00 Label: Step:

Gestione modi da Xilog a Cn

Xil_modo == 2	**Modatt_0**	**Modedem = 0**
]>[%V506.W == 0x2	]/[%V24.0	(T) %W14.B = 0x0
Xil_modo == 5	**Modatt_1**	**Modedem = 1**
]>[%V506.W == 0x5	]/[%V24.1	(T) %W14.B = 0x1
Xil_modo == 4	**Modatt_2**	**Modedem = 2**
]>[%V506.W == 0x4	]/[%V24.2	(T) %W14.B = 0x2
Xil_modo == 1	**Modatt_7**	**Modedem = 7**
]>[%V506.W == 0x1	]/[%V24.3	(T) %W14.B = 0x7
Xil_modo == 3	**Modatt_8**	**Modedem = 8**
]>[%V506.W == 0x3	]/[%V24.4	(T) %W14.B = 0x8
Xil_modo == 0	**Modatt_11**	**Modedem = 11**
]>[%V506.W == 0x0	]/[%V24.5	(T) %W14.B = 0xb

01 Label: Step:

Selezione dei modi

Modcour != Modedem	**Modpup**	**Selezione dei modi CN da plc**
]>[%R16.B != %W14.B	(S) %W5.1	
Modcour == Modedem	**Modpup**	**Selezione dei modi CN da plc**
]>[%R16.B == %W14.B	(R) %W5.1	

02 Label: Step:

Gestione modi da Cn a Xilog

03 Label: Step:

Gestione modi da Cn a Xilog

04 Label: Step: Gestione jog da Xilog a Cn

05 Label: Step: Gestione jog da Cn a Xilog

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Company:		
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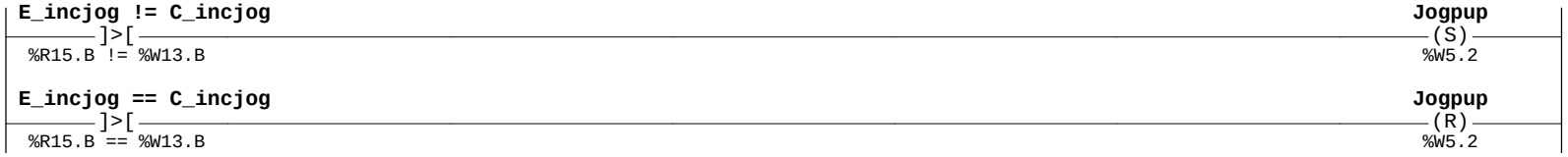
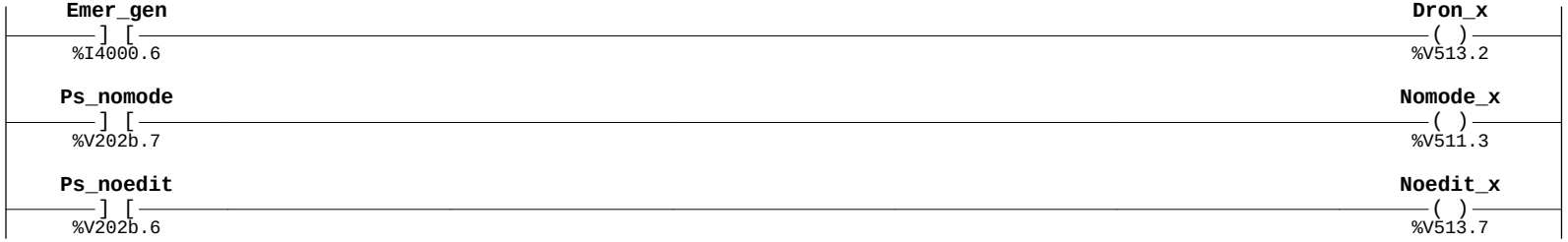
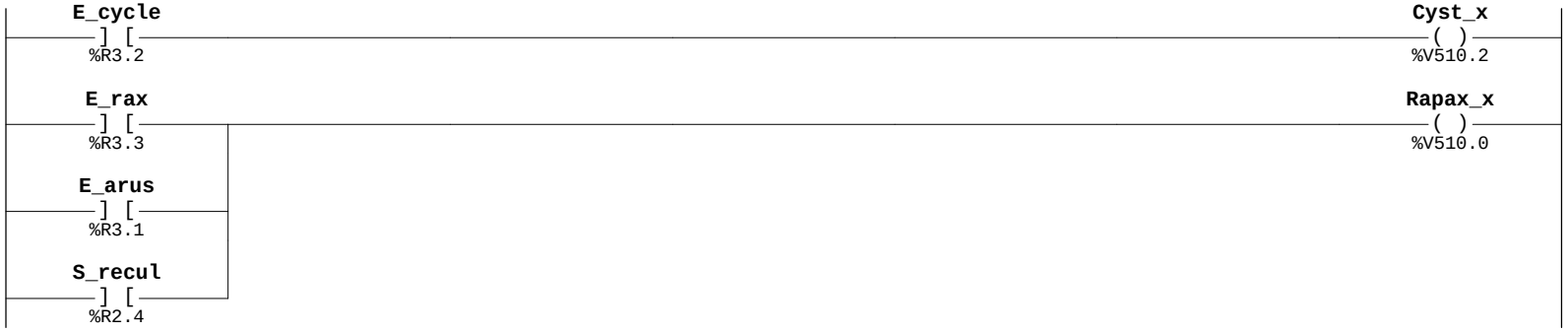
06 Label: Step: Selezione del tipo di jog



