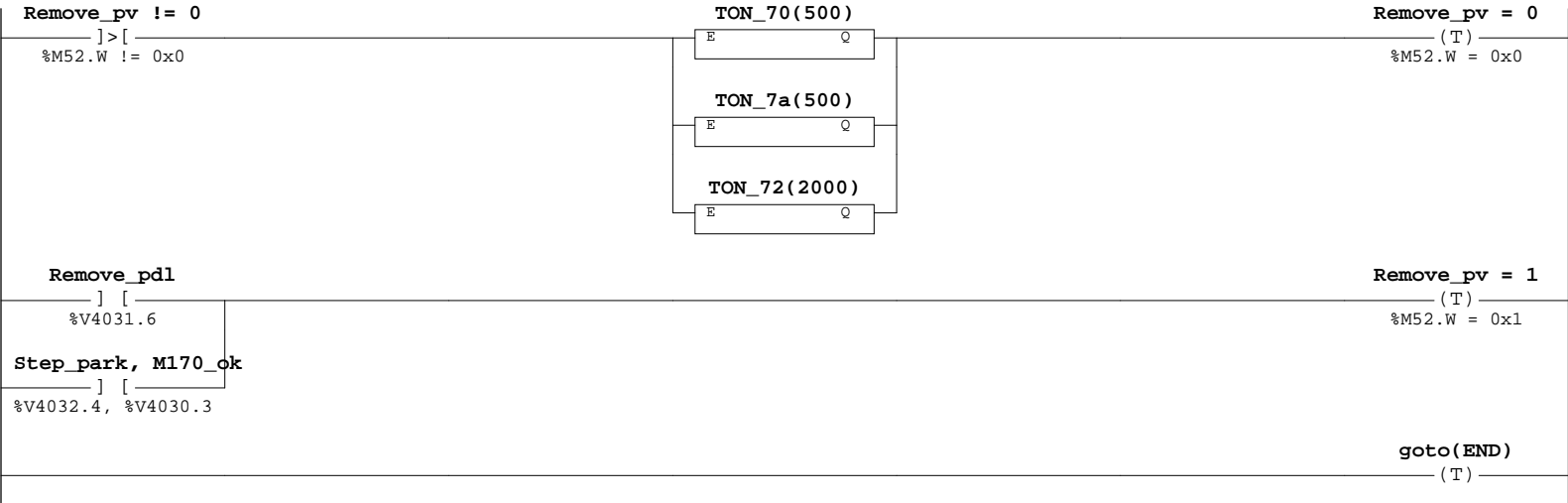
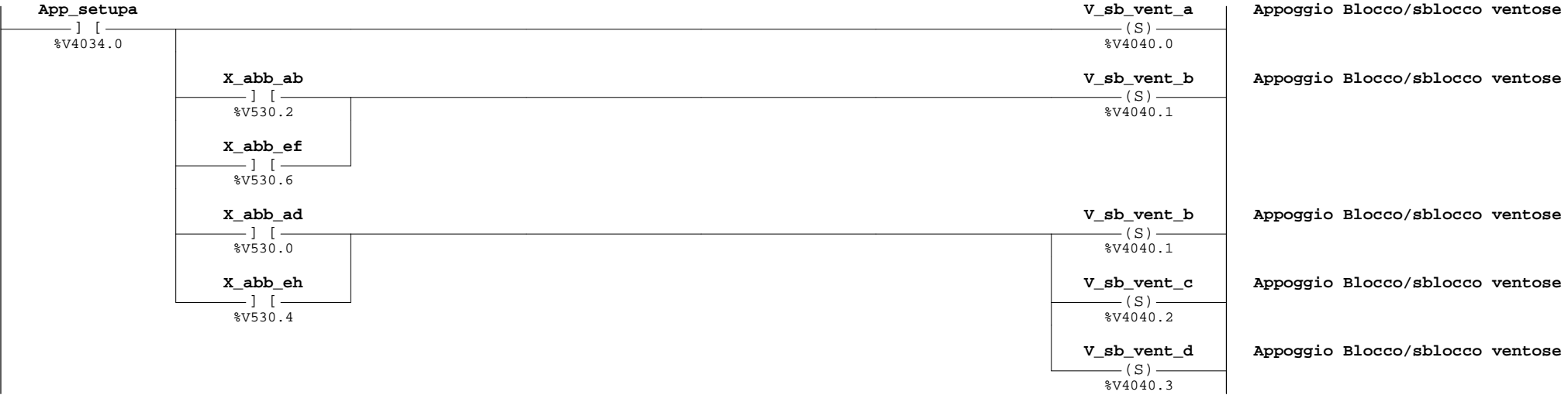


00 Label: Step: Remove_pv %M52.W = 0



[T] TON_70(0x1f4) : TON_70(500)
[T] TON_7a(0x1f4) : TON_7a(500)
[T] TON_72(0x7d0) : TON_72(2000)

01 Label: Step: Remove_pv %M52.W = 1



Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (00)	Page 1

02 Label: Step: Remove_pv %M52.W = 1

App_setupb		V_sb_vent_b	Appoggio Blocco/sblocco ventose
] [%V4034.1		(S) %V4040.1	
X_abb_ab		V_sb_vent_a	Appoggio Blocco/sblocco ventose
] [%V530.2		(S) %V4040.0	
X_abb_ef			
] [%V530.6			
App_setupc		V_sb_vent_c	Appoggio Blocco/sblocco ventose
] [%V4034.2		(S) %V4040.2	
X_abb_cd		V_sb_vent_d	Appoggio Blocco/sblocco ventose
] [%V530.1		(S) %V4040.3	
X_abb_gh			
] [%V530.5			

03 Label: Step: Remove_pv %M52.W = 1

App_setupd		V_sb_vent_d	Appoggio Blocco/sblocco ventose
] [%V4034.3		(S) %V4040.3	
X_abb_cd		V_sb_vent_c	Appoggio Blocco/sblocco ventose
] [%V530.1		(S) %V4040.2	
X_abb_gh			
] [%V530.5			
X_abb_ad		V_sb_vent_a	Appoggio Blocco/sblocco ventose
] [%V530.0		(S) %V4040.0	
X_abb_eh		V_sb_vent_b	Appoggio Blocco/sblocco ventose
] [%V530.4		(S) %V4040.1	
		V_sb_vent_c	Appoggio Blocco/sblocco ventose
		(S) %V4040.2	

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (02)	Page 2

04 Label: Step: Remove_pv %M52.W = 1

Index_10 = 0	Remove_pdl	
T	(R)	
%M1112.W = 0x0	%V4031.6	
Step_park, M170_ok	(1)	
]	(F)	
%V4032.4, %V4030.3		
	M1518 = Index_170	
	(T)	
	%M1518.W = %V402c.W	
	(2)	
	(T)	
	M170_ok	
	(R)	
	%V4030.3	
	Step_park	
	(R)	
	%V4032.4	

