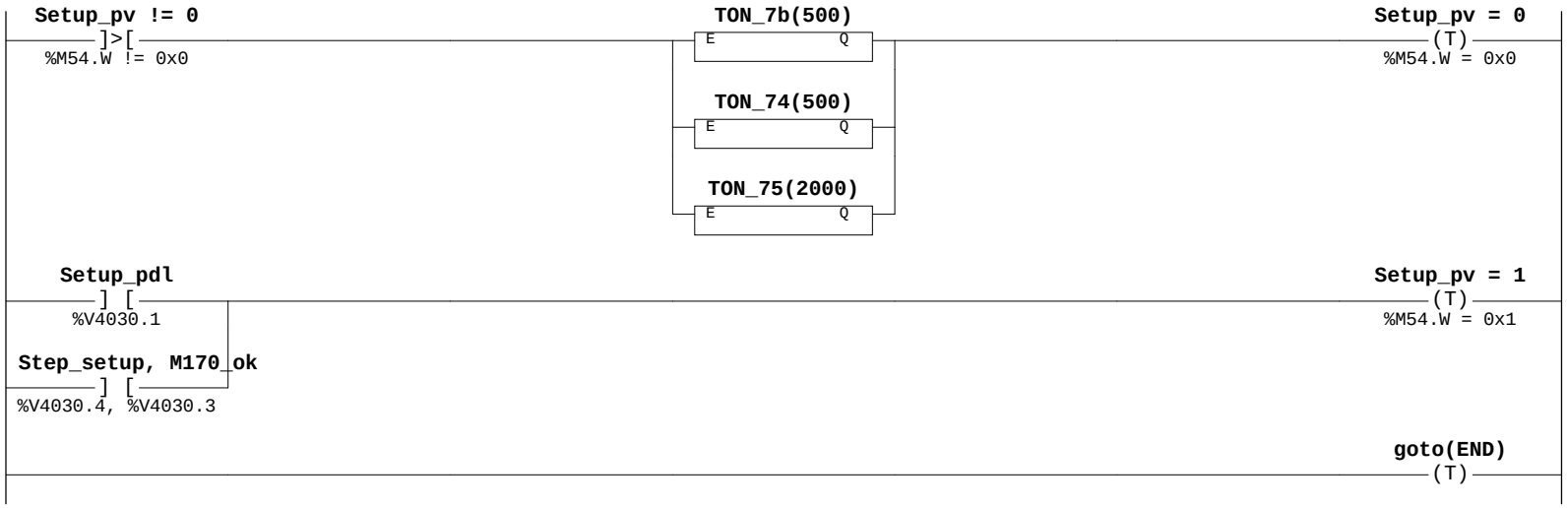
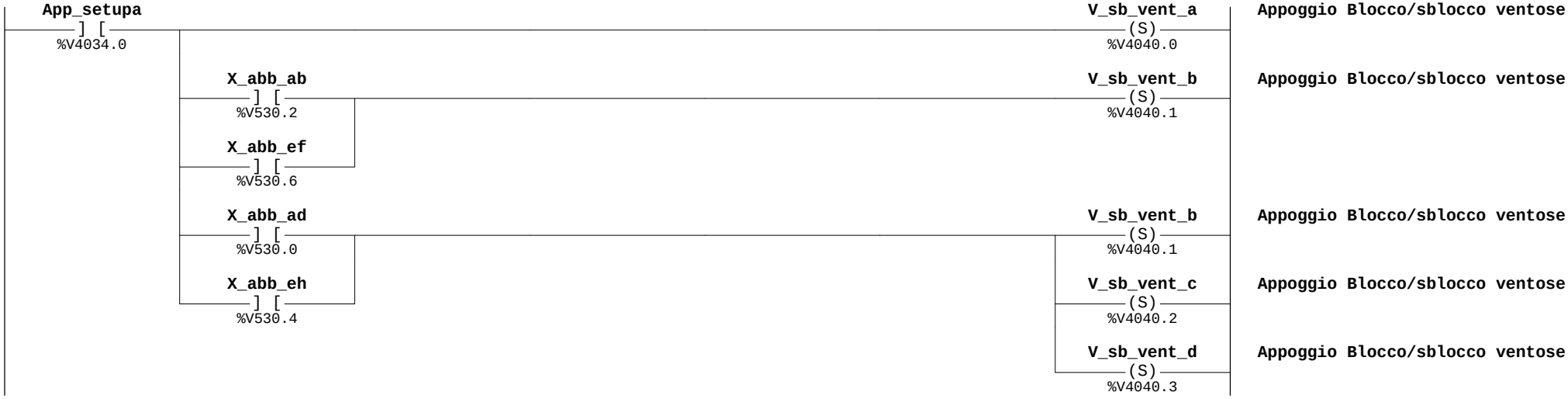
00 Label: Step: **Setup_pv** %M54.W **= 0**



[T] TON_7b(0x1f4) : TON_7b(500)
[T] TON_74(0x1f4) : TON_74(500)
[T] TON_75(0x7d0) : TON_75(2000)

01 Label: Step: **Setup_pv** %M54.W **= 1**



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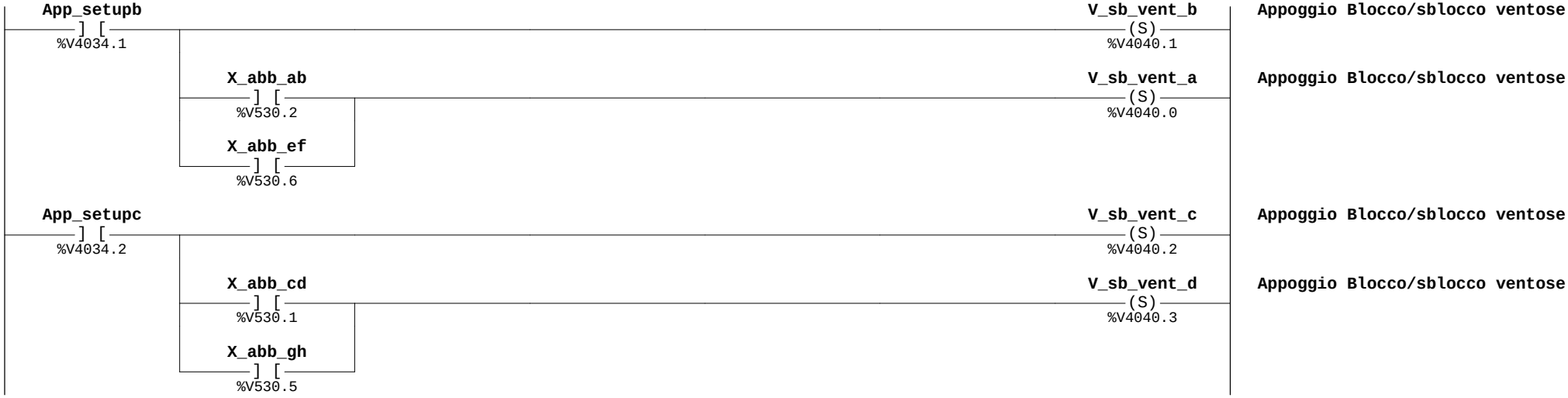
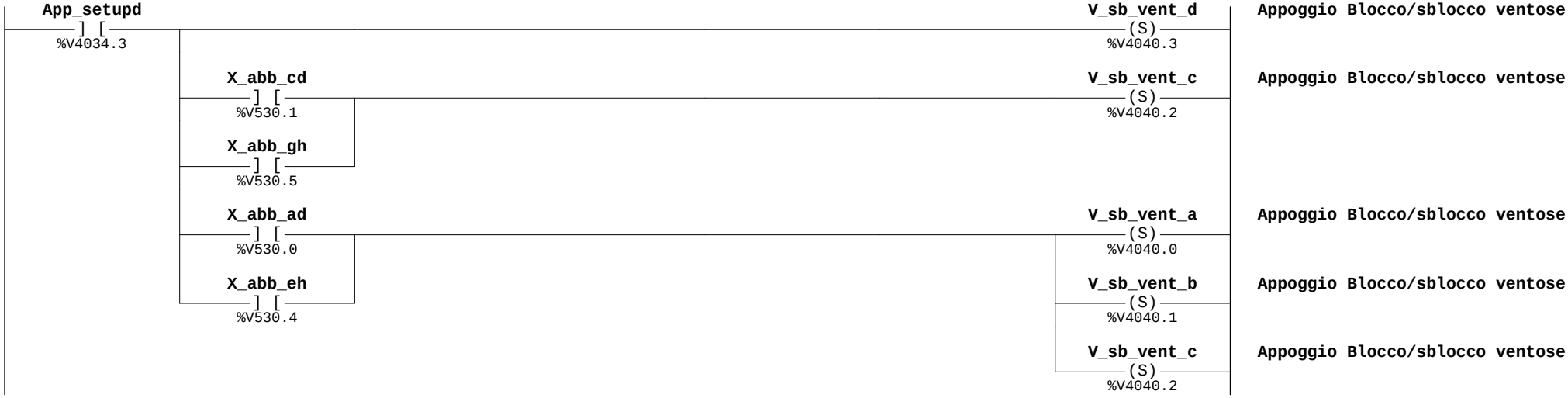
02 Label: Step: **Setup_pv** %M54.W **= 1**



