

**FC203 - <offline>**

"Cam\_Auto\_4\_Ladder"

**Name:** CAMAUTO4**Family:****Author:****Version:** 0.0**Block version:** 2**Time stamp Code:**

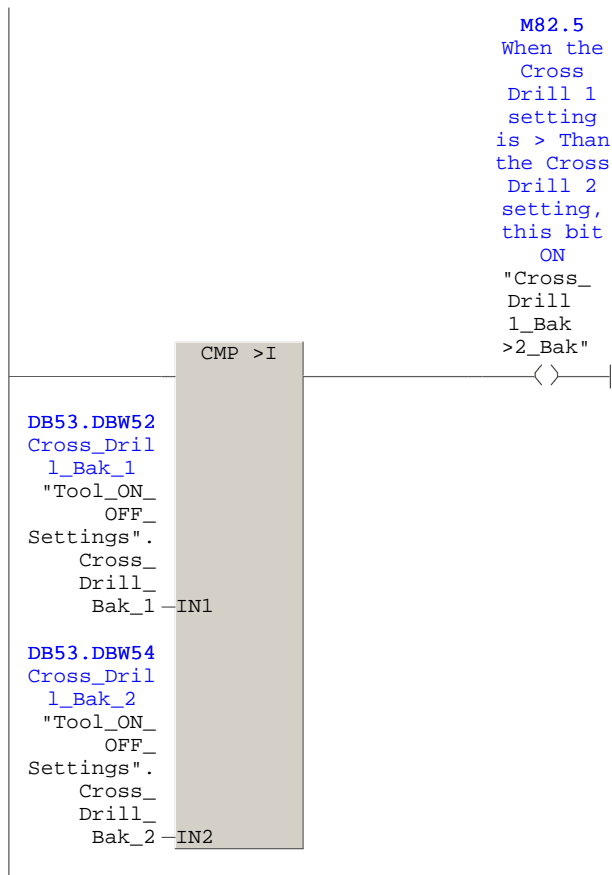
10/19/2004 09:59:13 PMPM

**Interface:**

06/28/2004 08:54:16 AMAM

**Lengths (block/logic/data):** 00864 00586 00000

Name	Data Type	Address	Comment
IN		0.0	
OUT		0.0	
IN_OUT		0.0	
TEMP		0.0	
RETURN		0.0	
RET_VAL		0.0	

**Block:** FC203**Network:** 1 Compare Cross Drill Settings 1 > 2

Network: 2 If the Cross Drill 1 setting is > than 2 the jump to Label M001

M82.5  
When the  
Cross  
Drill 1  
setting  
is > Than  
the Cross  
Drill 2  
setting,  
this bit  
ON  
"Cross\_  
Drill  
1\_Bak  
>2\_Bak"

M001

<JMP>

Network: 3 Encoder Position is Greater than the Cross Drill 1 Position

M115.4  
Encoder  
Position  
is  
Greater  
than the  
Cross  
Drill 1  
Position  
this bit  
is ON  
"Encdr\_  
Pos>Cross\_  
Drill\_1"

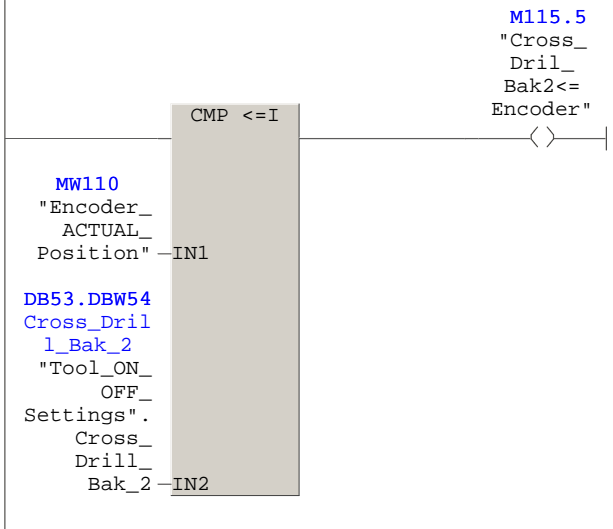
CMP >=I

<>

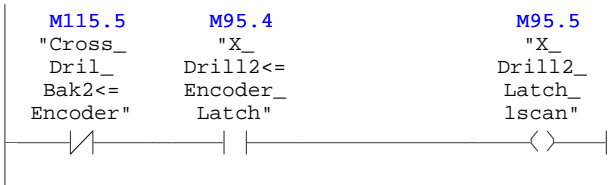
MW110  
"Encoder\_  
ACTUAL\_  
Position" -IN1

DB53.DBW52  
Cross\_Dril  
l\_Bak\_1  
"Tool\_ON\_  
OFF\_  
Settings".  
Cross\_  
Drill\_  
Bak\_1 -IN2

Network: 4 Encoder Position is <= than Cross Drill Back 2 Position



Network: 5 If the encoder pos > XDrill 2, hold latch for 1 scan



Network: 6



Network: 7





Network: 12

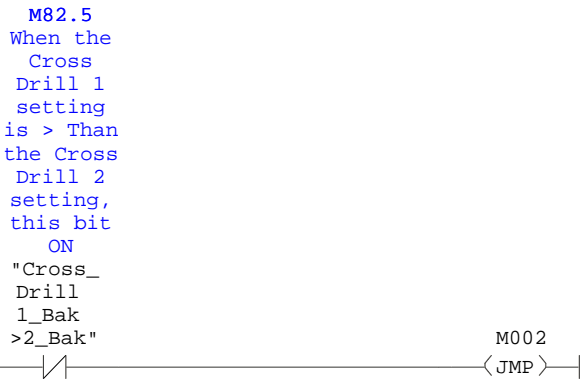


Network: 13

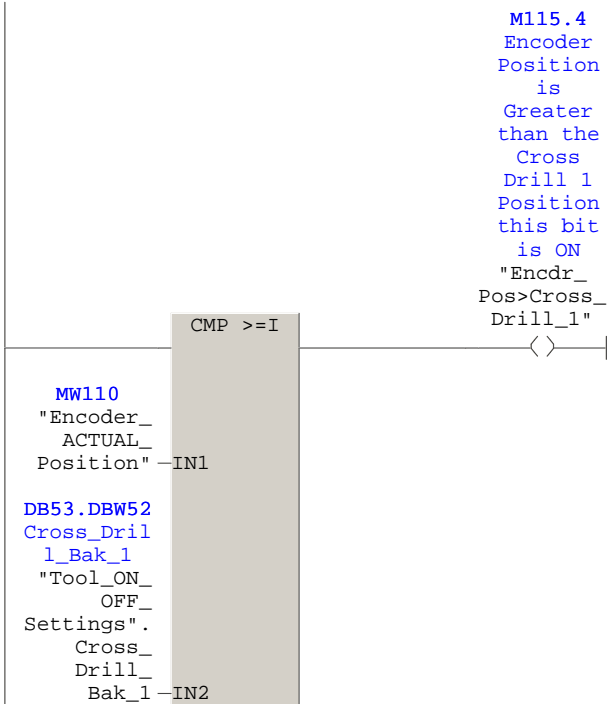


Network: 14 Jump to here if and Execute if Cross\_Drill 1\_Bak > 2\_Bak

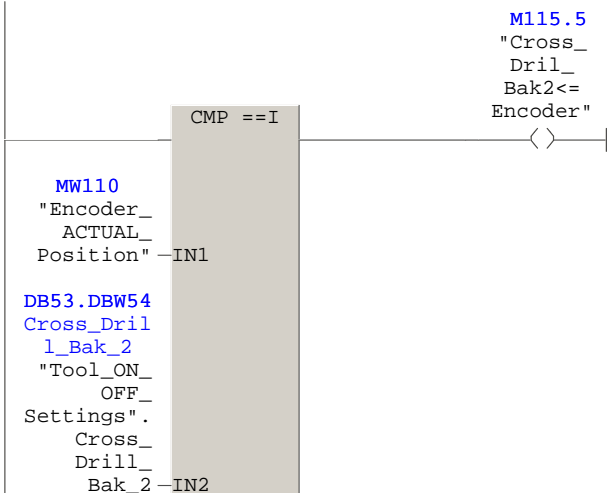
M001



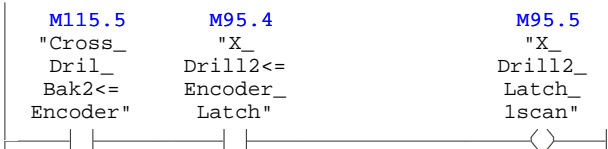
Network: 15 Encoder Position is Greater than the Cross Drill 1 Position



Network: 16 Encoder Position is = Cross Drill Back 2 Position



Network: 17



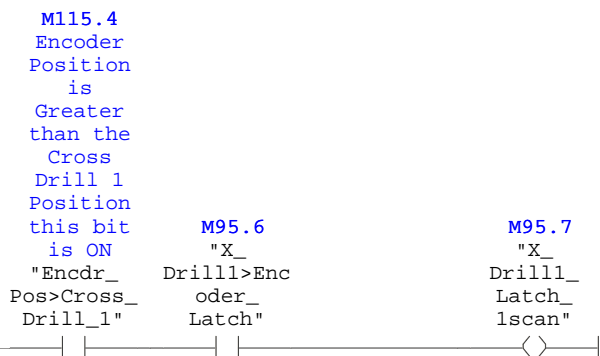
Network: 18



Network: 19



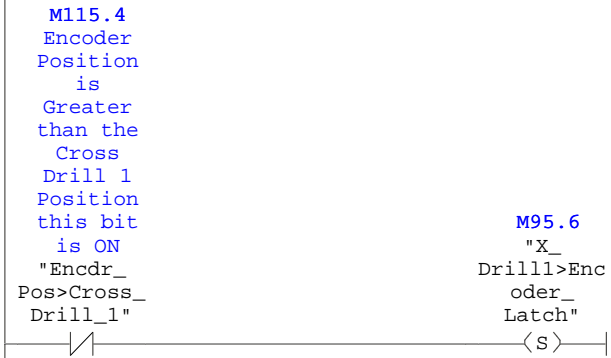
Network: 20



Network: 21



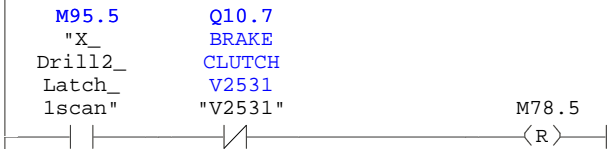
Network: 22



Network: 23



Network: 24

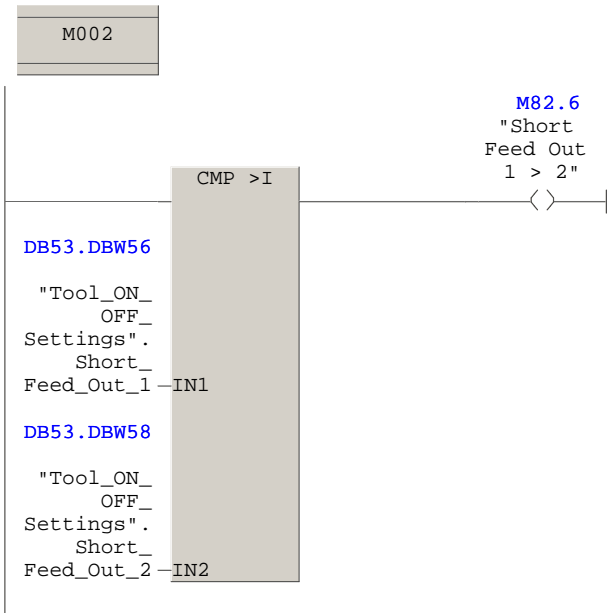


Network: 25





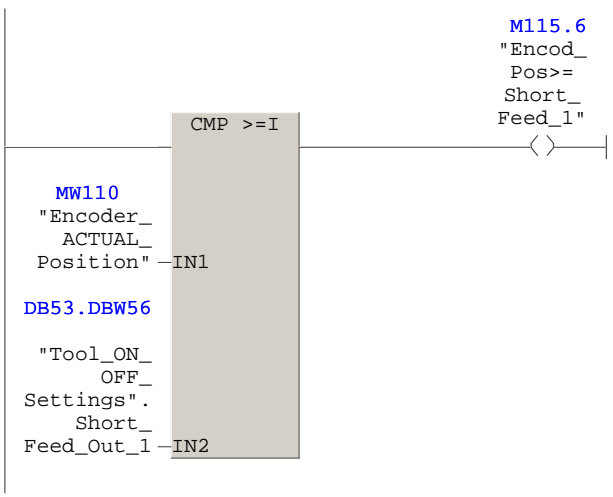
Network: 26 Jump to here if and Execute if Cross\_Drill 1\_Bak < 2\_Bak



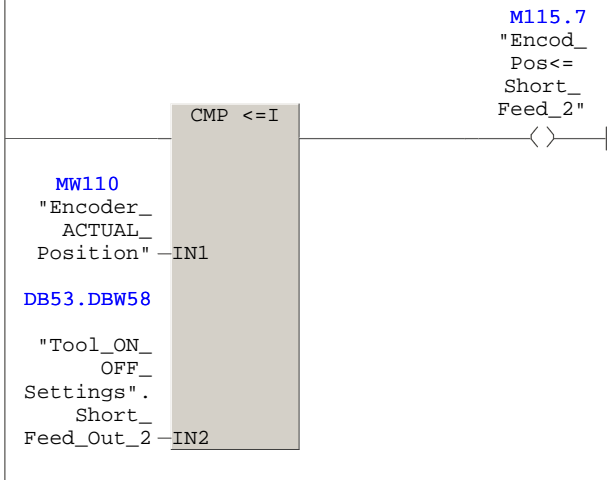
Network: 27



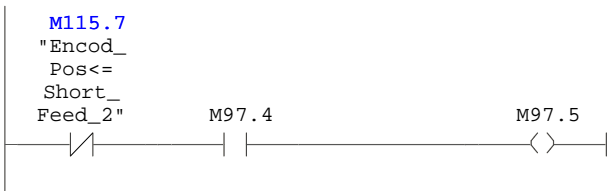
Network: 28 Encoder Position is >= than Short Feed Out 1 Position



Network: 29 Encoder Position is <= than Short Feed Out 2 Position



Network: 30



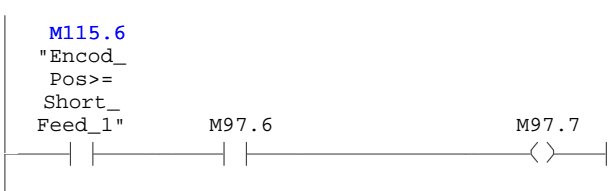
Network: 31



Network: 32



Network: 33



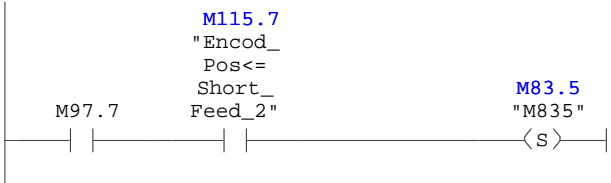
Network: 34



Network: 35



Network: 36



Network: 37



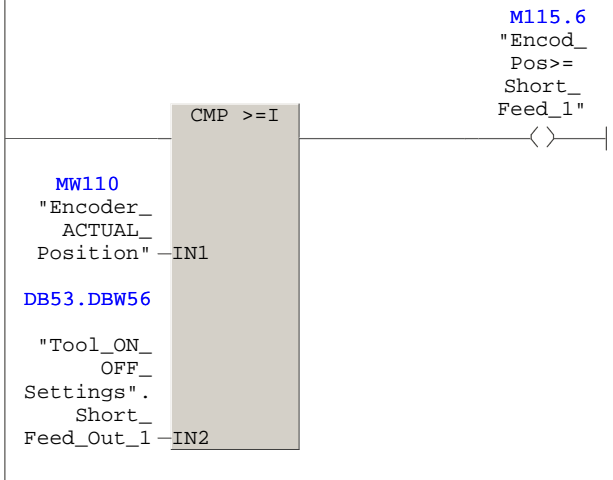
Network: 38 ShortFeedRange (~270-10d)



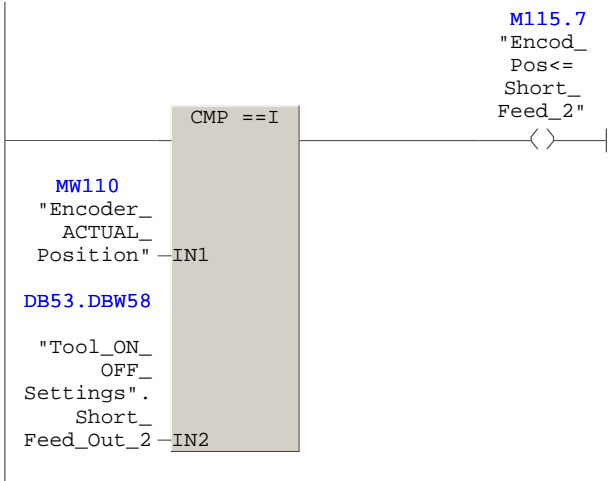
Network: 39 Jump to here and execute if Short Feed Out 1 > 2



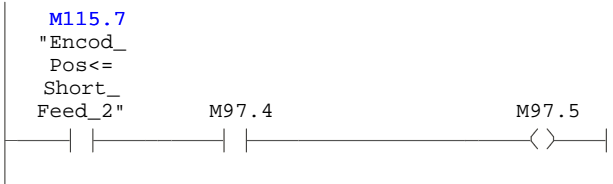
Network: 40 Encoder Position >= Short Feed out 1 Position



Network: 41 Encoder Position = Short Feed out 2 Position



Network: 42



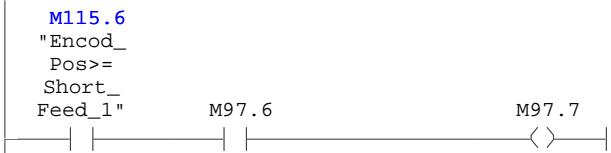
Network: 43



Network: 44



Network: 45



Network: 46



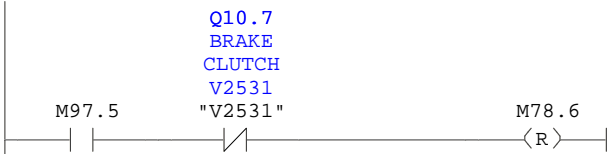
Network: 47



Network: 48



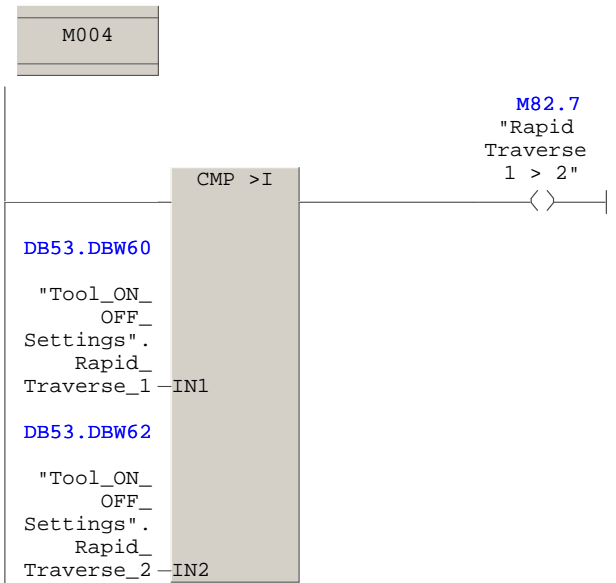
Network: 49



Network: 50 ShortFeedRange(~270-10d)



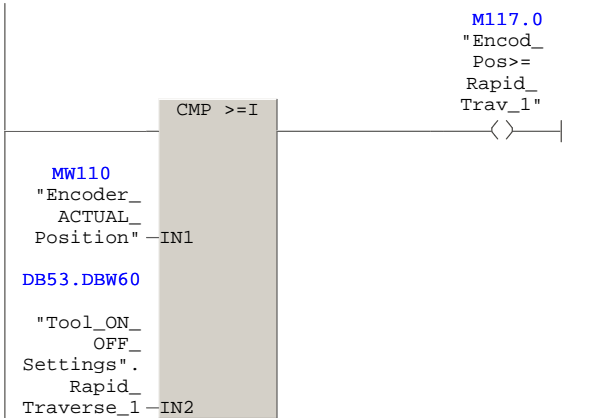
Network: 51 Jump to here and execute if Short Feed Out 1 < 2



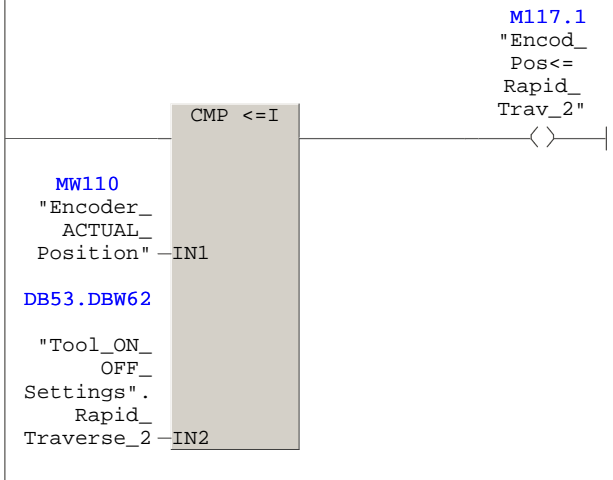
Network: 52



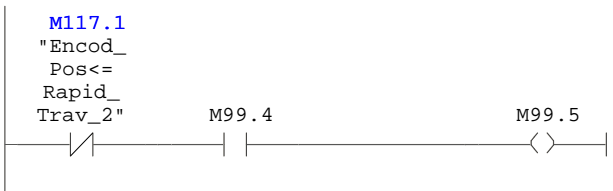
Network: 53 Encoder Position >= Rapid Traverse 1 Position



Network: 54 Encoder Position <= Rapid Traverse 2 Position



Network: 55



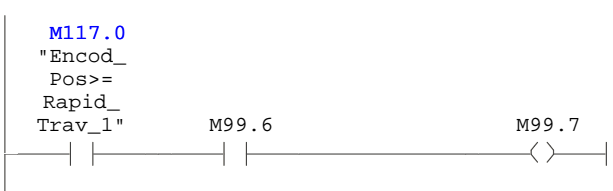
Network: 56



Network: 57



Network: 58



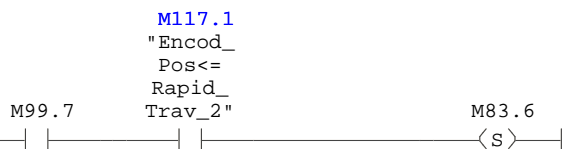
Network: 59



Network: 60



Network: 61



Network: 62



Network: 63 DRUM ROT.CONTR. -SOFTWCAM



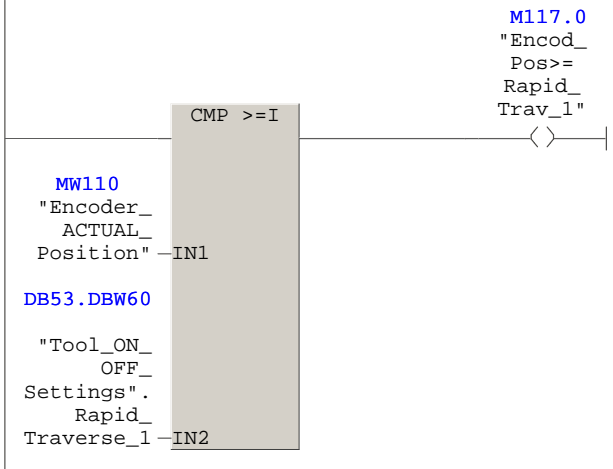
Network: 64 Jump to here and execute if Rapid Traverse 1 &gt; 2

M005

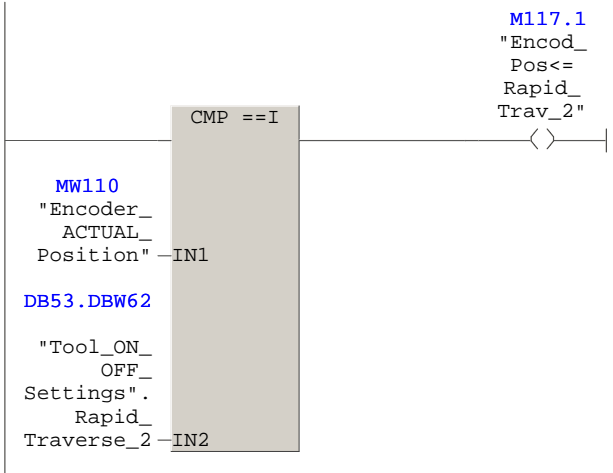




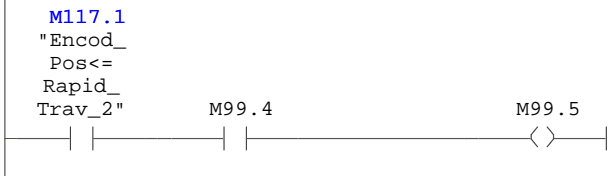
Network: 65 Encoder Position >= Rapid Traverse 1 Position



Network: 66 Encoder Position = Rapid Traverse 2 Position



Network: 67



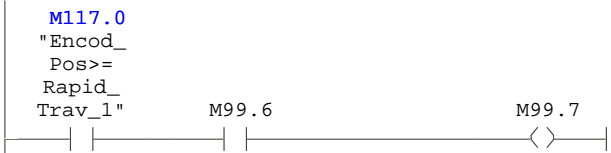
Network: 68



Network: 69



Network: 70



Network: 71



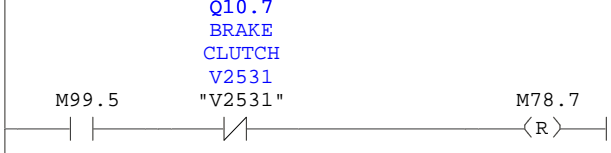
Network: 72



Network: 73



Network: 74



Network: 75 DRUM ROT.CONTR.-SOFTWCAM



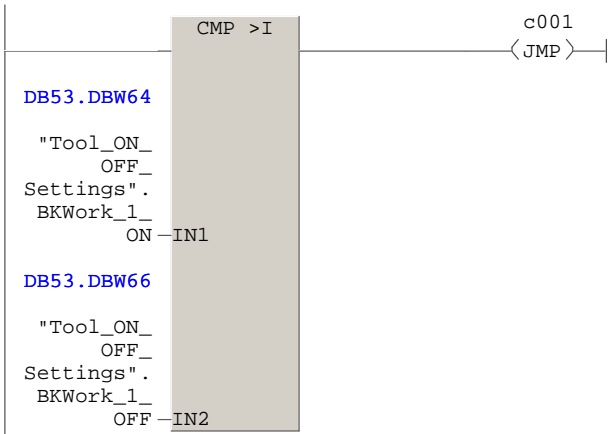
Network: 76 Jump to here and execute if Rapid Traverse 1 < 2



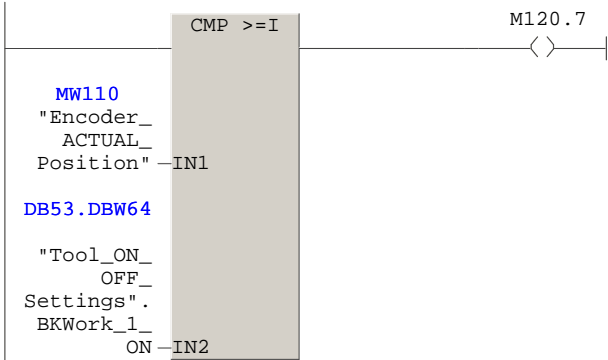
Network: 77



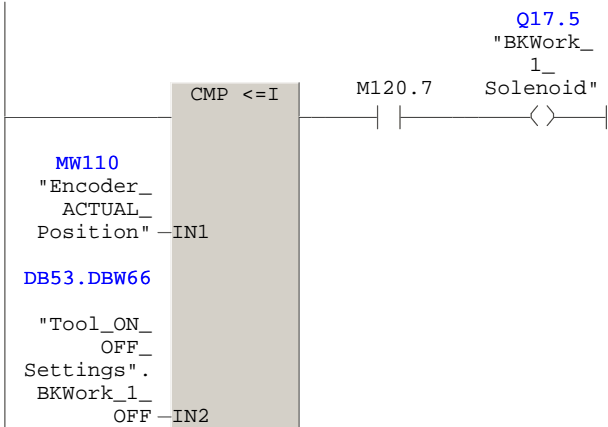
Network: 78 Jump if Back Working 1 ON is > than Back Working 1 OFF Position



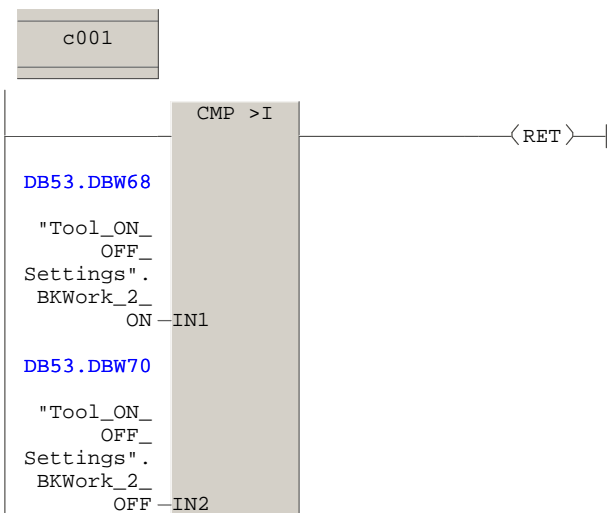
Network: 79 Encoder Position is >= than Back Working 1 ON Position



