
NC

Rev: V2 4

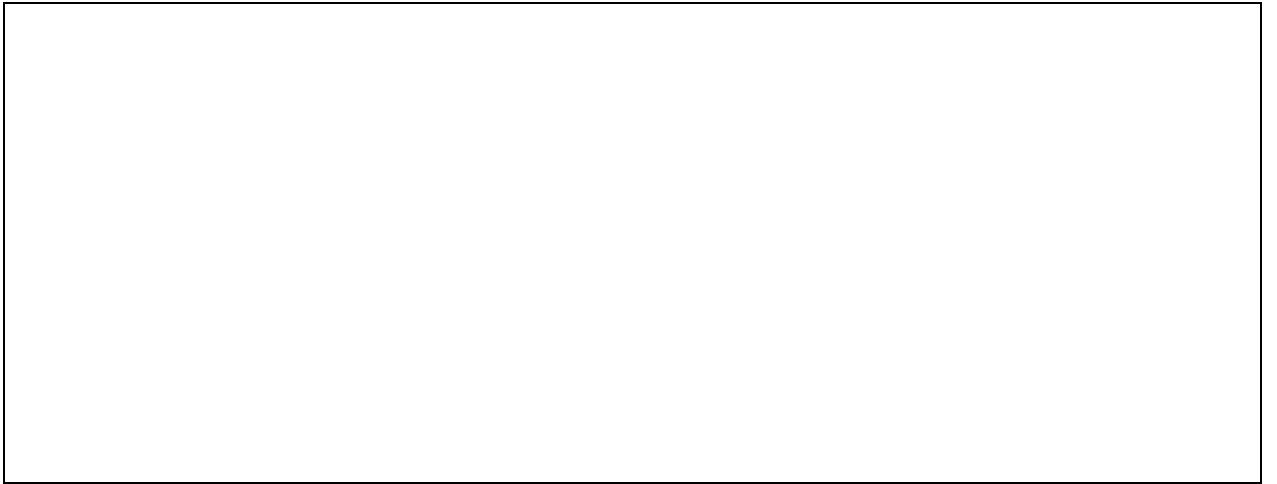
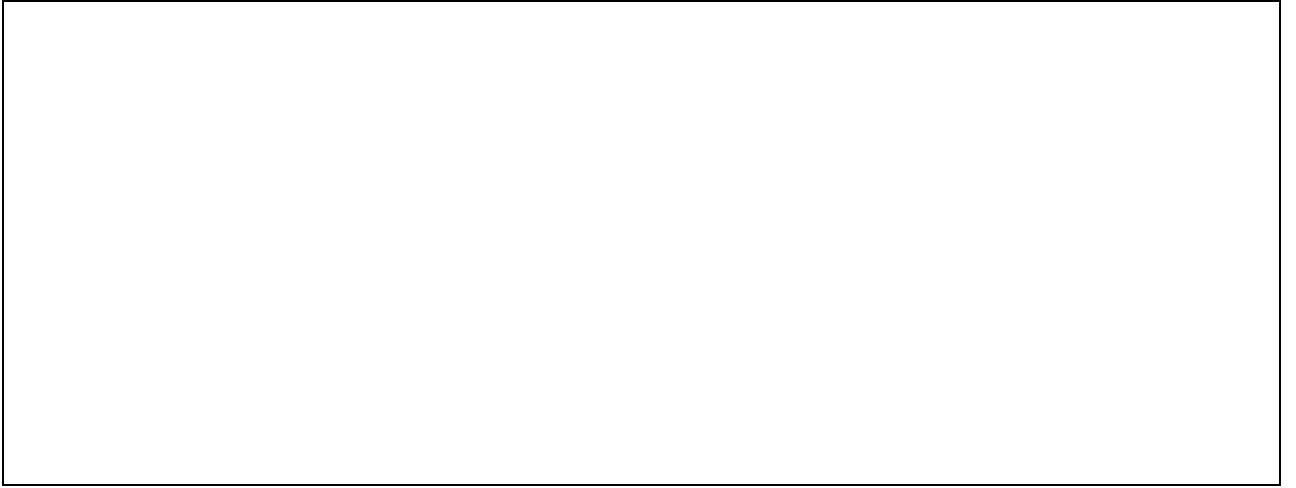
: 2016 10 10

NC



		μ	μ	μ

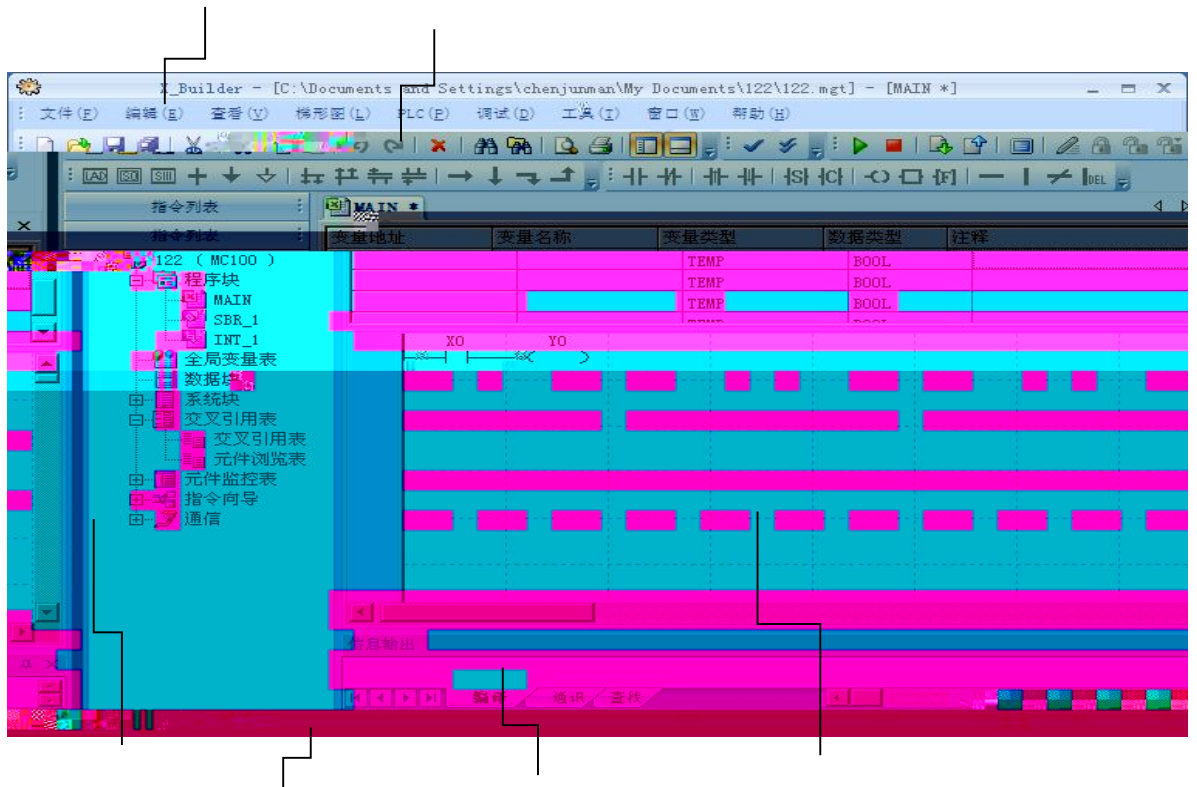
(4



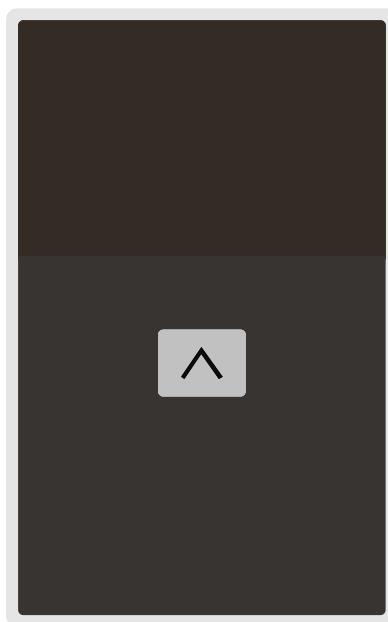


	x	x

Megmeet







Modbus

MC100 MC200

M80					
MC80-1006BRA	10	6			
MC80-1006BTA	10	6			
MC80-1410BRA	14	10			
MC80-1410BTA	14	10			
MC80-1614BRA	16	14			
MC80-1614BTA	16	14			
MC80-2416BRA	24	16			
MC80-2416BTA	24	16			
MC80-3624BRA	36	24			
MC80-3624BTA	36	24			
MC100					
MC100-1006BRA	10	6			
MC100-1006BTA	10	6			
MC100-1410BRA	14	10			
MC100-1410BTA	14	10			
MC100-1614BRA	16	14			
MC100-1614BTA	16	14			
MC100-1614BRA1		AD	DA	16	14
MC100-1614BTA1		AD	DA	16	14
MC100-2416BRA	24	16			

MC100- 2416BTA	24	16	
MC100- 3624BRA	36	24	
MC100- 3624BTA	36	24	
MC200			
MC200- 2012BRA	20	12	
MC200- 2012BTA	20	12	
MC200- 3232BRA	32	32	
MC200- 3232BTA	32	32	
MC200- 4040BRA	40	40	
MC200- 4040BTA	40	40	
MC280			
MC280- 1616BTA8	16	16	8
MC280- 1616BTA6	16	16	6
MC280- 1616BTA4	16	16	4
MC200E- 1616BTA8	16	16	8
MC200E- 1616BTA6	16	16	6
MC200E- 1616BTA4	16	16	4
MC100 (AC)			
MC100- 1006BRA2	10	6	
MC100- 1006BTA2	10	6	
MC100- 1410BRA2	14	10	
MC100- 1410BTA2	14	10	
MC100- 1614BRA2	16	14	
MC100- 1614BTA2	16	14	
MC100- 2416BRA2	24	16	
MC100- 2416BTA2	24	16	
MC100- 3624BRA2	36	24	
MC100- 3624BTA2	36	24	
MC100- 3624BRA3	36	24	
MC100 (DC)			
MC100- 1006BRD	10	6	
MC100- 1006BTD	10	6	
MC100- 1410BRD	14	10	
MC100- 1410BTD	14	10	
MC100- 1614BRD	16	14	
MC100- 1614BTD	16	14	
MC100- 2416BRD	24	16	
MC100- 2416BTD	24	16	
MC100- 3624BRD	36	24	

