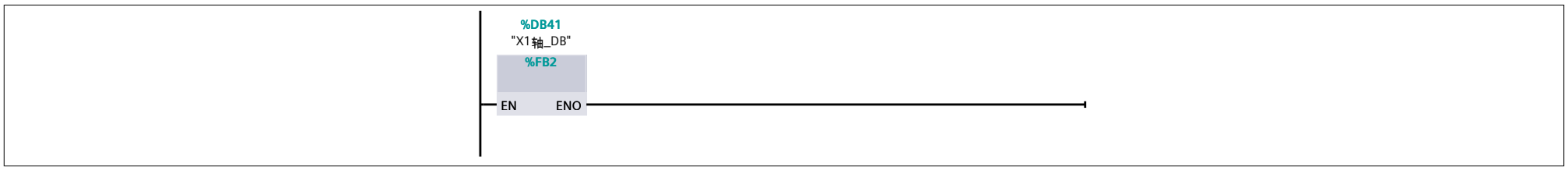
机电 203 第三组_V16 / PLC_1 [CPU 1215C DC/DC/DC] / 程序块

Main [OB1]

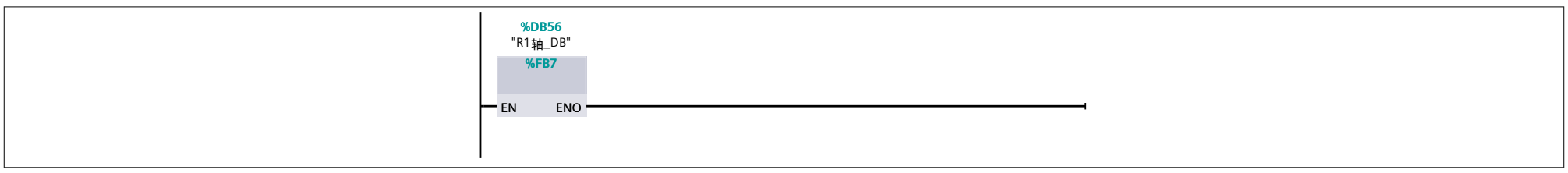
Main 属性							
常规							
名称	Main	**编号**	1	**类型**	OB	**语言**	LAD
编号	自动						
信息							
标题	"Main Program Sweep (Cycle)"	**作者**		**注释**		**系列**	
版本	0.1	**用户自定义 ID**					

Main			
名称	**数据类型**	**默认值**	**注释**
▼ Input			
Initial_Call	Bool		Initial call of this OB
Remanence	Bool		=True, if remanent data are available
Temp			
Constant			