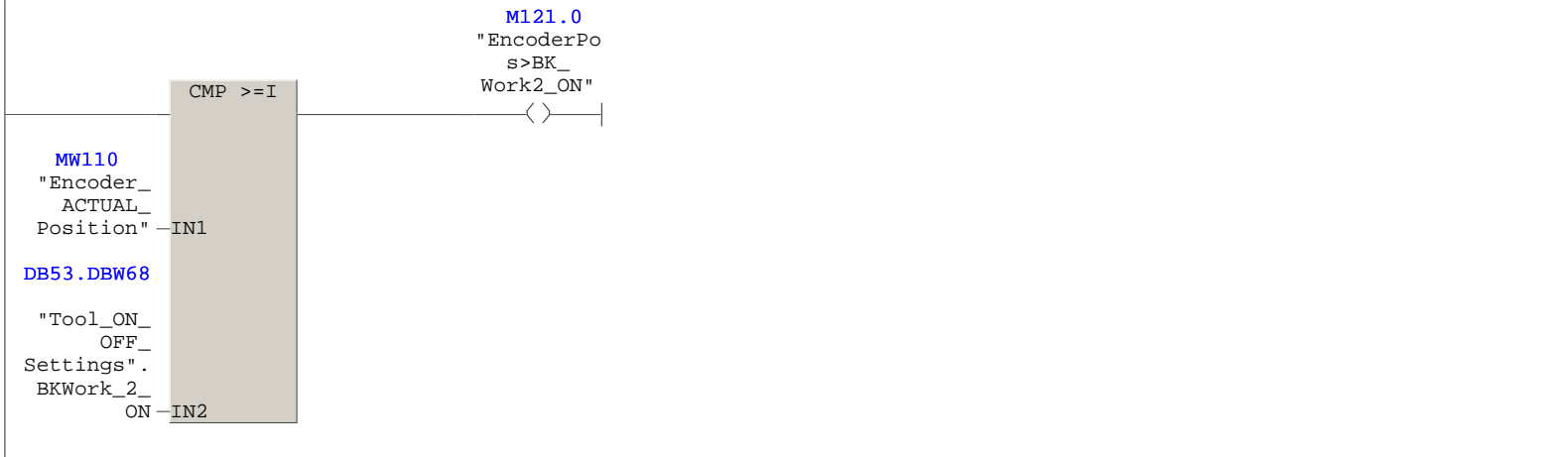
Network: 80 Encoder Position < Back Working 1 OFF Position BK working Sol ON



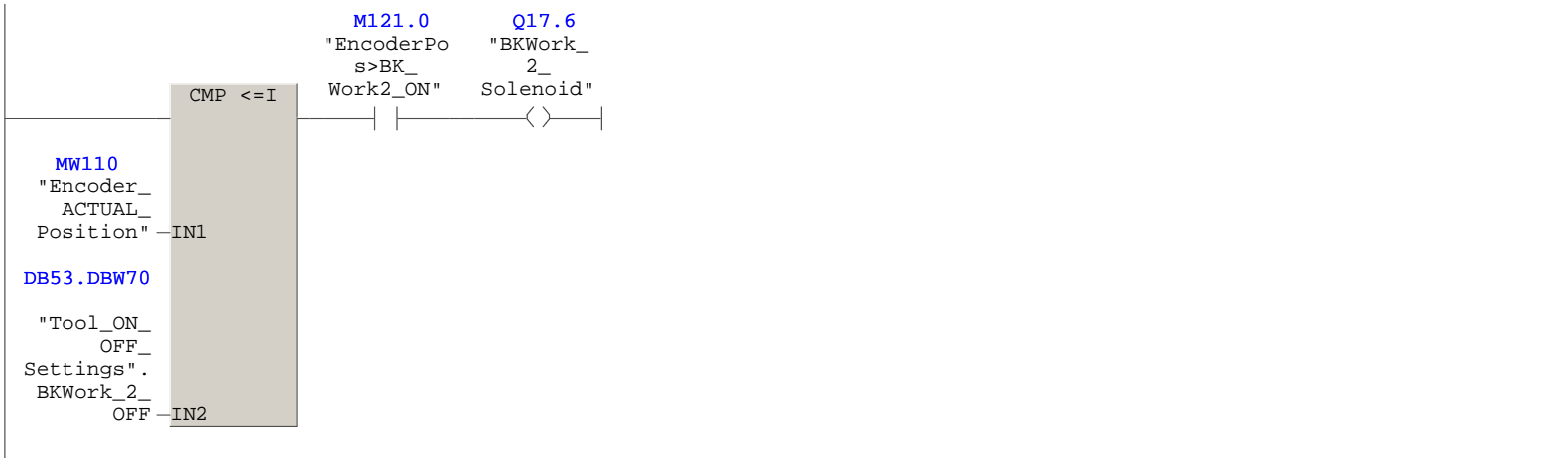
Network: 81 Jump here and execute if Back Working 1 ON POSITION > OFF



Network: 82 Encoder Position is > than Back Working 2 ON Position



Network: 83 EncoderPos < BK\_Work2\_OFF turn on the solenoid



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