MC100			
MC100- 0008ERN	0	8	10
MC100- 0008ETN	0	8	10
MC100- 0016ERN	0	16	10
MC100- 0016ETN	0	16	10
MC100- 0800ENN	8	0	10
MC100- 0808ERN	8	8	10
MC100- 0808ETN	8	8	10
MC100- 1600ENN	16	0	10
MC200			
MC200- 0008ERN	0	8	10
MC200- 0008ETN	0	8	10
MC200- 0016ERN	0	16	10
MC200- 0016ETN	0	16	10

MC200-0800ENN	8	0	10
MC200-0808ERN	8	8	10
MC200-0808ETN	8	8	
MC200-1600ENN	16	0	10
MC200-1616ERA	16	16	
MC200-1616ETA	16	16	
MC200-1616ERN	16	16	
MC200-1616ETN	16	16	

MC100			
MC100-2AD	2		
MC100-4AD	4		
MC100-2DA	2		
MC100-4DA	4		
MC100-5AM	4	1	
MC100-2PT	2		
MC100-4PT	4		
MC100-2TC	2		
MC100-4TC	4		
MC200			
MC200-2AD	2		
MC200-4AD	4		
MC200-8AD	8		
MC200-2DA	2		
MC200-4DA	4		
MC200-4AM	2	2	
MC200-5AM	4	1	
MC200-2TC	2		
MC200-4TC	4		
MC200-8TC	8		
MC200-2PT	2		
MC200-4PT	4		
MC200-2HC	2		
MHA-04-NT	4		

MC100	
MC100-DPS	Profibus DP (MC100-DPS)
MC200	
MC200-CPM	CANopen
MC200-RS485	
MC200-CPS	CANOPEN
MC200-CGP	

MC200	
MC200-ESM	/MC200-ESM





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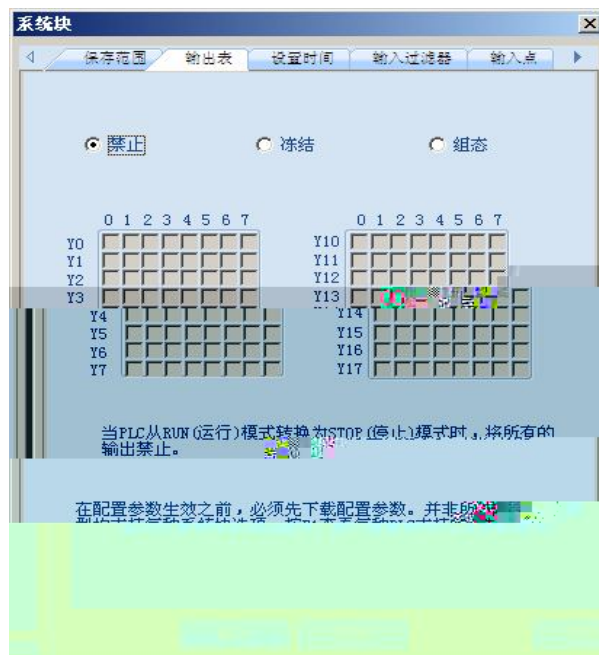
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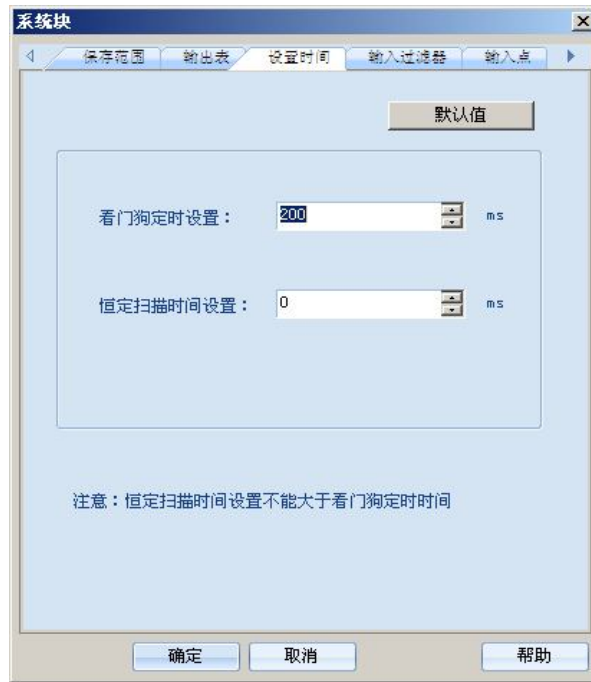


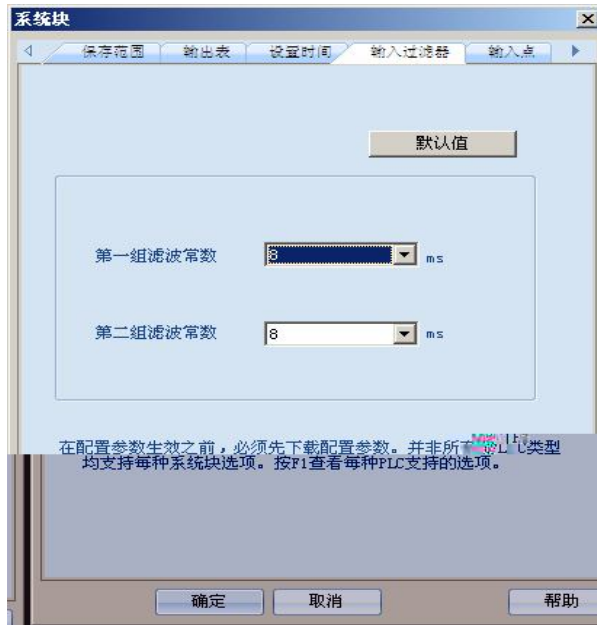
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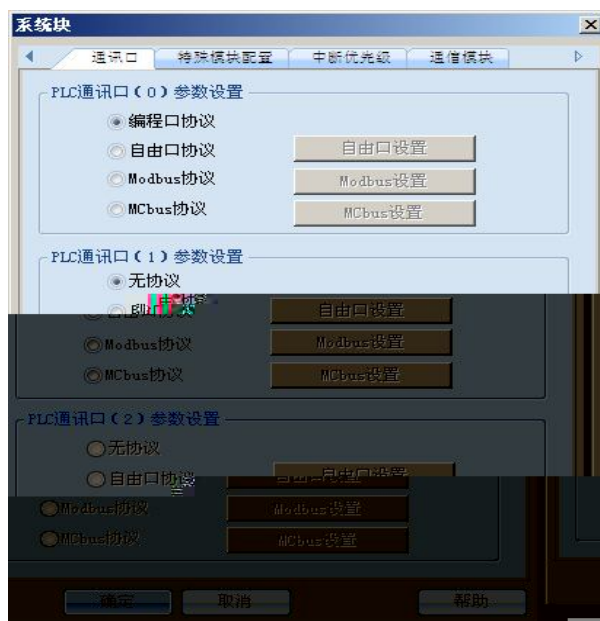
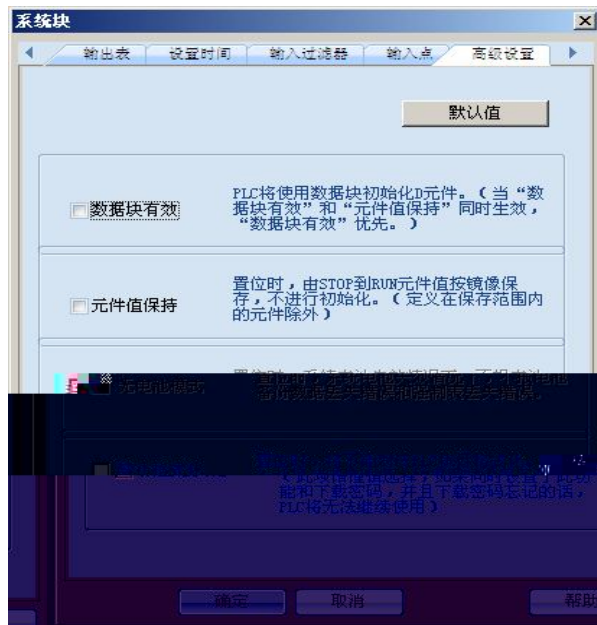
PLC/

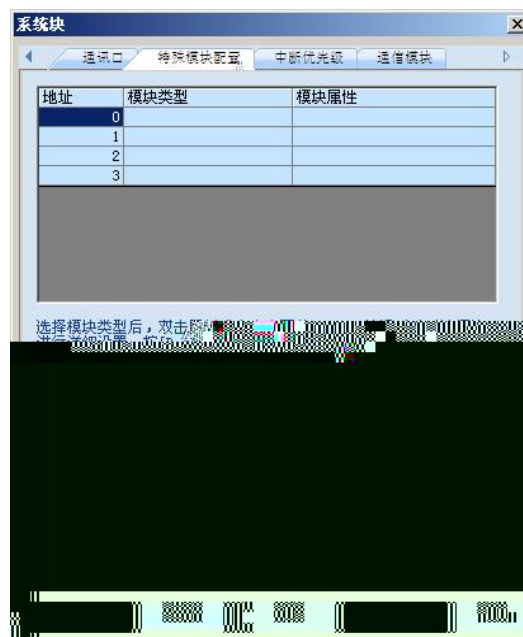
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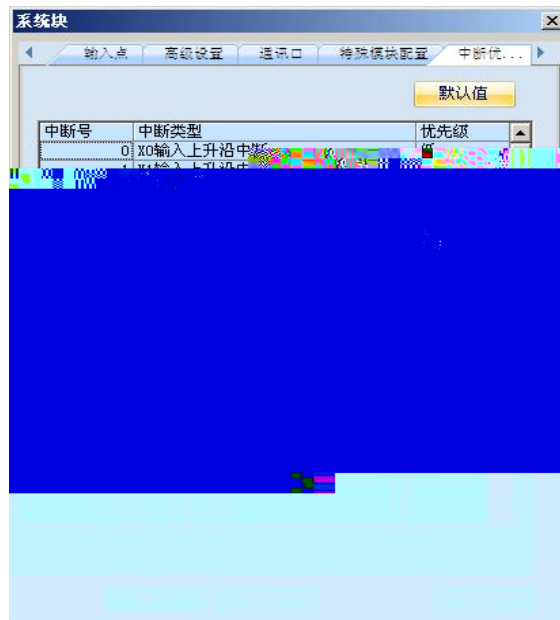


