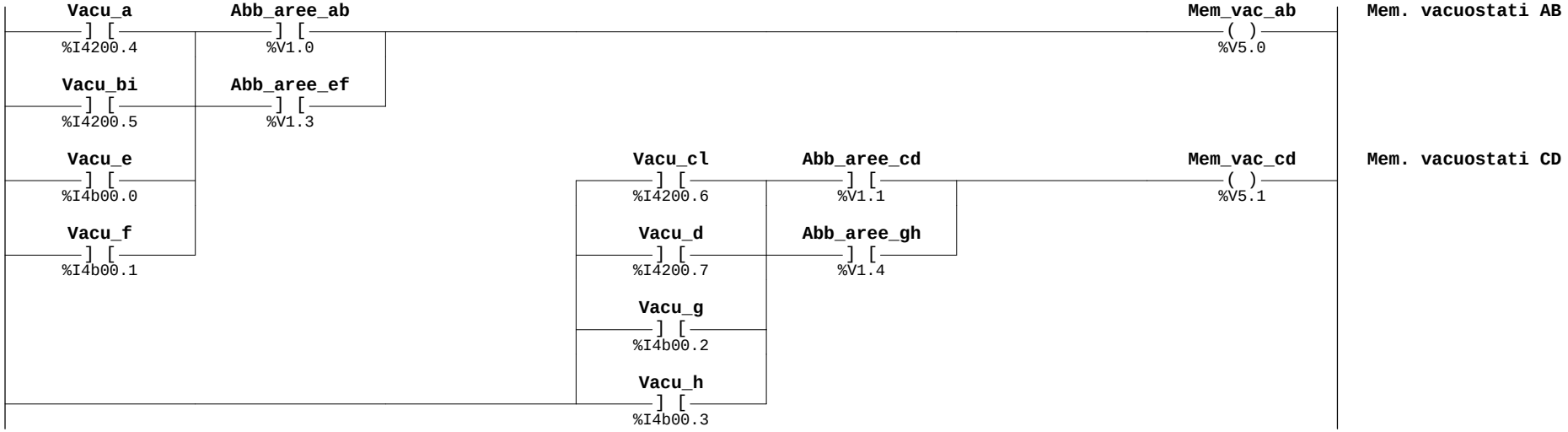
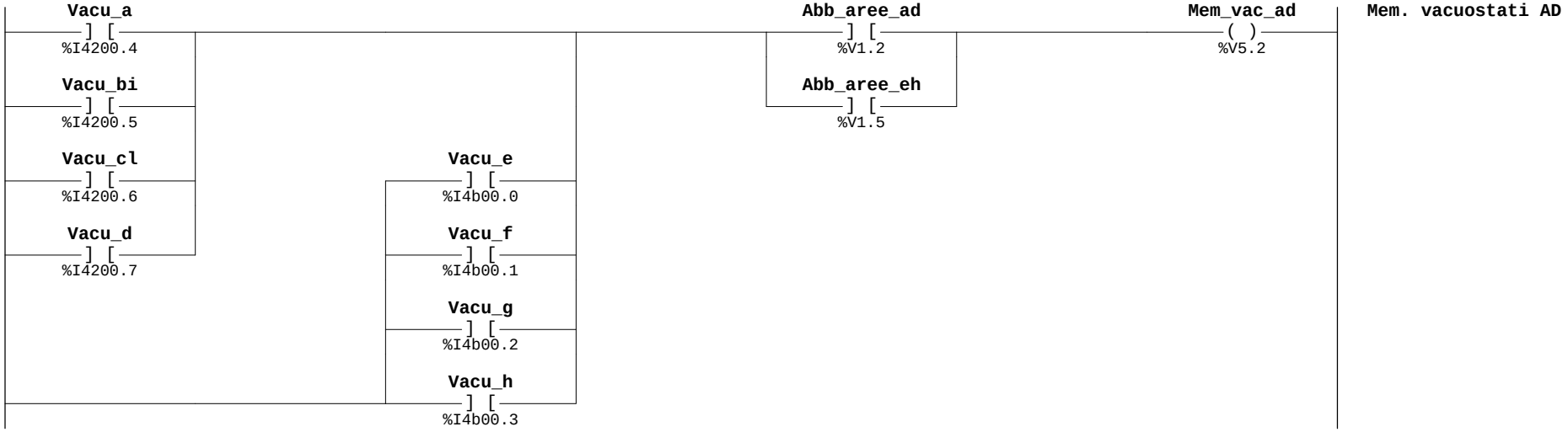
00 Label: Step:

Memorie vacuostati



01 Label: Step:

Memorie vacuostati



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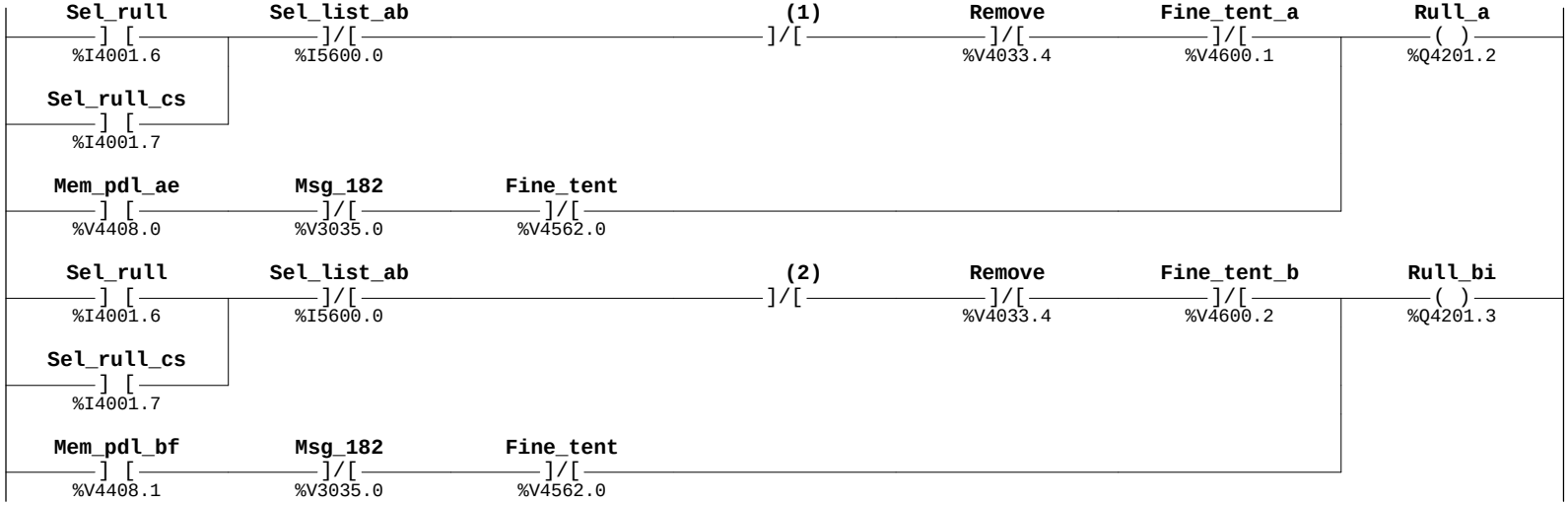
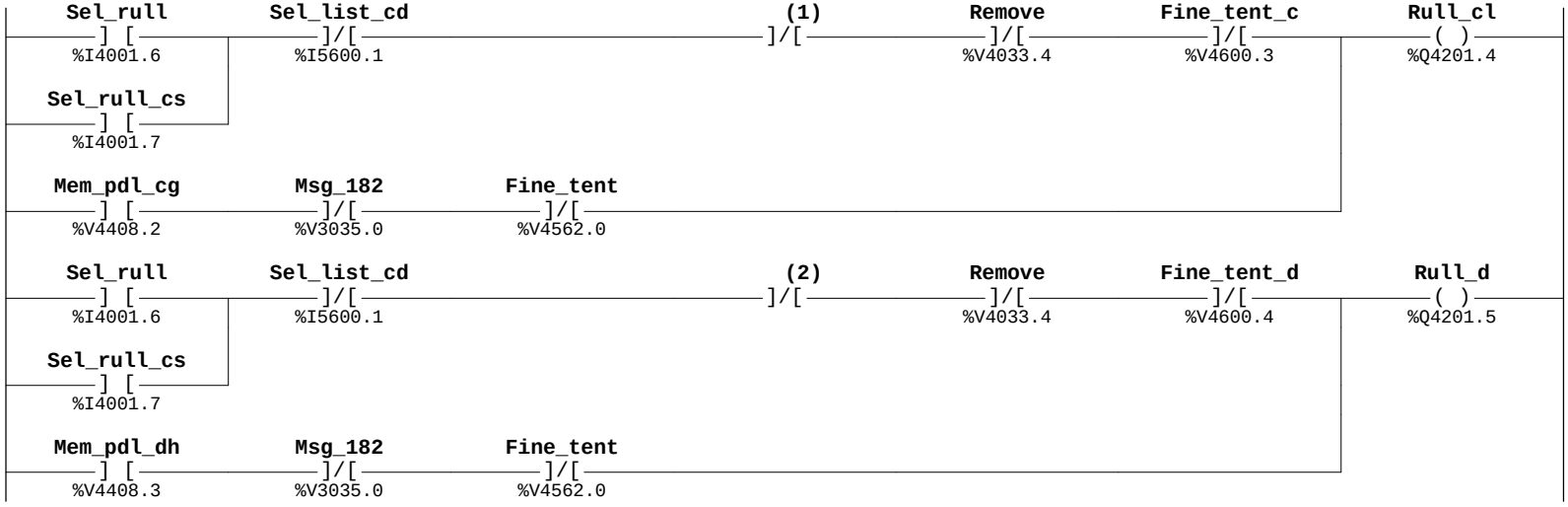
02 Label: Step: OUT rulliere



