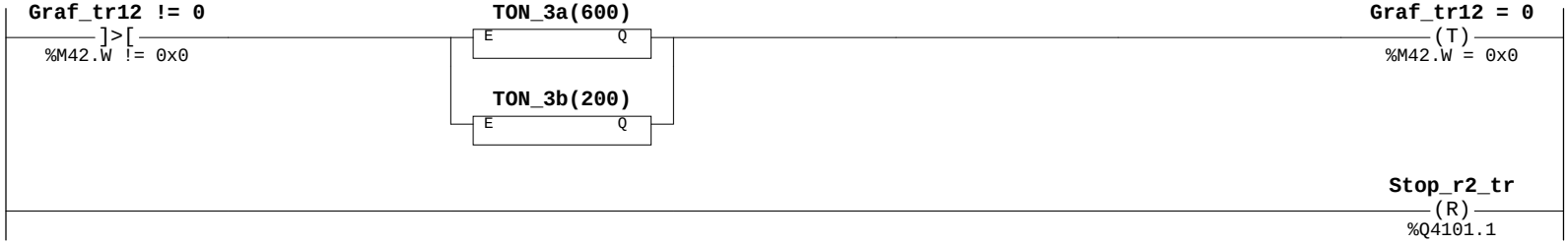
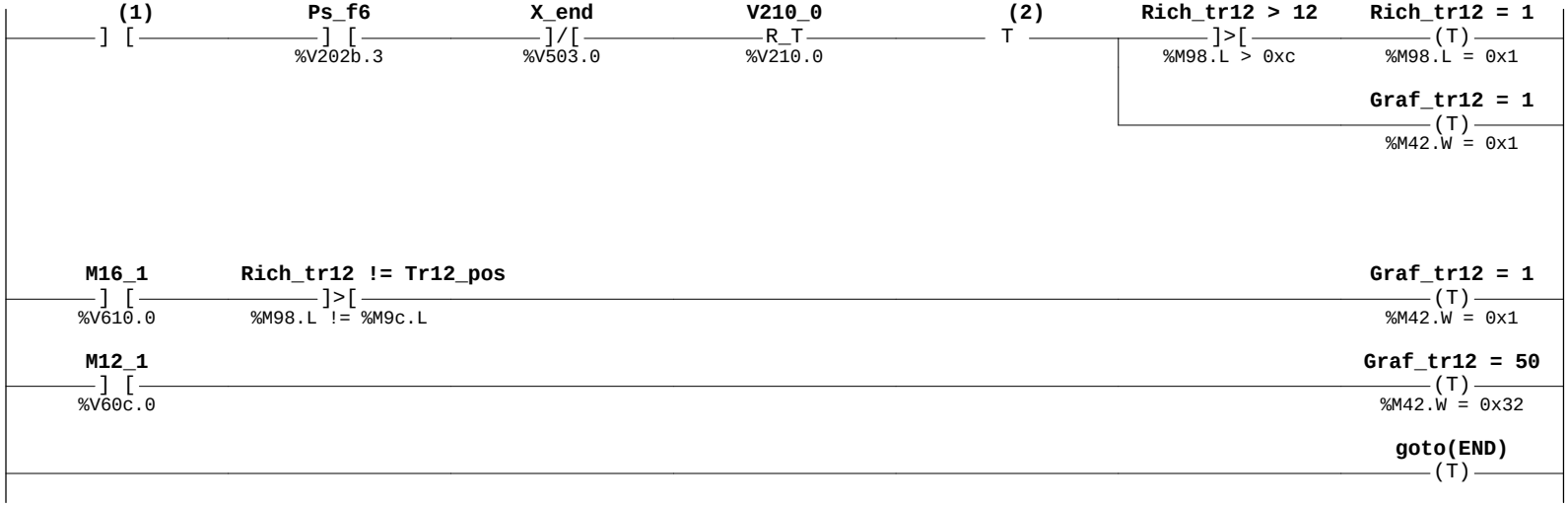
00 Label: Step:

01 Label: Step: **Graf_tr12** %M42.W **= 0**



[T] TON_3a(0x258) : TON_3a(600)
[T] TON_3b(0xc8) : TON_3b(200)

02 Label: Step: **Graf_tr12** %M42.W **= 0**



(1) %I4101.3, %I4001.3, %I4100.7 : Setting, Pul_um1, Pul_um2
(2) %M98.L = %M9c.L + 0x1 : Rich_tr12 = Tr12_pos + 1

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Project: **1040_78.mch**	**TITRE**	Date **28-02-2018**
Module: **TR12_POS.XLA**	**%SP133 (00)**	Page **1**

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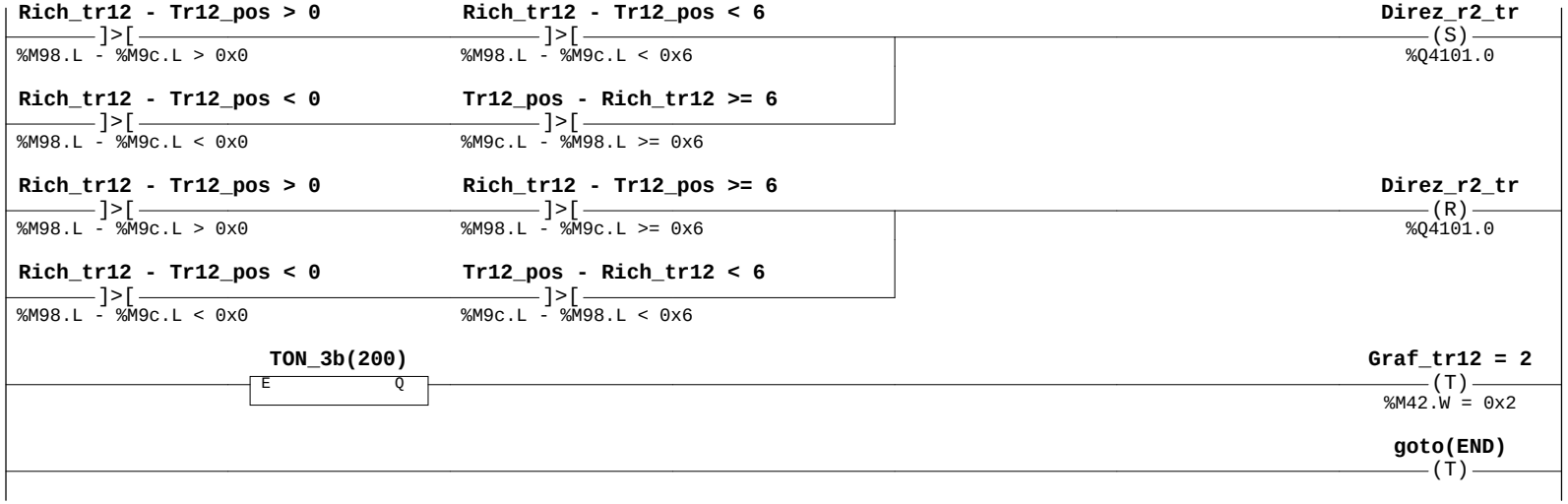
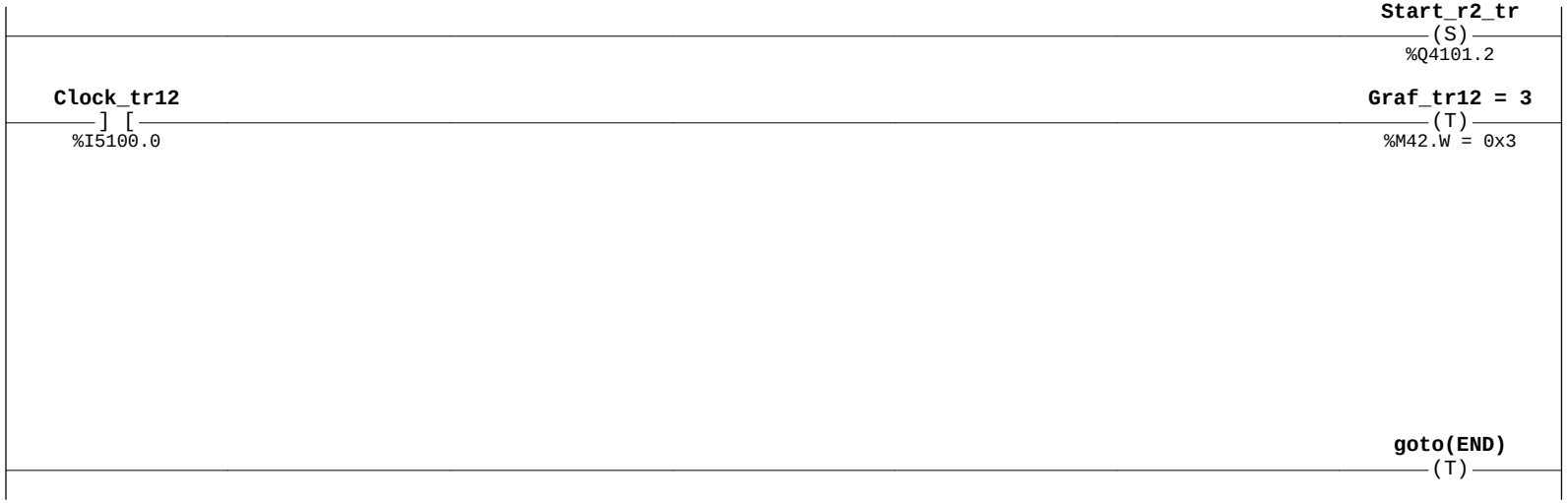
03 Label: Step: **Graf_tr12** %M42.W **= 1**

