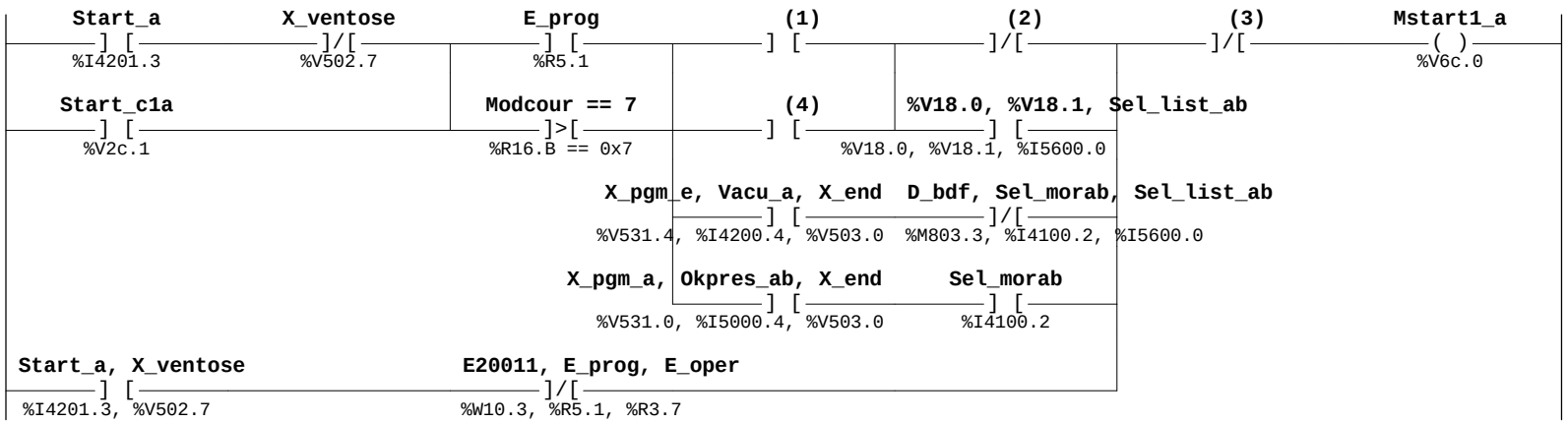
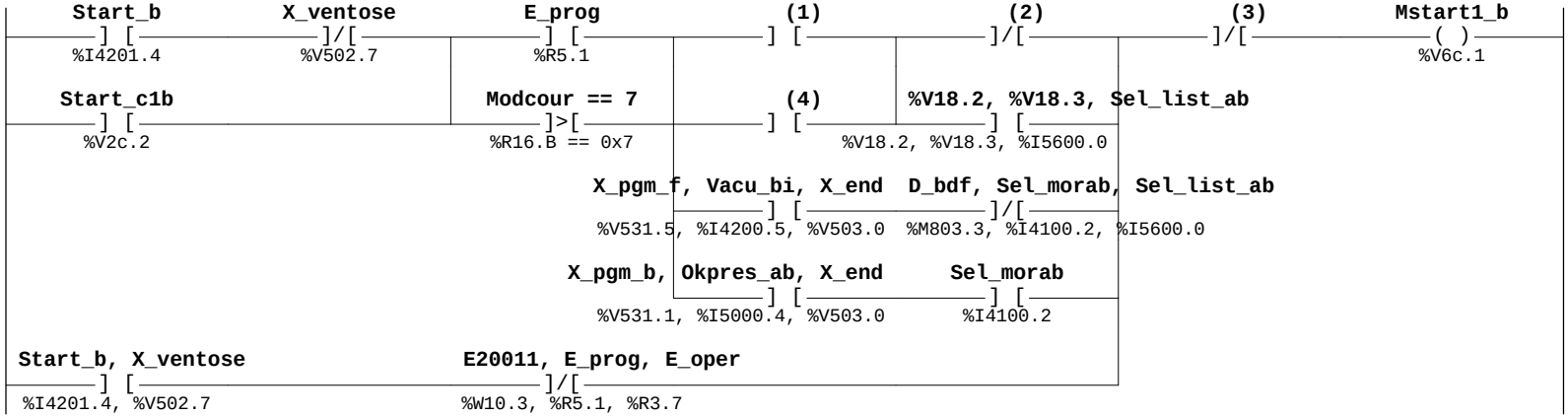
00 Label: Step: Verifica se tappeti / bumpers o nesting

01 Label: Step: Start area



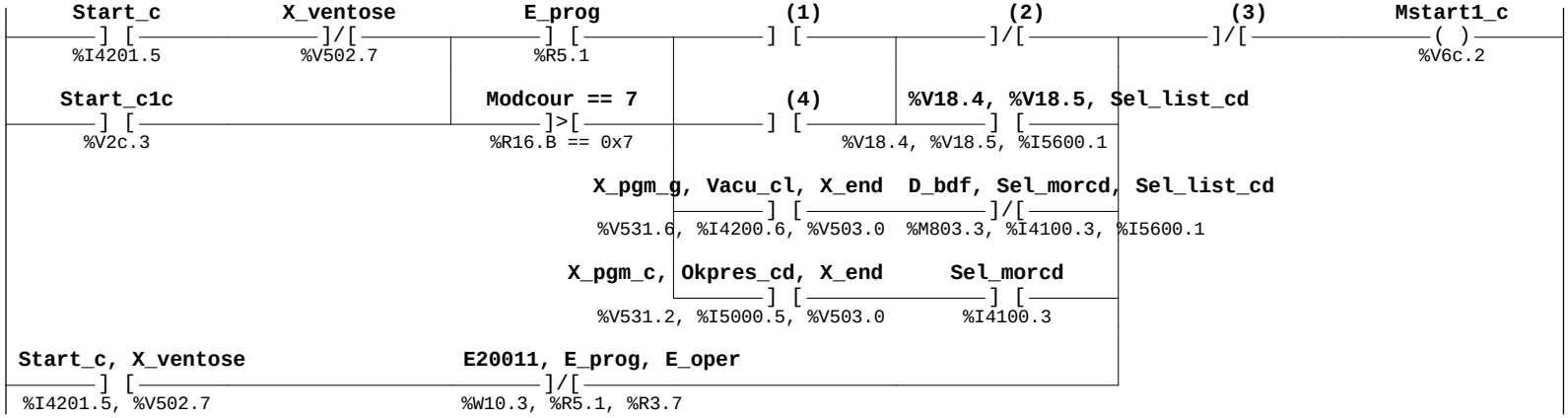
(1) %V531.0, %I4200.4, %V503.0 : X_pgm_a, Vacu_a, X_end
(2) %I4100.2, %I5600.0 : Sel_morab, Sel_list_ab
(3) %V503.4, %V5b4.0, %V5b4.4, %Vf.6, %I4c00.0, %V27.5, %I4101.3 : X_stat_gen, X_exec_a, X_exec_e, Pez_sblo, Auto_man, Wait_start, Setting
(4) %V531.4, %I4b00.0, %V503.0, %M803.3 : X_pgm_e, Vacu_e,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

02 Label: Step: Start area



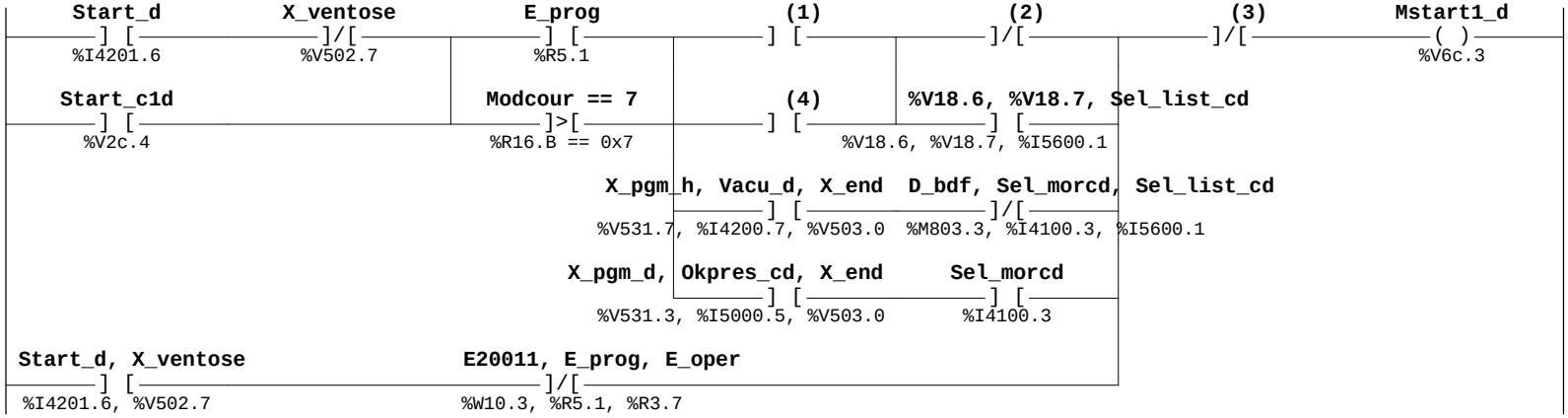
(1) %V531.1, %I4200.5, %V503.0 : X_pgm_b, Vacu_bi, X_end
(2) %I4100.2, %I5600.0 : Sel_morab, Sel_list_ab
(3) %V503.4, %V5b4.1, %V5b4.5, %Vf.6, %I4c00.0, %V27.5, %I4101.3 : X_stat_gen, X_exec_b, X_exec_f, Pez_sblo, Auto_man, Wait_start, Setting
(4) %V531.5, %I4b00.1, %V503.0, %M803.3 : X_pgm_f, Vacu_f,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

03 Label: Step: Start area



(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

04 Label: Step: Start area

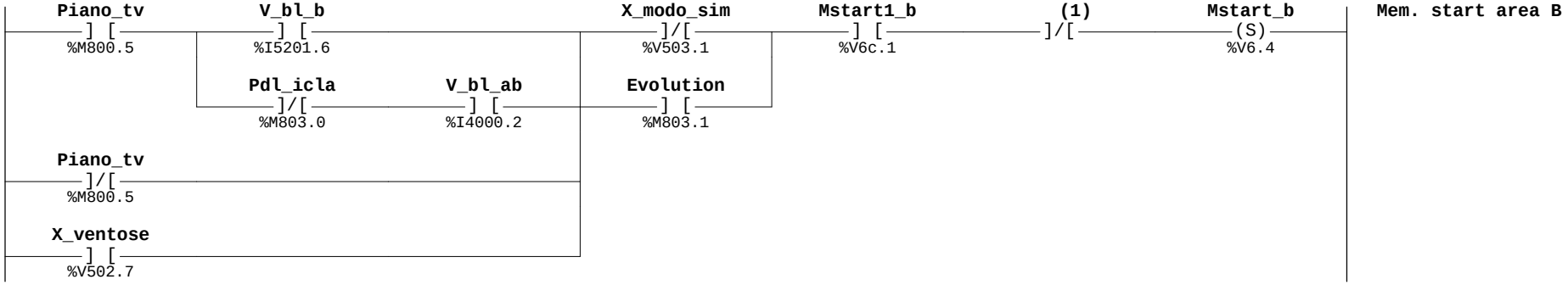


(1) %V531.3, %I4200.7, %V503.0 : X_pgm_d, Vacu_d, X_end
(2) %I4100.3, %I5600.1 : Sel_morcd, Sel_list_cd
(3) %V503.4, %V5b4.3, %V5b4.7, %Vf.6, %I4c00.0, %V27.5, %I4101.3 : X_stat_gen, X_exec_d, X_exec_h, Pez_sblo, Auto_man, Wait_start, Setting
(4) %V531.7, %I4b00.3, %V503.0, %M803.3 : X_pgm_h, Vacu_h,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

05 Label: Step: Start area A

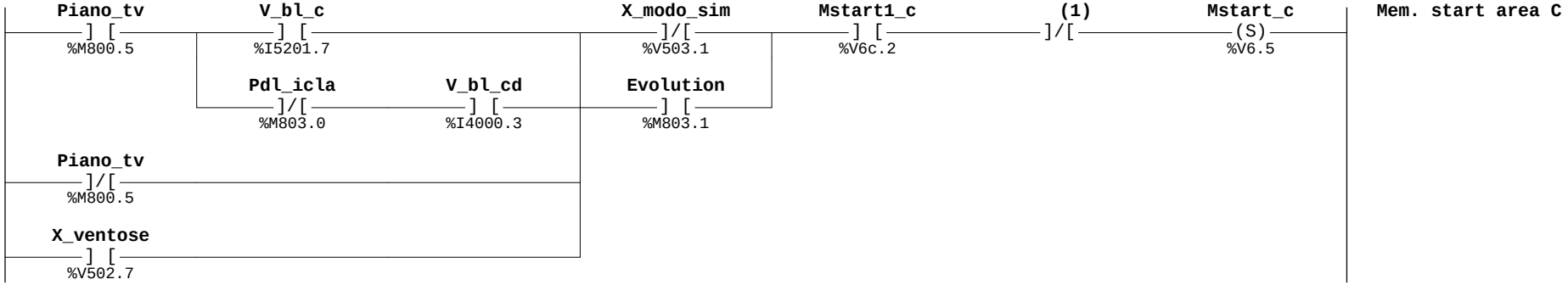
(1) %M800.5, %I4000.2 : Piano_tv, V_bl_ab
(2) %V4034.0, %V4034.4 : App_setupa, Change_prg_a

