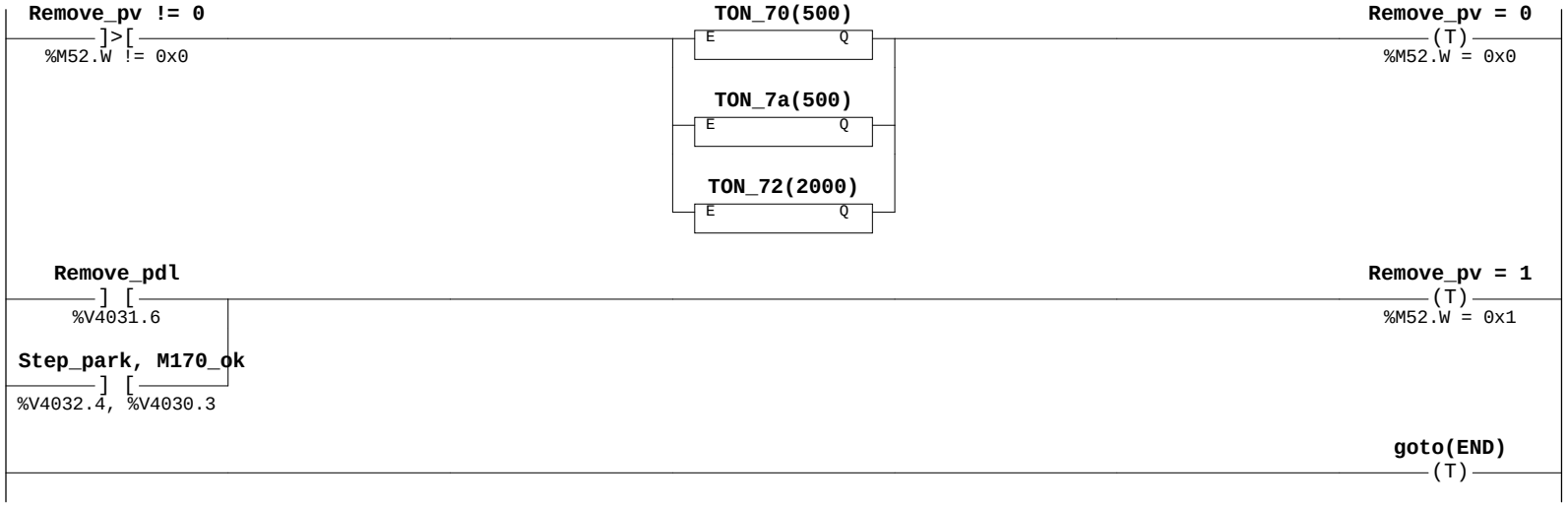
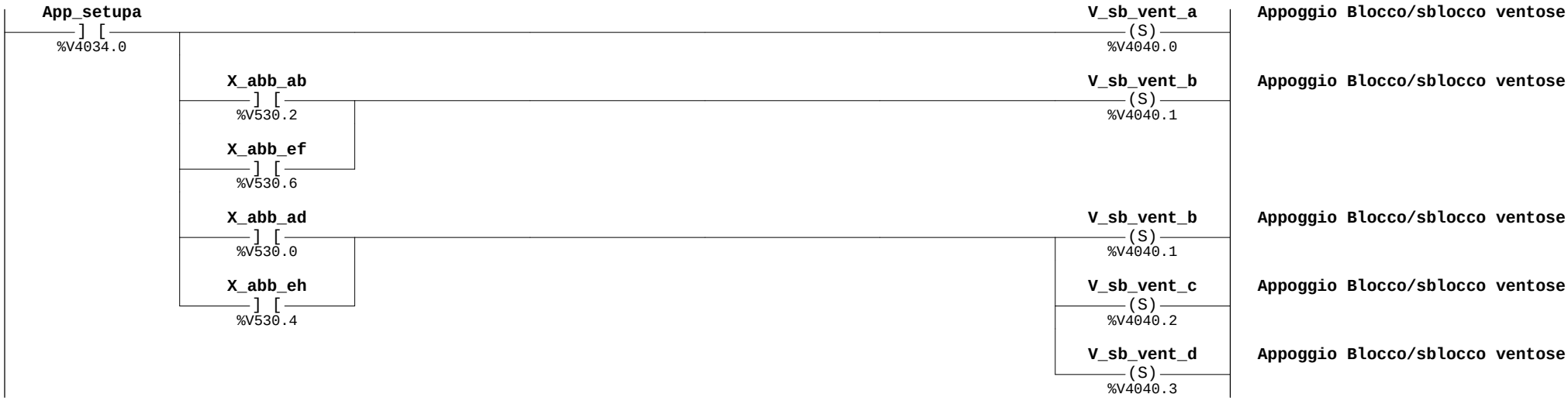
00 Label: Step: **Remove_pv** %M52.W **= 0**



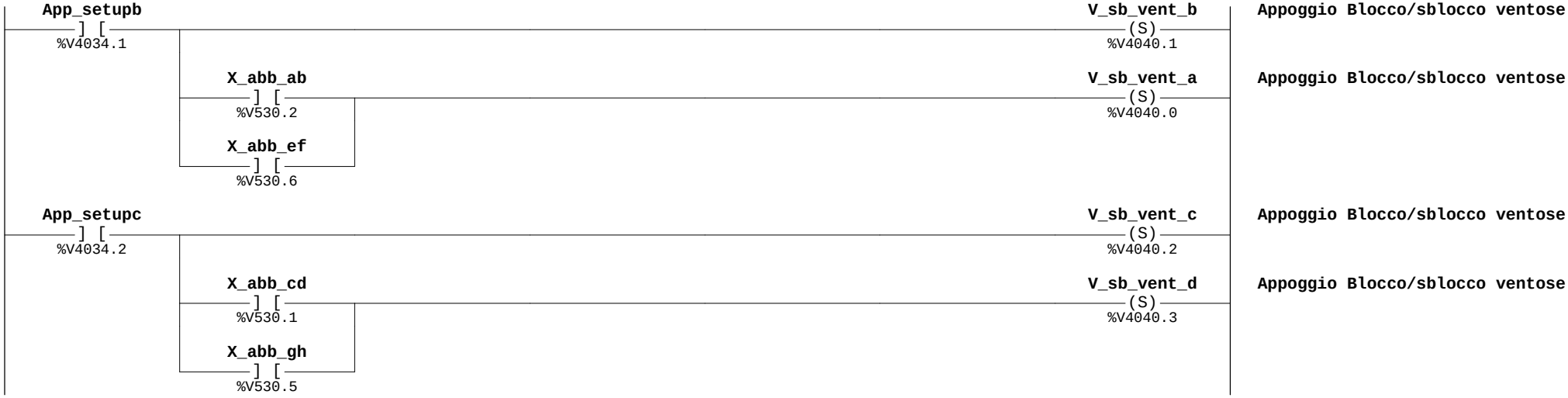
[T] TON_70(0x1f4) : TON_70(500)
[T] TON_7a(0x1f4) : TON_7a(500)
[T] TON_72(0x7d0) : TON_72(2000)

01 Label: Step: **Remove_pv** %M52.W **= 1**

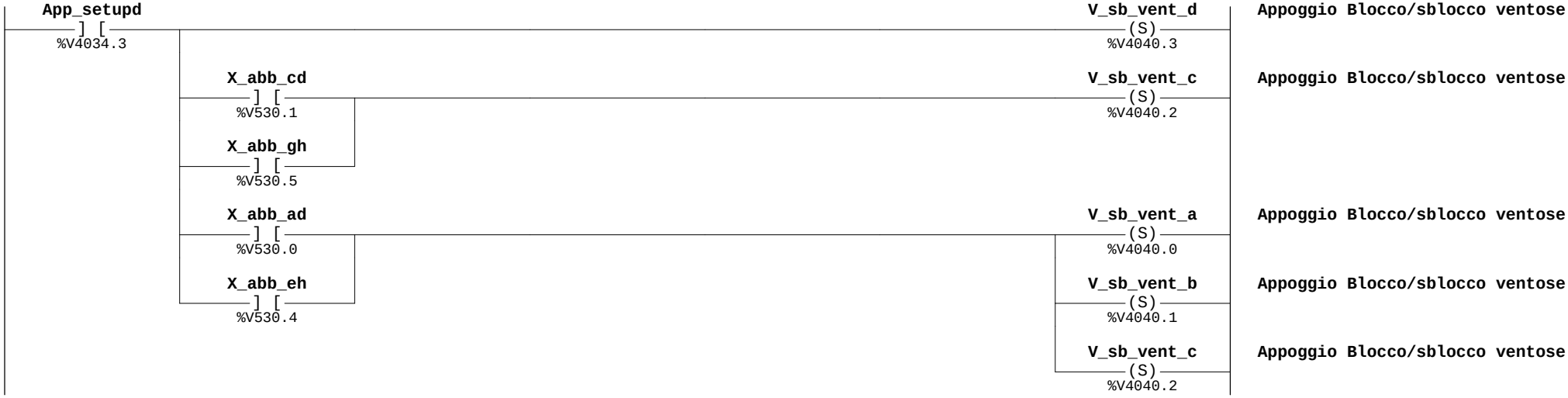


Author:		**NUM TOOLS**
Company:		
Project: **1040_78.mch**	**TITRE**	Date **28-02-2018**
Module: **REM_PV.XLA**	**%SP218 (00)**	Page **1**

02 Label: Step: **Remove_pv** %M52.W **= 1**



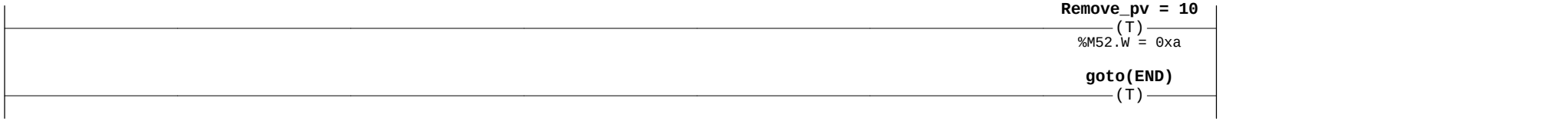
03 Label: Step: **Remove_pv** %M52.W **= 1**



