

Nesting		goto(START_N)
] [(T)
%M800.6		

Start_a	X_ventose	E_prog	(1)	(2)	(3)	Mstart1_a	Start area A
] []/[] [] []/[]/[()	
%I4201.3	%V502.7	%R5.1				%V6c.0	
Start_c1a		Modcour == 7	(4)	%V18.0, %V18.1, Sel_list_ab			
] [] >[] [] [
%V2c.1		%R16.B == 0x7		%V18.0, %V18.1, %I5600.0			
		X_pgm_e, Vacu_a, X_end D_bdf, Sel_morab, Sel_list_ab					
] []/[
		%V531.4, %I4200.4, %V503.0 %M803.3, %I4100.2, %I5600.0					
		X_pgm_a, Okpres_ab, X_end Sel_morab					
] []/[
		%V531.0, %I5000.4, %V503.0 %I4100.2					
Start_a, X_ventose		E20011, E_prog, E_oper					
] []/[
%I4201.3, %V502.7		%W10.3, %R5.1, %R3.7					

- (1) %V531.0, %I4200.4, %V503.0 : X_pgm_a, Vacu_a, X_end
- (2) %I4100.2, %I5600.0 : Sel_morab, Sel_list_ab
- (3) %V503.4, %V5b4.0, %V5b4.4, %Vf.6, %I4c00.0, %V27.5, %I4101.3 : X_stat_gen, X_exec_a, X_exec_e, Pez_sblo, Auto_man, Wait_start, Setting
- (4) %V531.4, %I4b00.0, %V503.0, %M803.3 : X_pgm_e, Vacu_e, X_end, D_bdf

02 Label: Step:

Start area

Start_b	X_ventose	E_prog	(1)	(2)	(3)	Mstart1_b
] %I4201.4]/[%V502.7] %R5.1] (4)]/[%V18.2, %V18.3, Sel_list_ab]/[() %V6c.1	
Start_clb] %V2c.2		Modcour == 7]>[%R16.B == 0x7] (4)] %V18.2, %V18.3, %I5600.0		
		X_pgm_f, Vacu_bi, X_end D_bdf, Sel_morab, Sel_list_ab] %V531.5, %I4200.5, %V503.0 %M803.3, %I4100.2, %I5600.0				
		X_pgm_b, Okpres_ab, X_end Sel_morab] %V531.1, %I5000.4, %V503.0 %I4100.2				
Start_b, X_ventose] %I4201.4, %V502.7		E20011, E_prog, E_oper]>[%W10.3, %R5.1, %R3.7				

Start area B

- (1) %V531.1, %I4200.5, %V503.0 : X_pgm_b, Vacu_bi, X_end
(2) %I4100.2, %I5600.0 : Sel_morab, Sel_list_ab
(3) %V503.4, %V5b4.1, %V5b4.5, %Vf.6, %I4c00.0, %V27.5, %I4101.3 : X_stat_gen, X_exec_b, X_exec_f, Pez_sblo, Auto_man, Wait_start, Setting
(4) %V531.5, %I4b00.1, %V503.0, %M803.3 : X_pgm_f, Vacu_f, X_end, D_bdf

03 Label: Step:

Start area

Start_c	X_ventose	E_prog	(1)	(2)	(3)	Mstart1_c
] %I4201.5]/[%V502.7] %R5.1] (4)]/[%V18.4, %V18.5, Sel_list_cd]/[() %V6c.2	
Start_clc] %V2c.3		Modcour == 7]>[%R16.B == 0x7] (4)] %V18.4, %V18.5, %I5600.1		
		X_pgm_g, Vacu_cl, X_end D_bdf, Sel_morcd, Sel_list_cd] %V531.6, %I4200.6, %V503.0 %M803.3, %I4100.3, %I5600.1				
		X_pgm_c, Okpres_cd, X_end Sel_morcd] %V531.2, %I5000.5, %V503.0 %I4100.3				
Start_c, X_ventose] %I4201.5, %V502.7		E20011, E_prog, E_oper]>[%W10.3, %R5.1, %R3.7				

Start area C

- (1) %V531.2, %I4200.6, %V503.0 : X_pgm_c, Vacu_cl, X_end
(2) %I4100.3, %I5600.1 : Sel_morcd, Sel_list_cd
(3) %V503.4, %V5b4.2, %V5b4.6, %Vf.6, %I4c00.0, %V27.5, %I4101.3 : X_stat_gen, X_exec_c, X_exec_g, Pez_sblo, Auto_man, Wait_start, Setting
(4) %V531.6, %I4b00.2, %V503.0, %M803.3 : X_pgm_g, Vacu_g, X_end, D_bdf

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE		Date 28-02-2018
Module: PROG.M.XLA	%SP2 (02)		Page 2

04 Label: Step:

Start area

Start_d	X_ventose	E_prog	(1)	(2)	(3)	Mstart1_d
]	[]	[]]/	()
%I4201.6	%V502.7	%R5.1				%V6c.3
Start_cld	Modcour == 7		(4)	%V18.6, %V18.7, Sel_list_cd		
]	[]	[]]/	
%V2c.4	%R16.B == 0x7		%V18.6, %V18.7, %I5600.1			
		X_pgm_h, Vacu_d, X_end	D_bdf, Sel_morcd,	Sel_list_cd		
]	[]]/	
		%V531.7, %I4200.7, %V503.0 %M803.3, %I4100.3, %I5600.1				
		X_pgm_d, Okpres_cd, X_end	Sel_morcd			
]	[]]/	
		%V531.3, %I5000.5, %V503.0 %I4100.3				
Start_d, X_ventose		E20011, E_prog, E_oper				
]	[]	[]]/	
%I4201.6, %V502.7		%W10.3, %R5.1, %R3.7				

Start area D

(1) %V531.3, %I4200.7, %V503.0 : X_pgm_d, Vacu_d, X_end
(2) %I4100.3, %I5600.1 : Sel_morcd, Sel_list_cd
(3) %V503.4, %V5b4.3, %V5b4.7, %Vf.6, %I4c00.0, %V27.5, %I4101.3 : X_stat_gen, X_exec_d, X_exec_h, Pez_sblo, Auto_man, Wait_start, Setting
(4) %V531.7, %I4b00.3, %V503.0, %M803.3 : X_pgm_h, Vacu_h, X_end, D_bdf

05 Label: Step:

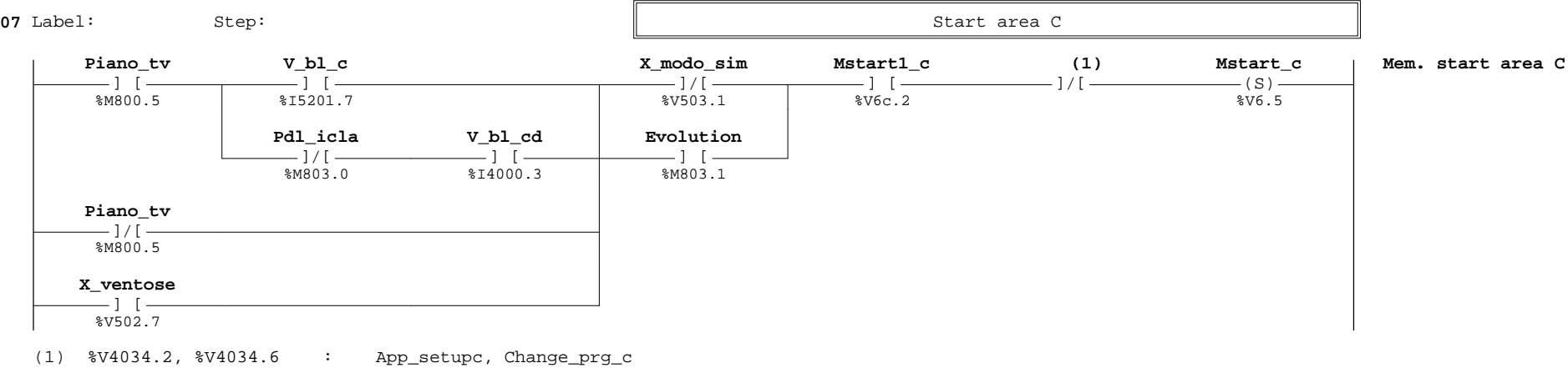
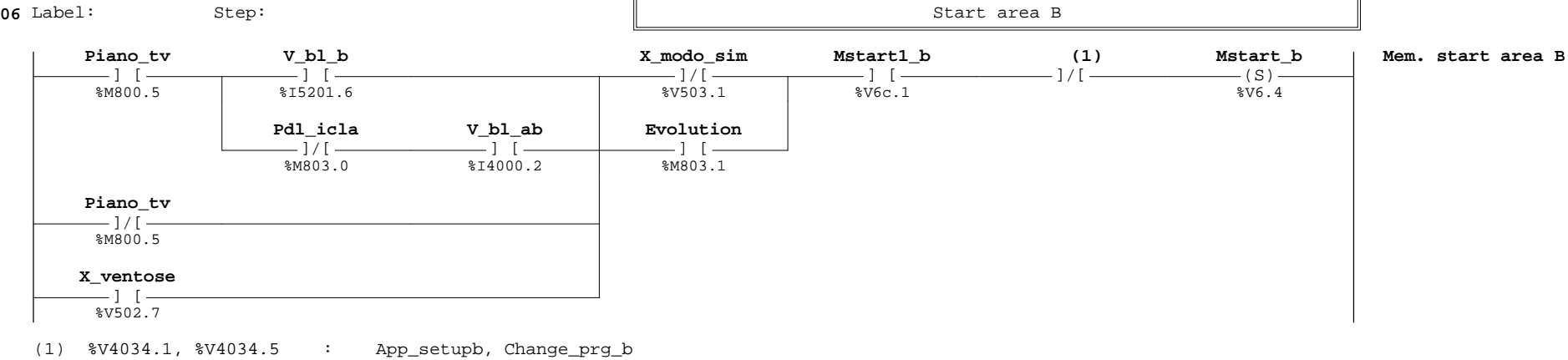
Start area A

