

TECHNICAL DOCUMENTATION

SP7_10

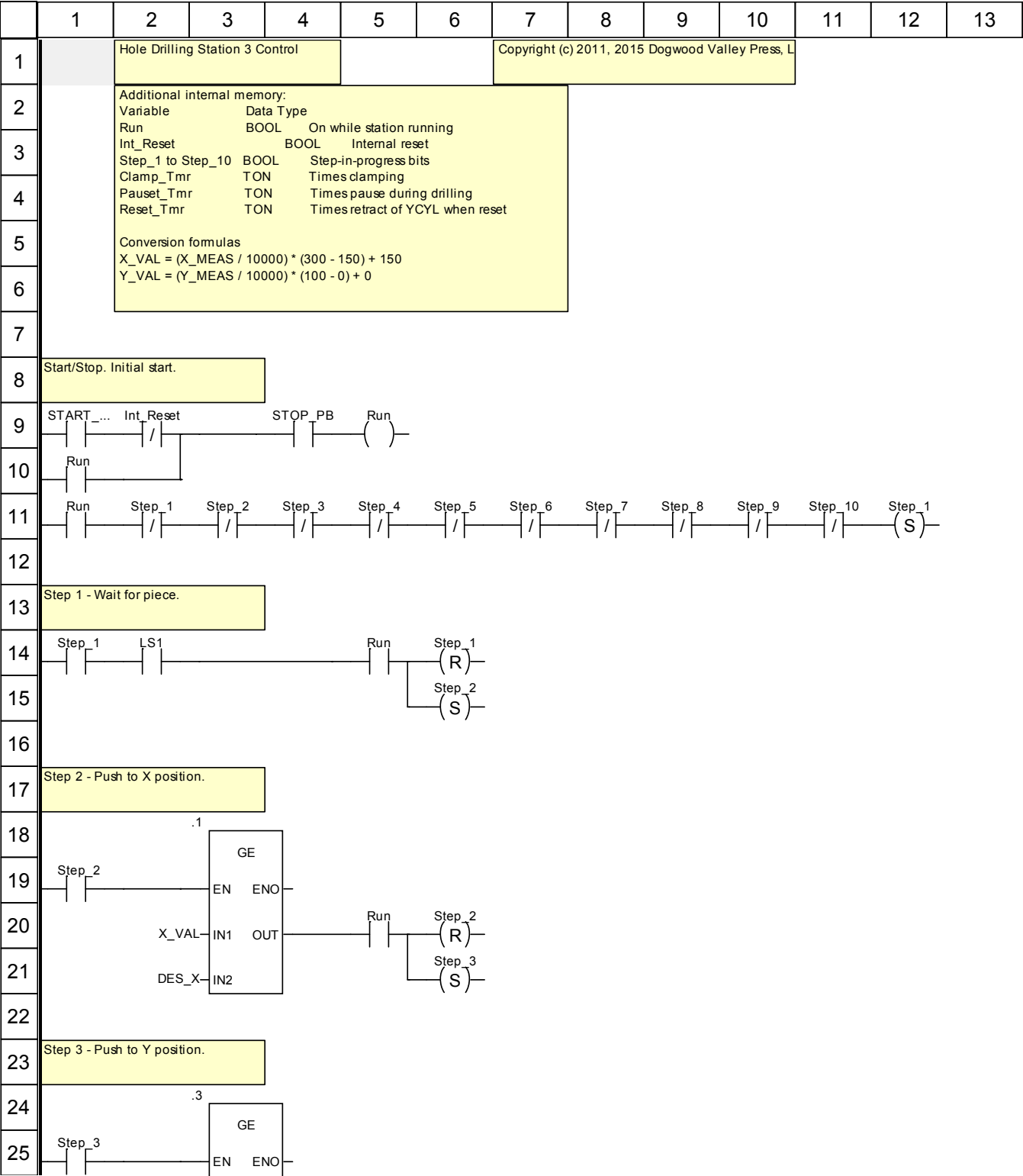
Project	SP7_10
Designer	
Application	sp7_10.stu
Software Version	Unity Pro L V10.0
Creation Date	4/12/2011 8:52:23 PM
Last Modification Date	12/23/2015 7:30:51 AM
Target PLC	BMX P34 1000 02.00CPU 340-10 Modbus