06 Label: Step: Start area B



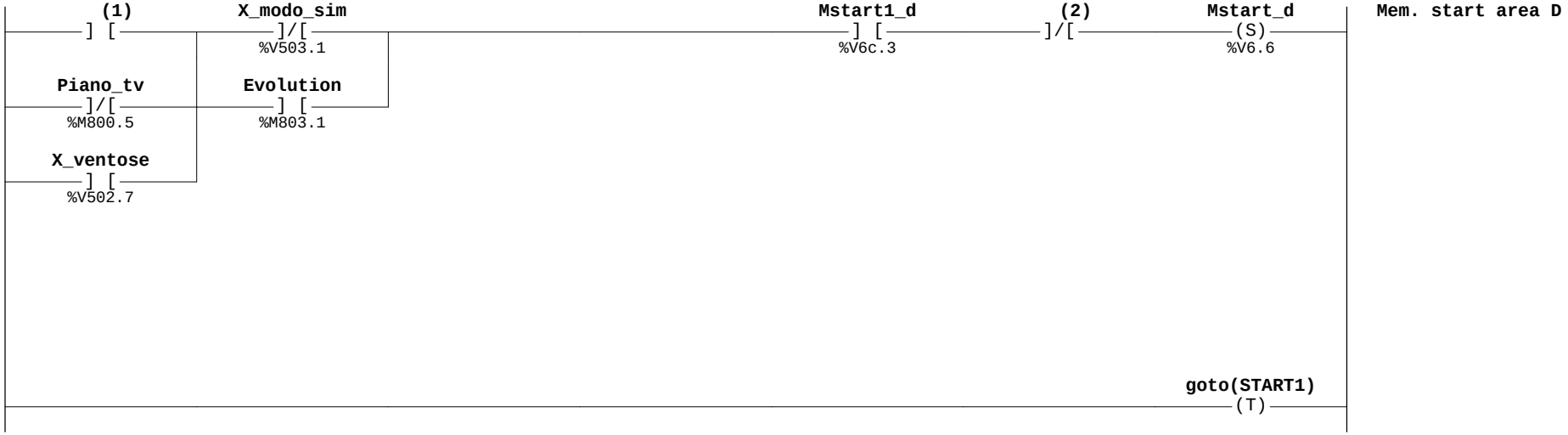
(1) %V4034.1, %V4034.5 : App_setupb, Change_prg_b

07 Label: Step: Start area C



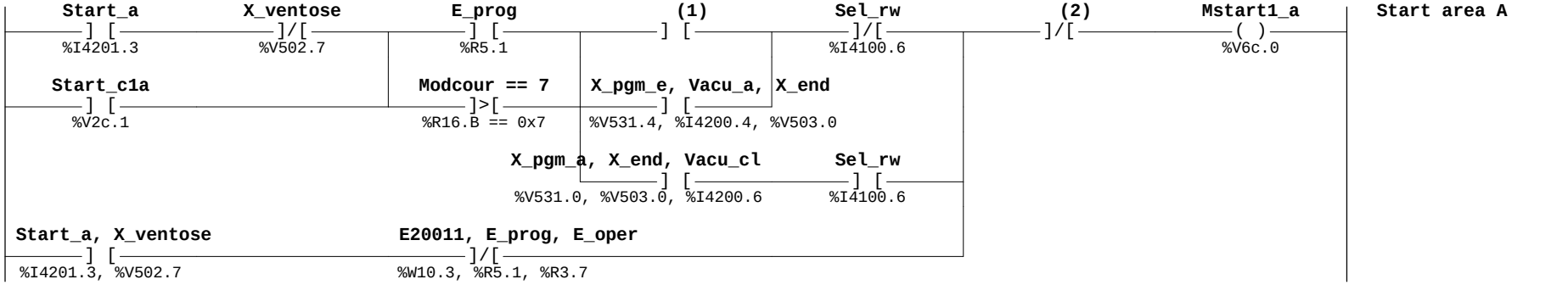
(1) %V4034.2, %V4034.6 : App_setupc, Change_prg_c

08 Label: Step: Start area D



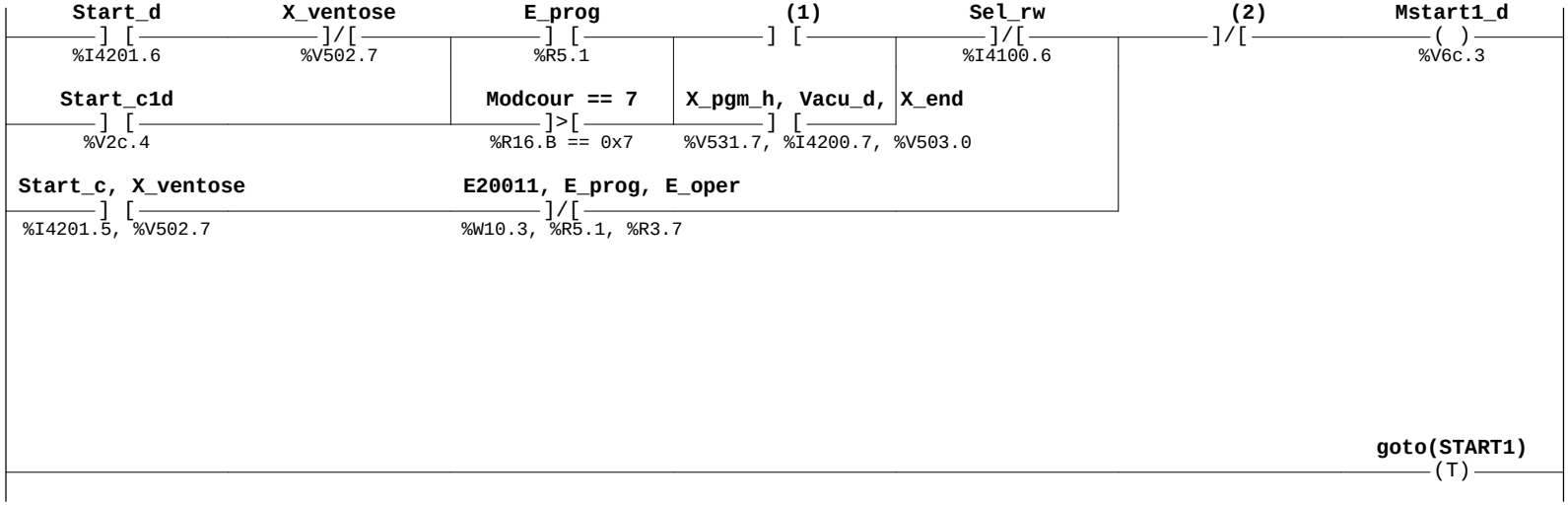
(1) %M800.5, %I4000.3 : Piano_tv, V_bl_cd
(2) %V4034.3, %V4034.7 : App_setupd, Change_prg_d

09 Label: **START_N** Step: Start area con nesting



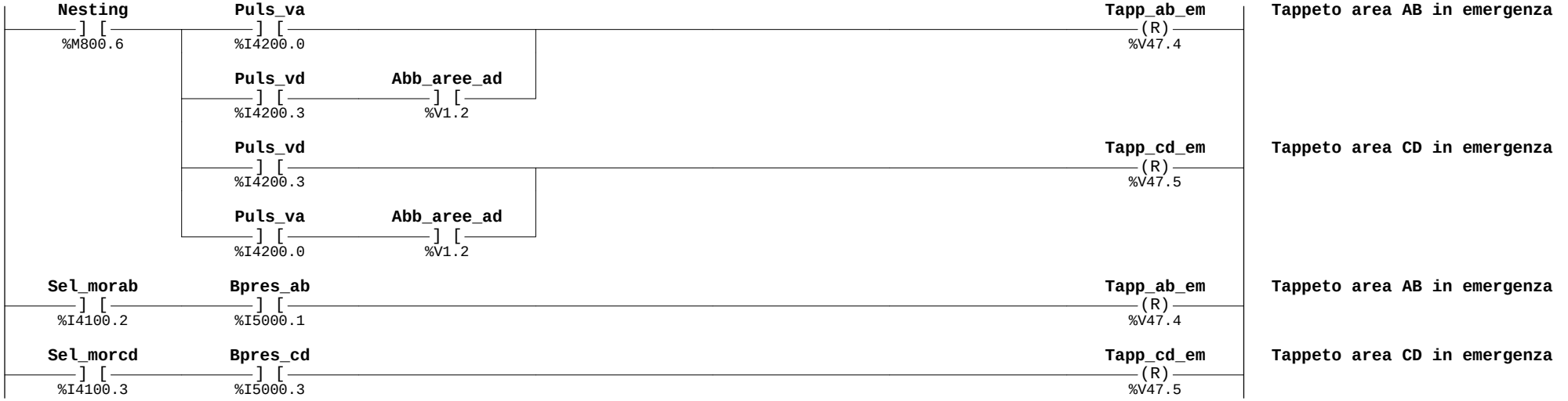
(1) %V531.0, %I4200.4, %V503.0 : X_pgm_a, Vacu_a, X_end
(2) %V503.4, %V5b4.0, %V5b4.4, %Vf.6, %V27.5, %I4101.3 : X_stat_gen, X_exec_a, X_exec_e, Pez_sblo, Wait_start, Setting

10 Label: Step: Start area con nesting

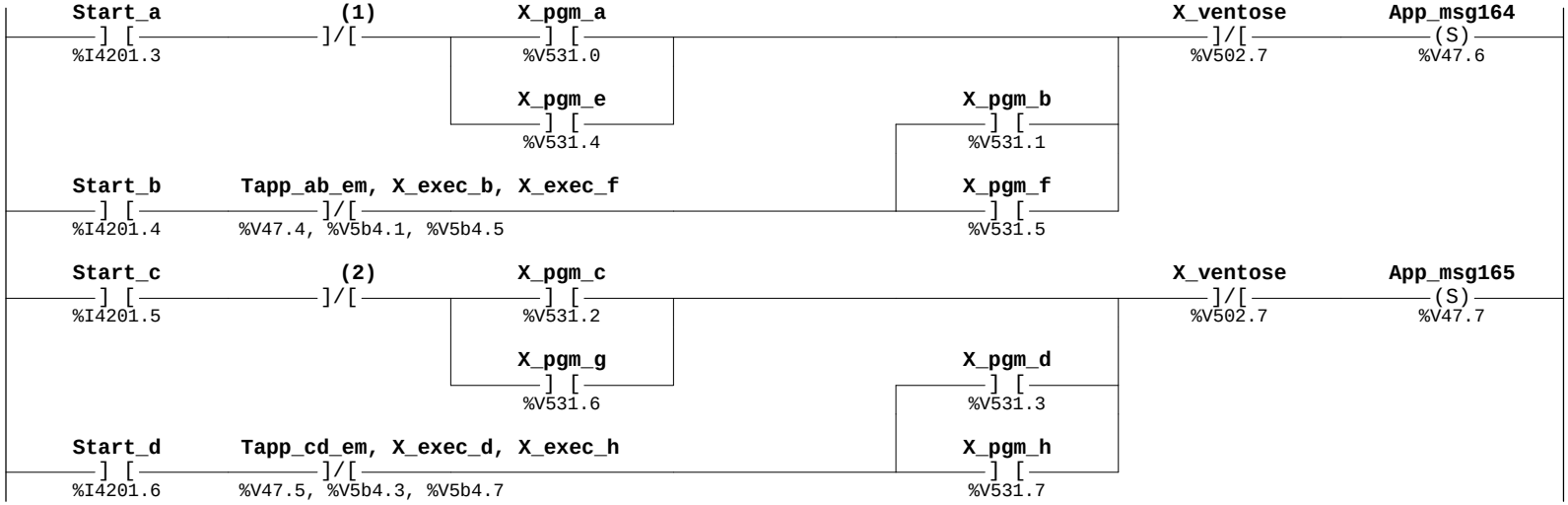


(1) %V531.3, %I4200.7, %V503.0 : X_pgm_d, Vacu_d, X_end
(2) %V503.4, %V5b4.3, %V5b4.7, %Vf.6, %V27.5, %I4101.3 : X_stat_gen, X_exec_d, X_exec_h, Pez_sblo, Wait_start, Setting