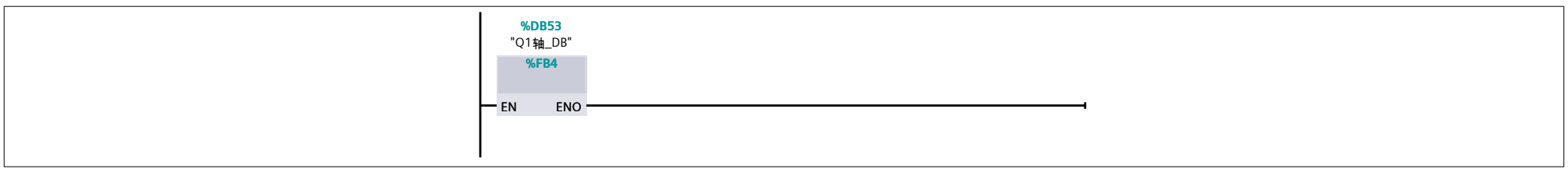
网络 1：



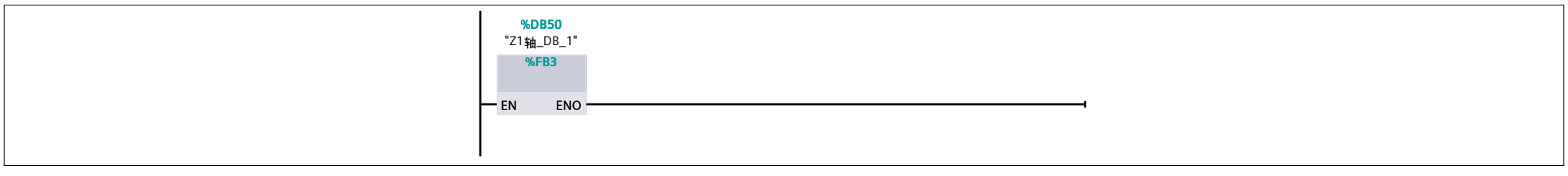
网络 2：



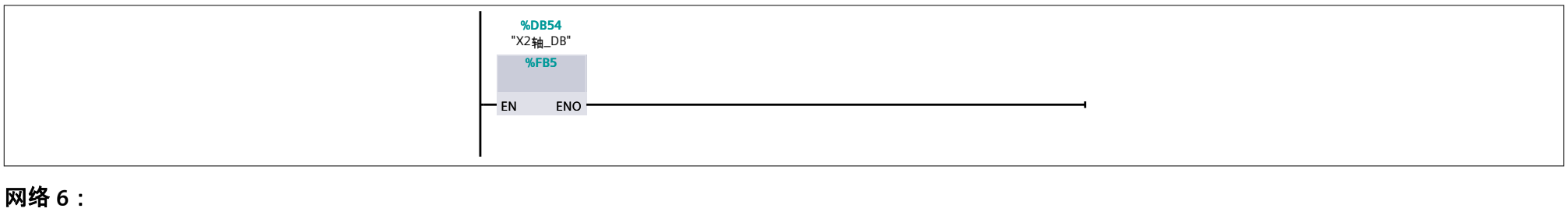
网络 3：



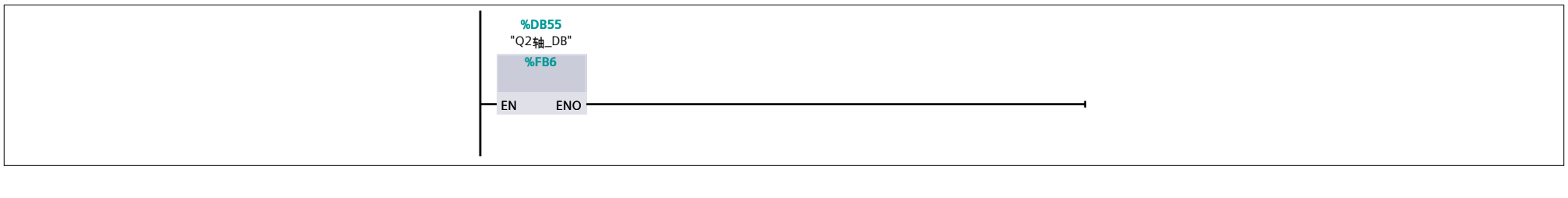
网络 4：



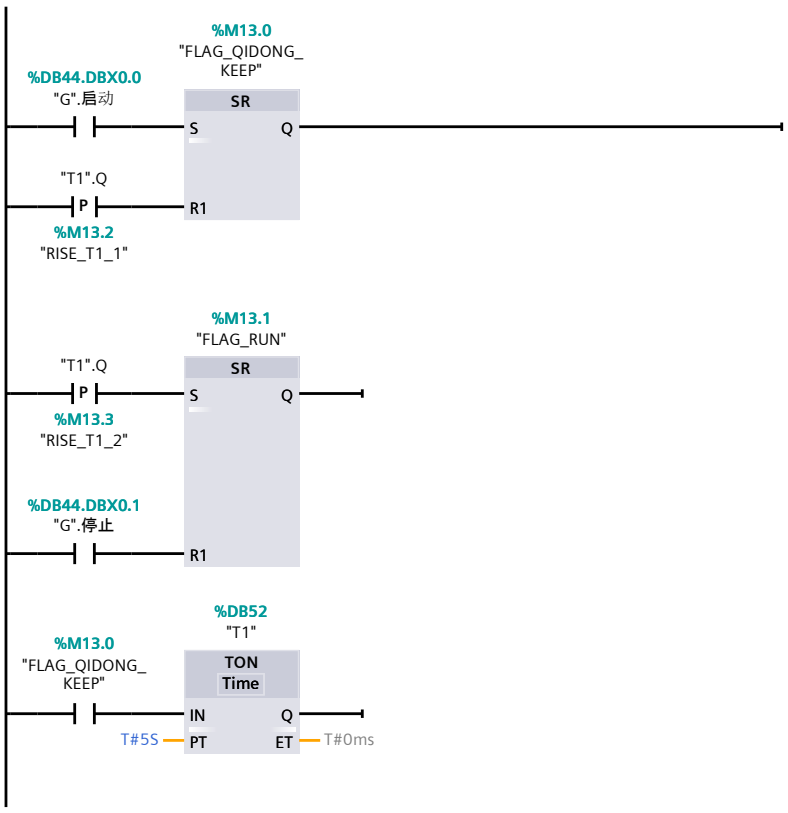
网络 5：



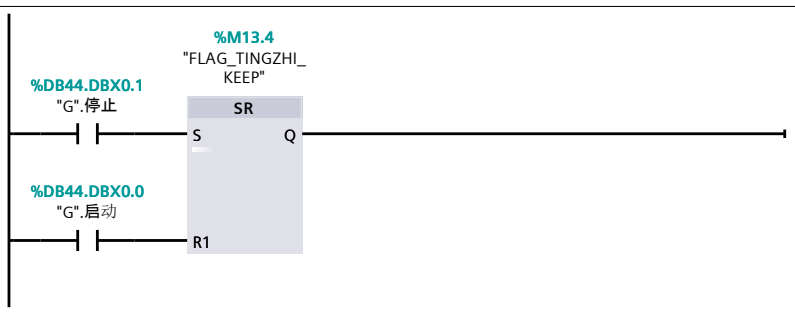
网络 6：



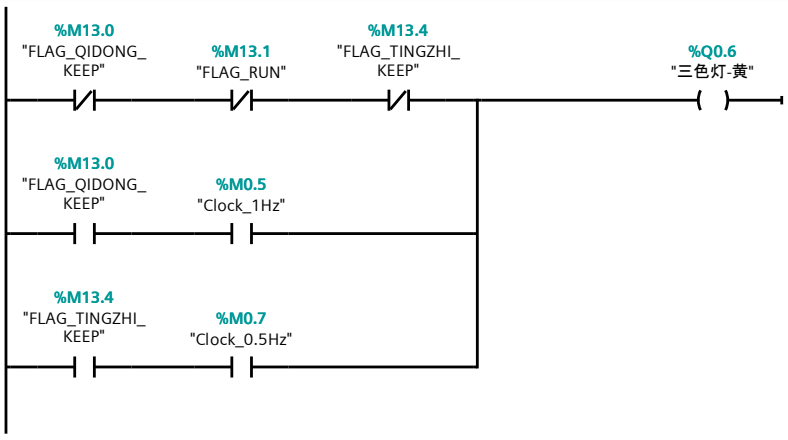
网络 7：启动状态处理



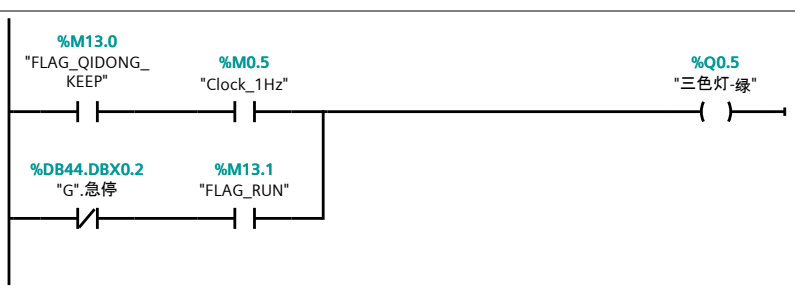
网络 8：停止状态处理



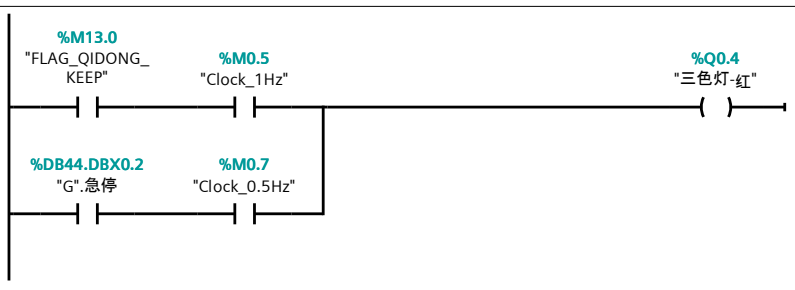
网络 9：红灯



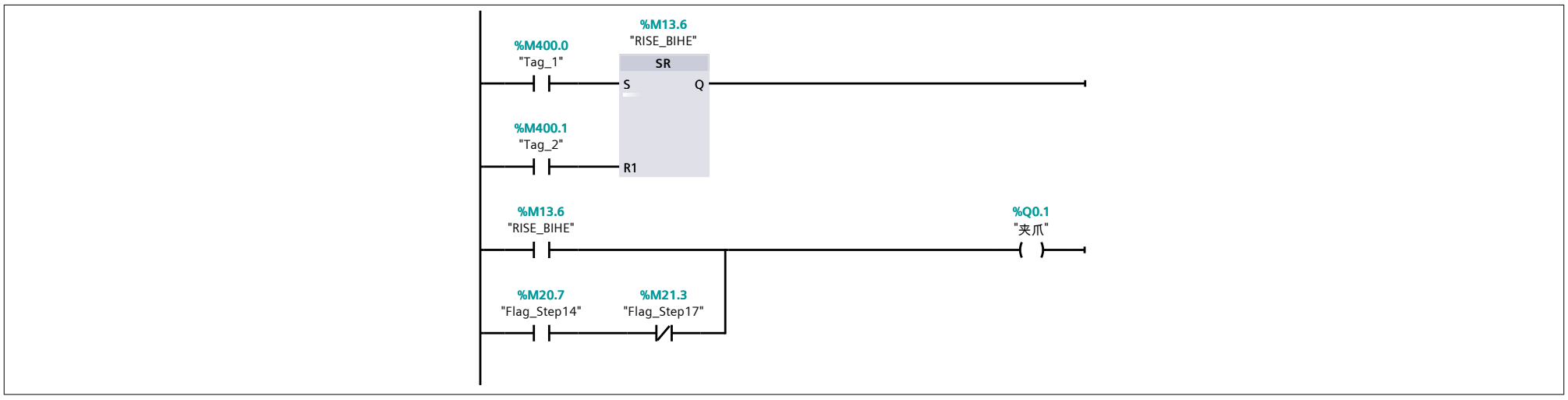
网络 10：绿灯



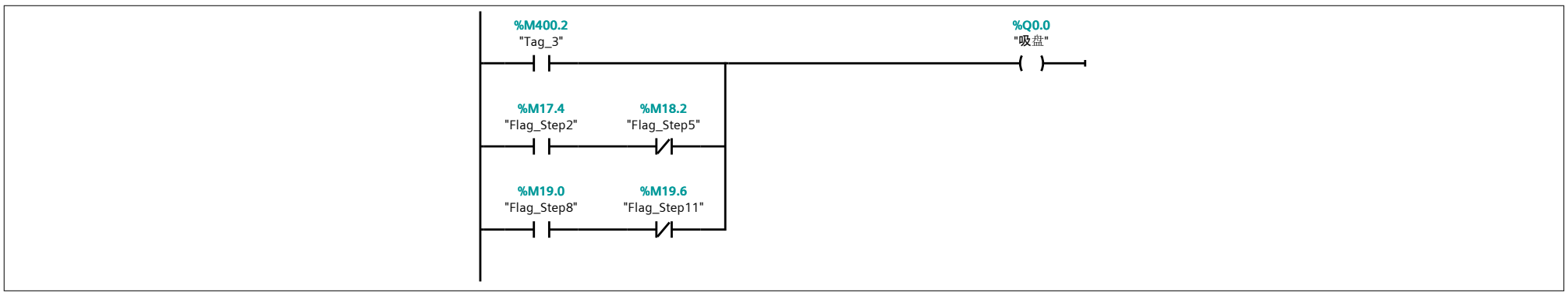
网络 11：黄灯



网络 12：夹爪

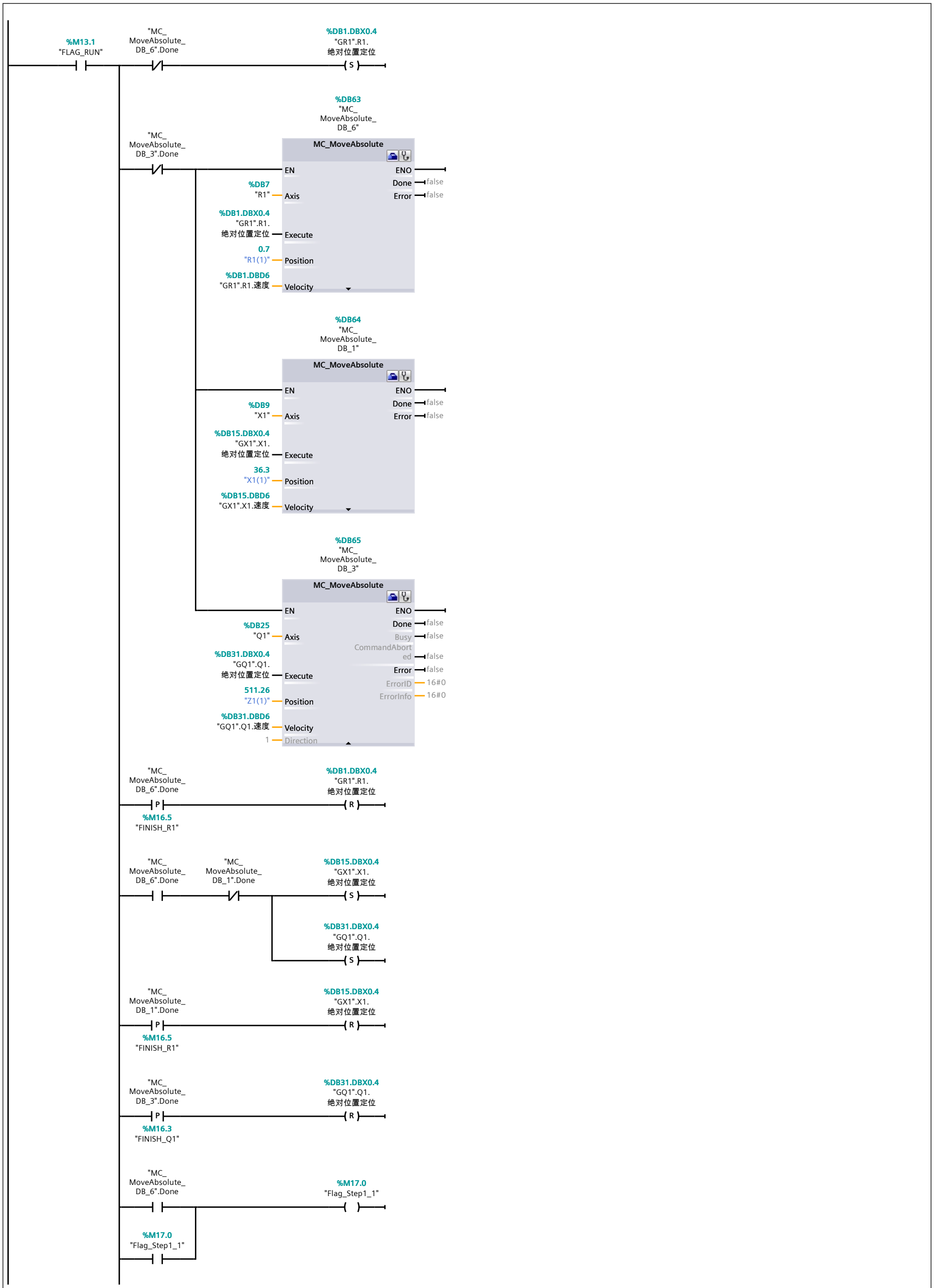


网络 13：吸盘



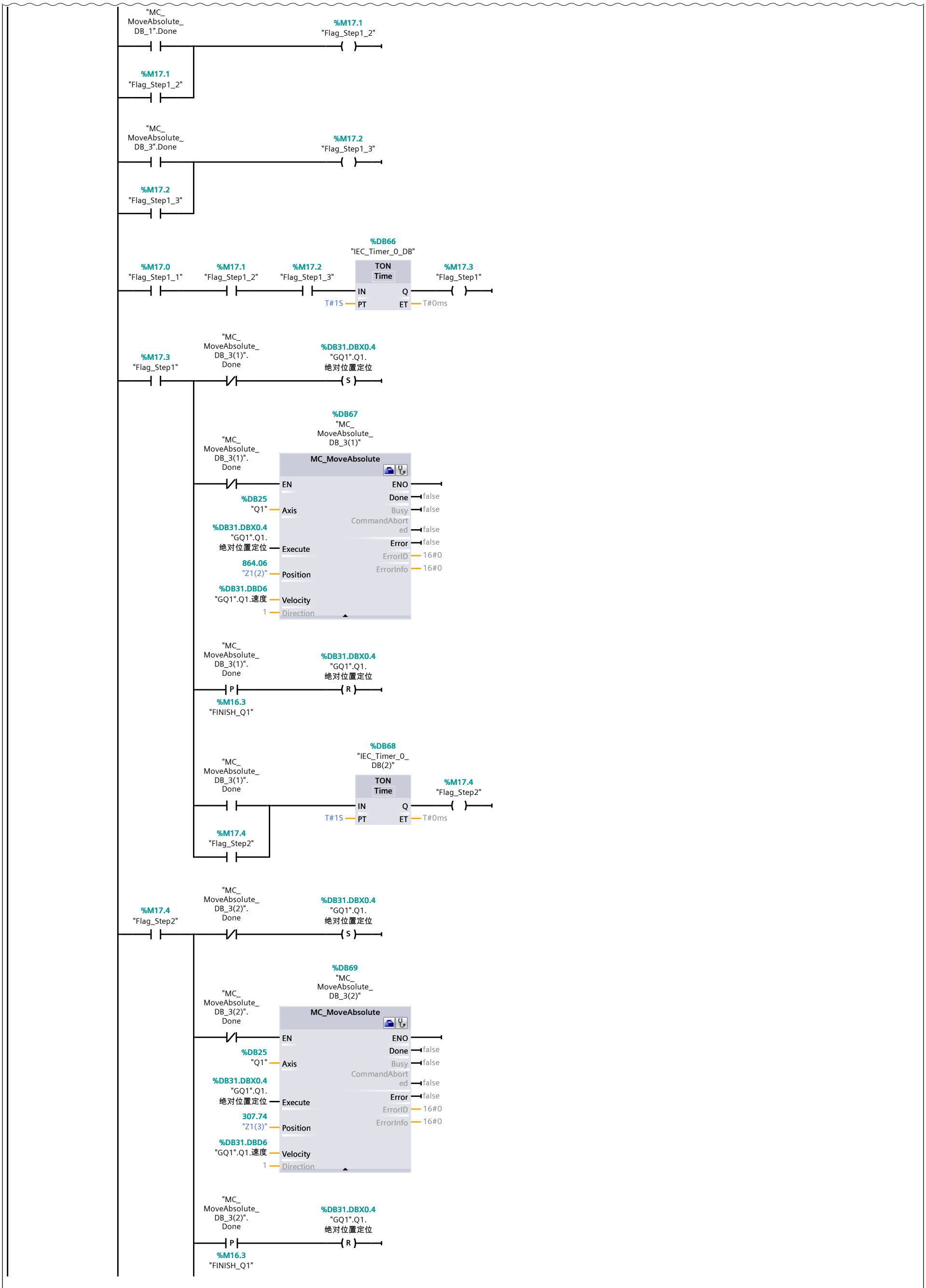
网络 14：

网络 14：（1.1 / 4.1）


%M13.1
"FLAG_RUN"
"MC_
MoveAbsolute_
DB_6".Done
%DB1.DBX0.4
"GR1".R1.
绝对位置定位
S
%DB63
"MC_
MoveAbsolute_
DB_6"
"MC_
MoveAbsolute_
DB_3".Done
MC_MoveAbsolute
EN
ENO
%DB7
"R1"
Axis
Done
false
Error
false
%DB1.DBX0.4
"GR1".R1.
绝对位置定位
Execute
0.7
"R1(1)"
Position
%DB1.DBD6
"GR1".R1.速度
Velocity
%DB64
"MC_
MoveAbsolute_
DB_1"
MC_MoveAbsolute
EN
ENO
%DB9
"X1"
Axis
Done
false
Error
false
%DB15.DBX0.4
"GX1".X1.
绝对位置定位
Execute
36.3
"X1(1)"
Position
%DB15.DBD6
"GX1".X1.速度
Velocity
%DB65
"MC_
MoveAbsolute_
DB_3"
MC_MoveAbsolute
EN
ENO
%DB25
"Q1"
Axis
Done
false
Busy
false
CommandAborted
false
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
Execute
Error
false
511.26
"Z1(1)"
Position
ErrorID
16#0
%DB31.DBD6
"GQ1".Q1.速度
Velocity
ErrorInfo
16#0
1
Direction
"MC_
MoveAbsolute_
DB_6".Done
%DB1.DBX0.4
"GR1".R1.
绝对位置定位
P
R
%M16.5
"FINISH_R1"
"MC_
MoveAbsolute_
DB_6".Done
"MC_
MoveAbsolute_
DB_1".Done
%DB15.DBX0.4
"GX1".X1.
绝对位置定位
S
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
S
"MC_
MoveAbsolute_
DB_1".Done
%DB15.DBX0.4
"GX1".X1.
绝对位置定位
P
R
%M16.5
"FINISH_R1"
"MC_
MoveAbsolute_
DB_3".Done
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
P
R
%M16.3
"FINISH_Q1"
"MC_
MoveAbsolute_
DB_6".Done
%M17.0
"Flag_Step1_1"
%M17.0
"Flag_Step1_1"

网络 14：（2.1 / 4.1）

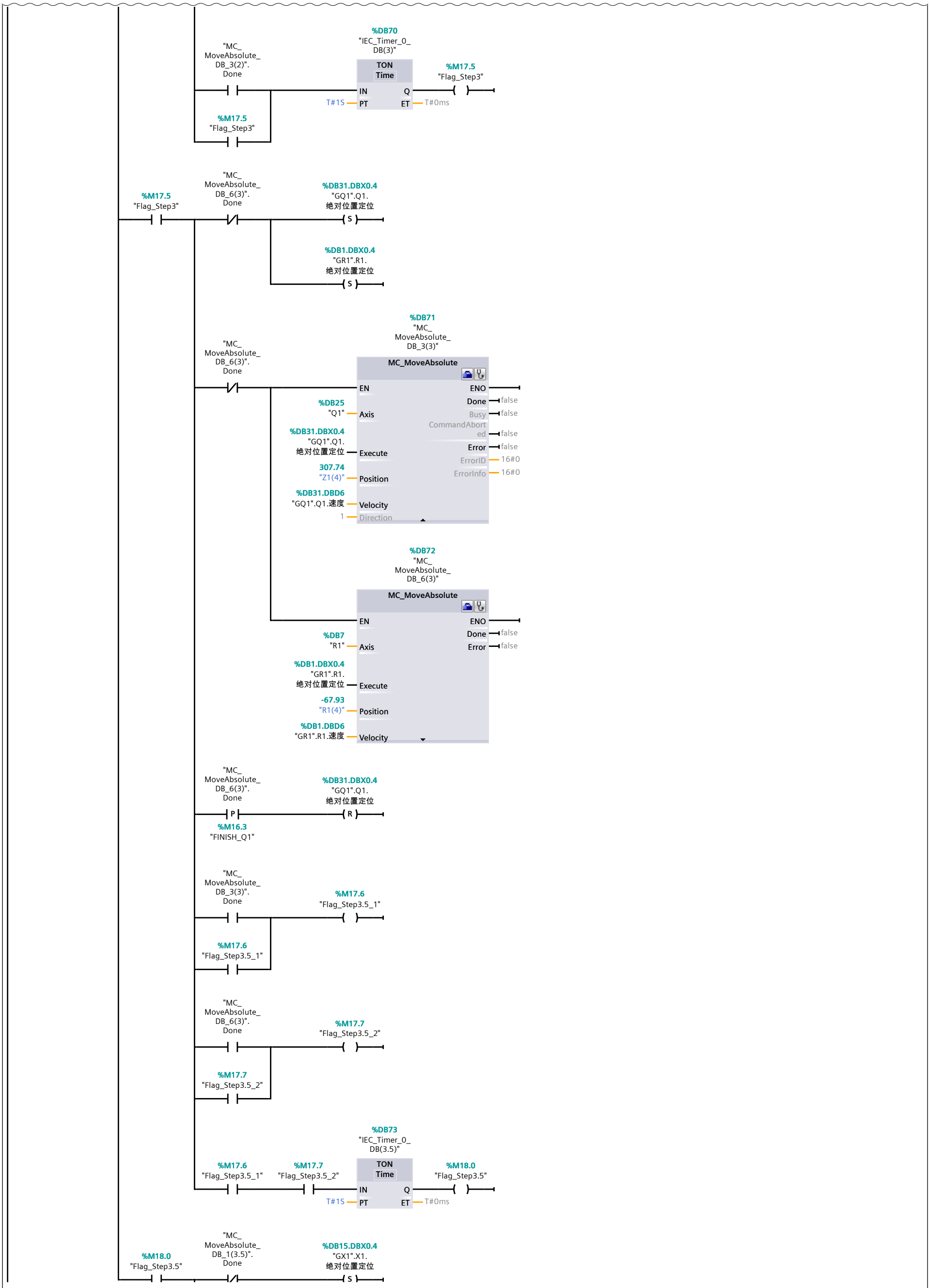
1.1 (页 1 - 4)



3.1 (页 1 - 6)