(1) %V5.3, %I4200.4, %I4b00.0, %V5.0, %V5.2 : Rull_off_a, Vacu_a, Vacu_e, Mem_vac_ab, Mem_vac_ad
(2) %V5.5, %I4200.5, %I4b00.1, %V5.0, %V5.2 : Rull_off_b, Vacu_bi, Vacu_f, Mem_vac_ab, Mem_vac_ad

03 Label: Step: OUT rulliere



(1) %V5.7, %I4200.6, %I4b00.2, %V5.1, %V5.2 : Rull_off_c, Vacu_cl, Vacu_g, Mem_vac_cd, Mem_vac_ad
(2) %V6.1, %I4200.7, %I4b00.3, %V5.1, %V5.2 : Rull_off_d, Vacu_d, Vacu_h, Mem_vac_cd, Mem_vac_ad

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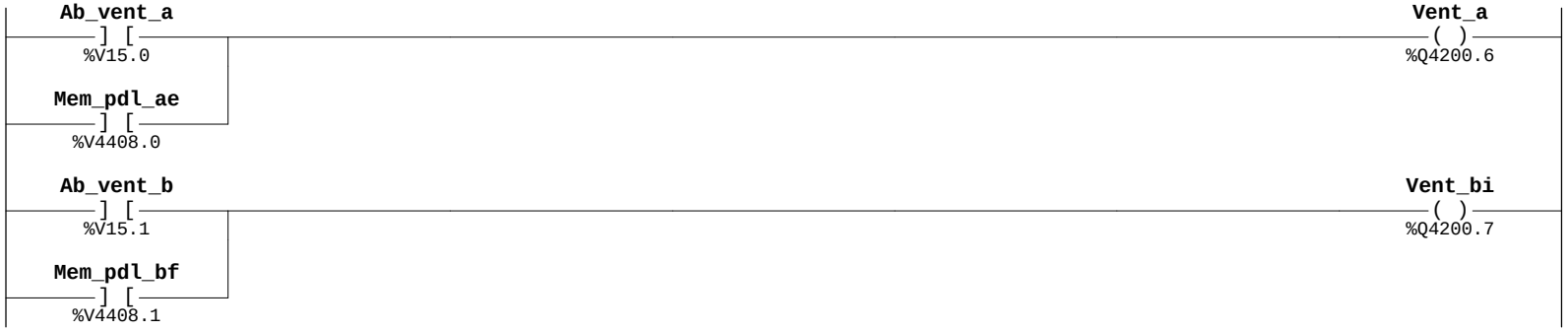
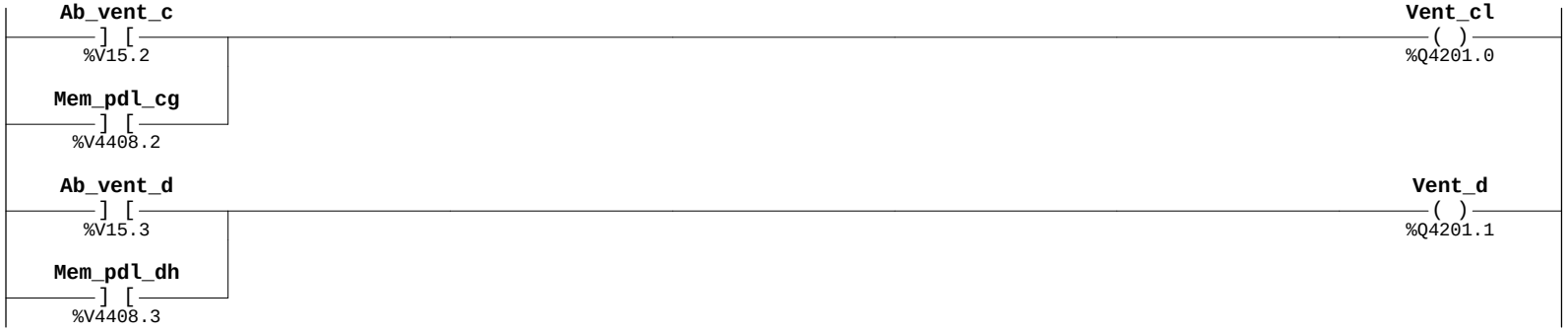
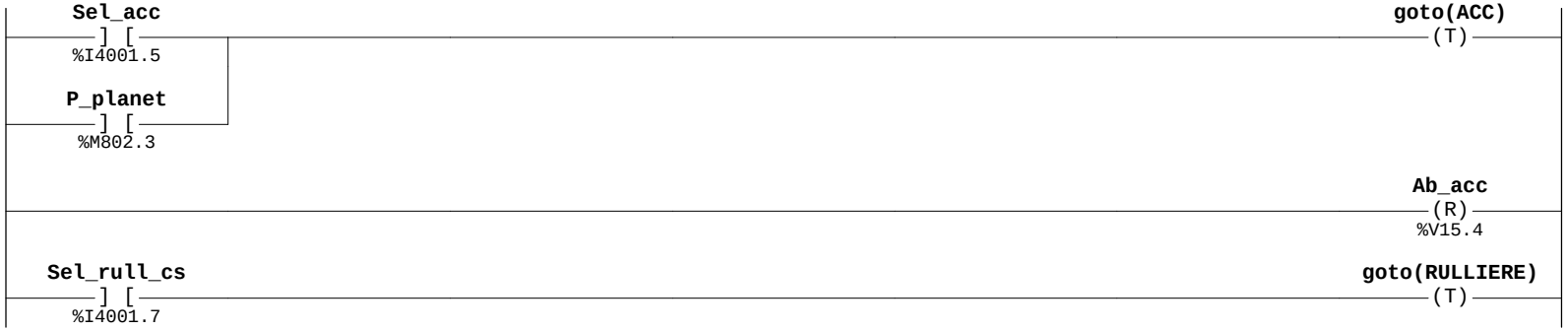
04 Label: Step: OUT ventose