04 Label: Step: **Remove_pv** %M52.W **= 1**

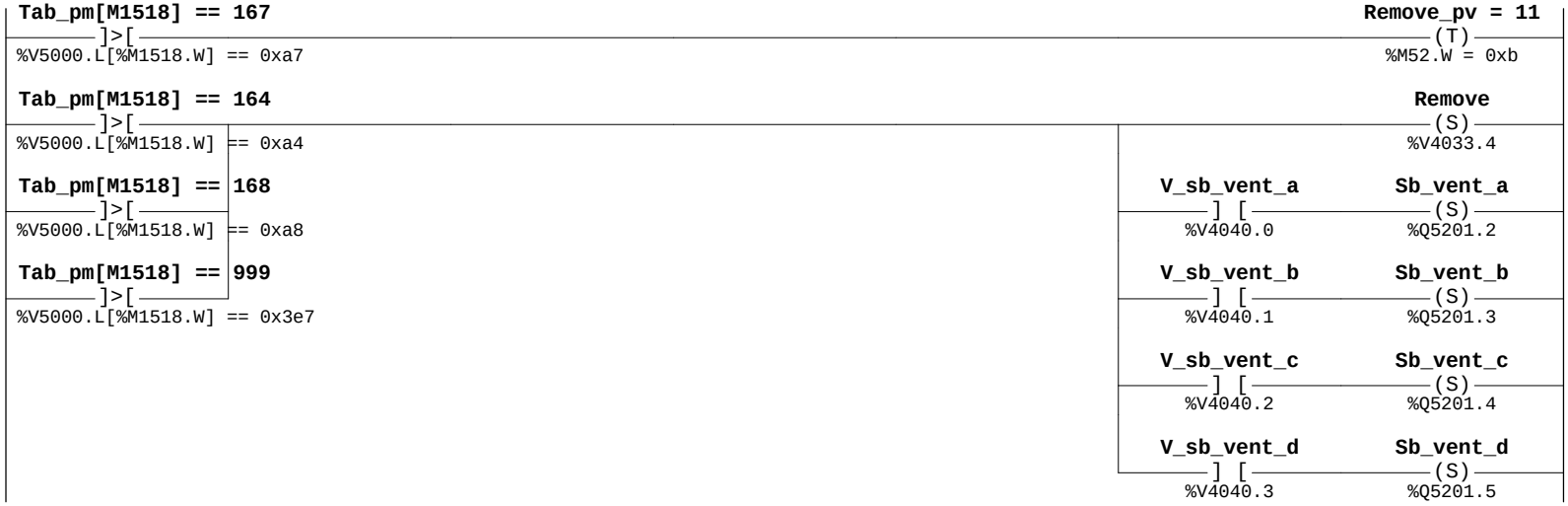
(1) %M1518.W = %V4038.W : M1518 = Index_remove
(2) %V402e.W = %M1518.W : Index_plc = M1518

05 Label: Step: **Remove_pv** %M52.W **= 1**

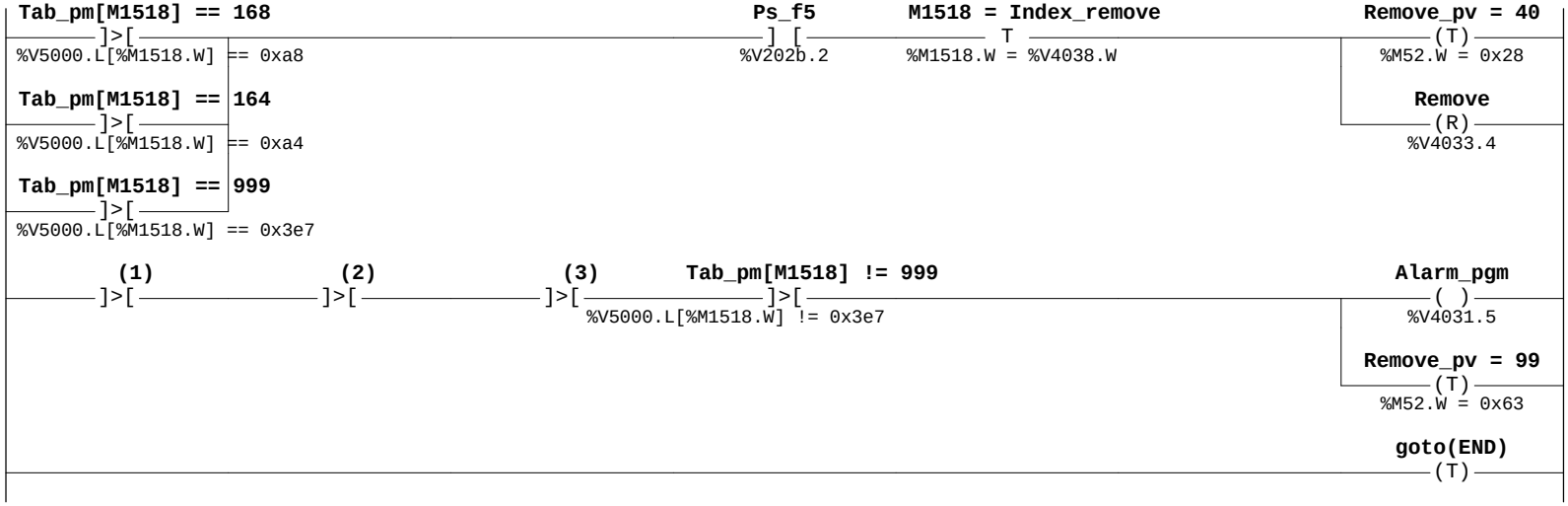


Author:		**NUM TOOLS**
Company:		
Project: **1040_78.mch**	**TITRE**	Date **28-02-2018**
Module: **REM_PV.XLA**	**%SP218 (04)**	Page **3**

06 Label: Step: **Remove_pv** %M52.W **= 10**



07 Label: Step: **Remove_pv** %M52.W **= 10**



(1) %V5000.L[%M1518.W] != 0xa4 : Tab_pm[M1518] != 164
(2) %V5000.L[%M1518.W] != 0xa7 : Tab_pm[M1518] != 167
(3) %V5000.L[%M1518.W] != 0xa8 : Tab_pm[M1518] != 168

08 Label: **Q_RIT2** Step: **Remove_pv** %M52.W **= 11** | Indice ventosa o piano |

M1518 = M1518 + 4 — T — %M1518.W = %M1518.W + 0x4 — **(1)** (T)

(1) %M1514.W = %V5000.L[%M1518.W] : M1514 = Tab_pm[M1518]

09 Label: Step: **Remove_pv** %M52.W **= 11** | Indice Motore |

M1518 = M1518 + 4 — T — %M1518.W = %M1518.W + 0x4 — **(1)** (T)

(1) %M1512.W = (%V5000.L[%M1518.W] - 0x1) * 0x10 : M1512 = (Tab_pm[M1518] - 1) * 16

10 Label: Step: **Remove_pv** %M52.W **= 11** | Indice Quota comandata |

(1) (T)

(1) %M1518.W = %M1518.W + 0x4 : M1518 = M1518 + 4

11 Label: Step: **Remove_pv** %M52.W **= 11** | index_1 = n° piano o ventosa |

Index_1 = 10 — T — %M1100.W = 0xa — **Index_2 = 0** — T — %M1102.W = 0x0 — **Index_8 = 0** — (T) — %M110e.W = 0x0

12 Label: **FASE11** Step: **Remove_pv** %M52.W **= 11** | Predisposizione start Syncro (ritorno)

M1514 == Index_1]>[%M1514.W == %M1100.W
Tab_pm[M1518] != Piano_10[Index_8]]>[%V5000.L[%M1518.W] != %M2010.L[%M110e.W]
(1) (S)
Move_ok (S) %V4030.0
goto(FASE11A) (T)
Index_1 += 1 (T) %M1100.W += 0x1
Index_2 += 1 (T) %M1102.W += 0x1
Index_8 += 4 (T) %M110e.W += 0x4

Predisposizione start motori

(1) %V7010.3[%M1512.W] : P_syncro_1[M1512]

13 Label: Step: **Remove_pv** %M52.W **= 11**

Index_1 > 126]>[%M1100.W > 0x7e
Alarm_pgm ( ) %V4031.5
Remove_pv = 99 (T) %M52.W = 0x63
Index_2 < 7]>[%M1102.W < 0x7
goto(FASE11) (T)
Index_2 == 7]>[%M1102.W == 0x7
Index_2 = 0 T %M1102.W = 0x0
Index_1 += 3 T %M1100.W += 0x3

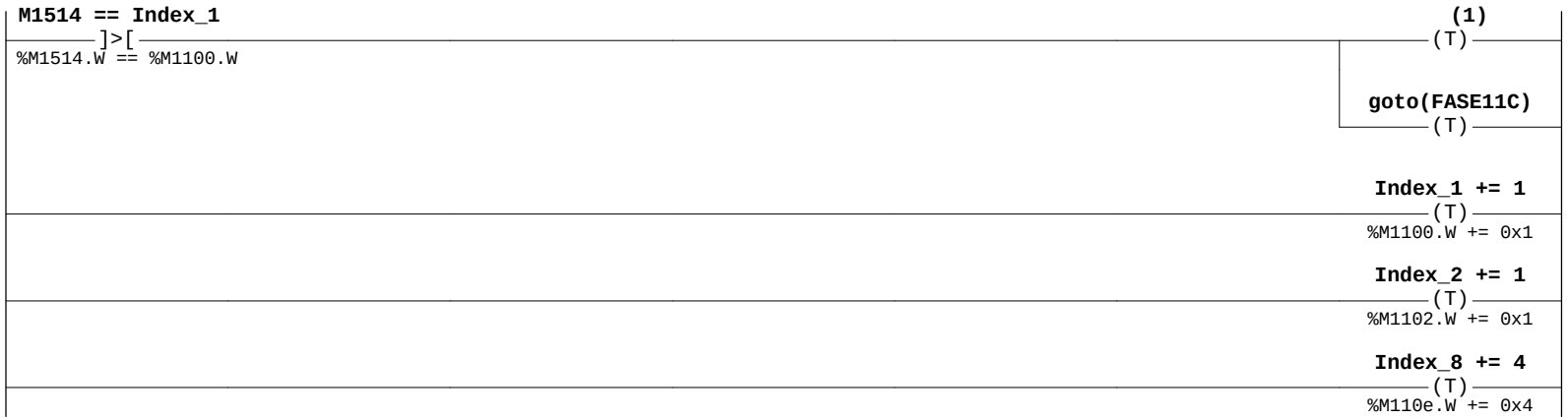
tentativo di posizionare una ven

14 Label: **FASE11A** Step: **Remove_pv** %M52.W **= 11** | Assegnazione Quota comandata

Index_1 = 10 T %M1100.W = 0xa
Index_2 = 0 T %M1102.W = 0x0
Index_8 = 0 (T) %M110e.W = 0x0