11 Label: Step: NESTING - MORSETTI

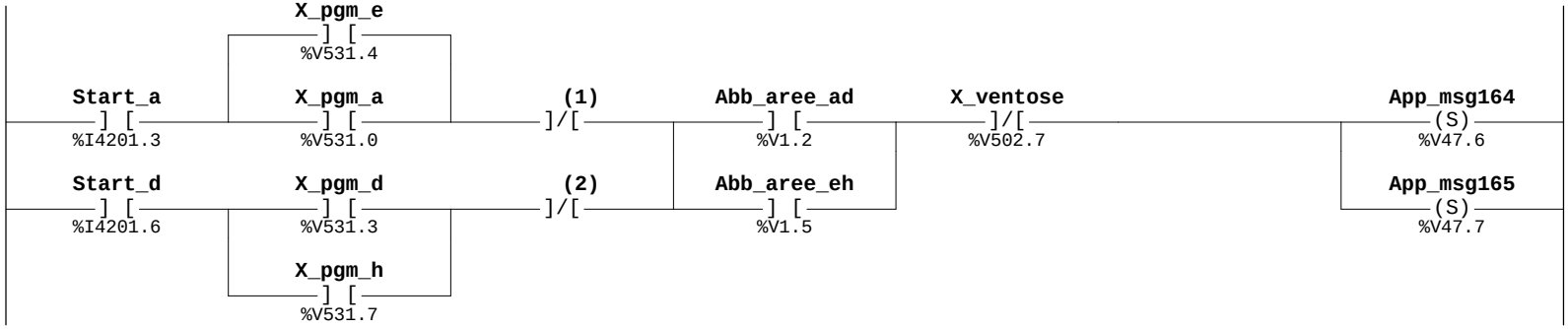


12 Label: Step: Gestione DIAGNOSTICA tappeti



(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

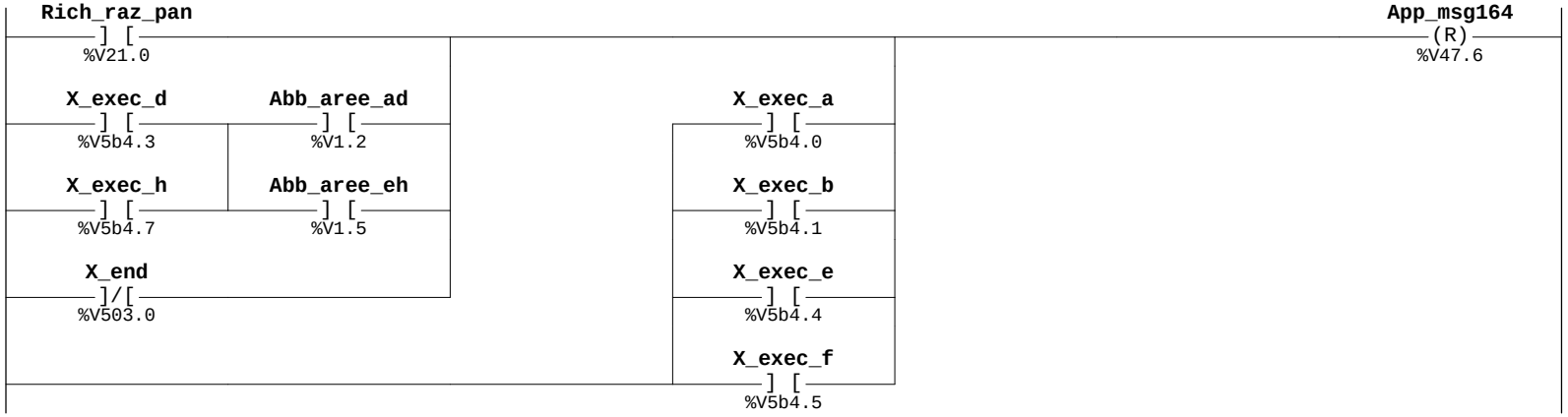
13 Label: Step: Gestione DIAGNOSTICA tappeti



(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

14 Label: Step:

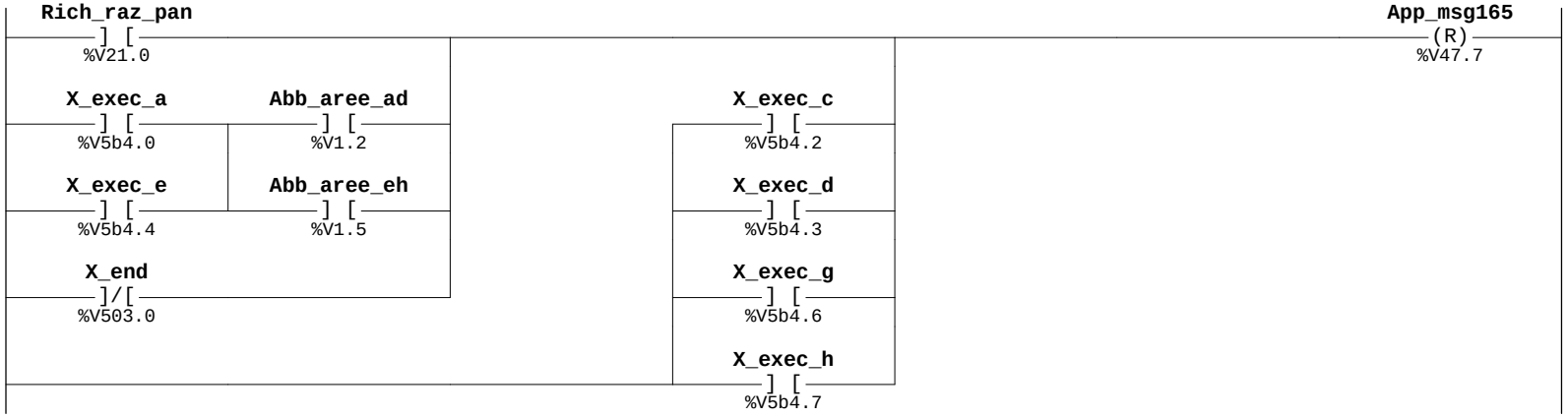
Gestione DIAGNOSTICA tappeti



Mem. per messaggio 164

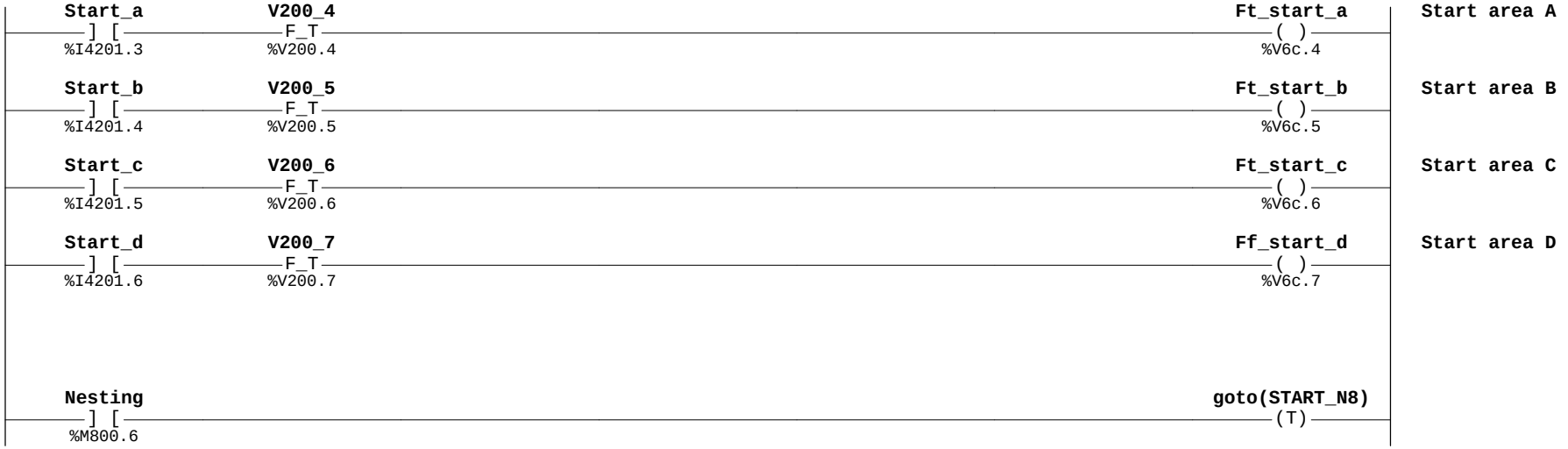
15 Label: Step:

Gestione DIAGNOSTICA tappeti

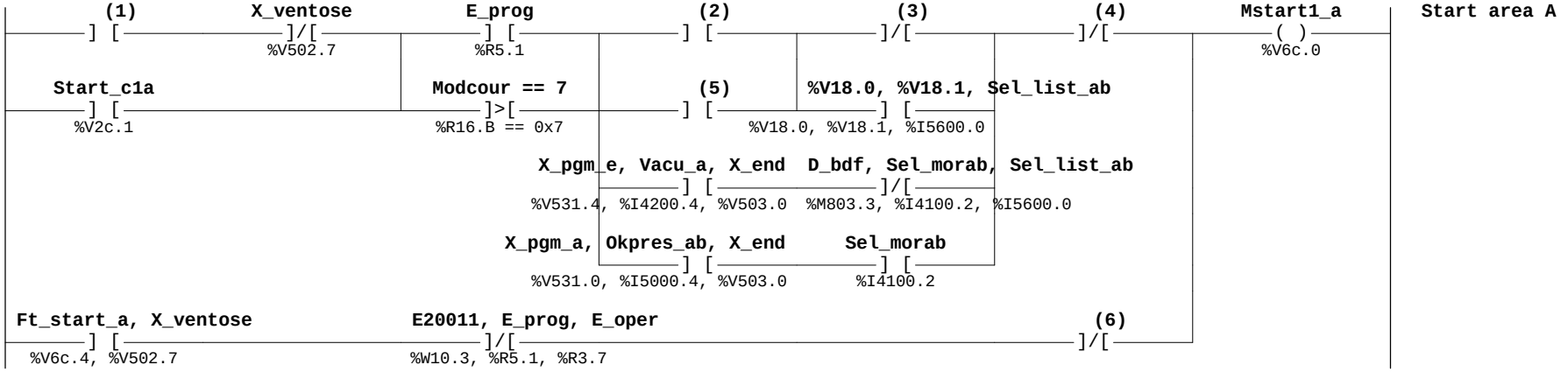


Mem. per messaggio 165

16 Label: Step: Fronte F_T su pulsanti di start aree per gestione tappeti

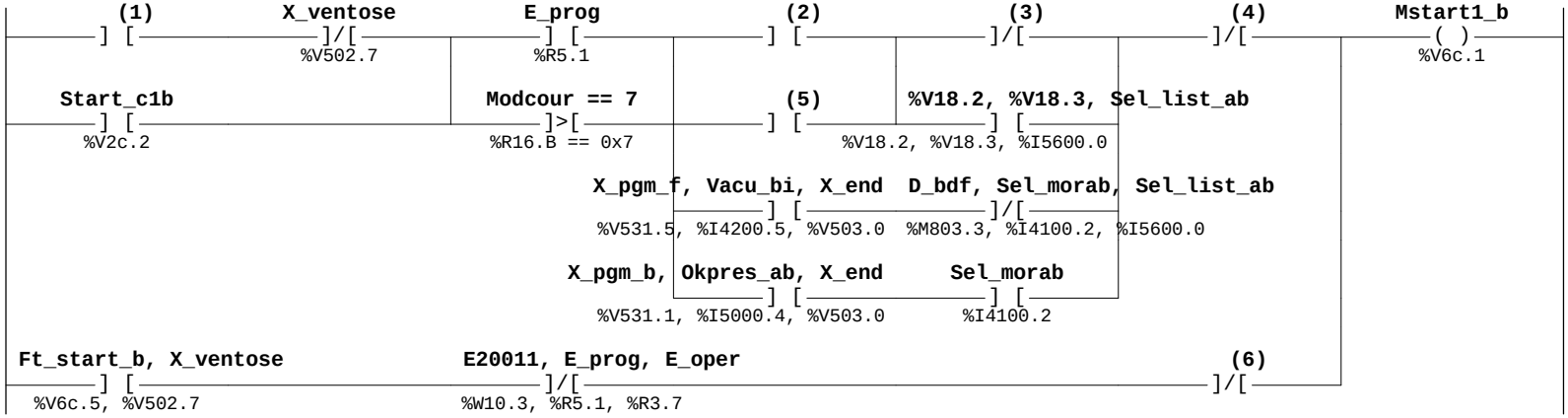


17 Label: Step: Start area con tappeti



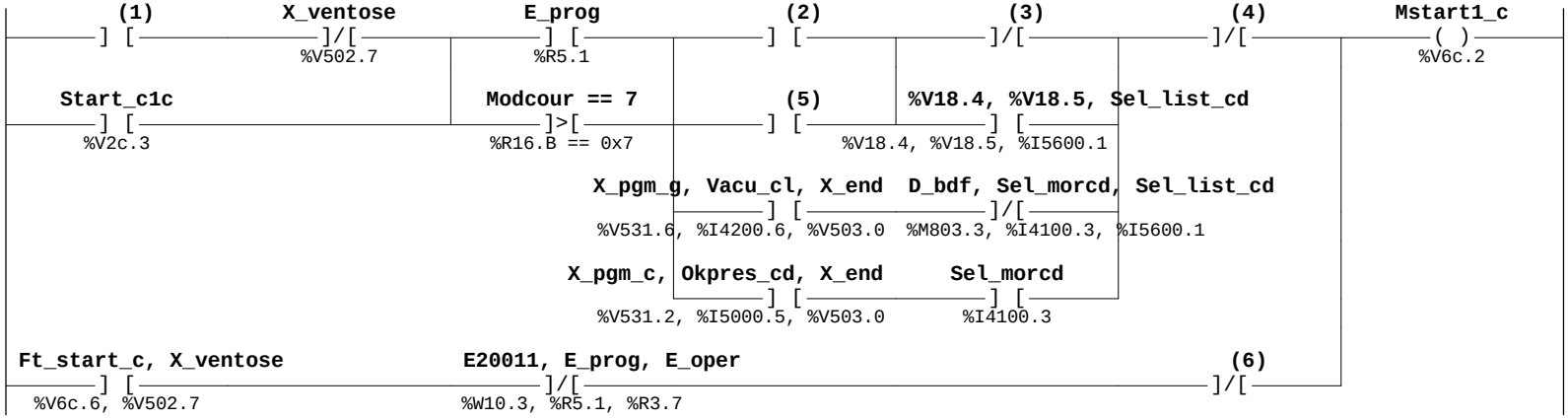
(1) %V6c.4, %V47.4 : Ft_start_a, Tapp_ab_em
(2) %V531.0, %I4200.4, %V503.0 : X_pgm_a, Vacu_a, X_end
(3) %I4100.2, %I5600.0 : Sel_morab, Sel_list_ab
(4) %V503.4, %V5b4.0, %V5b4.4, %Vf.6, %I4c00.0, %V27.5, %I4101.3 : X_stat_gen, X_exec_a, X_exec_e, Pez_sblo, Auto_man, Wait_start, Setting
(5) %V531.4, %I4b00.0,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