05 Label: Step: OUT ventose



06 Label: Step: Selezione gestione modo di lavoro



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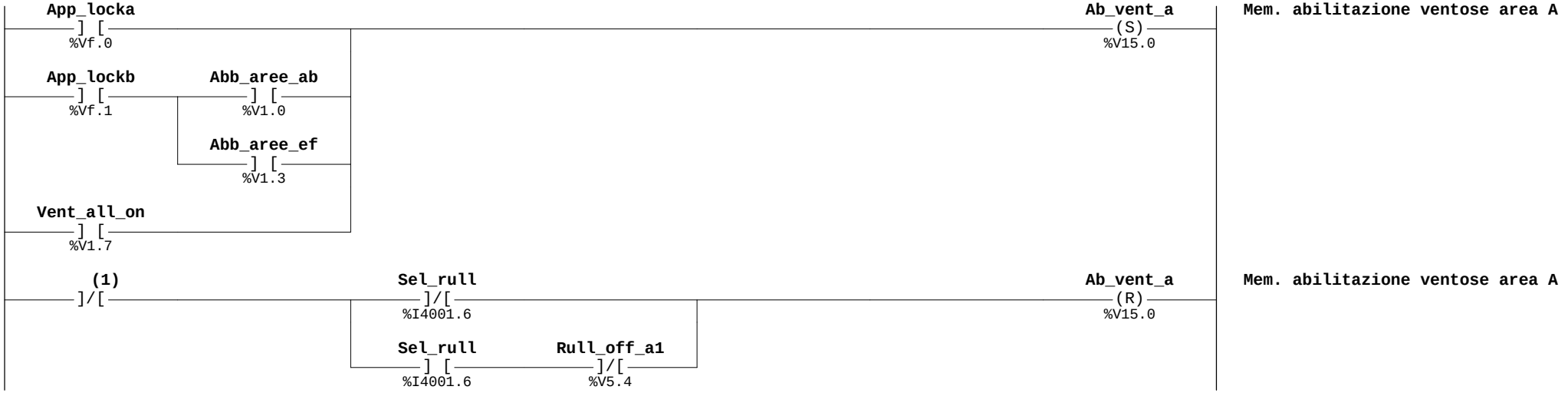
07 Label: **MODO0** Step:

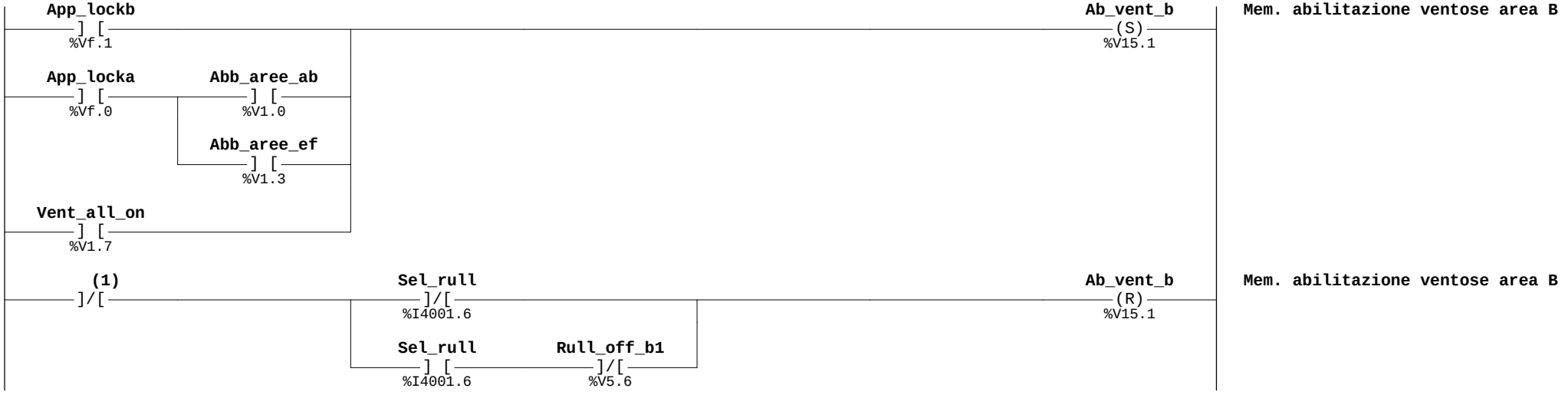
Gestione ON/OFF ventose area A



(1) %Vf.0, %Vf.1, %Vf.2, %Vf.3 : App_locka, App_lockb, App_lockc, App_lockd

08 Label: Step:

Gestione ON/OFF ventose area B



(1) %Vf.0, %Vf.1, %Vf.2, %Vf.3 : App_locka, App_lockb, App_lockc, App_lockd

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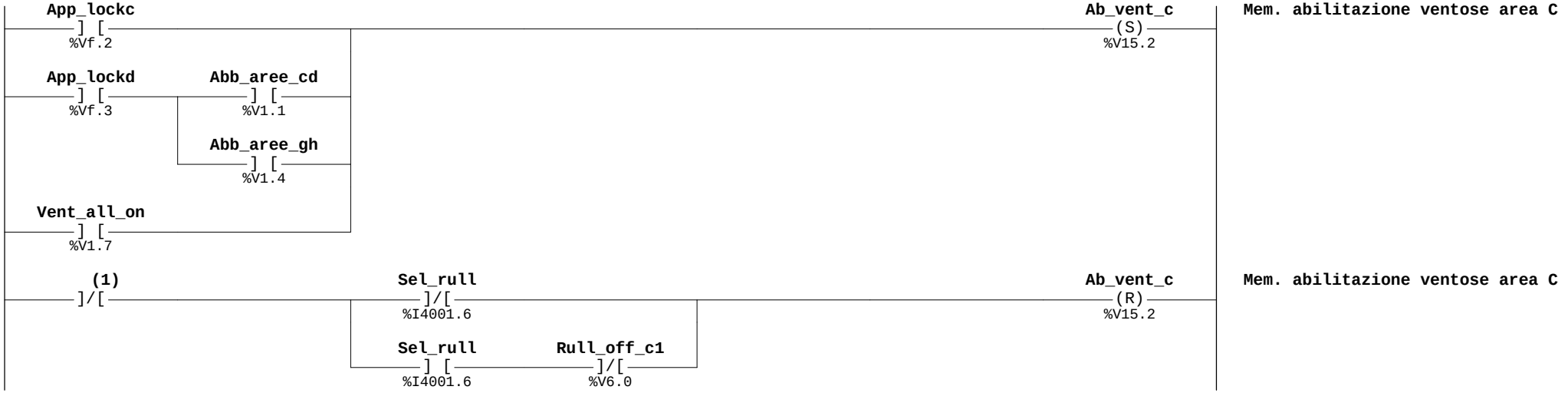
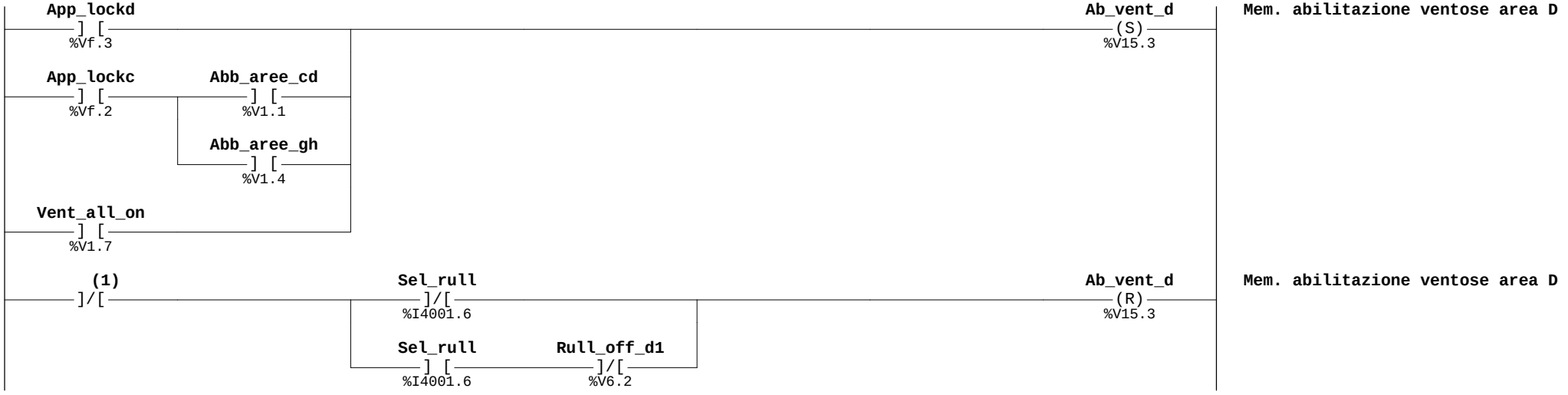
09 Label: Step: Gestione ON/OFF ventose area C



