

FST

5.WAREH

Name	Number	Uses	Description
FECCNTR	23	-	FEC Fast Counters
TCPIRFC2	26	-	TCP/IP Driver for FEC Standard

Options for 'FECCNTR'

<none>

Options for 'TCPIRFC2'

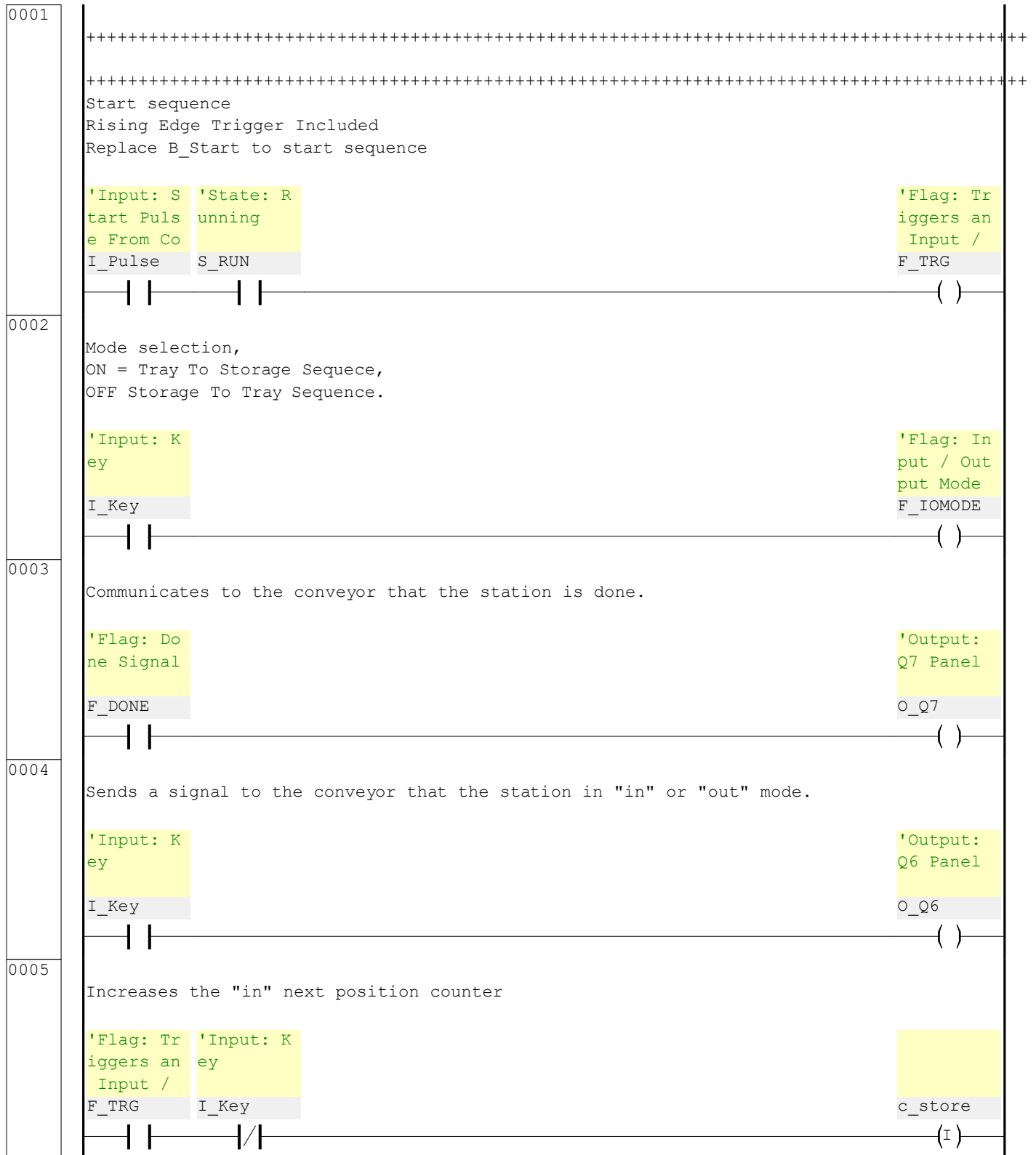
IP address: 10.110.60.5
IP netmask: 255.0.0.0
IP address gateway: 0.0.0.0

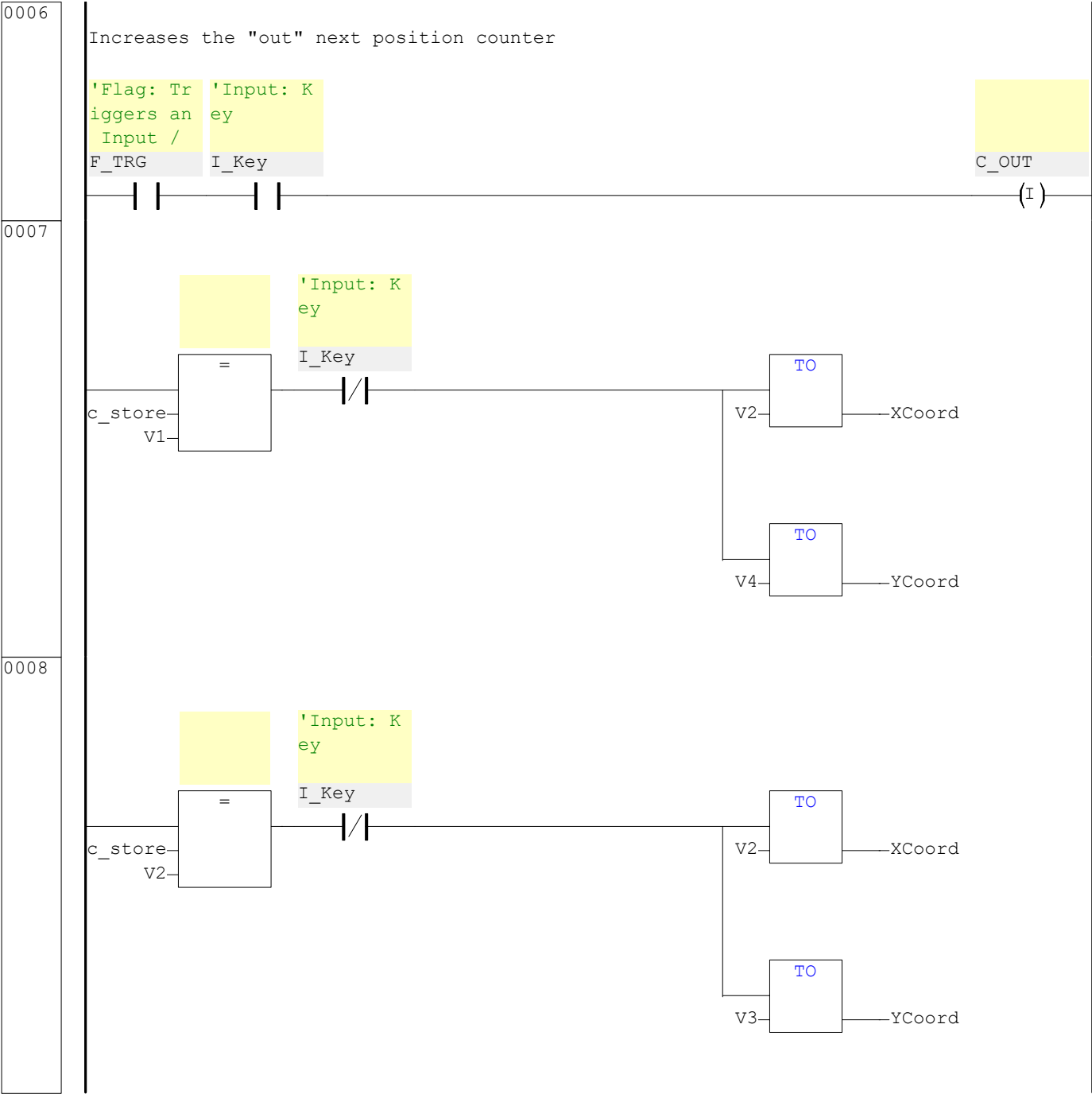
FST - 5.WAREH (No comment) - FEC Standard
Allocation List

Operand	Symbol	Comment
O0.0	O_Left	Output: Moves arm to the left
O0.1	O_Right	Output: Moves arm to the right
O0.2	O_Up	Output: Moves arm up
O0.3	O_Down	Output: Moves arm down
O0.4	O_Reach	Output: arm extends and reaches piece
O0.5	O_Grab	Output: Gripper closes
O0.6	O_FastX	Output: X axis moves fast
O0.7	O_FastY	Output: Y axis moves fast
O1.0	L_START	LED: Start
O1.1	L_RST	LED: Reset
O1.2	O_Q1	Output: Q1 Panel
O1.3	O_Q2	Output: Q2 Panel
O1.4	O_Q4	Output: Q4 Panel
O1.5	O_Q5	Output: Q5 Panel
O1.6	O_Q6	Output: Q6 Panel
O1.7	O_Q7	Output: Q7 Panel
I0.0	I_ULimit	Input: Y upper limit
I0.1	I_DLimit	Input: Y lower limit
I0.2	I_LLimit	Input: X Leftlimit
I0.3	I_RLimit	Input: x Right Limit
I0.4	I_Retract	Input: Arm is retracted
I0.5	I_Extend	Input: Arm is extended
I0.6	I_Open	Input: Gripper is open
I0.7	I_Closed	Input: Gripper is closed
I1.0	B_Start	Button: Start
I1.1	B_Stop	Button: Stop
I1.2	I_Key	Input: Key
I1.3	B_RST	Button: Reset
I1.6	I_Pulse	Input: Start Pulse From Conveyor
F0.0	S_RTS	State: Ready To Start
F0.1	S_RUN	State: Running
F0.2	S_RST	State: Reset
F0.3	S_HALT	State: Halted
F1.0	F_SDX	Flag: Slow Down X
F1.1	F_SDY	Flag: Slow Down on Y
F1.2	F_XP	Flag: X at Position
F1.3	F_YP	Flag: Y at Position
F1.4	F_RFCX	Flag: Reset X Axis Fast Counter
F1.5	F_RFCXD	Flag: Reset X Axis Fast Counter Dela
F1.6	F_RFCY	Flag: Reset Y Axis Fast Counter
F1.7	F_RFCYD	Flag: Reset Y Axis Fast C. Delay
F2.0	F_SS	Flag: Storing Sequence
F2.2	F_TRG	Flag: Triggers an Input / Output seq
F2.3	F_IOMODE	Flag: Input / Output Mode
F2.4	F_GTO	Flag: Go to Origin
F2.5	F_GTP	Flag: Go To Position
F2.6	F_GTT	Flag: Go To Tray
F3.4	F_EFY	Flag: Enable Fast Y
F5.8	F_NP	Flag: Not Pressed
F6.3	F_DONE	Flag: Done Signal
F6.8	F_DSTC	Flag: Done Signal To Conveyor
F7.0	F_SEQ1	Flag: Sequence 1
F7.1	F_SEQ2	Flag: Sequence 2
F7.5	f_ATPOS	Flag: At Position
F7.6	F_FIN	Sequence done
F36.0	F_SD	Flag: Sequence Done
F63.0	AUX	
F63.1	AUX2	
FW10 (U)	XActualP	X Axis actual value
FW11 (U)	YActualP	Y Axis actual position
FW12 (U)	C_X_2	Auxiliary X positio (enables slow m)
FW13 (U)	C_Y_2	Auxiliary Y Positio (enables slow m)
FW14 (U)	XCoord	X Goto Coordinate
FW15 (U)	YCoord	Y Goto Coordinate
FW16 (U)	XDesP	Desired X position
FW17 (U)	YdesP	Desired Y position
TON0	Restart1	

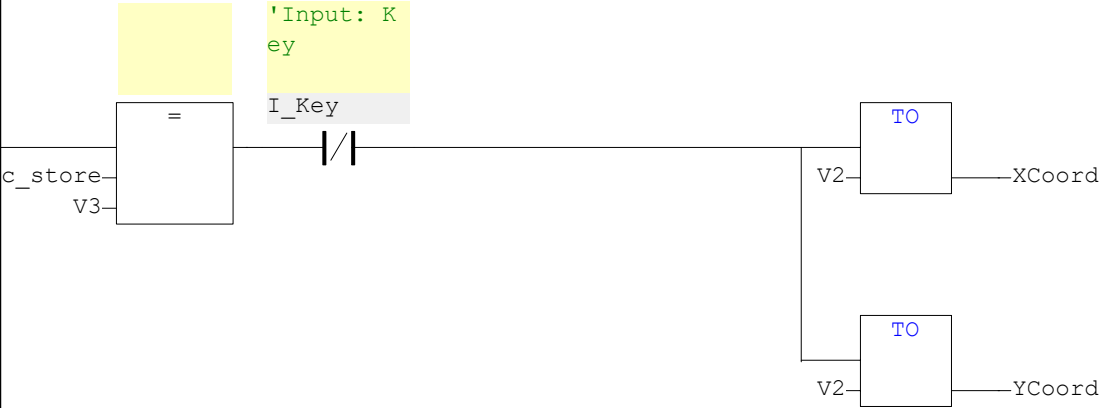
FST - 5.WAREH (No comment) - FEC Standard
Allocation List

Operand	Symbol	Comment
TON1	Restart2	
CW51	C_OUT	
CW100	c_store	

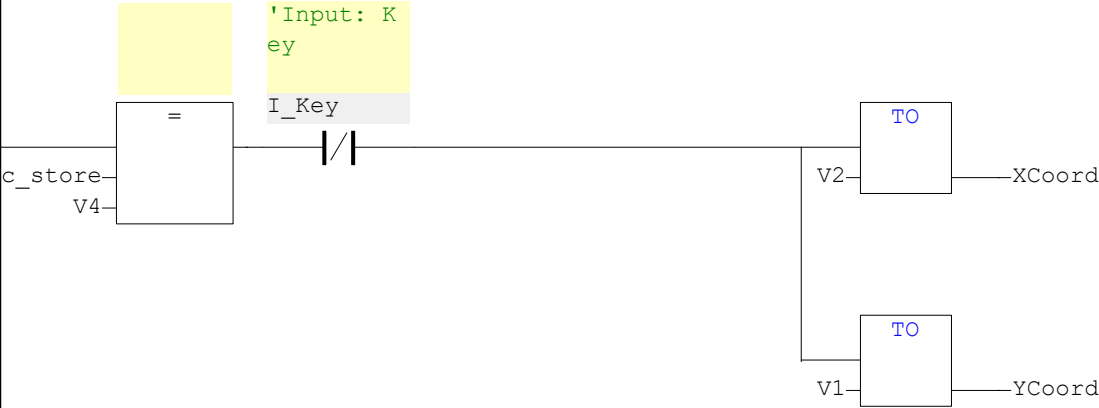




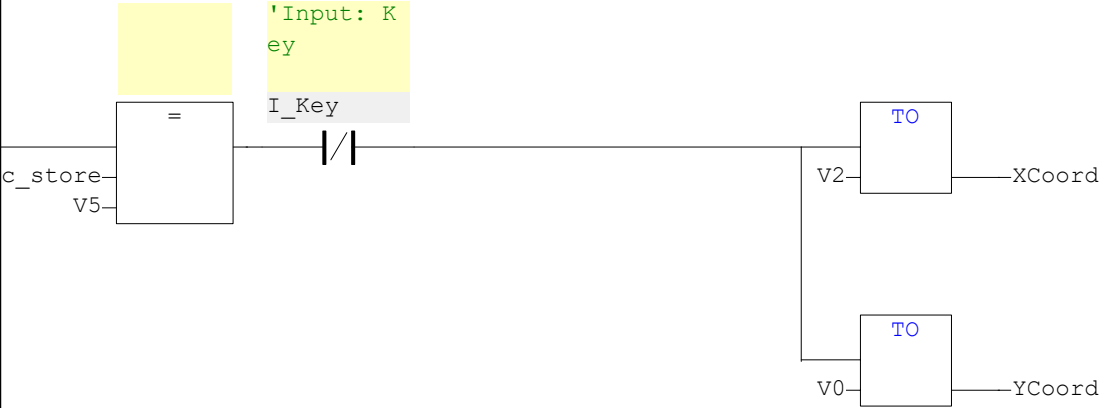
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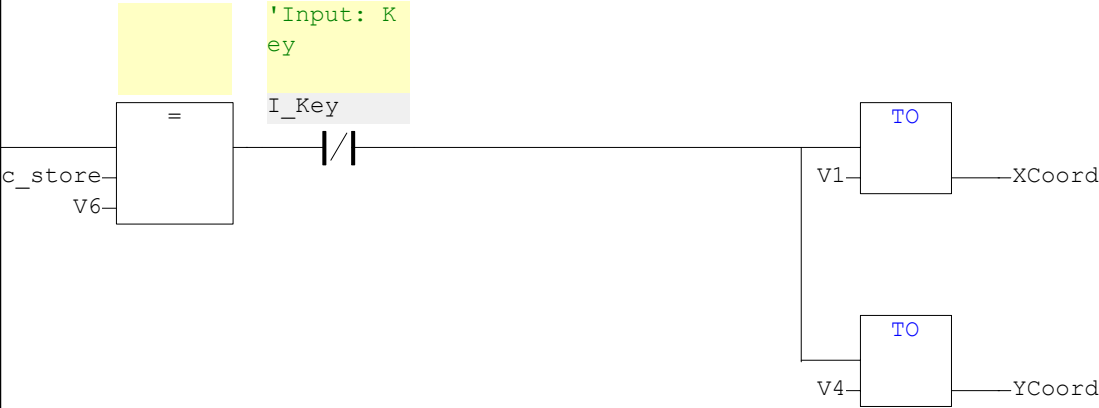
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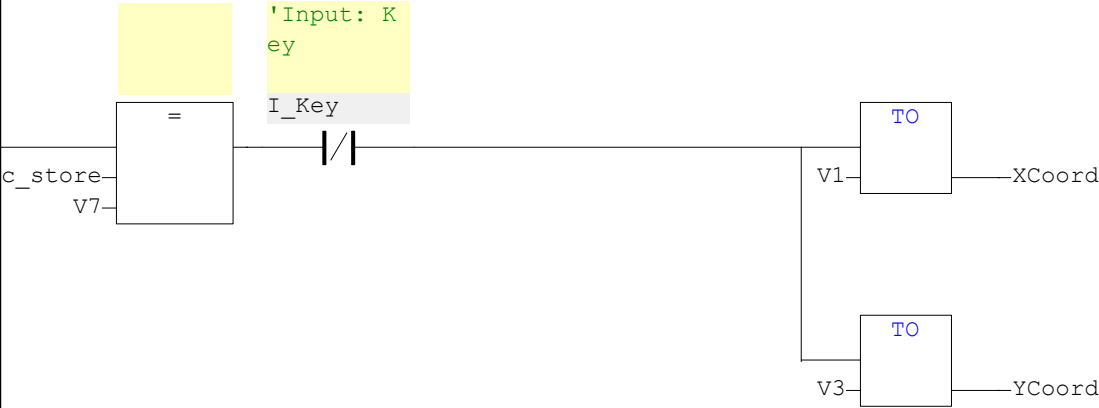
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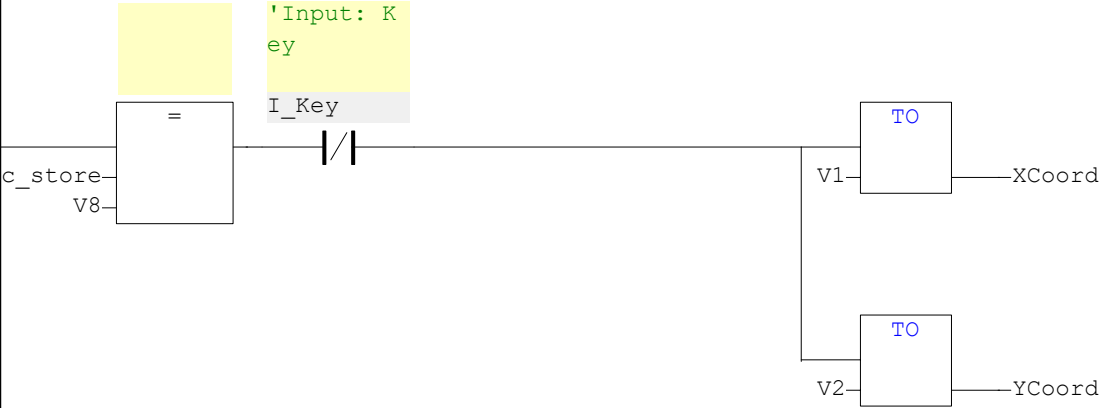
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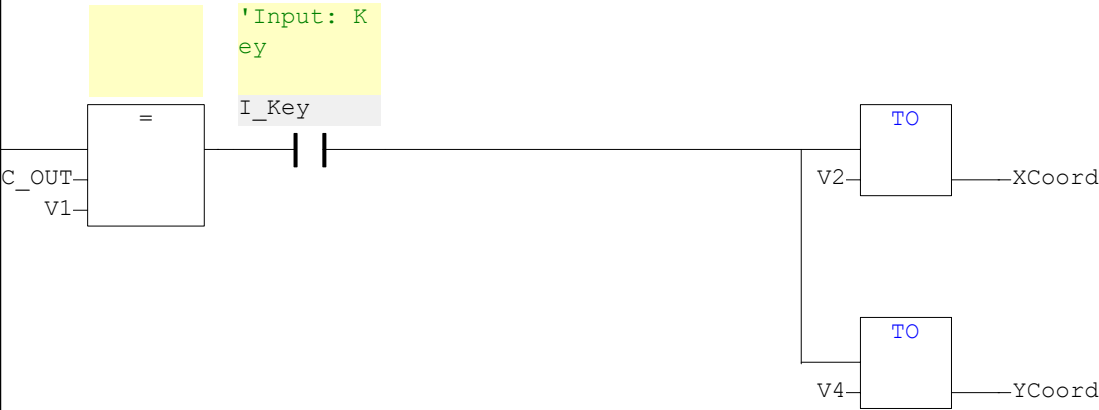
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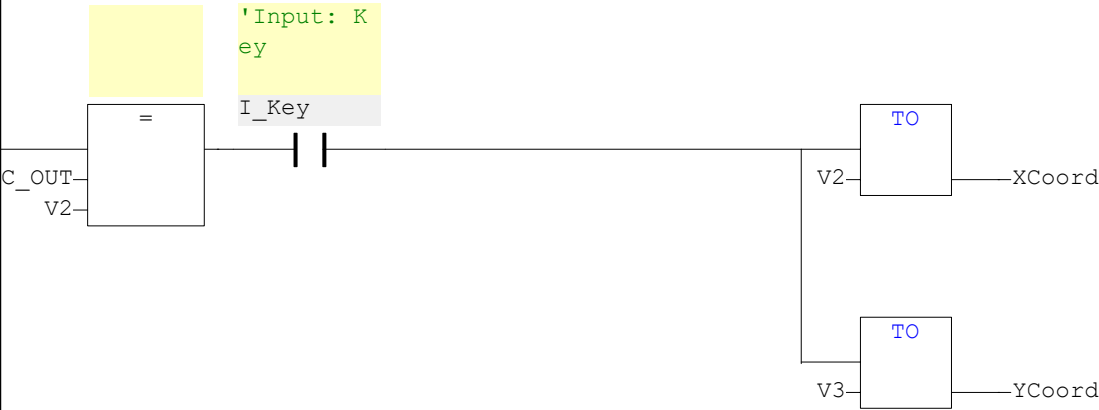
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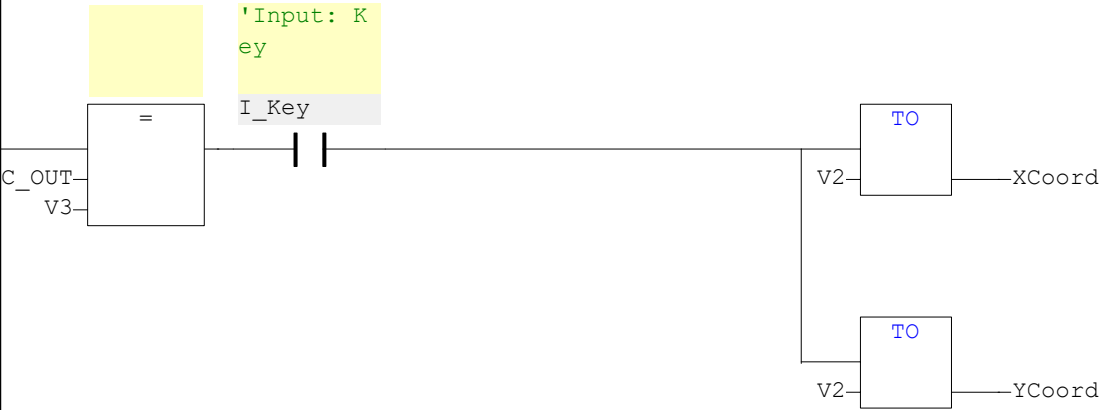
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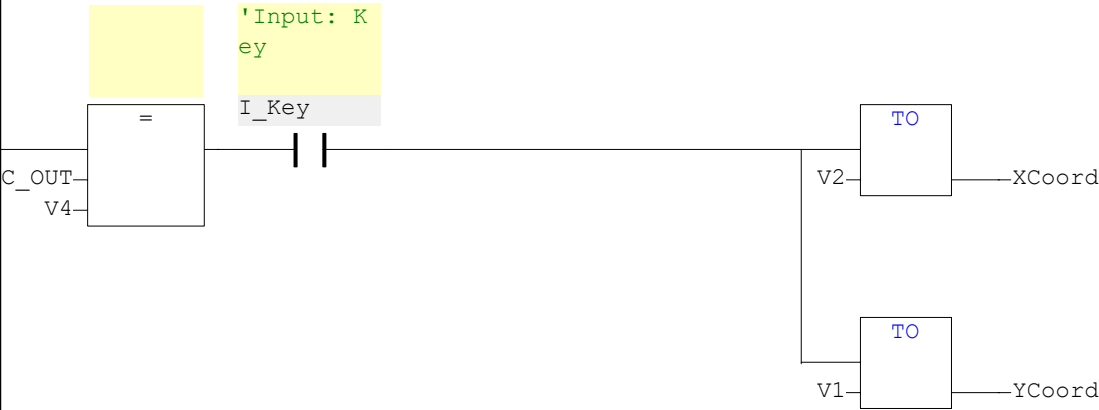
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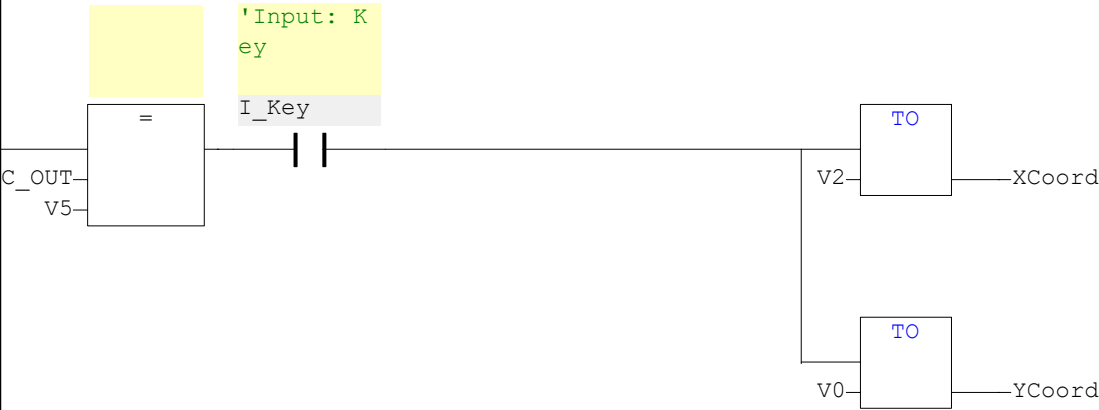
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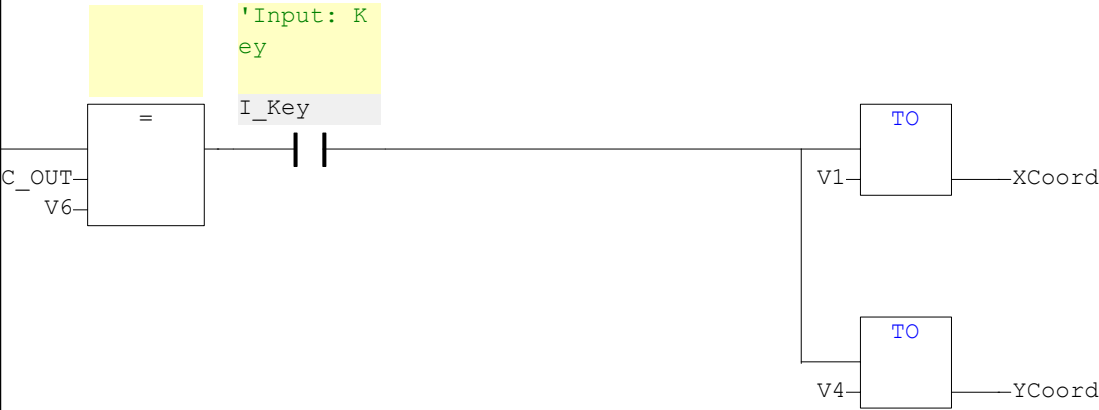
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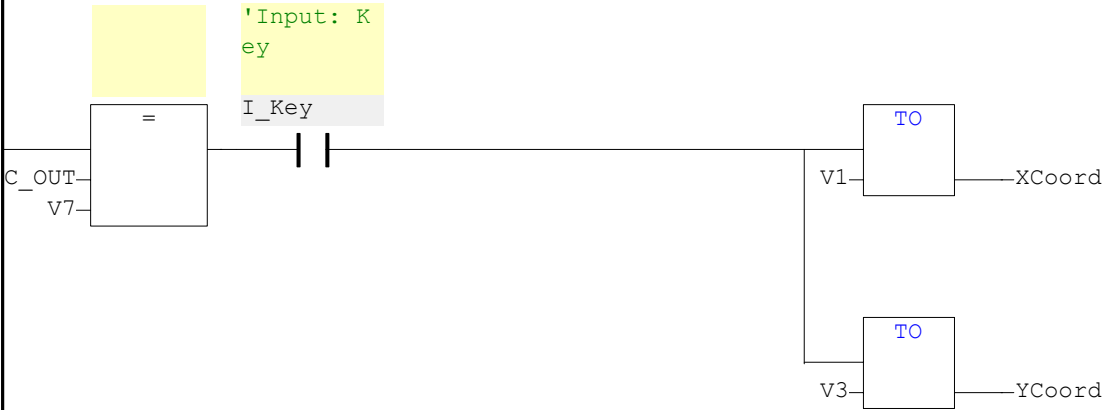
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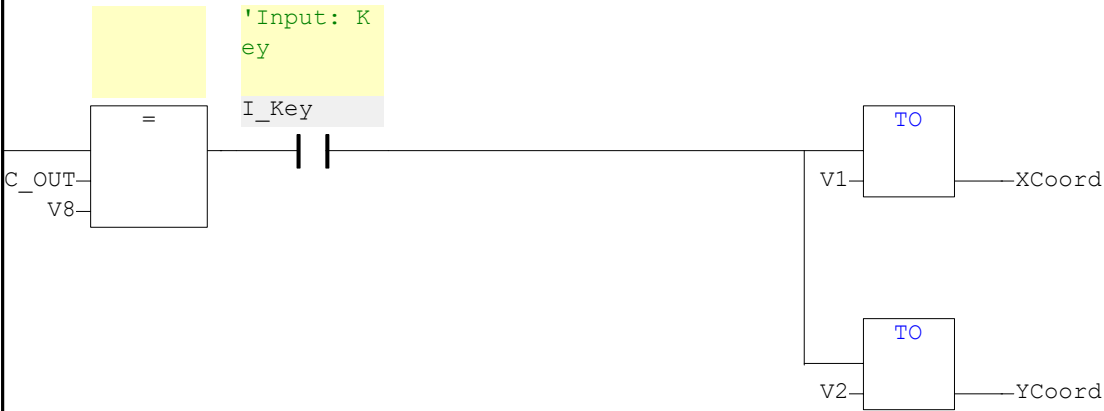
0020



0021



0022



0023

Lets all programs run

P1

(s)

P2

(s)

P3

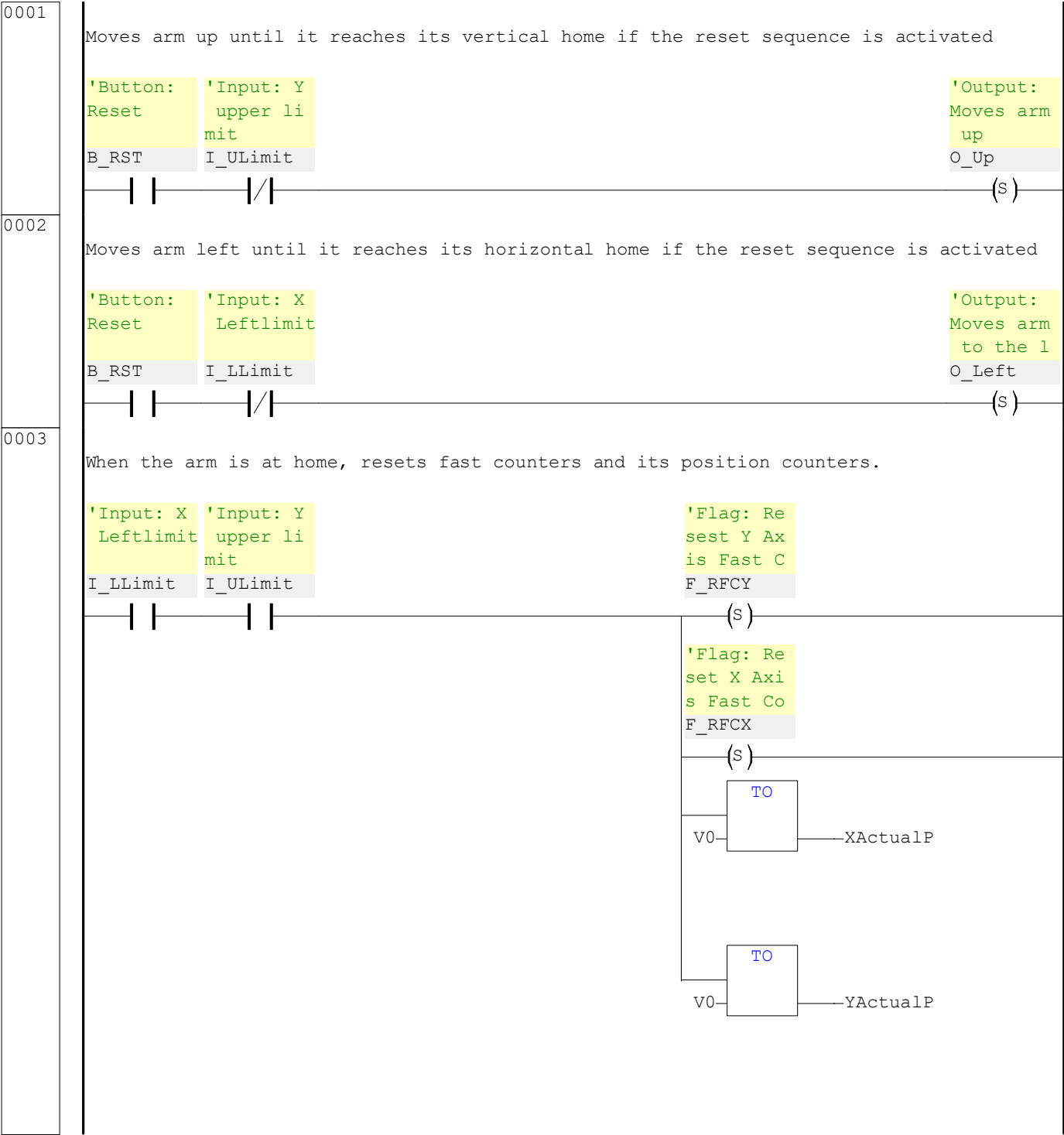
(s)

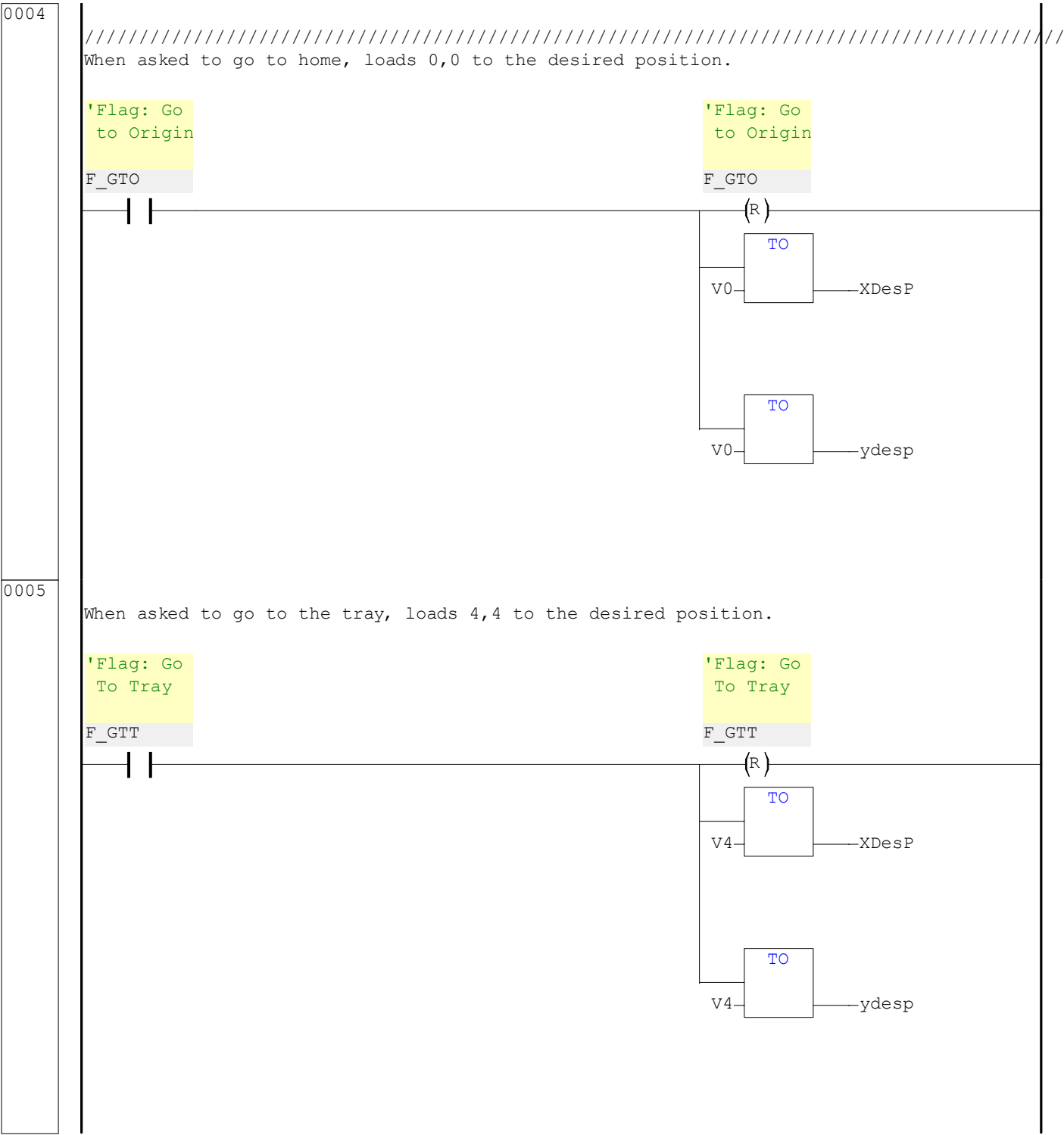
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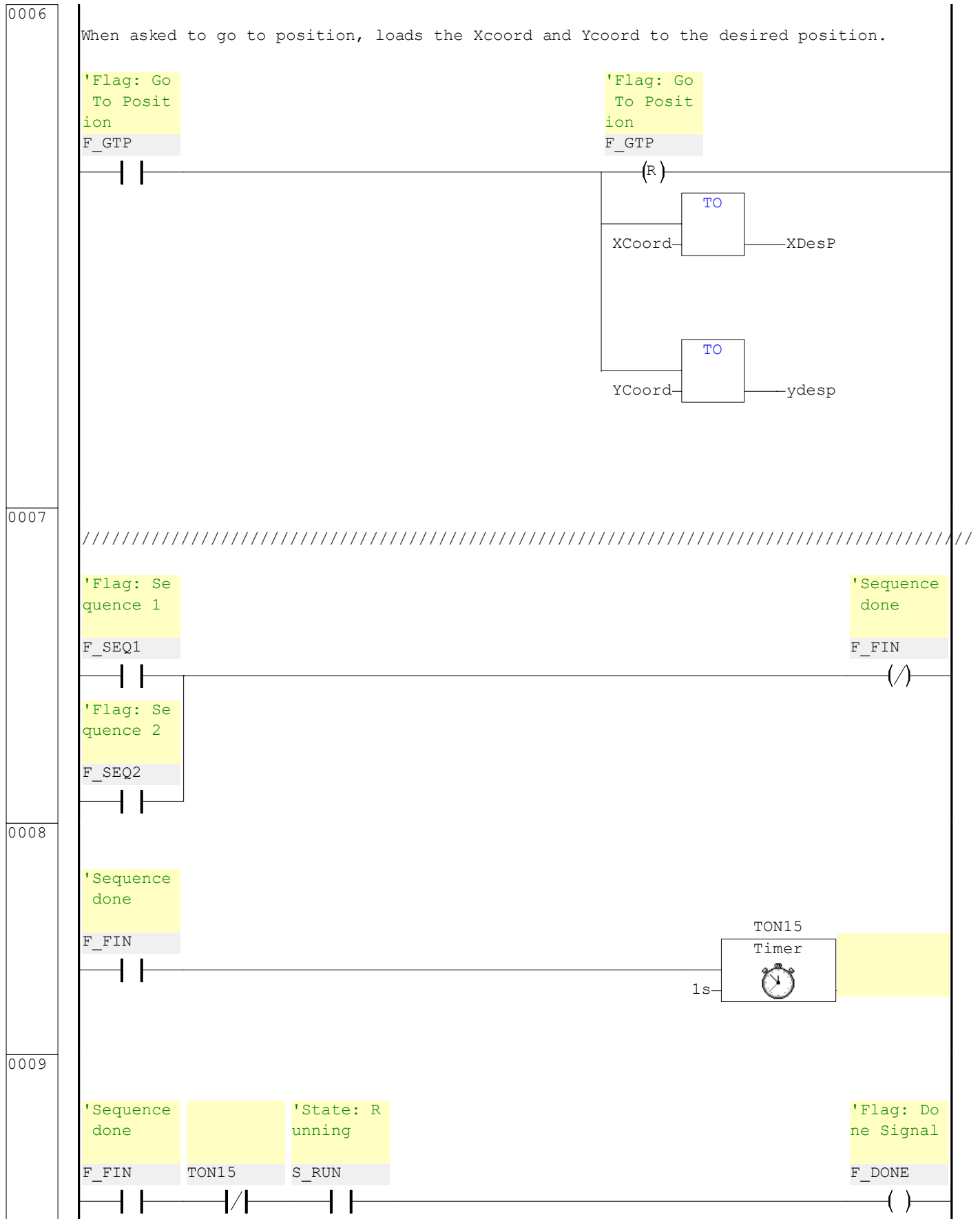
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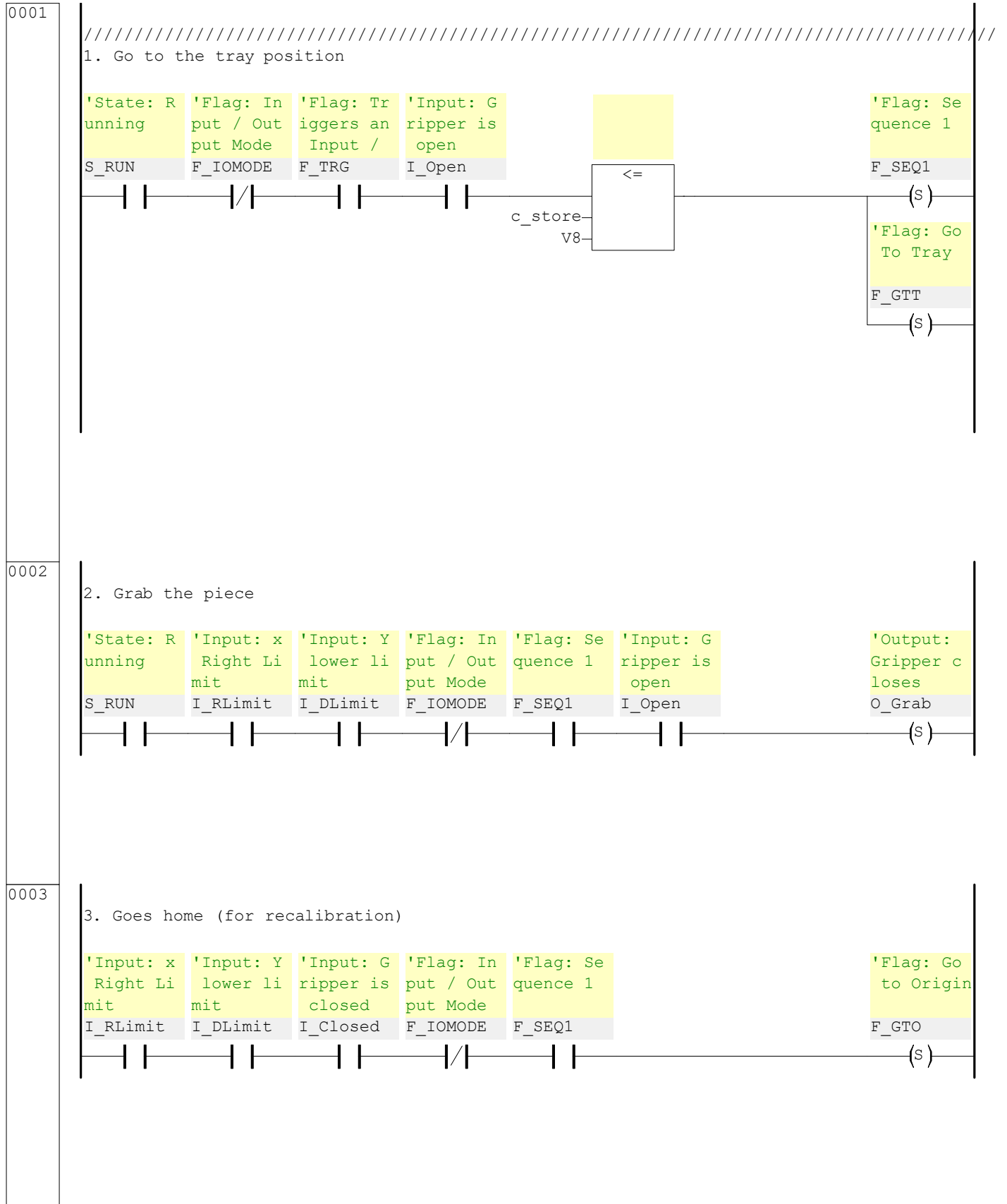
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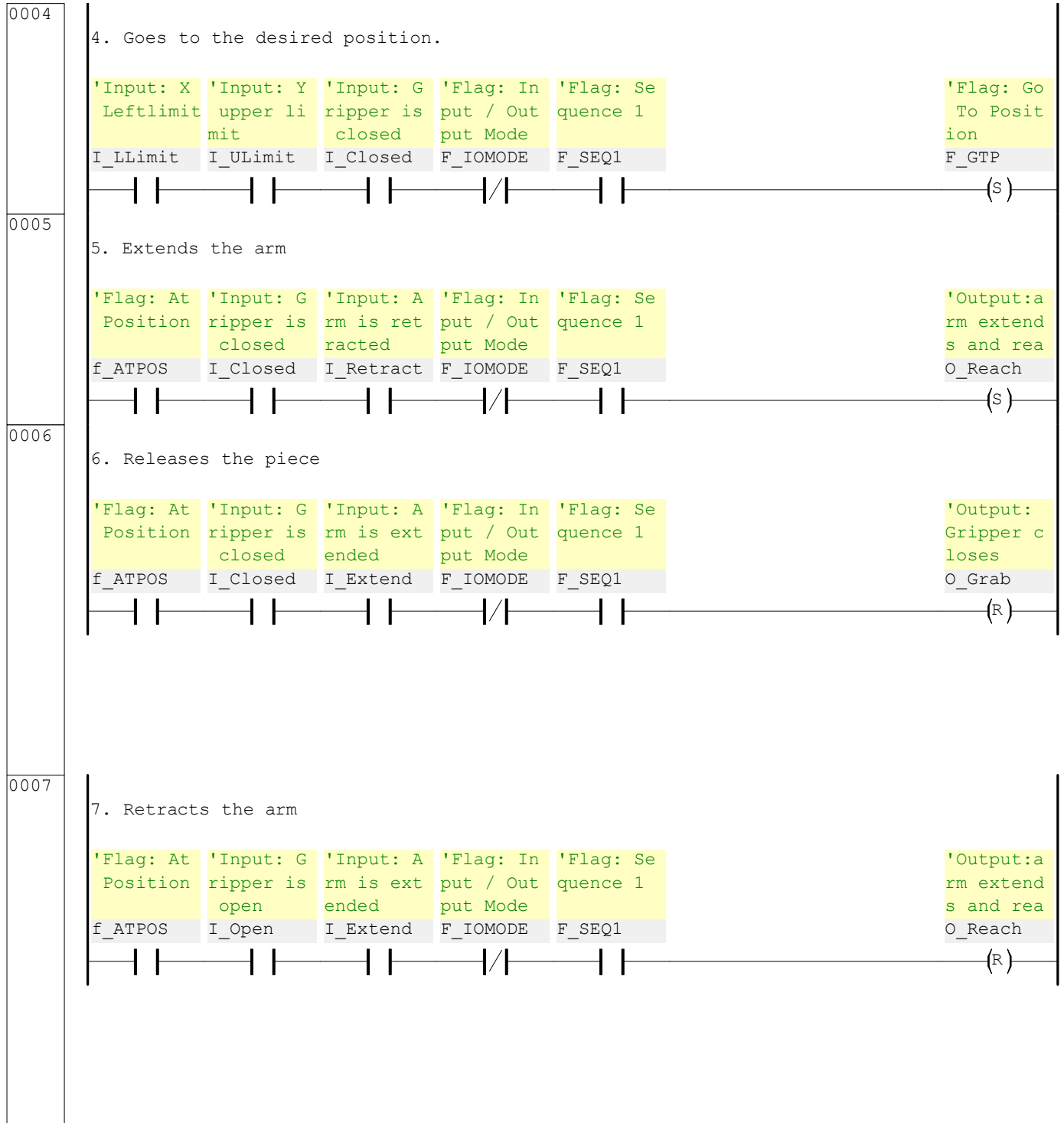
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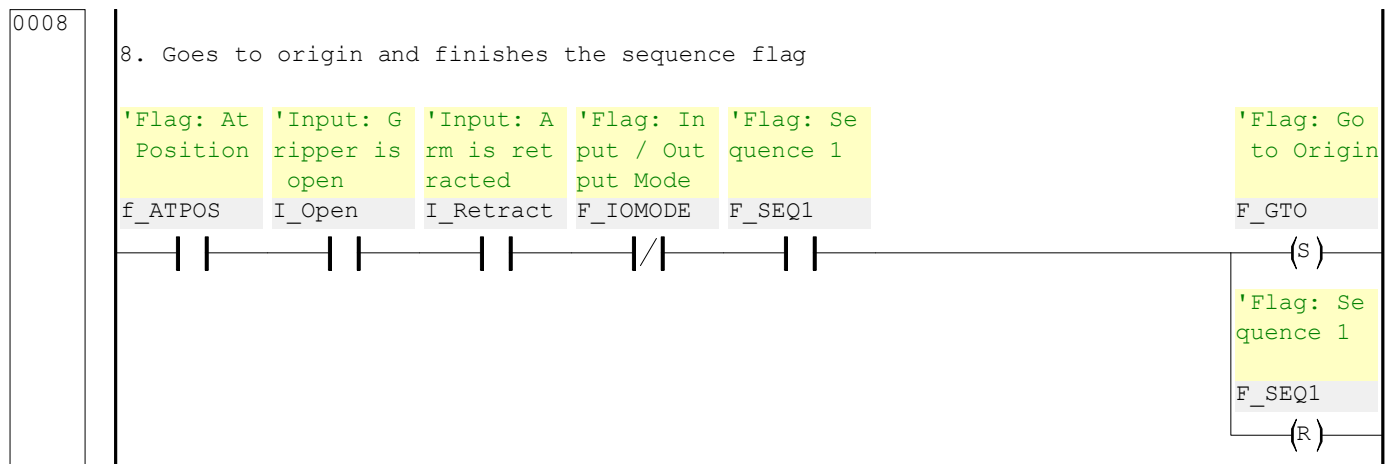


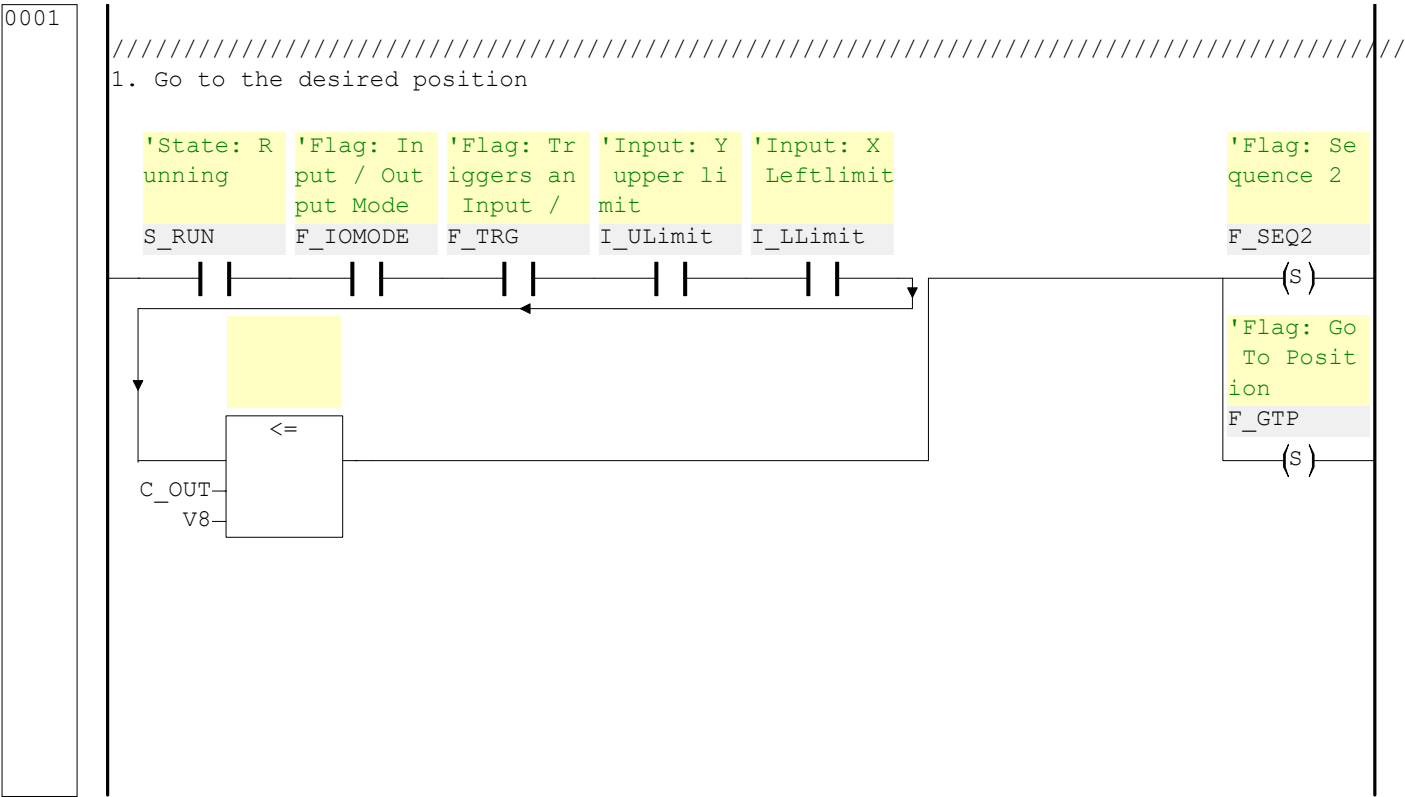


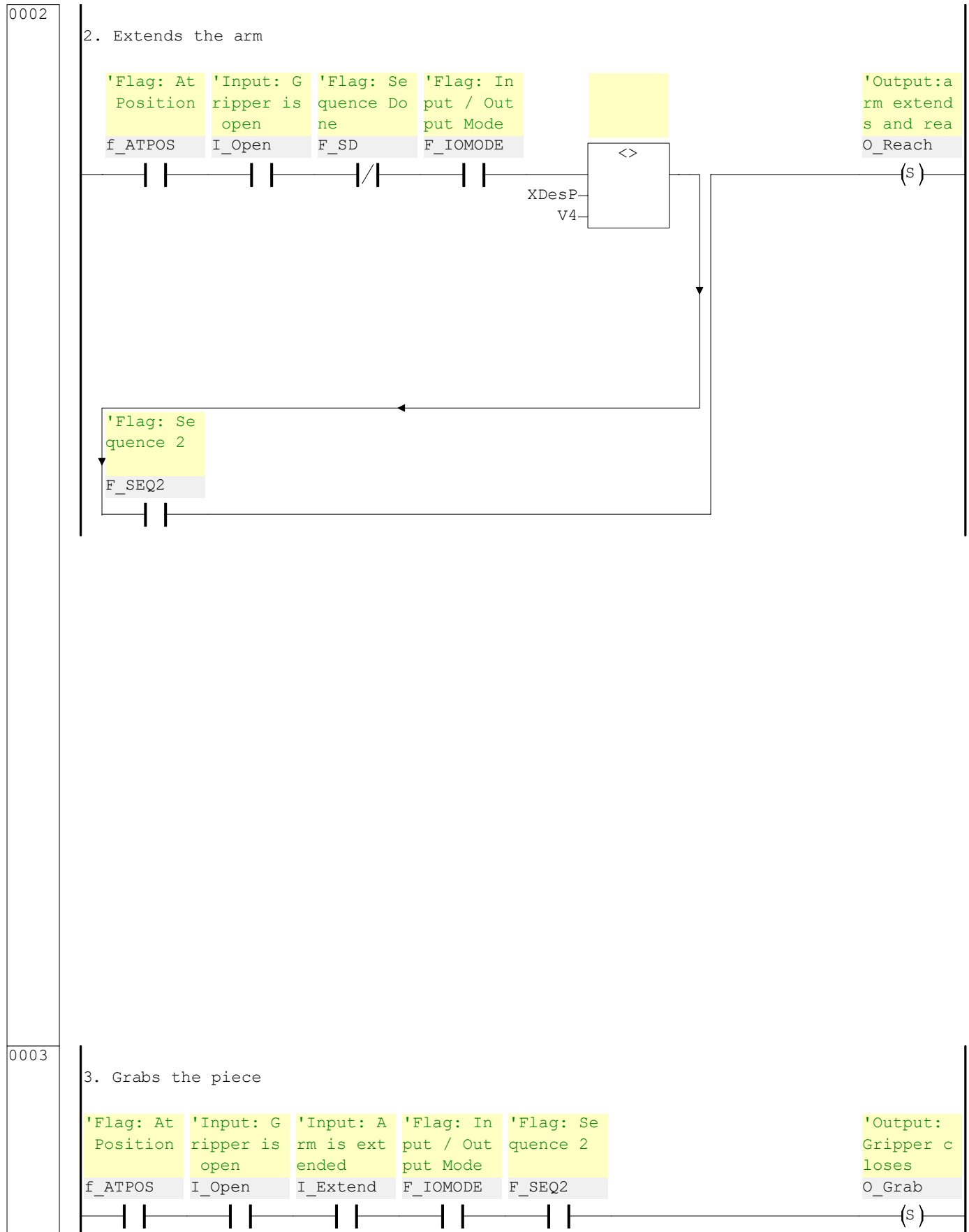


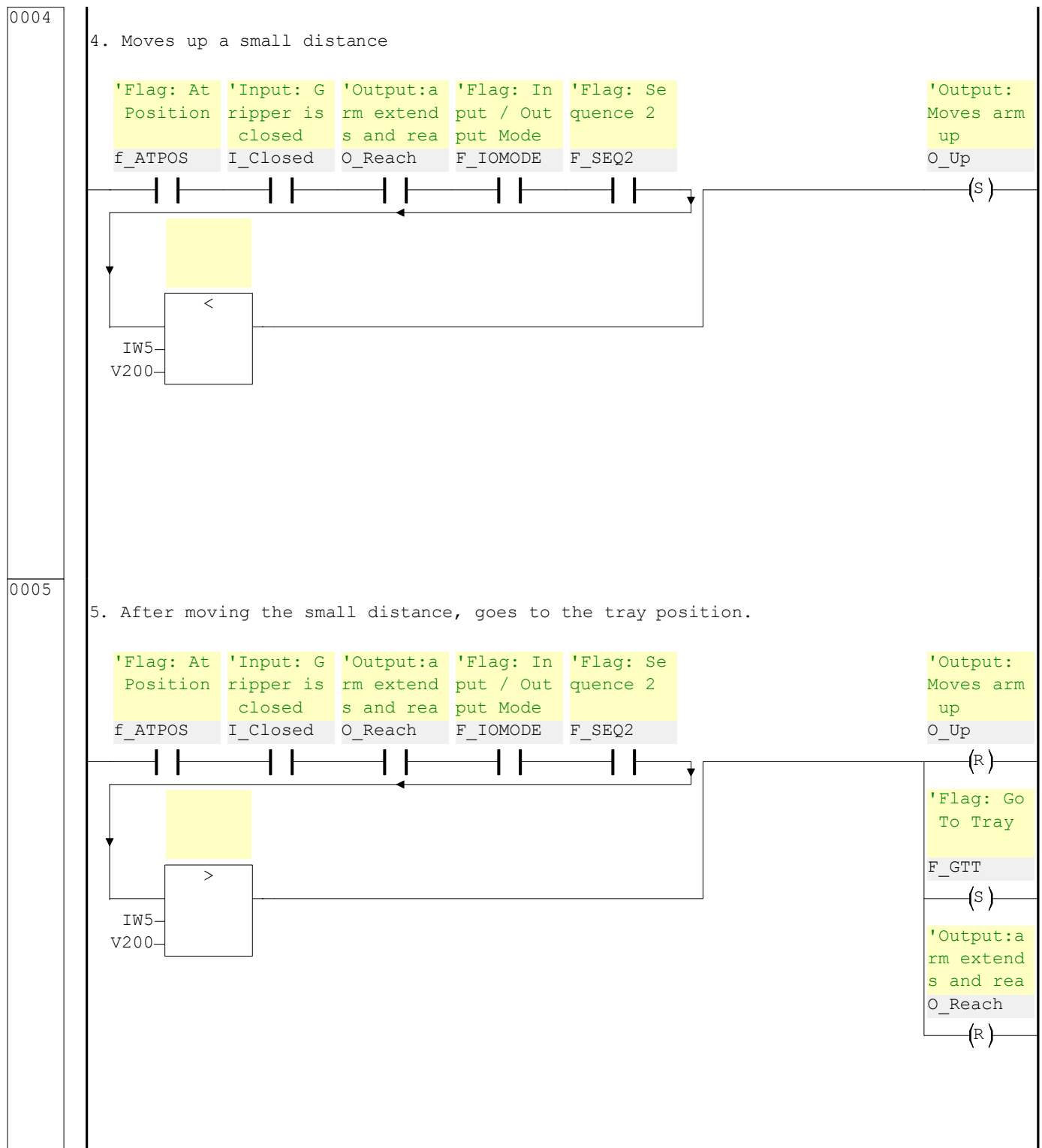


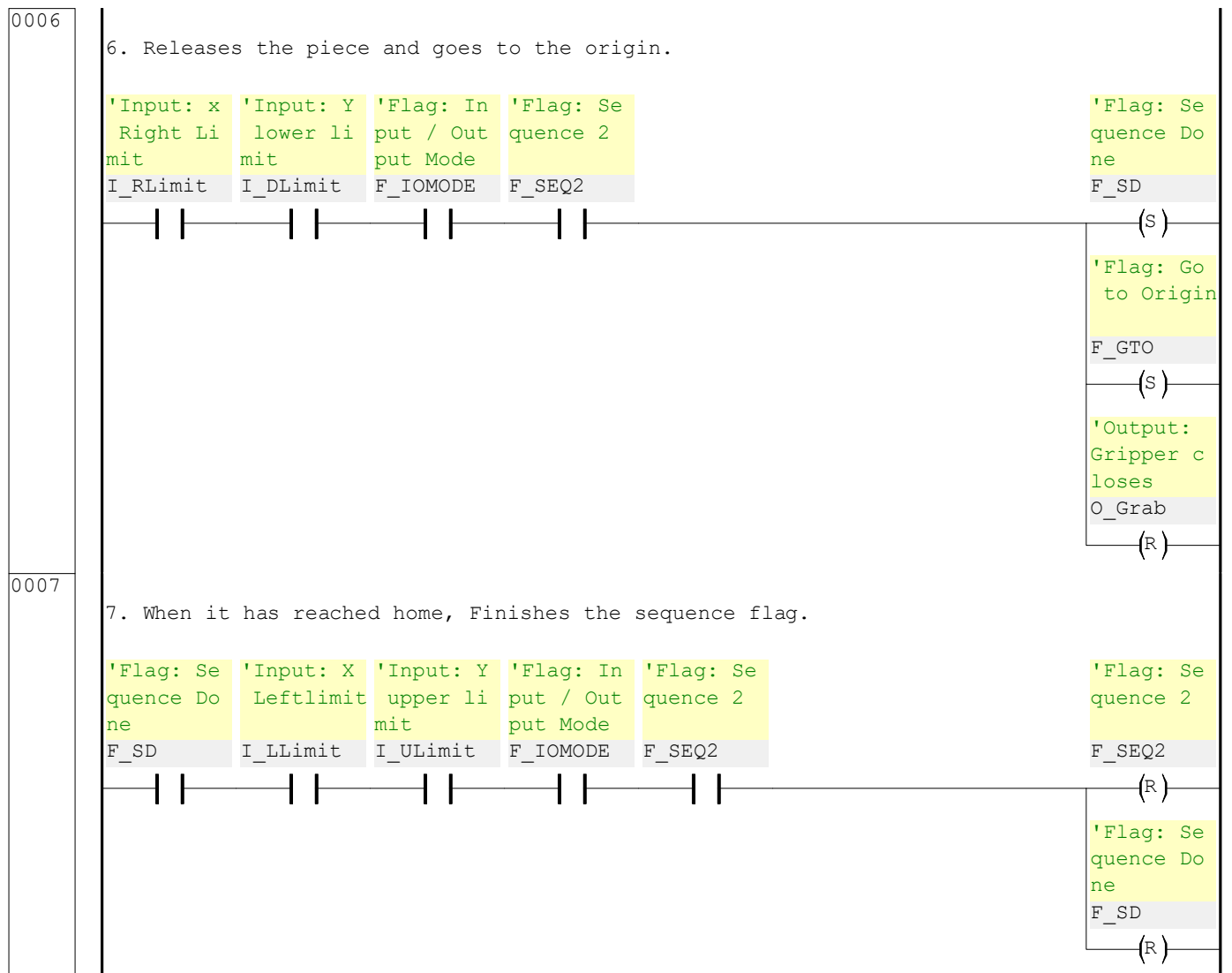




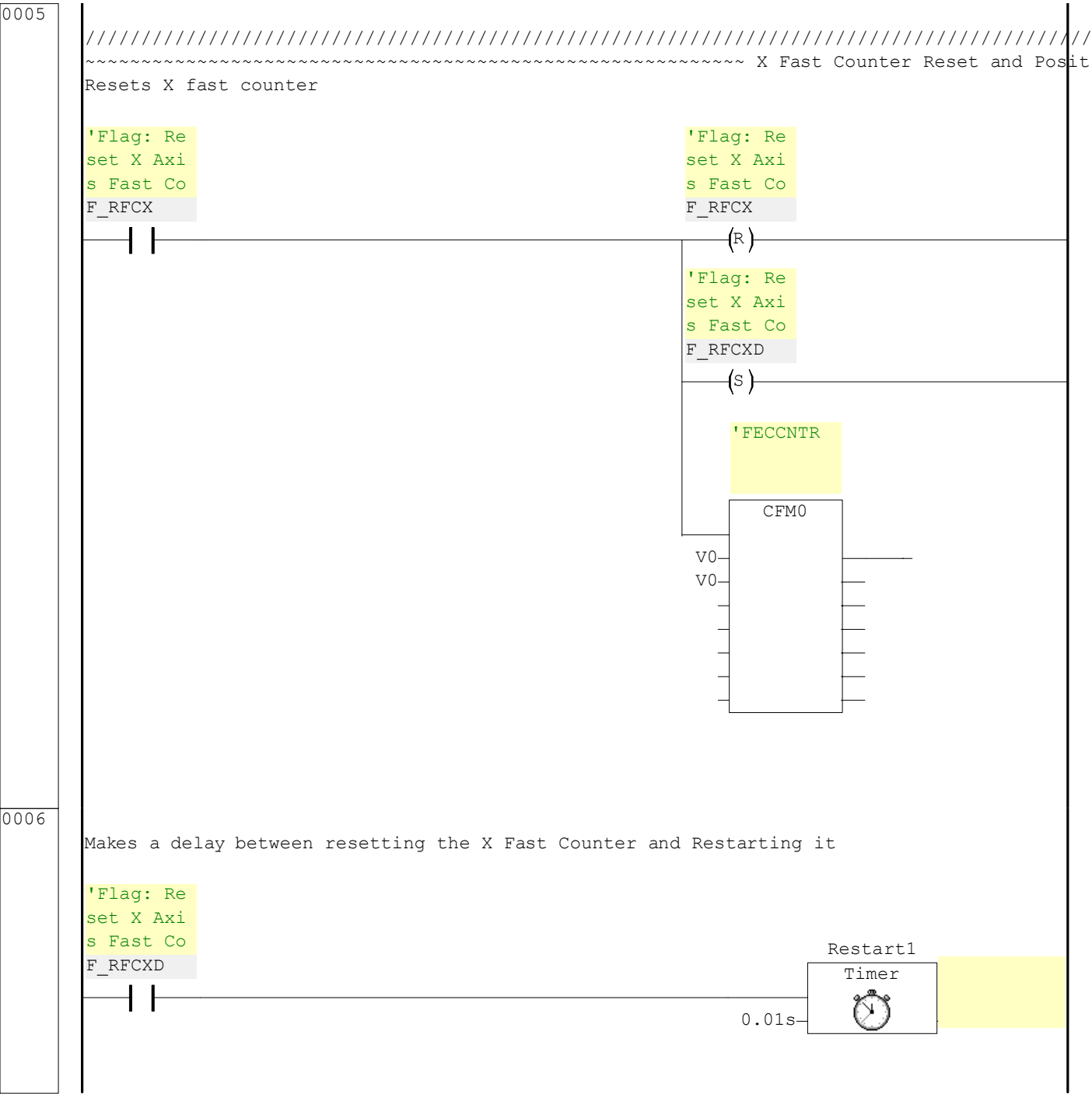


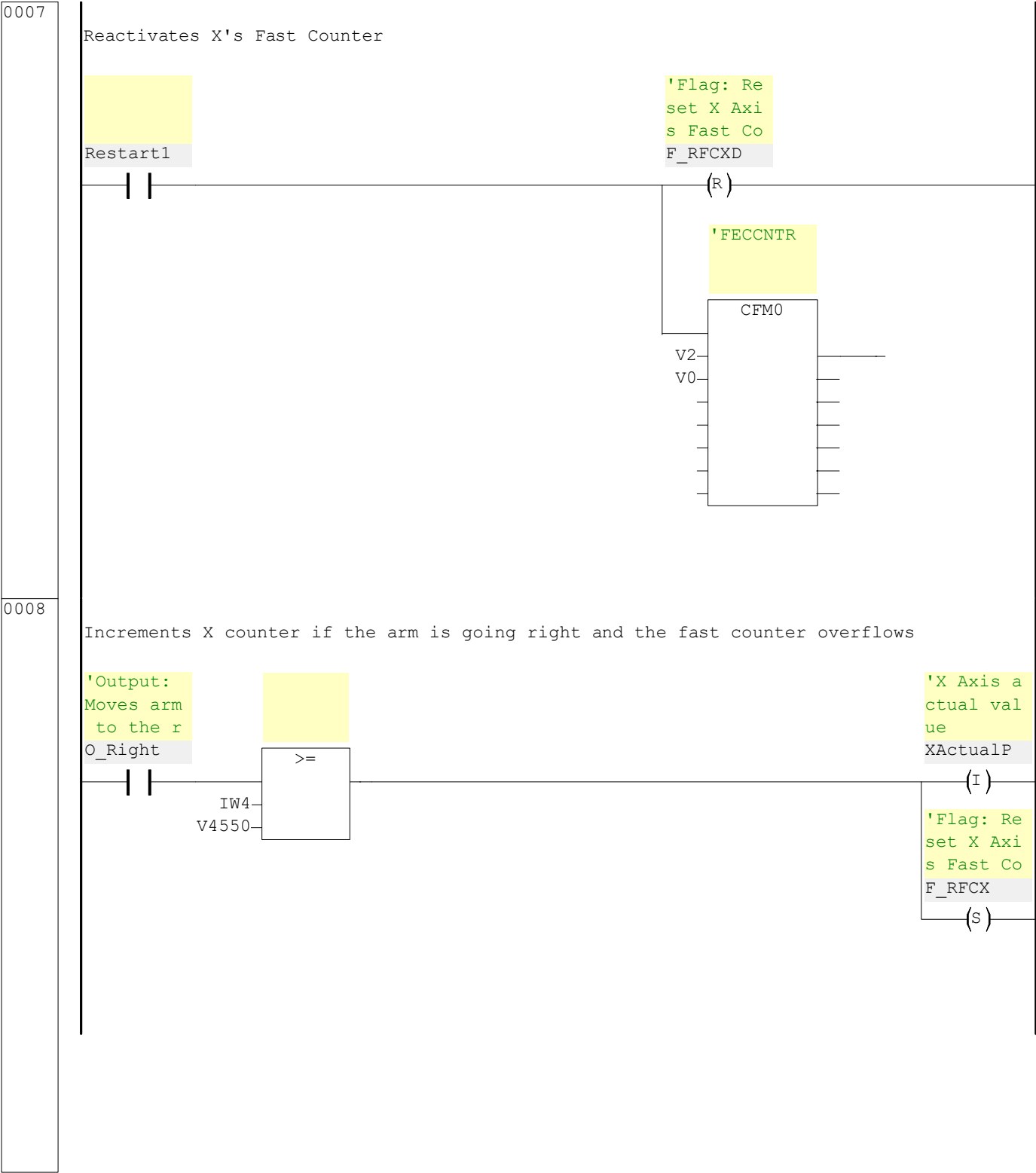


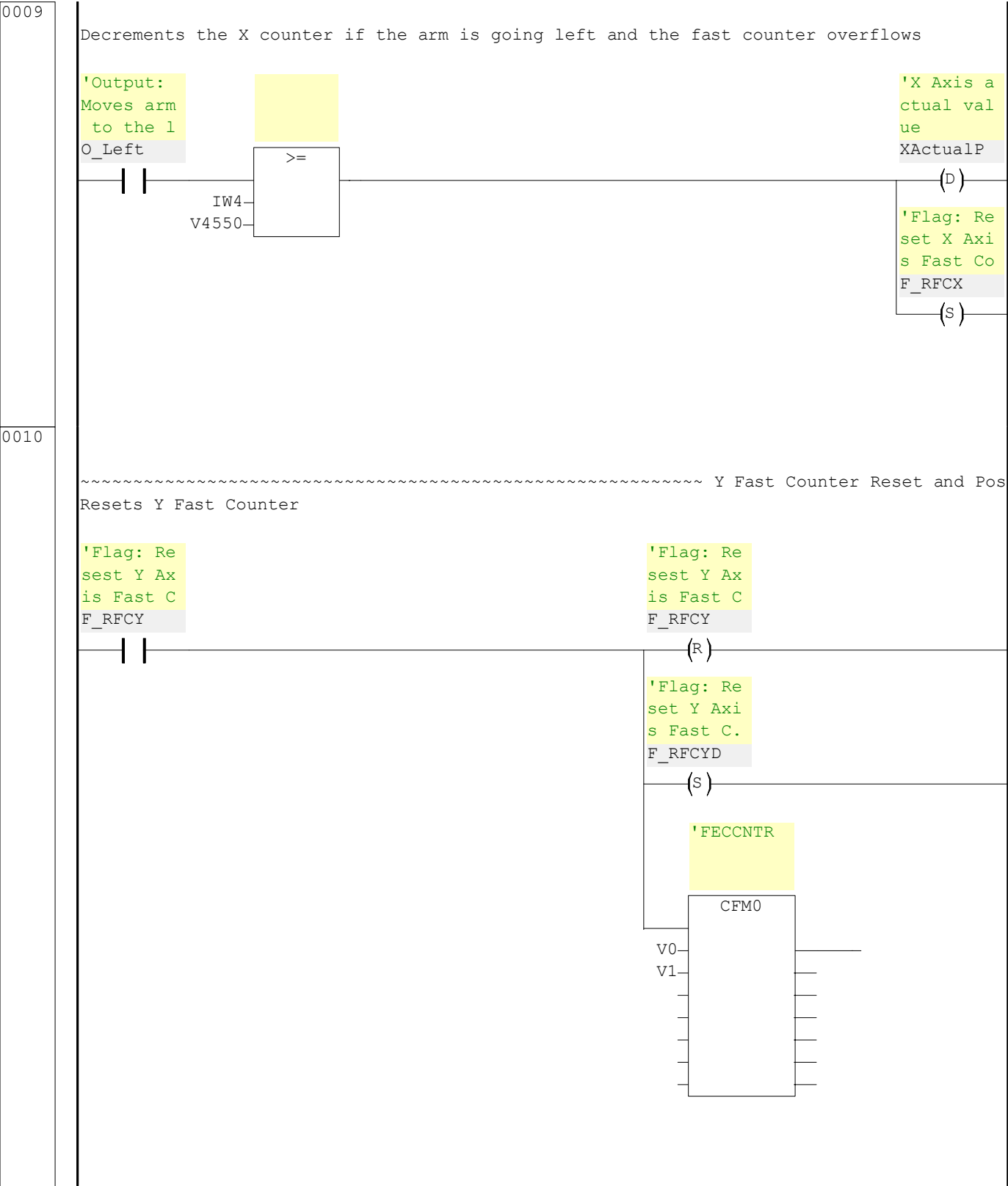


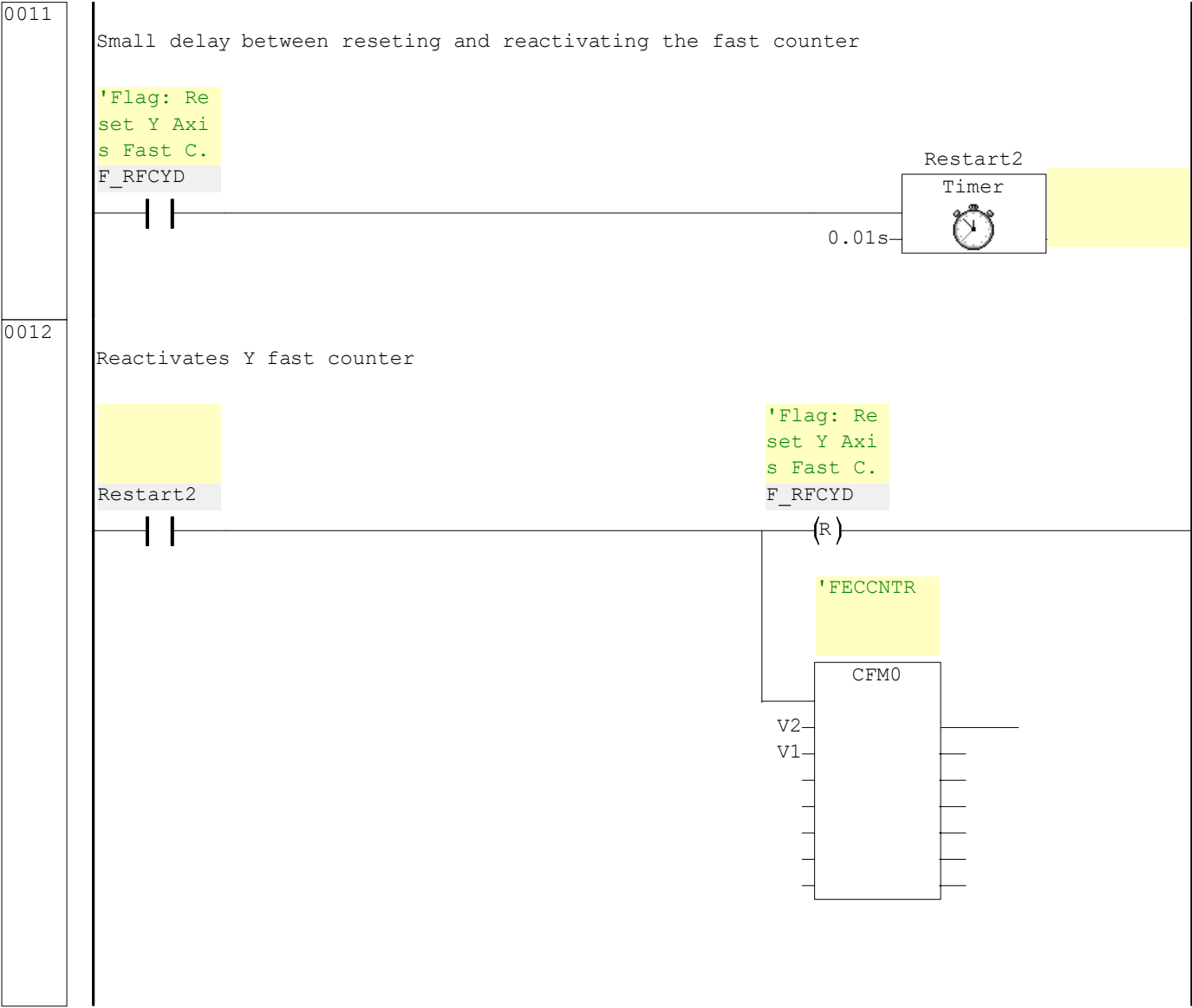


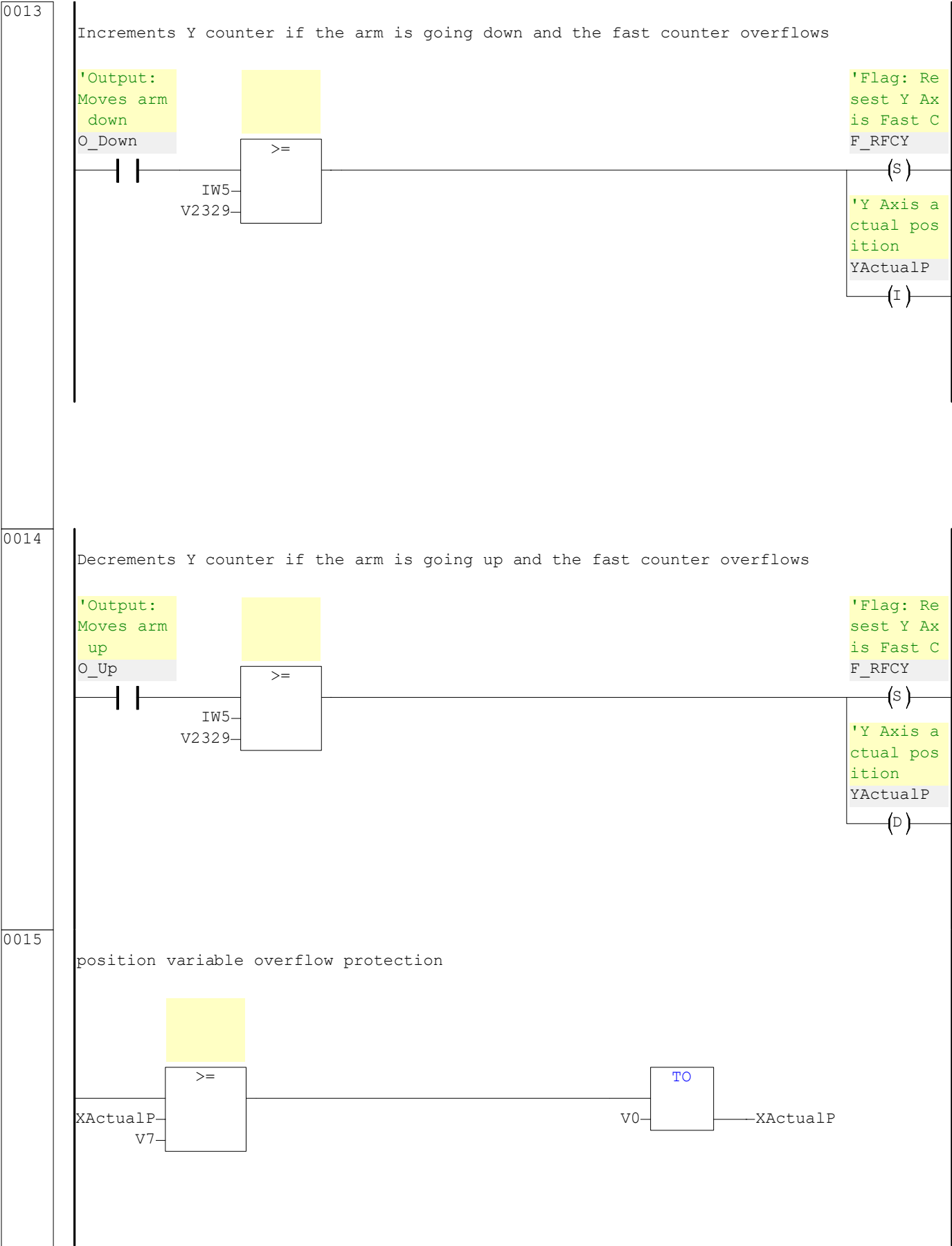
0001	//////////////////////////////////// Cuts-off movement up if the upper limit sensor is triggered 'Input: Y upper li mit I_ULimit 'Output: Moves arm up O_Up (R)
0002	Cuts-off movement left if the left limit sensor is triggered 'Input: X Leftlimit I_LLimit 'Output: Moves arm to the l O_Left (R)
0003	Cuts-off movement right if the right limit sensor is triggered 'Input: x Right Li mit I_RLimit 'Output: Moves arm to the r O_Right (R)
0004	Cuts-off movement down if the lower limit sensor is triggered 'Input: Y lower li mit I_DLimit 'Output: Moves arm down O_Down (R)

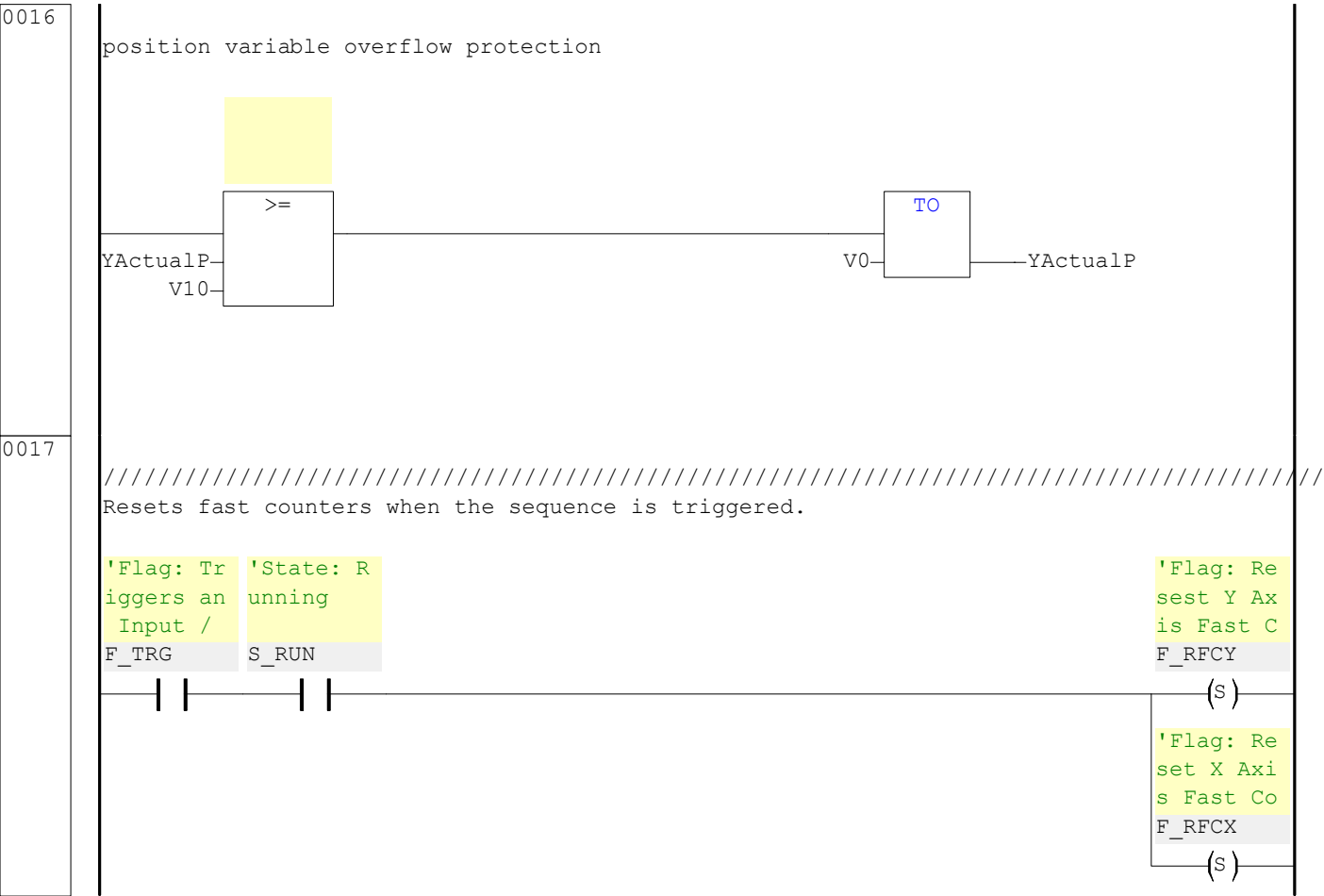


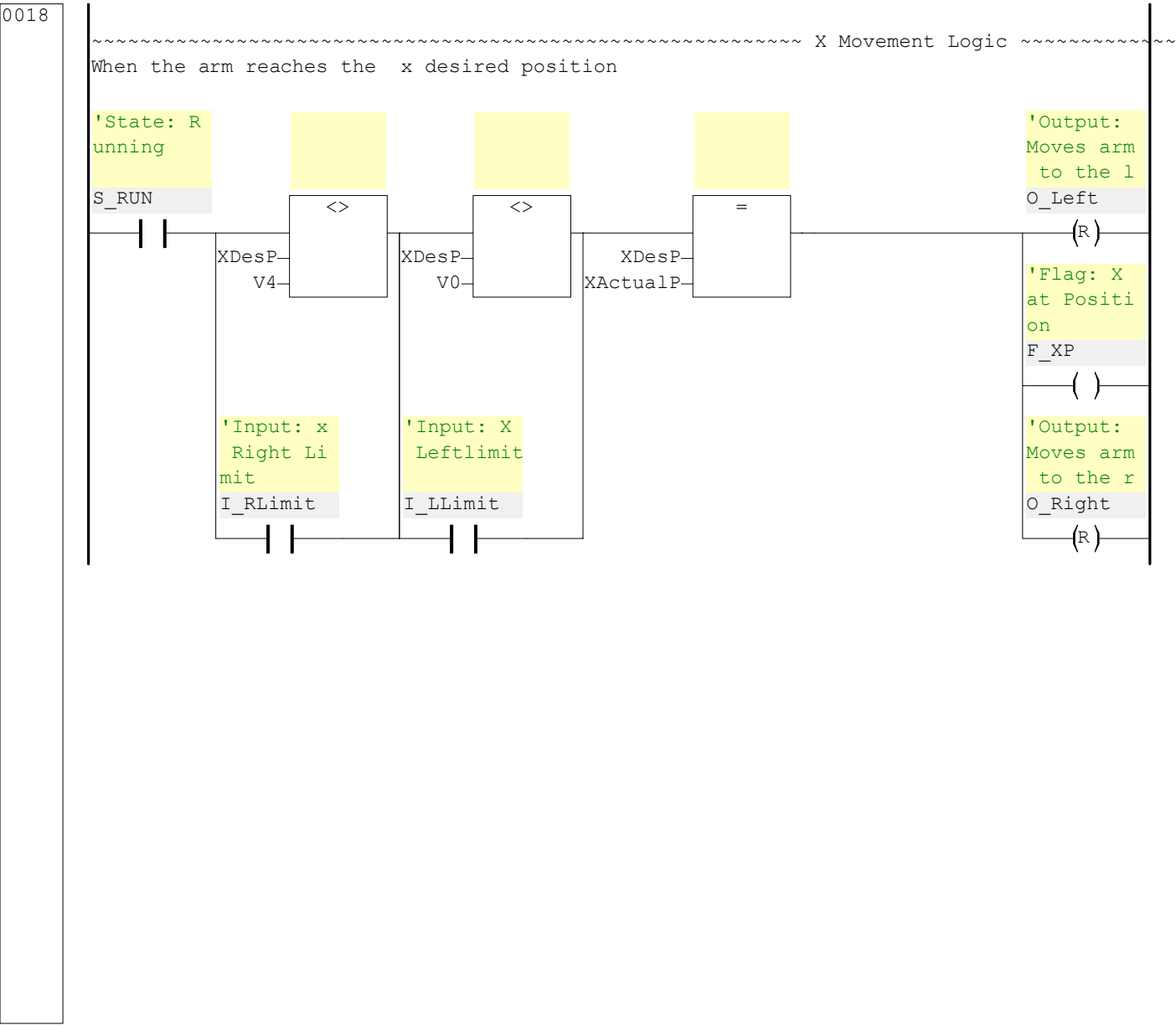


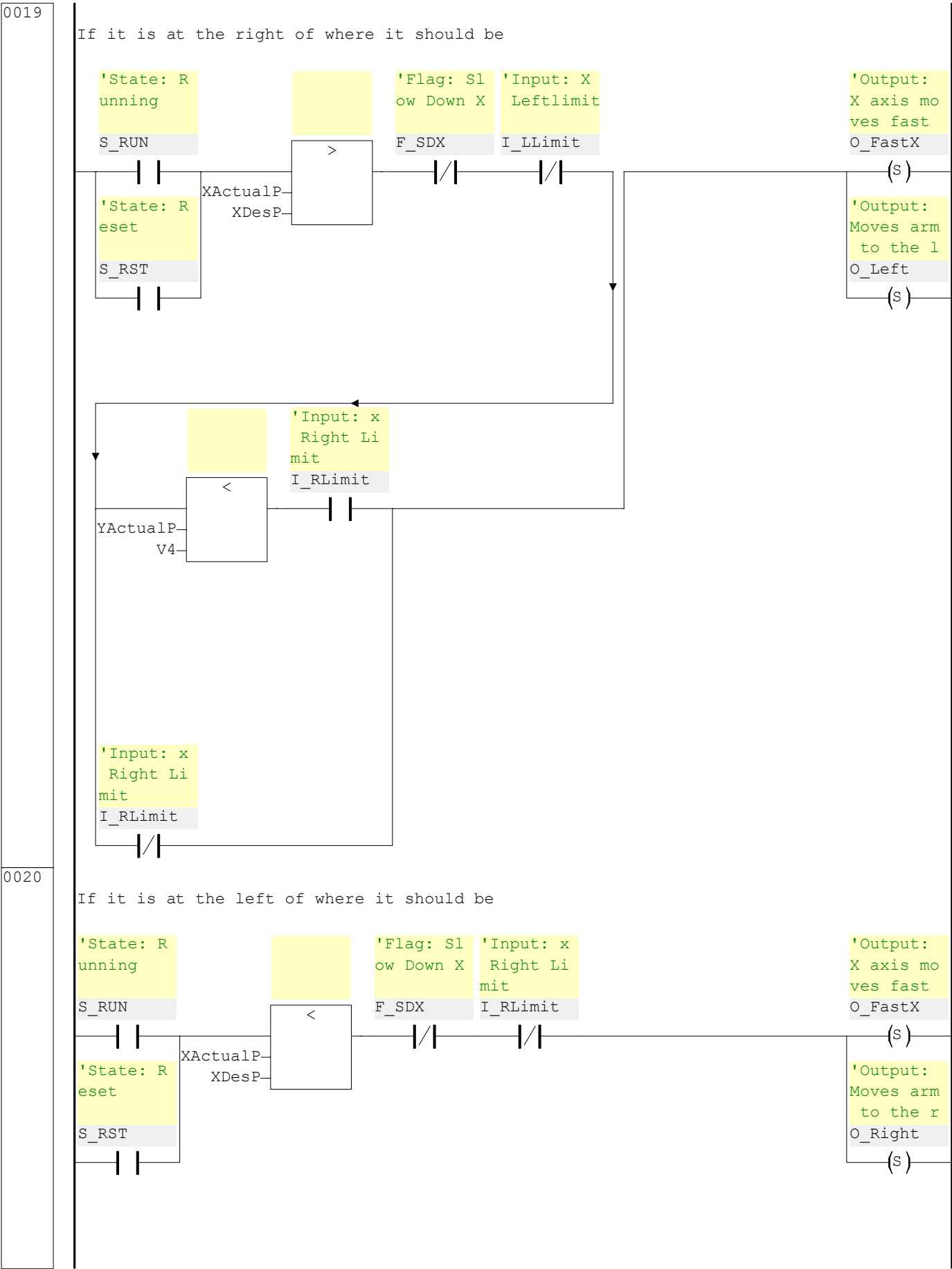


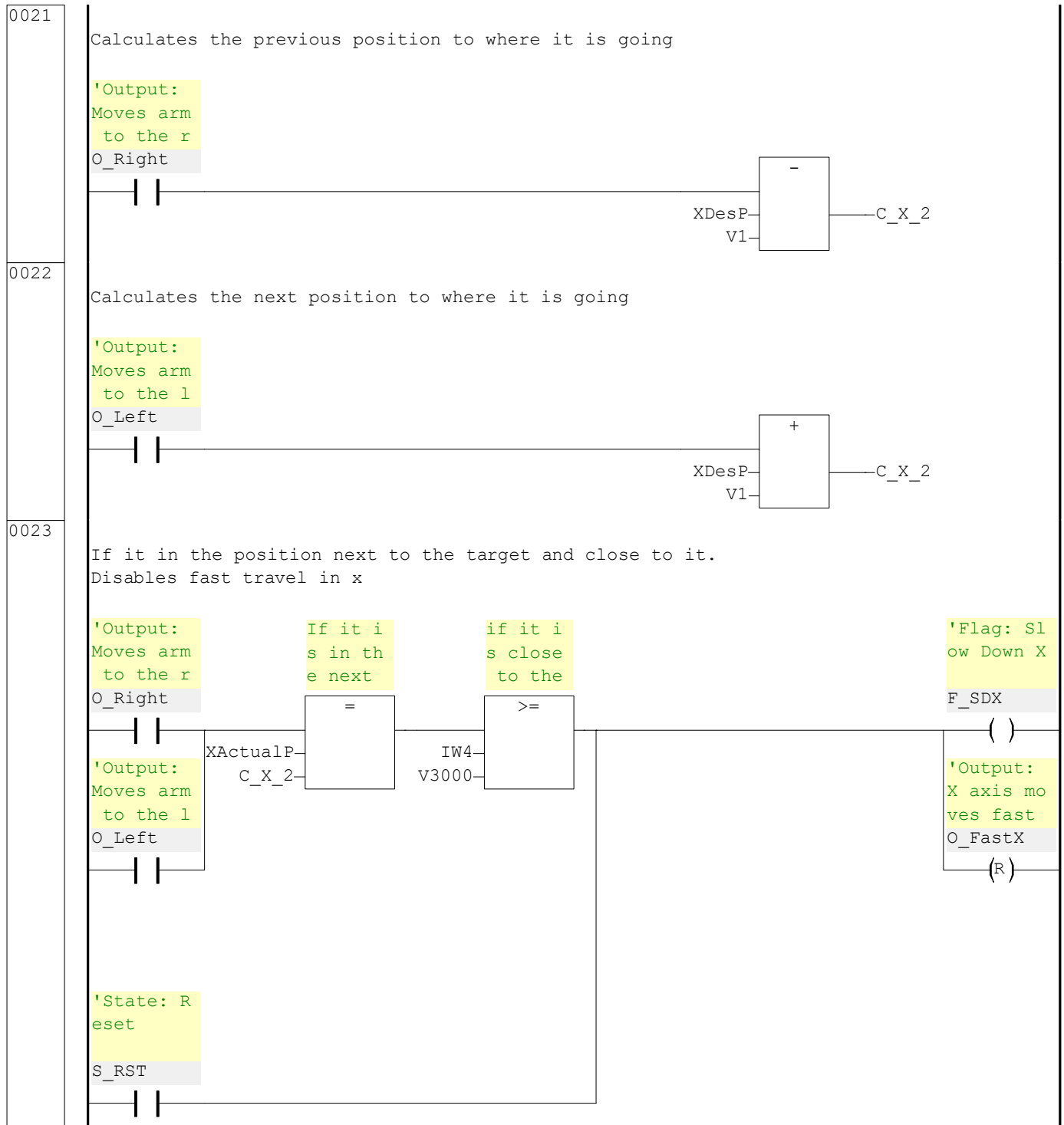


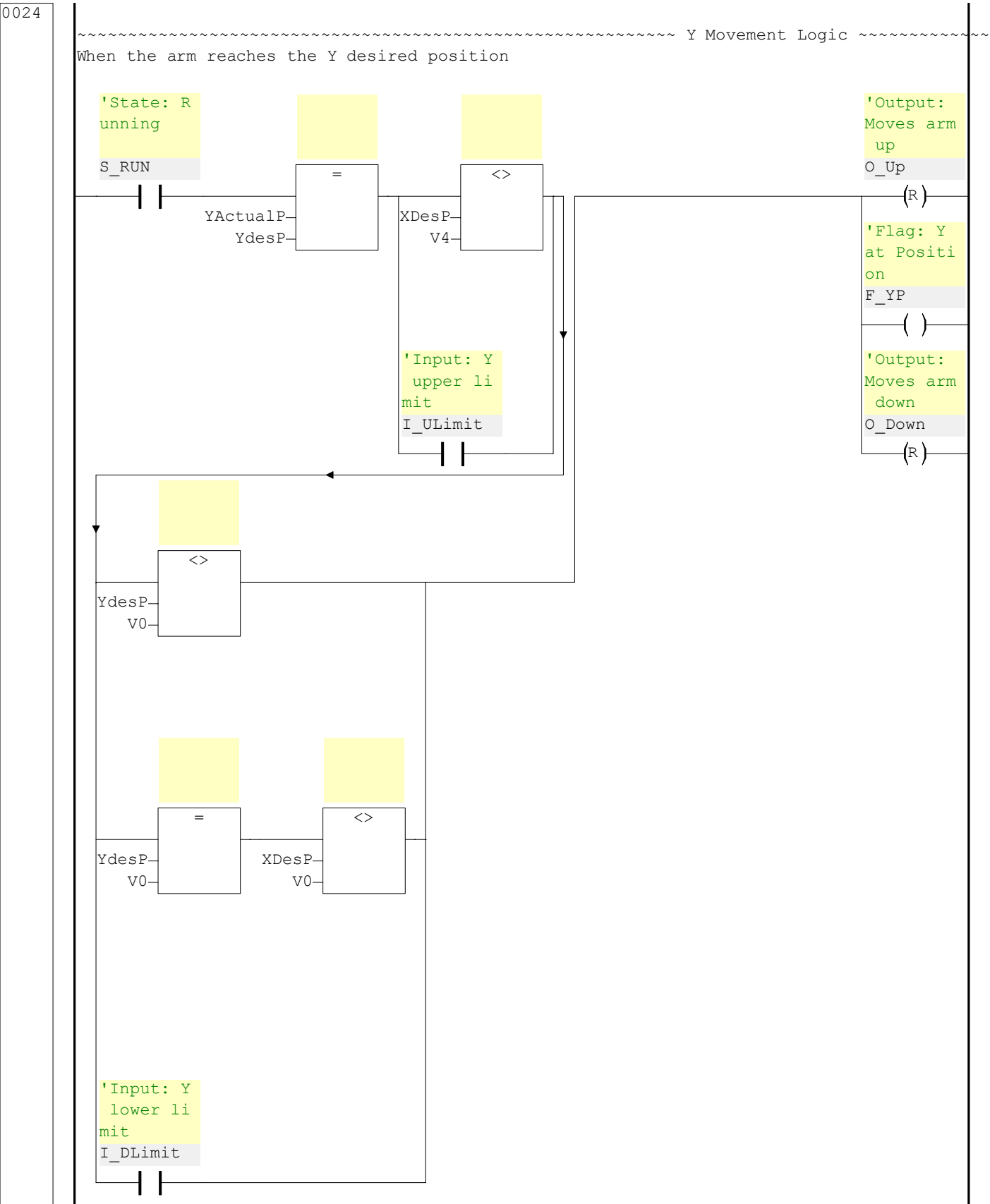


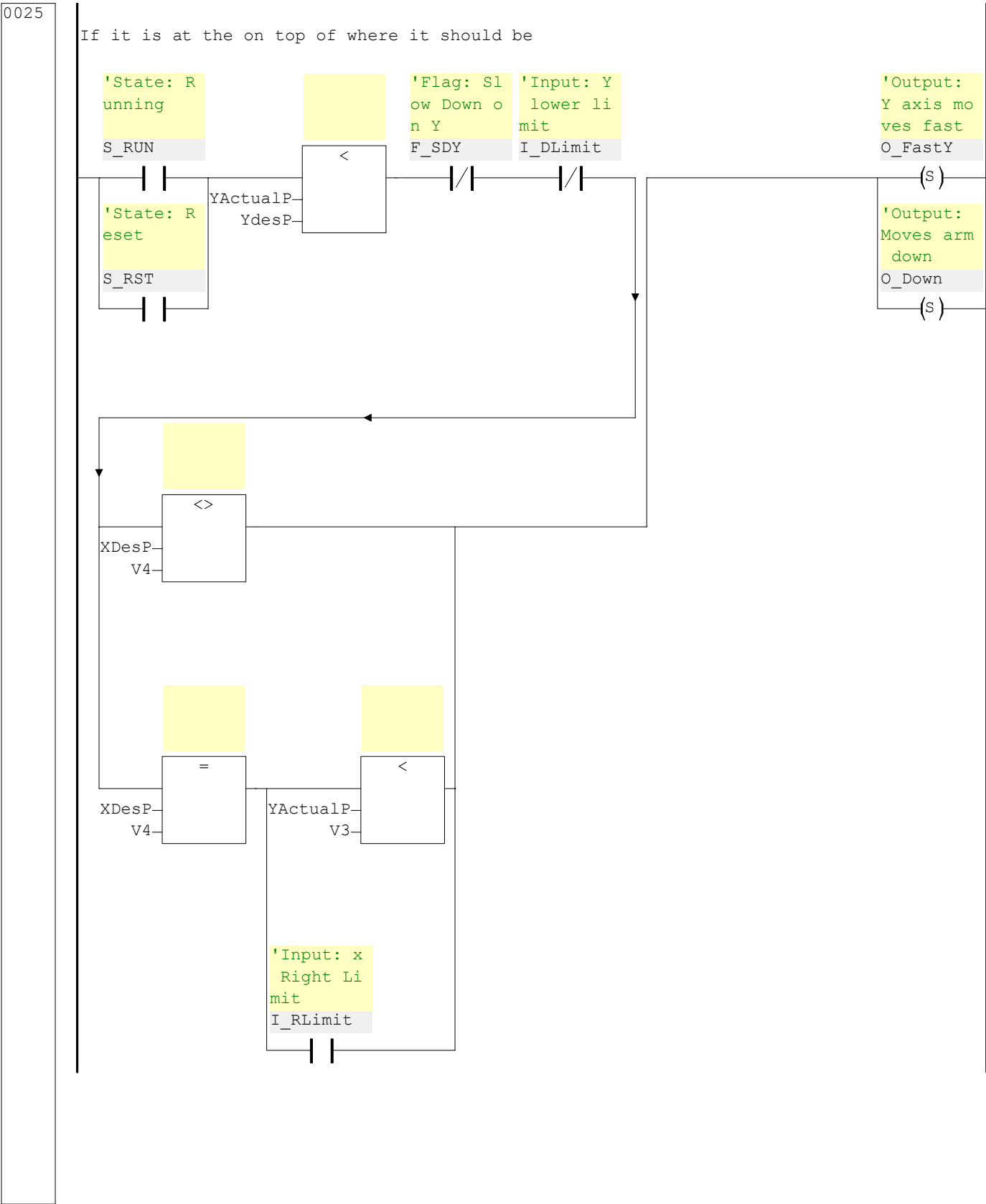


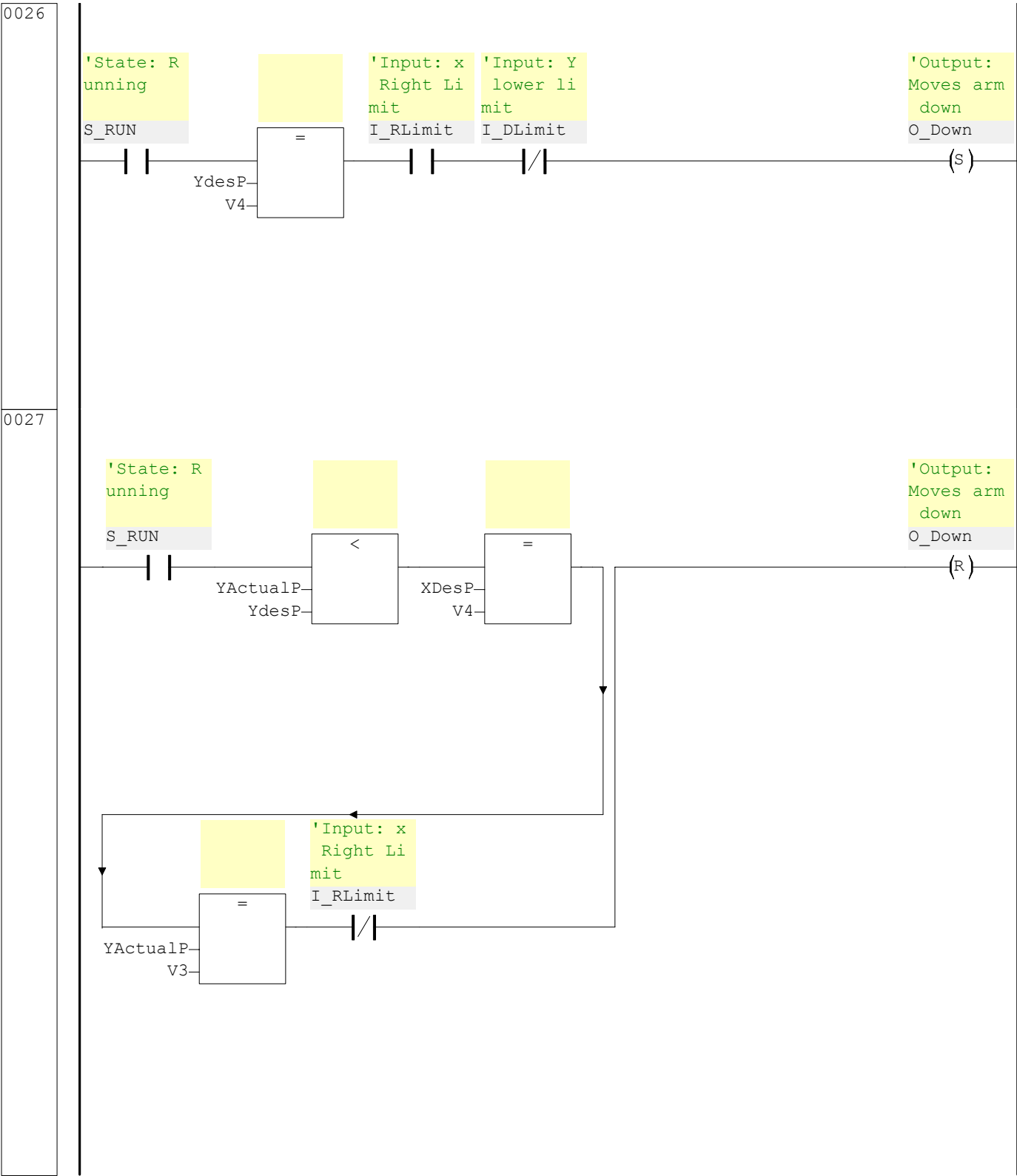


