

00 Label: Step:

Memorie vacuostati

Vacu_a	Abb_aree_ab	Mem_vac_ab	Mem. vacuostati AB
] %I4200.4] %V1.0	() %V5.0	
Vacu_bi	Abb_aree_ef		
] %I4200.5] %V1.3		
Vacu_e		Mem_vac_cd	Mem. vacuostati CD
] %I4b00.0		() %V5.1	
Vacu_f	Vacu_d	Abb_aree_gh	
] %I4b00.1] %I4200.7] %V1.4	
	Vacu_g		
] %I4b00.2		
	Vacu_h		
] %I4b00.3		

01 Label: Step:

Memorie vacuostati

Vacu_a	Abb_aree_ad	Mem_vac_ad	Mem. vacuostati AD
] %I4200.4] %V1.2	() %V5.2	
Vacu_bi	Abb_aree_eh		
] %I4200.5] %V1.5		
Vacu_cl			
] %I4200.6			
Vacu_d	Vacu_e		
] %I4200.7] %I4b00.0		
	Vacu_f		
] %I4b00.1		
	Vacu_g		
] %I4b00.2		
	Vacu_h		
] %I4b00.3		

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02 Label: Step:

OUT rulliere

Sel_rull	Sel_list_ab	(1)	Remove	Fine_tent_a	Rull_a
] %I4001.6] %I5600.0]/[]/[]/[() %Q4201.2
Sel_rull_cs] %I4001.7					
Mem_pdl_ae	Msg_182	Fine_tent			
] %V4408.0] %V3035.0]/[%V4562.0			
Sel_rull	Sel_list_ab	(2)	Remove	Fine_tent_b	Rull_bi
] %I4001.6] %I5600.0]/[]/[]/[() %Q4201.3
Sel_rull_cs] %I4001.7					
Mem_pdl_bf	Msg_182	Fine_tent			
] %V4408.1] %V3035.0]/[%V4562.0			

Abilitazione rulliera aiuto cari

Abilitazione rulliera aiuto cari

(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

Sel_rull	Sel_list_cd	(1)	Remove	Fine_tent_c	Rull_cl
] %I4001.6] %I5600.1]/[]/[]/[() %Q4201.4
Sel_rull_cs] %I4001.7					
Mem_pdl_cg	Msg_182	Fine_tent			
] %V4408.2] %V3035.0]/[%V4562.0			
Sel_rull	Sel_list_cd	(2)	Remove	Fine_tent_d	Rull_d
] %I4001.6] %I5600.1]/[]/[]/[() %Q4201.5
Sel_rull_cs] %I4001.7					
Mem_pdl_dh	Msg_182	Fine_tent			
] %V4408.3] %V3035.0]/[%V4562.0			

Abilitazione rulliera aiuto cari

Abilitazione rulliera aiuto cari

(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

Ab_vent_a] [%V15.0		Vent_a () %Q4200.6
Mem_pdl_ae] [%V4408.0		
Ab_vent_b] [%V15.1		Vent_bi () %Q4200.7
Mem_pdl_bf] [%V4408.1		

Abilitazione ventose area A

Abilitazione ventose area B - ar

05 Label: Step:

OUT ventose

Ab_vent_c] [%V15.2		Vent_cl () %Q4201.0
Mem_pdl_cg] [%V4408.2		
Ab_vent_d] [%V15.3		Vent_d () %Q4201.1
Mem_pdl_dh] [%V4408.3		

Abilitazione ventose area C - ar

Abilitazione ventose area D

06 Label: Step:

Selezione gestione modo di lavoro

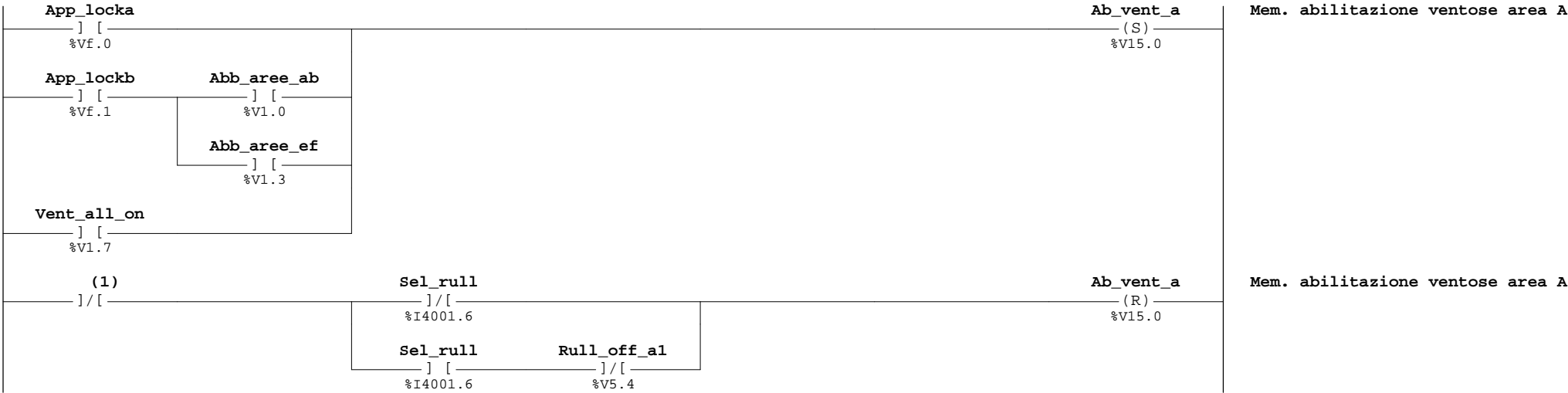
Sel_acc] [%I4001.5		goto(ACC) (T)
P_planet] [%M802.3		
		Ab_acc (R) %V15.4
Sel_rull_cs] [%I4001.7		goto(RULLIERE) (T)

Mem. abilitazione accostatori

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Company:			
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07 Label: MOD00 Step:

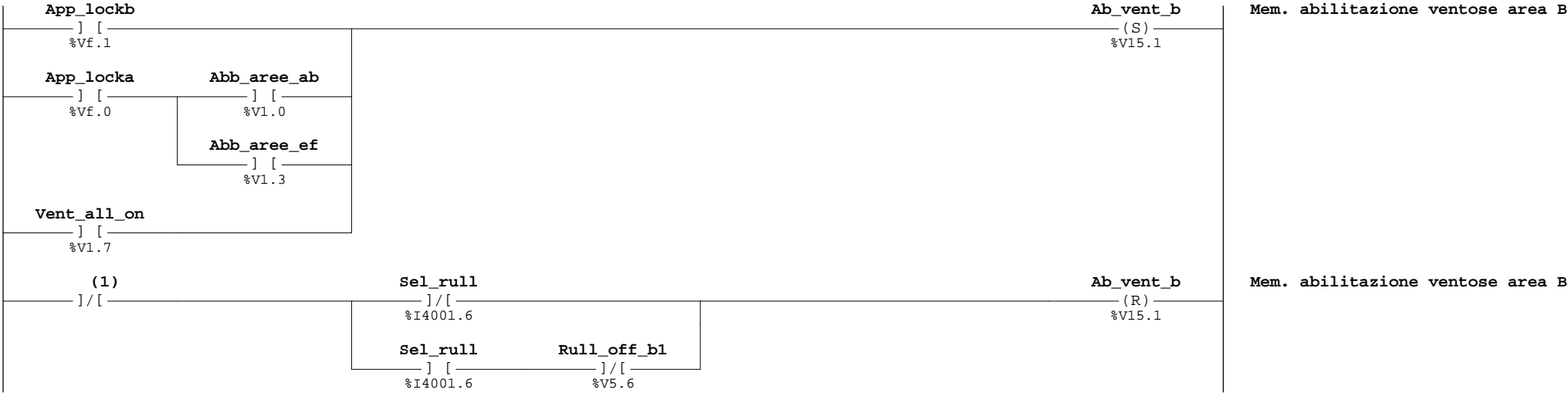
Gestione ON/OFF ventose area A



(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

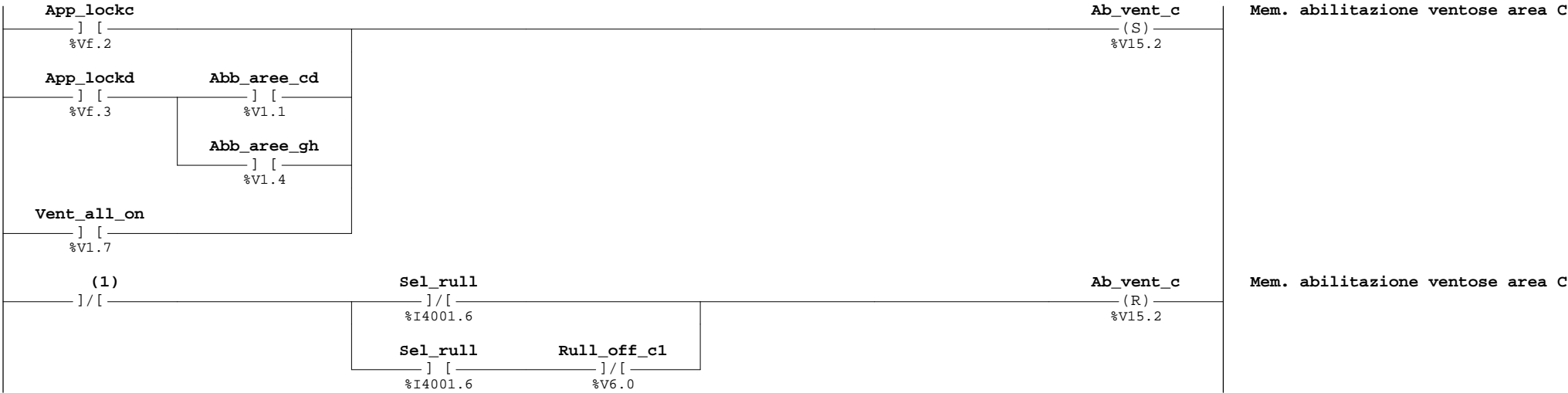


(1) %Vf.0, %Vf.1, %Vf.2, %Vf.3 : App_locka, App_lockb, App_lockc, App_lockd

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Company:			
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09 Label: Step:

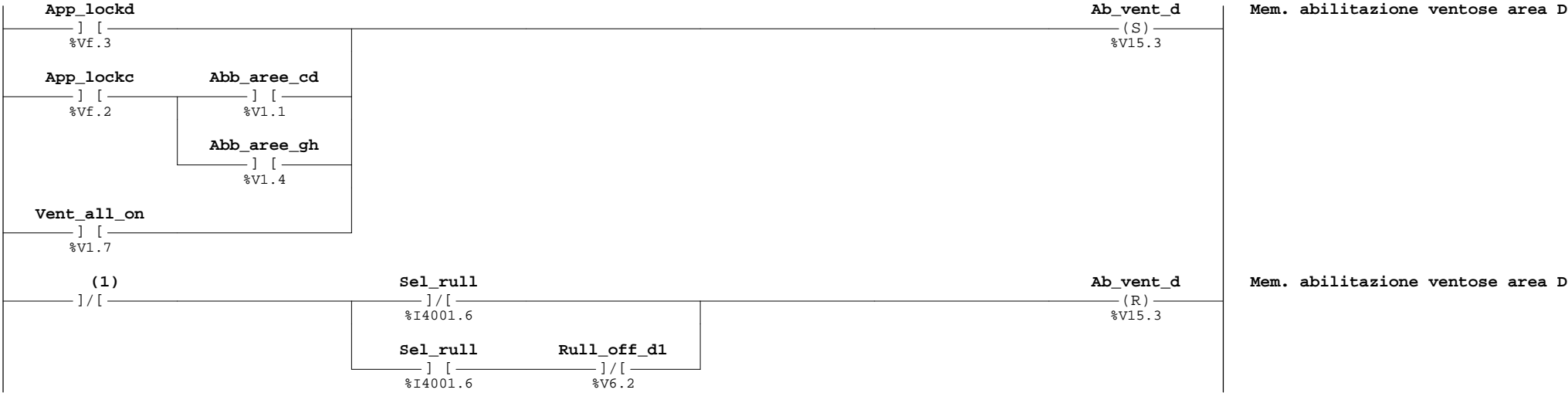
Gestione ON/OFF ventose area C



(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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Company:			
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```
11 Label:
```

Step:

Verifica se rulliere aiuto carico attive

Sel_rull

```
goto(RULLIERE)
```

_____] [_____
%I4001.6

— (T)