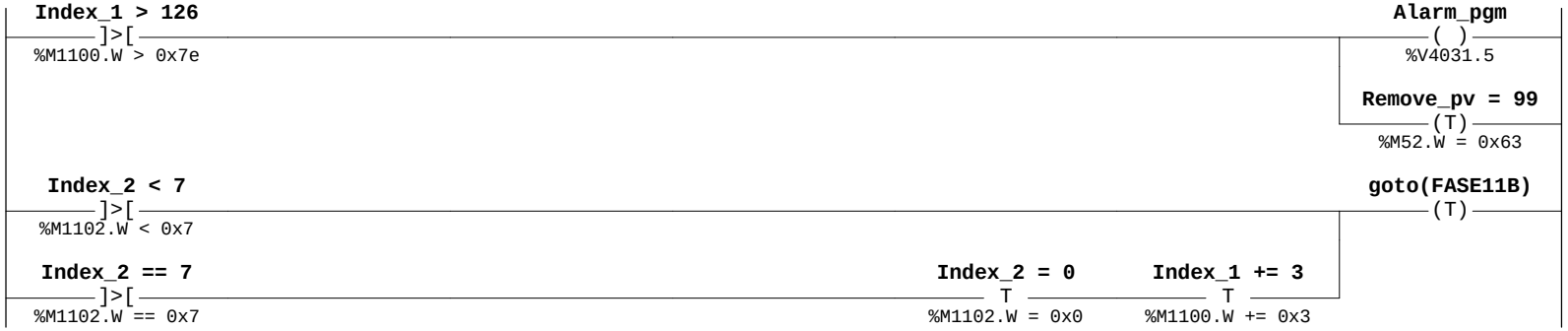
Author:		**NUM TOOLS**
Company:		
Project: **1040_78.mch**	**TITRE**	Date **28-02-2018**
Module: **REM_PV.XLA**	**%SP218 (12)**	Page **6**

15 Label: **FASE11B** Step: **Remove_pv** %M52.W **= 11**



(1) %V7012.L[%M1512.W] = %M2010.L[%M110e.W] : Q_prog_1[M1512] = Piano_10[Index_8]

16 Label: Step: **Remove_pv** %M52.W **= 11**



tentativo di posizionare una ven

17 Label: **FASE11C** Step: **Remove_pv** %M52.W **= 11**

Indice velocità

(1) %M1518.W = %M1518.W + 0x4 : M1518 = M1518 + 4

18 Label: Step: **Remove_pv** %M52.W **= 11** Assegnazione Velocità

(1)
(T)

(1) %V7016.W[%M1512.W] = %V4400.L : Feed_1[M1512] = Velocita

19 Label: Step: **Remove_pv** %M52.W **= 11**

(1)
(T)

(1) %M1518.W = %M1518.W + 0x8 : M1518 = M1518 + 8

20 Label: Step: **Remove_pv** %M52.W **= 11** Verifica indice

Tab_pm[M1518] == 167 **goto(Q_RIT2)**
]>[(T)
%V5000.L[%M1518.W] == 0xa7

Tab_pm[M1518] == 170 **Index_170 = M1518 + 4** **M170_ok** **lettura valore 170**
]>[T (S)
%V5000.L[%M1518.W] == 0xaa %V402c.W = %M1518.W + 0x4 %V4030.3

Remove_pv = 12
(T)
%M52.W = 0xc

(1) **Tab_pm[M1518] != 170** **Alarm_pgm** **tentativo di posizionare una ven**
]>[ ]>[( )
%V5000.L[%M1518.W] != 0xaa %V4031.5

Remove_pv = 99
(T)
%M52.W = 0x63

goto(END)
(T)

(1) %V5000.L[%M1518.W] != 0xa7 : Tab_pm[M1518] != 167

21 Label: Step: **Remove_pv** %M52.W **= 12** Reset dispositivo di aggancio

Cil_std = 0
(T)
%Q5200.B = 0x0

Cil_pdl_ab **Abil. cilindro aggancio area AB**
(R)
%Q5201.0

Cil_pdl_cd **Abil. cilindro aggancio area CD**
(R)
%Q5201.1

Cil_add = 0
(T)
%Q5400.B = 0x0

22 Label: Step: **Remove_pv** %M52.W **= 12** Start asse n..... se predisposto e posiz. pistone a quota corr.

(1)]>[
Pdl_ab]/[%I5201.0
Pdl_cd]/[%I5201.1
Vent_pdl_add == 0]>[%I5400.B == 0x0

Start_move **start movimentazione motori**
(S)
%V4030.7

Remove_pv = 13
(T)
%M52.W = 0xd

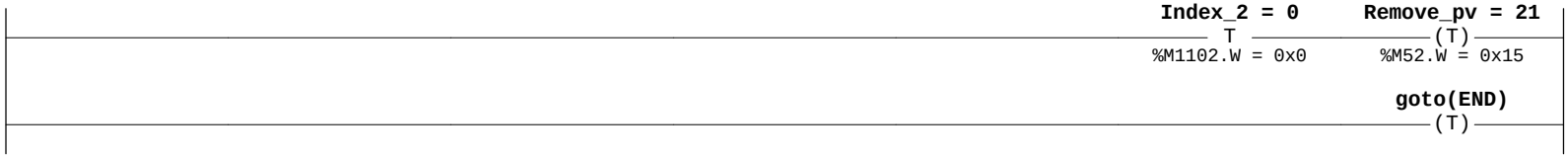
goto(END)
(T)

(1) %I5200.B == 0x0 : Vent_pdl_std == 0

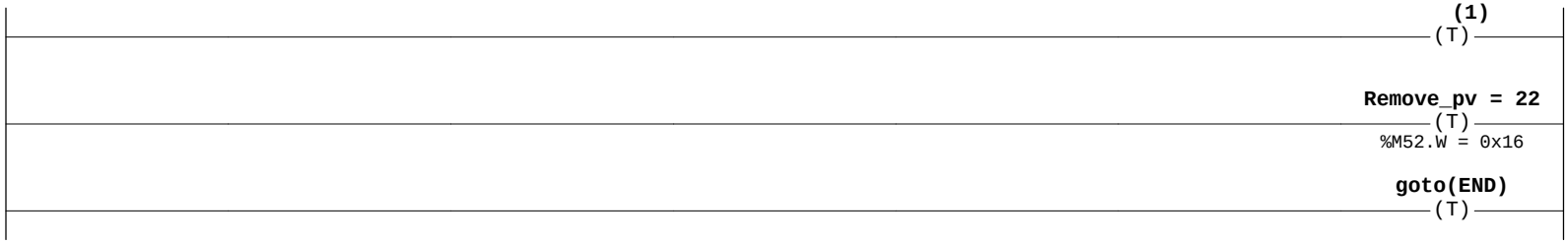
Author:		**NUM TOOLS**
Company:		
Project: **1040_78.mch**	**TITRE**	Date **28-02-2018**
Module: **REM_PV.XLA**	**%SP218 (21)**	Page **9**

23 Label: Step: **Remove_pv** %M52.W **= 13**

24 Label: Step: **Remove_pv** %M52.W **= 20**



25 Label: Step: **Remove_pv** %M52.W **= 21** Indice di Spaziamento



(1) %M1518.W = %V402e.W : M1518 = Index_plc

Author:		**NUM TOOLS**
Company:		
Project: **1040_78.mch**	**TITRE**	Date **28-02-2018**
Module: **REM_PV.XLA**	**%SP218 (23)**	Page **10**

26 Label: Step: **Remove_pv** %M52.W **= 22**

Tab_pm[M1518] == 167]>[%V5000.L[%M1518.W] == 0xa7 — **Remove_pv = 23** (T) %M52.W = 0x17

Tab_pm[M1518] != 167]>[%V5000.L[%M1518.W] != 0xa7 — **Alarm_pgm** ( ) %V4031.5

Remove_pv = 99 (T) %M52.W = 0x63

goto(END) (T)

tentativo di posizionare una ven

27 Label: **Q_SETUP2** Step: **Remove_pv** %M52.W **= 23**

Indice ventosa o piano

M1518 = M1518 + 4 T %M1518.W = %M1518.W + 0x4 — **(1)** (T)

(1) %M1514.W = %V5000.L[%M1518.W] : M1514 = Tab_pm[M1518]

28 Label: Step: **Remove_pv** %M52.W **= 23**

Appoggio su V4000 piano e ventose PGM

(1) (T)

Index_10 += 1 (T) %M1112.W += 0x1

(1) %V4000.B[%M1112.W] = %M1514.W : V4000[Index_10] = M1514

29 Label: Step: **Remove_pv** %M52.W **= 23**

Indice Motore

M1518 = M1518 + 4 T %M1518.W = %M1518.W + 0x4 — **(1)** (T)

(1) %M1512.W = (%V5000.L[%M1518.W] - 0x1) * 0x10 : M1512 = (Tab_pm[M1518] - 1) * 16

