

00 Label: Step:

Lettura potenziometri analogica e bit lampeggio

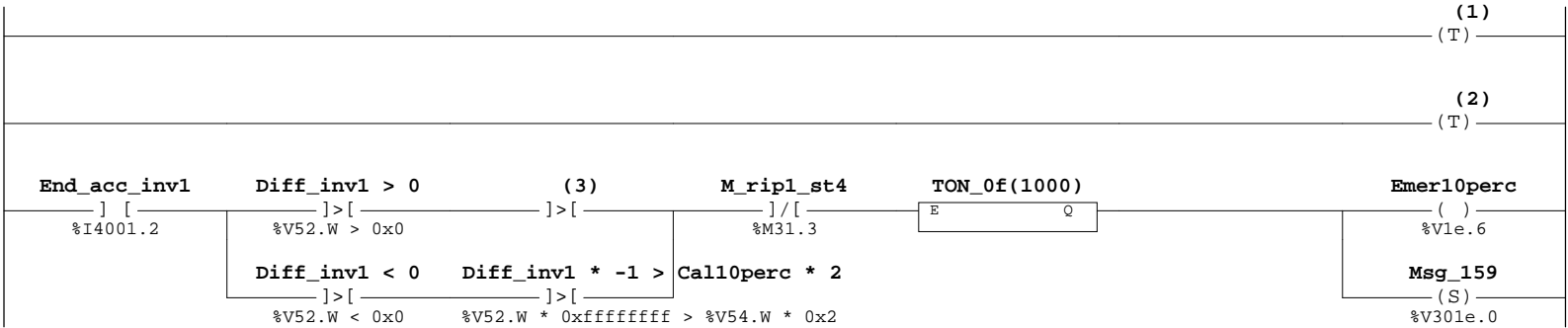


Lampeggio leed

(1) anai(0x10, %V66.&) : anai(16, V_pot2.&)
(2) anai(0x11, %V64.&) : anai(17, V_pot1.&)

01 Label: Step:

Verifica ed emergenza 10 percento



Emergenza per +10% analogica inv

ANOMALIA INVERTER 10%

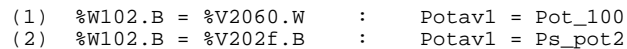
(1) %V52.W = %V66.W - %V50.W : Diff_inv1 = V_pot2 - V50_w
(2) %V54.W = %V50.W * 0xa / 0x64 : Call10perc = V50_w * 10 / 100
(3) %V52.W >= %V54.W : Diff_inv1 >= Call10perc
[T] TON_Of(0x3e8) : TON_Of(1000)

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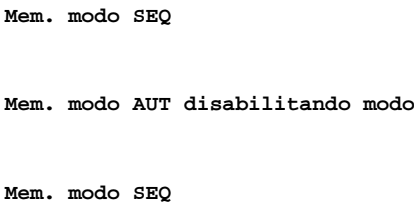
Rapporto potenziometro al 100%



Scrittura valore potenziometri



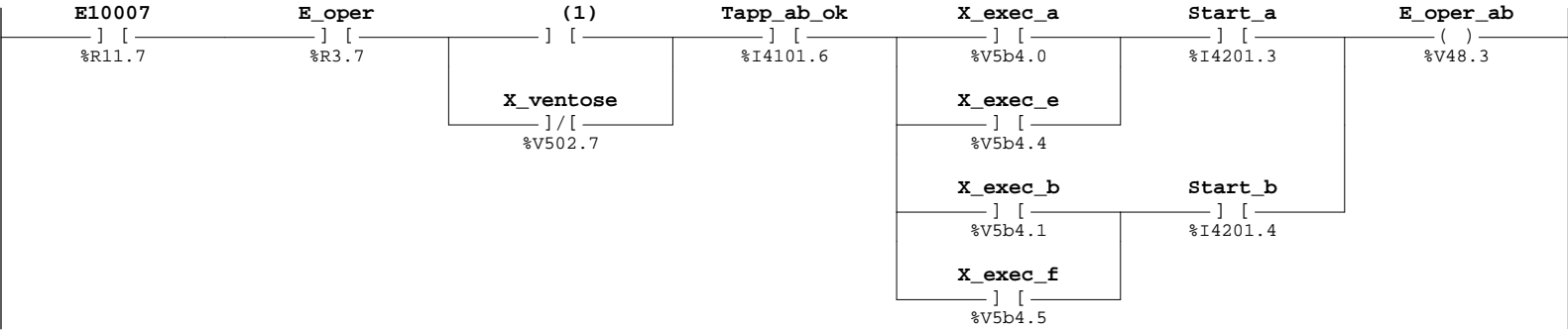
Gestione modo sequenziale



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05 Label: Step:

Gestione M0 con tappeti

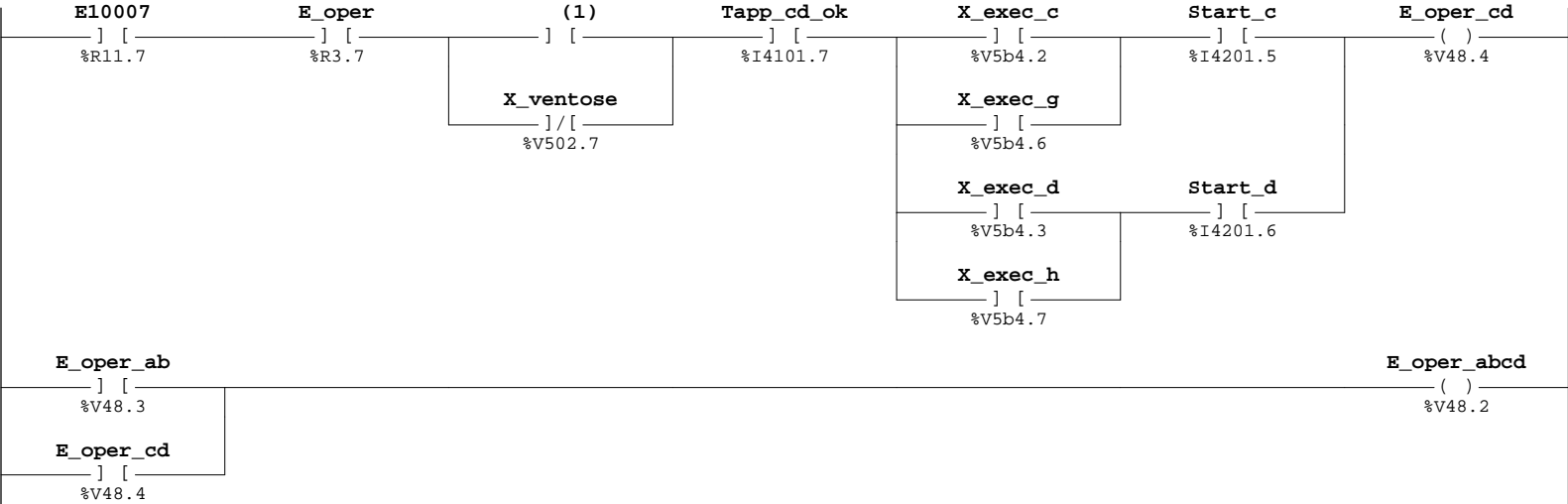


App. M0 con tappeti area AB

(1) %I4101.5, %I4101.7 : Tapp_cen_ok, Tapp_cd_ok

06 Label: Step:

Gestione M0 con tappeti



App. M0 con tappeti area CD

App. M0 con tappeti area AD

(1) %I4101.5, %I4101.6 : Tapp_cen_ok, Tapp_ab_ok

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07 Label:

Step:

Gestione Start Ciclo (M00)

<div>Ps_start</div> <div>]</div> <div>[</div> <div>%V202a.0</div>	<div>Modcour >= 1</div> <div>]</div> <div>>[</div> <div>%R16.B >= 0x1</div> <div>Xil_ini_ok == 0</div> <div>]</div> <div>>[</div> <div>%V504.W == 0x0</div> <div>Ab_aut_seq</div> <div>]</div> <div>[</div> <div>%V2a.4</div> <div>E10007</div> <div>]</div> <div>[</div> <div>%R11.7</div> <div>E10007</div> <div>]</div> <div>[</div> <div>%R11.7</div> <div>E_oper</div> <div>]</div> <div>[</div> <div>%R3.7</div> <div>E_oper_abcd</div> <div>]</div> <div>[</div> <div>%V48.2</div>	<div>Gen_em_cn</div> <div>]</div> <div>/[</div> <div>%V1e.0</div> <div>Xil_modo == 4</div> <div>]</div> <div>>[</div> <div>%V506.W == 0x4</div> <div>X_test_fora, X_test_magaz</div> <div>]</div> <div>/[</div> <div>%V503.2, %V503.3</div>	<div>(1)</div> <div>]</div> <div>/[</div> <div>()</div> <div>Rich_cicl_pa</div> <div>]</div> <div>/[</div> <div>()</div> <div>%V21.4</div>	Richiesta start ciclo da pannell
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(1) %Vf.6, %R3.1 : Pez_sblo, E_arus