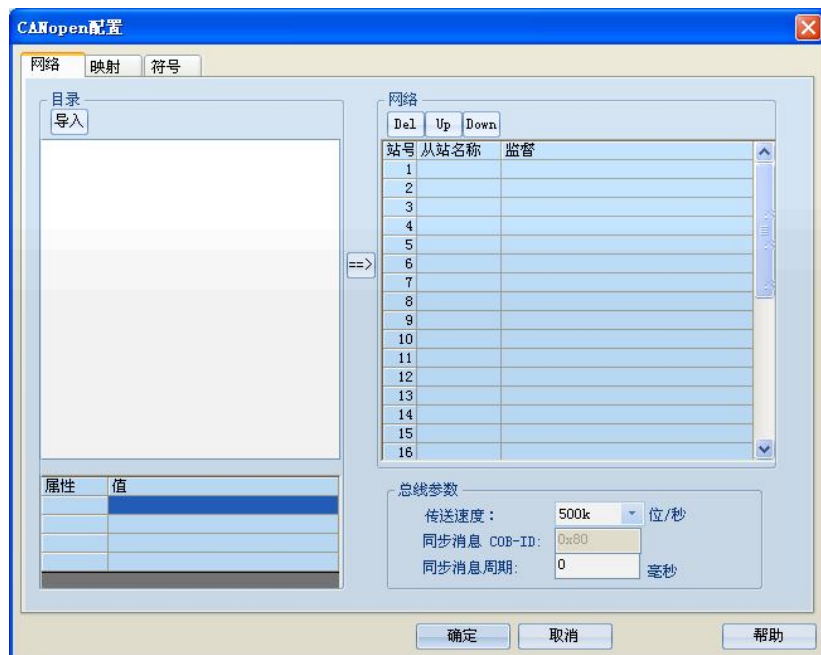
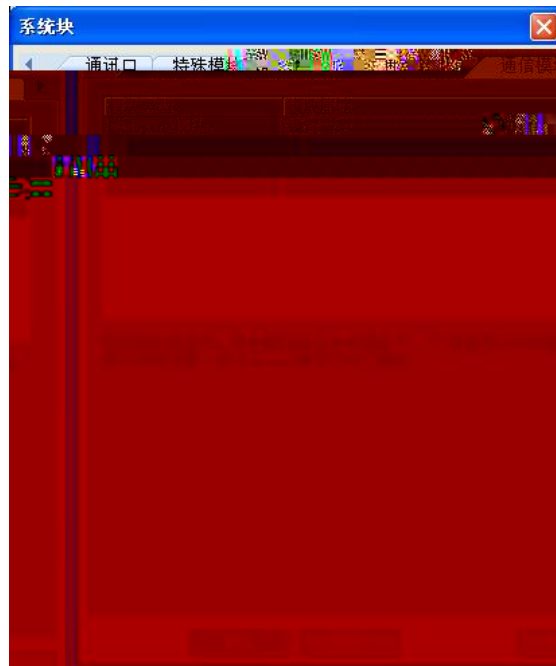












	变量名	变量地址	注释
1	正向定位控制	X4	正向定位控制
2	反向点动	X3	反向点动
3	正向点动	X2	正向点动
4	原点回归	X1	原点回归
5	停止按钮	X0	停止按钮

信息输出

编译 通讯 查找

- M

- B W @-(£5C ^~



SR



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PLC->



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	



RAM

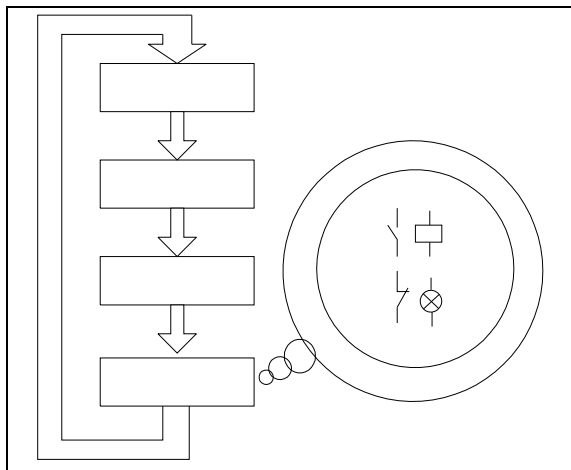
MC **FLC**

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21.2 PLC

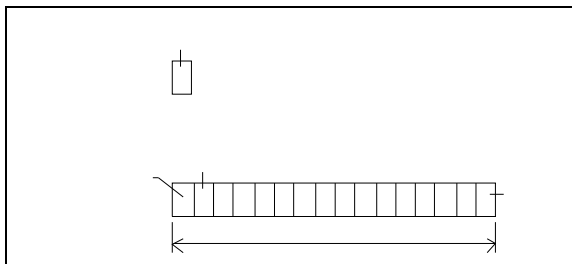
.....
.....



221		



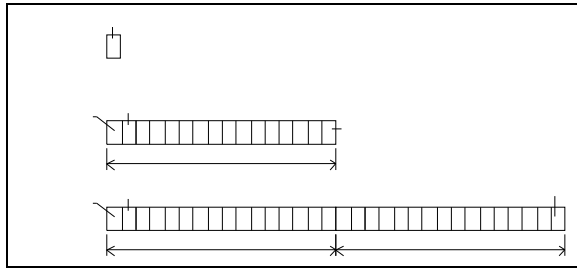
221		



	100ns
	10ns
	1ns

221		





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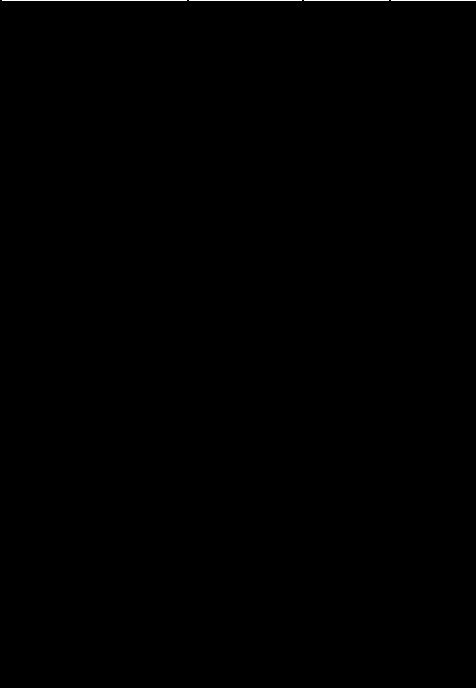
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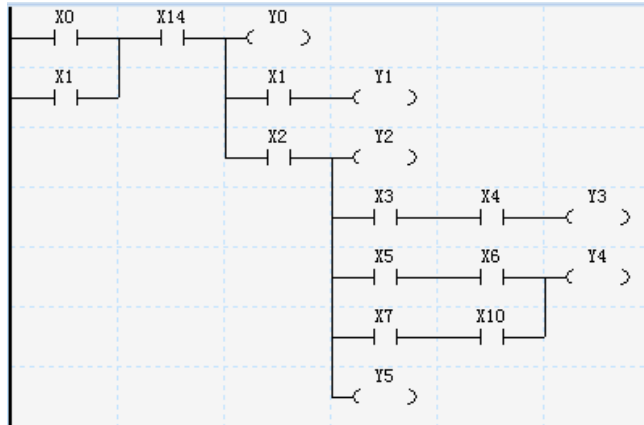
" "

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x

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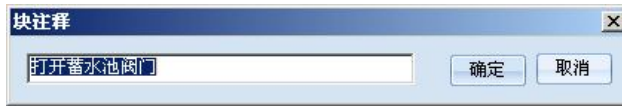
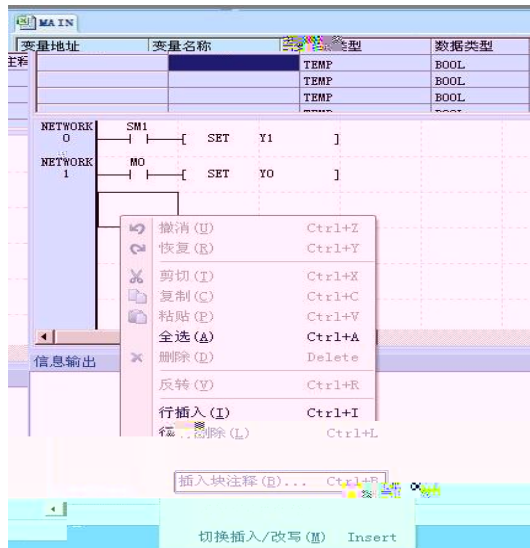
```
/*用户程序运行第一个周期，激活S0步进状态*/
SM1  | | [ SET S0 ]

/*步进状态S0的处理*/
S0   < S > | | Y0 < >
      | | M0 | | [ SET S20 ]

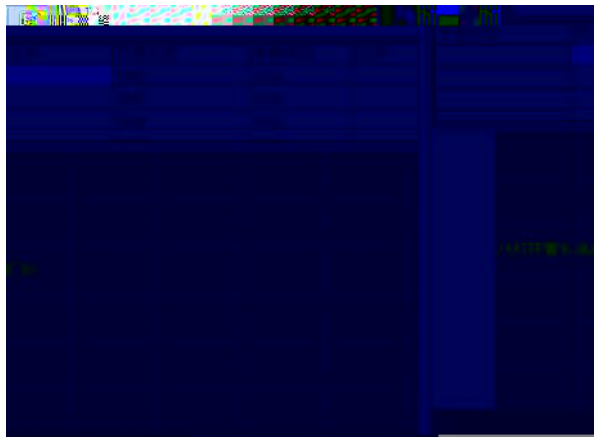
/*步进状态S20的处理*/
S20  < S > | | Y1 < >
      | | M1 | | S0 < >

[ RET ]
```