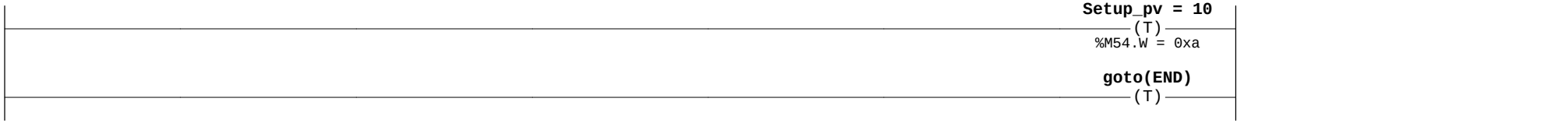
03 Label: Step: **Setup_pv** %M54.W **= 1**



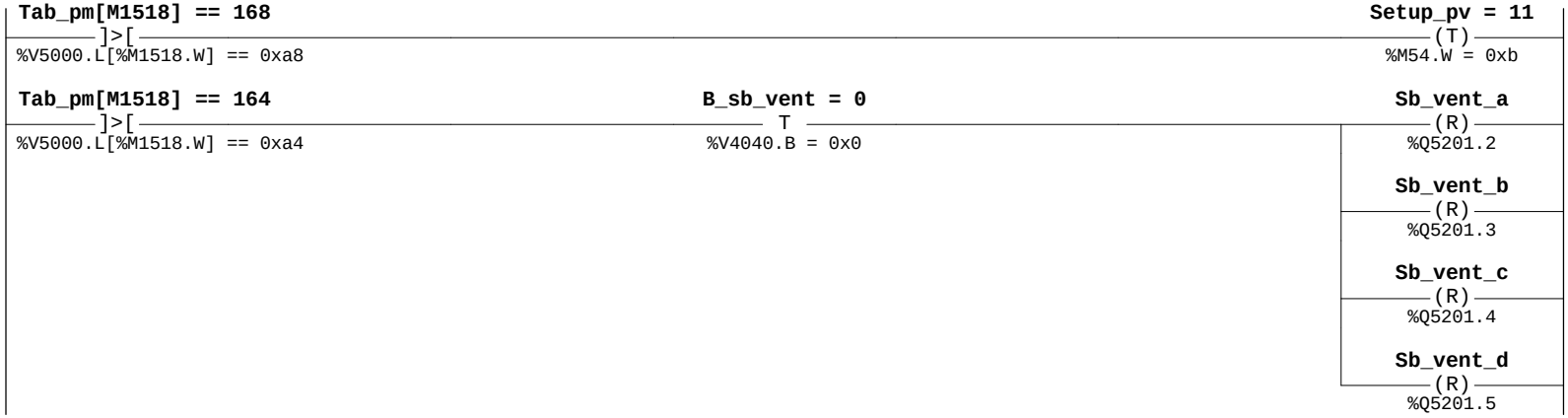
04 Label: Step: **Setup_pv** %M54.W **= 1**

(1) %M1518.W = %V402a.W : M1518 = Index_setup
(2) %V402e.W = %M1518.W : Index_plc = M1518

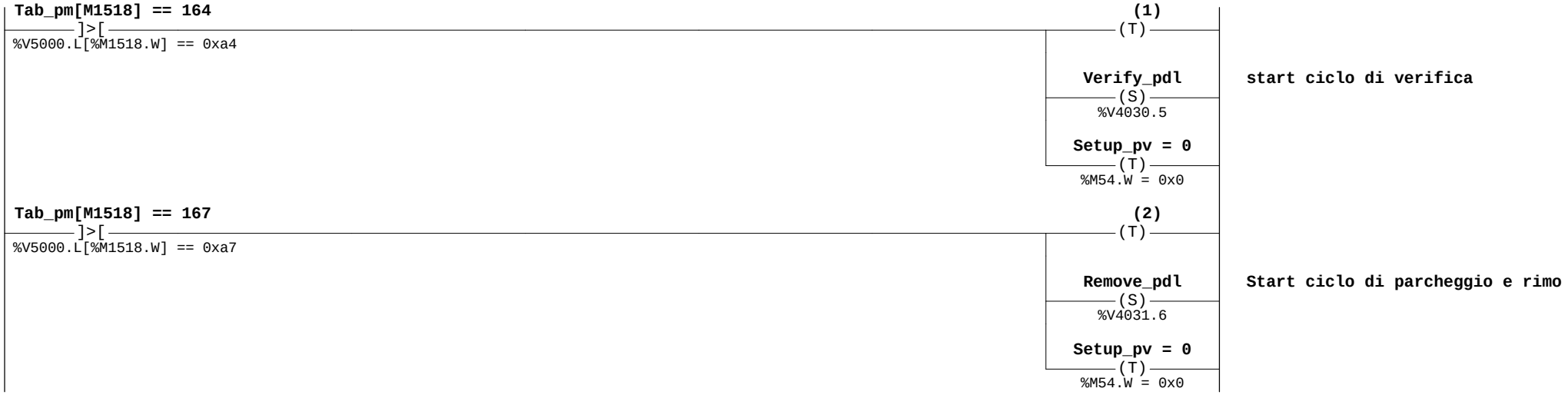
05 Label: Step: **Setup_pv** %M54.W **= 1**