MAST

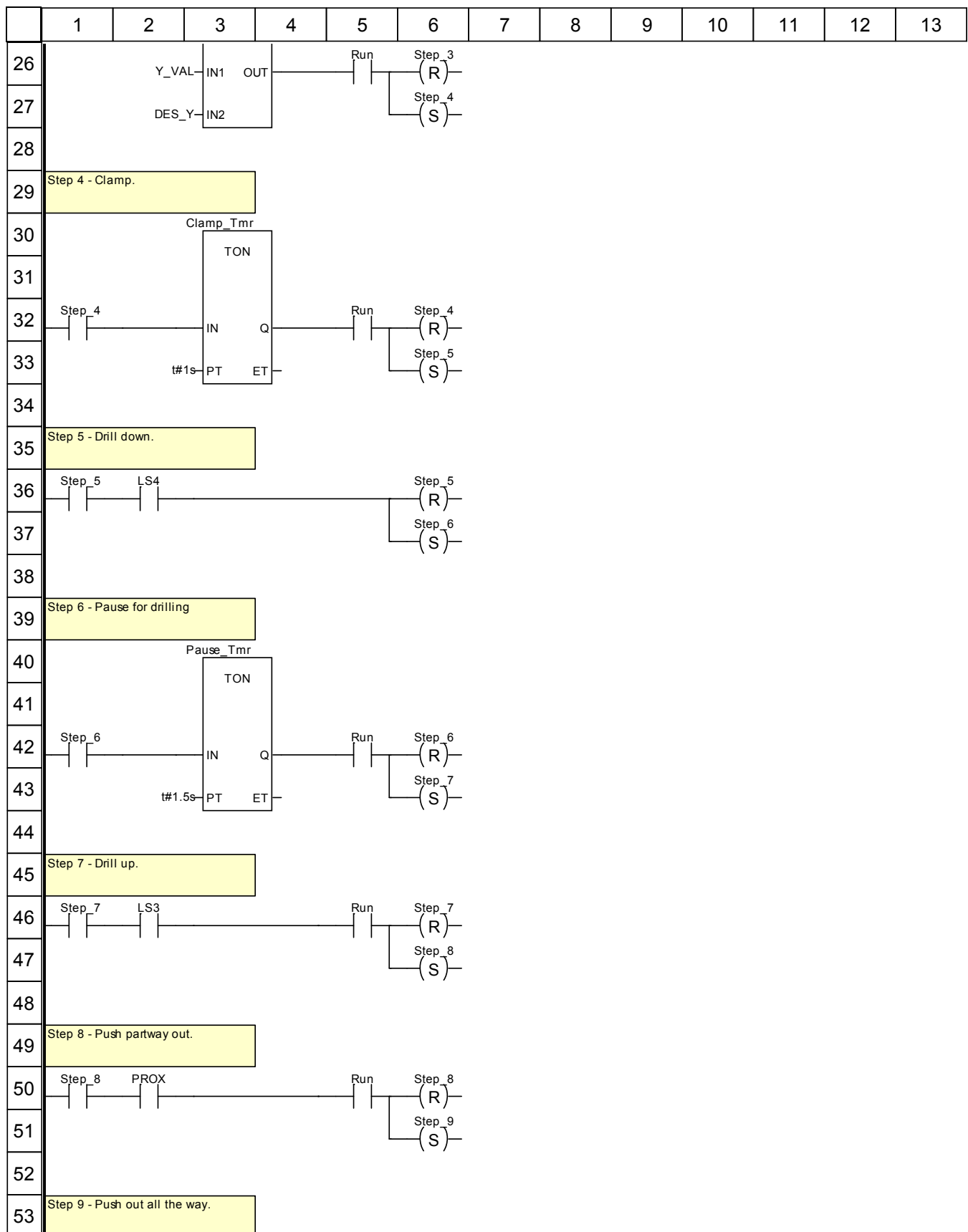
Specific properties

Configuration	Cyclic
Task period configuration	0
