

长度(块/逻辑/数据): 11678 10678 00048

第 1 页/共 34 页

名称	数据类型	地址	初始值	注释
STAT26	String[3]	194.0	'B3 '	
STAT27	String[4]	200.0	'JOG '	
STAT28	String[4]	206.0	'MDA '	
STAT29	String[4]	212.0	'AUTO'	
STAT30	String[4]	218.0	' '	
STAT31	String[4]	224.0	' '	
STAT32	String[4]	230.0	' %'	
STAT33	String[32]	236.0	' '	
STAT34	Real	270.0	1.234567e+002	
STAT35	Bool	274.0	FALSE	
STAT36	Bool	274.1	FALSE	
STAT37	Bool	274.2	FALSE	
STAT38	Bool	274.3	FALSE	
STAT39	Word	276.0	W#16#0	
STAT40	Array [1..32] Of Bool	278.0		
STAT41	Bool	282.0	FALSE	
STAT42	Bool	282.1	FALSE	
STAT43	Bool	282.2	FALSE	
STAT44	Bool	282.3	FALSE	
STAT45	String[3]	284.0	'G3 '	
STAT46	String[4]	290.0	'LOAD'	
STAT47	String[3]	296.0	'X2 '	
STAT48	String[3]	302.0	'Y2 '	
STAT49	String[3]	308.0	'RT '	
STAT50	String[3]	314.0	'Y22'	
STAT51	String[3]	320.0	'FT '	
STAT52	String[3]	326.0	'Y21'	
STAT53	String[3]	332.0	'GrL'	
STAT54	String[3]	338.0	'GrR'	
STAT55	String[3]	344.0	'X21'	
STAT56	String[3]	350.0	'X22'	
TEMP		0.0		
TEMP57	Bool	0.0		
TEMP58	Bool	0.1		
TEMP59	Bool	0.2		
TEMP60	Bool	0.3		
TEMP61	Bool	0.4		

名称	数据类型	地址	初始值	注释
TEMP62	Bool	0.5		
TEMP63	Bool	0.6		
TEMP64	Int	2.0		
TEMP65	Int	4.0		
TEMP66	Int	6.0		
TEMP67	Word	8.0		
TEMP68	Byte	10.0		
TEMP69	Int	12.0		
TEMP70	Byte	14.0		
TEMP71	Byte	15.0		
TEMP72	Int	16.0		
TEMP73	Word	18.0		

块：FB129MSST 19in MCP2

STEP7中有两种用来定义符号地址的表格形式:符号表(共享符号)和变量声明表(局域符号),其本质都是为了建立绝对地址与符号地址之间的内在联系,但表格针对的对象不同。共享符号是整个程序所使用的共同符号(用于全局符号定义的表为符号表);而局域符号是某一特定逻辑块(OB、FB、FC等)所使用的临时性标记,只能在特定的逻辑块中进行临时性定义。用于临时性的、局域符号定义的表被称为变量声明表,又称局部变量声明表。
局部变量声明表分为参数(输入参数IN、输出参数OUT、输入/输出参数IN_OUT)和局部变量。局部变量又包括静态变量(STAT)和临时变量(TEMP)两种。

程序段：1machine is C40u cuttingmachine

```
A      "Setup"  M6.0          -- Setup-Mode Active
FP     #STAT41  #STAT41
=      #STAT42  #STAT42
```

程序段：2A1-axis existiert

```
0      "Machine_C40U"  M298.4      -- machine is C40u cuttingmachine
0      "Machine_C60U"  M298.6      -- machine is C60U cuttingmachine
0      "Machine_C28P"  M298.2      -- machine is C28P cuttingmachine
0      "Machine_C100U" M298.7      -- machine is C100U cuttingmachine
=      "A1AxisExcists" M353.0      -- A1-axis existiert
```

程序段：3

```
A      "True"          M0.1          -- static HIGH-signal
=      #TEMP59          #TEMP59
A      #TEMP59          #TEMP59
A(
0      "Setup"          M6.0          -- Setup-Mode Active
0      "True"           M0.1          -- static HIGH-signal
)
A      "CopPlcData".STAT98 DB151.DBX25.4
```

```
A    #STAT0          #STAT0
R    #STAT0          #STAT0
R    #TEMP59         #TEMP59
```

程序段: 4

```
A(
O    "Setup"          M6.0          -- Setup-Mode Active
O    "True"           M0.1          -- static HIGH-signal
)
AN   "CopPlcData".STAT98 DB151.DBX25.4
AN   #STAT0           #STAT0
A    #TEMP59          #TEMP59
S    #STAT0           #STAT0
```

程序段: 5

```
A    #STAT0          #STAT0
=    "BhgIsConM"      M362.2        -- BHG is connected
```

程序段: 6

```
A(
A(
ON   "Setup"          M6.0          -- Setup-Mode Active
O
A    "CusDCMett"       M358.1        -- customercode DC-Mettingen
AN   "AllDoLo"         M295.4        -- all safetydoors are locked
AN   "Ing_EKey"        M442.1
)
JNB  _001
CALL "IEC-Replace"     FC231         -- part of string replace
IN0  :=#STAT1          #STAT1
IN1  :=#STAT33         #STAT33
IN2  :=32
IN3  :=1
RET_VAL:=#STAT1        #STAT1
_001: A    BR
)
JNB  _002
L    3
T    #TEMP68           #TEMP68
SET
SAVE
CLR
_002: A    BR
JC    M003
```

程序段: 7

```
O(
CALL "IEC-Replace"     FC231         -- part of string replace
IN0  :=#STAT1          #STAT1
IN1  :=#STAT30         #STAT30
IN2  :=4
IN3  :=1
RET_VAL:=#STAT1        #STAT1
A    BR
```

```
)
O(
A      "LedJog"          M126.3          -- LED Jog-operatorpanel
JNB    _003
CALL   "IEC-Replace"     FC231           -- part of string replace
IN0    :=#STAT1          #STAT1
IN1    :=#STAT27         #STAT27
IN2    :=4
IN3    :=1
RET_VAL:=#STAT1          #STAT1
_003: A      BR
)
O(
A      "LedJog"          M126.3          -- LED Jog-operatorpanel
A      "SelAxLoaderBhg"  M362.1          -- select axis loader via BHG
JNB    _004
CALL   "IEC-Replace"     FC231           -- part of string replace
IN0    :=#STAT1          #STAT1
IN1    :=#STAT46         #STAT46
IN2    :=4
IN3    :=1
RET_VAL:=#STAT1          #STAT1
_004: A      BR
)
O(
A      "LedMda"          M126.1          -- LED MDA-operatorpanel
JNB    _005
CALL   "IEC-Replace"     FC231           -- part of string replace
IN0    :=#STAT1          #STAT1
IN1    :=#STAT28         #STAT28
IN2    :=4
IN3    :=1
RET_VAL:=#STAT1          #STAT1
_005: A      BR
)
O(
A      "LedAuto"         M126.0          -- LED Auto-operatorpanel
JNB    _006
CALL   "IEC-Replace"     FC231           -- part of string replace
IN0    :=#STAT1          #STAT1
IN1    :=#STAT29         #STAT29
IN2    :=4
IN3    :=1
RET_VAL:=#STAT1          #STAT1
_006: A      BR
)
=      #TEMP59           #TEMP59
```

程序段: 8

```
O(
A(
A(
L      "Ovr"            MW8              -- active value Override
L      10
<I
)
JNB    _007
L      1
T      #TEMP65          #TEMP65
SET
SAVE
CLR
_007: A      BR
```

```
)
JNB _008
L 15
T #TEMP66 #TEMP66
SET
SAVE
CLR
_008: A BR
)
O(
A(
A(
L "Ovr" MW8 -- active value Override
L 10
>=I
)
A(
L "Ovr" MW8 -- active value Override
L 100
<I
)
JNB _009
L 2
T #TEMP65 #TEMP65
SET
SAVE
CLR
_009: A BR
)
JNB _00a
L 14
T #TEMP66 #TEMP66
SET
SAVE
CLR
_00a: A BR
)
O(
A(
A(
L "Ovr" MW8 -- active value Override
L 100
>=I
)
JNB _00b
L 3
T #TEMP65 #TEMP65
SET
SAVE
CLR
_00b: A BR
)
JNB _00c
L 13
T #TEMP66 #TEMP66
SET
SAVE
CLR
_00c: A BR
)
= #TEMP59 #TEMP59
```