30 Label: Step: **Remove_pv** %M52.W **= 23**

Indice Quota comandata

(1)
(T)

(1) %M1518.W = %M1518.W + 0x4 : M1518 = M1518 + 4

31 Label: Step: **Remove_pv** %M52.W **= 23**

Index_1 = 10 T %M1100.W = 0xa
Index_2 = 0 T %M1102.W = 0x0
Index_3 = 0 T %M1104.W = 0x0
Index_8 = 0 (T) %M110e.W = 0x0

32 Label: **FASE23** Step: **Remove_pv** %M52.W **= 23**

M1514 == Index_1]>[%M1514.W == %M1100.W
Tab_pm[M1518] != Piano_10[Index_8]]>[%V5000.L[%M1518.W] != %M2010.L[%M110e.W]
(1) (S)
Sincro_10_[Index_3] (S) %V4500.3[%M1104.W]
Move_ok (S) %V4030.0
goto(FASE23A) (T)

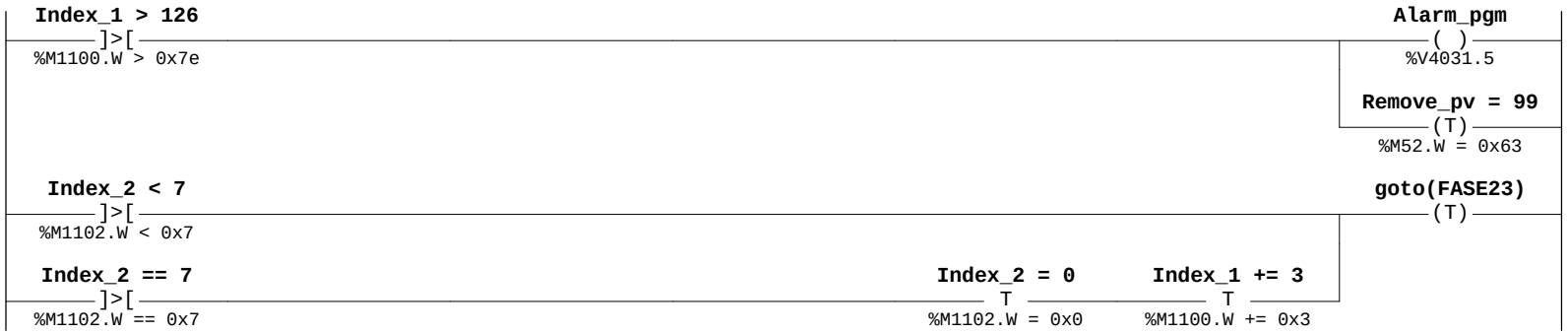
Predisposizione start motori

(1) %V7010.3[%M1512.W] : P_syncro_1[M1512]

33 Label: Step: **Remove_pv** %M52.W **= 23**

Index_1 += 1 (T) %M1100.W += 0x1
Index_3 += 1 (T) %M1104.W += 0x1
Index_2 += 1 (T) %M1102.W += 0x1
Index_8 += 4 (T) %M110e.W += 0x4

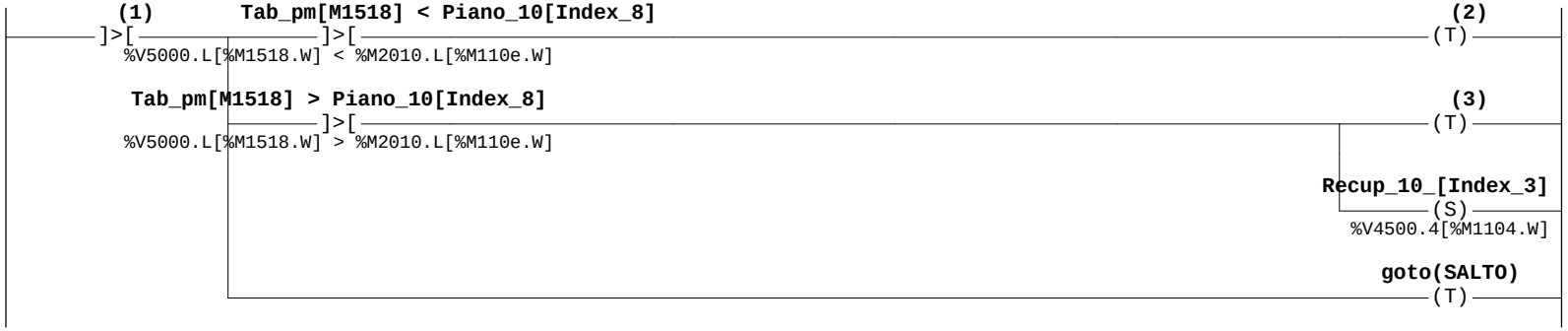
34 Label: Step: **Remove_pv** %M52.W **= 23**



tentativo di posizionare una ven

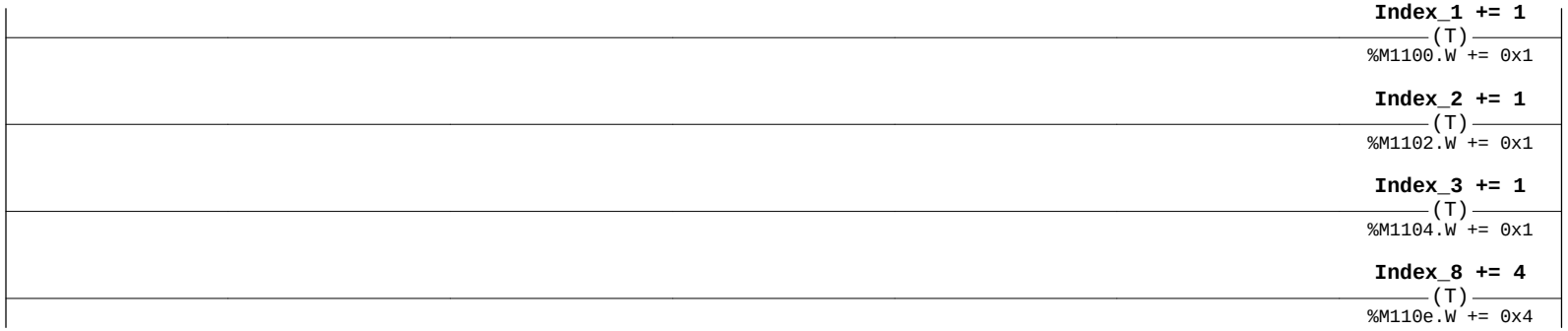
35 Label: **FASE23A** Step: **Remove_pv** %M52.W **= 23**

36 Label: **FASE23B** Step: **Remove_pv** %M52.W **= 23**

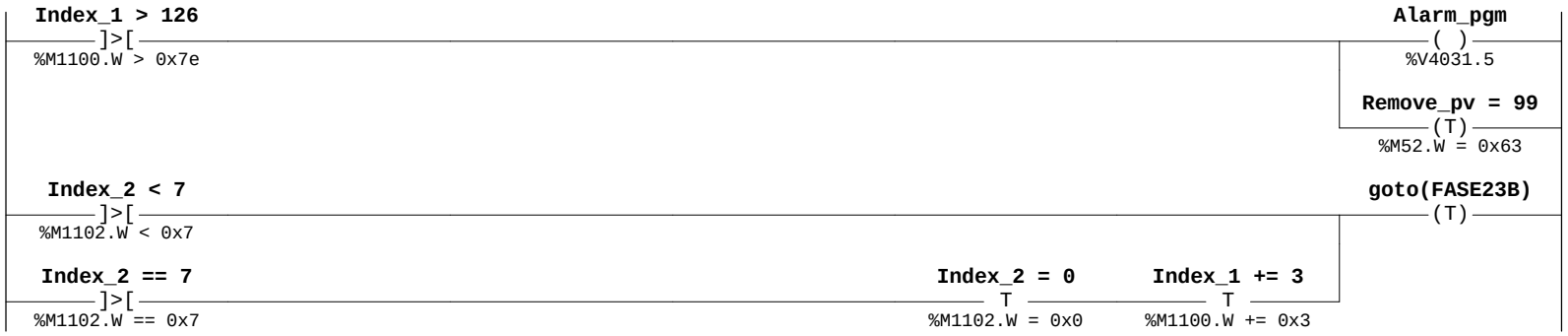


(1) %M1514.W == %M1100.W : M1514 == Index_1
(2) %V7012.L[%M1512.W] = %V5000.L[%M1518.W] - %V1290.B[%M1104.W] : Q_prog_1[M1512] = Tab_pm[M1518] - Tab_asola[Index_3]
(3) %V7012.L[%M1512.W] = %V5000.L[%M1518.W] + %V1290.B[%M1104.W] : Q_prog_1[M1512] = Tab_pm[M1518] + Tab_asola[Index_3]

37 Label: Step: **Remove_pv** %M52.W **= 23**



38 Label: Step: **Remove_pv** %M52.W **= 23**



tentativo di posizionare una ven

39 Label: **SALTO** Step: **Remove_pv** %M52.W **= 23**

Indice velocità

(1) %M1518.W = %M1518.W + 0x4 : M1518 = M1518 + 4

40 Label: Step: **Remove_pv** %M52.W **= 23**

Assegnazione Velocità

(1) %V7016.W[%M1512.W] = %V4400.L : Feed_1[M1512] = Velocita

41 Label: Step: **Remove_pv** %M52.W **= 23** — incremento indice

```
                                                                      (1)
|---------------------------------------------------------------------(T)---|
```