Watchdog time configuration	250

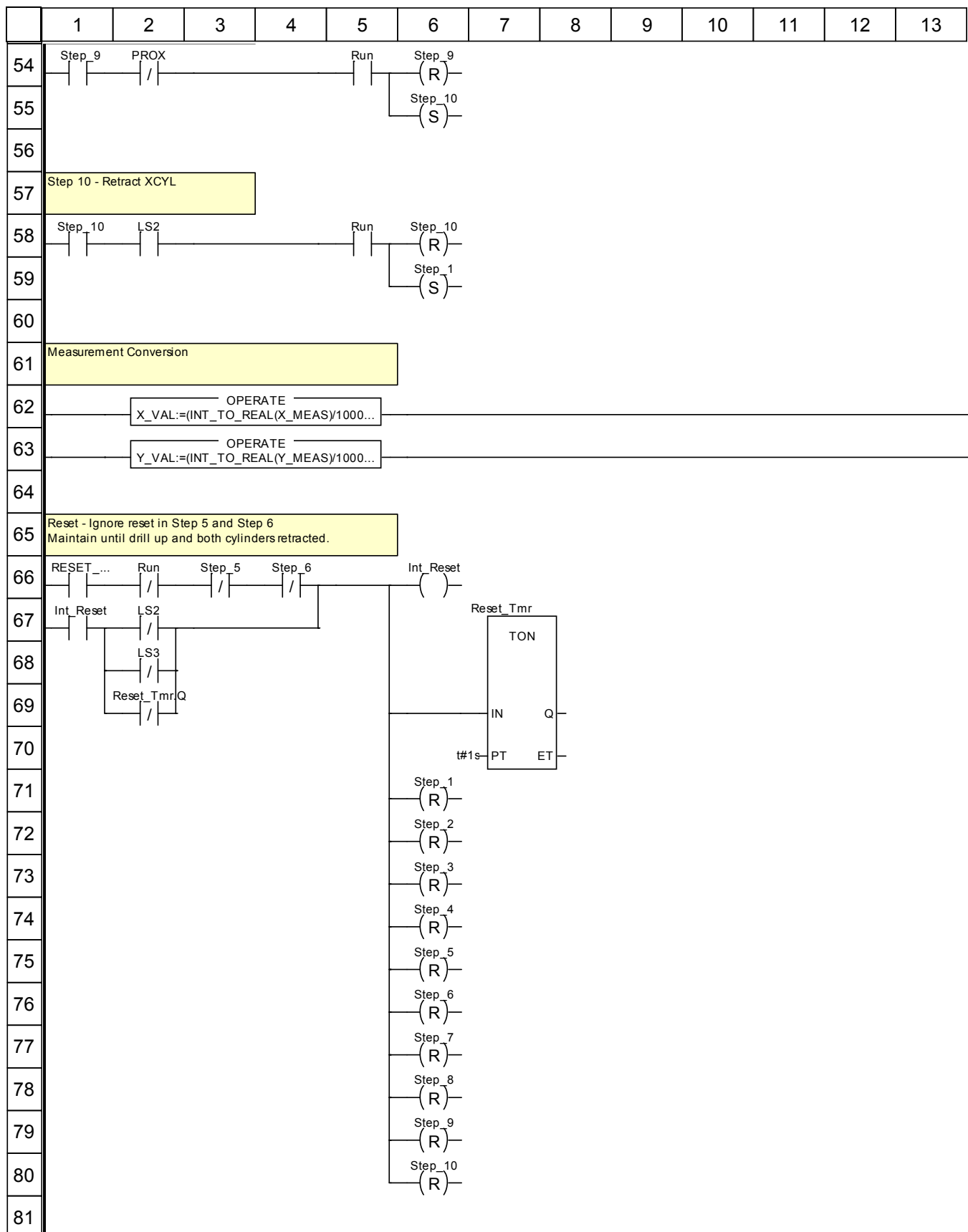
main : [MAST]