程序段: 9

```

A(
A(
A(
CALL "IEC-I_Strng" FC216      -- Integer convert to string
IN0  := "Ovr"             MW8      -- active value Override
RET_VAL := #STAT31        #STAT31
A    BR
)
JNB _00d
CALL "IEC-Delete" FC204      -- delete part of string
IN0  := #STAT31            #STAT31
IN1  := 1
IN2  := 1
RET_VAL := #STAT31        #STAT31
_00d: A    BR
)
JNB _00e
CALL "IEC-Replace" FC231      -- part of string replace
IN0  := #STAT1            #STAT1
IN1  := #STAT32           #STAT32
IN2  := 4
IN3  := 13
RET_VAL := #STAT1        #STAT1
_00e: A    BR
)
JNB _00f
CALL "IEC-Replace" FC231      -- part of string replace
IN0  := #STAT1            #STAT1
IN1  := #STAT31           #STAT31
IN2  := #TEMP65           #TEMP65
IN3  := #TEMP66           #TEMP66
RET_VAL := #STAT1        #STAT1
_00f: A    BR
=      #TEMP59            #TEMP59

```

程序段: 10

```

O(
A    "Ax1Sel-X"           M24.0      -- axis 1 selected-X
JNB _010
CALL "IEC-Replace" FC231      -- part of string replace
IN0  := #STAT1            #STAT1
IN1  := #STAT9           #STAT9
IN2  := 3
IN3  := 17
RET_VAL := #STAT1        #STAT1
_010: A    BR
)
O(
A    "Ax2Sel-Y"           M24.1      -- axis 2 selected-Y
JNB _011
CALL "IEC-Replace" FC231      -- part of string replace
IN0  := #STAT1            #STAT1
IN1  := #STAT10          #STAT10
IN2  := 3
IN3  := 17
RET_VAL := #STAT1        #STAT1
_011: A    BR
)

```

```

O(
A      "Ax3Sel-Z"          M24.2          -- axis 3 selected-Z
JNB    _012
CALL   "IEC-Replace"      FC231          -- part of string replace
IN0    :=#STAT1            #STAT1
IN1    :=#STAT11          #STAT11
IN2    :=3
IN3    :=17
RET_VAL:=#STAT1          #STAT1
_012: A      BR
)
O(
A      "Ax4Sel-A"          M24.3          -- axis 4 selected-A
JNB    _013
CALL   "IEC-Replace"      FC231          -- part of string replace
IN0    :=#STAT1            #STAT1
IN1    :=#STAT12          #STAT12
IN2    :=3
IN3    :=17
RET_VAL:=#STAT1          #STAT1
_013: A      BR
)
O(
A      "Ax5Sel-B"          M24.4          -- axis 5 selected-B
O      "Ax10Sel"           M25.1          -- axis 10 selected
)
JNB    _014
CALL   "IEC-Replace"      FC231          -- part of string replace
IN0    :=#STAT1            #STAT1
IN1    :=#STAT13          #STAT13
IN2    :=3
IN3    :=17
RET_VAL:=#STAT1          #STAT1
_014: A      BR
)
O(
A      "Ax6Sel-C"          M24.5          -- axis 6 selected-C
JNB    _015
CALL   "IEC-Replace"      FC231          -- part of string replace
IN0    :=#STAT1            #STAT1
IN1    :=#STAT14          #STAT14
IN2    :=3
IN3    :=17
RET_VAL:=#STAT1          #STAT1
_015: A      BR
)
O(
A      "Ax7Sel-V"          M24.6          -- axis 7 selected-V
JNB    _016
CALL   "IEC-Replace"      FC231          -- part of string replace
IN0    :=#STAT1            #STAT1
IN1    :=#STAT15          #STAT15
IN2    :=3
IN3    :=17
RET_VAL:=#STAT1          #STAT1
_016: A      BR
)
O(
A      "Ax8Sel-W"          M24.7          -- axis 8 selected-W
JNB    _017
CALL   "IEC-Replace"      FC231          -- part of string replace
IN0    :=#STAT1            #STAT1
IN1    :=#STAT16          #STAT16
IN2    :=3
IN3    :=17

```

```

    RET_VAL:=#STAT1      #STAT1
_017: A      BR
    )
    O(
    A      "Ax9Sel-X1"      M25.0      -- axis 9 selected-X1
    JNB     _018
    CALL    "IEC-Replace"    FC231      -- part of string replace
    IN0     :=#STAT1      #STAT1
    IN1     :=#STAT20     #STAT20
    IN2     :=3
    IN3     :=17
    RET_VAL:=#STAT1      #STAT1
_018: A      BR
    )
    O(
    A      "Ax11Sel-A1"      M25.2      -- axis 11 selected-A1
    JNB     _019
    CALL    "IEC-Replace"    FC231      -- part of string replace
    IN0     :=#STAT1      #STAT1
    IN1     :=#STAT21     #STAT21
    IN2     :=3
    IN3     :=17
    RET_VAL:=#STAT1      #STAT1
_019: A      BR
    )
    O(
    A      "Ax13Sel-U&X2"      M25.4      -- axis 13 selected-U&X2
    JNB     _01a
    CALL    "IEC-Replace"    FC231      -- part of string replace
    IN0     :=#STAT1      #STAT1
    IN1     :=#STAT18     #STAT18
    IN2     :=3
    IN3     :=17
    RET_VAL:=#STAT1      #STAT1
_01a: A      BR
    )
    O(
    A      "Ax13Sel-U&X2"      M25.4      -- axis 13 selected-U&X2
    A      "C29_50_AxConfig"    M404.4      -- C29/C50 axisconfiguration
    JNB     _01b
    CALL    "IEC-Replace"    FC231      -- part of string replace
    IN0     :=#STAT1      #STAT1
    IN1     :=#STAT47     #STAT47
    IN2     :=3
    IN3     :=17
    RET_VAL:=#STAT1      #STAT1
_01b: A      BR
    )
    O(
    A      "Ax14Sel-V1"      M25.5      -- axis 14 selected-V1
    JNB     _01c
    CALL    "IEC-Replace"    FC231      -- part of string replace
    IN0     :=#STAT1      #STAT1
    IN1     :=#STAT19     #STAT19
    IN2     :=3
    IN3     :=17
    RET_VAL:=#STAT1      #STAT1
_01c: A      BR
    )
    O(
    A      "Ax15Sel-Q"      M25.6      -- axis 15 selected-Q
    JNB     _01d
    CALL    "IEC-Replace"    FC231      -- part of string replace
    IN0     :=#STAT1      #STAT1
    IN1     :=#STAT17     #STAT17
    IN2     :=3

```

```
      IN3      :=17
      RET_VAL:=#STAT1      #STAT1
_01d: A      BR
      )
      =      #TEMP59      #TEMP59
```