08 Label:

Step:

Gestione Stop Ciclo (M00)

<div>Ps_stop</div> <div>]</div> <div>[</div> <div>%V202a.4</div>	<div>Wait_start</div> <div>]</div> <div>/[</div> <div>%V27.5</div>	<div>Memo_hold</div> <div>]</div> <div>(S)</div> <div>%V25.3</div>	Mem. hold durante ins. bussolle	
<div>Rich_hold_pa</div> <div>]</div> <div>[</div> <div>%V21.2</div>		<div>Memo_hold</div> <div>]</div> <div>(R)</div> <div>%V25.3</div>	Mem. hold durante ins. bussolle	
<div>Gen_em_cn</div> <div>]</div> <div>[</div> <div>%V1e.0</div>				
<div>Ps_start</div> <div>]</div> <div>[</div> <div>%V202a.0</div>				
<div>Memo_hold</div> <div>]</div> <div>[</div> <div>%V25.3</div>	<div>E30006 != 96</div> <div>]</div> <div>>[</div> <div>%Ra18.L != 0x60</div>	<div>Msg_144</div> <div>]</div> <div>/[</div> <div>%V300f.0</div>	<div>Rich_hold_pa</div> <div>]</div> <div>()</div> <div>%V21.2</div>	Richiesta hold assi da pannello

09 Label:

Step:

Gestione arresto opzionale (M01)

<div>X_tm01</div> <div>]</div> <div>[</div> <div>%V500.1</div>	<div>C_m01</div> <div>]</div> <div>()</div> <div>%W3.7</div>	Validazione dell'arresto opziona
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10 Label:

Step:

Gestione manipolatori assi

<div>(1)</div> <div>Setting</div> <div>%I4101.3</div>	<div>Xil_mod0 != 3</div> <div>%V506.W != 0x3</div>	<div>Ps_selax == 1</div> <div>%V202d.B == 0x1</div>	<div>Ps_piu</div> <div>%V202b.0</div>	<div>Jogpos0</div> <div>()</div> <div>%W9.0</div>	JOG positivo asse n° 0
			<div>Ps_meno</div> <div>%V202a.3</div>	<div>Jogneg0</div> <div>()</div> <div>%Wd.0</div>	JOG negativo asse n° 0
		<div>Ps_selax == 12</div> <div>%V202d.B == 0xc</div>	<div>Ps_piu</div> <div>%V202b.0</div>	<div>Jogpos1</div> <div>()</div> <div>%W9.1</div>	JOG positivo asse n° 1
			<div>Ps_meno</div> <div>%V202a.3</div>	<div>Jogneg1</div> <div>()</div> <div>%Wd.1</div>	JOG negativo asse n° 1
		<div>Ps_selax == 10</div> <div>%V202d.B == 0xa</div>	<div>Ps_piu</div> <div>%V202b.0</div>	<div>Jogpos2</div> <div>()</div> <div>%W9.2</div>	JOG positivo asse n° 2
			<div>Ps_meno</div> <div>%V202a.3</div>	<div>Jogneg2</div> <div>()</div> <div>%Wd.2</div>	JOG negativo asse n° 2