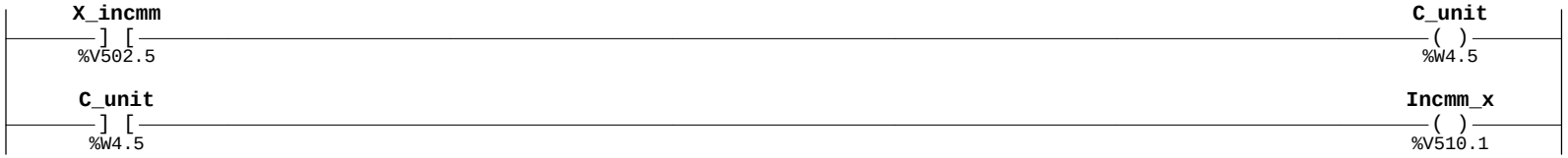
07 Label: Step: Emergenza, no mode, no edit a Xilog



08 Label: Step: Ciclo in corso, richiamo assi , mm/inch a Xilog



09 Label: Step: Gestione unità di misura



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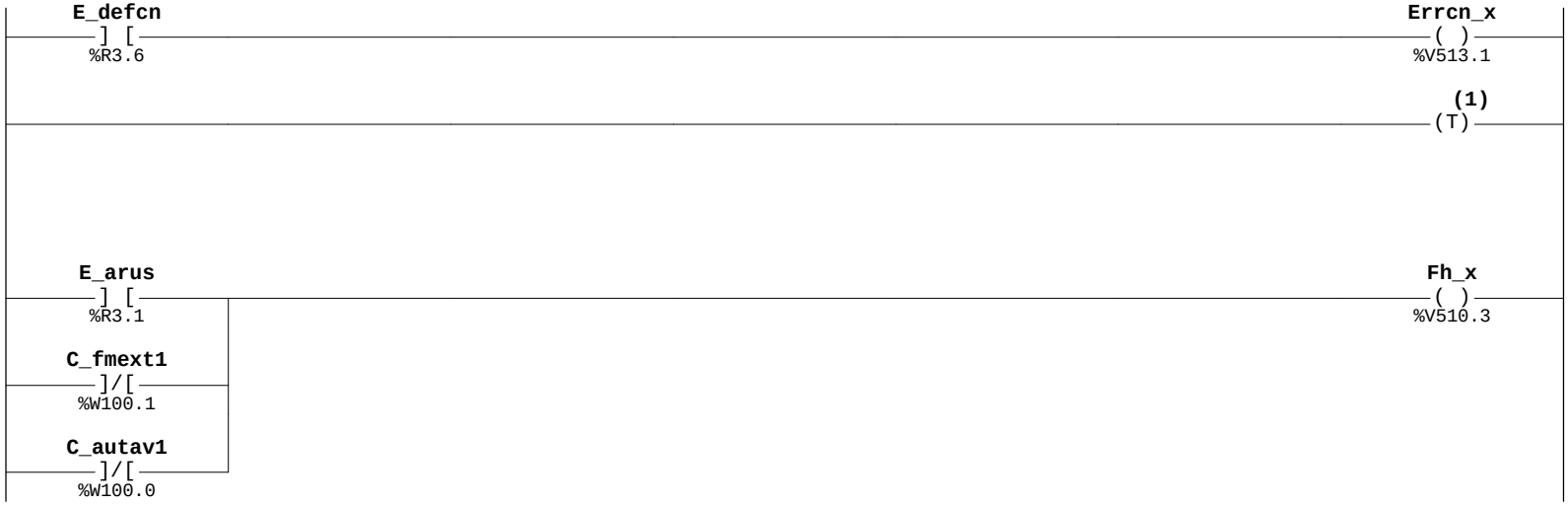
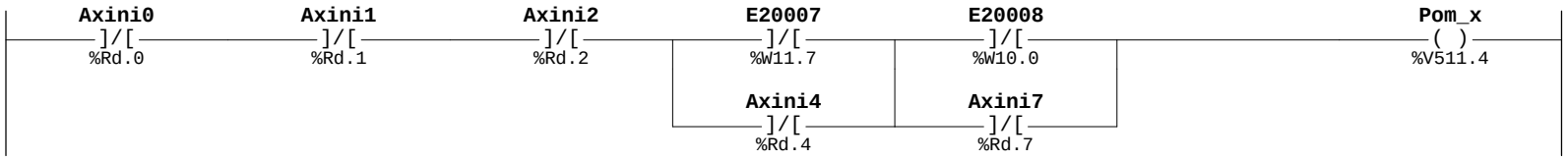
10 Label: Step: Cnc in errore, hold assi



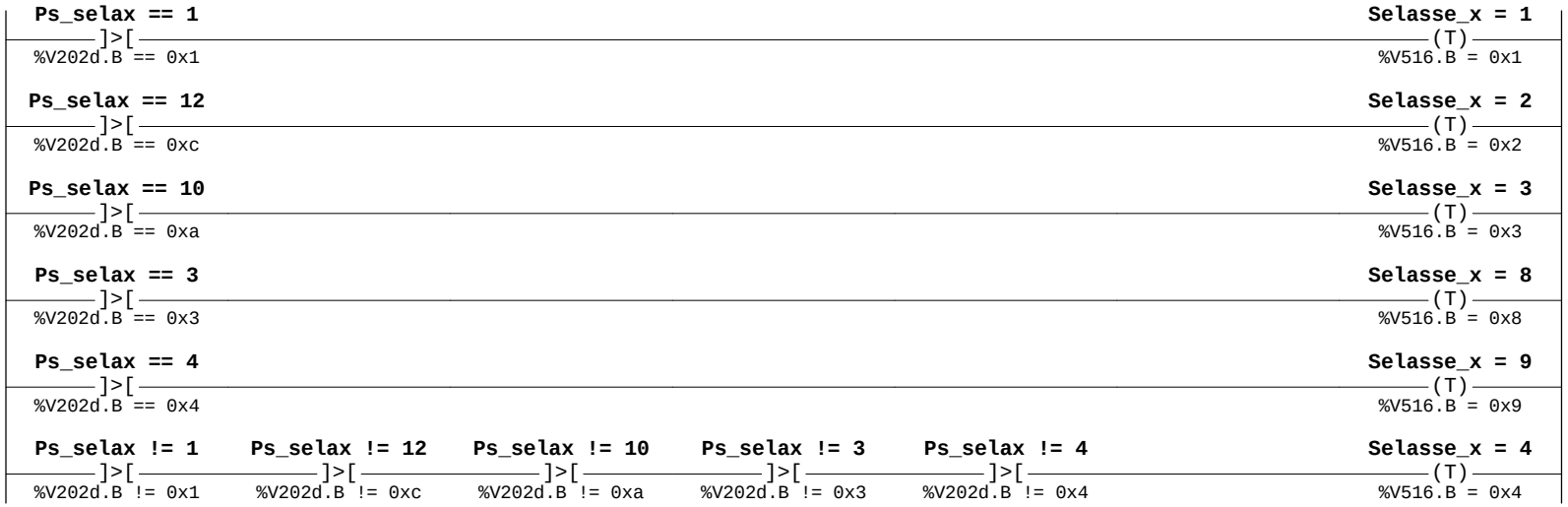
(1) %V521.B = %R18.B : Cn_all_x = Errmach

