```
Gen_em_cn
                                                                                                         Graf_tr12 = 0
        — ] [ —
                                                                                                            — (T)—
                                                                                                          %M42.W = 0x0
        %V1e.0
01 Label:
                  Step: Graf tr12 %M42.W = 0
    Graf_tr12 != 0
                                       TON_3a(600)
                                                                                                         Graf_tr12 = 0
        — 1> [ —
                                                                                                            — (T)—
     %M42.W != 0x0
                                                                                                          M42.W = 0x0
                                       TON_3b(200)
                                                                                                          Stop_r2_tr
                                                                                                                          Stop rapid 6 n.2 / Tool room pos
                                                                                                            — (R)-
                                                                                                            %Q4101.1
   [T] TON_3a(0x258) : TON_3a(600)
   [T] TON_3b(0xc8) : TON_3b(200)
02 Label:
                 Step: Graf_tr12 %M42.W = 0
           (1)
                                                          V210_0
                                                                                        Rich_tr12 > 12
                                                                                                         Rich_tr12 = 1
                         Ps_f6
                                          X_{end}
                                                                             (2)
                         —][—
                                          — ] / [ —
                                                          —R_T—
                                                                                           ___]>[____
                                                                                                         ——— (T)——
                        %V202b.3
                                          %V503.0
                                                          %V210.0
                                                                                         %M98.L > 0xc
                                                                                                         %M98.L = 0x1
                                                                                                         Graf tr12 = 1
                                                                                                           —— (T)——
                                                                                                          M42.W = 0x1
        M16 1
                    Rich_tr12 != Tr12_pos
                                                                                                         Graf_tr12 = 1
        _][_
                      ____]>[___
                                                                                                           —— (T)——
                     %M98.L != %M9c.L
                                                                                                          M42.W = 0x1
        %V610.0
        M12 1
                                                                                                         Graf_tr12 = 50
        — ] [ —
                                                                                                            — (T)—
                                                                                                          M42.W = 0x32
        %V60c.0
                                                                                                           goto(END)
                                                                                                            — (T) —
   (1) %I4101.3, %I4001.3, %I4100.7 : Setting, Pul_um1, Pul_um2
   (2) M98.L = M9c.L + 0x1 : Rich_tr12 = Tr12_pos + 1
```

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

Author:

Company:

00 Label:

Step:

```
Step: Graf_tr12 %M42.W = 1
03 Label:
                                                                    Ricerca direzione di rotazione magazzino
   Rich_{tr12} - Tr12_{pos} > 0
                                    Rich_tr12 - Tr12_pos < 6
                                                                                                         Direz_r2_tr
                                                                                                                         Direzione rapid 6 n.2 / Tool roo
       ___]>[____
                                       ____]>[____
                                                                                                            —(S)-
   M98.L - M9c.L > 0x0
                                     M98.L - M9c.L < 0x6
                                                                                                           %04101.0
   Rich_tr12 - Tr12_pos < 0
                                    Tr12_pos - Rich_tr12 >= 6
     ____]>[ _____
                                     ____]>[____
   M98.L - M9c.L < 0x0
                                    %M9c.L - %M98.L >= 0x6
   Rich_tr12 - Tr12_pos > 0
                                    Rich_tr12 - Tr12_pos >= 6
                                                                                                         Direz_r2_tr
                                                                                                                         Direzione rapid 6 n.2 / Tool roo
     — (R)—
   M98.L - M9c.L > 0x0
                                    %M98.L - %M9c.L >= 0x6
                                                                                                           %04101.0
   Rich_tr12 - Tr12_pos < 0
                                     Tr12_pos - Rich_tr12 < 6
                                      _____]>[____
   %M98.L - %M9c.L < 0x0
                                    M9c.L - M98.L < 0x6
                      TON_3b(200)
                                                                                                        Graf_tr12 = 2
                                                                                                          —— (T)—
                                                                                                         M42.W = 0x2
                                                                                                          goto(END)
                                                                                                           —— (T)—
   [T] TON_3b(0xc8) : TON_3b(200)
04 Label:
                  Step: Graf_tr12 %M42.W = 2
                                                                                                         Start r2 tr
                                                                                                                         Start rapid 6 n.2 / Tool room po
                                                                                                           — (S)—
                                                                                                           %04101.2
      Clock tr12
                                                                                                        Graf tr12 = 3
       — (T)—
       %I5100.0
                                                                                                         M42.W = 0x3
                                                                                                          goto(END)
                                                                                                            — (T) —
```

Company:		NOM	TOOLL	,
Project: 1040_78.mch	TITRE		Date	28-02-2018
Module: TR12_POS.XLA		%SP133 (03)	Page	2

NIIM TOOLS

Author:

```
Step: Graf_tr12 %M42.W = 3
                                                                                                              Start_r2_tr
                                                                                                                              Start rapid 6 n.2 / Tool room po
                                                                                                                 —(R)-
                                                                                                                %04101.2
      Direz r2 tr
                                                                                                             Tr12_pos += 1
        — ] [ —
                                                                                                               —— (T)——
        %Q4101.0
                                                                                                              M9c.L += 0x1
      Direz_r2_tr
                                                                                                             Tr12_pos -= 1
        — (T)—
        %Q4101.0
                                                                                                              %M9c.L -= 0x1
06 Label:
                   Step: Graf_tr12 %M42.W = 3
                                                                               Verifica posto magazzino
     Tr12_pos == 0
                                                                                                             Tr12_pos = 12
        ___]>[___
                                                                                                                — (T) —
                                                                                                              M9c.L = 0xc
      M9c.L == 0x0
     Tr12_pos == 13
                                                                                                             Tr12_pos = 1
      ____]>[____
                                                                                                               —— (T) ——
     %M9c.L == 0xd
                                                                                                              M9c.L = 0x1
                   Step: Graf_tr12 %M42.W = 3
07 Label:
                                                                             Controllo se raggiunto posto
    Tr12_pos != Rich_tr12
                                                                                                             Graf tr12 = 4
        ___ 1>[ ___
                                                                                                                — (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 \mid 0x2 : Out_41 = Out_41 | 2
   (2) write_q(0x4101, 0x1) : write_q(16641, 1)
```

Incremento memoria posto magazzino

Author:

05 Label:

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

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

Clock_tr12 	Graf_tr12
\$15100.U	617112.W -
	goto(EN

Author	:		NUM TOOLS		
Company	y:		NOM	тоопр	•
Project	: 1040_78.mch	TITRE		Date	28-02-2018
Module	: TR12_POS.XLA		%SP133 (08)	Page	4

Clock_tr12	Graf_tr12
]/[%I5100.0	(T)— %M42.W = 0
%1510U.U	%M42.W = U
	anto (FAT
	goto(END

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

Clock_tr12] [Graf_tr12 =(T)(T)
%15100.0	61742.W - 02
	goto(END
	(T)

Author:		NUM TOOLS		c c
Company:		NOM	тООП	5
Project: 1040_78.mch	TITRE		Date	28-02-2018
Module: TR12_POS.XLA		%SP133 (10)	Page	5

```
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 = 12
     Tr12_pos == 0
      ____]>[___
                                                                                                          —— (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		r. c
Company:		NOM	1001	1 5
Project: 1040_78.mch	TITRE		Date	28-02-2018
Module: TR12_POS.XLA		%SP133 (12)	Page	6

12 Label:

Step: $Graf_tr12$ %M42.W = 8

Clock_tr12	Graf_tr12 =
	(T)
%15100.0	
	goto(END)
	(T)

16 Label: Step: Graf_tr12 %M42.W = 10

Stop_r2_tr] [Clock_tr12	TON_3a(600)	### Graf_tr12 = 1 (T) *M42.W = 0xb
%Q4101.1	%I5100.0		\$M42.W = UXD
			goto(END)
			(T)

[T] $TON_3a(0x258)$: $TON_3a(600)$

Author:			NUM TOOLS		d
Company:			NOM	TOOL	5
Project: 104	0_78.mch	TITRE		Date	28-02-2018
Module: TR12	_POS.XLA		%SP133 (15)	Page	7

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 rapid 6 n.2 / Tool room po Start_r2_tr — (S) — %Q4101.2 Direz_r2_tr Direzione rapid 6 n.2 / Tool roo __(S)_ %Q4101.0 E40014 = 0— (T) — Wa38.L = 0x0Orig_tr12 $Graf_tr12 = 51$ —(T)— %15100.2 M42.W = 0x33goto(END) — (T) —

17 Label:

Step: **Graf_tr12** %M42.W = **11**

Author:

Company.				
Project: 1040_78.mch	TITRE		Date	28-02-2018
Module: TR12_POS.XLA		%SP133 (17)	Page	8
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NUM TOOLS

19 Label: Step: **Graf_tr12** %M42.W = **51** Clock_tr12 $Graf_tr12 = 52$ —][— *M42.W = 0x34 %I5100.0 goto(END) — (T) — 20 Label: Step: **Graf_tr12** %M42.W = **52** Start_r2_tr Start rapid 6 n.2 / Tool room po — (R) — %Q4101.2 Clock_tr12 $Graf_tr12 = 53$ —] / [— %I5100.0 goto(END) — (T) —

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Company:		NOM	TOOL	GI.
Project: 1040_78.mch	TITRE		Date	28-02-2018
Module: TR12_POS.XLA		%SP133 (19)	Page	9

Clock_tr12	Graf_tr12 =
	(T)
%15100.0	M42.W = 0x3
	goto(END)
	(T)
	(1)

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

Clock_tr12 	Graf_tr12 = 55 (T) %M42.₩ = 0x37
	goto(END)

Author:		NUM TOOLS		C
Company:		NOM	1001	סנ
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 Clock_tr12 $Graf_tr12 = 56$ —] [— *M42.W = 0x38 %15100.0 goto(END) — (T)— **24** Label: Step: **Graf_tr12** %M42.W = **56** (1) -(T)-(2) —(T)— TON_3a(600) $Graf_tr12 = 57$ —— (T)—— M42.W = 0x39goto(END) — (Т)— (1) $Q4101.B = Q4101.B \mid 0x2$: Out_41 = Out_41 | 2 (2) write_q(0x4101, 0x1) : write_q(16641, 1) [T] $TON_3a(0x258)$: $TON_3a(600)$

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Author:		NUM	TOOI	ַ <u>כ</u>
Company:		NOM	1001	10
Project: 1040_78.mch	TITRE		Date	28-02-2018
Module: TR12_POS.XLA		%SP133 (23)	Page	11

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

26 Label: END Step:

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