LAD 2 - PRINCIPALE - PROGRAMME DE CONTROLE PRINCIPAL --- Total Rungs in File = 11

0000 — PROGRAMME DE SIMULATION DE LA PERCEUSE
JSR
Jump To Subroutine
Prog File Number U:3

0001 — COMMANDES DS ACTIONS ET DES SORTIES
JSR
Jump To Subroutine
Prog File Number U:4

0002 — GRAFCET D'ARRÊT D'URGENCE
JSR
Jump To Subroutine
Prog File Number U:5

0003 — GRAFCET DE MODES DE MARCHES
JSR
Jump To Subroutine
Prog File Number U:6

0004 — GRAFCET DE PRODUCTION NORMALE
JSR
Jump To Subroutine
Prog File Number U:7

0005 — GRAFCET D'INITIALISATION
JSR
Jump To Subroutine
Prog File Number U:8

0006 — TRANSITIONS GRAFCET DE PRODUCTION NORMAL E
JSR
Jump To Subroutine
Prog File Number U:9

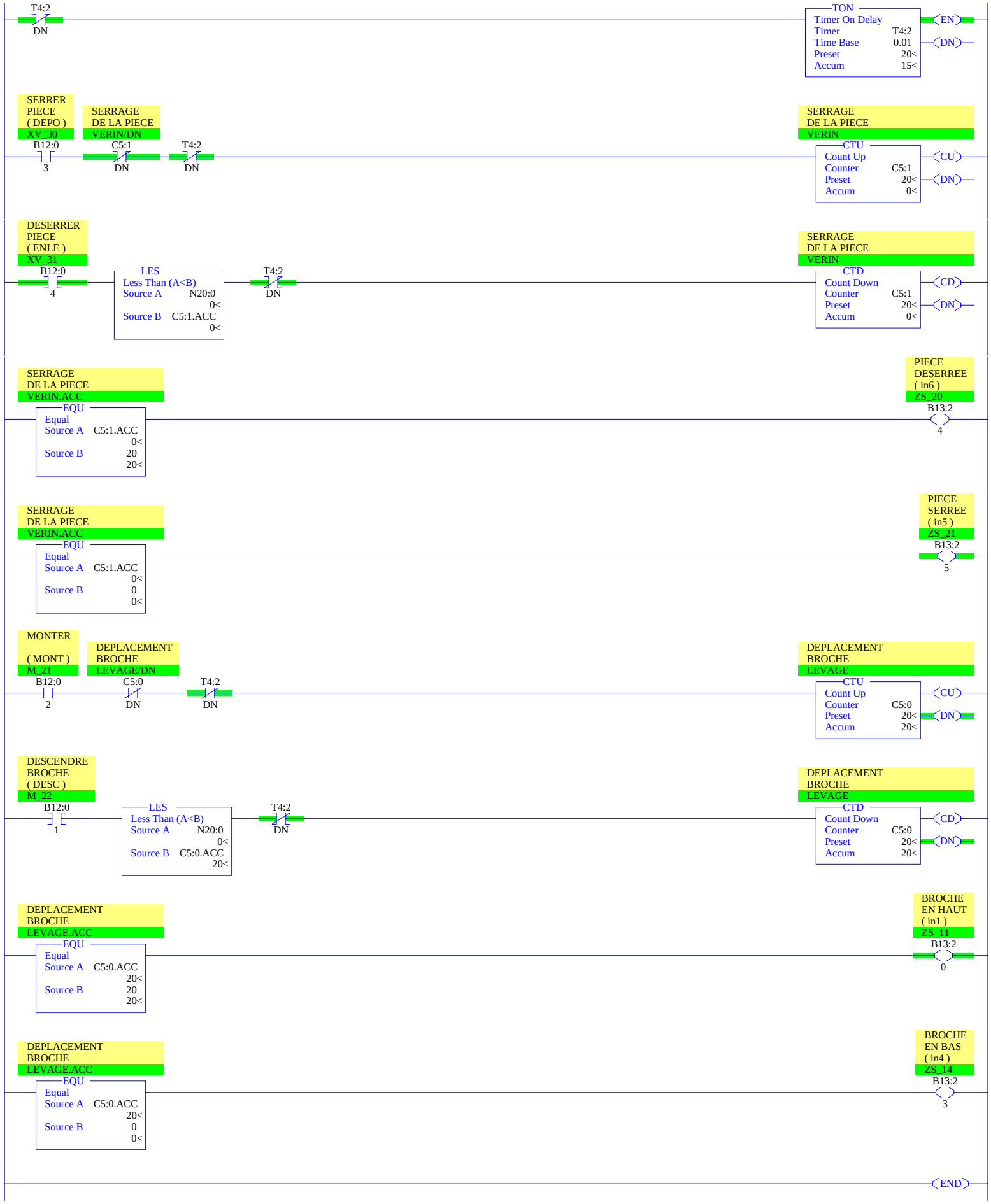
0007 — ETAPES GRAFCET DE PR ODUCTION NORMALE
JSR
Jump To Subroutine
Prog File Number U:10