(1) %I4101.3, %I4001.3, %I4100.7 : Setting, Pul_um1, Pul_um2

11 Label:

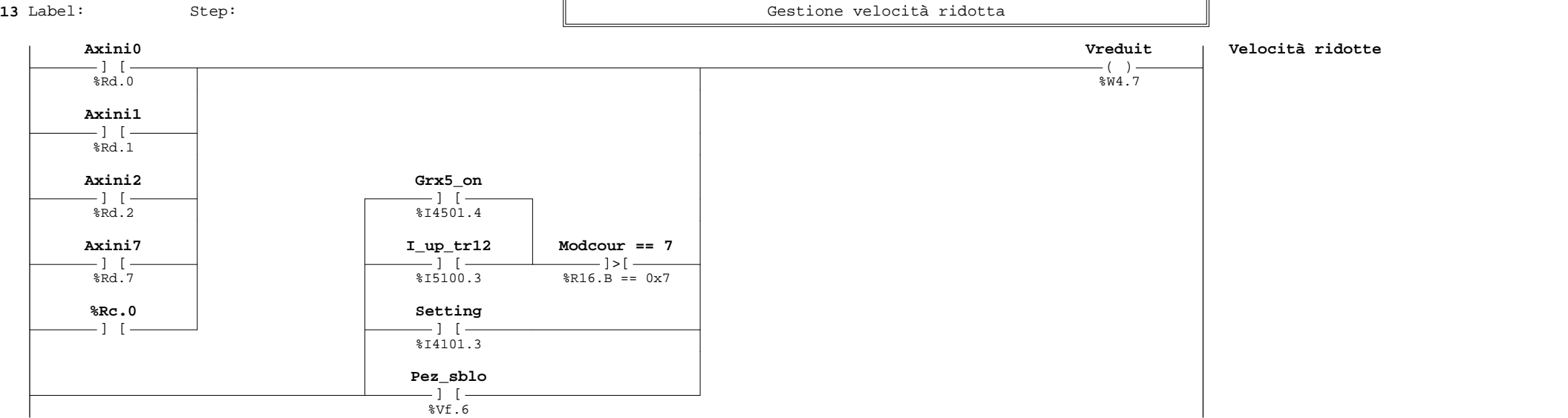
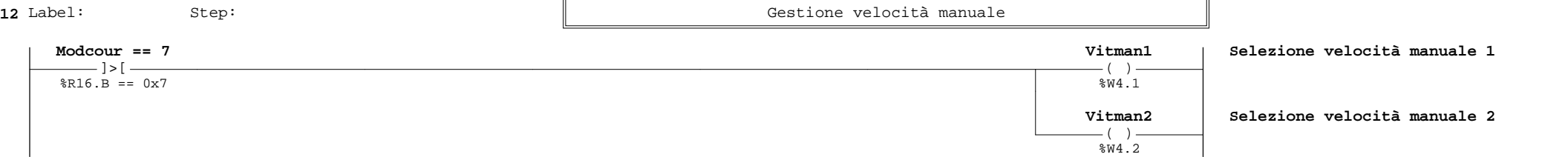
Step:

Gestione manipolatori assi

<div>(1)</div> <div>Setting</div> <div>%I4101.3</div>	<div>Xil_mod0 != 3</div> <div>%V506.W != 0x3</div>	<div>Ps_selax == 3</div> <div>%V202d.B == 0x3</div>	<div>Ps_piu</div> <div>%V202b.0</div>	<div>Jogpos7</div> <div>()</div> <div>%W9.7</div>	JOG positivo asse n° 7
			<div>Ps_meno</div> <div>%V202a.3</div>	<div>Jogneg7</div> <div>()</div> <div>%Wd.7</div>	JOG negativo asse n° 7
		<div>Ps_selax == 4</div> <div>%V202d.B == 0x4</div>	<div>Ps_piu</div> <div>%V202b.0</div>	<div>Jogpos8</div> <div>()</div> <div>%W8.0</div>	JOG positivo asse n° 8
			<div>Ps_meno</div> <div>%V202a.3</div>	<div>Jogneg8</div> <div>()</div> <div>%Wc.0</div>	JOG negativo asse n° 8

(1) %I4101.3, %I4001.3, %I4100.7 : Setting, Pul_um1, Pul_um2

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15 Label: Step:

Gestione led start/stop

E_cycle] [%R3.2		Ps_ledstart () %V200c.0	Led tasto start ciclo
E_arus] [%R3.1		Ps_ledstop () %V200c.1	Led tasto stop ciclo

16 Label: Step:

Ps_cuffia] [%V202a.7	V205_0 R_T %V205.0	E10003]/[%R11.3	M_app1 () %V28.3	Mem. appoggio soll. cuffie da op
M_app1] [%V28.3	Enab_cuff] [%V28.2		M_app2 () %V28.4	Mem. appoggio discesa cuffie da
M_app1] [%V28.3	M_app2]/[%V28.4		Enab_cuff () %V28.2	Mem. sollevamento cuffie da oper
Enab_cuff] [%V28.2				

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