\_setupa, App\_setupb, App\_setupc, App\_setupd
- (2) %I5201.5, %I4101.4, %I4000.6 : Setup\_d, Sel\_man\_aut, Emer\_gen

15 Label: END Step:

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