Totally Integrated Automation Portal		
---	--	--

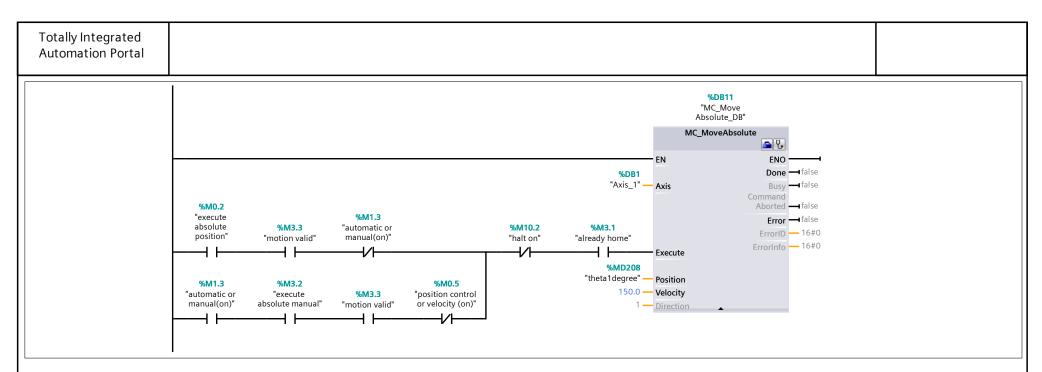
fix_plc / PLC_1 [CPU 1214C DC/DC/DC] / Program blocks

Motion Control [FC10]

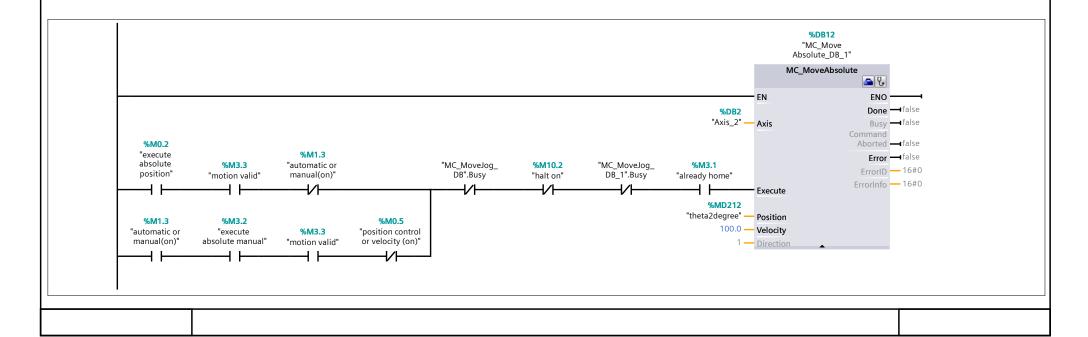
Motion Control Properties								
General								
Name	Motion Control	Number	10	Туре	FC	Language	LAD	
Numbering	Automatic							
Information								
Title		Author		Comment		Family		
Version	0.1	User-defined ID						

Motion Control							
Name	Data type	Default value	Comment				
Input							
Output							
InOut							
Temp							
Constant							
▼ Return							
Motion Control	Void						

Network 1:

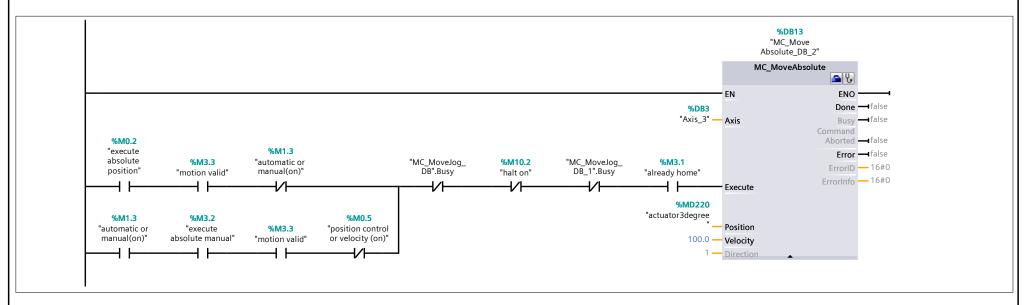


Network 2:

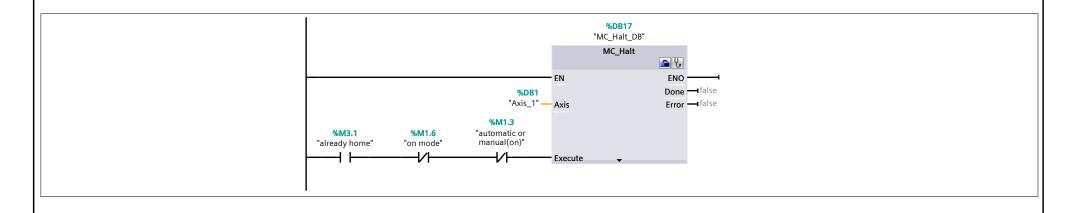


Totally Integrated
Automation Portal

Network 3:



Network 4: Dùng chuyển động của trục



Totally Integrated **Automation Portal** Network 5: %DB18 "MC_Halt_DB_1" MC_Halt ENO -Done → false %DB2 "Axis_2" — Axis Error — false %M1.3 %M3.1 %M1.6 "automatic or "already home" "on mode" manual(on)" Execute Network 6: **%DB19**"MC_Halt_DB_2" MC_Halt ENO -Done → false %DB3 "Axis_3" — Axis Error → false

%M1.3

"automatic or manual(on)"

Execute

%M3.1

"already home"

%M1.6

"on mode"