(1)	X_mod0_sim	Mstart1_a	(2)	Mstart_a
]	[]	[]/
	%V503.1	%V6c.0		(S)
				%V6.3
Piano_tv	Evolution			
]/	[
%M800.5	%M803.1			
X_ventose				
]	[
%V502.7				

Mem. start area A

(1) %M800.5, %I4000.2 : Piano_tv, V_bl_ab
(2) %V4034.0, %V4034.4 : App_setupa, Change_prg_a

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: PROG.M.XLA	%SP2 (04)	Page	3



10 Label:

Step:

Start area con nesting

Start_d] [%I4201.6	X_ventose]/[%V502.7	E_prog] [%R5.1	(1)] [%I4100.6	Sel_rw]/[%I4100.6	(2)]/[%V6c.3	Mstart1_d () %V6c.3
Start_cld] [%V2c.4	Modcour == 7]>[%R16.B == 0x7	X_pgm_h, Vacu_d, X_end] [%V531.7, %I4200.7, %V503.0				
Start_c, X_ventose] [%I4201.5, %V502.7	E20011, E_prog, E_oper]/[%W10.3, %R5.1, %R3.7					
						goto(START1) (T)

Start area D

- (1) %V531.3, %I4200.7, %V503.0 : X_pgm_d, Vacu_d, X_end
(2) %V503.4, %V5b4.3, %V5b4.7, %Vf.6, %V27.5, %I4101.3 : X_stat_gen, X_exec_d, X_exec_h, Pez_sblo, Wait_start, Setting

11 Label:

Step:

NESTING - MORSETTI

Nesting] [%M800.6	Puls_va] [%I4200.0	Puls_vd] [%I4200.3	Abb_aree_ad] [%V1.2	Tapp_ab_em (R) %V47.4
	Puls_vd] [%I4200.3	Puls_va] [%I4200.0	Abb_aree_ad] [%V1.2	Tapp_cd_em (R) %V47.5
Sel_morab] [%I4100.2	Bpres_ab] [%I5000.1	Sel_morcd] [%I4100.3	Bpres_cd] [%I5000.3	Tapp_ab_em (R) %V47.4
				Tapp_cd_em (R) %V47.5

Tappeto area AB in emergenza

Tappeto area CD in emergenza

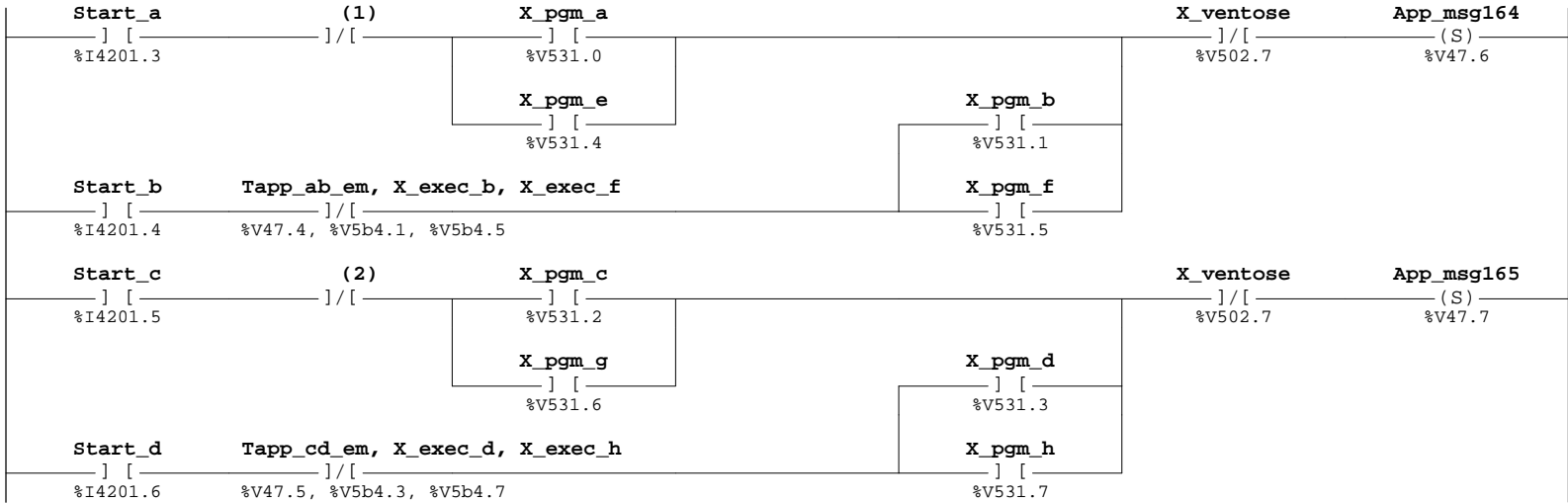
Tappeto area AB in emergenza

Tappeto area CD in emergenza

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: PROGM.XLA		%SP2 (10)	Page 6

12 Label: Step:

Gestione DIAGNOSTICA tappeti



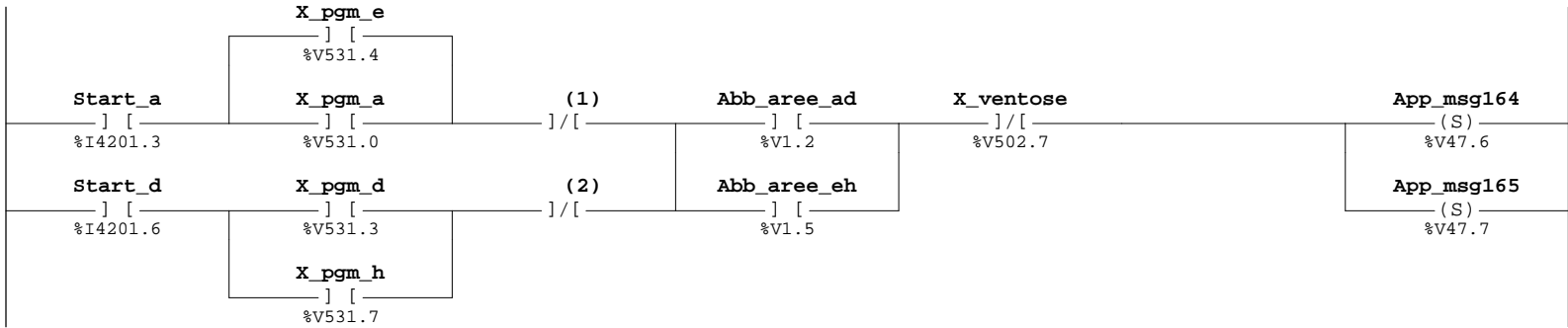
Mem. per messaggio 164

Mem. per messaggio 165

(1) %V47.4, %V5b4.0, %V5b4.4 : Tapp_ab_em, X_exec_a, X_exec_e
(2) %V47.5, %V5b4.2, %V5b4.6 : Tapp_cd_em, X_exec_c, X_exec_g

13 Label: Step:

Gestione DIAGNOSTICA tappeti



Mem. per messaggio 164

Mem. per messaggio 165

(1) %V47.4, %V5b4.0, %V5b4.4 : Tapp_ab_em, X_exec_a, X_exec_e
(2) %V47.5, %V5b4.3, %V5b4.7 : Tapp_cd_em, X_exec_d, X_exec_h

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	%SP2 (12)	Date 28-02-2018
Module: PROG.M.XLA			Page 7

14 Label: Step:

Gestione DIAGNOSTICA tappeti

Rich_raz_pan		App_msg164	
] [(R)	
%V21.0		%V47.6	
X_exec_d	Abb_aree_ad	X_exec_a	
] [] [] [
%V5b4.3	%V1.2	%V5b4.0	
X_exec_h	Abb_aree_eh	X_exec_b	
] [] [] [
%V5b4.7	%V1.5	%V5b4.1	
X_end		X_exec_e	
] / [] [
%V503.0		%V5b4.4	
		X_exec_f	
] [
		%V5b4.5	

Mem. per messaggio 164

15 Label: Step:

Gestione DIAGNOSTICA tappeti

Rich_raz_pan		App_msg165	
] [(R)	
%V21.0		%V47.7	
X_exec_a	Abb_aree_ad	X_exec_c	
] [] [] [
%V5b4.0	%V1.2	%V5b4.2	
X_exec_e	Abb_aree_eh	X_exec_d	
] [] [] [
%V5b4.4	%V1.5	%V5b4.3	
X_end		X_exec_g	
] / [] [
%V503.0		%V5b4.6	
		X_exec_h	
] [
		%V5b4.7	