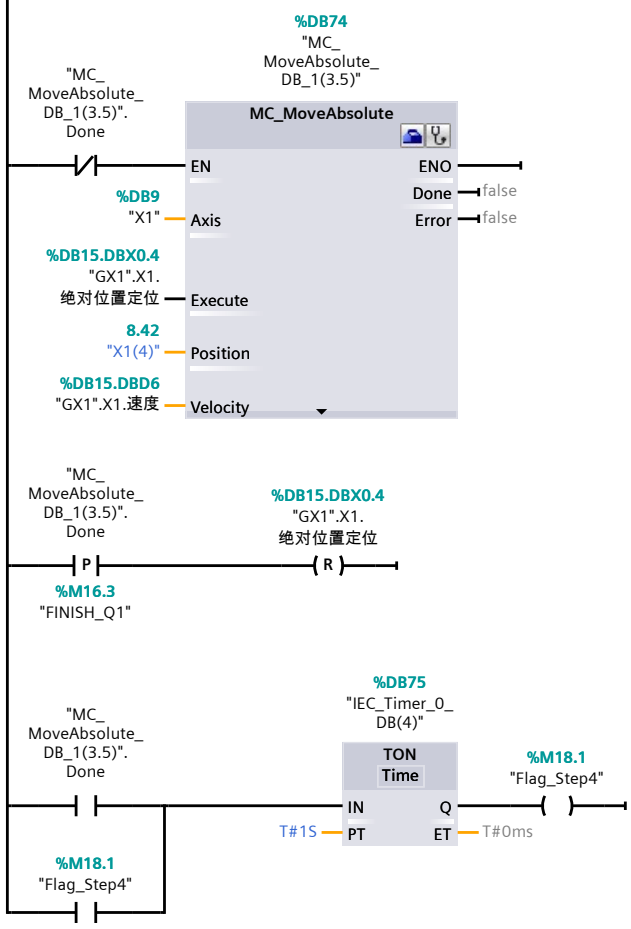
网络 14：（3.1 / 4.1）

2.1 (页 1 - 5)

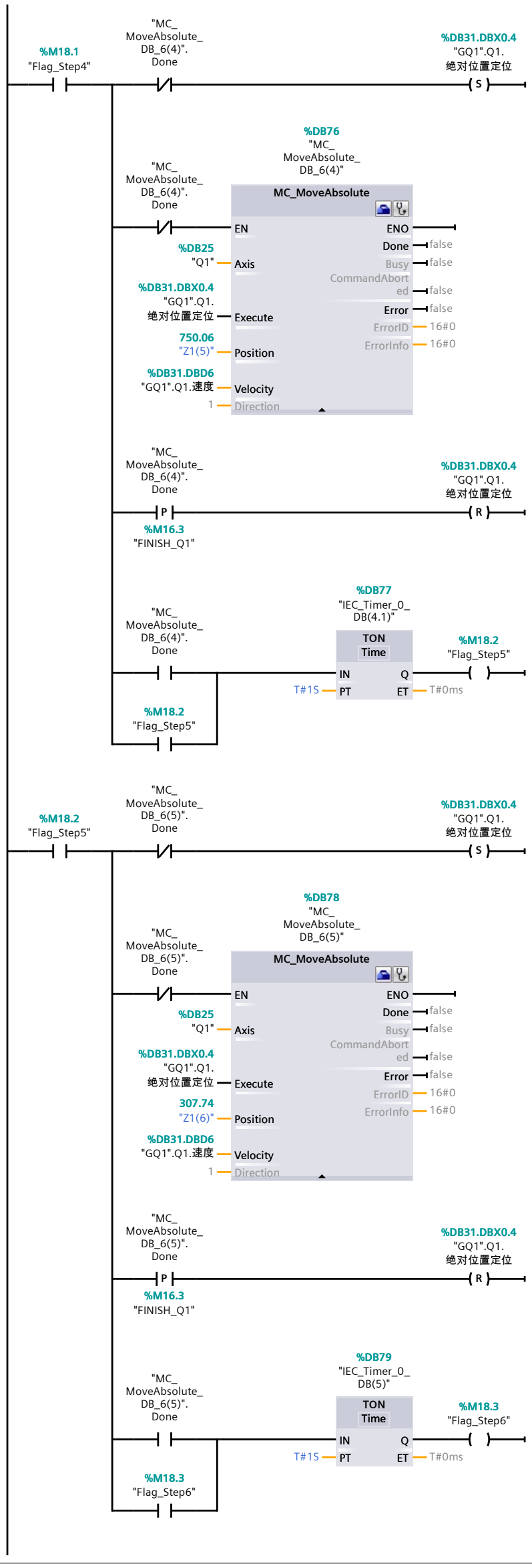


4.1 (页 1 - 7)

网络 14：（4.1 / 4.1）

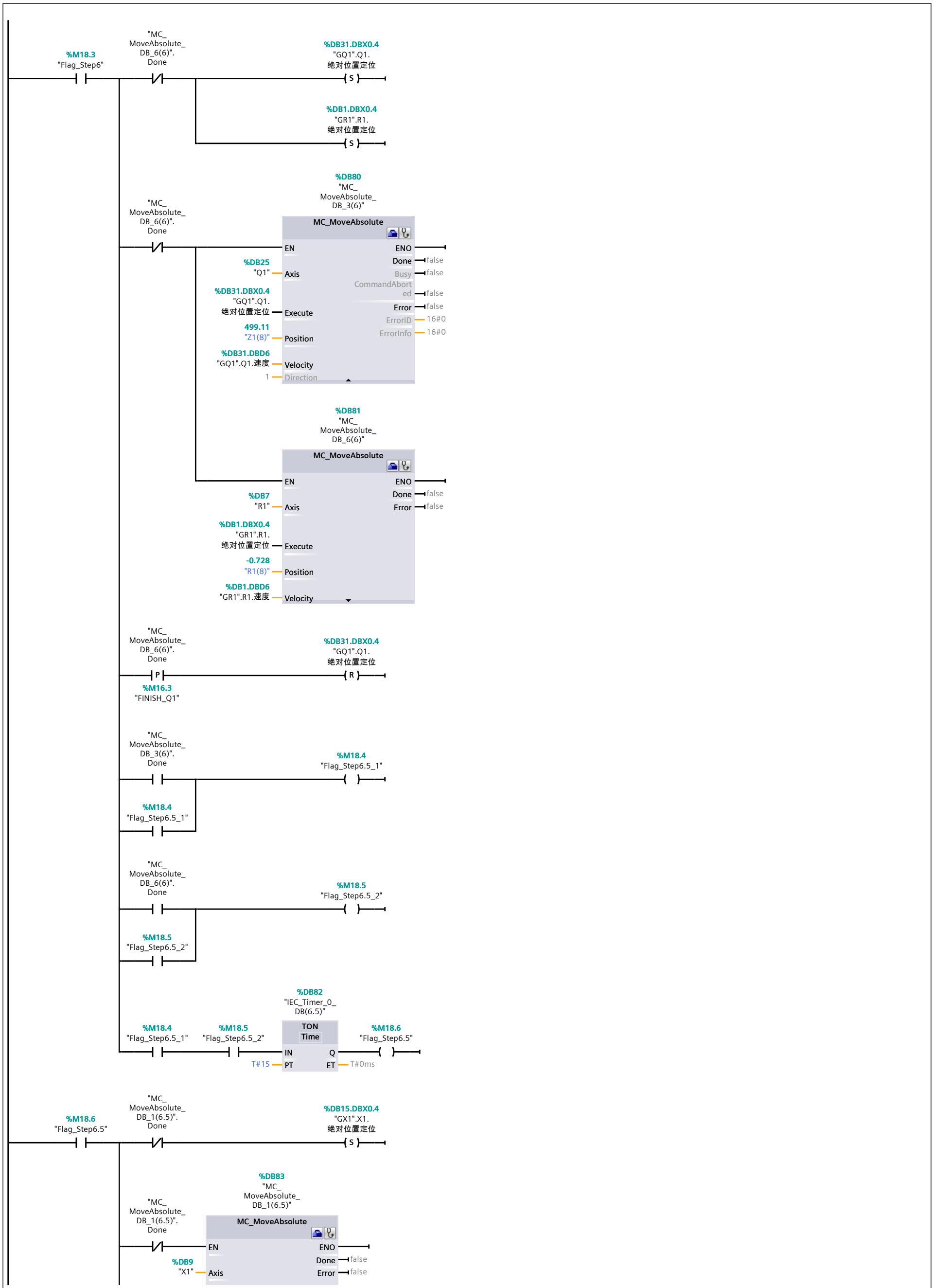

%DB74
"MC_
MoveAbsolute_
DB_1(3.5)"
"MC_
MoveAbsolute_
DB_1(3.5)".
Done
MC_MoveAbsolute
EN
ENO
%DB9
"X1"
Axis
Done
false
Error
false
%DB15.DBX0.4
"GX1".X1.
绝对位置定位
Execute
8.42
"X1(4)"
Position
%DB15.DBD6
"GX1".X1.速度
Velocity
"MC_
MoveAbsolute_
DB_1(3.5)".
Done
P
%M16.3
"FINISH_Q1"
%DB15.DBX0.4
"GX1".X1.
绝对位置定位
R
%DB75
"IEC_Timer_0_
DB(4)"
"MC_
MoveAbsolute_
DB_1(3.5)".
Done
TON
Time
IN
Q
T#1S
PT
ET
T#0ms
%M18.1
"Flag_Step4"
%M18.1
"Flag_Step4"
%M18.1
"Flag_Step4"

网络 15：

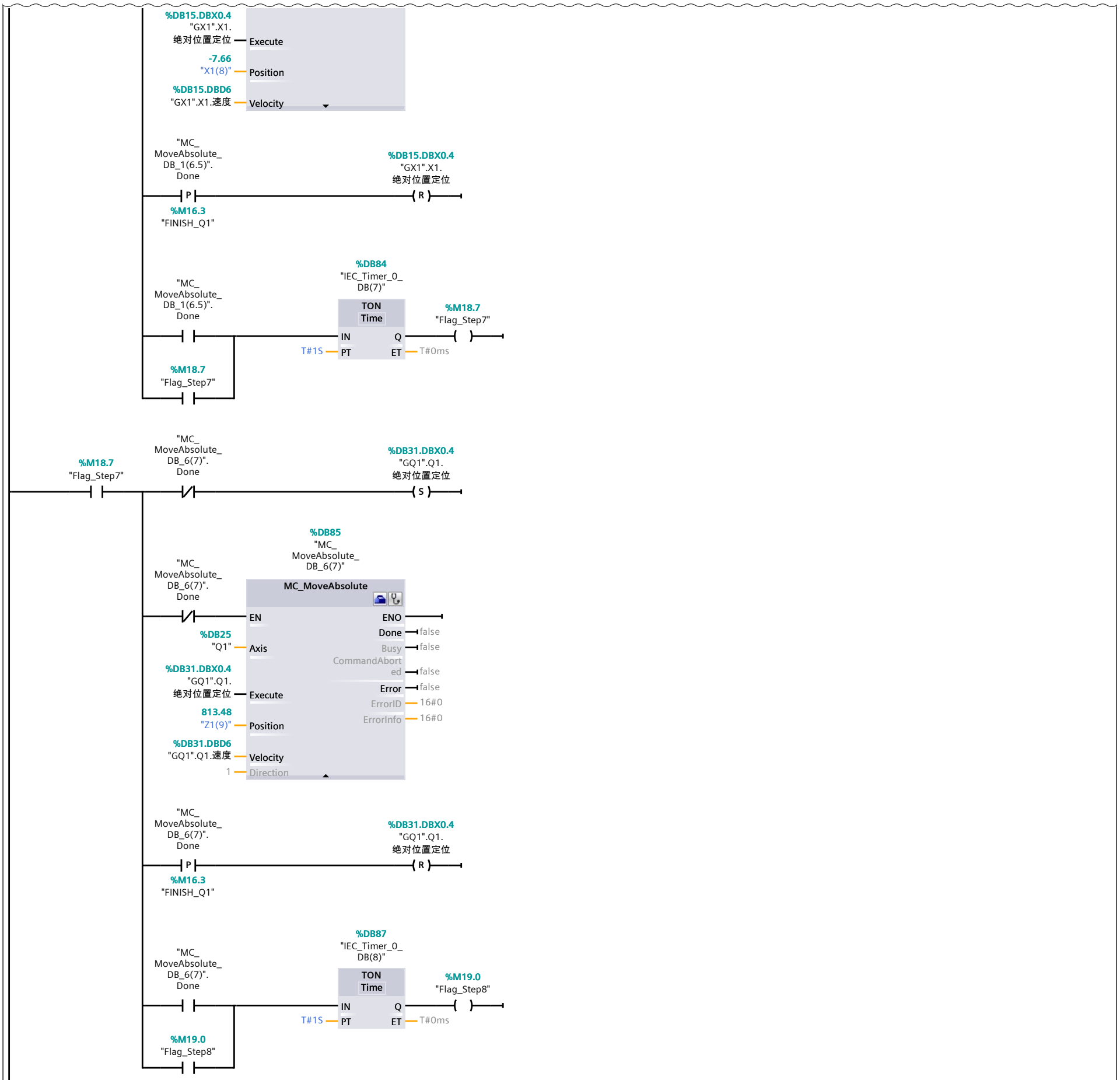

%M18.1
"Flag_Step4"
"MC_
MoveAbsolute_
DB_6(4)".
Done
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
S
%DB76
"MC_
MoveAbsolute_
DB_6(4)"
MC_MoveAbsolute
EN
ENO
%DB25
"Q1"
Axis
Done
false
Busy
false
CommandAborted
false
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
Execute
Error
false
ErrorID
16#0
750.06
"Z1(5)"
Position
ErrorInfo
16#0
%DB31.DBD6
"GQ1".Q1.速度
Velocity
1
Direction
P
R
%M16.3
"FINISH_Q1"
%DB77
"IEC_Timer_0_
DB(4.1)"
TON
Time
IN
Q
T#1S
PT
ET
T#0ms
%M18.2
"Flag_Step5"
%M18.2
"Flag_Step5"
"MC_
MoveAbsolute_
DB_6(5)".
Done
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
S
%DB78
"MC_
MoveAbsolute_
DB_6(5)"
MC_MoveAbsolute
EN
ENO
%DB25
"Q1"
Axis
Done
false
Busy
false
CommandAborted
false
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
Execute
Error
false
ErrorID
16#0
307.74
"Z1(6)"
Position
ErrorInfo
16#0
%DB31.DBD6
"GQ1".Q1.速度
Velocity
1
Direction
P
R
%M16.3
"FINISH_Q1"
%DB79
"IEC_Timer_0_
DB(5)"
TON
Time
IN
Q
T#1S
PT
ET
T#0ms
%M18.3
"Flag_Step6"
%M18.3
"Flag_Step6"