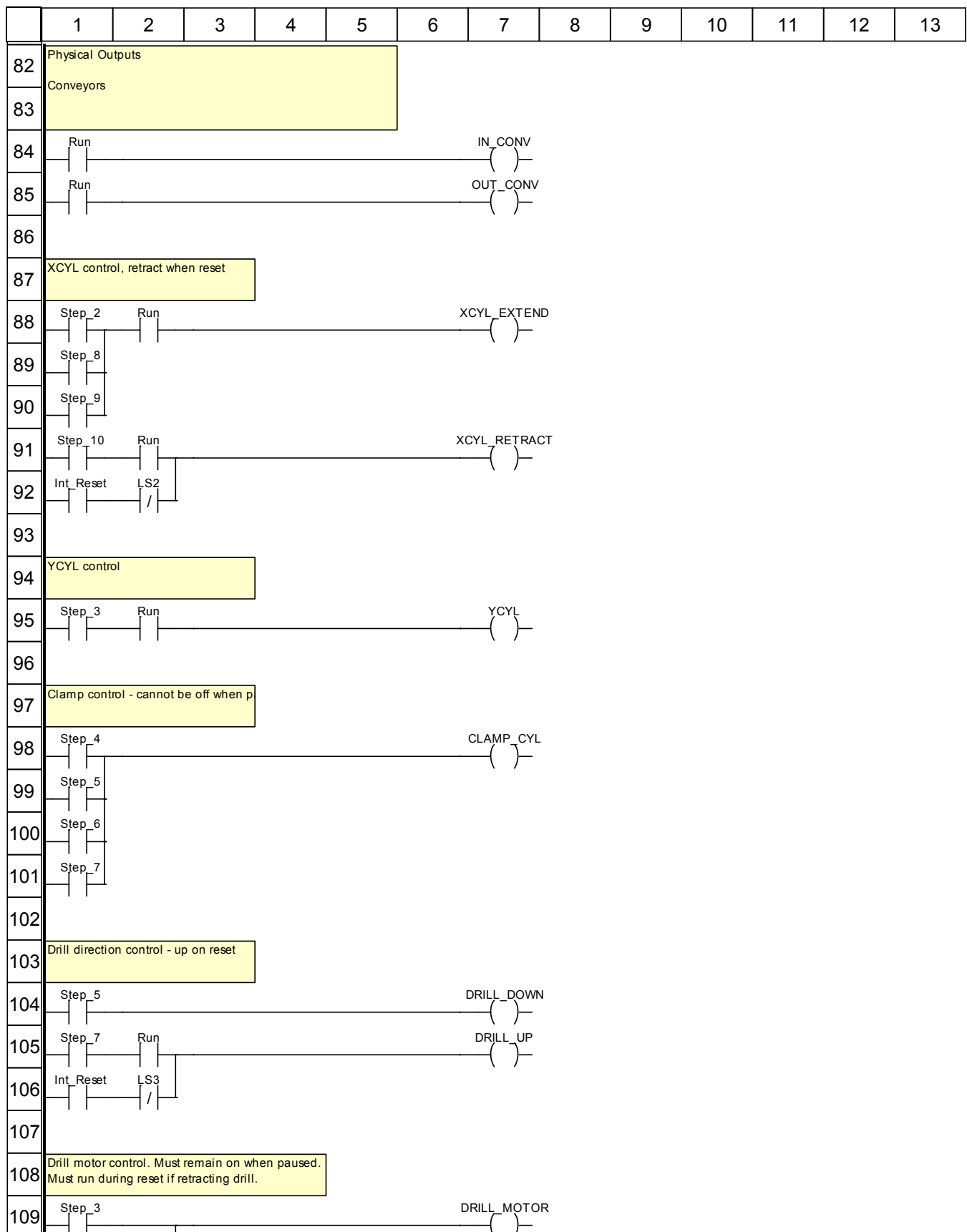
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110	Step_4												
111	Step_5												
112	Step_6												
113	Step_7												
114	Int_Reset	LS3											