Mem. per messaggio 165

Author:			NUM TOOLS	
Company:				
Project: 1040_78.mch	TITRE		Date	28-02-2018
Module: PROGM.XLA	%SP2 (14)		Page	8

16 Label:

Step:

Fronte F_T su pulsanti di start aree per gestione tappeti

Start_a	V200_4	Ft_start_a	Start area A
] [F_T	()	
%I4201.3	%V200.4	%V6c.4	
Start_b	V200_5	Ft_start_b	Start area B
] [F_T	()	
%I4201.4	%V200.5	%V6c.5	
Start_c	V200_6	Ft_start_c	Start area C
] [F_T	()	
%I4201.5	%V200.6	%V6c.6	
Start_d	V200_7	Ff_start_d	Start area D
] [F_T	()	
%I4201.6	%V200.7	%V6c.7	
Nesting		goto(START_N8)	
] [(T)	
%M800.6			

17 Label:

Step:

Start area con tappeti

(1)	X_ventose	E_prog	(2)	(3)	(4)	Mstart1_a	Start area A
] []/[] [] []/[]/[()	
	%V502.7	%R5.1				%V6c.0	
Start_c1a		Modcour == 7	(5)	%V18.0, %V18.1, Sel_list_ab			
] []>[] [] [
%V2c.1		%R16.B == 0x7		%V18.0, %V18.1, %I5600.0			
		X_pgm_e, Vacu_a, X_end D_bdf, Sel_morab, Sel_list_ab					
] []/[
		%V531.4, %I4200.4, %V503.0 %M803.3, %I4100.2, %I5600.0					
		X_pgm_a, Okpres_ab, X_end Sel_morab					
] [] [
		%V531.0, %I5000.4, %V503.0 %I4100.2					
Ft_start_a, X_ventose		E20011, E_prog, E_oper		(6)			
] []/[]/[
%V6c.4, %V502.7		%W10.3, %R5.1, %R3.7					

- (1) %V6c.4, %V47.4 : Ft_start_a, Tapp_ab_em
- (2) %V531.0, %I4200.4, %V503.0 : X_pgm_a, Vacu_a, X_end
- (3) %I4100.2, %I5600.0 : Sel_morab, Sel_list_ab
- (4) %V503.4, %V5b4.0, %V5b4.4, %Vf.6, %I4c00.0, %V27.5, %I4101.3 : X_stat_gen, X_exec_a, X_exec_e, Pez_sblo, Auto_man, Wait_start, Setting
- (5) %V531.4, %I4b00.0, %V503.0, %M803.3 : X_pgm_e, Vacu_e, X_end, D_bdf
- (6) %V503.4, %V5b4.0, %V5b4.4, %Vf.6, %I4c00.0, %V27.5 : X_stat_gen, X_exec_a, X_exec_e, Pez_sblo, Auto_man, Wait_start

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE		Date 28-02-2018
Module: PROG.M.XLA	%SP2 (16)		Page 9

18 Label:

Step:

Start area con tappeti

(1)	X_ventose	E_prog	(2)	(3)	(4)	Mstart1_b	Start area B
] [_____]/[_____ %V502.7] [_____]/[_____ %R5.1] [_____]/[_____ %V18.2, %V18.3, %I5600.0		() %V6c.1	
Start_c1b] [_____]/[_____ %V2c.2		Modcour == 7] > [_____]/[_____ %R16.B == 0x7		(5) %V18.2, %V18.3, Sel_list_ab] [_____]/[_____ %V531.5, %I4200.5, %V503.0 %M803.3, %I4100.2, %I5600.0		Sel_list_ab] [_____]/[_____ %V531.1, %I5000.4, %V503.0 %I4100.2	
X_pgm_f, Vacu_bi, X_end D_bdf, Sel_morab, Sel_list_ab] [_____]/[_____ %V531.1, %I5000.4, %V503.0 %I4100.2		X_pgm_b, Okpres_ab, X_end Sel_morab] [_____]/[_____ %V531.1, %I5000.4, %V503.0 %I4100.2		(6)			
Ft_start_b, X_ventose] [_____]/[_____ %V6c.5, %V502.7		E20011, E_prog, E_oper] [_____]/[_____ %W10.3, %R5.1, %R3.7					

- (1) %V6c.5, %V47.4 : Ft_start_b, Tapp_ab_em
- (2) %V531.1, %I4200.5, %V503.0 : X_pgm_b, Vacu_bi, X_end
- (3) %I4100.2, %I5600.0 : Sel_morab, Sel_list_ab
- (4) %V503.4, %V5b4.1, %V5b4.5, %Vf.6, %I4c00.0, %V27.5 : X_stat_gen, X_exec_b, X_exec_f, Pez_sblo, Auto_man, Wait_start, Setting
- (5) %V531.5, %I4b00.1, %V503.0, %M803.3 : X_pgm_f, Vacu_f, X_end, D_bdf
- (6) %V503.4, %V5b4.1, %V5b4.5, %Vf.6, %I4c00.0, %V27.5 : X_stat_gen, X_exec_b, X_exec_f, Pez_sblo, Auto_man, Wait_start

19 Label:

Step:

Start area con tappeti

(1)	X_ventose	E_prog	(2)	(3)	(4)	Mstart1_c	Start area C
] [_____]/[_____ %V502.7] [_____]/[_____ %R5.1] [_____]/[_____ %V18.4, %V18.5, %I5600.1		() %V6c.2	
Start_c1c] [_____]/[_____ %V2c.3		Modcour == 7] > [_____]/[_____ %R16.B == 0x7		(5) %V18.4, %V18.5, Sel_list_cd] [_____]/[_____ %V531.6, %I4200.6, %V503.0 %M803.3, %I4100.3, %I5600.1		Sel_list_cd] [_____]/[_____ %V531.2, %I5000.5, %V503.0 %I4100.3	
X_pgm_g, Vacu_cl, X_end D_bdf, Sel_morcd, Sel_list_cd] [_____]/[_____ %V531.2, %I5000.5, %V503.0 %I4100.3		X_pgm_c, Okpres_cd, X_end Sel_morcd] [_____]/[_____ %V531.2, %I5000.5, %V503.0 %I4100.3		(6)			
Ft_start_c, X_ventose] [_____]/[_____ %V6c.6, %V502.7		E20011, E_prog, E_oper] [_____]/[_____ %W10.3, %R5.1, %R3.7					

- (1) %V6c.6, %V47.5 : Ft_start_c, Tapp_cd_em
- (2) %V531.2, %I4200.6, %V503.0 : X_pgm_c, Vacu_cl, X_end
- (3) %I4100.3, %I5600.1 : Sel_morcd, Sel_list_cd
- (4) %V503.4, %V5b4.2, %V5b4.6, %Vf.6, %I4c00.0, %V27.5, %I4101.3 : X_stat_gen, X_exec_c, X_exec_g, Pez_sblo, Auto_man, Wait_start, Setting
- (5) %V531.6, %I4b00.2, %V503.0, %M803.3 : X_pgm_g, Vacu_g, X_end, D_bdf
- (6) %V503.4, %V5b4.2, %V5b4.6, %Vf.6, %I4c00.0, %V27.5 : X_stat_gen, X_exec_c, X_exec_g, Pez_sblo, Auto_man, Wait_start

Author:			NUM TOOLS	
Company:				
Project: 1040_78.mch	TITRE		Date	28-02-2018
Module: PROG.M.XLA	%SP2 (18)		Page	10

20 Label: Step:

Start area con tappeti

(1)	X_ventose	E_prog	(2)	(3)	(4)	Mstart1_d	Start area D
] [_____] / [_____] %V502.7] [_____] [_____] %R5.1] [_____] / [_____] [_____] / [_____] () %V6c.3			
Start_cld		Modcour == 7		(5) %V18.6, %V18.7, Sel_list_cd			
] [_____] [_____] %V2c.4] > [_____] [_____] %R16.B == 0x7] [_____] [_____] %V18.6, %V18.7, %I5600.1			
		X_pgm_h, Vacu_d, X_end D_bdf, Sel_morcd, Sel_list_cd					
] [_____] [_____] %V531.7, %I4200.7, %V503.0 %M803.3, %I4100.3, %I5600.1					
		X_pgm_d, Okpres_cd, X_end Sel_morcd					
] [_____] [_____] %V531.3, %I5000.5, %V503.0 %I4100.3					
Ff_start_d, X_ventose		E20011, E_prog, E_oper		(6)			
] [_____] [_____] %V6c.7, %V502.7] / [_____] [_____] %W10.3, %R5.1, %R3.7] / [_____] [_____] goto(MSTART)			
				(T)			

- (1) %V6c.7, %V47.5 : Ff_start_d, Tapp_cd_em
- (2) %V531.3, %I4200.7, %V503.0 : X_pgm_d, Vacu_d, X_end
- (3) %I4100.3, %I5600.1 : Sel_morcd, Sel_list_cd
- (4) %V503.4, %V5b4.3, %V5b4.7, %Vf.6, %I4c00.0, %V27.5, %I4101.3 : X_stat_gen, X_exec_d, X_exec_h, Pez_sblo, Auto_man, Wait_start, Setting
- (5) %V531.7, %I4b00.3, %V503.0, %M803.3 : X_pgm_h, Vacu_h, X_end, D_bdf
- (6) %V503.4, %V5b4.3, %V5b4.7, %Vf.6, %I4c00.0, %V27.5 : X_stat_gen, X_exec_d, X_exec_h, Pez_sblo, Auto_man, Wait_start