11 Label: Step: Gestione assi in movimento a Xilog

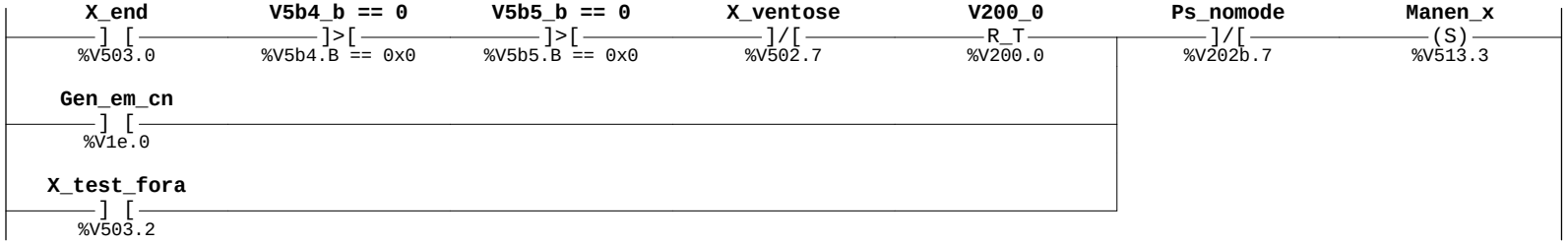
12 Label: Step: Gestione assi tarati a Xilog



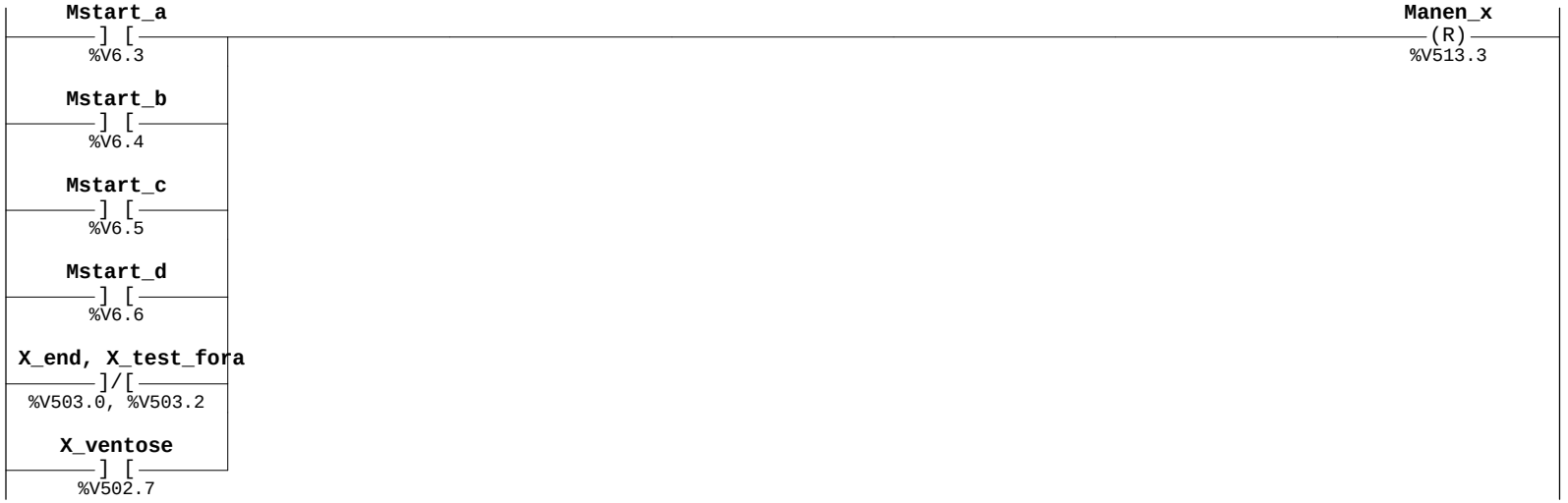
13 Label: Step: Gestione selettore assi a Xilog



