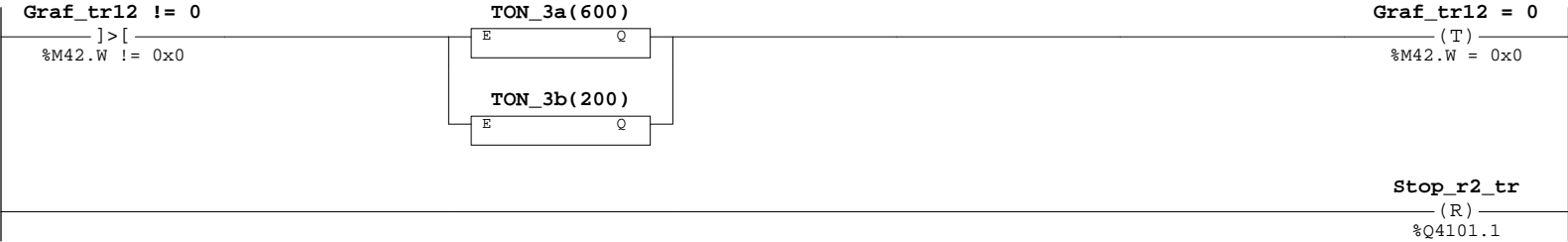


00 Label: Step:



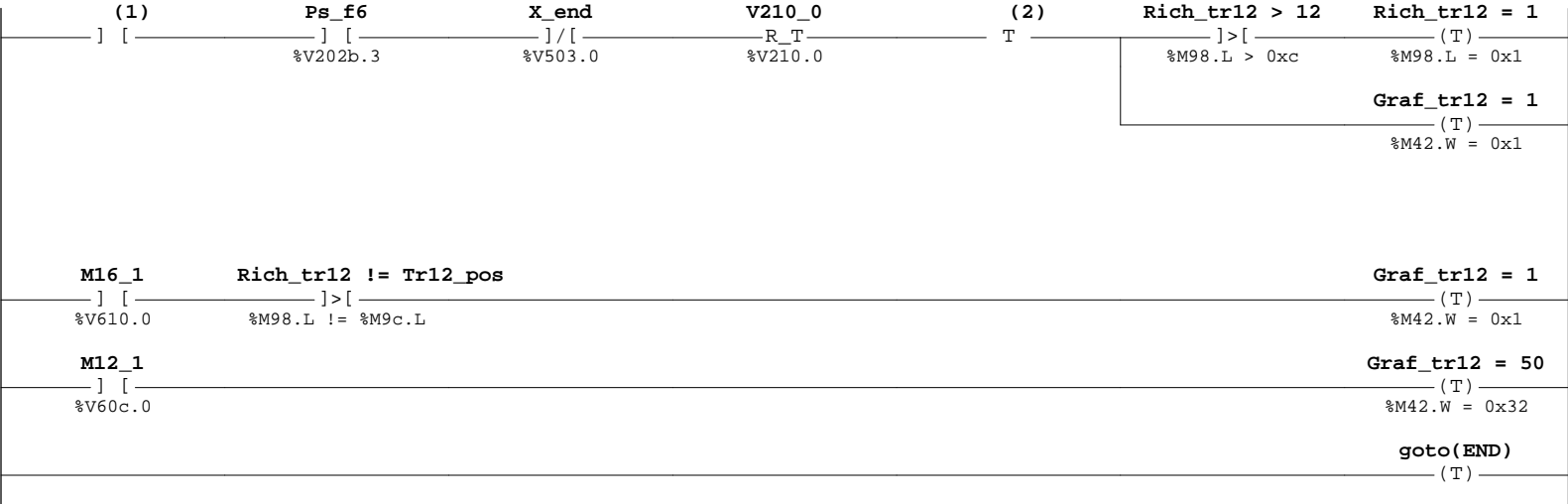
01 Label: Step: Graf_tr12 %M42.W = 0



Stop rapid 6 n.2 / Tool room pos

[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

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

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

Ricerca direzione di rotazione magazzino

Rich_tr12 - Tr12_pos > 0]>[%M98.L - %M9c.L > 0x0	Rich_tr12 - Tr12_pos < 6]>[%M98.L - %M9c.L < 0x6	Direz_r2_tr (S) %Q4101.0
Rich_tr12 - Tr12_pos < 0]>[%M98.L - %M9c.L < 0x0	Tr12_pos - Rich_tr12 >= 6]>[%M9c.L - %M98.L >= 0x6	
Rich_tr12 - Tr12_pos > 0]>[%M98.L - %M9c.L > 0x0	Rich_tr12 - Tr12_pos >= 6]>[%M98.L - %M9c.L >= 0x6	Direz_r2_tr (R) %Q4101.0
Rich_tr12 - Tr12_pos < 0]>[%M98.L - %M9c.L < 0x0	Tr12_pos - Rich_tr12 < 6]>[%M9c.L - %M98.L < 0x6	
TON_3b(200) E Q		Graf_tr12 = 2 (T) %M42.W = 0x2
		goto(END) (T)

Direzione rapid 6 n.2 / Tool roo

Direzione rapid 6 n.2 / Tool roo

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

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

	Start_r2_tr (S) %Q4101.2
Clock_tr12] [%I5100.0	Graf_tr12 = 3 (T) %M42.W = 0x3
	goto(END) (T)

Start rapid 6 n.2 / Tool room po

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

05 Label: Step: Graf_tr12 %M42.W = 3

Incremento memoria posto magazzino

	Start_r2_tr	
	(R)	
	%Q4101.2	
Direz_r2_tr	Tr12_pos += 1	
] [(T)	
%Q4101.0	%M9c.L += 0x1	
Direz_r2_tr	Tr12_pos -= 1	
] / [(T)	
%Q4101.0	%M9c.L -= 0x1	

Start rapid 6 n.2 / Tool room po

06 Label: Step: Graf_tr12 %M42.W = 3

Verifica posto magazzino

Tr12_pos == 0	Tr12_pos = 12	
] > [(T)	
%M9c.L == 0x0	%M9c.L = 0xc	
Tr12_pos == 13	Tr12_pos = 1	
] > [(T)	
%M9c.L == 0xd	%M9c.L = 0x1	

07 Label: Step: Graf_tr12 %M42.W = 3

