

00 Label: Step:

Visualizza messaggi

Rich_raz_pan] [%V21.0	Msg_2 (R) %V351.0	PROTEZIONE TERMICA MOTORI
	Msg_3 (R) %V352.0	PRESSIONE ARIA INSUFFICIENTE
	Msg_54 (R) %V385.0	ALLARME Sonda Termica EM5
	Msg_55 (R) %V386.0	ALLARME Sonda Termica EM6
	Msg_56 (R) %V387.0	ALLARME Sonda Termica ELCU
	Msg_57 (R) %V388.0	ALLARME Sonda Termica EM1

01 Label: Step:

Visualizza messaggi

Rich_raz_pan] [%V21.0	Msg_58 (R) %V389.0	ALLARME Sonda Termica EM2
	Msg_59 (R) %V38a.0	ALLARME Sonda Termica EM3
	Msg_60 (R) %V38b.0	ALLARME Sonda Termica EM4
	Msg_77 (R) %V39c.0	Elettromandrino senza utensile
	Msg_80 (R) %V39f.0	Attesa orientamento utensile
	Msg_137 (R) %V3008.0	Errore tastatura

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02 Label: Step:

Visualizza messaggi

Rich_raz_pan	Msg_141	RAPID 1
]	(R)	
%V21.0	%V300c.0	
	Msg_142	RAPID 2
	(R)	
	%V300d.0	
	Msg_149	Esecuzione simulata non possibil
	(R)	
	%V3014.0	
	Msg_159	ANOMALIA INVERTER 10%
	(R)	
	%V301e.0	
Rich_raz_pan	Msg_94	PEZZO NON BLOCCATO
]	(R)	
%V21.0	%V3ad.0	
X_ventose	Msg_95	RICHIESTO START SENZA PROGRAMMA
]	(R)	
%V502.7	%V3ae.0	

03 Label: Step:

Rich_raz_pan	Msg_178	Presenza errori motori PDL area
]	(R)	
%V21.0	%V3031.0	
	Msg_179	Presenza errori motori PDL area
	(R)	
	%V3032.0	
	Msg_180	Presenza errori motori PDL area
	(R)	
	%V3033.0	
	Msg_181	Presenza errori motori PDL area
	(R)	
	%V3034.0	

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04 Label: Step:

Rich_raz_pan] [%V21.0	Msg_62 (R) %V38d.0	ATTESA PROTEZIONI MAG. APERTA (s
	Msg_154 (R) %V3019.0	TOOL-ROOM NON IN POSIZIONE
	Msg_76 (R) %V39b.0	ANOMALIA CAMBIO UTENSILE
	Msg_156 (R) %V301b.0	ATTESA TOOL-ROOM BASSA

05 Label: Step:

Visualizza messaggi

Drv_ok_dc]/[%I4000.4	Conf_r10_e11] [%V102.0	E20022]/[%Wf.6	Msg_1 () %V350.0	FAULT DRIVE ASSI DI SETUP
	Conf_r10_e12] [%V103.0	E20023]/[%Wf.7		
	Conf_r10_e13] [%V104.0			
	E20007] [%W11.7			
	E20008] [%W10.0			

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06 Label: Step:

Visualizza messaggi

Emer_ter] [%I4000.7	Msg_2 (S) %V351.0	PROTEZIONE TERMICA MOTORI
Emer_ar]/[%I4201.0	Msg_3 (S) %V352.0	PRESSIONE ARIA INSUFFICIENTE
Gen_em_cn] [%V1e.0	Msg_4 () %V353.0	EMERGENZA MACCHINA
A0_alarm] [%Re21.0	Msg_5 () %V354.0	FAULT DRIVE ASSI BRUSHLESS
A1_alarm] [%Re23.0		
A2_alarm] [%Re25.0		

07 Label: Step:

Visualizza messaggi

A0_svon]/[%Re21.3	Msg_6 () %V355.0	FAULT DRIVE ASSE X
A1_svon]/[%Re23.3	Msg_7 () %V356.0	FAULT DRIVE ASSE Y
A2_svon]/[%Re25.3	Msg_8 () %V357.0	FAULT DRIVE ASSE Z
A7_svon]/[%Re2f.3	Msg_133 () %V3004.0	FAULT DRIVE ASSE B
A8_svon]/[%Re31.3	Msg_16 () %V35f.0	FAULT DRIVE ASSE C