Start ciclo di parcheggio e rimo

lettura valore 170

fine posizionamento step PARCHEG

(1) %M1518.W = %V4038.W : M1518 = Index_remove
(2) %V402e.W = %M1518.W : Index_plc = M1518

05 Label: Step: Remove_pv %M52.W = 1

	Remove_pv = 10	
	(T)	
	%M52.W = 0xa	
	goto(END)	
	(T)	

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE		Date 28-02-2018
Module: REM_PV.XLA	%SP218 (04)		Page 3

06 Label: Step: Remove_pv %M52.W = 10

Tab_pm[M1518] == 167		Remove_pv = 11	
] > [(T)	
%V5000.L[%M1518.W] == 0xa7		%M52.W = 0xb	
Tab_pm[M1518] == 164		Remove	
] > [(S)	
%V5000.L[%M1518.W] == 0xa4		%V4033.4	
Tab_pm[M1518] == 168		V_sb_vent_a	Sb_vent_a
] > [(S)	
%V5000.L[%M1518.W] == 0xa8		%V4040.0	%Q5201.2
Tab_pm[M1518] == 999		V_sb_vent_b	Sb_vent_b
] > [(S)	
%V5000.L[%M1518.W] == 0x3e7		%V4040.1	%Q5201.3
		V_sb_vent_c	Sb_vent_c
		(S)	
		%V4040.2	%Q5201.4
		V_sb_vent_d	Sb_vent_d
		(S)	
		%V4040.3	%Q5201.5

bit MSG rimozione ventose

Blocco/sblocco ventose area A

Blocco/sblocco ventose area B

Blocco/sblocco ventose area C

Blocco/sblocco ventose area D

07 Label: Step: Remove_pv %M52.W = 10

Tab_pm[M1518] == 168		Ps_f5	M1518 = Index_remove	Remove_pv = 40	
] > [] [(T)	
%V5000.L[%M1518.W] == 0xa8		%V202b.2	%M1518.W = %V4038.W	%M52.W = 0x28	
Tab_pm[M1518] == 164				Remove	
] > [(R)	
%V5000.L[%M1518.W] == 0xa4				%V4033.4	
Tab_pm[M1518] == 999					
] > [
%V5000.L[%M1518.W] == 0x3e7					
(1)	(2)	(3)	Tab_pm[M1518] != 999	Alarm_pgm	
] > [] > [()	
		%V5000.L[%M1518.W] != 0x3e7		%V4031.5	
				Remove_pv = 99	
				(T)	
				%M52.W = 0x63	
				goto(END)	
				(T)	

bit MSG rimozione ventose

tentativo di posizionare una ven

- (1) %V5000.L[%M1518.W] != 0xa4 : Tab_pm[M1518] != 164
- (2) %V5000.L[%M1518.W] != 0xa7 : Tab_pm[M1518] != 167
- (3) %V5000.L[%M1518.W] != 0xa8 : Tab_pm[M1518] != 168

Author:			NUM TOOLS	
Company:				
Project: 1040_78.mch	TITRE		Date	28-02-2018
Module: REM_PV.XLA			%SP218 (06)	Page 4

08

Label: Q_RIT2

Step: Remove_pv

%M52.W

= 11

Indice ventosa o piano

M1518 = M1518 + 4

T

(1)

%M1518.W = %M1518.W + 0x4

(T)

(1) %M1514.W = %V5000.L[%M1518.W]

:

M1514 = Tab_pm[M1518]

09

Label:

Step: Remove_pv

%M52.W

= 11

Indice Motore

M1518 = M1518 + 4

T

(1)

%M1518.W = %M1518.W + 0x4

(T)

(1) %M1512.W = (%V5000.L[%M1518.W] - 0x1) * 0x10

:

M1512 = (Tab_pm[M1518] - 1) * 16

10

Label:

Step: Remove_pv

%M52.W

= 11

Indice Quota comandata

(1)

(T)

(1) %M1518.W = %M1518.W + 0x4

:

M1518 = M1518 + 4

11

Label:

Step: Remove_pv

%M52.W

= 11

index_1 = n° piano o ventosa

Index_1 = 10

Index_2 = 0

Index_8 = 0

T

T

(T)

%M1100.W = 0xa

%M1102.W = 0x0

%M110e.W = 0x0

12 Label: FASE11Step: Remove_pv%M52.W= 11

Predisposizione start Syncro (ritorno)

M1514 == Index_1	Tab_pm[M1518] != Piano_10[Index_8]	(1)
]>[(S)
%M1514.W == %M1100.W	%V5000.L[%M1518.W] != %M2010.L[%M110e.W]	
		Move_ok
		(S)
		%V4030.0
		goto(FASE11A)
		(T)
		Index_1 += 1
		(T)
		%M1100.W += 0x1
		Index_2 += 1
		(T)
		%M1102.W += 0x1
		Index_8 += 4
		(T)
		%M110e.W += 0x4

Predisposizione start motori

(1) %V7010.3[%M1512.W] : P_syncro_1[M1512]

13 Label:Step: Remove_pv%M52.W= 11

Index_1 > 126	Alarm_pgm	
]>[()
%M1100.W > 0x7e	%V4031.5	
		Remove_pv = 99
		(T)
		%M52.W = 0x63
Index_2 < 7	goto(FASE11)	
]>[(T)
%M1102.W < 0x7		
Index_2 == 7	Index_2 = 0	Index_1 += 3
]>[T T
%M1102.W == 0x7	%M1102.W = 0x0	%M1100.W += 0x3

tentativo di posizionare una ven

14 Label: FASE11AStep: Remove_pv%M52.W= 11

Assegnazione Quota comandata

Index_1 = 10	Index_2 = 0	Index_8 = 0
T	T	(T)
%M1100.W = 0xa	%M1102.W = 0x0	%M110e.W = 0x0

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (12)	Page 6

15 Label: FASE11B Step: Remove_pv %M52.W = 11

M1514 == Index_1	(1)
]>[(T)
%M1514.W == %M1100.W	goto(FASE11C)
	(T)
	Index_1 += 1
	(T)
	%M1100.W += 0x1
	Index_2 += 1
	(T)
	%M1102.W += 0x1
	Index_8 += 4
	(T)
	%M110e.W += 0x4

(1) %V7012.L[%M1512.W] = %M2010.L[%M110e.W] : Q_prog_1[M1512] = Piano_10[Index_8]

16 Label: Step: Remove_pv %M52.W = 11

Index_1 > 126	Alarm_pgm
]>[()
%M1100.W > 0x7e	%V4031.5
	Remove_pv = 99
	(T)
	%M52.W = 0x63
Index_2 < 7	goto(FASE11B)
]>[(T)
%M1102.W < 0x7	
Index_2 == 7	Index_2 = 0
]>[Index_1 += 3
%M1102.W == 0x7	(T) (T)
	%M1102.W = 0x0 %M1100.W += 0x3

tentativo di posizionare una ven

17 Label: FASE11C Step: Remove_pv %M52.W = 11

	(1)
	(T)