(1) %Vf.0, %Vf.1, %Vf.2, %Vf.3 : App_locka, App_lockb, App_lockc, App_lockd

10 Label: Step: Gestione ON/OFF ventose area D



(1) %Vf.0, %Vf.1, %Vf.2, %Vf.3 : App_locka, App_lockb, App_lockc, App_lockd

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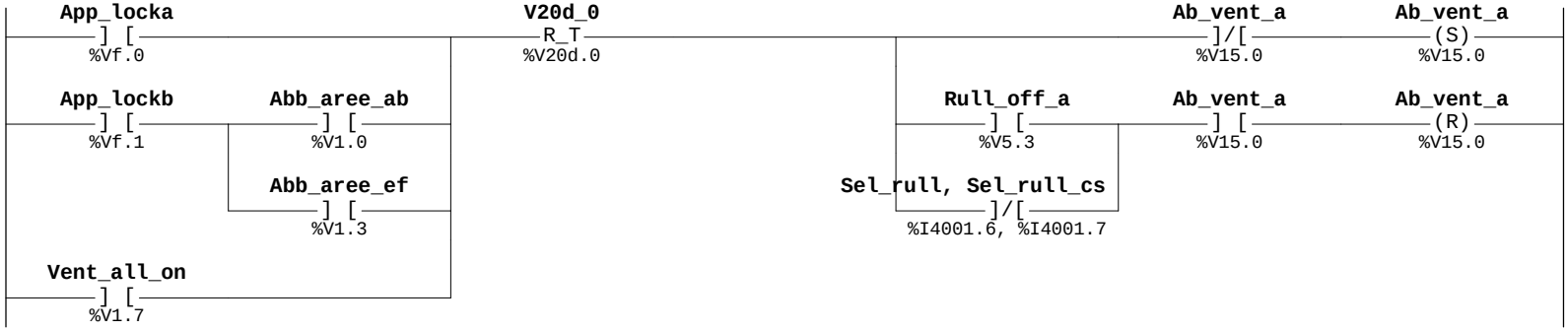
11 Label: Step: Verifica se rulliere aiuto carico attive

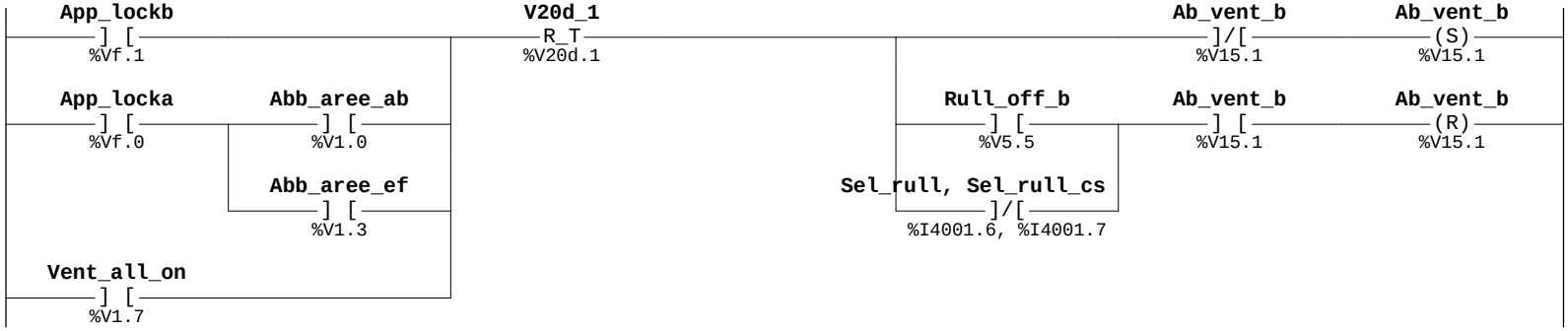
12 Label: **ACC** Step: Gestione accostatori

Copyright by...

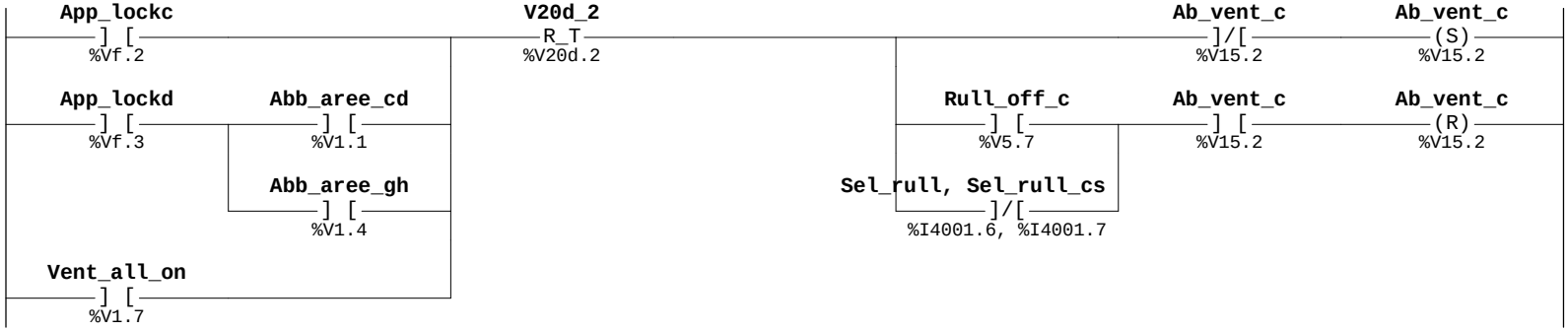
13 Label: Step: Gestione ON/OFF accostatori frontali area A



14 Label: Step: Gestione ON/OFF accostatori frontali area B



15 Label: Step: Gestione ON/OFF accostatori frontali area C



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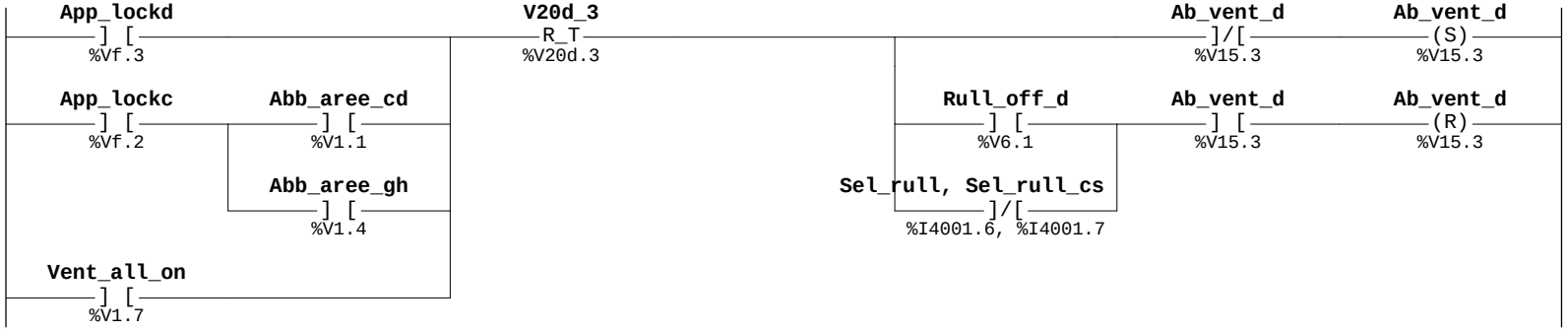
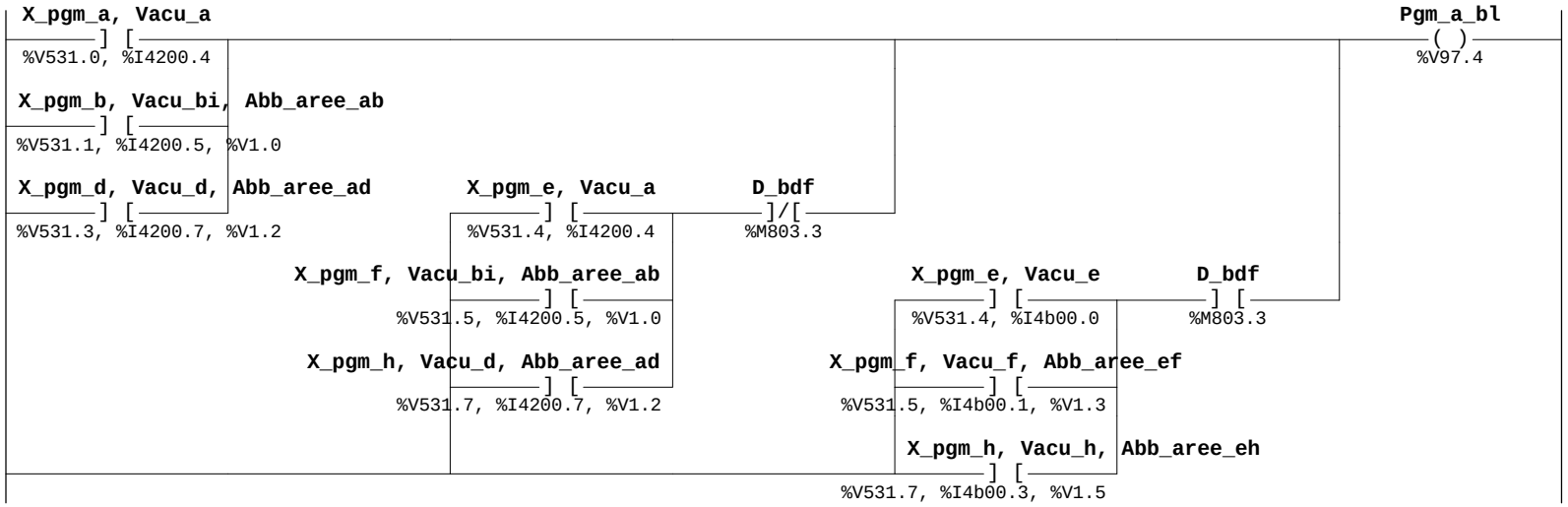
16 Label: Step: Gestione ON/OFF accostatori frontali area D



