

Time stamp: 08/27/2015 01:25:51 PM
 Interface: 03/21/2012 01:30:36 PM
 Lengths (block/logic/data): 02100 01748 00030

| Name | Data Type | Address | Comment |
|-------------------|----------------------|---------|---|
| IN | | 0.0 | |
| IN | Bool | 0.0 | true=communicatie aan, false=communicatie uit |
| OUT | | 0.0 | |
| IN_OUT | | 0.0 | |
| TEMP | | 0.0 | |
| lok_kcpar | Array [0..1] Of Word | 0.0 | |
| tRET_VAL | Int | 4.0 | |
| tDB11_Send_ERROR1 | Bool | 6.0 | |
| tDB11_Send_ERROR2 | Bool | 6.1 | |
| tDB11_Send_ERROR3 | Bool | 6.2 | |
| tDB14_Send_ERROR1 | Bool | 6.3 | |
| tDB14_Send_ERROR2 | Bool | 6.4 | |
| tDB14_Send_ERROR3 | Bool | 6.5 | |
| tDB14_Send_ERROR4 | Bool | 6.6 | |
| tDB14_Send_ERROR5 | Bool | 6.7 | |
| tDB14_Send_ERROR6 | Bool | 7.0 | |
| tDB15_Send_ERROR1 | Bool | 7.1 | |
| tDB15_Send_ERROR2 | Bool | 7.2 | |
| tDB15_Send_ERROR3 | Bool | 7.3 | |
| tDB15_Send_ERROR4 | Bool | 7.4 | |
| tDB15_Send_ERROR5 | Bool | 7.5 | |
| RETURN | | 0.0 | |
| RET_VAL | | 0.0 | |

Block: FC20

Deze bouwsteen stuurt hetvolgende op verandering naar FactoryLink
 DB11 Status (bit)
 DB14 Meetbereik
 DB15 Grenswaarden

Network: 1 DB11

DB11 wordt vergeleken met DB 221

```

AN  #IN                                // DB11 ----- #IN          -- true=commun
                                         icatie aan, false=communicatie ui
                                         t

JC  end

A   "HM_S1_DB11_Send"                   M312.0
JC  SEND

// VERGELIJK DB11 EN DB 221
CALL "COMP_DB (FB13)"                   FC10
SRC_DB_1 :=11
SRC_DB_2 :=221
SRC LENGTE:=256                          // Lengte (WORDS) = 256
SRC_START :=0                            // Start adres (byte adres) = 0

```

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AN      "HM_S1_DB14_Send"          // Zenden DB 14 actief      M312.1
AN      "HM_S1_DB15_Send"          // Zenden DB 15 actief      M312.2
S        "HM_S1_DB11_Send"         // Zenden DB 11 actief      M312.0
JC      end

//Kopieer DB11 naar DB221
CALL    "BLKMOV"                   SFC20           -- Copy Variab
                                           les

SRCBLK :=P#DB11.DBX0.0 BYTE 512
RET_VAL:=#tRET_VAL                 #tRET_VAL
DSTBLK :=P#DB221.DBX0.0 BYTE 512

AN      "HM_S1_DB11_Send"          M312.0
JC      end

SEND: NOP 0
//Zend als DB11<>DB221
A        "HM_S1_DB11_Send_DONE1"   M313.0
JC      DEE2

CALL    "FL_SEND" , "iDB_FL_SEND"  FB7 / DB22
ACT     := "HM_S1_DB11_Send"        M312.0
ID      :=1
LADDR  :=W#16#100
S5     :=TRUE
SEND   :=P#DB11.DBX0.0 BYTE 200    // DBB 0 tm DBB 199
LEN    :=200
DONE   := "HM_S1_DB11_Send_DONE1"  M313.0
ERROR  :=#tDB11_Send_ERROR1        #tDB11_Send_ERROR1
STATUS:= "DB_COMMUNICATIE_INFO".S1_DB11_01
                                           DB201.DBW0     -- 8181=job bu
                                           sy

// tel unsol DB11-1
AN      "HM_S1_DB11_Send_DONE1"    M313.0
JC      DEE2
L        "DB-FLPRW".unsol_11_1     DB13.DBB8      -- Teller uns
                                           oll. DB11-1

L        1
+I
T        "DB-FLPRW".unsol_11_1     DB13.DBB8      -- Teller uns
                                           oll. DB11-1

DEE2: NOP 0

AN      "HM_S1_DB11_Send_DONE1"    M313.0
JC      end
A        "HM_S1_DB11_Send_DONE2"    M313.1
JC      DEE3

CALL    "FL_SEND" , "iDB_FL_SEND"  FB7 / DB22
ACT     := "HM_S1_DB11_Send"        M312.0
ID      :=1
LADDR  :=W#16#100
S5     :=TRUE
SEND   :=P#DB11.DBX200.0 BYTE 200   // DBB 200 tm DBB 399
LEN    :=200
DONE   := "HM_S1_DB11_Send_DONE2"  M313.1
ERROR  :=#tDB11_Send_ERROR2        #tDB11_Send_ERROR2
STATUS:= "DB_COMMUNICATIE_INFO".S1_DB11_02
                                           DB201.DBW2

// tel unsol DB11-2
AN      "HM_S1_DB11_Send_DONE2"    M313.1
JC      DEE3
L        "DB-FLPRW".unsol_11_2     DB13.DBB9      -- Teller uns
                                           oll. DB11-2

L        1
+I
T        "DB-FLPRW".unsol_11_2     DB13.DBB9      -- Teller uns
                                           oll. DB11-2

DEE3: NOP 0

AN      "HM_S1_DB11_Send_DONE2"    M313.1
JC      end

CALL    "FL_SEND" , "iDB_FL_SEND"  FB7 / DB22

```

DONE := "HM_S1_DB11_Send_DONE3"
ERROR := #tDB11_Send_ERROR3
STATUS := "DB_COMMUNICATIE_INFO".S1_DB11_03

M313.2
#tDB11_Send_ERROR3
DB201.DBW4

```
// tel unsol DB11-3
AN "HM_S1_DB11_Send_DONE3" M313.2
JC DEE4
L "DB-FLPRW".unsol_11_3 DB13.DBB10 -- Teller uns
oll. DB11-3
L 1
+I
T "DB-FLPRW".unsol_11_3 DB13.DBB10 -- Teller uns
oll. DB11-3

DEE4: A "HM_S1_DB11_Send_DONE3" M313.2
R "HM_S1_DB11_Send_DONE1" M313.0
R "HM_S1_DB11_Send_DONE2" M313.1
R "HM_S1_DB11_Send_DONE3" M313.2
R "HM_S1_DB11_Send" M312.0

L S5T#1S
SE "tSDB11" T61 -- Server blok
keer zenden DB11

end: NOP 0
```

| |
|-----------------------------------|
| Network: 2 DB14 |
| DB14 wordt vergeleken met DB 224. |

```
AN #IN // DB14 ----- #IN -- true=commun
icatie aan, false=communicatie ui
t
JC end2
A "HM_S1_DB14_Send" M312.1
JC SEN2
// VERGELIJK DB14 EN DB 224
CALL "COMP_DB (FB13)" FC10
SRC_DB_1 :=14
SRC_DB_2 :=224
SRC LENGTE:=91 // Lengte (WORDS) = 91
SRC_START :=0 // Start adres (byte adres) = 0
ONGELIJK := "S1"><DB14" M348.1 -- Server DB14
>< DB224
A "S1"><DB14" M348.1 -- Server DB14
>< DB224
//AN "tSDB11"
AN "HM_S1_DB11_Send" // Zenden DB 11 actief M312.0
AN "HM_S1_DB15_Send" // Zenden DB 15 actief M312.2
S "HM_S1_DB14_Send" // Zenden DB 14 actief M312.1
JCN end2
// Copy DB14 naar DB224
CALL "BLKMOV" SFC20 -- Copy Variab
les
SRCBLK :=P#DB14.DBX0.0 BYTE 182
RET_VAL:=#tRET_VAL #tRET_VAL
DSTBLK :=P#DB224.DBX0.0 BYTE 182
AN "HM_S1_DB14_Send" M312.1
JC end2
SEN2: NOP 0
// Zend als DB14 <> DB224
CALL "FL_SEND" , "iDB_FL_SEND" FB7 / DB22
ACT := "HM_S1_DB14_Send" M312.1
ID :=1
LADDR :=W#16#100
S5 :=TRUE
SEND :=P#DB14.DBX0.0 BYTE 182 // DBB 0 tm DBB 181
LEN :=182
DONE := "HM_S1_DB14_Send_DONE1" M314.0
ERROR :=#tDB14_Send_ERROR1 #tDB14_Send_ERROR1
STATUS := "DB_COMMUNICATIE_INFO".S1_DB14_01 DB201.DBW20
```

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+I
T      "DB-FLPRW".unsol_14                                DB13.DBB16      -- Teller uns
                                                    oll. DB14

R14:  A      "HM_S1_DB14_Send_DONE1"                      M314.0
      R      "HM_S1_DB14_Send_DONE1"                      M314.0
      R      "HM_S1_DB14_Send"                            M312.1

end2: NOP      0

Network: 3      DB15
DB 15 wordt vergeleken met DB 225.

AN      #IN                                                // DB15 ----- #IN      -- true=commun
                                                    icatie aan, false=communicatie ui
t

JC      end3

A      "HM_S1_DB15_Send"                                    M312.2
JC      SEN3

// VERGELIJK DB15 EN DB 225
CALL    "COMP_DB (FB13)"                                    FC10
SRC_DB_1 :=15
SRC_DB_2 :=225
SRC LENGTE:=171      // Lengte (WORDS) = 171
SRC_START :=0        // Start adres (byte adres) = 0
ONGELIJK := "S1><DB15"                                    M348.2      -- Server DB15
                                                    >< DB225

A      "S1><DB15"                                          M348.2      -- Server DB15
                                                    >< DB225

AN      "HM_S1_DB11_Send"      //Zenden DB 11 actief      M312.0
AN      "HM_S1_DB14_Send"      //Zenden DB 14 actief      M312.1
S      "HM_S1_DB15_Send"      M312.2
JCN      end3

// Copy DB15 naar DB225
CALL    "BLKMOV"      SFC20      -- Copy Variab
                                                    les

SRCBLK :=P#DB15.DBX0.0 BYTE 342
RET_VAL:=#tRET_VAL      #tRET_VAL
DSTBLK :=P#DB225.DBX0.0 BYTE 342

AN      "HM_S1_DB15_Send"                                    M312.2
JC      end3
SEN3: NOP      0

// Zend als DB15 <> DB225
A      "HM_S1_DB15_Send_DONE1"                              M315.0
JC      D152

CALL    "FL_SEND" , "iDB_FL_SEND"                          FB7 / DB22
ACT     := "HM_S1_DB15_Send"                                M312.2
ID      :=1
LADDR   :=W#16#100
S5      :=TRUE
SEND    :=P#DB15.DBX0.0 BYTE 200      // DBB 0 tm DBB 199
LEN     :=200
DONE    := "HM_S1_DB15_Send_DONE1"                          M315.0
ERROR   :=#tDB15_Send_ERROR1      #tDB15_Send_ERROR1
STATUS := "DB_COMMUNICATIE_INFO".S1_DB15_01      DB201.DBW40
D152: NOP      0

AN      "HM_S1_DB15_Send_DONE1"                              M315.0
JC      end3

CALL    "FL_SEND" , "iDB_FL_SEND"                          FB7 / DB22
ACT     := "HM_S1_DB15_Send"                                M312.2
ID      :=1
LADDR   :=W#16#100
S5      :=TRUE
SEND    :=P#DB15.DBX200.0 BYTE 142      // DBB 200 tm DBB 341
LEN     :=142
DONE    := "HM_S1_DB15_Send_DONE2"                          M315.1