06 Label: Step: **Setup_pv** %M54.W **= 10**

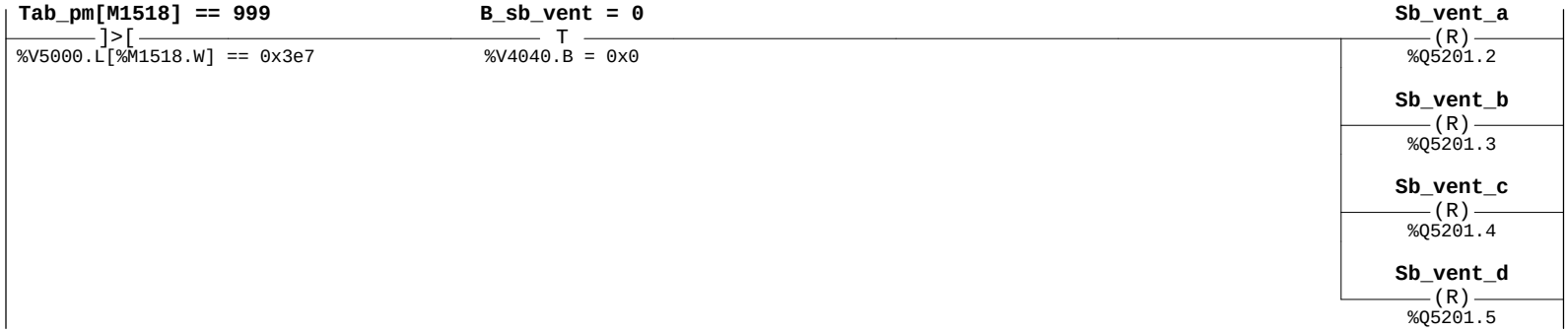


07 Label: Step: **Setup_pv** %M54.W **= 10**

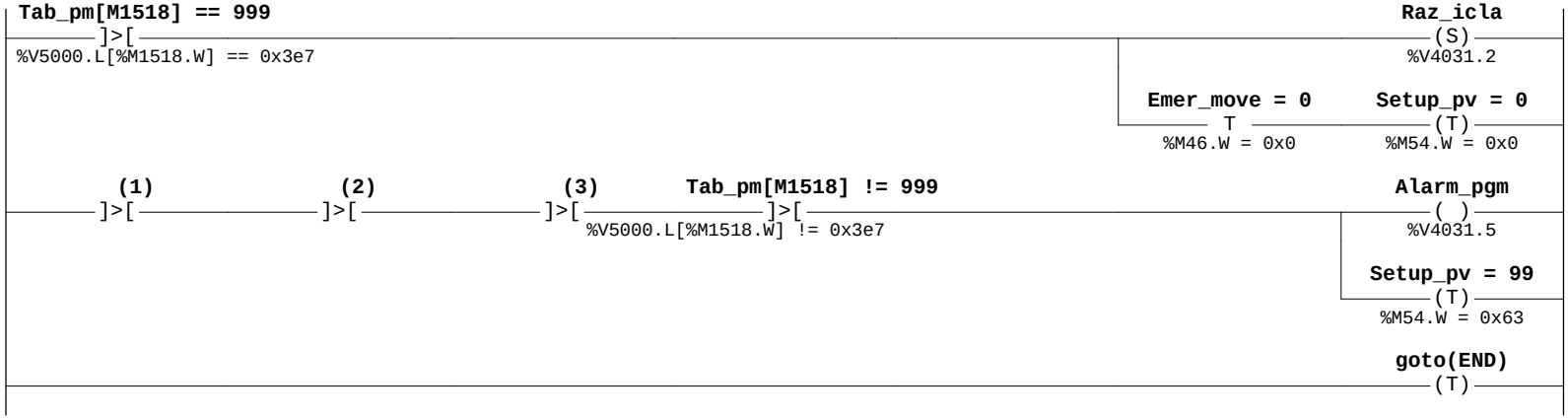


(1) %V4036.W = %M1518.W : Index_verify = M1518
(2) %V4038.W = %M1518.W : Index_remove = M1518

08 Label: Step: **Setup_pv** %M54.W **= 10**



09 Label: Step: **Setup_pv** %M54.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

10 Label: **Q_RIT** Step: **Setup_pv** %M54.W **= 11**

Indice ventosa o piano

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

11 Label: Step: **Setup_pv** %M54.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

12 Label: Step: **Setup_pv** %M54.W **= 11** | Indice Quota comandata

(1) (T)

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

13 Label: Step: **Setup_pv** %M54.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

14 Label: **FASE11** Step: **Setup_pv** %M54.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 — **Predisposizione start motori**
goto(FASE11A) (T)
Index_1 += 1 (T) %M1100.W += 0x1
Index_2 += 1 (T) %M1102.W += 0x1
Index_8 += 4 (T) %M110e.W += 0x4

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

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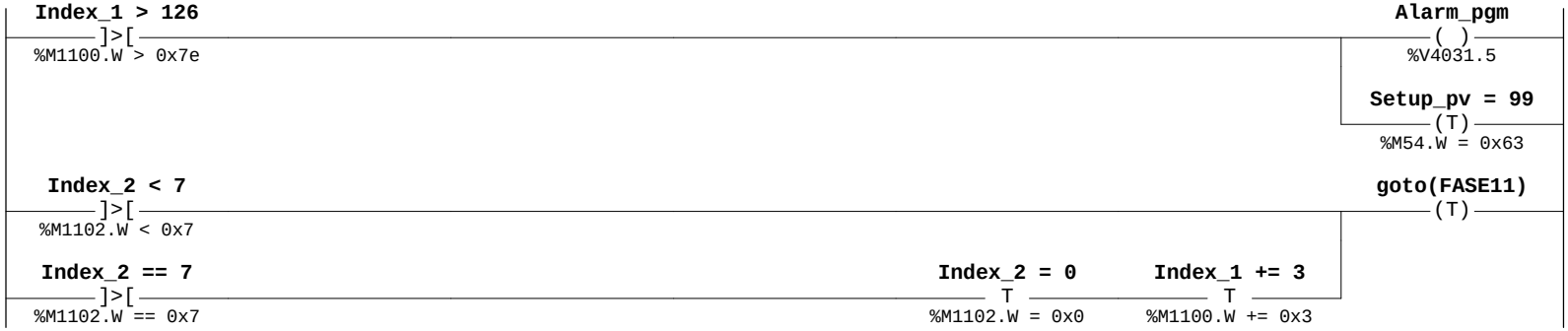
15 Label: Step: **Setup_pv** %M54.W **= 11**

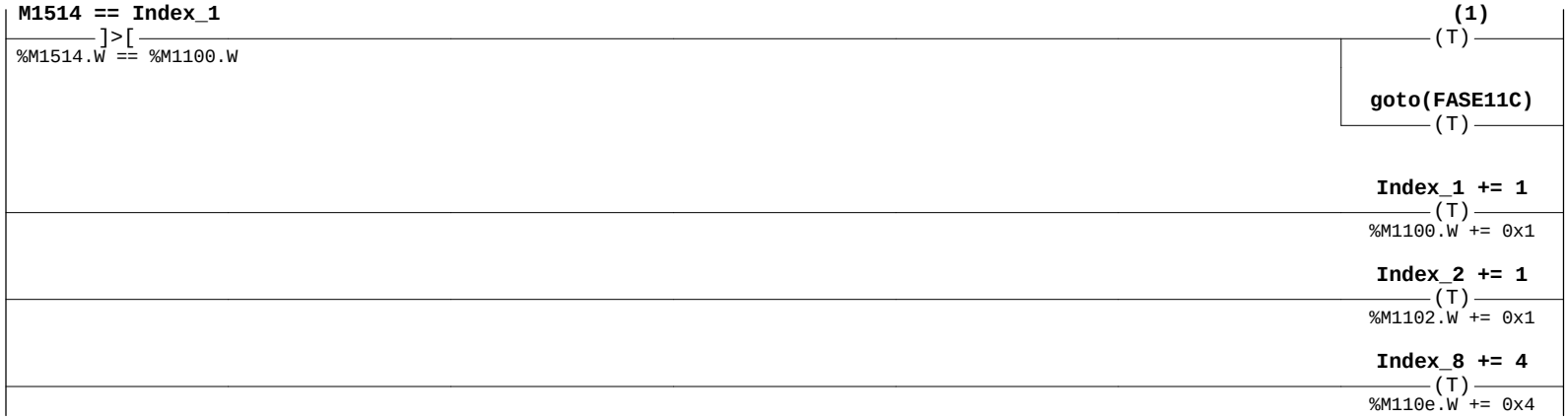


tentativo di posizionare una ven

16 Label: **FASE11A** Step: **Setup_pv** %M54.W **= 11**

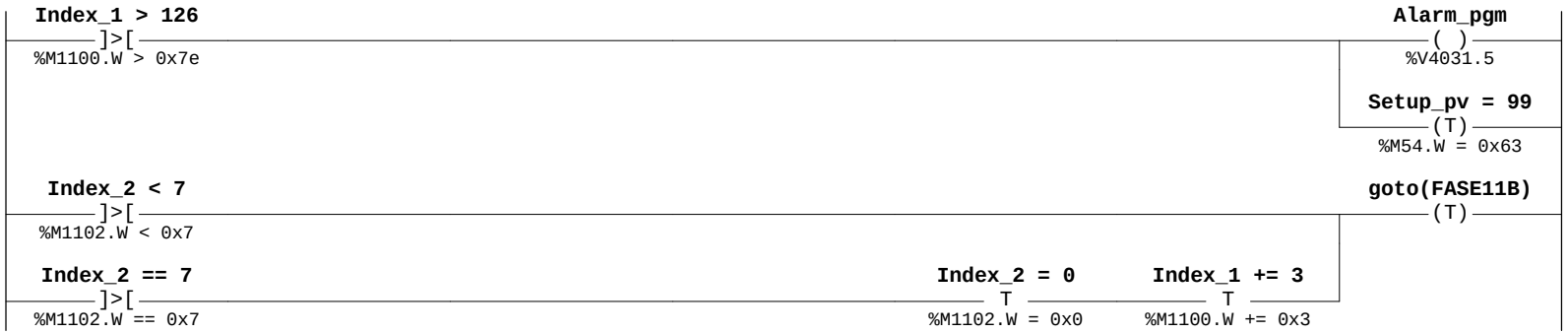
Assegnazione Quota comandata

17 Label: **FASE11B** Step: **Setup_pv** %M54.W **= 11**



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

18 Label: Step: **Setup_pv** %M54.W **= 11**



tentativo di posizionare una ven

19 Label: **FASE11C** Step: **Setup_pv** %M54.W **= 11** Indice velocità

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

20 Label: Step: **Setup_pv** %M54.W **= 11** Assegnazione Velocità

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

21 Label: Step: **Setup_pv** %M54.W **= 11**

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

22 Label: Step: **Setup_pv** %M54.W **= 11** | Verifica indice

Tab_pm[M1518] == 168]>[%V5000.L[%M1518.W] == 0xa8 — **goto(Q_RIT)** (T)