21 Label: START_N8 Step:

Start area con tappeti e nesting

(1)	X_ventose	E_prog	(2)	Sel_rw	(3)	Mstart1_a	Start area A
] [_____] / [_____] %V502.7] [_____] [_____] %R5.1] [_____] / [_____] [_____] / [_____] () %V6c.0			
Start_cla		Modcour == 7		X_pgm_e, Vacu_a, X_end			
] [_____] [_____] %V2c.1] > [_____] [_____] %R16.B == 0x7] [_____] [_____] %V531.4, %I4200.4, %V503.0			
		X_pgm_a, X_end, Vacu_cl Sel_rw					
] [_____] [_____] %V531.0, %V503.0, %I4200.6] [_____] [_____] %I4100.6			
Ft_start_a, X_ventose		E20011, E_prog, E_oper		(4)			
] [_____] [_____] %V6c.4, %V502.7] / [_____] [_____] %W10.3, %R5.1, %R3.7] / [_____] [_____] goto(MSTART)			
				(T)			

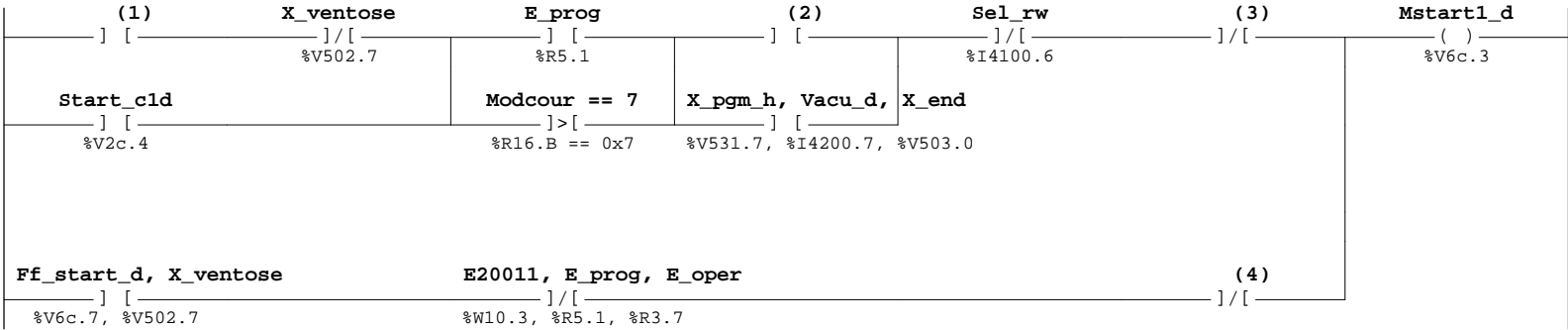
- (1) %V6c.4, %V47.4 : Ft_start_a, Tapp_ab_em
- (2) %V531.0, %I4200.4, %V503.0 : X_pgm_a, Vacu_a, X_end
- (3) %V503.4, %V5b4.0, %V5b4.4, %Vf.6, %V27.5, %I4101.3 : X_stat_gen, X_exec_a, X_exec_e, Pez_sblo, Wait_start, Setting
- (4) %V503.4, %V5b4.0, %V5b4.4, %Vf.6, %V27.5 : X_stat_gen, X_exec_a, X_exec_e, Pez_sblo, Wait_start

Author:			NUM TOOLS	
Company:				
Project: 1040_78.mch	TITRE		Date	28-02-2018
Module: PROG.M.XLA	%SP2 (20)		Page	11

22 Label:

Step:

Start area con tappeti e nesting



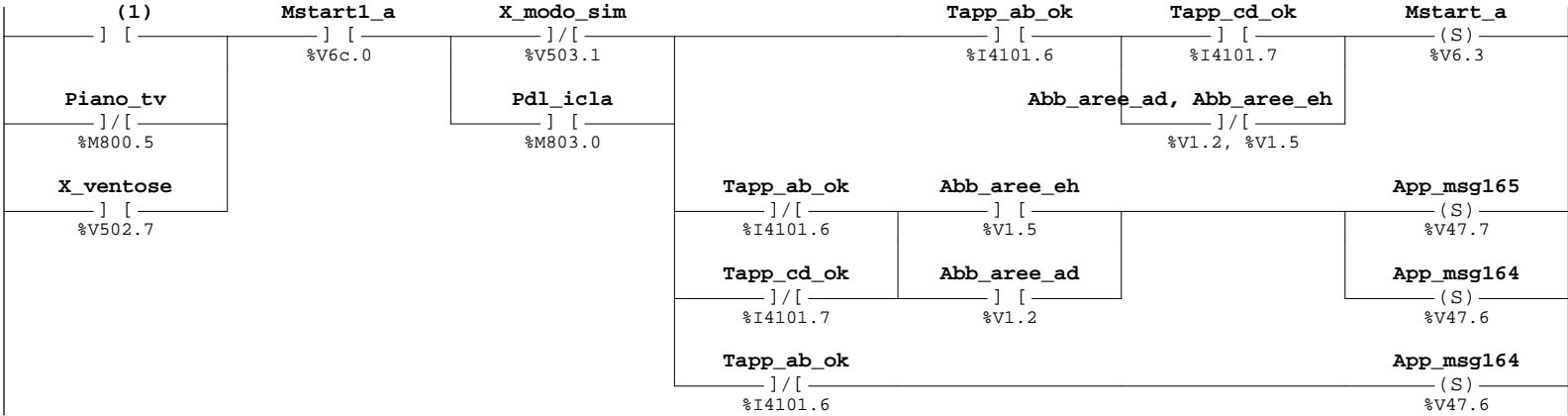
Start area D

- (1) %V6c.7, %V47.5 : Ff_start_d, Tapp_cd_em
(2) %V531.3, %I4200.7, %V503.0 : X_pgm_d, Vacu_d, X_end
(3) %V503.4, %V5b4.3, %V5b4.7, %Vf.6, %V27.5, %I4101.3 : X_stat_gen, X_exec_d, X_exec_h, Pez_sblo, Wait_start, Setting
(4) %V503.4, %V5b4.3, %V5b4.7, %Vf.6, %V27.5 : X_stat_gen, X_exec_d, X_exec_h, Pez_sblo, Wait_start

23 Label: MSTART

Step:

Gestione start area A



Mem. start area A

Mem. per messaggio 165

Mem. per messaggio 164

Mem. per messaggio 164

- (1) %M800.5, %I4000.2 : Piano_tv, V_bl_ab

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE		Date 28-02-2018
Module: PROG.M.XLA	%SP2 (22)		Page 12

24 Label: Step:

Gestione start aree B e C

(1)	Mstart1_b	X_mod0_sim	Tapp_ab_ok	Mstart_b
]	[]/[]	(S)
	%V6c.1	%V503.1	%I4101.6	%V6.4
Piano_tv		Pdl_icla	Tapp_ab_ok	App_msg164
]/[]]/[(S)
%M800.5		%M803.0	%I4101.6	%V47.6
X_ventose				
]	[
%V502.7				
(2)	Mstart1_c	X_mod0_sim	Tapp_cd_ok	Mstart_c
]	[]/[]	(S)
	%V6c.2	%V503.1	%I4101.7	%V6.5
Piano_tv		Pdl_icla	Tapp_cd_ok	App_msg165
]/[]]/[(S)
%M800.5		%M803.0	%I4101.7	%V47.7
X_ventose				
]	[
%V502.7				

Mem. start area B

Mem. per messaggio 164

Mem. start area C

Mem. per messaggio 165

(1) %M800.5, %I4000.2 : Piano_tv, V_bl_ab
(2) %M800.5, %I4000.3 : Piano_tv, V_bl_cd

25 Label: Step:

Gestione start area D

(1)	Mstart1_d	X_mod0_sim	Tapp_cd_ok	Tapp_ab_ok	Mstart_d
]	[]/[]]	(S)
	%V6c.3	%V503.1	%I4101.7	%I4101.6	%V6.6
Piano_tv		Pdl_icla	Abb_aree_ad, Abb_aree_eh		
]/[]]/[
%M800.5		%M803.0	%V1.2, %V1.5		
X_ventose			Tapp_ab_ok	Abb_aree_eh	App_msg164
]	[]/[]	(S)
%V502.7			%I4101.6	%V1.5	%V47.6
			Tapp_cd_ok	Abb_aree_ad	App_msg165
]/[]	(S)
			%I4101.7	%V1.2	%V47.7
			Tapp_cd_ok		App_msg165
]/[(S)
			%I4101.7		%V47.7