0008 — TRANSITIONS GRAFCET D'INITIALISATION PRO DUCTION
JSR
Jump To Subroutine
Prog File Number U:11

0009 — ETAPES GRAFCET D'INI TIALISATION PRODUCTI ON
JSR
Jump To Subroutine
Prog File Number U:12

0010 — END

LAD 3 - SIMULATION - SIMULATION DE LA PERCEUSE --- Total Rungs in File = 10



LAD 4 - ACTIONS - SORTIES ET ACTIONS DU PROGRAMME --- Total Rungs in File = 10

CONTRÔLE DES ACTIONS ET DES SORTIES DE LA PARTIE COMMANDE

GÉNÈRE UN FRONT MONTANT SUR LA COMMANDE MARCHE

0000
- DEPART DE CYCLE (m) DCY B13:0 1
- COMMANDE FRONT MONTANT DCY_COM B3:0 ONS 1
- BIT FRONT MONTANT DCY_BIT B3:0 2

REMET LES SORTIES ET LES ACTIONS À ZÉRO SUR UNE COMMANDE D'ARRÊT D'URGENCE

0001
- ETAPE_1 ARRET URGENCE X_1 B11:0 1
- MCR

0002
- ETAPE_21 X_21 B11:1 5
- TEMPORISATEUR DE DELAI POUR LA DESCENTE KC_X21
  - TON
  - Timer On Delay
  - Timer T14:0
  - Time Base 0.01
  - Preset 200<
  - Accum 0<
  - EN
  - DN

