

TECHNICAL DOCUMENTATION

SP14_02

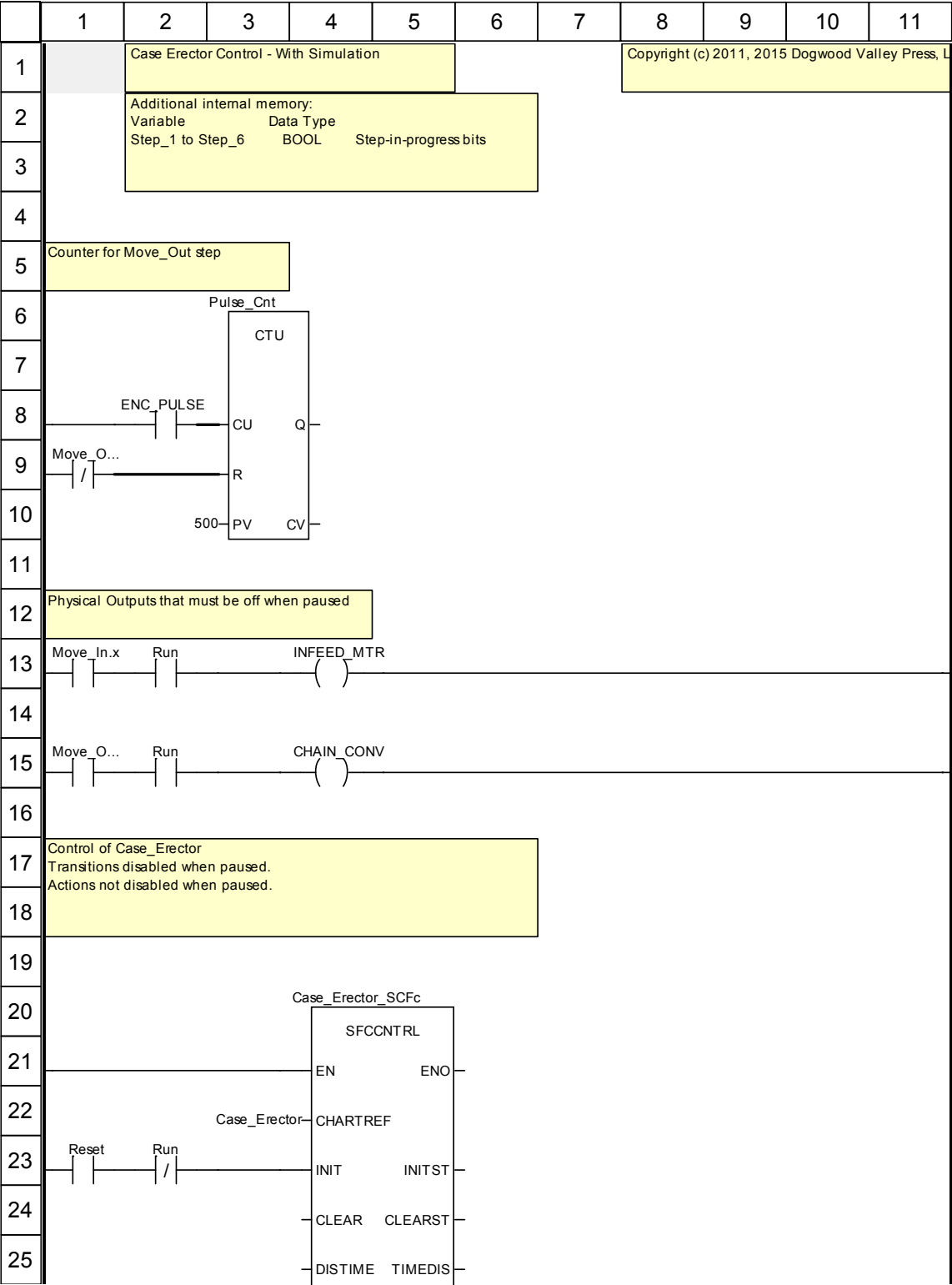
Project	SP14_02
Designer	
Application	sp14_02.stu
Software Version	Unity Pro L V10.0
Creation Date	4/12/2011 8:52:23 PM
Last Modification Date	12/24/2015 6:34:13 AM
Target PLC	BMX P34 1000 02.00CPU 340-10 Modbus

MAST

Specific properties

Configuration	Cyclic
Task period configuration	0
Watchdog time configuration	250

main : [MAST]

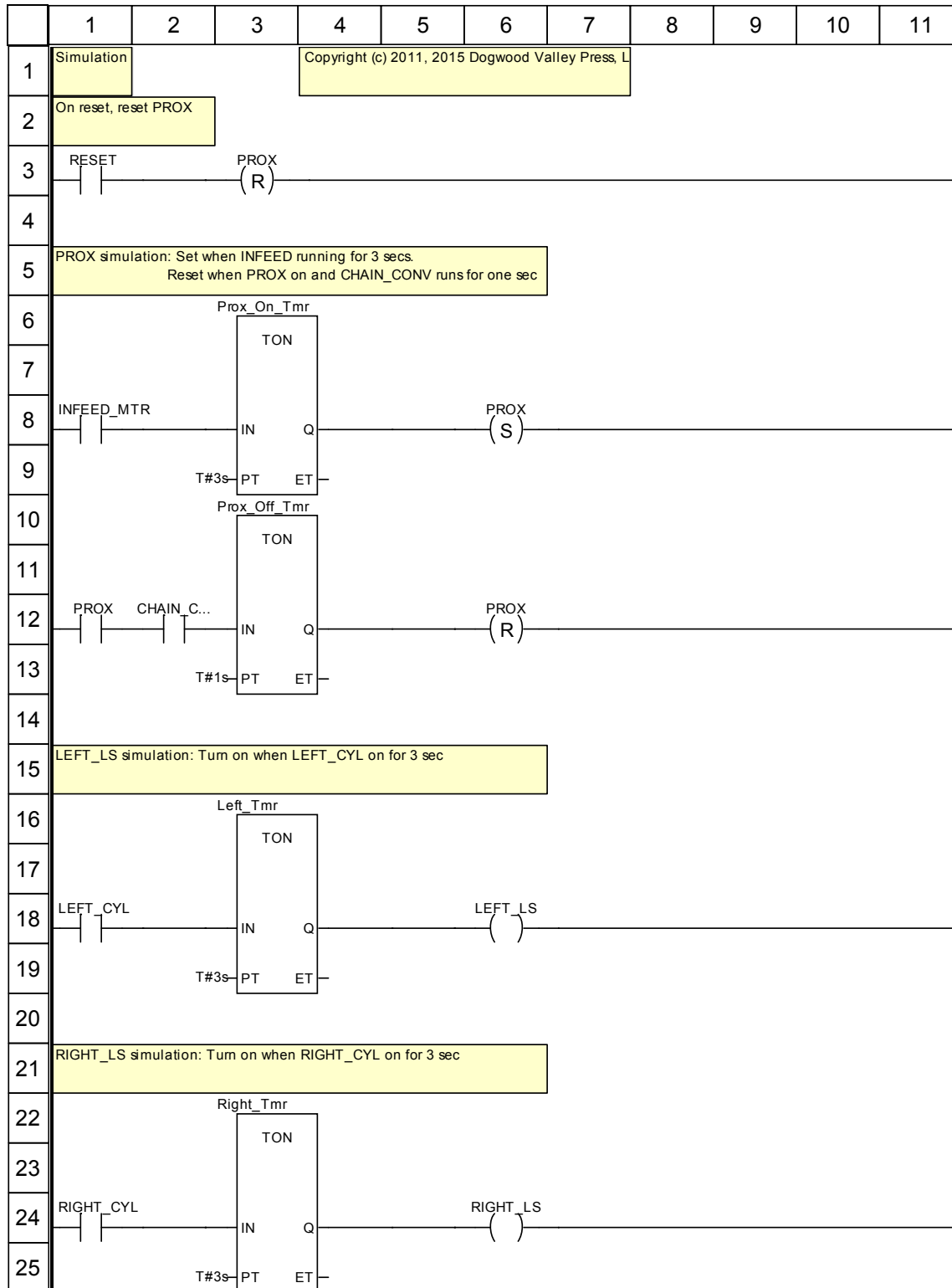


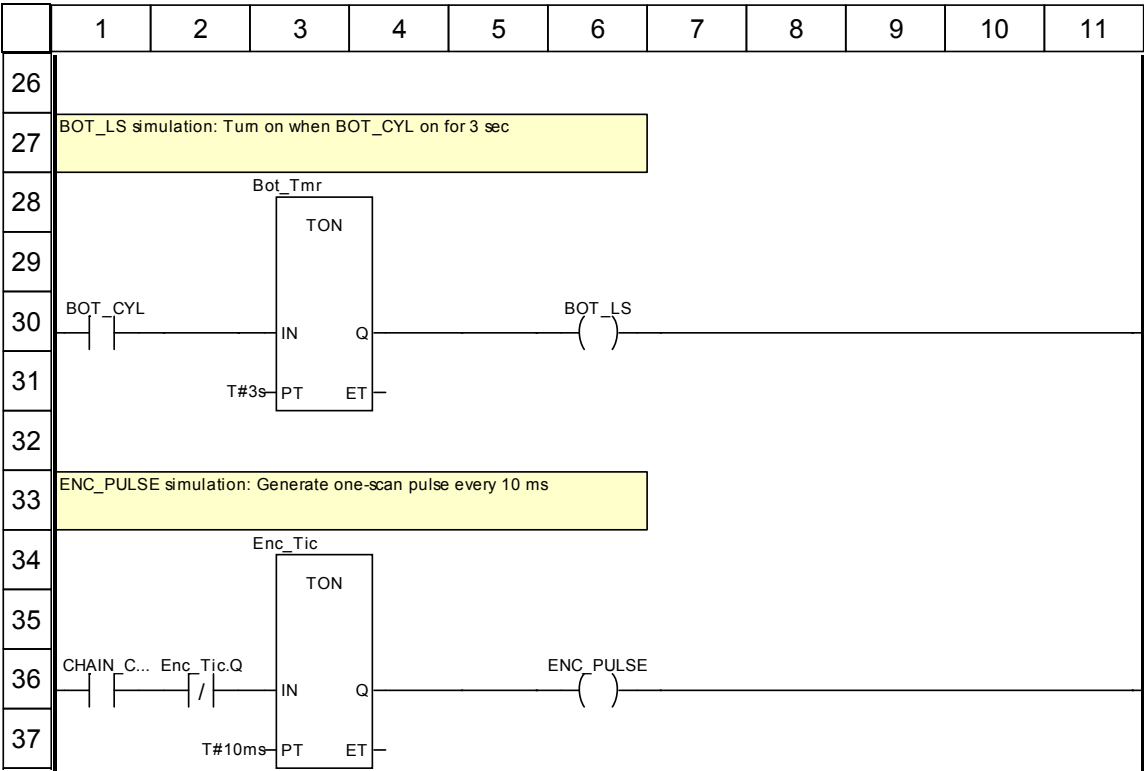
	1	2	3	4	5	6	7	8	9	10	11						
26	Run /			DISTR...	TRANS...												
27				DISACT	ACTDIS												
28				STEPUN	MODE...												
29				STEPPD...	STATE...												
30				RESET...	TIMEERR												
31				DISRM...	TERRA...												
32				ALLTRANS													
33				RESSTEPT													

Truncated labels:

Label	Position(s)
Move_Out.x	(1, 9) (1, 15)

Simulation : [MAST]





Truncated labels:

Label	Position(s)
CHAIN_CONV	(2, 12) (1, 36)

Case_Erector : [MAST]

Comment

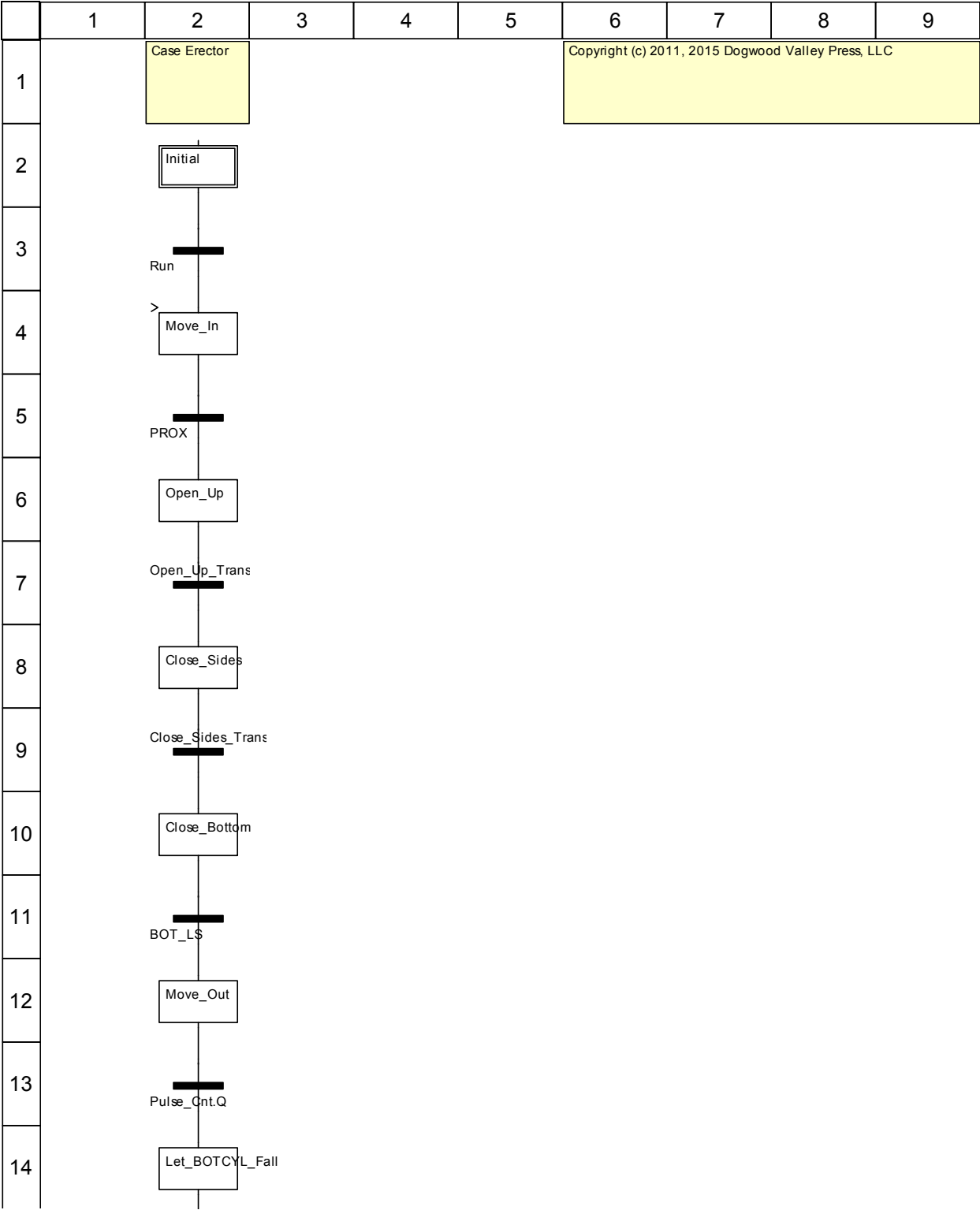
Common properties

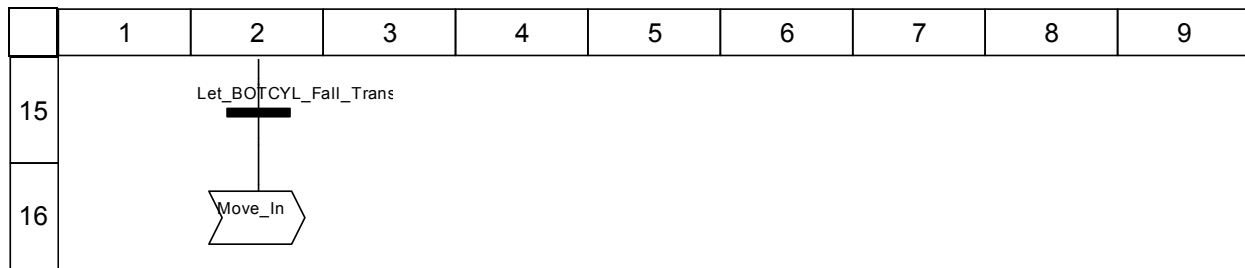
Functional module	
Condition name	

Specific properties

Operator control	No
Area number	0

Chart : [MAST - Case_Erector]





Object description

Steps:

Close Bottom			(2, 10)
Min./Max. supervision time:			Step delay time:
Comment:			
Actions:			
Qualifier: N	Time:	Variable: LEFT_CYL	
Qualifier: N	Time:	Variable: RIGHT_CYL	
Qualifier: N	Time:	Variable: BOT_CYL	

Close Sides			(2, 8)
Min./Max. supervision time:			Step delay time:
Comment:			
Actions:			
Qualifier: N	Time:	Variable: END_CYL	
Qualifier: N	Time:	Variable: GATE1	
Qualifier: N	Time:	Variable: LEFT_CYL	
Qualifier: N	Time:	Variable: RIGHT_CYL	

Initial (Initial Step)			(2, 2)
Min./Max. supervision time:			Step delay time:
Comment:			

Let_BOTCYL_Fall			(2, 14)
Min./Max. supervision time:			Step delay time:
Comment:			

Move In			(2, 4)
Min./Max. supervision time:			Step delay time:
Comment:			

Move Out			(2, 12)
Min./Max. supervision time:			Step delay time:
Comment:			
Actions:			
Qualifier: N	Time:	Variable: BOT_CYL	

Open Up			(2, 6)
Min./Max. supervision time:			Step delay time:
Comment:			
Actions:			
Qualifier: N	Time:	Variable: END_CYL	
Qualifier: N	Time:	Variable: GATE1	

Transitions:

Name	Type of Condition	Position	Comment
BOT_LS	Variable	(2, 11)	
ST :: Close_Sides_Trans	Section	(2, 9)	
ST :: Let BOTCYL_Fall_Trans	Section	(2, 15)	
ST :: Open_Up_Trans	Section	(2, 7)	
PROX	Variable	(2, 5)	
Pulse_Cnt.Q	Variable	(2, 13)	
Run	Variable	(2, 3)	

Jumps:

Name	Position	Comment
Move_In	(2, 16)	

Open_Up_Trans <Transition> : [MAST - Case_Erector]

1 | 10 | 20 | 30 | 40 | 50 | 60 | 70 | 80 | 90 | 100 | 110 |
120 | 134 |
1 Open_Up.t >= t#3s500ms

Close_Sides_Trans <Transition> : [MAST - Case_Erector]

1| 10| 20| 30| 40| 50| 60| 70| 80| 90| 100| 110|
120| 134|
1 LEFT_LS AND RIGHT_LS

Let_BOTCYL_Fall_Trans <Transition> : [MAST - Case_Erector]

1| 10| 20| 30| 40| 50| 60| 70| 80| 90| 100| 110|
120| 134|
1 Let_BOTCYL_Fall.t >= t#1s

Cross References

Application:

Addresses

Object	Referred into	Location	Usage
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Variables or FB instances

Object	Referred into	Location	Usage
BOT_CYL	Simulation : [MAST]	(I 30, c: 1)	R
	Chart : [MAST - Case_Erector]	(I 10, c: 2)	W
		(I 12, c: 2)	W
BOT_LS	Simulation : [MAST]	(I 30, c: 6)	W
	Chart : [MAST - Case_Erector]	(I 11, c: 2)	R
Bot_Tmr	Simulation : [MAST]	(I 28, c: 3)	FC
		(I 28, c: 3)	R
		(I 28, c: 3)	R
CHAIN_CONV	Simulation : [MAST]	(I 12, c: 2)	R
		(I 36, c: 1)	R
	main : [MAST]	(I 15, c: 4)	W
Case_Erector	main : [MAST]	(I 20, c: 4)	R
Case_Erector_SCFc	main : [MAST]	(I 20, c: 4)	FC
		(I 20, c: 4)	R
		(I 20, c: 4)	R
		(I 20, c: 4)	R
Close_Bottom	Chart : [MAST - Case_Erector]	(I 10, c: 2)	W
Close_Sides	Chart : [MAST - Case_Erector]	(I 8, c: 2)	W
Close_Sides_Trans	Chart : [MAST - Case_Erector]	(I 9, c: 2)	R
	Close_Sides_Trans <Transition> : [MAST - Case_Erector]	(I 1, c: 1)	W
ENC_PULSE	Simulation : [MAST]	(I 36, c: 6)	W
	main : [MAST]	(I 8, c: 2)	R
END_CYL	Chart : [MAST - Case_Erector]	(I 6, c: 2)	W
		(I 8, c: 2)	W
Enc_Tic	Simulation : [MAST]	(I 36, c: 2)	R
		(I 34, c: 3)	FC
		(I 34, c: 3)	R
		(I 34, c: 3)	R
GATE1	Chart : [MAST - Case_Erector]	(I 6, c: 2)	W
		(I 8, c: 2)	W
INFEED_MTR	Simulation : [MAST]	(I 8, c: 1)	R
	main : [MAST]	(I 13, c: 4)	W
Initial	Chart : [MAST - Case_Erector]	(I 2, c: 2)	W
LEFT_CYL	Simulation : [MAST]	(I 18, c: 1)	R
	Chart : [MAST - Case_Erector]	(I 8, c: 2)	W
		(I 10, c: 2)	W
LEFT_LS	Simulation : [MAST]	(I 18, c: 6)	W
	Close_Sides_Trans <Transition> : [MAST - Case_Erector]	(I 1, c: 1)	R
Left_Tmr	Simulation : [MAST]	(I 16, c: 3)	FC
		(I 16, c: 3)	R
		(I 16, c: 3)	R
Let_BOTCYL_Fall	Let_BOTCYL_Fall_Trans <Transition> : [MAST - Case_Erector]	(I 1, c: 1)	R
	Chart : [MAST - Case_Erector]	(I 14, c: 2)	W