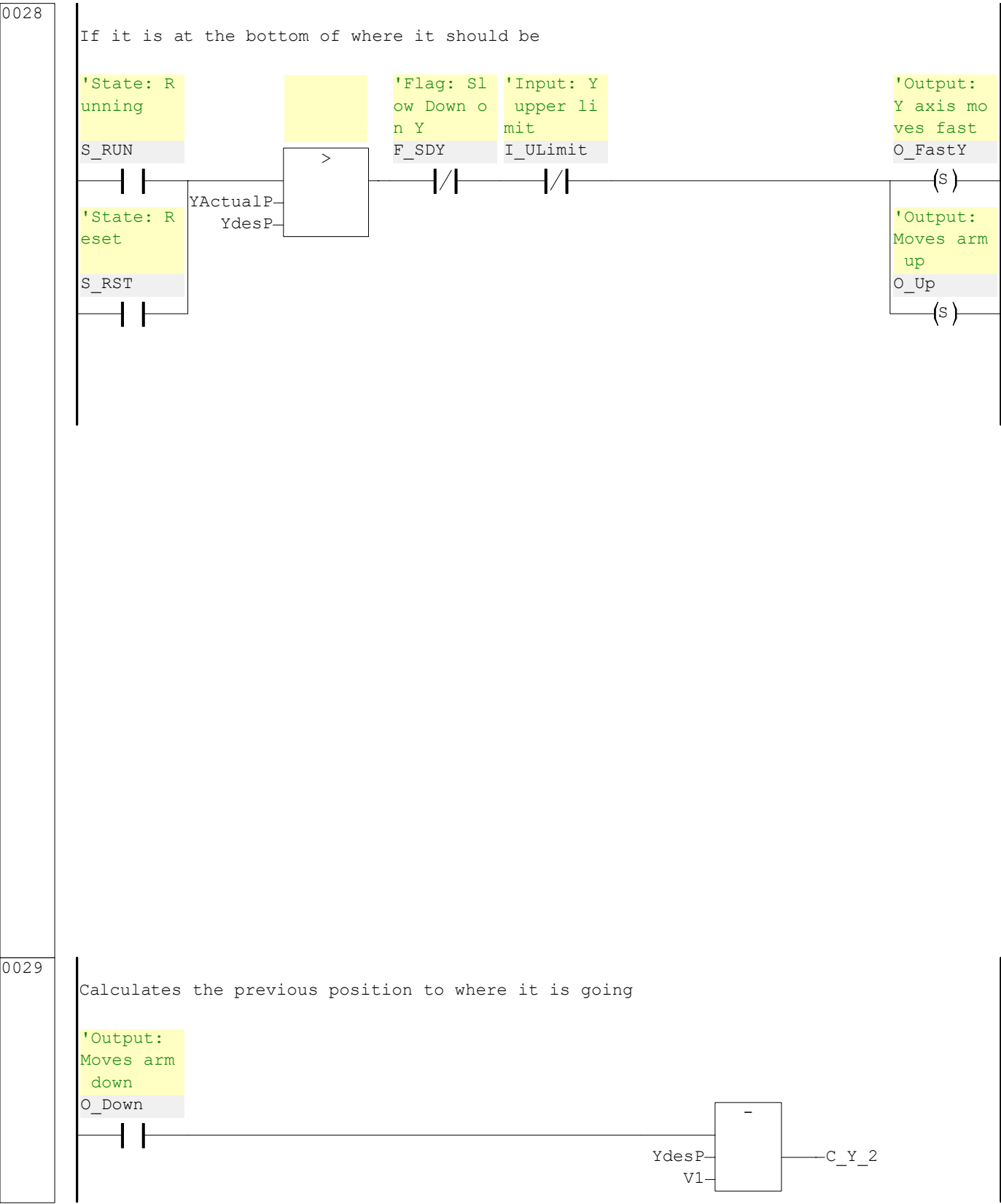


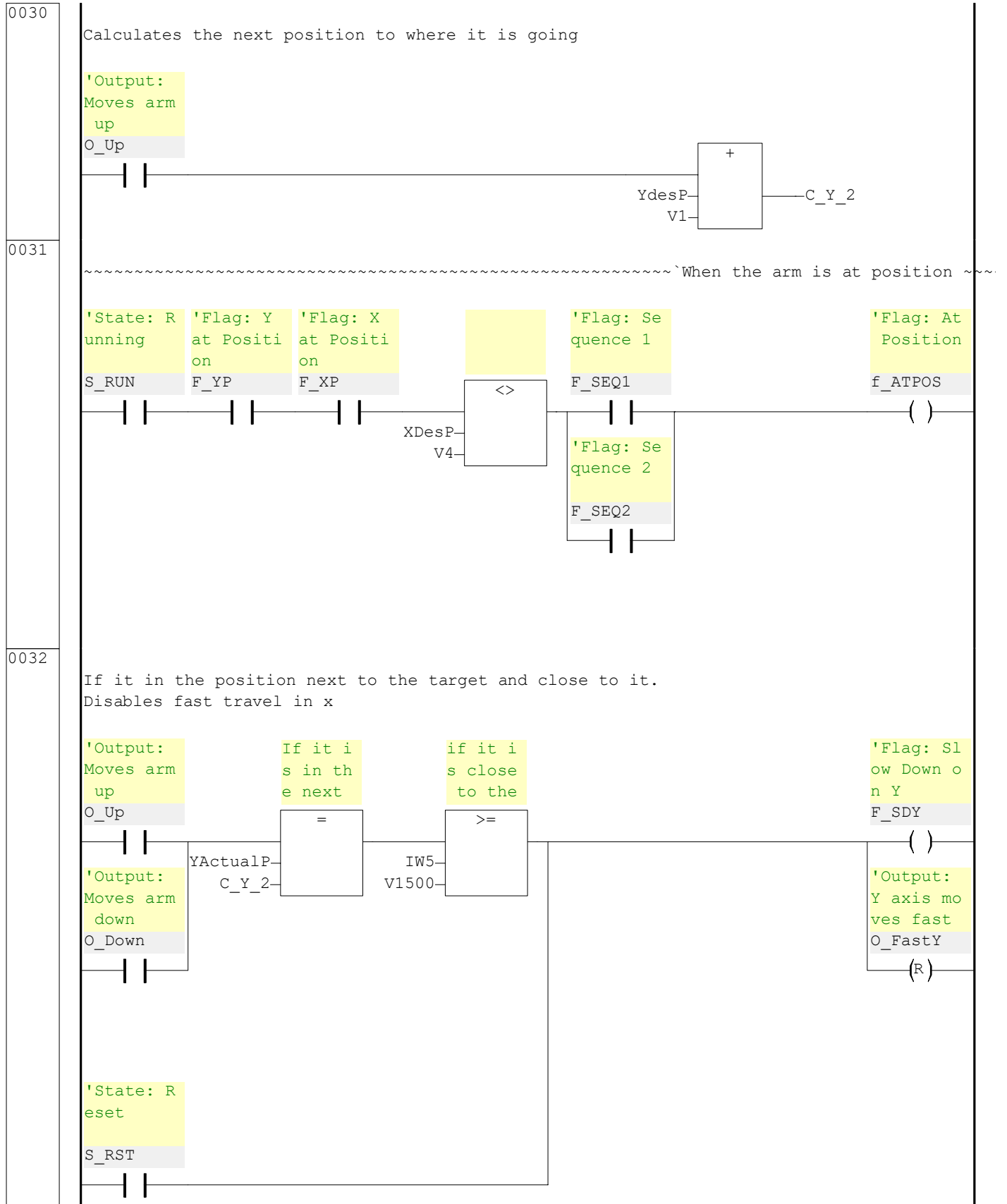


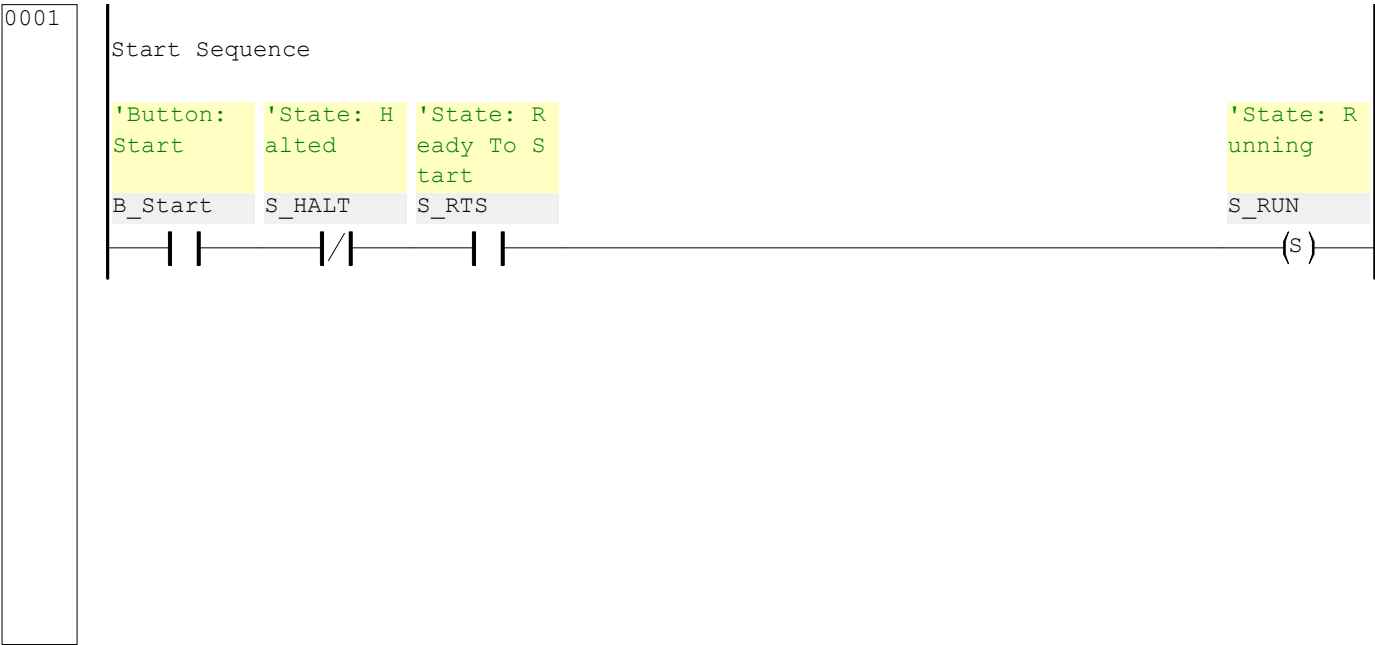


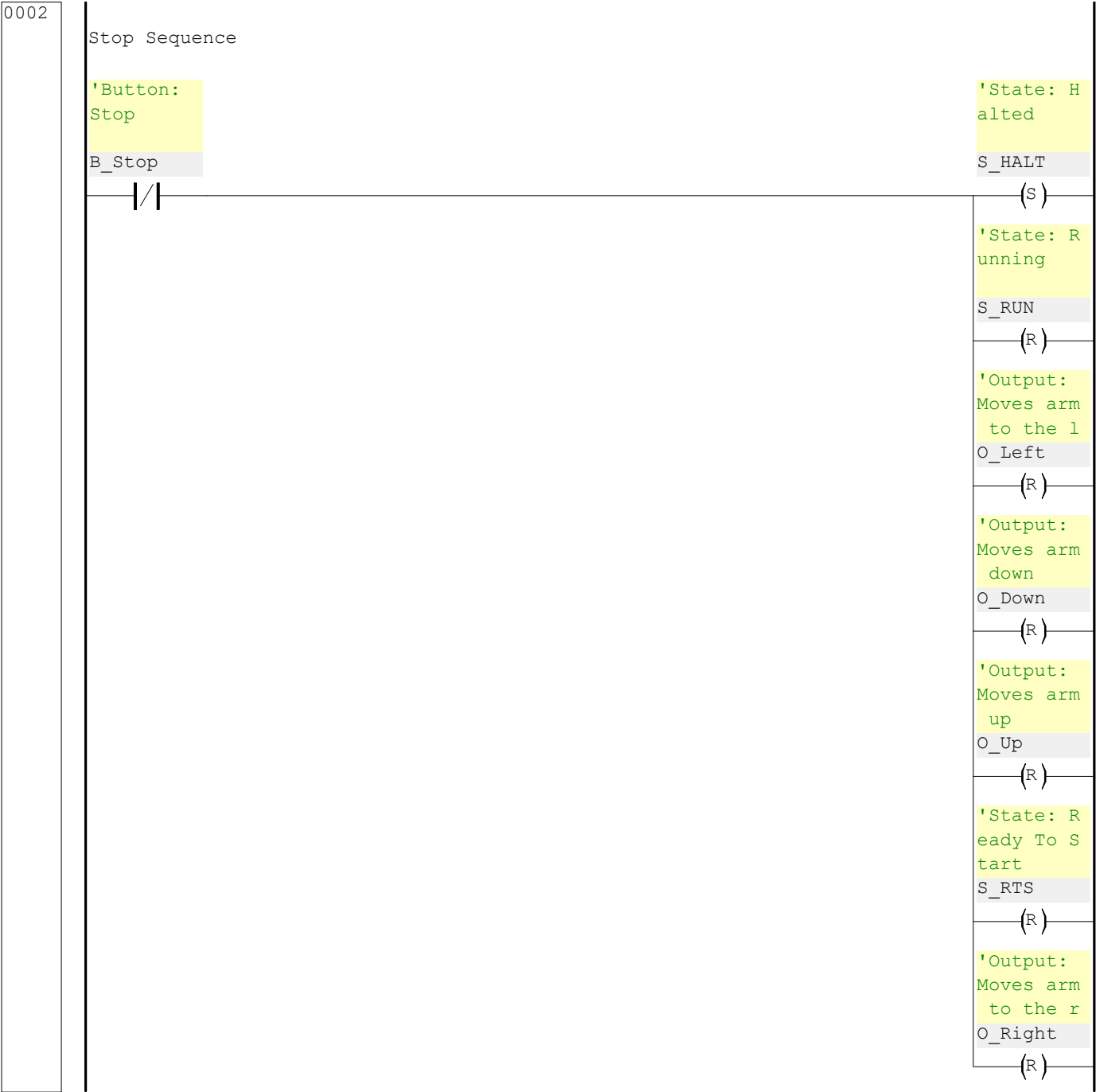


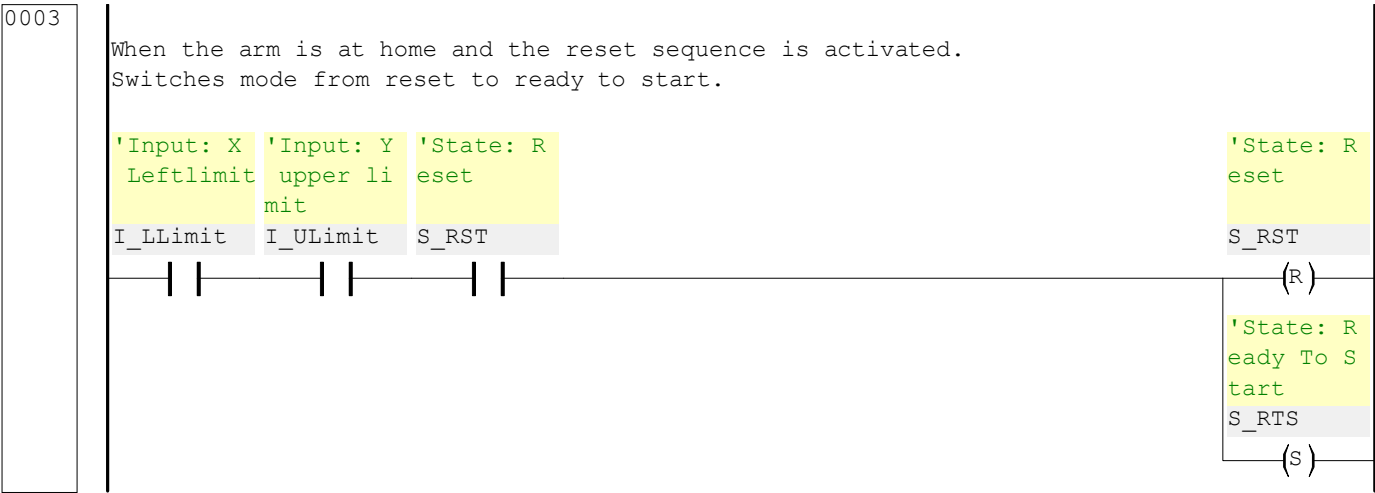












0004

Reset Sequence

'State: H
alted

S_HALT

'Button:
Reset

B_RST

'Flag: Se
quence Do
ne

F_SD

(R)

'Flag: At
Position

f_ATPOS

(R)

'State: R
eset

S_RST

(S)

'Output:a
rm extend
s and rea

O_Reach

(R)

'Output:
Gripper c
loses

O_Grab

(R)

'Flag: Go
to Origin

F_GTO

(S)

'Flag: Se
quence 2

F_SEQ2

(R)

'Flag: Se
quence 1

F_SEQ1

(R)

'State: H
alted

S_HALT

(R)

TO

V0-

c_store