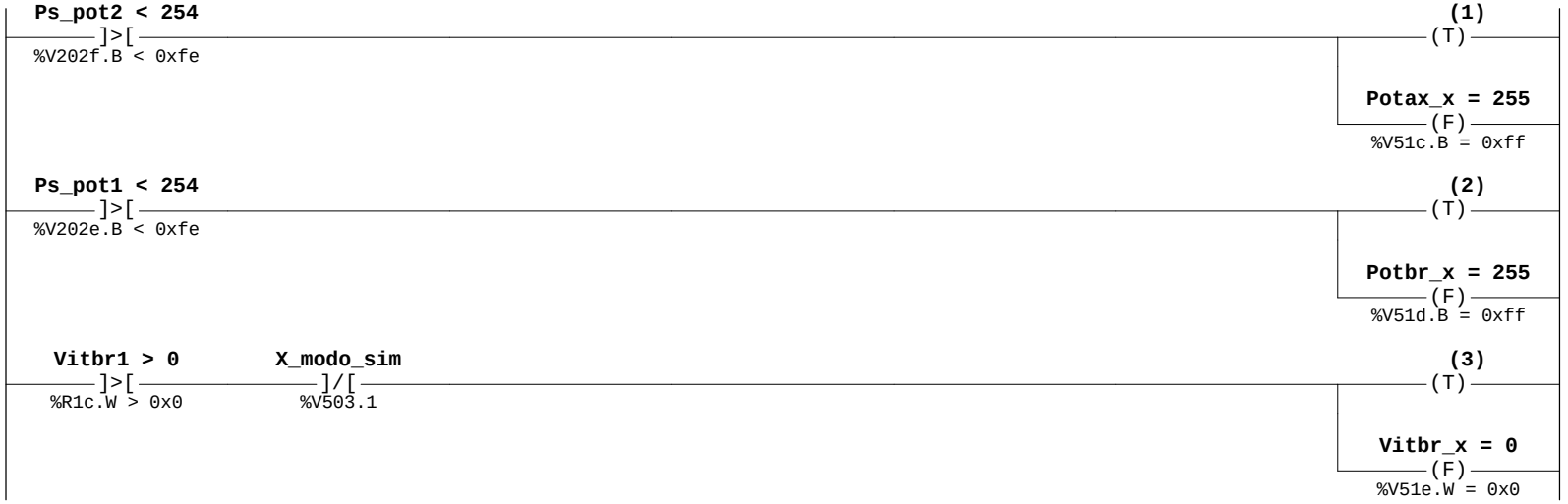
14 Label: Step: Gestione richiesta manuale in modo automatico



15 Label: Step: Gestione richiesta manuale in modo automatico



16 Label: Step: Gestione valore potenziometri a Xilog



(1) %V51c.B = %V202f.B : Potax_x = Ps_pot2
(2) %V51d.B = %V202e.B : Potbr_x = Ps_pot1
(3) %V51e.W = %R1c.W * 0xc350 / 0x7fff + 0x1 : Vitbr_x = Vitbr1 * 50000 / 32767 + 1

17 Label: Step: Gestione tastatore