(1) %M1518.W = %M1518.W + 0x4 : M1518 = M1518 + 4

Indice velocità

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (15)	Page 7

18 Label:Step: Remove_pv%M52.W= 11

Assegnazione Velocità

(1)
(T)

(1) %V7016.W[%M1512.W] = %V4400.L : Feed_1[M1512] = Velocita

19 Label:Step: Remove_pv%M52.W= 11

(1)
(T)

(1) %M1518.W = %M1518.W + 0x8 : M1518 = M1518 + 8

20 Label:Step: Remove_pv%M52.W= 11

Verifica indice

Tab_pm[M1518] == 167

goto(Q_RIT2)

]

[

%V5000.L[%M1518.W] == 0xa7

Tab_pm[M1518] == 170

Index_170 = M1518 + 4

M170_ok

]

[

%V5000.L[%M1518.W] == 0xaa

T

%V402c.W = %M1518.W + 0x4

%V4030.3

Remove_pv = 12

(T)

%M52.W = 0xc

(1)

Tab_pm[M1518] != 170

]

[

%V5000.L[%M1518.W] != 0xaa

()

%V4031.5

Remove_pv = 99

(T)

%M52.W = 0x63

goto(END)

(T)

lettura valore 170

tentativo di posizionare una ven

(1) %V5000.L[%M1518.W] != 0xa7 : Tab_pm[M1518] != 167

21 Label: Step: Remove_pv %M52.W = 12

Reset dispositivo di aggancio

	Cil_std = 0	
	(T)	
	%Q5200.B = 0x0	
	Cil_pdl_ab	
	(R)	
	%Q5201.0	
	Cil_pdl_cd	
	(R)	
	%Q5201.1	
	Cil_add = 0	
	(T)	
	%Q5400.B = 0x0	

Abil. cilindro aggancio area AB

Abil. cilindro aggancio area CD

22 Label: Step: Remove_pv %M52.W = 12

Start asse n..... se predisposto e posiz. pistone a quota corr.

(1)	Pdl_ab	Pdl_cd	Vent_pdl_add == 0	Start_move	
>[]/[]/[>[(S)	
	%I5201.0	%I5201.1	%I5400.B == 0x0	%V4030.7	
				Remove_pv = 13	
				(T)	
				%M52.W = 0xd	
				goto(END)	
				(T)	

start movimentazione motori

(1) %I5200.B == 0x0 : Vent_pdl_std == 0

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE		Date 28-02-2018
Module: REM_PV.XLA	%SP218 (21)		Page 9

23 Label: Step: Remove_pv %M52.W = 13

End_move	End_move	movimentazione motori eseguita
]	(R)	
%V4031.0	%V4031.0	
	Sb_pdl_ab	sblocco pdl area AB
	(R)	
	%Q5201.6	sblocco pdl area CD
	Sb_pdl_cd	
	(R)	
	%Q5201.7	
	Remove_pv = 20	
	(T)	
	%M52.W = 0x14	
	goto(END)	
	(T)	

24 Label: Step: Remove_pv %M52.W = 20

	Index_2 = 0	Remove_pv = 21
	T	(T)
	%M1102.W = 0x0	%M52.W = 0x15
		goto(END)
		(T)

25 Label: Step: Remove_pv %M52.W = 21

Indice di Spaziamento

	(1)
	(T)
	Remove_pv = 22
	(T)
	%M52.W = 0x16
	goto(END)
	(T)

(1) %M1518.W = %V402e.W : M1518 = Index_plc

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (23)	Page 10

26 Label: Step: Remove_pv %M52.W = 22

Tab_pm[M1518] == 167	Remove_pv = 23	
] <u>[</u>	(T)	
%V5000.L[%M1518.W] == 0xa7	%M52.W = 0x17	
Tab_pm[M1518] != 167	Alarm_pgm	tentativo di posizionare una ven
] <u>[</u>	()	
%V5000.L[%M1518.W] != 0xa7	%V4031.5	
	Remove_pv = 99	
	(T)	
	%M52.W = 0x63	
	goto(END)	
	(T)	

27 Label: Q_SETUP2 Step: Remove_pv %M52.W = 23

Indice ventosa o piano

M1518 = M1518 + 4	(1)	
T	(T)	
%M1518.W = %M1518.W + 0x4		
(1) %M1514.W = %V5000.L[%M1518.W] : M1514 = Tab_pm[M1518]		

28 Label: Step: Remove_pv %M52.W = 23

Appoggio su V4000 piano e ventose PGM

	(1)	
	(T)	
	Index_10 += 1	
	(T)	
	%M1112.W += 0x1	
(1) %V4000.B[%M1112.W] = %M1514.W : V4000[Index_10] = M1514		

29 Label: Step: Remove_pv %M52.W = 23

Indice Motore

M1518 = M1518 + 4	(1)	
T	(T)	
%M1518.W = %M1518.W + 0x4		
(1) %M1512.W = (%V5000.L[%M1518.W] - 0x1) * 0x10 : M1512 = (Tab_pm[M1518] - 1) * 16		

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (26)	Page 11

Indice Quota comandata

```
(1) %M1518.W = %M1518.W + 0x4      :      M1518 = M1518 + 4
```

```
31 Label:          Step: Remove_pv    %M52.W    = 23
```

Index_1 = 10	Index_2 = 0	Index_3 = 0	Index_8 = 0
T	T	T	(T)
%M1100.W = 0xa	%M1102.W = 0x0	%M1104.W = 0x0	%M110e.W = 0x0

```
32 Label: FASE23      Step: Remove_pv    %M52.W      = 23
```

M1514 == Index_1]>[Tab_pm[M1518] != Piano_10[Index_8]]>[(1) (S)
%M1514.W == %M1100.W	%V5000.L[%M1518.W] != %M2010.L[%M110e.W]	Sincro_10[Index_3] (S) %V4500.3[%M1104.W] Move_ok (S) %V4030.0 goto(FASE23A) (T)