18 Label: Step: Start area con tappeti



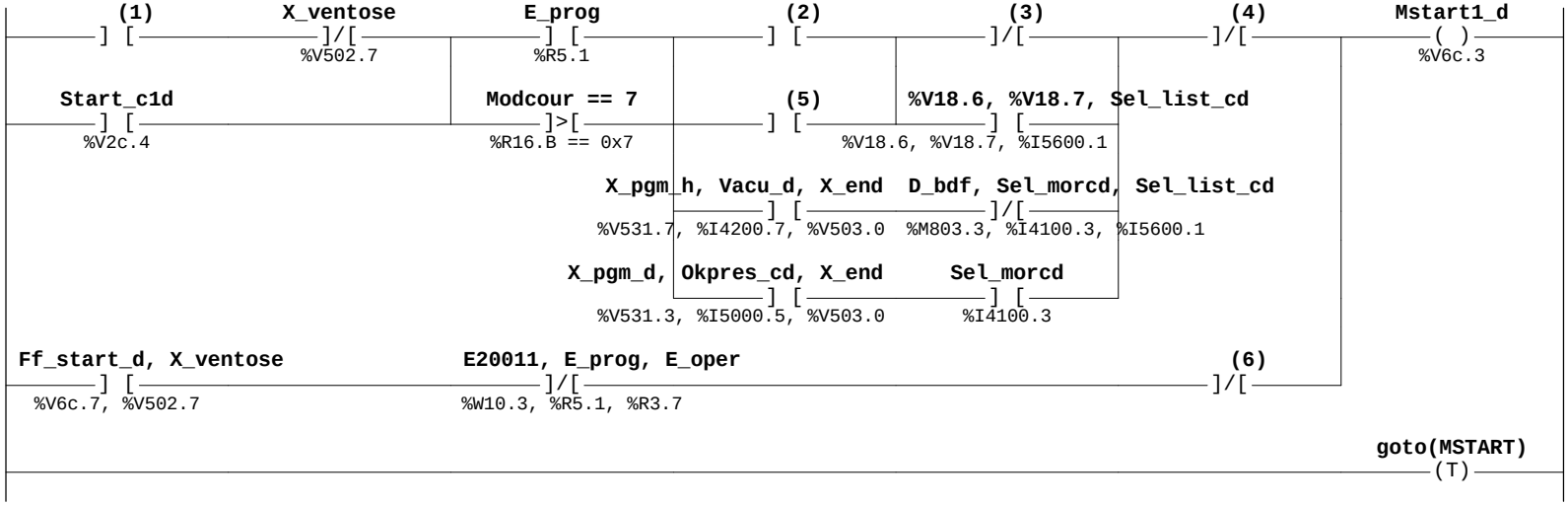
(1) %V6c.5, %V47.4 : Ft_start_b, Tapp_ab_em
(2) %V531.1, %I4200.5, %V503.0 : X_pgm_b, Vacu_bi, X_end
(3) %I4100.2, %I5600.0 : Sel_morab, Sel_list_ab
(4) %V503.4, %V5b4.1, %V5b4.5, %Vf.6, %I4c00.0, %V27.5, %I4101.3 : X_stat_gen, X_exec_b, X_exec_f, Pez_sblo, Auto_man, Wait_start, Setting
(5) %V531.5, %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



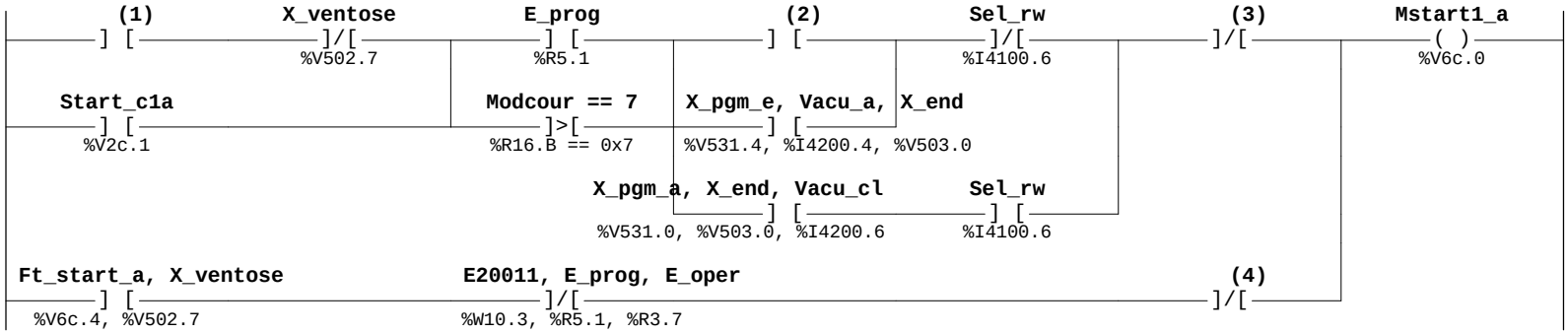
(1) %V6c.6, %V47.5 : Ft_start_c, Tapp_cd_em
(2) %V531.2, %I4200.6, %V503.0 : X_pgm_c, Vacu_cl, X_end
(3) %I4100.3, %I5600.1 : Sel_morcd, Sel_list_cd
(4) %V503.4, %V5b4.2, %V5b4.6, %Vf.6, %I4c00.0, %V27.5, %I4101.3 : X_stat_gen, X_exec_c, X_exec_g, Pez_sblo, Auto_man, Wait_start, Setting
(5) %V531.6,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

20 Label: Step: Start area con tappeti



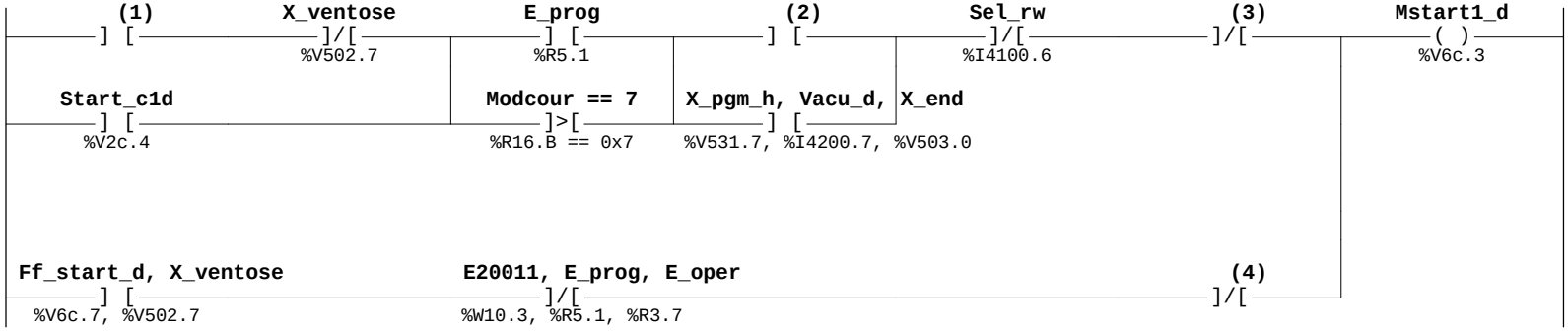
(1) %V6c.7, %V47.5 : Ff_start_d, Tapp_cd_em
(2) %V531.3, %I4200.7, %V503.0 : X_pgm_d, Vacu_d, X_end
(3) %I4100.3, %I5600.1 : Sel_morcd, Sel_list_cd
(4) %V503.4, %V5b4.3, %V5b4.7, %Vf.6, %I4c00.0, %V27.5, %I4101.3 : X_stat_gen, X_exec_d, X_exec_h, Pez_sblo, Auto_man, Wait_start, Setting
(5) %V531.7, %I4b00.3,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



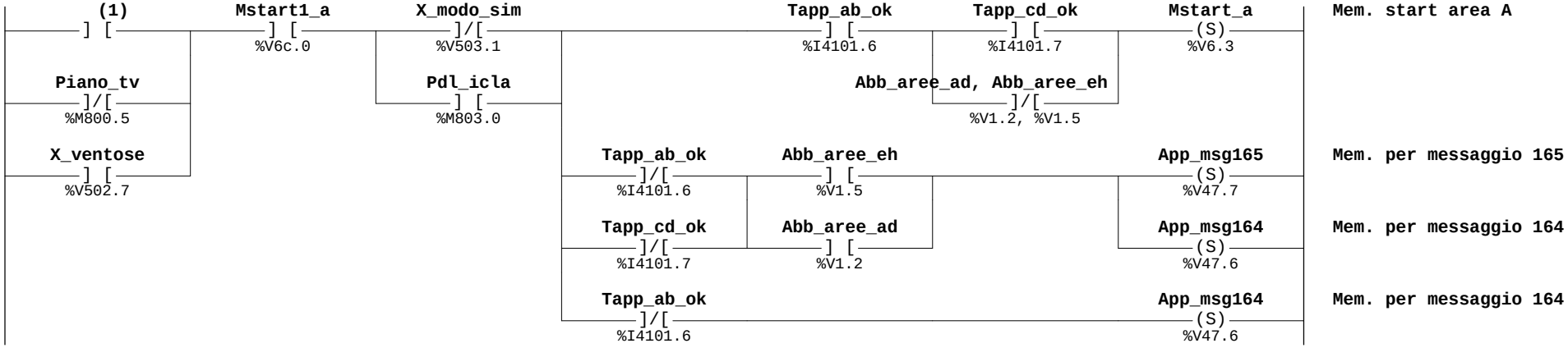
(1) %V6c.4, %V47.4 : Ft_start_a, Tapp_ab_em
(2) %V531.0, %I4200.4, %V503.0 : X_pgm_a, Vacu_a, X_end
(3) %V503.4, %V5b4.0, %V5b4.4, %Vf.6, %V27.5, %I4101.3 : X_stat_gen, X_exec_a, X_exec_e, Pez_sblo, Wait_start, Setting
(4) %V503.4, %V5b4.0, %V5b4.4, %Vf.6, %V27.5 : X_stat_gen, X_exec_a, X_exec_e, Pez_sblo,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

22 Label: Step: Start area con tappeti e nesting



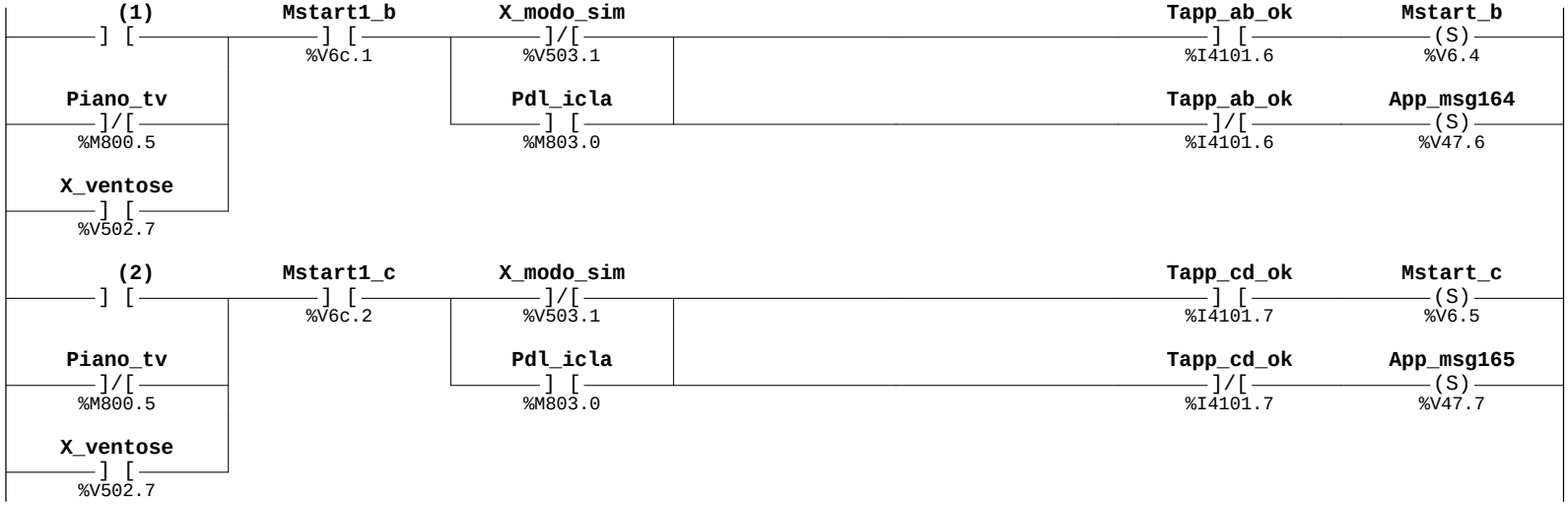
(1) %V6c.7, %V47.5 : Ff_start_d, Tapp_cd_em
(2) %V531.3, %I4200.7, %V503.0 : X_pgm_d, Vacu_d, X_end
(3) %V503.4, %V5b4.3, %V5b4.7, %Vf.6, %V27.5, %I4101.3 : X_stat_gen, X_exec_d, X_exec_h, Pez_sblo, Wait_start, Setting
(4) %V503.4, %V5b4.3, %V5b4.7, %Vf.6, %V27.5 : X_stat_gen, X_exec_d, X_exec_h, Pez_sblo,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