Ricerca direzione di rotazione magazzino



[T] TON_3b(0xc8) : TON_3b(200)

04 Label: Step: **Graf_tr12** %M42.W **= 2**



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Project: **1040_78.mch**	**TITRE**	Date **28-02-2018**
Module: **TR12_POS.XLA**	**%SP133 (03)**	Page **2**

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05 Label: Step: **Graf_tr12** %M42.W **= 3** Incremento memoria posto magazzino

Start_r2_tr (R) %Q4101.2 — **Start rapid 6 n.2 / Tool room po**

Direz_r2_tr] [%Q4101.0 — **Tr12_pos += 1** (T) %M9c.L += 0x1

Direz_r2_tr]/[%Q4101.0 — **Tr12_pos -= 1** (T) %M9c.L -= 0x1

06 Label: Step: **Graf_tr12** %M42.W **= 3** Verifica posto magazzino

Tr12_pos == 0]>[%M9c.L == 0x0 — **Tr12_pos = 12** (T) %M9c.L = 0xc

Tr12_pos == 13]>[%M9c.L == 0xd — **Tr12_pos = 1** (T) %M9c.L = 0x1

07 Label: Step: **Graf_tr12** %M42.W **= 3** Controllo se raggiunto posto

Tr12_pos != Rich_tr12]>[%M9c.L != %M98.L — **Graf_tr12 = 4** (T) %M42.W = 0x4

Tr12_pos == Rich_tr12]>[%M9c.L == %M98.L — **Graf_tr12 = 9** (T) %M42.W = 0x9

(1) (T)

(2) (T)

goto(END) (T)

(1) %Q4101.B = %Q4101.B | 0x2 : Out_41 = Out_41 | 2
(2) write_q(0x4101, 0x1) : write_q(16641, 1)

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Project: **1040_78.mch**	**TITRE**	Date **28-02-2018**
Module: **TR12_POS.XLA**	**%SP133 (05)**	Page **3**

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08 Label: Step: **Graf_tr12** %M42.W **= 4**

09 Label: Step: **Graf_tr12** %M42.W **= 5**

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10 Label: Step: **Graf_tr12** %M42.W **= 6**

