

```
00 Label:
```

Step:

Reset memorie PDL

					Velocita = 997	
					(T)	
					%V4400.L = 0x3e5	
Bit_all			Bit_all_x		Presenza allarmi piano motorizz	
] [()			
%V7a00.2			%V525.6			
Input_1_6	Input_7_12	Tent_pv == 0	V_sb_vent_a	T_in_corso	Sb_vent_a	Blocco/sblocco ventose area A
] [] [] > [] [] / [(S)	
%V4033.1	%V4033.2	%M5d.W == 0x0	%V4040.0	%V4562.1	%Q5201.2	
Fine_tent			V_sb_vent_b	T_in_corso	Sb_vent_b	Blocco/sblocco ventose area B
] [] [] / [(S)	
%V4562.0			%V4040.1	%V4562.1	%Q5201.3	
			V_sb_vent_c	T_in_corso	Sb_vent_c	Blocco/sblocco ventose area C
] [] / [(S)	
			%V4040.2	%V4562.1	%Q5201.4	
			V_sb_vent_d	T_in_corso	Sb_vent_d	Blocco/sblocco ventose area D
] [] / [(S)	
			%V4040.3	%V4562.1	%Q5201.5	

01 Label:

Step:

Ps_f2] [_____ %V202b.1	App_setupa] [_____ %V4034.0 App_setupb] [_____ %V4034.1	App_setupc] [_____ %V4034.2 App_setupd] [_____ %V4034.3	Msg_psf2 (S) _____ %V4031.3
Ps_f2] [_____ %V202b.1	X_end]/[_____ %V503.0	Sel_man_aut]/[_____ %I4101.4	Psf2_xend () _____ %V4031.4
	%V216.2 _____R_T_____	%V216.3 _____R_T_____	

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02 Label: Step:

Raz_icla		goto(END)	
] [(F)	
%V4031.2			
Psf2_xend		Emer_gen	
] []/[
%V4031.4		%I4000.6	
No_setup	Rich_raz_pan	X_bltypea	
]	[]	
%V4030.2	%V21.0	%V1151.3	
Alarm_pgm		X_bltypeb	
]]	
%V4031.5		%V1151.4	
Msg_psf2		X_bltypec	
]]	
%V4031.3		%V1151.5	
		X_bltyped	
]	
		%V1151.6	

03 Label: RESET Step:

M1512 = 0	M1514 = 0	M1518 = 0	I_biterr = 0	I_maskerr = 0	N_tentativi = 0	M151c = 0
T	T	T	T	T	T	(T)
%M1512.W = 0x0	%M1514.W = 0x0	%M1518.W = 0x0	%M151a.W = 0x0	%M153c.W = 0x0	%M1508.W = 0x0	%M151c.W = 0x0
Remove_pv = 0	Setup_pv = 0	Verify_pv = 0	(1)	Test_pgm = 0	Jog_pv = 0	M151e = 0
T	T	T	T	T	T	(T)
%M52.W = 0x0	%M54.W = 0x0	%M56.W = 0x0		%M48.W = 0x0	%M5b.W = 0x0	%M151e.W = 0x0
Index_setup = 0	(2)	Index_plc = 0	Index_170 = 0	(3)	Tent_pv = 0	(4)
T	T	T	T	T	T	(T)
%V402a.W = 0x0		%V402e.W = 0x0	%V402c.W = 0x0		%M5d.W = 0x0	
Init_icla				Raz_pv = 0	Emer_move = 0	Movimento_pv
]				T	T	(R)
%V4033.7				%M58.W = 0x0	%M46.W = 0x0	%V4032.0
						Res_emer
						(R)
						%V4033.0
P1_8_no_ok = 0	P9_14_no_ok = 0					N_tentativi = 0
T	T					(T)
%V4560.B = 0x0	%V4561.B = 0x0					%M1508.W = 0x0

- (1) %M50.W = 0x0 : Start_motori = 0
- (2) %V4036.W = 0x0 : Index_verify = 0
- (3) %V4038.W = 0x0 : Index_remove = 0
- (4) %V4038.W = 0x0 : Index_remove = 0

piani o ventose in movimento

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04 Label: Step:

	Init_icla	reset memorie all'inizializzazio
	(R)	
	%V4033.7	
	Remove_pdl	Start ciclo di parcheggio e rimo
	(R)	
	%V4031.6	
	Setup_pdl	start ciclo di setup
	(R)	
	%V4030.1	
	Verify_pdl	start ciclo di verifica
	(R)	
	%V4030.5	
	M170_ok	lettura valore 170
	(R)	
	%V4030.3	
Msg_185	Msg_psf2	
] [(R)	
%V3038.0	%V4031.3	

05 Label: Step:

	Move_ok	Predisposizione start motori
	(R)	
	%V4030.0	
	%Q5500.4	
	(R)	
	Alarm_pgm	tentativo di posizionare una ven
	(R)	
	%V4031.5	
	Step_setup	fine posizionamento step SETUP
	(R)	
	%V4030.4	
	Step_verify	fine posizionamento step VERIFIC
	(R)	
	%V4030.6	
	Step_park	fine posizionamento step PARCHEG
	(R)	
	%V4032.4	

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06 Label: Step:

	End_move (R)	movimentazione motori eseguita
	%V4031.0	
	Start_move (R)	start movimentazione motori
	%V4030.7	
	Input_1_6 (R)	input pistoncini ventose: piani
	%V4033.1	
	Input_7_12 (R)	input pistoncini ventose: piani
	%V4033.2	
	Input_ab_cd (R)	input pistoncini piani area AB,
	%V4033.3	
	Remove (R)	bit MSG rimozione ventose
	%V4033.4	

07 Label: Step:

	App_setupa (R)	appoggio start setup area A
	%V4034.0	
	App_setupb (R)	appoggio start setup area B
	%V4034.1	
	App_setupc (R)	appoggio start setup area C
	%V4034.2	
	App_setupd (R)	appoggio start setup area D
	%V4034.3	
	Jog_icla (R)	Jog motori PDL
	%V4032.1	
	No_setup (R)	bit setup non programmato
	%V4030.2	

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08 Label: Step:

	Check_ab	verifica sblocco avvenuto area A
	(R)	
	%V4032.5	
	Check_cd	verifica sblocco avvenuto area C
	(R)	
	%V4032.6	
	Stjogpm_x	Comando JOG [Piano Mot.]
	(R)	
	%V524.7	
	Fine_tent	
	(R)	
	%V4562.0	
	T_in_corso	
	(R)	
	%V4562.1	
	Agg_ok	
	(R)	
	%V4562.3	

09 Label: Step:

	Ps_ledf4	Led tasto F4
	(R)	
	%V200c.5	
	Setupa_x	Setup area A
	(R)	
	%V52e.3	
	Setupb_x	Setup area B
	(R)	
	%V52e.4	
	Setupc_x	Setup area C
	(R)	
	%V525.2	
	Setupd_x	Setup area D
	(R)	
	%V525.3	

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10 Label: Step:

	Fine_tent_d
	(R)
	%V4600.4
	Fine_tent_c
	(R)
	%V4600.3
	Fine_tent_b
	(R)
	%V4600.2
	Fine_tent_a
	(R)
	%V4600.1

11 Label: END Step:

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