网络 16：

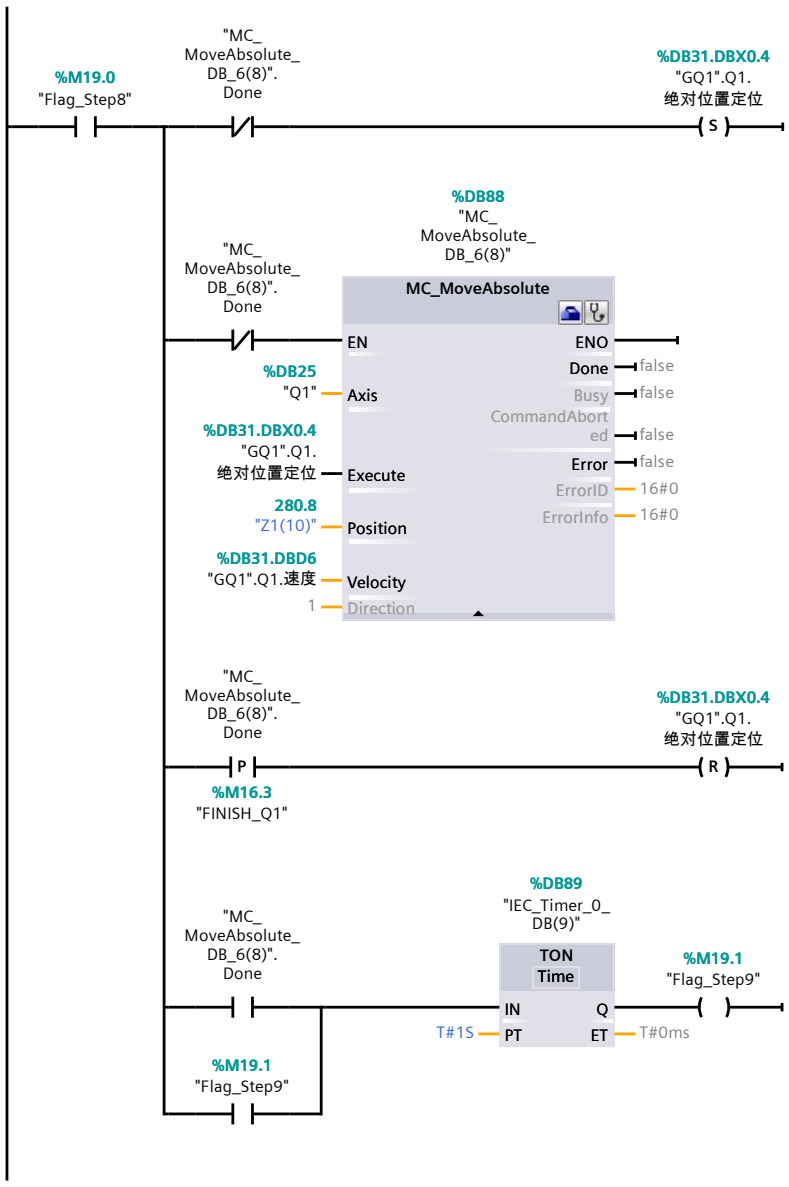
网络 16：（1.1 / 2.1）


%M18.3
"Flag_Step6"
"MC_
MoveAbsolute_
DB_6(6)".
Done
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
S
%DB1.DBX0.4
"GR1".R1.
绝对位置定位
S
%DB80
"MC_
MoveAbsolute_
DB_3(6)"
MC_MoveAbsolute
EN
ENO
%DB25
"Q1"
Axis
Done
false
Busy
false
CommandAborted
false
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
Execute
Error
false
499.11
"Z1(8)"
Position
ErrorID
16#0
%DB31.DBD6
"GQ1".Q1.速度
Velocity
ErrorInfo
16#0
1
Direction
%DB81
"MC_
MoveAbsolute_
DB_6(6)"
MC_MoveAbsolute
EN
ENO
%DB7
"R1"
Axis
Done
false
Error
false
%DB1.DBX0.4
"GR1".R1.
绝对位置定位
Execute
-0.728
"R1(8)"
Position
%DB1.DBD6
"GR1".R1.速度
Velocity
"MC_
MoveAbsolute_
DB_6(6)".
Done
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
P
R
%M16.3
"FINISH_Q1"
"MC_
MoveAbsolute_
DB_3(6)".
Done
%M18.4
"Flag_Step6.5_1"
%M18.4
"Flag_Step6.5_1"
"MC_
MoveAbsolute_
DB_6(6)".
Done
%M18.5
"Flag_Step6.5_2"
%M18.5
"Flag_Step6.5_2"
%DB82
"IEC_Timer_0_
DB(6.5)"
%M18.4
"Flag_Step6.5_1"
%M18.5
"Flag_Step6.5_2"
TON
Time
%M18.6
"Flag_Step6.5"
IN
Q
T#1S
PT
ET
T#0ms
%M18.6
"Flag_Step6.5"
"MC_
MoveAbsolute_
DB_1(6.5)".
Done
%DB15.DBX0.4
"GX1".X1.
绝对位置定位
S
%DB83
"MC_
MoveAbsolute_
DB_1(6.5)"
"MC_
MoveAbsolute_
DB_1(6.5)".
Done
MC_MoveAbsolute
EN
ENO
%DB9
"X1"
Axis
Done
false
Error
false

网络 16：（2.1 / 2.1）

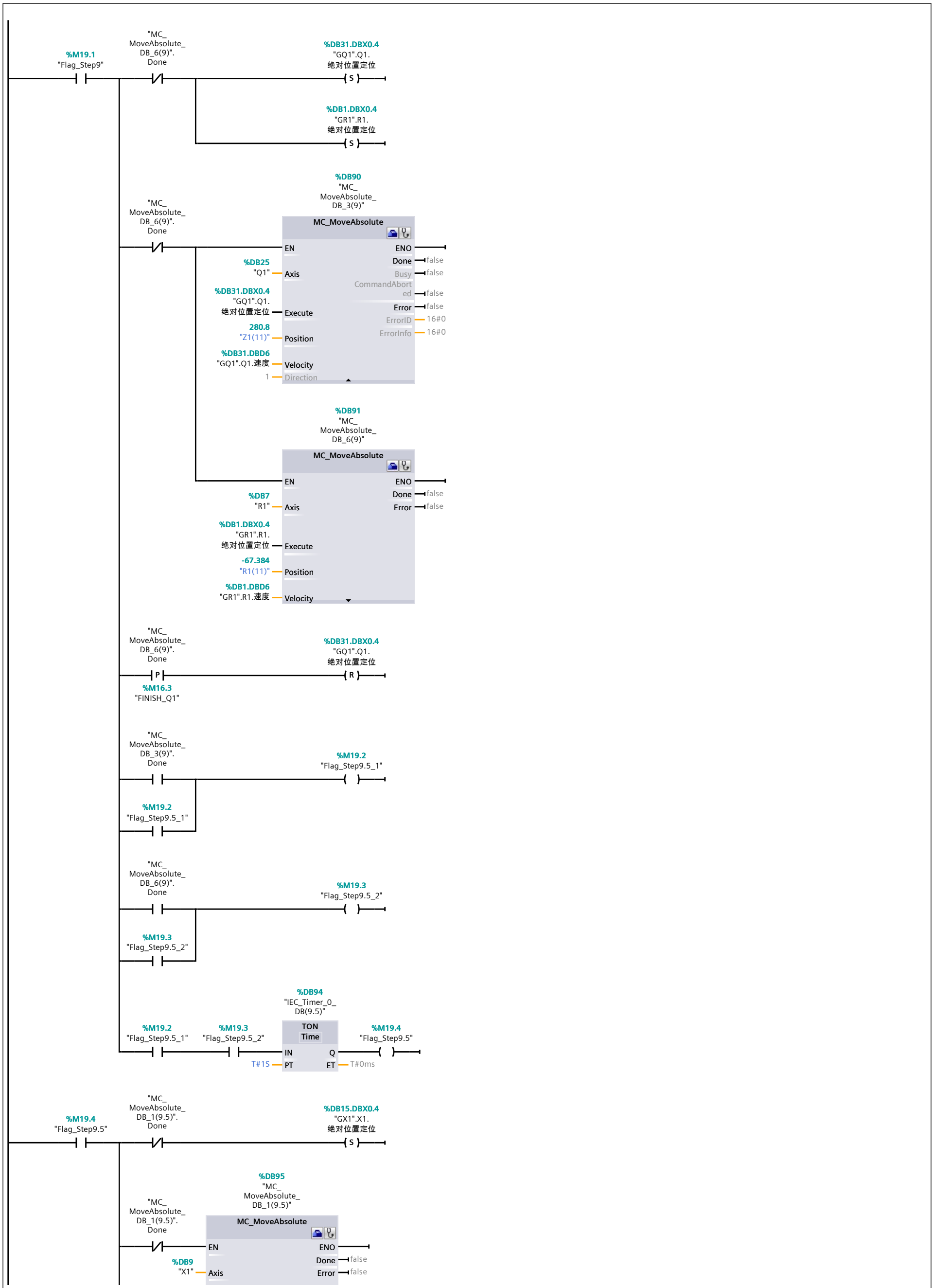

%DB15.DBX0.4
"GX1".X1.
绝对位置定位
Execute
-7.66
"X1(8)"
Position
%DB15.DBD6
"GX1".X1.速度
Velocity
"MC_
MoveAbsolute_
DB_1(6.5)".
Done
P
%M16.3
"FINISH_Q1"
%DB15.DBX0.4
"GX1".X1.
绝对位置定位
R
%DB84
"IEC_Timer_0_
DB(7)"
TON
Time
IN
PT
T#1S
Q
ET
T#0ms
%M18.7
"Flag_Step7"
%M18.7
"Flag_Step7"
"MC_
MoveAbsolute_
DB_6(7)".
Done
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
S
%DB85
"MC_
MoveAbsolute_
DB_6(7)"
MC_MoveAbsolute
EN
ENO
%DB25
"Q1"
Axis
Done
Busy
CommandAborted
Error
ErrorID
ErrorInfo
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
Execute
813.48
"Z1(9)"
Position
%DB31.DBD6
"GQ1".Q1.速度
Velocity
1
Direction
false
16#0
%DB87
%M19.0
"Flag_Step8"
%M19.0
"Flag_Step8"

网络 17：

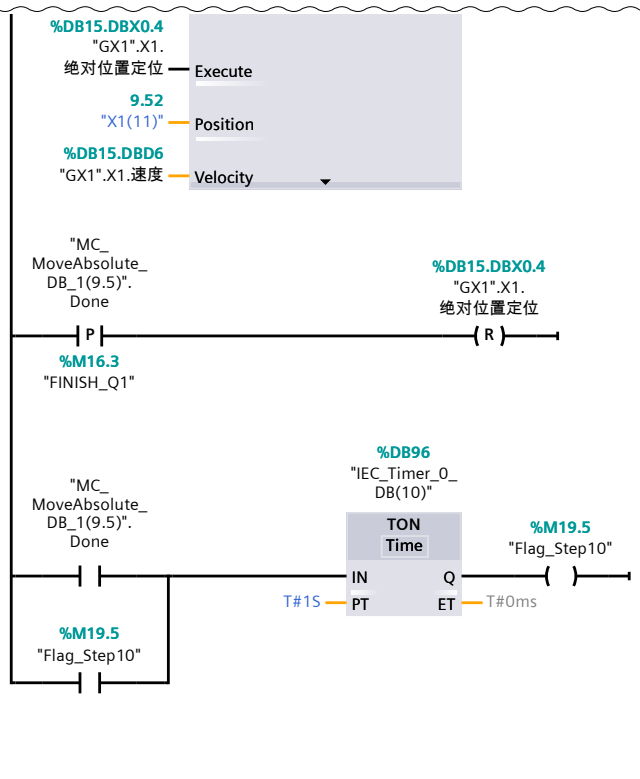

%M19.0
"Flag_Step8"
"MC_
MoveAbsolute_
DB_6(8)".
Done
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
S
%DB88
"MC_
MoveAbsolute_
DB_6(8)"
MC_MoveAbsolute
EN
ENO
%DB25
"Q1"
Axis
Done
false
Busy
false
CommandAborted
false
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
Execute
Error
false
ErrorID
16#0
280.8
"Z1(10)"
Position
ErrorInfo
16#0
%DB31.DBD6
"GQ1".Q1.速度
Velocity
1
Direction
"MC_
MoveAbsolute_
DB_6(8)".
Done
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
P
R
%M16.3
"FINISH_Q1"
%DB89
"IEC_Timer_0_
DB(9)"
"MC_
MoveAbsolute_
DB_6(8)".
Done
TON
Time
%M19.1
"Flag_Step9"
IN
Q
T#1S
PT
ET
T#0ms
%M19.1
"Flag_Step9"