11 Label: Step: **Graf_tr12** %M42.W **= 7**

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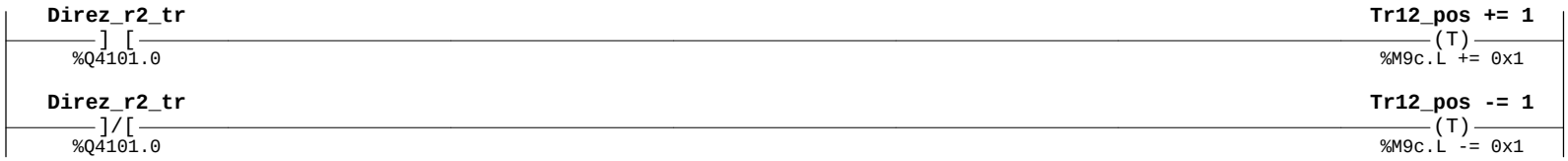
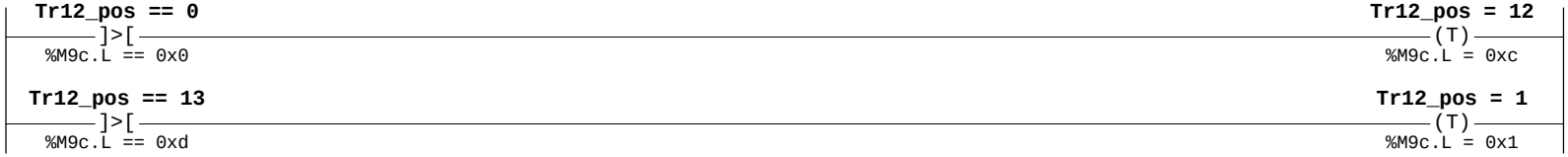
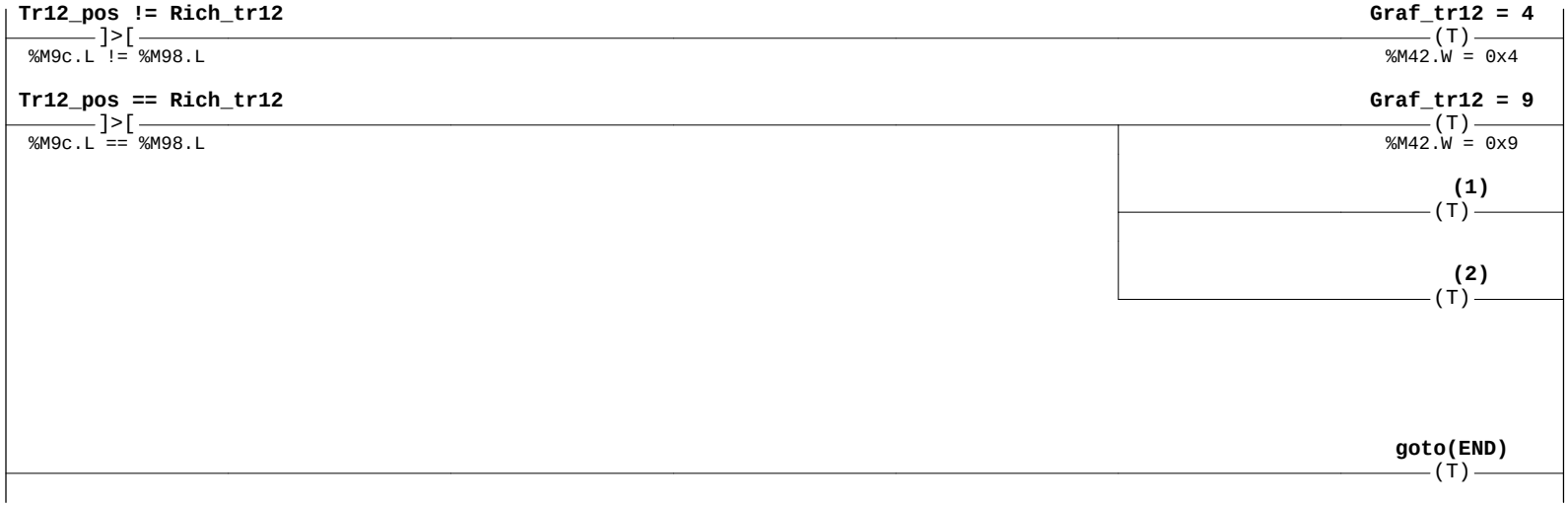
12 Label: Step: **Graf_tr12** %M42.W **= 8**