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

Setup_pv = 12 (T) %M54.W = 0xc

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

Setup_pv = 99 (T) %M54.W = 0x63

goto(END) (T)

(1) %V5000.L[%M1518.W] != 0xa8 : Tab_pm[M1518] != 168

23 Label: Step: **Setup_pv** %M54.W **= 12** | Reset dispositivo di aggancio

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

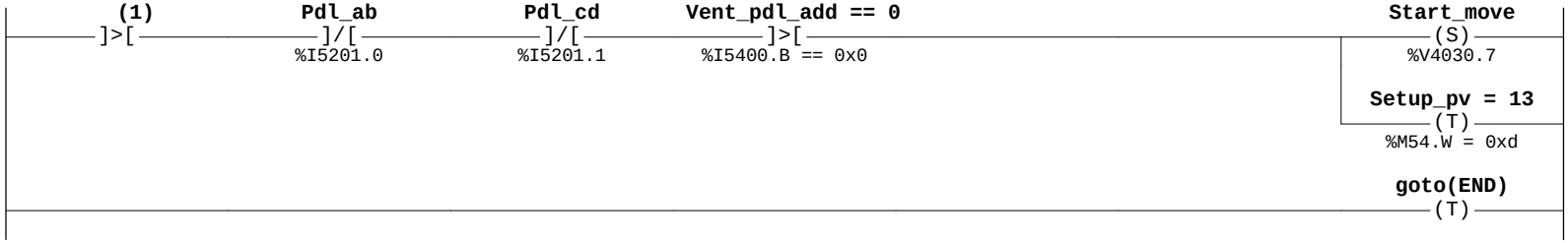
Cil_pdl_ab (R) %Q5201.0 — **Abil. cilindro aggancio area AB**

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

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

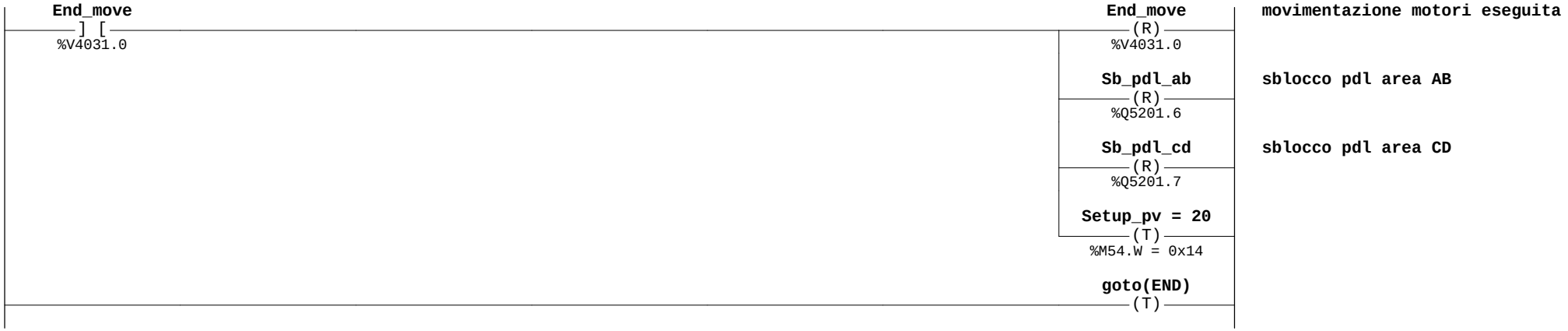
24 Label: Step: **Setup_pv** %M54.W **= 12**

Start asse n..... se predisposto e posiz. pistone a quota corr.

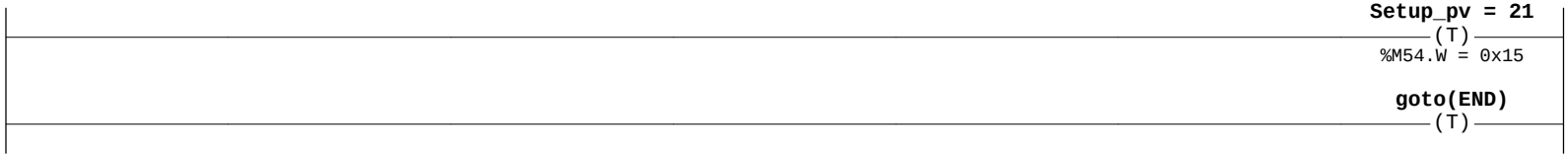


(1) %I5200.B == 0x0 : Vent_pdl_std == 0

25 Label: Step: **Setup_pv** %M54.W **= 13**



26 Label: Step: **Setup_pv** %M54.W **= 20**



27 Label: Step: **Setup_pv** %M54.W **= 21** | Indice di Spiazzamento |

(1)
(T)

Index_10 = 0
T
%M1112.W = 0x0

Setup_pv = 22
(T)
%M54.W = 0x16

goto(END)
(T)

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

28 Label: Step: **Setup_pv** %M54.W **= 22**

Tab_pm[M1518] == 168
]>[
%V5000.L[%M1518.W] == 0xa8

Setup_pv = 23
(T)
%M54.W = 0x17

Tab_pm[M1518] != 168
]>[
%V5000.L[%M1518.W] != 0xa8

Alarm_pgm
( )
%V4031.5

Setup_pv = 99
(T)
%M54.W = 0x63

goto(END)
(T)

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29 Label: **Q_SETUP** Step: **Setup_pv** %M54.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]

30 Label: Step: **Setup_pv** %M54.W **= 23** | Appoggio su V4000 piano e ventose |

(1)
(T)

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

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

31 Label: Step: **Setup_pv** %M54.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

32 Label: Step: **Setup_pv** %M54.W **= 23** | Indice Quota comandata |

(1) — (T)

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

33 Label: Step: **Setup_pv** %M54.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

34 Label: **FASE23** Step: **Setup_pv** %M54.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]

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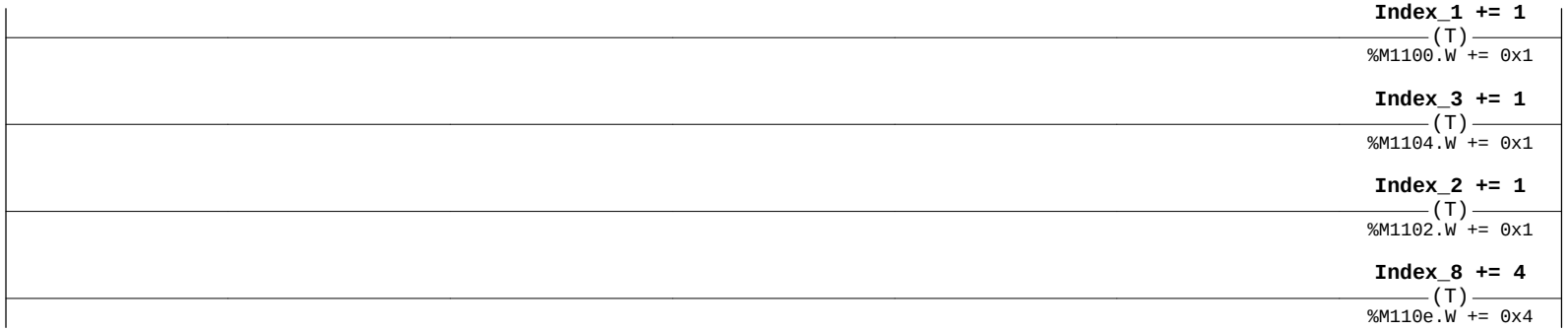
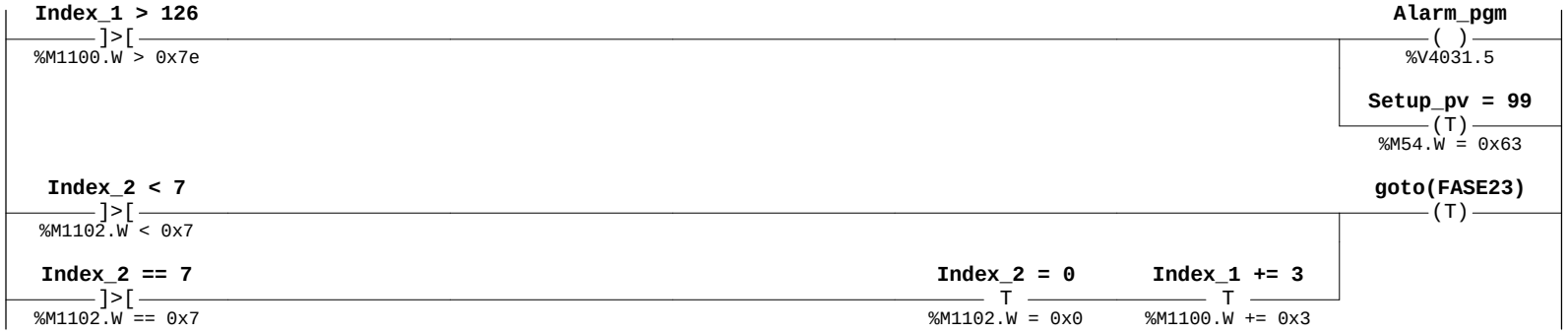
35 Label: Step: **Setup_pv** %M54.W **= 23**