网络 18：

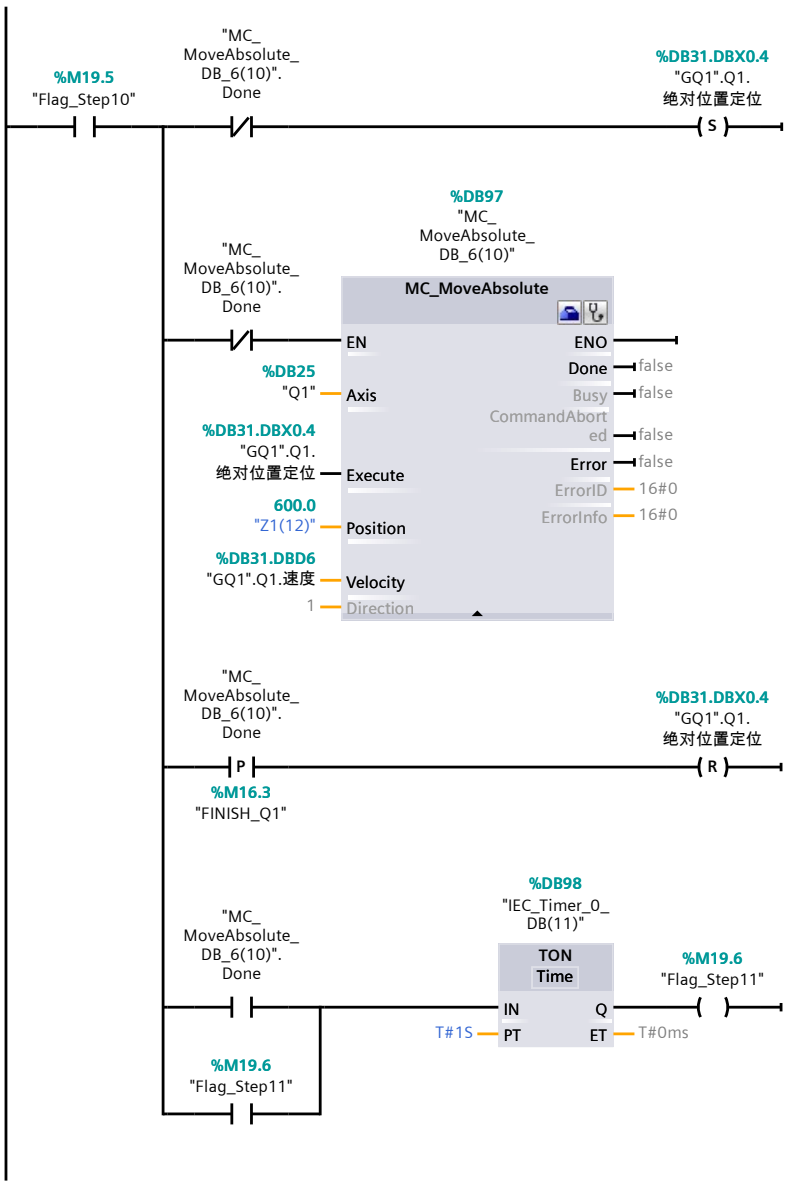
网络 18：（1.1 / 2.1）


%M19.1
"Flag_Step9"
"MC_
MoveAbsolute_
DB_6(9)".
Done
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
S
%DB1.DBX0.4
"GR1".R1.
绝对位置定位
S
%DB90
"MC_
MoveAbsolute_
DB_3(9)"
MC_MoveAbsolute
EN
ENO
%DB25
"Q1"
Axis
Done
false
Busy
false
CommandAborted
false
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
Execute
Error
false
280.8
"Z1(11)"
Position
ErrorID
16#0
%DB31.DBD6
"GQ1".Q1.速度
Velocity
ErrorInfo
16#0
1
Direction
%DB91
"MC_
MoveAbsolute_
DB_6(9)"
MC_MoveAbsolute
EN
ENO
%DB7
"R1"
Axis
Done
false
Error
false
%DB1.DBX0.4
"GR1".R1.
绝对位置定位
Execute
-67.384
"R1(11)"
Position
%DB1.DBD6
"GR1".R1.速度
Velocity
"MC_
MoveAbsolute_
DB_6(9)".
Done
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
P
R
%M16.3
"FINISH_Q1"
"MC_
MoveAbsolute_
DB_3(9)".
Done
%M19.2
"Flag_Step9.5_1"
%M19.2
"Flag_Step9.5_1"
"MC_
MoveAbsolute_
DB_6(9)".
Done
%M19.3
"Flag_Step9.5_2"
%M19.3
"Flag_Step9.5_2"
%DB94
"IEC_Timer_0_
DB(9.5)"
%M19.2
"Flag_Step9.5_1"
%M19.3
"Flag_Step9.5_2"
TON
Time
%M19.4
"Flag_Step9.5"
IN
Q
T#1S
PT
ET
T#0ms
%M19.4
"Flag_Step9.5"
"MC_
MoveAbsolute_
DB_1(9.5)".
Done
%DB15.DBX0.4
"GX1".X1.
绝对位置定位
S
%DB95
"MC_
MoveAbsolute_
DB_1(9.5)"
"MC_
MoveAbsolute_
DB_1(9.5)".
Done
MC_MoveAbsolute
EN
ENO
%DB9
"X1"
Axis
Done
false
Error
false

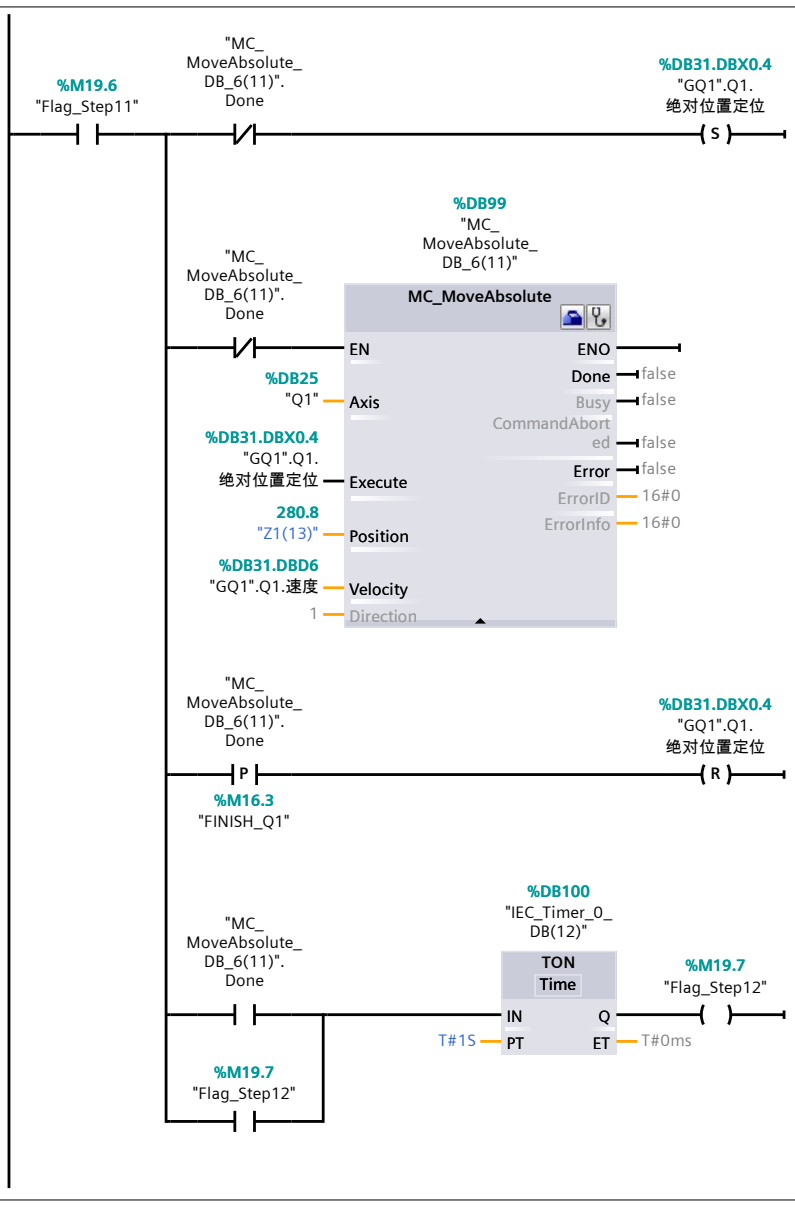
网络 18：（2.1 / 2.1）


%DB15.DBX0.4
"GX1".X1.
绝对位置定位
Execute
9.52
"X1(11)"
Position
%DB15.DBD6
"GX1".X1.速度
Velocity
"MC_
MoveAbsolute_
DB_1(9.5)".
Done
P
%M16.3
"FINISH_Q1"
%DB15.DBX0.4
"GX1".X1.
绝对位置定位
R
%DB96
"IEC_Timer_0_
DB(10)"
TON
Time
IN
Q
T#1S
PT
ET
T#0ms
%M19.5
"Flag_Step10"
"MC_
MoveAbsolute_
DB_1(9.5)".
Done
%M19.5
"Flag_Step10"

网络 19：

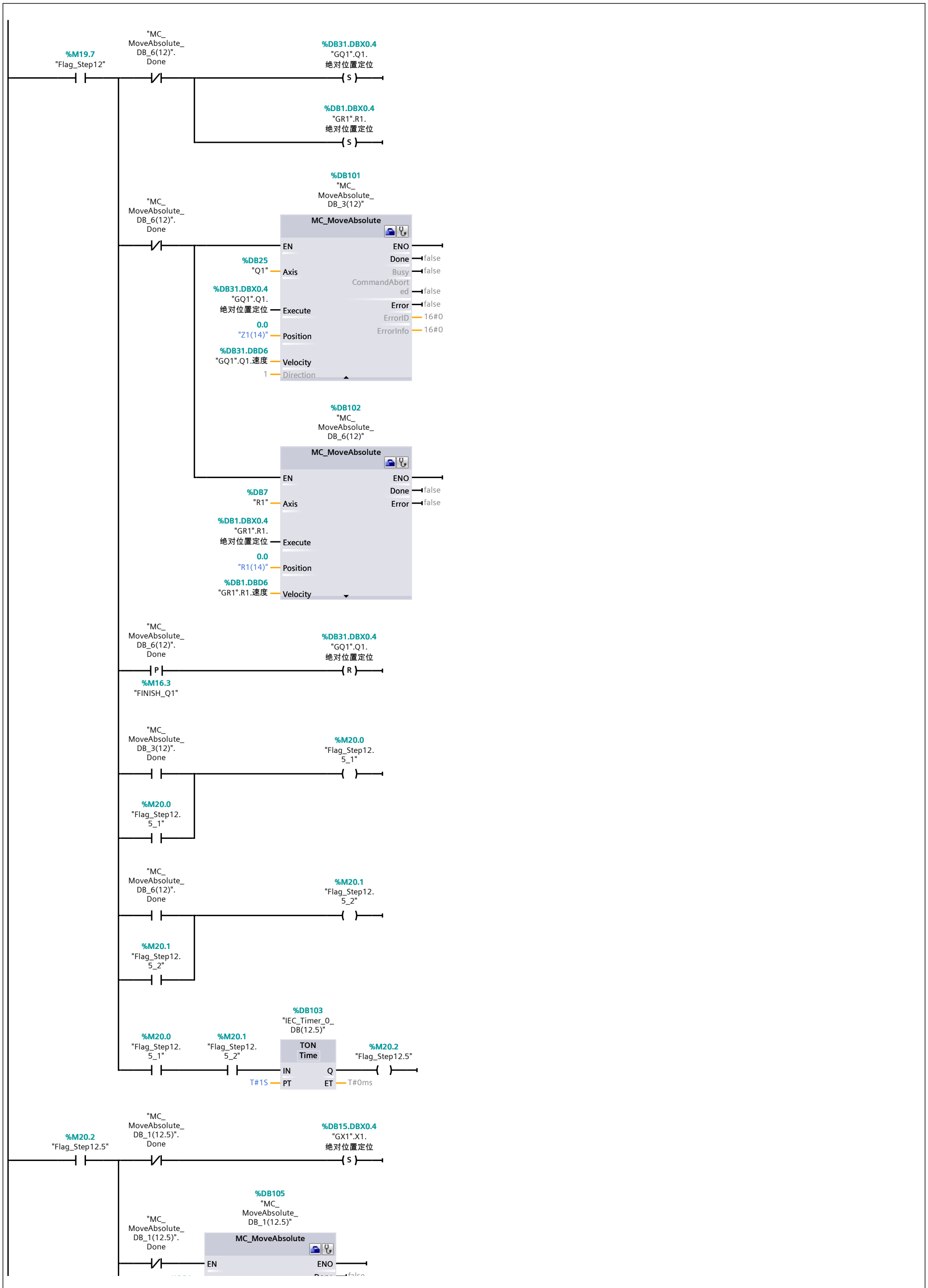


网络 20：



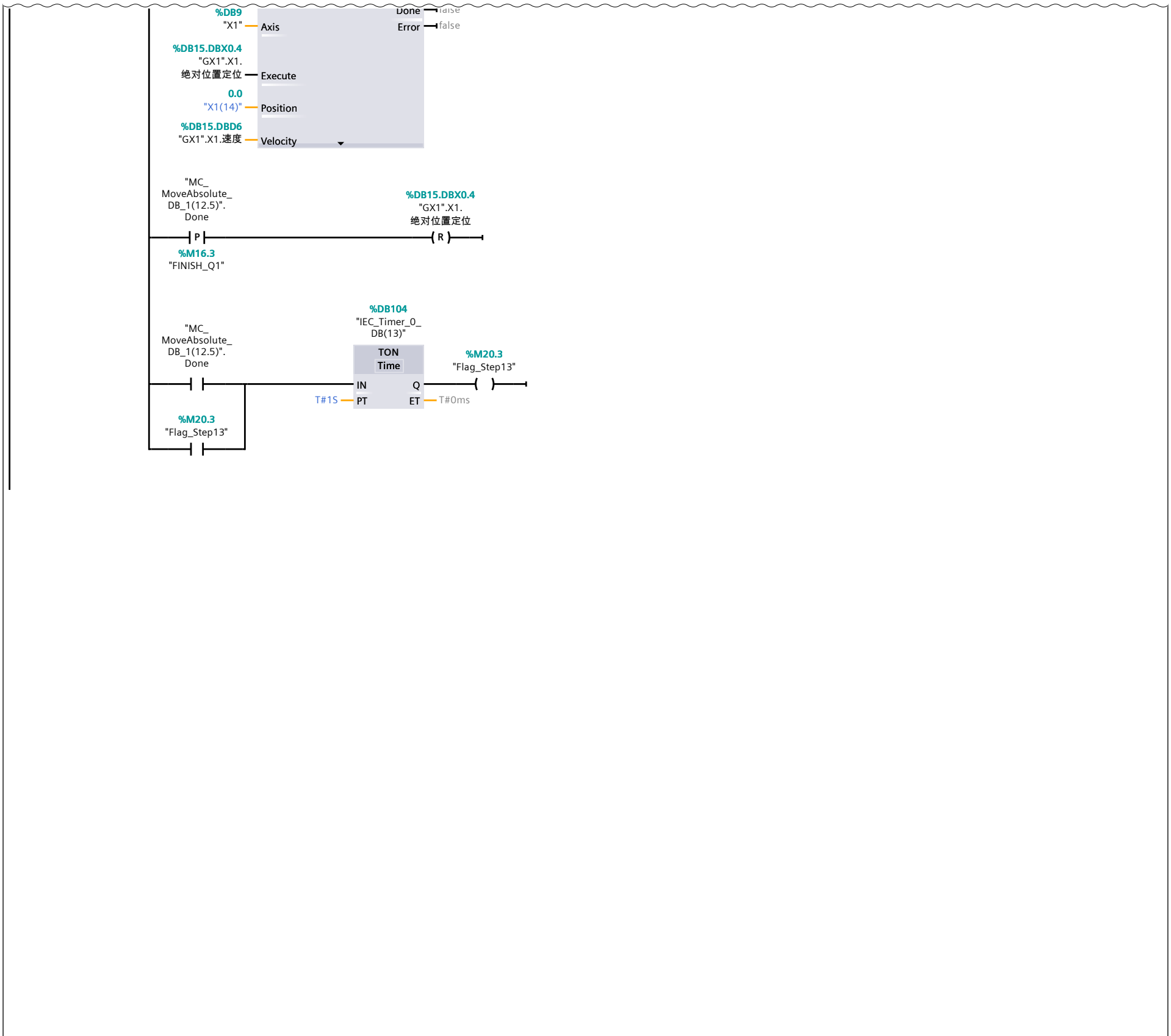
网络 21：

网络 21：（1.1 / 2.1）


%M19.7
"Flag_Step12"
"MC_
MoveAbsolute_
DB_6(12)".
Done
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
S
%DB1.DBX0.4
"GR1".R1.
绝对位置定位
S
%DB101
"MC_
MoveAbsolute_
DB_3(12)"
"MC_
MoveAbsolute_
DB_6(12)".
Done
MC_MoveAbsolute
EN
ENO
%DB25
"Q1"
Axis
Done
false
Busy
false
CommandAborted
false
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
Execute
Error
false
0.0
"Z1(14)"
Position
ErrorID
16#0
%DB31.DBD6
"GQ1".Q1.速度
Velocity
ErrorInfo
16#0
1
Direction
%DB102
"MC_
MoveAbsolute_
DB_6(12)"
MC_MoveAbsolute
EN
ENO
%DB7
"R1"
Axis
Done
false
Error
false
%DB1.DBX0.4
"GR1".R1.
绝对位置定位
Execute
0.0
"R1(14)"
Position
%DB1.DBD6
"GR1".R1.速度
Velocity
"MC_
MoveAbsolute_
DB_6(12)".
Done
P
%M16.3
"FINISH_Q1"
%DB31.DBX0.4
"GQ1".Q1.
绝对位置定位
R
"MC_
MoveAbsolute_
DB_3(12)".
Done
%M20.0
"Flag_Step12.
5_1"
%M20.0
"Flag_Step12.
5_1"
"MC_
MoveAbsolute_
DB_6(12)".
Done
%M20.1
"Flag_Step12.
5_2"
%M20.1
"Flag_Step12.
5_2"
%DB103
"IEC_Timer_0_
DB(12.5)"
%M20.0
"Flag_Step12.
5_1"
%M20.1
"Flag_Step12.
5_2"
TON
Time
IN
Q
%M20.2
"Flag_Step12.5"
T#1S
PT
ET
T#0ms
%M20.2
"Flag_Step12.5"
"MC_
MoveAbsolute_
DB_1(12.5)".
Done
%DB15.DBX0.4
"GX1".X1.
绝对位置定位
S
%DB105
"MC_
MoveAbsolute_
DB_1(12.5)"
"MC_
MoveAbsolute_
DB_1(12.5)".
Done
MC_MoveAbsolute
EN
ENO