```
goto(FINE)
```

— (T)

12 Label: ACC

Step:

Gestione accostatori

Ab_acc

Ab_vent_a

Mem. abilitazione ventose area A

————] / [————
%V15.4

— (S)

%V15.0

Ab_vent_b

— (S)

Mem. abilitazione ventose area B

%V15.1

Ab_vent_c

— (S)

Mem. abilitazione ventose area C

%V15.2

Ab_vent_d

— (S)

Mem. abilitazione ventose area D

%V15.3

Ab_acc

Mem. abilitazione accostatori

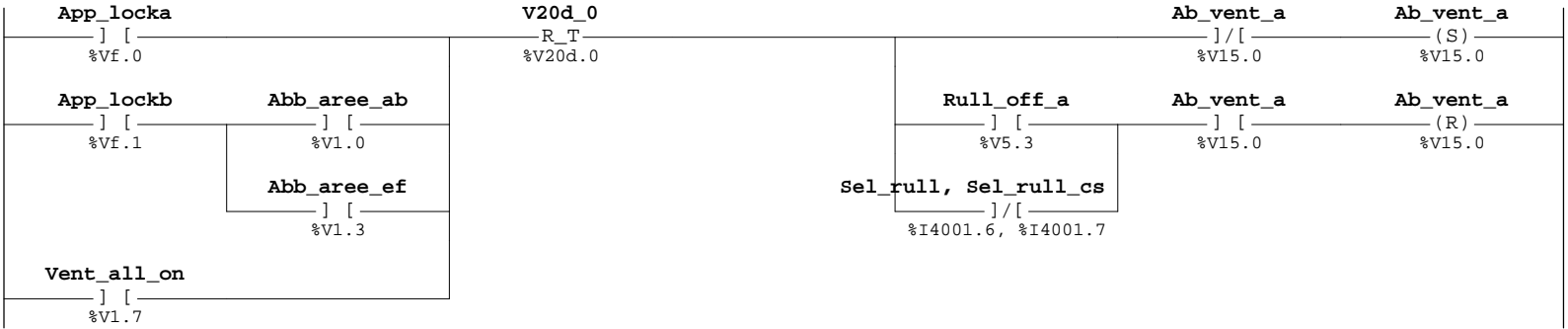
— (S)

(D)
%V15.4

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Company:			
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13 Label: Step:

Gestione ON/OFF accostatori frontali area A

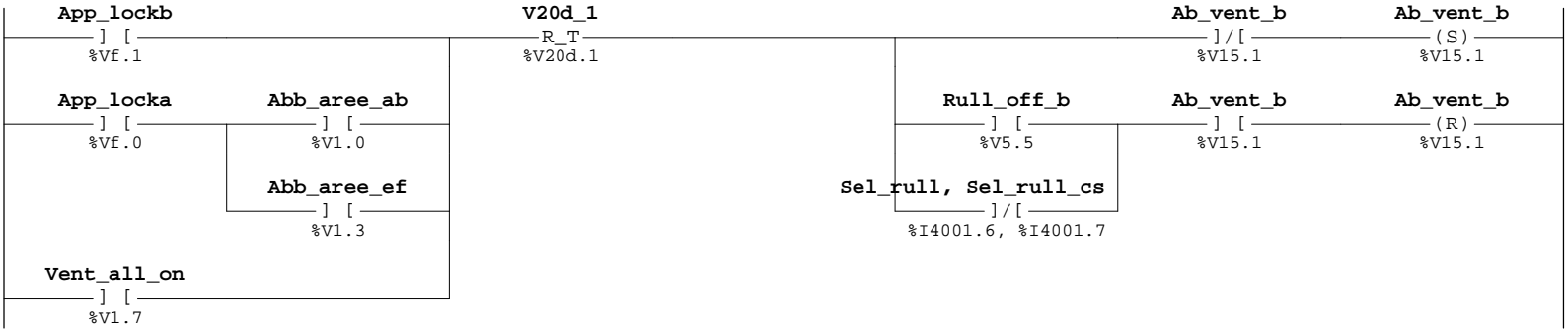


Mem. abilitazione ventose area A

Mem. abilitazione ventose area A

14 Label: Step:

Gestione ON/OFF accostatori frontali area B

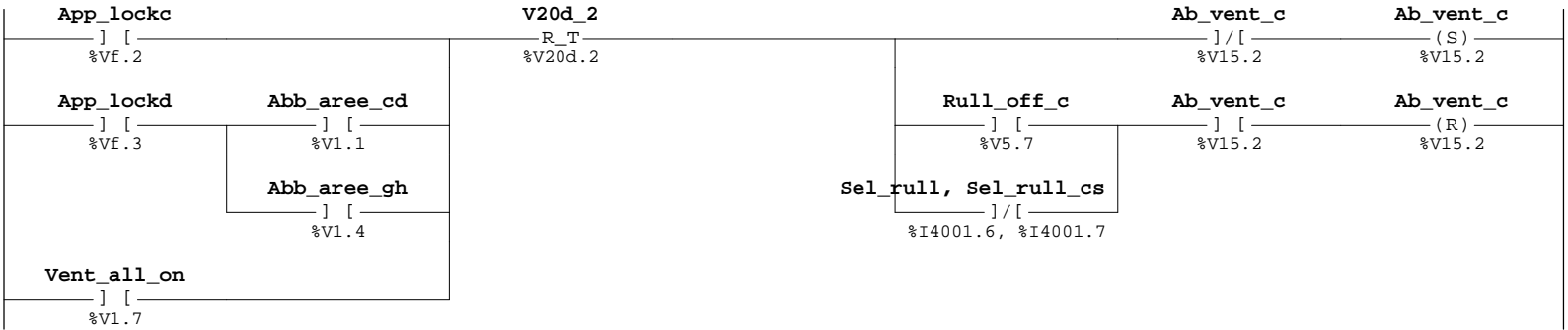


Mem. abilitazione ventose area B

Mem. abilitazione ventose area B

15 Label: Step:

Gestione ON/OFF accostatori frontali area C



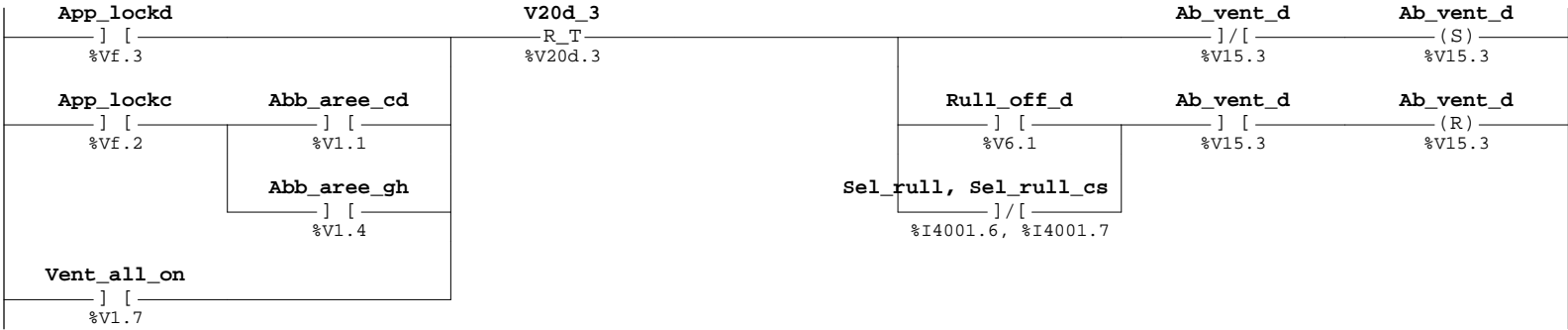
Mem. abilitazione ventose area C

Mem. abilitazione ventose area C

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Company:			
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16 Label: Step:

Gestione ON/OFF accostatori frontali area D



Mem. abilitazione ventose area D

Mem. abilitazione ventose area D

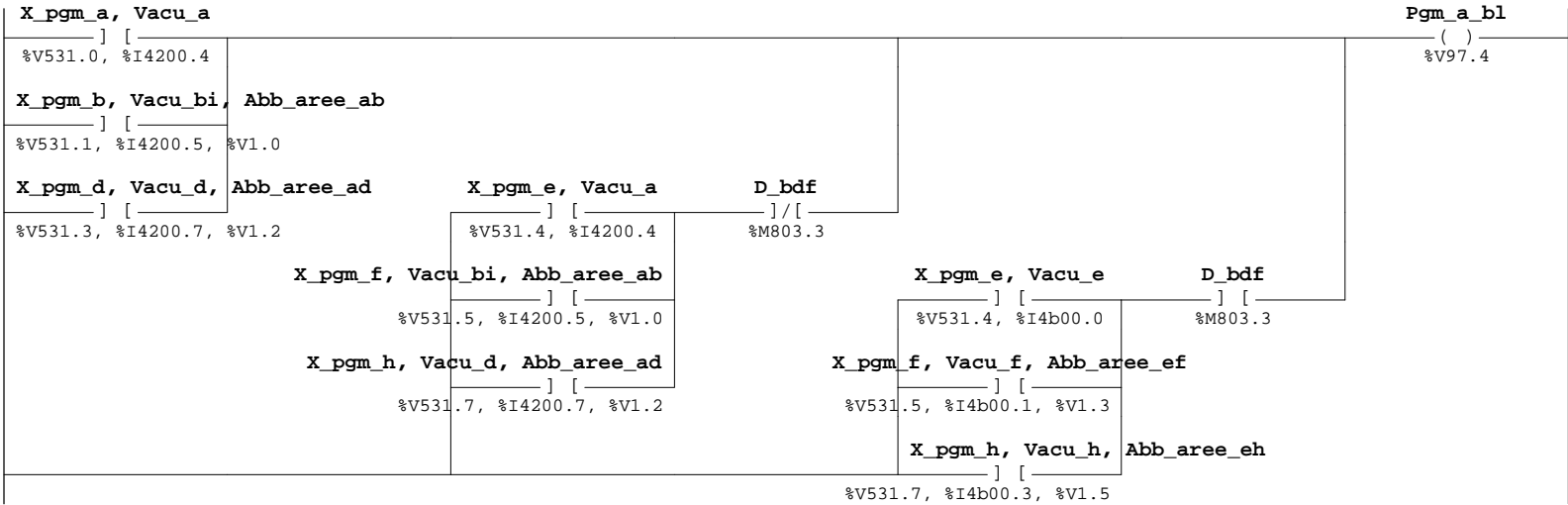
17 Label: Step:

Fine gsetione accostatori



18 Label: RULLIERE Step:

Programma presente e pannello bloccato su area A o E

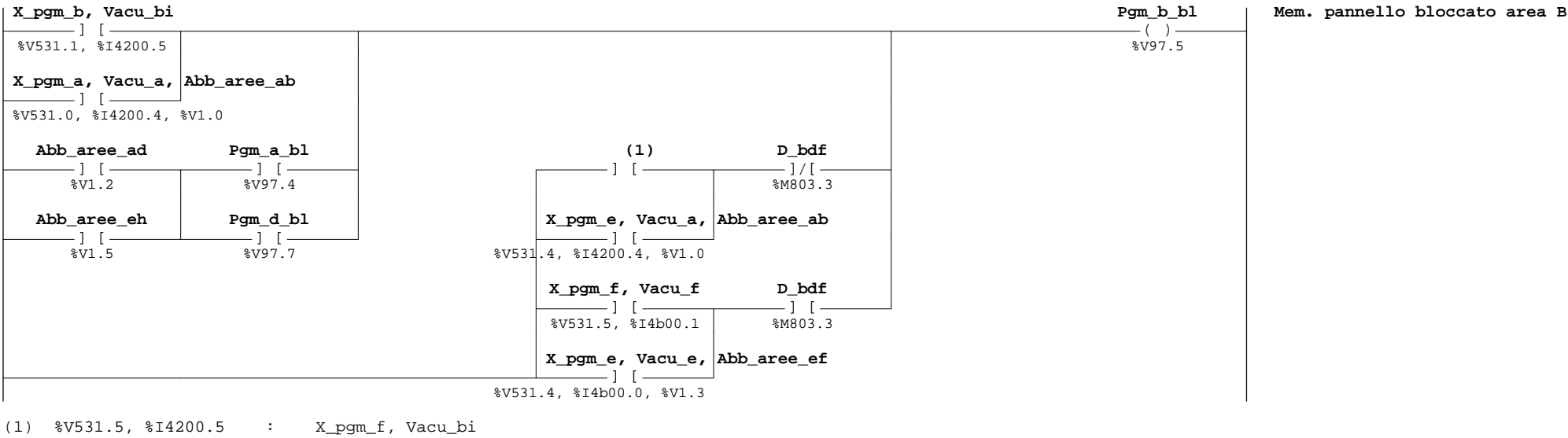


Mem. pannello bloccato area A

Author:		NUM TOOLS	
Company:			
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Module: PUFFER.XLA		%SP125 (16)	Page 8

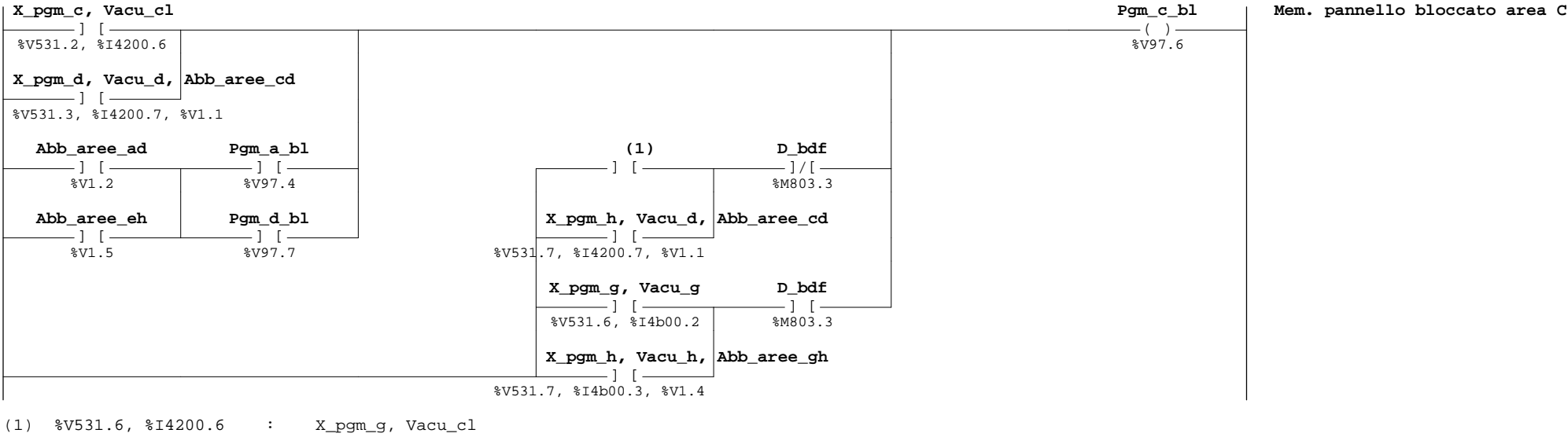
19 Label: Step:

Programma presente e pannello bloccato su area B o F



20 Label: Step:

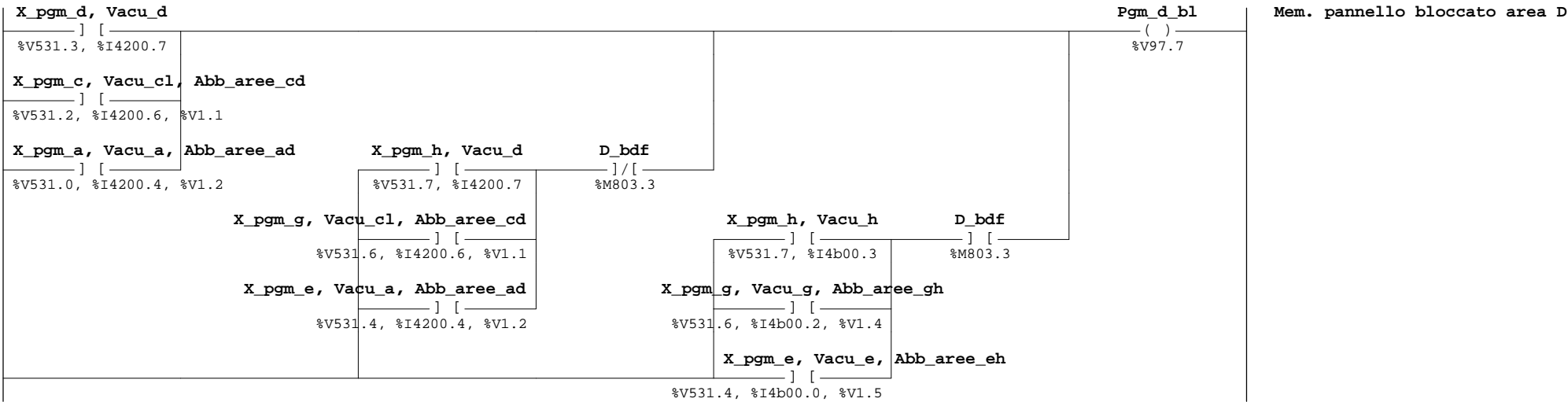
Programma presente e pannello bloccato su area C o G



Author:		NUM TOOLS	
Company:			
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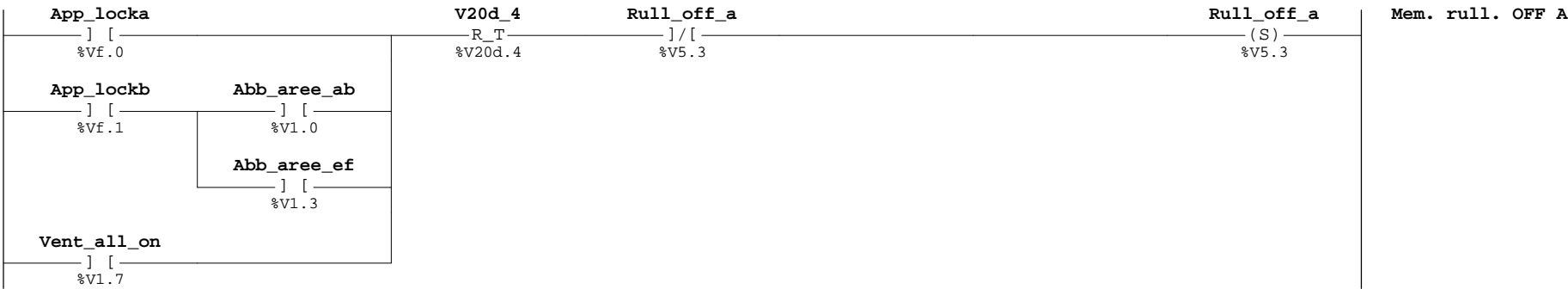
21 Label: Step:

Programma presente e pannello bloccato su area D o H



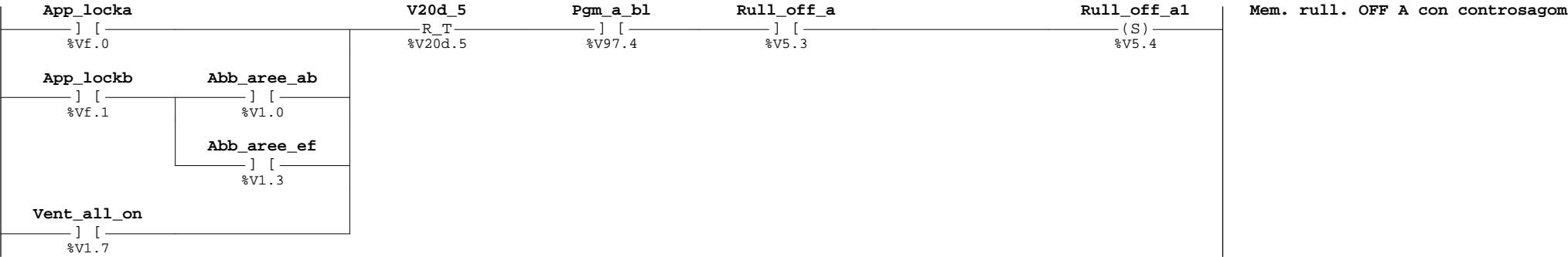
22 Label: Step:

Gestione ON/OFF rulliere area A



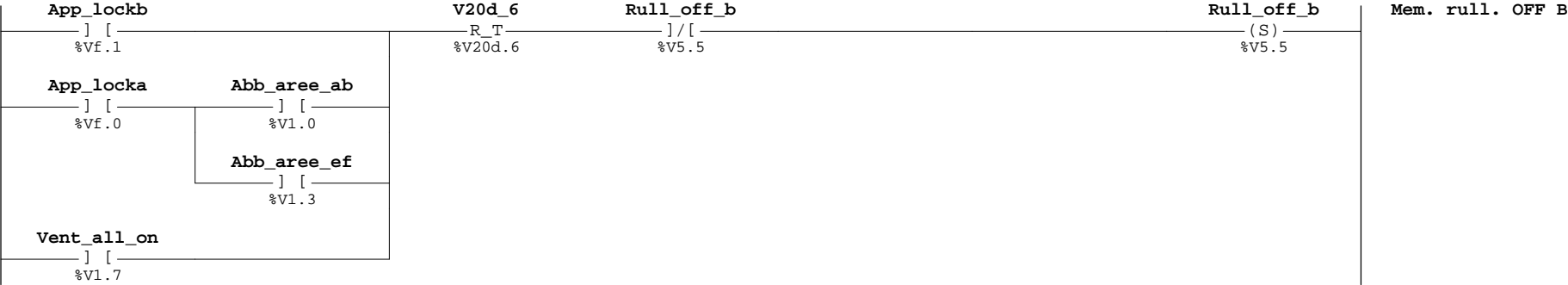
Author:		NUM TOOLS	
Company:			
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23 Label: Step:

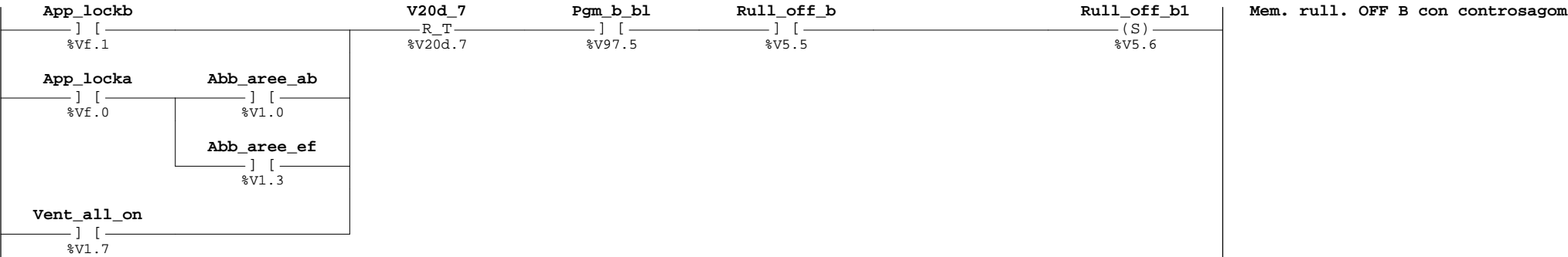


24 Label: Step:

Gestione ON/OFF rulliere area B



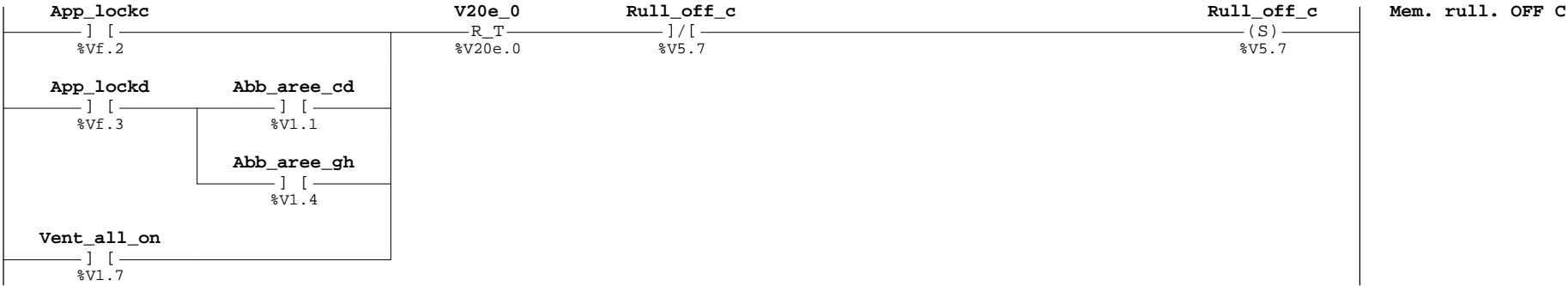
25 Label: Step:



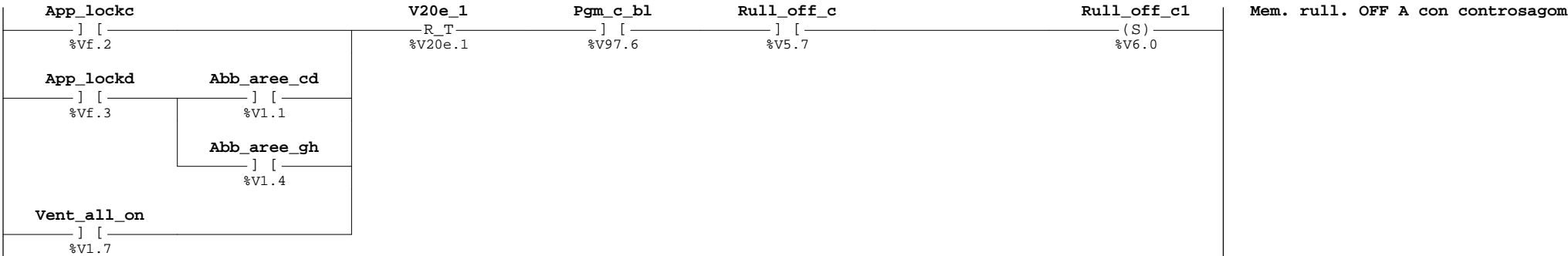
Author:		NUM TOOLS	
Company:			
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26 Label: Step:

Gestione ON/OFF rulliere area C

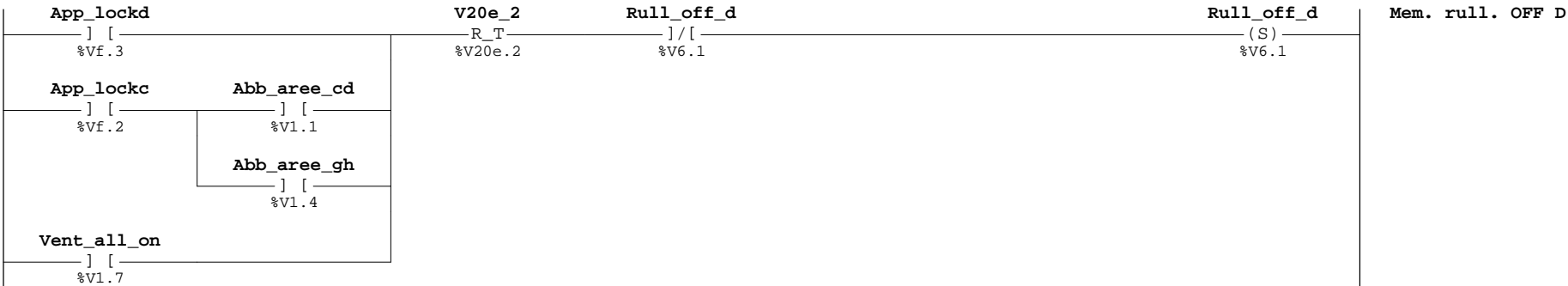


27 Label: Step:



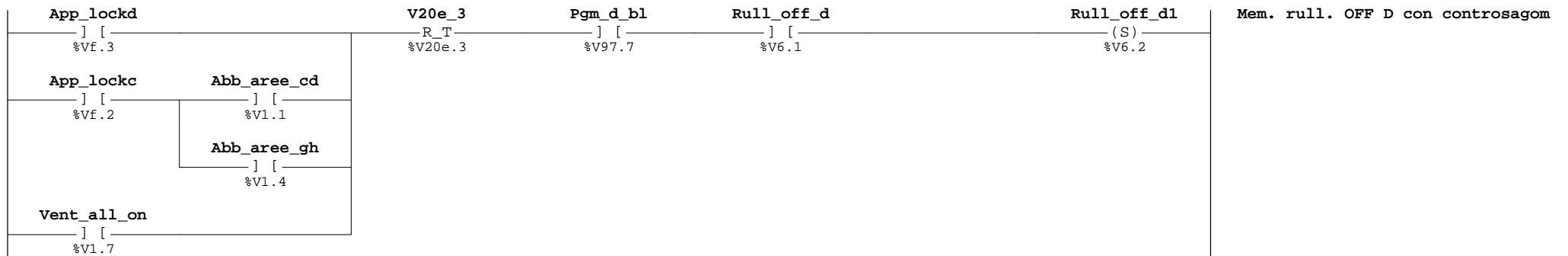
28 Label: Step:

Gestione ON/OFF rulliere area D



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29 Label: Step:



30 Label: Step:

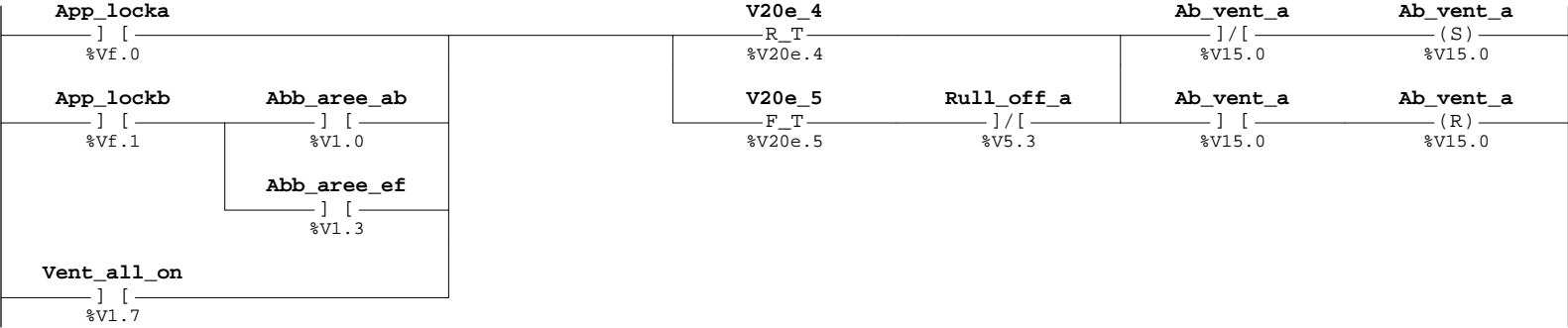
Selezione gestione modo di lavoro



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31 Label: MOD02 Step:

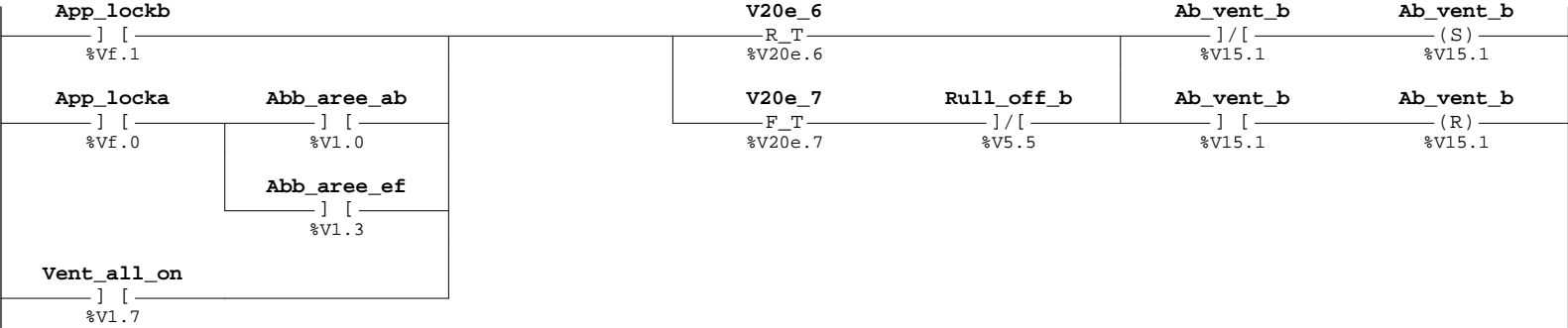
Gestione ventose con rulliere controsagome area A e B



Mem. abilitazione ventose area A

Mem. abilitazione ventose area A

32 Label: Step:

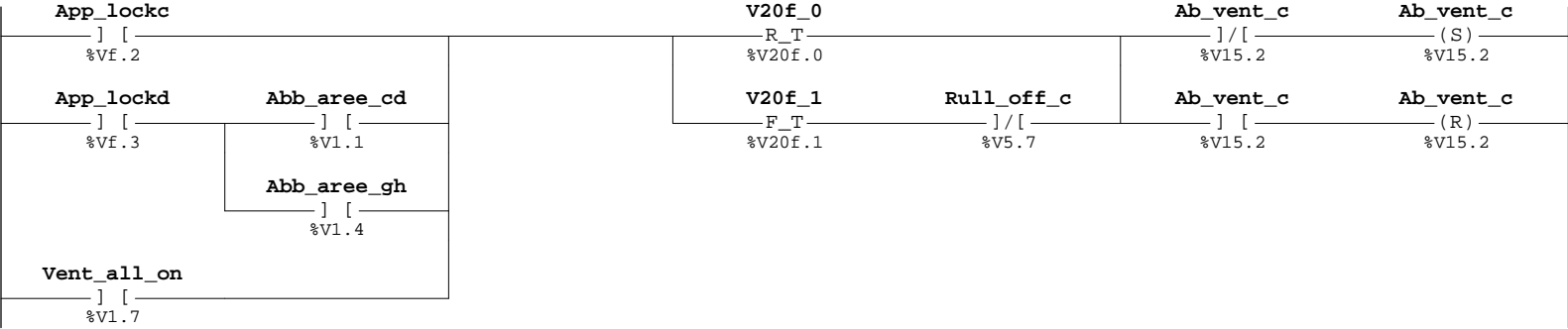


Mem. abilitazione ventose area B

Mem. abilitazione ventose area B

33 Label: Step:

Gestione ventose con rulliere controsagome area C e D

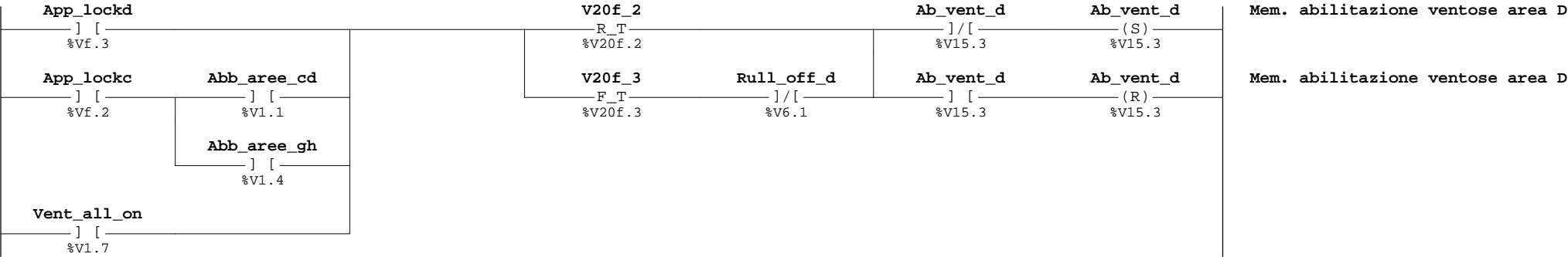


Mem. abilitazione ventose area C

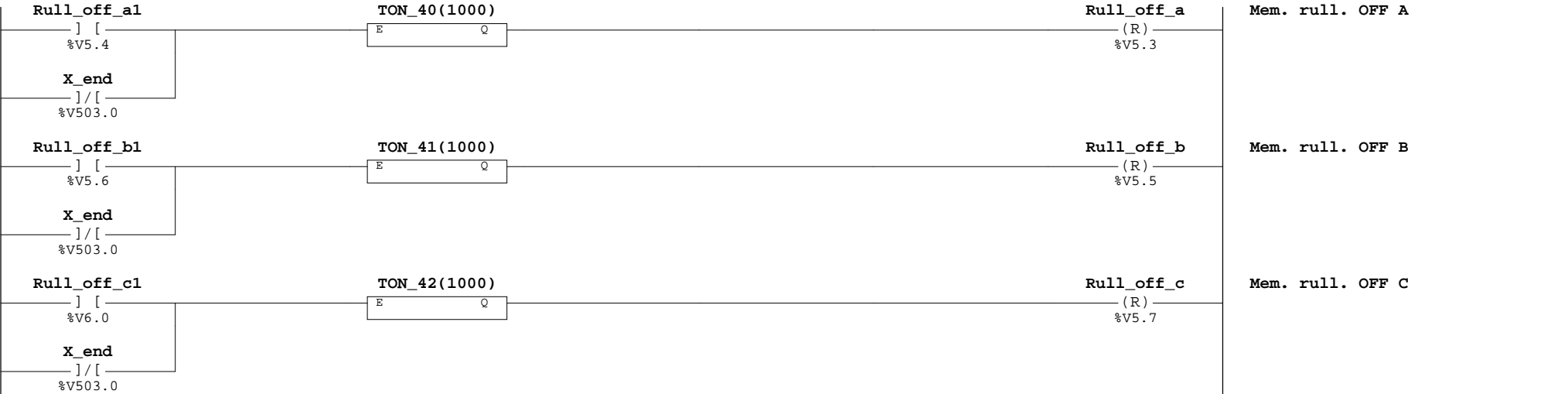
Mem. abilitazione ventose area C

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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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Company:			
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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)