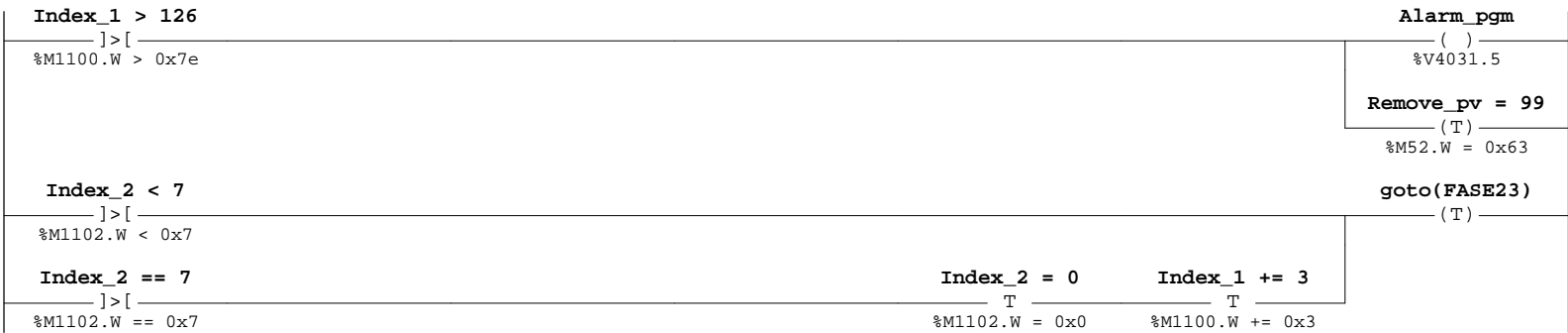
```
(1) %V7010.3[%M1512.W]      :    P_syncro_1[M1512]
```

```
33 Label:                Step: Remove_pv    %M52.W      = 23
```

	Index_1 += 1 (T)
	%M1100.W += 0x1
	Index_3 += 1 (T)
	%M1104.W += 0x1
	Index_2 += 1 (T)
	%M1102.W += 0x1
	Index_8 += 4 (T)
	%M110e.W += 0x4

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (30)	Page 12

34 Label: Step: Remove_pv %M52.W = 23

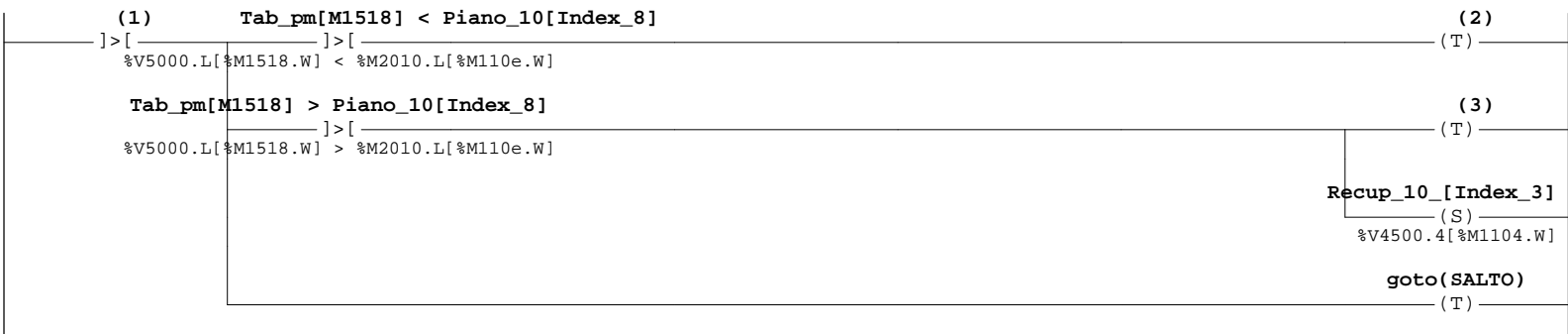


tentativo di posizionare una ven

35 Label: FASE23A Step: Remove_pv %M52.W = 23



36 Label: FASE23B Step: Remove_pv %M52.W = 23



(1) %M1514.W == %M1100.W : M1514 == Index_1

(2) %V7012.L[%M1512.W] = %V5000.L[%M1518.W] - %V1290.B[%M1104.W] : Q_prog_1[M1512] = Tab_pm[M1518] - Tab_asola[Index_3]

(3) %V7012.L[%M1512.W] = %V5000.L[%M1518.W] + %V1290.B[%M1104.W] : Q_prog_1[M1512] = Tab_pm[M1518] + Tab_asola[Index_3]

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (34)	Page 13

37 Label: Step: Remove_pv %M52.W = 23

	Index_1 += 1
	(T)
	%M1100.W += 0x1
	Index_2 += 1
	(T)
	%M1102.W += 0x1
	Index_3 += 1
	(T)
	%M1104.W += 0x1
	Index_8 += 4
	(T)
	%M110e.W += 0x4

38 Label: Step: Remove_pv %M52.W = 23

Index_1 > 126	Alarm_pgm	
]>[()	
%M1100.W > 0x7e	%V4031.5	tentativo di posizionare una ven
	Remove_pv = 99	
	(T)	
	%M52.W = 0x63	
Index_2 < 7	goto(FASE23B)	
]>[(T)	
%M1102.W < 0x7		
Index_2 == 7	Index_2 = 0	Index_1 += 3
]>[T	T
%M1102.W == 0x7	%M1102.W = 0x0	%M1100.W += 0x3

39 Label: SALTO Step: Remove_pv %M52.W = 23

Indice velocità
(1)
(T)

(1) %M1518.W = %M1518.W + 0x4 : M1518 = M1518 + 4

40 Label: Step: Remove_pv %M52.W = 23

Assegnazione Velocità
(1)
(T)

(1) %V7016.W[%M1512.W] = %V4400.L : Feed_1[M1512] = Velocita

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (37)	Page 14

41 Label:	Step: Remove_pv	%M52.W	= 23	incremento indice
				(1) (T)

(1) %M1518.W = %M1518.W + 0x8 : M1518 = M1518 + 8

42 Label:	Step: Remove_pv	%M52.W	= 23	Verifica indice
Tab_pm[M1518] == 167				goto(Q_SETUP2) (T)
%V5000.L[%M1518.W] == 0xa7				
Tab_pm[M1518] == 170				V4000[Index_10] = 127 Remove_pv = 24 (T)
%V5000.L[%M1518.W] == 0xaa				%M52.W = 0x18
(1) Tab_pm[M1518] != 170				Alarm_pgm ()
%V5000.L[%M1518.W] != 0xaa				%V4031.5
				Remove_pv = 99 (T)
				%M52.W = 0x63
				goto(END) (T)

tentativo di posizionare una ven

(1) %V5000.L[%M1518.W] != 0xa7 : Tab_pm[M1518] != 167

43 Label:	Step: Remove_pv	%M52.W	= 24	
P_syncro_1	Pistab_no_ok			Cil_pdl_ab
%V7010.3		%V4561.4		(S) %Q5201.0
	Pistab_no_ok			Cil_pdl_ab
		%V4561.4		(R) %Q5201.0
P_syncro_2	Pistcd_no_ok			Cil_pdl_cd
%V7020.3		%V4561.5		(S) %Q5201.1
	Pistcd_no_ok			Cil_pdl_cd
		%V4561.5		(R) %Q5201.1