Mem. start area D

Mem. per messaggio 164

Mem. per messaggio 165

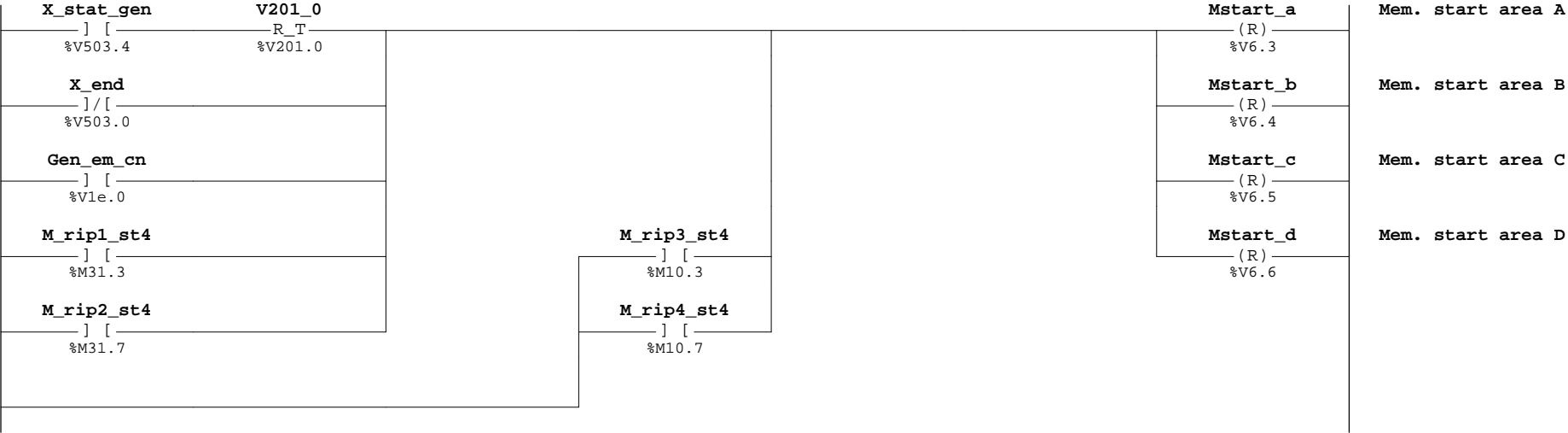
Mem. per messaggio 165

(1) %M800.5, %I4000.3 : Piano_tv, V_bl_cd

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: PROGM.XLA	%SP2 (24)	Page	13

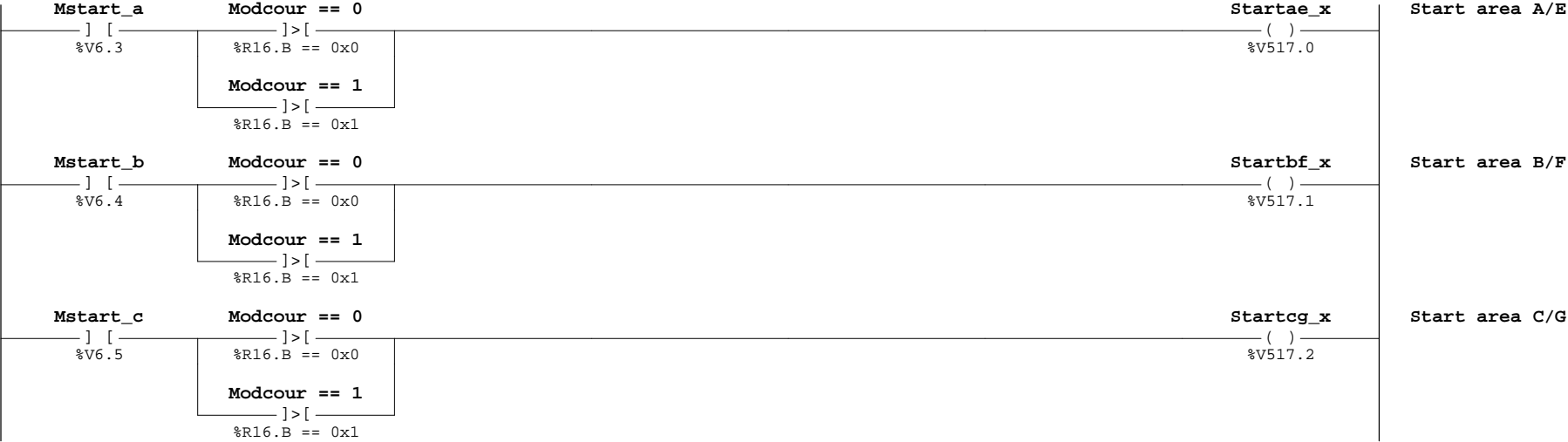
26 Label: **START1** Step:

Reset start area



27 Label: Step:

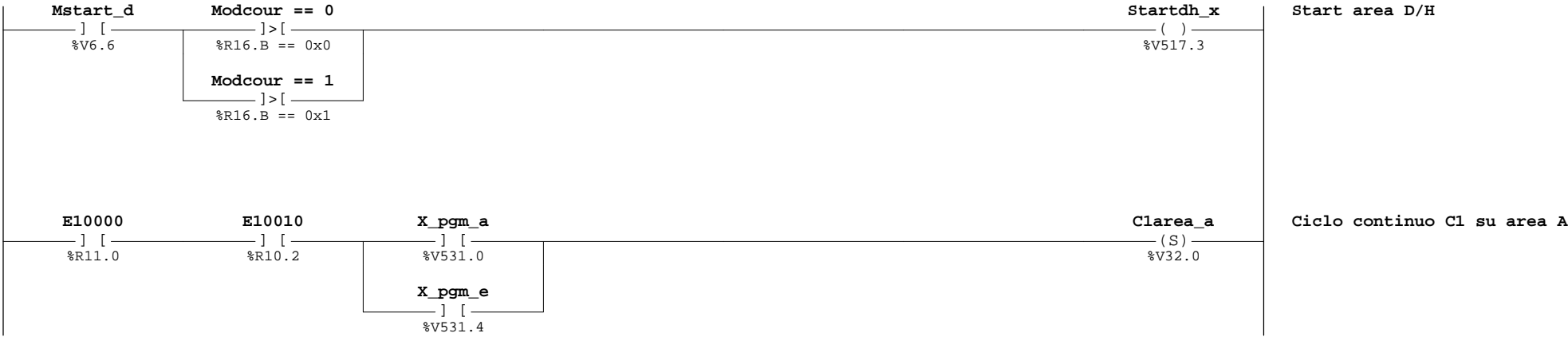
Start area a Xilog



28 Label:

Step:

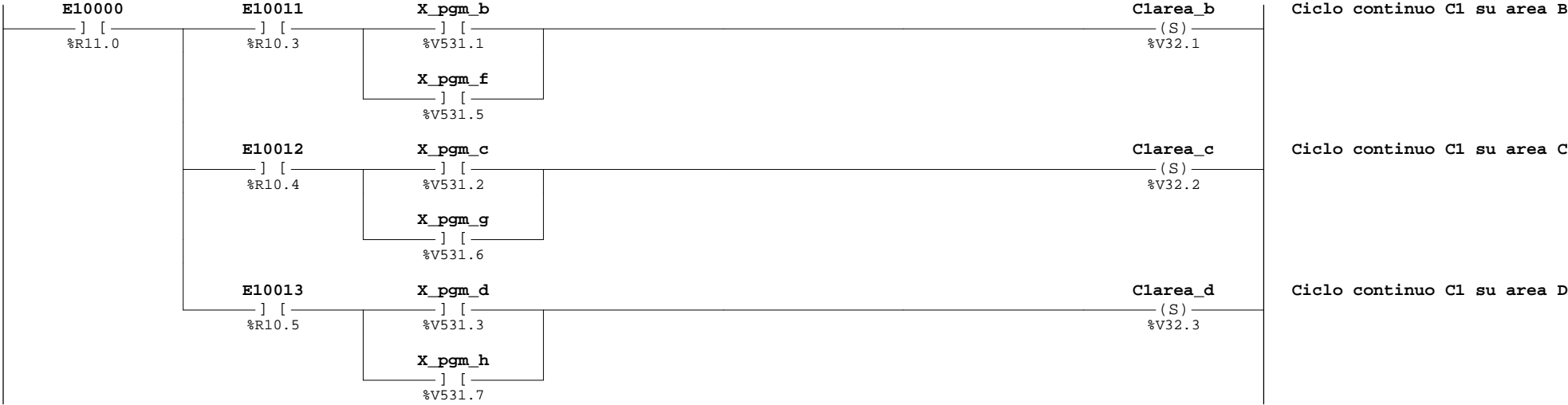
Start area a Xilog



29 Label:

Step:

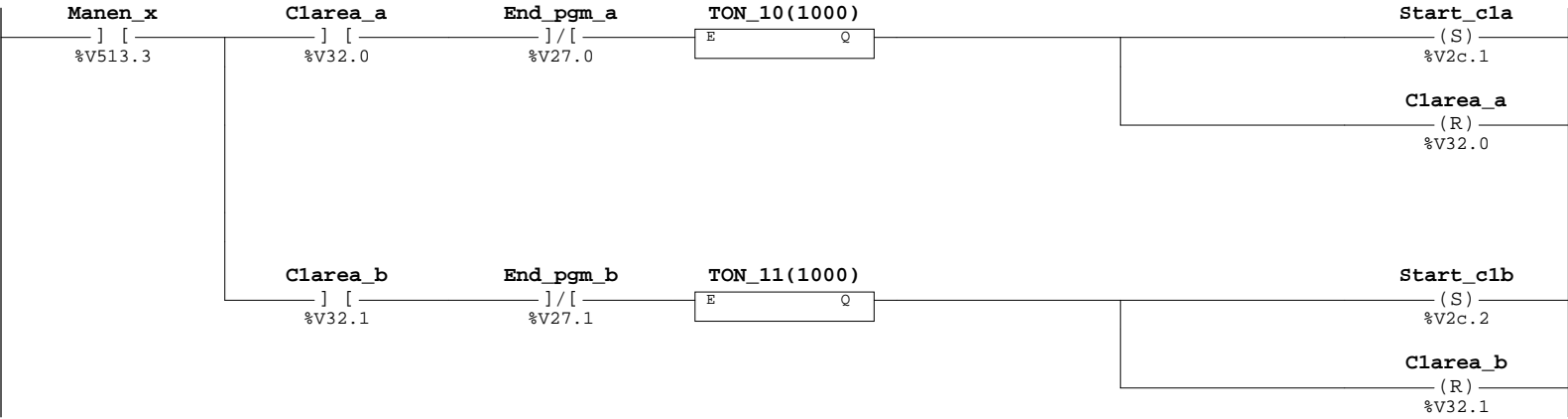
Gestione continuo



Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: PROGM.XLA		%SP2 (28)	Page 15

30 Label: Step:

Gestione continuo



Mem. ciclo continuo C1 abilitato

Ciclo continuo C1 su area A

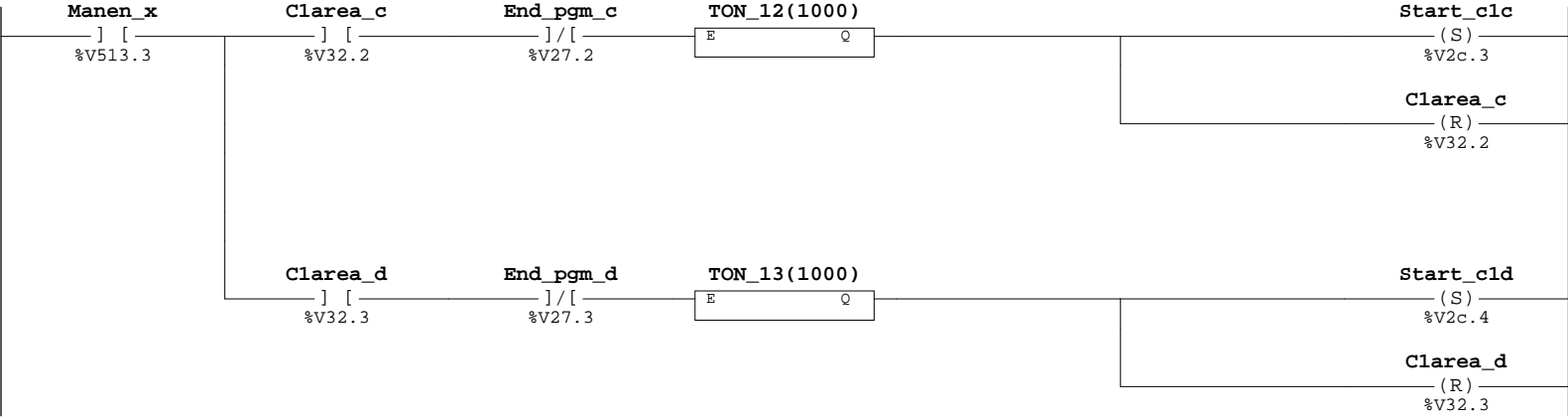
Mem. ciclo continuo C1 abilitato

Ciclo continuo C1 su area B

[T] TON_10(0x3e8) : TON_10(1000)
[T] TON_11(0x3e8) : TON_11(1000)

31 Label: Step:

Gestione continuo



Mem. ciclo continuo C1 abilitato

Ciclo continuo C1 su area C

Mem. ciclo continuo C1 abilitato

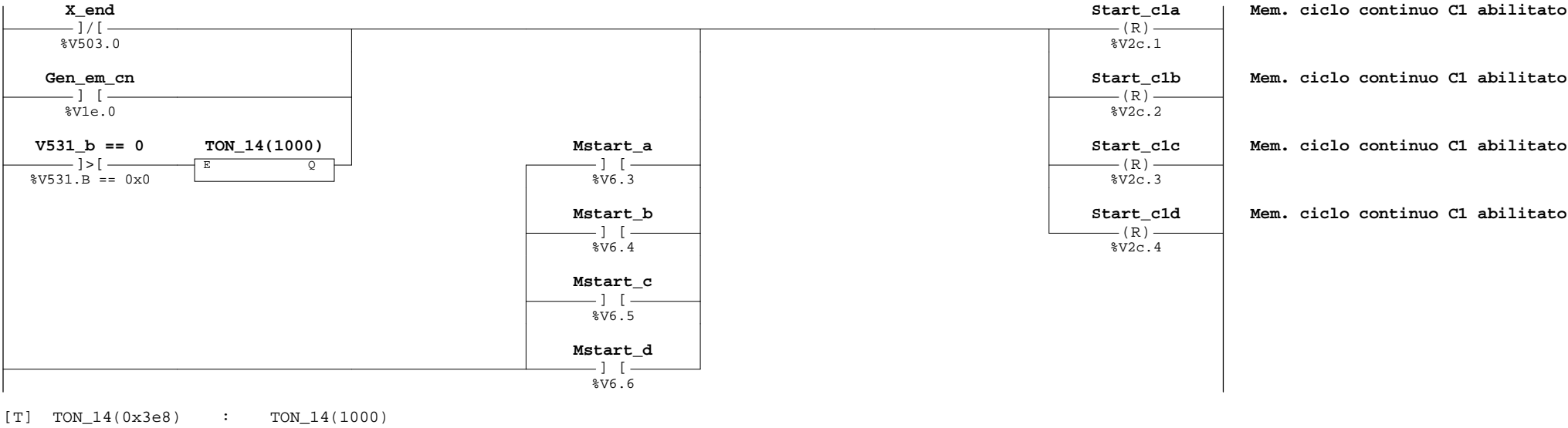
Ciclo continuo C1 su area D

[T] TON_12(0x3e8) : TON_12(1000)
[T] TON_13(0x3e8) : TON_13(1000)

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE		Date 28-02-2018
Module: PROGM.XLA			Page 16

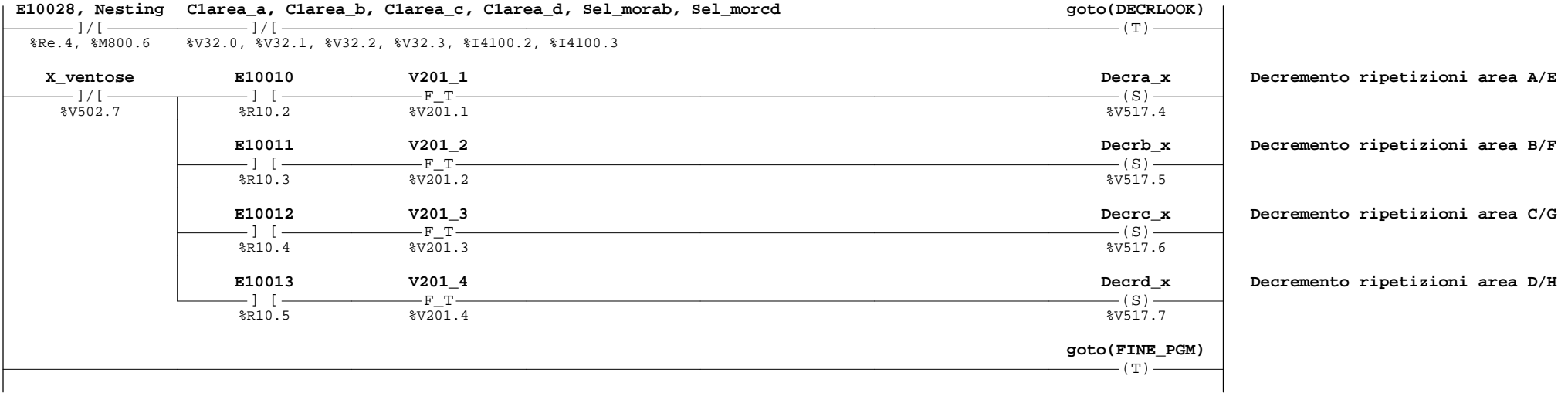
32 Label: Step:

Gestione continuo

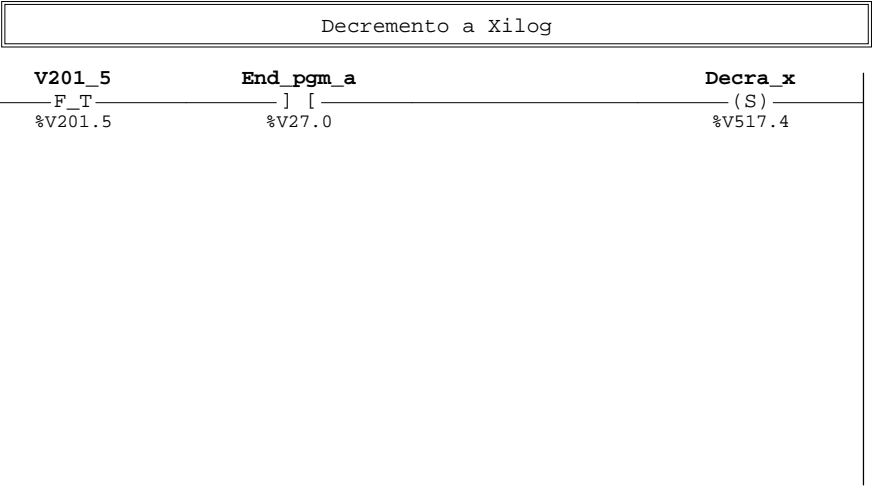


33 Label: Step:

Selezione metodo di decremento

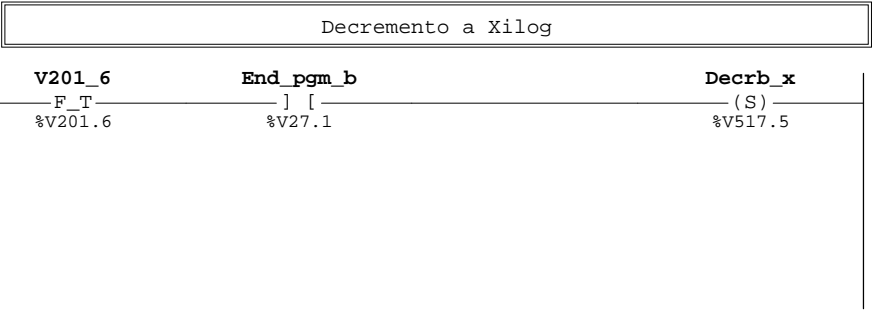


34 Label: **DECRL00K** Step:



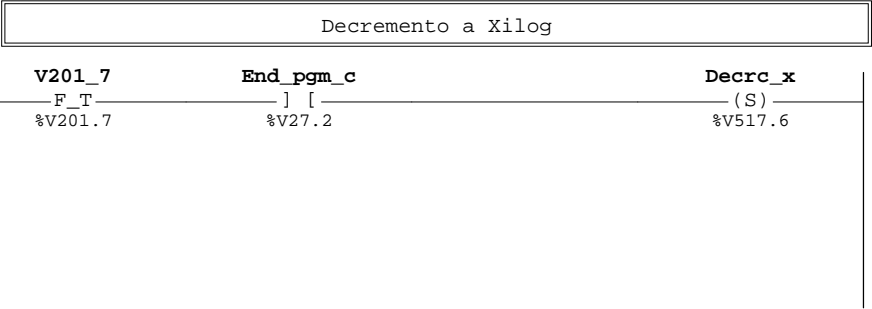
Decremento ripetizioni area A/E

35 Label: Step:



Decremento ripetizioni area B/F

36 Label: Step:



Decremento ripetizioni area C/G

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE		Date 28-02-2018
Module: PROG.M.XLA	%SP2 (34)		Page 18

37 Label: Step:

Decremento a Xilog

App_lockd		V202_0	End_pgm_d	Decrd_x	Decremento ripetizioni area D/H
] [F_T] [(S)	
%Vf.3		%V202.0	%V27.3	%V517.7	
App_lockc	Abb_aree_cd				
] [] [
%Vf.2	%V1.1				
App_locka	Abb_aree_gh				
] [] [
%Vf.0	%V1.4				
App_lockb	Abb_aree_ad				
] [] [
%Vf.1	%V1.2				
App_lockc	Abb_aree_eh				
] [] [
%Vf.2	%V1.5				

38 Label: FINE_PGM Step:

Fine programma

X_end	E20012	Automatico in corso
] [()	
%V503.0	%W10.4	
X_ventose	E10010	Mem. fine programma area A per d
]/[] [
%V502.7	%R10.2	
E_prog	E10011	Mem. fine programma area B per d
] [] [
%R5.1	%R10.3	
	E10012	Mem. fine programma area C per d
] [
	%R10.4	
	E10013	Mem. fine programma area D per d
] [
	%R10.5	
	End_pgm_a	
	(S)	
	%V27.0	
	End_pgm_b	
	(S)	
	%V27.1	
	End_pgm_c	
	(S)	
	%V27.2	
	End_pgm_d	
	(S)	
	%V27.3	

39 Label: Step:

Fine programma

Decra_x —] [— %V517.4		End_pgm_a —(R)— %V27.0	Mem. fine programma area A per d
Rich_raz_pan —] [— %V21.0			
X_end —]/[— %V503.0			
Decrb_x —] [— %V517.5		End_pgm_b —(R)— %V27.1	Mem. fine programma area B per d
Rich_raz_pan —] [— %V21.0			
X_end —]/[— %V503.0			

40 Label: Step:

Fine programma

Decrc_x —] [— %V517.6		End_pgm_c —(R)— %V27.2	Mem. fine programma area C per d
Rich_raz_pan —] [— %V21.0			
X_end —]/[— %V503.0			
Decrd_x —] [— %V517.7		End_pgm_d —(R)— %V27.3	Mem. fine programma area D per d
Rich_raz_pan —] [— %V21.0			
X_end —]/[— %V503.0			

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: PROG.M.XLA		%SP2 (39)	Page 20

41 Label: Step:

Decremento a Xilog

<div><div>X_decr_gen</div><div><div>]</div><div>[</div><div>R_T</div></div><div>%V503.5</div><div>%V202.1</div></div>		<div><div>Decra_x</div><div><div>(R)</div></div><div>%V517.4</div></div>	Decremento ripetizioni area A/E
<div><div>Rich_raz_pan</div><div><div>]</div><div>[</div></div><div>%V21.0</div></div>		<div><div>Decrb_x</div><div><div>(R)</div></div><div>%V517.5</div></div>	Decremento ripetizioni area B/F
<div><div>X_end</div><div><div>]/[</div></div><div>%V503.0</div></div>		<div><div>Decrc_x</div><div><div>(R)</div></div><div>%V517.6</div></div>	Decremento ripetizioni area C/G
		<div><div>Decrd_x</div><div><div>(R)</div></div><div>%V517.7</div></div>	Decremento ripetizioni area D/H

42 Label: Step:

Stato area a Xilog

<div><div>Vacu_a</div><div><div>]</div><div>[</div></div><div>%I4200.4</div></div>	<div><div>(1)</div><div><div>]/[</div></div></div>	<div><div>V202_2</div><div><div>R_T</div></div><div>%V202.2</div></div>	<div><div>E_oper</div><div><div>]/[</div></div><div>%R3.7</div></div>	<div><div>Statoa_x = 1</div><div><div>(T)</div></div><div>%V518.B = 0x1</div></div>
<div><div>Vacu_e</div><div><div>]</div><div>[</div></div><div>%I4b00.0</div></div>	<div><div>%V18.0, %V18.1, Sel_list_ab</div><div><div>]</div><div>[</div></div><div>%V18.0, %V18.1, %I5600.0</div></div>			
<div><div>Vacu_cl</div><div><div>]</div><div>[</div></div><div>%I4200.6</div></div>	<div><div>Sel_rw</div><div><div>]</div><div>[</div></div><div>%I4100.6</div></div>			
<div><div>Sel_morab, Okpres_ab</div><div><div>]</div><div>[</div></div><div>%I4100.2, %I5000.4</div></div>				

(1) %I4100.2, %I5600.0, %I4100.6 : Sel_morab, Sel_list_ab, Sel_rw

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: PROG.M.XLA		%SP2 (41)	Page 21

43 Label: Step:

Stato area a Xilog

Vacu_bi		(1)	V202_3	E_oper	Statob_x = 1
] []/[R_T]/[(T)
%I4200.5			%V202.3	%R3.7	%V519.B = 0x1
Vacu_f		%V18.2, %V18.3, Sel_list_ab			
] [] [
%I4b00.1		%V18.2, %V18.3, %I5600.0			
Sel_morab, Okpres_ab					
] [
%I4100.2, %I5000.4					
Vacu_cl		(2)	V202_4	E_oper	Statoc_x = 1
] []/[R_T]/[(T)
%I4200.6			%V202.4	%R3.7	%V51a.B = 0x1
Vacu_g		%V18.4, %V18.5, Sel_list_cd			
] [] [
%I4b00.2		%V18.4, %V18.5, %I5600.1			
Sel_morcd, Okpres_cd					
] [
%I4100.3, %I5000.5					

(1) %I4100.2, %I5600.0 : Sel_morab, Sel_list_ab
(2) %I4100.3, %I5600.1 : Sel_morcd, Sel_list_cd

44 Label: Step:

Stato area a Xilog

Vacu_d		(1)	V202_5	E_oper	Statod_x = 1
] []/[R_T]/[(T)
%I4200.7			%V202.5	%R3.7	%V51b.B = 0x1
Vacu_h		%V18.6, %V18.7, Sel_list_cd			
] [] [
%I4b00.3		%V18.6, %V18.7, %I5600.1			
Sel_morcd, Okpres_cd					
] [
%I4100.3, %I5000.5					

(1) %I4100.3, %I5600.1 : Sel_morcd, Sel_list_cd

Author:			NUM TOOLS	
Company:				
Project: 1040_78.mch	TITRE		Date	28-02-2018
Module: PROGM.XLA	%SP2 (43)		Page	22