Controllo se raggiunto posto

Tr12_pos != Rich_tr12	Graf_tr12 = 4	
] > [(T)	
%M9c.L != %M98.L	%M42.W = 0x4	
Tr12_pos == Rich_tr12	Graf_tr12 = 9	
] > [(T)	
%M9c.L == %M98.L	%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)

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

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

Clock_tr12

Graf_tr12 = 5

$$\frac{\text{---}}{\%I5100.0}] / [\text{---}$$

```

_____ (T) _____
%M42.W = 0x5

```

goto(END)
—— (T) ——

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

Clock_tr12

Graf_tr12 = 6

_____] [_____
%I5100.0

_____ (T) _____
 %M42.W = 0x6

goto(END)
—— (T) ——

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: TR12_POS.XLA		Page	4

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

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

Clock_tr12] [Graf_tr12 = 8 (T)
%I5100.0	%M42.W = 0x8
goto(END)	
(T)	

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: TR12_POS.XLA		Page	5

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

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

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

Tr12_pos == 0	Tr12_pos = 12
]>[(T)
%M9c.L == 0x0	%M9c.L = 0xc
Tr12_pos == 13	Tr12_pos = 1
]>[(T)
%M9c.L == 0xd	%M9c.L = 0x1

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

Tr12_pos != Rich_tr12	Graf_tr12 = 4
]>[(T)
%M9c.L != %M98.L	%M42.W = 0x4
Tr12_pos == Rich_tr12	Graf_tr12 = 9
]>[(T)
%M9c.L == %M98.L	%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)

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

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

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

Posiz_tr12	Graf_tr12 = 0
] [(T)
%I5100.1	%M42.W = 0x0
	goto(END)
	(T)