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08 Label: Step:

Tymer_tr	M114_1	Msg_23	ATTESA UTENSILE SBLOCCATO (rapid
]]	()	
%V34.2	%V672.0	%V366.0	
	M115_1	Msg_24	ATTESA UTENSILE BLOCCATO (rapid)
]	()	
	%V673.0	%V367.0	
	M182_1	Msg_116	POSTO SEL. NON VUOTO (random)
]	()	
	%V6b6.0	%V3c3.0	
	M183_1	Msg_117	POSTO SEL. SENZA UTENSILE (rando
]	()	
	%V6b7.0	%V3c4.0	
	M156_1	Msg_157	ATTESA TOOL-ROOM AVANTI (Y-)
]	()	
	%V69c.0	%V301c.0	
	M157_1	Msg_158	ATTESA TOOL-ROOM DIETRO (Y+)
]	()	
	%V69d.0	%V301d.0	

09 Label: Step:

Tymer_tr	M159_1	E30037 == 24	R24_fcspo	Msg_62	ATTESA PROTEZIONI MAG. APERTA (s
]]]]/[(S)	
%V34.2	%V69f.0	%Rb14.L == 0x18	%I5300.1	%V38d.0	
			Graf_tr24 != 0	Msg_154	TOOL-ROOM NON IN POSIZIONE
]	(S)	
			%M44.W != 0x0	%V3019.0	
			%V999.0	Msg_76	ANOMALIA CAMBIO UTENSILE
]/[(S)	
				%V39b.0	
			R24_fcup	Msg_156	ATTESA TOOL-ROOM BASSA
]/[(S)	
			%I5301.0	%V301b.0	
			Evolution		
			%M803.1		

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10 Label: Step:

Tymer_tr	M159_1	E30037 == 12	Open_tr	Msg_62	ATTESA PROTEZIONI MAG. APERTA (s
]	[]	[(S)	
%V34.2	%V69f.0	%Rb14.L == 0xc	%I5101.1	%V38d.0	
			Graf_tr12 != 0	Msg_154	TOOL-ROOM NON IN POSIZIONE
]	(S)	
			%M42.W != 0x0	%V3019.0	
			Posiz_tr12		
]		
			%I5100.1		
			%V999.0	Msg_76	ANOMALIA CAMBIO UTENSILE
]	(S)	
				%V39b.0	
			I_up_tr12	Msg_156	ATTESA TOOL-ROOM BASSA
]	(S)	
			%I5100.3	%V301b.0	
			Evolution		
]		
			%M803.1		

11 Label: Step:

Diag_30	Msg_30	CICLO DI C.U. IN CORSO (rapid)
]	()	
%V2e.3	%V36d.0	
Diag_31	Msg_31	TARATURA MAGAZZINO (rapid)
]	()	
%V2e.4	%V36e.0	
E10009	Msg_32	TARATURA ASSI
]	()	
%R10.1	%V36f.0	
Diag_33	Msg_33	ATTESA PULSANTE DI START
]	()	
%V2e.6	%V370.0	
Diag_34	Msg_34	TARATURA ASSI EFFETTUATA
]	()	
%V2e.7	%V371.0	

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12 Label: Step:

Visualizza messaggi

E10014	Msg_35	ERRORE TARATURA ASSE X
] [()	
%R10.6	%V372.0	
E10015	Msg_36	ERRORE TARATURA ASSE Y
] [()	
%R10.7	%V373.0	
E10016	Msg_37	ERRORE TARATURA ASSE Z
] [()	
%Rf.0	%V374.0	
E10017	Msg_38	ERRORE TARATURA ASSE A
] [()	
%Rf.1	%V375.0	

13 Label: Step:

Visualizza messaggi

E_oper	Msg_40	MACCHINA IN STANDBY
] [()	
%R3.7	%V377.0	
E_bat	Msg_41	BATTERIA SCARICA
] [()	
%R14.1	%V378.0	
M_rip1_st4	Msg_42	RIAGGANCIO EL. IN CORSO
] [()	
%M31.3	%V379.0	
M_rip2_st4		
] [
%M31.7		
M_rip3_st4		
] [
%M10.3		
M_rip4_st4		
] [
%M10.7		