0003
- ETAPE_22 X_22 B11:1 6
- DESCENDRE BROCHE (DESC) M_22 B12:0 1

0004
- ETAPE_23 X_23 B11:1 7
- ETAPE_31 X_31 B11:1 15
- MONTER (MONT) M_21 B12:0 2

0005
- ETAPE_24 X_24 B11:1 8
- ROTATION BROCHE (TOUR) M_10 B12:0 0

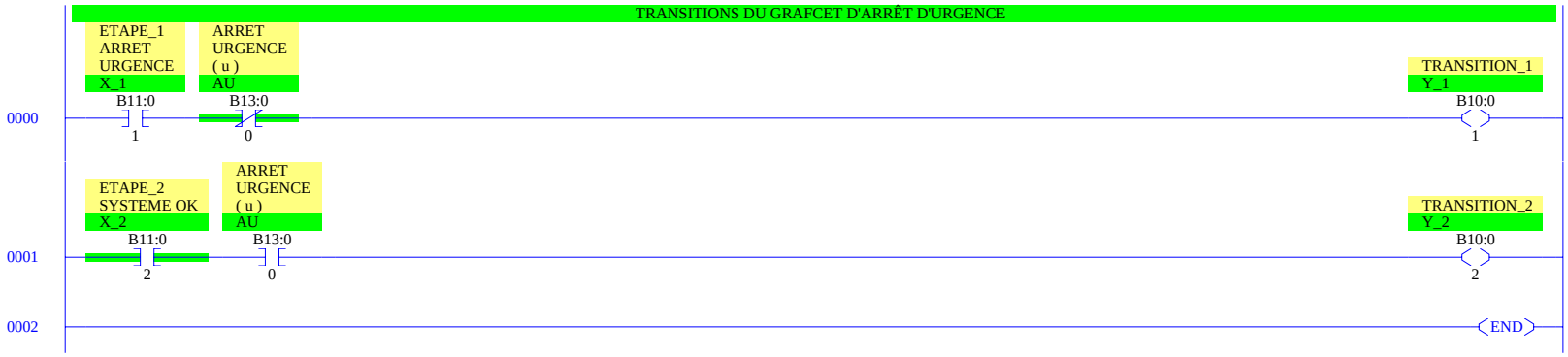
0006
- POSE DE PIECES (p) PIECE B13:0 10
- SERRER PIECE (DEPO) XV_30 B12:0 3

0007
- POSE DE PIECES (p) PIECE B13:0 10
- DESERRER PIECE (ENLE) XV_31 B12:0 4

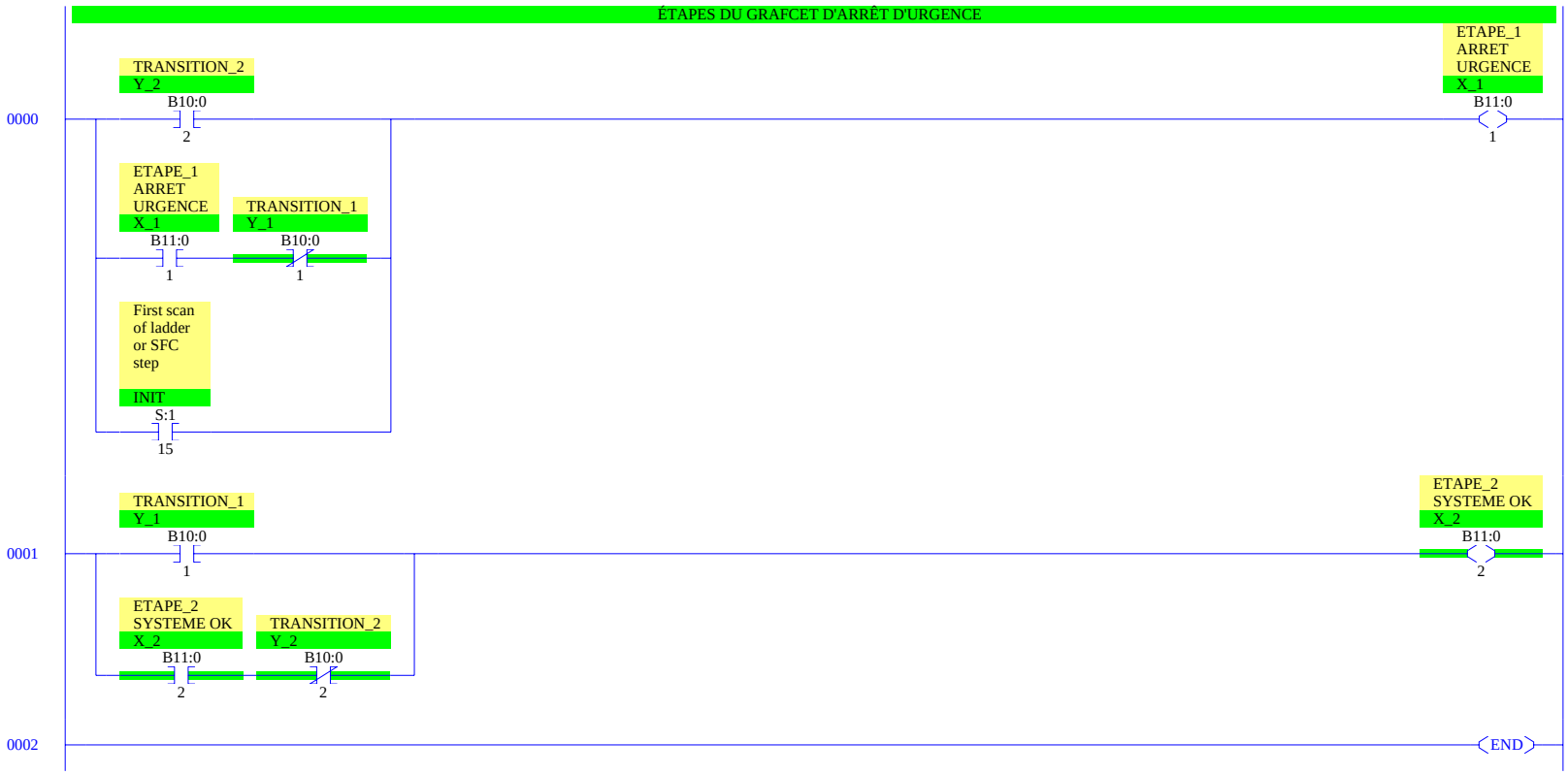
0008
- MCR

0009
- END

LAD 5 - GU_TRANS - TRANSITIONS GRAFCET ARRET D'URGENCE --- Total Rungs in File = 3



LAD 6 - GU_ETAPES - ETAPES GRAFCET ARRET D'URGENCE --- Total Rungs in File = 3



LAD 7 - GMM_TRANS - TRANSITIONS GRAFCET DES MODES DE MARCHES --- Total Rungs in File = 5

LAD 8 - GMM_ETAPES - ETAPES GRAFCET DES MODES DE MARCHES --- Total Rungs in File = 7

ÉTAPES DU GRAFCET DES MODES DE MARCHES

0000
ETAPE_1 ARRET URGENCE X_1 B11:0 1
ETAPE_10 GMM X_10 B11:0 10
ETAPE_10 GMM X_10 B11:0 10
TRANSITION_10 Y_10 B10:0 10
ETAPE_10 GMM X_10 B11:0 10

0001
ETAPE_1 ARRET URGENCE X_1 B11:0 1
MCR

0002
TRANSITION_10 Y_10 B10:0 10
ETAPE_11 INITIALISER COMPTEURS X_11 B11:0 11
