












-  Controller Controller1
-  Controller Fault Handler
-  Power-Up Handler

Tasks

-  MainTask
 -  MainProgram
 -  MainRoutine
 -  initial
 -  manual
-  SafetyTask
 -  SafetyProgram
 -  MainRoutine

Unscheduled Programs / Phases





















Motion Groups

-  MotionGroup1
 -  OsaX
 -  OsaY
 -  OsaZ

Ungrouped Axes
















Add-On Instructions

Data Types

-  User-Defined
 -  Osa_control
-  Strings
 -  STRING
-  Add-On-Defined
-  Module-Defined
 -  AB:1756_DI:C:0
 -  AB:1756_DNB_496Bytes:O:0
 -  AB:1756_DNB_500Bytes:I:0
 -  AB:1756_DNB_CommandRegister:O:0
 -  AB:1756_DNB_StatusRegister:I:0
 -  AB:1756_DNB_Status_128Bytes:S:0
 -  AB:1756_DO:C:0
 -  AB:1756_ENET_10SLOT:I:0
 -  AB:1756_ENET_10SLOT:O:0
 -  AB:1756_ENET_SLOT:I:0
 -  AB:1756_ENET_SLOT:O:0
 -  AB:1791DS_IB8XOB8_Safety1:I:0
 -  AB:1791DS_IB8XOB8_Safety1:O:0
 -  AB:1791DS_IB8XOB8_Safety3:I:0

Trends

I/O Configuration

-  1756 Backplane, 1756-A10
 -  [0] 1756-L62S Controler1
 -  [1] 1756-LSP Controler1:Partner
 -  [2] 1756-ENBT/A ETHERNET
 -  Ethernet
 -  1756-ENBT/A ETHERNET
 -  1756-ENBT/A ethernet2
 -  1756 Backplane, 1756-A10
 -  [3] 1756-ENBT/A ethernet2
 -  [6] 1756-IB16 DInput
 -  [7] 1756-OB16D Output
-  [3] 1756-DNB DeviceNet
 -  DeviceNet
 -  13 1791DS-IB8XOB8/A Safety_module
 -  63 1756-DNB DeviceNet



[6] 1756-M08SE Kinetix_com



SERCOS Network


















11 2093-AC05-MP5 osaX






























13 2093-AMP5 OsaY







































14 2093-AMP5 OsaZ


















Name	Value	Data Type	Scope
 group_MI_MGSR <i>group_MI_MGSR - MainProgram/MainRoutine - *11(MGSR)</i>		MOTION_INSTRUCTION	Controler1
 group_reset <i>group_reset - MainProgram/MainRoutine - 11(XIC)</i>	0	BOOL	Controler1
 initial <i>initial - MainProgram/initial - *4(OTU), 0(XIC), 1(XIC), 2(XIC), 3(XIC), 4(XIC), 5(XIC)</i> <i>initial - MainProgram/MainRoutine - *0(OTL), 1(XIC), 12(XIO), 22(XIO), 3(XIC), 32(XIO), 4(XIO)</i>	0	BOOL	Controler1
 initial_acum <i>initial_acum - MainProgram/MainRoutine - *1(DIV)</i>	0	DINT	Controler1
 initial_pom <i>initial_pom - MainProgram/initial - *4(OTU), 0(XIC)</i> <i>initial_pom - MainProgram/MainRoutine - *2(OTL), 1(XIO), 3(XIC), 4(XIO)</i>	0	BOOL	Controler1
 initial_start <i>initial_start - MainProgram/MainRoutine - 2(XIC)</i>	0	BOOL	Controler1
 initial_timer <i>initial_timer - MainProgram/MainRoutine - *1(TON), *2(RES)</i> <i>initial_timer.ACC - MainProgram/MainRoutine - 1(DIV)</i>		TIMER	Controler1
 MAS1 <i>MAS1 - MainProgram/MainRoutine - *12(MAS)</i>		MOTION_INSTRUCTION	Controler1
 MAS2 <i>MAS2 - MainProgram/MainRoutine - *22(MAS)</i>		MOTION_INSTRUCTION	Controler1
 MAS3 <i>MAS3 - MainProgram/MainRoutine - *32(MAS)</i>		MOTION_INSTRUCTION	Controler1
 MASR1 <i>MASR1 - MainProgram/initial - *0(MASR)</i> <i>MASR1.DN - MainProgram/initial - 1(XIC)</i>		MOTION_INSTRUCTION	Controler1
 MASR2 <i>MASR2 - MainProgram/initial - *0(MASR)</i> <i>MASR2.DN - MainProgram/initial - 1(XIC)</i>		MOTION_INSTRUCTION	Controler1
 MASR3 <i>MASR3 - MainProgram/initial - *0(MASR)</i> <i>MASR3.DN - MainProgram/initial - 1(XIC)</i>		MOTION_INSTRUCTION	Controler1
 MotionGroup1 <i>MotionGroup1 - MainProgram/MainRoutine - 11(MGSR)</i>		MOTION_GROUP	Controler1
 OsaX <i>OsaX - MainProgram/initial - 0(MASR), 1(MSO), 2(MAH), 3(MSF)</i> <i>OsaX - MainProgram/MainRoutine - *14(SSV), *20(SSV), 12(GSV), 12(MAS), 15(MASR), 16(MSO), 17(MAJ), 18(MAJ), 19(MAS), 5(MASR), 6(MAFR)</i> <i>OsaX - MainProgram/manual - 0(MSO), 1(MAH), 2(MSO), 3(MAJ), 4(MAJ), 5(MAS), 6(MSF)</i> <i>OsaX.AxisFault - MainProgram/MainRoutine - 42(NEQ)</i> <i>OsaX.DriveEnableStatus - MainProgram/initial - 2(XIC), 3(XIC)</i> <i>OsaX.DriveEnableStatus - MainProgram/MainRoutine - 42(XIC)</i> <i>OsaX.DriveFault - MainProgram/MainRoutine - 42(NEQ)</i> <i>OsaX.DriveOvertempFault - MainProgram/MainRoutine - 42(XIC)</i> <i>OsaX.DriveStatus - MainProgram/MainRoutine - 2(NEQ)</i> <i>OsaX.FeedbackFault - MainProgram/MainRoutine - 42(XIC)</i> <i>OsaX.ModuleFaults - MainProgram/MainRoutine - 42(NEQ)</i> <i>OsaX.MotorOvertempFault - MainProgram/MainRoutine - 42(XIC)</i> <i>OsaX.NegHardOvertravelFault - MainProgram/MainRoutine - 42(XIC)</i> <i>OsaX.NegSoftOvertravelFault - MainProgram/MainRoutine - 12(XIC), 13(XIC), 16(XIO), 42(XIC)</i> <i>OsaX.NegSoftOvertravelFault - MainProgram/manual - 5(XIO)</i> <i>OsaX.PosHardOvertravelFault - MainProgram/MainRoutine - 42(XIC)</i> <i>OsaX.PosSoftOvertravelFault - MainProgram/MainRoutine - 12(XIC), 13(XIC), 16(XIO), 42(XIC)</i>		AXIS_SERVO_DRIVE	Controler1



















OsaX (Continued)			
<i>OsaX.PosSoftOvertravelFault - MainProgram/manual - 5(XIO)</i>			
<i>OsaX.SERCOSFault - MainProgram/MainRoutine - 42(XIC)</i>			
 OsaY	0	AXIS_SERVO_DRIVE	Controler1
<i>OsaY - MainProgram/initial - 0(MASR), 1(MSO), 2(MAH), 3(MSF)</i>			
<i>OsaY - MainProgram/MainRoutine - *24(SSV), *30(SSV), 22(GSV), 22(MAS), 25(MASR), 26(MSO), 27(MAJ), 28(MAJ), 29(MAS), 7(MASR), 8(MAFR)</i>			
<i>OsaY - MainProgram/manual - 10(MAJ), 11(MAJ), 12(MAS), 13(MSF), 7(MSO), 8(MAH), 9(MSO)</i>			
<i>OsaY.AxisFault - MainProgram/MainRoutine - 43(NEQ)</i>			
<i>OsaY.DriveEnableStatus - MainProgram/initial - 2(XIC), 3(XIC)</i>			
<i>OsaY.DriveEnableStatus - MainProgram/MainRoutine - 43(XIC)</i>			
<i>OsaY.DriveFault - MainProgram/MainRoutine - 43(NEQ)</i>			
<i>OsaY.DriveOvertempFault - MainProgram/MainRoutine - 43(XIC)</i>			
<i>OsaY.DriveStatus - MainProgram/MainRoutine - 2(NEQ)</i>			
<i>OsaY.FeedbackFault - MainProgram/MainRoutine - 43(XIC)</i>			
<i>OsaY.ModuleFaults - MainProgram/MainRoutine - 43(NEQ)</i>			
<i>OsaY.MotorOvertempFault - MainProgram/MainRoutine - 43(XIC)</i>			
<i>OsaY.NegHardOvertravelFault - MainProgram/MainRoutine - 43(XIC)</i>			
<i>OsaY.NegSoftOvertravelFault - MainProgram/MainRoutine - 22(XIC), 23(XIC), 26(XIO), 43(XIC)</i>			
<i>OsaY.PosHardOvertravelFault - MainProgram/MainRoutine - 43(XIC)</i>			
<i>OsaY.PosSoftOvertravelFault - MainProgram/MainRoutine - 22(XIC), 23(XIC), 26(XIO), 43(XIC)</i>			
<i>OsaY.SERCOSFault - MainProgram/MainRoutine - 43(XIC)</i>			
 OsaZ	0	AXIS_SERVO_DRIVE	Controler1
<i>OsaZ - MainProgram/initial - 0(MASR), 1(MSO), 2(MAH), 3(MSF)</i>			
<i>OsaZ - MainProgram/MainRoutine - *34(SSV), *40(SSV), 10(MAFR), 32(GSV), 32(MAS), 35(MASR), 36(MSO), 37(MAJ), 38(MAJ), 39(MAS), 9(MASR)</i>			
<i>OsaZ - MainProgram/manual - 14(MSO), 15(MAH), 16(MSO), 17(MAJ), 18(MAJ), 19(MAS), 20(MSF)</i>			
<i>OsaZ.AxisFault - MainProgram/MainRoutine - 44(NEQ)</i>			
<i>OsaZ.DriveEnableStatus - MainProgram/initial - 2(XIC), 3(XIC)</i>			
<i>OsaZ.DriveEnableStatus - MainProgram/MainRoutine - 44(XIC)</i>			
<i>OsaZ.DriveFault - MainProgram/MainRoutine - 44(NEQ)</i>			
<i>OsaZ.DriveOvertempFault - MainProgram/MainRoutine - 44(XIC)</i>			
<i>OsaZ.DriveStatus - MainProgram/MainRoutine - 2(NEQ)</i>			
<i>OsaZ.FeedbackFault - MainProgram/MainRoutine - 44(XIC)</i>			
<i>OsaZ.ModuleFaults - MainProgram/MainRoutine - 44(NEQ)</i>			
<i>OsaZ.MotorOvertempFault - MainProgram/MainRoutine - 44(XIC)</i>			
<i>OsaZ.NegHardOvertravelFault - MainProgram/MainRoutine - 44(XIC)</i>			
<i>OsaZ.NegSoftOvertravelFault - MainProgram/MainRoutine - 32(XIC), 33(XIC), 36(XIO), 44(XIC)</i>			
<i>OsaZ.PosHardOvertravelFault - MainProgram/MainRoutine - 44(XIC)</i>			
<i>OsaZ.PosSoftOvertravelFault - MainProgram/MainRoutine - 32(XIC), 33(XIC), 36(XIO), 44(XIC)</i>			
<i>OsaZ.SERCOSFault - MainProgram/MainRoutine - 44(XIC)</i>			
 x_fault	0	INT	Controler1
<i>x_fault - MainProgram/MainRoutine - *42(MOV), 2(EQU), 3(EQU), 4(EQU)</i>			
 x_man_accel	0.0	REAL	Controler1
<i>x_man_accel - MainProgram/initial - *5(MOV)</i>			
<i>x_man_accel - MainProgram/MainRoutine - 17(MAJ), 18(MAJ)</i>			
<i>x_man_accel - MainProgram/manual - 3(MAJ), 4(MAJ)</i>			
 x_man_deccel	0.0	REAL	Controler1
<i>x_man_deccel - MainProgram/initial - *5(MOV)</i>			
<i>x_man_deccel - MainProgram/MainRoutine - 17(MAJ), 18(MAJ)</i>			
<i>x_man_deccel - MainProgram/manual - 3(MAJ), 4(MAJ), 5(MAS)</i>			
 x_man_gohome	0	BOOL	Controler1
<i>x_man_gohome - MainProgram/manual - 0(XIC)</i>			
 x_man_left	0	BOOL	Controler1
<i>x_man_left - MainProgram/manual - 2(XIC), 4(XIC), 5(XIO)</i>			
 x_man_reset	0	BOOL	Controler1
<i>x_man_reset - MainProgram/MainRoutine - 5(XIC)</i>			
 x_man_right	0	BOOL	Controler1
<i>x_man_right - MainProgram/manual - 2(XIC), 3(XIC), 5(XIO)</i>			

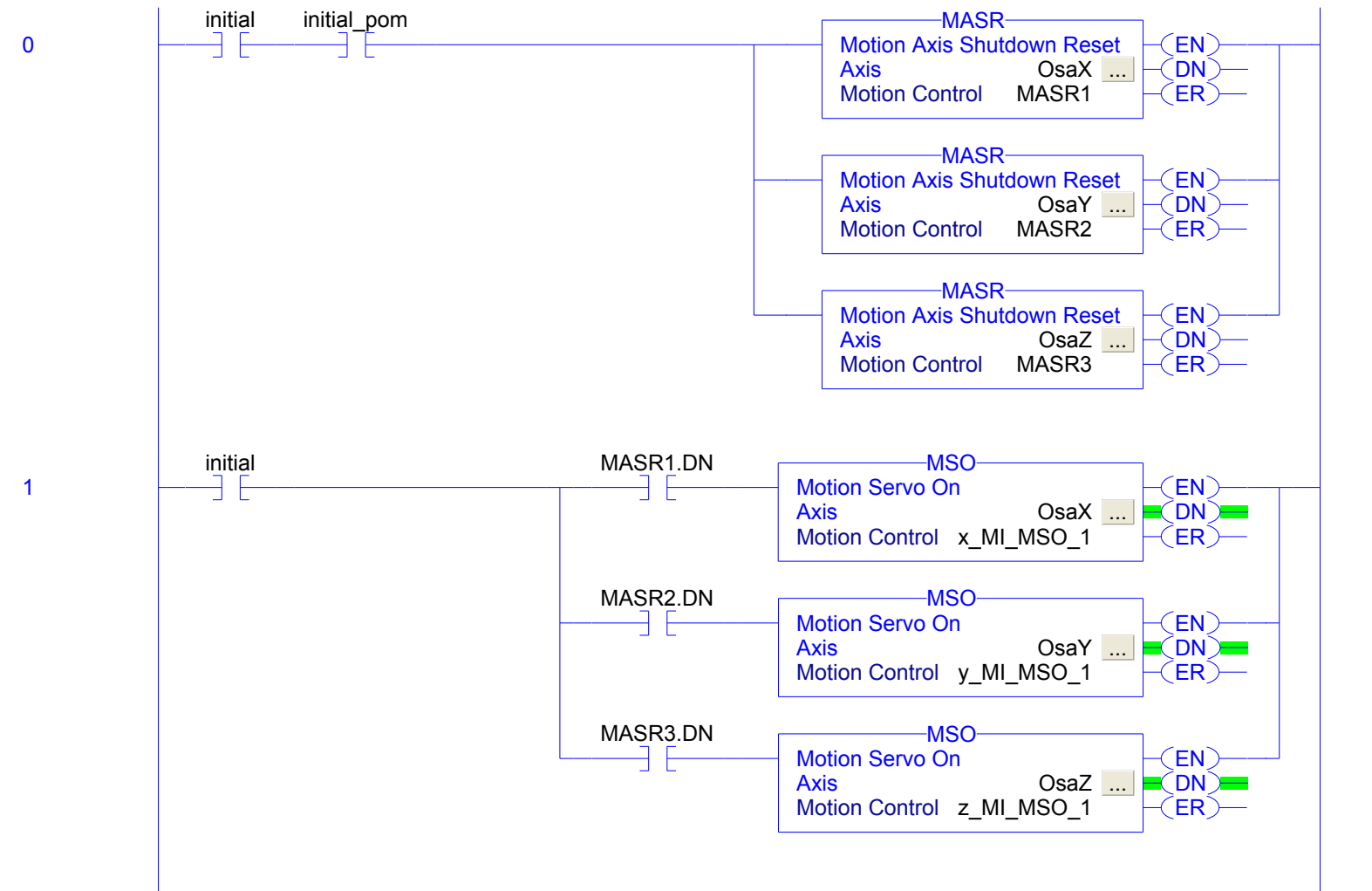
 x_man_speed x_man_speed - MainProgram/initial - *5(MOV) x_man_speed - MainProgram/MainRoutine - 17(MAJ), 18(MAJ) x_man_speed - MainProgram/manual - 3(MAJ), 4(MAJ)	0.0	REAL	Controler1
 x_MI_MAFR x_MI_MAFR - MainProgram/MainRoutine - *6(MAFR) x_MI_MAFR.DN - MainProgram/MainRoutine - 6(XIO) x_MI_MAFR.EN - MainProgram/MainRoutine - 5(XIO)		MOTION_INSTRUCTION	Controler1
 x_MI_MAH_1 x_MI_MAH_1 - MainProgram/initial - *2(MAH) x_MI_MAH_1.DN - MainProgram/initial - 3(XIC)		MOTION_INSTRUCTION	Controler1
 x_MI_MAH_2 x_MI_MAH_2 - MainProgram/manual - *1(MAH) x_MI_MAH_2.DN - MainProgram/manual - 6(XIC) x_MI_MAH_2.EN - MainProgram/manual - 0(XIO)		MOTION_INSTRUCTION	Controler1
 x_MI_MAJ_1 x_MI_MAJ_1 - MainProgram/manual - *3(MAJ)		MOTION_INSTRUCTION	Controler1
 x_MI_MAJ_2 x_MI_MAJ_2 - MainProgram/manual - *4(MAJ)		MOTION_INSTRUCTION	Controler1
 x_MI_MAS x_MI_MAS - MainProgram/manual - *5(MAS) x_MI_MAS.DN - MainProgram/manual - 6(XIC)		MOTION_INSTRUCTION	Controler1
 x_MI_MASR x_MI_MASR - MainProgram/MainRoutine - *5(MASR) x_MI_MASR.DN - MainProgram/MainRoutine - 6(XIC)		MOTION_INSTRUCTION	Controler1
 x_MI_MSF_1 x_MI_MSF_1 - MainProgram/initial - *3(MSF) x_MI_MSF_1.DN - MainProgram/initial - 4(XIC)		MOTION_INSTRUCTION	Controler1
 x_MI_MSF_2 x_MI_MSF_2 - MainProgram/manual - *6(MSF)		MOTION_INSTRUCTION	Controler1
 x_MI_MSO_1 x_MI_MSO_1 - MainProgram/initial - *1(MSO) x_MI_MSO_1.DN - MainProgram/initial - 2(XIC)		MOTION_INSTRUCTION	Controler1
 x_MI_MSO_2 x_MI_MSO_2 - MainProgram/manual - *0(MSO) x_MI_MSO_2.DN - MainProgram/manual - 1(XIC)		MOTION_INSTRUCTION	Controler1
 x_MI_MSO_3 x_MI_MSO_3 - MainProgram/manual - *2(MSO) x_MI_MSO_3.DN - MainProgram/manual - 3(XIC), 4(XIC)		MOTION_INSTRUCTION	Controler1
 x_position AliasFor: OsaX.ActualPosition Base Tag: OsaX.ActualPosition x_position - MainProgram/MainRoutine - 19(GRT), 19(LES)	0.0	REAL	Controler1
 x_SOT_ClearHardBits x_SOT_ClearHardBits - MainProgram/MainRoutine - *14(MOV), 14(SSV) x_SOT_ClearHardBits.0 - MainProgram/MainRoutine - *14(OTU)	0	DINT	Controler1
 x_SOT_MAJ_Off_SOT x_SOT_MAJ_Off_SOT - MainProgram/MainRoutine - *17(MAJ), *18(MAJ)		MOTION_INSTRUCTION	Controler1
 x_SOT_MAS x_SOT_MAS - MainProgram/MainRoutine - *19(MAS)		MOTION_INSTRUCTION	Controler1
 x_SOT_MASR		MOTION_INSTRUCTION	Controler1

x_SOT_MASR (Continued)			
<i>x_SOT_MASR - MainProgram/MainRoutine - *15(MASR)</i>			
<i>x_SOT_MASR.DN - MainProgram/MainRoutine - 16(XIC)</i>			
 x_SOT_MSO		MOTION_INSTRUCTION	Controler1
<i>x_SOT_MSO - MainProgram/MainRoutine - *16(MSO)</i>			
<i>x_SOT_MSO.DN - MainProgram/MainRoutine - 17(XIC), 18(XIC)</i>			
 x_SOT_NegMemory	0	BOOL	Controler1
<i>x_SOT_NegMemory - MainProgram/MainRoutine - *13(OTL), *21(OTU), 17(XIC)</i>			
 x_SOT_Ok_To_Override	0	BOOL	Controler1
<i>x_SOT_Ok_To_Override - MainProgram/MainRoutine - *21(OTU), 14(XIC)</i>			
 x_SOT_OvertravelResetState	0	DINT	Controler1
<i>x_SOT_OvertravelResetState - MainProgram/MainRoutine - *13(MOV), *14(MOV), *15(MOV), *16(MOV), *17(MOV), *18(MOV), *19(MOV), *20(MOV), *21(MOV), 14(EQU), 15(EQU), 16(EQU), 17(EQU), 18(EQU), 19(EQU), 20(EQU), 21(EQU)</i>			
 x_SOT_PosMemory	0	BOOL	Controler1
<i>x_SOT_PosMemory - MainProgram/MainRoutine - *13(OTL), *21(OTU), 18(XIC)</i>			
 x_SOT_SavedConfigFaults	0	DINT	Controler1
<i>x_SOT_SavedConfigFaults - MainProgram/MainRoutine - *12(GSV), 14(MOV), 20(MOV)</i>			
<i>x_SOT_SavedConfigFaults.0 - MainProgram/MainRoutine - 13(XIC), 15(XIO), 21(XIC)</i>			
 x_SOT_SetSoft	0	DINT	Controler1
<i>x_SOT_SetSoft - MainProgram/MainRoutine - *20(MOV), 20(SSV)</i>			
<i>x_SOT_SetSoft.0 - MainProgram/MainRoutine - *20(OTL)</i>			
 y_fault	0	INT	Controler1
<i>y_fault - MainProgram/MainRoutine - *43(MOV), 2(EQU), 3(EQU), 4(EQU)</i>			
 y_man_accel	0.0	REAL	Controler1
<i>y_man_accel - MainProgram/initial - *5(MOV)</i>			
<i>y_man_accel - MainProgram/MainRoutine - 27(MAJ), 28(MAJ)</i>			
<i>y_man_accel - MainProgram/manual - 10(MAJ), 11(MAJ)</i>			
 y_man_deccel	0.0	REAL	Controler1
<i>y_man_deccel - MainProgram/initial - *5(MOV)</i>			
<i>y_man_deccel - MainProgram/MainRoutine - 27(MAJ), 28(MAJ)</i>			
<i>y_man_deccel - MainProgram/manual - 10(MAJ), 11(MAJ), 12(MAS)</i>			
 y_man_gohome	0	BOOL	Controler1
<i>y_man_gohome - MainProgram/manual - 7(XIC)</i>			
 y_man_left	0	BOOL	Controler1
<i>y_man_left - MainProgram/manual - 11(XIC), 12(XIO), 9(XIC)</i>			
 y_man_reset	0	BOOL	Controler1
<i>y_man_reset - MainProgram/MainRoutine - 7(XIC)</i>			
 y_man_right	0	BOOL	Controler1
<i>y_man_right - MainProgram/manual - 10(XIC), 12(XIO), 9(XIC)</i>			
 y_man_speed	0.0	REAL	Controler1
<i>y_man_speed - MainProgram/initial - *5(MOV)</i>			
<i>y_man_speed - MainProgram/MainRoutine - 27(MAJ), 28(MAJ)</i>			
<i>y_man_speed - MainProgram/manual - 10(MAJ), 11(MAJ)</i>			
 y_MI_MAFR		MOTION_INSTRUCTION	Controler1
<i>y_MI_MAFR - MainProgram/MainRoutine - *8(MAFR)</i>			
<i>y_MI_MAFR.DN - MainProgram/MainRoutine - 8(XIO)</i>			
<i>y_MI_MAFR.EN - MainProgram/MainRoutine - 7(XIO)</i>			
 y_MI_MAH_1		MOTION_INSTRUCTION	Controler1
<i>y_MI_MAH_1 - MainProgram/initial - *2(MAH)</i>			
<i>y_MI_MAH_1.DN - MainProgram/initial - 3(XIC)</i>			

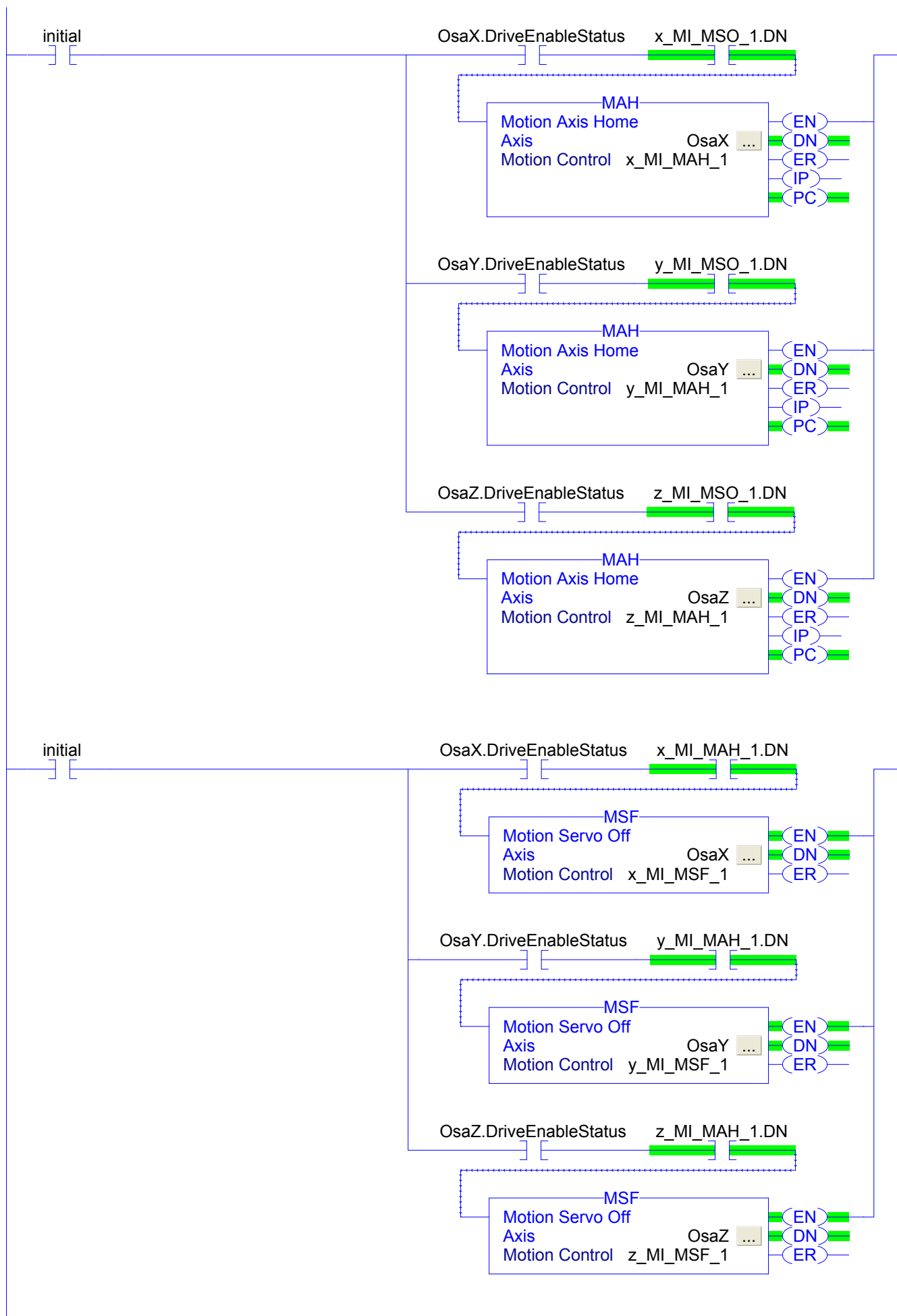
 y_MI_MAH_2 y_MI_MAH_2 - MainProgram/manual - *8(MAH) y_MI_MAH_2.DN - MainProgram/manual - 13(XIC) y_MI_MAH_2.EN - MainProgram/manual - 7(XIO)	MOTION_INSTRUCTION	Controler1
 y_MI_MAJ_1 y_MI_MAJ_1 - MainProgram/manual - *10(MAJ)	MOTION_INSTRUCTION	Controler1
 y_MI_MAJ_2 y_MI_MAJ_2 - MainProgram/manual - *11(MAJ)	MOTION_INSTRUCTION	Controler1
 y_MI_MAS y_MI_MAS - MainProgram/manual - *12(MAS) y_MI_MAS.DN - MainProgram/manual - 13(XIC)	MOTION_INSTRUCTION	Controler1
 y_MI_MASR y_MI_MASR - MainProgram/MainRoutine - *7(MASR) y_MI_MASR.DN - MainProgram/MainRoutine - 8(XIC)	MOTION_INSTRUCTION	Controler1
 y_MI_MSF_1 y_MI_MSF_1 - MainProgram/initial - *3(MSF) y_MI_MSF_1.DN - MainProgram/initial - 4(XIC)	MOTION_INSTRUCTION	Controler1
 y_MI_MSF_2 y_MI_MSF_2 - MainProgram/manual - *13(MSF)	MOTION_INSTRUCTION	Controler1
 y_MI_MSO_1 y_MI_MSO_1 - MainProgram/initial - *1(MSO) y_MI_MSO_1.DN - MainProgram/initial - 2(XIC)	MOTION_INSTRUCTION	Controler1
 y_MI_MSO_2 y_MI_MSO_2 - MainProgram/manual - *7(MSO) y_MI_MSO_2.DN - MainProgram/manual - 8(XIC)	MOTION_INSTRUCTION	Controler1
 y_MI_MSO_3 y_MI_MSO_3 - MainProgram/manual - *9(MSO) y_MI_MSO_3.DN - MainProgram/manual - 10(XIC), 11(XIC)	MOTION_INSTRUCTION	Controler1
 y_position 0.0 AliasFor: OsaY.ActualPosition Base Tag: OsaY.ActualPosition y_position - MainProgram/MainRoutine - 29(GRT), 29(LES)	REAL	Controler1
 y_SOT_ClearHardBits 0 y_SOT_ClearHardBits - MainProgram/MainRoutine - *24(MOV), 24(SSV) y_SOT_ClearHardBits.0 - MainProgram/MainRoutine - *24(OTU)	DINT	Controler1
 y_SOT_MAJ_Off_SOT y_SOT_MAJ_Off_SOT - MainProgram/MainRoutine - *27(MAJ), *28(MAJ)	MOTION_INSTRUCTION	Controler1
 y_SOT_MAS y_SOT_MAS - MainProgram/MainRoutine - *29(MAS)	MOTION_INSTRUCTION	Controler1
 y_SOT_MASR y_SOT_MASR - MainProgram/MainRoutine - *25(MASR) y_SOT_MASR.DN - MainProgram/MainRoutine - 26(XIC)	MOTION_INSTRUCTION	Controler1
 y_SOT_MSO y_SOT_MSO - MainProgram/MainRoutine - *26(MSO) y_SOT_MSO.DN - MainProgram/MainRoutine - 27(XIC), 28(XIC)	MOTION_INSTRUCTION	Controler1
 y_SOT_NegMemory 0 y_SOT_NegMemory - MainProgram/MainRoutine - *23(OTL), *31(OTU), 27(XIC)	BOOL	Controler1
 y_SOT_Ok_To_Override 0 y_SOT_Ok_To_Override - MainProgram/MainRoutine - *31(OTU), 24(XIC)	BOOL	Controler1
 y_SOT_OvertravelResetState 0	DINT	Controler1

y_SOT_OvertravelResetState (Continued)			
y_SOT_OvertravelResetState - MainProgram/MainRoutine - *23(MOV), *24(MOV), *25(MOV), *26(MOV), *27(MOV), *28(MOV), *29(MOV), *30(MOV), *31(MOV), 24(EQU), 25(EQU), 26(EQU), 27(EQU), 28(EQU), 29(EQU), 30(EQU), 31(EQU)			
 y_SOT_PosMemory	0	BOOL	Controler1
y_SOT_PosMemory - MainProgram/MainRoutine - *23(OTL), *31(OTU), 28(XIC)			
 y_SOT_SavedConfigFaults	0	DINT	Controler1
y_SOT_SavedConfigFaults - MainProgram/MainRoutine - *22(GSV), 24(MOV), 30(MOV)			
y_SOT_SavedConfigFaults.0 - MainProgram/MainRoutine - 23(XIC), 25(XIO), 31(XIC)			
 y_SOT_SetSoft	0	DINT	Controler1
y_SOT_SetSoft - MainProgram/MainRoutine - *30(MOV), 30(SSV)			
y_SOT_SetSoft.0 - MainProgram/MainRoutine - *30(OTL)			
 z_fault	0	INT	Controler1
z_fault - MainProgram/MainRoutine - *44(MOV), 2(EQU), 3(EQU), 4(EQU)			
 z_man_accel	0.0	REAL	Controler1
z_man_accel - MainProgram/initial - *5(MOV)			
z_man_accel - MainProgram/MainRoutine - 37(MAJ), 38(MAJ)			
z_man_accel - MainProgram/manual - 17(MAJ), 18(MAJ)			
 z_man_deccel	0.0	REAL	Controler1
z_man_deccel - MainProgram/initial - *5(MOV)			
z_man_deccel - MainProgram/MainRoutine - 37(MAJ), 38(MAJ)			
z_man_deccel - MainProgram/manual - 17(MAJ), 18(MAJ), 19(MAS)			
 z_man_down	0	BOOL	Controler1
z_man_down - MainProgram/manual - 16(XIC), 18(XIC), 19(XIO)			
 z_man_gohome	0	BOOL	Controler1
z_man_gohome - MainProgram/manual - 14(XIC)			
 z_man_reset	0	BOOL	Controler1
z_man_reset - MainProgram/MainRoutine - 9(XIC)			
 z_man_speed	0.0	REAL	Controler1
z_man_speed - MainProgram/initial - *5(MOV)			
z_man_speed - MainProgram/MainRoutine - 37(MAJ), 38(MAJ)			
z_man_speed - MainProgram/manual - 17(MAJ), 18(MAJ)			
 z_man_up	0	BOOL	Controler1
z_man_up - MainProgram/manual - 16(XIC), 17(XIC), 19(XIO)			
 z_MI_MAFR		MOTION_INSTRUCTION	Controler1
z_MI_MAFR - MainProgram/MainRoutine - *10(MAFR)			
z_MI_MAFR.DN - MainProgram/MainRoutine - 10(XIO)			
z_MI_MAFR.EN - MainProgram/MainRoutine - 9(XIO)			
 z_MI_MAH_1		MOTION_INSTRUCTION	Controler1
z_MI_MAH_1 - MainProgram/initial - *2(MAH)			
z_MI_MAH_1.DN - MainProgram/initial - 3(XIC)			
 z_MI_MAH_2		MOTION_INSTRUCTION	Controler1
z_MI_MAH_2 - MainProgram/manual - *15(MAH)			
z_MI_MAH_2.DN - MainProgram/manual - 20(XIC)			
z_MI_MAH_2.EN - MainProgram/manual - 14(XIO)			
 z_MI_MAJ_1		MOTION_INSTRUCTION	Controler1
z_MI_MAJ_1 - MainProgram/manual - *17(MAJ)			
 z_MI_MAJ_2		MOTION_INSTRUCTION	Controler1
z_MI_MAJ_2 - MainProgram/manual - *18(MAJ)			
 z_MI_MAS		MOTION_INSTRUCTION	Controler1
z_MI_MAS - MainProgram/manual - *19(MAS)			
z_MI_MAS.DN - MainProgram/manual - 20(XIC)			

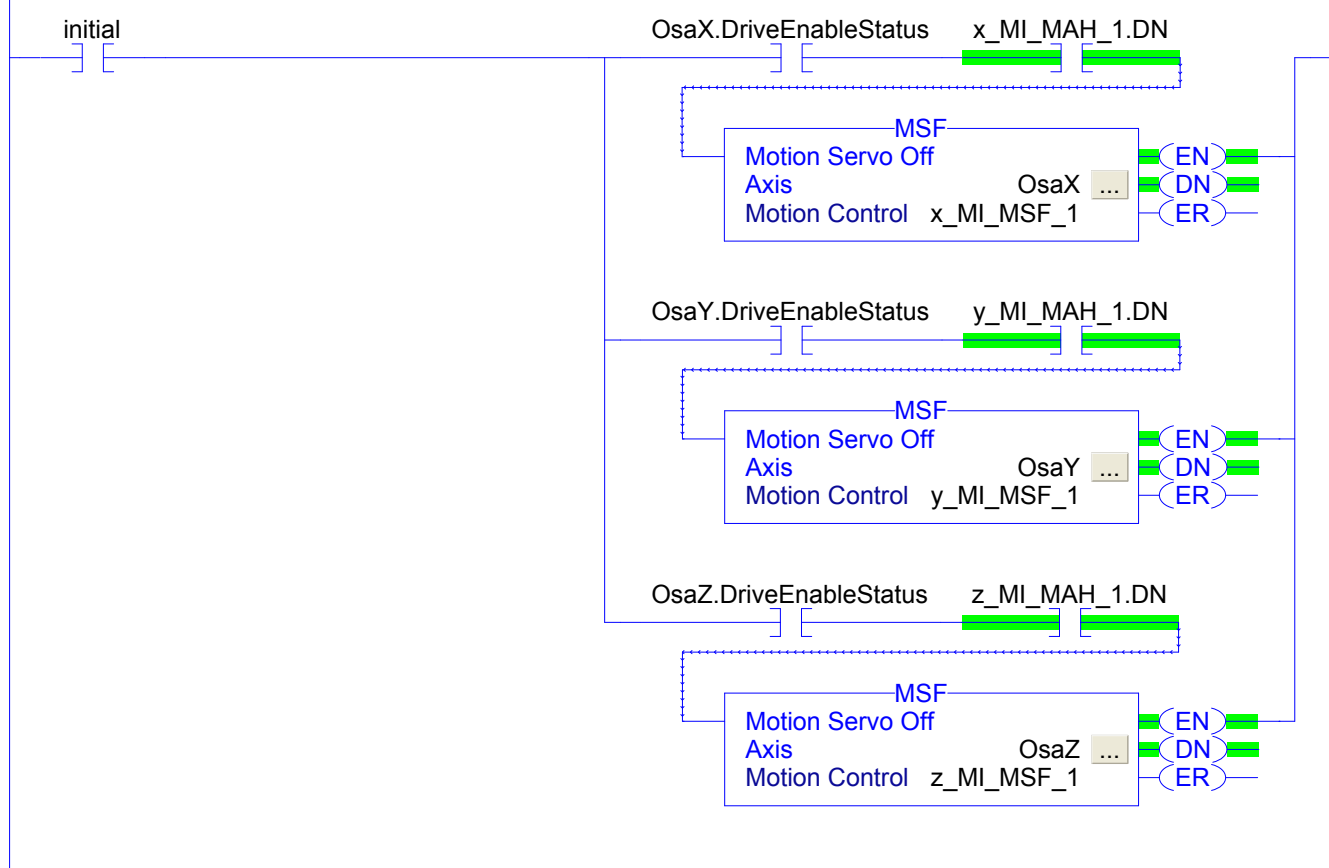
 z_MI_MASR z_MI_MASR - MainProgram/MainRoutine - *9(MASR) z_MI_MASR.DN - MainProgram/MainRoutine - 10(XIC)	MOTION_INSTRUCTION	Controller1
 z_MI_MSF_1 z_MI_MSF_1 - MainProgram/initial - *3(MSF) z_MI_MSF_1.DN - MainProgram/initial - 4(XIC)	MOTION_INSTRUCTION	Controller1
 z_MI_MSF_2 z_MI_MSF_2 - MainProgram/manual - *20(MSF)	MOTION_INSTRUCTION	Controller1
 z_MI_MSO_1 z_MI_MSO_1 - MainProgram/initial - *1(MSO) z_MI_MSO_1.DN - MainProgram/initial - 2(XIC)	MOTION_INSTRUCTION	Controller1
 z_MI_MSO_2 z_MI_MSO_2 - MainProgram/manual - *14(MSO) z_MI_MSO_2.DN - MainProgram/manual - 15(XIC)	MOTION_INSTRUCTION	Controller1
 z_MI_MSO_3 z_MI_MSO_3 - MainProgram/manual - *16(MSO) z_MI_MSO_3.DN - MainProgram/manual - 17(XIC), 18(XIC)	MOTION_INSTRUCTION	Controller1
 z_position 0.0 AliasFor: OsaZ.ActualPosition Base Tag: OsaZ.ActualPosition z_position - MainProgram/MainRoutine - 39(GRT), 39(LES)	REAL	Controller1
 z_SOT_ClearHardBits 0 z_SOT_ClearHardBits - MainProgram/MainRoutine - *34(MOV), 34(SSV) z_SOT_ClearHardBits.0 - MainProgram/MainRoutine - *34(OTU)	DINT	Controller1
 z_SOT_MAJ_Off_SOT z_SOT_MAJ_Off_SOT - MainProgram/MainRoutine - *37(MAJ), *38(MAJ)	MOTION_INSTRUCTION	Controller1
 z_SOT_MAS z_SOT_MAS - MainProgram/MainRoutine - *39(MAS)	MOTION_INSTRUCTION	Controller1
 z_SOT_MASR z_SOT_MASR - MainProgram/MainRoutine - *35(MASR) z_SOT_MASR.DN - MainProgram/MainRoutine - 36(XIC)	MOTION_INSTRUCTION	Controller1
 z_SOT_MSO z_SOT_MSO - MainProgram/MainRoutine - *36(MSO) z_SOT_MSO.DN - MainProgram/MainRoutine - 37(XIC), 38(XIC)	MOTION_INSTRUCTION	Controller1
 z_SOT_NegMemory 0 z_SOT_NegMemory - MainProgram/MainRoutine - *33(OTL), *41(OTU), 37(XIC)	BOOL	Controller1
 z_SOT_Ok_To_Override 0 z_SOT_Ok_To_Override - MainProgram/MainRoutine - *41(OTU), 34(XIC)	BOOL	Controller1
 z_SOT_OvertravelResetState 0 z_SOT_OvertravelResetState - MainProgram/MainRoutine - *33(MOV), *34(MOV), *35(MOV), *36(MOV), *37(MOV), *38(MOV), *39(MOV), *40(MOV), *41(MOV), 34(EQU), 35(EQU), 36(EQU), 37(EQU), 38(EQU), 39(EQU), 40(EQU), 41(EQU)	DINT	Controller1
 z_SOT_PosMemory 0 z_SOT_PosMemory - MainProgram/MainRoutine - *33(OTL), *41(OTU), 38(XIC)	BOOL	Controller1
 z_SOT_SavedConfigFaults 0 z_SOT_SavedConfigFaults - MainProgram/MainRoutine - *32(GSV), 34(MOV), 40(MOV) z_SOT_SavedConfigFaults.0 - MainProgram/MainRoutine - 33(XIC), 35(XIO), 41(XIC)	DINT	Controller1
 z_SOT_SetSoft 0 z_SOT_SetSoft - MainProgram/MainRoutine - *40(MOV), 40(SSV) z_SOT_SetSoft.0 - MainProgram/MainRoutine - *40(OTL)	DINT	Controller1



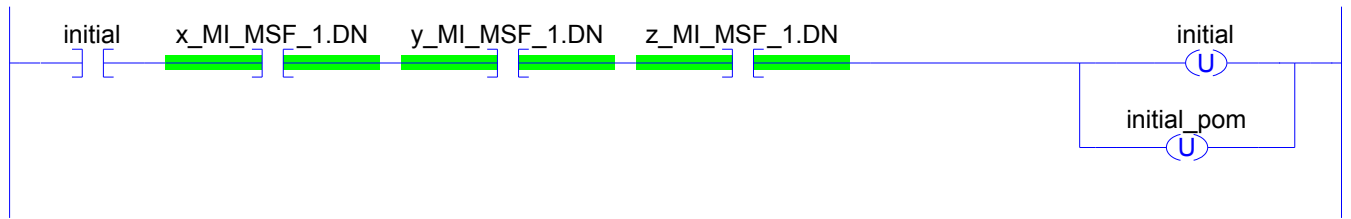
2



3



4



5

initial

MOV
Move
Source 20
Dest x_man_accel
0.0

MOV
Move
Source 20
Dest y_man_accel
0.0

MOV
Move
Source 20
Dest z_man_accel
0.0

MOV
Move
Source 20
Dest x_man_deccel
0.0

MOV
Move
Source 20
Dest y_man_deccel
0.0

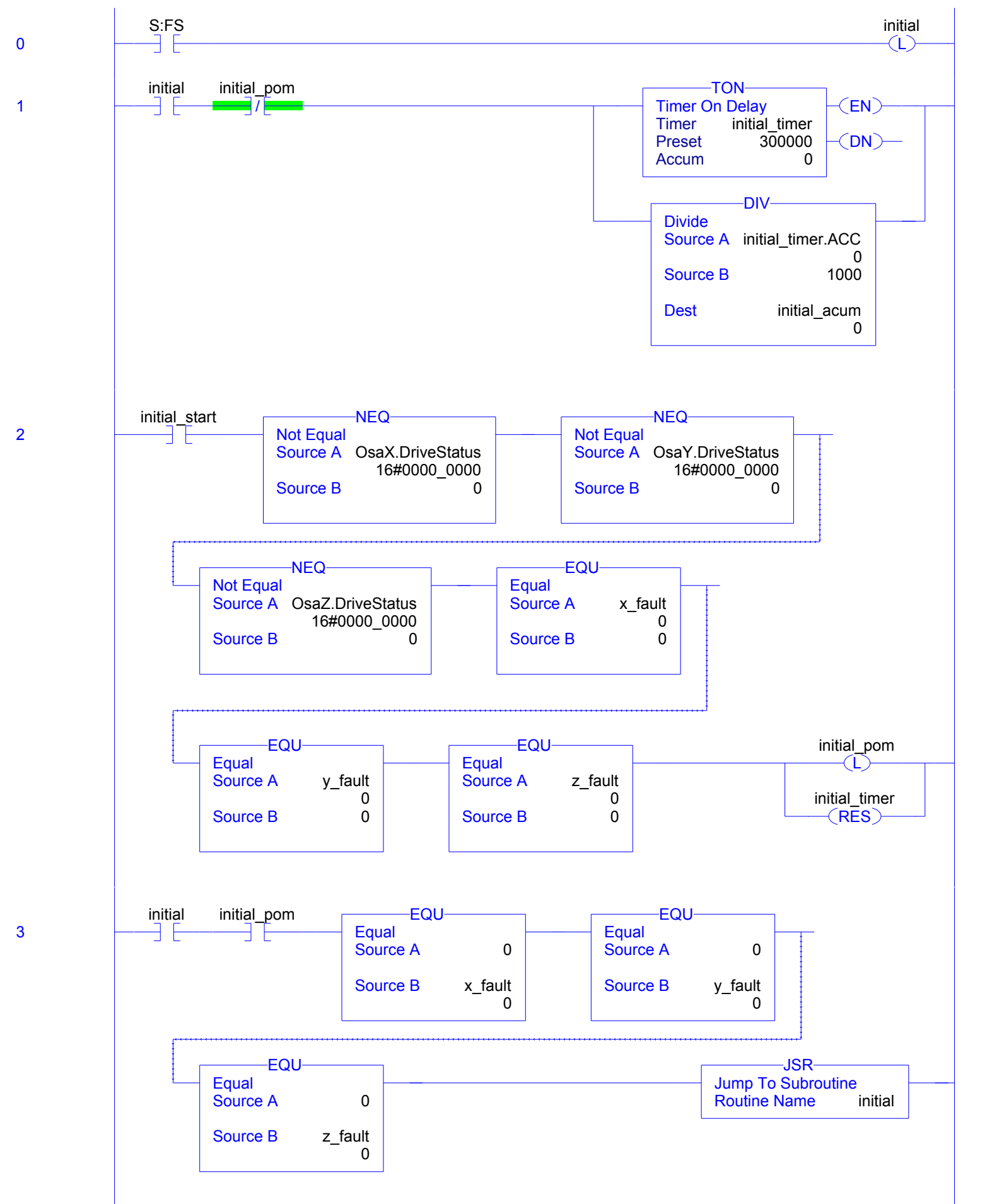
MOV
Move
Source 20
Dest z_man_deccel
0.0

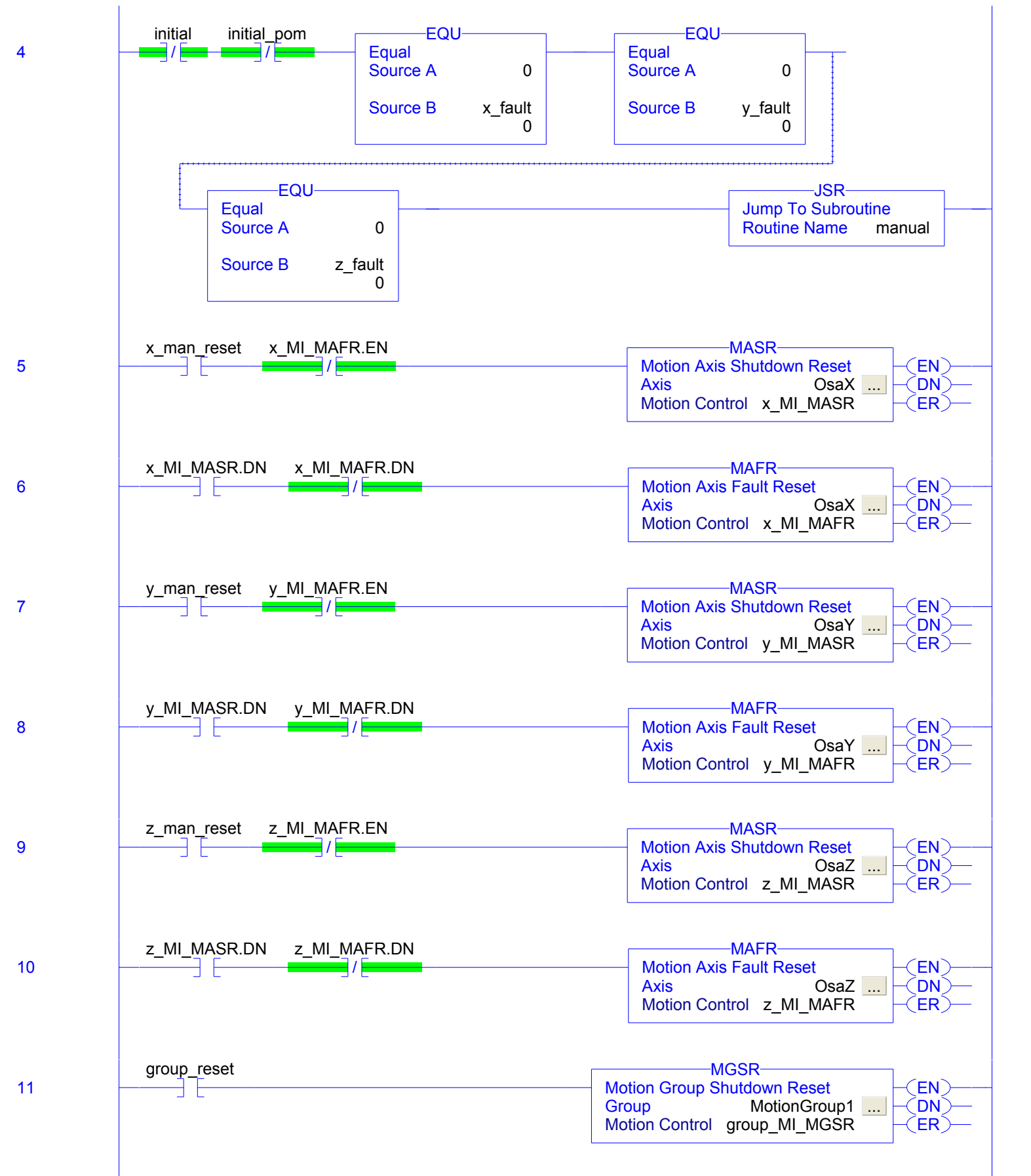
MOV
Move
Source 10
Dest x_man_speed
0.0

MOV
Move
Source 10
Dest y_man_speed
0.0

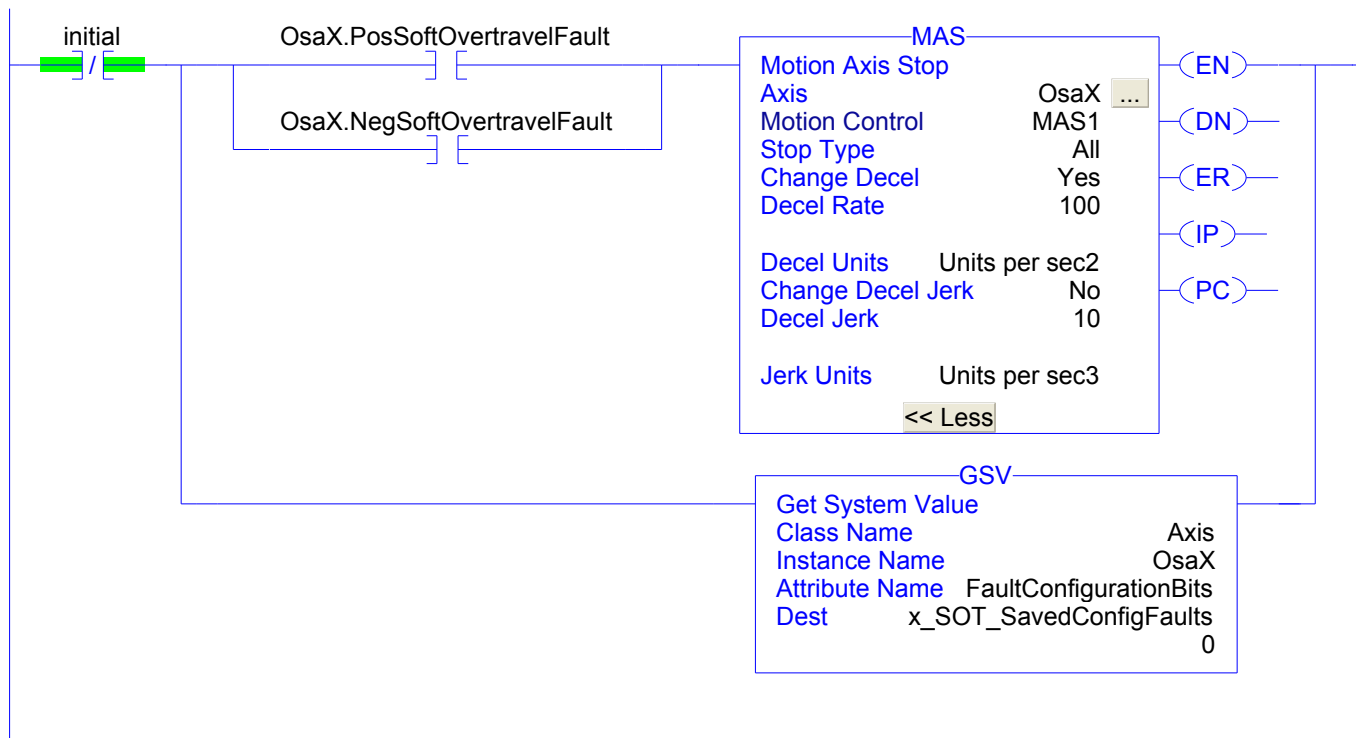
MOV
Move
Source 10
Dest z_man_speed
0.0



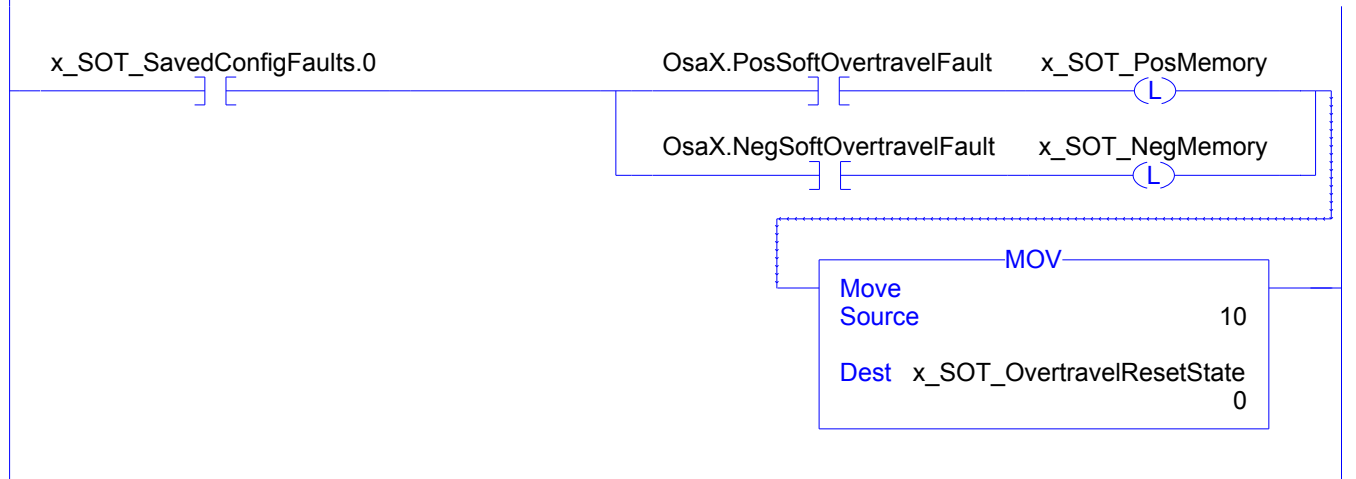




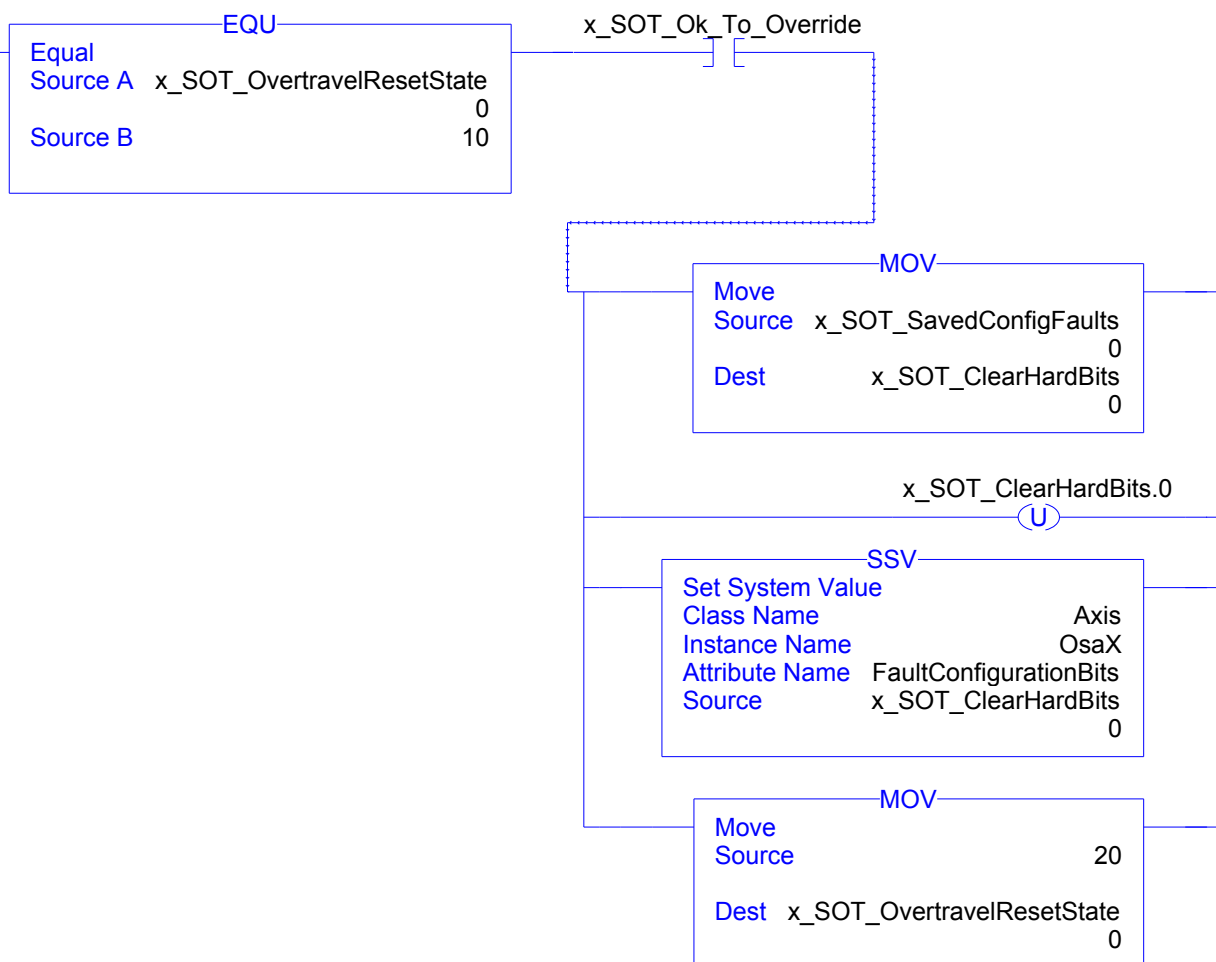
12



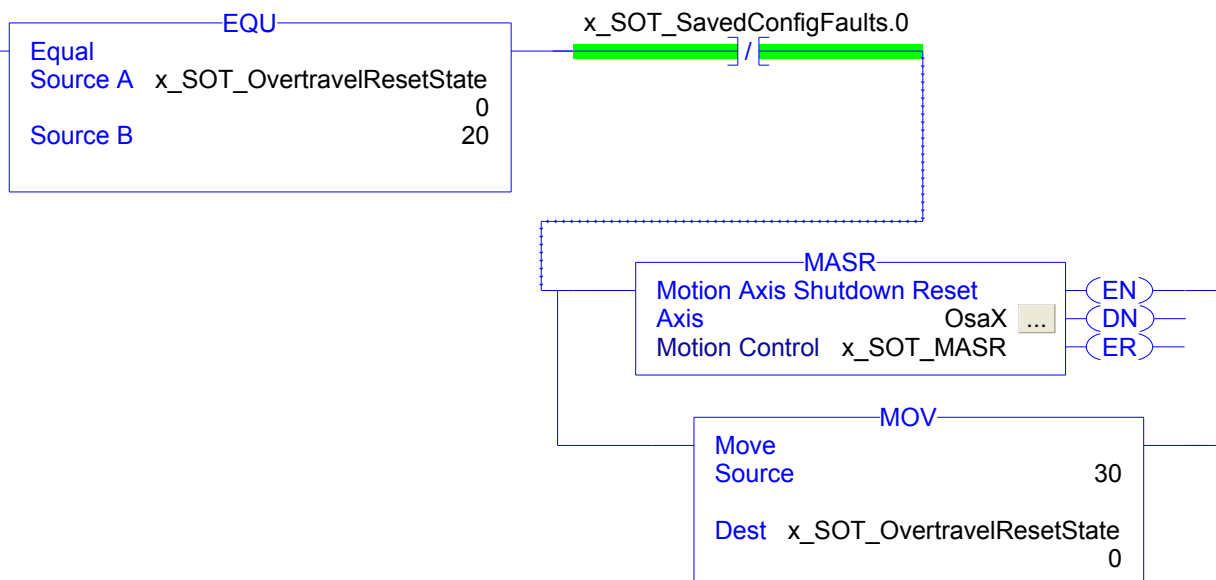
13



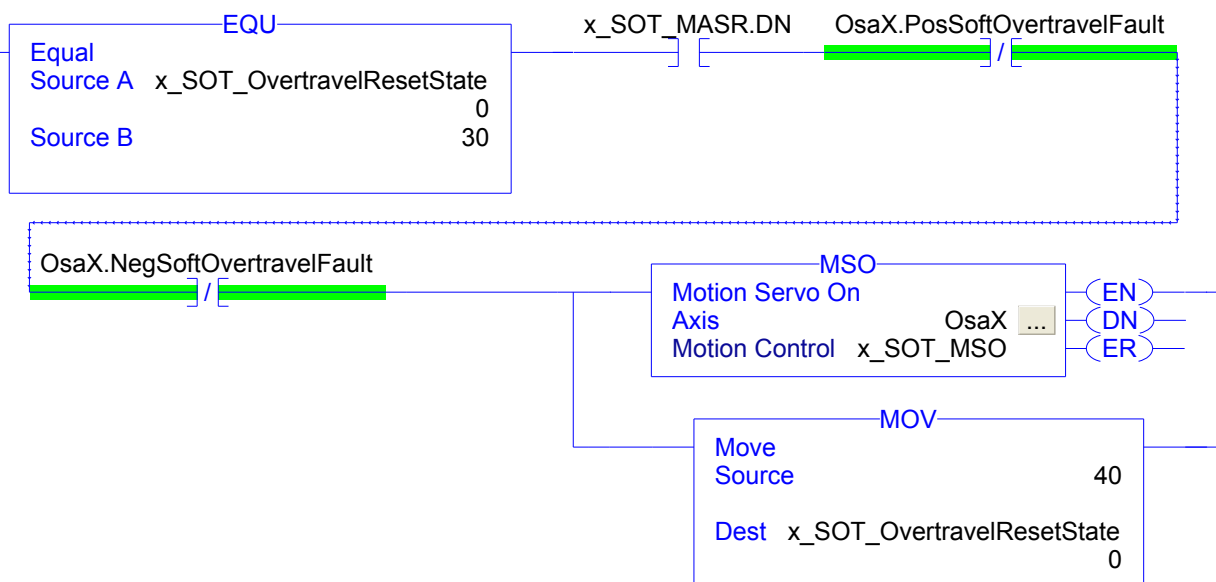
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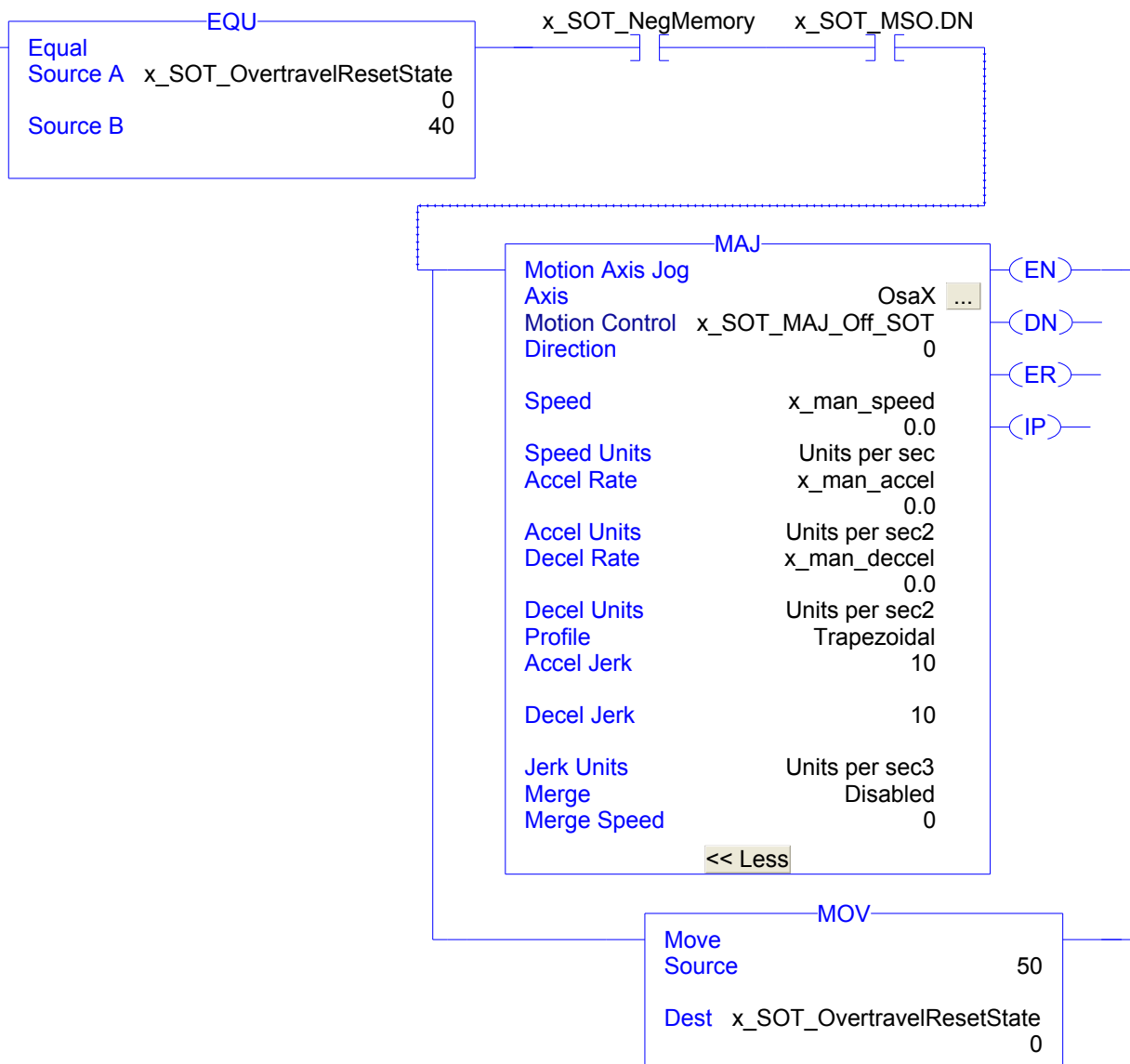
15



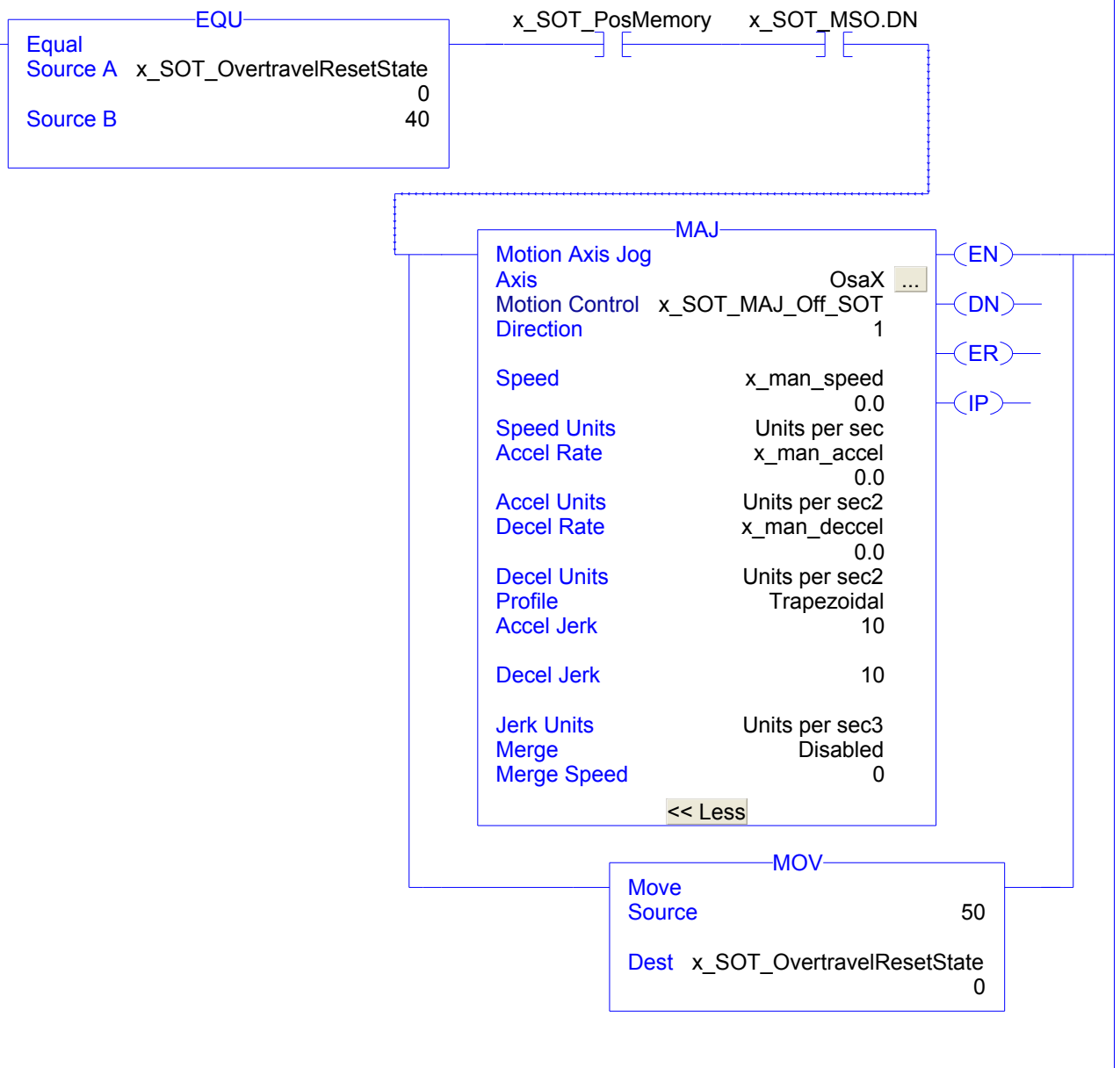
16



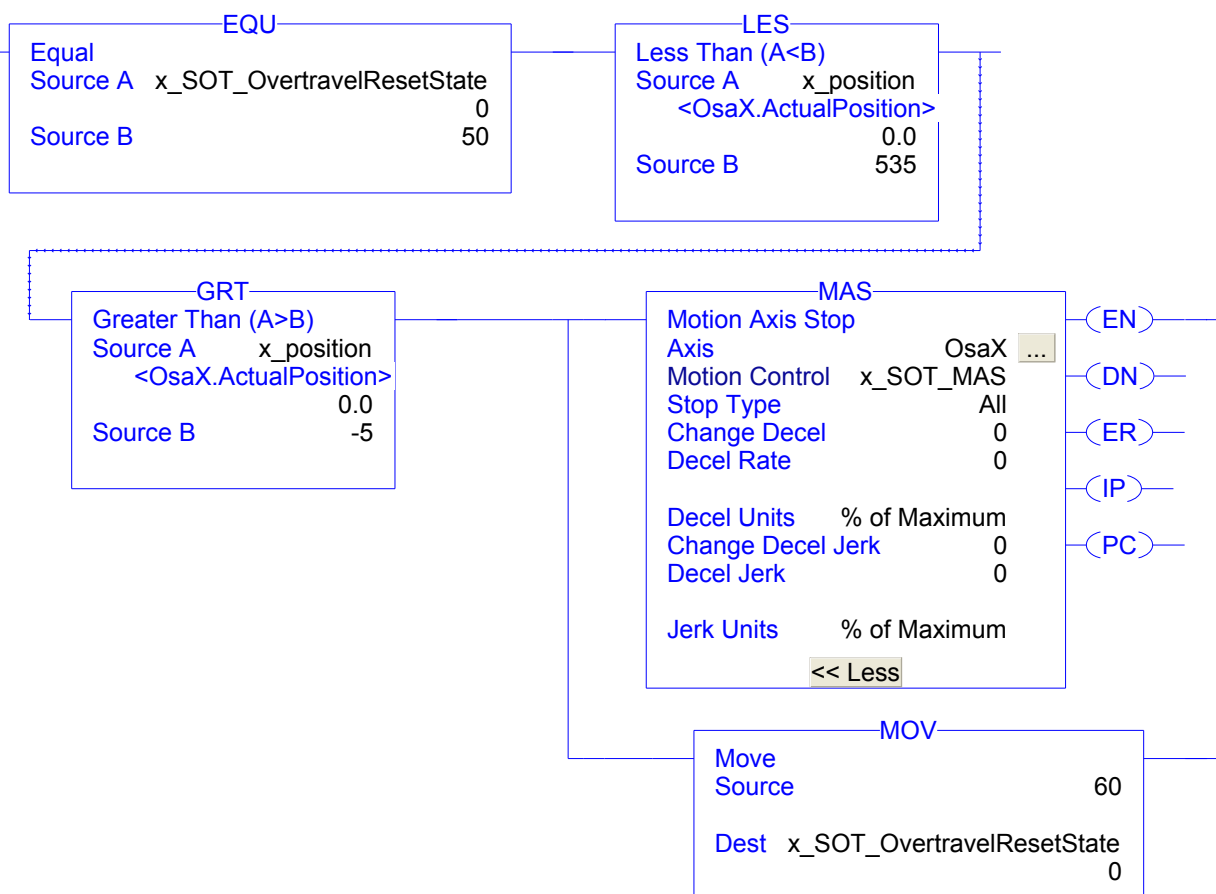
17



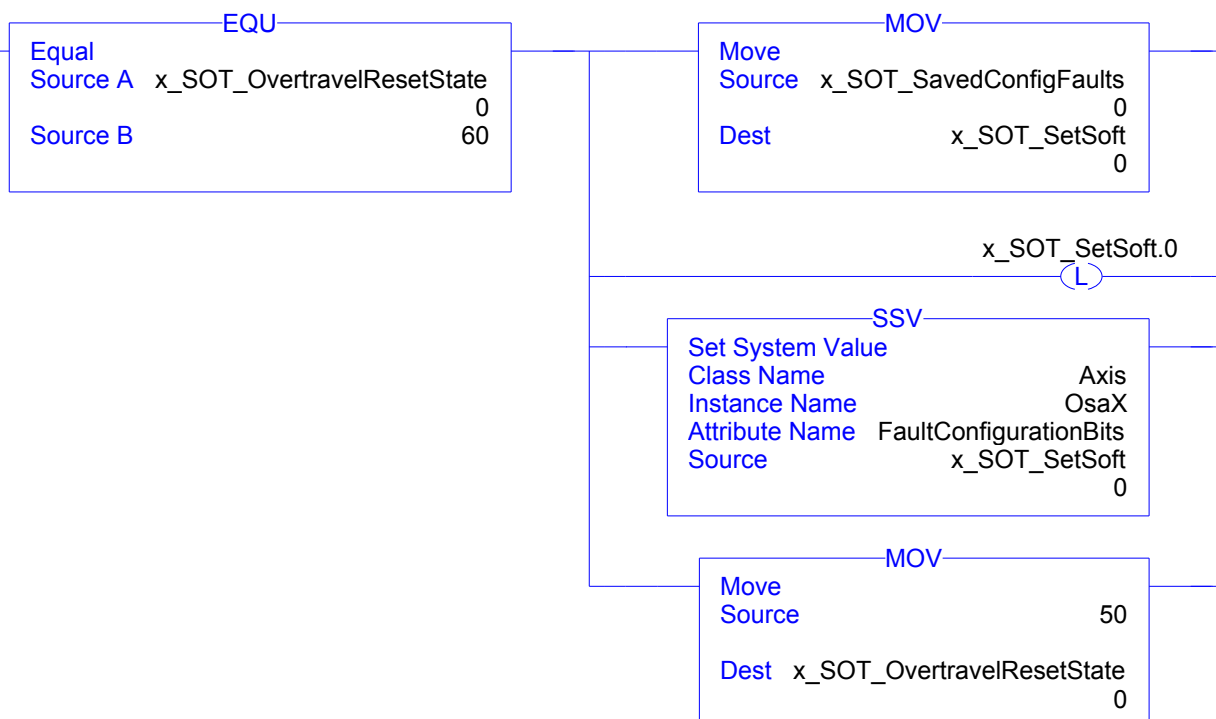
18



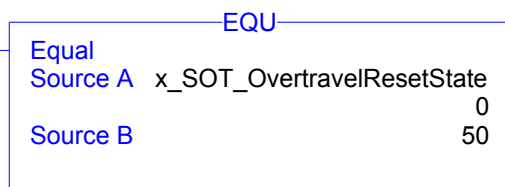
19



20



21



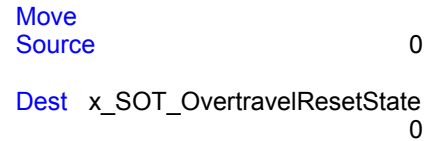
x_SOT_SavedConfigFaults.0

x_SOT_Ok_To_Override

x_SOT_NegMemory

x_SOT_PosMemory

MOV



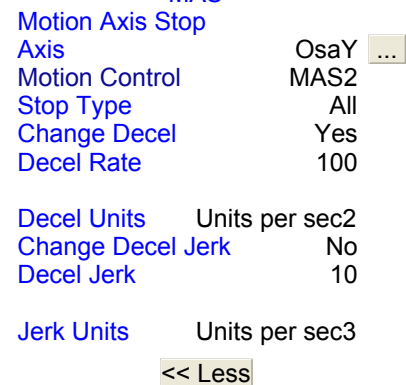
22

initial

OsaY.PosSoftOvertravelFault

OsaY.NegSoftOvertravelFault

MAS



(EN)

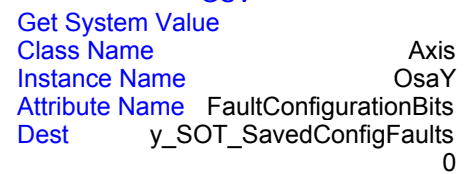
(DN)

(ER)

(IP)

(PC)

GSV



23

y_SOT_SavedConfigFaults.0

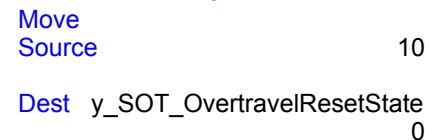
OsaY.PosSoftOvertravelFault

y_SOT_PosMemory

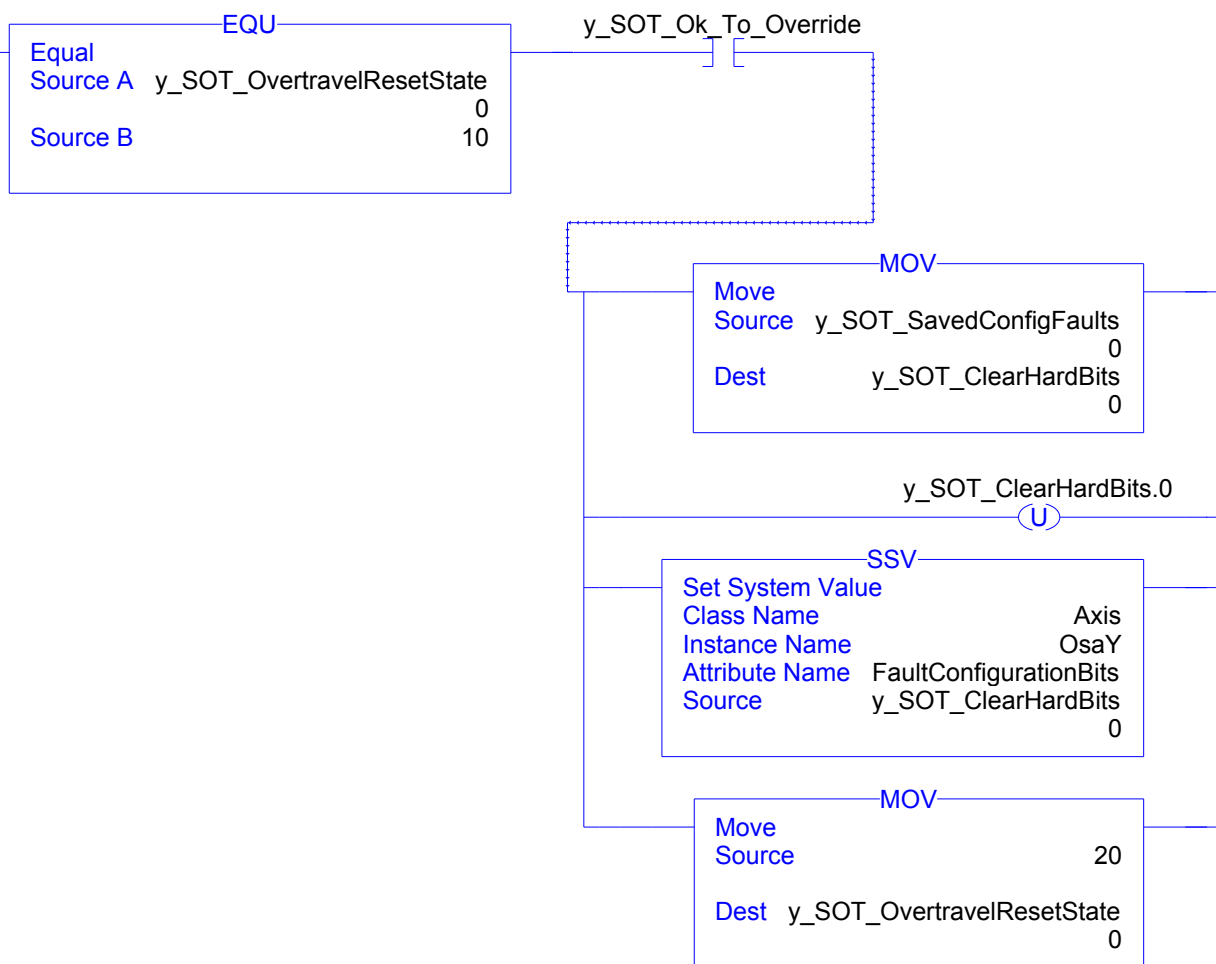
OsaY.NegSoftOvertravelFault

y_SOT_NegMemory

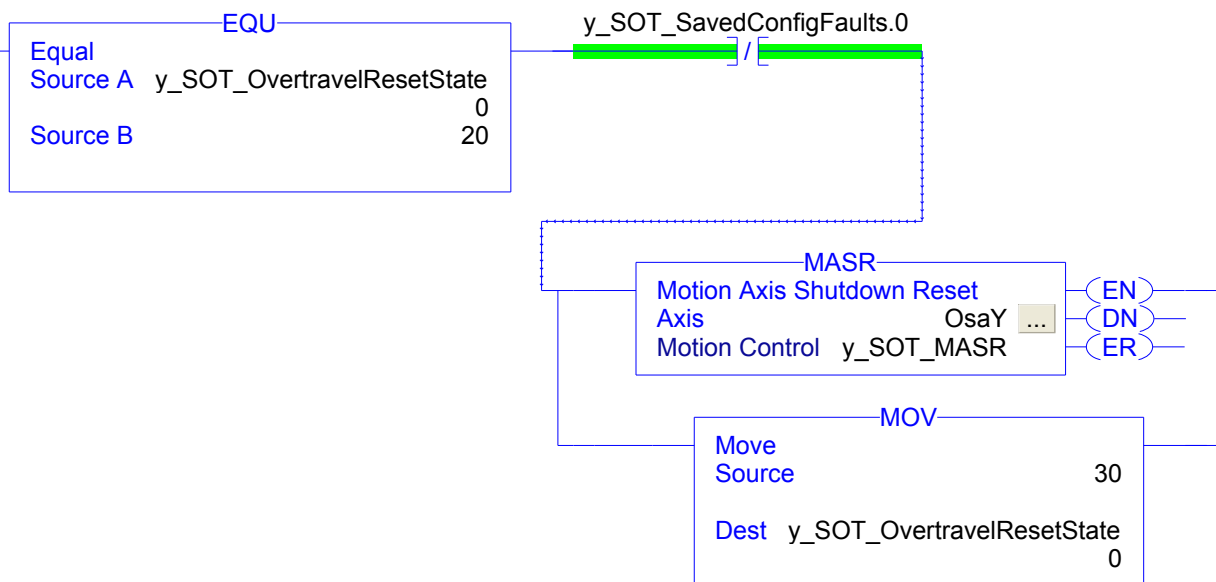
MOV



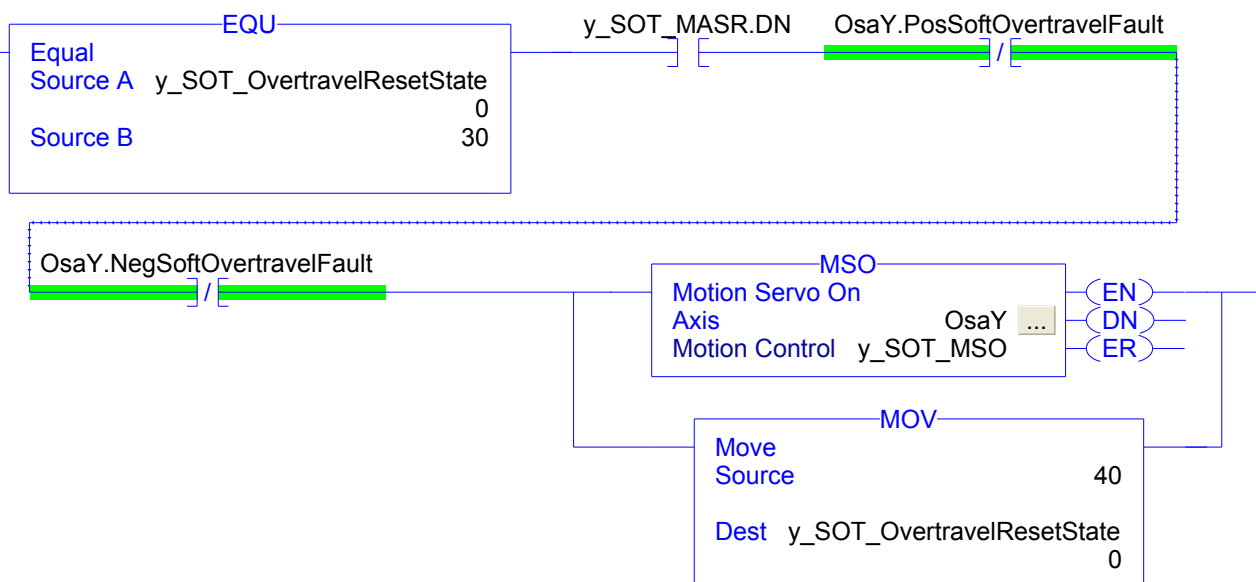
24



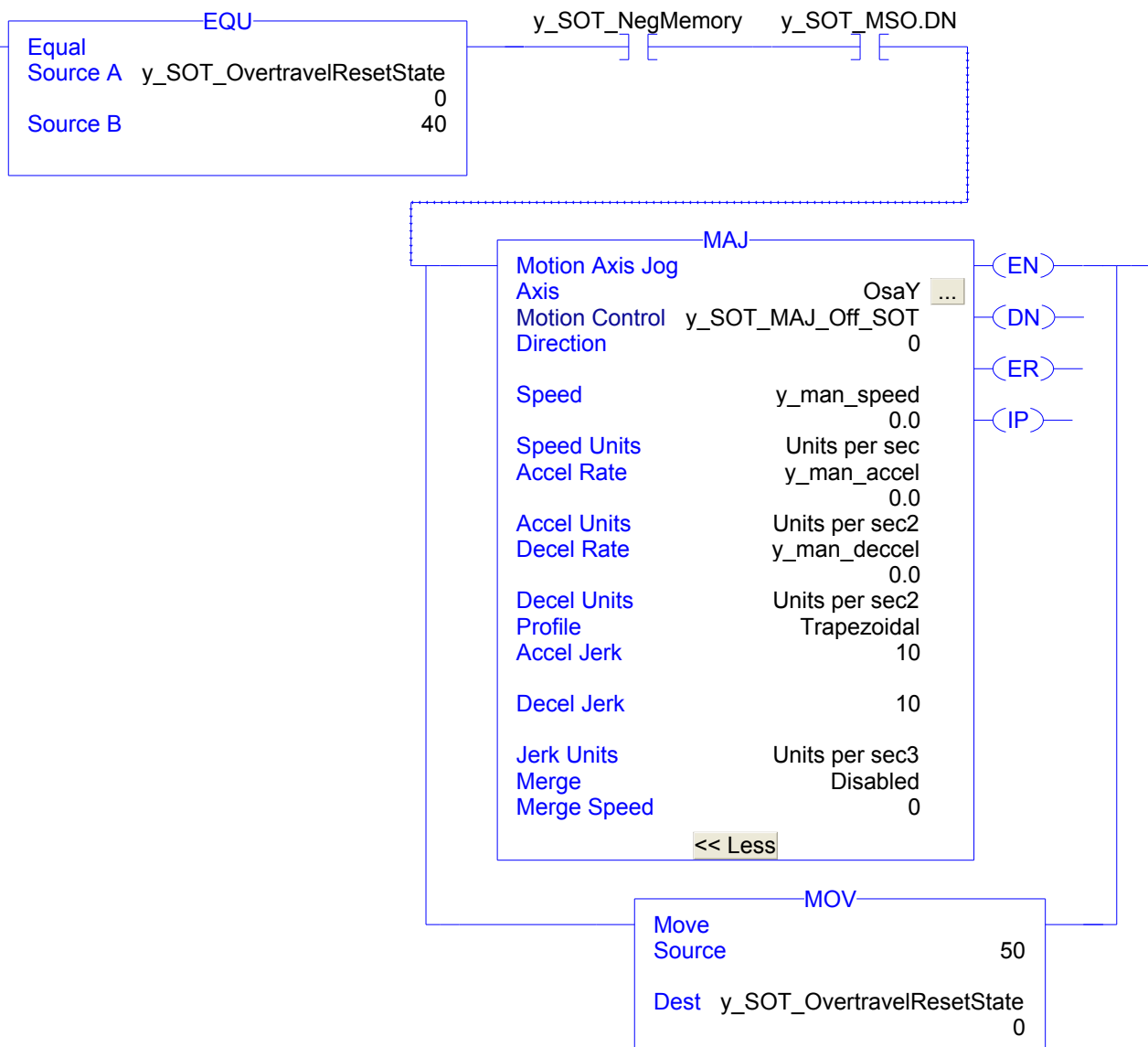
25



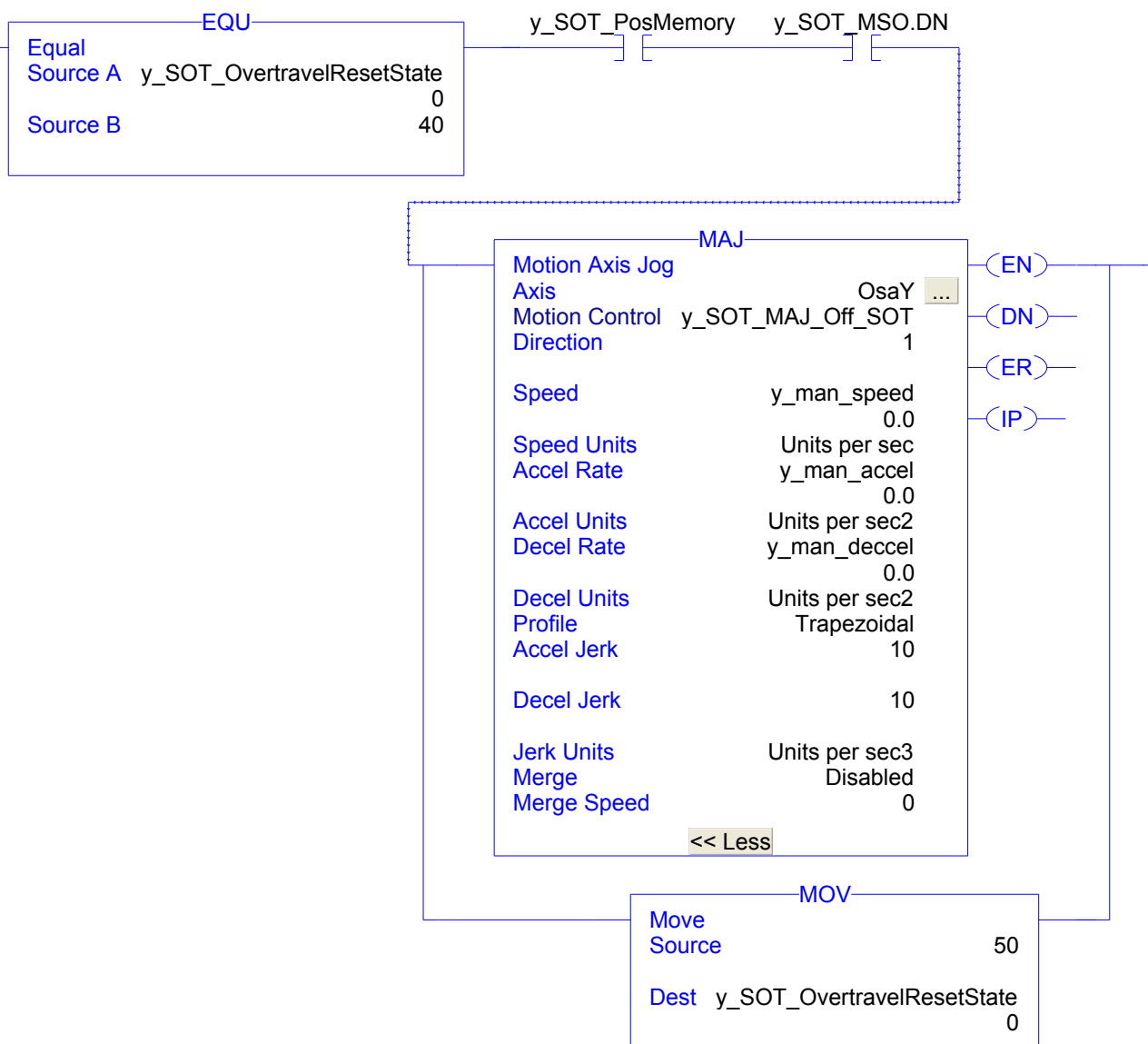
26



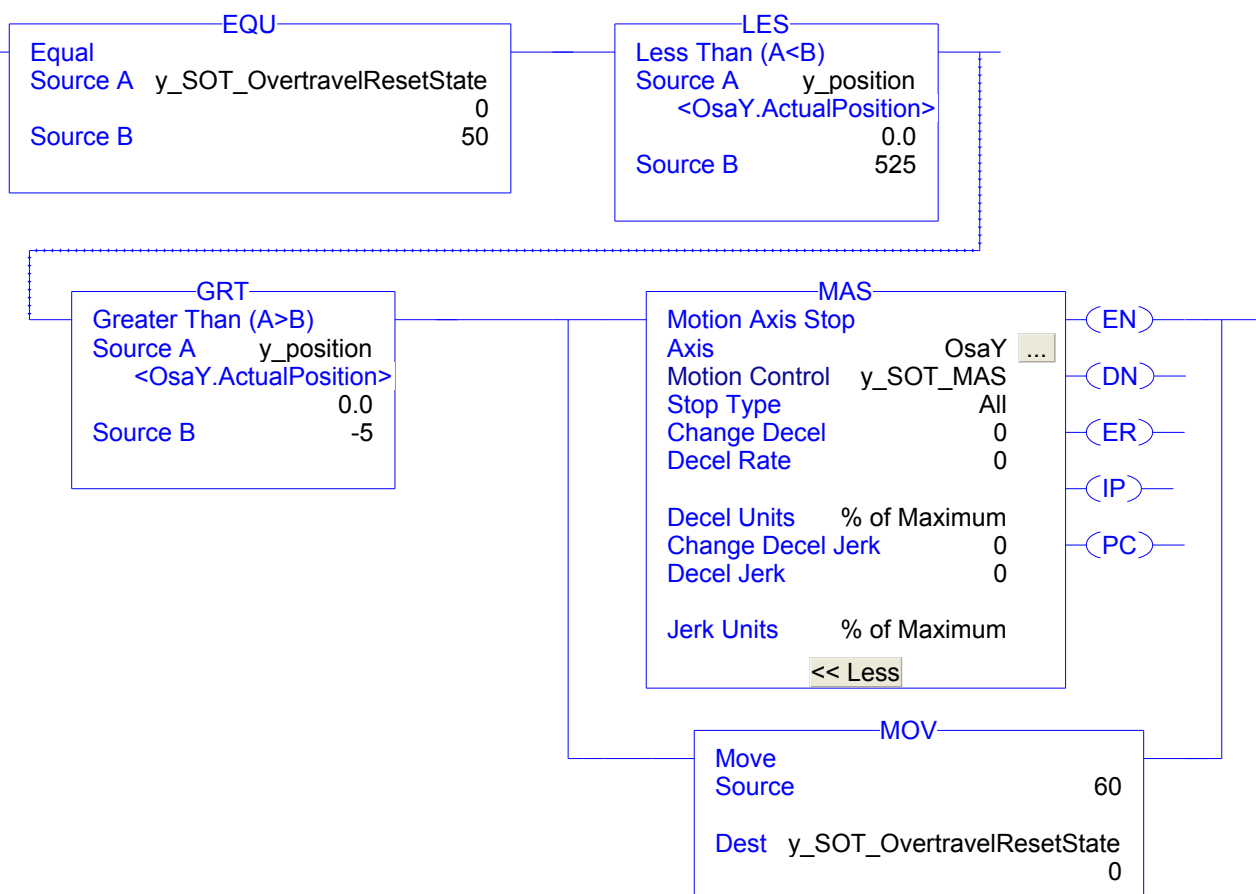
27



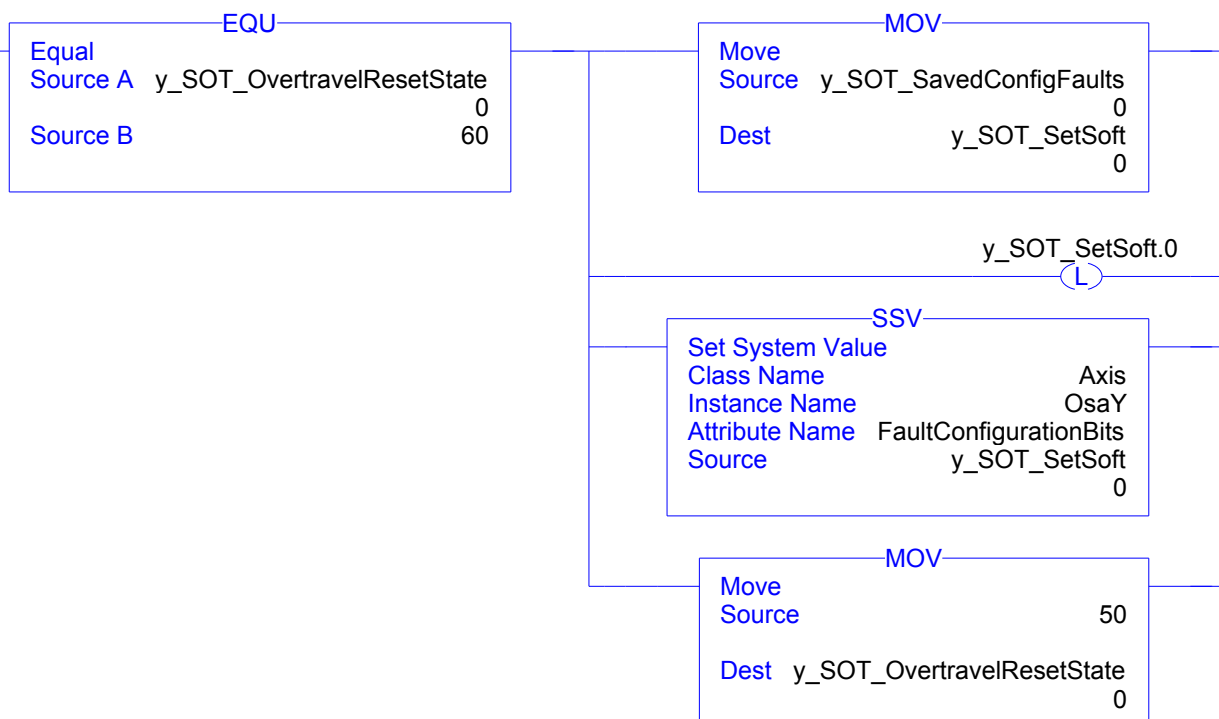
28



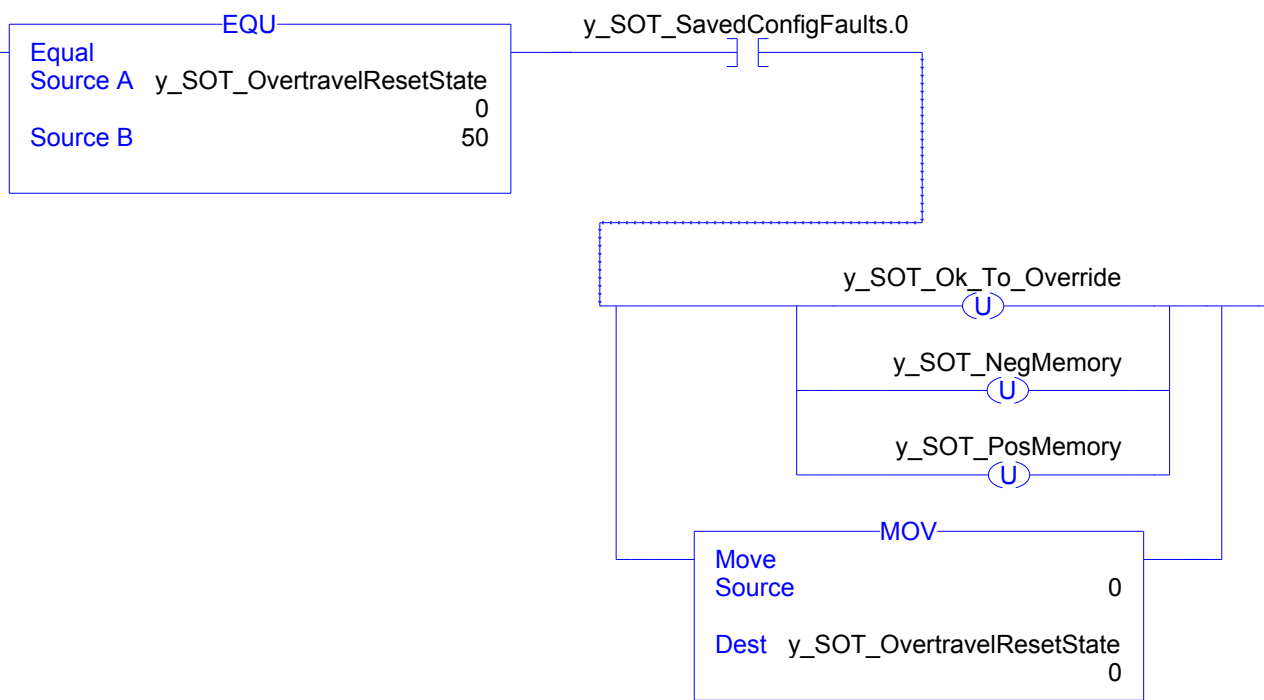
29



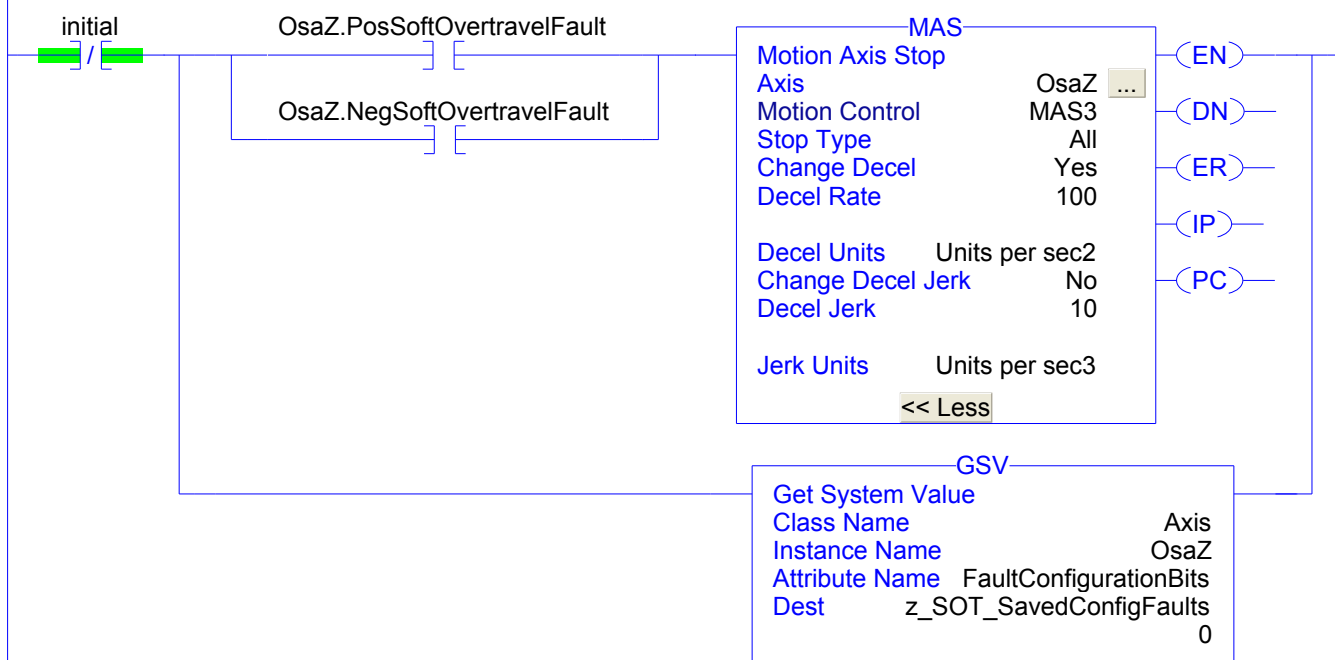
30



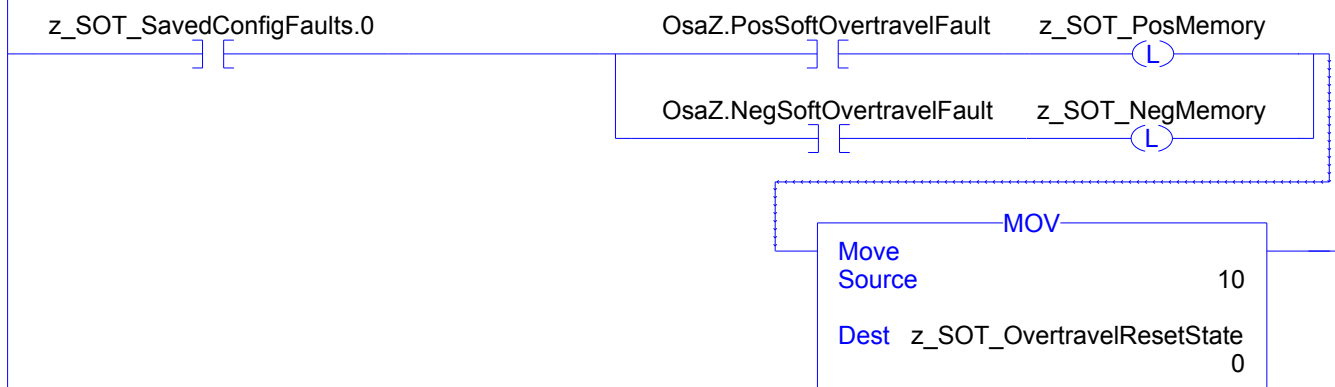
31



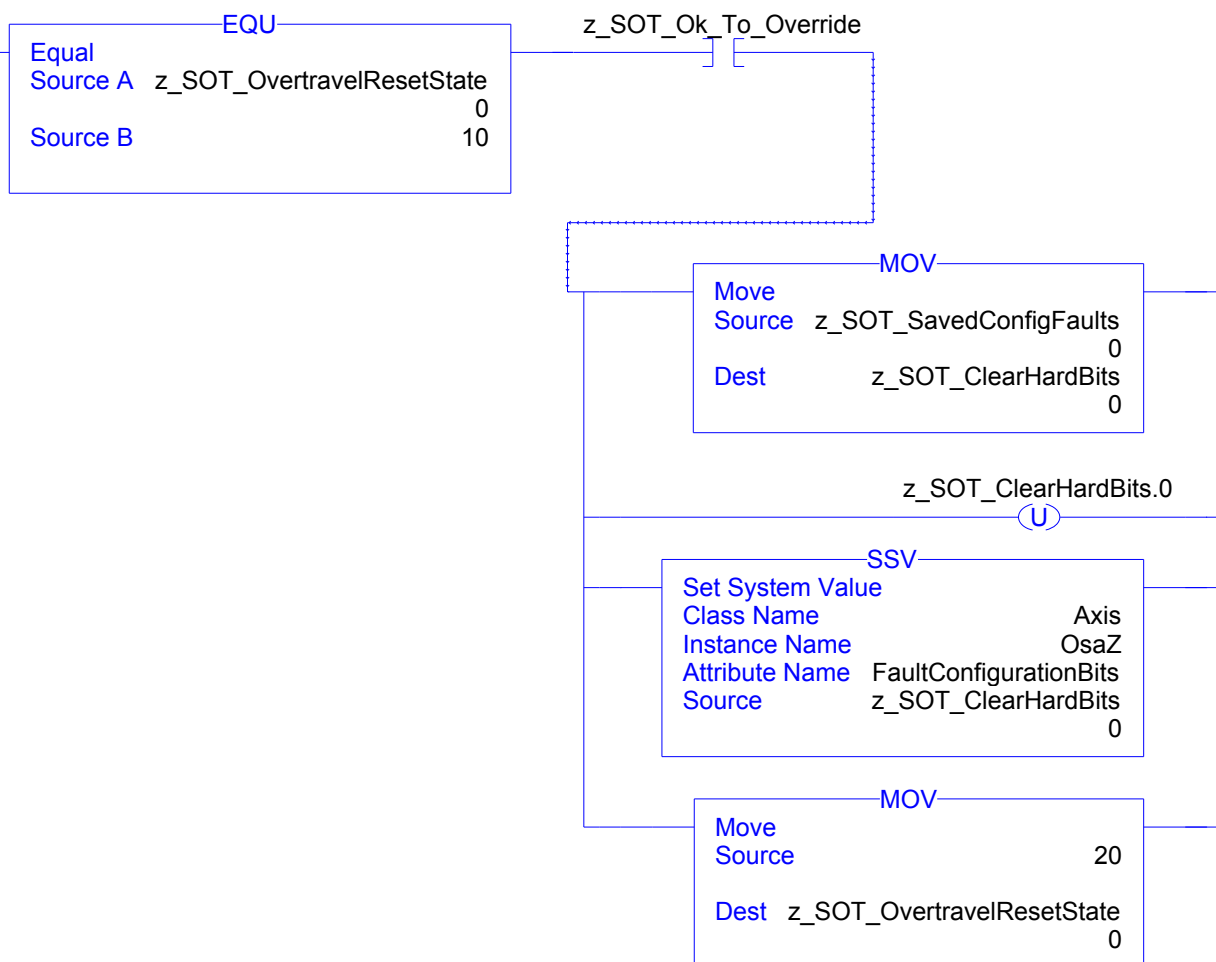
32



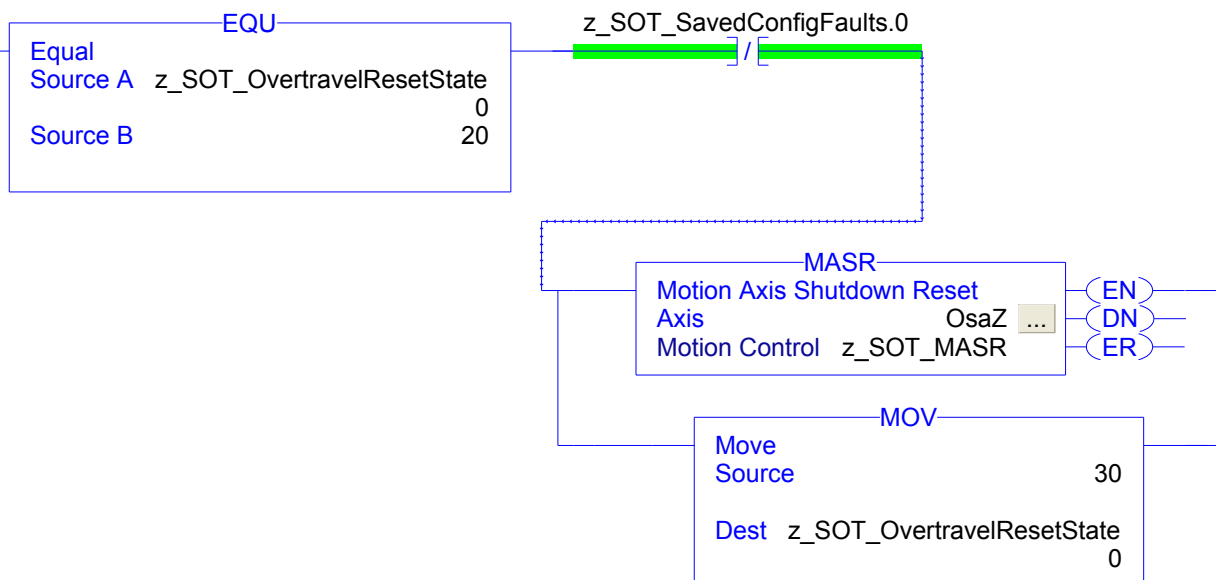
33



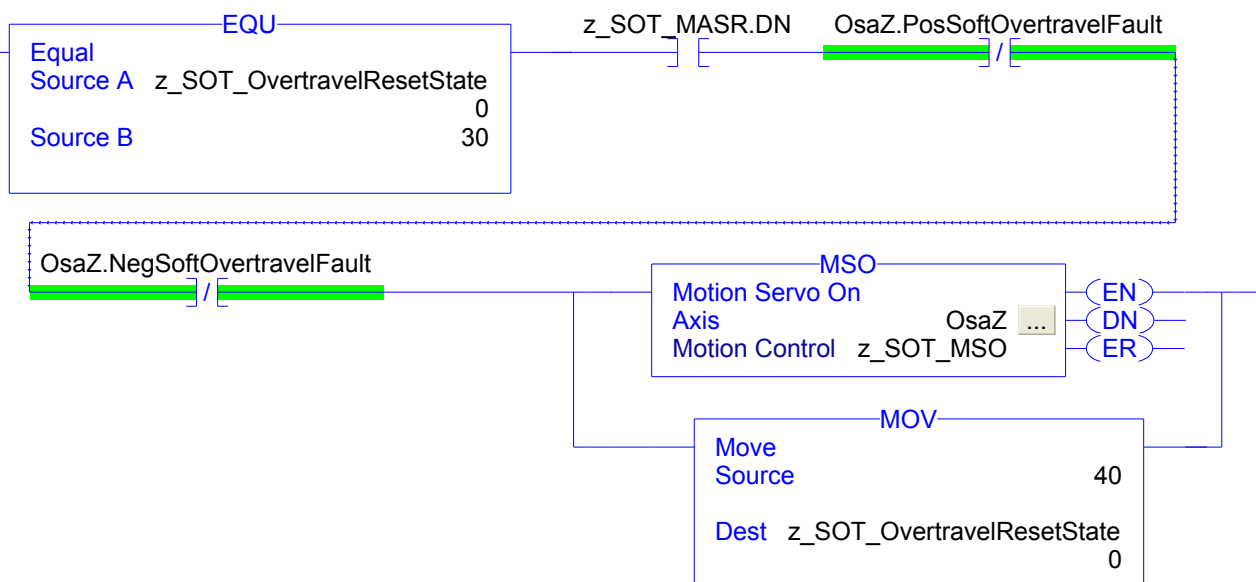
34



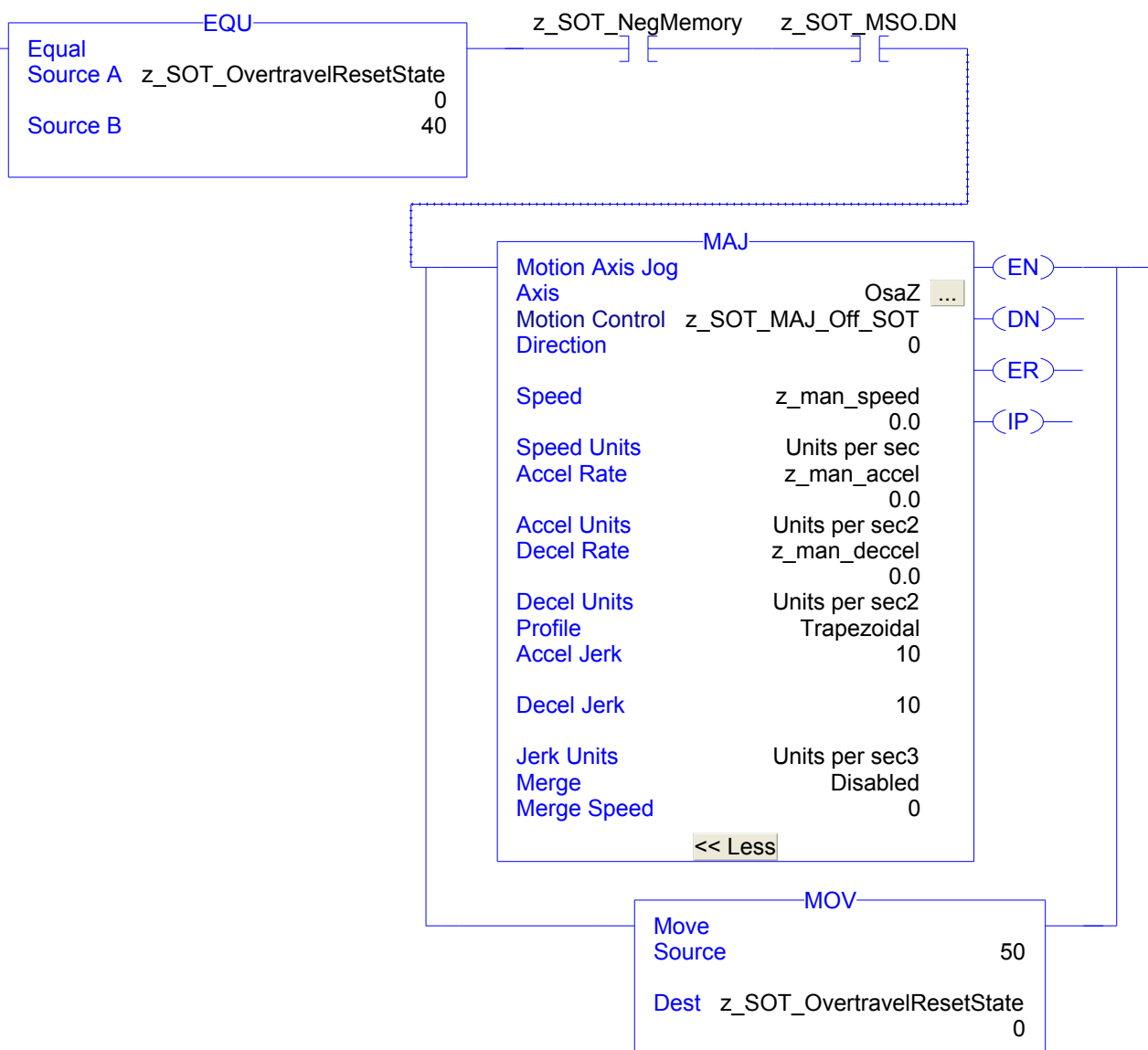
35



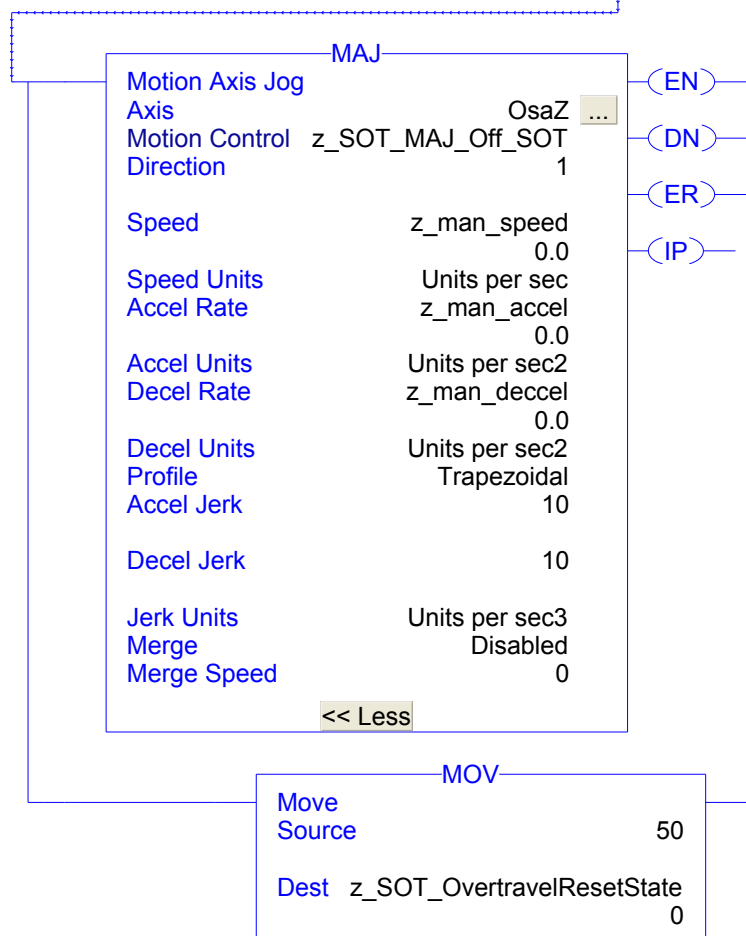
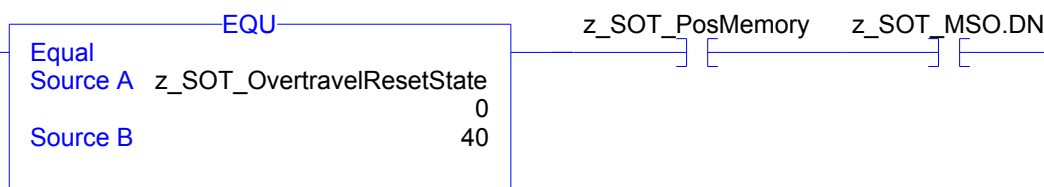
36