Abil. cilindro aggancio area AB

Abil. cilindro aggancio area AB

Abil. cilindro aggancio area CD

Abil. cilindro aggancio area CD

Author:			NUM TOOLS	
Company:				
Project: 1040_78.mch	TITRE		Date	28-02-2018
Module: REM_PV.XLA	%SP218 (41)		Page	15

44 Label: Step: Remove_pv %M52.W = 24

P_syncro_3	Pist1_no_ok	Cil_pdl_1	Abil. cilindro aggancio ventose
]]/[(S)	
%V7030.3	%V4560.0	%Q5200.0	
	Pist1_no_ok	Cil_pdl_1	Abil. cilindro aggancio ventose
]	(R)	
	%V4560.0	%Q5200.0	
P_syncro_4	Pist2_no_ok	Cil_pdl_2	Abil. cilindro aggancio ventose
]]/[(S)	
%V7040.3	%V4560.1	%Q5200.1	
	Pist2_no_ok	Cil_pdl_2	Abil. cilindro aggancio ventose
]	(R)	
	%V4560.1	%Q5200.1	
P_syncro_5	Pist3_no_ok	Cil_pdl_3	Abil. cilindro aggancio ventose
]]/[(S)	
%V7050.3	%V4560.2	%Q5200.2	
	Pist3_no_ok	Cil_pdl_3	Abil. cilindro aggancio ventose
]	(R)	
	%V4560.2	%Q5200.2	

45 Label: Step: Remove_pv %M52.W = 24

P_syncro_6	Pist4_no_ok	Cil_pdl_4	Abil. cilindro aggancio ventose
]]/[(S)	
%V7060.3	%V4560.3	%Q5200.3	
	Pist4_no_ok	Cil_pdl_4	Abil. cilindro aggancio ventose
]	(R)	
	%V4560.3	%Q5200.3	
P_syncro_7	Pist5_no_ok	Cil_pdl_5	Abil. cilindro aggancio ventose
]]/[(S)	
%V7070.3	%V4560.4	%Q5200.4	
	Pist5_no_ok	Cil_pdl_5	Abil. cilindro aggancio ventose
]	(R)	
	%V4560.4	%Q5200.4	
P_syncro_8	Pist6_no_ok	Cil_pdl_6	Abil. cilindro aggancio ventose
]]/[(S)	
%V7080.3	%V4560.5	%Q5200.5	
	Pist6_no_ok	Cil_pdl_6	Abil. cilindro aggancio ventose
]	(R)	
	%V4560.5	%Q5200.5	

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (44)	Page 16

46 Label: Step: Remove_pv %M52.W = 24

P_syncro_9	Pist7_no_ok	Cil_pdl_7	Abil. cilindro aggancio ventose
]]/[(S)	
%V7090.3	%V4560.6	%Q5200.6	
	Pist7_no_ok	Cil_pdl_7	Abil. cilindro aggancio ventose
]	(R)	
	%V4560.6	%Q5200.6	
P_syncro_10	Pist8_no_ok	Cil_pdl_8	Abil. cilindro aggancio ventose
]]/[(S)	
%V70a0.3	%V4560.7	%Q5200.7	
	Pist8_no_ok	Cil_pdl_8	Abil. cilindro aggancio ventose
]	(R)	
	%V4560.7	%Q5200.7	
P_syncro_11	Pist9_no_ok	Cil_pdl_9	Abil. cilindro aggancio ventose
]]/[(S)	
%V70b0.3	%V4561.0	%Q5400.0	
	Pist9_no_ok	Cil_pdl_9	Abil. cilindro aggancio ventose
]	(R)	
	%V4561.0	%Q5400.0	

47 Label: Step: Remove_pv %M52.W = 24

P_syncro_12	Pist10_no_ok	Cil_pdl_10	Abil. cilindro aggancio ventose
]]/[(S)	
%V70c0.3	%V4561.1	%Q5400.1	
	Pist10_no_ok	Cil_pdl_10	Abil. cilindro aggancio ventose
]	(R)	
	%V4561.1	%Q5400.1	
P_syncro_13	Pist11_no_ok	Cil_pdl_11	Abil. cilindro aggancio ventose
]]/[(S)	
%V70d0.3	%V4561.2	%Q5400.2	
	Pist11_no_ok	Cil_pdl_11	Abil. cilindro aggancio ventose
]	(R)	
	%V4561.2	%Q5400.2	
P_syncro_14	Pist12_no_ok	Cil_pdl_12	Abil. cilindro aggancio ventose
]]/[(S)	
%V70e0.3	%V4561.3	%Q5400.3	
	Pist12_no_ok	Cil_pdl_12	Abil. cilindro aggancio ventose
]	(R)	
	%V4561.3	%Q5400.3	

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (46)	Page 17

48 Label: Step: Remove_pv %M52.W = 24

<div>Vent_pdl_1</div> <div><div><div></div><div></div></div><div>%I5200.0</div></div>	<div>Vent_pdl_2</div> <div><div><div></div><div></div></div><div>%I5200.1</div></div>	<div>Vent_pdl_3</div> <div><div><div></div><div></div></div><div>%I5200.2</div></div>	<div>Vent_pdl_4</div> <div><div><div></div><div></div></div><div>%I5200.3</div></div>	<div>Vent_pdl_5</div> <div><div><div></div><div></div></div><div>%I5200.4</div></div>	<div>Vent_pdl_6</div> <div><div><div></div><div></div></div><div>%I5200.5</div></div>	<div>Input_1_6</div> <div><div><div></div><div></div></div><div>%V4033.1</div></div>
<div>Cil_pdl_1</div> <div><div><div></div><div></div></div><div>%Q5200.0</div></div>	<div>Cil_pdl_2</div> <div><div><div></div><div></div></div><div>%Q5200.1</div></div>	<div>Cil_pdl_3</div> <div><div><div></div><div></div></div><div>%Q5200.2</div></div>	<div>Cil_pdl_4</div> <div><div><div></div><div></div></div><div>%Q5200.3</div></div>	<div>Cil_pdl_5</div> <div><div><div></div><div></div></div><div>%Q5200.4</div></div>	<div>Cil_pdl_6</div> <div><div><div></div><div></div></div><div>%Q5200.5</div></div>	
<div>Vent_pdl_7</div> <div><div><div></div><div></div></div><div>%I5200.6</div></div>	<div>Vent_pdl_8</div> <div><div><div></div><div></div></div><div>%I5200.7</div></div>	<div>Vent_pdl_9</div> <div><div><div></div><div></div></div><div>%I5400.0</div></div>	<div>Vent_pdl_10</div> <div><div><div></div><div></div></div><div>%I5400.1</div></div>	<div>Vent_pdl_11</div> <div><div><div></div><div></div></div><div>%I5400.2</div></div>	<div>Vent_pdl_12</div> <div><div><div></div><div></div></div><div>%I5400.3</div></div>	<div>Input_7_12</div> <div><div><div></div><div></div></div><div>%V4033.2</div></div>
<div>Cil_pdl_7</div> <div><div><div></div><div></div></div><div>%Q5200.6</div></div>	<div>Cil_pdl_8</div> <div><div><div></div><div></div></div><div>%Q5200.7</div></div>	<div>Cil_pdl_9</div> <div><div><div></div><div></div></div><div>%Q5400.0</div></div>	<div>Cil_pdl_10</div> <div><div><div></div><div></div></div><div>%Q5400.1</div></div>	<div>Cil_pdl_11</div> <div><div><div></div><div></div></div><div>%Q5400.2</div></div>	<div>Cil_pdl_12</div> <div><div><div></div><div></div></div><div>%Q5400.3</div></div>	
<div>Pdl_ab</div> <div><div><div></div><div></div></div><div>%I5201.0</div></div>	<div>Pdl_cd</div> <div><div><div></div><div></div></div><div>%I5201.1</div></div>					<div>Input_ab_cd</div> <div><div><div></div><div></div></div><div>%V4033.3</div></div>
<div>Cil_pdl_ab</div> <div><div><div></div><div></div></div><div>%Q5201.0</div></div>	<div>Cil_pdl_cd</div> <div><div><div></div><div></div></div><div>%Q5201.1</div></div>					