23 Label: **MSTART** Step: Gestione start area A



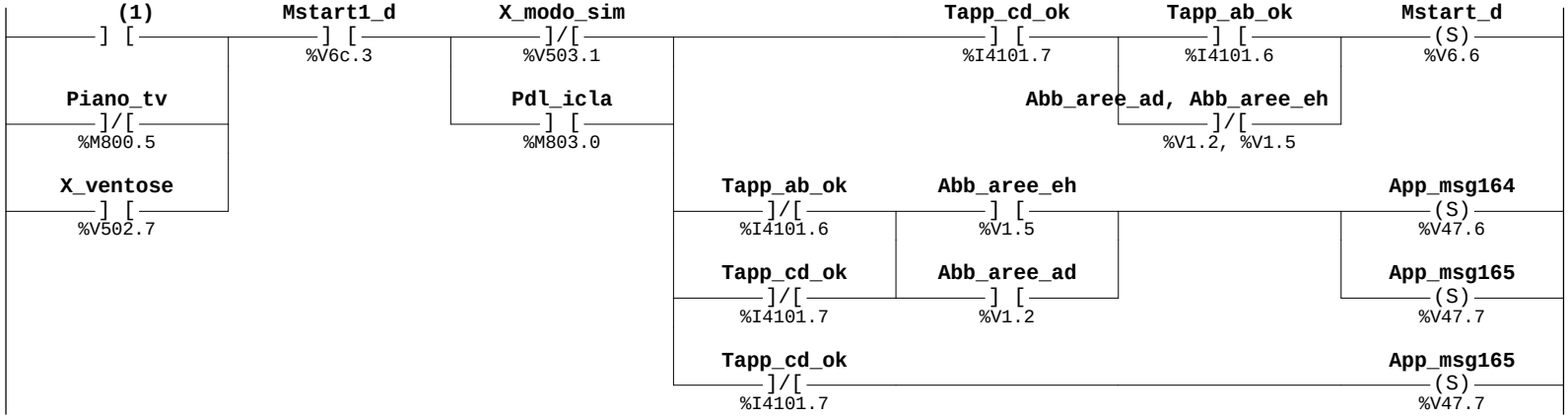
(1) %M800.5, %I4000.2 : Piano_tv, V_bl_ab

24 Label: Step: Gestione start aree B e C



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

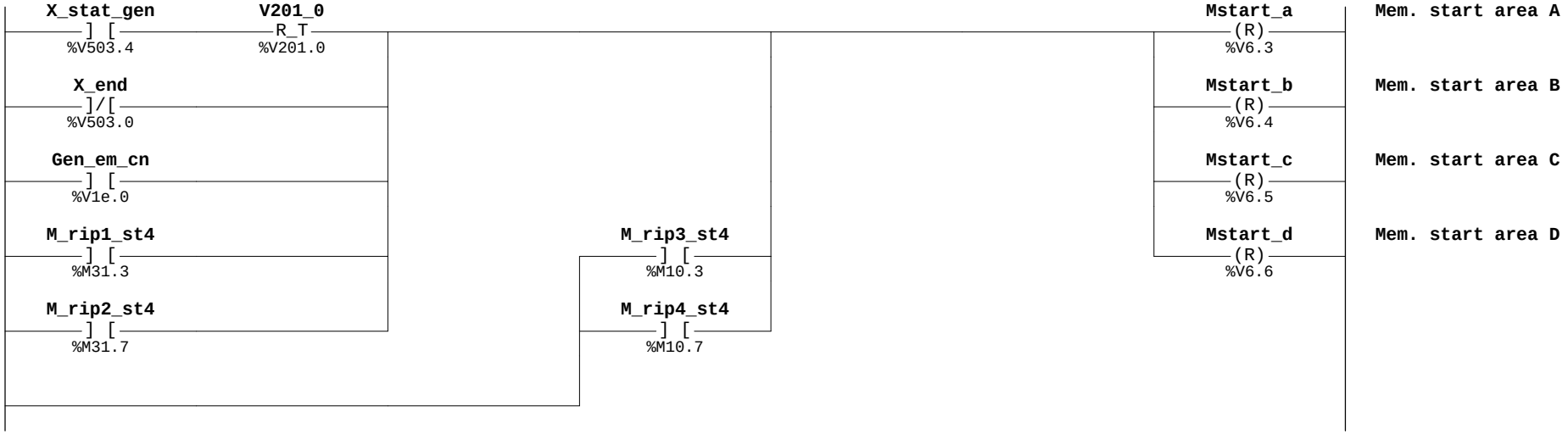
25 Label: Step: Gestione start area D



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

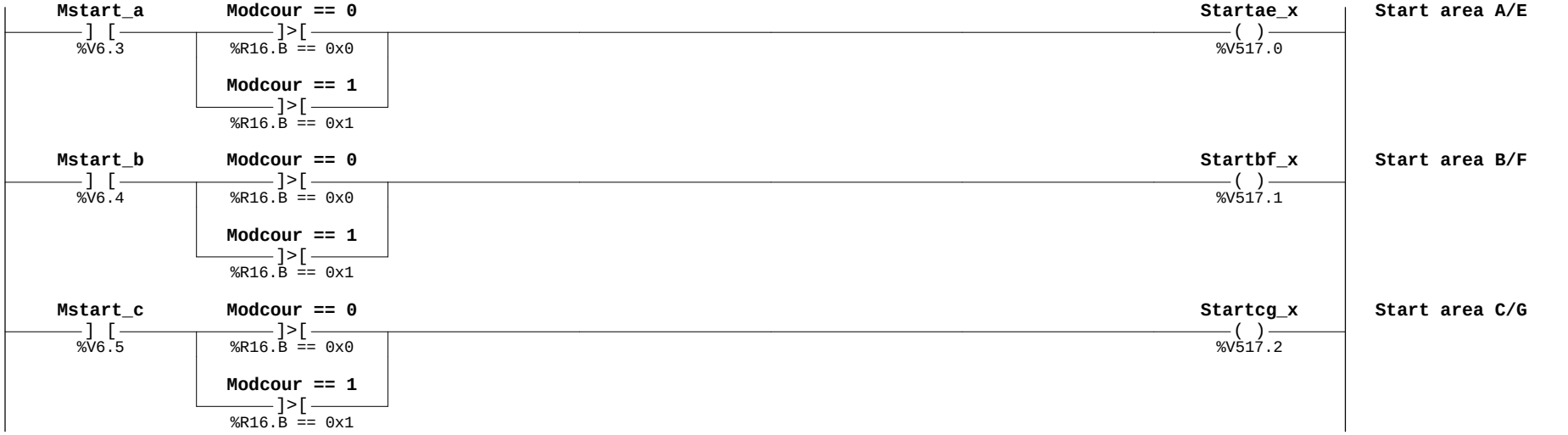
26 Label: **START1** Step:

Reset start area

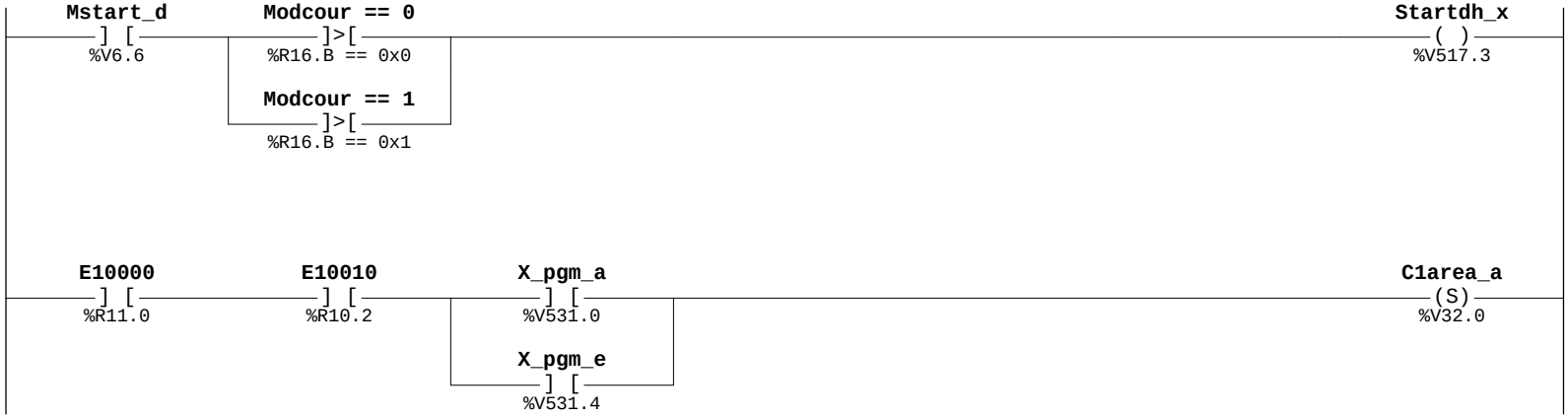


27 Label: Step:

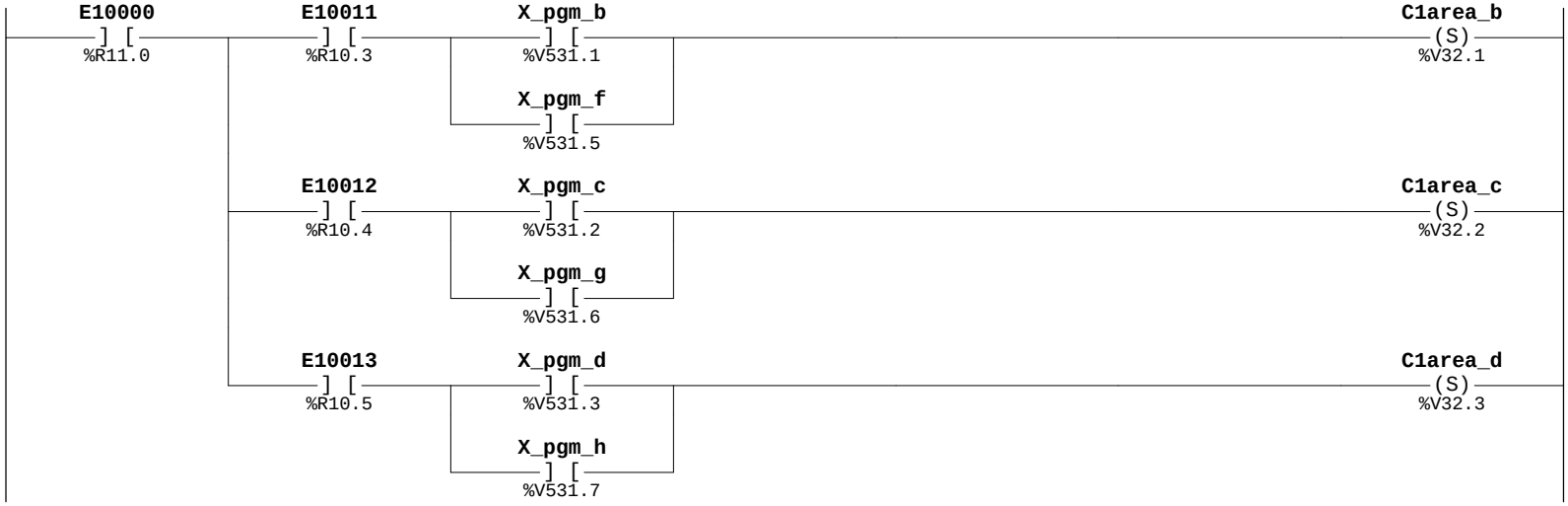
Start area a Xilog



28 Label: Step: Start area a Xilog

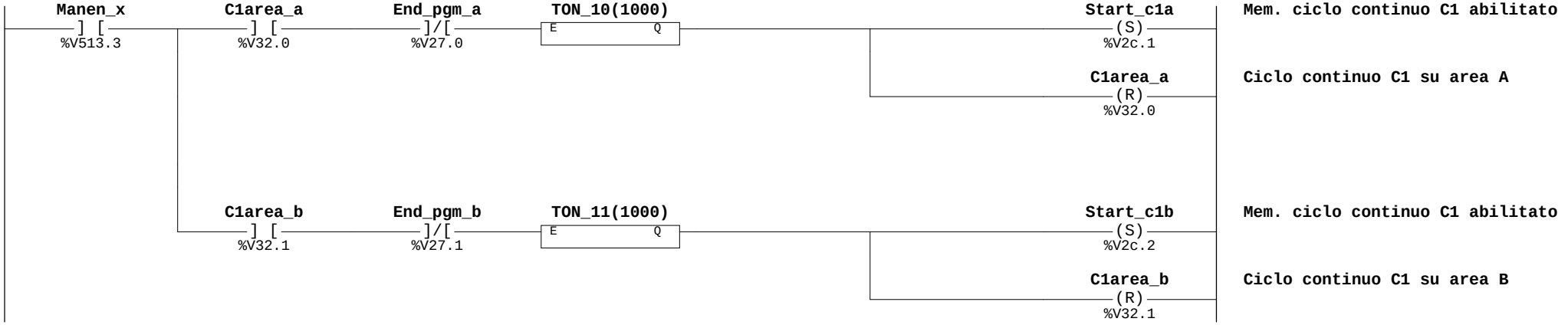


29 Label: Step: Gestione continuo



30 Label: Step:

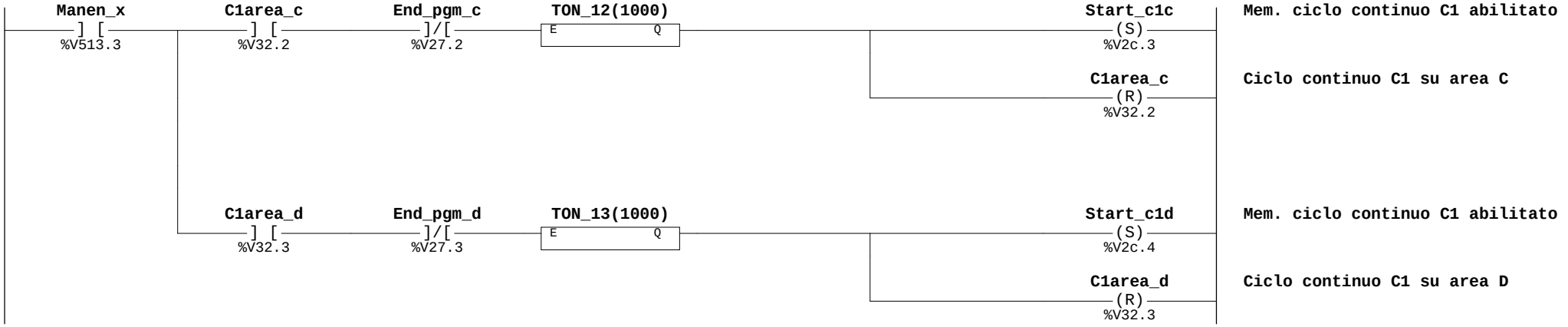
Gestione continuo



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

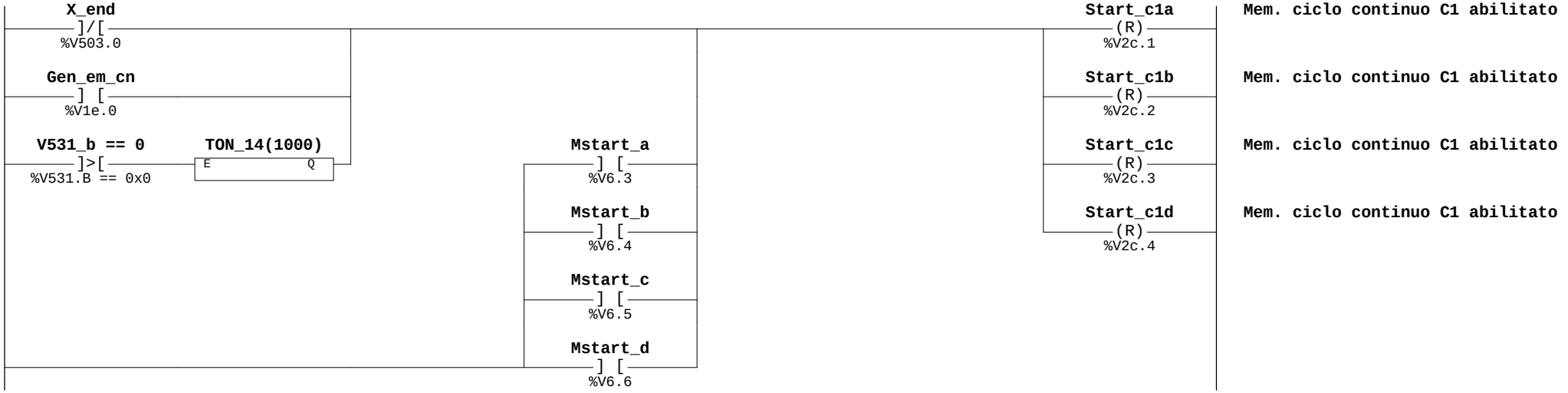
31 Label: Step:

Gestione continuo



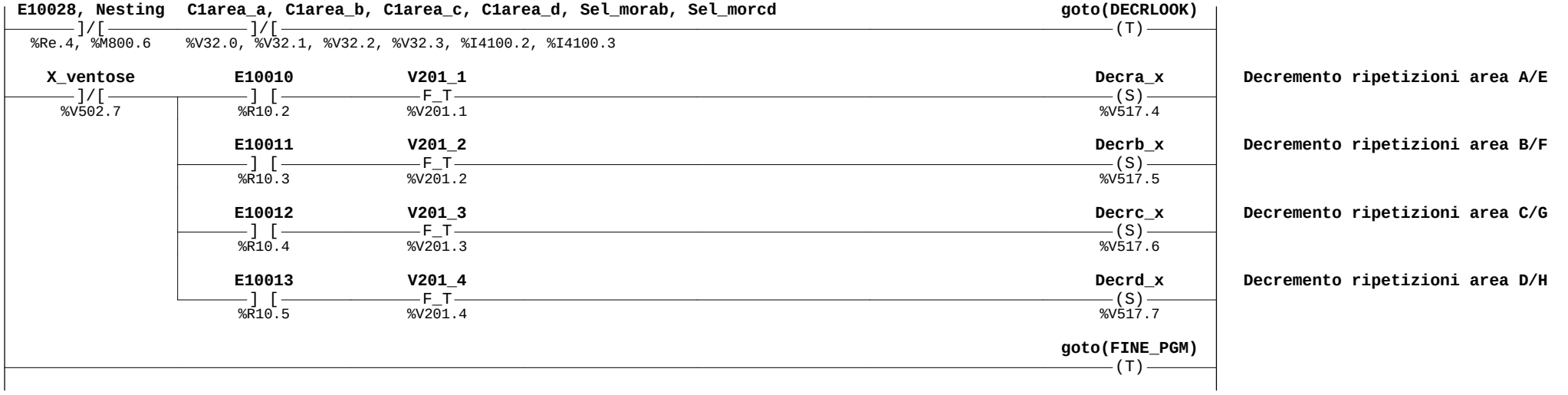
[T] TON_12(0x3e8) : TON_12(1000)
[T] TON_13(0x3e8) : TON_13(1000)

32 Label: Step: Gestione continuo



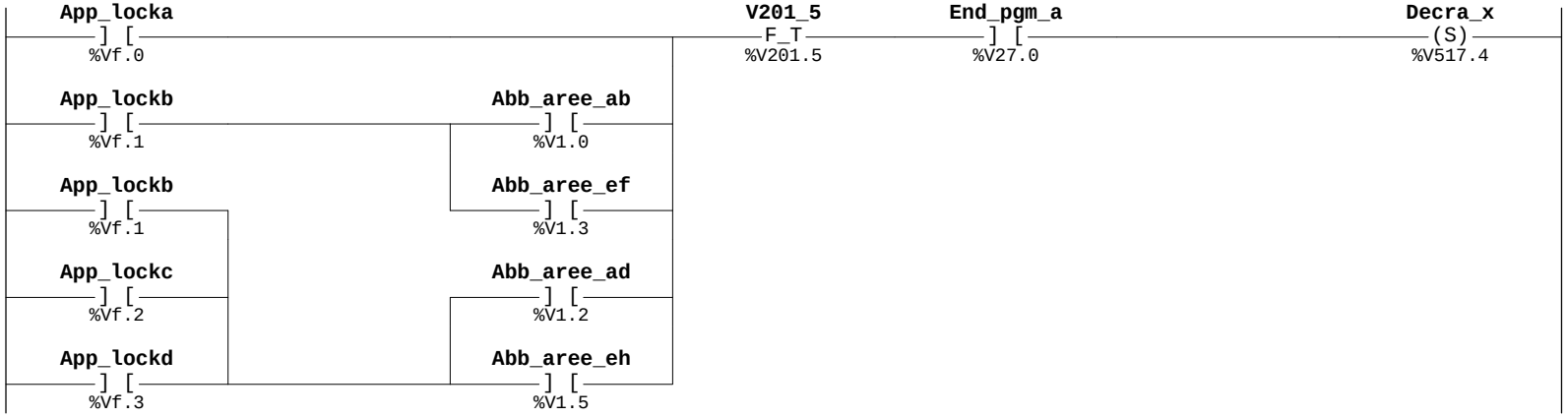
[T] TON_14(0x3e8) : TON_14(1000)