(1) %M1518.W = %M1518.W + 0x8 : M1518 = M1518 + 8

42 Label: Step: **Remove_pv** %M52.W **= 23** — Verifica indice

```
 Tab_pm[M1518] == 167                                          goto(Q_SETUP2)
|----]>[-------------------------------------------------------------(T)----|
 %V5000.L[%M1518.W] == 0xa7

 Tab_pm[M1518] == 170              V4000[Index_10] = 127      Remove_pv = 24
|----]>[---------------------------------------T---------------------(T)----|
 %V5000.L[%M1518.W] == 0xaa        %V4000.B[%M1112.W] = 0x7f   %M52.W = 0x18

        (1)      Tab_pm[M1518] != 170                             Alarm_pgm      tentativo di posizionare una ven
|----]>[-----------]>[--------------------------------------+--------( )----|
          %V5000.L[%M1518.W] != 0xaa                        |       %V4031.5
                                                            |
                                                            |     Remove_pv = 99
                                                            +--------(T)----|
                                                                   %M52.W = 0x63

                                                                    goto(END)
|--------------------------------------------------------------------(T)----|
```

(1) %V5000.L[%M1518.W] != 0xa7 : Tab_pm[M1518] != 167

43 Label: Step: **Remove_pv** %M52.W **= 24**

```
  P_syncro_1      Pistab_no_ok                                  Cil_pdl_ab     Abil. cilindro aggancio area AB
|-----] [-----+------]/[----------------------------------------(S)-------|
   %V7010.3   |    %V4561.4                                     %Q5201.0
              |
              |   Pistab_no_ok                                  Cil_pdl_ab     Abil. cilindro aggancio area AB
              +------] [----------------------------------------(R)-------|
                   %V4561.4                                     %Q5201.0

  P_syncro_2      Pistcd_no_ok                                  Cil_pdl_cd     Abil. cilindro aggancio area CD
|-----] [-----+------]/[----------------------------------------(S)-------|
   %V7020.3   |    %V4561.5                                     %Q5201.1
              |
              |   Pistcd_no_ok                                  Cil_pdl_cd     Abil. cilindro aggancio area CD
              +------] [----------------------------------------(R)-------|
                   %V4561.5                                     %Q5201.1
```

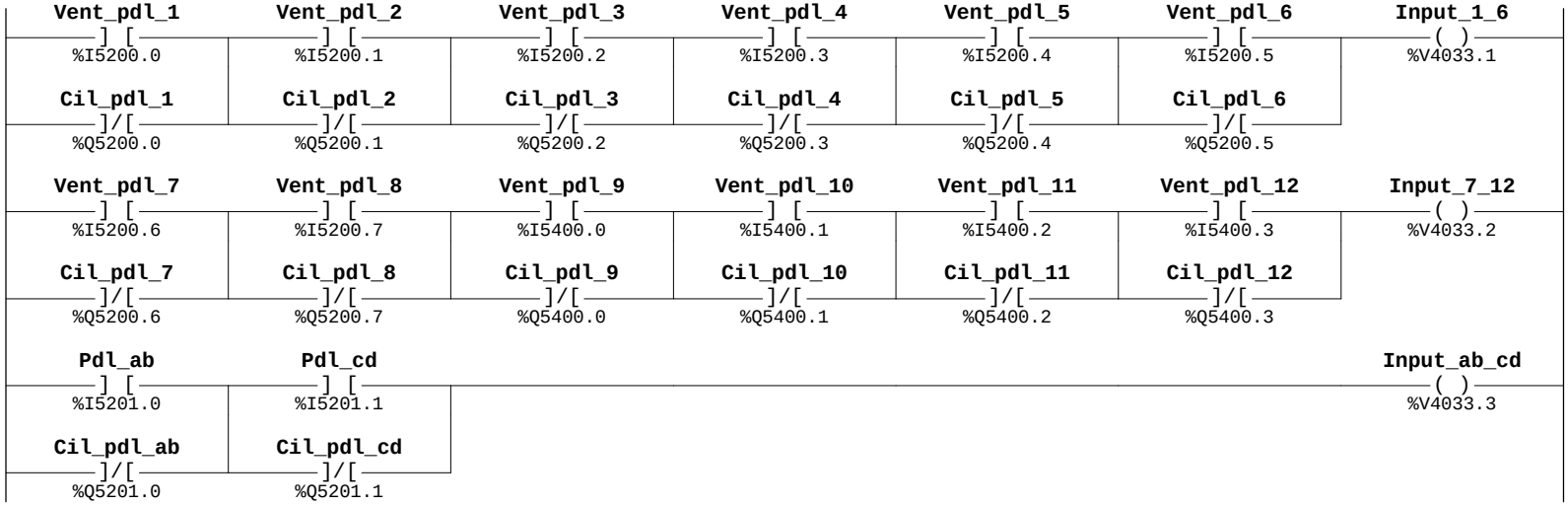
44 Label: Step: **Remove_pv** %M52.W **= 24**

45 Label: Step: **Remove_pv** %M52.W **= 24**

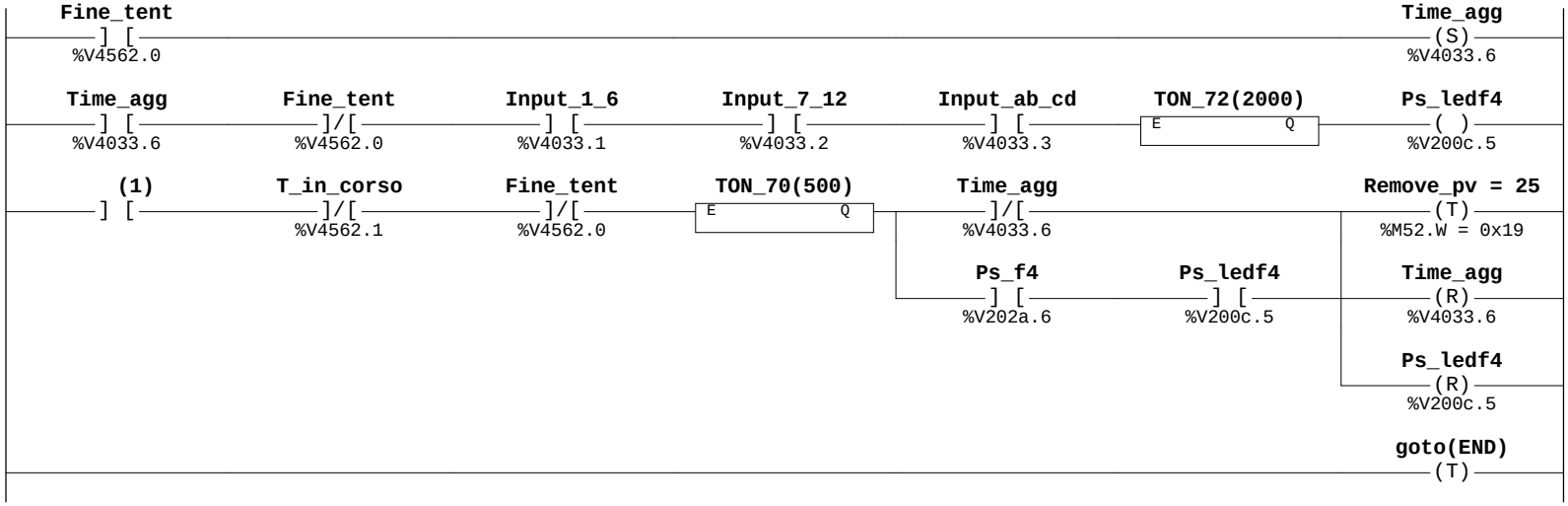
46 Label: Step: **Remove_pv** %M52.W **= 24**

47 Label: Step: **Remove_pv** %M52.W **= 24**

48 Label: Step: **Remove_pv** %M52.W **= 24**



49 Label: Step: **Remove_pv** %M52.W **= 24**

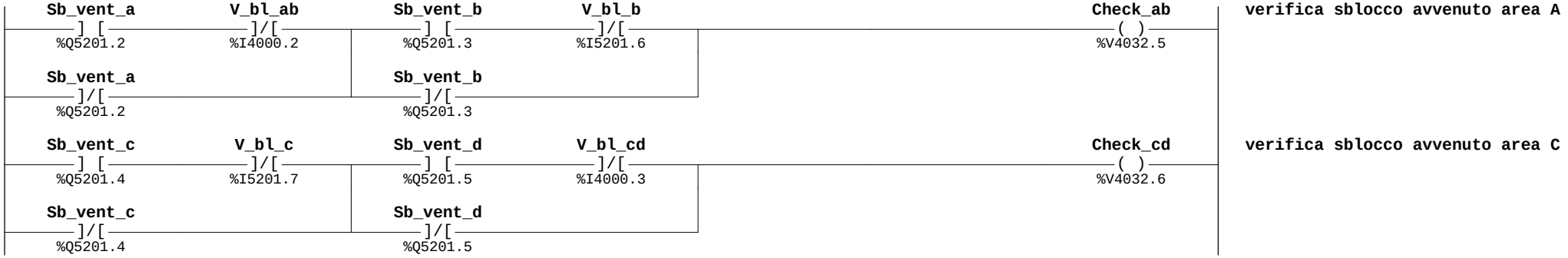


(1) %V4033.1, %V4033.2, %V4033.3 : Input_1_6, Input_7_12, Input_ab_cd
[T] TON_72(0x7d0) : TON_72(2000)
[T] TON_70(0x1f4) : TON_70(500)

Author:		**NUM TOOLS**
Company:		
Project: **1040_78.mch**	**TITRE**	Date **28-02-2018**
Module: **REM_PV.XLA**	**%SP218 (48)**	Page **18**