36 Label: Step: **Setup_pv** %M54.W **= 23**



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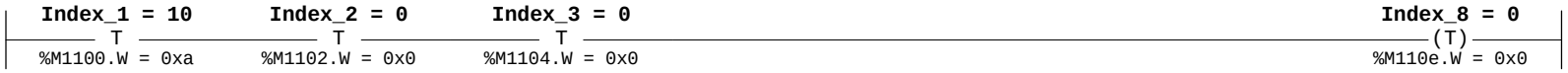
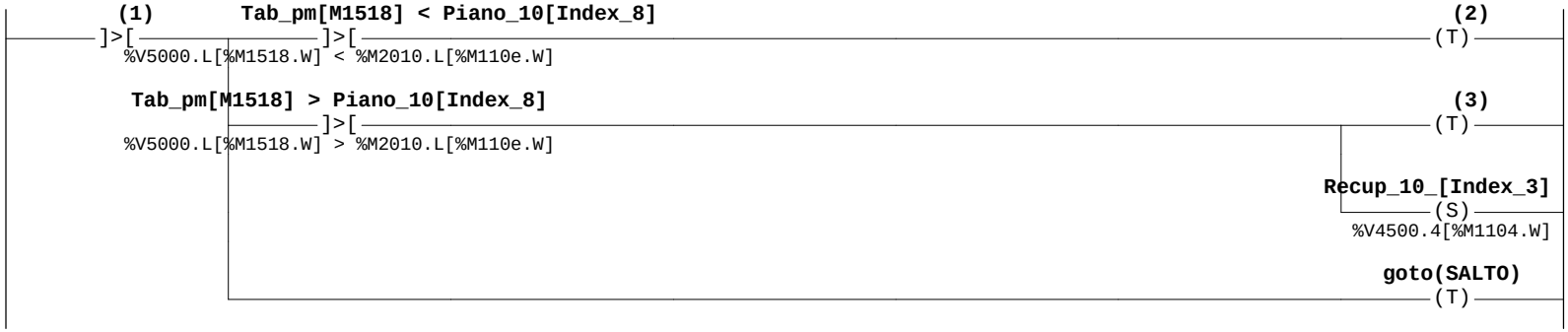
37 Label: **FASE23A** Step: **Setup_pv** %M54.W **= 23**

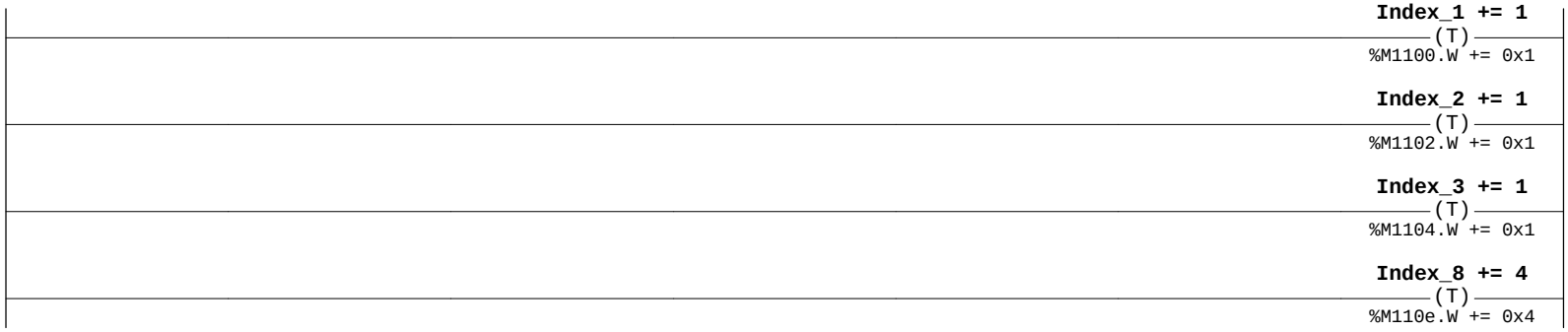


38 Label: **FASE23B** Step: **Setup_pv** %M54.W **= 23**

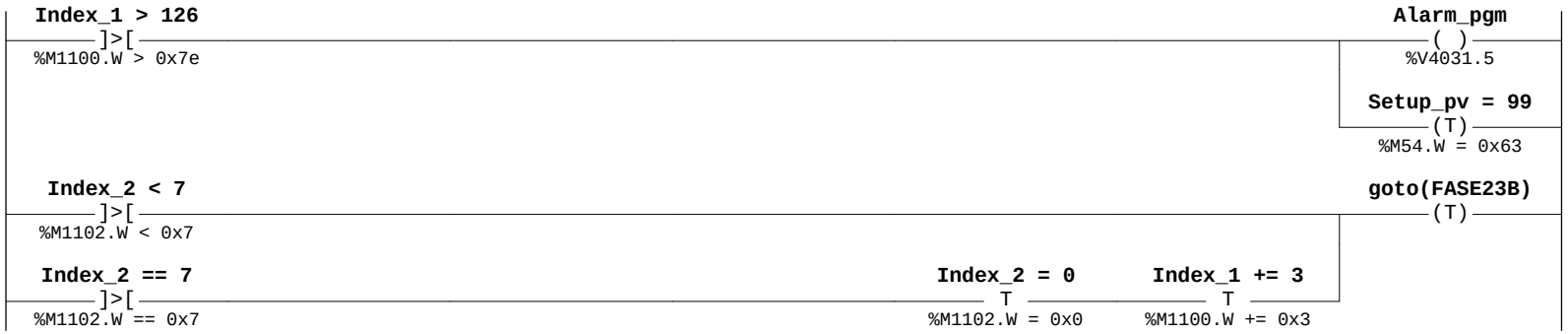


(1) %M1514.W == %M1100.W : M1514 == Index_1
(2) %V7012.L[%M1512.W] = %V5000.L[%M1518.W] - %V1290.B[%M1104.W] : Q_prog_1[M1512] = Tab_pm[M1518] - Tab_asola[Index_3]
(3) %V7012.L[%M1512.W] = %V5000.L[%M1518.W] + %V1290.B[%M1104.W] : Q_prog_1[M1512] = Tab_pm[M1518] + Tab_asola[Index_3]

39 Label: Step: **Setup_pv** %M54.W **= 23**



40 Label: Step: **Setup_pv** %M54.W **= 23**



tentativo di posizionare una ven

41 Label: **SALTO** Step: **Setup_pv** %M54.W **= 23** Indice velocità

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

42 Label: Step: **Setup_pv** %M54.W **= 23** Assegnazione Velocità

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

43 Label: Step: **Setup_pv** %M54.W **= 23** incremento indice

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

44 Label: Step: **Setup_pv** %M54.W **= 23**

Verifica indice

Tab_pm[M1518] == 168 → **goto(Q_SETUP)** (T)
%V5000.L[%M1518.W] == 0xa8

Tab_pm[M1518] == 170 AND **V4000[Index_10] = 127** → **Setup_pv = 24** (T)
%V5000.L[%M1518.W] == 0xaa AND %V4000.B[%M1112.W] = 0x7f → %M54.W = 0x18

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

Setup_pv = 99 (T)
%M54.W = 0x63

goto(END) (T)