45 Label: Step:

Stato area a Xilog

Mstart_a	V202_6	Statoa_x = 2
] [R_T	(T)
%V6.3	%V202.6	%V518.B = 0x2
Mstart_b	V202_7	Statob_x = 2
] [R_T	(T)
%V6.4	%V202.7	%V519.B = 0x2
Mstart_c	V203_0	Statoc_x = 2
] [R_T	(T)
%V6.5	%V203.0	%V51a.B = 0x2
Mstart_d	V203_1	Statod_x = 2
] [R_T	(T)
%V6.6	%V203.1	%V51b.B = 0x2

46 Label: Step:

Stato area a Xilog

E10010	V203_2	Fine_prga
] [R_T	(S)
%R10.2	%V203.2	%V25.4
E10011	V203_3	Fine_prgb
] [R_T	(S)
%R10.3	%V203.3	%V25.5
E10012	V203_4	Fine_prgc
] [R_T	(S)
%R10.4	%V203.4	%V25.6
E10013	V203_5	Fine_prgd
] [R_T	(S)
%R10.5	%V203.5	%V25.7

Mem. fine programma su area A pe

Mem. fine programma su area B pe

Mem. fine programma su area C pe

Mem. fine programma su area D pe

47 Label: Step:

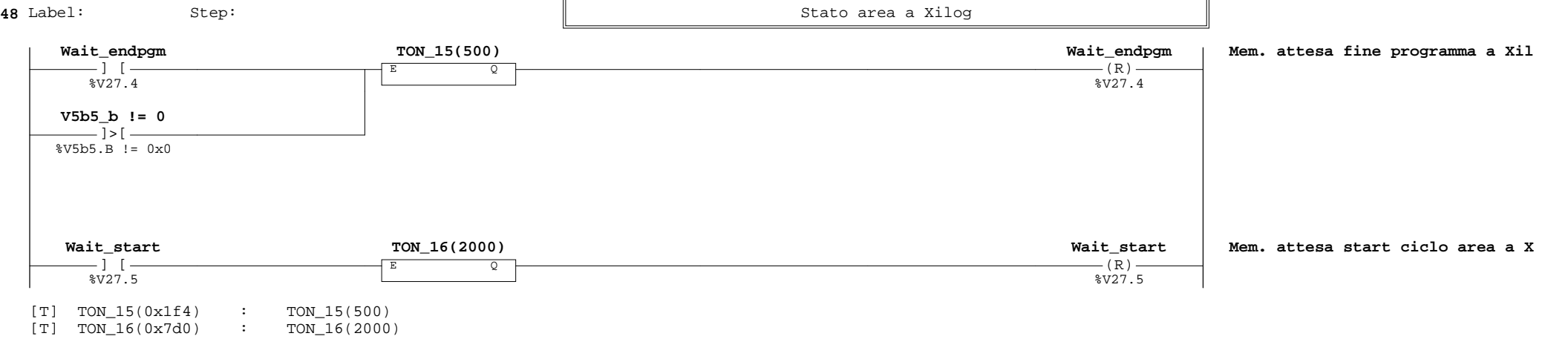
Stato area a Xilog

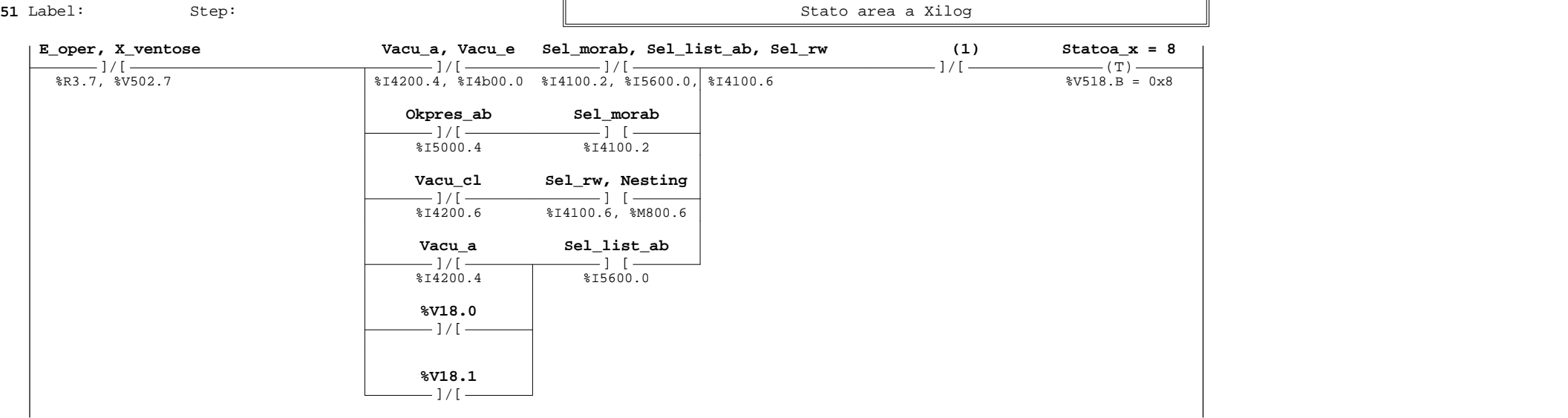
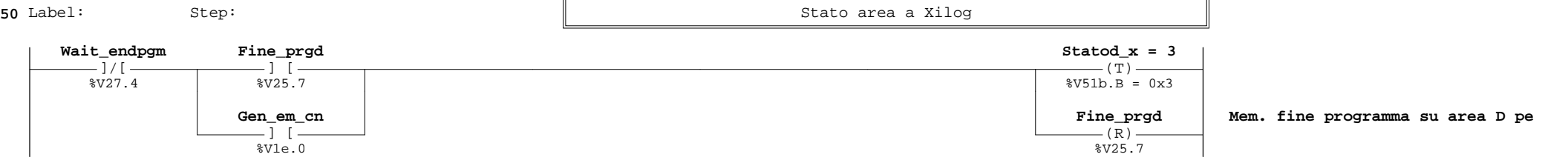
Fine_prga	Wait_endpgm
] [(S)
%V25.4	%V27.4
Fine_prgb	Wait_start
] [(S)
%V25.5	%V27.5
Fine_prgc	
] [
%V25.6	
Fine_prgd	
] [
%V25.7	

Mem. attesa fine programma a Xil

Mem. attesa start ciclo area a X

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: PROGM.XLA		%SP2 (45)	Page 23





52 Label: Step:

Stato area a Xilog

E_oper, X_ventose	Vacu_bi, Vacu_f	Sel_morab, Sel_list_ab	(1)	Statob_x = 8
]/[%R3.7, %V502.7]/[%I4200.5, %I4b00.1]/[%I4100.2, %I5600.0]/[(T)	%V519.B = 0x8
	Okpres_ab	Sel_morab		
]/[%I5000.4]/[%I4100.2		
	Vacu_bi	Sel_list_ab		
]/[%I4200.5]/[%I5600.0		
	%V18.2			
]/[
	%V18.3			
]/[

(1) %V5b4.1, %V5b4.5 : X_exec_b, X_exec_f

53 Label: Step:

Stato area a Xilog

E_oper, X_ventose	Vacu_cl, Vacu_g	Sel_morcd, Sel_list_cd	(1)	Statoc_x = 8
]/[%R3.7, %V502.7]/[%I4200.6, %I4b00.2]/[%I4100.3, %I5600.1]/[(T)	%V51a.B = 0x8
	Okpres_cd	Sel_morcd		
]/[%I5000.5]/[%I4100.3		
	Vacu_cl	Sel_list_cd		
]/[%I4200.6]/[%I5600.1		
	%V18.4			
]/[
	%V18.5			
]/[

(1) %V5b4.2, %V5b4.6 : X_exec_c, X_exec_g

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: PROG.M.XLA		%SP2 (52)	Page 26

54 Label: Step:

Stato area a Xilog

E_oper, X_ventose	Vacu_d, Vacu_h	Sel_morcd, Sel_list_cd	(1)	Statod_x = 8
]/[%R3.7, %V502.7]/[%I4200.7, %I4b00.3]/[%I4100.3, %I5600.1]/[(T)	%V51b.B = 0x8
	Okpres_cd	Sel_morcd		
]/[%I5000.5]/[%I4100.3		
	Vacu_d	Sel_list_cd		
]/[%I4200.7]/[%I5600.1		
	%V18.6			
]/[
	%V18.7			
]/[

(1) %V5b4.3, %V5b4.7 : X_exec_d, X_exec_h

55 Label: Step:

Gestione laser posizionamento ventose

M146_1	Laser2	Laser DX posizinzamento piani/ven
]/[%V692.0	(S) %Q4601.7	
M148_1	Laser2	Laser DX posizinzamento piani/ven
]/[%V694.0	(R) %Q4601.7	
E_raz		
]/[%R3.0		
M145_1	Laser1	Laser SX posizinzamento piani/ven
]/[%V691.0	(S) %Q4601.6	
M147_1	Laser1	Laser SX posizinzamento piani/ven
]/[%V693.0	(R) %Q4601.6	
E_raz		
]/[%R3.0		

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: PROGM.XLA	%SP2 (54)	Page	27