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Truncated labels:

Label	Position(s)
RESET_PB	(1, 66)
START_PB	(1, 9)
X_VAL:=(INT TO REAL(X_MEAS)/10000.0)*(300.0-150.0)+150.0;	(2, 62)
Y_VAL:=(INT TO REAL(Y_MEAS)/10000.0)*(110.0-0.0)+0.0;	(2, 63)

Cross References

Application:

Addresses

Object	Referred into	Location	Usage
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Variables or FB instances

Object	Referred into	Location	Usage
CLAMP_CYL	main : [MAST]	(I 98, c: 7)	W
Clamp_Tmr	main : [MAST]	(I 30, c: 3)	FC
		(I 30, c: 3)	R
		(I 30, c: 3)	R
DES_X	main : [MAST]	(I 18, c: 3)	R
DES_Y	main : [MAST]	(I 24, c: 3)	R
DRILL_DOWN	main : [MAST]	(I 104, c: 7)	W
DRILL_MOTOR	main : [MAST]	(I 109, c: 7)	W
DRILL_UP	main : [MAST]	(I 105, c: 7)	W
IN_CONV	main : [MAST]	(I 84, c: 7)	W
Int_Reset	main : [MAST]	(I 9, c: 2)	R
		(I 66, c: 6)	W
		(I 67, c: 1)	R
		(I 92, c: 1)	R
		(I 106, c: 1)	R
		(I 114, c: 1)	R
LS1	main : [MAST]	(I 14, c: 2)	R
LS2	main : [MAST]	(I 58, c: 2)	R
		(I 67, c: 2)	R
		(I 92, c: 2)	R
LS3	main : [MAST]	(I 46, c: 2)	R
		(I 68, c: 2)	R
		(I 106, c: 2)	R
		(I 114, c: 2)	R
LS4	main : [MAST]	(I 36, c: 2)	R
OUT_CONV	main : [MAST]	(I 85, c: 7)	W
PROX	main : [MAST]	(I 50, c: 2)	R
		(I 54, c: 2)	R
Pause_Tmr	main : [MAST]	(I 40, c: 3)	FC
		(I 40, c: 3)	R
		(I 40, c: 3)	R
RESET_PB	main : [MAST]	(I 66, c: 1)	R
Reset_Tmr	main : [MAST]	(I 69, c: 2)	R
		(I 67, c: 7)	FC
		(I 67, c: 7)	R
		(I 67, c: 7)	R
Run	main : [MAST]	(I 9, c: 5)	W
		(I 10, c: 1)	R
		(I 11, c: 1)	R
		(I 14, c: 5)	R
		(I 20, c: 5)	R
		(I 26, c: 5)	R
		(I 32, c: 5)	R
		(I 42, c: 5)	R
		(I 46, c: 5)	R