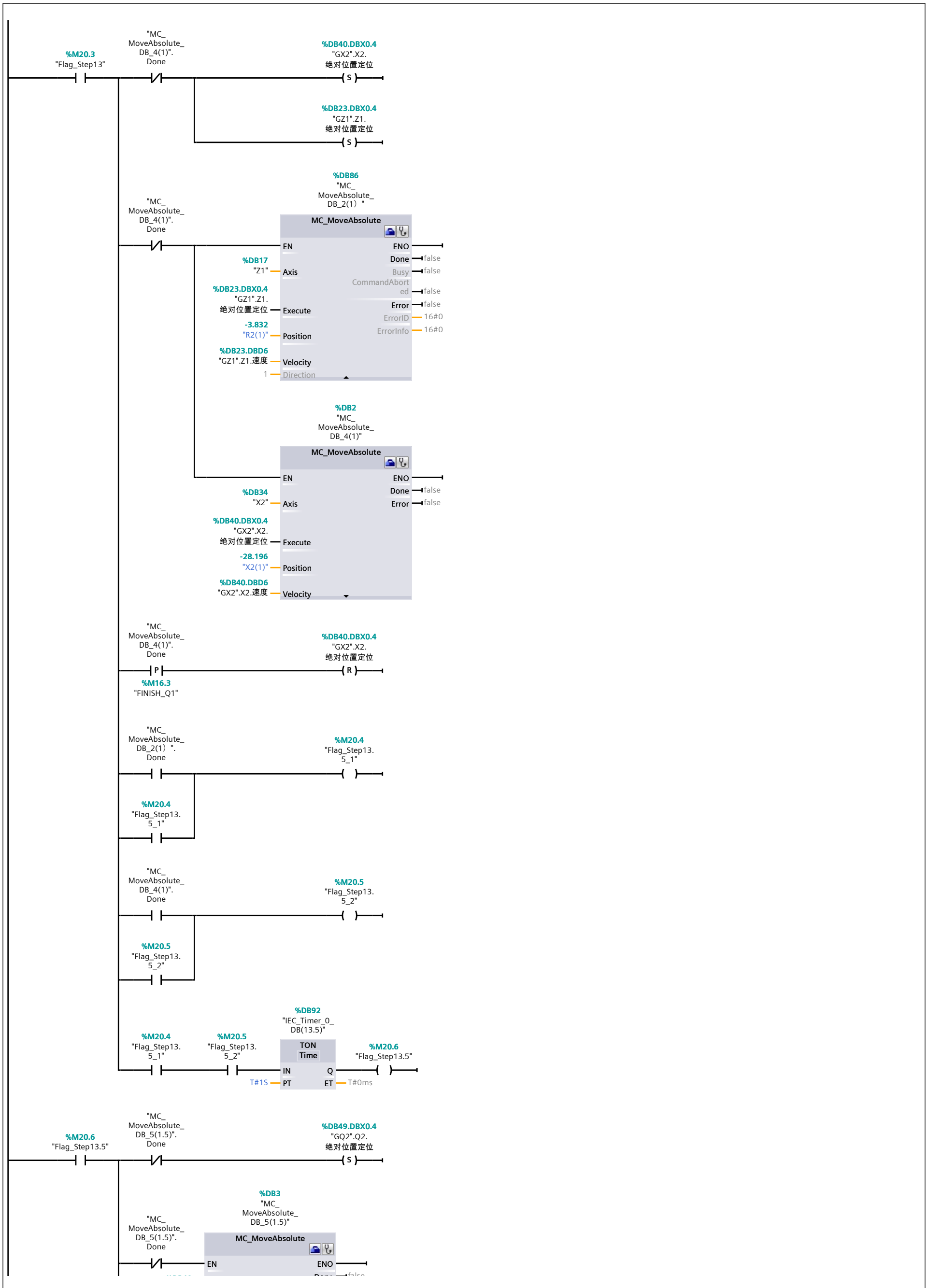
网络 21： (2.1 / 2.1)

1.1 (页 1 - 15)



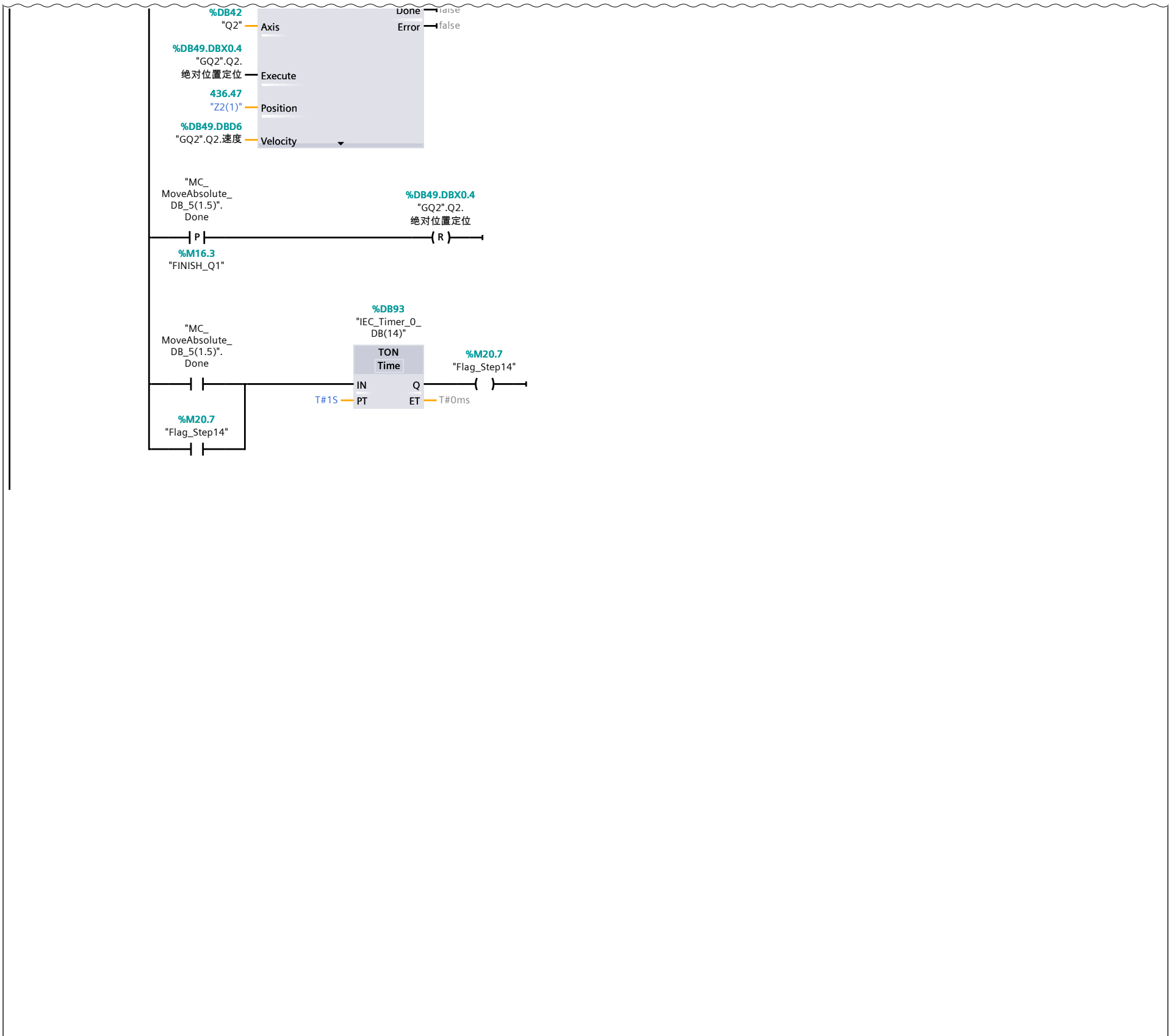
网络 22：

网络 22：（1.1 / 2.1）

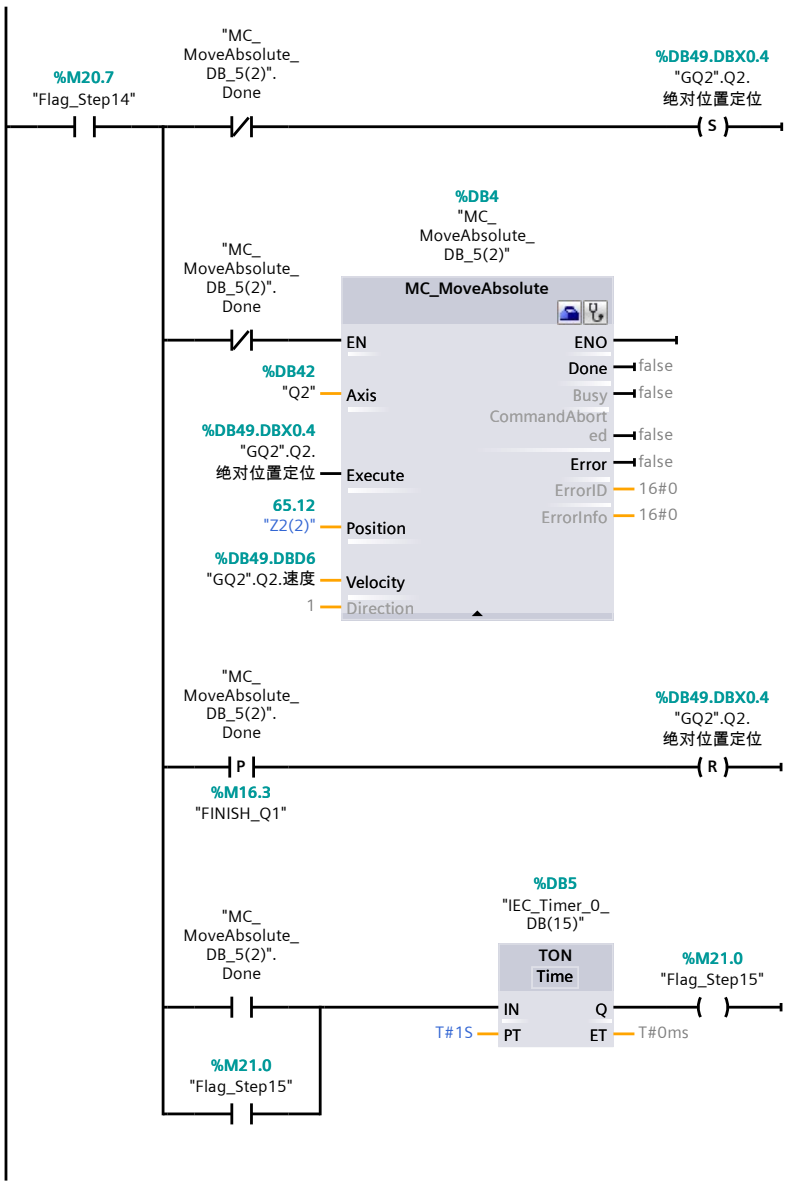

%M20.3
"Flag_Step13"
"MC_
MoveAbsolute_
DB_4(1)".
Done
%DB40.DBX0.4
"GX2".X2.
绝对位置定位
S
%DB23.DBX0.4
"GZ1".Z1.
绝对位置定位
S
"MC_
MoveAbsolute_
DB_4(1)".
Done
%DB86
"MC_
MoveAbsolute_
DB_2(1）"
MC_MoveAbsolute
EN
ENO
%DB17
"Z1"
Axis
Done
false
Busy
false
CommandAborted
false
%DB23.DBX0.4
"GZ1".Z1.
绝对位置定位
Execute
Error
false
-3.832
"R2(1)"
Position
ErrorID
16#0
%DB23.DBD6
"GZ1".Z1.速度
Velocity
ErrorInfo
16#0
1
Direction
%DB2
"MC_
MoveAbsolute_
DB_4(1)"
MC_MoveAbsolute
EN
ENO
%DB34
"X2"
Axis
Done
false
Error
false
%DB40.DBX0.4
"GX2".X2.
绝对位置定位
Execute
-28.196
"X2(1)"
Position
%DB40.DBD6
"GX2".X2.速度
Velocity
"MC_
MoveAbsolute_
DB_4(1)".
Done
%DB40.DBX0.4
"GX2".X2.
绝对位置定位
P
R
%M16.3
"FINISH_Q1"
"MC_
MoveAbsolute_
DB_2(1）".
Done
%M20.4
"Flag_Step13.
5_1"
%M20.4
"Flag_Step13.
5_1"
"MC_
MoveAbsolute_
DB_4(1)".
Done
%M20.5
"Flag_Step13.
5_2"
%M20.5
"Flag_Step13.
5_2"
%DB92
"IEC_Timer_0_
DB(13.5)"
%M20.4
"Flag_Step13.
5_1"
%M20.5
"Flag_Step13.
5_2"
TON
Time
%M20.6
"Flag_Step13.5"
IN
Q
T#1S
PT
ET
T#0ms
%M20.6
"Flag_Step13.5"
"MC_
MoveAbsolute_
DB_5(1.5)".
Done
%DB49.DBX0.4
"GQ2".Q2.
绝对位置定位
S
%DB3
"MC_
MoveAbsolute_
DB_5(1.5)"
"MC_
MoveAbsolute_
DB_5(1.5)".
Done
MC_MoveAbsolute
EN
ENO