ETAPE_11 INITIALISER COMPTEURS X_11 B11:0 11
TRANSITION_11 Y_11 B10:0 11

0003
TRANSITION_11 Y_11 B10:0 11
ETAPE_12 SYSTEME PRET X_12 B11:0 12
TRANSITION_13 Y_13 B10:0 13
ETAPE_12 SYSTEME PRET X_12 B11:0 12
TRANSITION_12 Y_12 B10:0 12

0004
TRANSITION_12 Y_12 B10:0 12
ETAPE_13 SYSTEME EN MODE ARRET X_13 B11:0 13
ETAPE_13 SYSTEME EN MODE ARRET X_13 B11:0 13
TRANSITION_13 Y_13 B10:0 13

0005
MCR

0006
END

LAD 9 - GPN_TRANS - TRANSITIONS GRAFCET DE PRODUCTION NORMALE --- Total Rungs in File = 6

TRANSITIONS DU GRAFCET DE PRODUCTION NORMALE

0000
ETAPE_20 X_20 B11:1 4 | ETAPE_13 SYSTEME EN MODE ARRET X_13 B11:0 13 | TRANSITION_20 Y_20 B10:1 4

0001
ETAPE_21 X_21 B11:1 5 | TEMPS DE DELAI POUR LA DESCENTE KI_X21 T14:0 DN | TRANSITION_21 Y_21 B10:1 5

0002
ETAPE_22 X_22 B11:1 6 | BROCHE EN BAS (in4) ZS_14 B13:2 3 | TRANSITION_22 Y_22 B10:1 6

0003
ETAPE_24 X_24 B11:1 8 | ETAPE_23 X_23 B11:1 7 | BROCHE EN HAUT (in1) ZS_11 B13:2 0 | TRANSITION_24 Y_24 B10:1 8

0004
ETAPE_25 X_25 B11:1 9 | ETAPE_12 SYSTEME PRET X_12 B11:0 12 | TRANSITION_25 Y_25 B10:1 9

0005
END

LAD 10 - GPN_ETAPES - ETAPES GRAFCET DE PRODUCTION NORMALE --- Total Rungs in File = 9

