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**NC**

**Rev: V2 4**

**: 2016 10 10**

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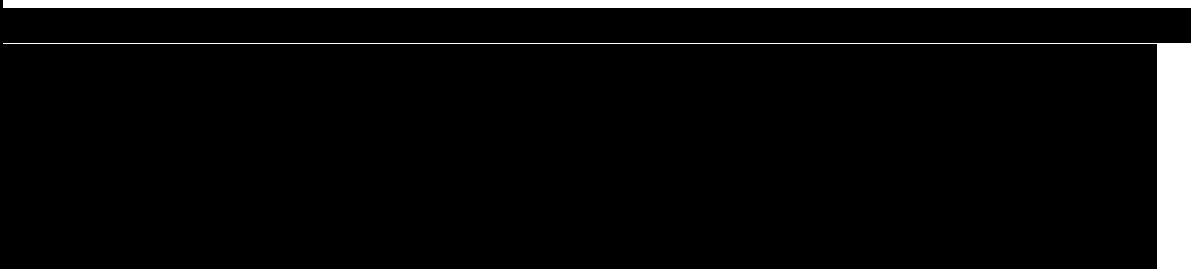
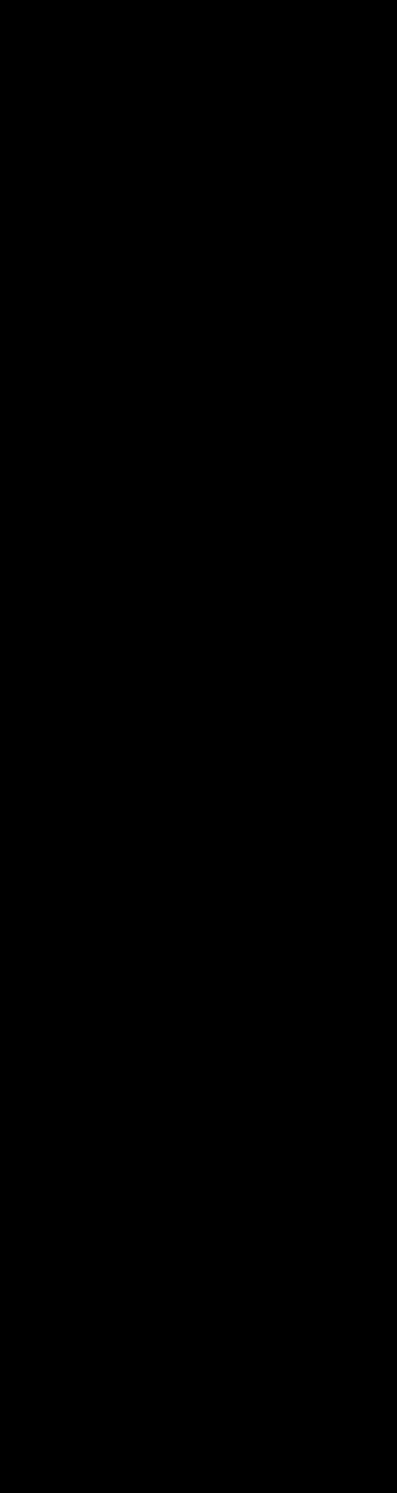
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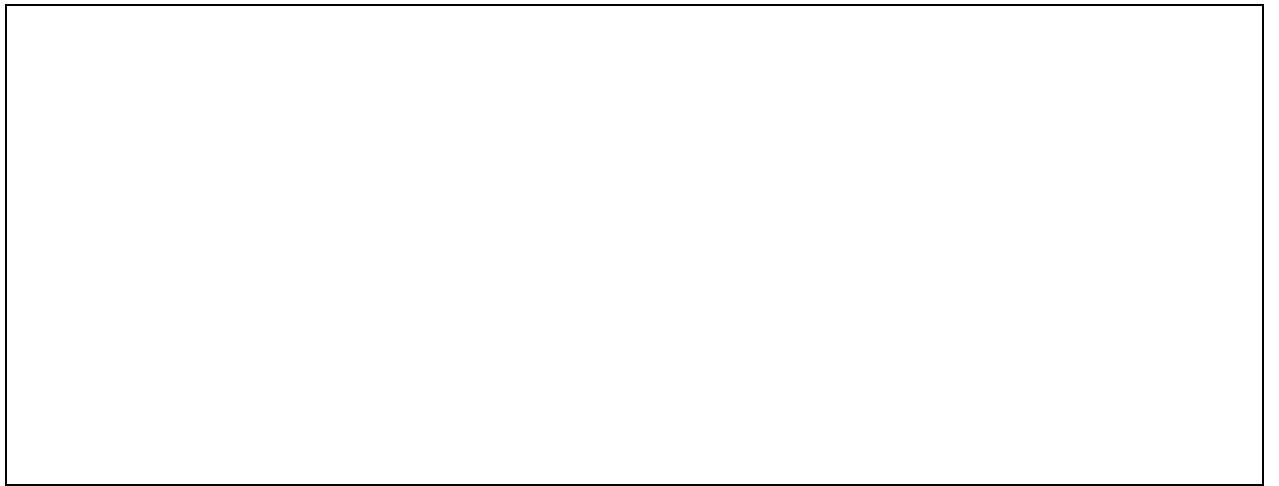
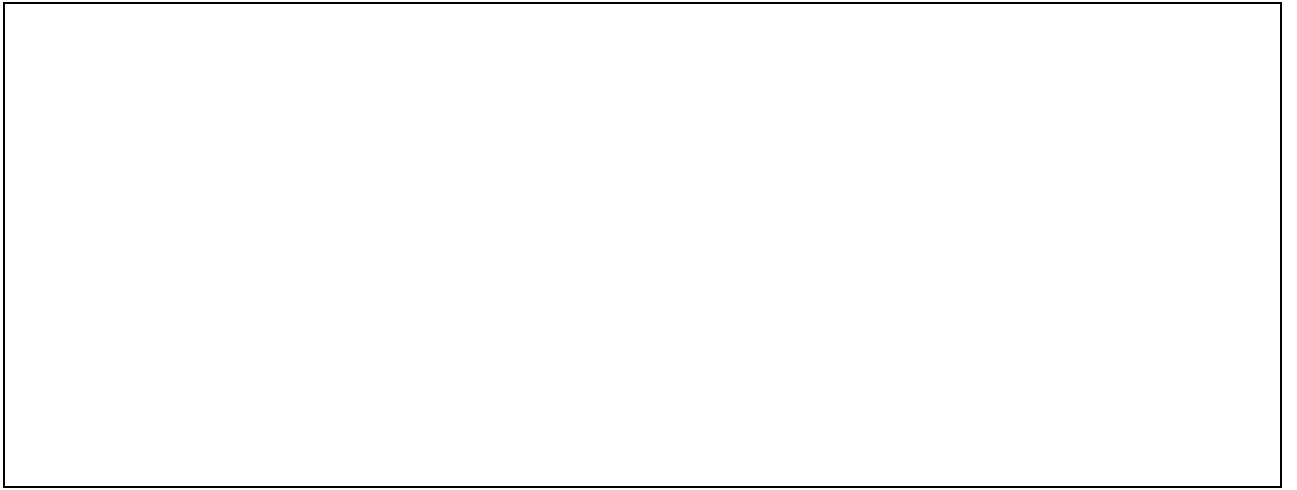
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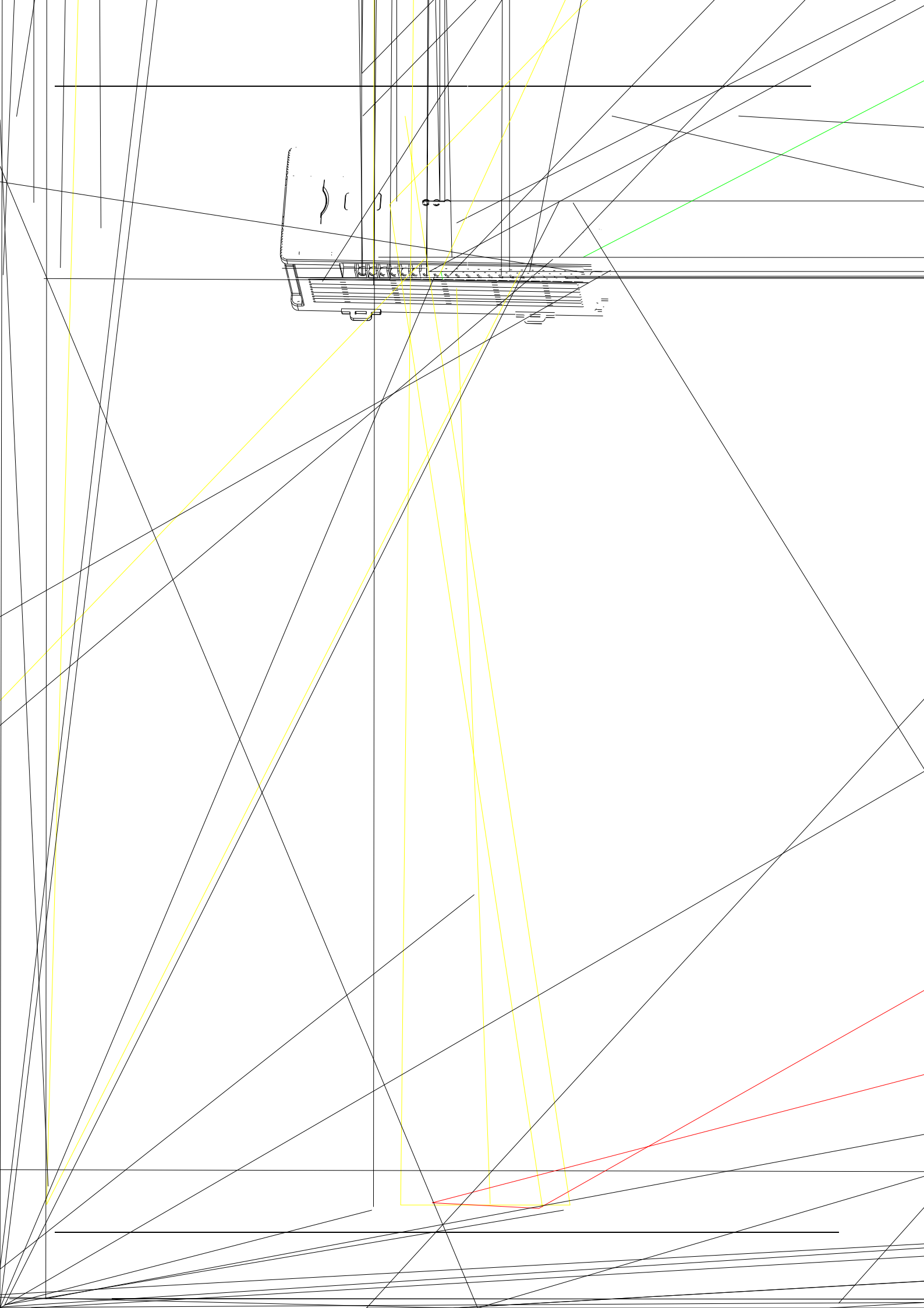


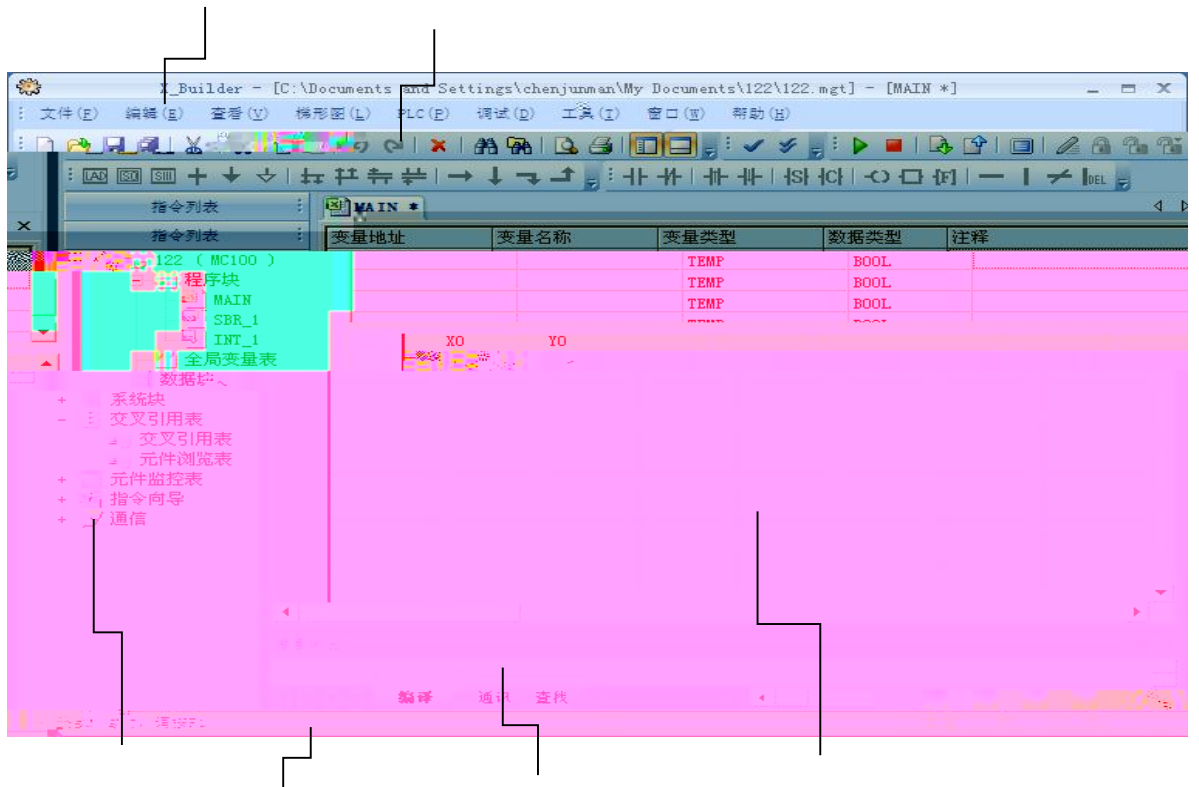
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„L„gà 5RH\$P TME	†^2B Fë™"ð TME PGT„7	H\$`H•"ð TME PGT„(dH	HEH°;iòTc° x f~	

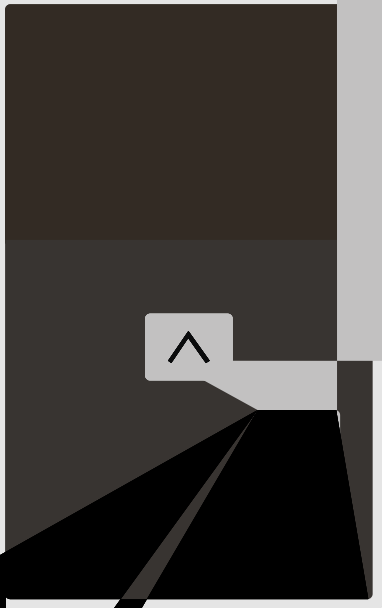














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<b>MC100</b>	

<b>MC200</b>	

<b>MC100</b>	
<b>MC200</b>	

<b>MC200</b>	

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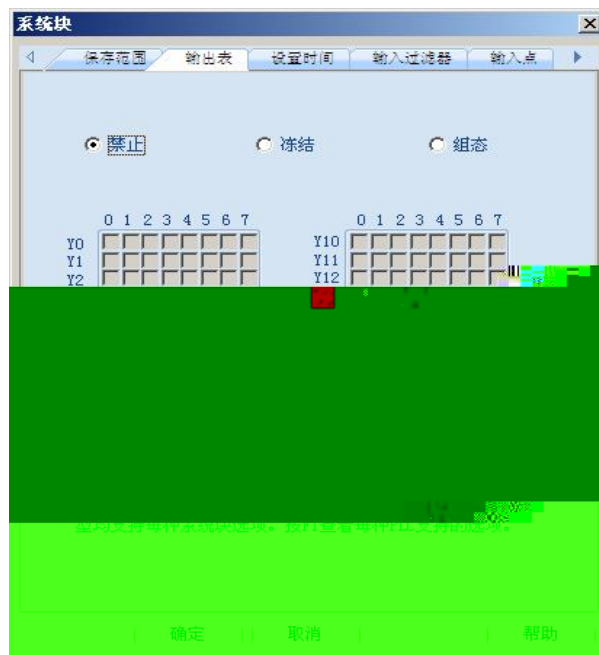


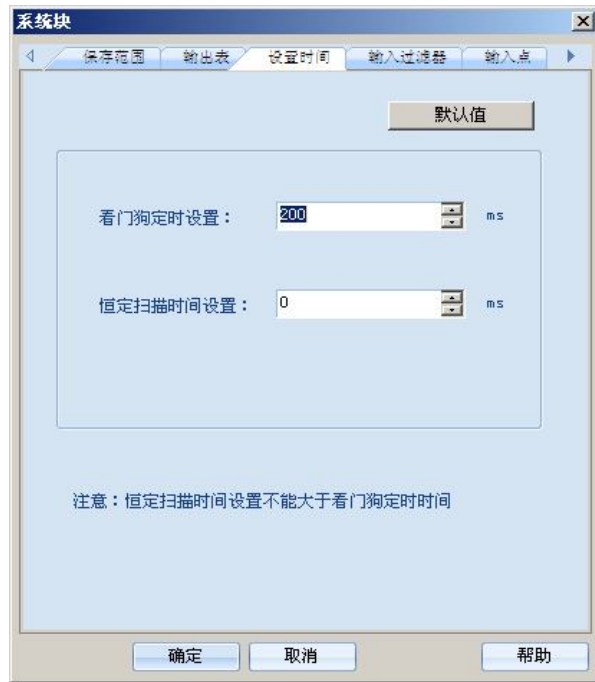
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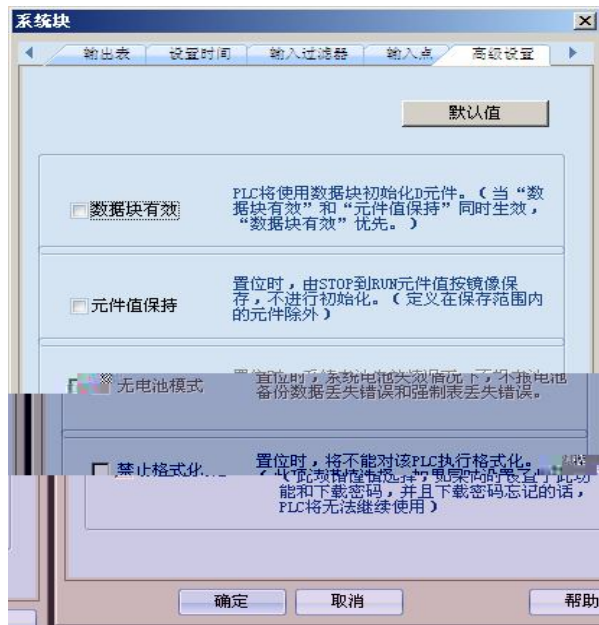
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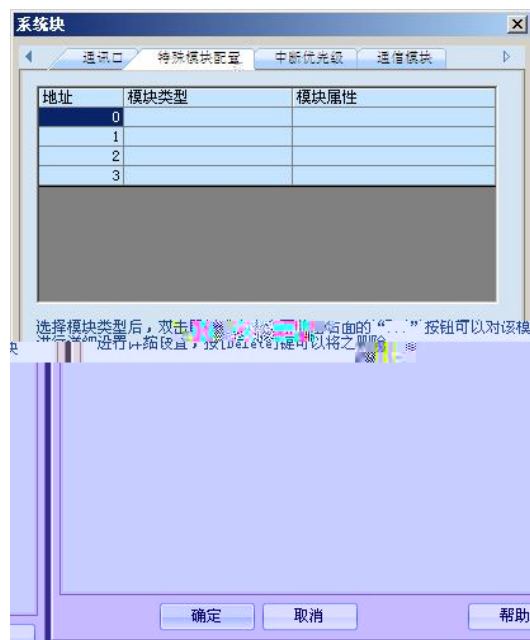
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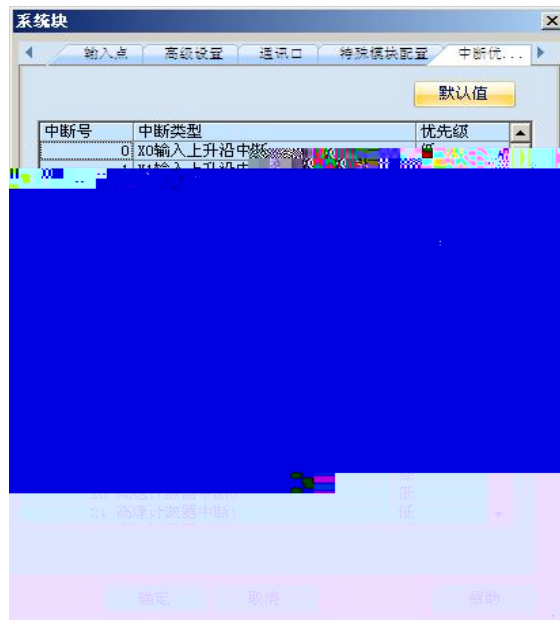


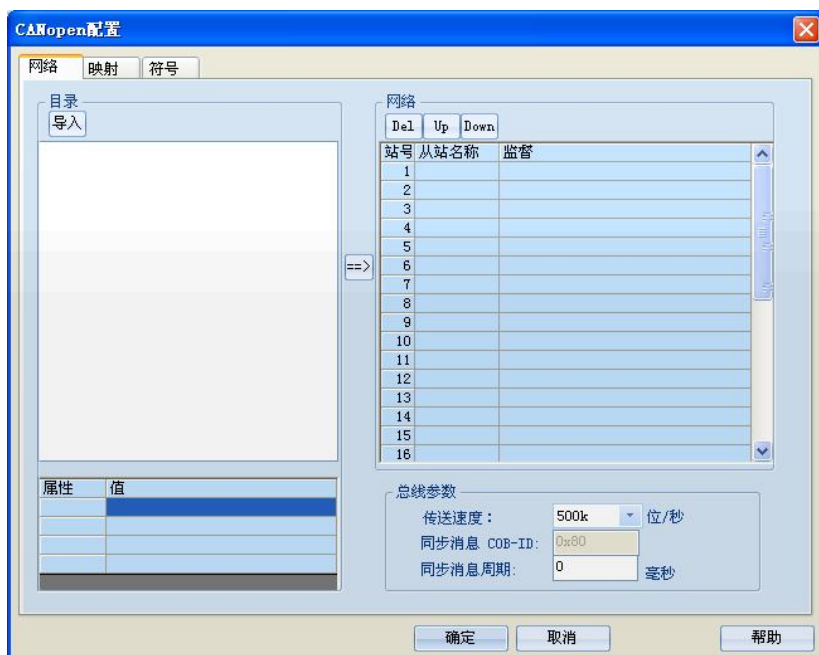
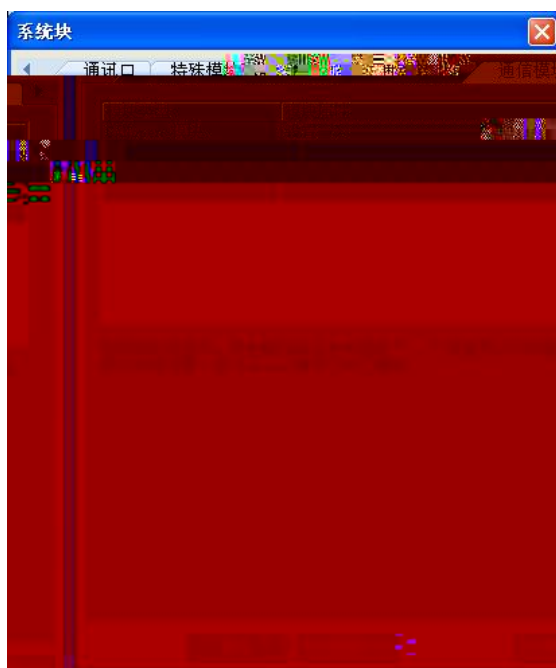












	变量名	变量地址	注释
1	正向定位控制	X4	正向定位控制
2	反向点动	X3	反向点动
3	正向点动	X2	正向点动
4	原点回归	X1	原点回归
5	停止按钮	X0	停止按钮

信息输出

编译 通讯 查找

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PLC时间

时间设置

时 (Hours) : 4

分 (Minutes) : 38

秒 (Seconds) : 38

日期设置

年 (Years) : 2000

月 (Months) : 11

日 (Days) : 16

当前时间 设置时间 关闭窗口

元件值写入

地址	数据类型	ON	是/否
M0	BOOL	ON	<input checked="" type="checkbox"/>

取消

强制元件

地址	数据类型	值	是/否
M0	BOOL	ON	<input checked="" type="checkbox"/>

确定 取消

变量地址	变量名称	变量类型	数据类型	注释
		TEMP	BOOL	
		TEMP	BOOL	
		TEMP	BOOL	
		TEMP	BOOL	

NETWORK 0

MO  [ SET ON YO ]

取消强制

地址	数据类型	是/否
MO	BOOL	<input checked="" type="checkbox"/>

确定

取消

元件名称	数据类型	显示格式	当前值	新数值
1 X1	BOOL	二进制	OFF	
2 Y1	BOOL	二进制	OFF	
3 D1	WORD	十进制	0	
4 D2	WORD	十进制	0	

读取数据寄存器值

输入数据寄存器地址范围：  ---  (一次最大可读取500个地址值)

地址	值	显示类型

从RAM读取  
合并到数据块  
覆盖数据块  
退出



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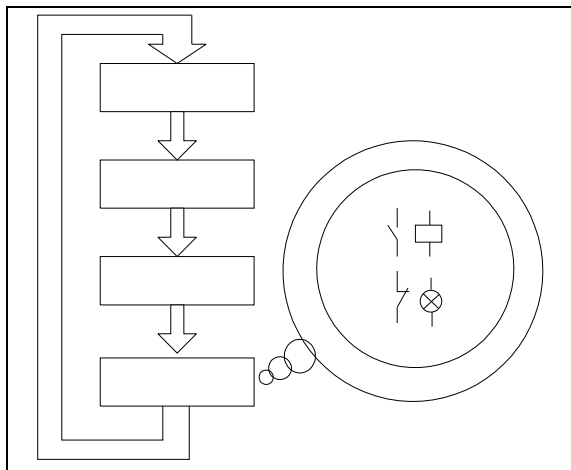
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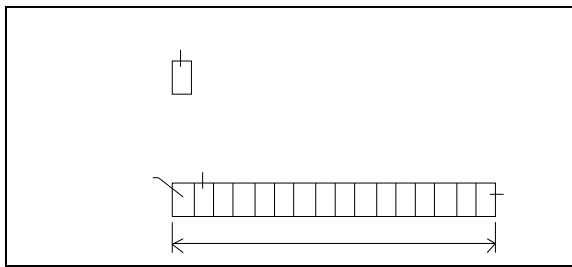
21.2 PLC



221		

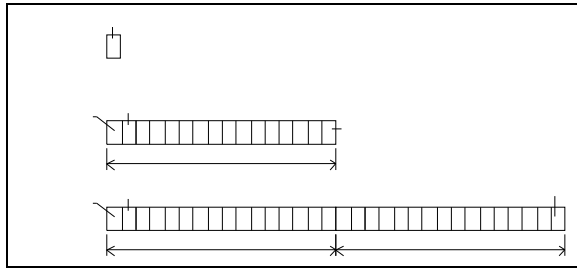


221		




221		





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44

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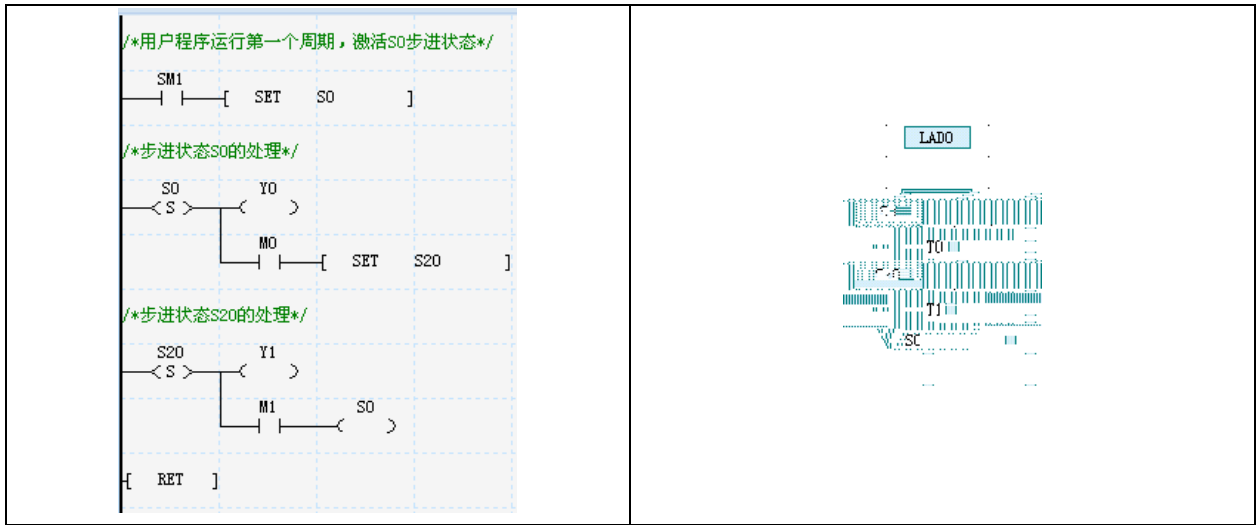
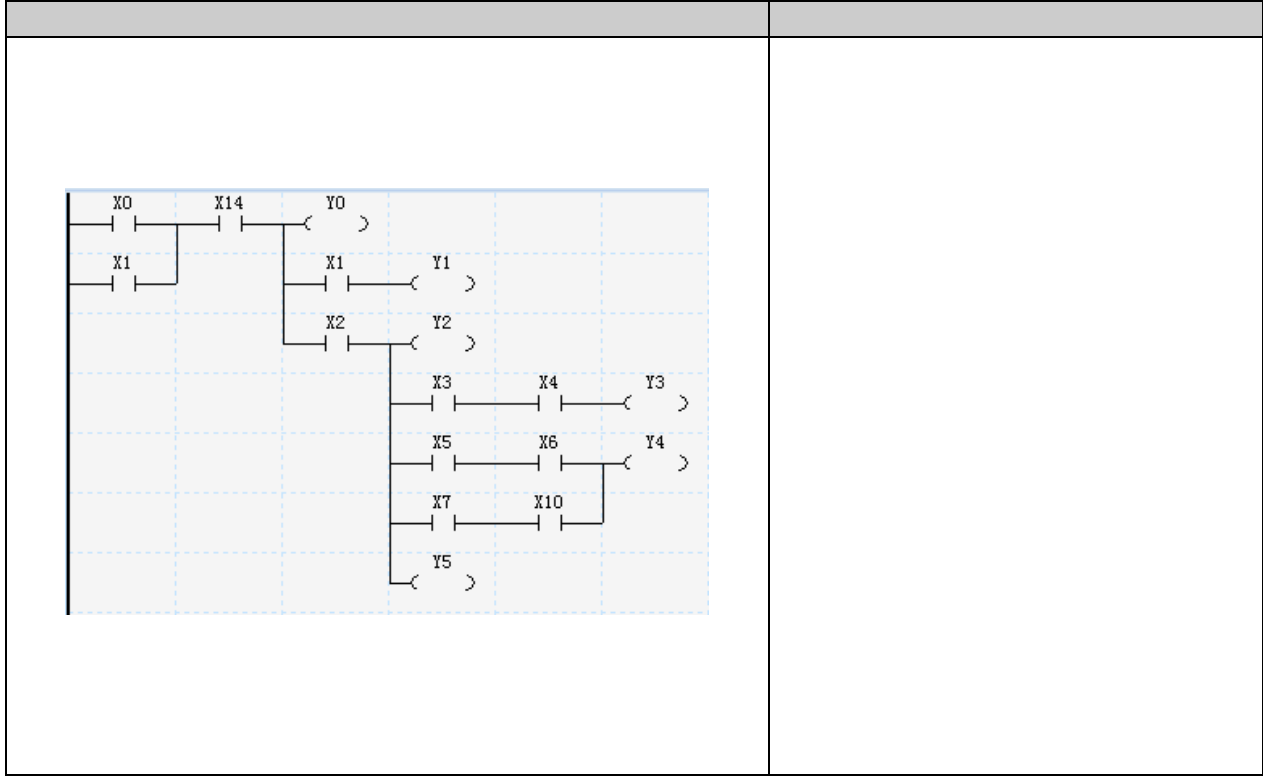


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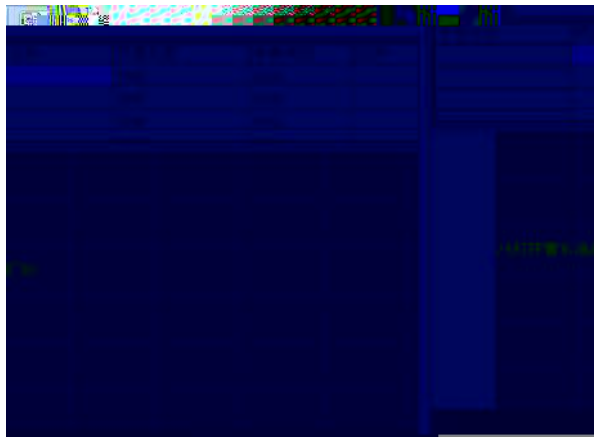
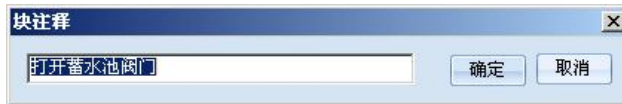
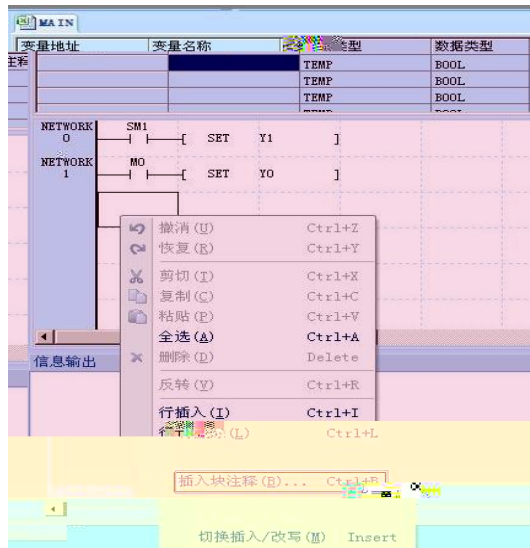
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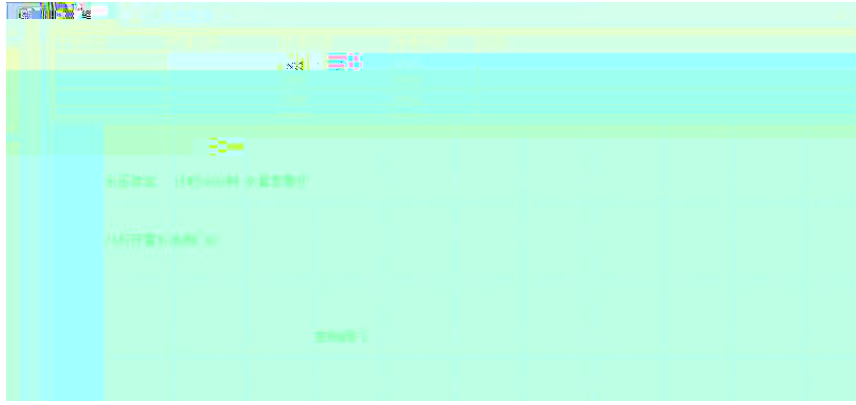






MAIN \* 全局变量表 \* < > X

变量名	变量地址	注释
1 水压	X0	水压标志
2 计时	T0	
3 启动1	M0	
4 启动2	M1	
5 停止1	M2	
6 告警灯	T0	水量告警灯
7 阀门	Y1	控制阀



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MAIN \* SBR\_1 \*

变量地址	变量名称	变量类型	数据类型	注释
V0	IN1	IN	INT	
V1	IN2	IN_OUT	INT	
		OUT	BOOL	
V2	OUT1	TEMP	INT	
		TEMP	BOOL	

B 0

SNO [ ADD V0 V1 V2 ]

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- 
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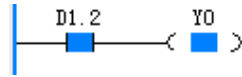
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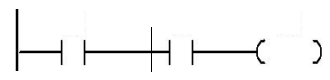
		M200 M100 M80 M280
		1

S

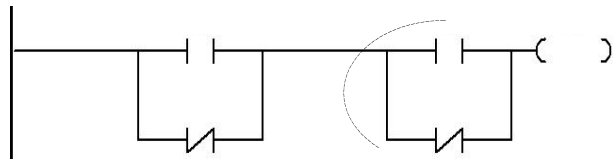


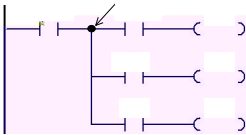
		M200 M100 M80 M280
		1









	<b>M200 M100 M80 M280</b>
	<b>1</b>

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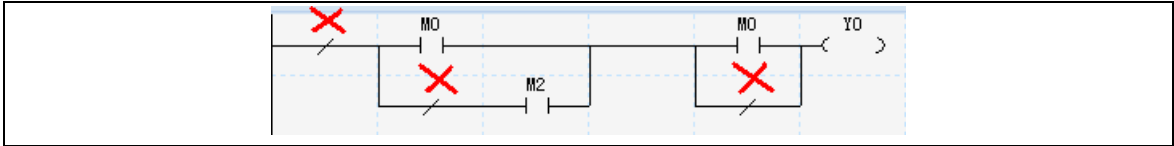
	M200	M100	M80	M280
	2			

[ SET    ON  
          YO       ]

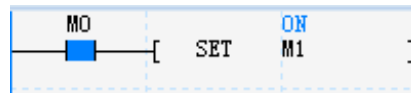
	M200	M100	M80	M280
	2			

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[ SET (D) ]		M200 M100 M80 M280			
		1			



[ RST (D) ]		M200 M100 M80 M280			
<b>RS</b>		1			

S



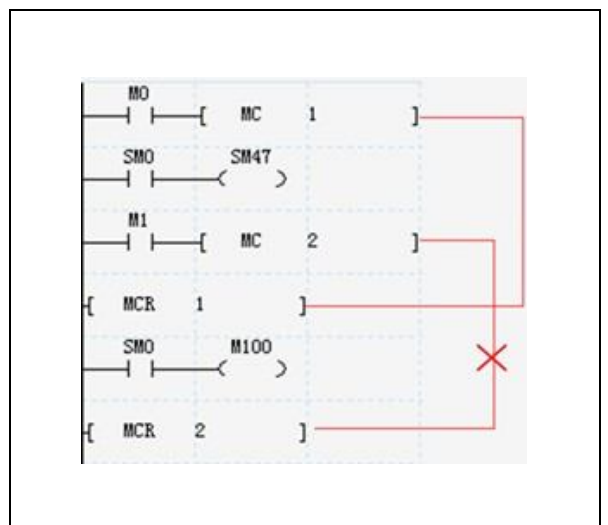
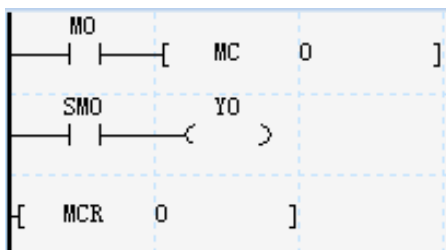
[ NOP ]		M200 M100 M80 M280			
		1			

		<b>M200 M100 M80 M280</b>
		<b>3</b>

S

		<b>M200 M100 M80 M280</b>
		<b>1</b>

S



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<S>		<b>M200 M100 M80 M250</b>
		<b>3</b>

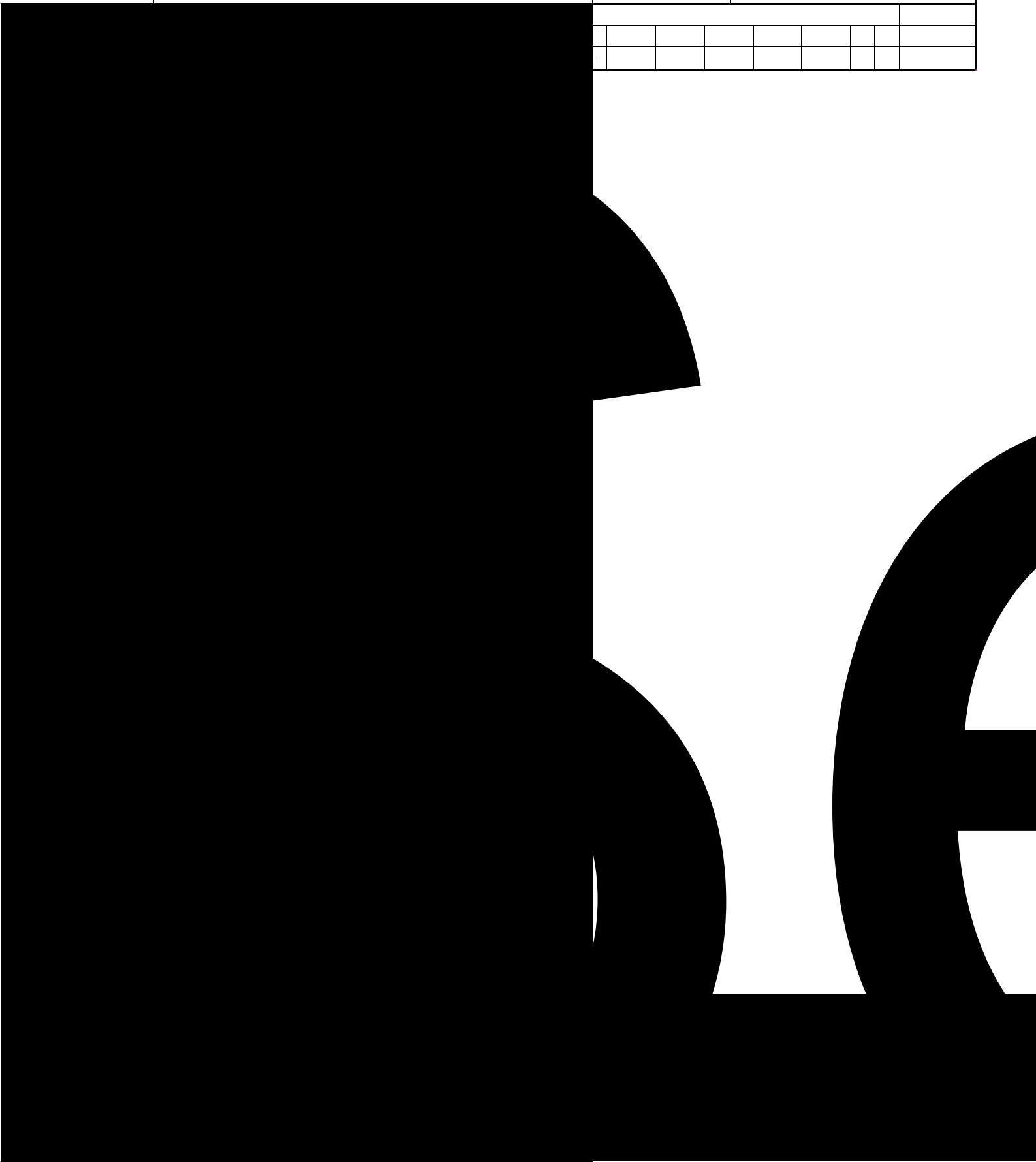
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*D*


[ RET ]		<b>M200 M100 M80 M280</b>
<b>RET</b>		<b>1</b>

	M200 M100 M80 M280			
<i>D S</i>	5			

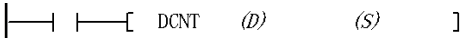


		<b>MC200 MC100 MC80 MC280</b>
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**D**

		<b>MC200 MC100 M80 M260</b>
<i>D S</i>		<b>5</b>

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 <i>D S</i>		<b>M200 M100 M80 M280</b>
		<b>7</b>

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[ FOR (S) ]		M200 M100 M80 M280
S		3

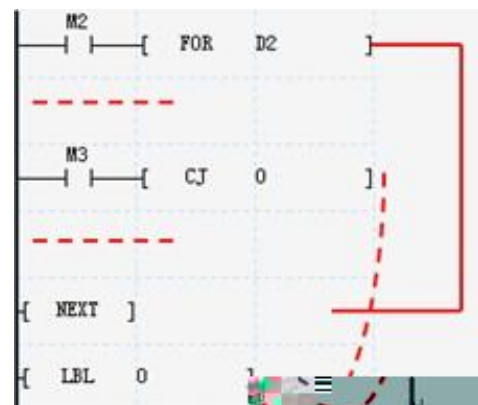
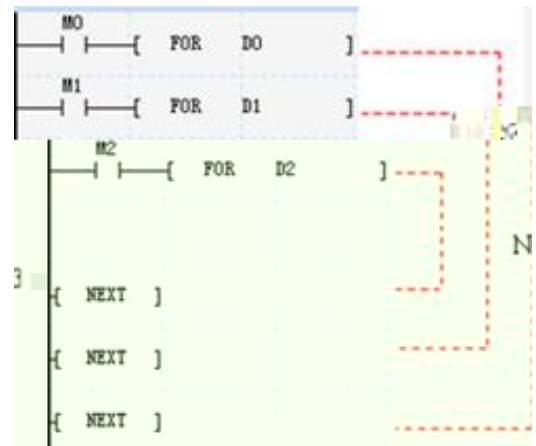
S

[ NEXT ]		M200 M100 M80 M280
		1

```

SM1 | | | [ MOV 0 100 DO ]
M2  | | | [ FOR 100 ]
SM0 | | | [ INC 100 DO ]
[ NEXT ]

```



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M3
| | | [ CJ 0 ]
-----
M2
| | | [ FOR D2 ]
-----
[ LBL 0 ]
-----
[ NEXT ]

```

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MO
| | | [ FOR D1 ]
-----
SMO
| | | [ MC 0 ]
-----
[ NEXT ]
-----
[ MCR 0 ]

```



		MC200	MC100	MC80	MC280
[ LBL (S) ]					
<b>S</b>		<b>3</b>			

**S**

**S**

```

[ LBL 0 ]
-----
MO
| | | [ CJ 0 ]
-----
SMO
| | | [ MOV 100 D0 ]
| | | [ CFEND ]
-----
[ LBL 0 ]
-----
M1
| | | [ MOV 200 D0 ]

```

重要的标号定义

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—  —[ CJ (S) ]										M200 M100 M80 M280			
<b>S</b>										<b>3</b>			

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—   —  [ WDT ]		<b>M200 M100 M80 M280</b>
		<b>1</b>

Ž5 @ ‡), @HCP € H &!, SãP r~A@d XCP g \$ €A'5 @ ‡), @D 5ô5 @ ‡), @N" 0hdp"BQv â @ ‡), @N"

**M200 M100 M80 M280**

|—| |—| [ EI ]

		M200	M100	M80	M280
[ CALL (子程序名) (参数1) (参数2) ]					
	1	2			

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		M200	M100	M80	M280
[ CSRET ]					
CSRET		1			

—   —  [ MOV (S) (D) ]										M200 M100 M80 M280			
<i>S D</i>										5			

*S*

*D*

*S*

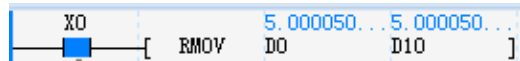
*D S*

X0 [ MOV 500 500 ]  
 DO D0 D10

—   —  [ DMOV (S) (D) ]										M200 M100 M80 M280			
<i>S D</i>										7			

										M200 M100 M80 M280			
[ RMOV (S) (D) ]													
S D										7			

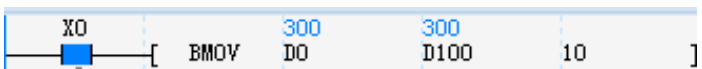
S  
D



S  
D S

										M200 M100 M80 M280			
[ BMOV (S1) (D) (S2) ]													
S1 D S2										7			

S  
D



S2

S1  
S2 D  
S2 S1  
S2

.....

														<b>M200 M100 M80 M280</b>			
[ <i>(S1)</i> FMOV <i>(D)</i> <i>(S2)</i> ]																	
<i>S1</i> <i>D</i> <i>S2</i>														<b>7</b>			

**S1**                                **S1 D S2**  
**D**                                     **S2**  
**S2**                                    **S1 D**

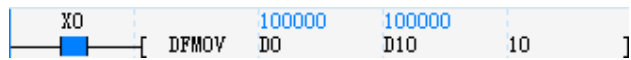
**S1**  
**D**                                **S2**  
**S1**



														<b>M200 M100 M80 M280</b>			
[ DFMOV ( <i>S1</i> ) ( <i>D</i> ) ( <i>S2</i> ) ]																	
<i>S1</i> <i>D</i> <i>S2</i>														<b>9</b>			

**S1**                                **S1 D S2**  
**D**                                     **S2**  
**S2**                                    **S1 D**

**S1**  
**D**                                **S2**  
**S1**



—   —  [ SWAP (D) ]										M200 M100 M80 M280			
D										3			

X0 [ SWAP DO ]

D  
D

—   —  [ XCH (D1) (D2) ]										M200 M100 M80 M280			
D1 D2										5			

D1

D2

D1

D2

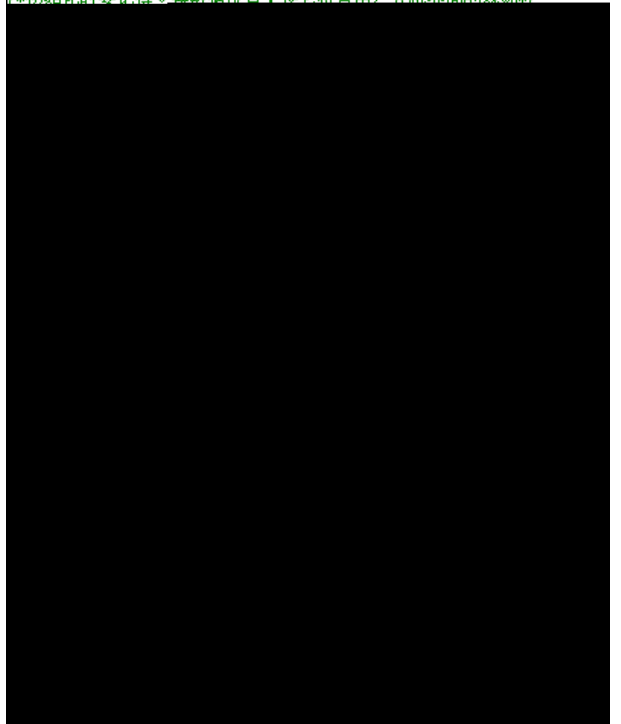
D1 D2

D1

D2

X0 [ XCH DO D10 ]

/\*用户人机界面访问DO D1，对用户来说是可见的\*/  
/\*初始化时要记得交换数据位置，使它符合用户人机界面的规则\*/



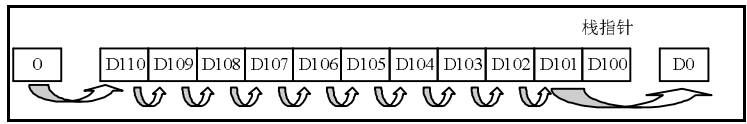
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<b>FIFO</b> / / /										M200 M100 M80 M280							
D1 D2 S										7							

MO	9	1000	10
[ FIFO	D100	D0	]

D1                    D1                    D2  
   D1                D1                S  
  
 D1



D1

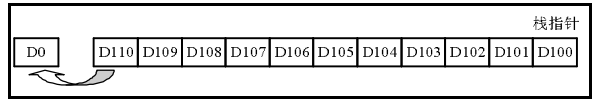
S

—   —  [ LIFO (D1) (D2) (S) ]										M200 M100 M80 M280			
D1 D2 S										7			

—   —  [ LIFO 9 D100 1000 D0 10 ]									
-----------------------------------	--	--	--	--	--	--	--	--	--

S

D2 D1 D1



D1

S

---

M200 M100 M80 M250

[ | | | | WSFR (S1) (D) (S2) (S3) ]

---

MC200

1 1 WSEI (S1) (0) (S2) (S3) 1

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—   —  [ ADD (S1) (S2) (D) ]		M200 M100 M80 M280			
<b>S1 S2 D</b>		<b>7</b>			

S1  
S2  
D

X0	[	ADD	1000 D0	2000 D1	3000 D10	]
----	---	-----	------------	------------	-------------	---

S1 S2 D  
D

—   —  [ SUB (S1) (S2) (D) ]		M200 M100 M80 M280			
<b>S1 S2 D</b>		<b>7</b>			

											M200 M100 M80 M280			
											8			
S1 S2 D														

S1

S2

D

XO	MUL	1000 D0	2000 D1	2000000 D10
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S1 S2 D

											M200 M100 M80 M280			
											7			
S1 S2 D														

S1

S2

S2

D

XO	DIV	2500 D0	1000 D1	2 D10
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S1 S2 D

—   —  [ SQT (S) (D) ]										M200 M100 M80 M280			
S D										5			

S  
D

S

S  
D  
D

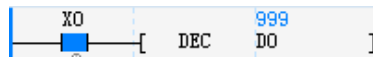
X0	1000	31
—  [ SQT D0 D10 ]		

—   —  [ INC (D) ]										M200 M100 M80 M280			
D										3			

—   —  [ DEC (D) ]										M200 M100 M80 M280			
<i>D</i>										3			

*D*

*D*



—   —  [ VABS (S) (D) ]										M200 M100 M80 M280			
<i>S D</i>										5			

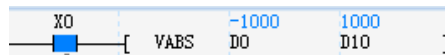
*S*

*S*

*S*

*D*

*D S*



—   —  [ NEG (S) (D) ]										M200 M100 M80 M280			
<i>S D</i>										5			

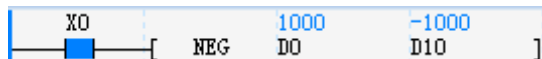
*S*

*S*

*S*

*D*

*D S*



---   ---  [ DADD (S1) (S2) (D) ]										M200 M100 M80 M280			
S1 S2 D										10			

S1  
S2  
D

X0	100000	200000	300000
[ DADD	D0	D2	D10 ]

S1 S2 D  
D

---   ---  [ DSUB (S1) (S2) (D) ]										M200 M100 M80 M280			
S1 S2 D										10			

S1  
S2  
D

X0	100000	200000	-100000
[ DSUB	D0	D2	D10 ]

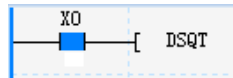
S1 S2 D  
D

										M200 M100		N	
—   —  [ DMUL (S1) (S2) (D) ]													
S1 S2 D												10	

										M100 M80 M280			
—   —  [ DSQT (S) (D) ]													
S D													

S  
D

S



S  
D

Ê

D

Ä, PEö TM€ •rTg# sP';Ö "p,, i]

										M200 M100 M80 M280			
—   —  [ DINC (D) ]													
D										4			

---

—   — [ DDEC (D) ]		M200 M100 M80 M280
--------------------	--	--------------------

---

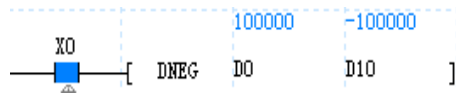
										M200 M100 M80 M280					
—   —  [ DNEG (S) (D) ]															
S D										7					

S  
D

S

S

D S



—   —  [ DSUM (S1) (S2) (D) ]										M200 M100 M80 M280			
S1 S2 D										9			

S1  
S2  
D

S1 S2  
D

S2

S0	[ DMOV 100000 100000 D0 ]
	[ DMOV 200000 200000 D2 ]
	[ DMOV 300000 300000 D4 ]
	[ DMOV 400000 400000 D6 ]
	[ DMOV 500000 500000 D8 ]
X0	[ DSUM 100000 5 150000 D100 ]

—   —  [ RADD (S1) (S2) (D) ]										M200 M100 M280			
S1 S2 D										10			

S1  
S2  
D

S1 S2  
D  
D

X0	[ RADD -1000.20 2000.500 1000.300 D0 D2 D10 ]
----	---

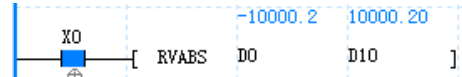


---

---

[ RVABS (S) (D) ]										M200 M100 M280		
S D										7		

S  
D



S D

[ RNEG (S) (D) ]										M200 M100 M280		
S D										7		

S  
D

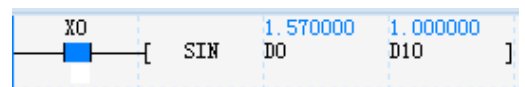


S D

[ SIN (S) (D) ]										M200 M100 M280		
S D										7		

D

S  
D



S  
D

[ COS (S) (D) ]										M200 M100 M280		
S D										7		

S  
D

X0	[	COS	3.140000	-1.00000	]
			D0	D10	

S

D

D

[ TAN (S) (D) ]										M200 M100 M280		
S D										7		

S  
D

X0	[	TAN	1.570000	1255.848	]
			D0	D10	

S

D

D

—   —  [ POWER (S1) (S2) (D) ]											M200 M100 M280					
<i>S1 S2 D</i>											10					

—   —  [ EXP (S) (D) ]											M200 M100 M280					
S D											7					

S  
D

X0	[	EXP	10.00000	22026.46	]
			DO	D10	

S  
D S  
D

—   —  [ RSLM (S1) (S2) (D) ]											M200 M100 M280					
S1 S2 D											9					

S1  
S2  
D

S1 S2  
D

S2

---

5 2 P I 2 G = 2 X 5 2 ! 2 ! 5 5 5

---

\$ A

---

5 A 7 5 5 / 5 2 ! 2 ! / / 5 5 2 5 ! 5 / 2 5 5 2 P I 3 ! 3 ! / 5

—   —  [ ACOS (S) (D) ]													MC280		
S D															
													7		

D

S  
D

SMD	[ ATAN	3.140000	1.262481
<input checked="" type="checkbox"/>	DO	D0	D10

S  
D

—   —  [ LOG (S) (D) ]													MC280		
S D															
													7		

D

S  
D

SMD	[ LOG	3.000000	0.477121
<input checked="" type="checkbox"/>	DO	D0	D10

S  
D

—   —  [ RAD (S) (D) ]													MC280		
S D															
													7		

S  
D

S

D

SMD	[ RAD	180.0000	3.141593
<input checked="" type="checkbox"/>	DO	D0	D10

---

$\left[ \begin{array}{c} \text{---} \\ \text{---} \end{array} \right] \text{ DEG } (S) \quad (D) \quad ]$		<b>M280</b>
<i>S</i> <i>D</i>		<b>7</b>

---



—   —  [ DTI (S) (D) ]										M200 M100 M80 M280					
S D										6					

S  
D

S S

D

S  
D

X0	[ DTI	10000	10000
	DO	D10	]



—   —  [ INT	
S	
2± 817	

		M200	M100	M280
		6		
				5

S  
D

S  
D

20, 05 TMB TMB \$R, R 3 F H L TMB TMB of 0 `pp  
6CDq`p

M200 M100 M280

|—| |—| [ DINT (S) (D) ]

—   —  [ BCD (S) (D) ]										M200 M100 M80 M280			
<i>S D</i>										5			

*S*  
*D*

*S*

*D*

*S*

*D*

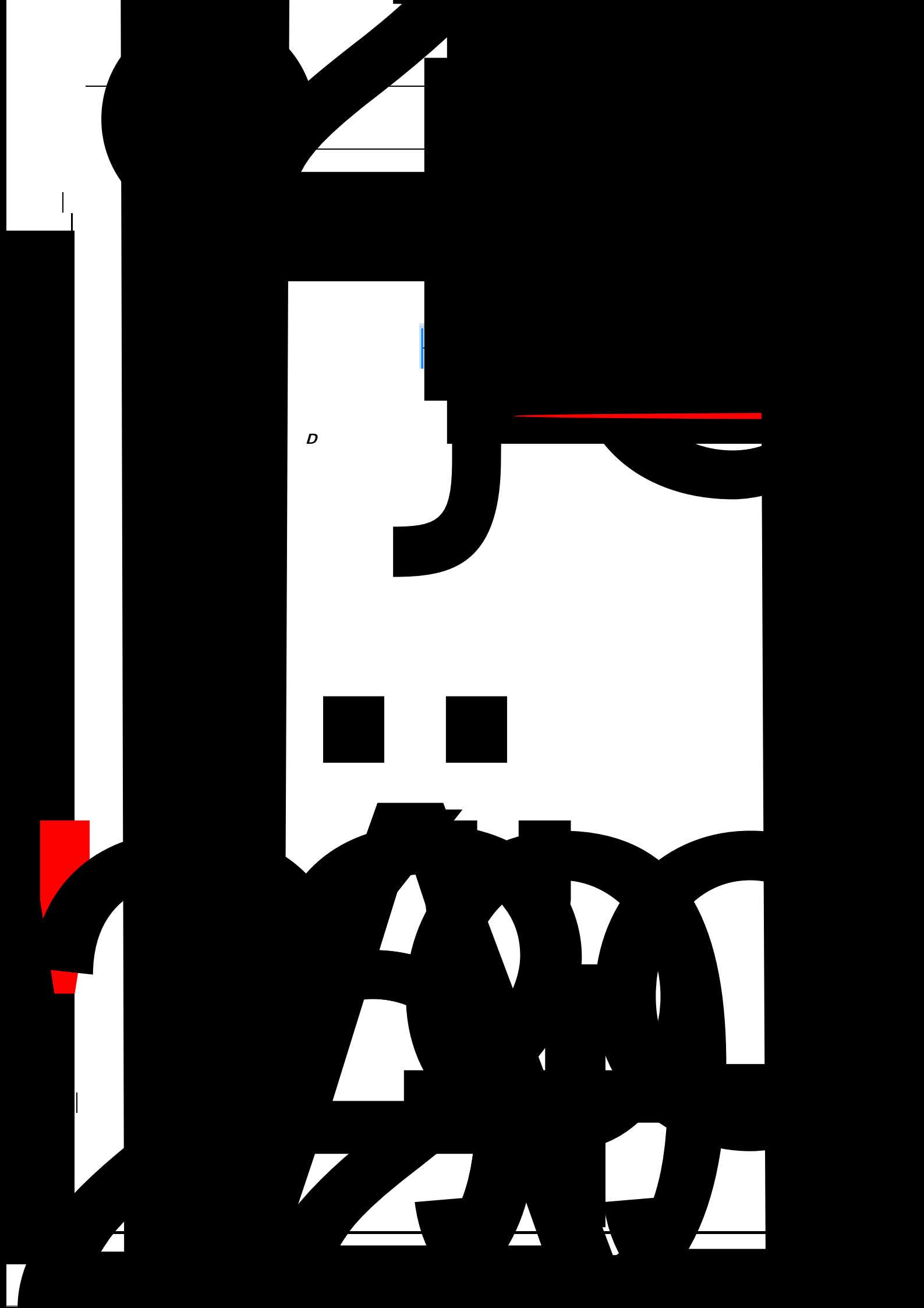
X0	[ BCD	3333	13107
	DO	D10	

[ DBCD (S) (D) ]										M200 M100 M80 M280			
<i>S D</i>										7			

---

[	BIN	(S)	(D)	]
---	-----	-----	-----	---

M200	M100	M80	M280
------	------	-----	------



*D*

|—| |—| [ DGBIN (S) (D) ]

M200 M100 M80 M280

S D

7

S  
D

XO [ DGBIN 3435973836 2290649224 DO D10 ]

S  
D

/ &

M200 M100 M80 M280

|—| |—| [ SEG (S) (D) ]

—   —  [ ASC (S1~S8) (D) ]										
<b>S1 S8 D</b>										

S1 S8

MO [ ASC

D



D

Ä

M200 M100 M80 M280

|—| |—| [ ITA (S1) (D) (S2) ]

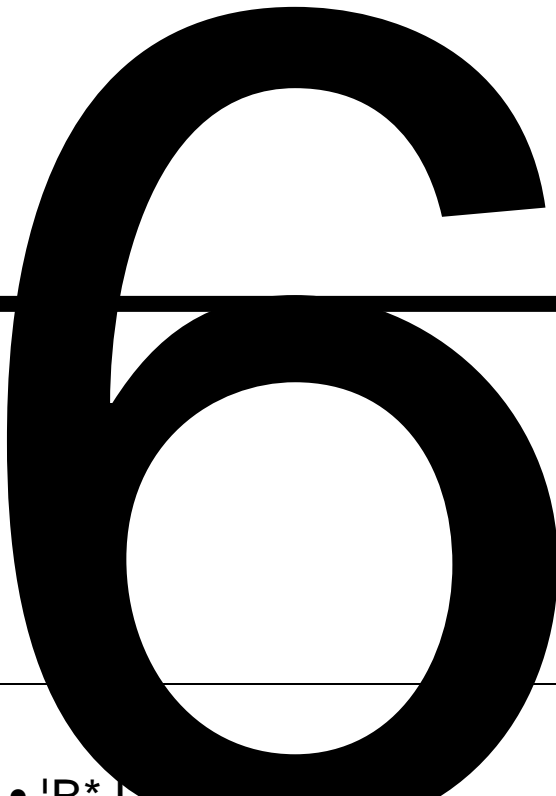
										<b>M200 M100 M80 M280</b>			
— —  [ ATI (S1) (D) (S2) ]													
<b>S1 D S2</b>										<b>7</b>			

**S1**

**S1**

**S1**

M0?±S1



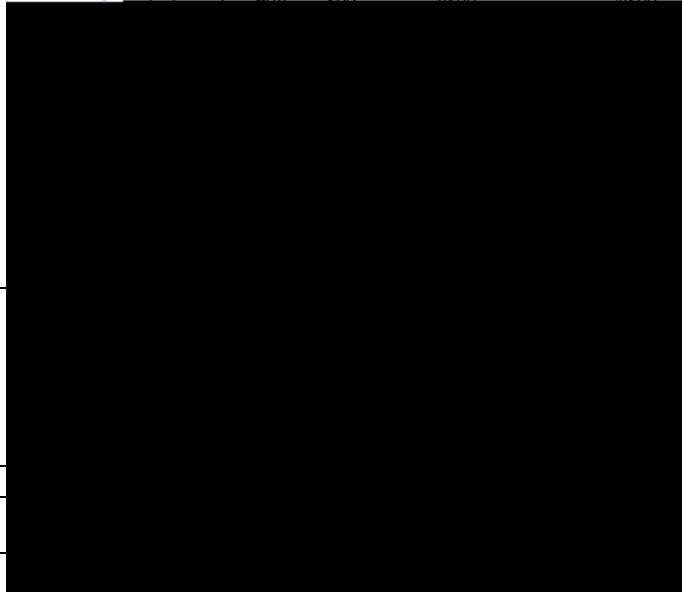
$V_{ML}$                        $V_{MH}$                        $V_{SL}$                        $V_{SH}$   
 $S_n$                                        $D_n$

A  $V_{SL}$   $V_{SH}$   $V_{ML}$   $V_{MH}$   
 B  $V_{SL}$   $V_{ML}$  A  
 $D_n$   $S_n$  A                      B

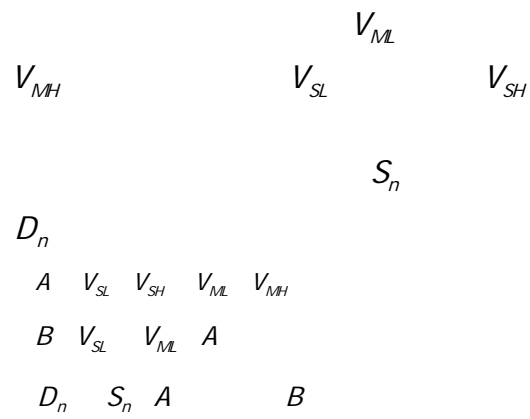
$D_n$

/\*D100-D103依次保存低点测量值、高点测量值、低点标准值、高点标准值\*/

SM1                                      100



RLCNV (S1) (S2) (D) (S3) ]                      M200 M280



$D_n$

M1	[	MOV	282	282	D1000	]	
	[	MOV	3530	3530	D1001	]	
	[	MOV	260	260	D1002	]	
	[	MOV	3650	3650	D1003	]	
M4	[	MOV	282	282	D100	]	
	[	MOV	3530	3530	D101	]	
	[	MOV	1906	1906	D102	]	
	[	MOV	0	0	D103	]	
	[	MOV	5000	5000	D104	]	
	[	MOV	-115	-115	D105	]	
M2	[	LCNV	282	282	D1000	D200	6



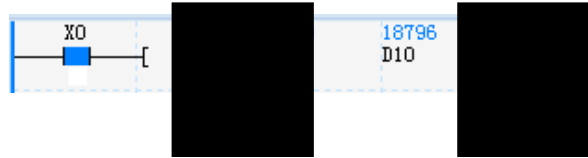
S1  
S2  
D



S1 S2  
D

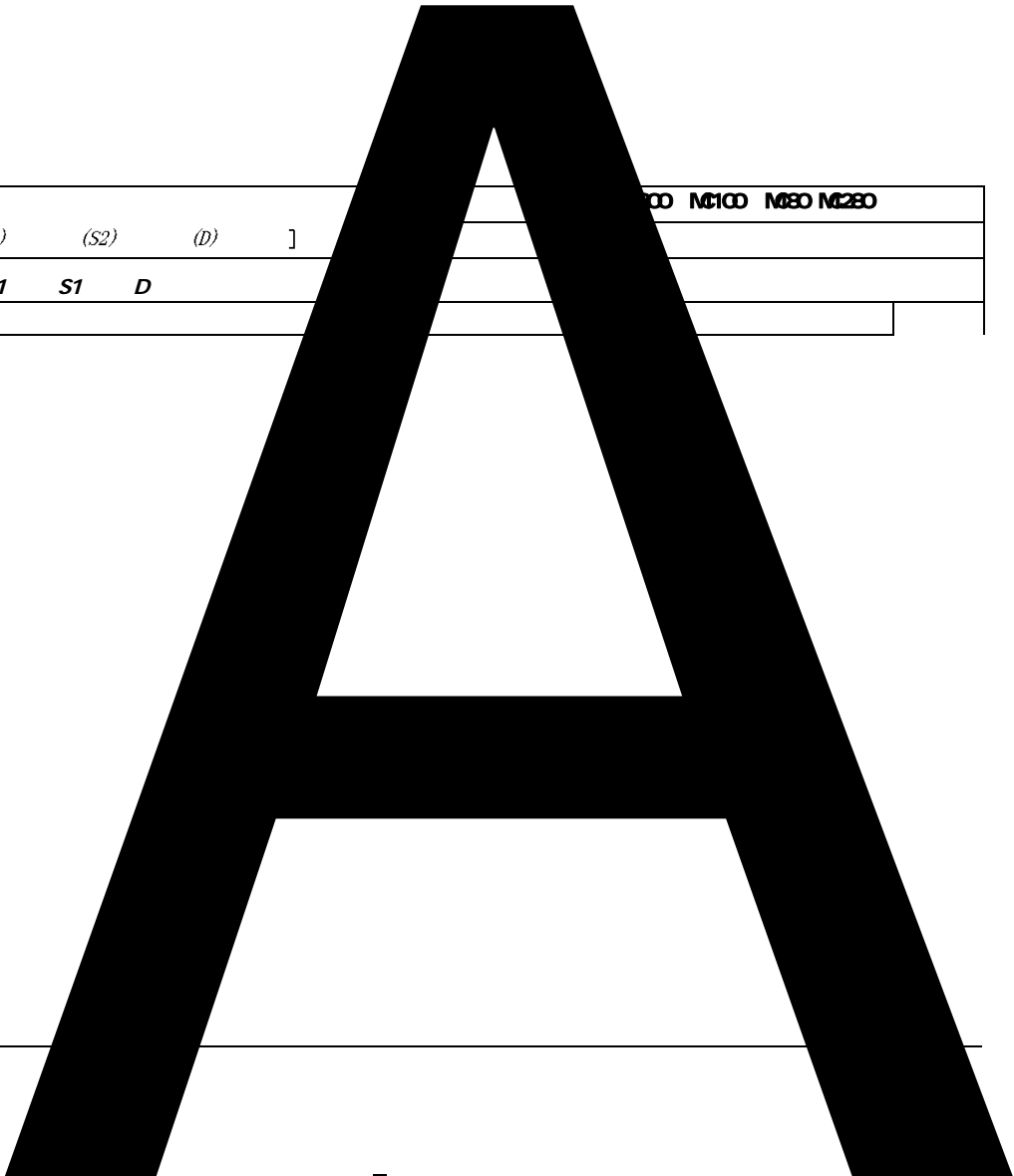
										M200 M100 M80 M280					
[ WINV (S) (D) ]															
S D										5					

S  
D



S  
D

										M200 M100 M80 M280					
[ DWAND (S1) (S2) (D) ]															
S1 S1 D															



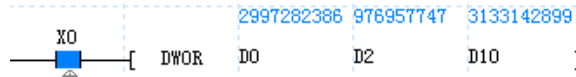
[ DWOR (S1) (S2) (D) ]										M200 M100 M80 M280				
S1 S2 D										10				

D

S1

S2

D



S1 S2

[ DWXOR (S1) (S2) (D) ]										M200 M100 M80 M280				
S1 S2 D										10				

S1

S2

D



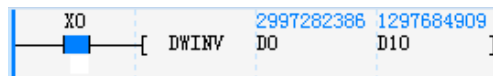
S1 S2

D

[ DWINV (S) (D) ]														
S D														

S

D



S

D

—   —  [ ROR (S1) (D) (S2) ]													
<b>S1    D    S2</b>													

**S1**  
**D**  
**S2**

**S1**

**S2**

**D**

[ ROL (S1) (D) (S2) ]														
<i>S1 D S2</i>														

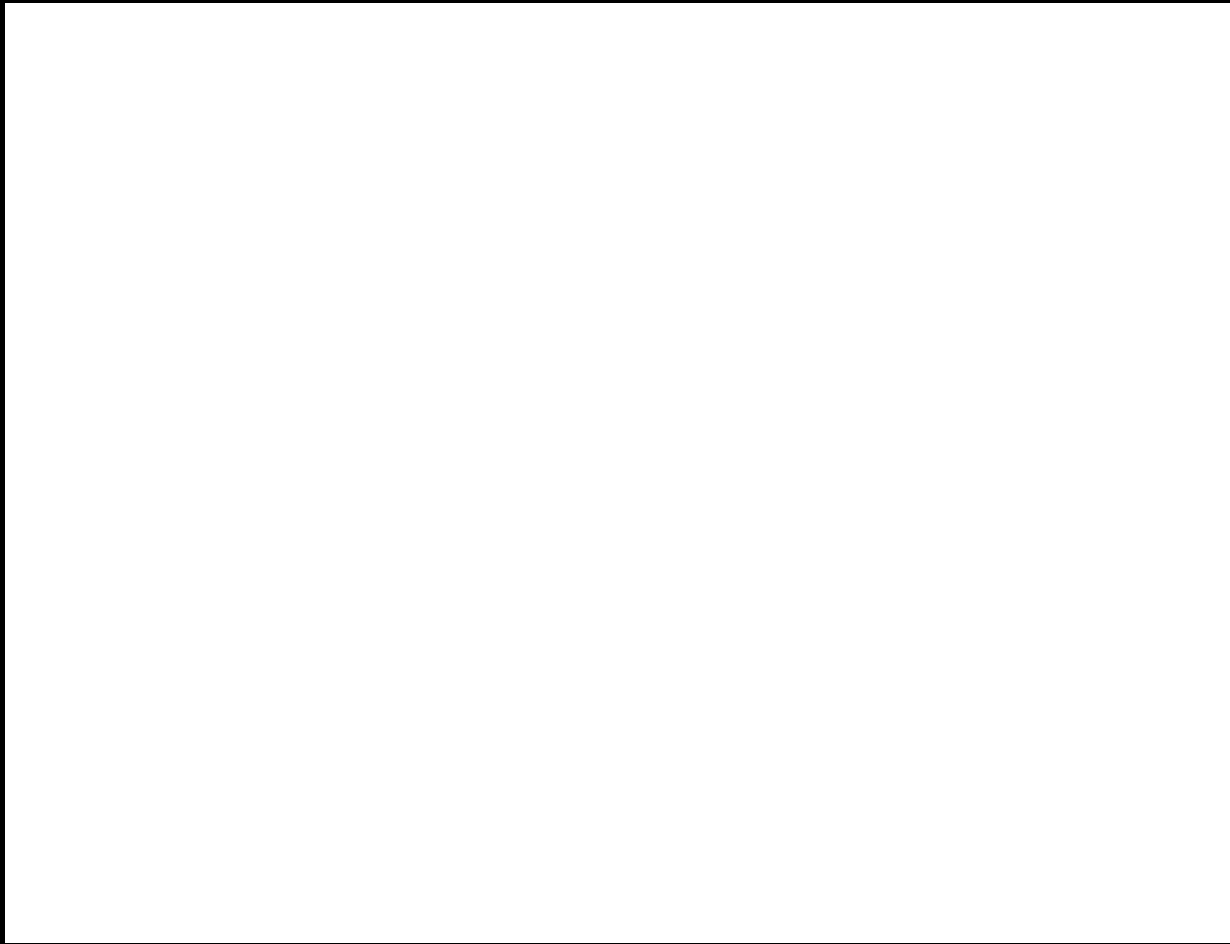
*S1*  
*D*  
*S2*

*S2 S1 D*



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--	--	--



---

---

A thin, light-colored diagonal line that starts from the left edge of the page and extends upwards and to the right, crossing the horizontal line below it. The line is very faint and appears to be a scanning artifact or a stray mark.

[ DROL (S1) (D) (S2) ]											
<b>S1 D S2</b>											

**S1**  
**D**  
**S2**

MO	3013123244	753280811	
[ DROL DO D10 30 ]			

**S1**  
**S2**      **D**

[ DRCR (S1) (D) (S2) ]											
<b>S1 D S2</b>											

**S1**  
**D**  
**S2**

MO	3013123244	722891539	
[ DRCR DO D10 11 ]			

**S1**  
**S2**      **D**

MO [ DRCL (S1) (D) (S2) ]																
S1 D S2																

S1  
D  
S2

MO	3013123244	1488165020	
[ DRCL	D0	D10	25 ]

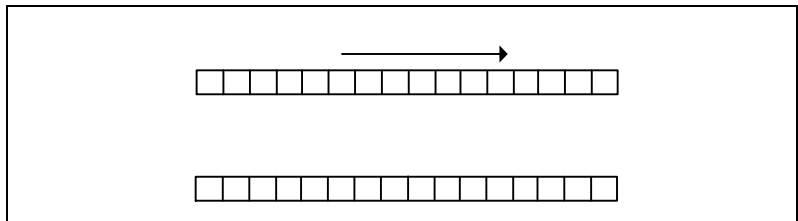
S1  
S2  
D

MO [ DRCL (S1) (D) (S2) ]																
S1 D S2																

S1  
D  
S2

MO	31452	982	
[ SHR	D0	D10	5 ]

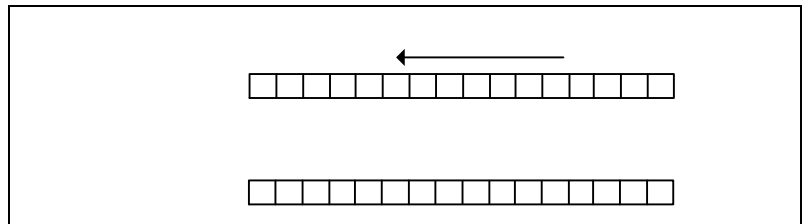
S1  
S2  
S2  
S1



--- ---  [ SHL (S1) (D) (S2) ]																
<b>S1      D      S2</b>																

S1  
D  
S2  
  
S2      S1  
S2      S1

```
MO |---|---| [ SHL 31452 28160 ]
      |---|---| [ SHL DO D10 7 ]
```



--- ---  [ DSHR (S1) (D) (S2) ]																
<b>S1      D      S2</b>																

S1  
D  
S2  
  
S2      S1  
S2      S1

S2      S1

```
MO |---|---| [ DSHR 1939381420 1893927 ]
      |---|---| [ DSHR DO D10 10 ]
```

S1  
S2      S1  
S2      S1

---

		[	DSHL	(S1)	(D)	(S2)	]		
--	--	---	------	------	-----	------	---	--	--

/ -

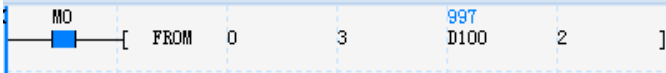
**4 0**



FROM (S1) (S2) (D) (S3)																
S1 S2 D S3																

S1 S3 S1 D S3 S2

S2 S3



D

S3

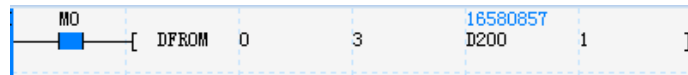
----- -----  [ DFROM (S1) (S2) (D) (S3) ]																
S1 S2 D S3																

S1

S1 S2 S3  
D S3

S2

S3



D

S3

----- -----  [ TO (S1) (S2) (S3) (S4) ]																
S1 S2 S3 S4																

S1 S3 S4 S2 S4 S1

S2 S4

```
SMD [ TO 0 8 1000 2 ]
```

S3  
S4

[ DTQ (S1) (S2) (S3) (S4) ]																
S1 S2 S3 S4																

S1 S3 S4 S1

S2 S4

S2

S4

SMD	[	DTQ	0	8	16711935	1	]
-----	---	-----	---	---	----------	---	---

S3

S4

[ VRRD (S) (D) ]																
S D																

S

D

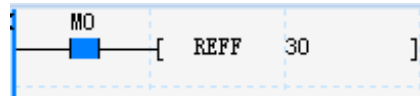
MO	[	VRRD	0	78	D10	]
----	---	------	---	----	-----	---

—   —  [ REFF (S) ]			
<b>S</b>			

**S**

•

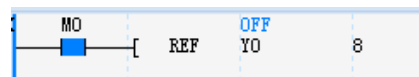
•



—   —  [ REF (D) (S) ]			
<b>D S</b>			

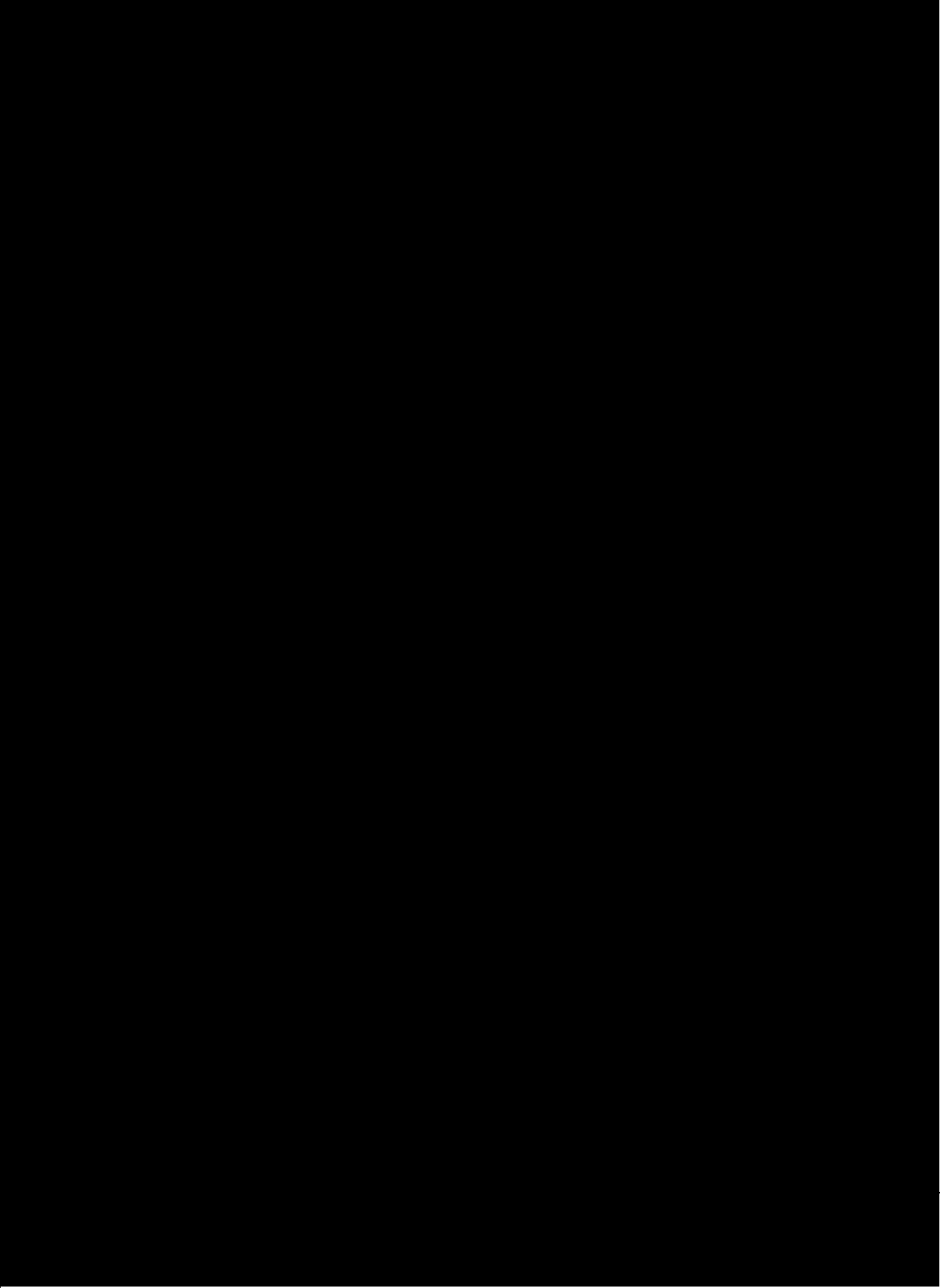
**D**

**S**



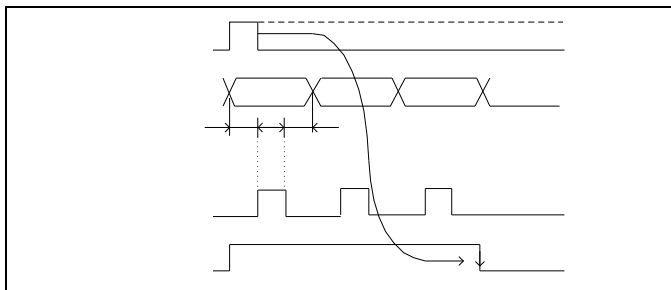
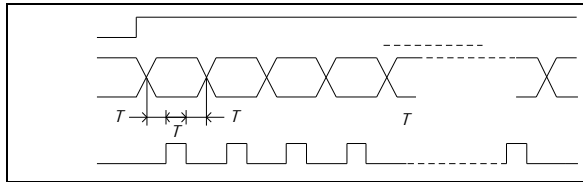
—   —  [ EROMWR (S1) (S2) ]			
<b>S1 S2</b>			

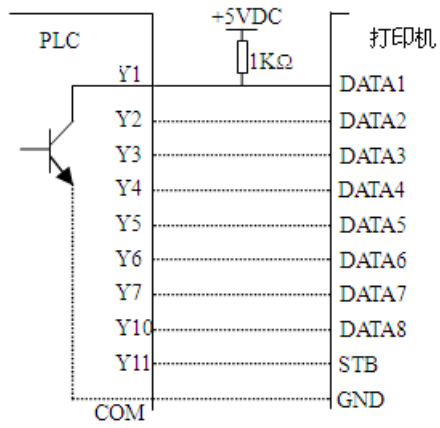
5' &XΕPT ς



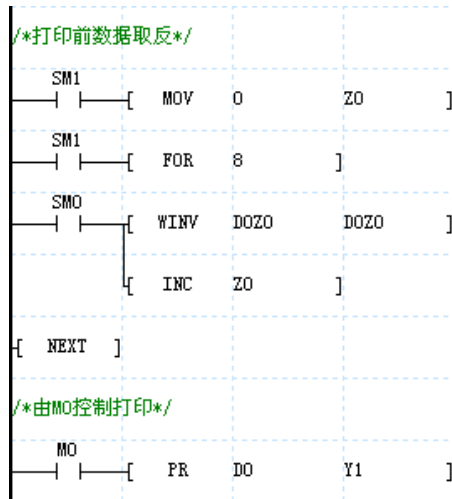
[ <b>FR</b> ]			
(S) (D)			

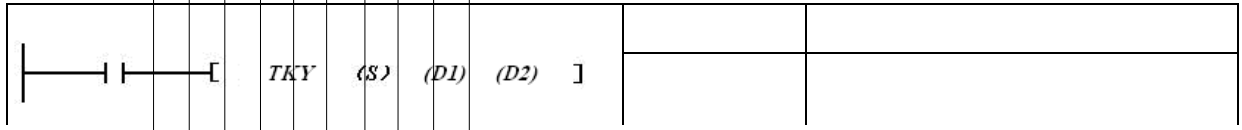
**S**  
**D**



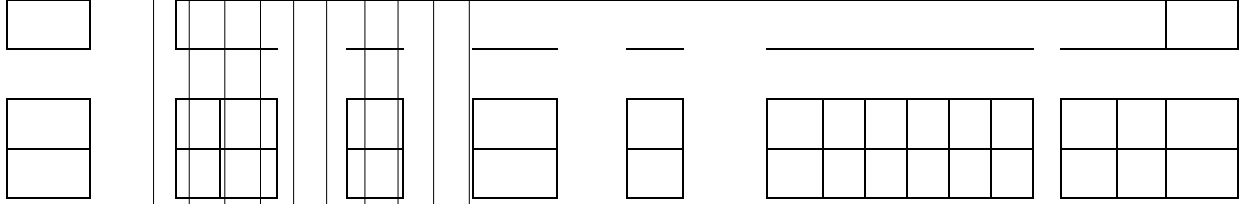


Ω



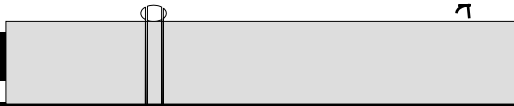


S



S

D2

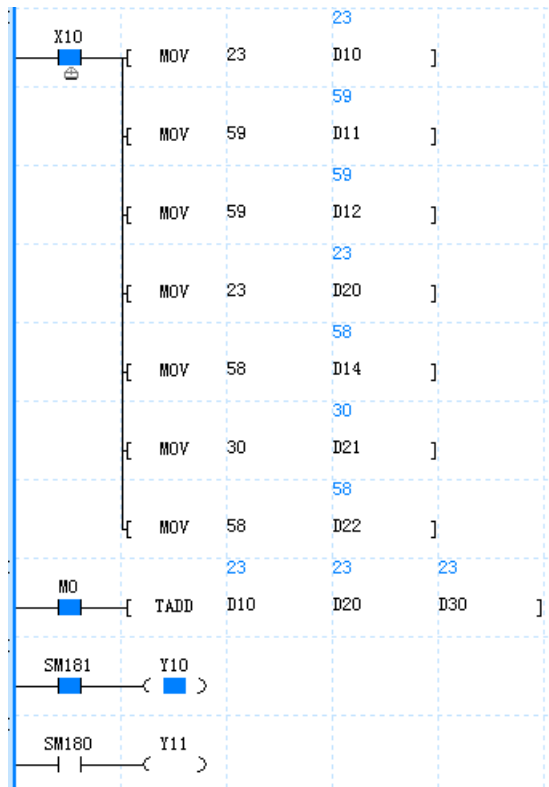





[ TADD (S1) (S2) (D) ]											
<b>S1 S2 D</b>											

--	--	--	--	--	--	--	--

**S1**  
**S1**  
  
**S2**  
**S2**  
  
**D**  
  
**D**



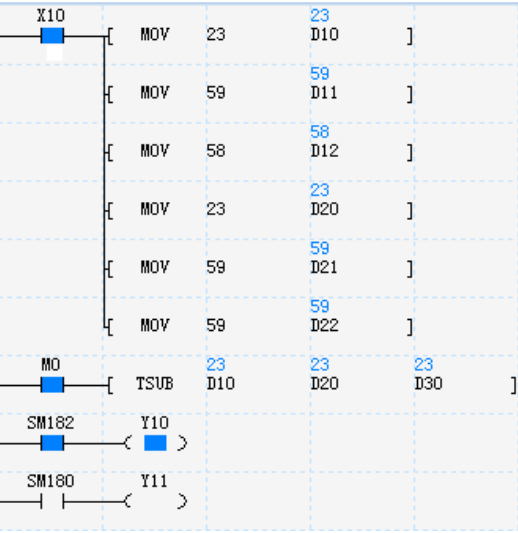

[ TSUB (S1) (S2) (D) ]																				<b>M280</b>									
<i>S1</i>										<i>S2</i>										<i>D</i>									

*S1*  
*S1*


*S2*  
*S2*

*D*

*D*



[ HOUR (S) (D1) (D2) ]										<b>M280</b>					
<i>S</i> <i>D1</i> <i>D2</i>															

*D1*

*S*

*D2*

*D1*

*D1*

*D1*

*D2*

*D1*

*S*

MO	[	MOV	1000	1000	D100	]
M1	[	HOUR	D100	1000	0	D200 OFF M10
M10	[	YO	)			

<input type="checkbox"/>	<input type="checkbox"/>	DCMP=	(S1)	(S2)	(D)			<b>M280</b>				
<input type="checkbox"/>	<input type="checkbox"/>	DCMP<	(S1)	(S2)	(D)							
<input type="checkbox"/>	<input type="checkbox"/>	DCMP>	(S1)	(S2)	(D)							
<input type="checkbox"/>	<input type="checkbox"/>	DCMP<>	(S1)	(S2)	(D)							
<input type="checkbox"/>	<input type="checkbox"/>	DCMP>=	(S1)	(S2)	(D)							
<input type="checkbox"/>	<input type="checkbox"/>	DCMP<=	(S1)	(S2)	(D)							
			<b>S1</b>	<b>S2</b>	<b>D</b>							
			<b>S1</b>	<b>S2</b>	<b>D</b>							
			<b>S1</b>	<b>S2</b>	<b>D</b>							
			<b>S1</b>	<b>S2</b>	<b>D</b>							
			<b>S1</b>	<b>S2</b>	<b>D</b>							
			<b>S1</b>	<b>S2</b>	<b>D</b>							
			<b>S1</b>	<b>S2</b>	<b>D</b>							

**S1**  
**S2**  
**D**

**S1 S2**  
**S1 S2**

<input checked="" type="checkbox"/> SMO	[ MOV	2004	2004	D0	]			
	[ MOV	10	10	D1	]			
	[ MOV	25	25	D2	]			
	[ MOV	2004	2004	D10	]			
	[ MOV	10	10	D11	]			
	[ MOV	24	24	D12	]			
<input checked="" type="checkbox"/> XO	[ DCMP=	2004	2004	D0	D10	OFF	M0	]
	[ DCMP<	2004	2004	D0	D10	OFF	M1	]
	[ DCMP>	2004	2004	D0	D10	ON	M2	]
	[ DCMP<>	2004	2004	D0	D10	ON	M3	]
	[ DCMP>=	2004	2004	D0	D10	ON	M4	]
	[ DCMP<=	2004	2004	D0	D10	OFF	M5	]



---

----- -----  HTOS (S) (D) 1			
S D			

---

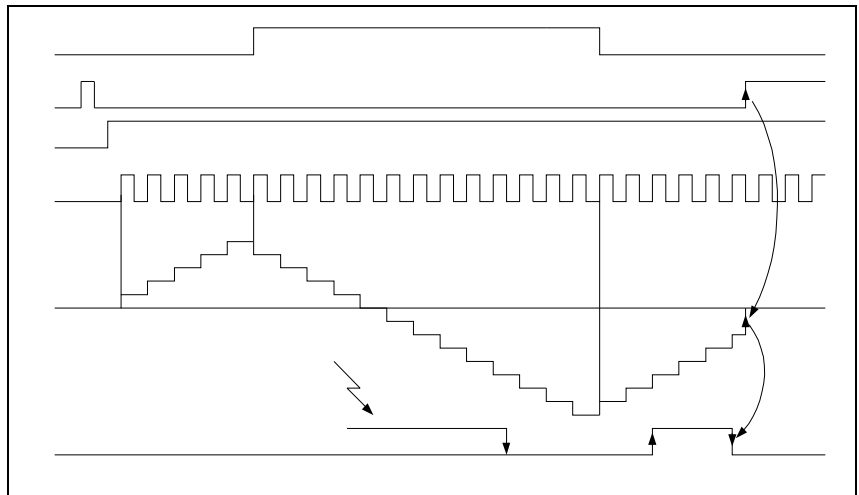
[ HCNT (D) (S) ]											
<i>D S</i>											

**D**

**S**

X10	SM236			
		(	)	
X11	RST	OFF	C236	
■	[		]	
X12	HCNT	0	C236	-5
■	[		]	

**S**



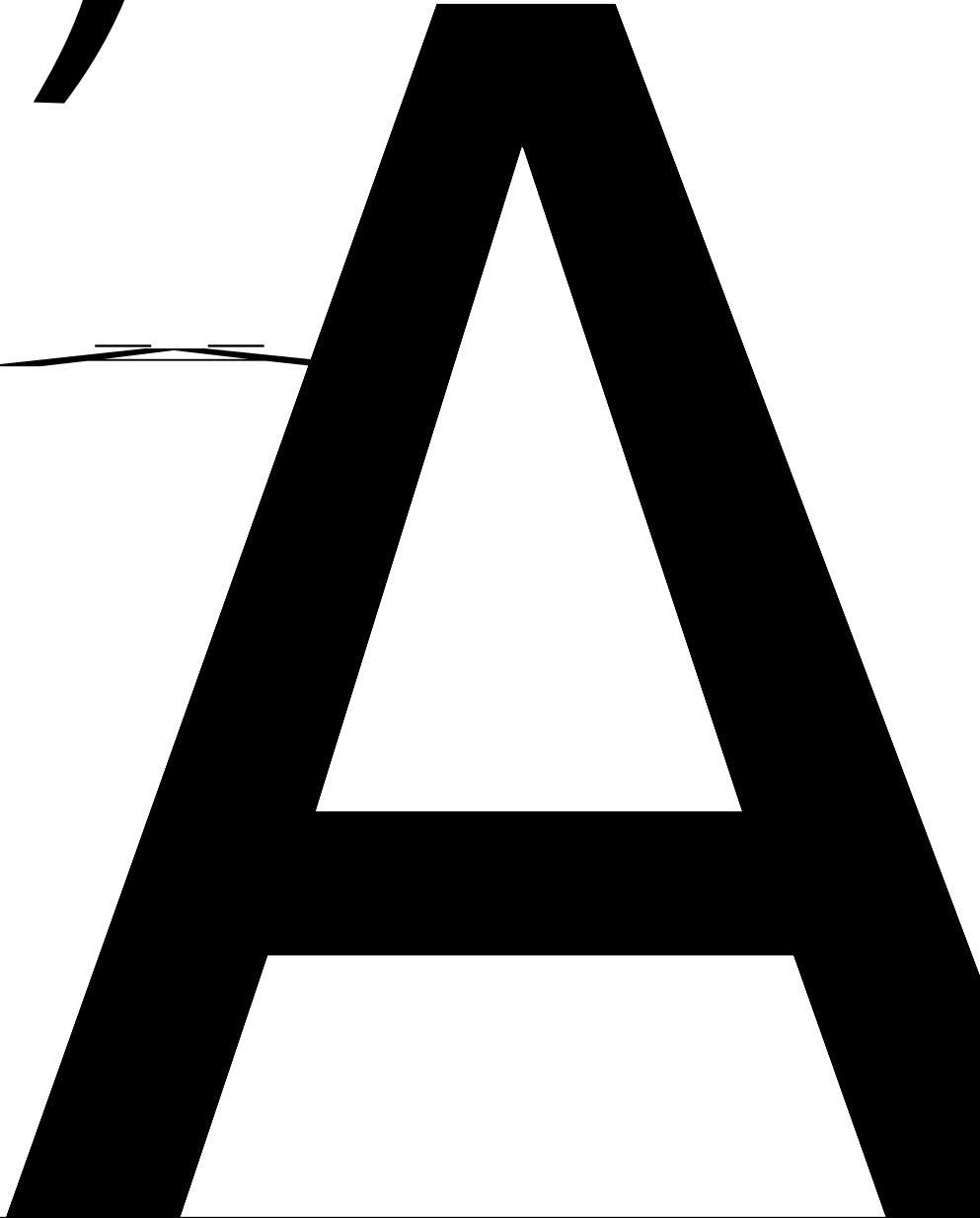
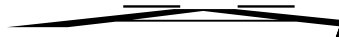


—   —  [ DHSCS (S1) (S2) (D) ]											
<i>S1 S2 D</i>											

*S1*

*S2*

*D*

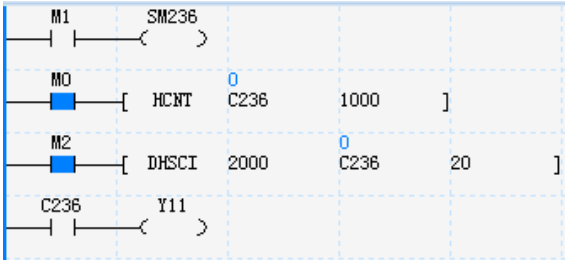


[ DHSCI (S1) (S2) (S3) ]															
<b>S1 S2 S3</b>															

**S1**

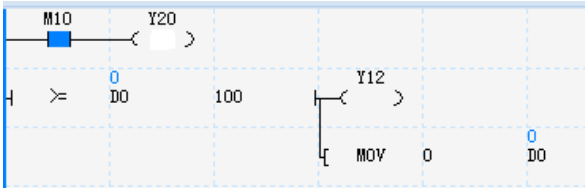
**S2**

**S3**



**S1**

**S3**



---

—   —  [ DHSPI (S1) (S2) (S3) ]											
<b>S1 S2 S3</b>											

**S1**

**S2**

**S3**

---

—   —  [ DHSCR (S1) (S2) (D) ]																					
<b>S1 S2 D</b>																					

**S1**

È

**S2**

**D**

**S2**

**S1 D**

—   —		DHSZ	(S1)	(S2)	(S3)	(D)		
		<b>S1</b>	<b>S2</b>	<b>S3</b>	<b>D</b>			

**S1**

**S2**

**S3**

**D** 

---

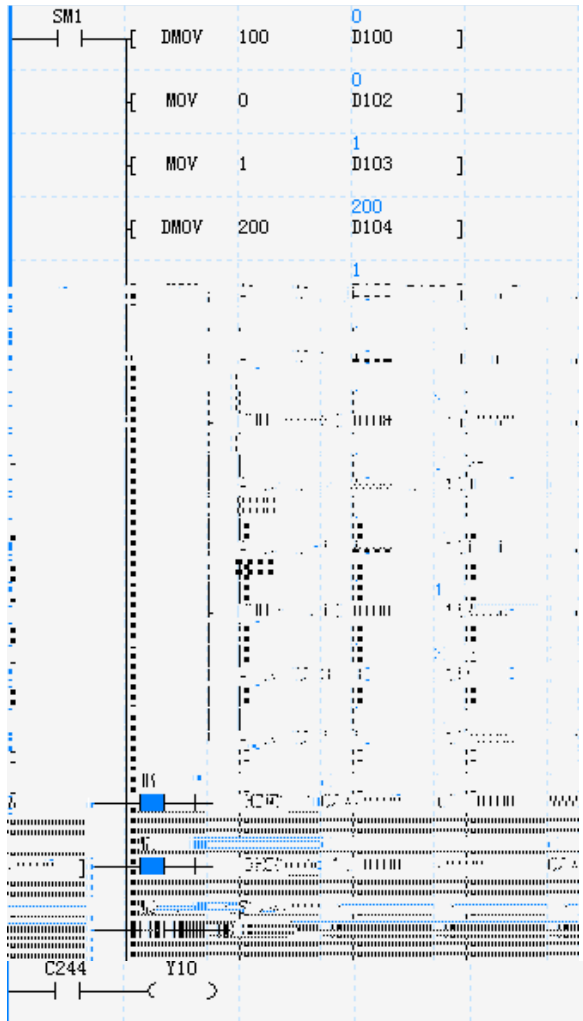
—   —  [ DHST (S1) (S2) (S3) ]														
<i>S1 S2 S3</i>														

*S1*

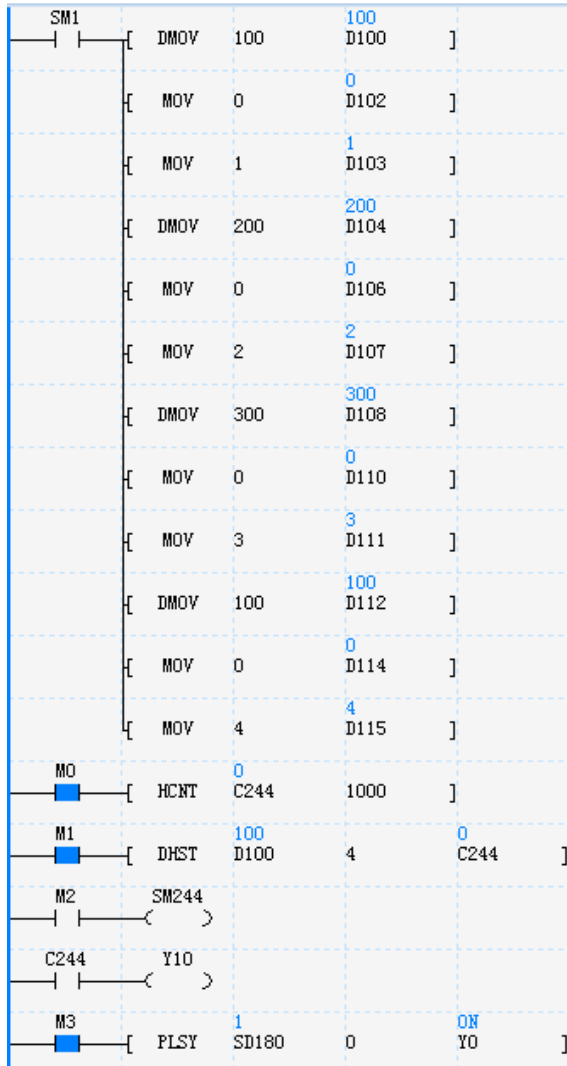
*S2*

*S3*

---

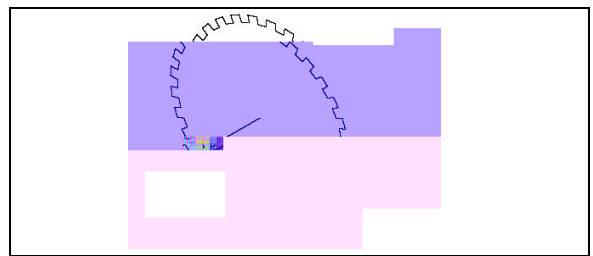
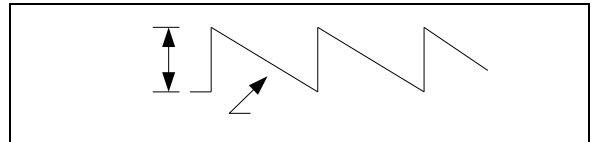





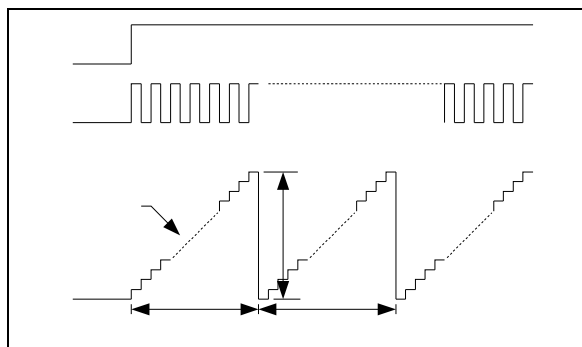
				SPD	(S1)	(S2)	(D)	]			
				S1	S2	D					

S1  
S2  
D



610 10

SMD	[	PLSY	10000	0	ON	Y0
MO	[	SPD	ON	X0	1000	D10



[ PLSY (S1) (S2) (D) ]											
S1 S2 D											

S1

S1

S1

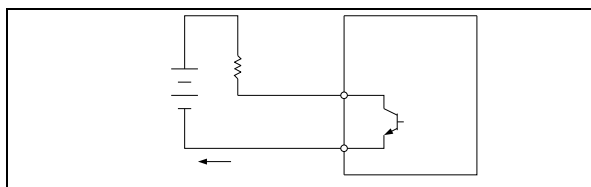
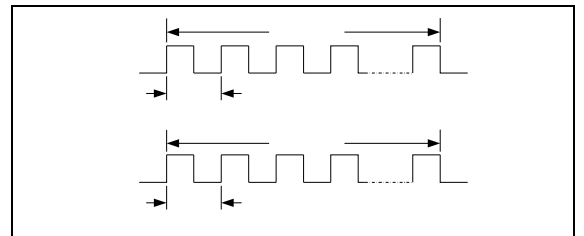
S2

S2

S2

D

M1	[	PLSY	1000	10000	OFF	Y1	]
	[	PLSY	1000	10000	OFF	Y0	]



—   —  [ PLSR		(S1)	(S2)	(S3)	(D)		
		<b>S1</b>	<b>S2</b>	<b>S3</b>	<b>D</b>		



**S1**



**S1**

**S2**

**D**

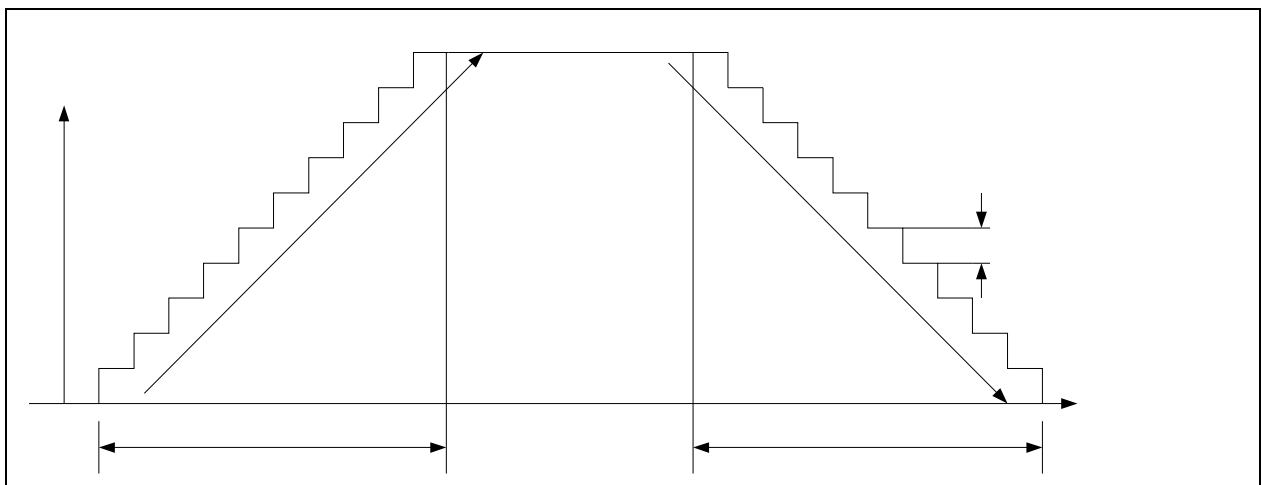
**S3**

**S1 S3**


**S3 S1**

**S1 S3**

**S3 S1**



---

MO						OFF
	PLSR	10	110	1000		Y1
	PLSR	10	110	1000		Y0

—   —  [ PLS (S1) (S2) (D1) ]											
<b>S1 S2 D1</b>											

S1  
S2  
D

P  $F_N$   $T_{up}$   
F F  
 $T_{down}$

$$P \frac{F_N F_N F_N F_N T_{up}}{F F}$$

$$P \frac{F_N F_N F_N F_N T_{down}}{F F}$$

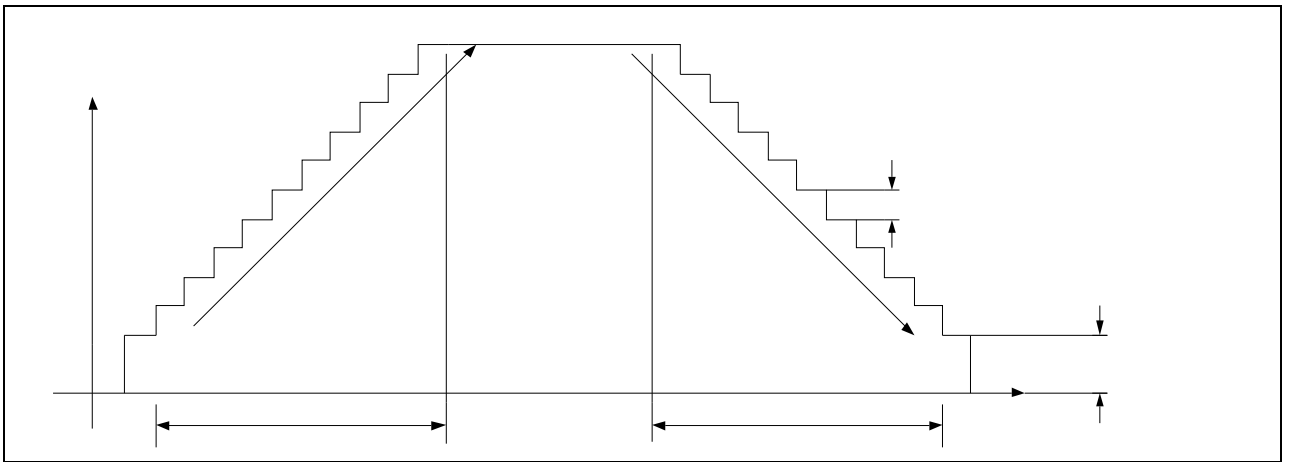
F

$$P \frac{F F F F T_{up} T_{down}}{F F}$$

$$P \frac{F_M F_M F_M F_M T_{up} T_{down}}{F F}$$

---

--- ---							
(S1) (S2) (S3) (S4) (D)							



---

MO	[	PLSB	100	10000	10000	1000	OFF	Y1	]
	[	PLSB	100	10000	10000	1000	OFF	Y0	]

---

—   —  [ PWM (S1) (S2) (D) ]											
S1 S2 D											

S1

S1

S1  
S1 ms S1

S2

S2  
S1 ms S1

S2

S1

D

D

S1

S1

S1 S2





SM1	[	MOV	1000	1000	D500	]					
	[	MOV	500	500	D510	]					
	[	MOV	16#7	7	D511	]					
	[	MOV	70	70	D512	]					
	[	MOV	100	100	D513	]					
	[	MOV	25	25	D514	]					
	[	MOV	0	0	D515	]					
	[	MOV	63	63	D516	]					
	[	FMOV	0	26	D517	8	]				
	[	MOV	2000	2000	D525	]					
	[	MOV	2000	2000	D526	]					
	[	MOV	2000	2000	D527	]					
	[	MOV	2000	2000	D528	]					
MO	[	FROM	0	5	631	D501	1	]			
	[	PID	1000	631	500	24349	D500	D501	D510	D502	]
	[	TO	0	8	24349	D502	1	]			

*D*

*S3*

*S3 15 S3*

*18*

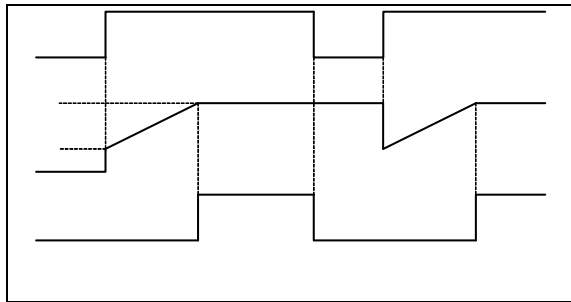
*S3 1*

*S3 S3 6*

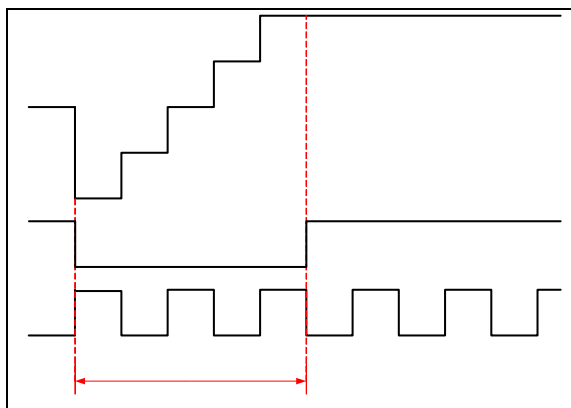
				RAMP	(S1)	(S2)	(D1)	(S3)	(D2)											
					<b>S1</b>	<b>S2</b>	<b>D1</b>	<b>S3</b>	<b>D2</b>											

**S1**  
**S2**  
**D1**  
**S3**      **S3**  
**D2**

**S2**      **D1**  
  
**D1**      **D2**  
**D1**      **S1**



**S3**



```

SM1 | | [ MOV 0 0 DO ]
     | | [ MOV 2000 2000 D1 ]
X0  | [ RAMP 0 DO 2000 D1 2000 D10 1000 ON MO ]
X1  | [ TO 0 6 D10 1 ]
  
```

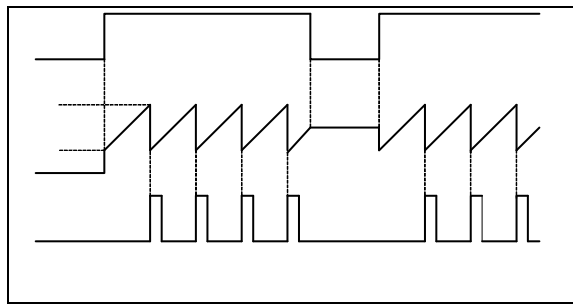
**D1**      **D2**

[ ... ]																			
<i>S1</i> <i>S2</i> <i>D1</i> <i>S3</i> <i>D2</i>																			

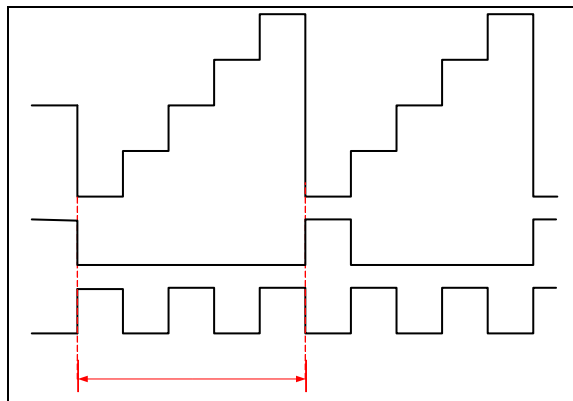
*S1*  
*S2*  
*D1*  
*S3*     *S3*  
*D2*

*S1 S2   D1 S2 D2*

*S1*             *D1*             *S2*  
*S1*             *D2*             *D2*  
                   *D2*             *D1*  
                                   *D1*  
*S1*



*S3*



SM1	[	MOV	0	0	D0	]		
	[	MOV	2000	2000	D1	]		
X0	[	HACKLE	D0	D1	D10	1000	OFF	MO
X1	[	TO	0	1	1096	D10	1	]

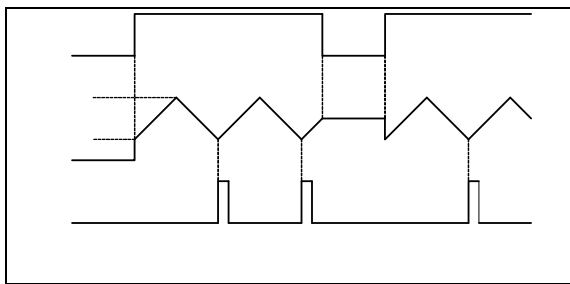
*D1*             *D2*  
*D1*             *S1*

[ TRIANGLE (S1) (S2) (D1) (S3) (D2) ]						
<b>S1 S2 D1 S3 D2</b>						

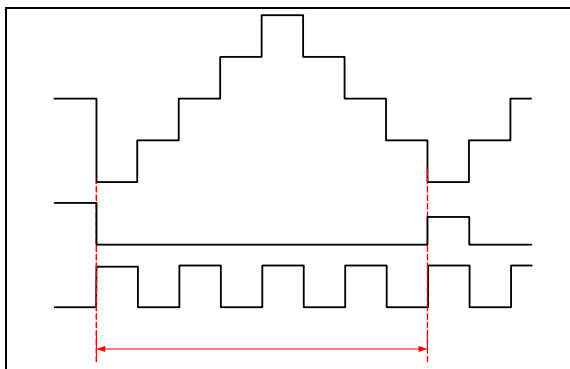
**S1**  
**S2**  
**D1**  
**S3**  
**D2**

**S1 S2 D1 S2 D2**  
**S3**

**D1 S2**  
**D1 S1**  
**D2**  
**D2**  
**D2 D1**  
**D1 S1**



**S3**



SM1	[	MOV	0	0	D0	]		
	[	MOV	2000	2000	D1	]		
X0	[	TRIANGLE	0	2000	1364	D10	1000	OFF
	[							MO
X1	[	TO	0	1	1364	D10	1	]

**D2** **D1**  
**D1 S1**

[ <b>ABSD</b> ]																
<i>(S1) (S2) (D) (S3)</i>																

**S1**

**S2**

**D**

**S3**

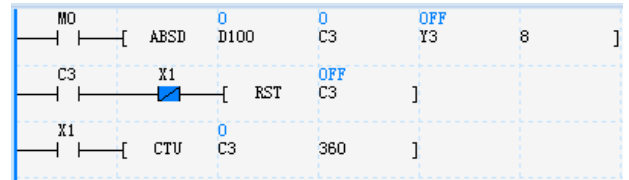
**S3**

**S1**

**S2**

**D**

**S1 S1**

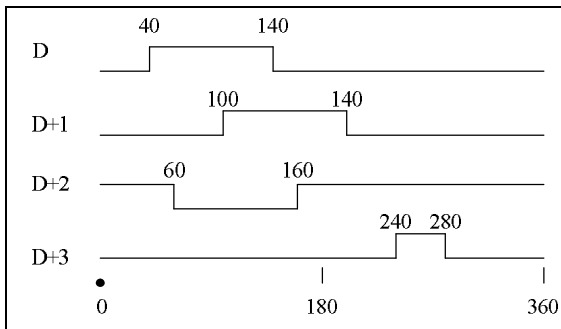


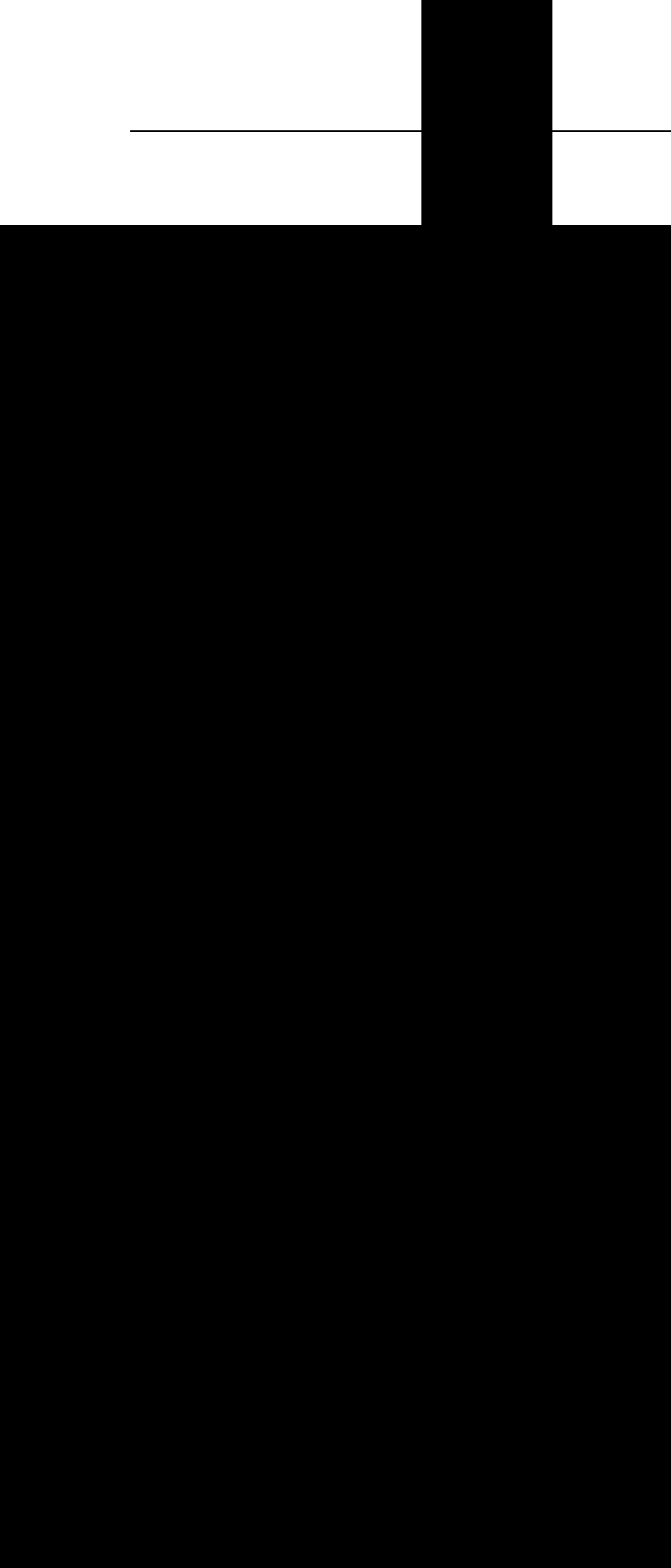
**S1**

**S2**

<b>S1</b>		<b>S1</b>		<b>D</b>
<b>S1</b>		<b>S1</b>		<b>D</b>
<b>S1</b>		<b>S1</b>		<b>D</b>
<b>S1</b>		<b>S1</b>		<b>D</b>
<b>S1</b>		<b>S1</b>		<b>D</b>

**D**





---

]									

**S1**


---

---

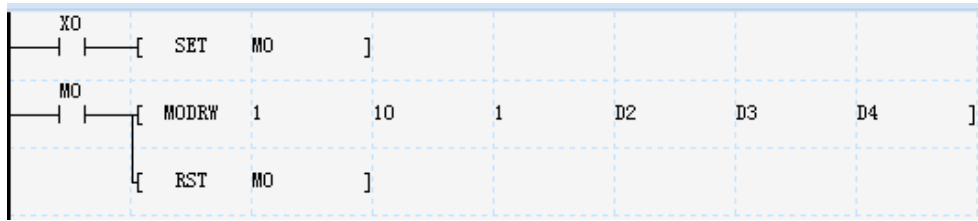




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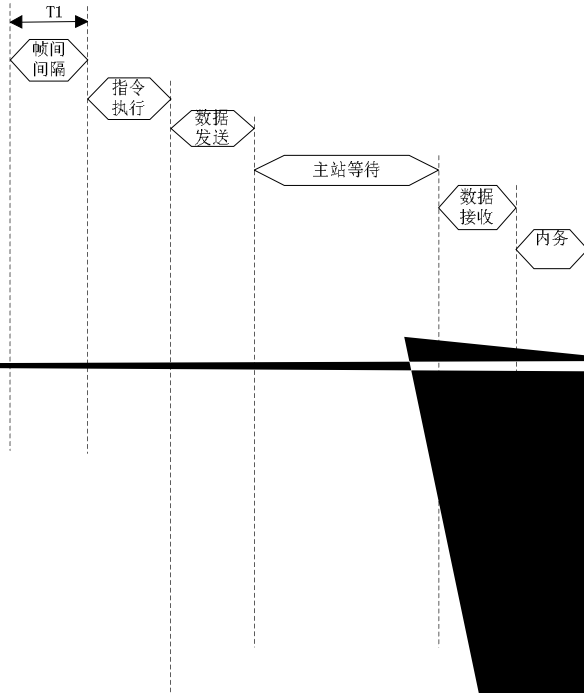
|—|—|

---



SM30

SM135



T — ms

T T T ms

T ms

T ms

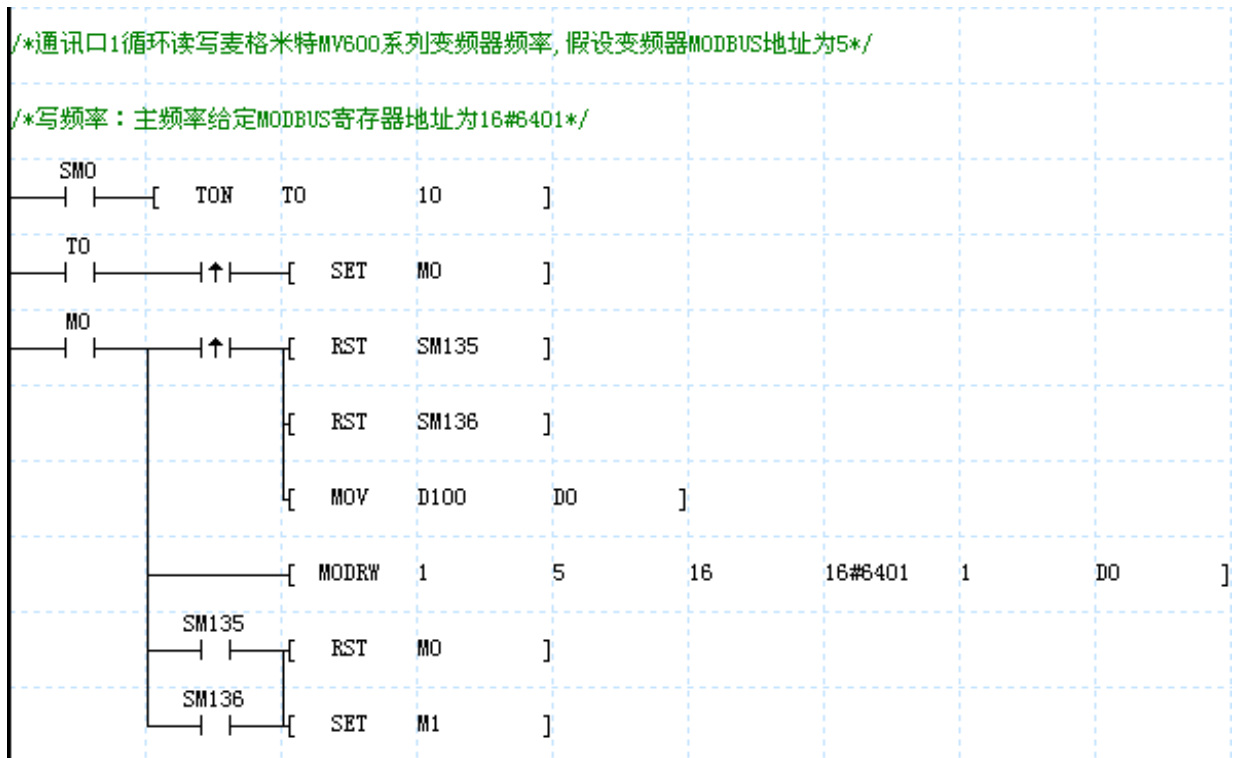
T INT — ms

T ms

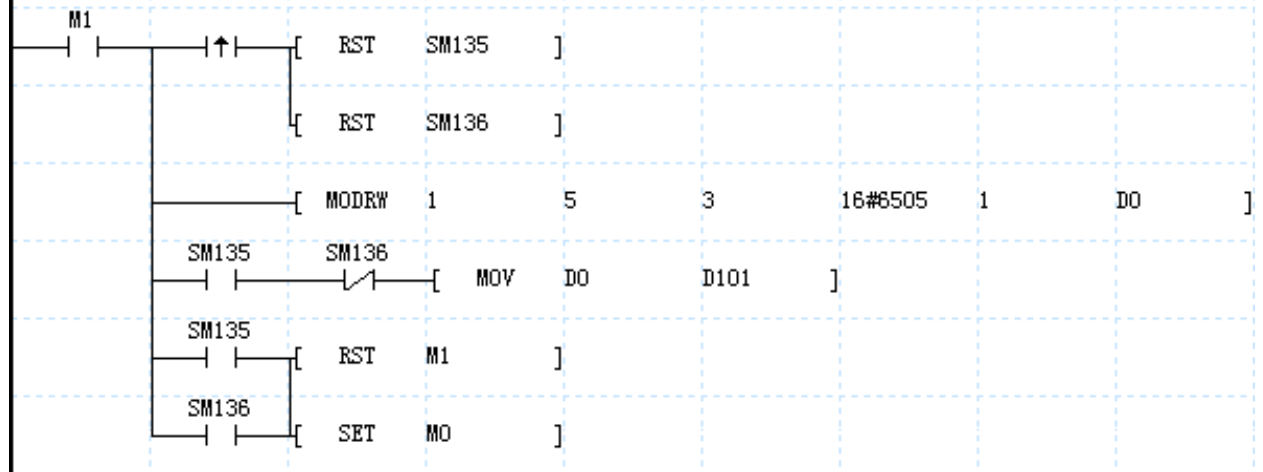
```
/*使能M1, M2, M3实现MODBUS轮询示例,*/  
/*01 Read Coil Status*/  
/*D100纪录错 D110纪录详细错 D1001纪录成功通信次数*/  
M1 [ MOV 16#11 D0 ]  
    [ MOV 16#1 D1 ]  
    [ MOV 16#13 D2 ]  
    [ MOV 16#25 D3 ]  
M1 [ S0j T1 ]  
    [ I:0.0 ]  
/*02 Read Input Status*/  
S0j [ T1 ]
```





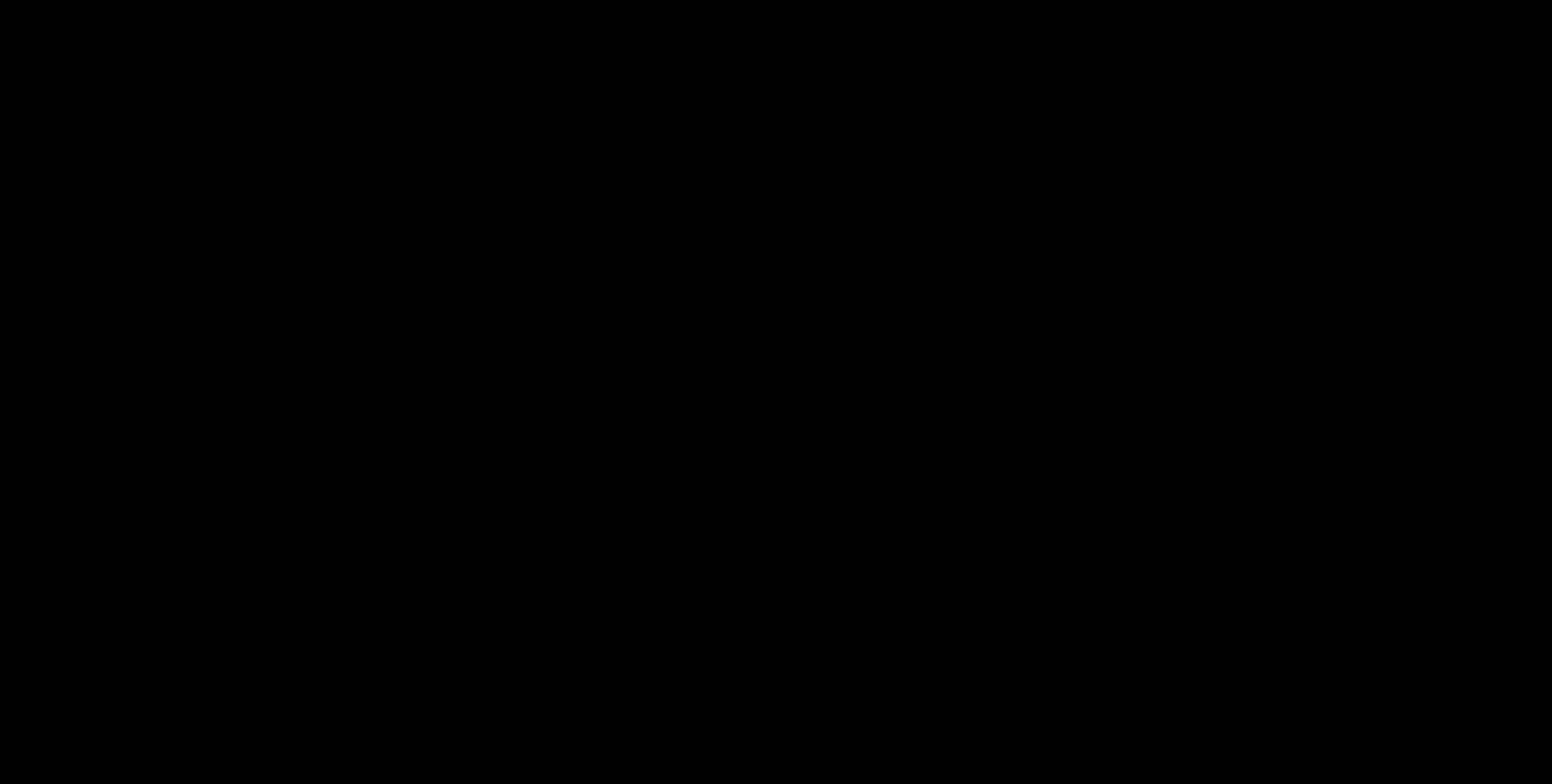


/\*读频率：变频器当前运行频率MODBUS寄存器地址为16#6505\*/



M90														
[ MODLINK 1 D200 D46 M114 M156 ]														
<i>S1</i>					<i>S2</i>									





[ RCV (S1) (D) (S2) ]			
<b>S1 D S2</b>			

**S1**  
**D**  
**S2**

SM1	[ RCV 1 D20 5 ]
SM123	[ INC D100 ]

---   ---  [ CCITT (S1) (S2) (D) ]																											
<b>S1 S2 D</b>																											

**S1**

**S2**

**S2**

**D**

**S1**

**S2**

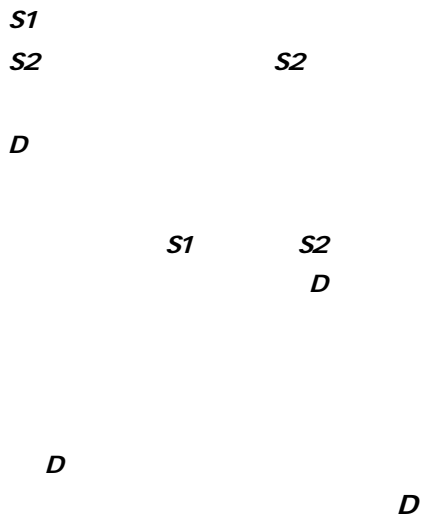
**D**

**D**

**D**

SM1	[	MOV	16#0	0	D0	]	
	[	MOV	16#11	17	D1	]	
	[	MOV	16#22	34	D2	]	
	[	MOV	16#33	51	D3	]	
	[	MOV	16#44	68	D4	]	
	[	MOV	16#55	85	D5	]	
	[	MOV	16#66	102	D6	]	
	[	MOV	16#77	119	D7	]	
X0	[	MOV	0	28097	D100	]	
	[	CCITT	D0	8	28097	D100	]

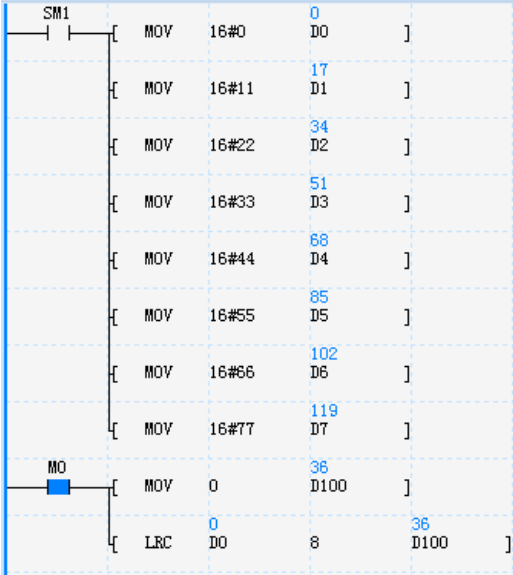
----- -----  [ CRC16 (S1) (S2) (D) ]																	
<b>S1 S2 D</b>																	



SM1	[	MOV	16#0	0	D0	]
	[	MOV	16#11	17	D1	]
	[	MOV	16#22	34	D2	]
	[	MOV	16#33	51	D3	]
	[	MOV	16#44	68	D4	]
	[	MOV	16#55	85	D5	]
	[	MOV	16#66	102	D6	]
	[	MOV	16#77	119	D7	]
X0	[	MOV	0	57708	D100	]
	[	CRC16	0	8	57708	D100

[ LRC (S1) (S2) (D) ]											
<i>S1 S2 D</i>											

*S1*  
*S2*                      *S2*  
  
*D*  
  
                  *S1*            *S2*  
                                  *D*  
  
*D*    *D*



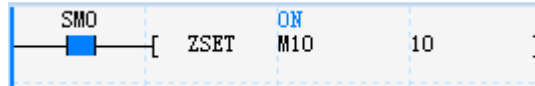
[ ZRST (D) (S) ]											
<i>D S</i>											

*D*  
*S*  
  
                  *D*                      *S*



[ ZSET (D) (S) ]														
D S														

D  
S



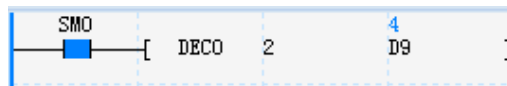
D S

[ DECO (S) (D) ]														
S D														

S  
D

D

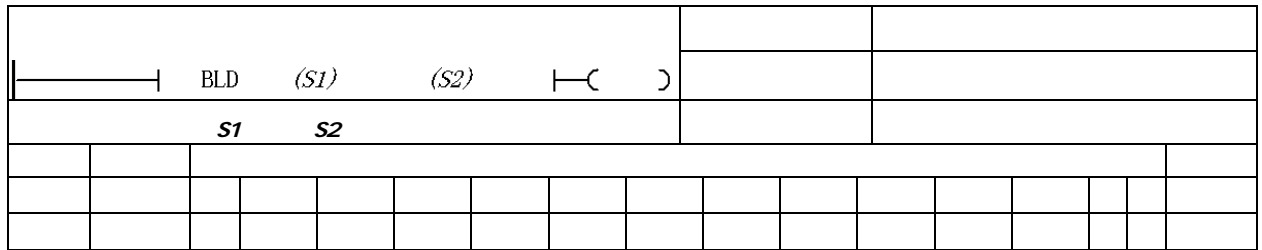
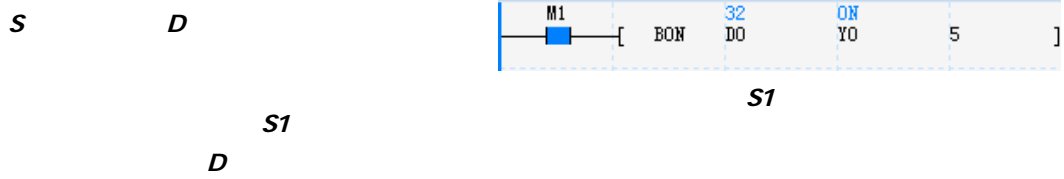
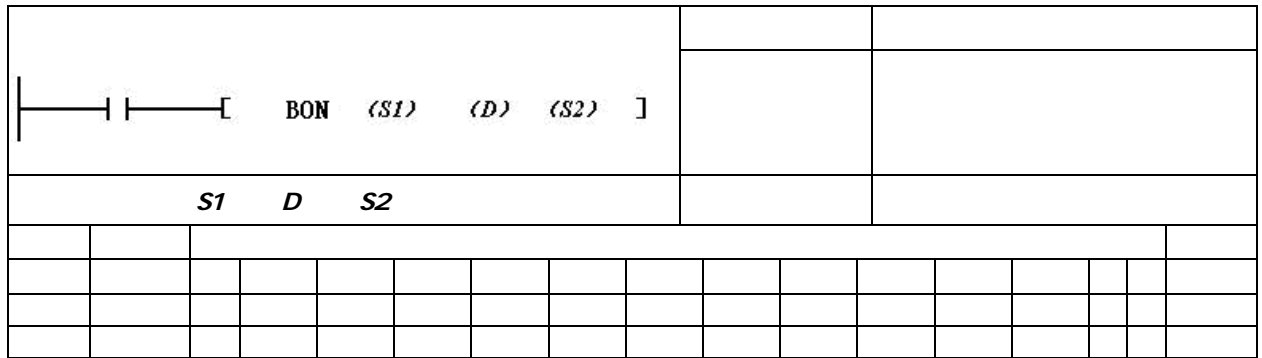
S



---

—   —  [ ENCO (S) (D) ]			
<b>S D</b>			

---



-----  BLDI (S1) (S2)  -( )														
S1 S2														

S1  
S2 S2

|-----| BLDI 1000 DO 5 |-( Y0 )

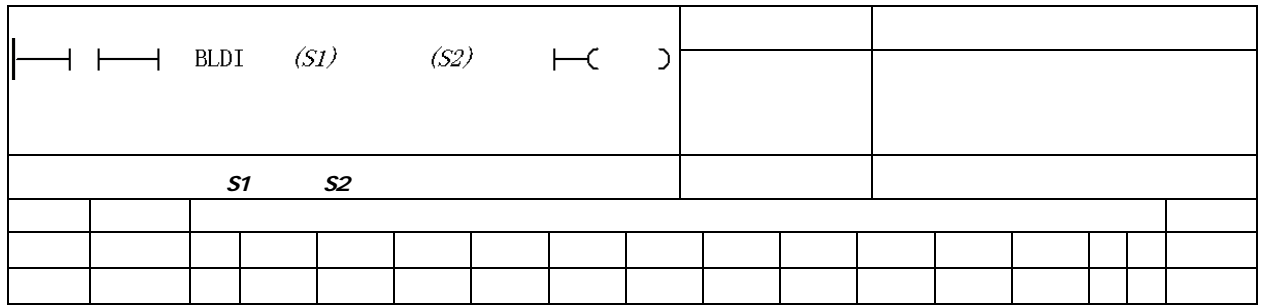
S1 S2

-----  BLD (S1) (S2)  -( )														
S1 S2														

S1  
S2 S2

|-----| BLDI 1000 DO 5 |-( Y0 )

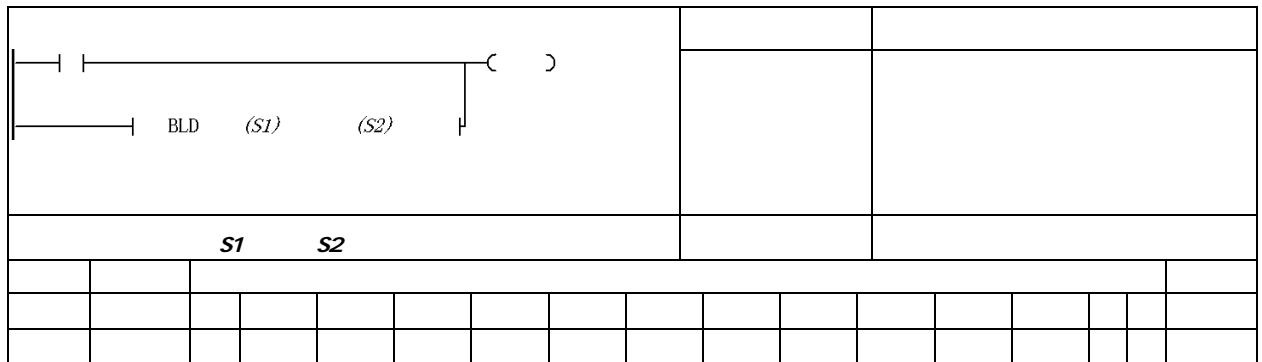
S1 S2



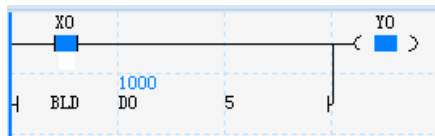
*S1*  
*S2*



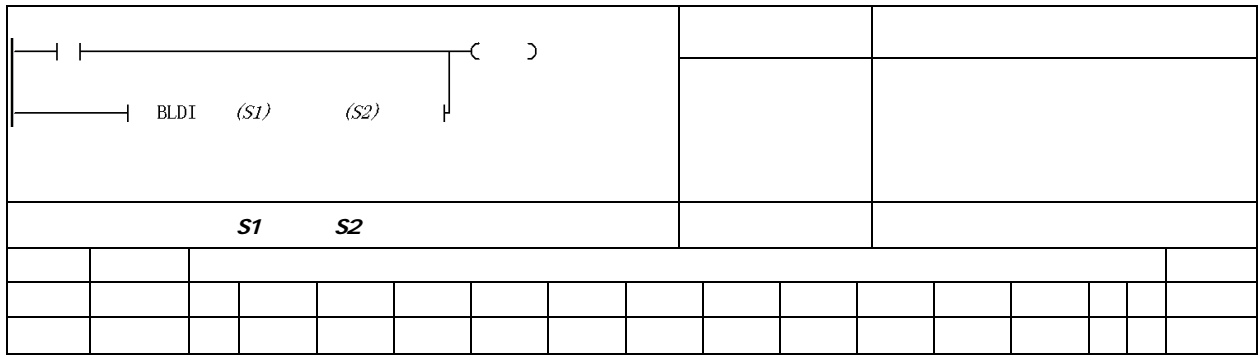
*S1*            *S2*



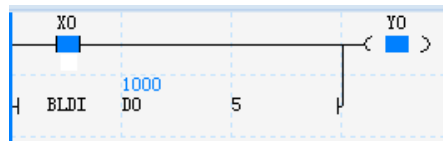
*S1*  
*S2*



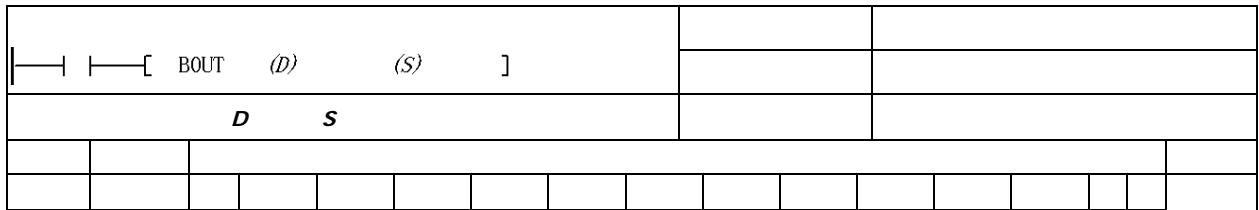
*S1*            *S2*



**S1**  
**S2**                    **S2**

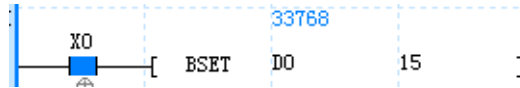


**S1**                    **S2**



[ BSET (D) (S) ]																											
<i>D S</i>																											

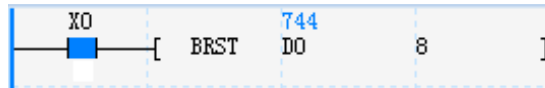
*D*  
*S2 S2*



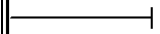
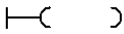
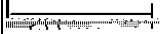

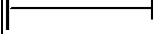


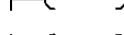

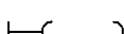


*D S*

[ BRST (D) (S) ]																											
<i>D S</i>																											

*D*  
*S2 S2*



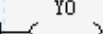
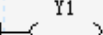
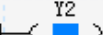
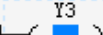
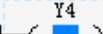
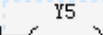
*D S*

	=	(S1)	(S2)			
	<	(S1)	(S2)			
	>	(S1)	(S2)			
	<>	(S1)	(S2)			
	>=	(S1)	(S2)			
	<=	(S1)	(S2)			

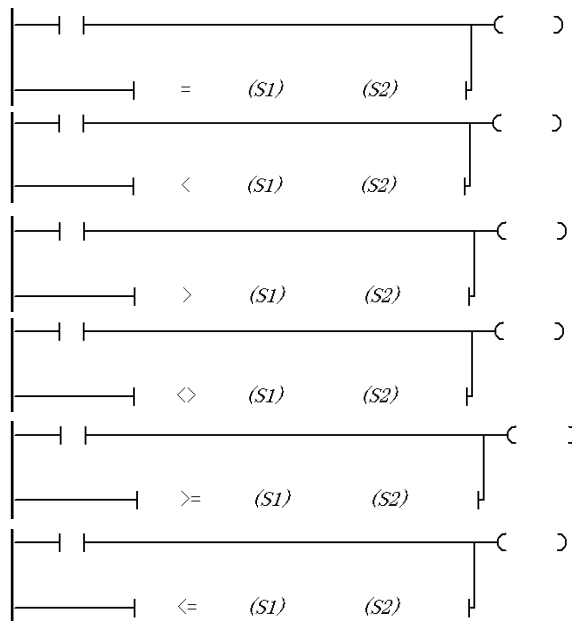
S1





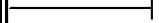



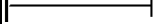



S2

S1 S2

H	=	1000 D0	-2000 D1		Y0
H	<	1000 D0	-2000 D1		Y1
H	>	1000 D0	-2000 D1		Y2
H	<>	1000 D0	-2000 D1		Y3
H	>=	1000 D0	-2000 D1		Y4
H	<=	1000 D0	-2000 D1		Y5

$\vdash \vdash = (S1) (S2) \vdash \vdash$		
$\vdash \vdash < (S1) (S2) \vdash \vdash$		
$\vdash \vdash > (S1) (S2) \vdash \vdash$		
$\vdash \vdash \diamond (S1) (S2) \vdash \vdash$		
$\vdash \vdash \triangleright (S1) (S2) \vdash \vdash$		
$\vdash \vdash \triangleleft (S1) (S2) \vdash \vdash$		



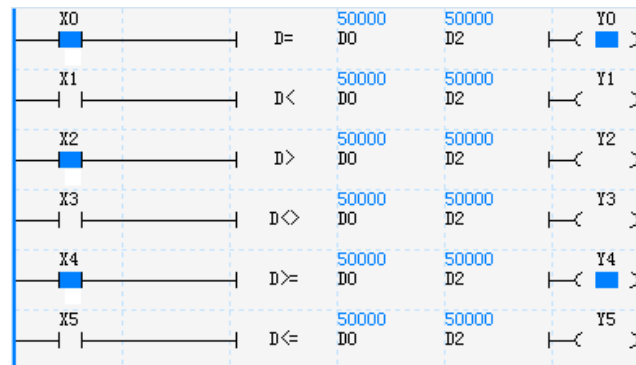
	D=	(S1)	(S2)		
	D<	(S1)	(S2)		
	D>	(S1)	(S2)		
	D<>	(S1)	(S2)		
	D>=	(S1)	(S2)		
	D<=	(S1)	(S2)		

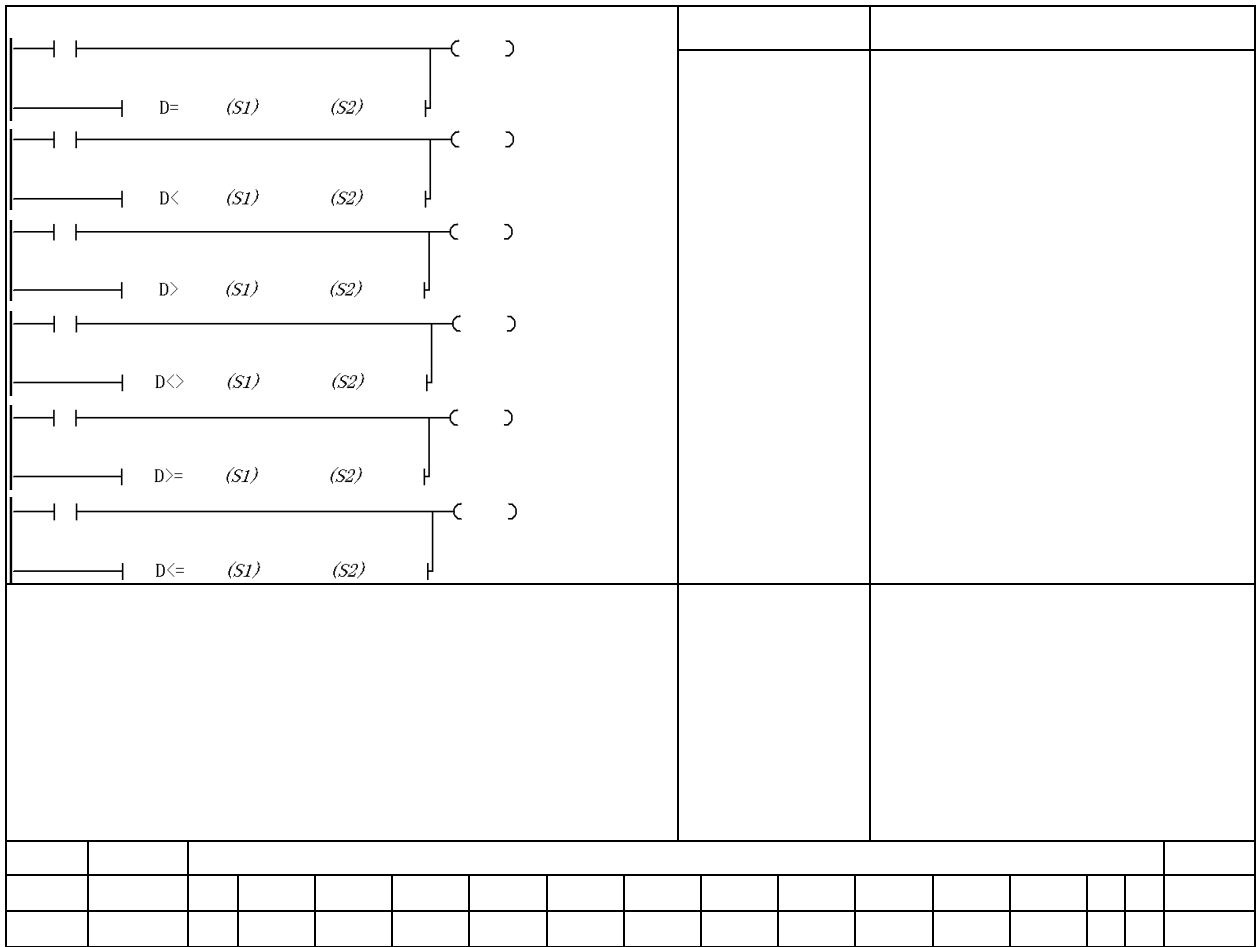
		D=	(S1)	(S2)		(	)		
		D<	(S1)	(S2)		(	)		
		D>	(S1)	(S2)		(	)		
		D<>	(S1)	(S2)		(	)		
		D>=	(S1)	(S2)		(	)		
		D<=	(S1)	(S2)		(	)		

S1

S2

S1 S2

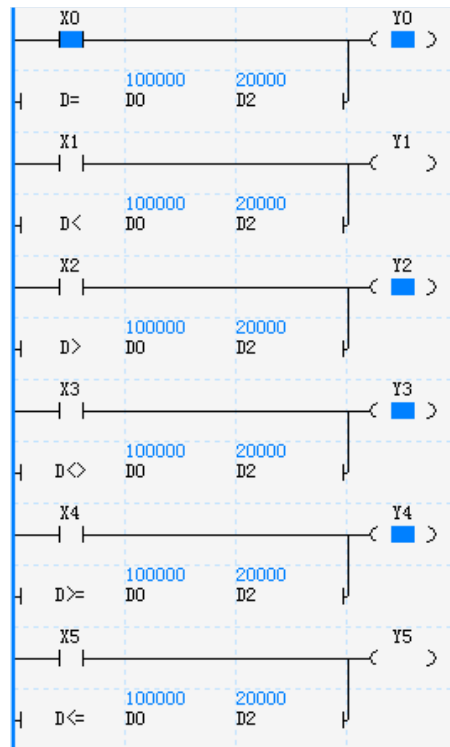




**S1**

**S2**

**S1 S2**



-----	R=	(S1)	(S2)	-----	)		
-----	R<	(S1)	(S2)	-----	)		
-----	R>	(S1)	(S2)	-----	)		
-----	R<>	(S1)	(S2)	-----	)	0	0
-----	R>=	(S1)	(S2)	-----	)		
-----	R<=	(S1)	(S2)	-----	)		

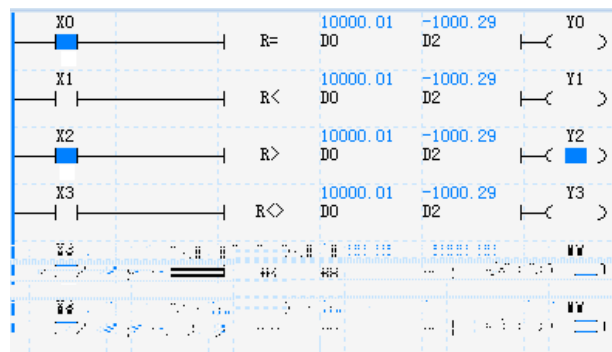
© 2010 Microsoft Corporation. All rights reserved. Microsoft, the Microsoft Dynamics logo, and the Microsoft Dynamics logo are either registered trademarks or trademarks of Microsoft Corporation in the United States and/or other countries.

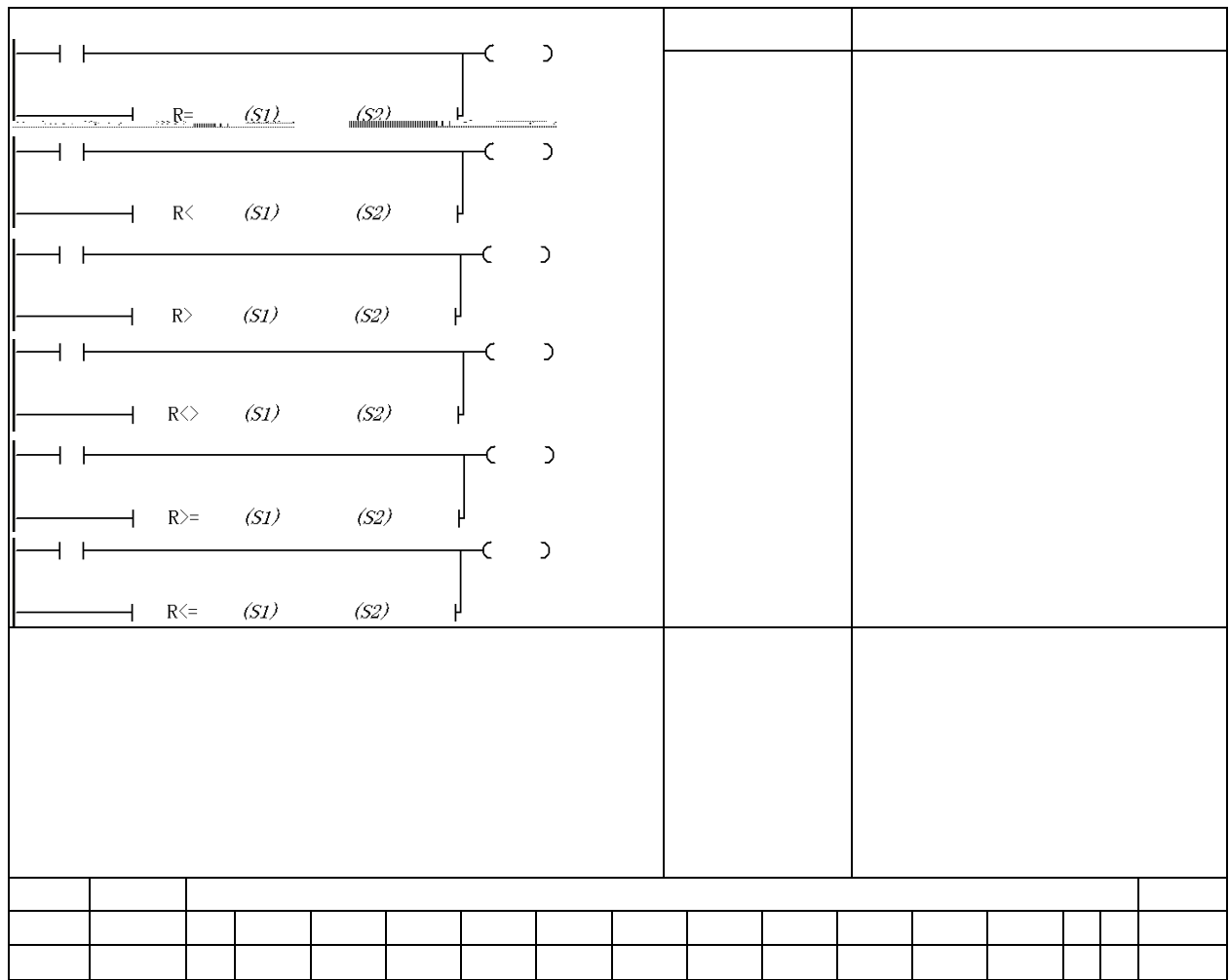
		R=	(S1)	(S2)		)		
		R<	(S1)	(S2)		)		
		R>	(S1)	(S2)		)		
		R<>	(S1)	(S2)		)		
		R>=	(S1)	(S2)		)		
		R<=	(S1)	(S2)		)		

S1

S2

S1 S2

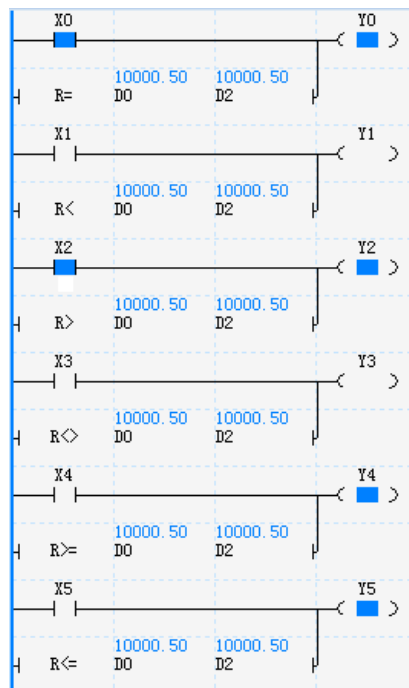




**S1**

**S2**

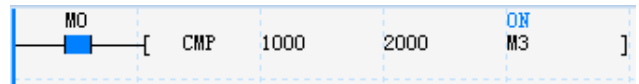
**S1 S2**



[ <b>CMP</b> ]																			
<i>S1 S2 D</i>																			

*S1*  
*S2*  
*D*

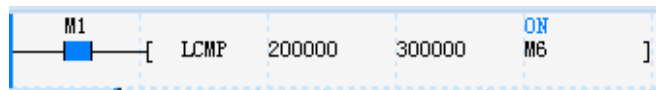
*S1 S2*  
*D D D*



[ ]																			
<i>S1 S2 D</i>																			

*S1*  
*S2*  
*D*

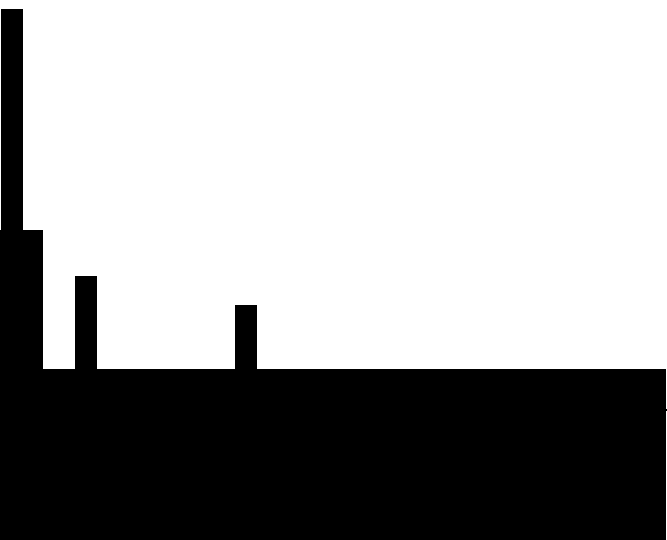
*S1 S2*  
*D D D*



*S1 S2*

---

— —  [ ROP ]																						
<i>S1 S2 D</i>																						
										@	ı	ö	™	€	4ef7h	•	™	02a				



[ BKSUB (S1) (S2) (D) (S3) ]			
<b>BKSUB</b>			

S1

S2

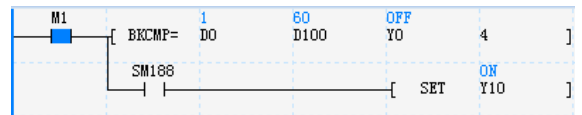
D

S3

M1	[	BKSUB	1	30	-29	5	]
			D10	D100	D1000		

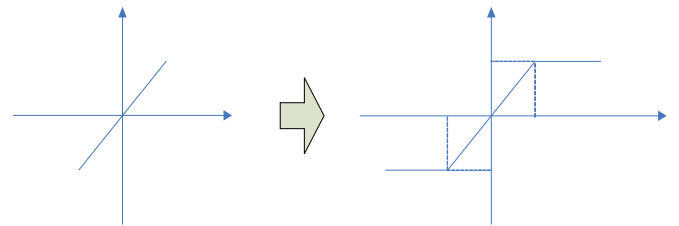
[	BKCMF=	(S1)	(S2)	(D)	(S3)	]		
[	BKCMF<	(S1)	(S2)	(D)	(S3)	]		
[	BKCMF>	(S1)	(S2)	(D)	(S3)	]		
[	BKCMF<=	(S1)	(S2)	(D)	(S3)	]		
[	BKCMF>=	(S1)	(S2)	(D)	(S3)	]		
[	BKCMF>=	(S1)	(S2)	(D)	(S3)	]		
<b>BKCMF</b>								
		(S1)	(S2)	(D)	(S3)			

S1  
S2  
D  
S3



----- -----  [ LIMIT (S1) (S2) (S3) (D) ]																
(S1) (S2) (S3) (D)																

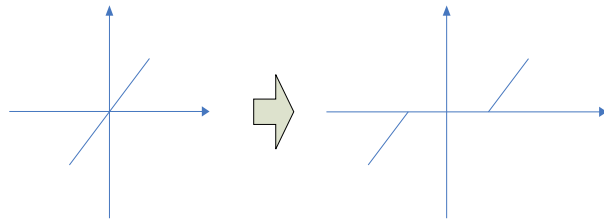
S1  
S2  
S3  
D:



M1	[	LIMIT	10	100	30	30	]
<input checked="" type="checkbox"/>		DO	D10	D100	D1000		

----- -----  [ DBAND (S1) (S2) (S3) (D) ]													
(S1) (S2) (S3) (D)													

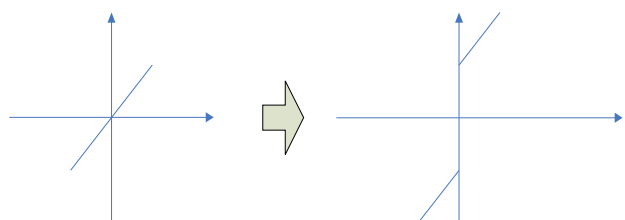
S1  
S2  
S3  
D:



M1	[ DBAND	-100	100	30	0
	D0	D10	D100	D1000	

----- -----  [ ZONE (S1) (S2) (S3) (D) ]													
(S1) (S2) (S3) (D)													

S1  
S2  
S3  
D:



M1	[	ZONE	-100	100	30	130	]
		D0	D10	D100	D1000		

		[		SCL	(S1)	(S2)	(D)	]						
				(S1)	(S2)	(S3)	(D)							

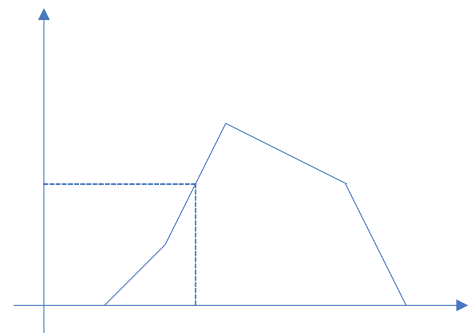
S1

M1	[	SCL	25	5	40	]
		D10	D100	D1000		

S2

D:





SER (S1) (S2) (D) (S3) ]															
(S1) (S2) (S3) (D)															

S1

S2

D

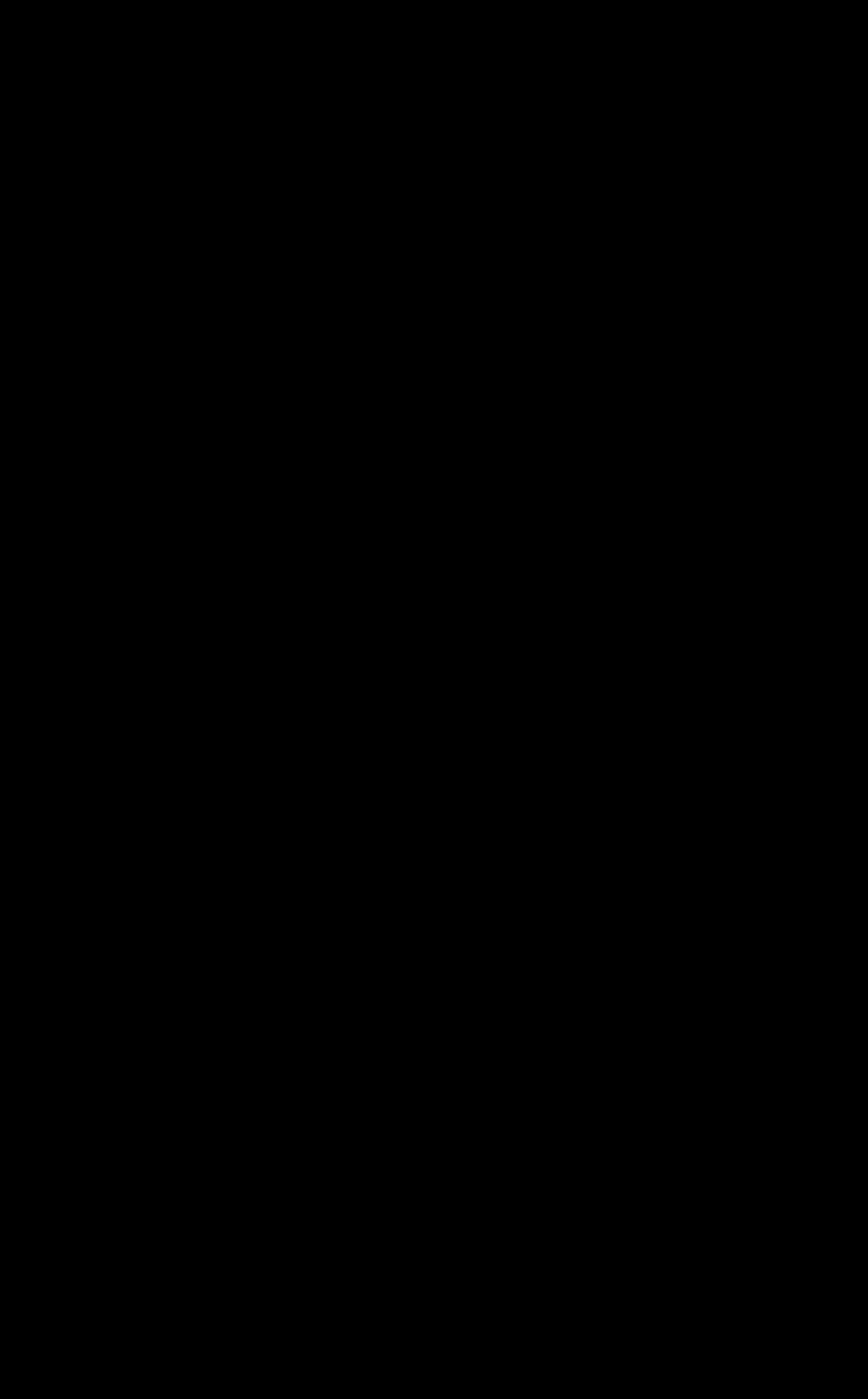
S3

S3

[ STRADD (S1) (D) (S2) ]														
(S1) S2 D														

**S1**  
**S2**  
**D:**

“ • €! Ÿ ™ˆ Dt\$ Ō? @ ú, ð ™€ ð ™€ bC @ ú, [S



—

□  
□  
□

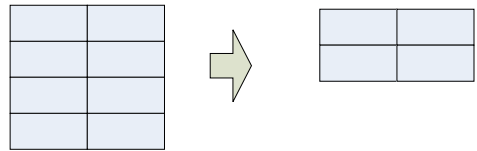
—

—

----- ----- ----- ----- ----- ----- ----- ----- ----- ----- ----- ----- ----- -----														
----- ----- ----- ----- ----- ----- ----- ----- ----- ----- ----- ----- ----- -----														
<b>S1    D    S2</b>														

S1  
D  
S2

M1	12849	13363	
[	STRIGHT	D10	D100    3    ]

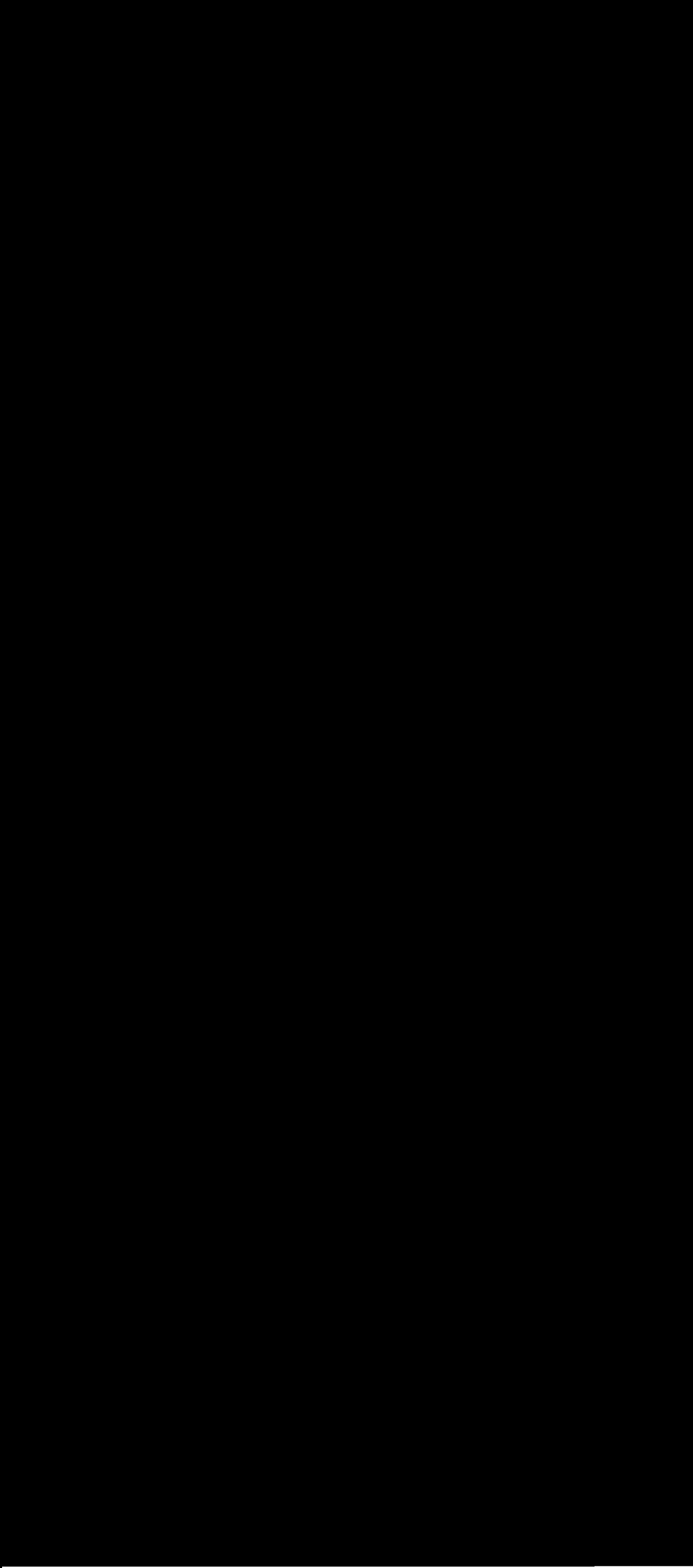


<i>S1</i> <i>D</i> <i>S2</i>														

*S1*

*D*

*S2*



---


---

---

----- -----  [ STRMIDW (S1) (D) (S2) ]																
<i>S1    D    S2</i>																

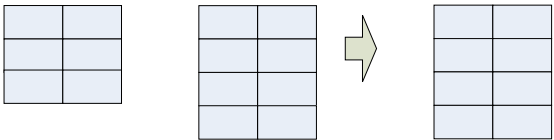
*S1*

*D*

*S2*

*S2+1*

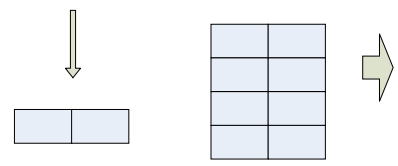
M1		12849	12596	2
—■—	[ STRMIDW	D10	D100	DO ]

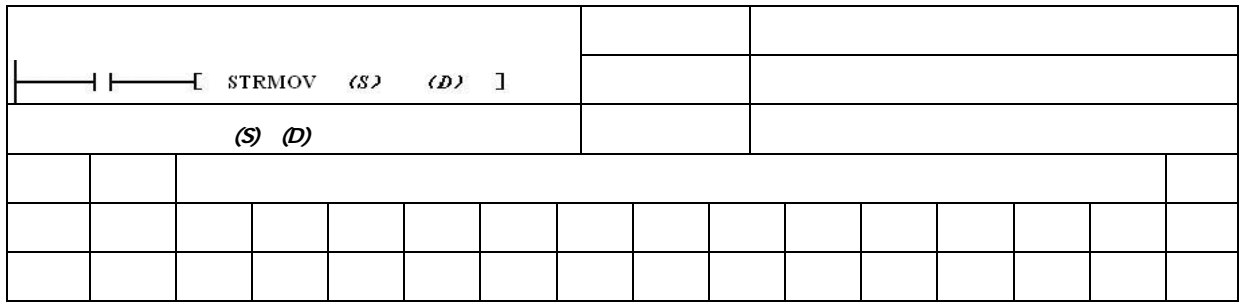


[ STRINSTR (S1) (S2) (D) (S3) ]													
<i>S1 S2 D S3</i>													

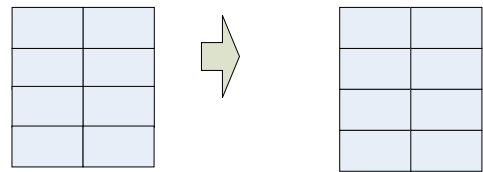
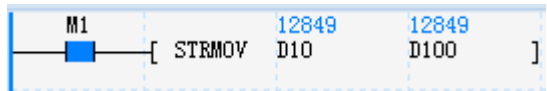
*S1*  
*S2*  
*D*  
*S3*

```
M1 [STRINSTR "45" 12849 4 D10 D100 2 ]
```





S  
D:



$F_{acc} = \sqrt{\frac{F}{T}}$																
$F_{acc} = \sqrt{\frac{F}{T}}$																
$F_{acc} = \sqrt{\frac{F}{T}}$																
		<i>S1</i>	<i>S2</i>	<i>S3</i>	<i>D</i>											

*F<sub>acc</sub>*

*S1*

*S2*

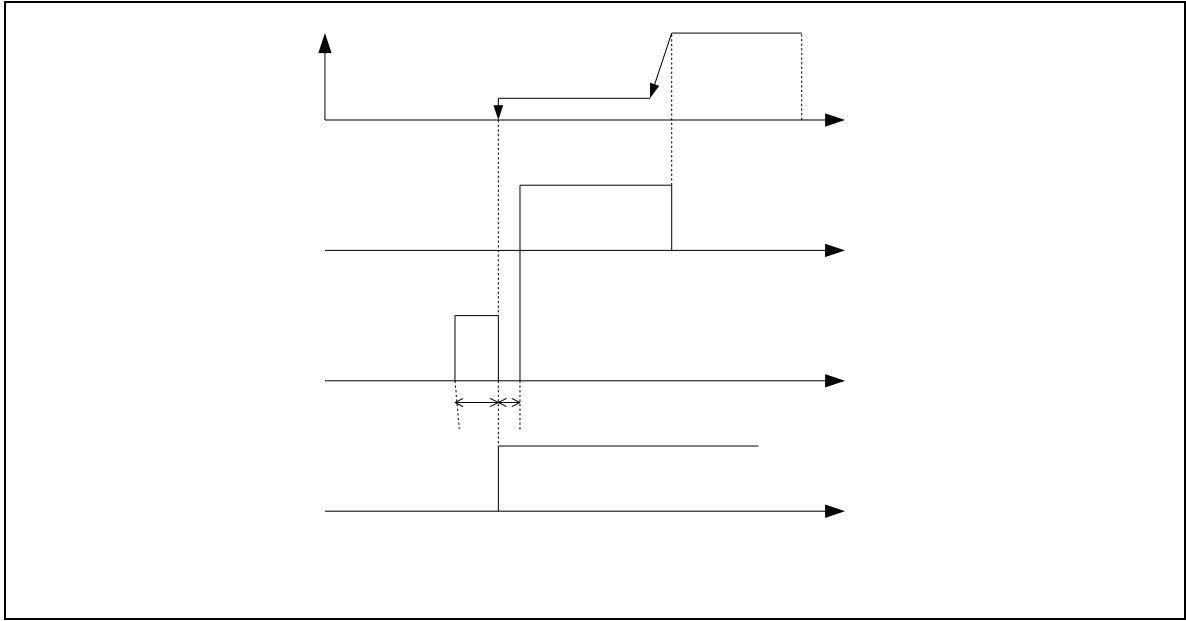
*S3*

*D*

$$F_{acc} = \sqrt{\frac{F}{T}}$$

*F*

*T*



<b>S</b> <b>D1</b> <b>D2</b>				

—   —  [ DRVI (S1) (S2) (D1) (D2) ]																			
<b>S1 S2 D1 D2</b>																			

**S1**

$$F_{acc} \sqrt{\frac{F}{T}}$$

**F**

**S2**

**T**

**F<sub>acc</sub>**

**D1**

**D2**

**S1**

● **S1**

● **S1**

**S1**

●

●

**S1**

---   ---  [ DRVA (S1) (S2) (D1) (D2) ]																			
<b>S1 S2 D1 D2</b>																			

S1

$$F_{acc} \sqrt{\frac{F}{T}}$$

S2

F

T

D1

F<sub>acc</sub>

D2

D2

D2

S1

•

•

S1

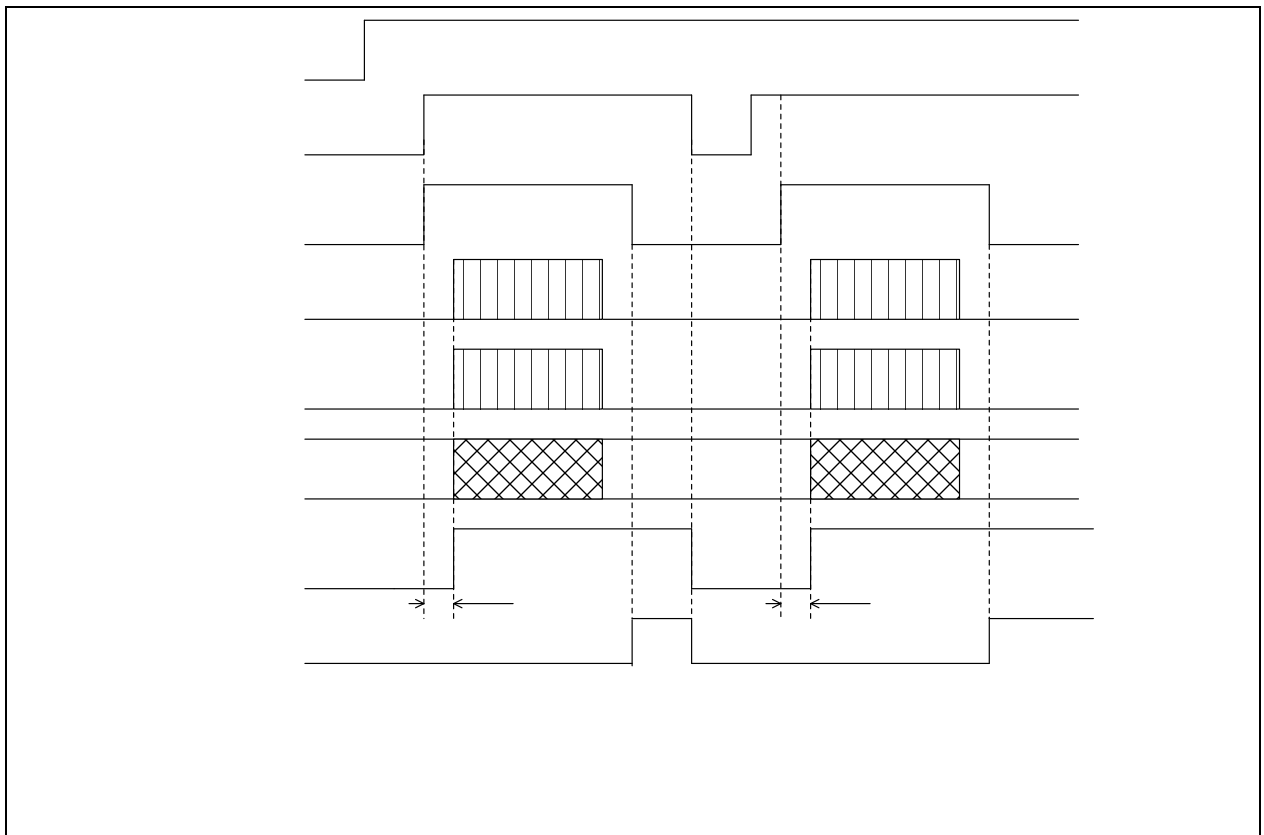
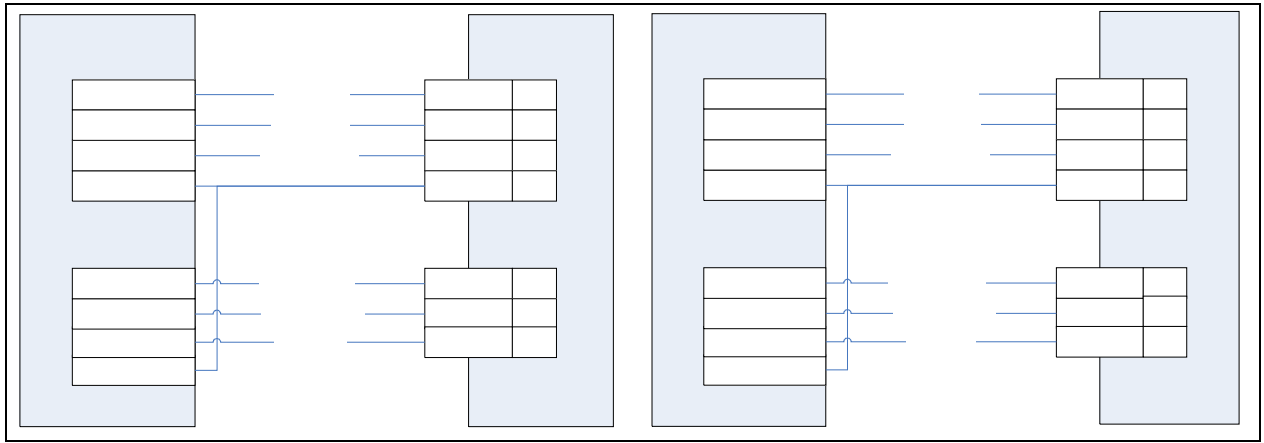
---

—   —  [ ABS (S) (D1) (D2) ]											
<b>S D1 D2</b>											

**S**

**D1**

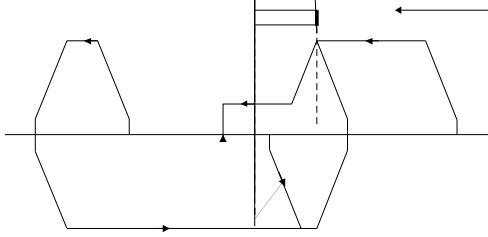
**D2**



		[	<b>DSZR</b>	]		
			(S1)	(S2)	(D1)	(D2)

---


*D2*



S0	[	DMOV	10000	100000	SD202	]
	[	MOV	100	100	SD204	]
	[	MOV	5000	5000	SD205	]
	[	MOV	2000	2000	SD207	]
	[	MOV	8000	8000	SD208	]

M8	[	DSZR	OFF	OFF	OFF	OFF	]
			M100	X0	Y0	Y4	

[ STOPDV ]			
		<i>S1</i>	<i>S2</i>
		<i>S3</i>	<i>D</i>

**S2**

**D**

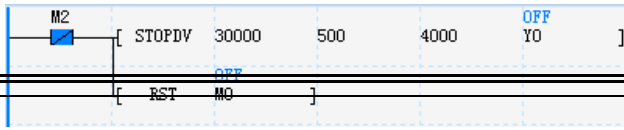
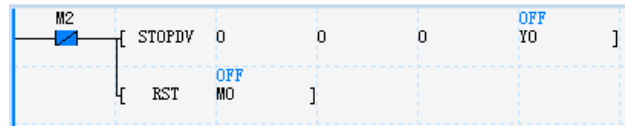


**INT\_1**

程序名称: INT\_1 作者:

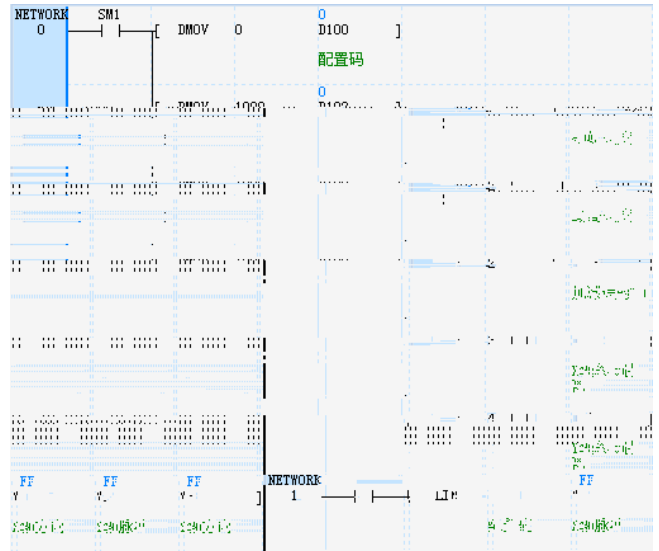
中断事件: X6输入上升沿中断(中断号=6) ...

程序说明:



		<b>LUN</b>								
		S	D1	D2	D3	D4				


D1 D3

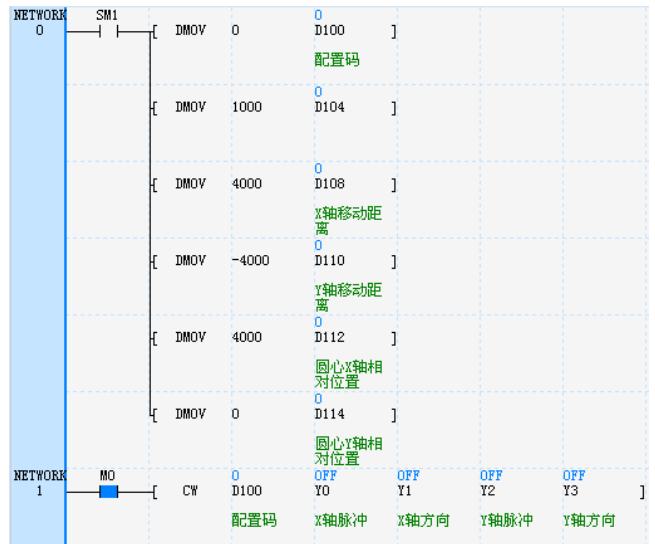
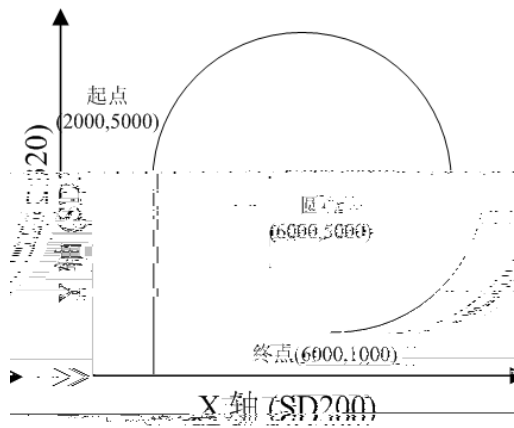


---

$\left[ \begin{array}{c} \text{---} \\ \text{---} \\ \text{---} \end{array} \right]$ <b>QW</b> $]$							
S	D1	D2	D3	D4			

	<table border="1"><thead><tr><th></th><th></th></tr></thead><tbody><tr><td></td><td></td></tr><tr><td></td><td></td></tr></tbody></table>												
	<table border="1"><thead><tr><th></th><th></th><th></th></tr></thead><tbody><tr><td></td><td></td><td></td></tr><tr><td></td><td></td><td></td></tr><tr><td></td><td></td><td></td></tr></tbody></table>												

---



[ <b>CW</b> ]							
	<b>S</b>	<b>D1</b>	<b>D2</b>	<b>D3</b>	<b>D4</b>		





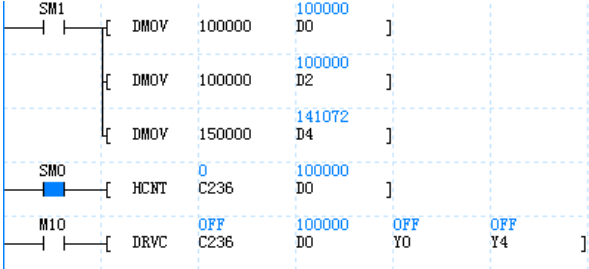


---

[ GEARBOX ]		
<i>D1 S1 D2 S2</i>		

---

[ DRVC (S1) (D1) (S2) (D2) ]														



——[ CAMTABLE (S1) (S2) (S3) (S4) (S5) ]														

M1			↑		[ CAMTABLE	R10	D12	D14	D16	D18	]
M3					[ CAMBOX	D0	X0	Y2	Y3	X10	]

—— [ CAMBOX (S1) (D1) (D2) (D3) (D4) ]														

M1	——	↑	[CAMTABLE	R10	D12	D14	D16	D18	]
M3	——	[CAMBOX	D0	X0	Y2	Y3	X10	]	

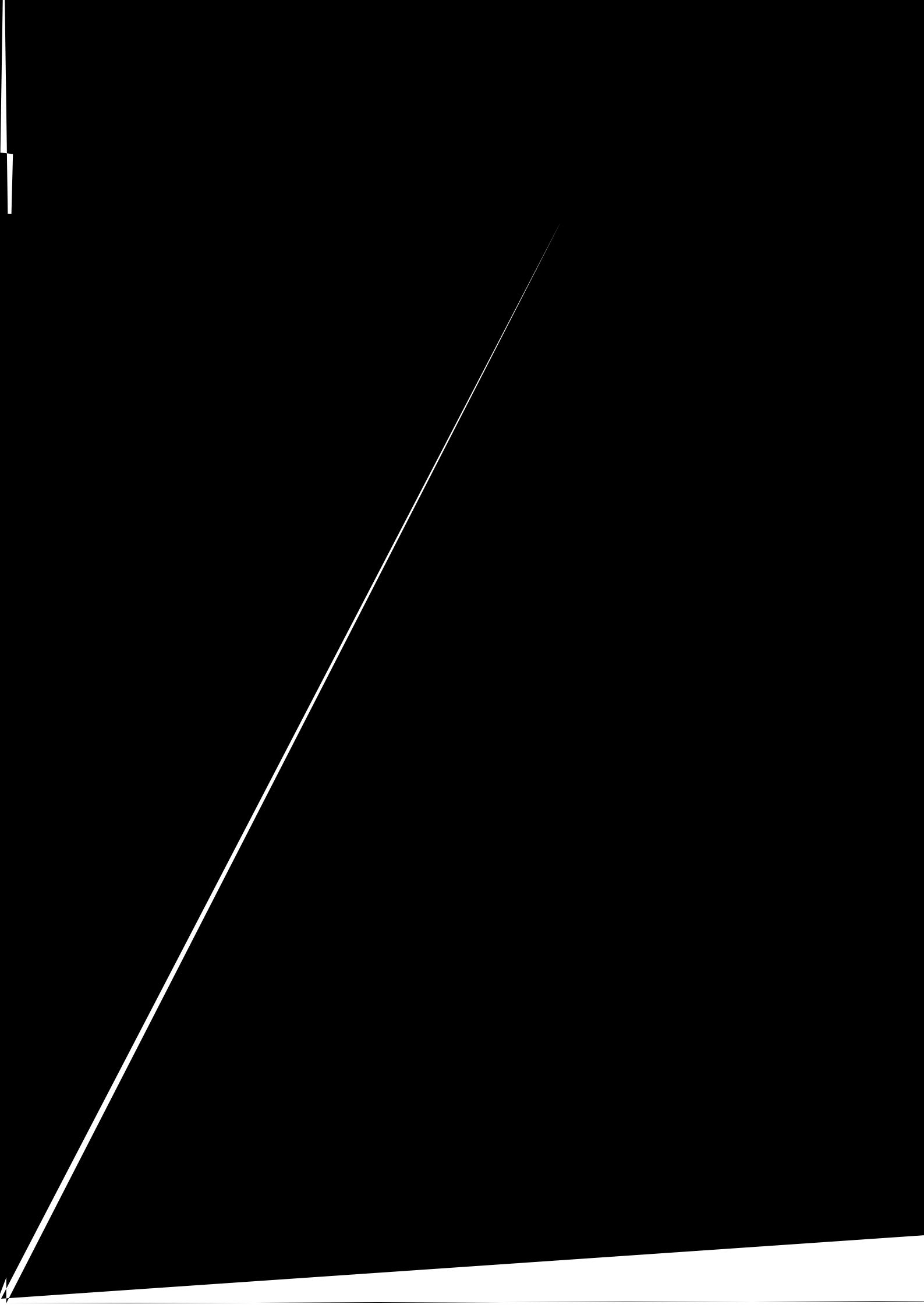
[ MEAN (S1) (D) (S2) ]										MC280				

S1  
S2  
D

M1	[	MEAN	32	10	4	]
			D0	D10		

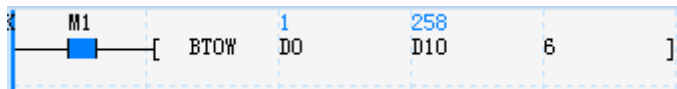
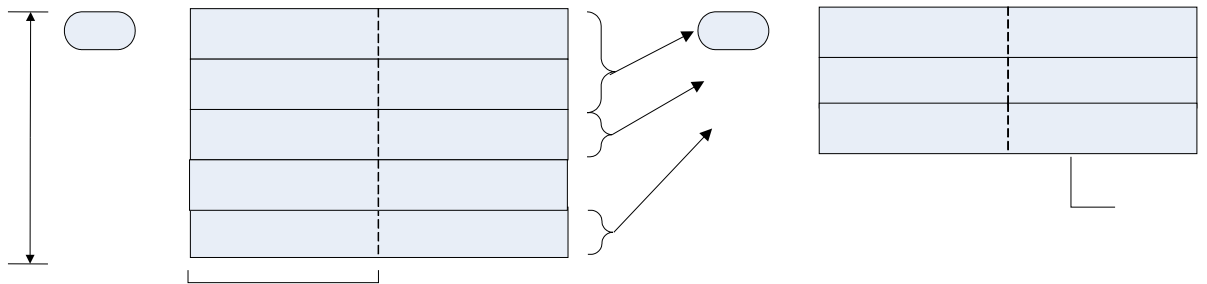
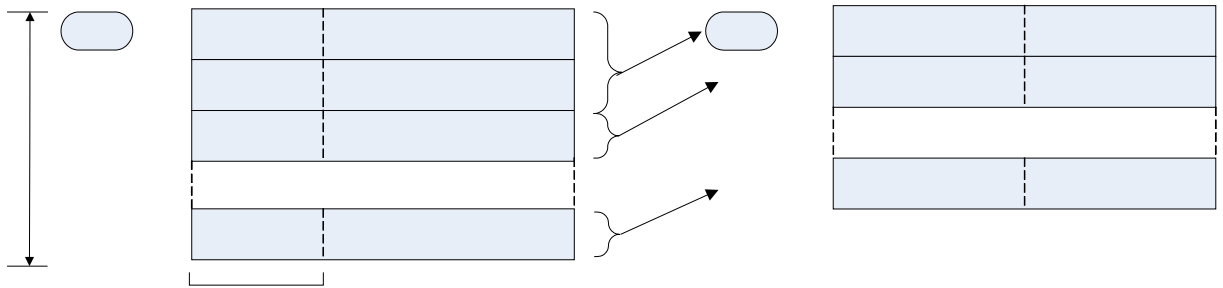
[ WTOB (S1) (D) (S2) ]										MC280				
7														

S1  
S2  
D



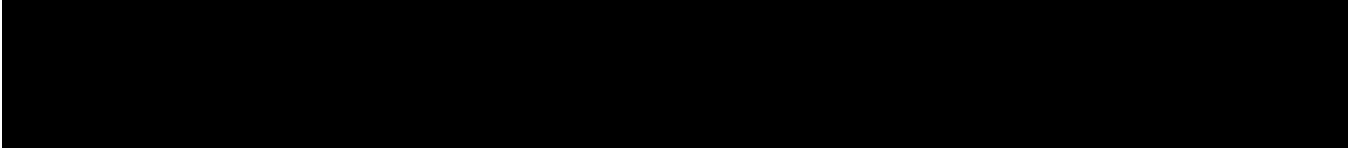
[ BTOW (S1) (D) (S2) ]																

S1  
S2  
D



---

|—| — [ **UNI** (*S1*) (*D*) (*S2*) ]



[ <b>DIS</b> (S1) (D) (S2) ]																			



----- -----  [ RND (D) ]														
<i>D</i>														

*D*








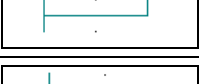


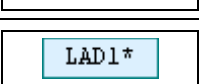
----- -----  [ DUTY (S1) (S2) (D) ]														
<i>S1 S2 D</i>														

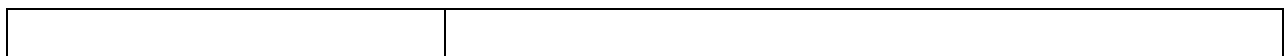
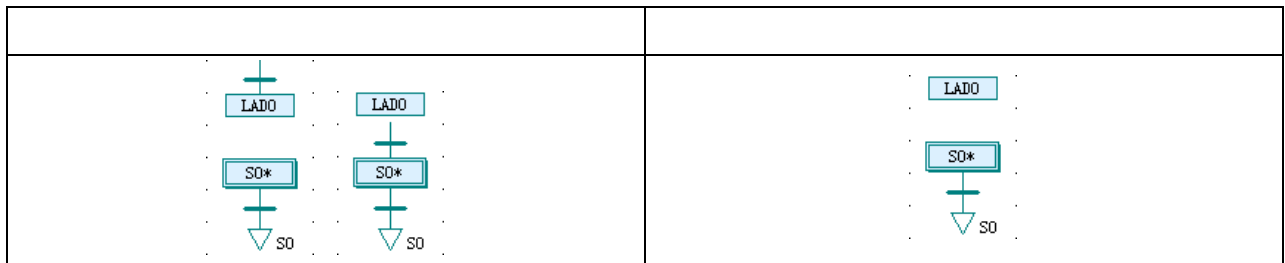
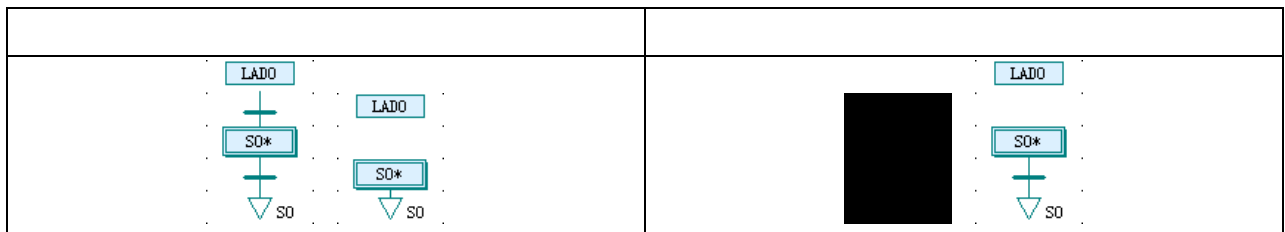
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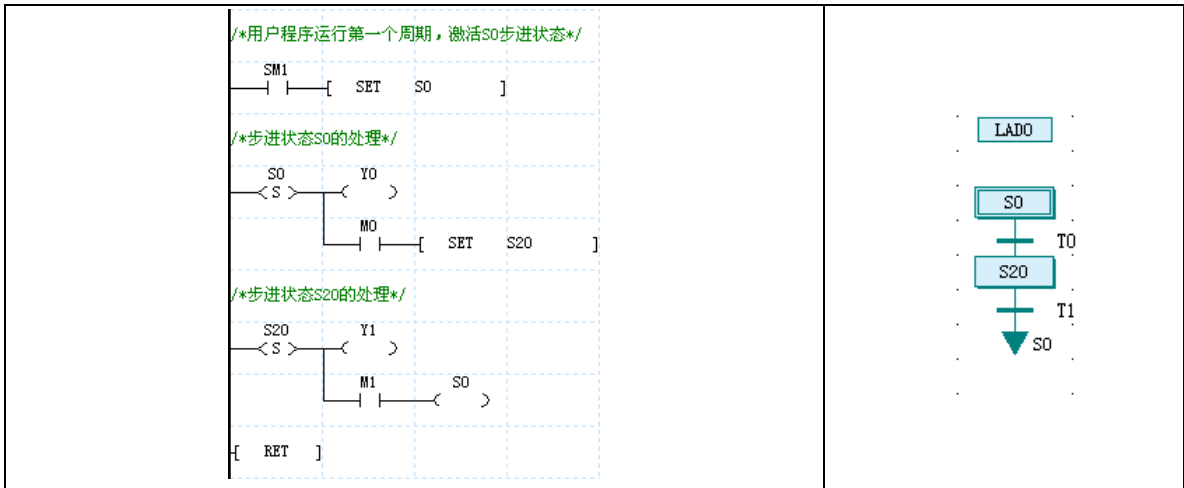
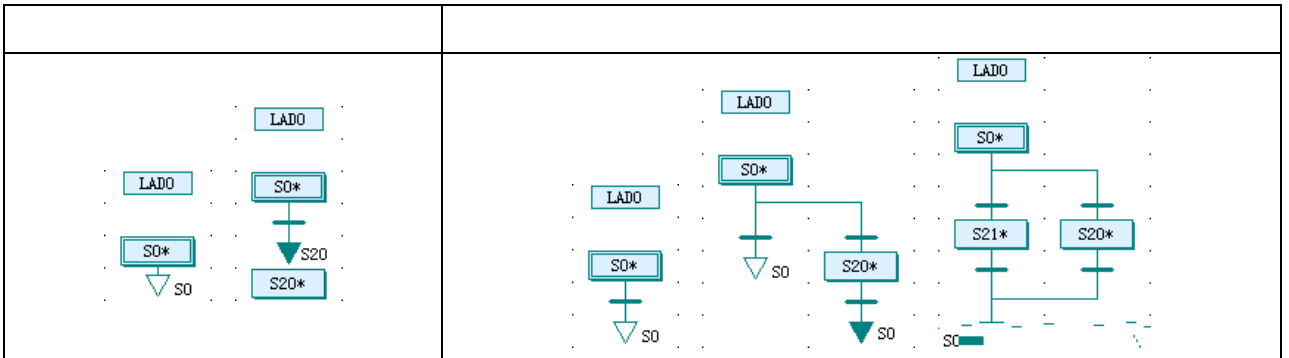
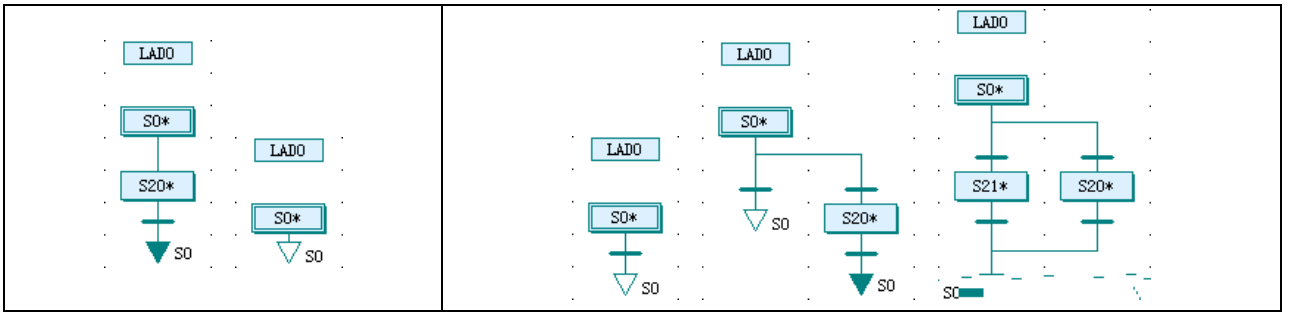
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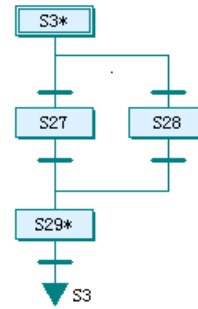
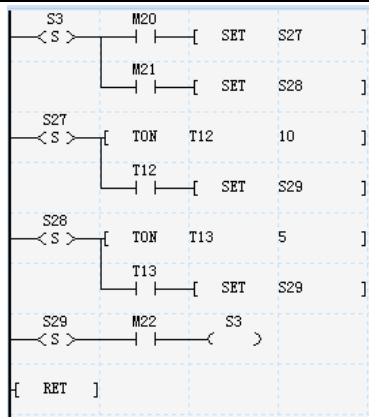
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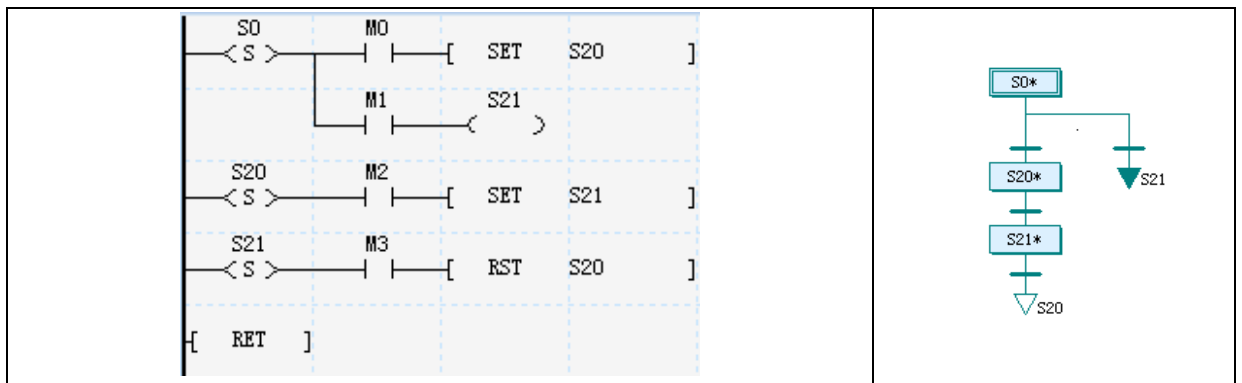
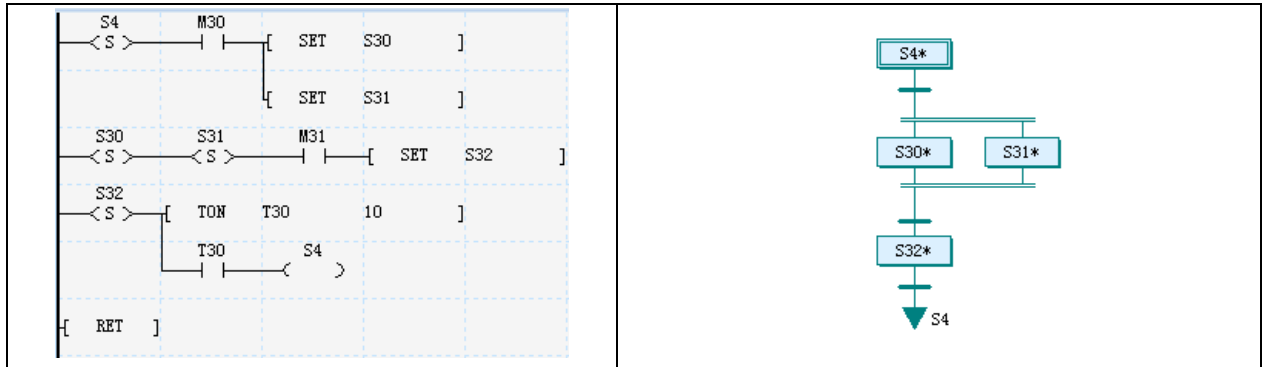


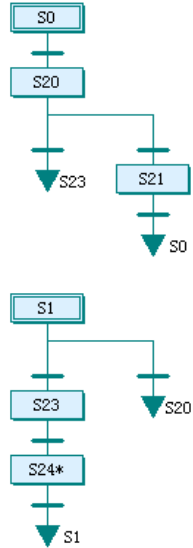
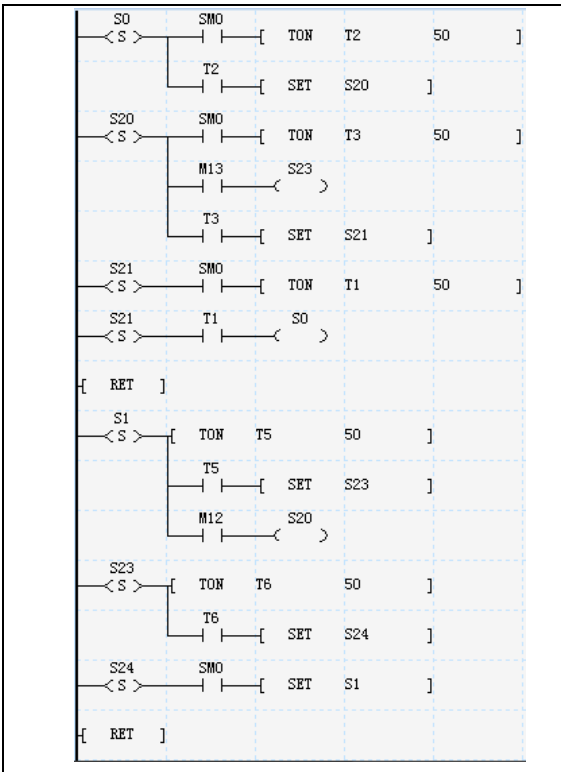
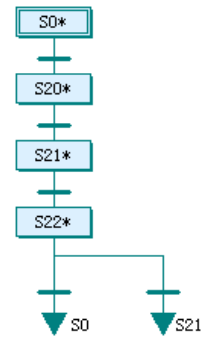
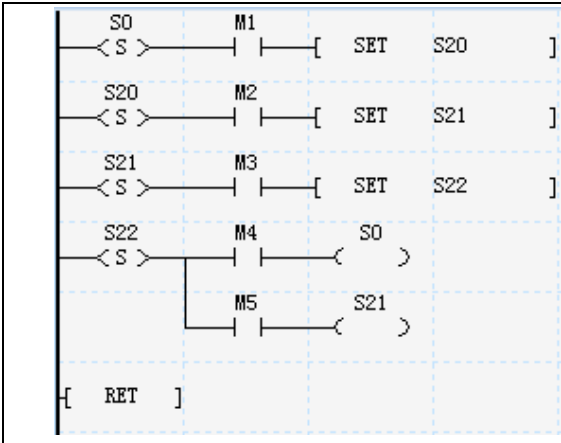
		
		
		
		
		
		
		
		
		

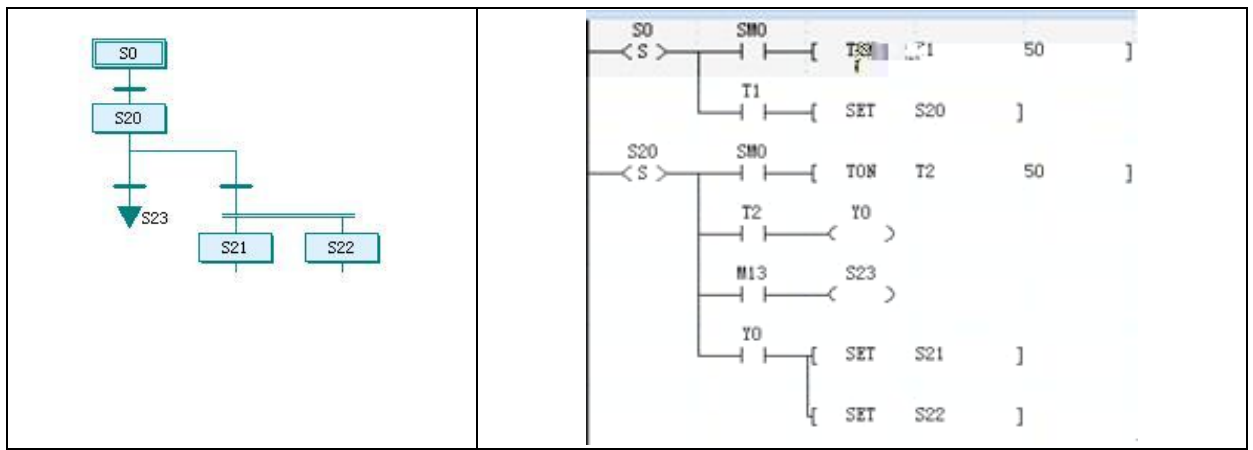






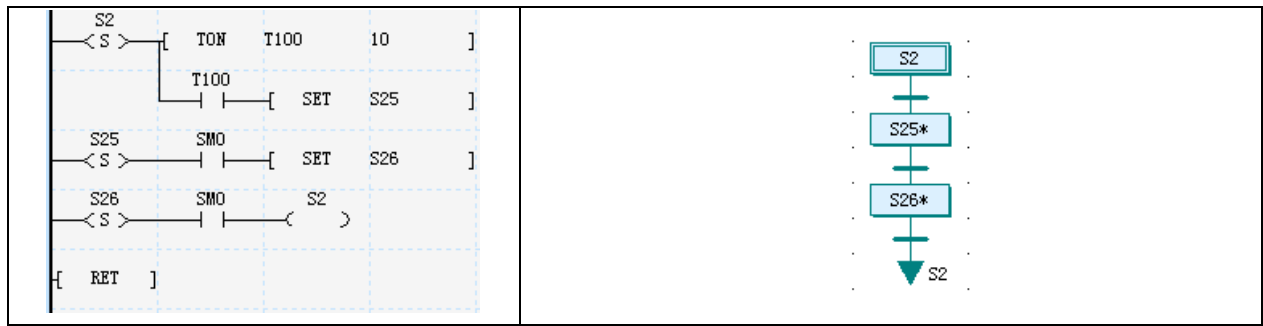






5.31 STL SFC





5.31 STL SFC

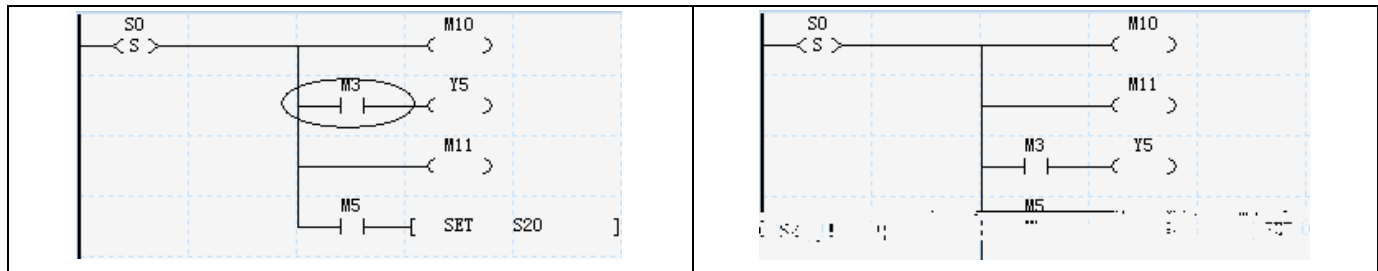
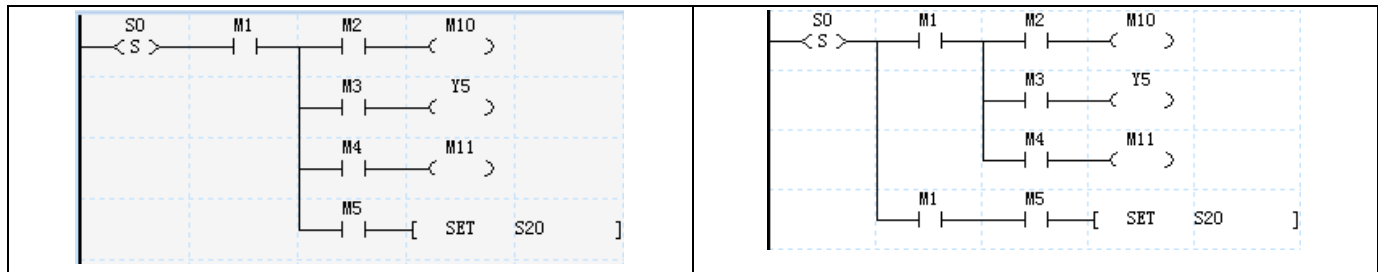
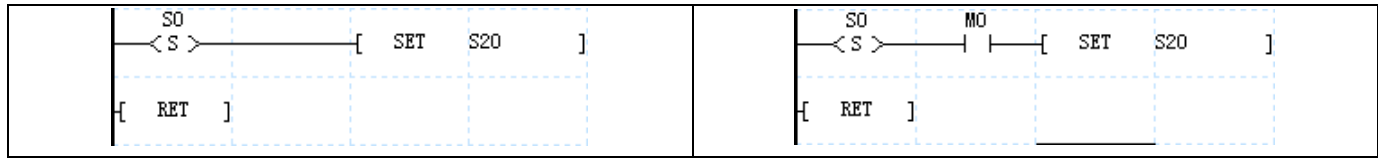


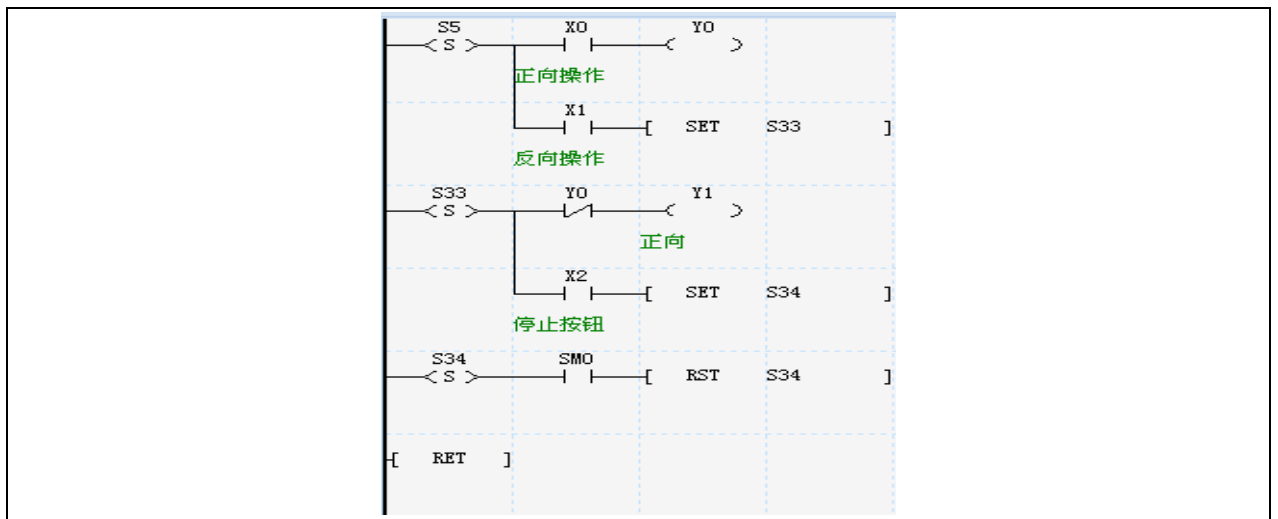
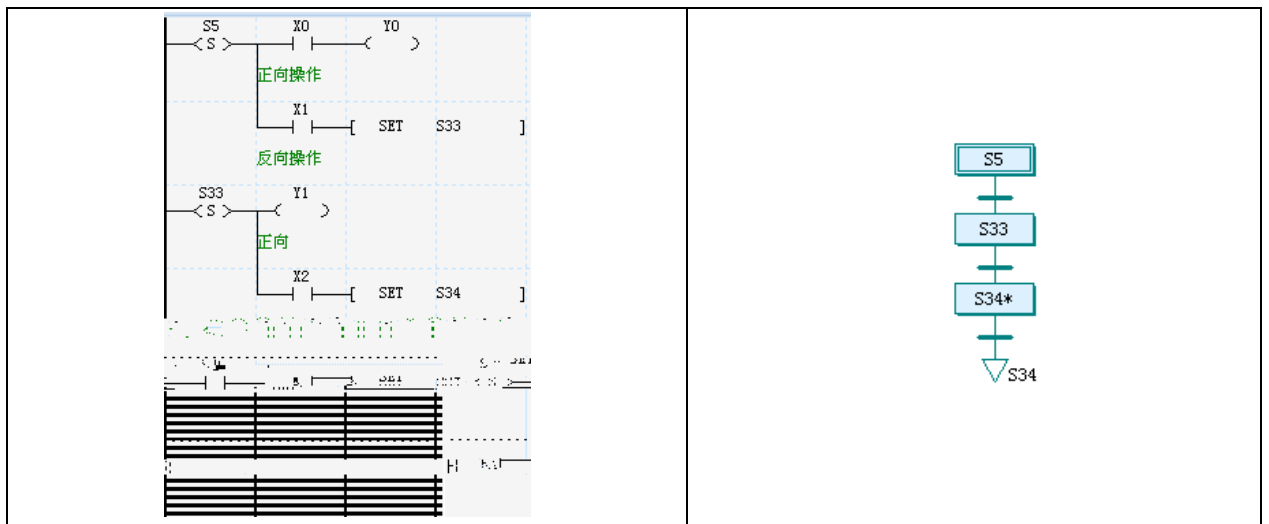
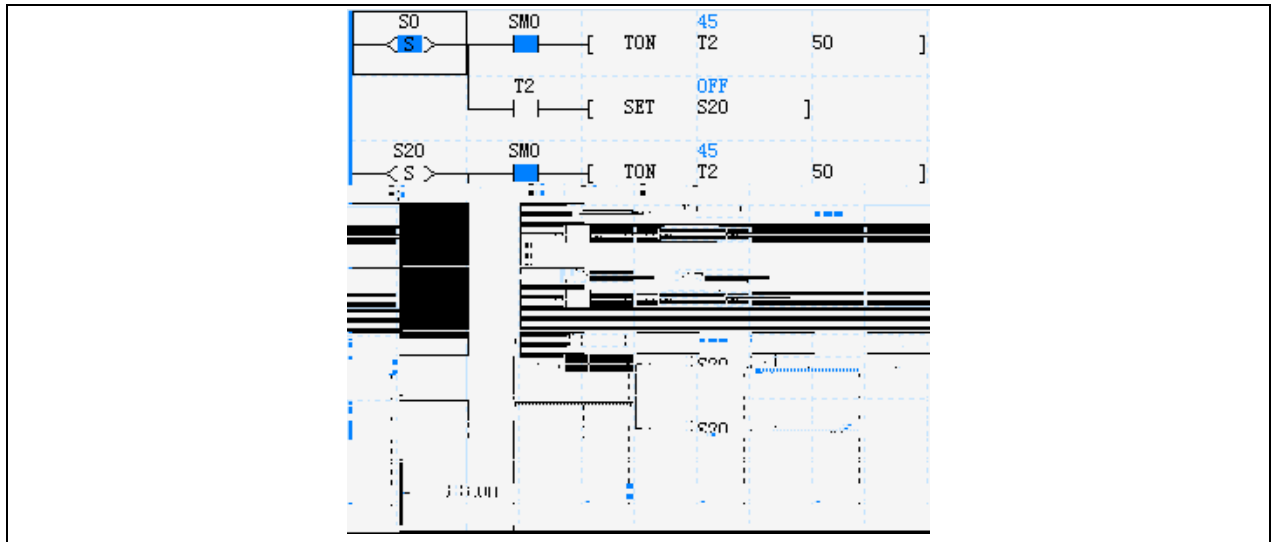
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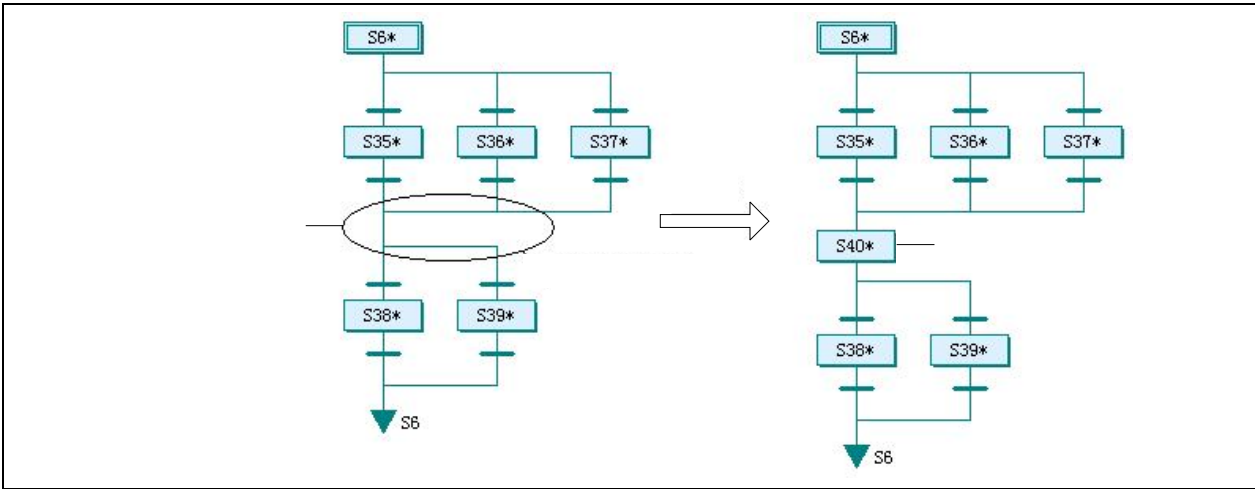
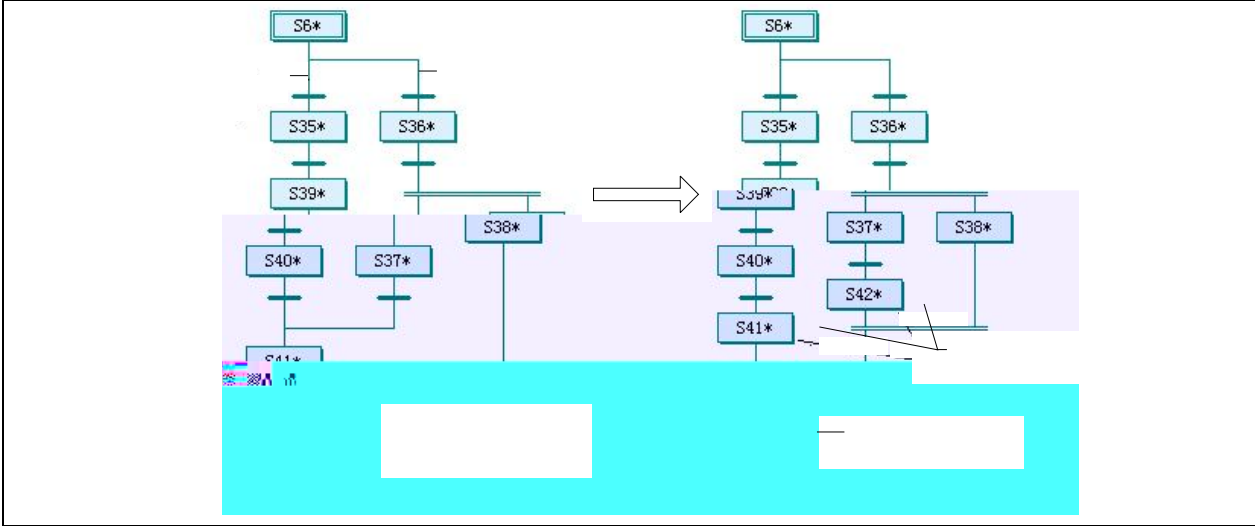
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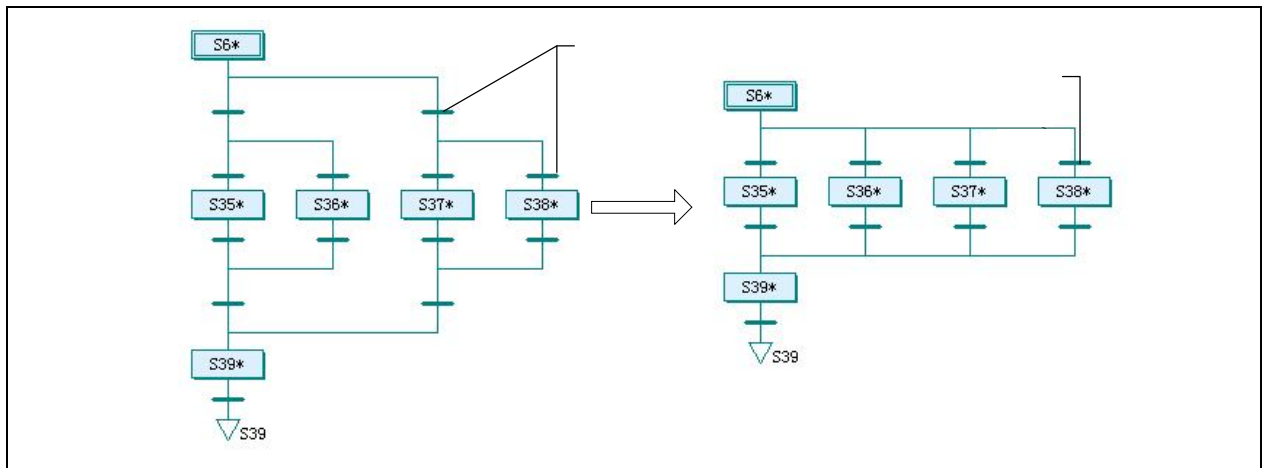
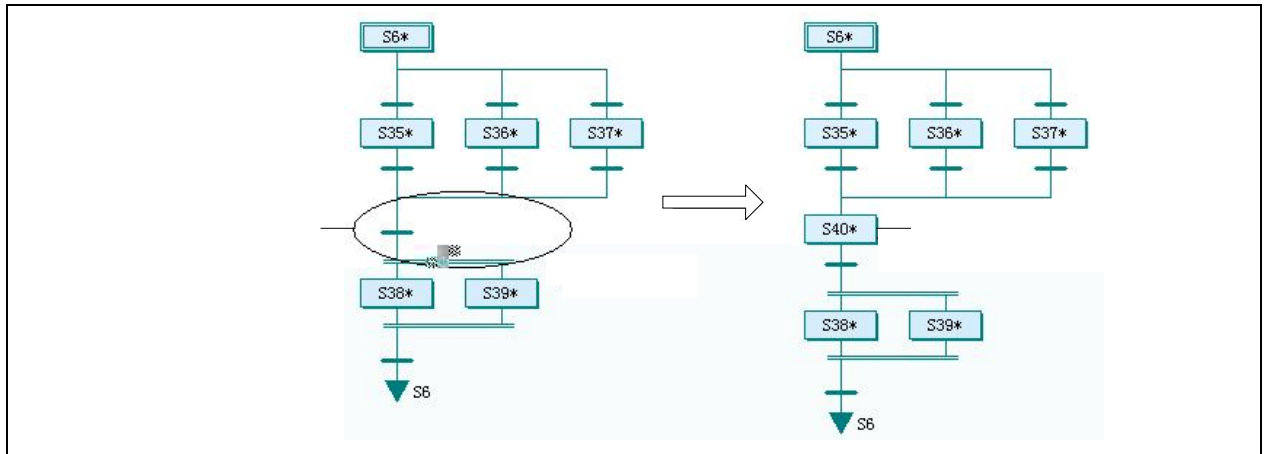
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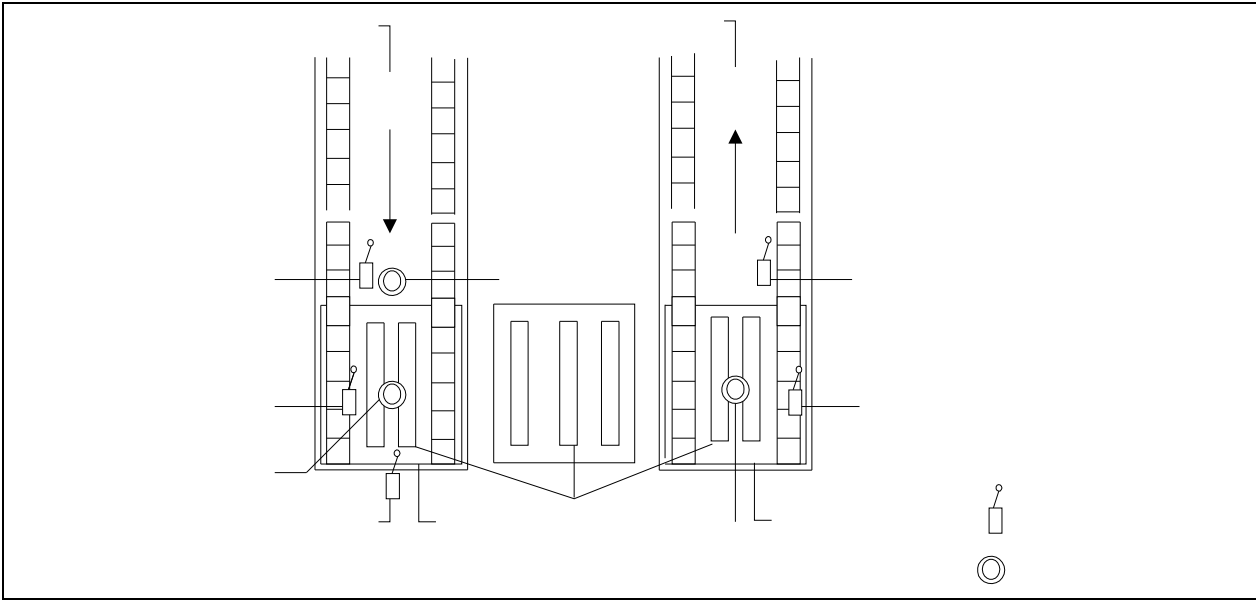


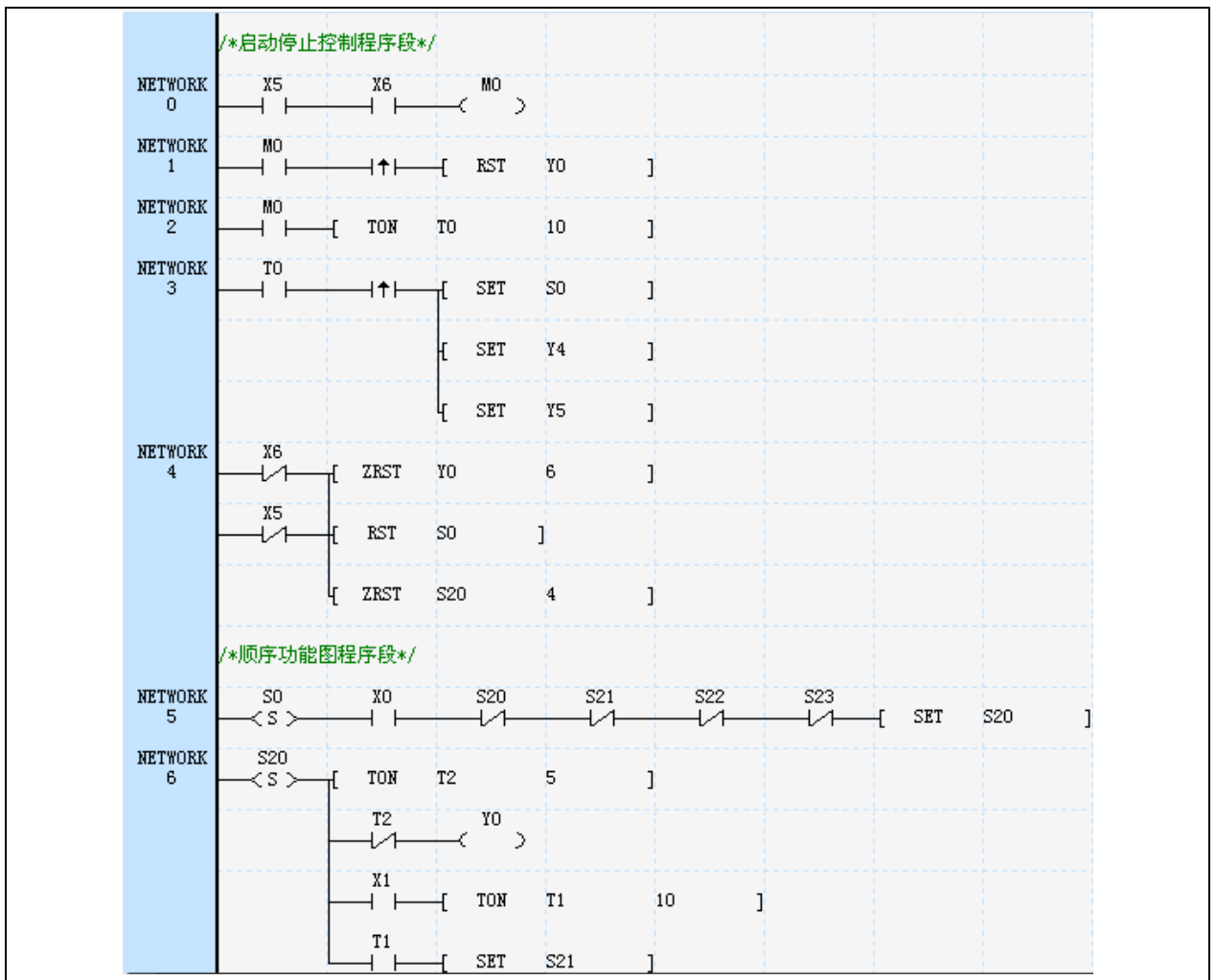


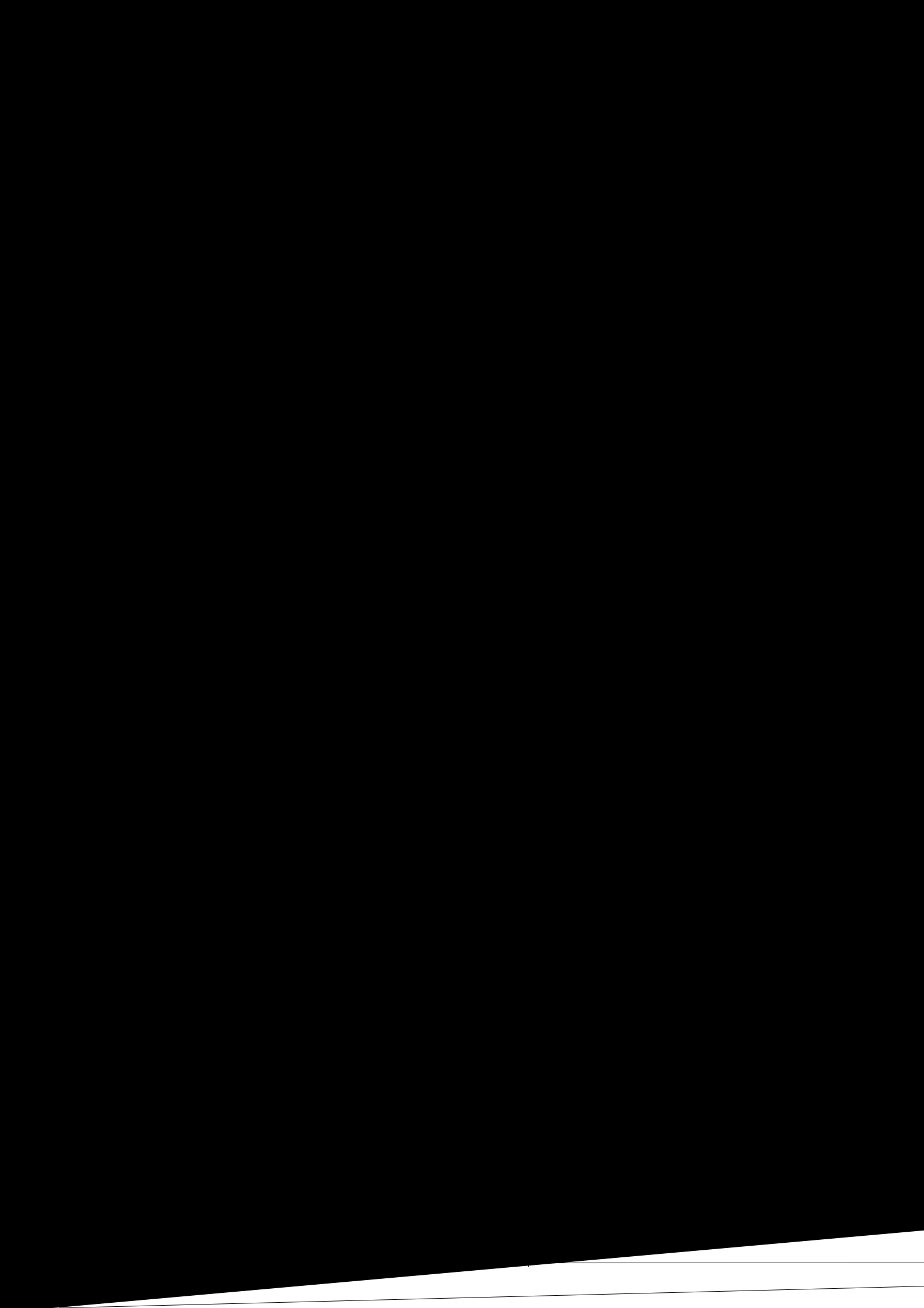




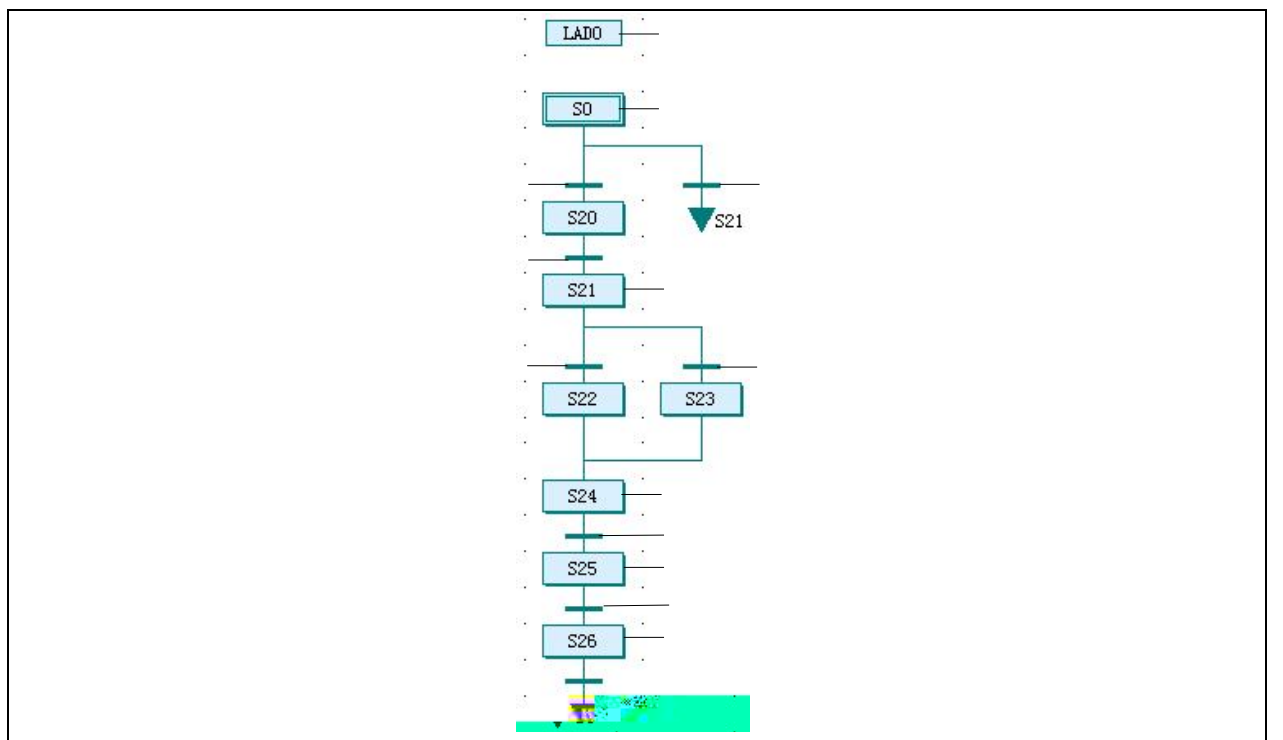


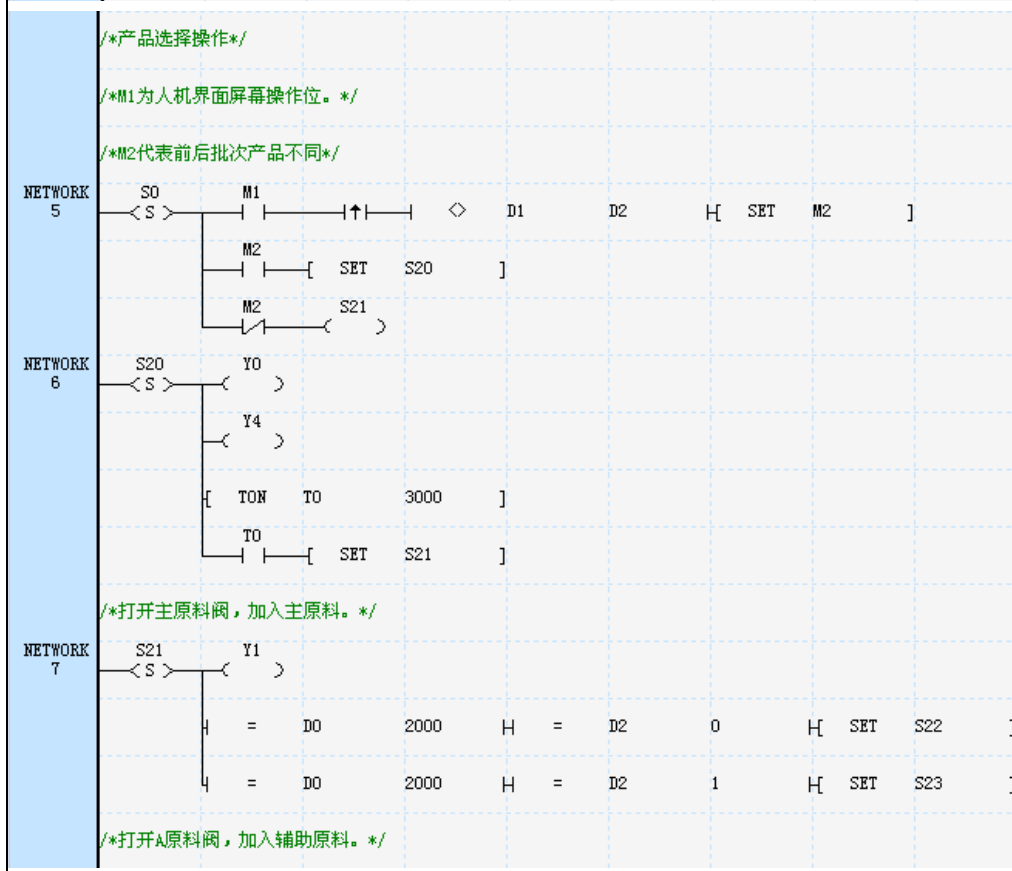


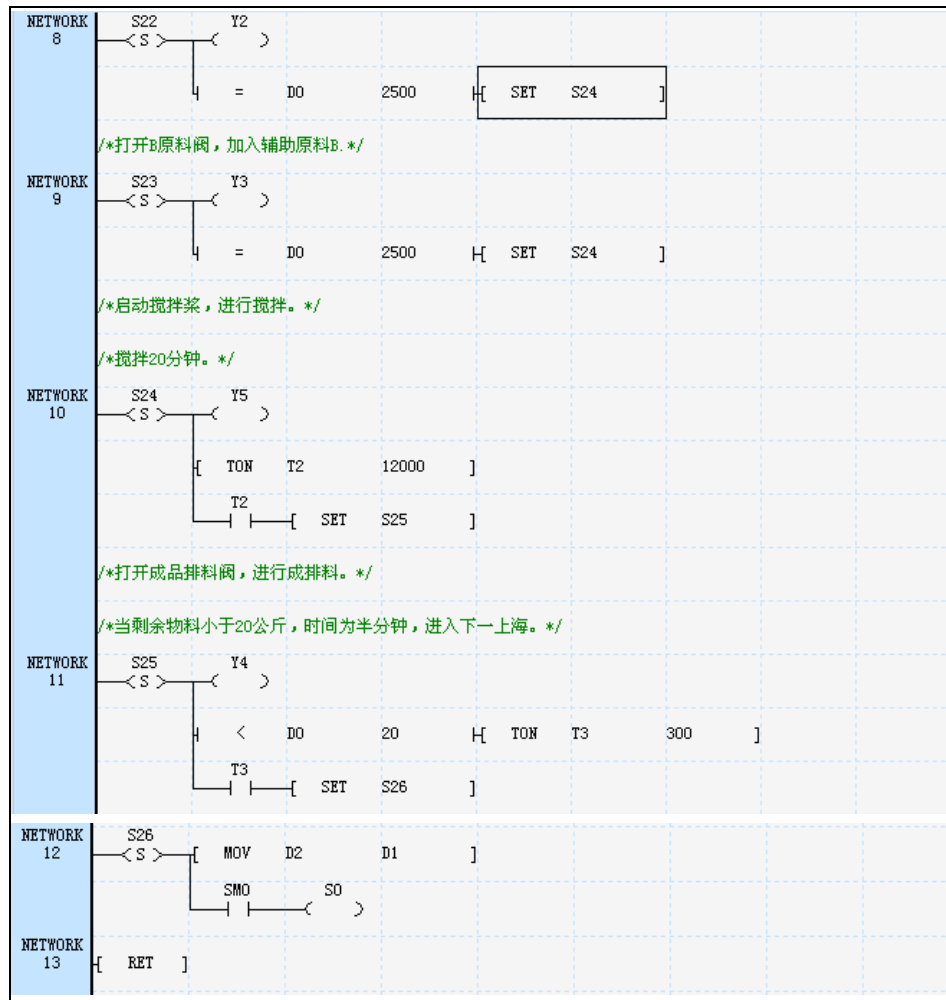


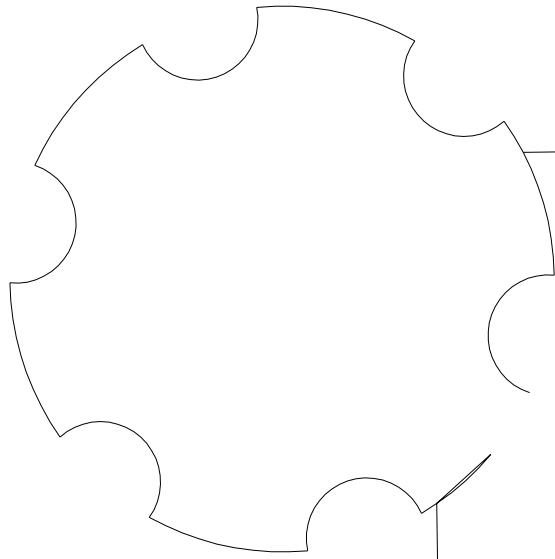
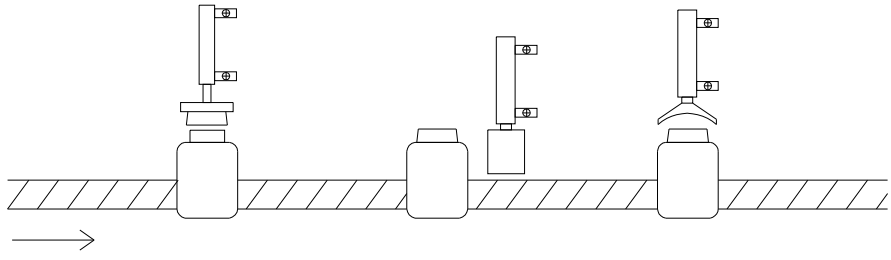


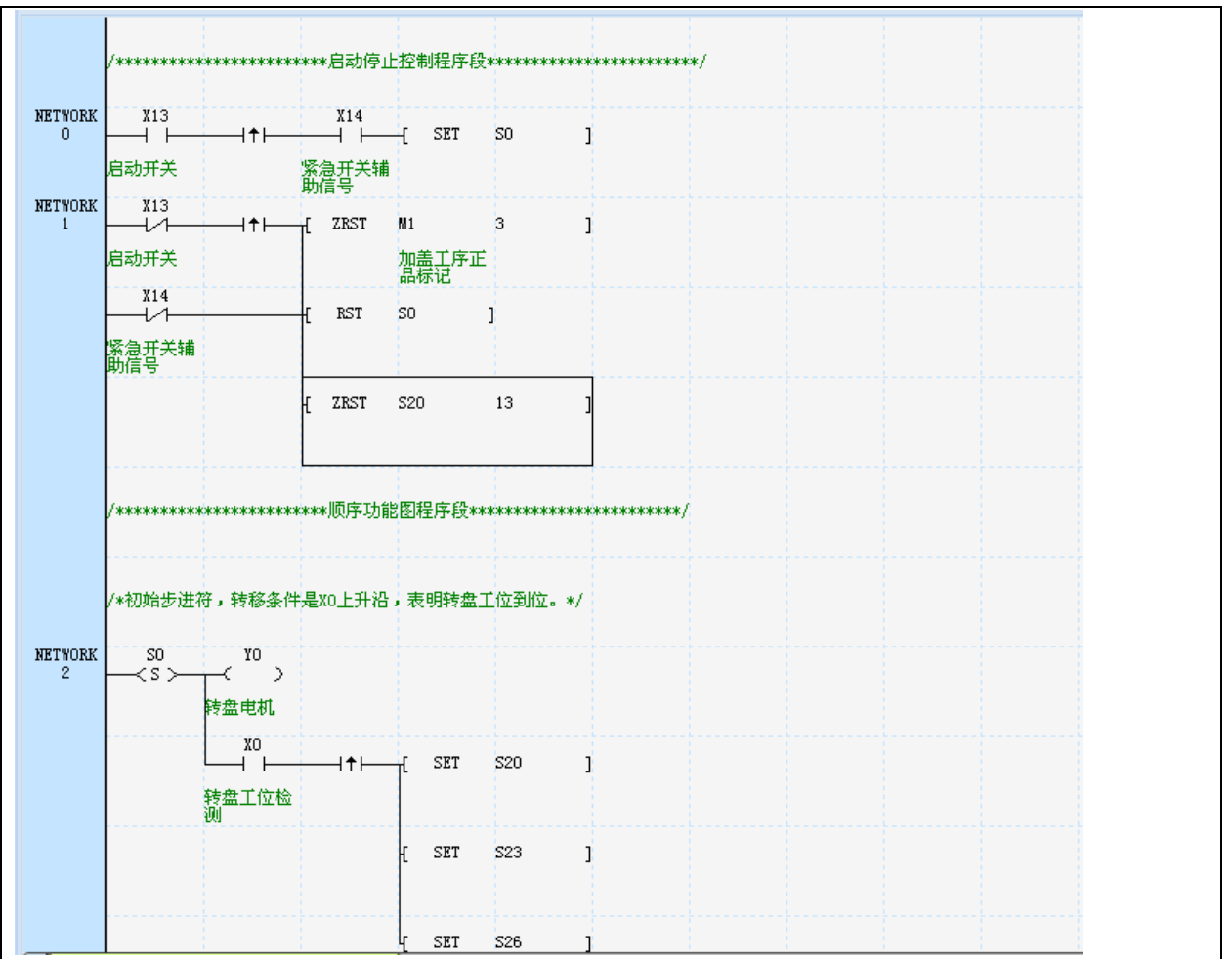
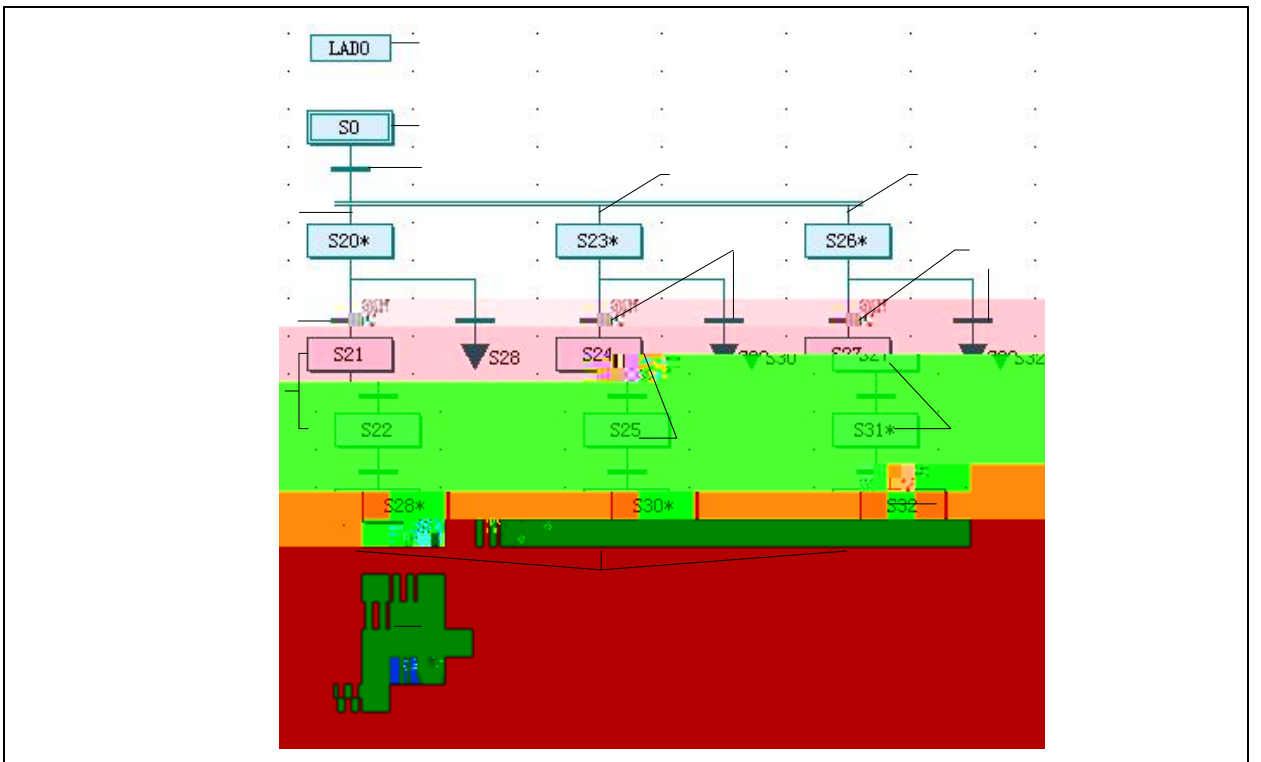
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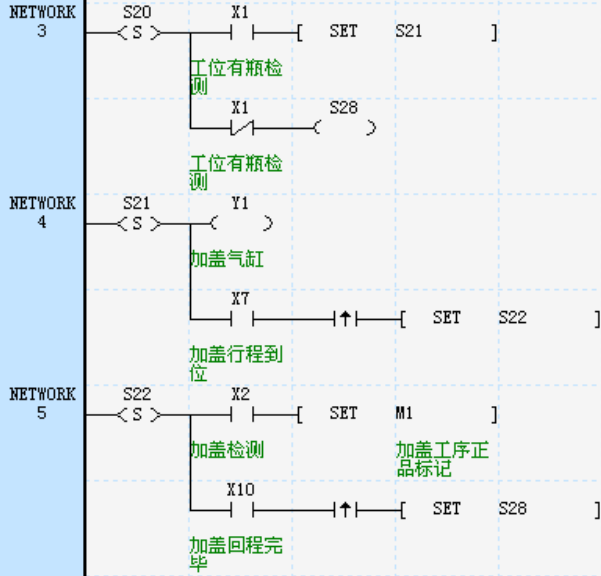




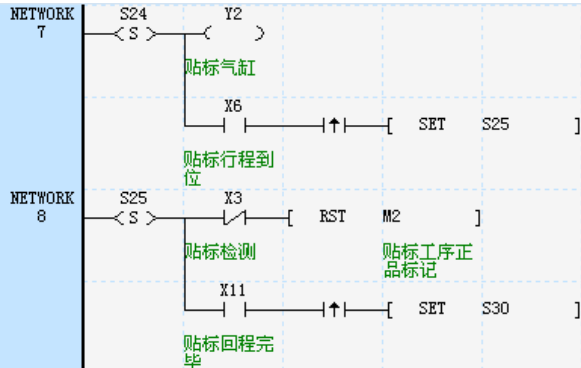
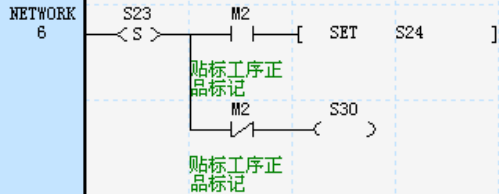




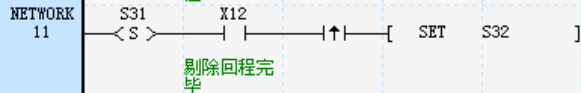
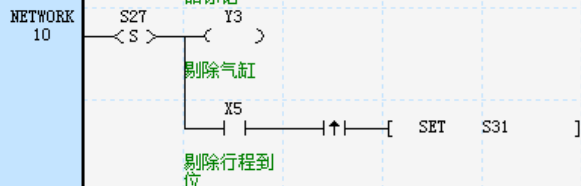
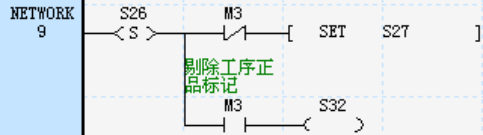
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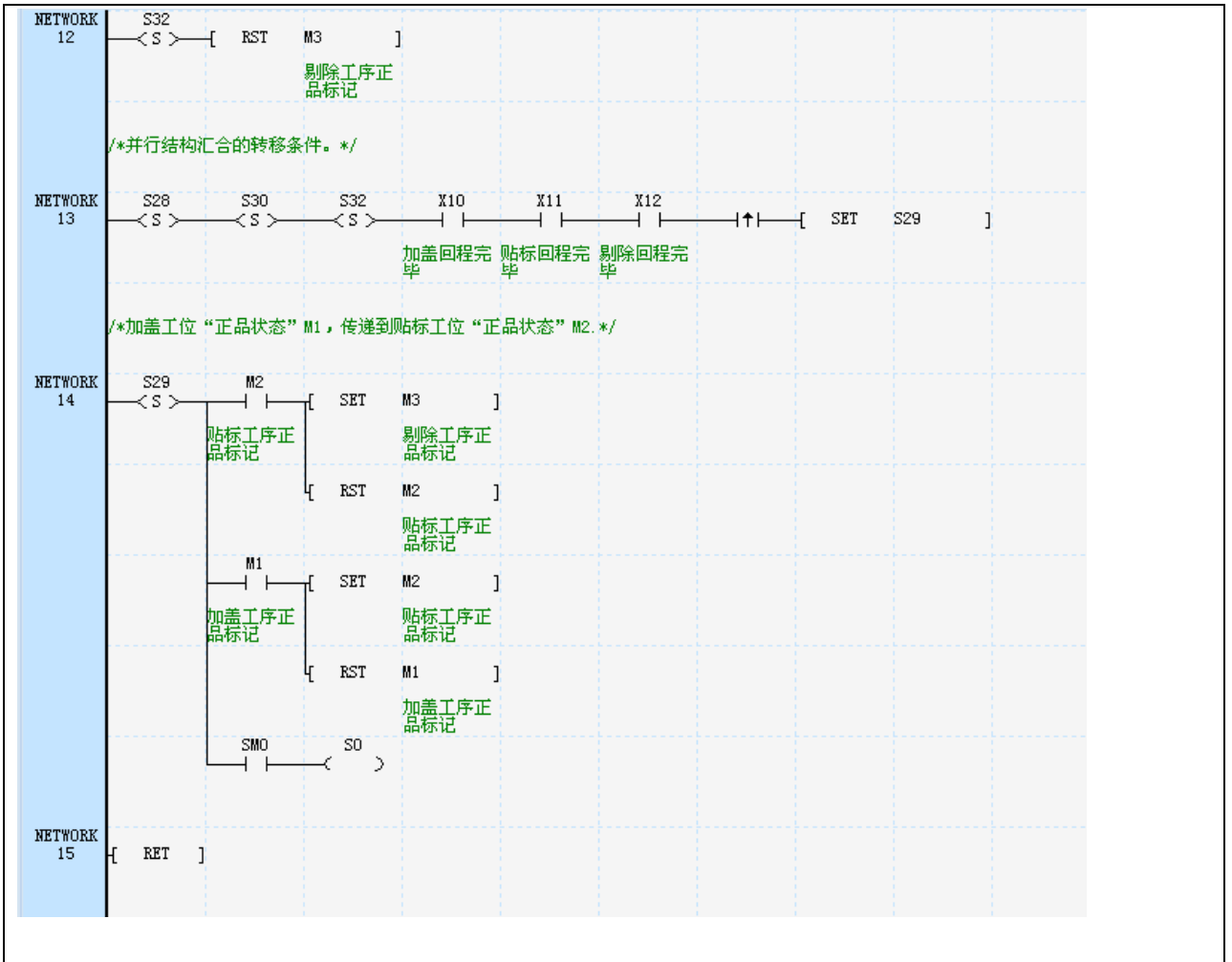


/\*贴标工序流程\*/



/\*剔除工序流程\*/





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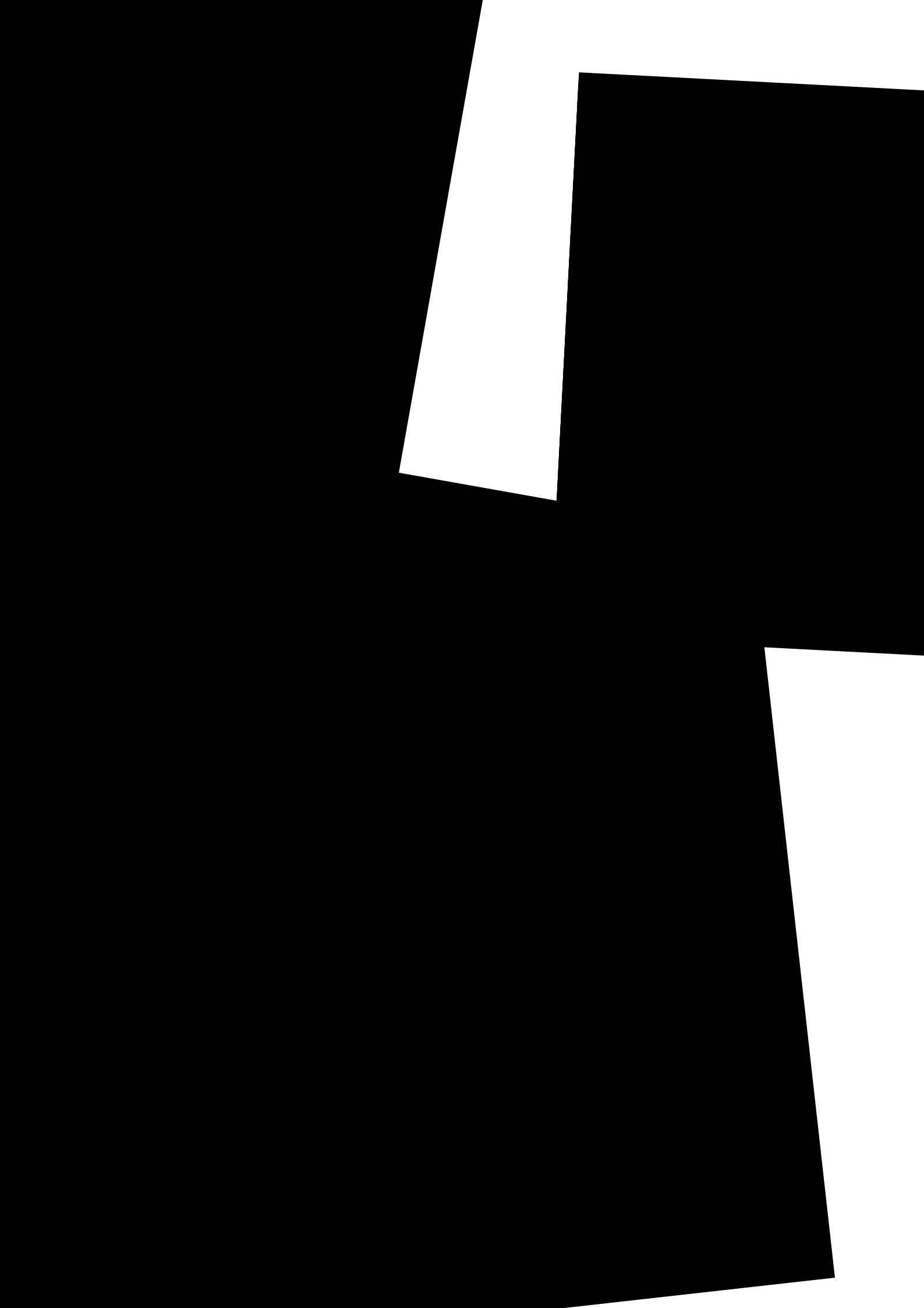
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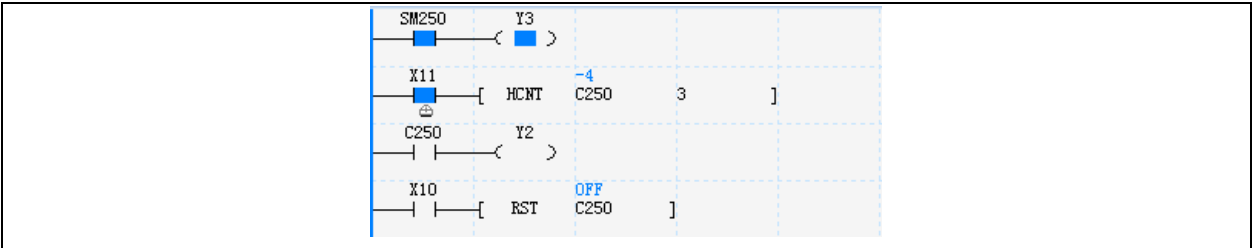
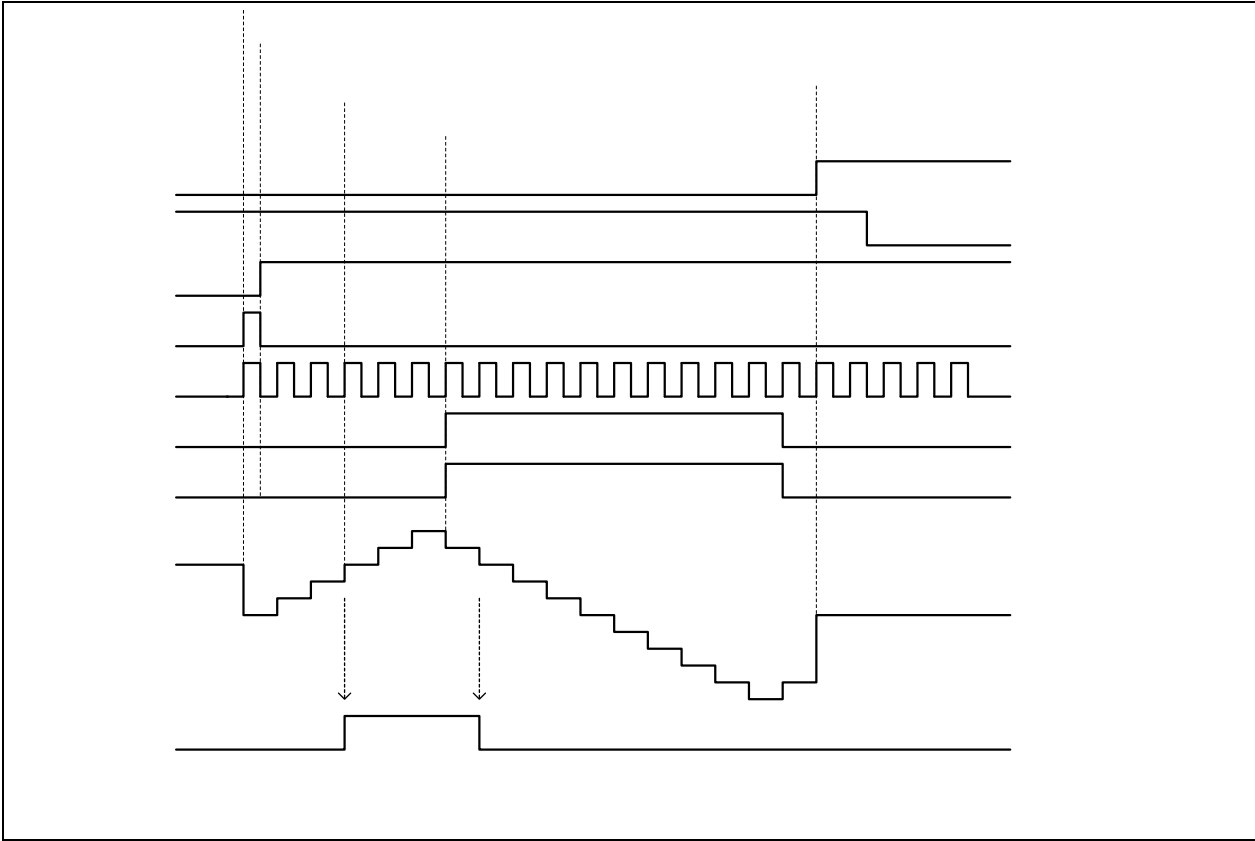
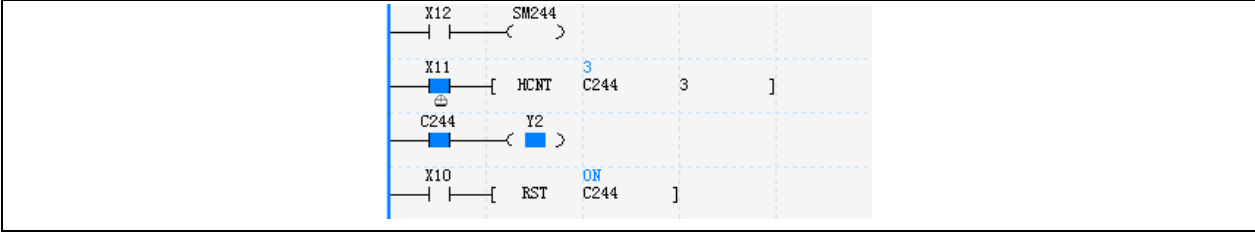


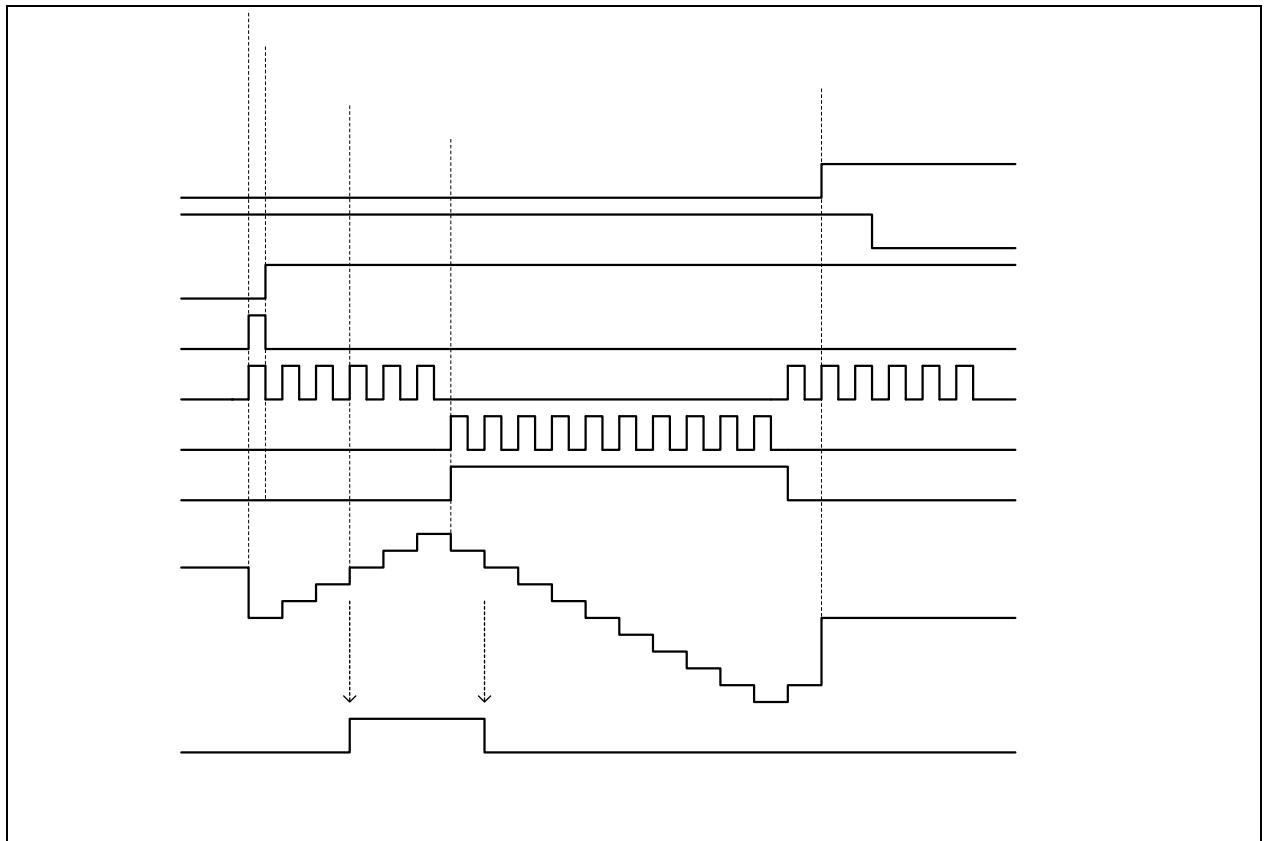




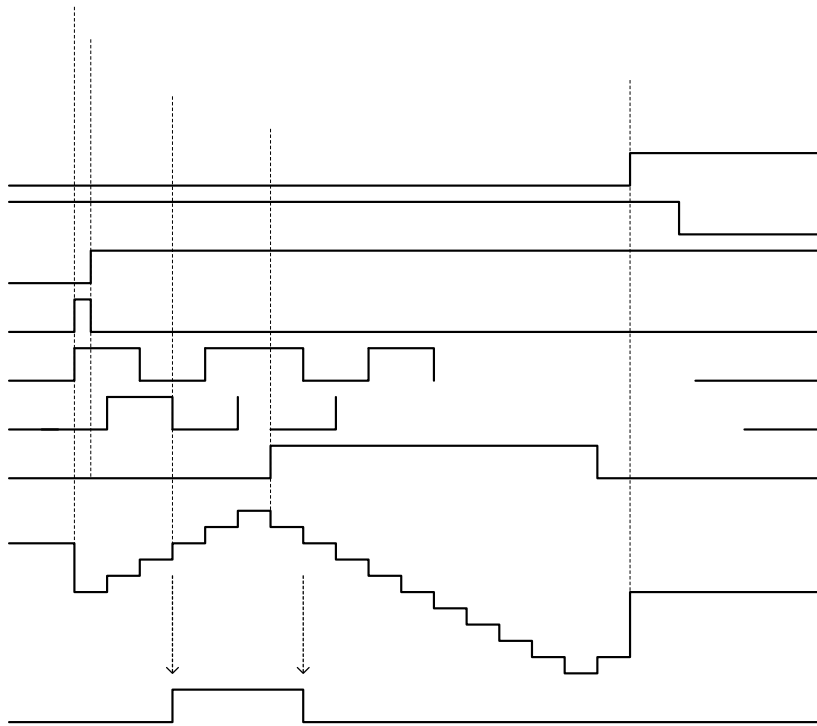
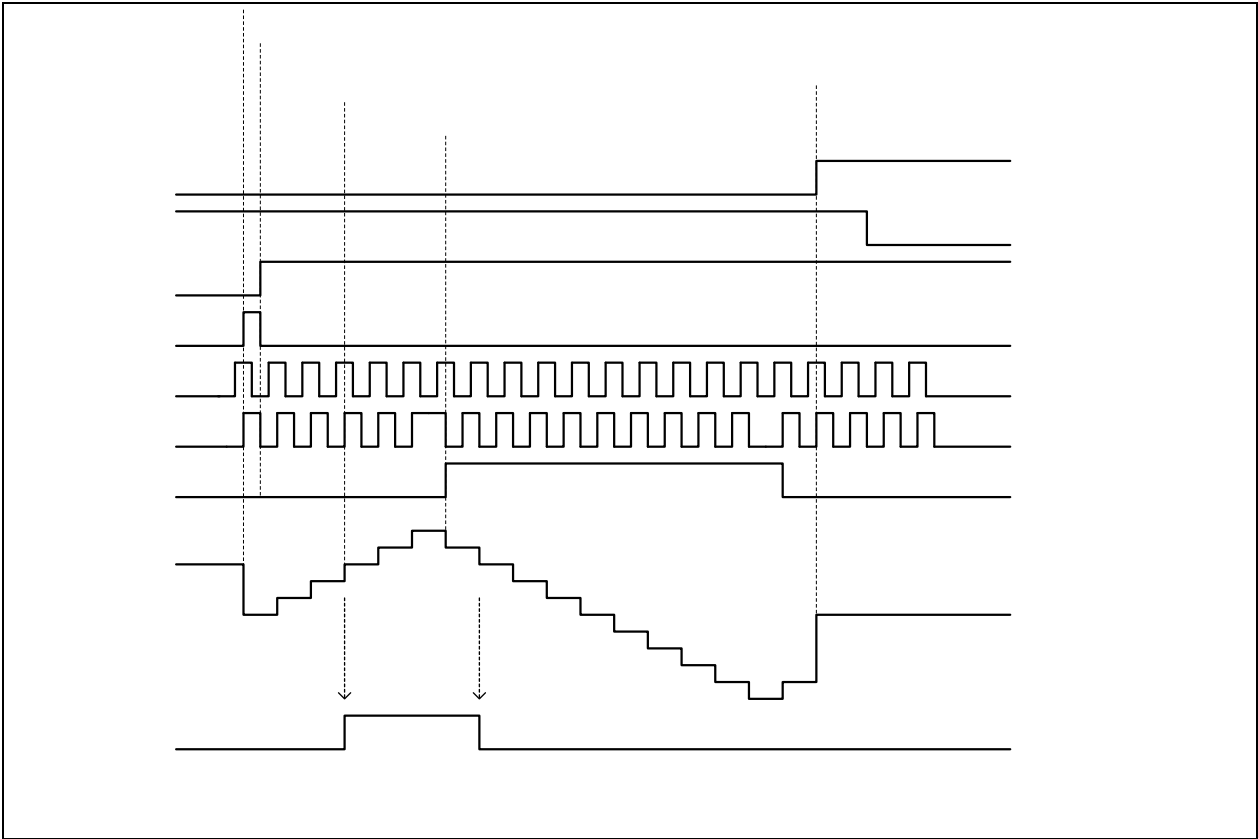


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SM250	Y3			
X11	HCNT	C250	4	3
C250	Y2			
X10	RST	C250	ON	



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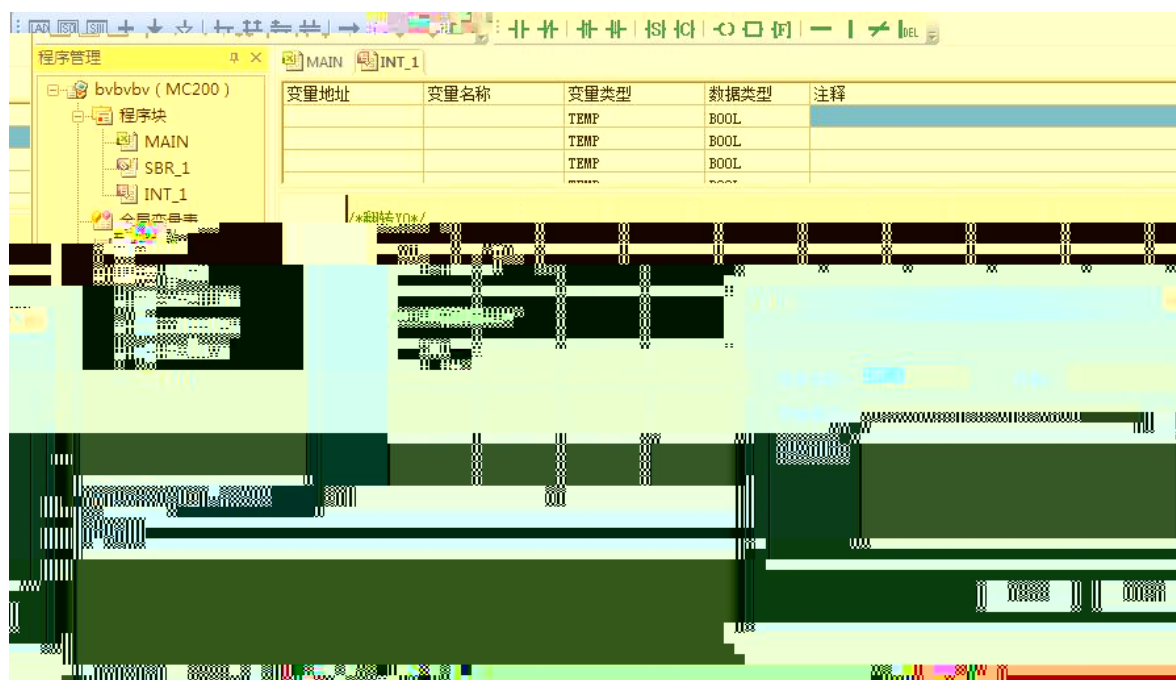
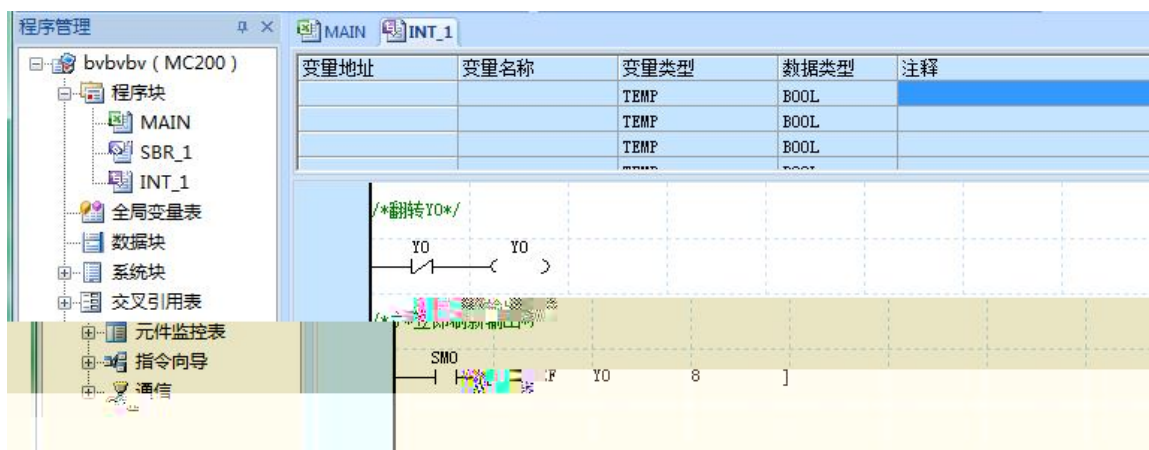
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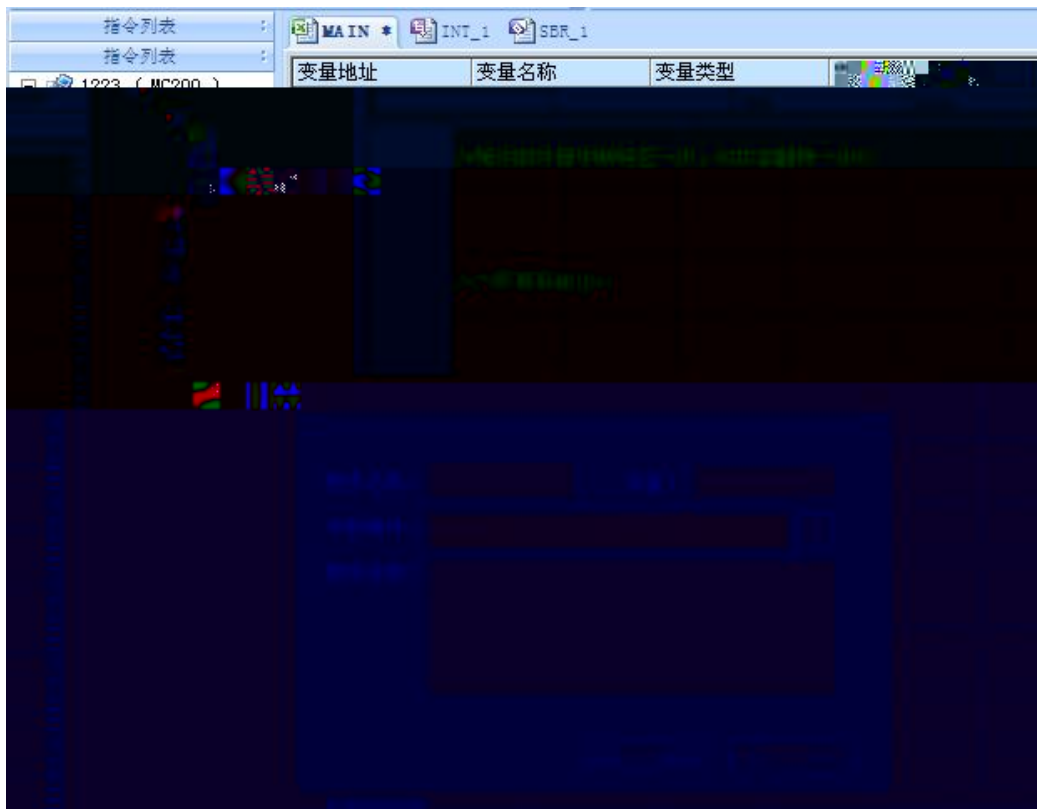


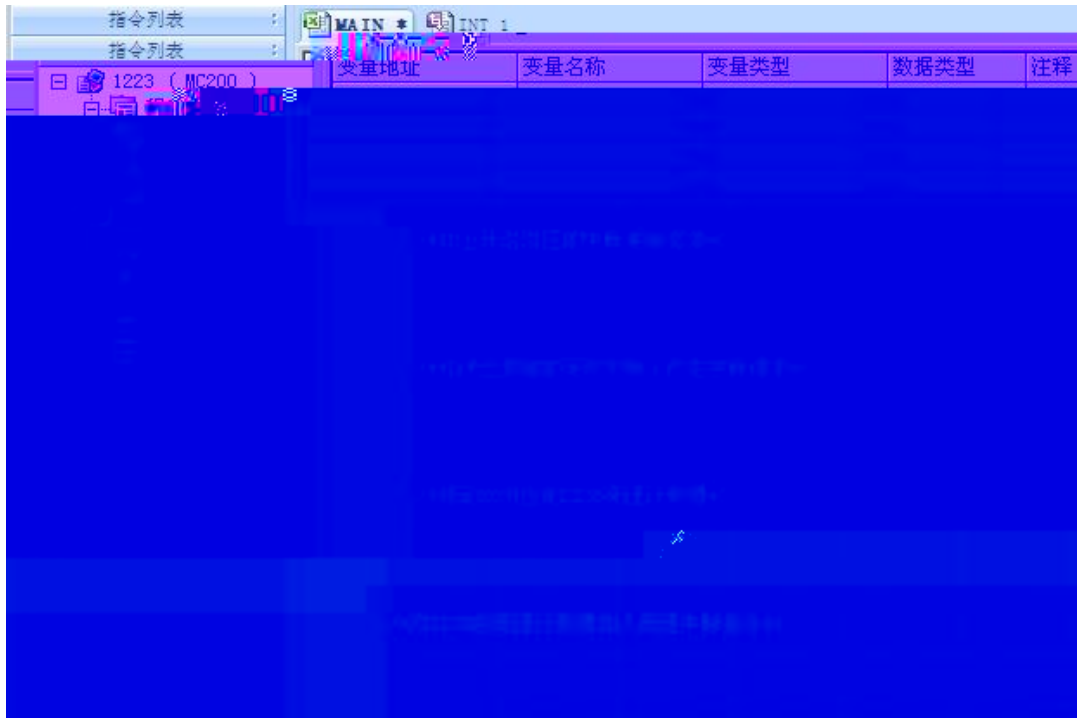
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指令列表 : MAIN \* INT\_1

1223 ( MC200 )

- 程序块
  - MAIN
  - SBR\_1
  - INT\_1
- 全局变量表
- 数据块
- 系统块
- 交叉引用表
- 元件监控表
- 指令向导
- 通信

变量地址	变量名称	变量类型	数据类型	注释
		TEMP	BOOL	
		TEMP	BOOL	
		TEMP	BOOL	
		TRMP	BOOL	

```

/*记录高速输出中断完成次数*/
SMO
| | | [ INC D17 ]
  
```

INT\_1

程序名称: INT\_1 作者: \_\_\_\_\_

中断事件: PTO (YO) 输出完成中断 (中断号=18) ...

程序说明: \_\_\_\_\_

确定 取消

指令列表 : MAIN \* INT\_1

1223 ( MC200 )

- 程序块
  - MAIN
  - INT\_1
- 全局变量表
- 数据块
- 系统块
- 交叉引用表
- 元件监控表
- 指令向导
- 通信

变量地址	变量名称	变量类型	数据类型	注释
		TEMP	BOOL	
		TEMP	BOOL	

```

SMO
| | | [ EI ]
  
```

```

/*使系统高速输出完成中断有效*/
SMO SM63
| | | [ ]
  
```

```

/*注意：调用高速输出PLS指令前请确认初始化参数是否被设置。*/
M1
| | | [ PLS 3000 3 YO ]
  
```

```

/*注意：在开机时执行一次，若设置包络线参数有所改变则需重新调用一遍。*/
SM1
| | | [ DMOV 5000 D3000 ]
| | | [ DMOV 1000 D3002 ]
| | | [ DMOV 6000 D3004 ]
  
```

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指令列表 : MAIN \* SMO1-SENOD \*

变量地址	变量名称	变量类型	数据类型	注释
		TEMP	BOOL	
		TEMP	BOOL	
		TEMP	BOOL	

```

/*翻转Y3*/
Y3 ———— / ———— ( Y3 )

/*立即刷新*/
SMO ———— [ REF Y0 8 ]

```

SMO1-SENOD

程序名称: SMO1-SENOD 作者:

中断事件: COM1的帧发送中断 (中断号=36) ...

程序说明:

确定 取消

指令列表 : MAIN \* SMO1-SENOD \*

变量地址	变量名称	变量类型	数据类型	注释
		TEMP	BOOL	
		TEMP	BOOL	
		TEMP	BOOL	

```

/*使系统中断使能有效*/
SM0 ———— [ EI ]

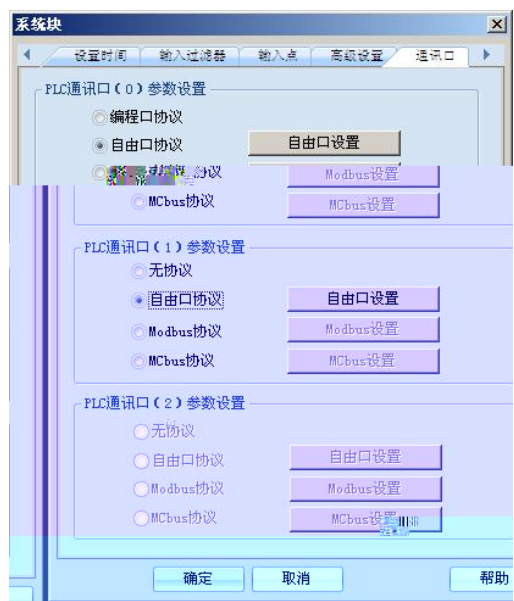
/*使XOM1发送帧中断有效*/
SM1 ———— [ SET SM54 ]

```

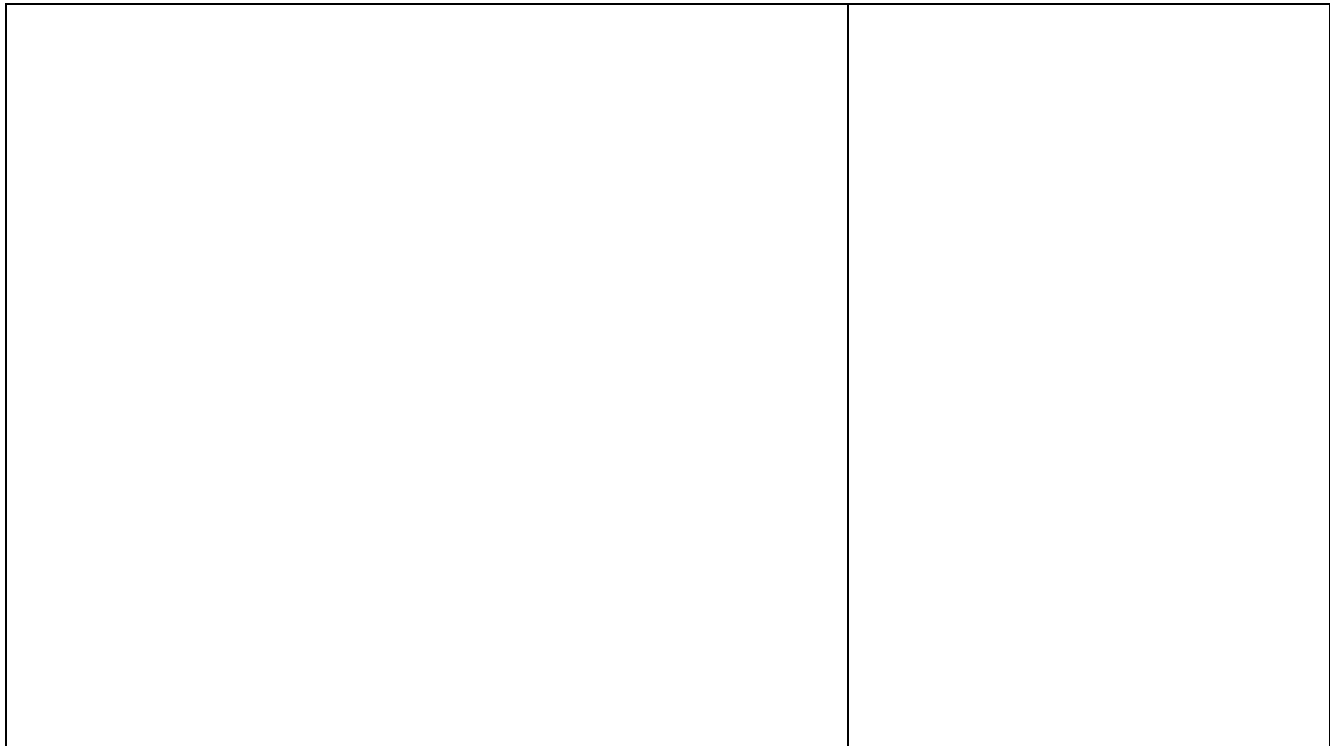
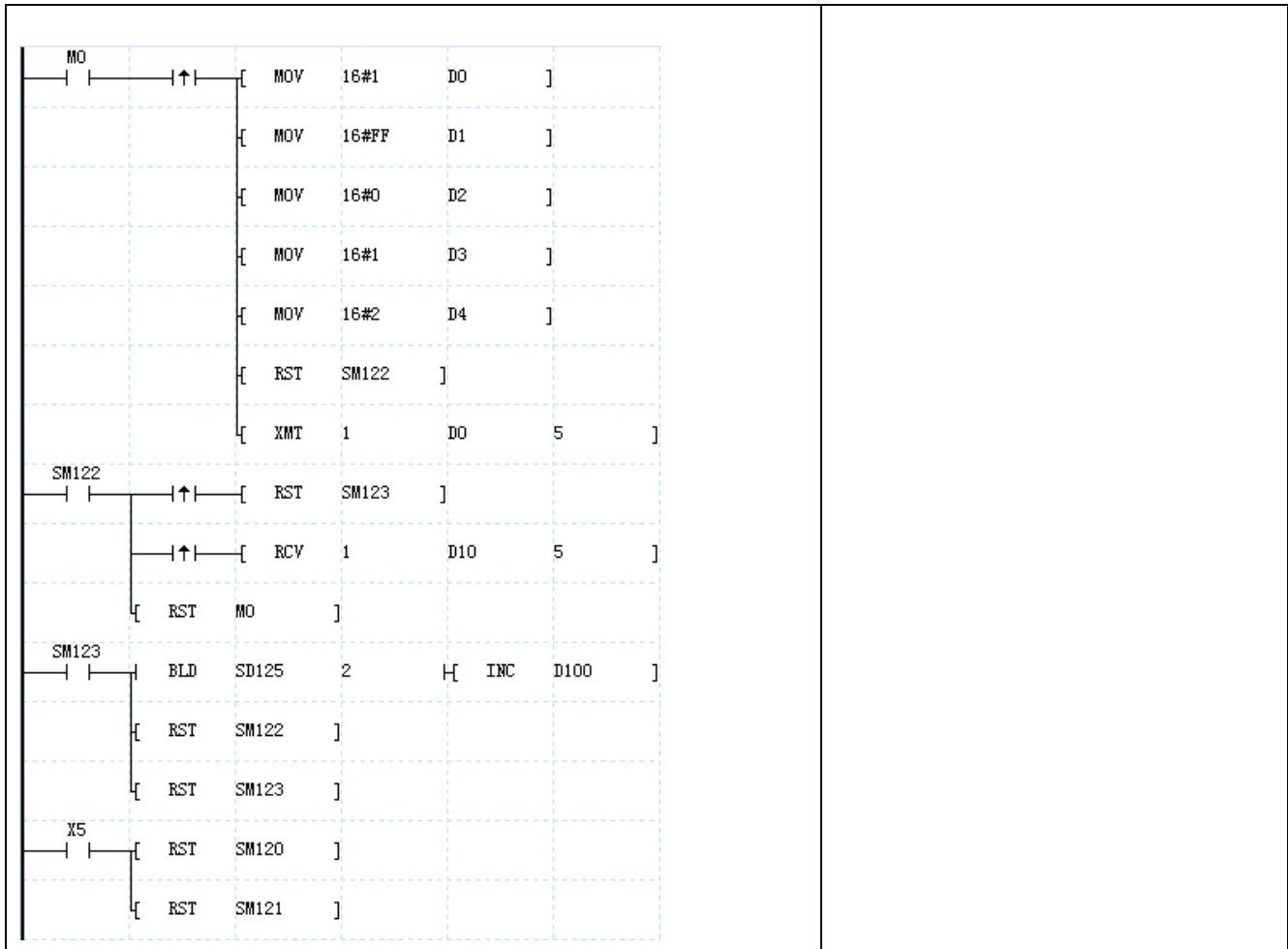
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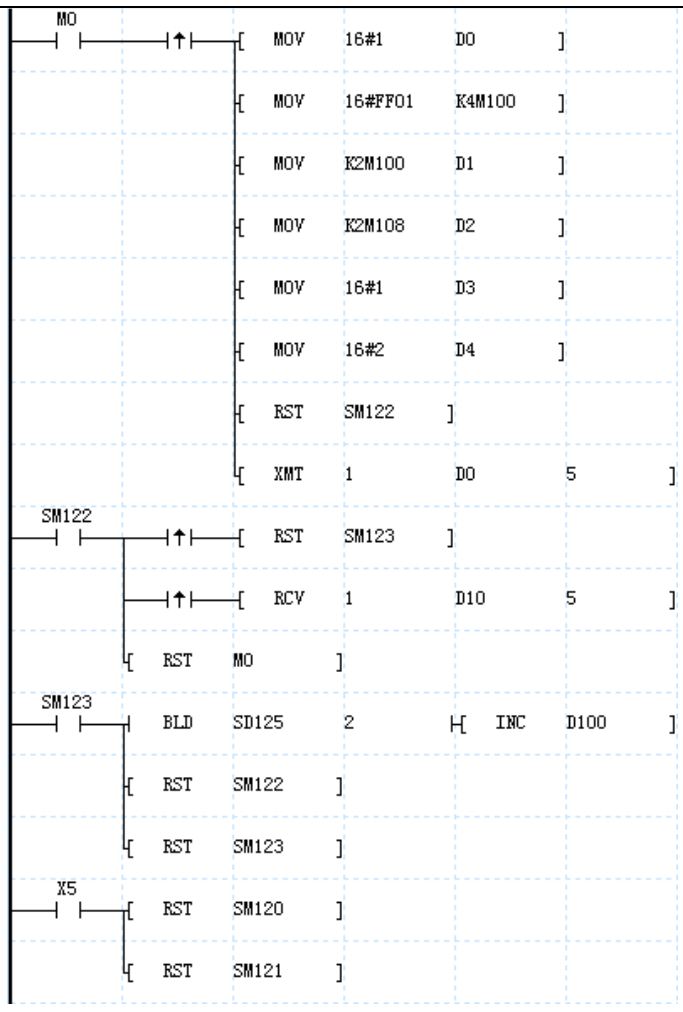
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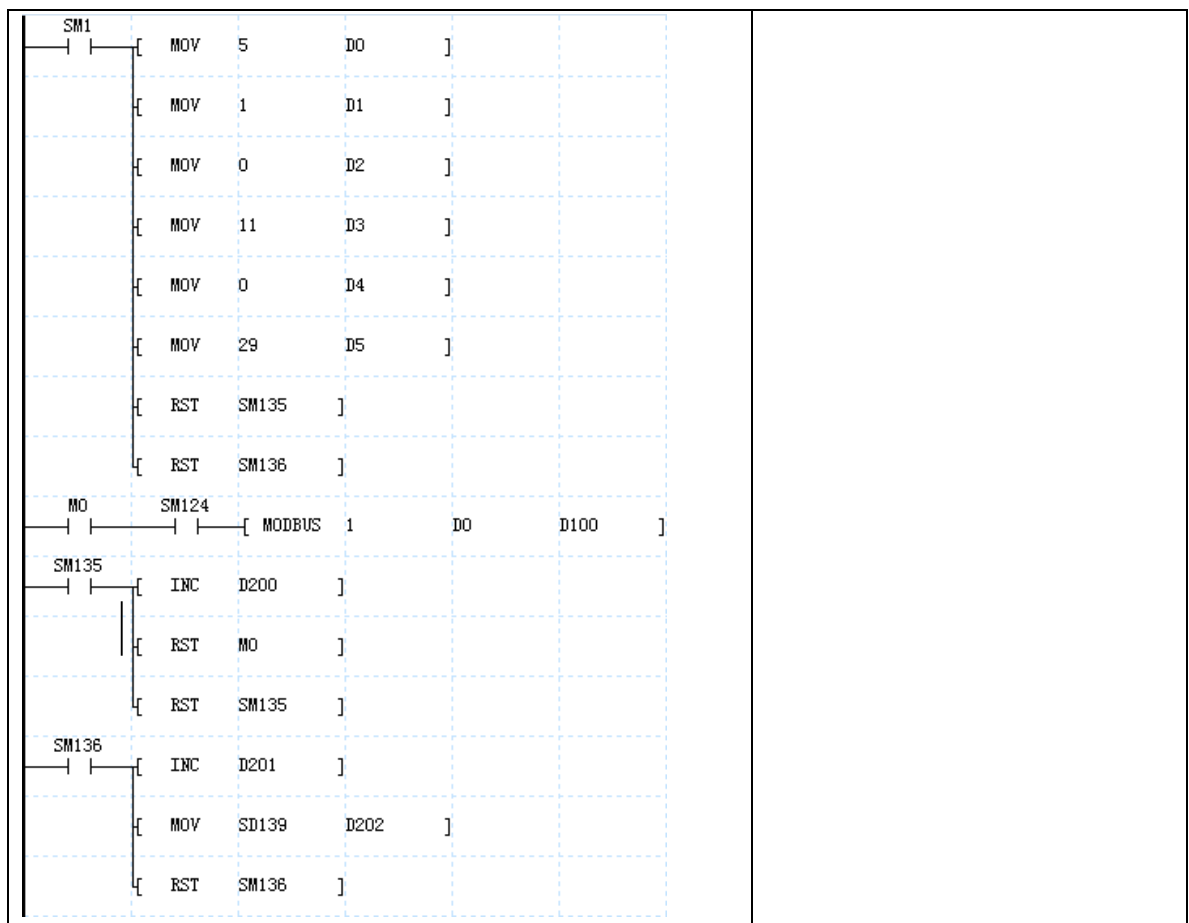
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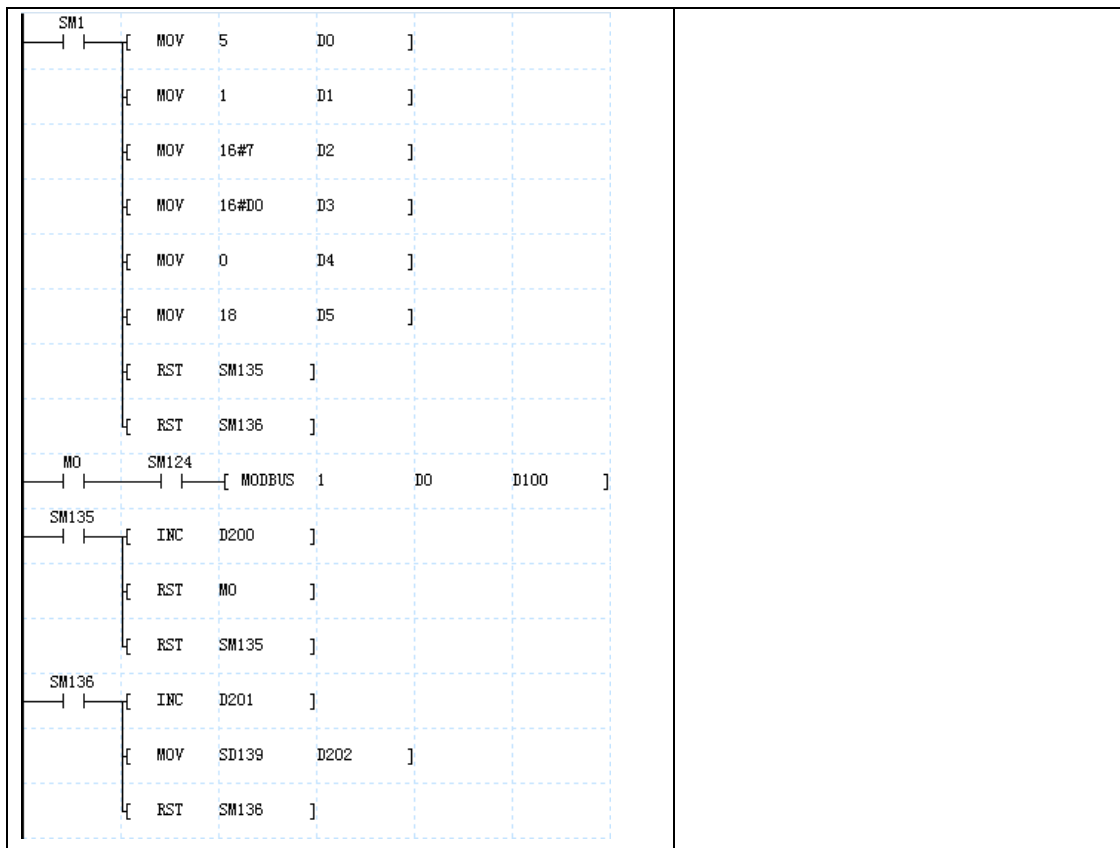
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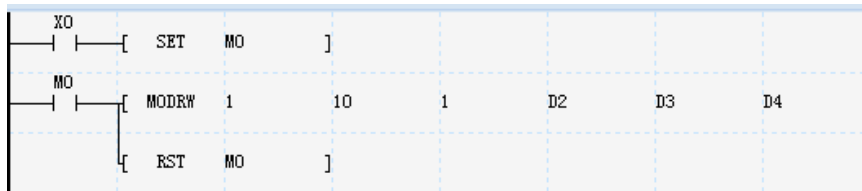
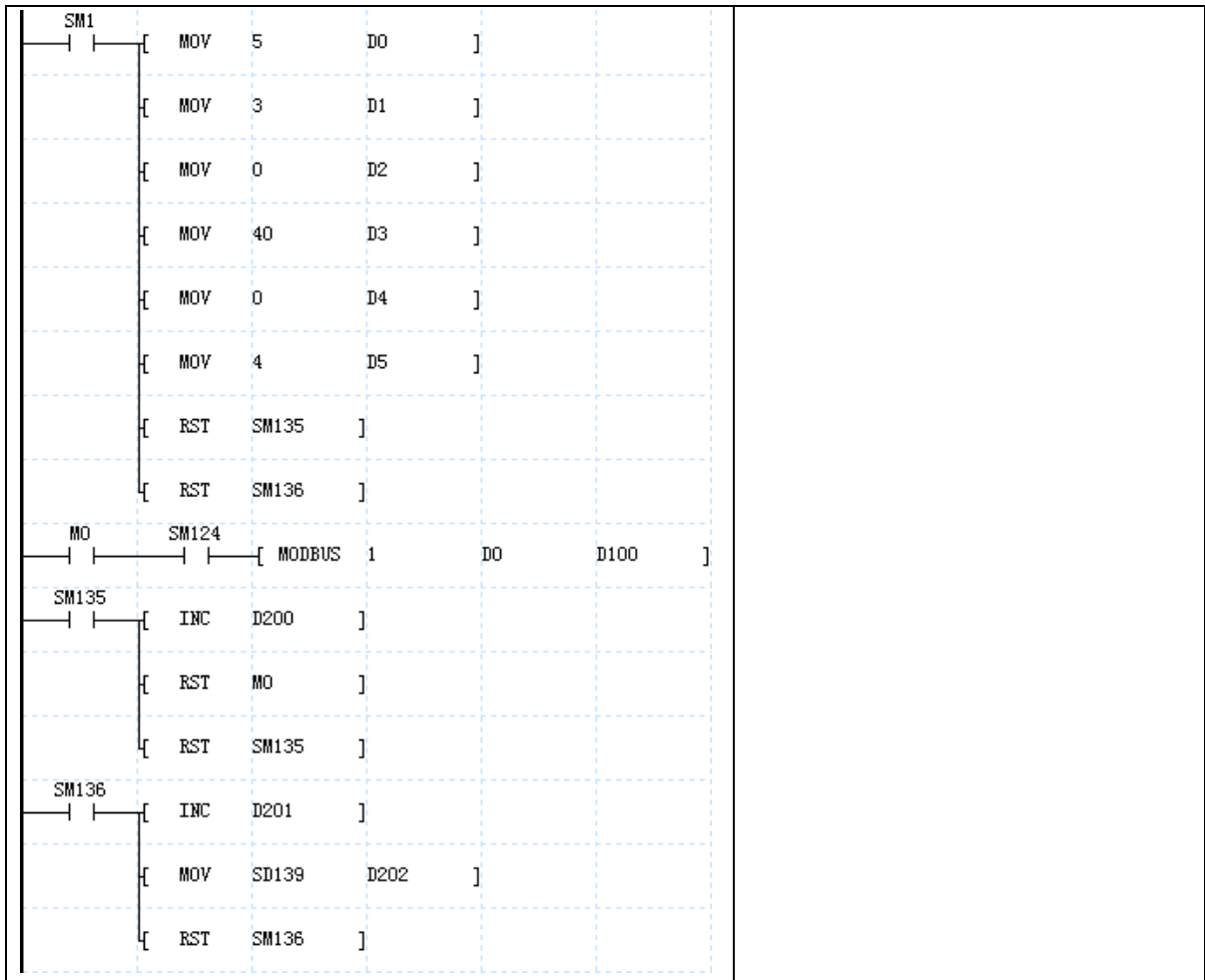


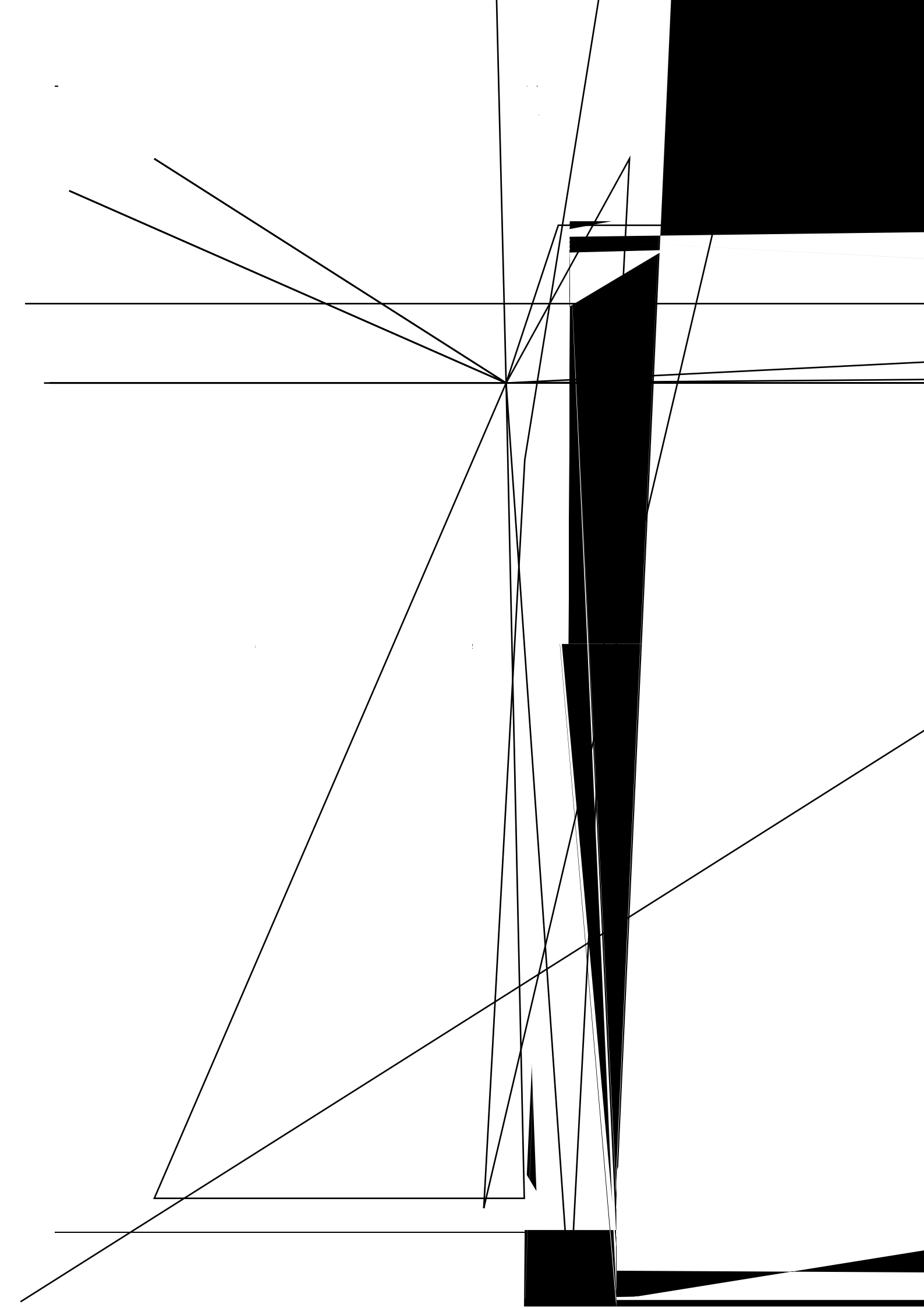


6121 Modbus





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*T*

*T* — *ms*

*T* — *ms*

*T T T ms*

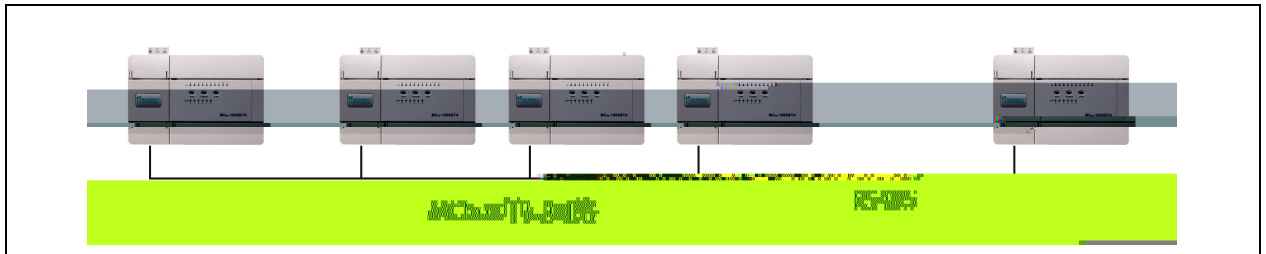
*T ms*

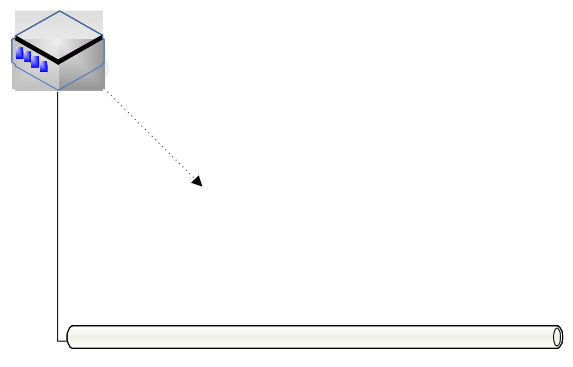
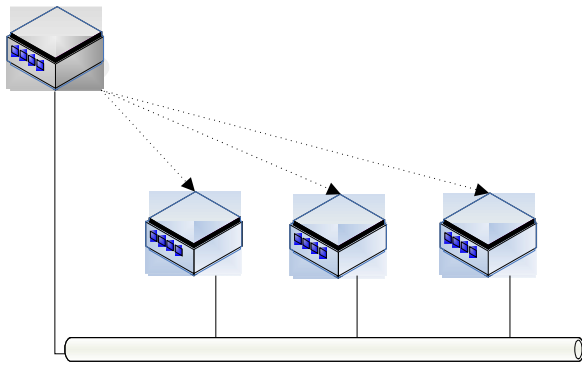
*T ms*

*T INT — ms*

*T ms*

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| | | \_\_\_\_\_

|

|



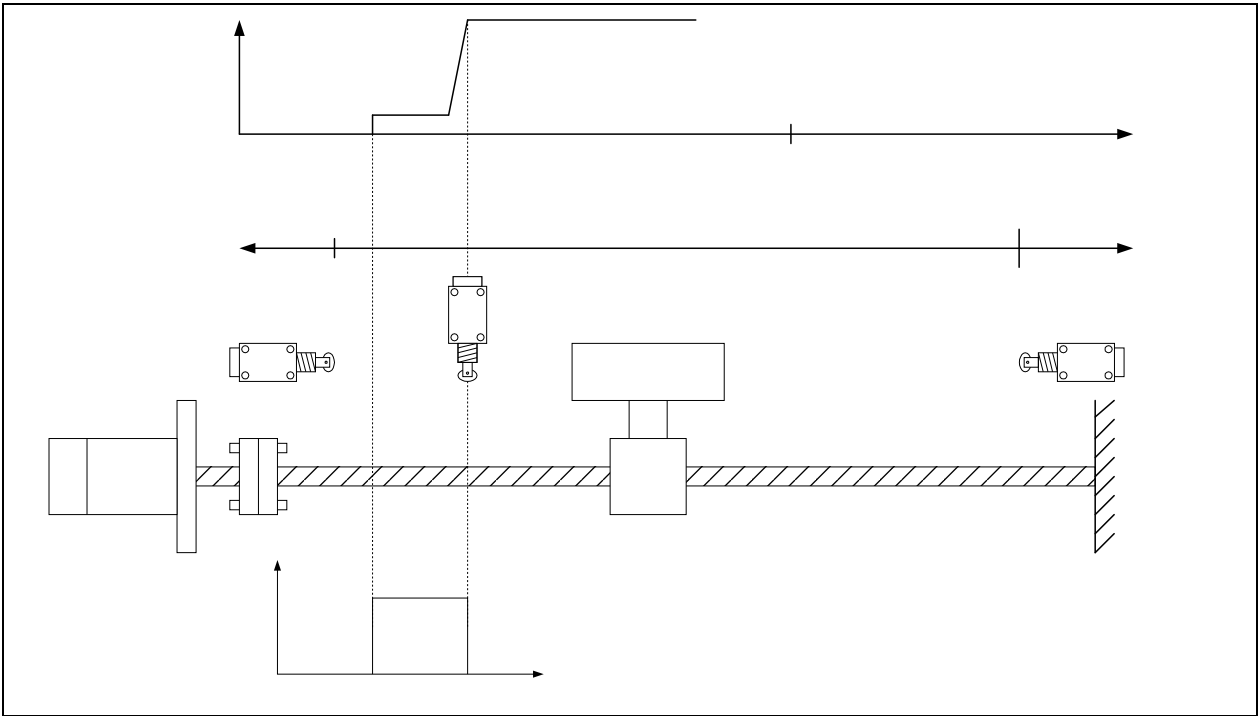
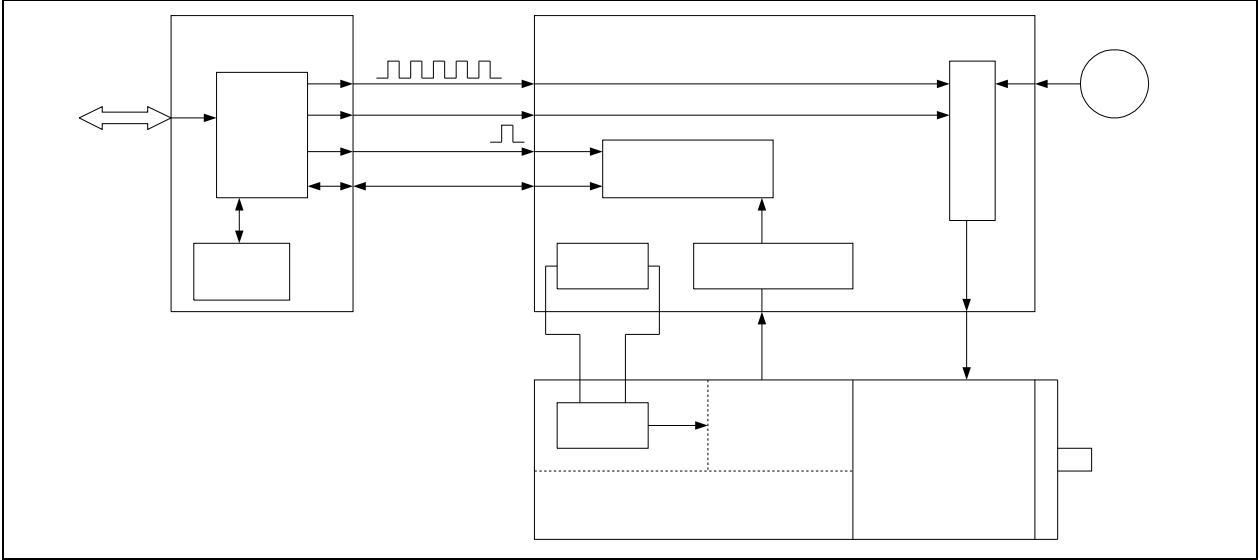


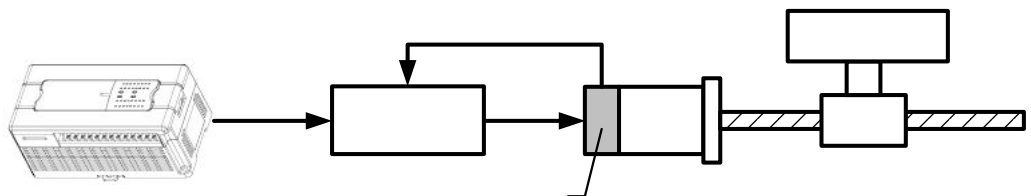
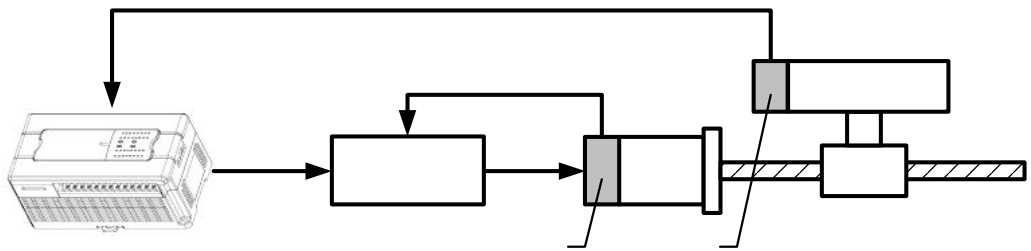
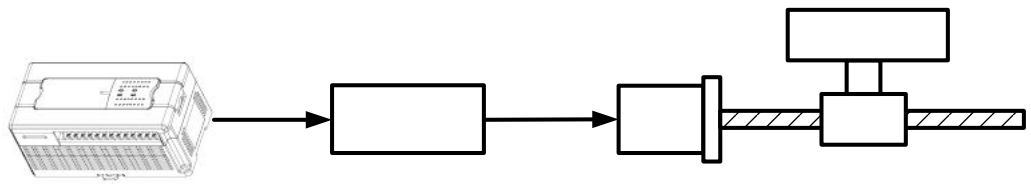
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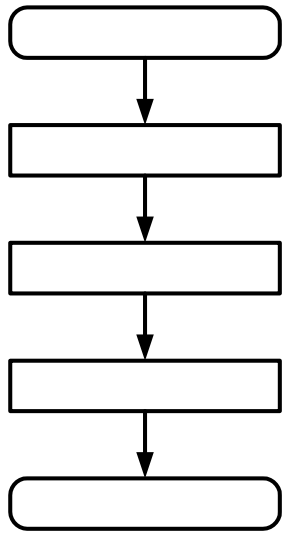
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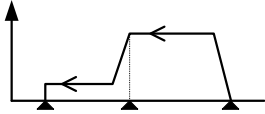
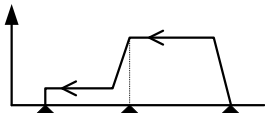
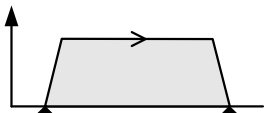
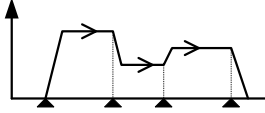
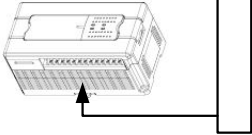
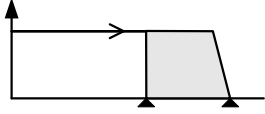
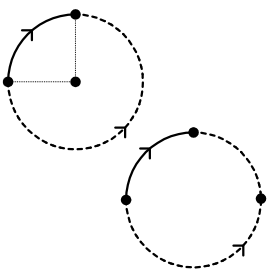
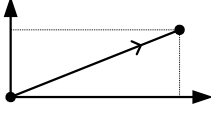
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**11. 2 PLC**

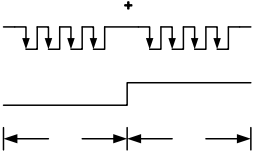
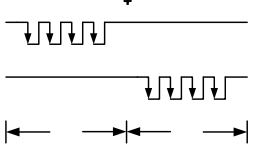
						
						
						
						
						
						
						
						

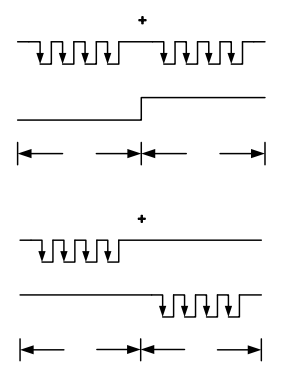

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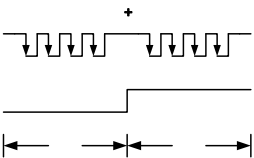
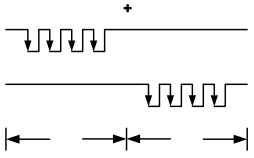
$$F_{acc} = \sqrt{\frac{F}{T}}$$

$T$

- $F$
- $F_{acc}$   $F_{acc}$
- $F_{acc}$   $F_{acc}$



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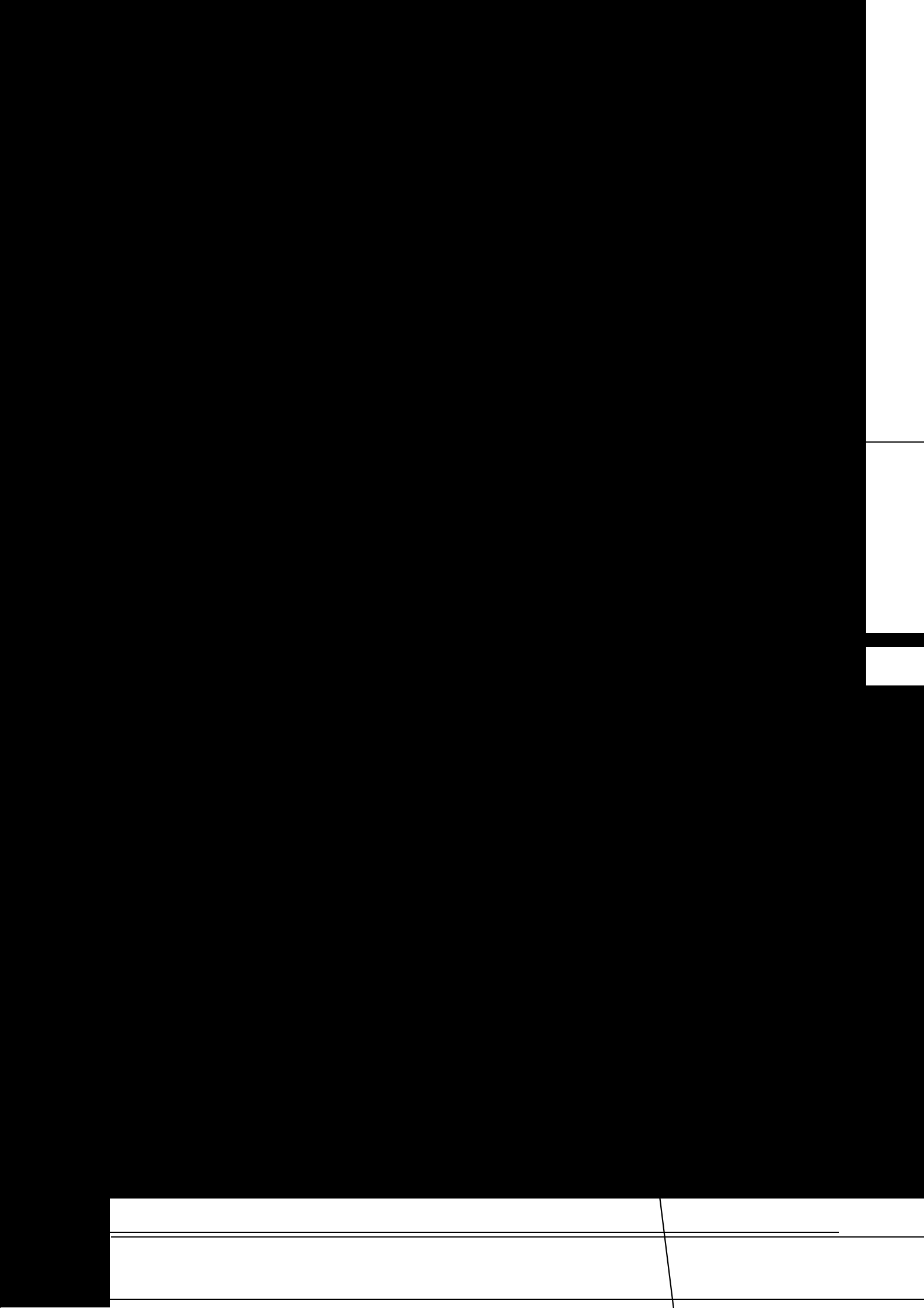
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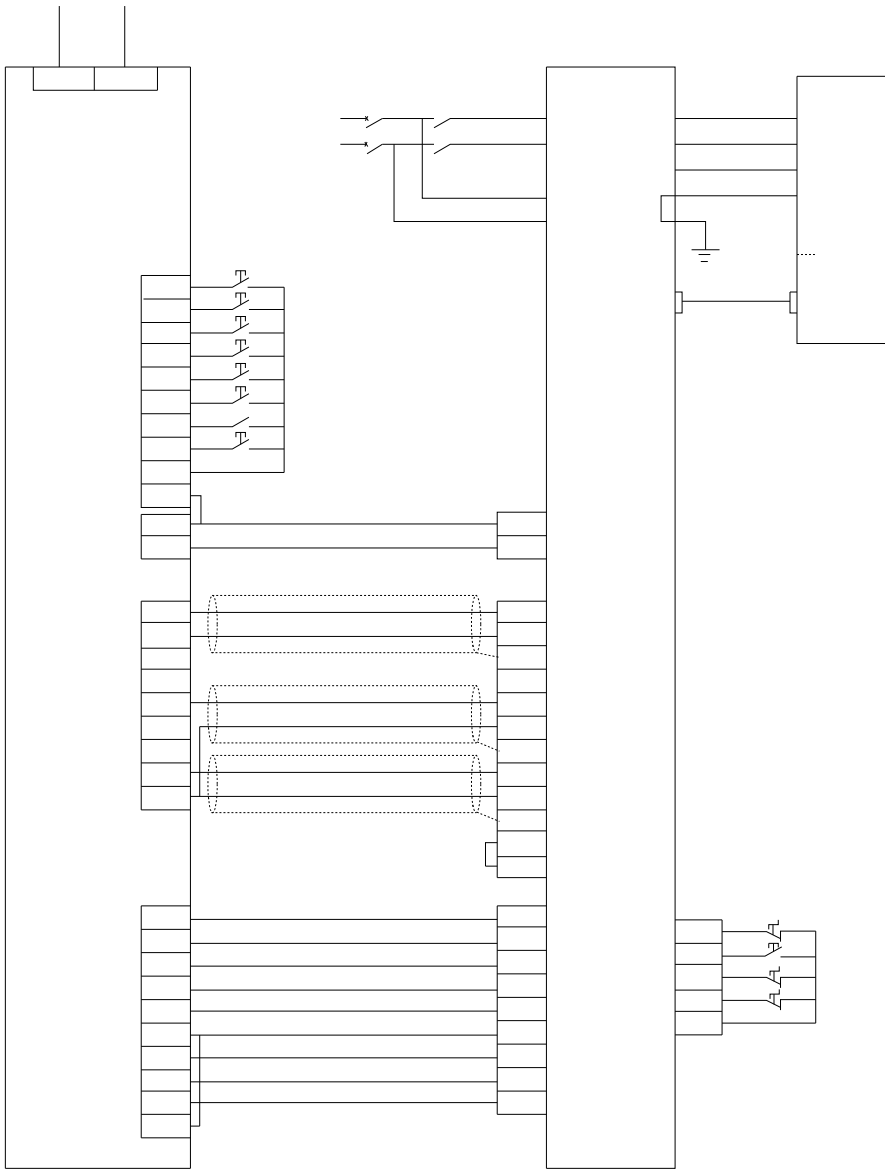
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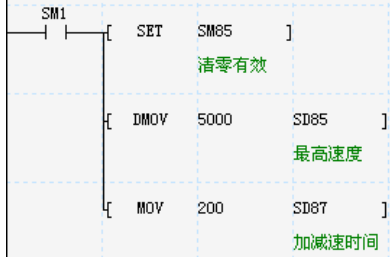
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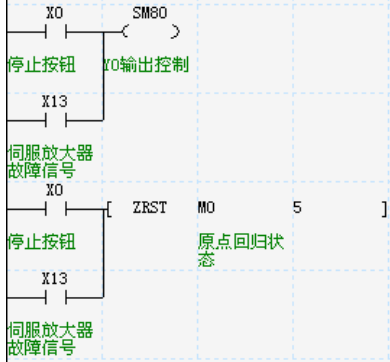
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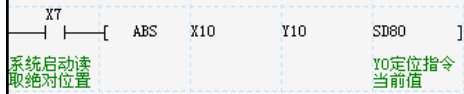
/\*上电初始化\*/



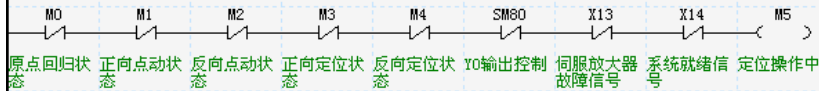
/\*故障和停止时停止输出脉冲，并停止所有的定位操作\*/



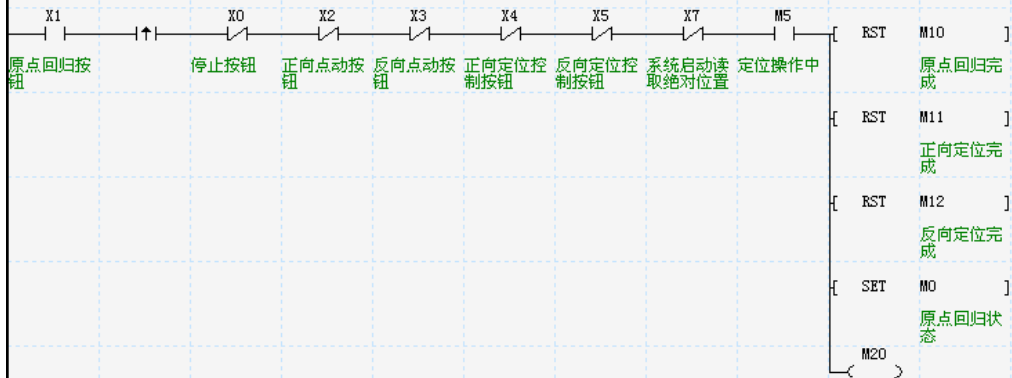
/\*绝对位置值读取\*/

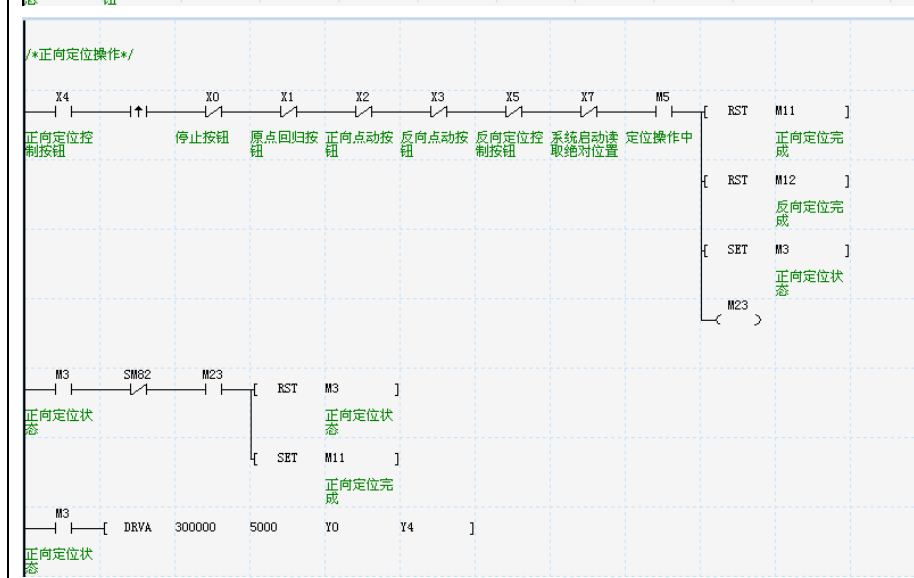
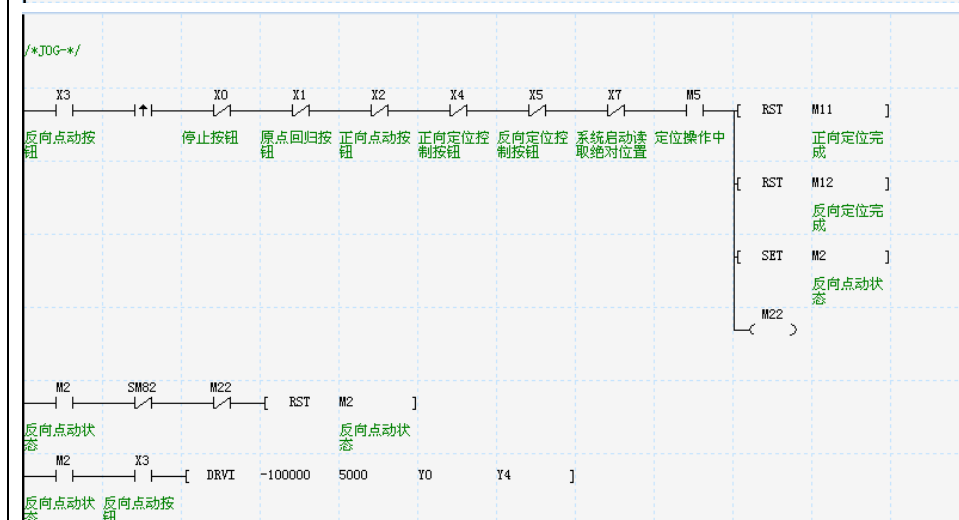
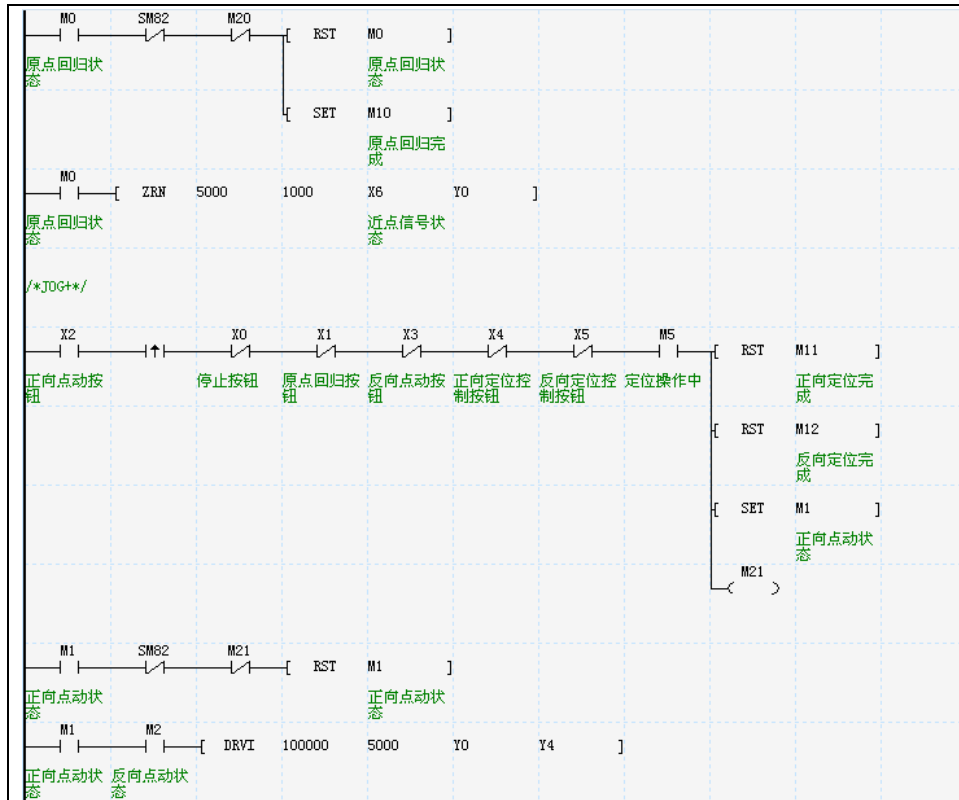


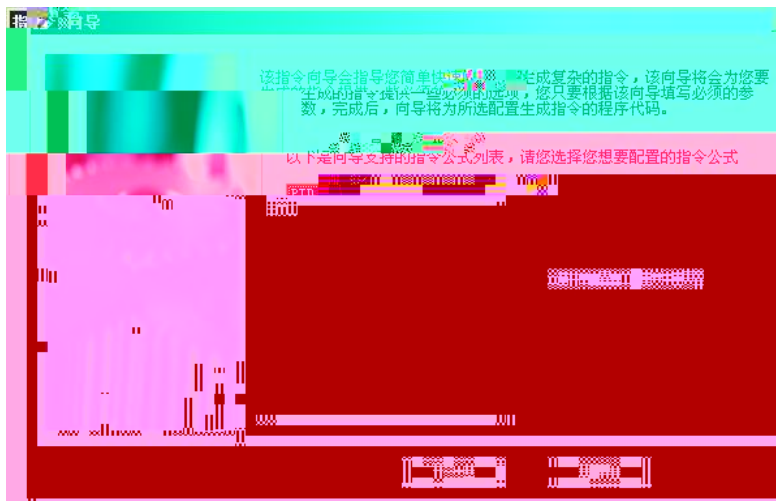
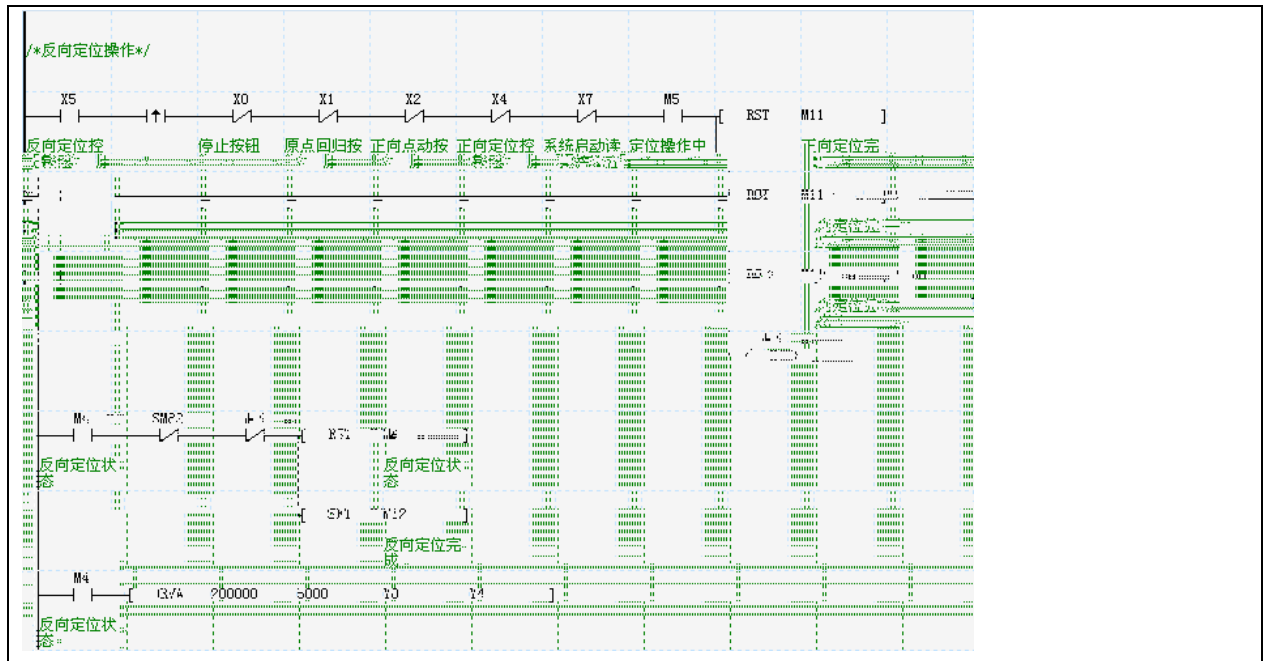
/\*检测是否正在进行定位操作。M5为0X表示当前没有进行操作。\*/

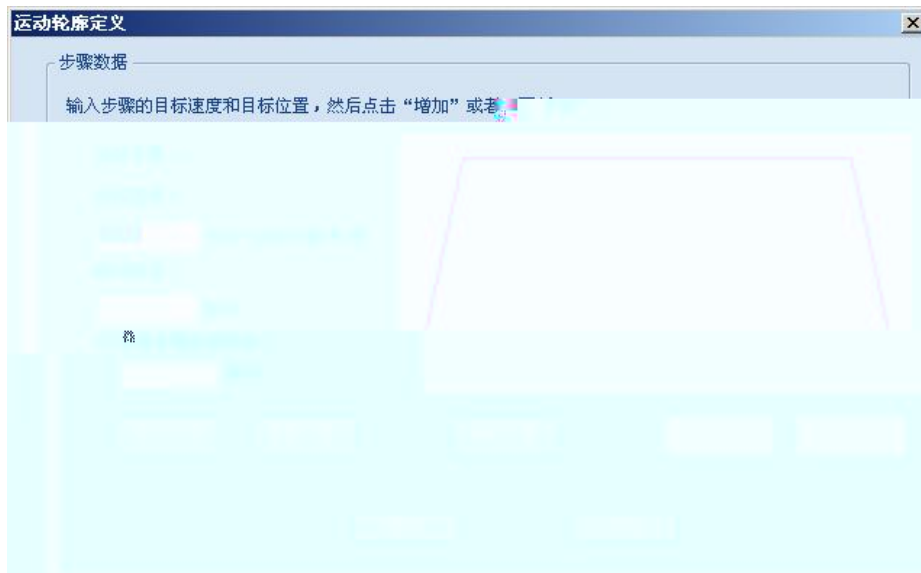
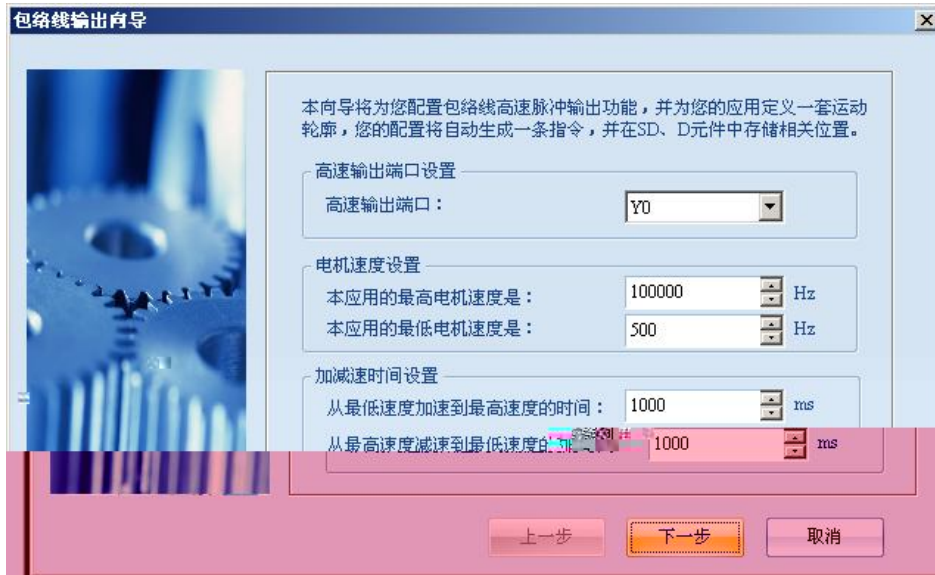


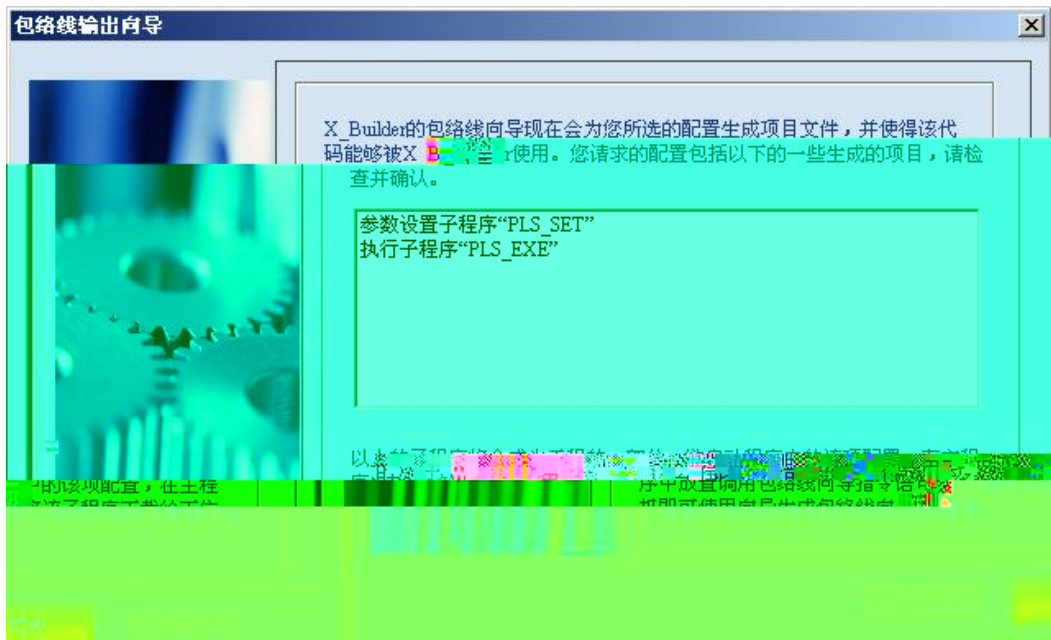
/\*原点回归\*/

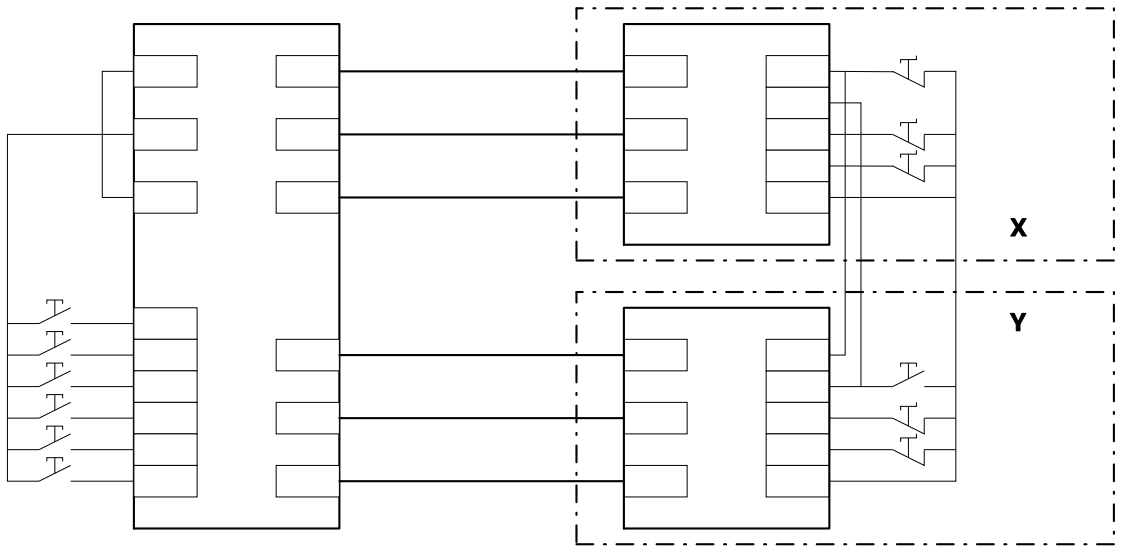
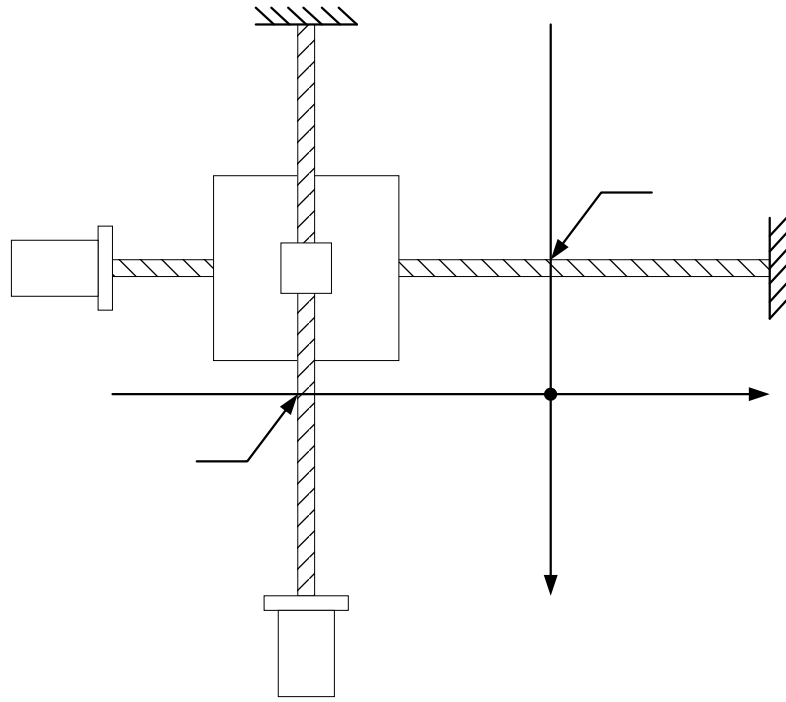






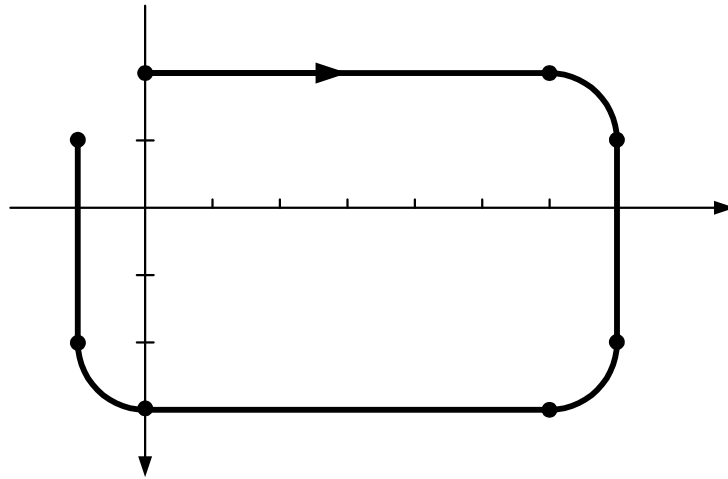






**X**

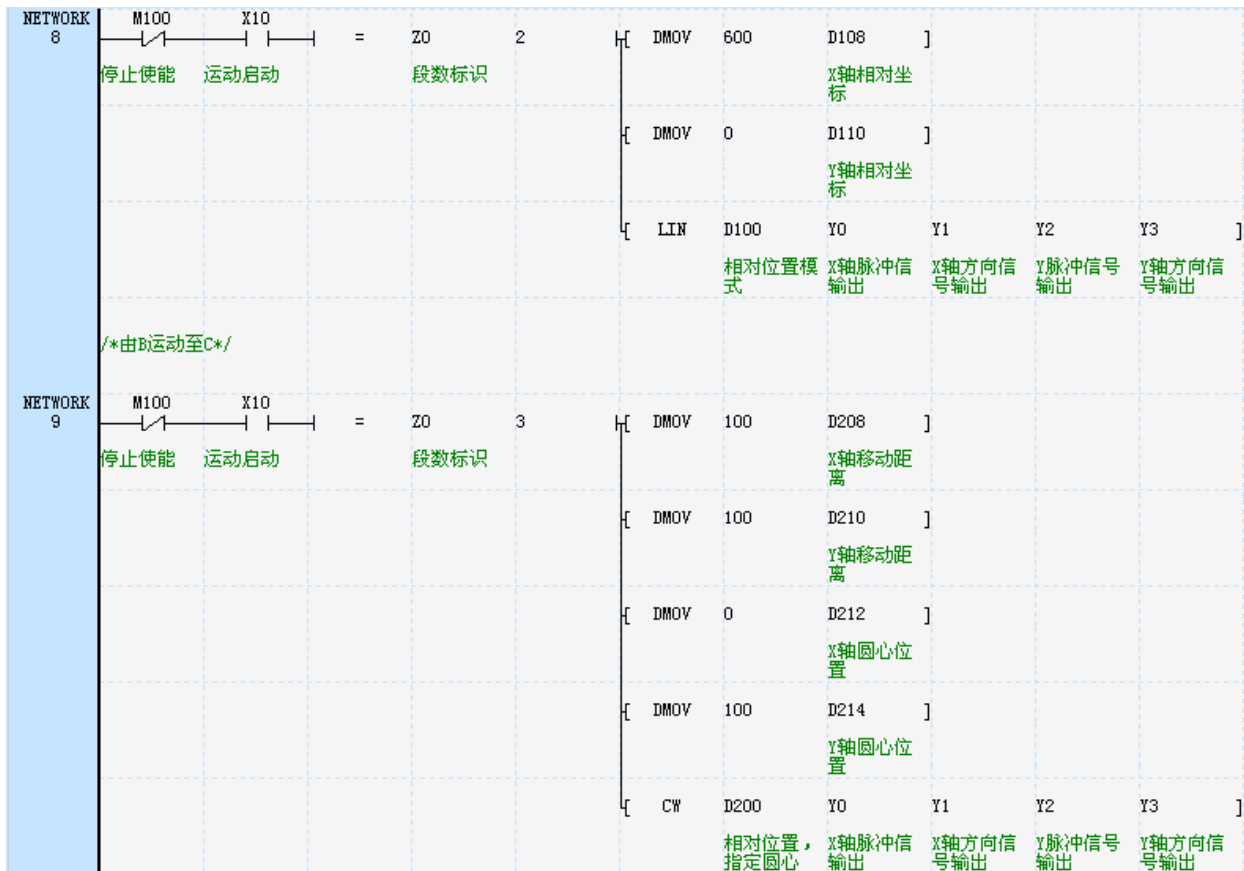
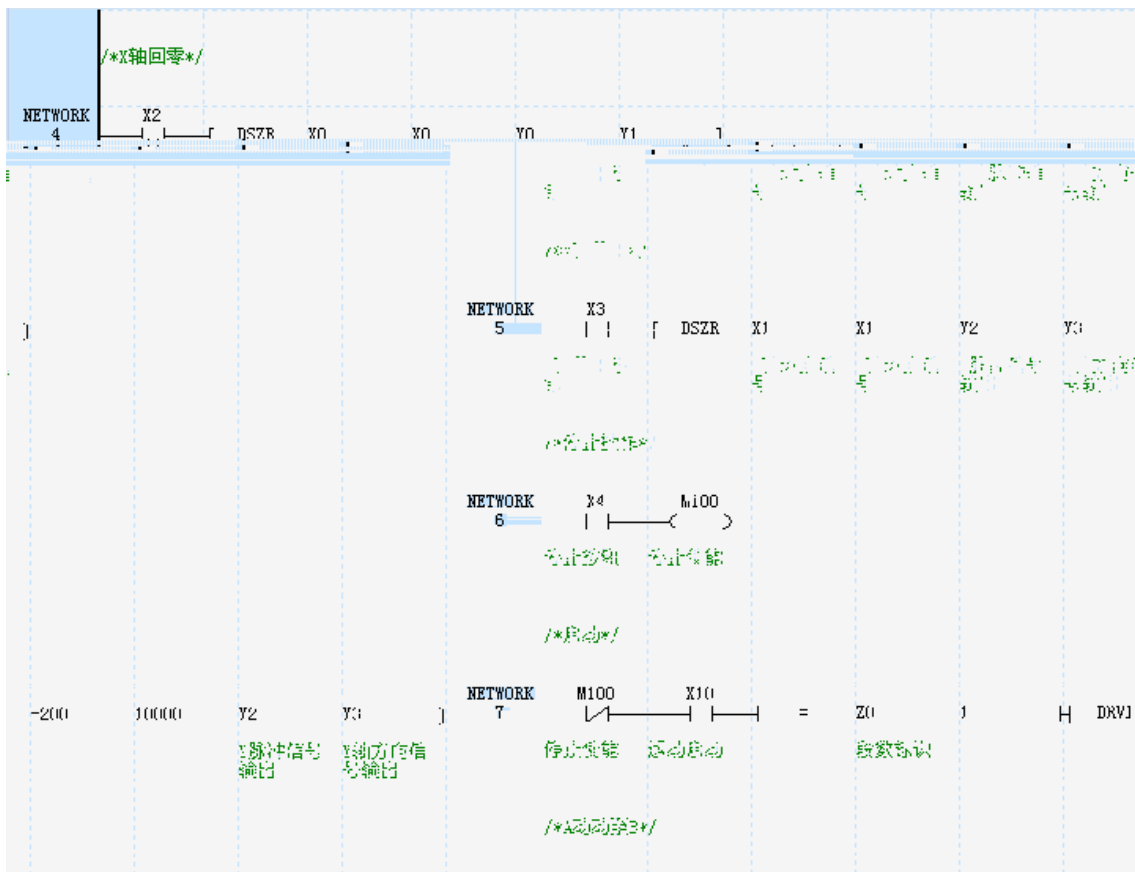
**Y**

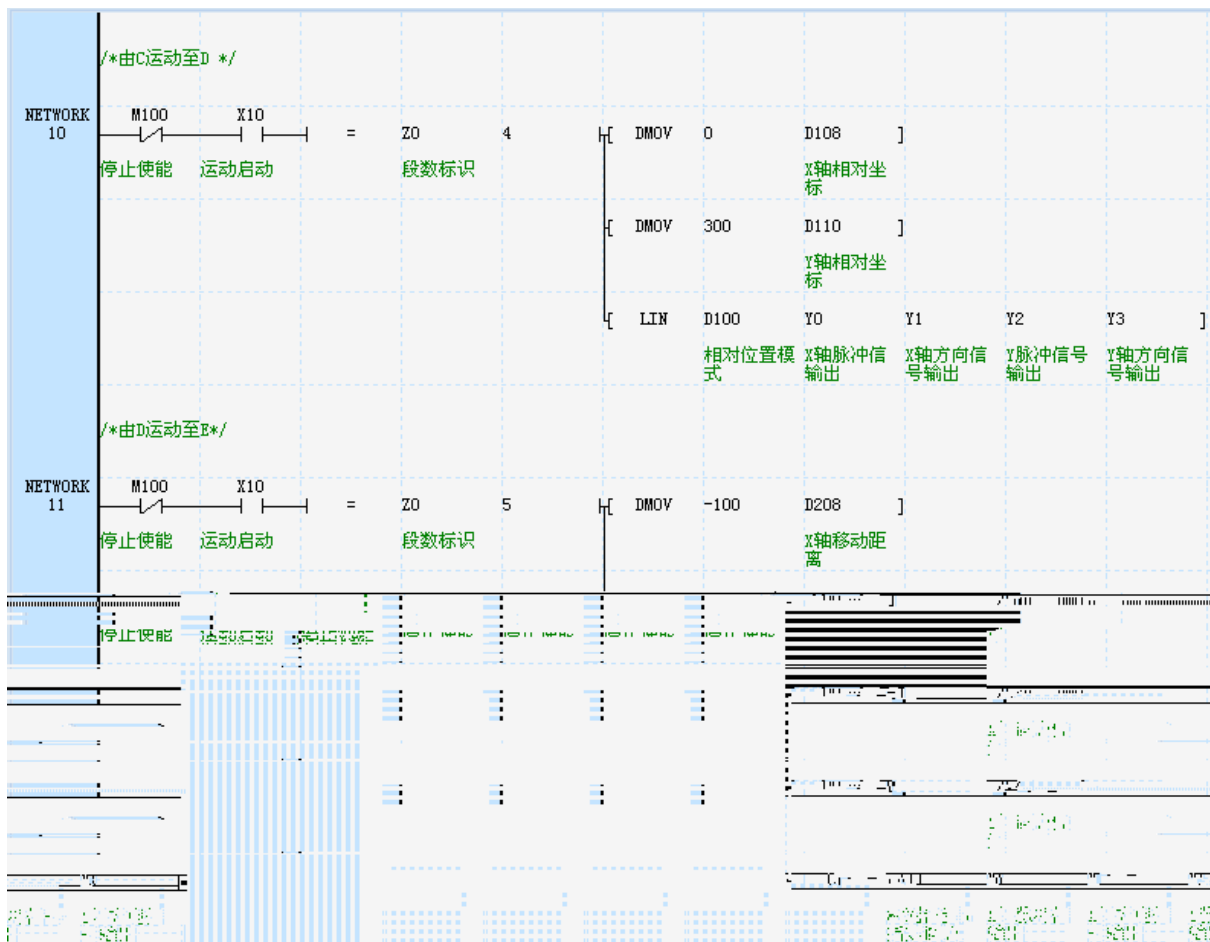


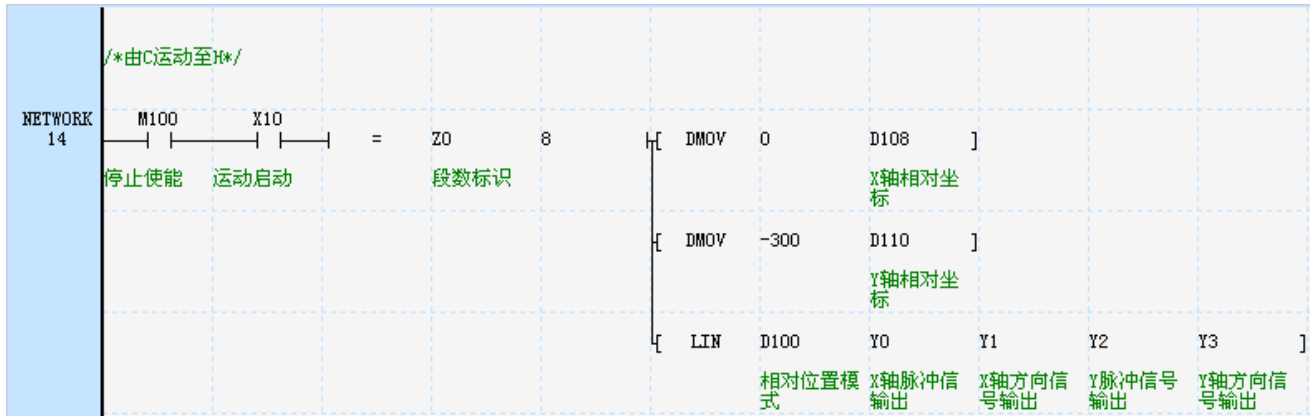
		/*初始化运动控制指令相关软元件*/			
NETWORK 0	SM1	[	DMOV	0	D100 ]
					相对位置模式
		[	DMOV	10000	D102 ]
					直线插补初始速度
		[	DMOV	10000	D104 ]
					直线插补合成速度
	[	DMOV	100	D106 ]	
				直线插补减速时间	
	[	DMOV	0	D108 ]	
				X轴相对坐标	
	[	DMOV	0	D110 ]	
				Y轴相对坐标	
NETWORK 1	SM1	[	DMOV	0	D200 ]
					相对位置, 指定圆心
	[	DMOV	10000	D202 ]	
				圆弧插补保留	

[	DMOV	10000	D204	]	圆弧插补合成速度
[	DMOV	100	D206	]	保留
[	DMOV	0	D208	]	X轴移动距离
[	DMOV	0	D210	]	Y轴移动距离
[	DMOV	0	D212	]	X轴圆心位置
[	DMOV	0	D214	]	Y轴圆心位置
[	MOV	1	Z0	]	段数标识
[	SET	SM72		]	Y2脉冲输出完成中断
[	SET	SM69		]	中断使能控制
[	EI			]	

NETWORK 2	SNO	[	DMOV	200000	SD202	]	Y0最高速度
		[	MOV	10	SD204	]	Y0基度速度
		[	MOV	100	SD205	]	Y0加减速时间
		[	MOV	10	SD207	]	Y0爬行速度
		[	DMOV	2000	SD208	]	Y0回归速度
NETWORK 3	SNO	[	DMOV	200000	SD322	]	Y2最高速度
		[	MOV	10	SD324	]	Y2基度速度
		[	MOV	100	SD325	]	Y2加减速时间
		[	MOV	10	SD327	]	Y2爬行速度
		[	DMOV	2000	SD328	]	Y2回归速度











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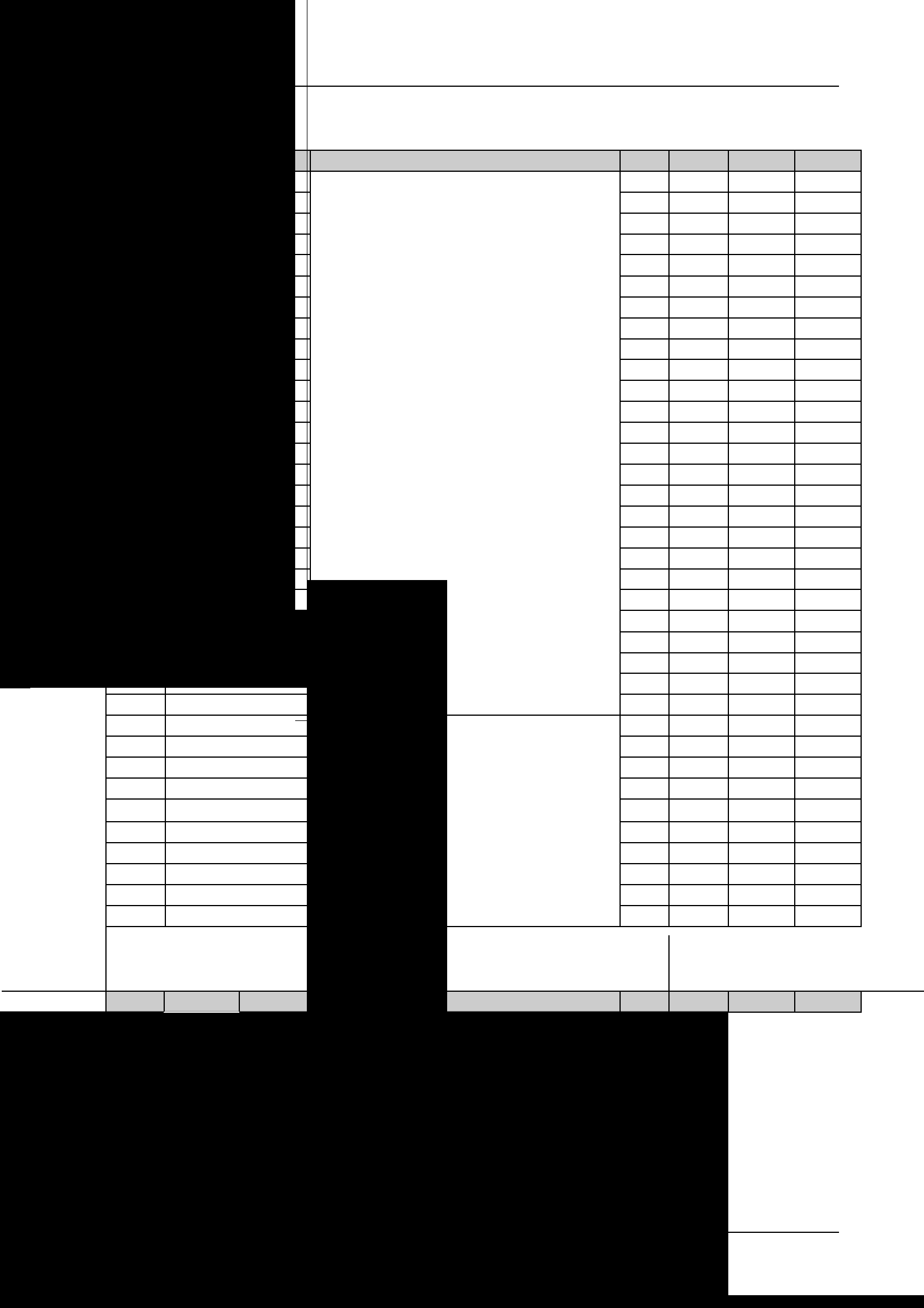








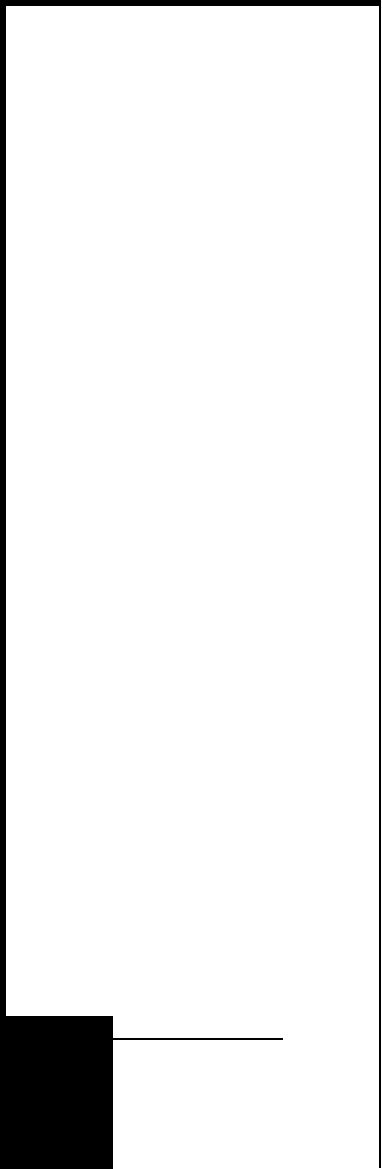
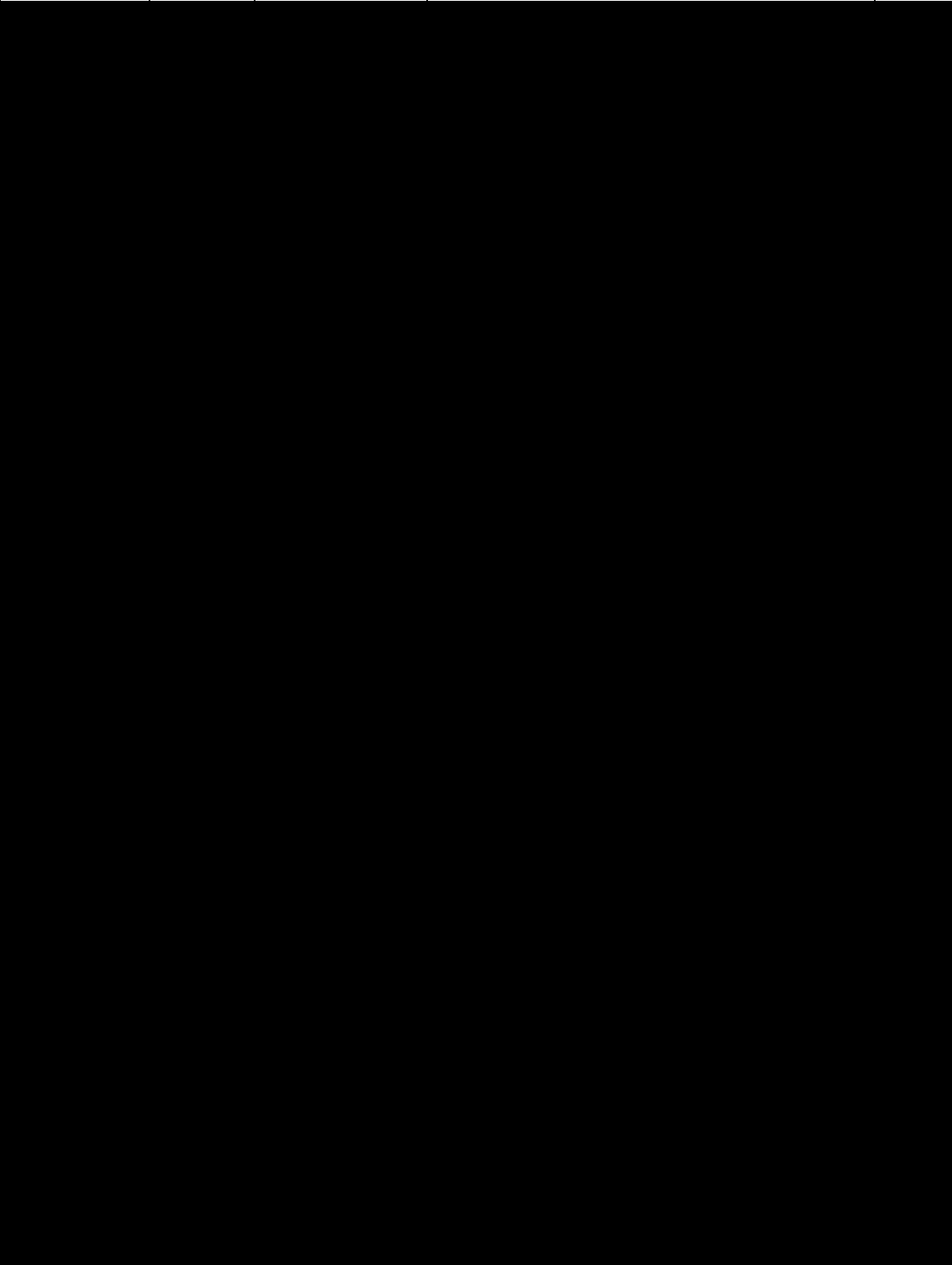
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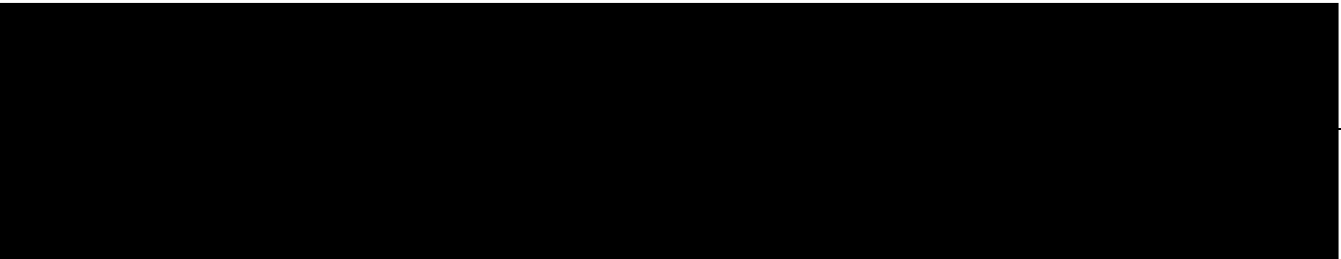
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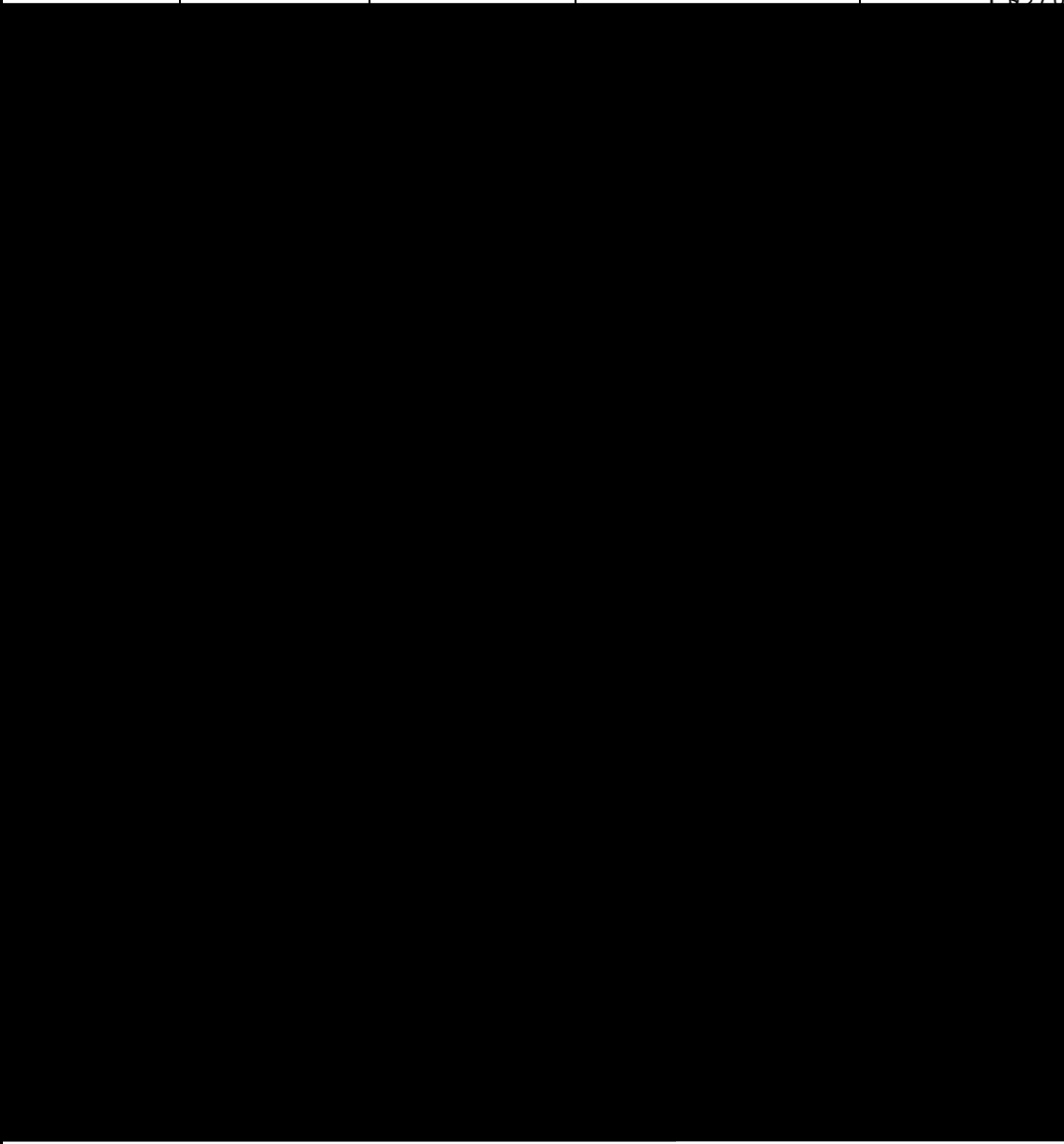




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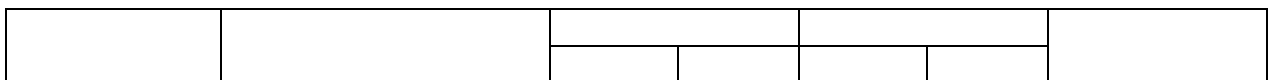
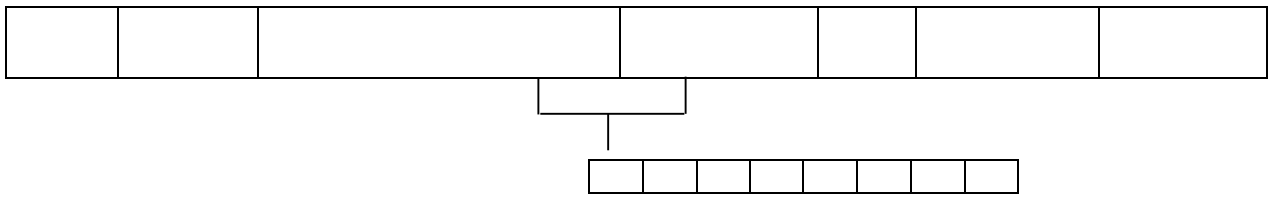
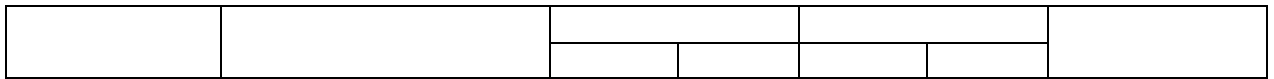
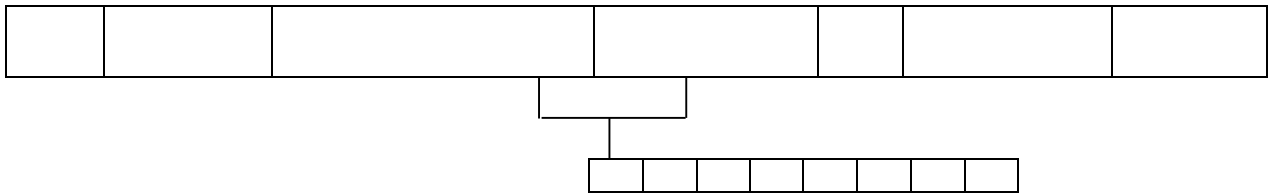
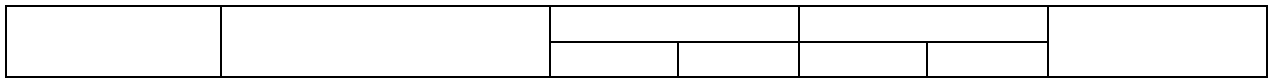
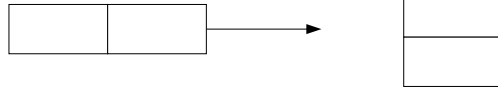
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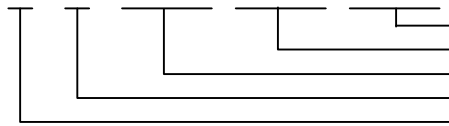




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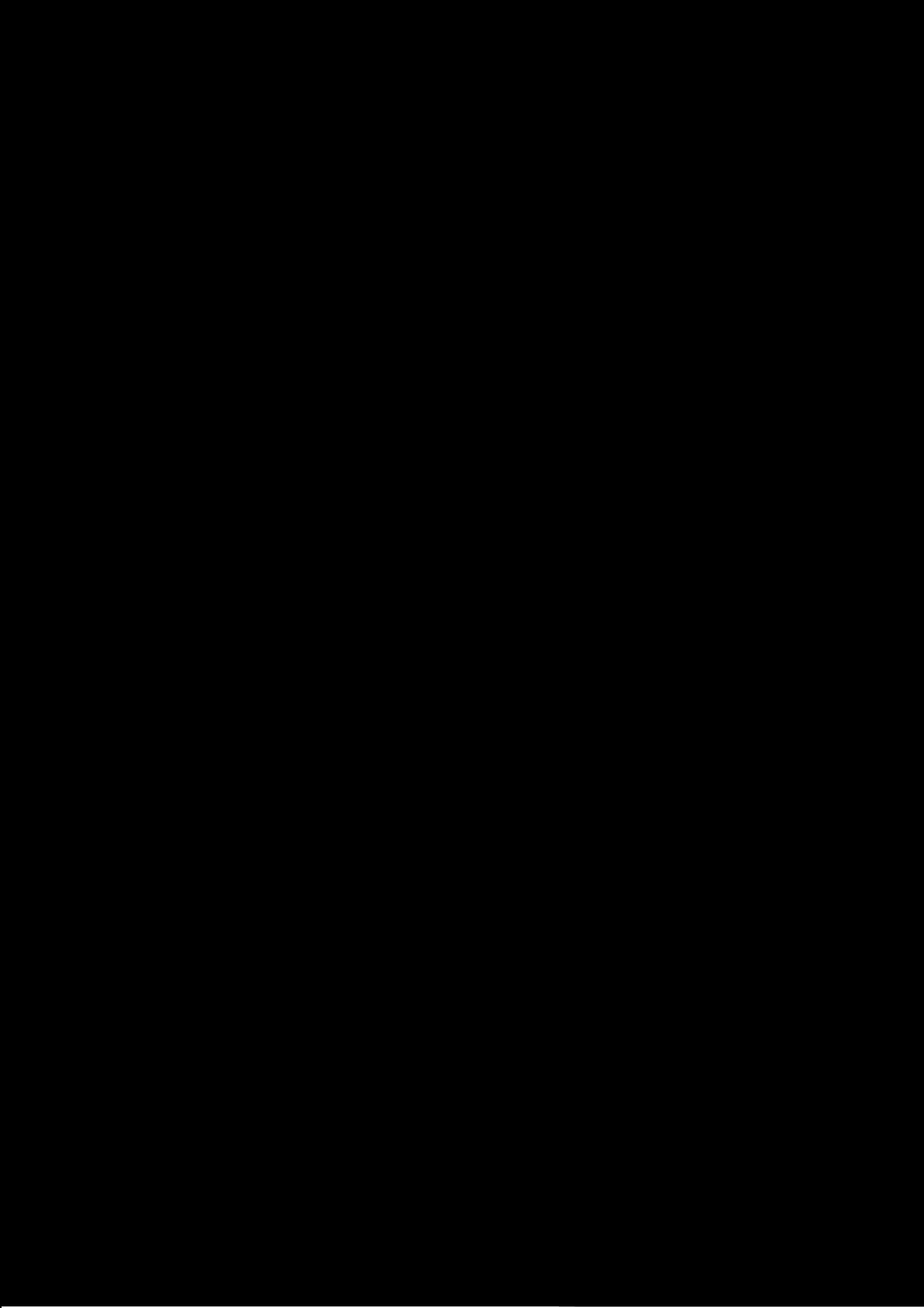
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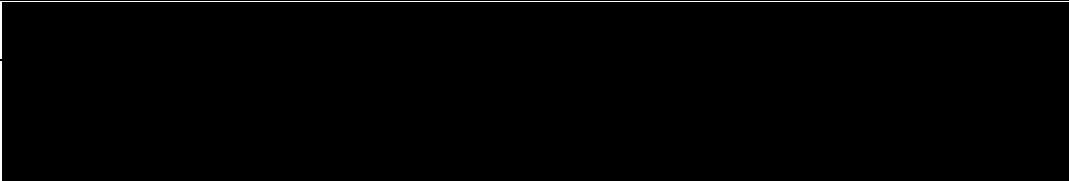
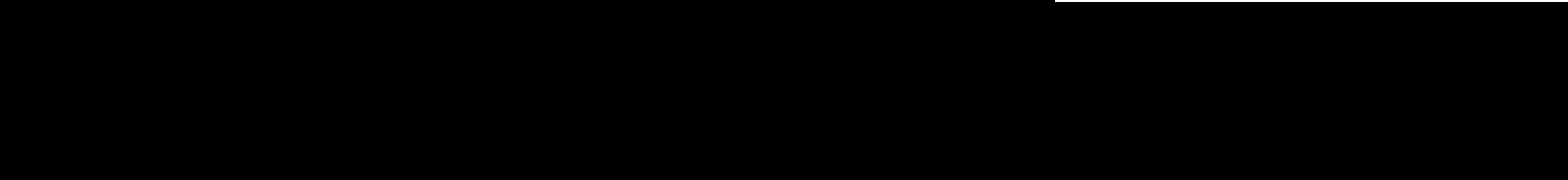
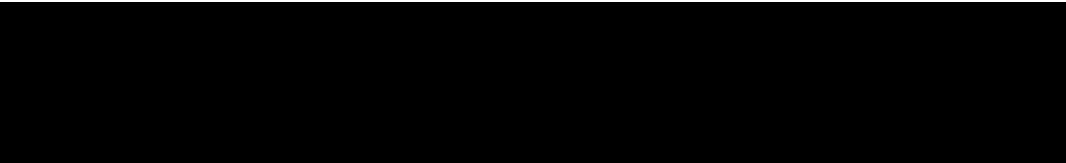
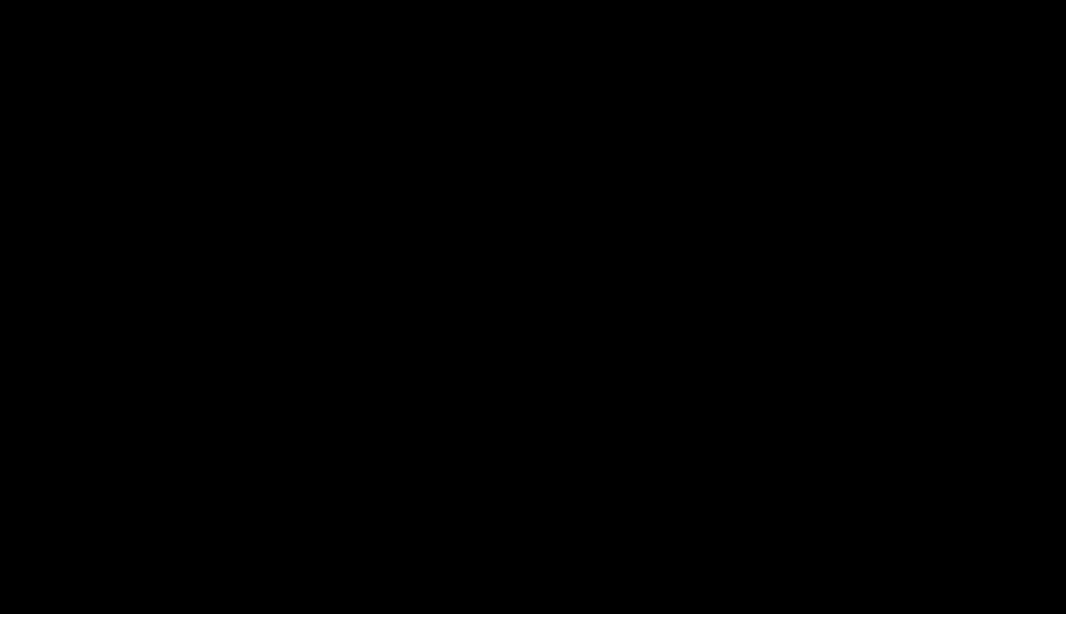
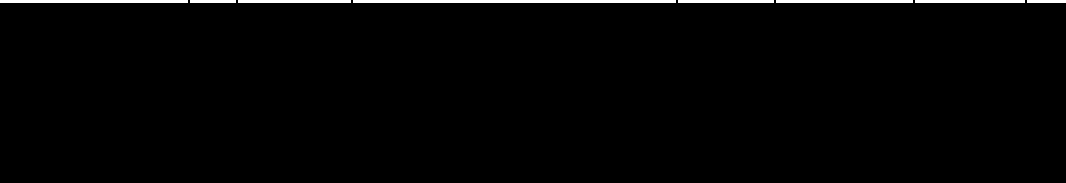








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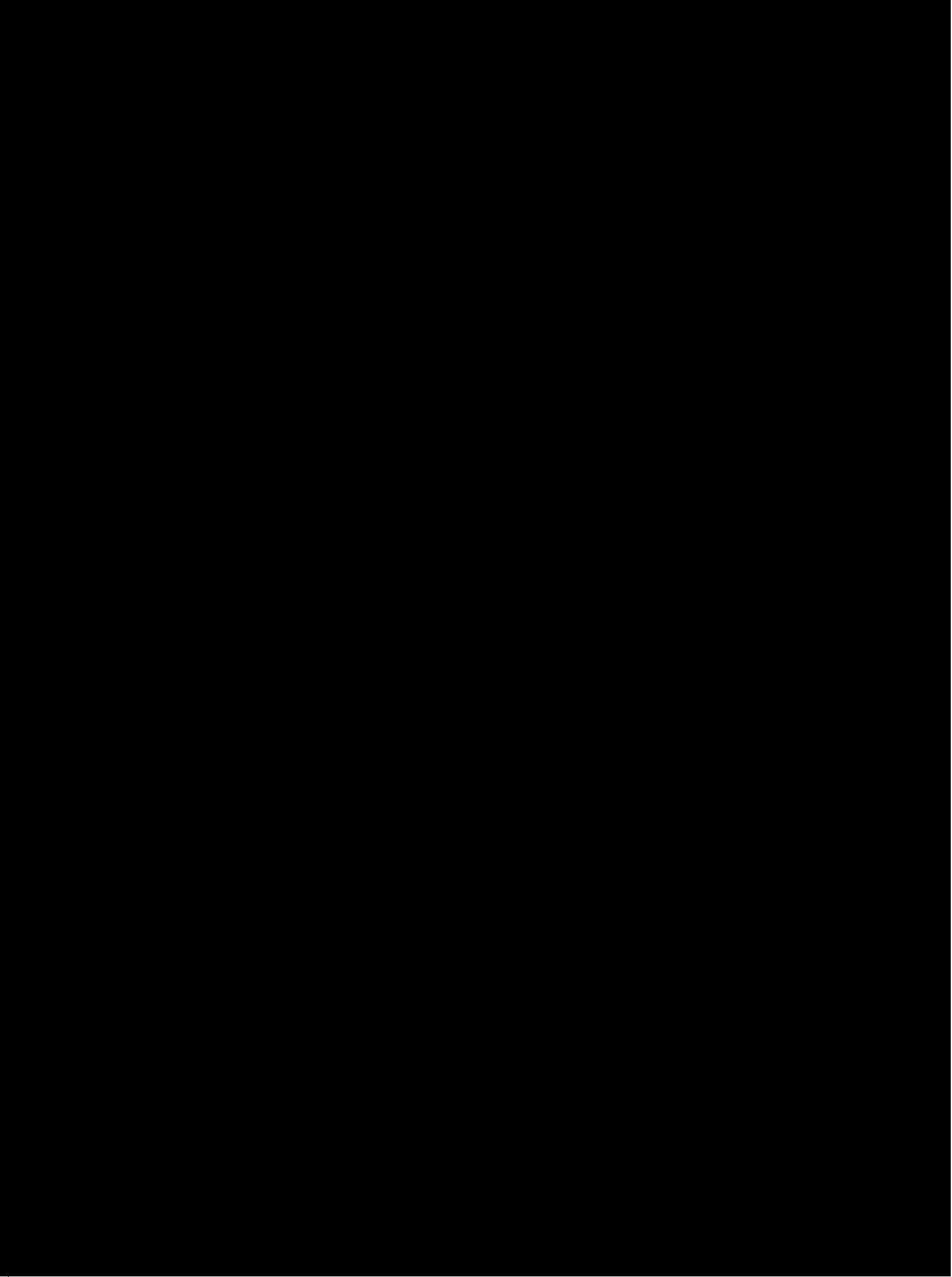




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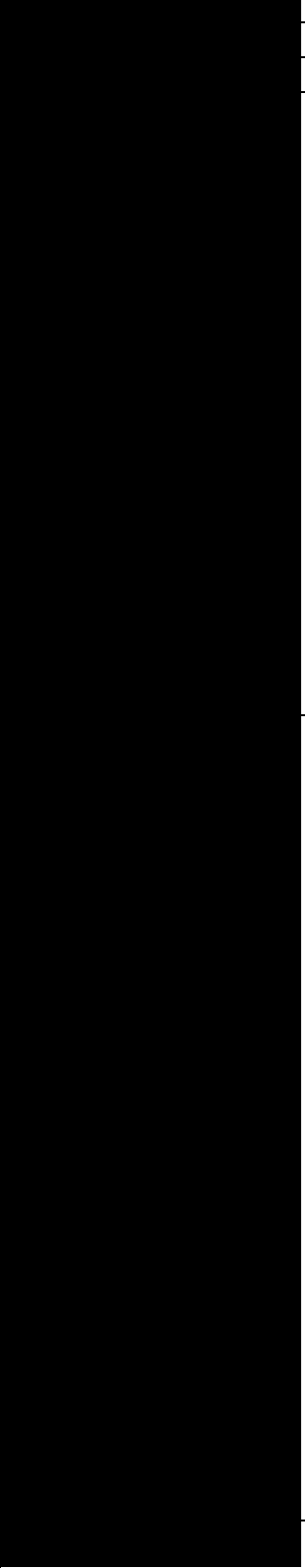
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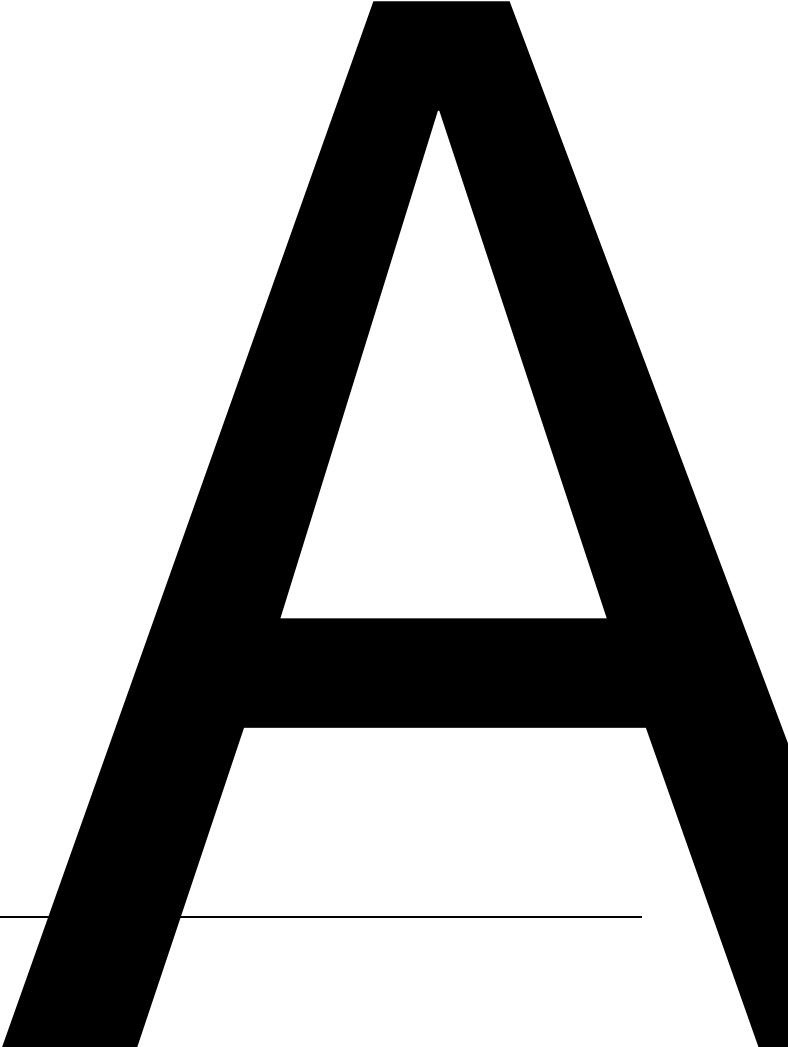
The main body of the page is mostly blank white space. There are a few small, faint vertical lines or artifacts, possibly from the scanning process, located in the lower half of the page.

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