(1) %V5000.L[%M1518.W] != 0xa8 : Tab_pm[M1518] != 168

45 Label: Step: **Setup_pv** %M54.W **= 24**

P_syncro_1 %V7010.3 AND NOT **Pistab_no_ok** %V4561.4 → **Cil_pdl_ab** %Q5201.0 (S) — **Abil. cilindro aggancio area AB**

Pistab_no_ok %V4561.4 → **Cil_pdl_ab** %Q5201.0 (R) — **Abil. cilindro aggancio area AB**

P_syncro_2 %V7020.3 AND NOT **Pistcd_no_ok** %V4561.5 → **Cil_pdl_cd** %Q5201.1 (S) — **Abil. cilindro aggancio area CD**

Pistcd_no_ok %V4561.5 → **Cil_pdl_cd** %Q5201.1 (R) — **Abil. cilindro aggancio area CD**

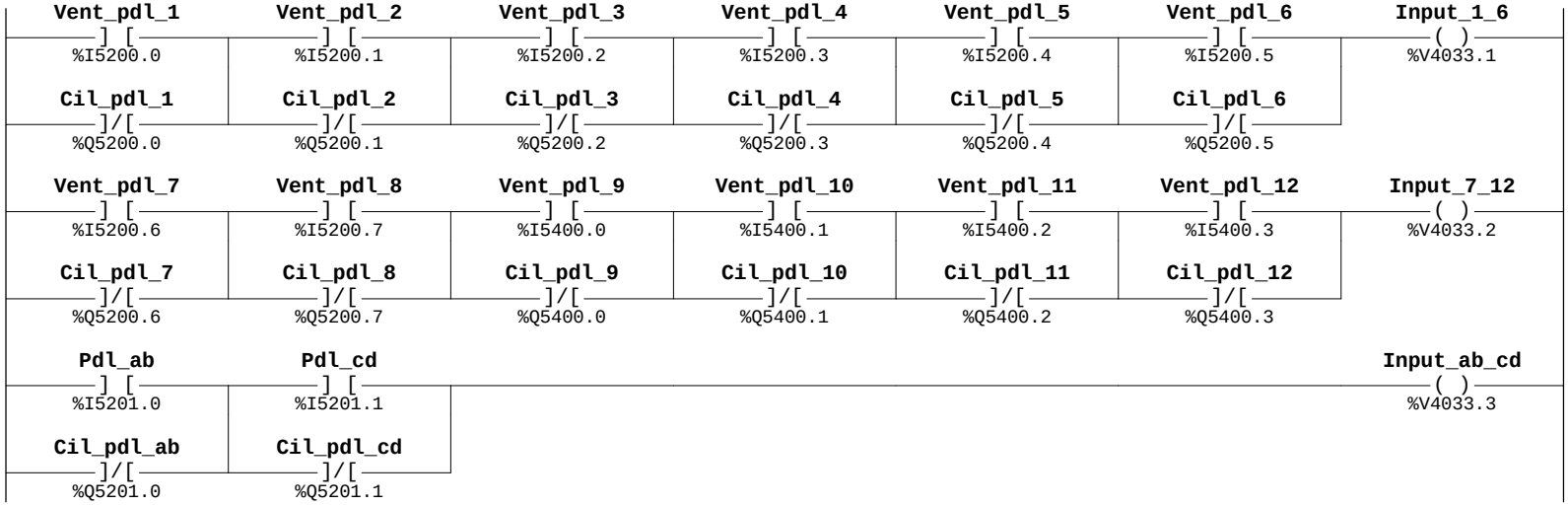
46 Label: Step: **Setup_pv** %M54.W **= 24**

47 Label: Step: **Setup_pv** %M54.W **= 24**

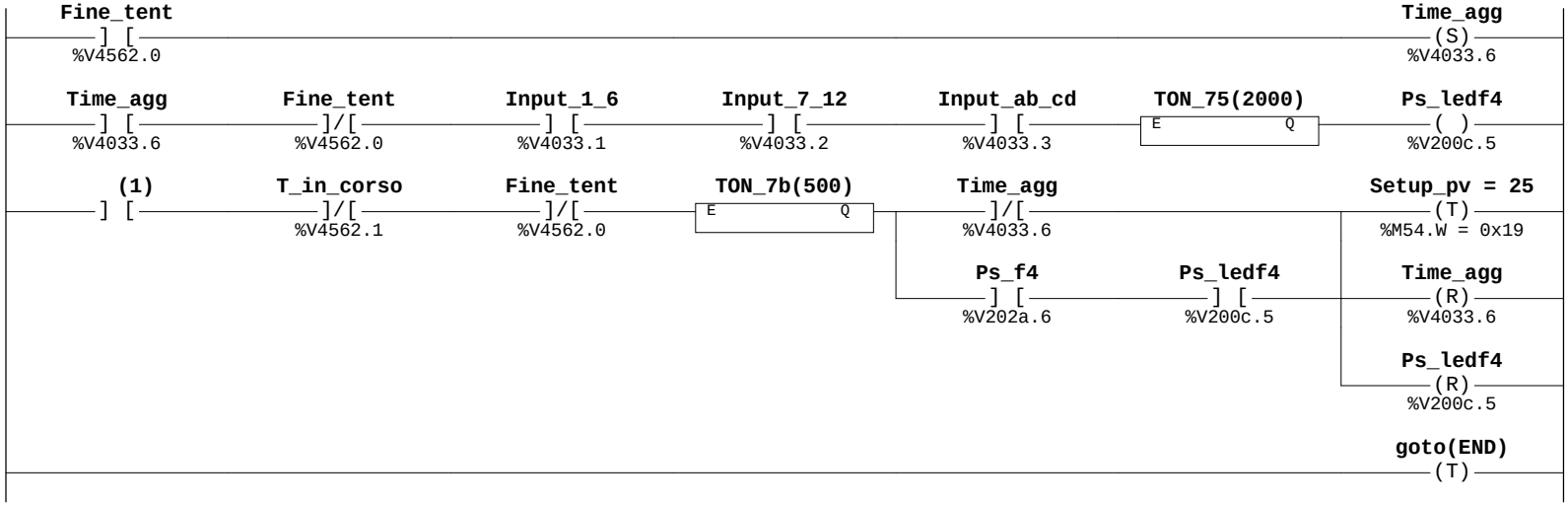
48 Label: Step: **Setup_pv** %M54.W **= 24**

49 Label: Step: **Setup_pv** %M54.W **= 24**

50 Label: Step: **Setup_pv** %M54.W **= 24**



51 Label: Step: **Setup_pv** %M54.W **= 24**



(1) %V4033.1, %V4033.2, %V4033.3 : Input_1_6, Input_7_12, Input_ab_cd
[T] TON_75(0x7d0) : TON_75(2000)
[T] TON_7b(0x1f4) : TON_7b(500)

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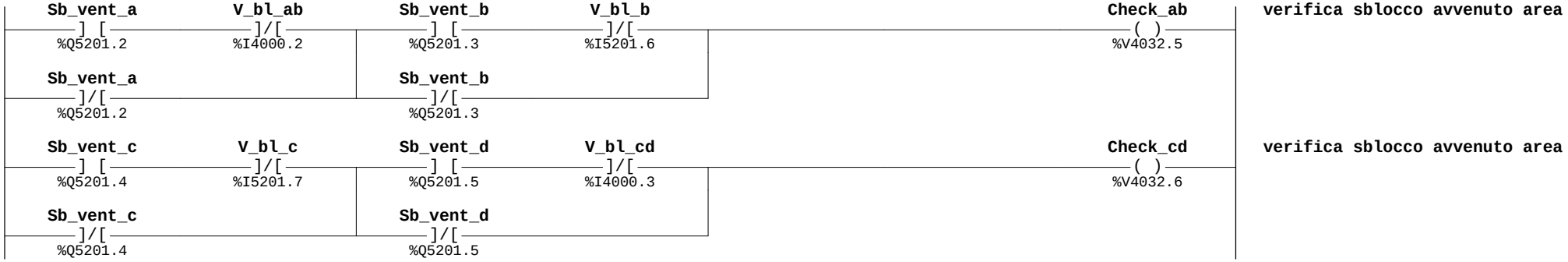
52 Label: Step: **Setup_pv** %M54.W **= 25**