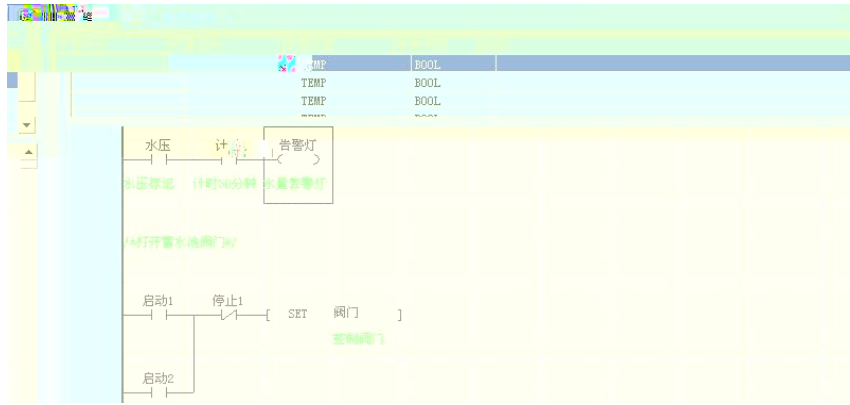


“ ” “ ”



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	Y0	水量告警灯
7	报警灯	Y1	报警灯



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8X'o™ 2r ¥6

The screenshot shows a software window with a title bar containing 'MAIN *' and 'SBR_1 *'. Below the title bar is a table with the following columns: '变量地址' (Variable Address), '变量名称' (Variable Name), '变量类型' (Variable Type), '数据类型' (Data Type), and '注释' (Comment). The table contains the following data:

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	

Below the table is a ladder logic diagram. It features a normally open contact labeled 'SM0' connected to a coil labeled 'ADD'. The coil is followed by three variable addresses: 'V0', 'V1', and 'V2', all enclosed in square brackets.

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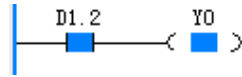
-
- -

MC/MCR

SFC

		M200 M100 M80 M280
		1

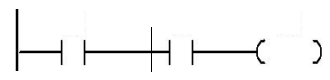
S



		M200 M100 M80 M280
		1

S

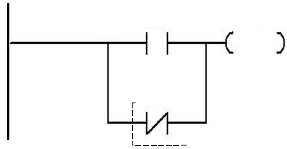
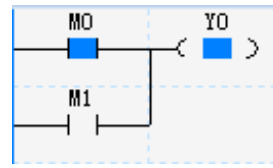


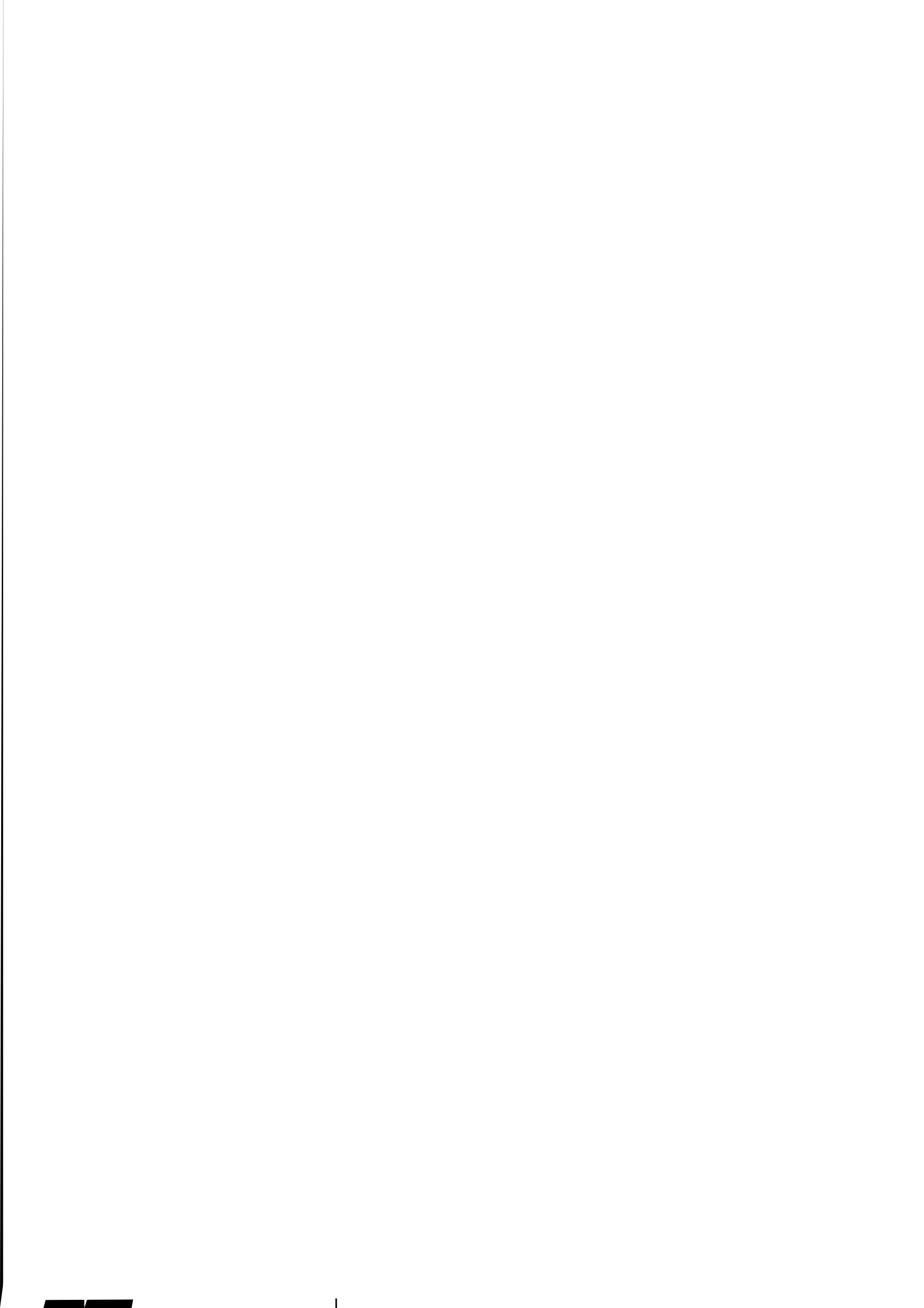


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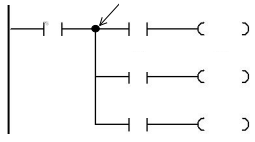
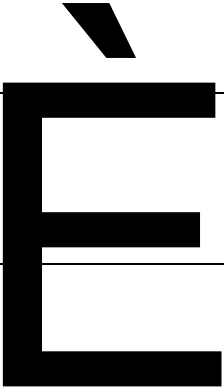
S

" "



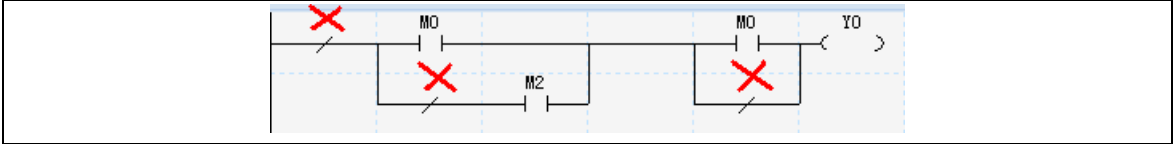


WY' > >PQ

 MPS		M200 M100 M80 M280
		1

/





[] [SET (D)]		M200	M100	M80	M280
SET		1			



[] [RST (D)]		M200	M100	M80	M280
RST		1			

S



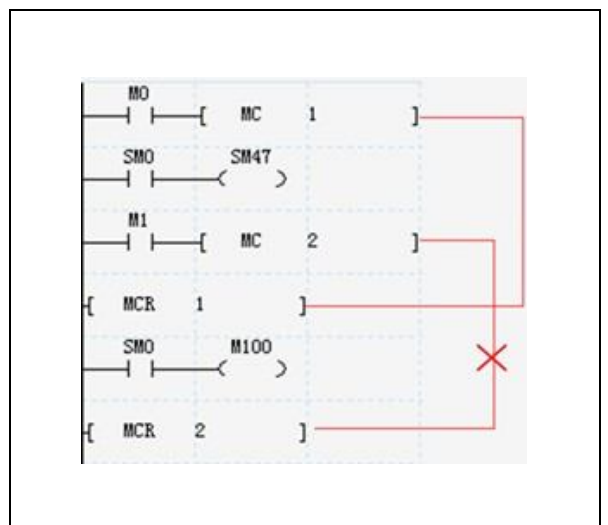
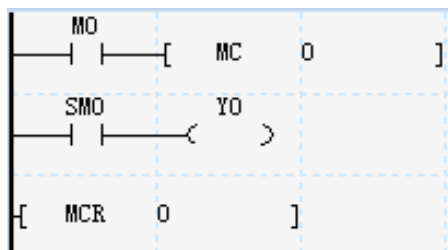
[] [NOP]		M200	M100	M80	M280
NOP		1			

[MC (S) 1]		M200 M100 M80 M280			
MC		3			

S

[MCR (S) 1]		M200 M100 M80 M280			
MCR		1			


S



<S>—		M200 M100 M80 M280
STL		3

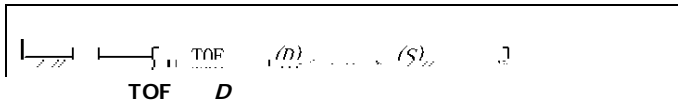
D

[RET]		M200 M100 M80 M280
RET		1

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

D

S

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

		M200 M100 M80 M280	
CTU D S		5	

$\left[\begin{array}{c} \\ \hline \end{array} \right] \left[\begin{array}{c} \\ \hline \end{array} \right] [\text{DCNT } (D) \quad (S)]$		MC200 MC100 M80 MC280
DCNT D S		7