ÉTAPES DU GRAFCET DE PRODUCTION NORMALE

0000
TRANSITION_25 Y_25 B10:1 9 | ETAPE_20 X_20 B11:1 4 | ETAPE_20 X_20 B11:1 4 | TRANSITION_20 Y_20 B10:1 4 | ETAPE_10 GMM X_10 B11:0 10

0001
ETAPE_10 GMM X_10 B11:0 10 | MCR

0002
TRANSITION_20 Y_20 B10:1 4 | ETAPE_21 X_21 B11:1 5 | ETAPE_21 X_21 B11:1 5 | TRANSITION_21 Y_21 B10:1 5

0003
TRANSITION_21 Y_21 B10:1 5 | ETAPE_22 X_22 B11:1 6 | ETAPE_22 X_22 B11:1 6 | TRANSITION_22 Y_22 B10:1 6

0004
TRANSITION_22 Y_22 B10:1 6 | ETAPE_23 X_23 B11:1 7 | ETAPE_23 X_23 B11:1 7 | TRANSITION_24 Y_24 B10:1 8

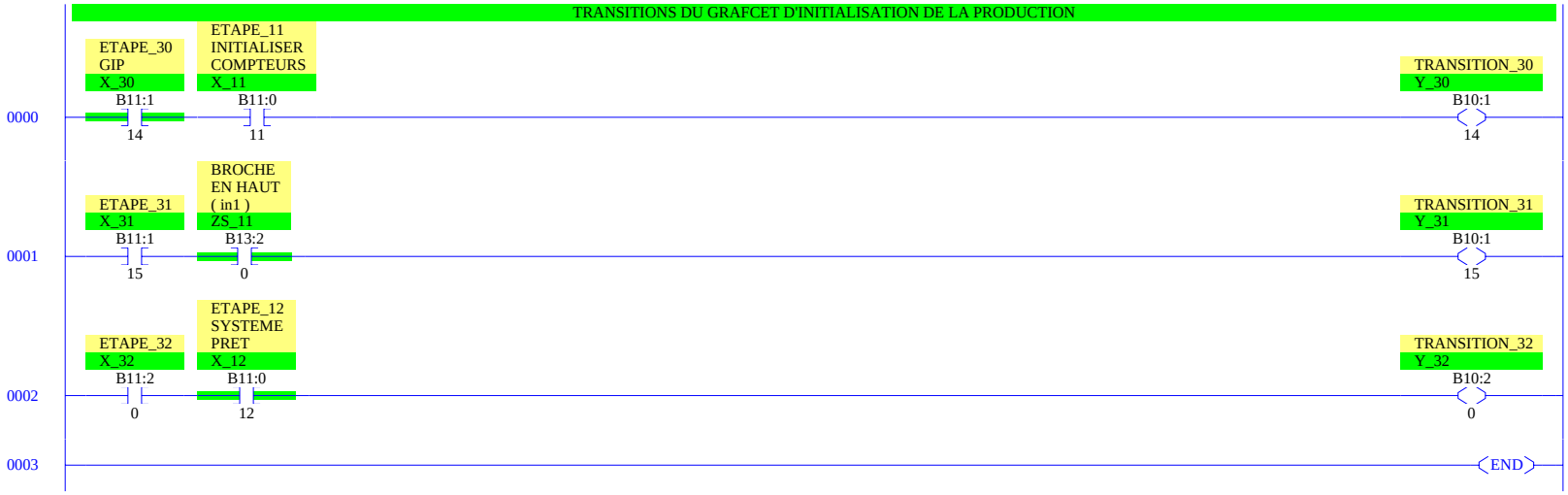
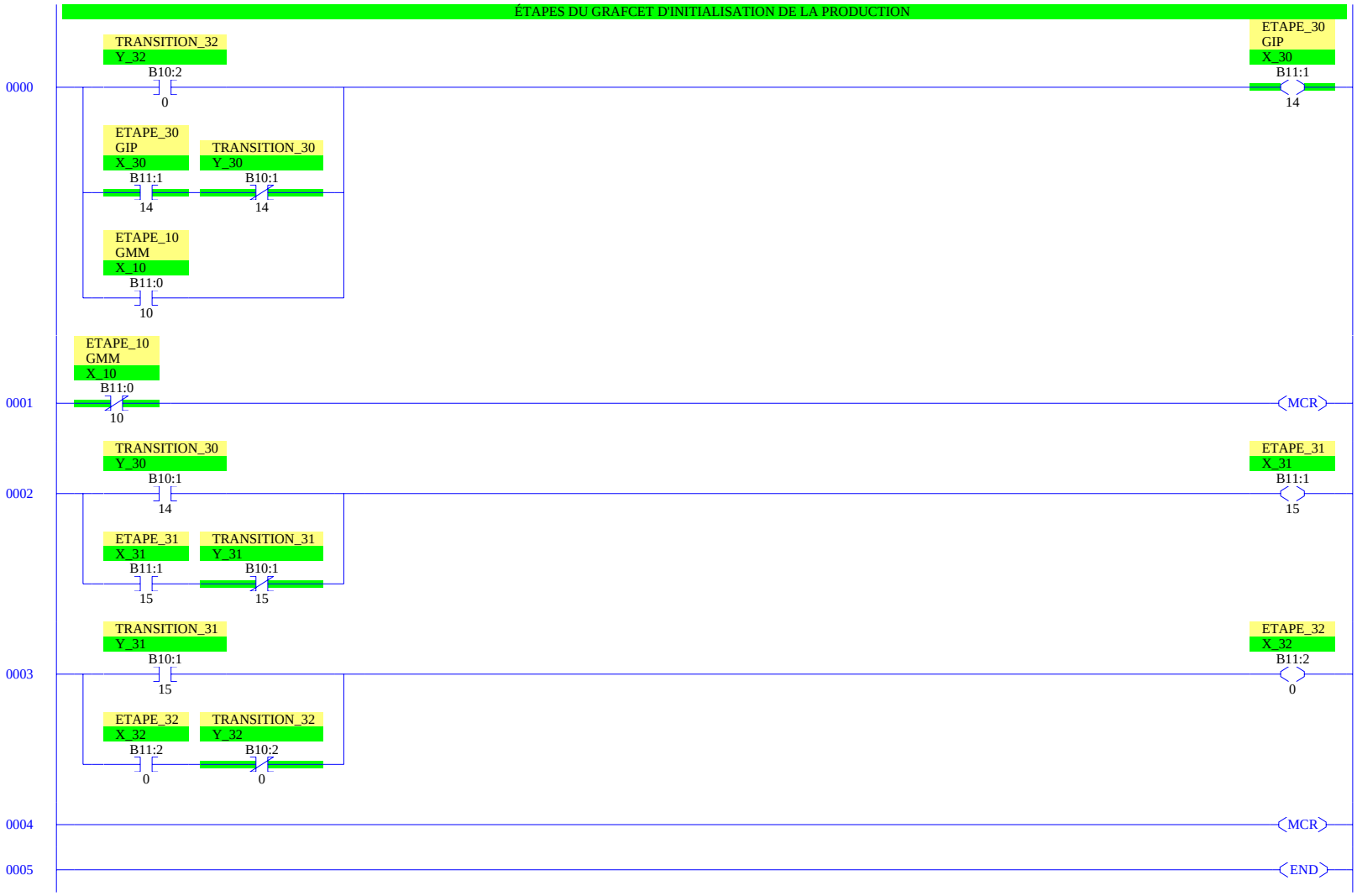
0005
TRANSITION_20 Y_20 B10:1 4 | ETAPE_24 X_24 B11:1 8 | ETAPE_24 X_24 B11:1 8 | TRANSITION_24 Y_24 B10:1 8

0006
TRANSITION_24 Y_24 B10:1 8 | ETAPE_25 X_25 B11:1 9 | ETAPE_25 X_25 B11:1 9 | TRANSITION_25 Y_25 B10:1 9

0007
MCR

0008
END

LAD 11 - GIP_TRANS - TRANSITIONS GRAFCET D'INITIALISATION PRODUCTION --- Total Rungs in File = 4



LAD 12 - GIP_ETAPES - ETAPES GRAFCET D'INITIALISATION PRODUCTION --- Total Rungs in File = 6