50 Label: Step: **Remove_pv** %M52.W **= 25**

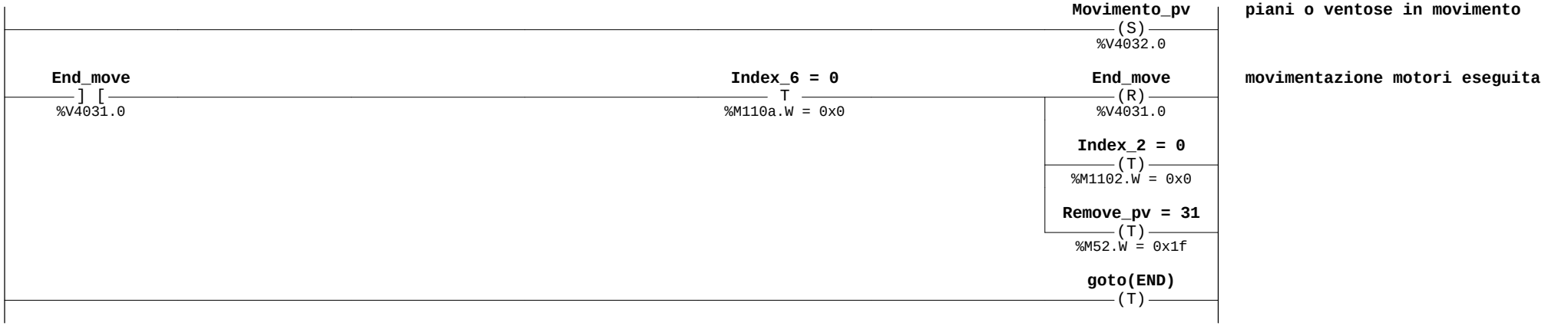
51 Label: Step: **Remove_pv** %M52.W **= 25**



52 Label: Step: **Remove_pv** %M52.W **= 25**

Start asse n..... se predisposto e pos. a quota programma

53 Label: Step: **Remove_pv** %M52.W **= 26**



54 Label: **RESET** Step: **Remove_pv** %M52.W **= 31**

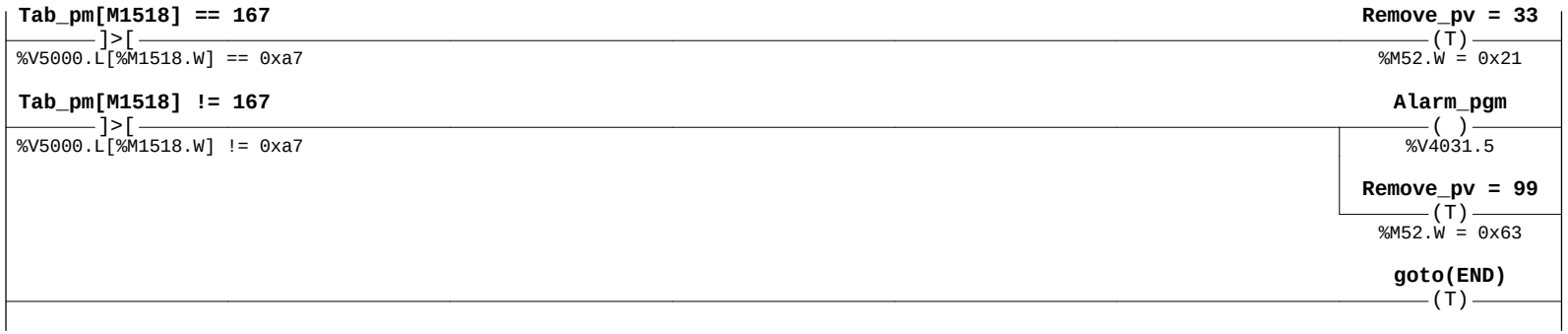
(1) %V4500.3[%M110a.W] : Sincro_10_[Index_6]

55 Label: Step: **Remove_pv** %M52.W **= 31**

indice di spaziamento

(1) %M1518.W = %V402e.W : M1518 = Index_plc

56 Label: Step: **Remove_pv** %M52.W **= 32**



tentativo di posizionare una ven

57 Label: **M_CORR2** Step: **Remove_pv** %M52.W **= 33**

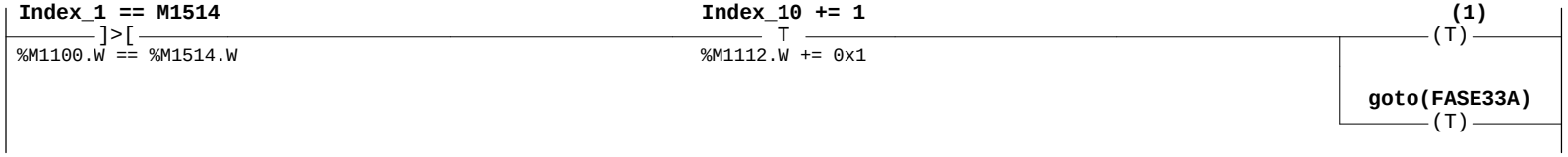
(1) %M1514.W = %V5000.L[%M1518.W] : M1514 = Tab_pm[M1518]

58 Label: Step: **Remove_pv** %M52.W **= 33**

59 Label: Step: **Remove_pv** %M52.W **= 33** indice quota comandata

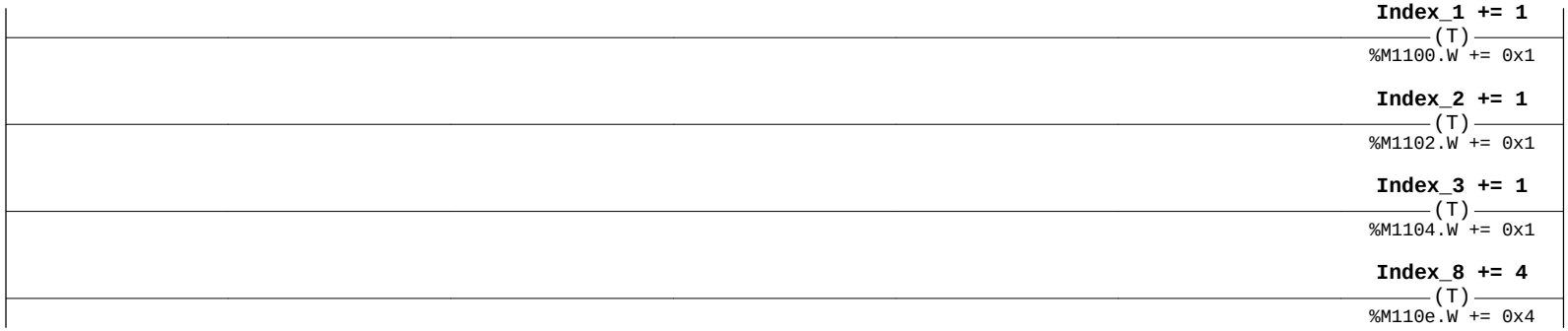
(1) %M1518.W = %M1518.W + 0x8 : M1518 = M1518 + 8

60 Label: **FASE33** Step: **Remove_pv** %M52.W **= 33** Memorizzazione Quote ventose

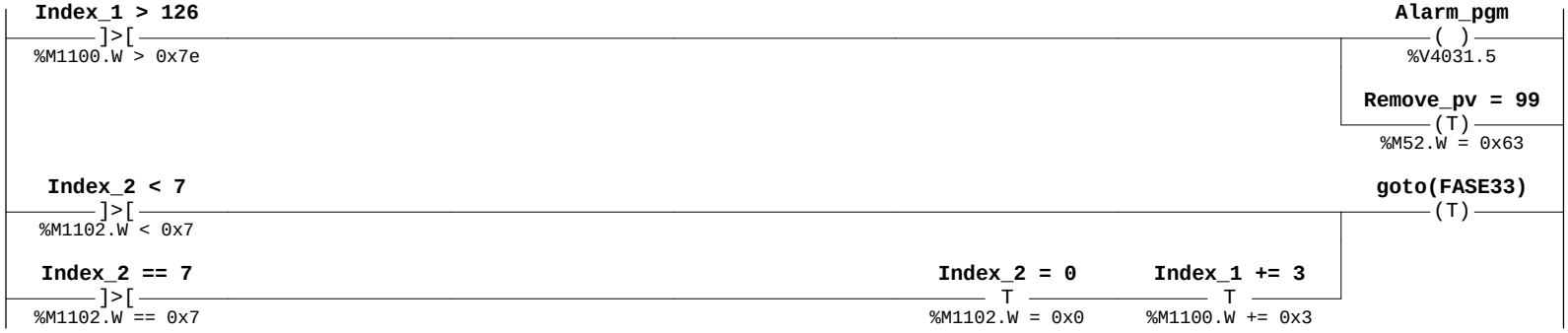


(1) %M2010.L[%M110e.W] = %V5000.L[%M1518.W] : Piano_10[Index_8] = Tab_pm[M1518]

