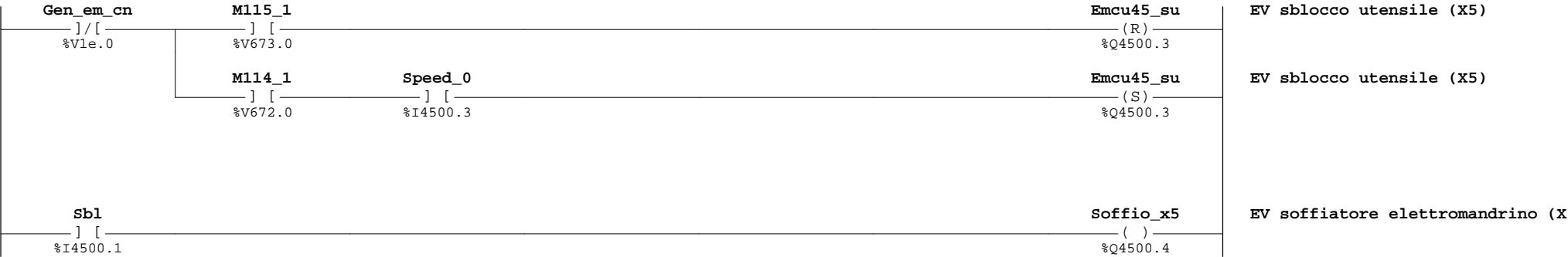
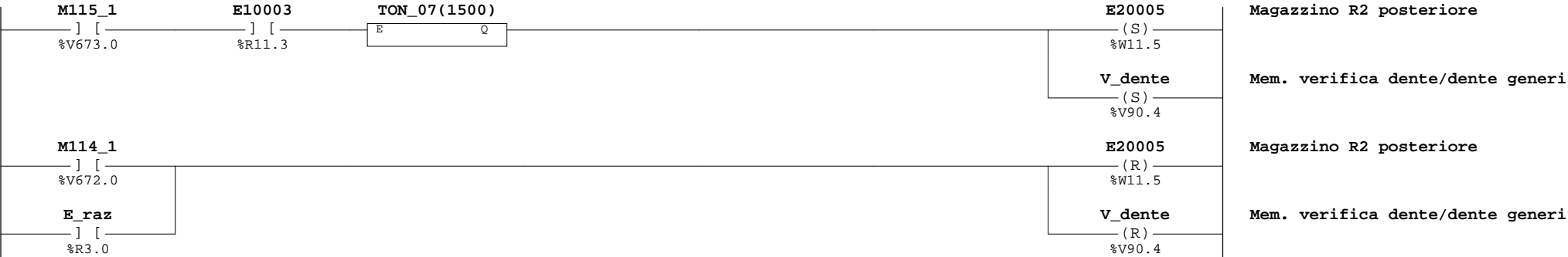


00 Label: Step:



01 Label: Step:



[T] TON_07(0x5dc) : TON_07(1500)

02 Label: Step:



Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE		Date 28-02-2018
Module: ELMANO~1.XLA	%SP51 (00)		Page 1

03 Label: Step:

Icil_basso	Icil_alto	(1)	Evolution	Gruppox5_on
] %I4500.4	[%I4500.6]/[] %M803.1	(R) %Q4501.1
Cuffia_dis				Gruppox5_off
] %I4500.7				(S) %Q4501.0
M117_1				App_iniz_lub.5
] %V675.0				(S) %V44.5
M116_1				App_iniz_lub.5
] %V674.0				(R) %V44.5
E_raz				
] %R3.0				
Ra47_0				
] %Ra47.0				

Discesa gruppo X5

Salita gruppo X5

Mem. appoggio inizio lubrificazi

Mem. appoggio inizio lubrificazi

(1) %V88.5, %V84.3, %Vf.6, %V44.5 : Ab_asst1, Test_ell, Pez_sblo, App_iniz_lub.5

04 Label: Step:

Verifica se AUT o MDI

(1)	Pres_ell, El_1_on	goto(END)
] %I4000.0, %Q4100.2]/[(T)
X_test_fora		goto(TESTIO)
] %V503.2]/[(T)
X_mod0_sim, E_oper		goto(AUTO)
] %V503.1, %R3.7]/[(T)
		goto(RESET)
		(F)

(1) %M800.4, %V100.0 : El_11kw, Conf_ell_cu

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: ELMANO~1.XLA		%SP51 (03)	Page 2

05 Label: TESTIO Step:

Inverter on						
(1)	X_conv == 1	Res_sell	Inv1_on_em1			
]	[]	[(S)		
	%V401.B == 0x1	%Q4101.3	%V8.0			
			Inv1_on_em1			
			(R)			
			%V8.0			
			Inv1_ccw_em1			
			()			
			%V8.1			

Mem. inverter 1 richiesto da EM1

Mem. inverter 1 richiesto da EM1

Mem. inverter 1 CCW da EM1

(1) %V84.3, %V22.6, %V402.1 : Test_el1, App_freq1_0, X_convon

06 Label: AUTO Step:

Inverter on			
(2)	App_freq1_0	Res_sell	Inv1_on_em1
]/[]/[]/[(S)
	%V22.6	%Q4101.3	%V8.0
			Inv1_ccw_em1
			(S)
			%V8.1
		Ra37_0	Ab_asst1
]/[(S)
		%Ra37.0	%V88.5

Mem. inverter 1 richiesto da EM1

Mem. inverter 1 CCW da EM1

Abilitazione discesa el.1

(1) %V503.1, %R3.7, %R11.3, %V33.0 : X_modosim, E_oper, E10003, Ciclo_cul
(2) %Ra4b.B & 0xf == 0x1 : Ra4b_4.B & 15 == 1
(3) %V503.1, %R3.7, %I4101.3, %R11.6, %V33.0 : X_modosim, E_oper, Setting, E10006, Ciclo_cul

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: ELMANO~1.XLA		%SP51 (05)	Page 3

07 Label: **RESET** Step:

Disabilitazione elettromandrino

E_raz] [%R3.0		Inv_eml = 0 (T) %V8.B = 0x0
M05_1, X_end] [%R122.2, %V503.0		Ab_asst1 (R) %V88.5
E10003] [%R11.3		
Ra47_1.B != 0]>[%Ra47.B != 0x0		

Abilitazione discesa el.1

08 Label: Step:

Rotazione elettromandrino

Inv1_on_eml] [%V8.0	Itir] [%I4500.2	E10030]/[%Re.6	E_arus]/[%R3.1	El_1_on () %Q4100.2
				Asp_1 () %Q5301.6
				As_1 () %Q4500.5

Rotazione el. 1 (Rapid 1)

EV aspirazione 1 (X5)

Abilitazione aspirazione central

09 Label: **END** Step:

Ra37_0] [%Ra37.0	Itir]/[%I4500.2	E10003]/[%R11.3	El1_sut (S) %V3b.0
Test_el1] [%V84.3	Sb1] [%I4500.1		
E30119 == 1]>[%Rd5c.L == 0x1			
E_raz] [%R3.0			El1_sut (R) %V3b.0
			E30119 = 0 (T) %Rd5c.L = 0x0

Elettromandrino 1 senza utensile

Elettromandrino 1 senza utensile

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE	Date	28-02-2018
Module: ELMANO~1.XLA		%SP51 (07)	Page 4

10 Label: Step:

Author:		NUM TOOLS	
Company:			
Project: 1040_78.mch	TITRE		Date 28-02-2018
Module: ELMANO~1.XLA	%SP51 (10)		Page 5