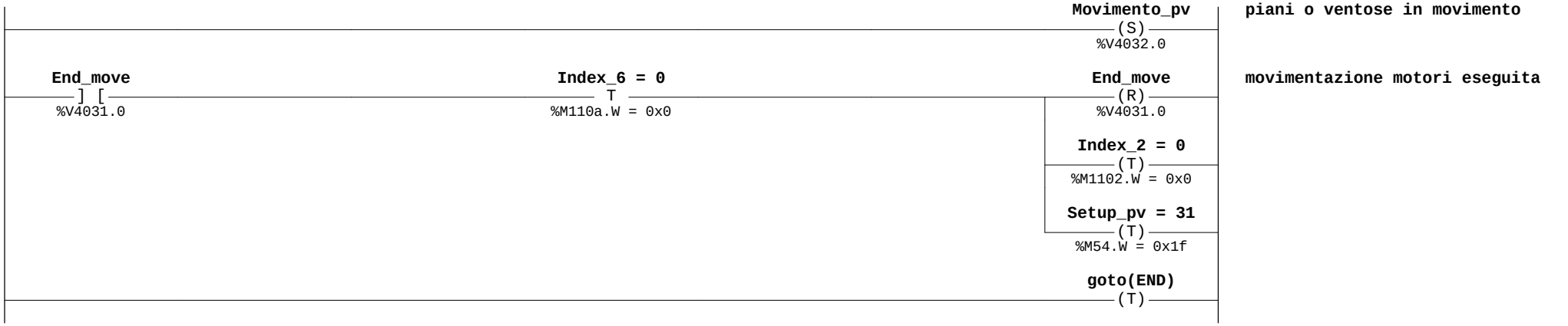
53 Label: Step: **Setup_pv** %M54.W **= 25**



54 Label: Step: **Setup_pv** %M54.W **= 25**

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

55 Label: Step: **Setup_pv** %M54.W **= 26**



56 Label: **RESET** Step: **Setup_pv** %M54.W **= 31**

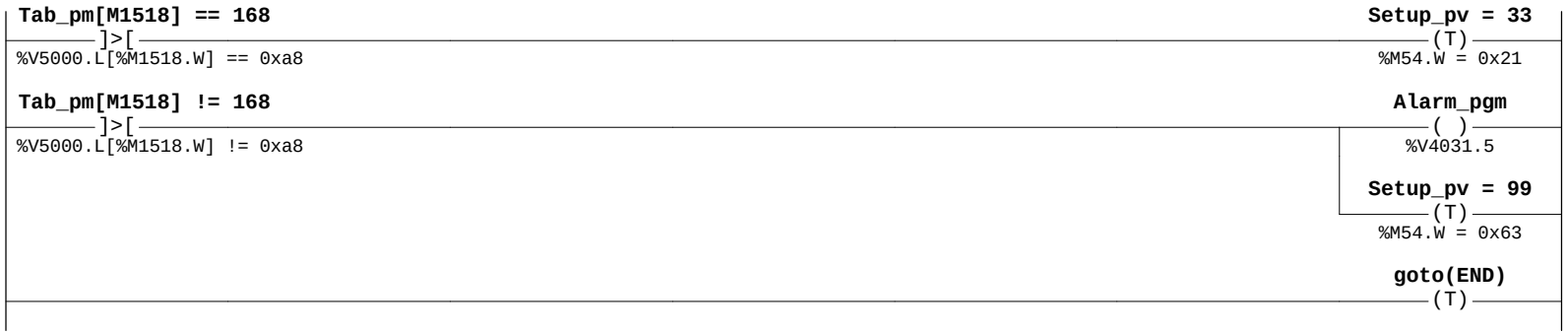
(1) %V4500.3[%M110a.W] : Sincro_10_[Index_6]

57 Label: Step: **Setup_pv** %M54.W **= 31**

indice di spaziamento

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

58 Label: Step: **Setup_pv** %M54.W **= 32**



tentativo di posizionare una ven

59 Label: **M_CORR** Step: **Setup_pv** %M54.W **= 33**

n° piano o ventosa

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

60 Label: Step: **Setup_pv** %M54.W **= 33**

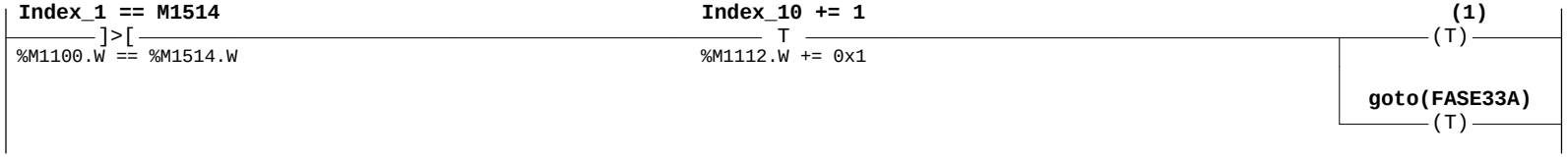
61 Label: Step: **Setup_pv** %M54.W **= 33**

indice quota comandata

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

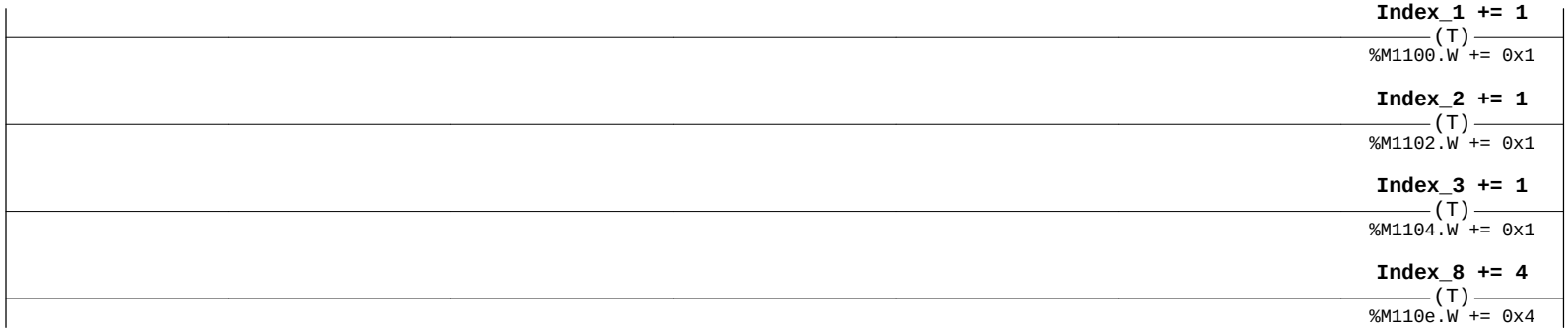
62 Label: **FASE33** Step: **Setup_pv** %M54.W **= 33**

Memorizzazione Quote piani e ventose

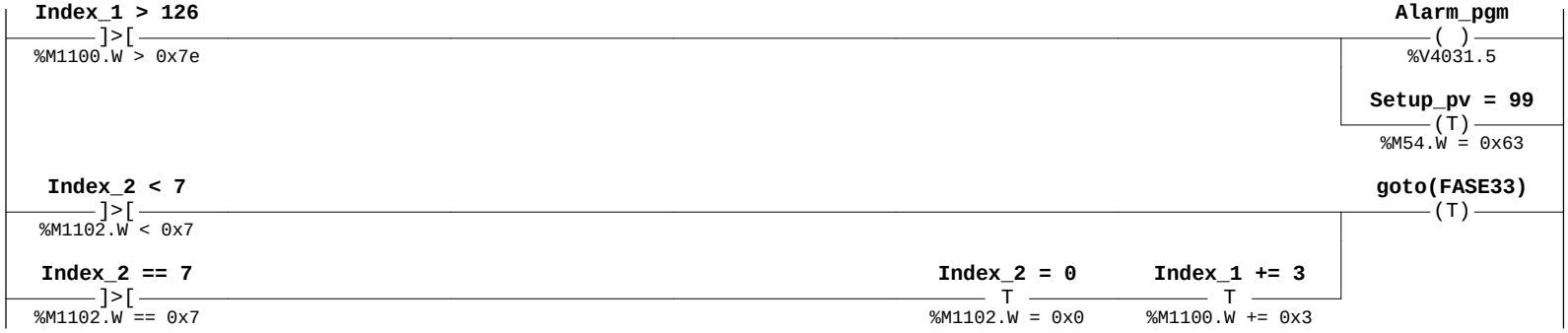


(1) %M2010.L[%M110e.W] = %V5000.L[%M1518.W] : Piano_10[Index_8] = Tab_pm[M1518]