61 Label: Step: **Remove_pv** %M52.W **= 33**

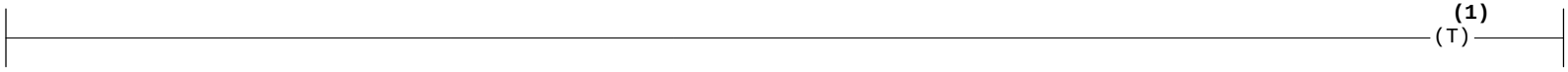


62 Label: Step: **Remove_pv** %M52.W **= 33**



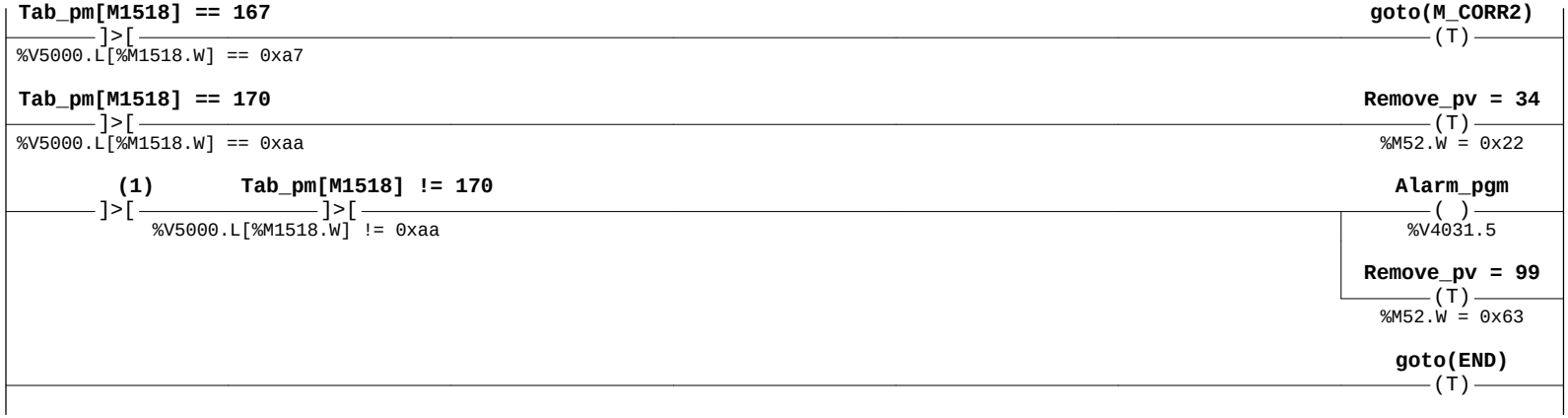
tentativo di posizionare una ven

63 Label: **FASE33A** Step: **Remove_pv** %M52.W **= 33**



(1) %M1518.W = %M1518.W + 0xc : M1518 = M1518 + 12

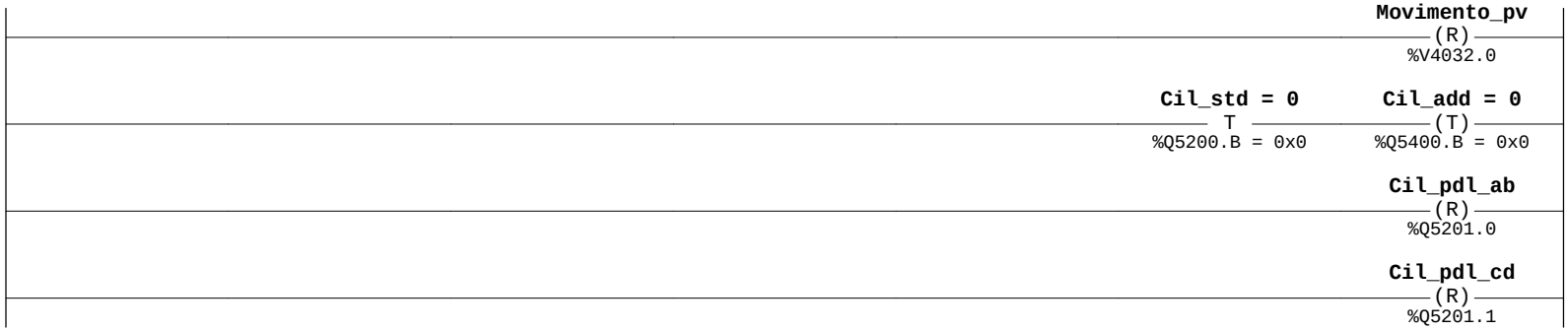
64 Label: Step: **Remove_pv** %M52.W **= 33**



tentativo di posizionare una ven

(1) %V5000.L[%M1518.W] != 0xa7 : Tab_pm[M1518] != 167

65 Label: Step: **Remove_pv** %M52.W **= 34**

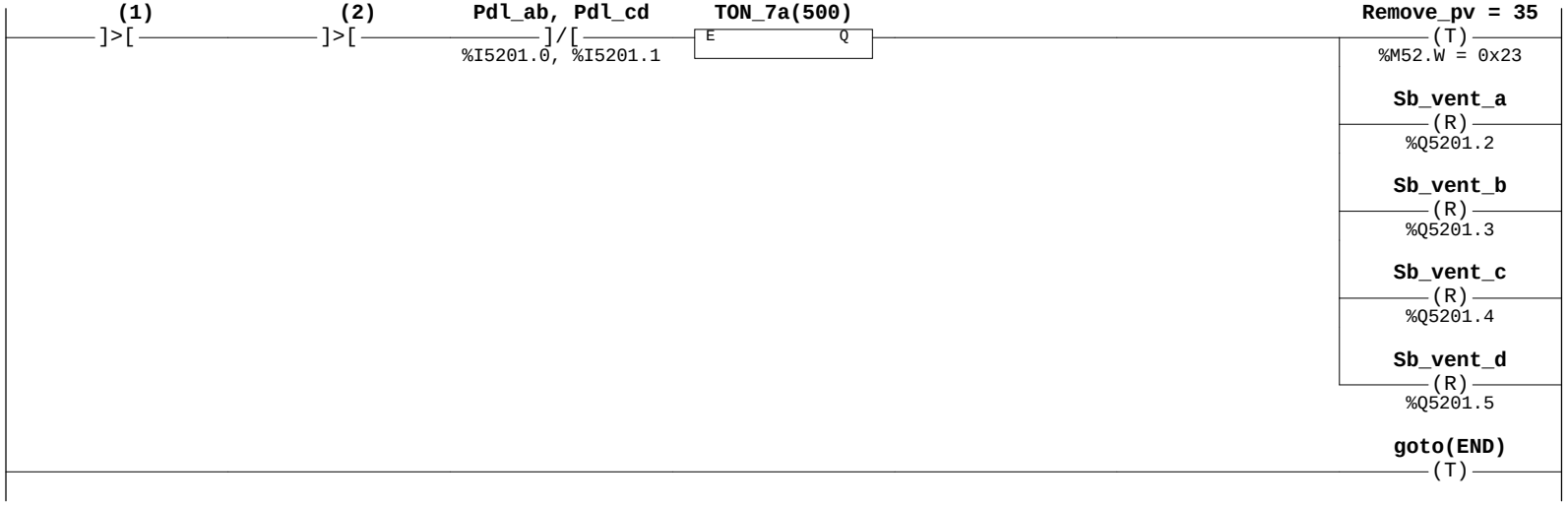


piani o ventose in movimento

Abil. cilindro aggancio area AB

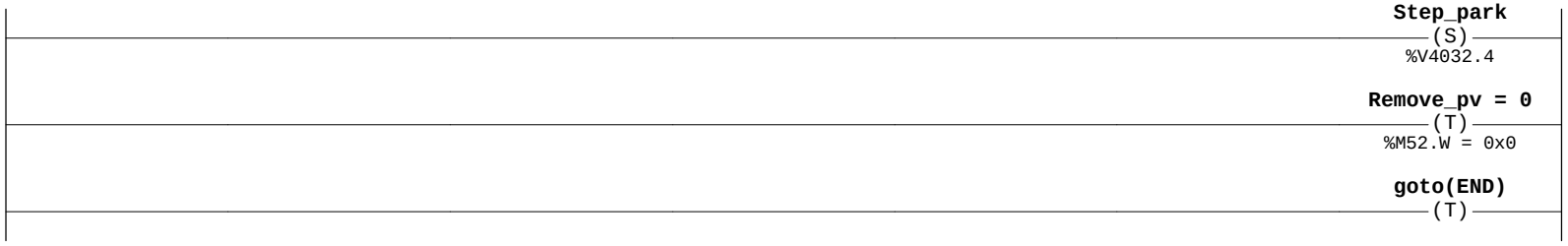
Abil. cilindro aggancio area CD

66 Label: Step: **Remove_pv** %M52.W **= 34**

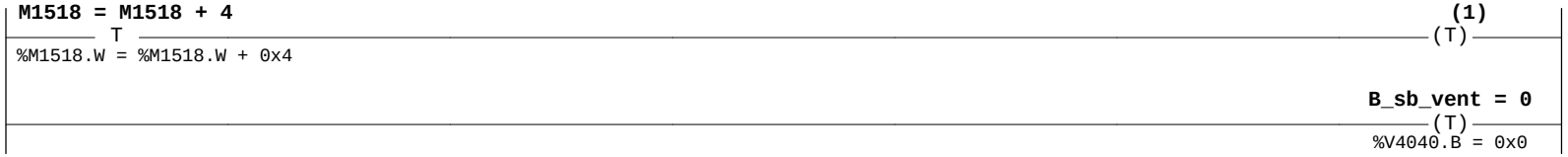


(1) %I5200.B == 0x0 : Vent_pdl_std == 0
(2) %I5400.B == 0x0 : Vent_pdl_add == 0
[T] TON_7a(0x1f4) : TON_7a(500)

67 Label: Step: **Remove_pv** %M52.W **= 35**



68 Label: **M_CORRF5** Step: **Remove_pv** %M52.W **= 40**

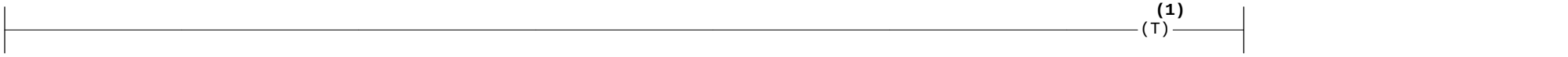


(1) %M1514.W = %V5000.L[%M1518.W] : M1514 = Tab_pm[M1518]

Author:		**NUM TOOLS**
Company:		
Project: **1040_78.mch**	**TITRE**	Date **28-02-2018**
Module: **REM_PV.XLA**	**%SP218 (66)**	Page **25**