input pistoncini ventose: piani

input pistoncini ventose: piani

input pistoncini piani area AB,

49 Label: Step: Remove_pv %M52.W = 24

<div>Fine_tent</div> <div><div><div></div><div></div></div><div>%V4562.0</div></div>						<div>Time_agg</div> <div><div><div></div><div></div></div><div>%V4033.6</div></div>
<div>Time_agg</div> <div><div><div></div><div></div></div><div>%V4033.6</div></div>	<div>Fine_tent</div> <div><div><div></div><div></div></div><div>%V4562.0</div></div>	<div>Input_1_6</div> <div><div><div></div><div></div></div><div>%V4033.1</div></div>	<div>Input_7_12</div> <div><div><div></div><div></div></div><div>%V4033.2</div></div>	<div>Input_ab_cd</div> <div><div><div></div><div></div></div><div>%V4033.3</div></div>	<div>TON_72(2000)</div> <div><div><div></div><div></div></div><div>E</div><div>Q</div></div>	<div>Ps_ledf4</div> <div><div><div></div><div></div></div><div>%V200c.5</div></div>
<div>(1)</div> <div><div><div></div><div></div></div><div></div></div>	<div>T_in_corso</div> <div><div><div></div><div></div></div><div>%V4562.1</div></div>	<div>Fine_tent</div> <div><div><div></div><div></div></div><div>%V4562.0</div></div>	<div>TON_70(500)</div> <div><div><div></div><div></div></div><div>E</div><div>Q</div></div>	<div>Time_agg</div> <div><div><div></div><div></div></div><div>%V4033.6</div></div>	<div>Remove_pv = 25</div> <div><div><div></div><div></div></div><div>%M52.W = 0x19</div></div>	
				<div>Ps_f4</div> <div><div><div></div><div></div></div><div>%V202a.6</div></div>	<div>Ps_ledf4</div> <div><div><div></div><div></div></div><div>%V200c.5</div></div>	<div>Time_agg</div> <div><div><div></div><div></div></div><div>%V4033.6</div></div>
						<div>Ps_ledf4</div> <div><div><div></div><div></div></div><div>%V200c.5</div></div>
						<div>goto(END)</div> <div><div><div></div><div></div></div><div></div></div>

bit per timer di attesa aggancio

Led tasto F4

bit per timer di attesa aggancio

Led tasto F4

(1) %V4033.1, %V4033.2, %V4033.3 : Input_1_6, Input_7_12, Input_ab_cd
[T] TON_72(0x7d0) : TON_72(2000)
[T] TON_70(0x1f4) : TON_70(500)

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (48)	Page 18

50 Label: Step: Remove_pv %M52.W = 25

	Input_1_6	input pistoncini ventose: piani
	(R)	
	%V4033.1	
	Input_7_12	input pistoncini ventose: piani
	(R)	
	%V4033.2	
	Input_ab_cd	input pistoncini piani area AB,
	(R)	
	%V4033.3	
	Fine_tent	
	(R)	
	%V4562.0	
	Agg_ok	
	(R)	
	%V4562.3	

51 Label: Step: Remove_pv %M52.W = 25

Sb_vent_a	V_b1_ab	Sb_vent_b	V_b1_b	Check_ab	verifica sblocco avvenuto area A
]	[]	[()	
%Q5201.2	%I4000.2	%Q5201.3	%I5201.6	%V4032.5	
Sb_vent_a		Sb_vent_b			
]/[]/[
%Q5201.2		%Q5201.3			
Sb_vent_c	V_b1_c	Sb_vent_d	V_b1_cd	Check_cd	verifica sblocco avvenuto area C
]	[]	[()	
%Q5201.4	%I5201.7	%Q5201.5	%I4000.3	%V4032.6	
Sb_vent_c		Sb_vent_d			
]/[]/[
%Q5201.4		%Q5201.5			

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (50)	Page 19

52 Label: Step: Remove_pv %M52.W = 25

Start asse n..... se predisposto e pos. a quota programma

Check_ab	Check_cd	Start_move	
—] [—	—] [—	(S) —	
%V4032.5	%V4032.6	%V4030.7	
		Check_ab	
		(R) —	
		%V4032.5	
		Check_cd	
		(R) —	
		%V4032.6	
		Remove_pv = 26	
		(T) —	
		%M52.W = 0x1a	
		goto(END)	
		(T) —	

start movimentazione motori

verifica sblocco avvenuto area A

verifica sblocco avvenuto area C

53 Label: Step: Remove_pv %M52.W = 26

		Movimento_pv	
		(S) —	
		%V4032.0	
End_move	Index_6 = 0	End_move	
—] [—	— T —	(R) —	
%V4031.0	%M110a.W = 0x0	%V4031.0	
		Index_2 = 0	
		(T) —	
		%M1102.W = 0x0	
		Remove_pv = 31	
		(T) —	
		%M52.W = 0x1f	
		goto(END)	
		(T) —	

piani o ventose in movimento

movimentazione motori eseguita

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (52)	Page 20

54 Label: **RESET** Step: **Remove_pv** %M52.W = 31

Index_6 < 84	(1)
]>[(R)
%M110a.W < 0x54	
	Index_6 += 1
	(T)
	%M110a.W += 0x1
	goto(RESET)
	(T)

(1) %V4500.3[%M110a.W] : Sincro_10_[Index_6]