Cross References

Object	Referred into	Location	Usage
Let_BOTCYL_Fall_Trans	Let_BOTCYL_Fall_Trans <Transition> : [MAST - Case_Erector]	(l 1, c: 1)	W
	Chart : [MAST - Case_Erector]	(l 15, c: 2)	R
Move_In	main : [MAST]	(l 13, c: 1)	R
	Chart : [MAST - Case_Erector]	(l 4, c: 2)	W
		(l 16, c: 2)	L REF
Move_Out	main : [MAST]	(l 9, c: 1)	R
		(l 15, c: 1)	R
	Chart : [MAST - Case_Erector]	(l 12, c: 2)	W
Open_Up	Chart : [MAST - Case_Erector]	(l 6, c: 2)	W
	Open_Up_Trans <Transition> : [MAST - Case_Erector]	(l 1, c: 1)	R
Open_Up_Trans	Open_Up_Trans <Transition> : [MAST - Case_Erector]	(l 1, c: 1)	W
	Chart : [MAST - Case_Erector]	(l 7, c: 2)	R
PROX	Simulation : [MAST]	(l 3, c: 3)	W
		(l 8, c: 6)	W
		(l 12, c: 1)	R
		(l 12, c: 6)	W
	Chart : [MAST - Case_Erector]	(l 5, c: 2)	R
Prox_Off_Tmr	Simulation : [MAST]	(l 10, c: 3)	FC
		(l 10, c: 3)	R
		(l 10, c: 3)	R
Prox_On_Tmr	Simulation : [MAST]	(l 6, c: 3)	FC
		(l 6, c: 3)	R
		(l 6, c: 3)	R
Pulse_Cnt	main : [MAST]	(l 6, c: 3)	FC
		(l 6, c: 3)	R
		(l 6, c: 3)	R
		(l 6, c: 3)	R
	Chart : [MAST - Case_Erector]	(l 13, c: 2)	R
RIGHT_CYL	Simulation : [MAST]	(l 24, c: 1)	R
	Chart : [MAST - Case_Erector]	(l 8, c: 2)	W
		(l 10, c: 2)	W
RIGHT_LS	Simulation : [MAST]	(l 24, c: 6)	W
	Close_Sides_Trans <Transition> : [MAST - Case_Erector]	(l 1, c: 13)	R
Reset	Simulation : [MAST]	(l 3, c: 1)	R
	main : [MAST]	(l 23, c: 1)	R
Right_Tmr	Simulation : [MAST]	(l 22, c: 3)	FC
		(l 22, c: 3)	R
		(l 22, c: 3)	R
Run	main : [MAST]	(l 13, c: 2)	R
		(l 15, c: 2)	R
		(l 23, c: 2)	R
		(l 26, c: 1)	R
	Chart : [MAST - Case_Erector]	(l 3, c: 2)	R

Subroutines

Object	Referred into	Location	Usage
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