14 Label: Step:

Visualizza messaggi

M_rip1_st2] [%M31.1		Msg_43 () %V37a.0
M_rip2_st2] [%M31.5		
M_rip3_st2] [%M10.1		
M_rip4_st2] [%M10.5		
Stop_rot] [%V22.0		Msg_44 () %V37b.0

SEL. LO STATO DI EMERGENZA MACCH

ATTESA ROTAZIONE GRUPPO

15 Label: Step:

Visualizza messaggi

Setting] [%I4101.3		Msg_47 () %V37e.0
X_inv1] [%V50c.0	Inv1_on] [%Q4000.7	End_acc_inv1]/[%I4001.2
	Inv1_on]/[%Q4000.7	App_freq1_0]/[%V22.6
Setting]/[%I4101.3	X_inv1] [%V50c.0	Emer_inv1]/[%I4001.0
Ok_twin1]/[%I4301.3	Conf_ell_cu] [%V100.0	

SETTING

FREQUENZA INVERTER NON OK

MSG ALLARME INVERTER 1

ALLARME SONDA TERMICA ELCU

[T] TON_26(0x2710) : TON_26(10000)

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16 Label: Step:

Visualizza messaggi

Lub_aut] [%M802.4	Lub_iniz] [%V7.4	Msg_73 () %V398.0	LUBRIFICAZIONE IN CORSO
	Err_lub] [%V7.7	Msg_74 () %V399.0	ERRORE LUBRIFICAZIONE
	Lubr_gr]/[%I4201.1	Msg_75 () %V39a.0	POMPA LUBRIFICANTE VUOTA
Ell_sut] [%V3b.0		Msg_77 (S) %V39c.0	ELETTROMANDRINO SENZA UTENSILE
Forat_npos] [%V44.2	Gen_em_cn]/[%V1e.0	Msg_80 (S) %V39f.0	ATTESA ORIENTAMENTO UTENSILE
[T] TON_27(0x1388) : TON_27(5000)			

17 Label: Step:

Visualizza messaggi

Modcour == 1]>[%R16.B == 0x1	E_prog] [%R5.1	E_cycle]/[%R3.2	Msg_91 () %V3aa.0	< START > PROSSIMO BLOCCO DI PRO
Ab_aut_seq] [%V2a.4				
Enab_cuff] [%V28.2			Msg_79 () %V39e.0	CUFFIA ELETTROMANDRINO SOLLEVATA
Ps_noedit] [%V202b.6			Msg_92 () %V3ab.0	NO EDIT
Ps_nomode] [%V202b.7			Msg_93 () %V3ac.0	NO MODE

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18 Label: Step:

Visualizza messaggi

Start_a] [%I4201.3	X_pgm_a] [%V531.0	Vacu_a] / [%I4200.4	(1)] / [() %V1d.3	App_msg94_2
	X_pgm_e] [%V531.4	D_bdf] / [%M803.3	(2)] / [%I5600.0	Sel_list_ab
	X_pgm_e] [%V531.4	D_bdf] [%M803.3	Vacu_e] / [%I4b00.0	
Start_b] [%I4201.4	X_pgm_b] [%V531.1	Vacu_bi] / [%I4200.5	(3)] / [%I5600.0	Sel_list_ab
	X_pgm_f] [%V531.5	D_bdf] / [%M803.3	Vacu_f] / [%I4b00.1	

App. messaggio 94

- (1) %I4100.2, %R11.5 : Sel_morab, E10005
(2) %V18.0, %V18.1, %I4200.4 : %V18.0, %V18.1, Vacu_a
(3) %V18.2, %V18.3, %I4200.5 : %V18.2, %V18.3, Vacu_bi

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19 Label: Step:

Visualizza messaggi

Start_c] [%I4201.5	X_pgm_c] [%V531.2	Vacu_cl] [%I4200.6	(1)] [%Vld.4
	X_pgm_g] [%V531.6	D_bdf] [%M803.3	Sel_list_cd] [%I5600.1
	X_pgm_g] [%V531.6	D_bdf] [%M803.3	Vacu_g] [%I4b00.2
Start_d] [%I4201.6	X_pgm_d] [%V531.3	Vacu_d] [%I4200.7	
	X_pgm_h] [%V531.7	D_bdf] [%M803.3	(3)] [%I5600.1
	X_pgm_h] [%V531.7	D_bdf] [%M803.3	Vacu_h] [%I4b00.3