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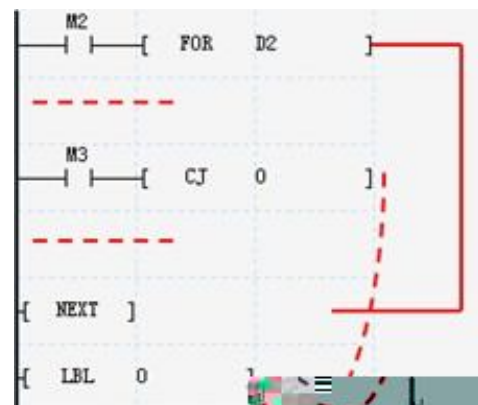
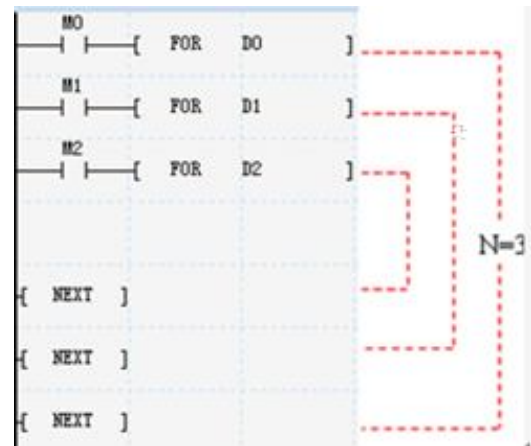
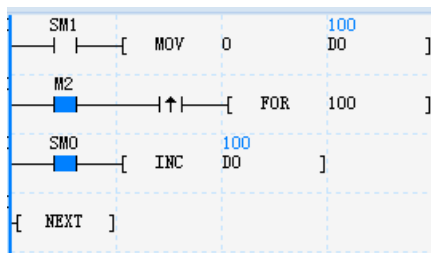


16 4
16 4

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

S

[NEXT]		M200 M100 M80 M280
NEXT		1



```

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

```

```

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

```



		MC200	MC100	MC80	MC280
[LBL (S)				
	LBL S	3			

S

S

S

S

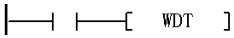
```

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


```

重要的标号定义

— —[CJ (S)]										M200 M100 M80 M280			
CJ S										3			

		M200 M100 M80 M280
WDE0		1

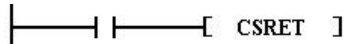


 CALL (子程序名) (参数1) (参数2)		M200	M100	M80	M280
CALL	1	2			

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 CSRET		M200	M100	M80	M280
CSRET		1			

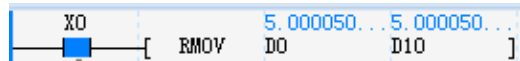
	M200	M100	M80	M280
	5			

500
D10]

	M200	M100	M80	M280
	7			

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

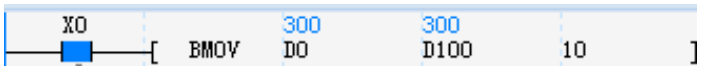
S
D



S
D S

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

S
D



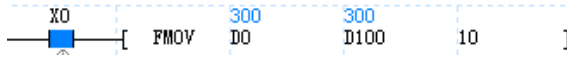
S2

S1
S2 D
S2 S1
S2

										M200 M100 M80 M280					
----- ----- ----- ----- ----- ----- ----- ----- ----- -----															
FMOV S1 D S2										7					

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

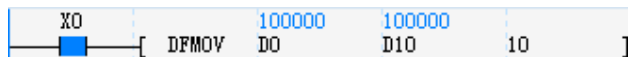
S1
D **S2**
S1



										M200 M100 M80 M280					
----- ----- ----- ----- ----- ----- ----- ----- ----- -----															
DFMOV S1 D S2										9					

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

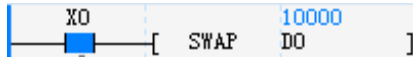
S1
D **S2**
S1



x

.....

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



D

D

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

D1

D2

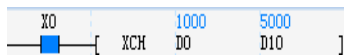
D1

D2

D1 D2

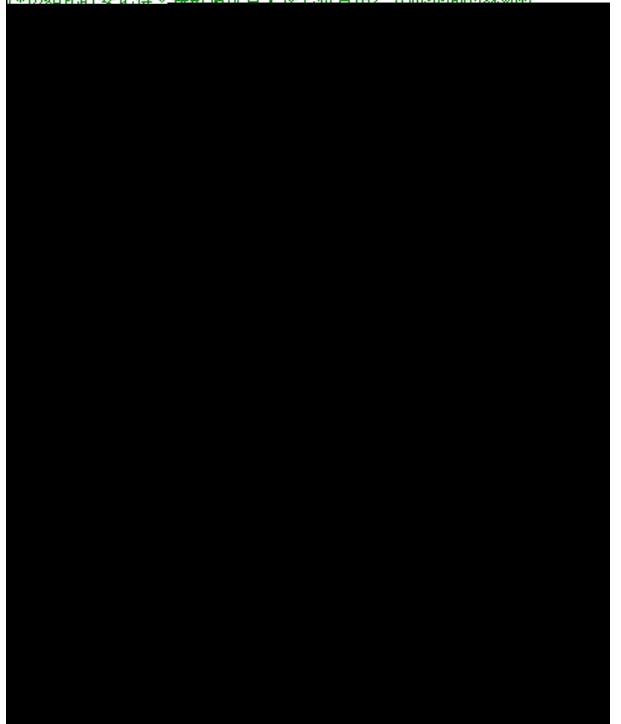
D1

D2



/*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*/

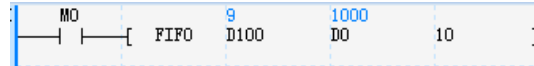


— — —

—

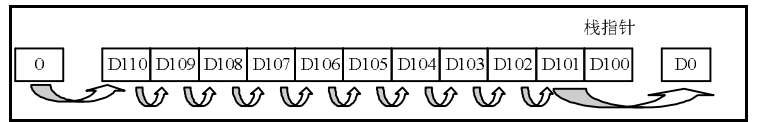
										M200 M100 M80 M280			
FIFO										7			

1



D1 **D1** **D2**
D1 **D1** **S**

D1



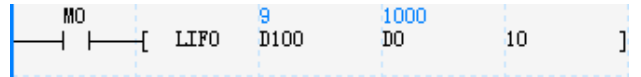
.....

.....

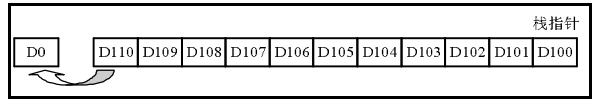
D1

S

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



S



D2 D1
D1

.....

.....

D1

S

M200 M100 M80 M280

|—| |—| [WSFR (S1) (D) (S2) (S3)]

MC200

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

										M200 M100 M80 M280					
MUL S1 S2 D										8					

S1

S2

D

X0	MUL	1000	2000	2000000
<input checked="" type="checkbox"/>		D0	D1	D10

S1 S2 D

										M200 M100 M80 M280					
DIV S1 S2 D										7					

S1

S2

S2

D

X0	DIV	2500	1000	2
<input checked="" type="checkbox"/>		D0	D1	D10

S1 S2 D

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

S
D

S

S
D
D

X0	1000	31
[SQT	D0	D10]

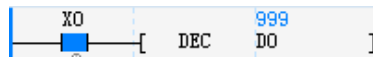
Ä
A

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

— — [DEC (D)]										M200 M100 M80 M280			
DMC D										3			

D

D



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

S

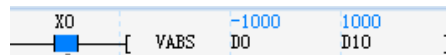
S

S

D

S

D



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

S

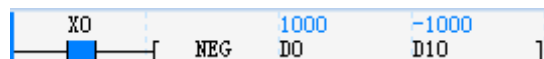
S

S

D

S

D



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

S1
S2
D

X0	100000	200000	-100000	
[DSUB	D0	D2 D10]

S1 S2 D
D

— [DMUL (S1) (S2) (D)]

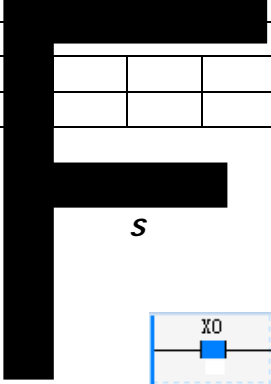
DMUL S1 S2 D

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



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

S \$Ä ò•™ó•&&5 ì
D



X0	83000	288
[DSQT DO D10]		

S
D S

"ó. ñ•00010t™"

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

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

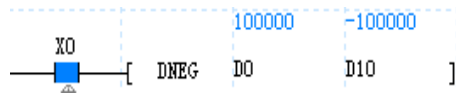
										M200 M100 M80 M280					
— — [DNEG (S) (D)]															
DNEG S D										7					

S
D

S

S

D S



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

S1
S2
D

S1 S2
D

S2

S0	[DMOV 100000 D0]	100000	D0
	[DMOV 200000 D2]	200000	D2
	[DMOV 300000 D4]	300000	D4
	[DMOV 400000 D6]	400000	D6
	[DMOV 500000 D8]	500000	D8
X0	[DSUM D0 5 D100]	100000	1500000

×

.....

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

S1
S2
D

S1 S2
D
D

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

— — [RSUB (S1) (S2) (D)]										M200 M100 M200 1			0	
R50B S1 S2										10				

S1

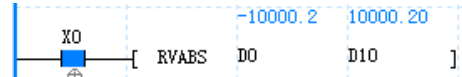
S2

D

1

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

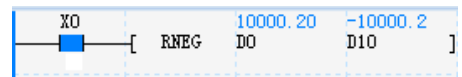
S
D



S D

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

S
D

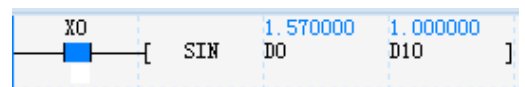


S D

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

D

S
D



S
D

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

S
D

X0	[COS	3.140000	-1.00000]
			D0	D10	

S

D

D

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

S
D

X0	[TAN	1.570000	1255.848]
			D0	D10	

S

D

D

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

S
D

X0	[EXP	10.00000	22026.46]
		DO	D10		

(

5

S
D
D

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

S1
S2
D

S1 S2

F 4'hr #q 9 CE D

S2

— — [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

— — [DEG (S) (D)]		M280
S D		7

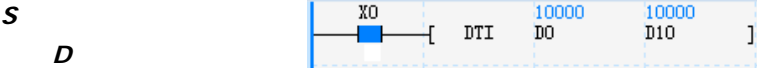
\$Àc*ý Œc+i`

				LMW

	8421BCD	

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

S S S D
D



— — [INT (S) (D)]											M200 M100 M280					
INT S D											6					

S
D

S D S D

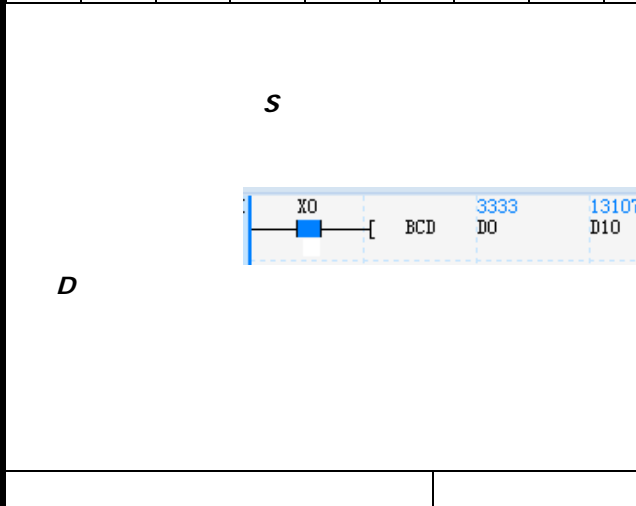
S
D

X0	10000.50	10000
— [INT D0 D10]		

M200 M100 M280

|—| |—| [DINT (S) (D)]

— — [BCD (S) (D)]											
BCD S D											



7	

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

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

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

S
D

X0	43690	65535
[GRY DO D10]		

S
D

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

S
D

XO	3435973836	2290649224
<input checked="" type="checkbox"/>	[DGBIN DO	D10]

S
D

— — [SEG (S) (D)]										M200 M100 M80 M280			
------------------------	--	--	--	--	--	--	--	--	--	--------------------	--	--	--

				M200 M100 M80 M280																			
— — [ASC (S1~S8) (D)]																							
ASC S1 S8 D				19																			

79=

MO	[ASC	12345678	12849	DO]
----	---	-----	----------	-------	----	---

S1 S8
D
D
D0³
D1
D2 / D4 2
D1
D2
D2

ITA (S1) (D) (S2)]

M200 M100 M80 M280

										M200 M100 M80 M280				
— — [ATI (S1) (D) (S2)]														
ATI S1 D S2										7				
	WORD													
	WORD													
	WORD													

'!B*δ@δ ™€ pVY '÷@

S1

S1

S1

f

S1 M0?±**S1**

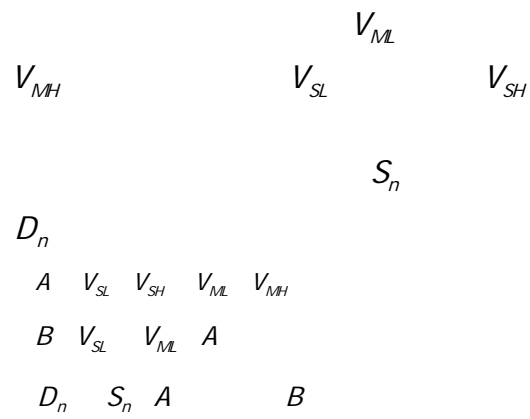
V_{ML} V_{MH} V_{SL} V_{SH}

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	
[REDACTED]			



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

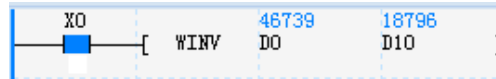
S1
S2
D



S1 S2
D

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

S
D



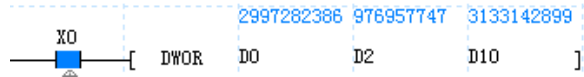
S
D

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

[DWOR (S1) (S2) (D)]										MC200 MC100 M80 M280				
DWOR S1 S2 D										10				

D

S1
S2
D



S1 S2

[DWXOR (S1) (S2) (D)]										MC200 MC100 M80 M280				
DWXOR S1 S2 D										10				

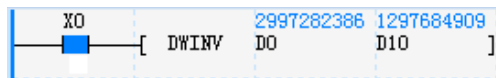
S1
S2
D



S1 S2
D

[DWINV (S) (D)]										MC200 MC100 MC80MC280				
DWMNV S D										7				

S
D



S
D

— — [ROR (S1) (D) (S2)]										MC200 MC100 MC80MC280					
										SM181					
ROR S1 D S2										7					

S1

D

S2

S1

S2

D

[ROL (S1) (D) (S2)]										MC200 MC100 MC80MC280				
										SM181				
ROL S1 D S2										7				

S1

D

S2

S2 S1 D
 Ü (

— — [RCL (S1) (D) (S2)]		MC200 MC100 MC80MC280
		SM181
RCL S1 D S2		7

[DROL (S1) (D) (S2)]										MC200 MC100 MC80MC280									
										SM181									
DROL S1 D S2										9									

S1
D
S2

MO	3013123244 753280811	
[DROL DO D10 30]		

S1
S2 D

[DROR (S1) (D) (S2)]										MC200 MC100 MC80MC280									
										SM181									
DROR S1 D S2										9									

S1
D
S2

MO	3013123244 722891539	
[DROR DO D10 11]		

S1
S2
D

MO										MC200 MC100 MC80MC280									
[DRCL (S1) (D) (S2)]										SM181									
DRCL S1 D S2										9									

S1
D
S2

MO										3013123244 1488165020									
[DRCL D0 D10 25]																			

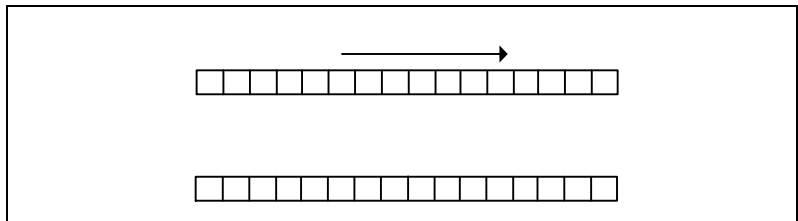
S1
S2
D

MO										MC200 MC100 MC80MC280									
[SHR (S1) (D) (S2)]																			
SHR S1 D S2										7									

S1
D
S2

MO										31452 982									
[SHR D0 D10 5]																			

S1
S2
S2
S1

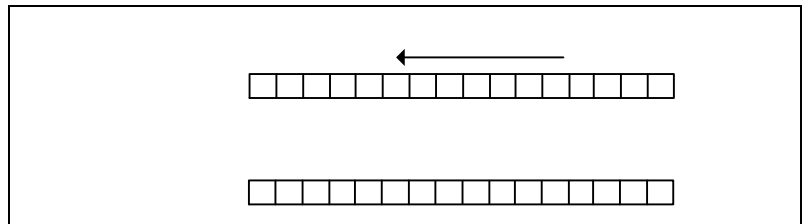


[SHL (S1) (D) (S2)]		MC200 MC100 MC80MC280	
SHL S1 D S2		7	

S1
D
S2

S2

S2



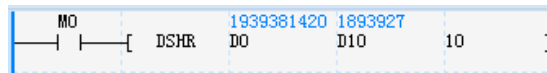
S1
D

[DSHR (S1) (D) (S2)]		MC200 MC100 MC80MC280	
DSHR S1 D S2		9	

S1
D
S2

S2

S2 S1

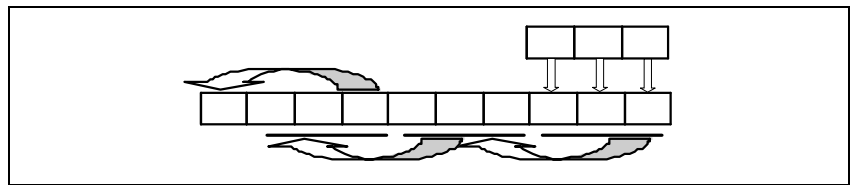


S1
D

[SFTL (S1) (D) (S2) (S3)										MC200 MC100 MC80MC280					
SFTL S1 D S2 S3										9					

S1
D
S2
S3

```
MO | | [ SFTL ON ON 10 3 ]
      XO M10
```



S2 S3

 D

S2 S3

 S3

 S1

S3

[REDACTED]										MC200		MC280							
FROM										S1	S2	D	S3						
														9					

S1

S1

S2

S3

D

S3

S2

S3

```

MO [ FROM 0 3 997 D100 2 ]

```

D

S3

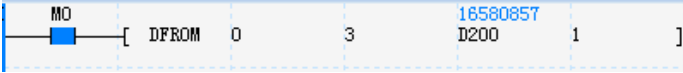
----- ----- ----- ----- ----- ----- ----- ----- ----- -----										MC200 MC280									
[DFROM (S1) (S2) (D) (S3)]																			
DFROM S1 S2 D S3										10									

S1

S1 S2 S3
D S3


S2

S3



D

S3

 [TO (S1) (S2) (S3) (S4)]		MC200 MC280
TO S1 S2 S3 S4		9

S1

S3 S4

S1

S2 S4

S2

S4

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

S3

S4

[DTQ (S1) (S2) (S3) (S4)]										MC200 MC280				
DTQ S1 S2 S3 S4										10				

S1 S3 S4 S1

S2 S4

S2 S4

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

S3
S4

[VRRD (S) (D)]										MC200 MC100				
VRRD S D										5				

S

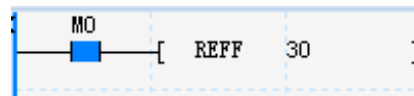
D

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

— — [REFF (S)]										MC200 MC100 MC80 MC280			
REF S										3			

S

-
-

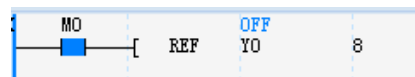


— — [REF (D) (S)]										MC200 MC100 MC80 MC280			
REF D S										5			

D

S

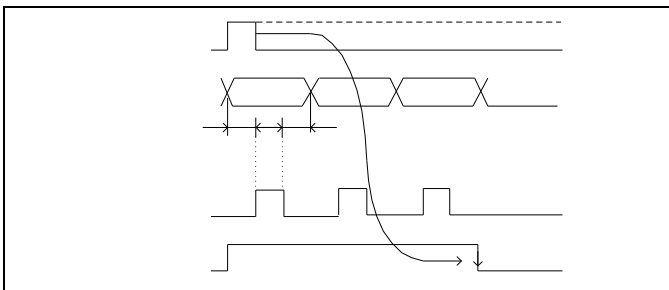
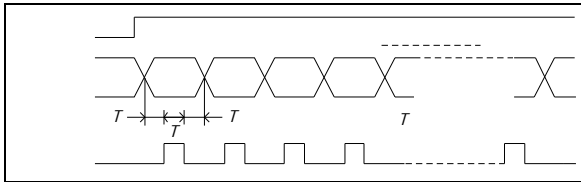
.....

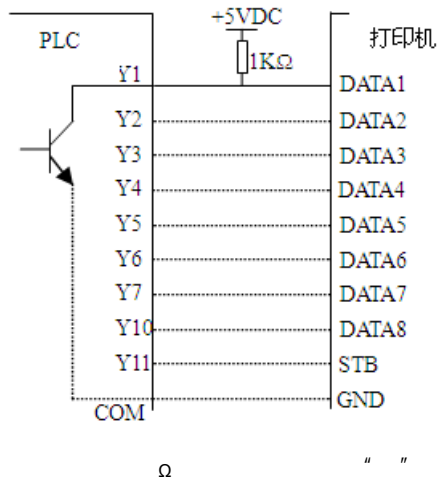


— — [EROMWR (S1) (S2)]		MC200 MC100 MC280	
EROMMR S1 S2		6	

[FR]		MC200 MC280	
PR (S) (D)		5	

S
D






```

/*打印前数据取反*/
SM1 [ MOV 0 Z0 ]
SM1 [ FOR 8 ]
SM0 [ WINV DOZO DOZO ]
[ INC Z0 ]
[ NEXT ]
/*由MO控制打印*/
MO [ PR DO Y1 ]

```

		MC200 MC100 MC280
TWR S		3

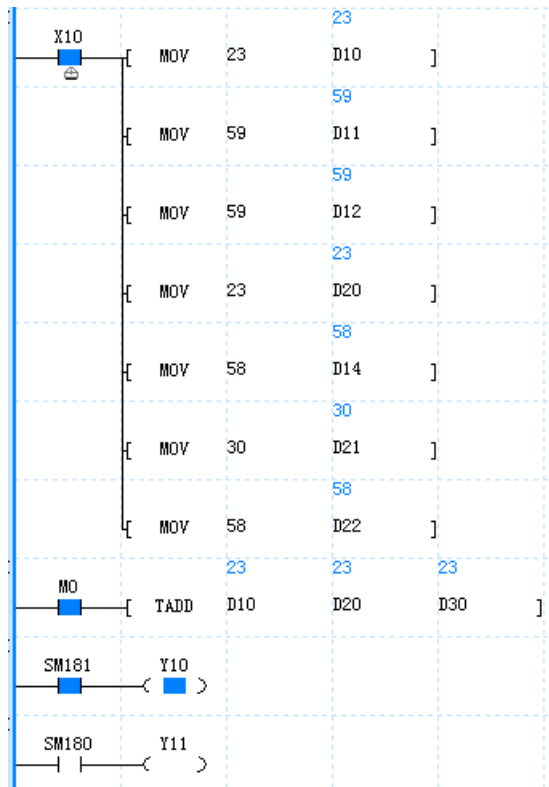
[TADD (S1) (S2) (D)]										MC200 MC100 MC280	
										SM180 SM181	
TADD S1 S2 D										7	

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

S1
S1

S2
S2

D
D



" "
" "
" "

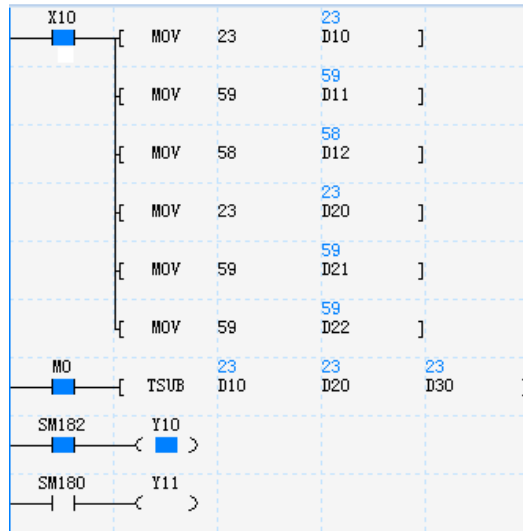
[TSUB (S1) (S2) (D)]										MC200 MC100 MC80	
										SM180 SM182	
TADD S1 S2 D										7	

S1
S1

S2
S2

D

D



" "

" "

" "

[HOUR (S) (D1) (D2)]										MC200 MC100 MC280	
HOUR S D1 D2										8	

D1

S

D2

D1

D1

D1

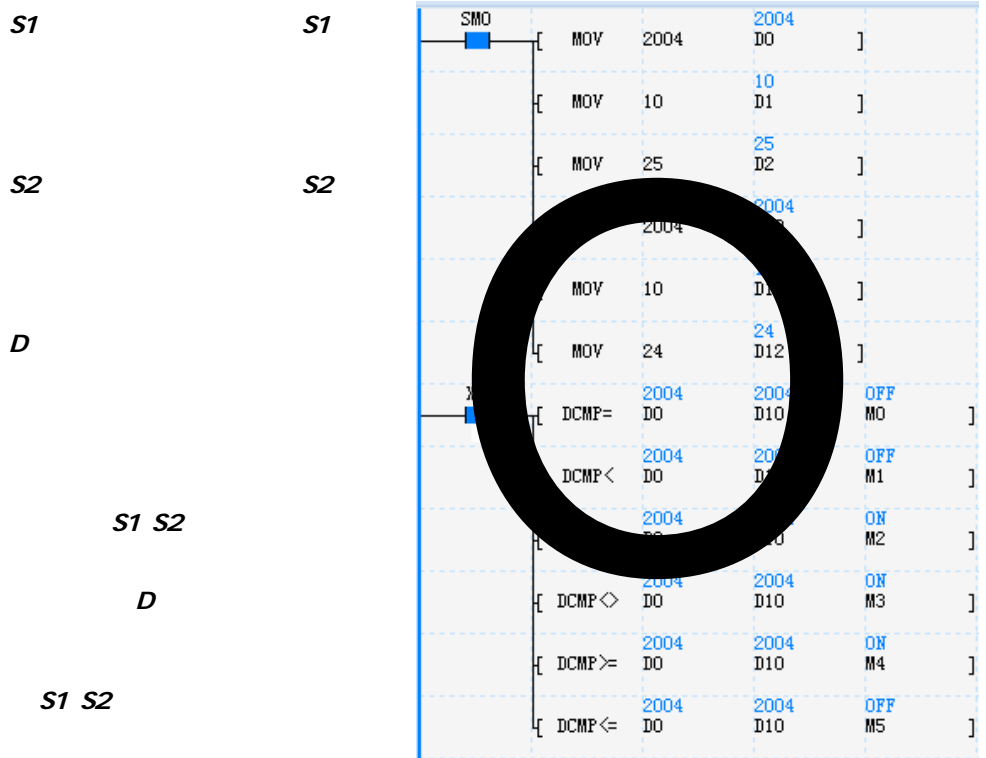
D2

D1

S

M0	[MOV	1000	1000	D100]
M1	[HOUR	1000	0	D200	OFF M10
M10	(YO)			

				MC200	MC100	MC280
[—	DCMP=	(S1) (S2) (D)			
[—	DCMP<	(S1) (S2) (D)			
[—	DCMP>	(S1) (S2) (D)			
[—	DCMP<>	(S1) (S2) (D)			
[—	DCMP>=	(S1) (S2) (D)			
[—	DCMP<=	(S1) (S2) (D)			
DCMP	S1	S2	D			
DCMP	S1	S2	D			
DCMP	S1	S2	D			
DCMP	S1	S2	D			
DCMP	S1	S2	D			
DCMP	S1	S2	D			



<table border="0"> <tr><td> </td><td> </td><td>[</td><td>TCMP=</td><td>(S1)</td><td>(S2)</td><td>(D)</td><td>]</td></tr> <tr><td> </td><td> </td><td>[</td><td>TCMP<</td><td>(S1)</td><td>(S2)</td><td>(D)</td><td>]</td></tr> <tr><td> </td><td> </td><td>[</td><td>TCMP></td><td>(S1)</td><td>(S2)</td><td>(D)</td><td>]</td></tr> <tr><td> </td><td> </td><td>[</td><td>TCMP<></td><td>(S1)</td><td>(S2)</td><td>(D)</td><td>]</td></tr> <tr><td> </td><td> </td><td>[</td><td>TCMP>=</td><td>(S1)</td><td>(S2)</td><td>(D)</td><td>]</td></tr> <tr><td> </td><td> </td><td>[</td><td>TCMP<=</td><td>(S1)</td><td>(S2)</td><td>(D)</td><td>]</td></tr> </table>			[TCMP=	(S1)	(S2)	(D)]			[TCMP<	(S1)	(S2)	(D)]			[TCMP>	(S1)	(S2)	(D)]			[TCMP<>	(S1)	(S2)	(D)]			[TCMP>=	(S1)	(S2)	(D)]			[TCMP<=	(S1)	(S2)	(D)]		MC200 MC100 MC280
		[TCMP=	(S1)	(S2)	(D)]																																											
		[TCMP<	(S1)	(S2)	(D)]																																											
		[TCMP>	(S1)	(S2)	(D)]																																											
		[TCMP<>	(S1)	(S2)	(D)]																																											
		[TCMP>=	(S1)	(S2)	(D)]																																											
		[TCMP<=	(S1)	(S2)	(D)]																																											
<table border="0"> <tr><td>TCMP</td><td>S1</td><td>S2</td><td>D</td></tr> <tr><td>TCMP</td><td>S1</td><td>S2</td><td>D</td></tr> <tr><td>TCMP</td><td>S1</td><td>S2</td><td>D</td></tr> <tr><td>TCMP</td><td>S1</td><td>S2</td><td>D</td></tr> <tr><td>TCMP</td><td>S1</td><td>S2</td><td>D</td></tr> <tr><td>TCMP</td><td>S1</td><td>S2</td><td>D</td></tr> </table>	TCMP	S1	S2	D	TCMP	S1	S2	D	TCMP	S1	S2	D	TCMP	S1	S2	D	TCMP	S1	S2	D	TCMP	S1	S2	D		7																								
TCMP	S1	S2	D																																															
TCMP	S1	S2	D																																															
TCMP	S1	S2	D																																															
TCMP	S1	S2	D																																															
TCMP	S1	S2	D																																															
TCMP	S1	S2	D																																															