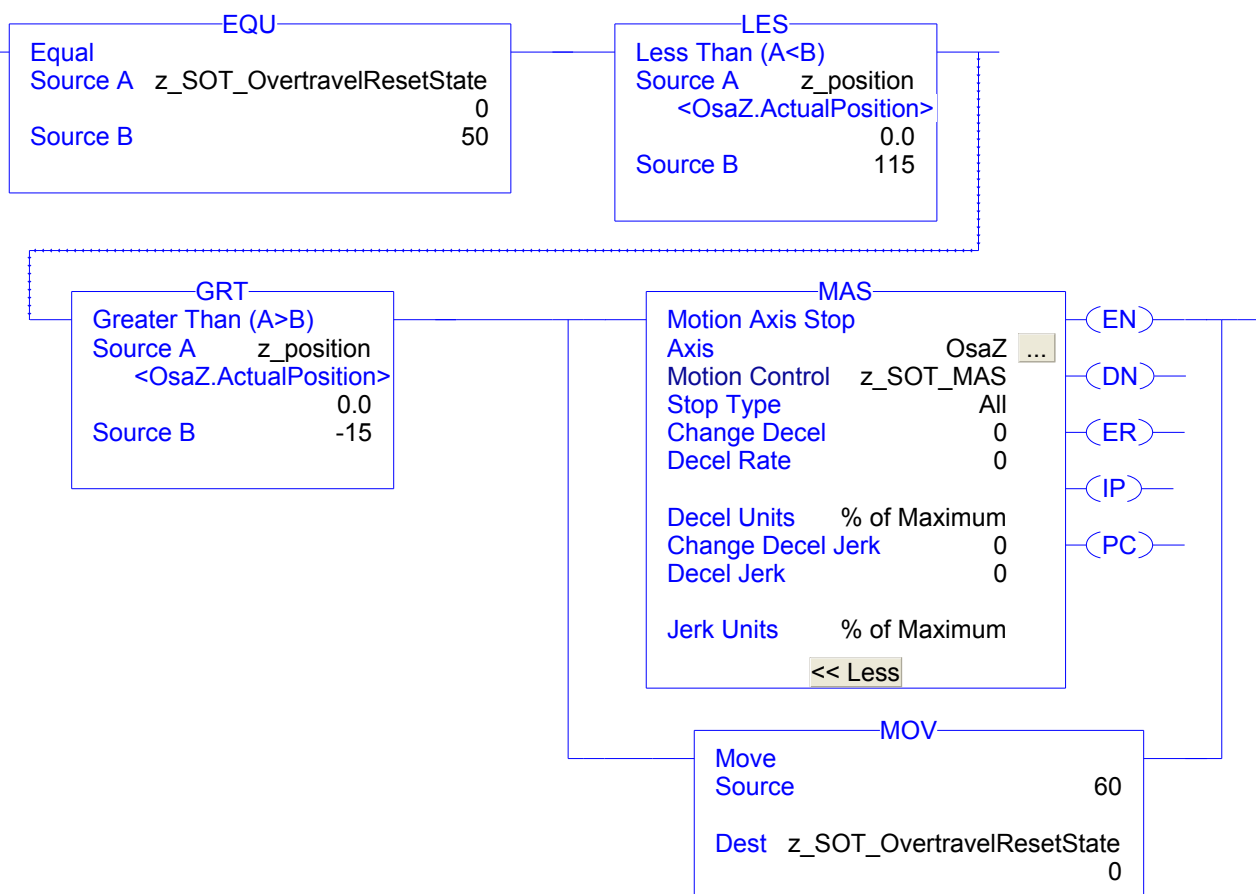
37



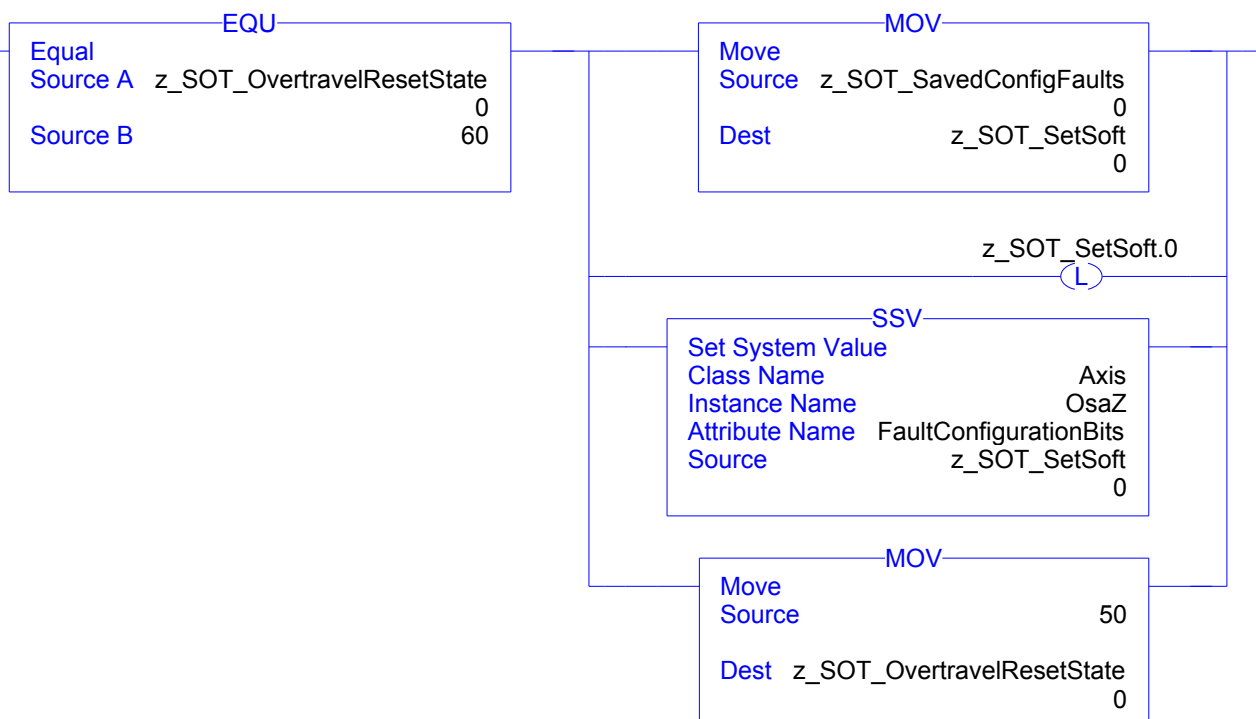
38



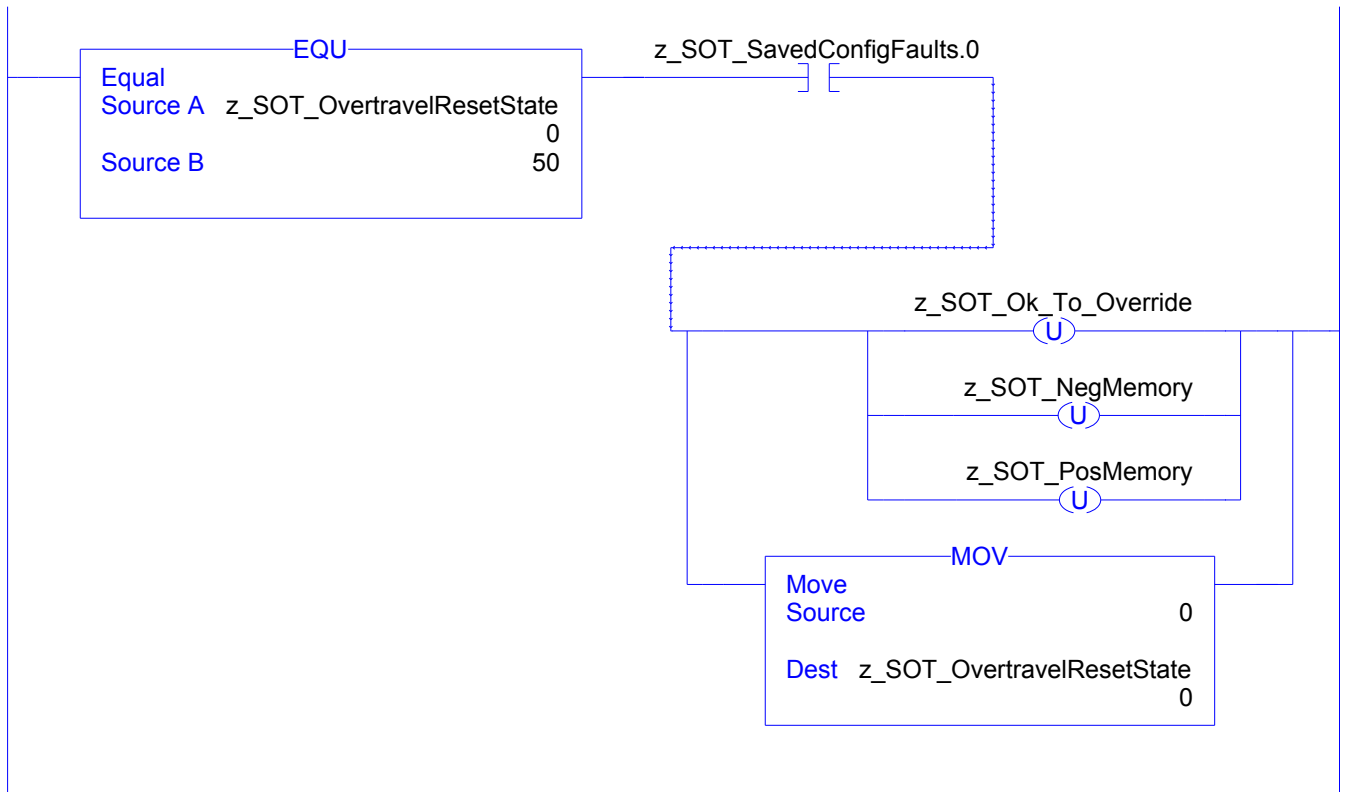
39



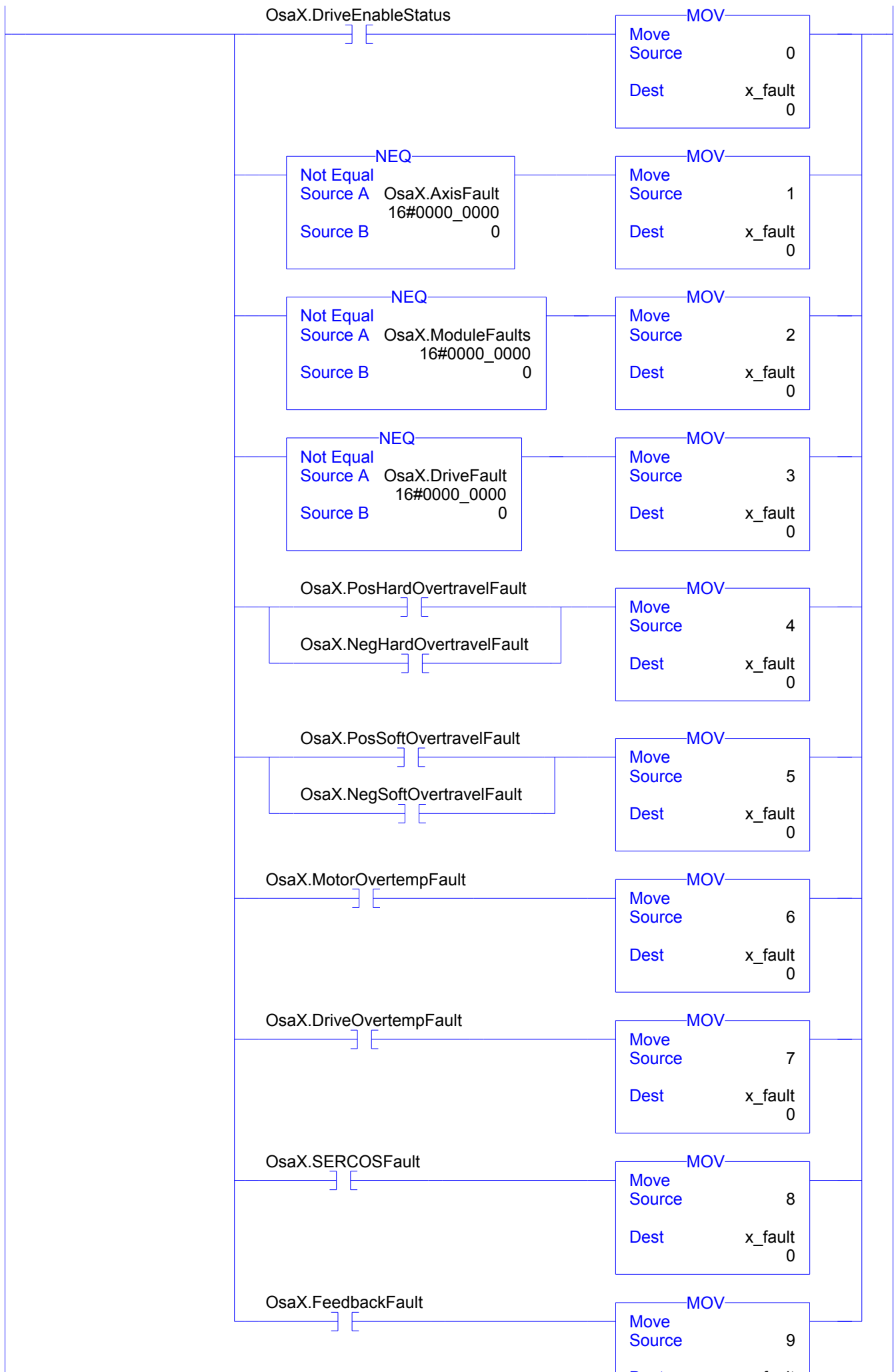
40



41

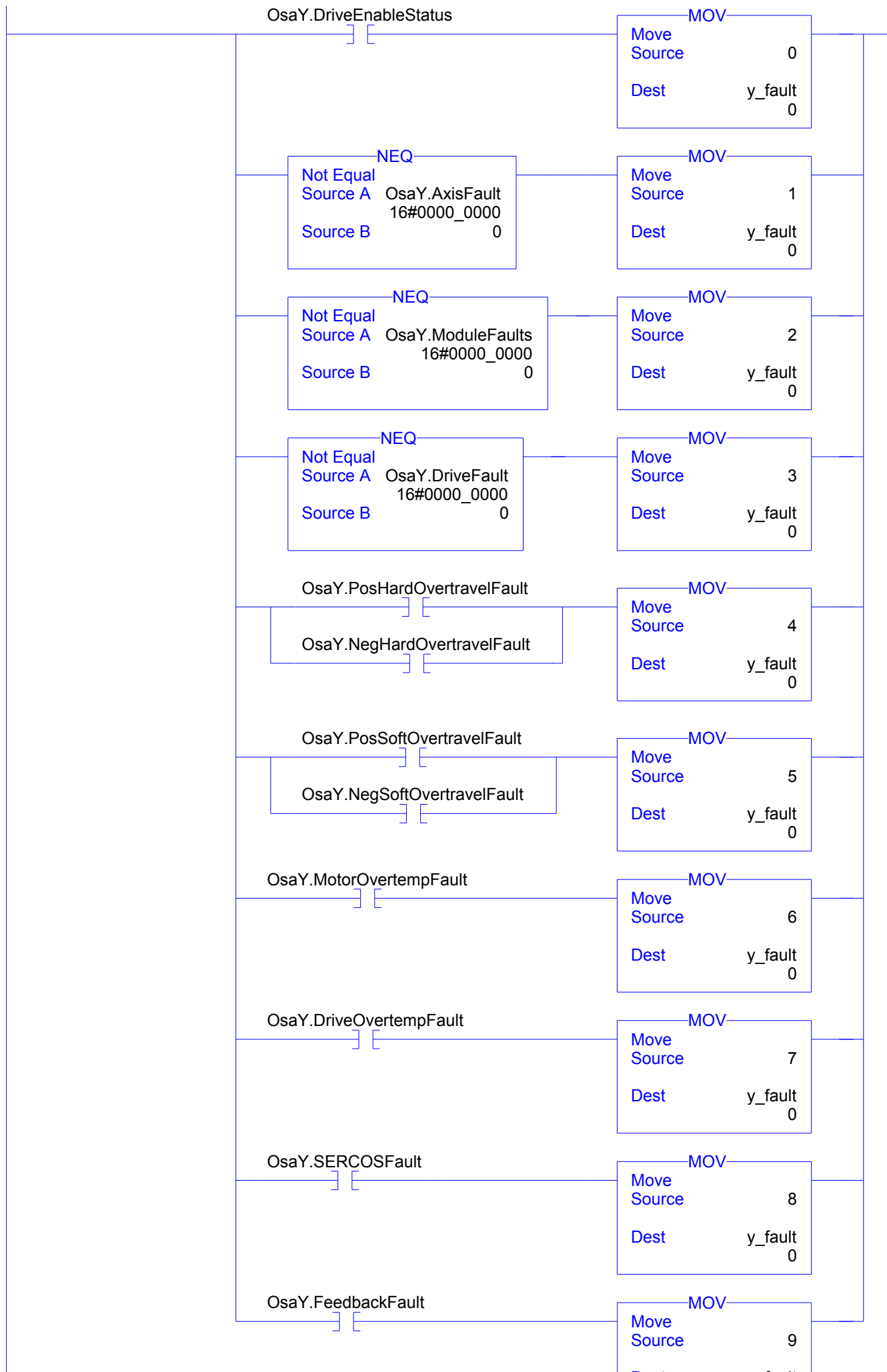


42



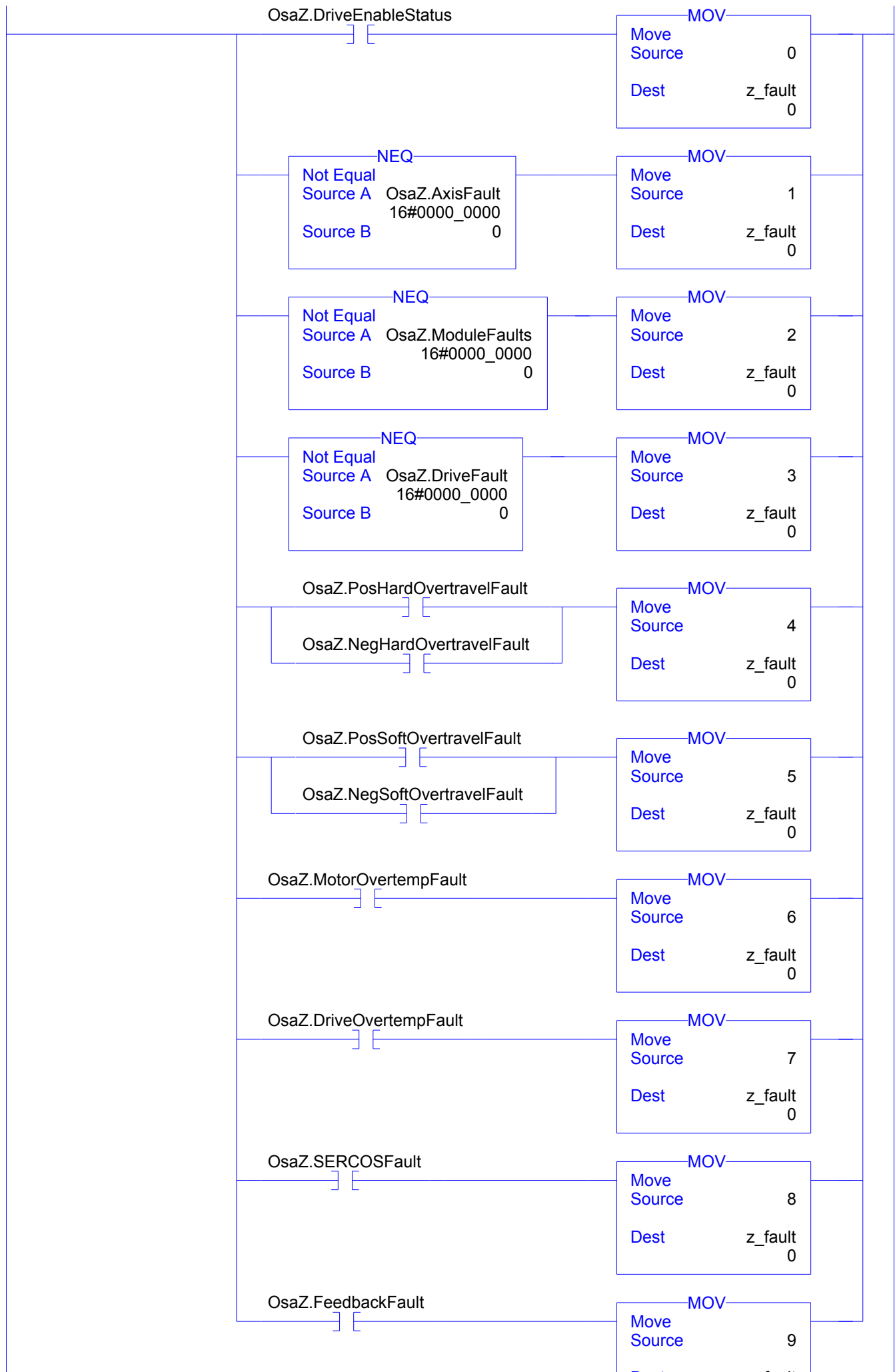
Dest	x_tauit
	0

43



Dest	y_tauit
	0

44



(End)

Dest

z_tauit
0