程序段: 11

```
      O(
      A      "True"      M0.1      -- static HIGH-signal
      JNB      _01e
      CALL      "IEC-Replace"      FC231      -- part of string replace
      IN0      :=#STAT1      #STAT1
      IN1      :=#STAT8      #STAT8
      IN2      :=5
      IN3      :=6
      RET_VAL:=#STAT1      #STAT1
_01e: A      BR
      )
      O(
      A      "Led1"      M126.4      -- LED Step 1 operatorpanel
      JNB      _01f
      CALL      "IEC-Replace"      FC231      -- part of string replace
      IN0      :=#STAT1      #STAT1
      IN1      :=#STAT2      #STAT2
      IN2      :=5
      IN3      :=6
      RET_VAL:=#STAT1      #STAT1
_01f: A      BR
      )
      O(
      A      "Led10"      M126.5      -- LED Step 10 operatorpanel
      JNB      _020
      CALL      "IEC-Replace"      FC231      -- part of string replace
      IN0      :=#STAT1      #STAT1
      IN1      :=#STAT3      #STAT3
      IN2      :=5
      IN3      :=6
      RET_VAL:=#STAT1      #STAT1
_020: A      BR
      )
      O(
      A      "Led100"      M126.6      -- LED Step 100 operatorpanel
      JNB      _021
      CALL      "IEC-Replace"      FC231      -- part of string replace
      IN0      :=#STAT1      #STAT1
      IN1      :=#STAT4      #STAT4
      IN2      :=5
      IN3      :=6
      RET_VAL:=#STAT1      #STAT1
_021: A      BR
      )
      O(
      A      "Led1000"      M126.7      -- LED Step 1000 operatorpanel
      JNB      _022
      CALL      "IEC-Replace"      FC231      -- part of string replace
      IN0      :=#STAT1      #STAT1
      IN1      :=#STAT5      #STAT5
      IN2      :=5
      IN3      :=6
      RET_VAL:=#STAT1      #STAT1
_022: A      BR
      )
      O(
```

```
A      "Led10000"      M127.0      -- LED Step 10000 operatorpanel
JNB    _023
CALL   "IEC-Replace"   FC231      -- part of string replace
IN0    :=#STAT1        #STAT1
IN1    :=#STAT6        #STAT6
IN2    :=5
IN3    :=6
RET_VAL:=#STAT1        #STAT1
_023: A      BR
      )
      O(
      A      "LedVar"      M127.1      -- LED Var operatorpanel
      JNB    _024
      CALL   "IEC-Replace"   FC231      -- part of string replace
      IN0    :=#STAT1        #STAT1
      IN1    :=#STAT7        #STAT7
      IN2    :=5
      IN3    :=6
      RET_VAL:=#STAT1        #STAT1
_024: A      BR
      )
      =      #TEMP59        #TEMP59
```

程序段: 12

```
O(
A      "Ax17Sel-Y21"      M26.0      -- axis 17 selected-Y21
JNB    _025
CALL   "IEC-Replace"   FC231      -- part of string replace
IN0    :=#STAT1        #STAT1
IN1    :=#STAT52        #STAT52
IN2    :=3
IN3    :=17
RET_VAL:=#STAT1        #STAT1
_025: A      BR
      )
      O(
      A      "Ax18Sel-X21"      M26.1      -- axis 18 selected-X21
      JNB    _026
      CALL   "IEC-Replace"   FC231      -- part of string replace
      IN0    :=#STAT1        #STAT1
      IN1    :=#STAT55        #STAT55
      IN2    :=3
      IN3    :=17
      RET_VAL:=#STAT1        #STAT1
_026: A      BR
      )
      O(
      A      "Ax19Sel-X22"      M26.2      -- axis 19 selected-X22
      JNB    _027
      CALL   "IEC-Replace"   FC231      -- part of string replace
      IN0    :=#STAT1        #STAT1
      IN1    :=#STAT56        #STAT56
      IN2    :=3
      IN3    :=17
      RET_VAL:=#STAT1        #STAT1
_027: A      BR
      )
      O(
      A      "Ax20Sel"      M26.3      -- axis 20 selected
      JNB    _028
      CALL   "IEC-Replace"   FC231      -- part of string replace
      IN0    :=#STAT1        #STAT1
      IN1    :=#STAT50        #STAT50
```

```
IN2      :=3
IN3      :=17
RET_VAL :=#STAT1      #STAT1
_028: A    BR
      )
      O(
      A    "Ax25Sel"      M27.0      -- axis 25 selected
      A(
      O    "LoaderC50Emo" M411.1      -- BeLoadertyp C50 EM0
      O    "LoadC50Int"   M411.2      -- Internal loader C50
      )
      A    "SelAxLoaderBhg" M362.1      -- select axis loader via BHG
      JNB  _029
      CALL "IEC-Replace"   FC231      -- part of string replace
      IN0   :=#STAT1      #STAT1
      IN1   :=#STAT54     #STAT54
      IN2   :=3
      IN3   :=17
      RET_VAL :=#STAT1      #STAT1
_029: A    BR
      )
      O(
      A    "Ax26Sel"      M27.1      -- axis 26 selected
      A(
      O    "LoaderC50Emo" M411.1      -- BeLoadertyp C50 EM0
      O    "LoadC50Int"   M411.2      -- Internal loader C50
      )
      A    "SelAxLoaderBhg" M362.1      -- select axis loader via BHG
      JNB  _02a
      CALL "IEC-Replace"   FC231      -- part of string replace
      IN0   :=#STAT1      #STAT1
      IN1   :=#STAT53     #STAT53
      IN2   :=3
      IN3   :=17
      RET_VAL :=#STAT1      #STAT1
_02a: A    BR
      )
      =    #TEMP59        #TEMP59
```

程序段: 13

```
      O(
      A    "Ax1Sel-X"      M24.0      -- axis 1 selected-X
      A    "Ax1Act-X"      M20.0      -- axis 1 active-X
      AN   "COPAct"        M6.2      -- COP active
      JNB  _02b
      L    1
      T    #TEMP67        #TEMP67
      SET
      SAVE
      CLR
_02b: A    BR
      )
      O(
      A    "Ax2Sel-Y"      M24.1      -- axis 2 selected-Y
      A    "Ax2Act-Y"      M20.1      -- axis 2 active-Y
      JNB  _02c
      L    2
      T    #TEMP67        #TEMP67
      SET
      SAVE
      CLR
_02c: A    BR
      )
```

```

O(
A    "Ax3Sel-Z"      M24.2      -- axis 3 selected-Z
A    "Ax3Act-Z"      M20.2      -- axis 3 active-Z
JNB  _02d
L    3
T    #TEMP67          #TEMP67
SET
SAVE
CLR
_02d: A    BR
)
O(
A    "Ax4Sel-A"      M24.3      -- axis 4 selected-A
A    "Ax4Act-A"      M20.3      -- axis 4 active-A
JNB  _02e
L    4
T    #TEMP67          #TEMP67
SET
SAVE
CLR
_02e: A    BR
)
O(
A    "Ax5Sel-B"      M24.4      -- axis 5 selected-B
A    "Ax5Act-B"      M20.4      -- axis 5 active-B
O
A    "Ax10Sel"        M25.1      -- axis 10 selected
A    "Ax10Act"        M21.1      -- axis 10 active
)
AN    "BAxCopB11"     M294.6     -- B-axis is coupling mit B11
AN    "BAxCopB12"     M294.7     -- B-axis is coupling with B12-axis
JNB  _02f
L    5
T    #TEMP67          #TEMP67
SET
SAVE
CLR
_02f: A    BR
)
O(
A    "Ax6Sel-C"      M24.5      -- axis 6 selected-C
A    "Ax6Act-C"      M20.5      -- axis 6 active-C
JNB  _030
L    6
T    #TEMP67          #TEMP67
SET
SAVE
CLR
_030: A    BR
)
O(
A    "Ax7Sel-V"      M24.6      -- axis 7 selected-V
A    "Ax7Act-V"      M20.6      -- axis 7 active-V
JNB  _031
L    7
T    #TEMP67          #TEMP67
SET
SAVE
CLR
_031: A    BR
)
O(
A    "Ax8Sel-W"      M24.7      -- axis 8 selected-W
A    "Ax8Act-W"      M20.7      -- axis 8 active-W
JNB  _032