69 Label: Step: **Remove_pv** %M52.W **= 40**

70 Label: Step: **Remove_pv** %M52.W **= 40** Indice quota di prelievo

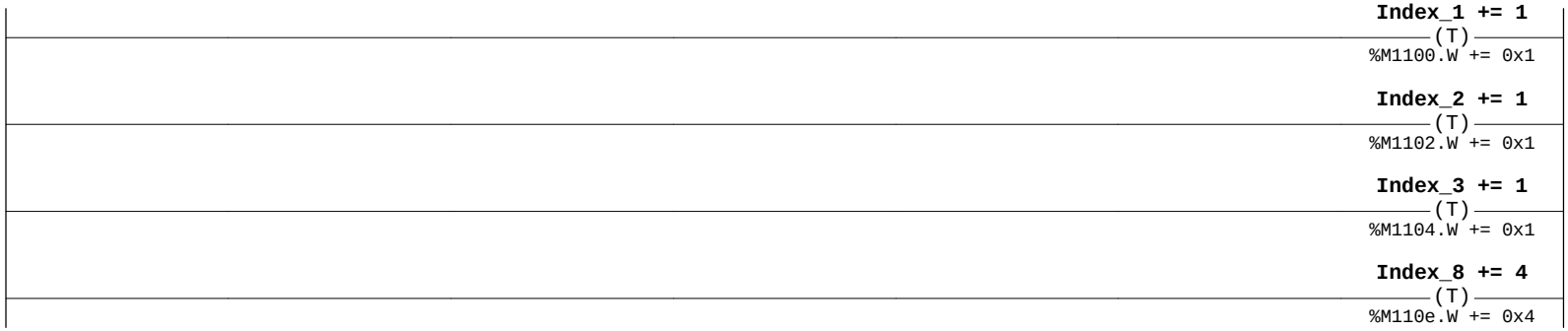


(1) %M1518.W = %M1518.W + 0x10 : M1518 = M1518 + 16

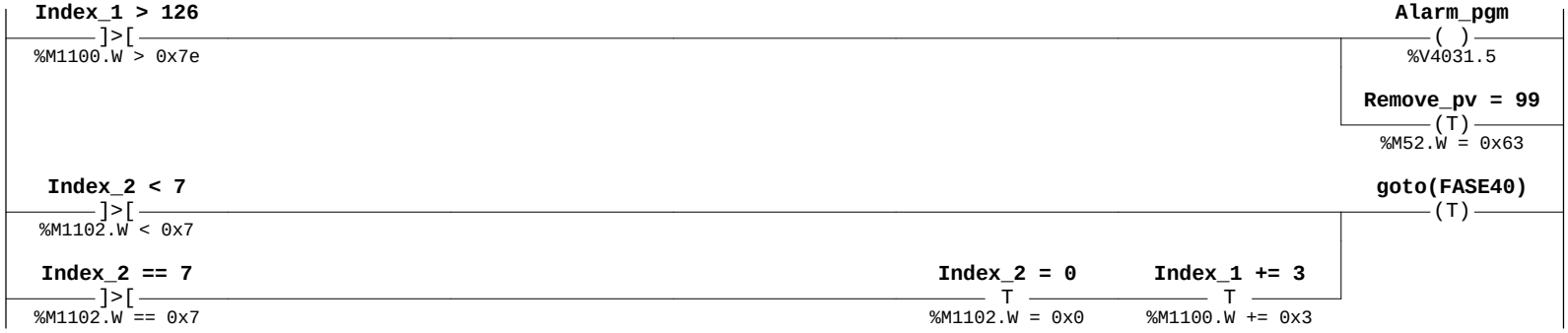
71 Label: **FASE40** Step: **Remove_pv** %M52.W **= 40**

(1) %M2010.L[%M110e.W] = %V5000.L[%M1518.W] : Piano_10[Index_8] = Tab_pm[M1518]

72 Label: Step: **Remove_pv** %M52.W **= 40**

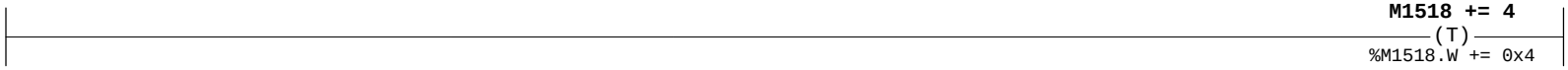


73 Label: Step: **Remove_pv** %M52.W **= 40**



tentativo di posizionare una ven

74 Label: **FASE40A** Step: **Remove_pv** %M52.W **= 40**



75 Label: Step: **Remove_pv** %M52.W **= 40**

Tab_pm[M1518] == 167 — **goto(M_CORRF5)** (T)
%V5000.L[%M1518.W] == 0xa7

Tab_pm[M1518] == 170 — **M1518 += 4** (T)
%V5000.L[%M1518.W] == 0xaa — %M1518.W += 0x4

(1) **Tab_pm[M1518] != 170** — **Alarm_pgm** ( ) — **tentativo di posizionare una ven**
%V5000.L[%M1518.W] != 0xaa — %V4031.5

Remove_pv = 99 (T)
%M52.W = 0x63

goto(END) (T)

(1) %V5000.L[%M1518.W] != 0xa7 : Tab_pm[M1518] != 167

76 Label: Step: **Remove_pv** %M52.W **= 40**

Tab_pm[M1518] == 167 — **goto(M_CORRF5)** (T)
%V5000.L[%M1518.W] == 0xa7

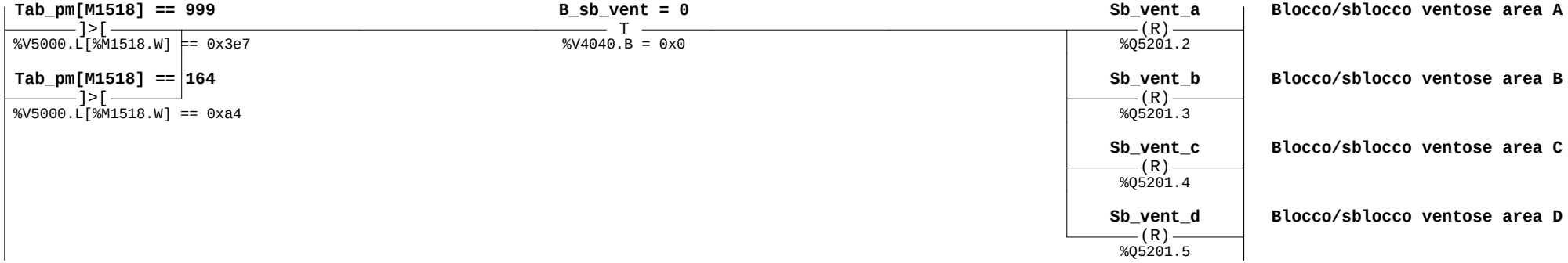
Tab_pm[M1518] == 168 — **Index_setup = M1518** T — **Setup_pdl** (S) — **start ciclo di setup**
%V5000.L[%M1518.W] == 0xa8 — %V402a.W = %M1518.W — %V4030.1

Ps_ledf4 (R) — **Led tasto F4**
%V200c.5

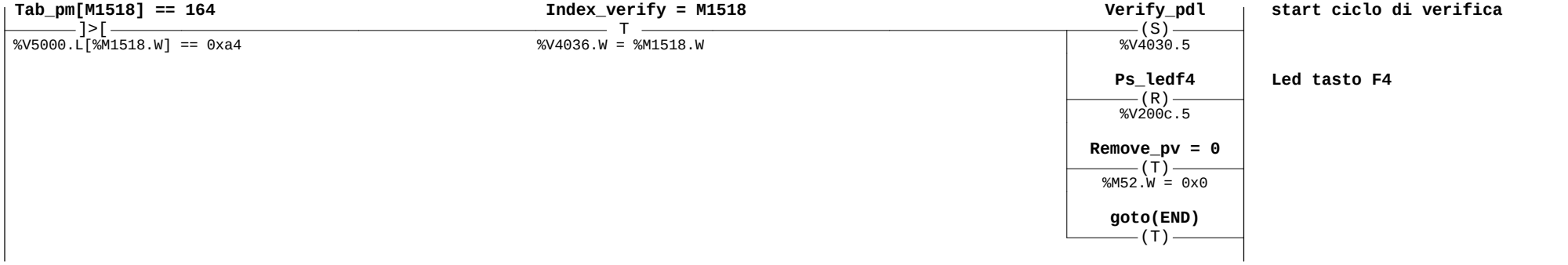
Remove_pv = 0 (T)
%M52.W = 0x0

goto(END) (T)

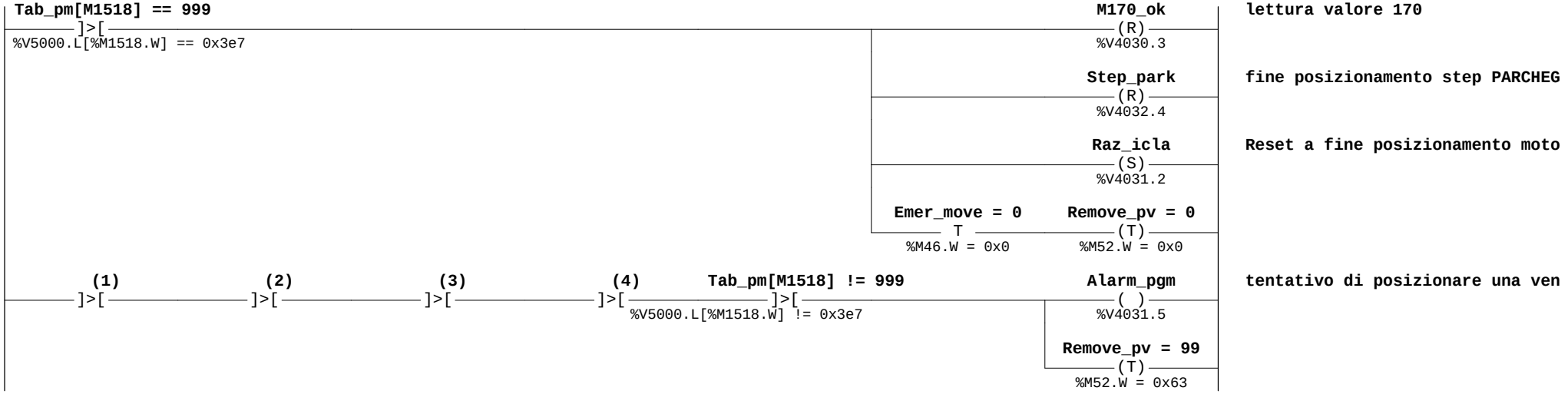
77 Label: Step: **Remove_pv** %M52.W **= 40**



78 Label: Step:



79 Label: Step: **Remove_pv** %M52.W **= 40**



(1) %V5000.L[%M1518.W] != 0xa4 : Tab_pm[M1518] != 164
(2) %V5000.L[%M1518.W] != 0xa7 : Tab_pm[M1518] != 167
(3) %V5000.L[%M1518.W] != 0xa8 : Tab_pm[M1518] != 168
(4) %V5000.L[%M1518.W] != 0xaa : Tab_pm[M1518] != 170

80 Label: **END** Step: