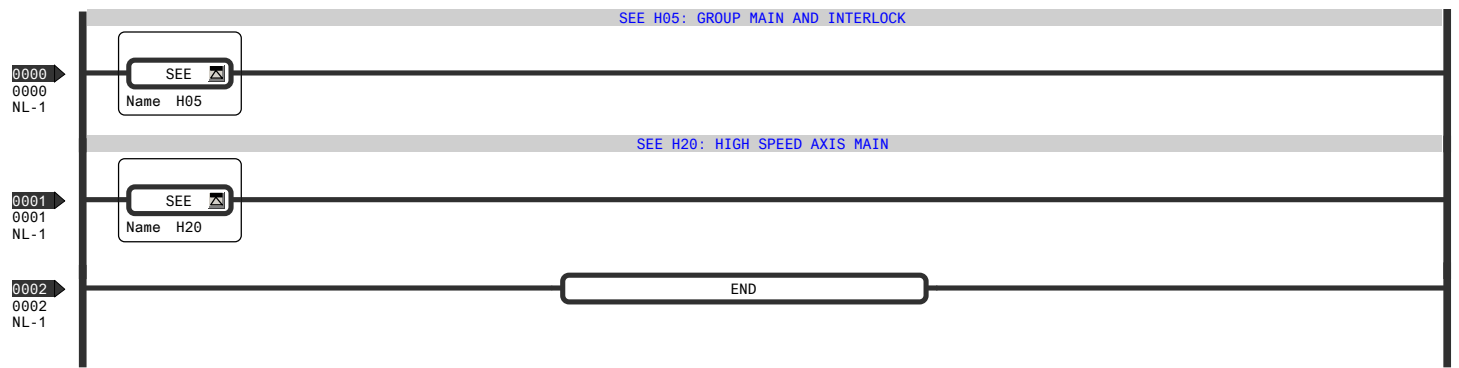
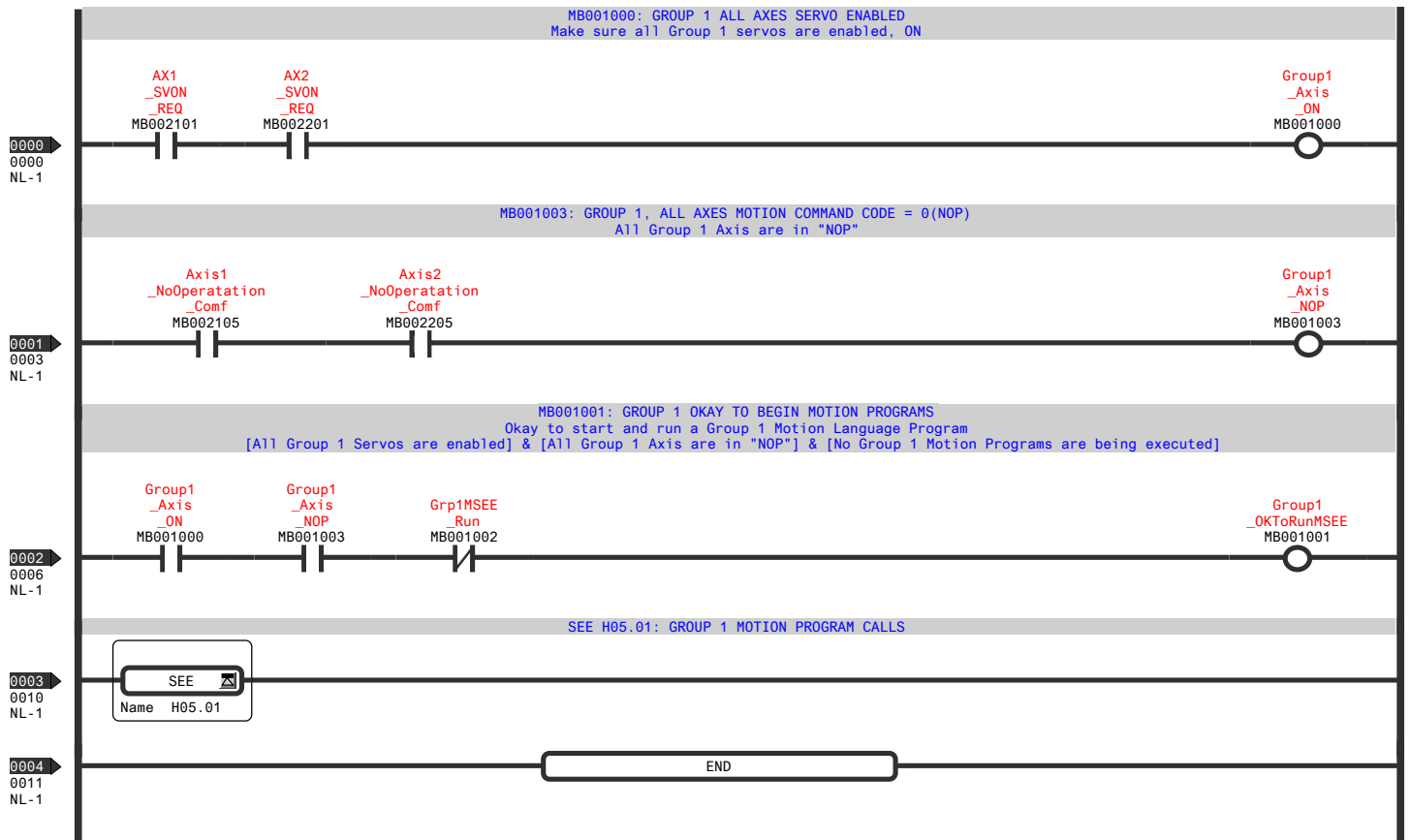


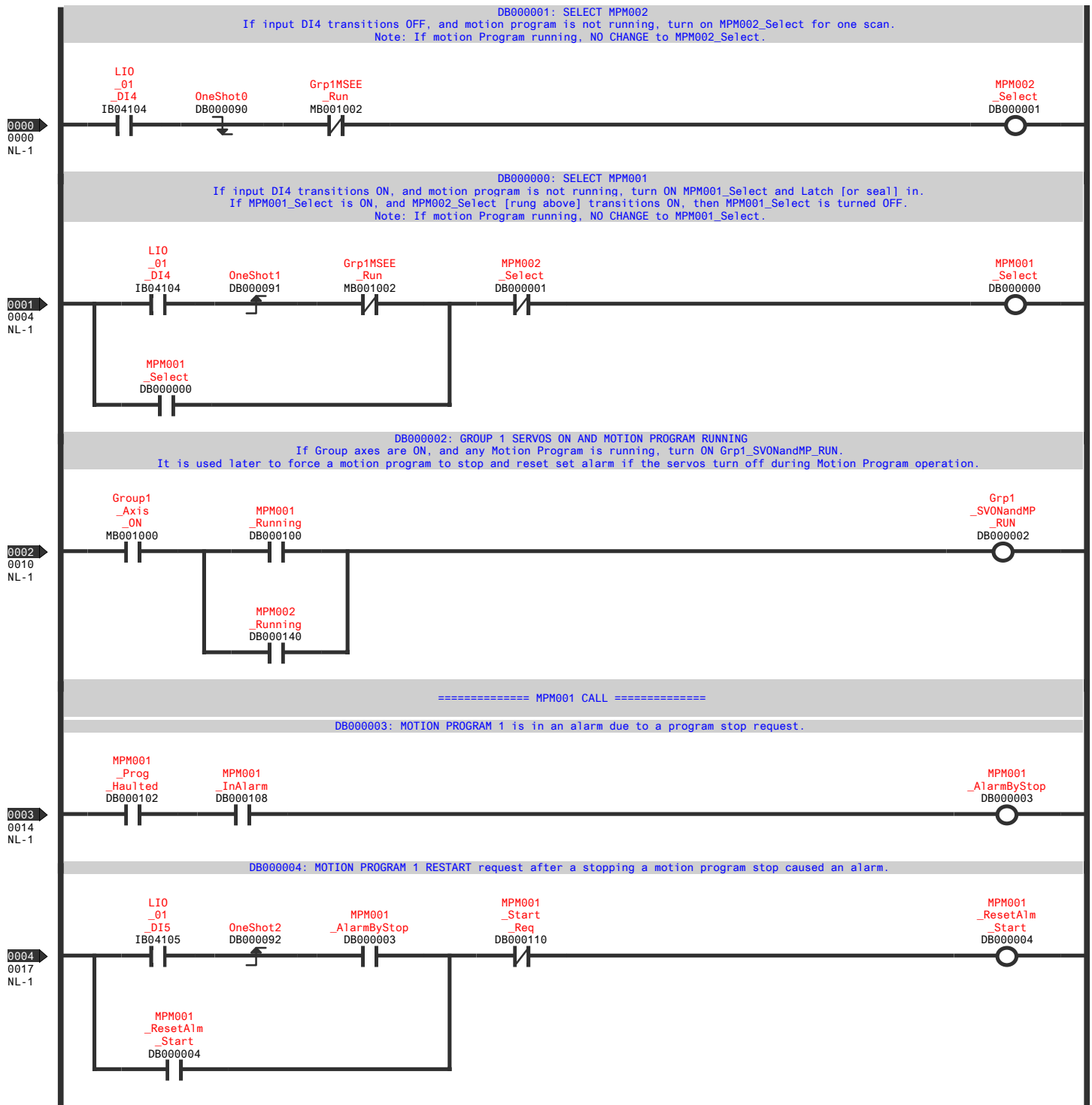
High Speed Main

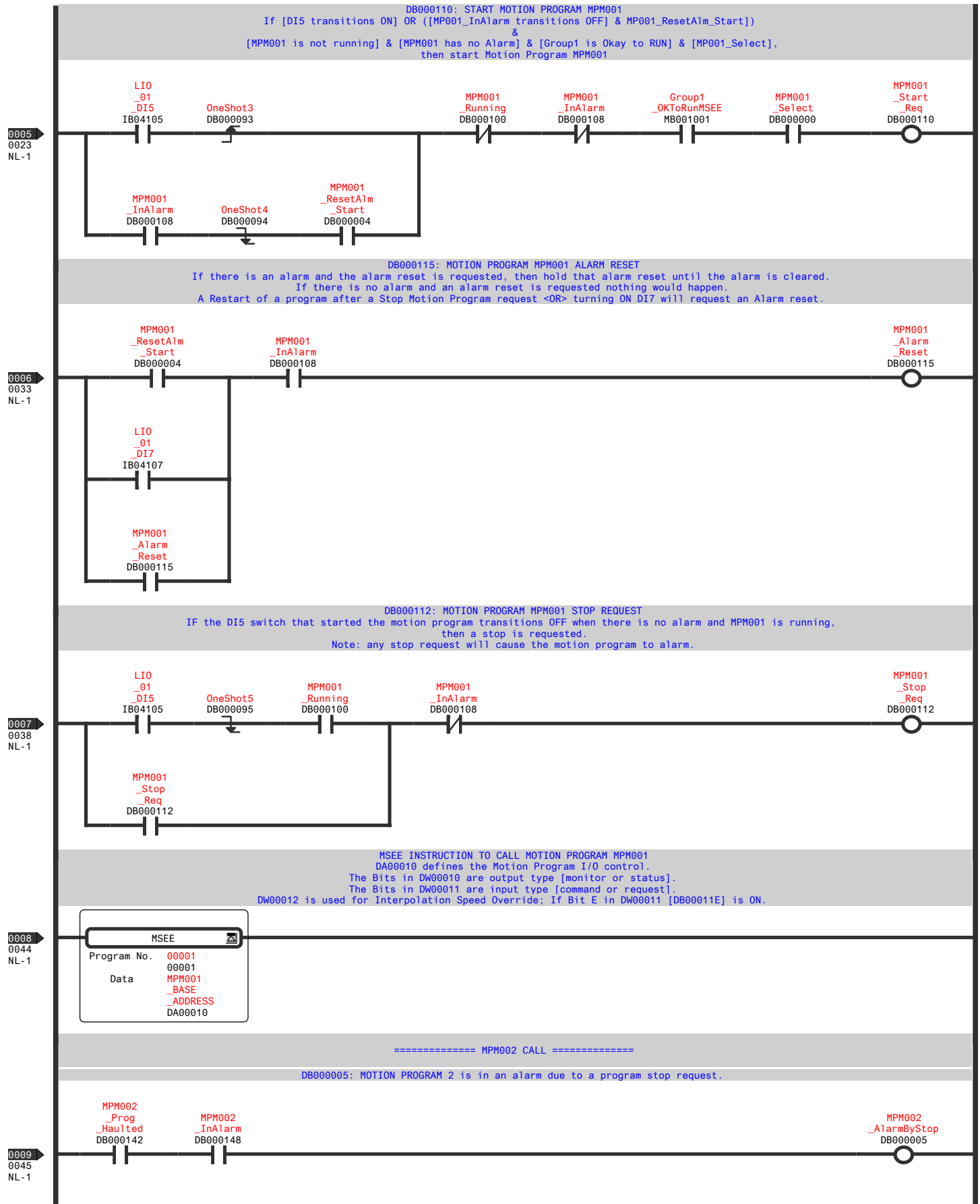


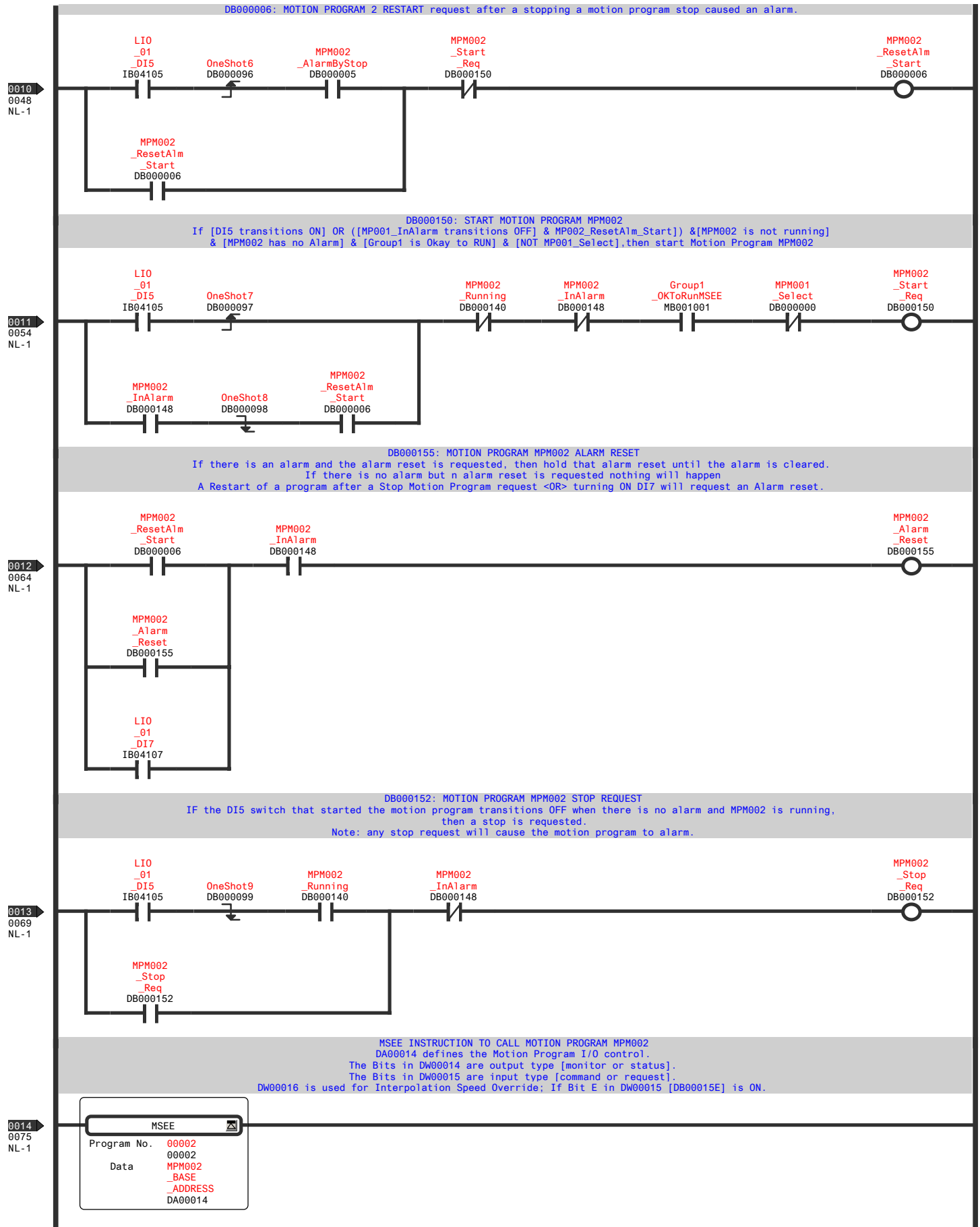
Group Main and Interlock

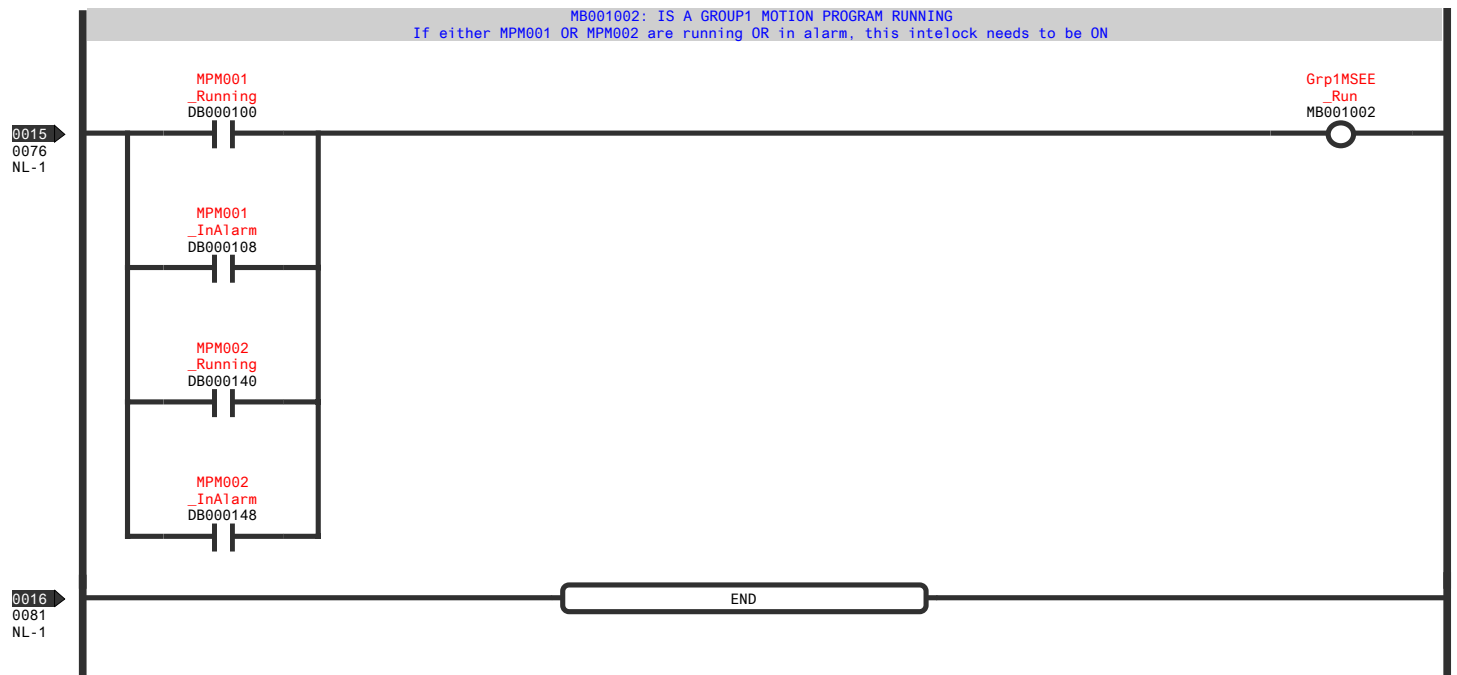


Group 1 Motion Program Calls

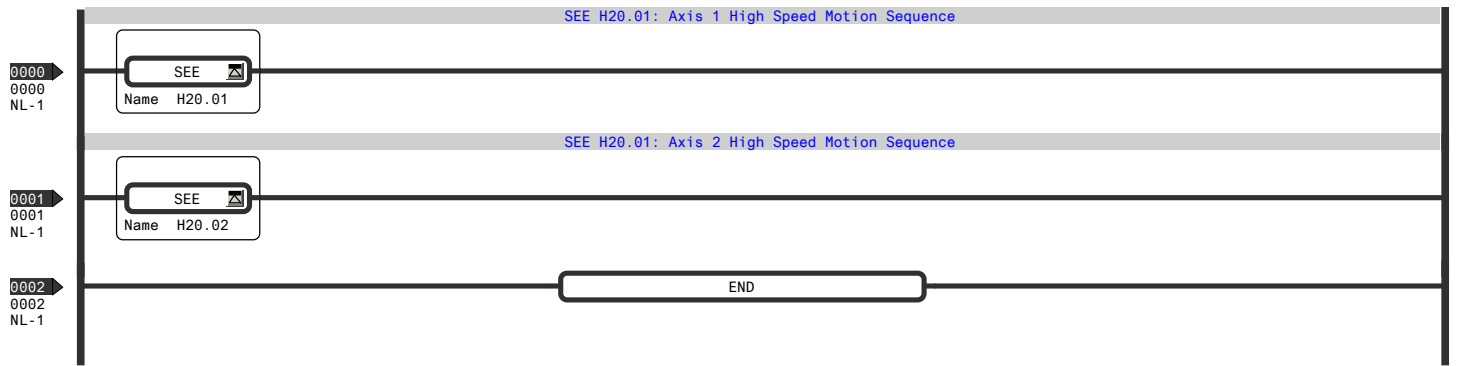




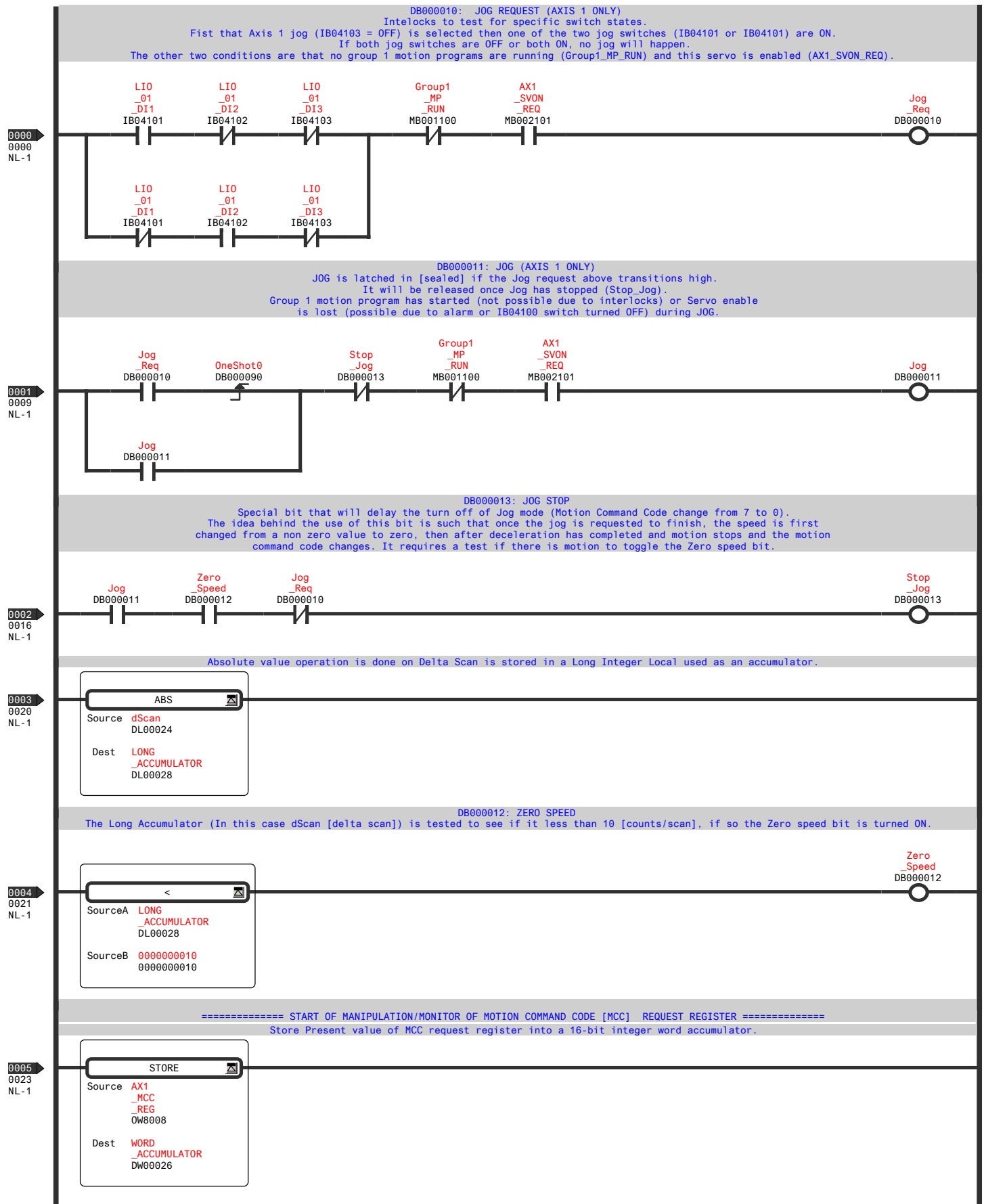




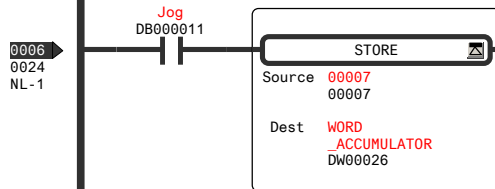
High Speed Axis Main



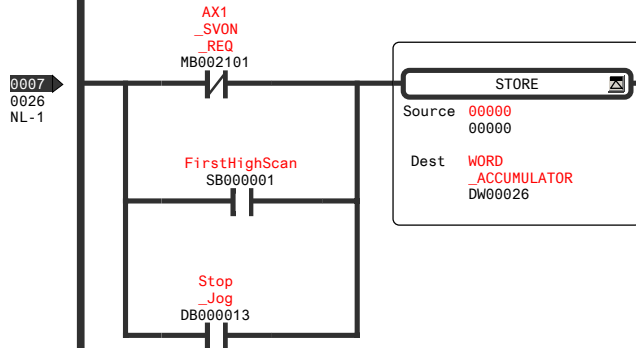
Axis 1 High Speed Motion Sequence



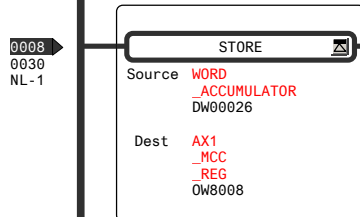
If Jog is true overwrite accumulator with a 7. This will only happen if Servos are enabled and if the group this servo is a member of has NO motion programs executing.



Overwrite the accumulator with a Zero if this axis servo is NOT enabled.
OR
It is the first High speed scan after controller power up.
OR
Stop_Jog is ON.



Store the accumulator in the MCC request register.



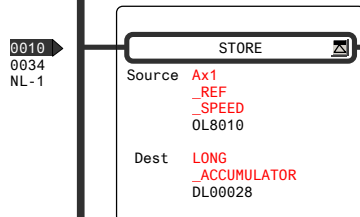
===== END OF MANIPULATION/MONITOR OF MOTION COMMAND CODE [MCC] REQUEST REGISTER =====

OB80092: AX1_JogStep_DIR (Bit is used to force JOG (MCC=7) and Step (MCC=8) in the negative direction)
If Jog is ON and the Jog reverse input is ON the Jog is done in the reverse direction.

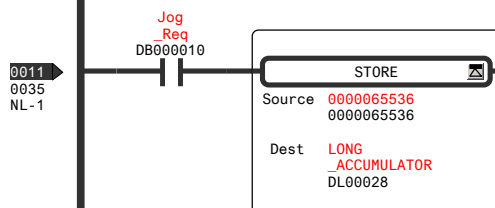


===== START OF MANIPULATION/MONITOR OF SPEED REQUEST REGISTER =====

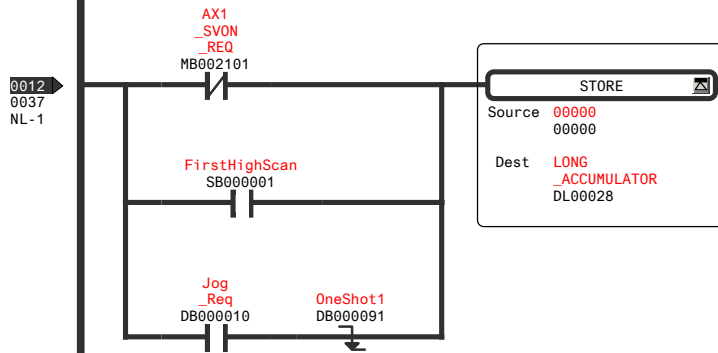
Store the speed request register in a Long interger (32-bit) accumulator



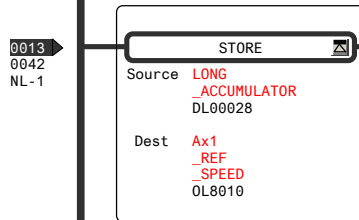
If Jog request is ON, then overwrite the accumulator with a value of 65536 [1000units/min]



Overwrite the accumulator with 0 if Axis Servo is OFF.
 OR
 It is the first High Speed Scan after controller power up.
 OR
 Jog request transitions OFF.



Store the accumulator in the speed request register.



===== END OF MANIPULATION/MONITOR OF SPEED REQUEST REGISTER =====

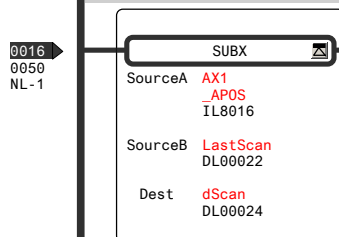
DB000000: AXIS MOTION COMMAND FEEDBACK IS ZERO
 Test that Motion Command Code feedback register for this Axis is Zero (NOP)



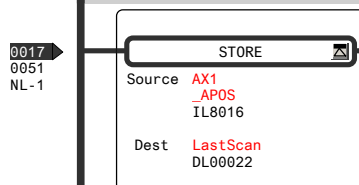
MB002105: NO OPERATION CONFIRMATION
 Absolute test that there is no motion, no motion buffered and held.



===== START OF DELTA SCAN CREATION =====
 AXIS FEEDBACK -- FEEDBACK OF AXIS LAST SCAN = DELTA SCAN



FEEDBACK OF AXIS LAST SCAN



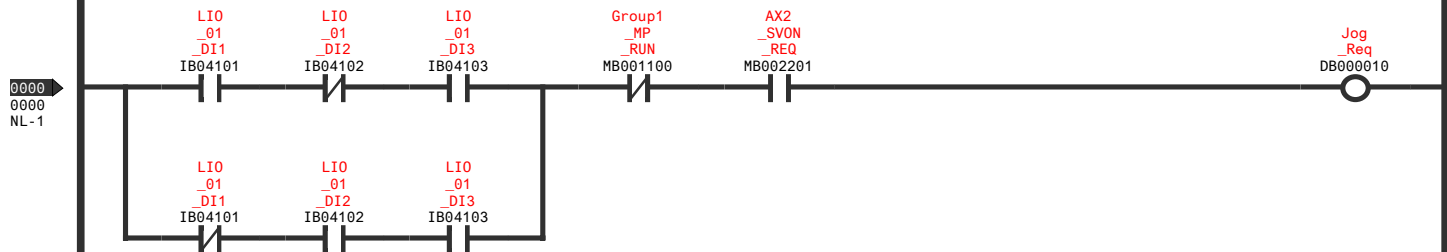
0018
0052
NL-1

END

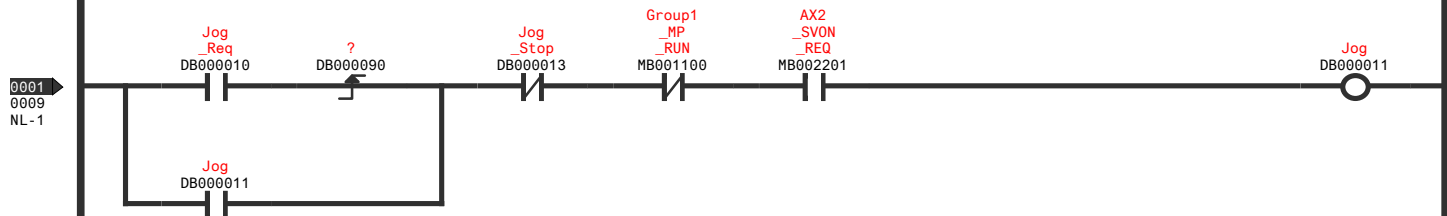
		Draw. Date.2004.12.14	H20.01 Main Program Axis 1 High Speed Motion Sequence	PMP2000-962401 P00115
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Program Comment

DB000010: JOG REQUEST (AXIS 1 ONLY)
 Interlocks to test for specific switch states.
 First that Axis 2 jog (IB04103 = ON) is selected then one of the two jog switches (IB04101 or IB04101) are ON.
 If both jog switches are OFF or both ON, no jog will happen.
 The other two conditions are that no group 1 motion programs are running (Group1_MP_RUN) and this servo is enabled (AX2_SVON_REQ).



DB000011: JOG (AXIS 2 ONLY)
 JOG is latched in [sealed] if the Jog request above transitions high.
 It will be released once Jog has stopped (Stop_Jog).
 Group 1 motion program has started (not possible due to interlocks) or Servo enable is lost (possible due to alarm or IB04100 switch turned OFF) during JOG.



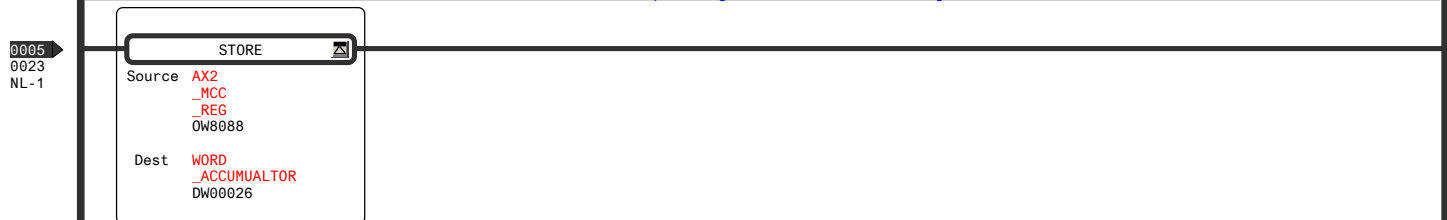
DB000013: JOG STOP
 Special bit that will delay the turn off of Jog mode (Motion Command Code change from 7 to 0).
 The idea behind the use of this bit is such that once the jog is requested to finish, the speed is first changed from a non zero value to zero, then after deceleration has completed and motion stops and the motion command code changes. It requires a test if there is motion to toggle the Zero speed bit.