```

```
L      8
T      #TEMP67          #TEMP67
SET
SAVE
CLR
_032: A      BR
)
O(
A      "Ax9Sel-X1"      M25.0      -- axis 9 selected-X1
A      "Ax9Act-X1"      M21.0      -- axis 9 active-X1
JNB    _033
L      9
T      #TEMP67          #TEMP67
SET
SAVE
CLR
_033: A      BR
)
O(
A      "Ax9Sel-X1"      M25.0      -- axis 9 selected-X1
A      "Ax9Act-X1"      M21.0      -- axis 9 active-X1
A      "C29_50_AxConfig" M404.4    -- C29/C50 axisconfiguration
JNB    _034
L      9
T      #TEMP67          #TEMP67
SET
SAVE
CLR
_034: A      BR
)
O(
A      "Ax10Sel"        M25.1      -- axis 10 selected
A      "Ax10Act"        M21.1      -- axis 10 active
O
A      "Ax5Sel-B"       M24.4      -- axis 5 selected-B
A      "Ax5Act-B"       M20.4      -- axis 5 active-B
)
A      "BAxCopB11"      M294.6     -- B-axis is coupling mit B11
JNB    _035
L      10
T      #TEMP67          #TEMP67
SET
SAVE
CLR
_035: A      BR
)
O(
A      "Ax11Sel-A1"     M25.2      -- axis 11 selected-A1
A      "Ax11Act-A1"     M21.2      -- axis 11 active-A1
JNB    _036
L      11
T      #TEMP67          #TEMP67
SET
SAVE
CLR
_036: A      BR
)
O(
A      "Ax12Sel"        M25.3      -- axis 12 selected
A      "Ax12Act"        M21.3      -- axis 12 active
JNB    _037
L      12
T      #TEMP67          #TEMP67
SET
SAVE
```

```
CLR
_037: A BR
)
O(
A "Ax13Sel-U&X2" M25.4 -- axis 13 selected-U&X2
A "Ax13Act-U&X2" M21.4 -- axis 13 active-U&X2
JNB _038
L 1
T #TEMP67 #TEMP67
SET
SAVE
CLR
_038: A BR
)
O(
A "Ax13Sel-U&X2" M25.4 -- axis 13 selected-U&X2
A "Ax13Act-U&X2" M21.4 -- axis 13 active-U&X2
A "C29_50_AxConfig" M404.4 -- C29/C50 axisconfiguration
JNB _039
L 10
T #TEMP67 #TEMP67
SET
SAVE
CLR
_039: A BR
)
O(
A "Ax14Sel-V1" M25.5 -- axis 14 selected-V1
A "Ax14Act-V1" M21.5 -- axis 14 active-V1
JNB _03a
L 2
T #TEMP67 #TEMP67
SET
SAVE
CLR
_03a: A BR
)
O(
A "Ax15Sel-Q" M25.6 -- axis 15 selected-Q
A "Ax15Act-Q" M21.6 -- axis 15 active-Q
JNB _03b
L 3
T #TEMP67 #TEMP67
SET
SAVE
CLR
_03b: A BR
)
O(
A "Ax15Sel-Q" M25.6 -- axis 15 selected-Q
A "Ax15Act-Q" M21.6 -- axis 15 active-Q
A "C29_50_AxConfig" M404.4 -- C29/C50 axisconfiguration
JNB _03c
L 11
T #TEMP67 #TEMP67
SET
SAVE
CLR
_03c: A BR
)
O(
A(
A(
A "Ax10Sel" M25.1 -- axis 10 selected
A "Ax10Act" M21.1 -- axis 10 active
O
```

```
A      "Ax5Sel-B"      M24.4      -- axis 5 selected-B
A      "Ax5Act-B"      M20.4      -- axis 5 active-B
)
A      "BAxCopB12"     M294.7     -- B-axis is coupling with B12-axis
O
A      "Ax16Sel"       M25.7     -- axis 16 selected-
A      "Ax16Act"       M21.7     -- axis 16 active
)
JNB    _03d
L      4
T      #TEMP67         #TEMP67
SET
SAVE
CLR
_03d: A      BR
)
O(
A      "Ax17Sel-Y21"   M26.0     -- axis 17 selected-Y21
JNB    _03e
L      1
T      #TEMP67         #TEMP67
SET
SAVE
CLR
_03e: A      BR
)
O(
A      "Ax18Sel-X21"   M26.1     -- axis 18 selected-X21
JNB    _03f
L      2
T      #TEMP67         #TEMP67
SET
SAVE
CLR
_03f: A      BR
)
O(
A      "Ax19Sel-X22"   M26.2     -- axis 19 selected-X22
JNB    _040
L      1
T      #TEMP67         #TEMP67
SET
SAVE
CLR
_040: A      BR
)
O(
A      "Ax20Sel"       M26.3     -- axis 20 selected
JNB    _041
L      2
T      #TEMP67         #TEMP67
SET
SAVE
CLR
_041: A      BR
)
=      #TEMP62         #TEMP62
```

程序段: 14

```

O(
A(
O    "Ax1Sel-X"      M24.0      -- axis 1 selected-X
O    "Ax2Sel-Y"      M24.1      -- axis 2 selected-Y
O    "Ax3Sel-Z"      M24.2      -- axis 3 selected-Z
O    "Ax4Sel-A"      M24.3      -- axis 4 selected-A
O    "Ax5Sel-B"      M24.4      -- axis 5 selected-B
O    "Ax6Sel-C"      M24.5      -- axis 6 selected-C
O    "Ax7Sel-V"      M24.6      -- axis 7 selected-V
O    "Ax8Sel-W"      M24.7      -- axis 8 selected-W
O    "Ax9Sel-X1"     M25.0      -- axis 9 selected-X1
O    "Ax10Sel"       M25.1      -- axis 10 selected
O    "Ax11Sel-A1"    M25.2      -- axis 11 selected-A1
O    "Ax12Sel"       M25.3      -- axis 12 selected
O
A(
O    "Ax13Sel-U&X2"  M25.4      -- axis 13 selected-U&X2
O    "Ax15Sel-Q"     M25.6      -- axis 15 selected-Q
O    "Ax26Sel"       M27.1      -- axis 26 selected
)
A    "C29_50_AxConfig" M404.4    -- C29/C50 axisconfiguration
)
JNB  _042
L    1
T    #TEMP70          #TEMP70
SET
SAVE
CLR
_042: A    BR
)
O(
A(
O    "Ax14Sel-V1"    M25.5      -- axis 14 selected-V1
O    "Ax16Sel"       M25.7      -- axis 16 selected-
O    "BAxCopB12"     M294.7     -- B-axis is couplling with B12-axis
O    "Ax17Sel-Y21"   M26.0      -- axis 17 selected-Y21
O    "Ax18Sel-X21"   M26.1      -- axis 18 selected-X21
)
JNB  _043
L    2
T    #TEMP70          #TEMP70
SET
SAVE
CLR
_043: A    BR
)
O(
A(
O    "Ax19Sel-X22"   M26.2      -- axis 19 selected-X22
O    "Ax20Sel"       M26.3      -- axis 20 selected
)
JNB  _044
L    3
T    #TEMP70          #TEMP70
SET
SAVE
CLR
_044: A    BR
)
=    #TEMP59          #TEMP59

```

程序段: 15

```

A      "Ax1Sel-X"      M24.0      -- axis 1 selected-X
=      "LedXAxis"      M175.1     -- LED selection X-axis
A      "LedXAxis"      M175.1     -- LED selection X-axis
O(
A      "Ax2Sel-Y"      M24.1      -- axis 2 selected-Y
=      "LedYAxis"      M175.2     -- LED selection Y-axis
A      "LedYAxis"      M175.2     -- LED selection Y-axis
)
O(
A      "Ax3Sel-Z"      M24.2      -- axis 3 selected-Z
=      "LedZAxis"      M175.3     -- LED selection Z-axis
A      "LedZAxis"      M175.3     -- LED selection Z-axis
)
O(
A      "Ax4Sel-A"      M24.3      -- axis 4 selected-A
=      "LedAAxis"      M174.5     -- LED selection A-axis
A      "LedAAxis"      M174.5     -- LED selection A-axis
)
O(
A(
O      "Ax5Sel-B"      M24.4      -- axis 5 selected-B
O      "Ax10Sel"       M25.1      -- axis 10 selected
)
=      "LedBAxis"      M174.7     -- LED selection B-axis
A      "LedBAxis"      M174.7     -- LED selection B-axis
)
O(
A      "Ax6Sel-C"      M24.5      -- axis 6 selected-C
=      "LedCAxis"      M175.0     -- LED selection C-axis
A      "LedCAxis"      M175.0     -- LED selection C-axis
)
O(
A      "Ax17Sel-Y21"    M26.0      -- axis 17 selected-Y21
A      "SelAxLoaderBhg" M362.1    -- select axis loader via BHG
=      "LedVAxis"      M174.1     -- LED selection V-axis
A      "LedVAxis"      M174.1     -- LED selection V-axis
)
O(
A(
O      "Ax8Sel-W"      M24.7      -- axis 8 selected-W
O      "Ax20Sel"       M26.3      -- axis 20 selected
A      "SelAxLoaderBhg" M362.1    -- select axis loader via BHG
)
=      "LedWAxis"      M175.4     -- LED selection W-axis
A      "LedWAxis"      M175.4     -- LED selection W-axis
)
O(
A(
O      "Ax9Sel-X1"     M25.0      -- axis 9 selected-X1
O      "Ax18Sel-X21"   M26.1      -- axis 18 selected-X21
A      "SelAxLoaderBhg" M362.1    -- select axis loader via BHG
)
=      "LedX1Axis"     M175.5     -- LED selection X1-axis
A      "LedX1Axis"     M175.5     -- LED selection X1-axis
)
O(
A      "Ax11Sel-A1"     M25.2      -- axis 11 selected-A1
A      "A1AxisExcists" M353.0     -- A1-axis existiert
=      "LedCutGap"     M174.0     -- LED confirm cutterhead