63 Label: Step: **Setup_pv** %M54.W **= 33**



64 Label: Step: **Setup_pv** %M54.W **= 33**

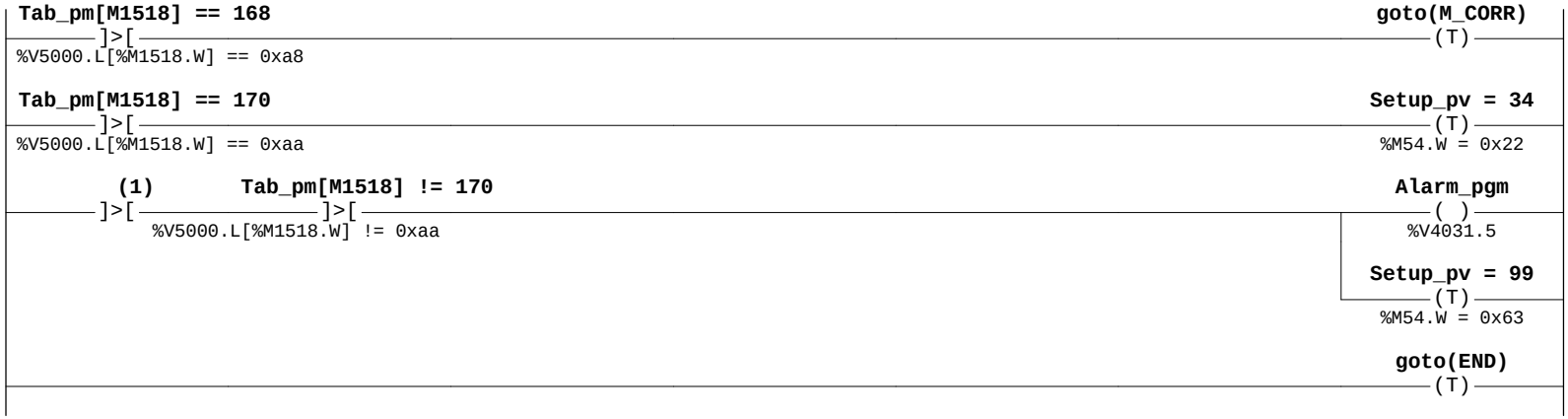


tentativo di posizionare una ven

65 Label: **FASE33A** Step: **Setup_pv** %M54.W **= 33**

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

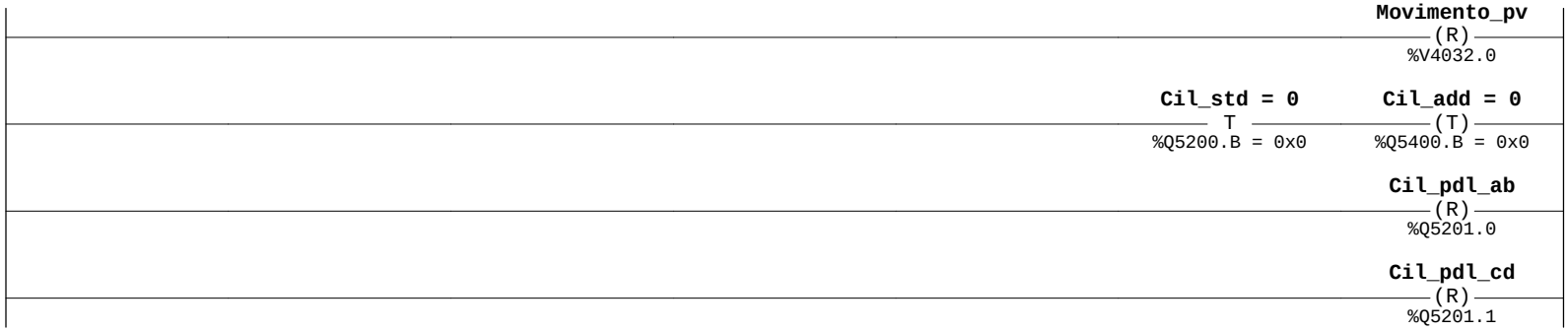
66 Label: Step: **Setup_pv** %M54.W **= 33**



tentativo di posizionare una ven

(1) %V5000.L[%M1518.W] != 0xa8 : Tab_pm[M1518] != 168

67 Label: Step: **Setup_pv** %M54.W **= 34**

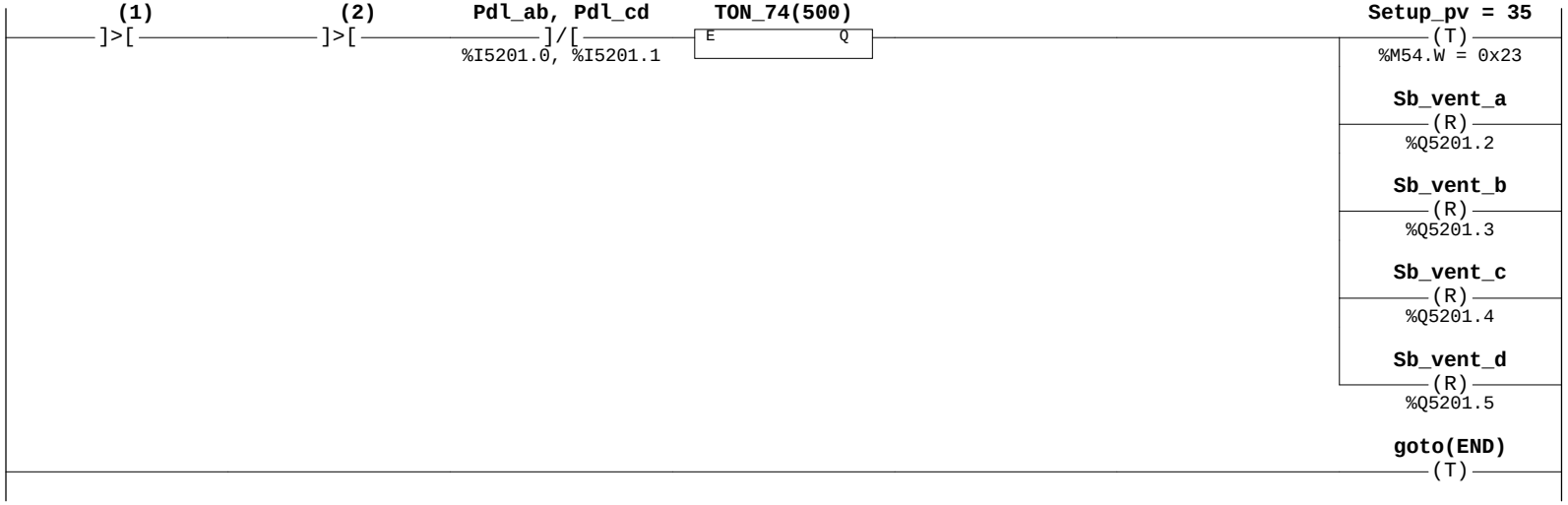


piani o ventose in movimento

Abil. cilindro aggancio area AB

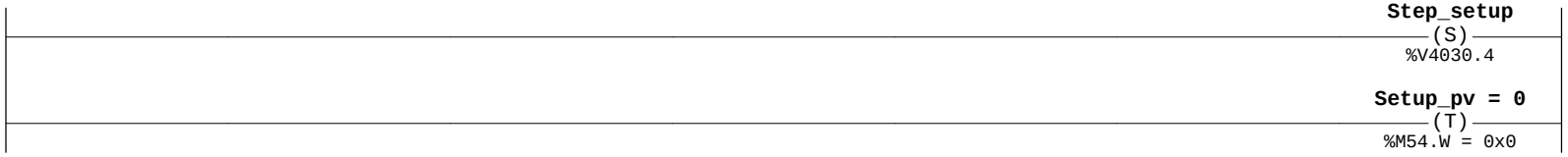
Abil. cilindro aggancio area CD

68 Label: Step: **Setup_pv** %M54.W **= 34**



(1) %I5200.B == 0x0 : Vent_pdl_std == 0
(2) %I5400.B == 0x0 : Vent_pdl_add == 0
[T] TON_74(0x1f4) : TON_74(500)

69 Label: Step: **Setup_pv** %M54.W **= 35**



70 Label: **END** Step:

Author:		**NUM TOOLS**
Company:		
Project: **1040_78.mch**	**TITRE**	Date **28-02-2018**
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