App. messaggio 94

- (1) %I4100.3, %R11.5 : Sel_morcd, E10005
(2) %V18.4, %V18.5, %I4200.6 : %V18.4, %V18.5, Vacu_cl
(3) %V18.6, %V18.7, %I4200.7 : %V18.6, %V18.7, Vacu_d

20 Label: Step:

Visualizza messaggi

Sel_morab] [%I4100.2	Start_a] [%I4201.3	Okpres_ab] [%I5000.4	App_msg94] [%Vld.5
	Start_b] [%I4201.4		
Sel_morcd] [%I4100.3	Start_c] [%I4201.5	Okpres_cd] [%I5000.5	
	Start_d] [%I4201.6		

App. messaggio 94

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21 Label: Step:

Visualizza messaggi

App_msg94	X_end	Msg_94
] [] [(S)
%V1d.5	%V503.0	%V3ad.0
App_msg94_1		
] [
%V1d.4		
App_msg94_2		
] [
%V1d.3		
Em_pznbl		
] [
%V28.7		
(1)	Vacu_c1	
] []/[
	%I4200.6	

PEZZO NON BLOCCATO

(1) %I4201.3, %V531.0, %I4100.6, %M800.6 : Start_a, X_pgm_a, Sel_rw, Nesting

22 Label: Step:

Visualizza messaggi

Start_a	(1)	X_end	Msg_95
] []/[] [(S)
%I4201.3		%V503.0	%V3ae.0
Start_b	X_pgm_b, X_pgm_f		
] []/[
%I4201.4	%V531.1, %V531.5		
Start_c	X_pgm_c, X_pgm_g		
] []/[
%I4201.5	%V531.2, %V531.6		
Start_d	X_pgm_d, X_pgm_h		
] []/[
%I4201.6	%V531.3, %V531.7		
Ps_pot1 < 2	Ps_pot1 > -1		Msg_96
]>[]>[()
%V202e.B < 0x2	%V202e.B > 0xffffffff		%V3af.0
App_msg129			Msg_129
] [()
%V4033.5			%V3000.0

RICHIESTO START SENZA PROGRAMMA

ZERO FEED_RATE

ESEGUIRE TARATURA PIANI E VENTOS

(1) %V531.0, %V531.4 : X_pgm_a, X_pgm_e

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23 Label: Step:

Visualizza messaggi

E30127 == 2	Msg_137	ERRORE TASTATURA
]>[(S)	
%Rd7c.L == 0x2	%V3008.0	
Ps_error	Msg_138	TIME OUT SERIALE
] [()	
%V202c.0	%V3009.0	
X_mod0_simXil_mod0 != 4Evolution	Msg_149	Esecuzione simulata non possibil
] [()	
%V503.1%V506.W != 0x4%M803.1	%V3014.0	

24 Label: Step:

Visualizza messaggi

Sel_morab	Msg_150	LAVORAZIONE CON MORSETTI AREA AB
] [()	
%I4100.2	%V3015.0	
Sel_morcd	Msg_151	LAVORAZIONE CON MORSETTI AREA CD
] [()	
%I4100.3	%V3016.0	
Ab_pn	Msg_152	MORSETTI AREA AB ALTI PNEUMATICA
] [()	
%I5001.6	%V3017.0	
Cd_pn	Msg_153	MORSETTI AREA CD ALTI PNEUMATICA
] [()	
%I5001.7	%V3018.0	
App_msg_167	Msg_167	FARE RIFERIMENTO CUFFIA
] [()	
%V1f.1	%V3026.0	
App_msg_168	Msg_168	FAULT MOTORE CUFFIA
] [()	
%V1f.0	%V3027.0	

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25 Label: Step:

Anom_cu		Msg_154	TOOL-ROOM NON IN POSIZIONE
] [_____ %V28.0		()_____ %V3019.0	
Tymer_cf	M24_1	Msg_172	ATTESA PISTONE CUFFIA BASSO
] [_____ %V43.7] [_____ %V618.0	()_____ %V302b.0	
	M25_1	Msg_29	ATTESA CUFFIA POSIZIONE DI C.U.
] [_____ %V619.0	()_____ %V36c.0	
	M26_1	Msg_173	ATTESA PISTONE CUFFIA ALTO
] [_____ %V61a.0	()_____ %V302c.0	
El_11kw	Pres_el1, El_1_on	Msg_160	PRESSOSTATO REFRIGERATORE EL.1
] [_____ %M800.4]/[_____ %I4000.0, %Q4100.2	()_____ %V301f.0	

26 Label: Step:

Visualizza messaggi

Piano_tv] [_____ %M800.5	Sel_man_aut]/[_____ %I4101.4	V_bl_ab]/[_____ %I4000.2	Msg_162 _____ ()_____ %V3021.0	VENTOSE NON BLOCCATE SU PIANO AB
		V_bl_b]/[_____ %I5201.6		
		V_bl_cd]/[_____ %I4000.3	Msg_163 _____ ()_____ %V3022.0	VENTOSE NON BLOCCATE SU PIANO CD
		V_bl_c]/[_____ %I5201.7		

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27 Label: Step:

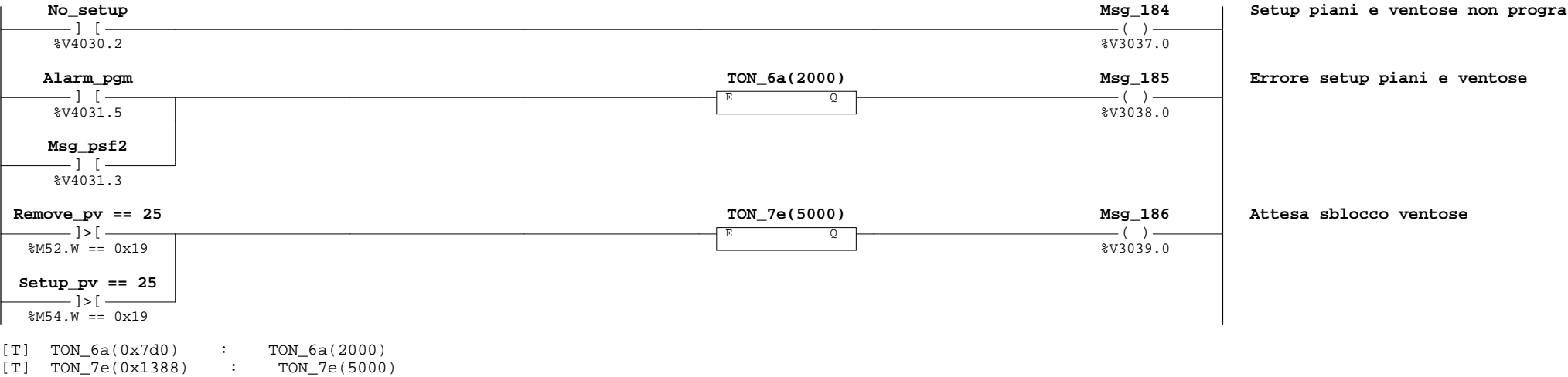
App_msg164	Msg_164	CICLO AREA AB NON OK
] [()	
%V47.6	%V3023.0	
App_msg165	Msg_165	CICLO AREA CD NON OK
] [()	
%V47.7	%V3024.0	
X_bltypea	Msg_178	Presenza errori motori PDL area
] [(S)	
%V1151.3	%V3031.0	
X_bltypeb	Msg_179	Presenza errori motori PDL area
] [(S)	
%V1151.4	%V3032.0	
X_bltypec	Msg_180	Presenza errori motori PDL area
] [(S)	
%V1151.5	%V3033.0	
X_bltyped	Msg_181	Presenza errori motori PDL area
] [(S)	
%V1151.6	%V3034.0	