33 Label: Step: Selezione metodo di decremento



34 Label: **DECRLOOK** Step:

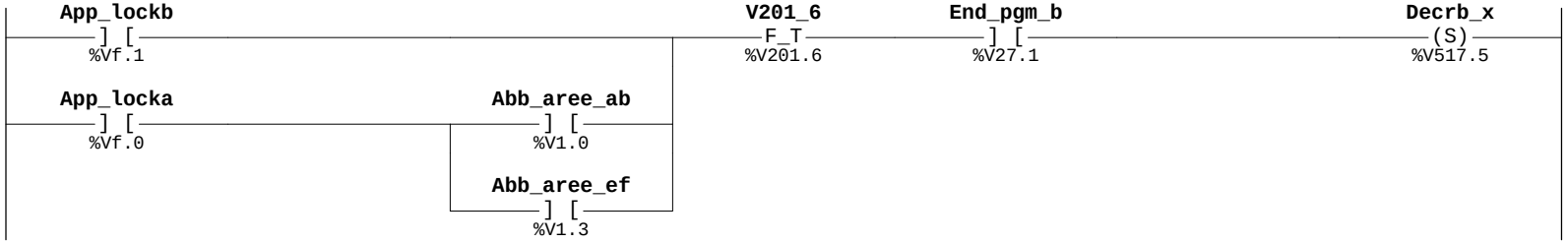
Decremento a Xilog



Decremento ripetizioni area A/E

35 Label: Step:

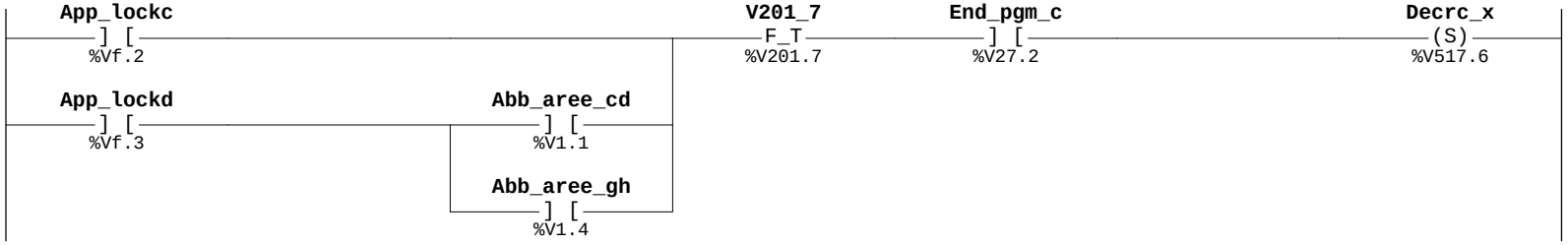
Decremento a Xilog



Decremento ripetizioni area B/F

36 Label: Step:

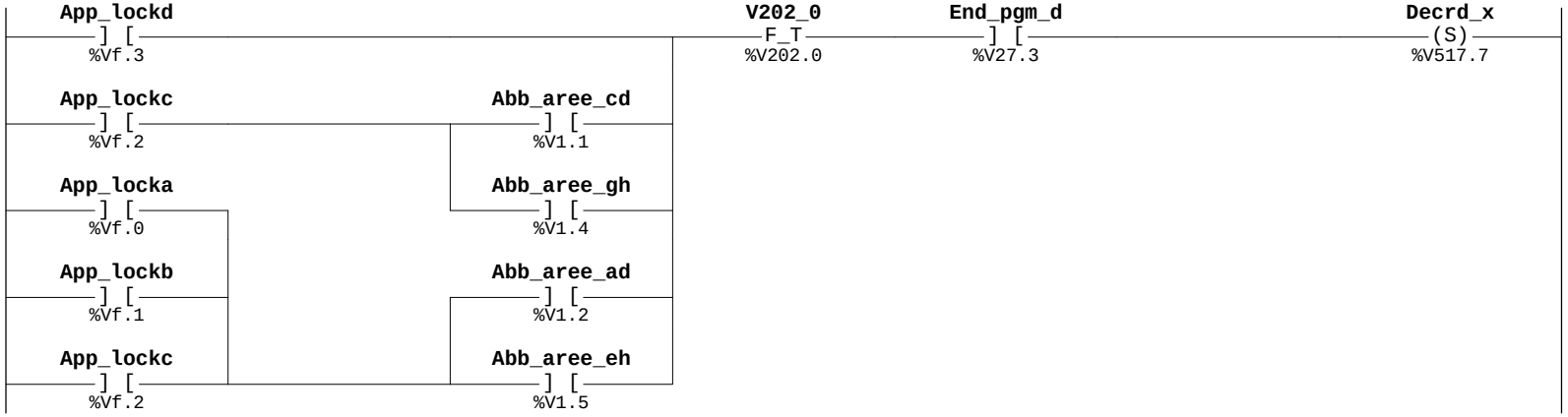
Decremento a Xilog



Decremento ripetizioni area C/G

37 Label: Step:

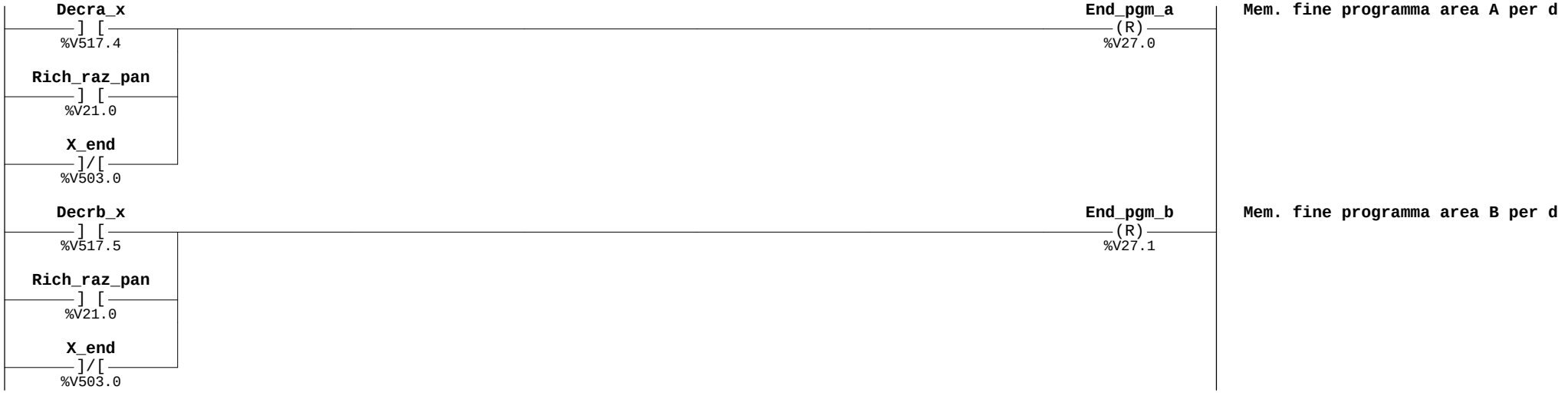
Decremento a Xilog



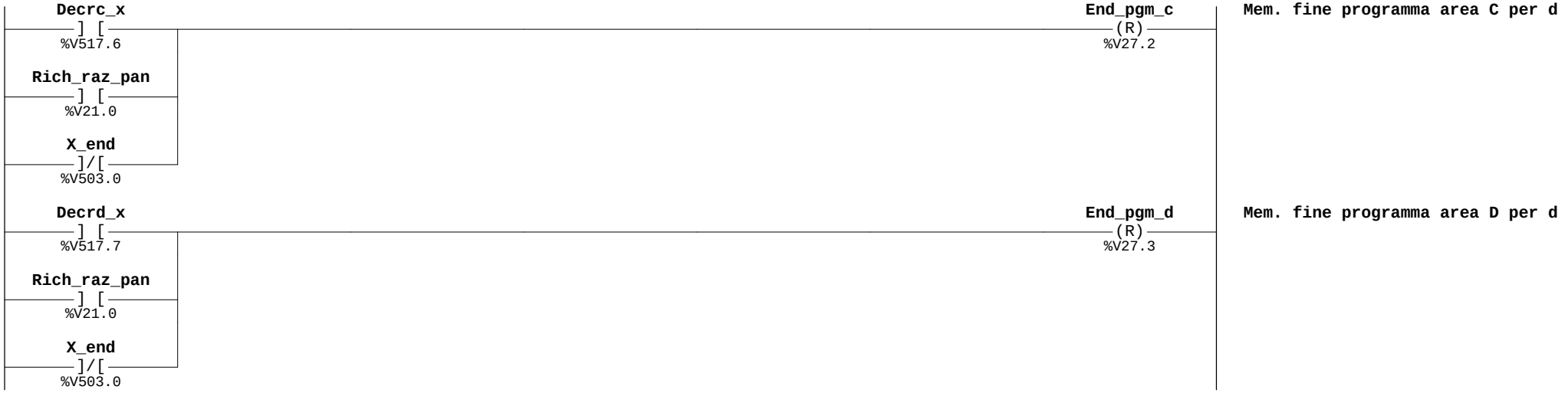
38 Label: **FINE_PGM** Step:

Fine programma

39 Label: Step: Fine programma



40 Label: Step: Fine programma



41 Label: Step:

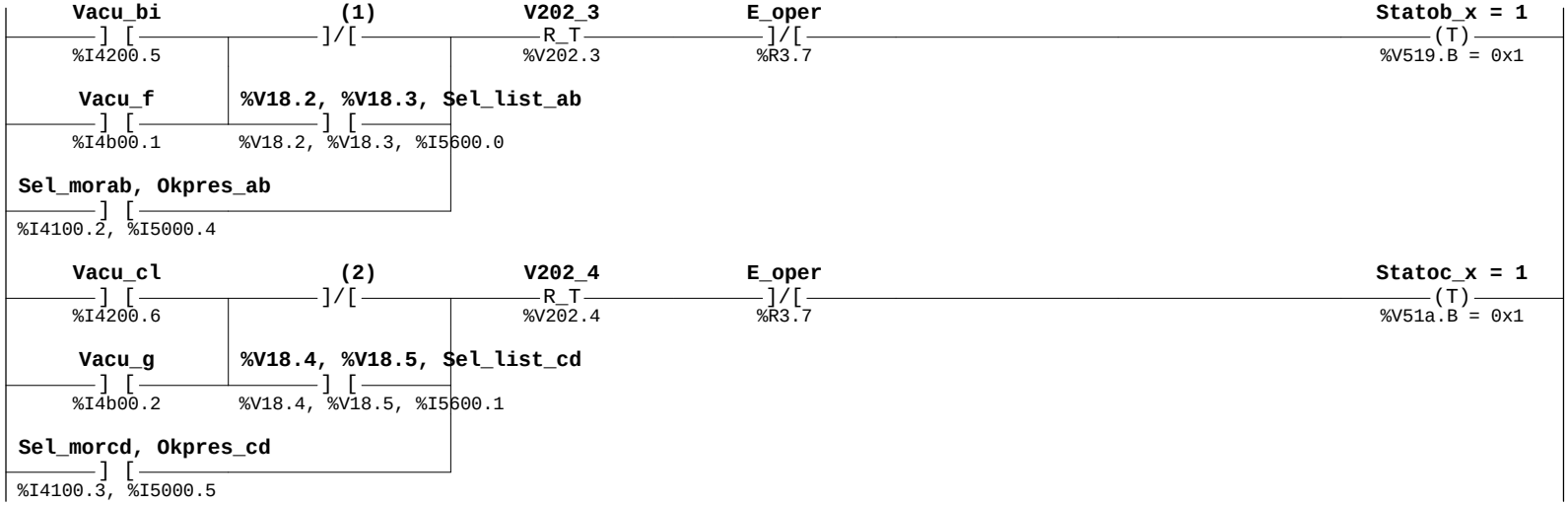
Decremento a Xilog

42 Label: Step:

Stato area a Xilog

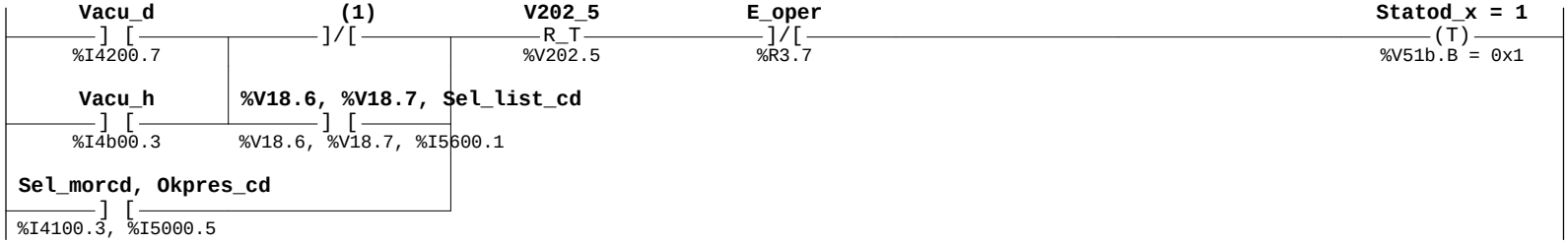
(1) %I4100.2, %I5600.0, %I4100.6 : Sel_morab, Sel_list_ab, Sel_rw

43 Label: Step: Stato area a Xilog



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

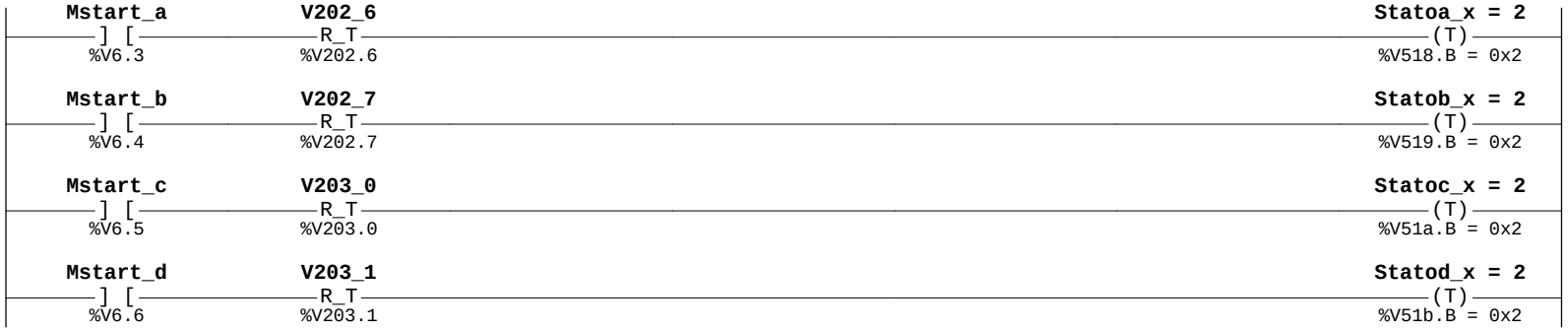
44 Label: Step: Stato area a Xilog



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

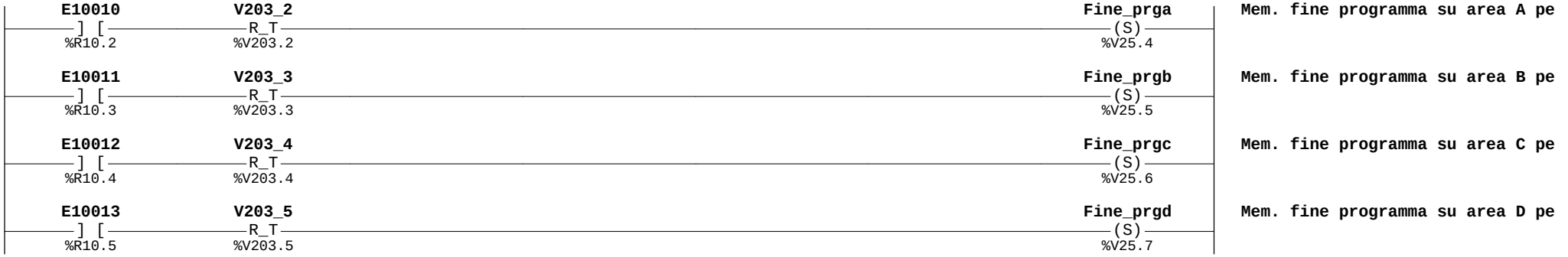
45 Label: Step:

Stato area a Xilog



46 Label: Step:

Stato area a Xilog

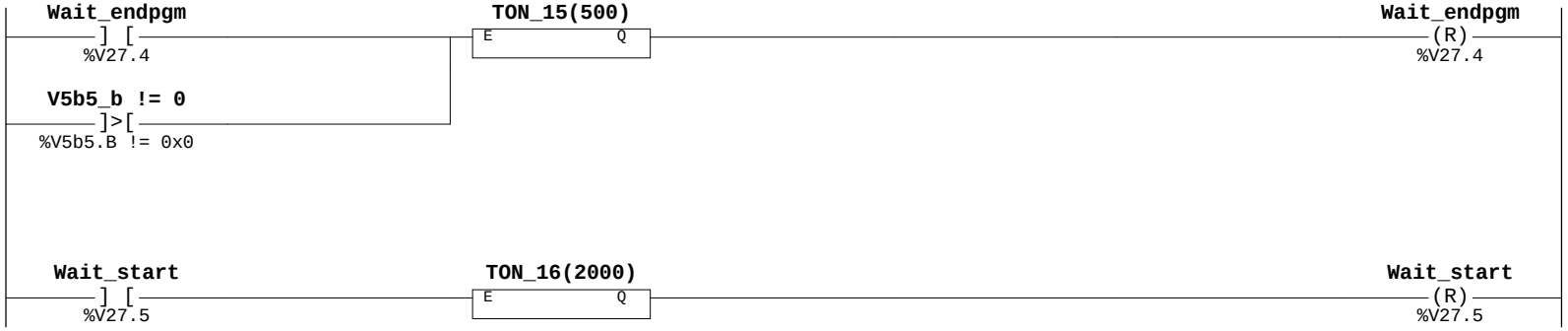


47 Label: Step:

Stato area a Xilog

48 Label: Step:

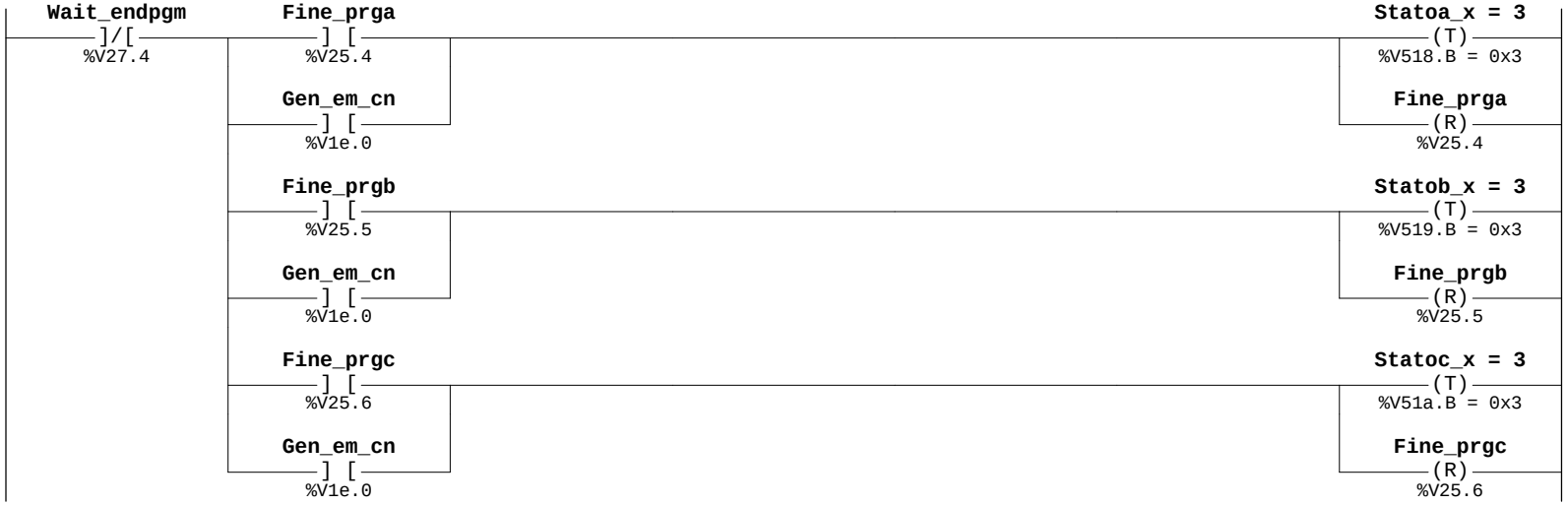
Stato area a Xilog



[T] TON_15(0x1f4) : TON_15(500)
[T] TON_16(0x7d0) : TON_16(2000)

49 Label: Step:

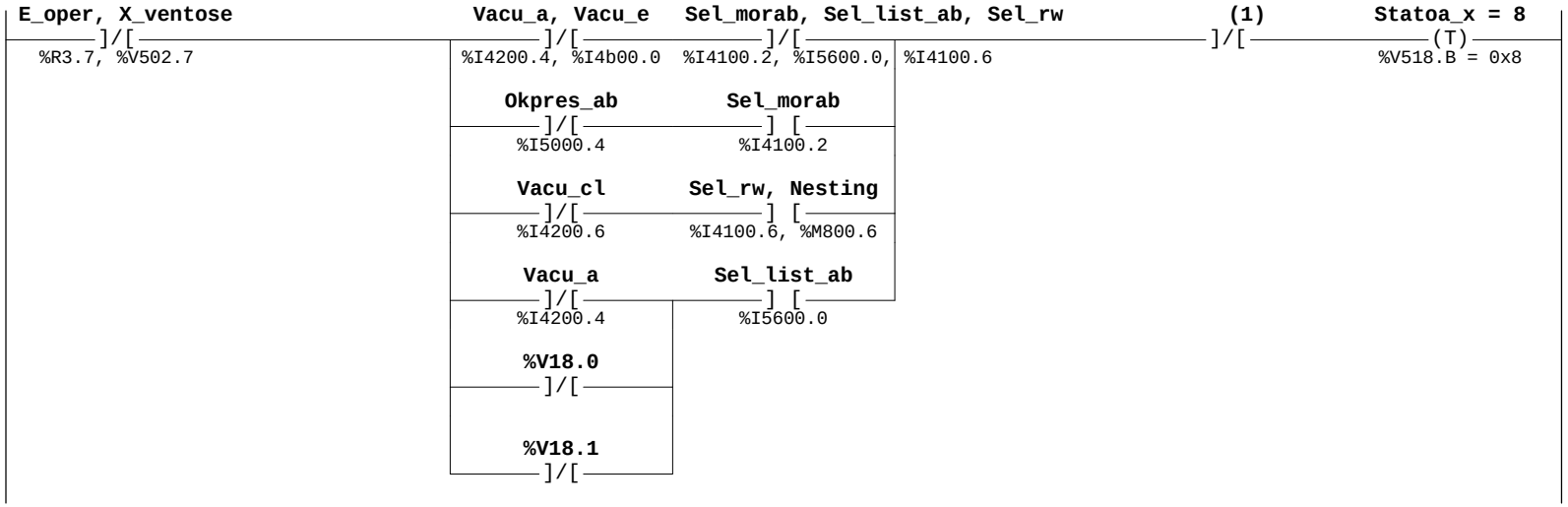
Stato area a Xilog



50 Label: Step: Stato area a Xilog

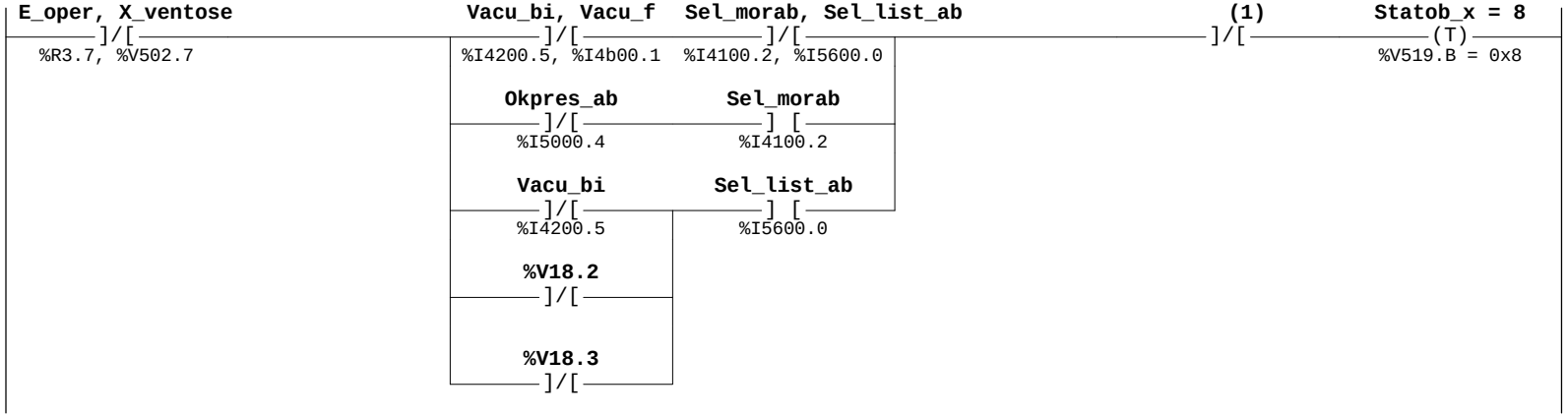
Mem. fine programma su area D pe

51 Label: Step: Stato area a Xilog



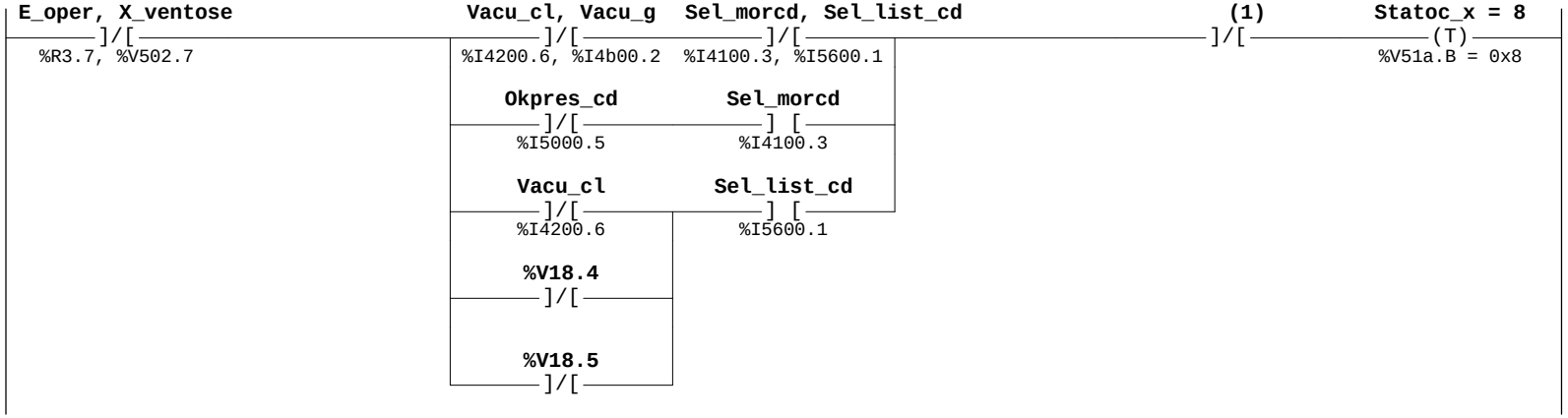
(1) %V5b4.0, %V5b4.4 : X_exec_a, X_exec_e

52 Label: Step: Stato area a Xilog



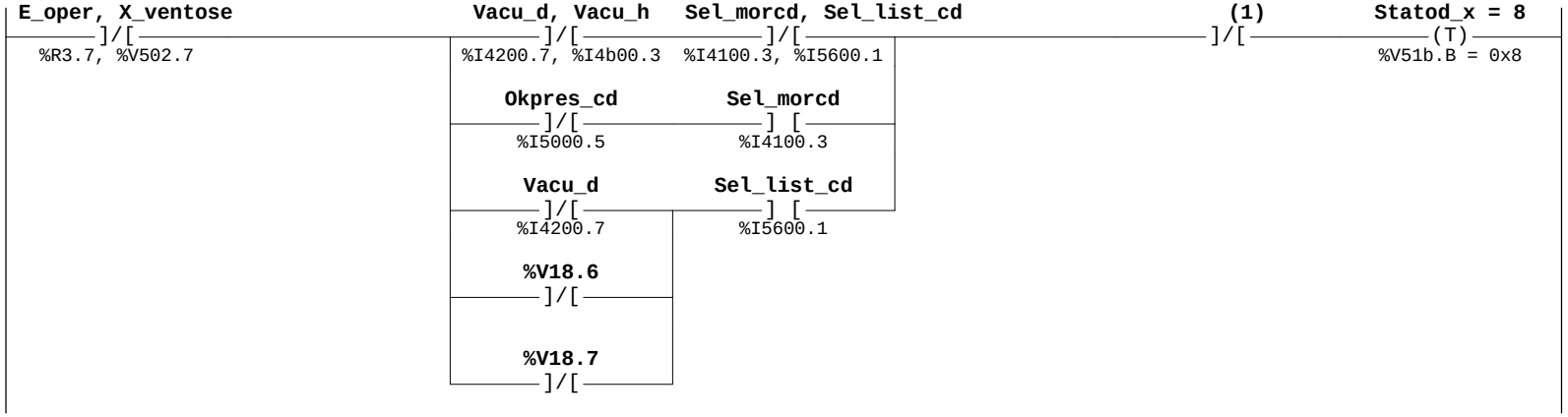
(1) %V5b4.1, %V5b4.5 : X_exec_b, X_exec_f

53 Label: Step: Stato area a Xilog



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

54 Label: Step: Stato area a Xilog



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

55 Label: Step: Gestione laser posizionamento ventose