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

Ciclo taratura magazzino

	Start_r2_tr (S) %Q4101.2	Start rapid 6 n.2 / Tool room po
	Direz_r2_tr (S) %Q4101.0	Direzione rapid 6 n.2 / Tool roo
	E40014 = 0 (T) %Wa38.L = 0x0	
Orig_tr12] [Graf_tr12 = 51 (T) %M42.W = 0x33	
%I5100.2	goto(END) (T)	

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: TR12_POS.XLA		Page	8


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

[illegible]

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

	Start_r2_tr	Start rapid 6 n.2 / Tool room po
	(R)	
	%Q4101.2	
Clock_tr12	Graf_tr12 = 53	
] / [(T)	
%I5100.0	%M42.W = 0x35	
	goto(END)	
	(T)	

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: TR12_POS.XLA		Page	9

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

Clock_tr12	Graf_tr12 = 54
] %I5100.0	(T) %M42.W = 0x36
	goto(END)
	(T)

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

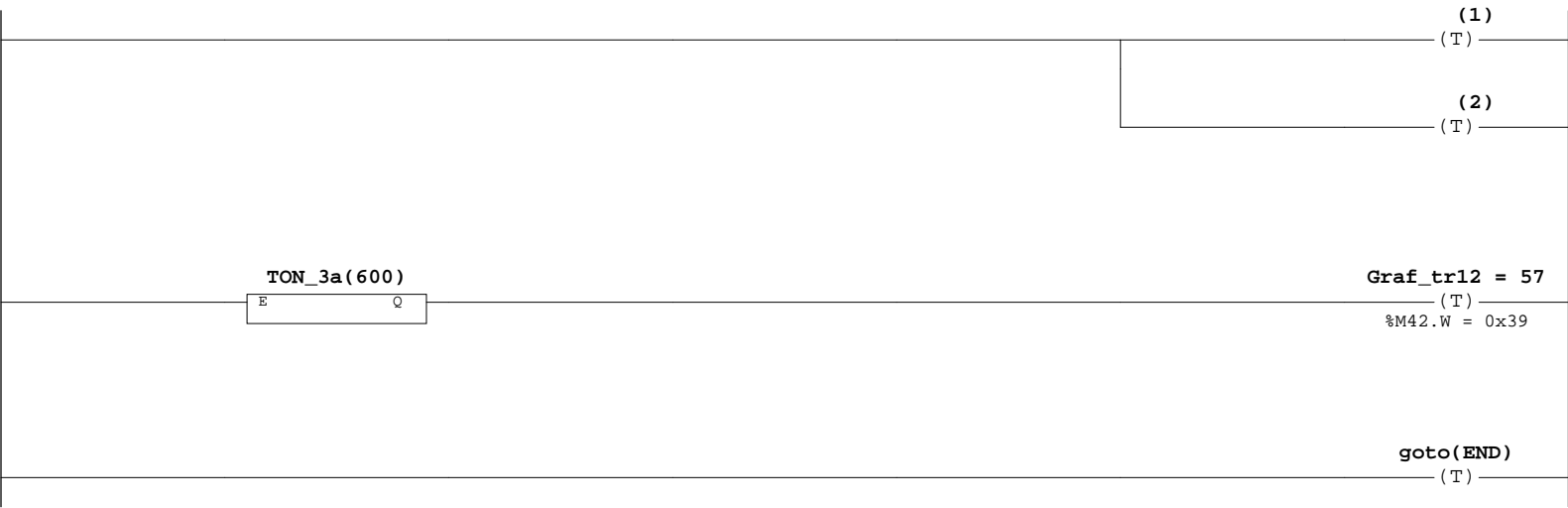
Clock_tr12	Graf_tr12 = 55
] %I5100.0	(T) %M42.W = 0x37
	goto(END)
	(T)

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE		Date 28-02-2018
Module: TR12_POS.XLA		%SP133 (21)	Page 10

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

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

Posiz_tr12	E40014 = 1
]	(T)
%I5100.1	%Wa38.L = 0x1
	Tr12_pos = 1
	(T)
	%M9c.L = 0x1
	Graf_tr12 = 0
	(T)
	%M42.W = 0x0
	goto(END)
	(T)

26 Label: END Step:

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: TR12_POS.XLA		%SP133 (25)	Page 12