```

```

L      "DB-FLPRW".unsol_15          DB13.DBB17          -- Teller uns
L      1
+I
T      "DB-FLPRW".unsol_15          DB13.DBB17          -- Teller uns
oll. DB15

R15:  A      "HM_S1_DB15_Send_DONE2" M315.1
      R      "HM_S1_DB15_Send_DONE1" M315.0
      R      "HM_S1_DB15_Send_DONE2" M315.1
      R      "HM_S1_DB15_Send"       M312.2

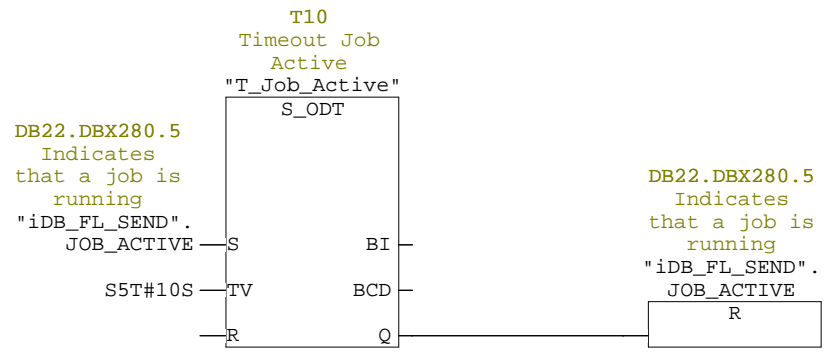
end3: NOP  0

```

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Network: 4      Reset running job
Timeout job active: reset job_active

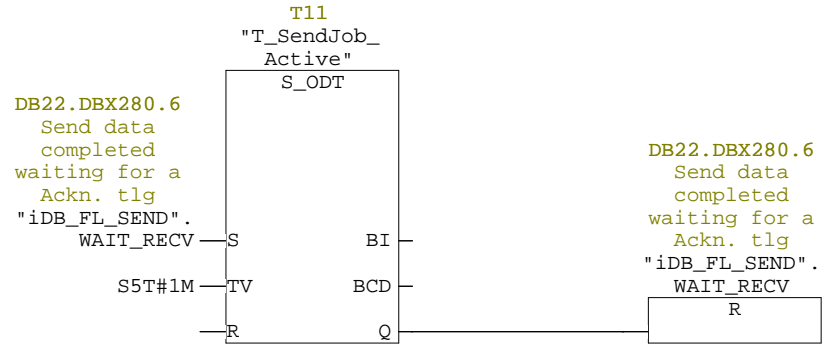
```



```

Network: 5      Reset running job
Timeout job active: reset job_active

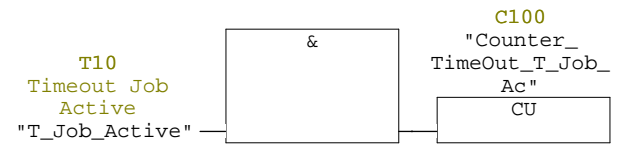
```



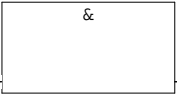
```

Network: 6

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T11
"T_SendJob_
Active"



CU1
"Counter_
TimeOut_T_SJ_
Act"
CU