28 Label: Step:

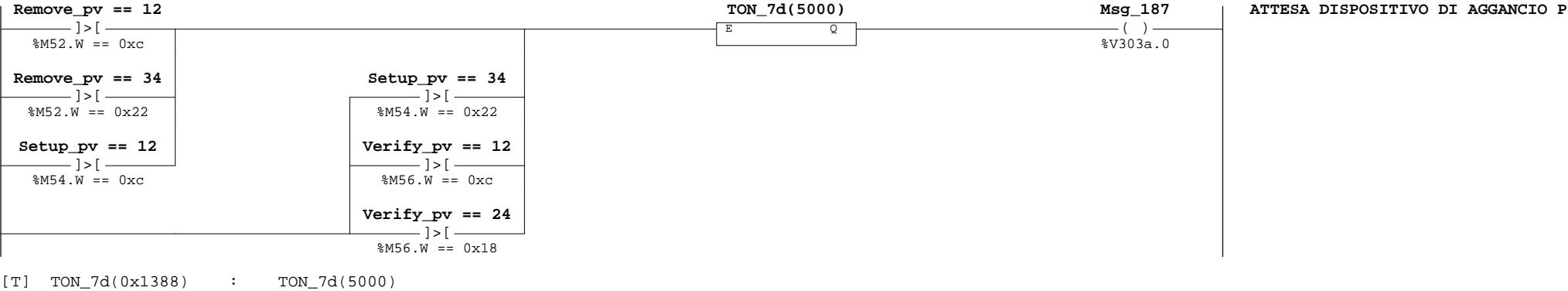
Remove	Msg_182	Premere F5 per conferma rimozion
] [()	
%V4033.4	%V3035.0	
Remove_pv > 0	Msg_183	Setup piani e ventose in corso
]>[(S)	
%M52.W > 0x0	%V3036.0	
Setup_pv > 0		
]>[
%M54.W > 0x0		
Verify_pv > 0		
]>[
%M56.W > 0x0		
Raz_icla	Msg_183	Setup piani e ventose in corso
] [(R)	
%V4031.2	%V3036.0	

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29 Label: Step:



30 Label: Step:



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31 Label: Step:

Time_agg] [_____ %V4033.6		Cil_pdl_ab] [_____ %Q5201.0	Pdl_ab]/[_____ %I5201.0	Msg_188 _____ ()_____ %V303b.0	ATTESA AGGANCIO PIANI
App_msg129] [_____ %V4033.5		Pistab_no_ok] [_____ %V4561.4			
App_msg_f5 _____] [_____ %V4562.2		Cil_pdl_cd _____] [_____ %Q5201.1	Pdl_cd _____]/[_____ %I5201.1		
		Pistcd_no_ok _____] [_____ %V4561.5			

32 Label: Step:

Time_agg _____] [_____ %V4033.6		Cil_pdl_1 _____] [_____ %Q5200.0	Vent_pdl_1 _____]/[_____ %I5200.0	Msg_189 _____ ()_____ %V303c.0	ATTESA AGGANCIO VENTOSA - PIANO
App_msg129 _____] [_____ %V4033.5		Pist1_no_ok _____] [_____ %V4560.0			
App_msg_f5 _____] [_____ %V4562.2		Cil_pdl_2 _____] [_____ %Q5200.1	Vent_pdl_2 _____]/[_____ %I5200.1	Msg_190 _____ ()_____ %V303d.0	ATTESA AGGANCIO VENTOSA - PIANO
		Pist2_no_ok _____] [_____ %V4560.1			
		Cil_pdl_3 _____] [_____ %Q5200.2	Vent_pdl_3 _____]/[_____ %I5200.2	Msg_191 _____ ()_____ %V303e.0	ATTESA AGGANCIO VENTOSA - PIANO
		Pist3_no_ok _____] [_____ %V4560.2			

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33 Label: Step:

Time_agg] [%V4033.6		Cil_pdl_4] [%Q5200.3	Vent_pdl_4]/[%I5200.3	Msg_192 () %V303f.0	ATTESA AGGANCIO VENTOSA - PIANO
App_msg129] [%V4033.5		Pist4_no_ok] [%V4560.3			
App_msg_f5] [%V4562.2		Cil_pdl_5] [%Q5200.4	Vent_pdl_5]/[%I5200.4	Msg_193 () %V3040.0	ATTESA AGGANCIO VENTOSA - PIANO
		Pist5_no_ok] [%V4560.4			
		Cil_pdl_6] [%Q5200.5	Vent_pdl_6]/[%I5200.5	Msg_194 () %V3041.0	ATTESA AGGANCIO VENTOSA - PIANO
		Pist6_no_ok] [%V4560.5			