13 Label: Step: **Graf_tr12** %M42.W **= 8**



14 Label: Step: **Graf_tr12** %M42.W **= 8**



(1) %Q4101.B = %Q4101.B | 0x2 : Out_41 = Out_41 | 2
(2) write_q(0x4101, 0x1) : write_q(16641, 1)

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Project: **1040_78.mch**	**TITRE**	Date **28-02-2018**
Module: **TR12_POS.XLA**	**%SP133 (12)**	Page **6**

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15 Label: Step: **Graf_tr12** %M42.W **= 9**

16 Label: Step: **Graf_tr12** %M42.W **= 10**

[T] TON_3a(0x258) : TON_3a(600)

Author:		**NUM TOOLS**
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Project: **1040_78.mch**	**TITRE**	Date **28-02-2018**
Module: **TR12_POS.XLA**	**%SP133 (15)**	Page **7**

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17 Label: Step: **Graf_tr12** %M42.W **= 11**

18 Label: Step: **Graf_tr12** %M42.W **= 50**

Ciclo taratura magazzino

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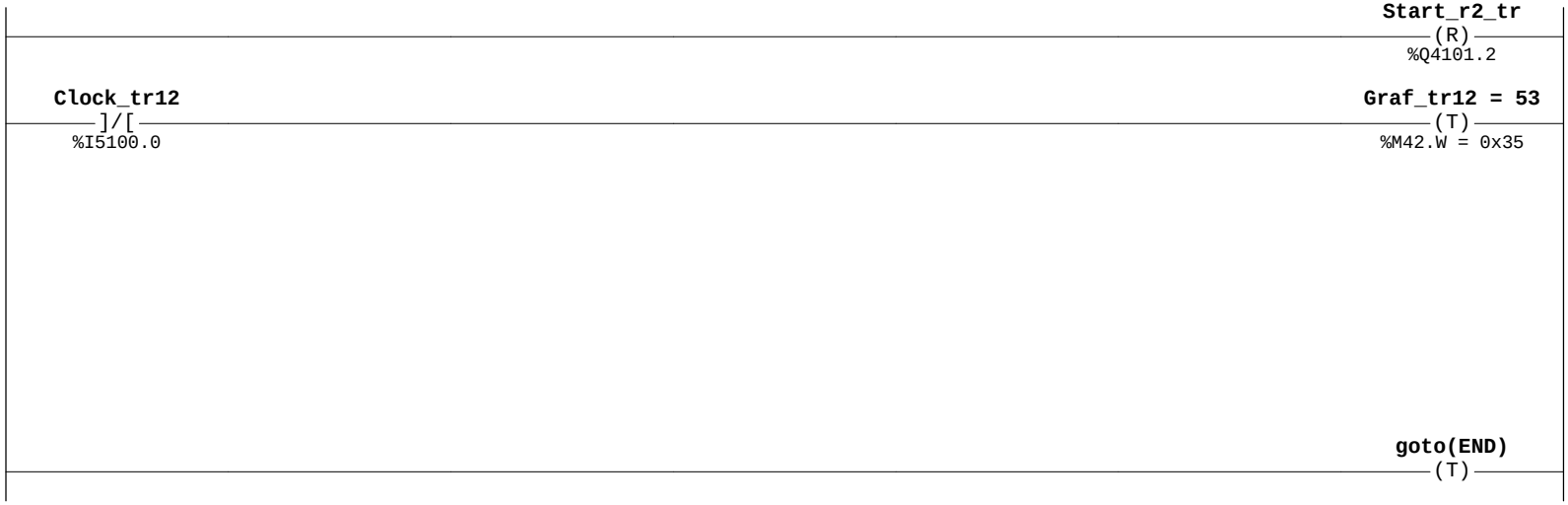
19 Label: Step: **Graf_tr12** %M42.W **= 51**