```

```

A      "LedCutGap"      M174.0      -- LED confirm cutterhead
)
O(
A(
O      "Ax13Sel-U&X2"    M25.4      -- axis 13 selected-U&X2
O
A      "Ax18Sel-X21"    M26.1      -- axis 18 selected-X21
AN     "C29_50_AxConfig" M404.4    -- C29/C50 axisconfiguration
O
A      "Ax25Sel"        M27.0      -- axis 25 selected
A(
O      "LoadIntC29"      M408.0    -- Integrierter Loader C29
O      "LoaderC50Emo"    M411.1    -- BeLoadertyp C50 EMO
O      "LoadC50Int"      M411.2    -- Internal loader C50
)
)
=      "LedUAxis"        M175.7    -- LED selection U-axis
A      "LedUAxis"        M175.7    -- LED selection U-axis
)
O(
A      "Ax19Sel-X22"     M26.2      -- axis 19 selected-X22
A      "SelAxLoaderBhg"  M362.1    -- select axis loader via BHG
=      "LedV1Axis"       M175.6    -- LED selection V1-axis
A      "LedV1Axis"       M175.6    -- LED selection V1-axis
)
O(
A(
O      "Ax15Sel-Q"       M25.6      -- axis 15 selected-Q
O
A      "Ax26Sel"         M27.1      -- axis 26 selected
A      "LoadIntC29"      M408.0    -- Integrierter Loader C29
O
A      "Ax26Sel"         M27.1      -- axis 26 selected
A(
O      "LoaderC50Emo"    M411.1    -- BeLoadertyp C50 EMO
O      "LoadC50Int"      M411.2    -- Internal loader C50
)
)
=      "LedQAxis"        M174.6    -- LED selection Q-axis
A      "LedQAxis"        M174.6    -- LED selection Q-axis
)
=      #TEMP59           #TEMP59

```

程序段: 16

```

O(
A      #TEMP62           #TEMP62
AN     #STAT37           #STAT37
AN     #STAT38           #STAT38
=      L      20.0
BLD    103
A(
L      0
L      DB150.DBW 18
==I
)
JNB    _045
CALL   "GET" , "GetAxPos"      FB2 / DB117      -- read NC Variable / Entity DB of FB2 (NC-Vari
                                able read)
IN0    :=L20.0
IN1    :=1
IN2    :=P#DB118.DBX 110.0 BYTE 10
IN3    :=#TEMP70          #TEMP70
IN4    :=

```

```
IN5  :=#TEMP67          #TEMP67
IN6  :=
IN7  :=
IN8  :=
IN9  :=
IN10 :=
IN11 :=
IN12 :=
IN13 :=
IN14 :=
IN15 :=
IN16 :=
IN17 :=
IN18 :=
IN19 :=
IN20 :=
IN21 :=
IN22 :=
IN23 :=
IN24 :=
IN25 :=
IN26 :=
IN27 :=
IN28 :=
IN29 :=
IN30 :=
IN31 :=
IN32 :=
IN33 :=
OUT34:=#STAT37          #STAT37
OUT35:=#STAT38          #STAT38
OUT36:=#STAT39          #STAT39
I037 :=#STAT34          #STAT34
I038 :=
I039 :=
I040 :=
I041 :=
I042 :=
I043 :=
I044 :=
_045: A    BR
      )
      O(
      A(
      A      "Ax1Sel-X"          M24.0          -- axis 1 selected-X
      A      "Ax1Act-X"         M20.0          -- axis 1 active-X
      O
      A      "Ax8Sel-W"          M24.7          -- axis 8 selected-W
      A      "Ax8Act-W"          M20.7          -- axis 8 active-W
      O
      A(
      O      "Ax5Sel-B"          M24.4          -- axis 5 selected-B
      O
      A      "Ax10Sel"           M25.1          -- axis 10 selected
      A      "Ax10Act"           M21.1          -- axis 10 active
      )
      A      DB10.DBX    64.4
      )
      A      "COPAct"           M6.2            -- COP active
      JNB    _046
      L      "CopPlcData".STAT0  DB151.DBDO0
      T      #STAT34            #STAT34
      SET
      SAVE
      CLR
_046: A    BR
```

```
)
O(
A(
A(
A      "Ax19Sel-X22"           M26.2           -- axis 19 selected-X22
AN     "LoadC50Int"           M411.2           -- Internal loader C50
O      "Ax25Sel"               M27.0           -- axis 25 selected
)
AN     "LoaderInt2C50"         M411.3           -- nternal loading type2 C50
O      "Ax26Sel"               M27.1           -- axis 26 selected
)
A      "C29_50_AxConfig"       M404.4           -- C29/C50 axisconfiguration
JNB    _047
L      0.000000e+000
T      #STAT34                  #STAT34
SET
SAVE
CLR
_047: A      BR
)
=      #TEMP59                  #TEMP59
```

程序段: 17

```
O(
L      3
T      #TEMP68                  #TEMP68
SET
SAVE
CLR
A      BR
)
O(
A(
O      "Chan1isAct"           M5.0              -- channel 1 is active
O      "Chan2isAct"           M5.1              -- channel 2 is active
O      "Chan3isAct"           M5.2              -- channel 3 is active
O      "Chan4isAct"           M5.3              -- channel 4 is active
)
JNB    _048
L      2
T      #TEMP68                  #TEMP68
SET
SAVE
CLR
_048: A      BR
)
=      #TEMP59                  #TEMP59
```

程序段: 18

```
M003: O(
A      "QuitDisp"             M185.7           -- Quit signal display BHG
=      L      20.0
BLD    103
AN     "Ax17Sel-Y21"           M26.0           -- axis 17 selected-Y21
AN     "Ax10Sel"               M25.1           -- axis 10 selected
JNB    _049
CALL   "BHGDisp"               FC13            -- Displaycontrol for Handheld Unit
IN0    :=#TEMP68               #TEMP68
IN1    :=#STAT1                #STAT1
IN2    :=L20.0
```

```

IN3 :=#STAT34          #STAT34
IN4 :=B#16#8
IN5 :=30
IN6 :=B#16#4
OUT7:=#TEMP58          #TEMP58
_049: A
)
O(
A    "QuitDisp"          M185.7      -- Quit signal display BHG
=    L    20.0
BLD  103
A(
O    "Ax17Sel-Y21"        M26.0      -- axis 17 selected-Y21
O
A    "Ax18Sel-X21"        M26.1      -- axis 18 selected-X21
A    "C29_50_AxConfig"    M404.4     -- C29/C50 axisconfiguration
O    "Ax19Sel-X22"        M26.2      -- axis 19 selected-X22
O    "Ax20Sel"            M26.3      -- axis 20 selected
O    "Ax10Sel"            M25.1      -- axis 10 selected
O
A    "Machine_C100U"      M298.7     -- machine is C100U cuttingmachine
A(
O    "Ax1Sel-X"           M24.0      -- axis 1 selected-X
O    "Ax2Sel-Y"           M24.1      -- axis 2 selected-Y
)
)
JNB  _04a
CALL "BHGDISP"            FC13      -- Displaycontrol for Handheld Unit
IN0 :=#TEMP68             #TEMP68
IN1 :=#STAT1              #STAT1
IN2 :=L20.0
IN3 :=#STAT34             #STAT34
IN4 :=B#16#8
IN5 :=30
IN6 :=B#16#3
OUT7:=#TEMP58             #TEMP58
_04a: A
)
=    #TEMP59              #TEMP59
```