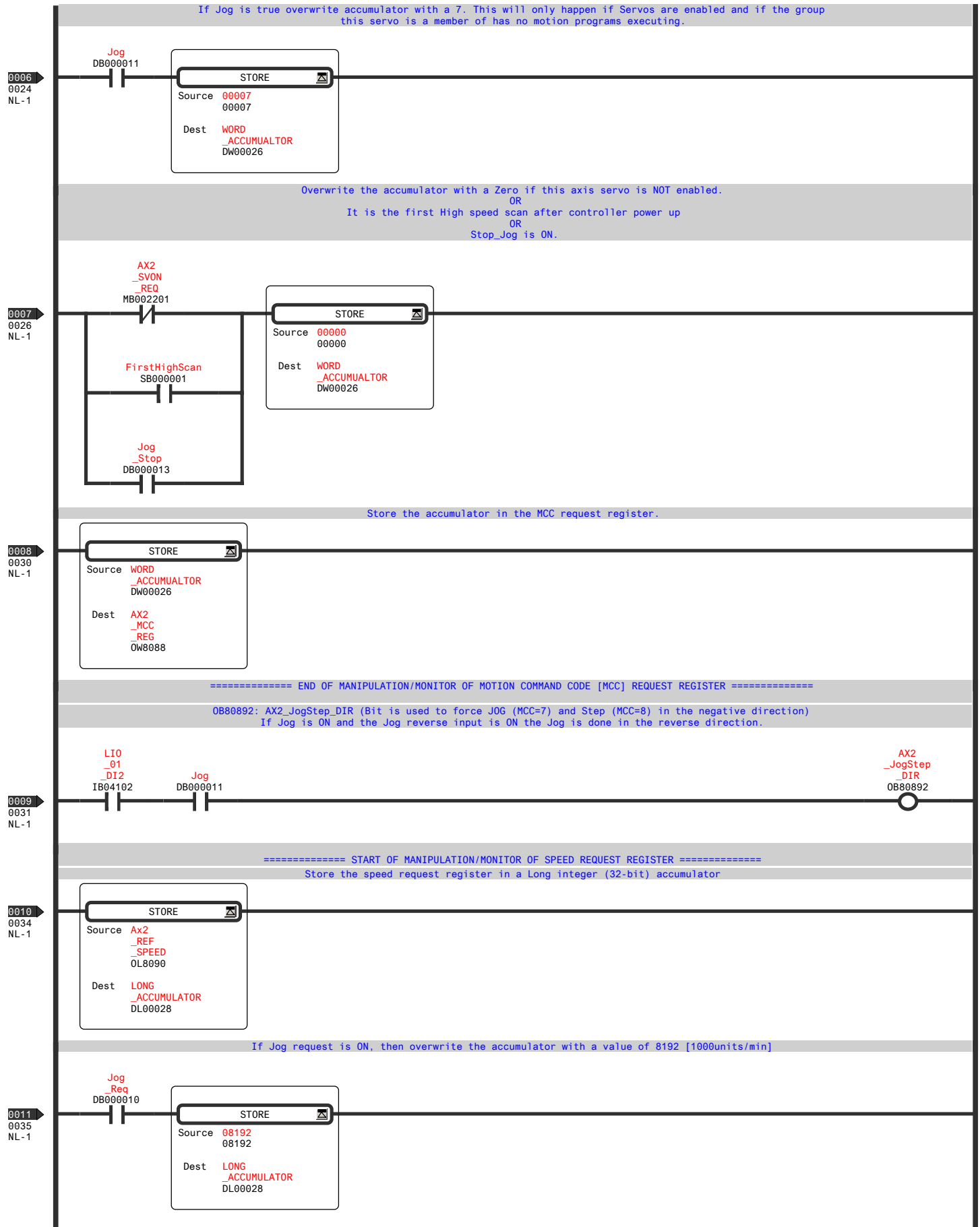


Absolute value operation is done on Delta Scan is stored in a Long Integer Local used as an accumulator.

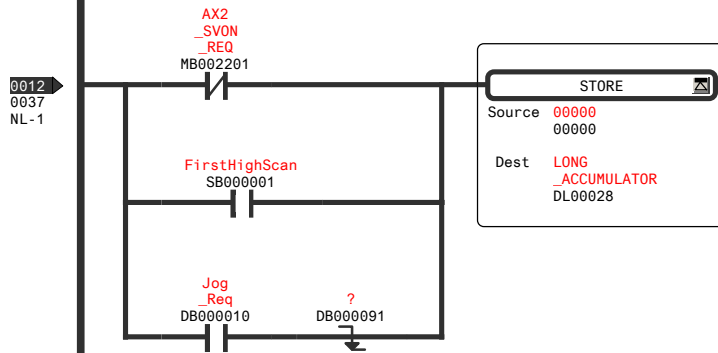


===== START OF MANIPULATION/MONITOR OF MOTION COMMAND CODE [MCC] REQUEST REGISTER =====
 Store Present value of MCC request register into a 16-bit integer word accumulator.

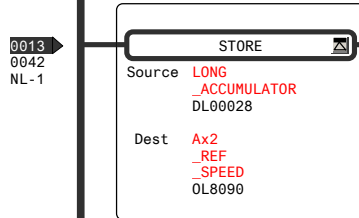




Overwrite the accumulator with 0 if Axis Servo is OFF.
 OR
 It is the first High Speed Scan after controller power up.
 OR
 Jog request transitions OFF.



Store the accumulator in the speed request register.



===== END OF MANIPULATION/MONITOR OF SPEED REQUEST REGISTER =====

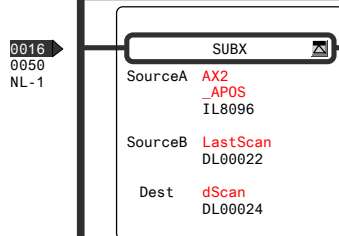
DB000000: AXIS MOTION COMMAND FEEDBACK IS ZERO Test that Motion Command Code feedback register for this Axis is Zero (NOP)



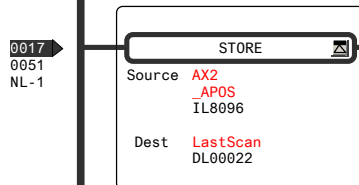
MB002205: AXIS 2 NO OPERATION CONFIRMATION Absolute test that there is no motion, no motion buffered and held.



AXIS FEEDBACK -- FEEDBACK OF AXIS LAST SCAN = DELTA SCAN



FEEDBACK OF AXIS LAST SCAN




0018
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NL-1

END

		Draw. Date.2004.12.14	H20.02 Main Program Axis 2 High Speed Motion Sequence	PMP2000-962401 P00120
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Name L20

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NL-1

END

		Draw. Date.2004.12.14	L Main Program Low Speed Main	PMP2000-962401 P00122
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