20 Label: Step: **Graf_tr12** %M42.W **= 52**



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21 Label: Step: **Graf_tr12** %M42.W **= 53**

22 Label: Step: **Graf_tr12** %M42.W **= 54**

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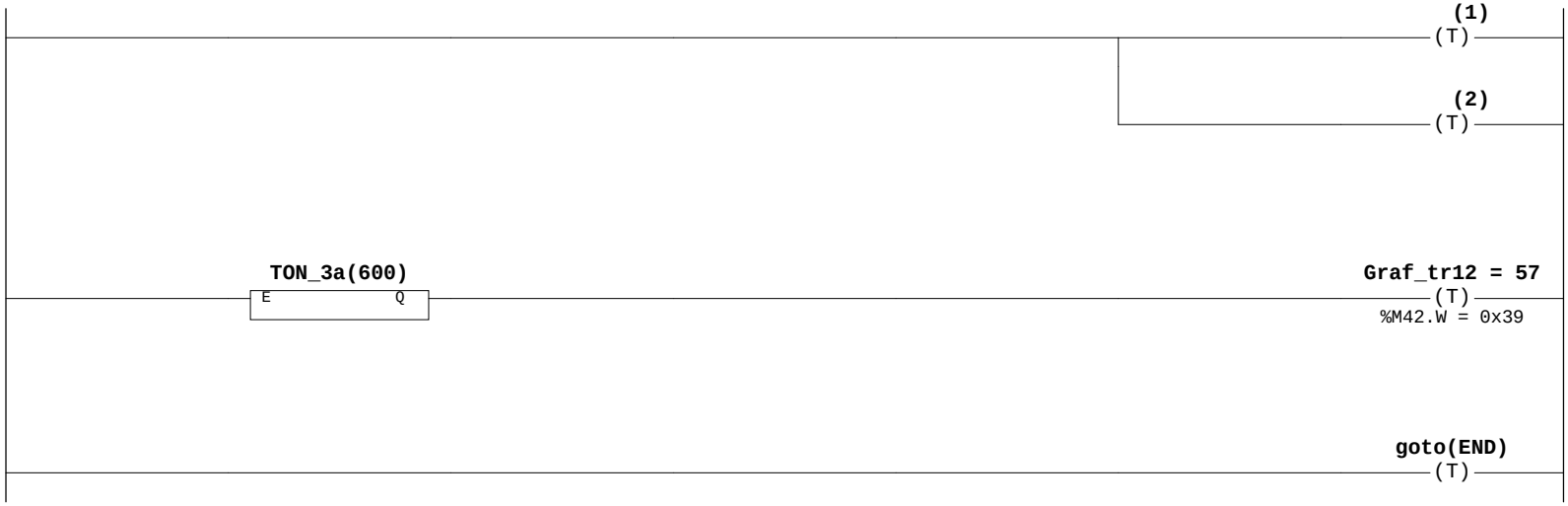
23 Label: Step: **Graf_tr12** %M42.W **= 55**

24 Label: Step: **Graf_tr12** %M42.W **= 56**



(1) %Q4101.B = %Q4101.B | 0x2 : Out_41 = Out_41 | 2
(2) write_q(0x4101, 0x1) : write_q(16641, 1)
[T] TON_3a(0x258) : TON_3a(600)

Author:		**NUM TOOLS**
Company:		
Project: **1040_78.mch**	**TITRE**	Date **28-02-2018**
Module: **TR12_POS.XLA**	**%SP133 (23)**	Page **11**

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25 Label: Step: **Graf_tr12** %M42.W **= 57**

26 Label: **END** Step:

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