程序段: 19

```

L    0
T    #TEMP71  #TEMP71
NOP  0
```

程序段: 20

```

A    "Setup"              M6.0      -- Setup-Mode Active
A(
O    "Ing_EKey"            M442.1
O    "AllDoLo"            M295.4    -- all safetydoors are locked
ON   "CusDCMett"          M358.1    -- customercode DC-Mettingen
)
A(
L    0
L    0
==I
)
=    #TEMP57              #TEMP57
A    #TEMP57              #TEMP57
O(
```

```
A(
A(
ON      "Setup"          M6.0          -- Setup-Mode Active
O
A      "LedWAxis"        M175.4        -- LED selection W-axis
A      "WCoupOn"         M359.0        -- W-Axis is in JOG-Mode
A(
L      "CopPlcData".STAT3 DB151.DBW8
L      -1
==I
)
AN      "SelAxLoaderBhg" M362.1        -- select axis loader via BHG
)
JNB     _04b
CALL    "FILL"            SFC21        -- Init memory
BVAL    :=#TEMP71         #TEMP71
RET_VAL:=#TEMP72         #TEMP72
BLK     :=#STAT40         #STAT40
_04b: A   BR
)
NOT
=      #TEMP57            #TEMP57
A      #TEMP57            #TEMP57
)
=      #TEMP59            #TEMP59
```

程序段: 21

```
A      "FPbXAxis"        M158.1        -- pushbutton selection X-axis
A      "Ax1Act-X"        M20.0         -- axis 1 active-X
A      #TEMP57            #TEMP57
JNB     _04c
CALL    "FILL"            SFC21        -- Init memory
BVAL    :=#TEMP71         #TEMP71
RET_VAL:=#TEMP72         #TEMP72
BLK     :=#STAT40         #STAT40
_04c: A   BR
S      #STAT40[1]         #STAT40[1]
```

程序段: 22

```
A      "FPbYAxis"        M158.2        -- pushbutton selection Y-axis
A      "Ax2Act-Y"        M20.1         -- axis 2 active-Y
A      #TEMP57            #TEMP57
JNB     _04d
CALL    "FILL"            SFC21        -- Init memory
BVAL    :=#TEMP71         #TEMP71
RET_VAL:=#TEMP72         #TEMP72
BLK     :=#STAT40         #STAT40
_04d: A   BR
S      #STAT40[2]         #STAT40[2]
```

程序段: 23

```
A      "FPbZAxis"        M158.3        -- pushbutton selection Z-axis
A      "Ax3Act-Z"        M20.2         -- axis 3 active-Z
A      #TEMP57            #TEMP57
JNB     _04e
CALL    "FILL"            SFC21        -- Init memory
BVAL    :=#TEMP71         #TEMP71
```

```
RET_VAL:=#TEMP72 #TEMP72
BLK      :=#STAT40 #STAT40
_04e: A   BR
S        #STAT40[3] #STAT40[3]
```

程序段: 24

```
A      "FPbAAxis" M157.5      -- pushbutton selection A-axis
A      "Ax4Act-A" M20.3       -- axis 4 active-A
A      #TEMP57    #TEMP57
JNB    _04f
CALL   "FILL"     SFC21       -- Init memory
BVAL   :=#TEMP71  #TEMP71
RET_VAL:=#TEMP72  #TEMP72
BLK    :=#STAT40  #STAT40
_04f: A   BR
S        #STAT40[4] #STAT40[4]
```

程序段: 25

```
A(
O      "FPbBAxis" M157.7      -- pushbutton selection B-axis
O(
A      "COPAct"   M6.2        -- COP active
FN     #STAT43    #STAT43
A      "Ax10Sel"  M25.1       -- axis 10 selected
)
O(
A      "COPAct"   M6.2        -- COP active
FP     #STAT44    #STAT44
A      "RefEnd"   M6.3        -- all axis referenced
A      "Ax5Sel-B" M24.4       -- axis 5 selected-B
)
)
A      #TEMP57    #TEMP57
JNB    _050
CALL   "FILL"     SFC21       -- Init memory
BVAL   :=#TEMP71  #TEMP71
RET_VAL:=#TEMP72  #TEMP72
BLK    :=#STAT40  #STAT40
_050: A   BR
=      L      20.0
A      L      20.0
A(
ON     "COPAct"   M6.2        -- COP active
ON     "RefEnd"   M6.3        -- all axis referenced
)
A      "Ax5Act-B" M20.4       -- axis 5 active-B
AN     "Testaufbau" M6.1      -- Test active
S      #STAT40[5] #STAT40[5]
A      L      20.0
A      "COPAct"   M6.2        -- COP active
A(
O      "RefEnd"   M6.3        -- all axis referenced
O      "Testaufbau" M6.1      -- Test active
)
A      "Ax10Act"  M21.1       -- axis 10 active
S      #STAT40[10] #STAT40[10]
```

程序段: 26

```
A      "FPbCAxis"      M158.0      -- pushbutton selection C-axis
A      "Ax6Act-C"      M20.5      -- axis 6 active-C
A      #TEMP57          #TEMP57
JNB    _051
CALL   "FILL"          SFC21      -- Init memory
      BVAL      :=#TEMP71      #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
      BLK       :=#STAT40      #STAT40
_051: A      BR
      S      #STAT40[6]      #STAT40[6]
```

程序段: 27

```
A      "FPbVAxis"      M157.1      -- pushbutton selection V-axis
AN     "SelAxLoaderBhg" M362.1      -- select axis loader via BHG
A      "Ax7Act-V"      M20.6      -- axis 7 active-V
A      #TEMP57          #TEMP57
JNB    _052
CALL   "FILL"          SFC21      -- Init memory
      BVAL      :=#TEMP71      #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
      BLK       :=#STAT40      #STAT40
_052: A      BR
      S      #STAT40[7]      #STAT40[7]
```

程序段: 28

```
A(
A      "FPbWAxis"      M158.4      -- pushbutton selection W-axis
A      "False"         M0.0      -- statisches LOW-Signal
O
A      "WCoupOn"       M359.0      -- W-Axis is in JOG-Mode
AN     #STAT40[8]      #STAT40[8]
A(
L      "CopPlcData".STAT3 DB151.DBW8
L      3
==I
)
)
AN     "SelAxLoaderBhg" M362.1      -- select axis loader via BHG
A      "Ax8Act-W"      M20.7      -- axis 8 active-W
A      #TEMP57          #TEMP57
JNB    _053
CALL   "FILL"          SFC21      -- Init memory
      BVAL      :=#TEMP71      #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
      BLK       :=#STAT40      #STAT40
_053: A      BR
      S      #STAT40[8]      #STAT40[8]
```

程序段: 29

```
A      "FPbX1Axis"      M158.5      -- pushbutton selection X1-axis
AN     "SelAxLoaderBhg"  M362.1      -- select axis loader via BHG
A      "Ax9Act-X1"      M21.0      -- axis 9 active-X1
A      #TEMP57           #TEMP57
JNB    _054
CALL   "FILL"           SFC21      -- Init memory
      BVAL      :=#TEMP71      #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
      BLK       :=#STAT40      #STAT40
_054: A      BR
      S      #STAT40[9]      #STAT40[9]
```

程序段: 30

```
A      "FPbCutGap"      M157.0      -- pushbutton confirm cutterhead
A      "A1AxisExcists"  M353.0      -- A1-axis existiert
A      "Ax11Act-A1"     M21.2      -- axis 11 active-A1
A      #TEMP57           #TEMP57
JNB    _055
CALL   "FILL"           SFC21      -- Init memory
      BVAL      :=#TEMP71      #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
      BLK       :=#STAT40      #STAT40
_055: A      BR
      S      #STAT40[11]     #STAT40[11]
```

程序段: 31

```
A      "FPbUAxis"      M158.7      -- pushbutton selection U-axis
AN     "NoReleaseX2Axis" M393.7      -- no release X2-axis
AN     "SelAxLoaderBhg" M362.1      -- select axis loader via BHG
A      "Ax13Act-U&X2"   M21.4      -- axis 13 active-U&X2
A      #TEMP57           #TEMP57
JNB    _056
CALL   "FILL"           SFC21      -- Init memory
      BVAL      :=#TEMP71      #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
      BLK       :=#STAT40      #STAT40
_056: A      BR
      S      #STAT40[13]     #STAT40[13]
```