17 Label: Step: Fine gsetione accostatori

18 Label: **RULLIERE** Step: Programma presente e pannello bloccato su area A o E



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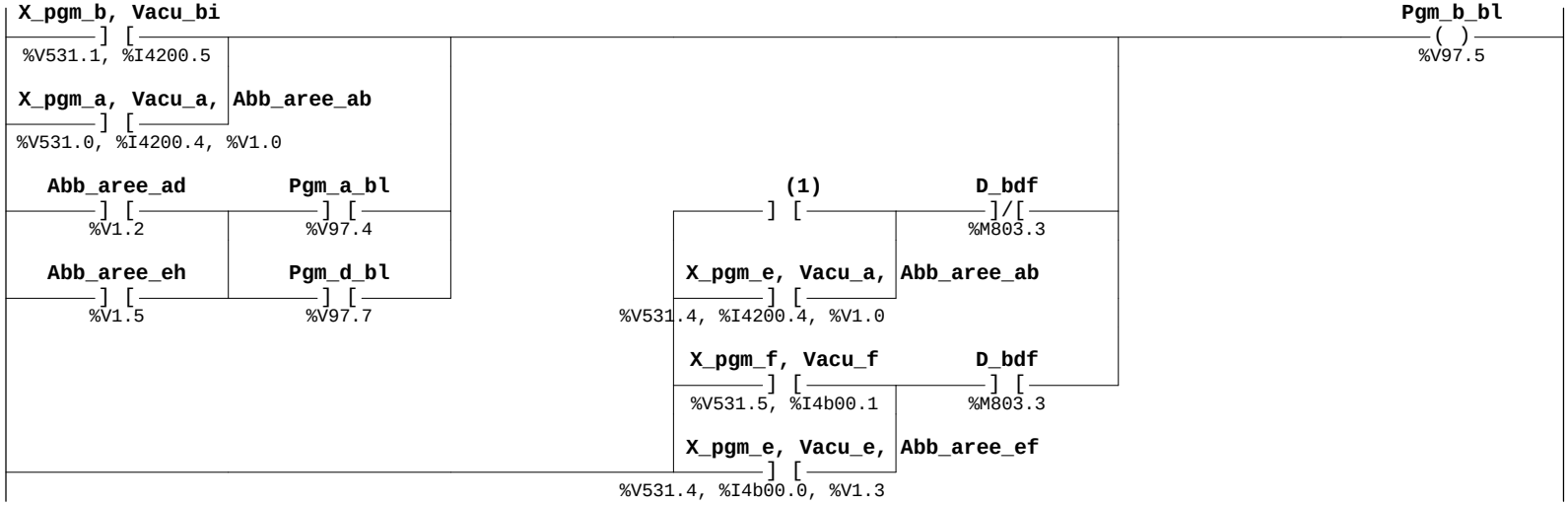
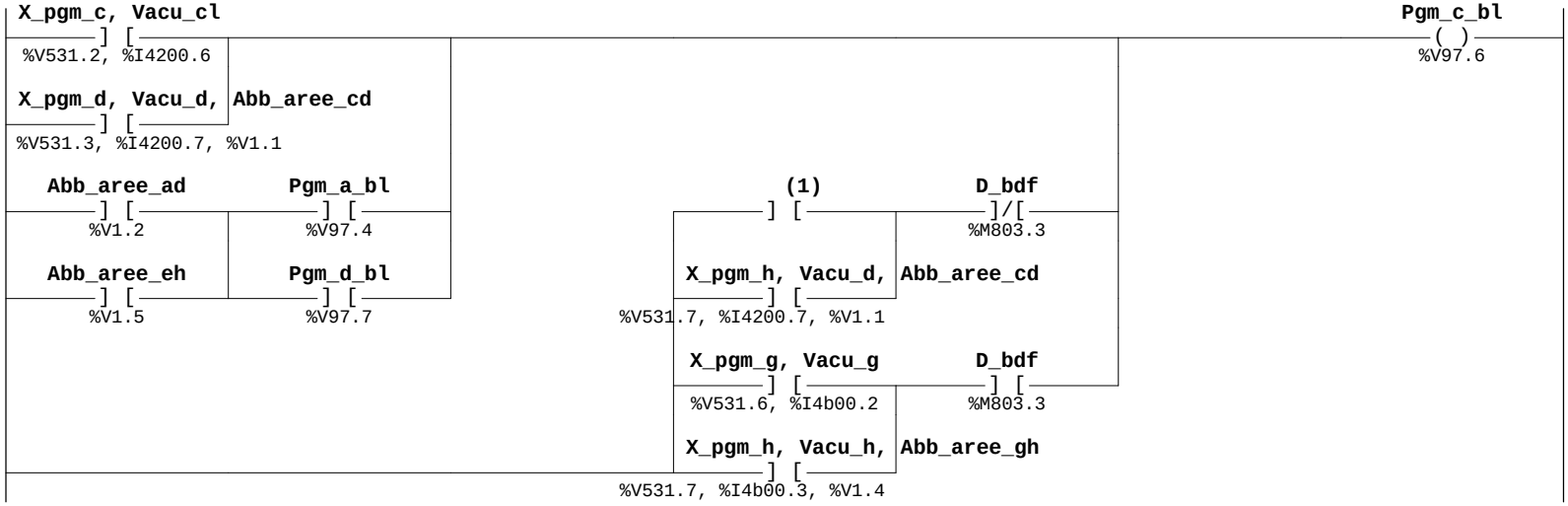
19 Label: Step: Programma presente e pannello bloccato su area B o F