55 Label: Step: **Remove_pv** %M52.W = 31

indice di spaziamiento

Index_10 = 0	(1)
T	(T)
%M1112.W = 0x0	
	Sb_pdl_ab
	(R)
	%Q5201.6
	Sb_pdl_cd
	(R)
	%Q5201.7
	Remove_pv = 32
	(T)
	%M52.W = 0x20
	goto(END)
	(T)

sblocco pdl area AB

sblocco pdl area CD

(1) %M1518.W = %V402e.W : M1518 = Index_plc

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (54)	Page 21

56 Label: Step: Remove_pv %M52.W = 32

Tab_pm[M1518] == 167	Remove_pv = 33	
]>[(T)	
%V5000.L[%M1518.W] == 0xa7	%M52.W = 0x21	
Tab_pm[M1518] != 167	Alarm_pgm	tentativo di posizionare una ven
]>[()	
%V5000.L[%M1518.W] != 0xa7	%V4031.5	
	Remove_pv = 99	
	(T)	
	%M52.W = 0x63	
	goto(END)	
	(T)	

57 Label: M_CORR2 Step: Remove_pv %M52.W = 33

M1518 = M1518 + 4	(1)	
T	(T)	
%M1518.W = %M1518.W + 0x4		
(1) %M1514.W = %V5000.L[%M1518.W] : M1514 = Tab_pm[M1518]		

58 Label: Step: Remove_pv %M52.W = 33

Index_1 = 10	Index_2 = 0	Index_3 = 0	Index_8 = 0
T	T	T	(T)
%M1100.W = 0xa	%M1102.W = 0x0	%M1104.W = 0x0	%M110e.W = 0x0

59 Label: Step: Remove_pv %M52.W = 33

indice quota comandata	
(1)	
(T)	
(1) %M1518.W = %M1518.W + 0x8 : M1518 = M1518 + 8	

60 Label: FASE33 Step: Remove_pv %M52.W = 33

Index_1 == M1514	Index_10 += 1	(1)
]>[T	(T)
%M1100.W == %M1514.W	%M1112.W += 0x1	
	goto(FASE33A)	
	(T)	
(1) %M2010.L[%M110e.W] = %V5000.L[%M1518.W] : Piano_10[Index_8] = Tab_pm[M1518]		

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (56)	Page 22

61 Label: Step: Remove_pv %M52.W = 33

	Index_1 += 1
	(T)
	%M1100.W += 0x1
	Index_2 += 1
	(T)
	%M1102.W += 0x1
	Index_3 += 1
	(T)
	%M1104.W += 0x1
	Index_8 += 4
	(T)
	%M110e.W += 0x4

62 Label: Step: Remove_pv %M52.W = 33

Index_1 > 126	Alarm_pgm	
]>[()	
%M1100.W > 0x7e	%V4031.5	
	Remove_pv = 99	
	(T)	
	%M52.W = 0x63	
Index_2 < 7	goto(FASE33)	
]>[(T)	
%M1102.W < 0x7		
Index_2 == 7	Index_2 = 0	Index_1 += 3
]>[T	T
%M1102.W == 0x7	%M1102.W = 0x0	%M1100.W += 0x3

tentativo di posizionare una ven

63 Label: FASE33A Step: Remove_pv %M52.W = 33

	(1)
	(T)

(1) %M1518.W = %M1518.W + 0xc : M1518 = M1518 + 12

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (61)	Page 23

64 Label: Step: Remove_pv %M52.W = 33

Tab_pm[M1518] == 167	goto(M_CORR2)
]>[(T)
%V5000.L[%M1518.W] == 0xa7	
Tab_pm[M1518] == 170	Remove_pv = 34
]>[(T)
%V5000.L[%M1518.W] == 0xaa	%M52.W = 0x22
(1) Tab_pm[M1518] != 170	Alarm_pgm
]>[()
%V5000.L[%M1518.W] != 0xaa	%V4031.5
	Remove_pv = 99
	(T)
	%M52.W = 0x63
	goto(END)
	(T)

tentativo di posizionare una ven

(1) %V5000.L[%M1518.W] != 0xa7 : Tab_pm[M1518] != 167

65 Label: Step: Remove_pv %M52.W = 34

	Movimento_pv
	(R)
	%V4032.0
Cil_std = 0	Cil_add = 0
T	(T)
%Q5200.B = 0x0	%Q5400.B = 0x0
	Cil_pdl_ab
	(R)
	%Q5201.0
	Cil_pdl_cd
	(R)
	%Q5201.1

piani o ventose in movimento

Abil. cilindro aggancio area AB

Abil. cilindro aggancio area CD

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (64)	Page 24


```
66 Label:          Step: Remove_pv    %M52.W    = 34
```

(1)	(2)	Pd1_ab, Pd1_cd	TON_7a(500)	Remove_pv = 35	
]>[E	(T)	
%I5201.0, %I5201.1			Q	%M52.W = 0x23	
				Sb_vent_a	Blocco/sblocco ventose area A
				(R)	
				%Q5201.2	
				Sb_vent_b	Blocco/sblocco ventose area B
				(R)	
				%Q5201.3	
				Sb_vent_c	Blocco/sblocco ventose area C
				(R)	
				%Q5201.4	
				Sb_vent_d	Blocco/sblocco ventose area D
				(R)	
				%Q5201.5	
				goto(END)	
				(T)	

```
(1) %I5200.B == 0x0      : Vent_pdl_std == 0
(2) %I5400.B == 0x0      : Vent_pdl_add == 0
[T] TON_7a(0x1f4)       : TON_7a(500)
```

67 Label: Step: Remove_pv %M52.W = 35

	Step_park	fine posizionamento step PARCHEGGIO
	(S)	
	%V4032.4	
	Remove_pv = 0	
	(T)	
	%M52.W = 0x0	
	goto(END)	
	(T)	

68 Label: M_CORRF5 Step: Remove_pv %M52.W = 40

M1518 = M1518 + 4	(1)
T	(T)
%M1518.W = %M1518.W + 0x4	
	B_sb_vent = 0
	(T)
	%V4040.B = 0x0

```
(1) %M1514.W = %V5000.L[%M1518.W]      :      M1514 = Tab_pm[M1518]
```

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (66)	Page 25

69 Label: Step: Remove_pv %M52.W = 40

Index_1 = 10	Index_2 = 0	Index_3 = 0	Index_8 = 0
(T)	(T)	(T)	(T)
%M1100.W = 0xa	%M1102.W = 0x0	%M1104.W = 0x0	%M110e.W = 0x0
			Sb_vent_a
			(R)
			%Q5201.2
			Sb_vent_b
			(R)
			%Q5201.3
			Sb_vent_c
			(R)
			%Q5201.4
			Sb_vent_d
			(R)
			%Q5201.5

Blocco/sblocco ventose area A

Blocco/sblocco ventose area B

Blocco/sblocco ventose area C

Blocco/sblocco ventose area D

70 Label: Step: Remove_pv %M52.W = 40

Indice quota di prelievo

(1)
(T)