Cross References

Object	Referred into	Location	Usage
		(l 50, c: 5)	R
		(l 54, c: 5)	R
		(l 58, c: 5)	R
		(l 66, c: 2)	R
		(l 84, c: 1)	R
		(l 85, c: 1)	R
		(l 88, c: 2)	R
		(l 91, c: 2)	R
		(l 95, c: 2)	R
		(l 105, c: 2)	R
START_PB	main : [MAST]	(l 9, c: 1)	R
STOP_PB	main : [MAST]	(l 9, c: 4)	R
Step_1	main : [MAST]	(l 11, c: 2)	R
		(l 11, c: 12)	W
		(l 14, c: 1)	R
		(l 14, c: 6)	W
		(l 59, c: 6)	W
		(l 71, c: 6)	W
Step_10	main : [MAST]	(l 11, c: 11)	R
		(l 55, c: 6)	W
		(l 58, c: 1)	R
		(l 58, c: 6)	W
		(l 80, c: 6)	W
		(l 91, c: 1)	R
Step_2	main : [MAST]	(l 11, c: 3)	R
		(l 15, c: 6)	W
		(l 19, c: 1)	R
		(l 20, c: 6)	W
		(l 72, c: 6)	W
		(l 88, c: 1)	R
Step_3	main : [MAST]	(l 11, c: 4)	R
		(l 21, c: 6)	W
		(l 25, c: 1)	R
		(l 26, c: 6)	W
		(l 73, c: 6)	W
		(l 95, c: 1)	R
		(l 109, c: 1)	R
Step_4	main : [MAST]	(l 11, c: 5)	R
		(l 27, c: 6)	W
		(l 32, c: 1)	R
		(l 32, c: 6)	W
		(l 74, c: 6)	W
		(l 98, c: 1)	R
		(l 110, c: 1)	R
Step_5	main : [MAST]	(l 11, c: 6)	R
		(l 33, c: 6)	W
		(l 36, c: 1)	R
		(l 36, c: 6)	W
		(l 66, c: 3)	R
		(l 75, c: 6)	W
		(l 99, c: 1)	R
		(l 104, c: 1)	R
		(l 111, c: 1)	R
Step_6	main : [MAST]	(l 11, c: 7)	R
		(l 37, c: 6)	W

Cross References

Object	Referred into	Location	Usage
		(l 42, c: 1)	R
		(l 42, c: 6)	W
		(l 66, c: 4)	R
		(l 76, c: 6)	W
		(l 100, c: 1)	R
		(l 112, c: 1)	R
Step_7	main : [MAST]	(l 11, c: 8)	R
		(l 43, c: 6)	W
		(l 46, c: 1)	R
		(l 46, c: 6)	W
		(l 77, c: 6)	W
		(l 101, c: 1)	R
		(l 105, c: 1)	R
		(l 113, c: 1)	R
Step_8	main : [MAST]	(l 11, c: 9)	R
		(l 47, c: 6)	W
		(l 50, c: 1)	R
		(l 50, c: 6)	W
		(l 78, c: 6)	W
		(l 89, c: 1)	R
Step_9	main : [MAST]	(l 11, c: 10)	R
		(l 51, c: 6)	W
		(l 54, c: 1)	R
		(l 54, c: 6)	W
		(l 79, c: 6)	W
		(l 90, c: 1)	R
XCYL_EXTEND	main : [MAST]	(l 88, c: 7)	W
XCYL_RETRACT	main : [MAST]	(l 91, c: 7)	W
X_MEAS	main : [MAST]	(l 62, c: 2)	R
X_VAL	main : [MAST]	(l 18, c: 3)	R
		(l 62, c: 2)	W
YCYL	main : [MAST]	(l 95, c: 7)	W
Y_MEAS	main : [MAST]	(l 63, c: 2)	R
Y_VAL	main : [MAST]	(l 24, c: 3)	R
		(l 63, c: 2)	W

EF objects

Object	Referred into	Location	Usage
ge	main : [MAST]	(l 18, c: 3)	FC
		(l 24, c: 3)	FC
ge_real	main : [MAST]	(l 18, c: 3)	FC
		(l 24, c: 3)	FC
int_to_real	main : [MAST]	(l 62, c: 2)	FC
		(l 63, c: 2)	FC