

00 Label: Step:

| | |
|---------------------------------|----------------------------------|
| M162_1] [%V6a2.0 | goto(SCRIVI) (T) |
| M163_1] [%V6a3.0 | goto(VER) (T) |
| | Res_m162 (R) %V34.0 |
| | Res_m163 (R) %V34.1 |
| | goto(END) (T) |

Mem. sblocco funzione M162

Mem. sblocco funzione M163

01 Label: SCRIVI Step:

Aggiorna Posti utensile

| | | |
|--|--|-------------------|
| E30121 > 0]>[%Rd64.L > 0x0 | E30121 < 30]>[%Rd64.L < 0x1e | (1) (T) |
| | E30120 == 0]>[%Rd60.L == 0x0 | (2) (T) |
| | E30120 == 1]>[%Rd60.L == 0x1 | (3) (T) |

- (1) %M11.W = %Rd64.L * 0x4 : Indice_tr = E30121 * 4
(2) %M5fc.L[%M11.W] = 0x0 : %M5fc.L[Indice_tr] = 0
(3) %M5fc.L[%M11.W] = %Rd68.L : %M5fc.L[Indice_tr] = E30122

| | | | |
|----------------------|--------------|------------------|-----------------|
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| Project: 1040_78.mch | TITRE | | Date 28-02-2018 |
| Module: TR_WRITE.XLA | | %SP132 (00) | Page 1 |

02 Label: Step:

Aggiorna Elettromandrini

| | | | |
|-------------------------|-----------------------|----------------------|----------------------|
| E30121 == 1000 | E30120 == 0 | %M5f8.L = 0 | %M5fc.L = 0 |
|] > [|] > [| T | (T) |
| %Rd64.L == 0x3e8 | %Rd60.L == 0x0 | %M5f8.L = 0x0 | %M5fc.L = 0x0 |
| E30120 == 1 | | (1) | (2) |
|] > [| | T | (T) |
| %Rd60.L == 0x1 | | | |

(1) %M5f8.L = %Rd6c.L : %M5f8.L = E30123
(2) %M5fc.L = %Rd68.L : %M5fc.L = E30122

03 Label: Step:

| | | |
|--|------------------|-----------------------------------|
| | Res_m162 | Mem. sblocco funzione M162 |
| | (S) | |
| | %V34.0 | |
| | goto(END) | |
| | (T) | |

04 Label: VER Step:

| | |
|--|-------------------|
| | (1) |
| | (T) |
| | E40013 = 0 |
| | (T) |
| | %Wa34.L = 0x0 |

(1) %M11.W = %Rd64.L * 0x4 : Indice_tr = E30121 * 4

| | | | |
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| Project: 1040_78.mch | TITRE | | Date 28-02-2018 |
| Module: TR_WRITE.XLA | | | Page 2 |

05 Label: Step:

| | | |
|---|---|--|
| E40013 == 0]>[%Wa34.L == 0x0 | %M5f8.L[Indice_tr] == Out11]>[%M5f8.L[%M11.W] == %R17c.L | E40013 = 1 (T) %Wa34.L = 0x1 E40013 = 2 (F) %Wa34.L = 0x2 |
| | | Res_m163 (S) %V34.1 |
| | | goto(END) (T) |

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06 Label: END           Step:
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| | | | |
|----------------------|--------------|------------------|------------|
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| Module: TR_WRITE.XLA | | Page | 3 |