

USED PLC RESOURCES

:INPUTS

; I20 = SELECTOR SWITCH 1
; I21 = SELECTOR SWITCH 1
; I22 = SELECTOR SWITCH 1
; I23 = SELECTOR SWITCH 2
; I24 = SELECTOR SWITCH 2
; I25 = PUSH BUTTON “+”
; I26 = PUSH BUTTON “MANRAPID”
; I27 = PUSH BUTTON “-“
; I28 = ENABLING PUSH BUTTON

:REGISTERS

; R60 =
; R61 =

:TIMERS

T17

DEF HDWON M600 ; Movement with handwheel
DEF JOGON M601 ; Movement with Jog buttons
DEF XSEL M602 ; X axis selected
DEF YSEL M603 ; Y axis selected
DEF ZSEL M604 ; Z axis selected
DEF 4SEL M605 ; 4th axis selected
DEF 5SEL M606 ; 5th axis selected
DEF 6SEL M607 ; 6th axis selected
DEF 7SEL M608 ; 7th axis selected

CY1

...
END

PRG

REA

I28 ; enabling push button
AND (I23 OR I24) ; selection switch 2
= HDWON ; movement with handwheel ON

I28 ; enabling push button
AND NOT I23 AND NOT I24 ; no selection switch 2
AND CPS SELECTOR GE 8 ; selection switch CNC
= JOGON ; movement with JOG buttons

NOT I20 AND NOT I21 AND NOT I22 = XSEL ; X axis selected
NOT I20 AND NOT I21 AND I22 = YSEL ; Y axis selected
NOT I20 AND I21 AND I22 = ZSEL ; Z axis selected
NOT I20 AND I21 AND NOT I22 = 4SEL ; 4th axis selected
I20 AND I21 AND NOT I22 = 5SEL ; 5th axis selected
I20 AND I21 AND I22 = 6SEL ; 6th axis selected
I20 AND NOT I21 AND I22 = 7SEL ; 7th axis selected

M2047 = MOV 0 R60

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HDWON AND XSEL = MOV 1 R60
HDWON AND YSEL = MOV 8 R60
HDWON AND ZSEL = MOV $40 R60
HDWON AND 4SEL = MOV $200 R60
HDWON AND 5SEL = MOV $1000 R60
HDWON AND 6SEL = MOV $8000 R60
HDWON AND 7SEL = MOV $40000 R60
;
I23 AND I24 = RL1 R60 1 R60
I23 AND NOT I24 = RL1 R60 2 R60
;
M2047 = OR R60 $40000000 R60           ; Enable handwheel (B30HBEVAR)
;
DFU HDWON                               ; handwheel selected
OR CPS R60 NE R61                       ; or new selection
  = MOV R60 R61
  = CNCWR(R61,HBEVAR,M1000)
DFD HDWON
  = MOV 0 R61
  = CNCWR(R61,HBEVAR,M1000)
;
JOGON AND I25 AND XSEL = AXIS+1
JOGON AND I25 AND YSEL = AXIS+2
JOGON AND I25 AND ZSEL = AXIS+3
JOGON AND I25 AND 4SEL = AXIS+4
JOGON AND I25 AND 5SEL = AXIS+5
JOGON AND I25 AND 6SEL = AXIS+6
JOGON AND I25 AND 7SEL = AXIS+7
;
JOGON AND I27 AND XSEL = AXIS-1
JOGON AND I27 AND YSEL = AXIS-2
JOGON AND I27 AND ZSEL = AXIS-3
JOGON AND I27 AND 4SEL = AXIS-4
JOGON AND I27 AND 5SEL = AXIS-5
JOGON AND I27 AND 6SEL = AXIS-6
JOGON AND I27 AND 7SEL = AXIS-7
;
JOGON AND I26 = MANRAPID
;
DFD I28
  = TG1 17 100
MANUAL AND NOT MDI
AND T17
  = M100
;
...
...
NOT M100 = /STOP
...

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