程序段: 32

```
A      "FPbV1Axis"      M158.6      -- pushbutton selection V1-axis
AN     "SelAxLoaderBhg" M362.1      -- select axis loader via BHG
A      "Ax14Act-V1"     M21.5      -- axis 14 active-V1
A      #TEMP57           #TEMP57
JNB    _057
CALL   "FILL"           SFC21      -- Init memory
      BVAL      :=#TEMP71      #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
      BLK       :=#STAT40      #STAT40
_057: A      BR
      S      #STAT40[14]     #STAT40[14]
```

程序段: 33

```
A      "FPbQAxis"      M157.6      -- pushbutton selection Q-axis
AN     "SelAxLoaderBhg" M362.1      -- select axis loader via BHG
A      "Ax15Act-Q"      M21.6      -- axis 15 active-Q
A      #TEMP57          #TEMP57
JNB    _058
CALL   "FILL"          SFC21      -- Init memory
      BVAL      :=#TEMP71      #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
      BLK       :=#STAT40      #STAT40
_058: A      BR
      S      #STAT40[15]      #STAT40[15]
```

程序段: 34

```
A      "FPbVAxis"      M157.1      -- pushbutton selection V-axis
A      "SelAxLoaderBhg" M362.1      -- select axis loader via BHG
A      "Ax17Act-Y21"    M22.0      -- axis 17 active-Y21
A      #TEMP57          #TEMP57
JNB    _059
CALL   "FILL"          SFC21      -- Init memory
      BVAL      :=#TEMP71      #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
      BLK       :=#STAT40      #STAT40
_059: A      BR
      S      #STAT40[17]      #STAT40[17]
```

程序段: 35

```
A      "FPbX1Axis"      M158.5      -- pushbutton selection X1-axis
A      "SelAxLoaderBhg" M362.1      -- select axis loader via BHG
A      "Ax18Act-X21"    M22.1      -- axis 18 active-X21
A      #TEMP57          #TEMP57
JNB    _05a
CALL   "FILL"          SFC21      -- Init memory
      BVAL      :=#TEMP71      #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
      BLK       :=#STAT40      #STAT40
_05a: A      BR
      S      #STAT40[18]      #STAT40[18]
```

程序段: 36

```
A      "FPbV1Axis"      M158.6      -- pushbutton selection V1-axis
A      "SelAxLoaderBhg" M362.1      -- select axis loader via BHG
A      #TEMP57          #TEMP57
JNB    _05b
CALL   "FILL"          SFC21      -- Init memory
      BVAL      :=#TEMP71      #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
      BLK       :=#STAT40      #STAT40
_05b: A      BR
      S      #STAT40[19]      #STAT40[19]
```

程序段: 37

```
A      "FPbWAxis"          M158.4      -- pushbutton selection W-axis
A      "SelAxLoaderBhg"     M362.1      -- select axis loader via BHG
A(
O      "CopPlcData".STAT99 DB151.DBX25.5
O      "Testaufbau"         M6.1        -- Test active
)
A      #TEMP57              #TEMP57
JNB    _05c
CALL   "FILL"               SFC21       -- Init memory
      BVAL :=#TEMP71        #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
      BLK :=#STAT40         #STAT40
_05c: A      BR
      S      #STAT40[20]     #STAT40[20]
```

程序段: 38

```
A      "FPbUAxis"          M158.7      -- pushbutton selection U-axis
A(
O      "LoadIntC29"         M408.0      -- Integrierter Loader C29
O      "LoaderC50Emo"       M411.1      -- BeLoadertyp C50 EM0
O      "LoadC50Int"         M411.2      -- Internal loader C50
O      "LoaderInt2C50"      M411.3      -- nternal loading type2 C50
)
A      "SelAxLoaderBhg"     M362.1      -- select axis loader via BHG
A(
O      "CopPlcData".STAT99 DB151.DBX25.5
O      "Testaufbau"         M6.1        -- Test active
)
A      #TEMP57              #TEMP57
JNB    _05d
CALL   "FILL"               SFC21       -- Init memory
      BVAL :=#TEMP71        #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
      BLK :=#STAT40         #STAT40
_05d: A      BR
      S      #STAT40[25]     #STAT40[25]
```

程序段: 39

```
A(
A      "FPbQAxis"          M157.6      -- pushbutton selection Q-axis
A      "LoadIntC29"         M408.0      -- Integrierter Loader C29
O
A      "FPbQAxis"          M157.6      -- pushbutton selection Q-axis
A(
O      "LoaderC50Emo"       M411.1      -- BeLoadertyp C50 EM0
O      "LoadC50Int"         M411.2      -- Internal loader C50
O      "LoaderInt2C50"      M411.3      -- nternal loading type2 C50
)
)
A      "SelAxLoaderBhg"     M362.1      -- select axis loader via BHG
A      #TEMP57              #TEMP57
JNB    _05e
CALL   "FILL"               SFC21       -- Init memory
      BVAL :=#TEMP71        #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
```

```
      BLK      :=#STAT40      #STAT40
_05e: A      BR
      S      #STAT40[26]      #STAT40[26]
```

程序段: 40

```
      A      "FPbWAxis"      M158.4      -- pushbutton selection W-axis
      A      "LoaderInt2C50"  M411.3      -- nternal loading type2 C50
      A      "SelAxLoaderBhg" M362.1      -- select axis loader via BHG
      A      #TEMP57          #TEMP57
      A      "False"         M0.0        -- statisches LOW-Signal
      JNB    _05f
      CALL   "FILL"          SFC21        -- Init memory
      BVAL   :=#TEMP71      #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
      BLK    :=#STAT40      #STAT40
_05f: A      BR
      S      #STAT40[27]      #STAT40[27]
```

程序段: 41

```
      A(
      A      "FPbVAxis"      M157.1      -- pushbutton selection V-axis
      AN     "LoadIntC29"    M408.0      -- Integrierter Loader C29
      AN     "LoaderC50Emo"  M411.1      -- BeLoadertyp C50 EM0
      AN     "LoadC50Int"    M411.2      -- Internal loader C50
      AN     "LoaderInt2C50" M411.3      -- nternal loading type2 C50
      O
      A      "FPbUAxis"      M158.7      -- pushbutton selection U-axis
      A      "False"         M0.0        -- statisches LOW-Signal
      A(
      O      "LoadIntC29"    M408.0      -- Integrierter Loader C29
      O      "LoaderC50Emo"  M411.1      -- BeLoadertyp C50 EM0
      O      "LoadC50Int"    M411.2      -- Internal loader C50
      )
      )
      A      "SelAxLoaderBhg" M362.1      -- select axis loader via BHG
      A(
      O      "CopPlcData".STAT99 DB151.DBX25.5
      O      "Testaufbau"    M6.1        -- Test active
      )
      A      #TEMP57          #TEMP57
      JNB    _060
      CALL   "FILL"          SFC21        -- Init memory
      BVAL   :=#TEMP71      #TEMP71
      RET_VAL:=#TEMP72      #TEMP72
      BLK    :=#STAT40      #STAT40
_060: A      BR
      S      #STAT40[28]      #STAT40[28]
```

程序段: 42

```
      O(
      A      "Setup"         M6.0        -- Setup-Mode Active
      A(
      O      "Ing_EKey"      M442.1
      O      "AlldoLo"       M295.4      -- all safetydoors are locked
      ON     "CusDCMett"     M358.1      -- customercode DC-Mettingen
      )
      JNB    _061
```

```

CALL "FILL"          SFC21          -- Init memory
  BVAL  :=#STAT40      #STAT40
  RET_VAL:=#TEMP72     #TEMP72
  BLK   :=P#M 24.0 DWORD 1
_061: A    BR
      )
      O(
AN      "Setup"        M6.0          -- Setup-Mode Active
JNB     _062
L       0
T       "Ax1-31Select" MD24          -- Array axis 1 to 31
SET
SAVE
CLR
_062: A    BR
      )
      =      #TEMP59          #TEMP59