Mem. pannello bloccato area B

(1) %V531.5, %I4200.5 : X_pgm_f, Vacu_bi

20 Label: Step: Programma presente e pannello bloccato su area C o G



Mem. pannello bloccato area C

(1) %V531.6, %I4200.6 : X_pgm_g, Vacu_cl

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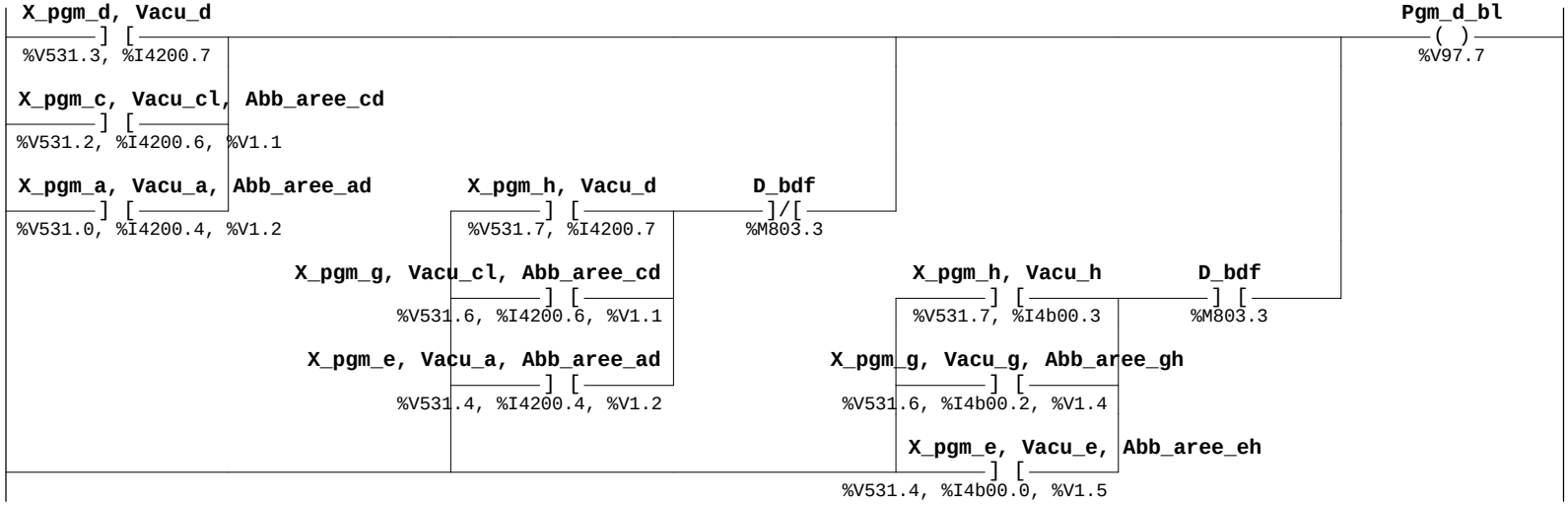
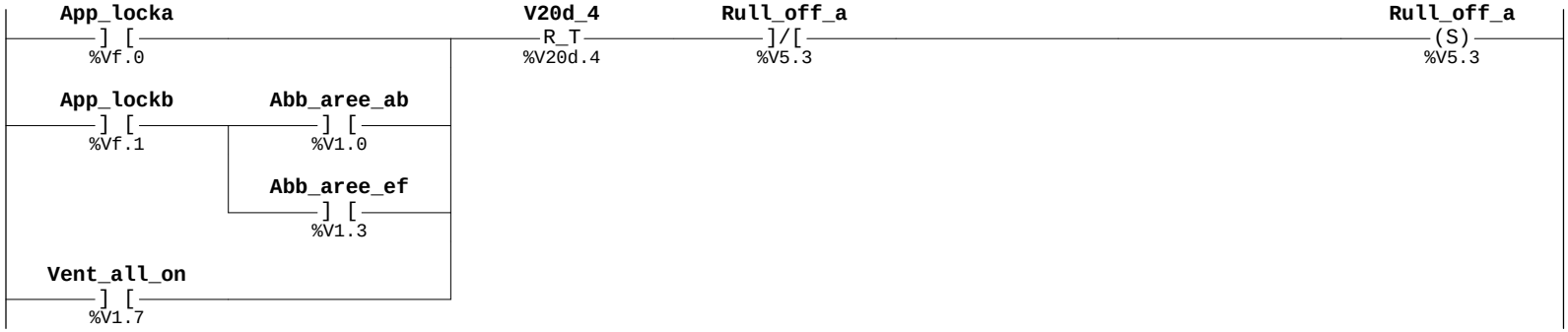
21 Label: Step: Programma presente e pannello bloccato su area D o H



Mem. pannello bloccato area D

22 Label: Step: Gestione ON/OFF rulliere area A



Mem. rull. OFF A

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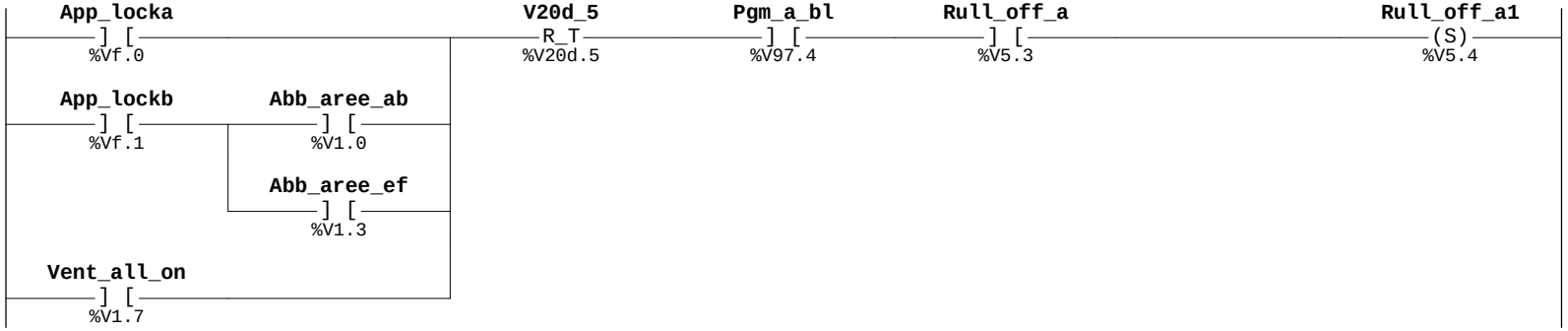
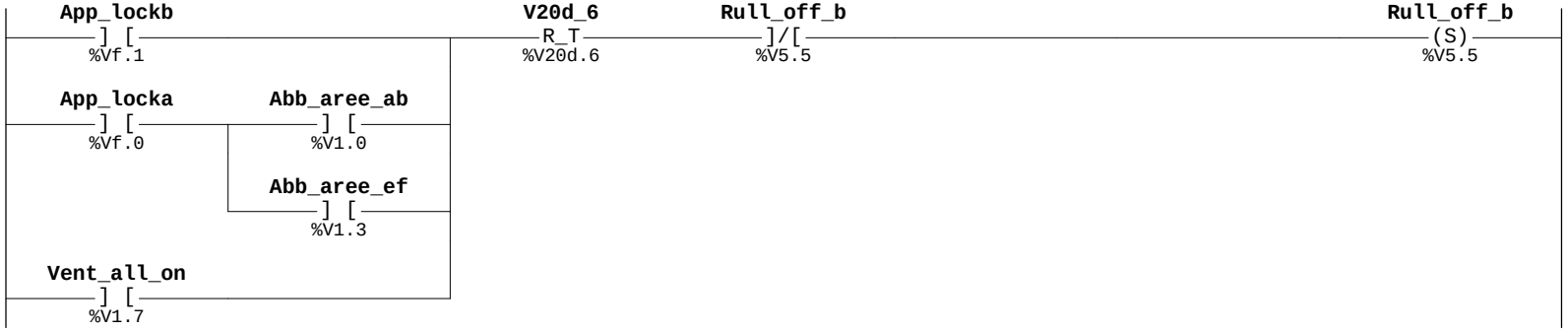
23 Label: Step:



Mem. rull. OFF A con controsagom

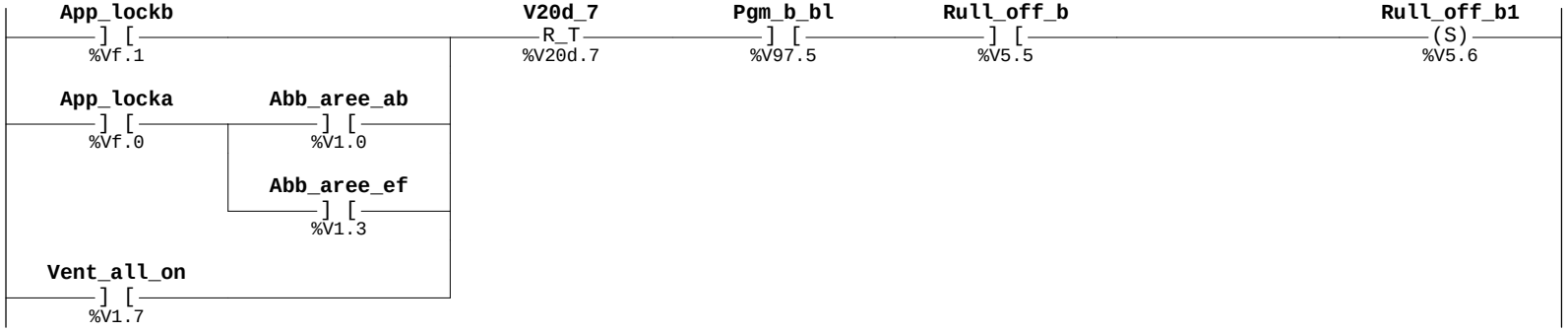
24 Label: Step:

Gestione ON/OFF rulliere area B



Mem. rull. OFF B

25 Label: Step:

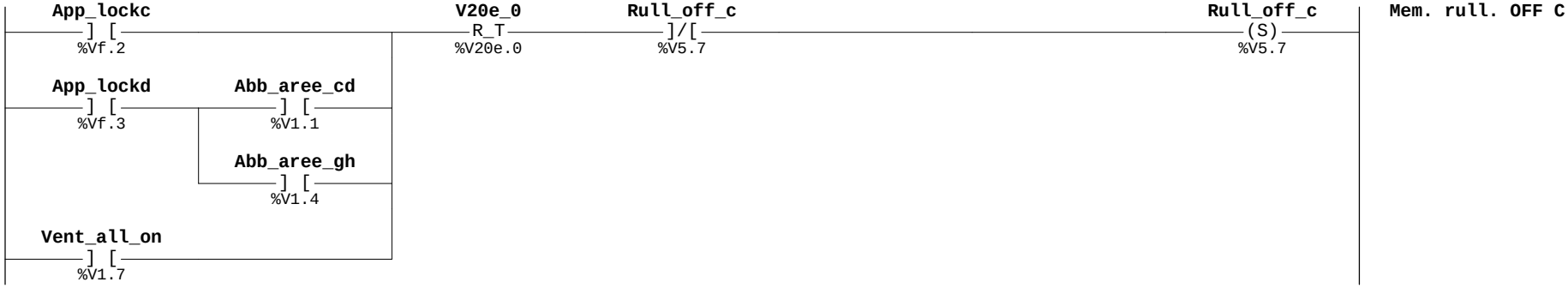


Mem. rull. OFF B con controsagom

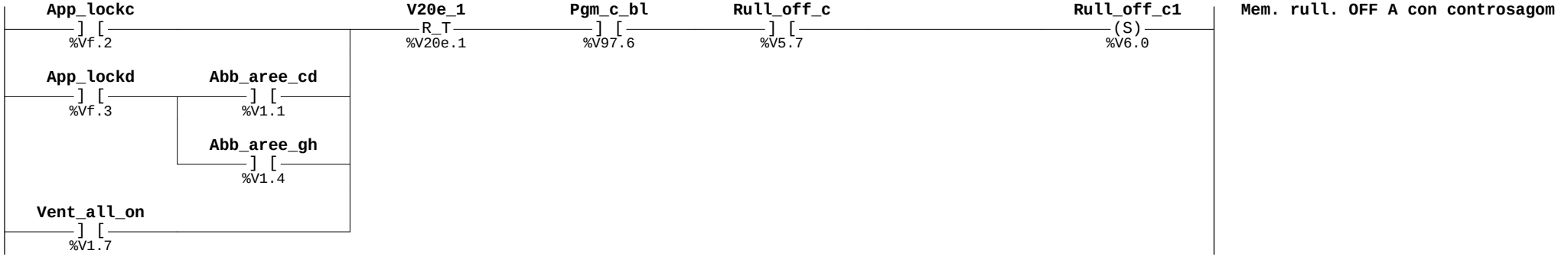
Copyright by...

26 Label: Step:

Gestione ON/OFF rulliere area C

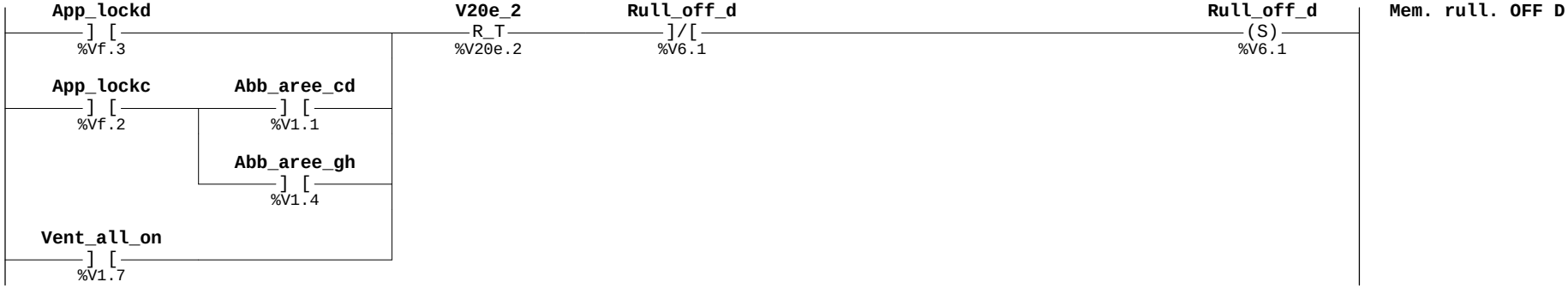


27 Label: Step:



28 Label: Step:

Gestione ON/OFF rulliere area D



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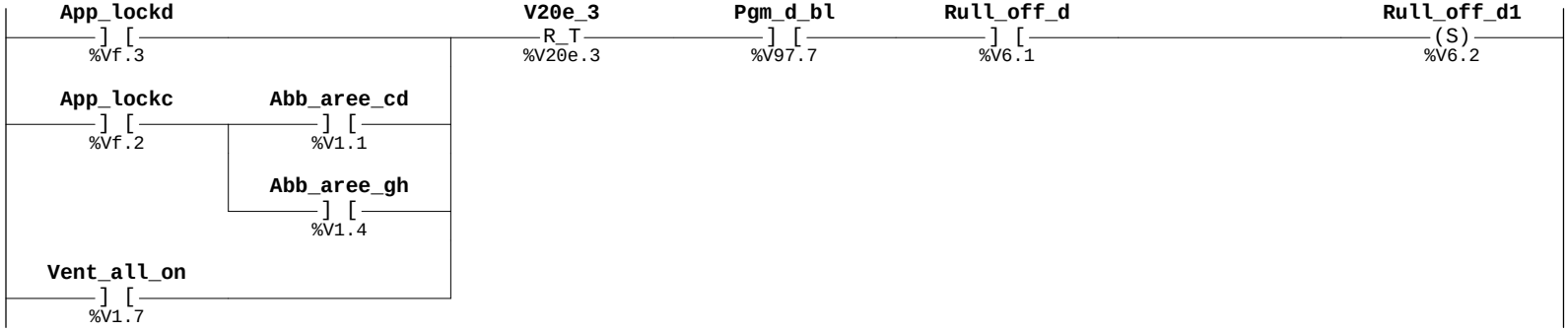
29 Label: Step:



Mem. rull. OFF D con controsagom

30 Label: Step:

Selezione gestione modo di lavoro

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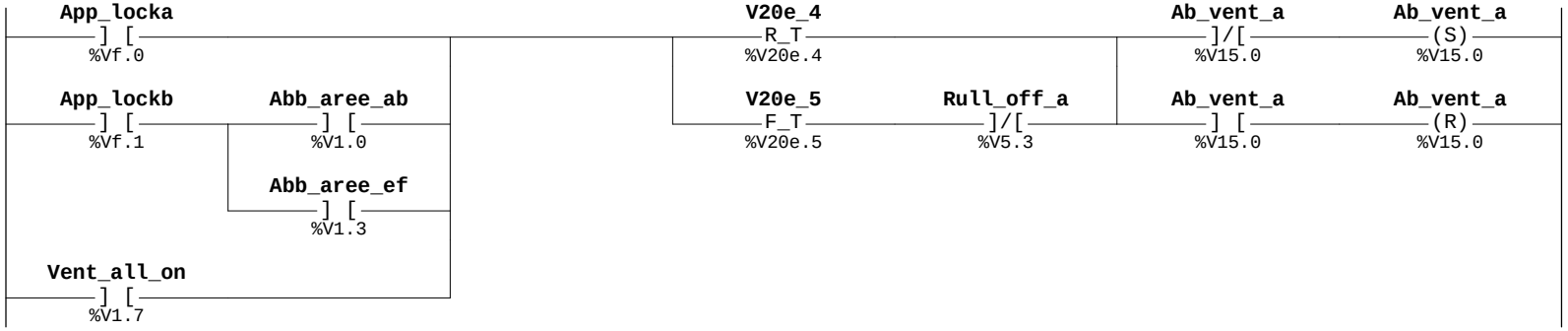
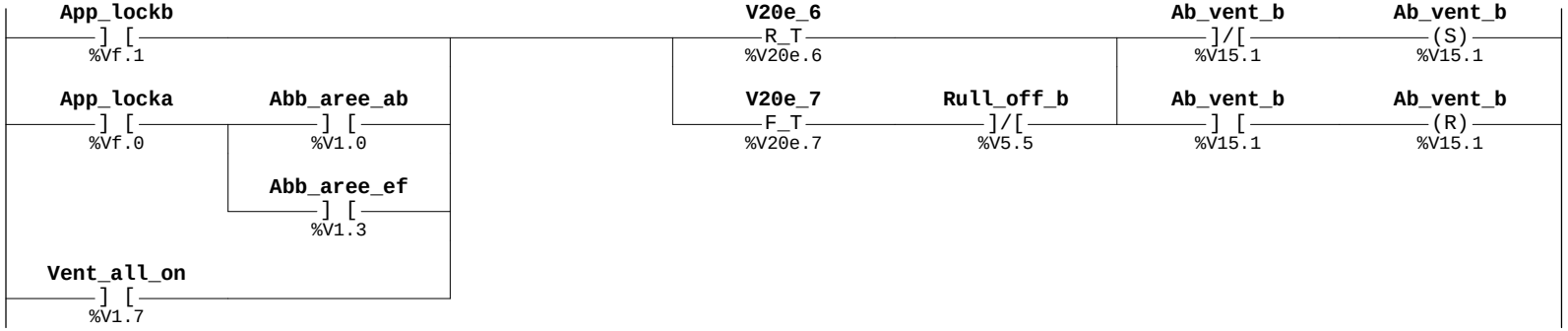
31 Label: **MODO2** Step:

Gestione ventose con rulliere controsagome area A e B

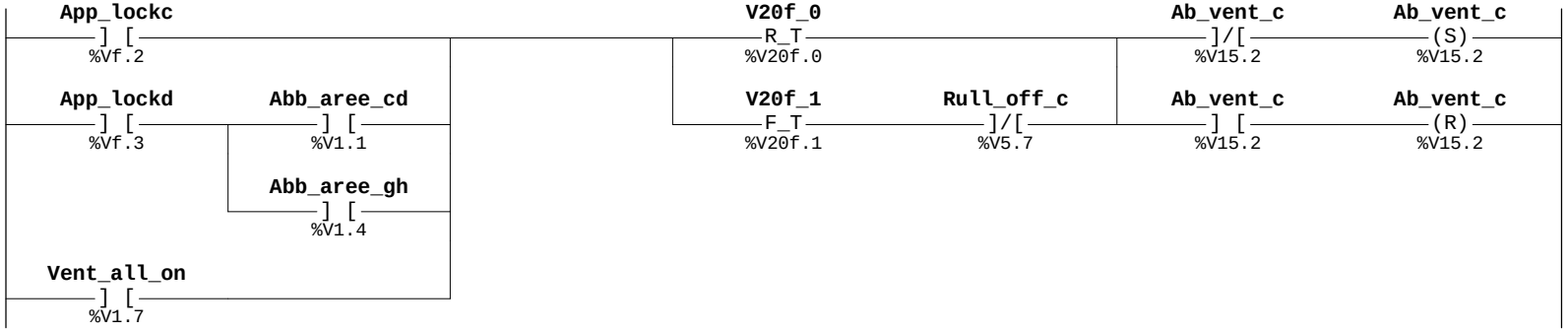


32 Label: Step:



33 Label: Step:

Gestione ventose con rulliere controsagome area C e D



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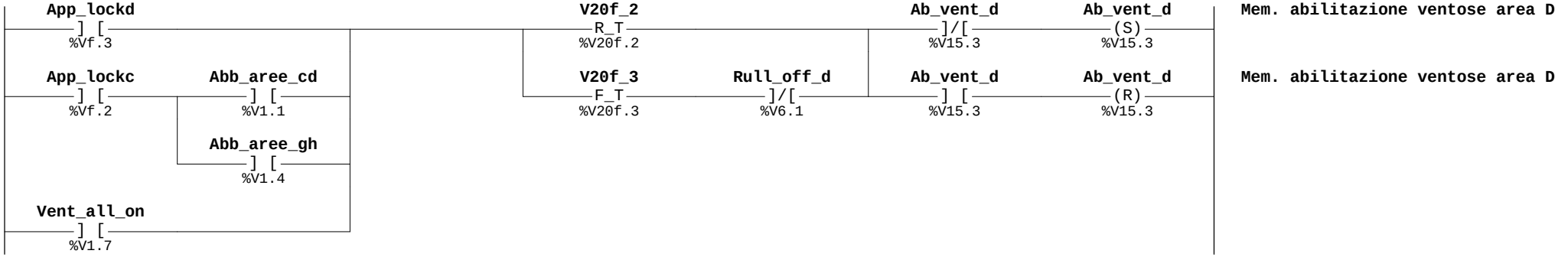
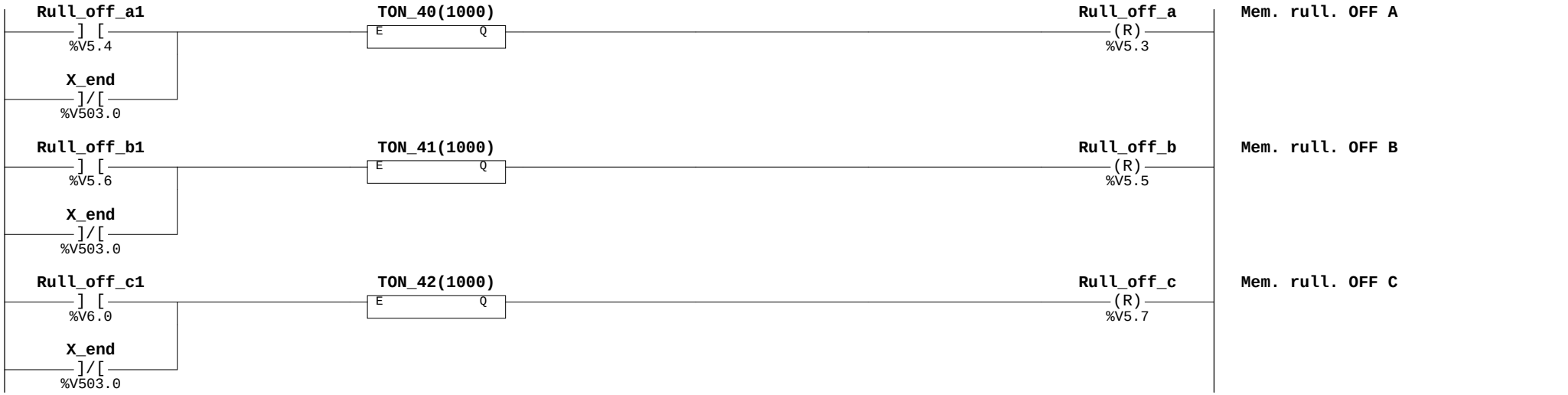
34 Label: Step:



35 Label: **FINE** Step:




```
[T]  TON_40(0x3e8)    :    TON_40(1000)
[T]  TON_41(0x3e8)    :    TON_41(1000)
[T]  TON_42(0x3e8)    :    TON_42(1000)
```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36 Label: Step:

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[T]  TON_43(0x3e8)    :    TON_43(1000)
[T]  TON_44(0x3e8)    :    TON_44(1000)
[T]  TON_45(0x3e8)    :    TON_45(1000)
[T]  TON_46(0x3e8)    :    TON_46(1000)
[T]  TON_47(0x3e8)    :    TON_47(1000)
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