34 Label: Step:

Time_agg] [%V4033.6		Cil_pdl_7] [%Q5200.6	Vent_pdl_7]/[%I5200.6	Msg_195 () %V3042.0	ATTESA AGGANCIO VENTOSA - PIANO
App_msg129] [%V4033.5		Pist7_no_ok] [%V4560.6			
App_msg_f5] [%V4562.2		Cil_pdl_8] [%Q5200.7	Vent_pdl_8]/[%I5200.7	Msg_196 () %V3043.0	ATTESA AGGANCIO VENTOSA - PIANO
		Pist8_no_ok] [%V4560.7			
		Cil_pdl_9] [%Q5400.0	Vent_pdl_9]/[%I5400.0	Msg_197 () %V3044.0	ATTESA AGGANCIO VENTOSA - PIANO
		Pist9_no_ok] [%V4561.0			

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35 Label: Step:

Time_agg] [%V4033.6	Cil_pdl_10] [%Q5400.1	Vent_pdl_10]/[%I5400.1	Msg_198 () %V3045.0	ATTESA AGGANCIO VENTOSA - PIANO
App_msg129] [%V4033.5	Pist10_no_ok] [%V4561.1			
App_msg_f5] [%V4562.2	Cil_pdl_11] [%Q5400.2	Vent_pdl_11]/[%I5400.2	Msg_199 () %V3046.0	ATTESA AGGANCIO VENTOSA - PIANO
	Pist11_no_ok] [%V4561.2			
	Cil_pdl_12] [%Q5400.3	Vent_pdl_12]/[%I5400.3	Msg_200 () %V3047.0	ATTESA AGGANCIO VENTOSA - PIANO
	Pist12_no_ok] [%V4561.3			

36 Label: Step:

App_msg_f5] [%V4562.2	Msg_201 () %V3048.0	PREMERE F5 PER CONFERMA AGGANCIO
Inib_start_a] [%V4035.0	%V3054.0 ()	
Inib_start_b] [%V4035.1	%V3055.0 ()	
Inib_start_c] [%V4035.2	%V3056.0 ()	
Inib_start_d] [%V4035.3	%V3057.0 ()	

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37 Label: Step:

Itir					
]	[
%I4500.2					
Sbl		E10003		Msg_171	ANOMALIA ELETTROMANDRINO
]	[]/[()	
%I4500.1		%R11.3		%V302a.0	
Cuffia_dis				Msg_174	CUFFIA DISABILITATA
]	[()
%I4500.7				%V302d.0	

38 Label: **MSG1** Step:

Decodifica messaggi 1-128

	Ind_msg1 = 1 (T)
	%M20.W = 0x1
	App_msg1 = 0 (T)
	%M22.W = 0x0

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39 Label: LOOP Step:

Decodifica messaggi 129-256

Msg_prec[Ind_msg1]	(1)
] [(T)
%V34f.0[%M20.W]	
Msg_prec1[Ind_msg1]	
] [
%V2fff.0[%M20.W]	
	Ind_msg1 += 1
	(T)
	%M20.W += 0x1
Ind_msg1 <= 128	goto(LOOP)
]>[(T)
%M20.W <= 0x80	

(1) %M22.W = %M22.W + %M20.W : App_msg1 = App_msg1 + Ind_msg1

40 Label: COPY_MSG Step:

App_msg1 == App_msg2	goto(FINE)
]>[(T)
%M22.W == %M24.W	
	(1)
	(T)
Lastplcala_x == 0	TON_28(200)
]>[(2)
%V520.B == 0x0	(T)
Lastplcala_x == 1	TON_29(200)
]>[(3)
%V520.B == 0x1	(T)

(1) %M24.W = %M22.W : App_msg2 = App_msg1
(2) %V520.B = 0x1 : Lastplcala_x = 1
(3) %V520.B = 0x0 : Lastplcala_x = 0
[T] TON_28(0xc8) : TON_28(200)
[T] TON_29(0xc8) : TON_29(200)

41 Label: FINE Step:

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