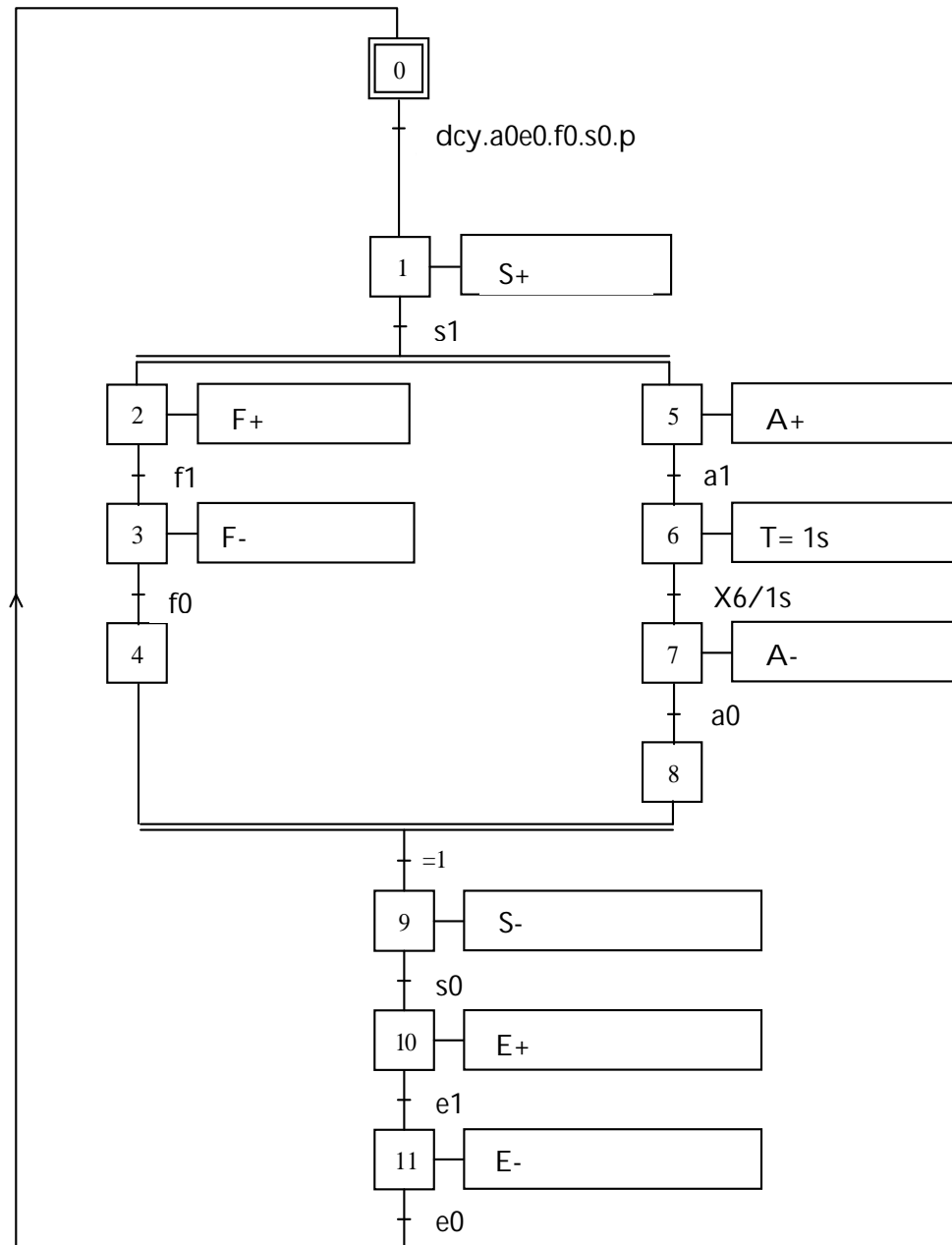


Grafcet de point de vue partie commande



Mise en équations partielle

$$X0 = (X11.e0 + X0). \overline{X1}$$

$$X1 = (X0.dcy.a0e0.f0.s0.p + X1). \overline{X2.X5}$$

$$X2 = (X1.s1 + X2). \overline{X3}$$

$$X5 = (X1.s1 + X5). \overline{X6}$$

$$X4 = (X3.f0 + X4). \overline{X9}$$

$$X9 = (X3.X8 + X9). \overline{X10}$$

$$A+ = X5$$

Programme Abel partiel

Module usinage

Declarations

Usinage device 'P22V10' ;

dcy, a0, a1, e0, e1 f0, f1 ,s0, s1, p pin 1, 2, 3, 4, 5 ,6, 7, 8, 9, 10 ;

A1 , A0, E1 , E0-, F1 , F0, S1 , S0, T pin 14, 15, 16, 17, 18, 19, 20, 21, 22 istype 'com';

X0..X11 node istype 'reg';

equations

X0 := (X11&e0 # X0)& ! X1 ;

.....

A1 = X5 ;

....

End usinage