```

程序段: 43

```

O      "NcProgActChan1" M2.0          -- NC-program aktive channel 1
O      "NcProgActChan2" M2.1          -- NC-program is run channel 2
O      "NcProgWaitChan1" M2.2         -- NC-program wait channel 1
O      "NcProgWaitChan2" M2.3         -- NC-program wait channel2
O
A      "LedSingleBlock" M128.2         -- LED singlemove operatorpanel
A      "NcProgStopChan1" M2.4          -- NC-program Stoppmodus channel 1
O
A      "LedSingleBlock" M128.2         -- LED singlemove operatorpanel
A      "NcProgStopChan2" M2.5          -- NC-program Stoppmodus channel 2
=      "LedCycleStart" M127.5         -- LED cyclestart operatorpanel

```

程序段: 44

```

AN      "PbCycleStop" M102.0          -- pushbutton cyclestop operatorpanel
=      "LedCycleStop" M127.4          -- LED cyclestop operatorpanel

```

程序段: 45

```

A      "FPbSingleBlock" M190.6         -- pushbutton singlemove operatorpanel
AN     "LedSingleBlock" M128.2         -- LED singlemove operatorpanel
A(
O      "LedAuto"        M126.0         -- LED Auto-operatorpanel
O      "LedMda"          M126.1         -- LED MDA-operatorpanel
)
=      #TEMP61           #TEMP61
A      #TEMP61           #TEMP61
S      "LedSingleBlock" M128.2         -- LED singlemove operatorpanel
A(
A      "FPbSingleBlock" M190.6         -- pushbutton singlemove operatorpanel
A      "LedSingleBlock" M128.2         -- LED singlemove operatorpanel
AN     #TEMP61           #TEMP61
O
AN     "LedAuto"         M126.0         -- LED Auto-operatorpanel
AN     "LedMda"          M126.1         -- LED MDA-operatorpanel
)
R      "LedSingleBlock" M128.2         -- LED singlemove operatorpanel
NOP    0

```

程序段: 46

```

A      "ProgStart"      M0.7          -- NC-program starten
FN     #STAT35          #STAT35
A      "LedCycleStart"  M127.5       -- LED cyclestart operatorpanel
=      L      20.0
BLD    103
A      "LedCycleStart"  M127.5       -- LED cyclestart operatorpanel
FN     #STAT36          #STAT36
=      L      20.1
BLD    103
CALL   "NcProgLed"      FC120        -- LED Control of active NC-programs
IN0:=L20.0
IN1:=L20.1
A      BR
=      #TEMP59          #TEMP59

```

程序段: 47

```

A      "True"           M0.1          -- static HIGH-signal
=      "StaticTrue"     M172.7       -- BHG-Signal static true

```

程序段: 48

```

A(
O      "KSwBHG"         M185.6       -- Keyswitch HBG
O      "KSw3"           M104.4       -- Keyswitch Label 3 operatorpanel
O      "KSw2"           M102.6       -- Keyswitch Label 2 operatorpanel
)
A      "Testaufbau"     M6.1          -- Test active
O
A(
O      "KSwMan"         M114.3       -- Keyswitch Jobsetter MCP(I4.3+M403.4)
O      "KSwData"        M114.5       -- Keyswitch datainput release
)
AN     "Testaufbau"     M6.1          -- Test active
=      "Setup"          M6.0         -- Setup-Mode Active

```

程序段: 49

```

A      "FeedOvr0"       M103.0       -- Feed override Bit 0 operatorpanel
AN     "FeedOvr1"       M103.1       -- Feed override Bit 1 operatorpanel
AN     "FeedOvr2"       M103.2       -- Feed override Bit 2 operatorpanel
AN     "FeedOvr3"       M103.3       -- Feed override Bit 3 operatorpanel
AN     "FeedOvr4"       M103.4       -- Feed override Bit 4 operatorpanel
=      #TEMP60          #TEMP60

```

程序段: 50

```

A      "Setup"          M6.0          -- Setup-Mode Active
AN     "CutProIsRun"    M297.2       -- cuttinprocess is running
AN     "CopPlcData".STAT98 DB151.DBX25.4
=      #TEMP63          #TEMP63

```

程序段: 51

```

A(
A  #TEMP63  #TEMP63
A  "BhgOvr0" M185.1      -- Override Bit 0 BHG
O
AN #TEMP63  #TEMP63
A  "FeedOvr0" M103.0     -- Feed override Bit 0 operatorpanel
O  #TEMP60  #TEMP60
)
=  "OvrA"    M7.0        -- Active Override Bit 0
A  "OvrA"    M7.0        -- Active Override Bit 0
=  L        20.0
BLD 103
A(
A  #TEMP63  #TEMP63
A  "BhgOvr1" M185.2      -- Override Bit 0 BHG
O
AN #TEMP63  #TEMP63
A  "FeedOvr1" M103.1     -- Feed override Bit 1 operatorpanel
)
AN #TEMP60  #TEMP60
=  "OvrB"    M7.1        -- Active Override Bit 1
A  "OvrB"    M7.1        -- Active Override Bit 1
=  L        20.1
BLD 103
A(
A  #TEMP63  #TEMP63
A  "BhgOvr2" M185.3      -- Override Bit 0 BHG
O
AN #TEMP63  #TEMP63
A  "FeedOvr2" M103.2     -- Feed override Bit 2 operatorpanel
)
AN #TEMP60  #TEMP60
=  "OvrC"    M7.2        -- Active Override Bit 2
A  "OvrC"    M7.2        -- Active Override Bit 2
=  L        20.2
BLD 103
A(
A  #TEMP63  #TEMP63
A  "BhgOvr3" M185.4      -- Override Bit 0 BHG
O
AN #TEMP63  #TEMP63
A  "FeedOvr3" M103.3     -- Feed override Bit 3 operatorpanel
)
AN #TEMP60  #TEMP60
=  "OvrD"    M7.3        -- Active Override Bit 3
A  "OvrD"    M7.3        -- Active Override Bit 3
=  L        20.3
BLD 103
A(
A  #TEMP63  #TEMP63
A  "BhgOvr4" M185.5      -- Override Bit 0 BHG
O
AN #TEMP63  #TEMP63
A  "FeedOvr4" M103.4     -- Feed override Bit 4 operatorpanel
)
AN #TEMP60  #TEMP60
=  "OvrE"    M7.4        -- Active Override Bit 4
A  "OvrE"    M7.4        -- Active Override Bit 4
=  L        20.4
BLD 103
CALL "GrayInt" FC119      -- Gray-Code to Integer konvert

```

```
IN0 :=L20.0
IN1 :=L20.1
IN2 :=L20.2
IN3 :=L20.3
IN4 :=L20.4
OUT5:="Ovr"      MW8      -- active value Override
NOP  0
```

程序段: 52

```
A(
L  "Ovr"  MW8      -- active value Override
L  100
>=I
)
JNB  _063
L  100
T  "Ovr"  MW8      -- active value Override
_063: NOP  0
```

程序段: 53

```
O(
L  DB19.DBB  22
T  #TEMP69      #TEMP69
SET
SAVE
CLR
A  BR
)
O(
A(
O(
L  #TEMP69      #TEMP69
L  1
==I
)
O
A  "Chan1Act"    M18.0      -- channel 1 active
AN "Chan2Act"    M18.1      -- channel 2 active
AN "Chan3Act"    M18.2      -- channel 3 active
AN "Chan4Act"    M18.3      -- channel 4 active
)
=  "Chan1Disp"    M1.2      -- channel 1 is active in MMC
A  "Chan1Disp"    M1.2      -- channel 1 is active in MMC
)
O(
A(
L  #TEMP69      #TEMP69
L  2
==I
)
=  "Chan2Disp"    M1.3      -- channel 2 is active in MMC
A  "Chan2Disp"    M1.3      -- channel 2 is active in MMC
)
O(
A(
L  #TEMP69      #TEMP69
L  3
==I
)
=  "Chan3Disp"    M1.4      -- channel 3 is active in MMC
```

```
A      "Chan3Disp"    M1.4          -- channel 3 is active in MMC
)
O(
A(
L      #TEMP69        #TEMP69
L      4
==I
)
=      "Chan4Disp"    M1.5          -- channel 4 is active in MMC
A      "Chan4Disp"    M1.5          -- channel 4 is active in MMC
)
=      #TEMP59        #TEMP59
```