网络 22：（2.1 / 2.1）

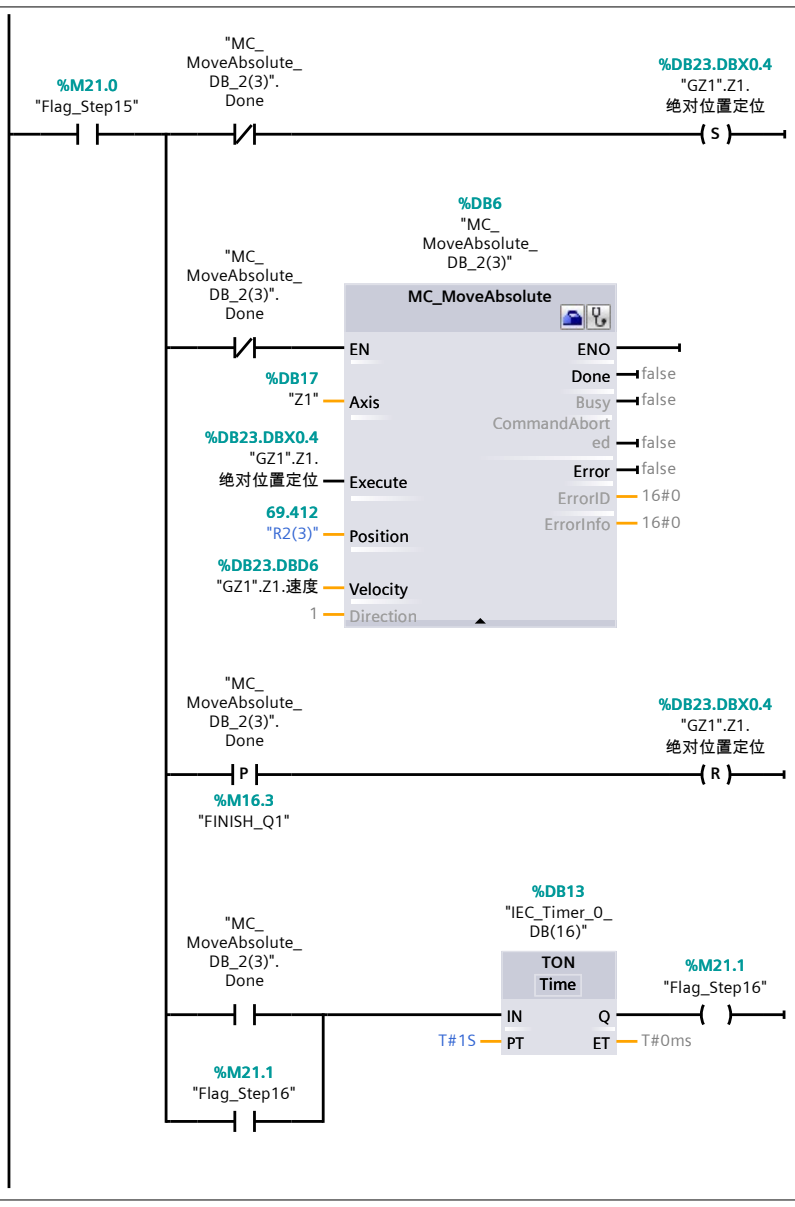
1.1 (页 1 - 18)



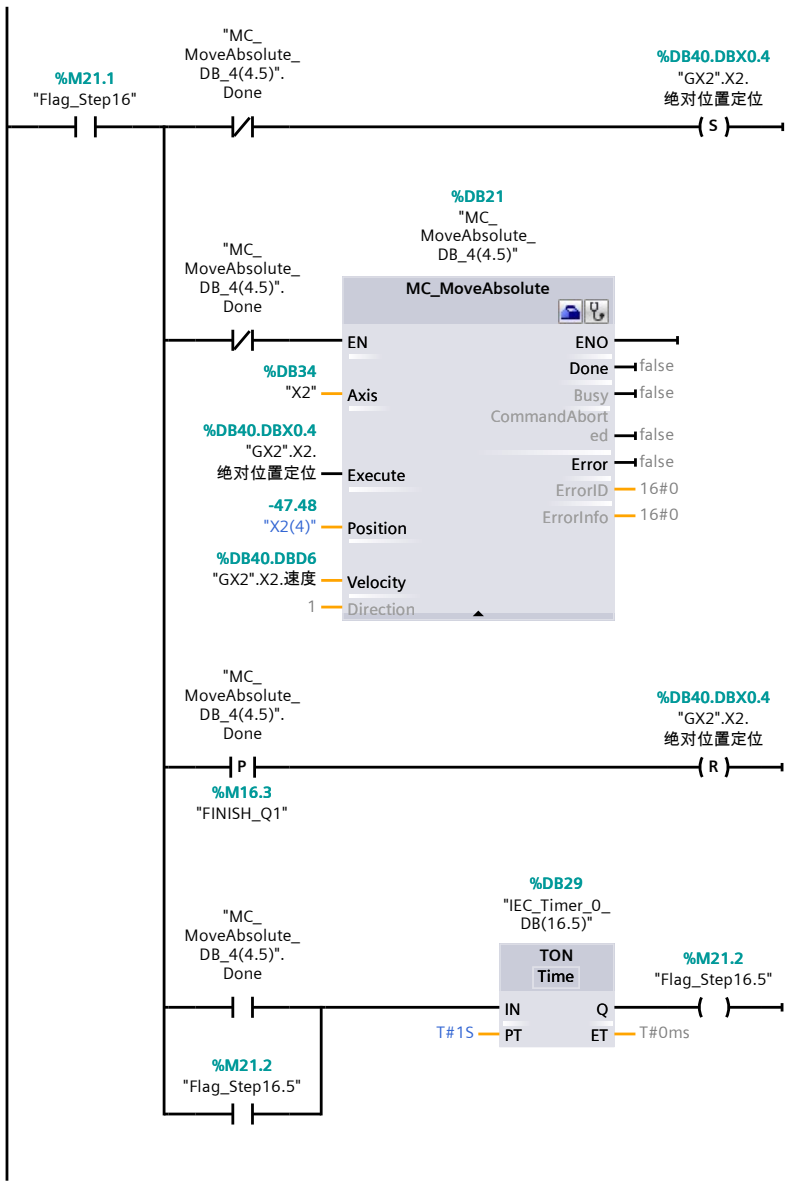
网络 23：



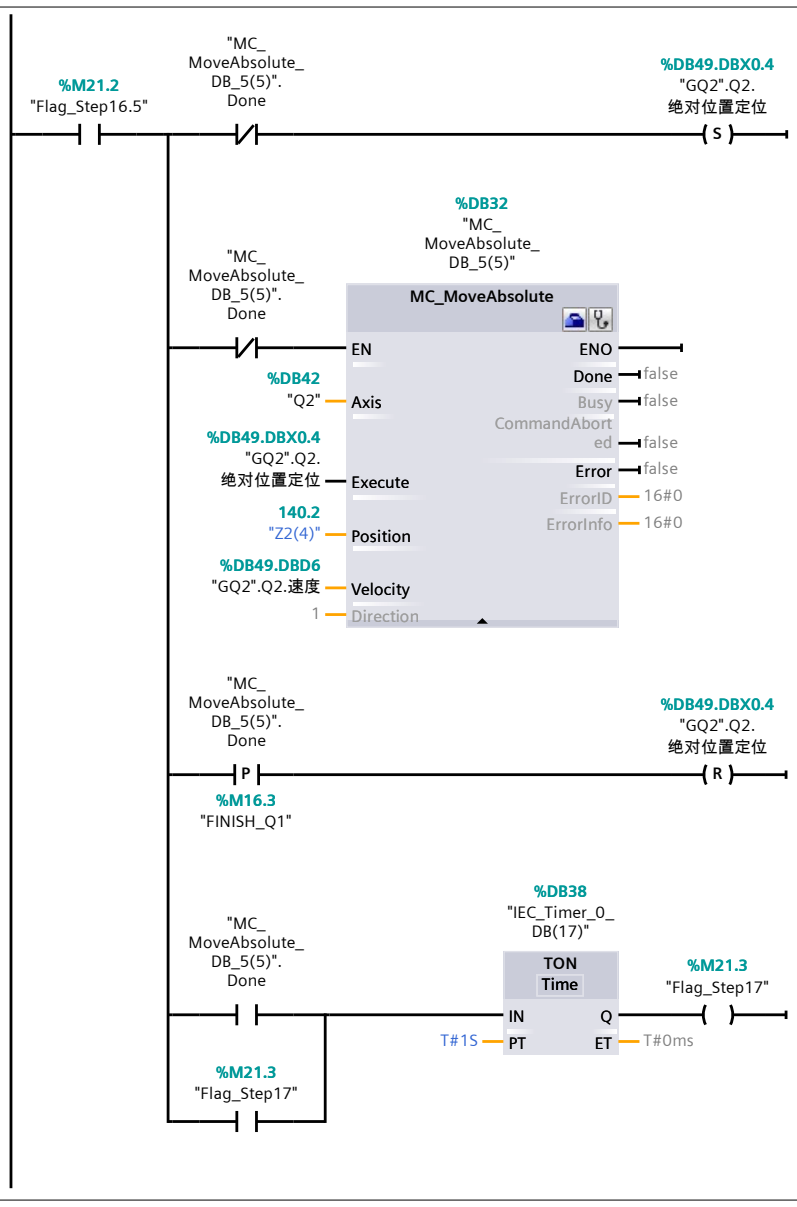
网络 24：



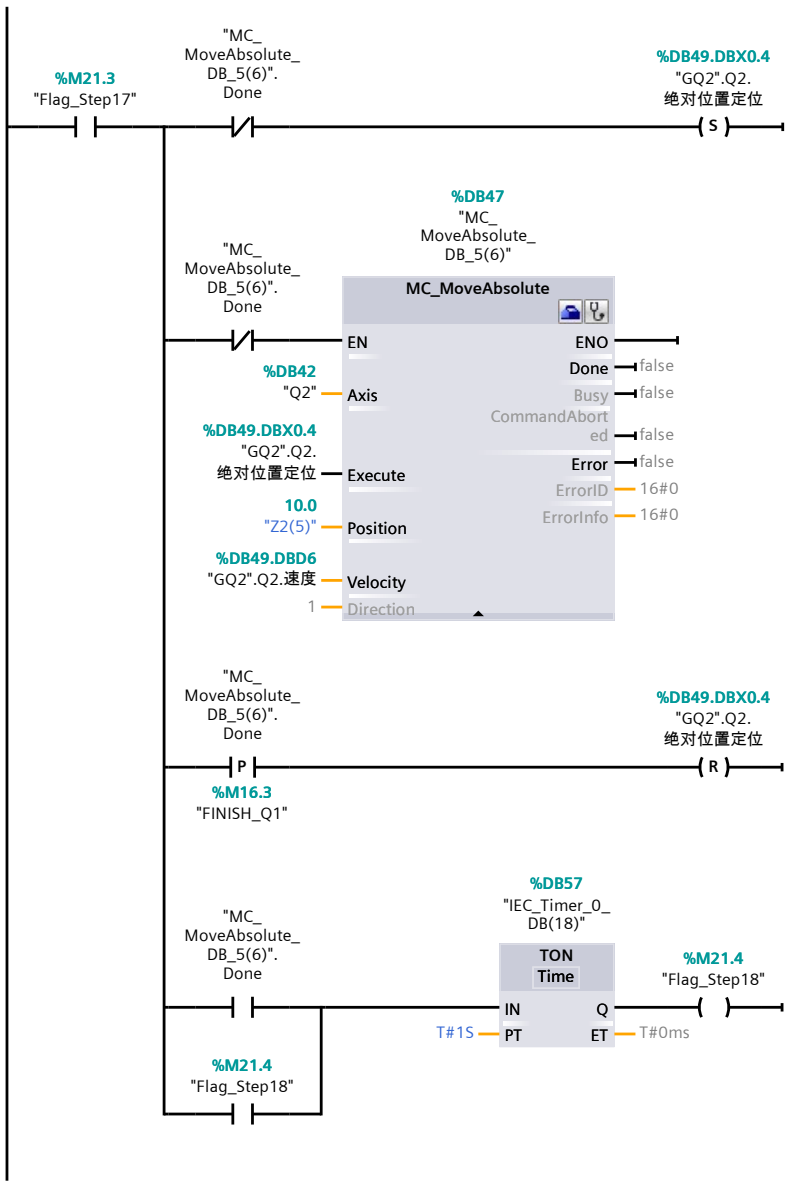
网络 25：


%M21.1
"Flag_Step16"
"MC_
MoveAbsolute_
DB_4(4.5)".
Done
%DB40.DBX0.4
"GX2".X2.
绝对位置定位
S
%DB21
"MC_
MoveAbsolute_
DB_4(4.5)"
MC_MoveAbsolute
EN
ENO
%DB34
"X2"
Axis
Done
false
Busy
false
CommandAborted
false
%DB40.DBX0.4
"GX2".X2.
绝对位置定位
Execute
Error
false
ErrorID
16#0
-47.48
"X2(4)"
Position
ErrorInfo
16#0
%DB40.DBD6
"GX2".X2.速度
Velocity
1
Direction
"MC_
MoveAbsolute_
DB_4(4.5)".
Done
%DB40.DBX0.4
"GX2".X2.
绝对位置定位
P
R
%M16.3
"FINISH_Q1"
%DB29
"IEC_Timer_0_
DB(16.5)"
"MC_
MoveAbsolute_
DB_4(4.5)".
Done
TON
Time
%M21.2
"Flag_Step16.5"
IN
Q
T#1S
PT
ET
T#0ms
%M21.2
"Flag_Step16.5"

网络 26：

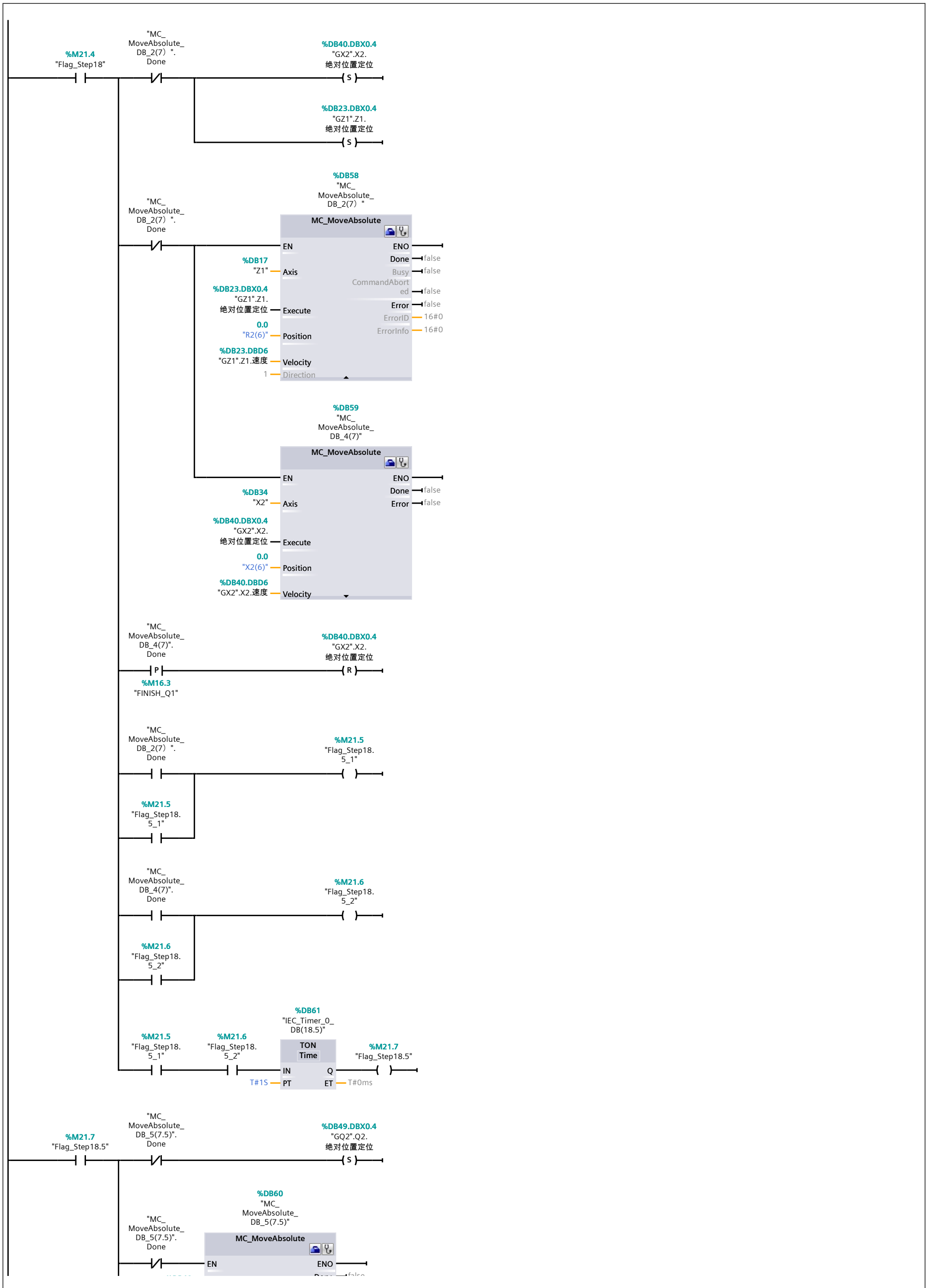

%M21.2
"Flag_Step16.5"
"MC_
MoveAbsolute_
DB_5(5)".
Done
%DB49.DBX0.4
"GQ2".Q2.
绝对位置定位
S
%DB32
"MC_
MoveAbsolute_
DB_5(5)"
MC_MoveAbsolute
EN
ENO
%DB42
"Q2"
Axis
Done
false
Busy
false
CommandAborted
false
%DB49.DBX0.4
"GQ2".Q2.
绝对位置定位
Execute
Error
false
ErrorID
16#0
140.2
"Z2(4)"
Position
ErrorInfo
16#0
%DB49.DBD6
"GQ2".Q2.速度
Velocity
1
Direction
"MC_
MoveAbsolute_
DB_5(5)".
Done
%DB49.DBX0.4
"GQ2".Q2.
绝对位置定位
P
R
%M16.3
"FINISH_Q1"
%DB38
"IEC_Timer_0_
DB(17)"
"MC_
MoveAbsolute_
DB_5(5)".
Done
TON
Time
%M21.3
"Flag_Step17"
IN
Q
T#1S
PT
ET
T#0ms
%M21.3
"Flag_Step17"

网络 27：

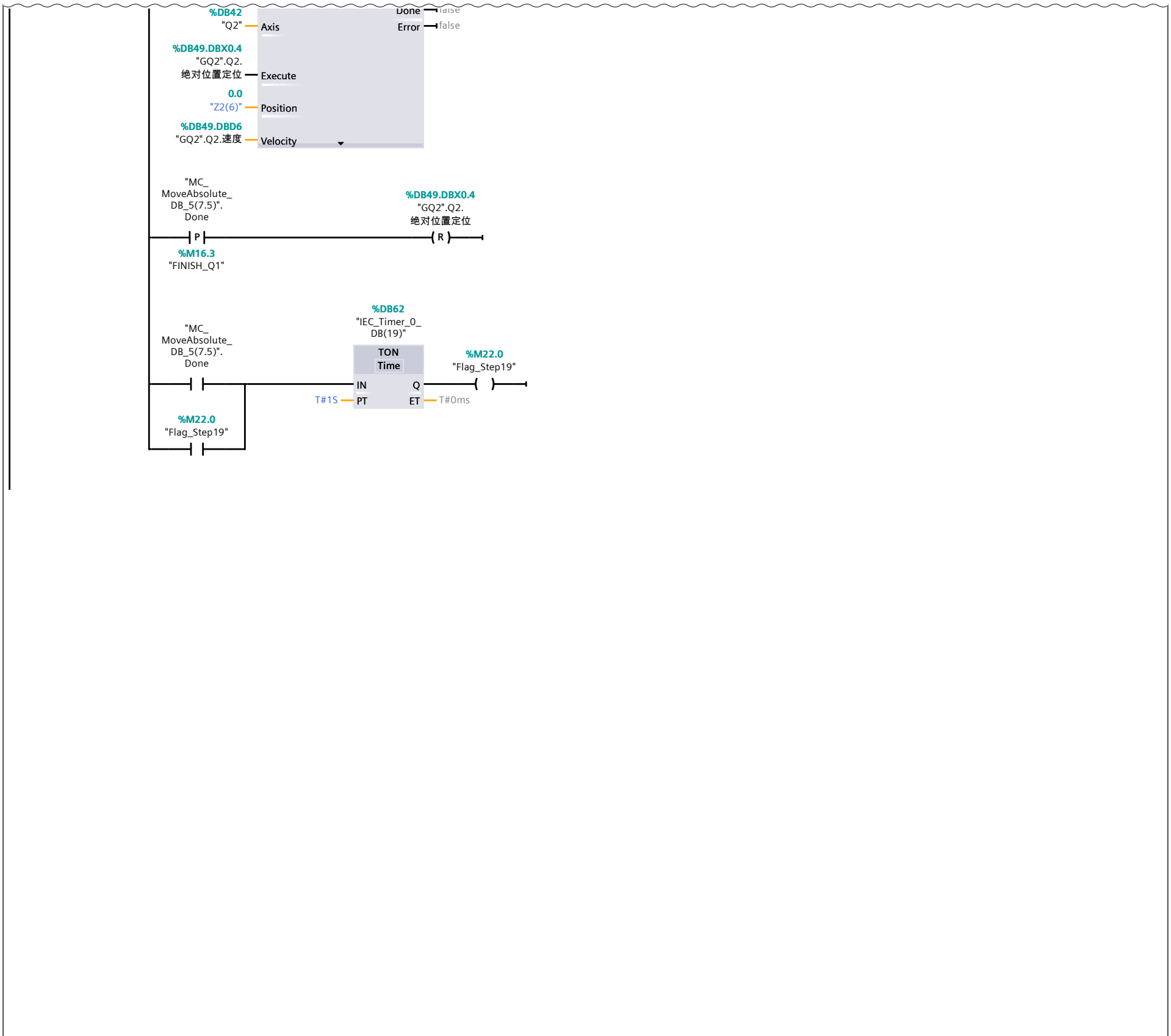

%M21.3
"Flag_Step17"
"MC_
MoveAbsolute_
DB_5(6)".
Done
%DB49.DBX0.4
"GQ2".Q2.
绝对位置定位
S
%DB47
"MC_
MoveAbsolute_
DB_5(6)"
"MC_
MoveAbsolute_
DB_5(6)".
Done
MC_MoveAbsolute
EN
ENO
%DB42
"Q2"
Axis
Done
false
Busy
false
%DB49.DBX0.4
"GQ2".Q2.
绝对位置定位
Execute
CommandAborted
false
Error
false
10.0
"Z2(5)"
Position
ErrorID
16#0
%DB49.DBD6
"GQ2".Q2.速度
Velocity
ErrorInfo
16#0
1
Direction
"MC_
MoveAbsolute_
DB_5(6)".
Done
%DB49.DBX0.4
"GQ2".Q2.
绝对位置定位
P
R
%M16.3
"FINISH_Q1"
%DB57
"IEC_Timer_0_
DB(18)"
"MC_
MoveAbsolute_
DB_5(6)".
Done
TON
Time
%M21.4
"Flag_Step18"
IN
Q
T#1S
PT
ET
T#0ms
%M21.4
"Flag_Step18"

网络 28：

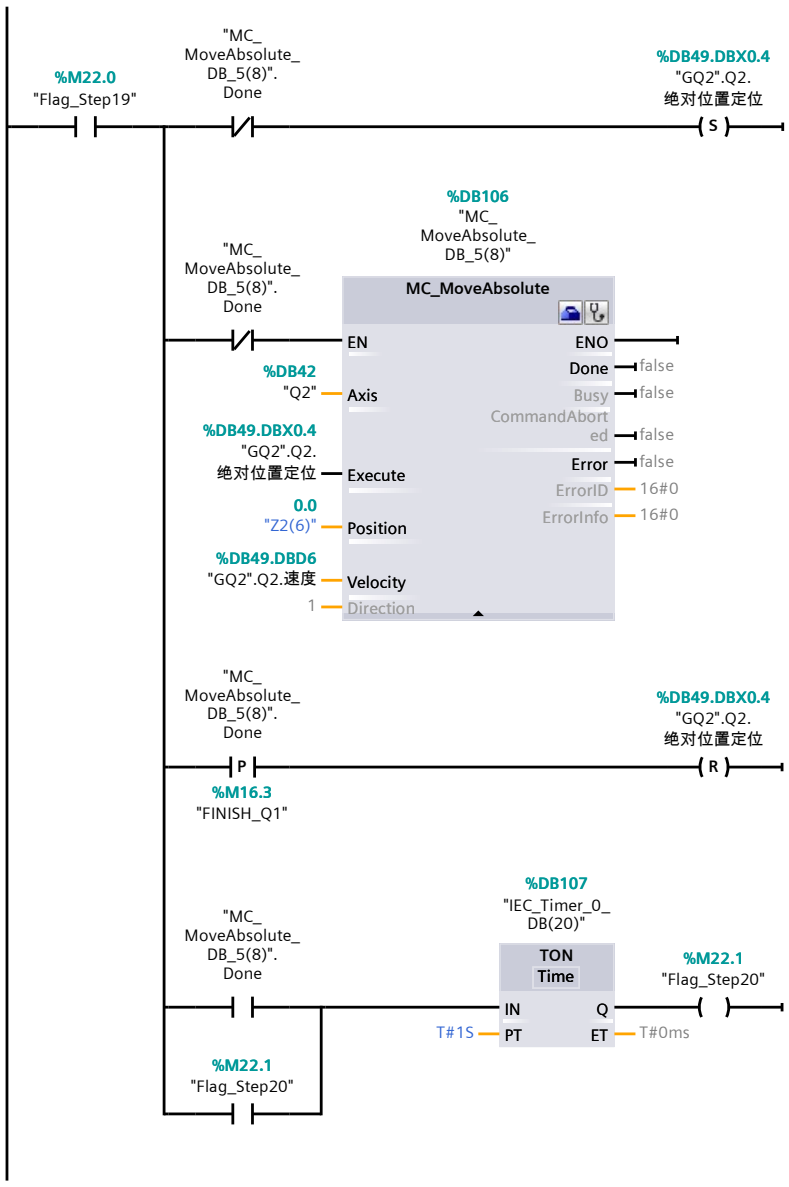
网络 28：（1.1 / 2.1）


%M21.4
"Flag_Step18"
"MC_
MoveAbsolute_
DB_2(7）".
Done
%DB40.DBX0.4
"GX2".X2.
绝对位置定位
S
%DB23.DBX0.4
"GZ1".Z1.
绝对位置定位
S
%DB58
"MC_
MoveAbsolute_
DB_2(7）"
"MC_
MoveAbsolute_
DB_2(7）".
Done
MC_MoveAbsolute
EN
ENO
%DB17
"Z1"
Axis
Done
false
Busy
false
CommandAborted
false
%DB23.DBX0.4
"GZ1".Z1.
绝对位置定位
Execute
Error
false
0.0
"R2(6)"
Position
ErrorID
16#0
%DB23.DBD6
"GZ1".Z1.速度
Velocity
ErrorInfo
16#0
1
Direction
%DB59
"MC_
MoveAbsolute_
DB_4(7)"
MC_MoveAbsolute
EN
ENO
%DB34
"X2"
Axis
Done
false
Error
false
%DB40.DBX0.4
"GX2".X2.
绝对位置定位
Execute
0.0
"X2(6)"
Position
%DB40.DBD6
"GX2".X2.速度
Velocity
"MC_
MoveAbsolute_
DB_4(7)".
Done
P
%DB40.DBX0.4
"GX2".X2.
绝对位置定位
R
%M16.3
"FINISH_Q1"
"MC_
MoveAbsolute_
DB_2(7）".
Done
%M21.5
"Flag_Step18.
5_1"
%M21.5
"Flag_Step18.
5_1"
"MC_
MoveAbsolute_
DB_4(7)".
Done
%M21.6
"Flag_Step18.
5_2"
%M21.6
"Flag_Step18.
5_2"
%DB61
"IEC_Timer_0_
DB(18.5)"
%M21.5
"Flag_Step18.
5_1"
%M21.6
"Flag_Step18.
5_2"
TON
Time
%M21.7
"Flag_Step18.5"
IN
Q
T#1S
PT
ET
T#0ms
%M21.7
"Flag_Step18.5"
"MC_
MoveAbsolute_
DB_5(7.5)".
Done
%DB49.DBX0.4
"GQ2".Q2.
绝对位置定位
S
%DB60
"MC_
MoveAbsolute_
DB_5(7.5)"
"MC_
MoveAbsolute_
DB_5(7.5)".
Done
MC_MoveAbsolute
EN
ENO

网络 28：（2.1 / 2.1）


%DB42
"Q2"
Axis
Done
Error
false
%DB49.DBX0.4
"GQ2".Q2.
绝对位置定位
Execute
0.0
"Z2(6)"
Position
%DB49.DBD6
"GQ2".Q2.速度
Velocity
"MC_
MoveAbsolute_
DB_5(7.5)".
Done
P
%M16.3
"FINISH_Q1"
%DB49.DBX0.4
"GQ2".Q2.
绝对位置定位
R
%DB62
"IEC_Timer_0_
DB(19)"
TON
Time
IN
PT
T#1S
Q
ET
T#0ms
%M22.0
"Flag_Step19"
"MC_
MoveAbsolute_
DB_5(7.5)".
Done
%M22.0
"Flag_Step19"

网络 29：


%M22.0
"Flag_Step19"
"MC_
MoveAbsolute_
DB_5(8)".
Done
%DB49.DBX0.4
"GQ2".Q2.
绝对位置定位
S
%DB106
"MC_
MoveAbsolute_
DB_5(8)"
"MC_
MoveAbsolute_
DB_5(8)".
Done
MC_MoveAbsolute
EN
ENO
%DB42
"Q2"
Axis
Done
false
Busy
false
CommandAborted
false
%DB49.DBX0.4
"GQ2".Q2.
绝对位置定位
Execute
Error
false
ErrorID
16#0
0.0
"Z2(6)"
Position
ErrorInfo
16#0
%DB49.DBD6
"GQ2".Q2.速度
Velocity
1
Direction
"MC_
MoveAbsolute_
DB_5(8)".
Done
%DB49.DBX0.4
"GQ2".Q2.
绝对位置定位
P
R
%M16.3
"FINISH_Q1"
%DB107
"IEC_Timer_0_
DB(20)"
"MC_
MoveAbsolute_
DB_5(8)".
Done
TON
Time
%M22.1
"Flag_Step20"
IN
Q
T#1S
PT
ET
T#0ms
%M22.1
"Flag_Step20"