(1) %M1518.W = %M1518.W + 0x10 : M1518 = M1518 + 16

71 Label: FASE40 Step: Remove_pv %M52.W = 40

Index_1 == M1514	Index_10 += 1	(1)
]>[(T)	(T)
%M1100.W == %M1514.W	%M1112.W += 0x1	
		goto(FASE40A)
		(T)

(1) %M2010.L[%M110e.W] = %V5000.L[%M1518.W] : Piano_10[Index_8] = Tab_pm[M1518]

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (69)	Page 26

72 Label: Step: Remove_pv %M52.W = 40

	Index_1 += 1
	(T)
	%M1100.W += 0x1
	Index_2 += 1
	(T)
	%M1102.W += 0x1
	Index_3 += 1
	(T)
	%M1104.W += 0x1
	Index_8 += 4
	(T)
	%M110e.W += 0x4

73 Label: Step: Remove_pv %M52.W = 40

Index_1 > 126	Alarm_pgm	
]>[()	
%M1100.W > 0x7e	%V4031.5	tentativo di posizionare una ven
	Remove_pv = 99	
	(T)	
	%M52.W = 0x63	
Index_2 < 7	goto(FASE40)	
]>[(T)	
%M1102.W < 0x7		
Index_2 == 7	Index_2 = 0	Index_1 += 3
]>[T	T
%M1102.W == 0x7	%M1102.W = 0x0	%M1100.W += 0x3

74 Label: FASE40A Step: Remove_pv %M52.W = 40

	M1518 += 4
	(T)
	%M1518.W += 0x4

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE		Date 28-02-2018
Module: REM_PV.XLA	%SP218 (72)		Page 27

75 Label: Step: Remove_pv %M52.W = 40

Tab_pm[M1518] == 167	goto(M_CORRF5)
]>[(T)
%V5000.L[%M1518.W] == 0xa7	
Tab_pm[M1518] == 170	M1518 += 4
]>[(T)
%V5000.L[%M1518.W] == 0xaa	
%M1518.W += 0x4	
(1) Tab_pm[M1518] != 170	Alarm_pgm
]>[()
%V5000.L[%M1518.W] != 0xaa	
%V4031.5	
Remove_pv = 99	
(T)	
%M52.W = 0x63	
goto(END)	
(T)	

tentativo di posizionare una ven

(1) %V5000.L[%M1518.W] != 0xa7 : Tab_pm[M1518] != 167

76 Label: Step: Remove_pv %M52.W = 40

Tab_pm[M1518] == 167	goto(M_CORRF5)
]>[(T)
%V5000.L[%M1518.W] == 0xa7	
Tab_pm[M1518] == 168	Index_setup = M1518
]>[(S)
%V5000.L[%M1518.W] == 0xa8	
%V402a.W = %M1518.W	
%V4030.1	
Ps_ledf4	
(R)	
%V200c.5	
Remove_pv = 0	
(T)	
%M52.W = 0x0	
goto(END)	
(T)	

start ciclo di setup

Led tasto F4

Author:			NUM TOOLS	
Company:				
Project: 1040_78.mch	TITRE		Date	28-02-2018
Module: REM_PV.XLA			%SP218 (75)	Page 28

77 Label: Step: Remove_pv %M52.W = 40

Tab_pm[M1518] == 999	B_sb_vent = 0	Sb_vent_a	Blocco/sblocco ventose area A
] %V5000.L[%M1518.W] == 0x3e7	T %V4040.B = 0x0	(R) %Q5201.2	
Tab_pm[M1518] == 164		Sb_vent_b	Blocco/sblocco ventose area B
] %V5000.L[%M1518.W] == 0xa4		(R) %Q5201.3	
		Sb_vent_c	Blocco/sblocco ventose area C
		(R) %Q5201.4	
		Sb_vent_d	Blocco/sblocco ventose area D
		(R) %Q5201.5	

78 Label: Step:

Tab_pm[M1518] == 164	Index_verify = M1518	Verify_pdl	start ciclo di verifica
] %V5000.L[%M1518.W] == 0xa4	T %V4036.W = %M1518.W	(S) %V4030.5	
		Ps_ledf4	Led tasto F4
		(R) %V200c.5	
		Remove_pv = 0	
		(T) %M52.W = 0x0	
		goto(END)	
		(T)	

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (77)	Page 29

79 Label: Step: Remove_pv %M52.W = 40

<pre>Tab_pm[M1518] == 999]>[%V5000.L[%M1518.W] == 0x3e7</pre>	<div style="border: 1px solid black; padding: 5px; margin-bottom: 5px;"> <p style="text-align: center;">M170_ok</p> <p style="text-align: center;">(R)</p> <p style="text-align: center;">%V4030.3</p> </div> <div style="border: 1px solid black; padding: 5px; margin-bottom: 5px;"> <p style="text-align: center;">Step_park</p> <p style="text-align: center;">(R)</p> <p style="text-align: center;">%V4032.4</p> </div> <div style="border: 1px solid black; padding: 5px; margin-bottom: 5px;"> <p style="text-align: center;">Raz_icla</p> <p style="text-align: center;">(S)</p> <p style="text-align: center;">%V4031.2</p> </div> <div style="border: 1px solid black; padding: 5px; margin-bottom: 5px;"> <p style="text-align: center;">Emer_move = 0 Remove_pv = 0</p> <p style="text-align: center;">T (T)</p> <p style="text-align: center;">%M46.W = 0x0 %M52.W = 0x0</p> </div>	<p>lettura valore 170</p> <p>fine posizionamento step PARCHEG</p> <p>Reset a fine posizionamento moto</p>
<pre>(1) (2) (3) (4) Tab_pm[M1518] != 999]>[]>[]>[]>[%V5000.L[%M1518.W] != 0x3e7</pre>	<div style="border: 1px solid black; padding: 5px; margin-bottom: 5px;"> <p style="text-align: center;">Alarm_pgmm</p> <p style="text-align: center;">()</p> <p style="text-align: center;">%V4031.5</p> </div> <div style="border: 1px solid black; padding: 5px;"> <p style="text-align: center;">Remove_pv = 99</p> <p style="text-align: center;">(T)</p> <p style="text-align: center;">%M52.W = 0x63</p> </div>	<p>tentativo di posizionare una ven</p>

```
(1) %V5000.L[%M1518.W] != 0xa4      :   Tab_pm[M1518] != 164
(2) %V5000.L[%M1518.W] != 0xa7      :   Tab_pm[M1518] != 167
(3) %V5000.L[%M1518.W] != 0xa8      :   Tab_pm[M1518] != 168
(4) %V5000.L[%M1518.W] != 0xaa      :   Tab_pm[M1518] != 170
```

```
80 Label: END          Step:
```

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: REM_PV.XLA		%SP218 (79)	Page 30