----- ----- HTOS (S) (D) 1		MC280
HTOS (S) (D)		5

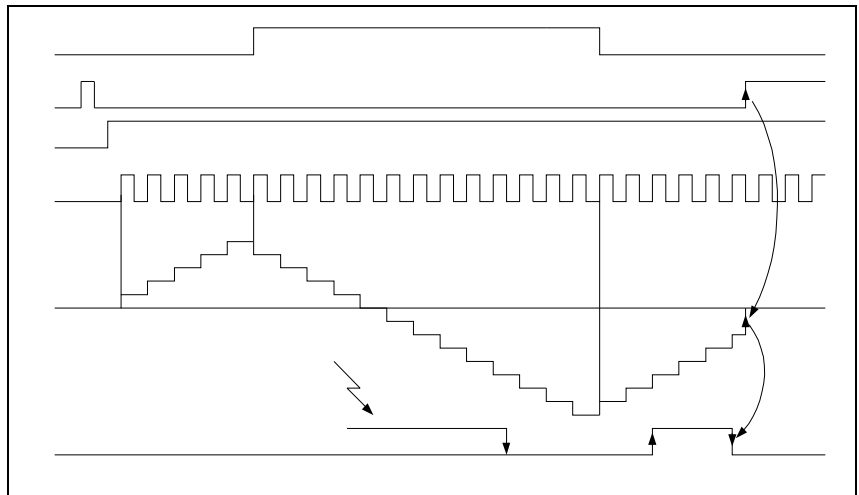
[HCNT (D) (S)]										MC200 MC100 MC80MC280									
HCNT D S										7									

D

S

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

S



— — [DHSCS (S1) (S2) (D)]										MC200 MC100 MC80 MC280			
DHSCS S1 S2 D										10			

S1



S2

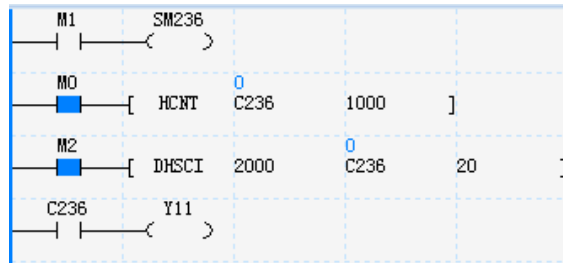
D

--- --- [DHSCI (S1) (S2) (S3)]										MC200 MC100 MC80 MC280			
DHSCI S1 S2 S3										10			

S1

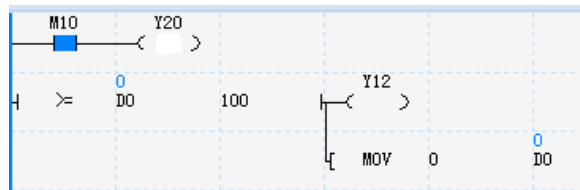
S2

S3



S1

S3



[DHSPI (S1) (S2) (S3)]										MC280				
DHSPI S1 S2 S3										10				

S1

q87™€ LER]ÖyP 7' L7 •™ TE9R]ØFQñ ñ%™,™„XFA° ž' ñ%™û {ë" E³>B ' 'À™€ xE„d 'T.ñ%™

S2

S3

Ö73B* 9™# @ ÁN™ c%9R Ä



— — [DHSCR (S1) (S2) (D)]										MC200 MC100 MC80 MC280			
DHSCR S1 S2 D										10			

S1

S2

D

P

S2

È

S1 D

										MC200 MC100 MC80 MC280										
DHSZ	(S1)	(S2)	(S3)	(D)																
DHSZ	S1	S2	S3	D																

S1

S2

S3

D

— — [DHST (S1) (S2) (S3)]										MC200 MC100 MC80 MC280				
DHST S1 S2 S3										10				

S1

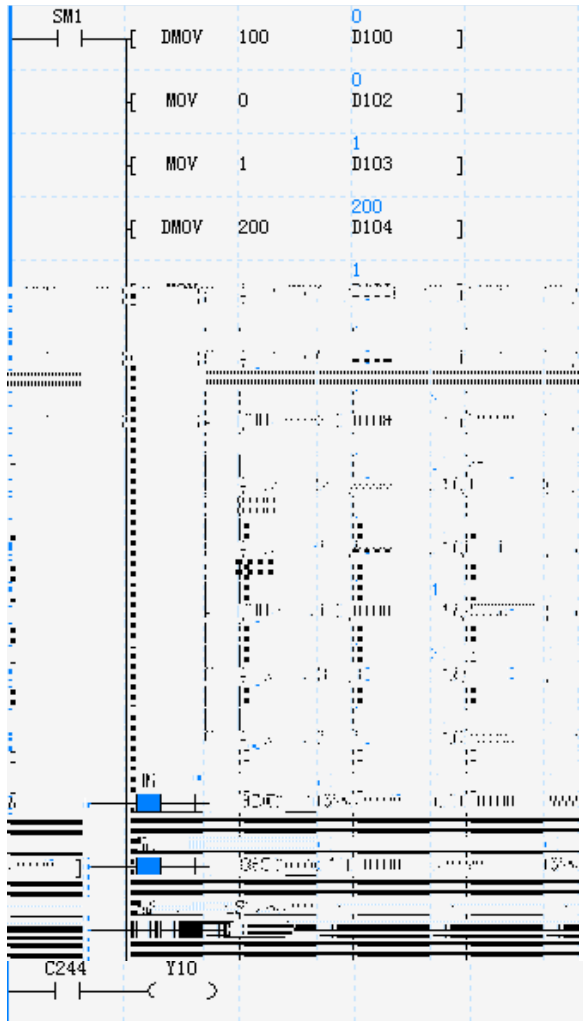
S2

S3

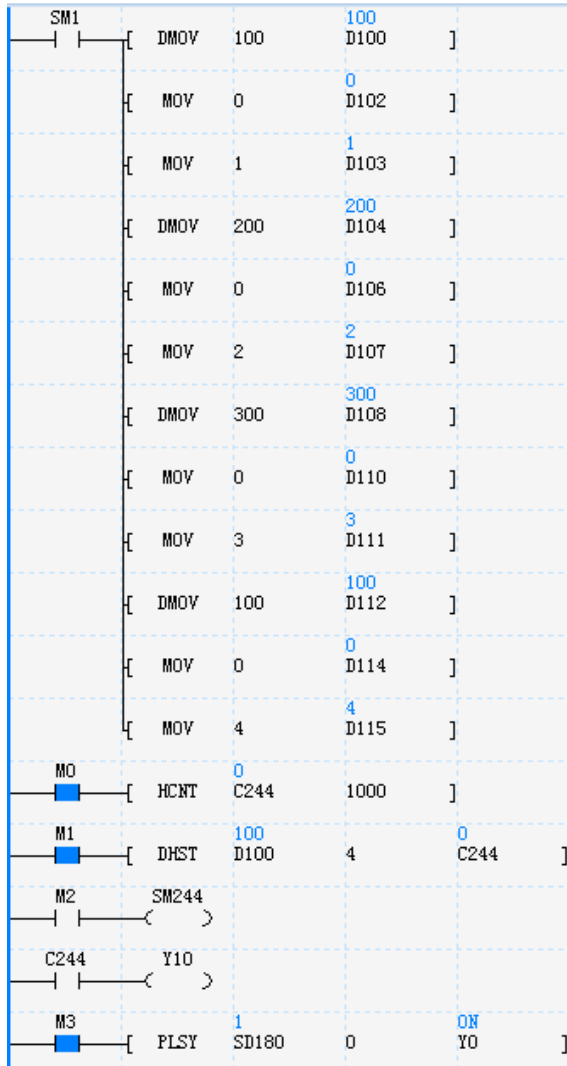
Y

Y

Y

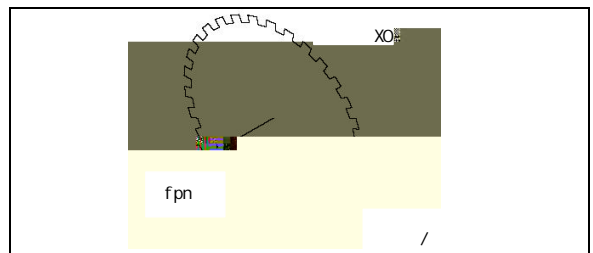
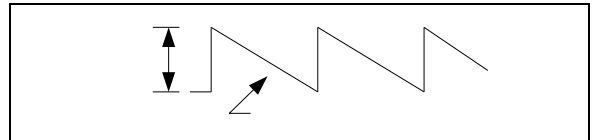


MC280



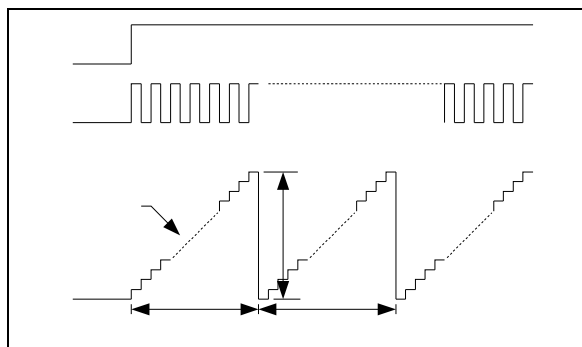
										MC200 MC100 MC80 MC280			
— — [SPD (S1) (S2) (D)]													
SPD S1 S2 D										7			

S1
S2
D



610 10

SMD	[PLSY	10000	0	ON YO
MO	[SPD	ON XO	1000	10000 D10



--- --- [PLSY (S1) (S2) (D)]										MC200 MC100 MC80 MC280			
PLSY S1 S2 D										9			

S1

S1

S1

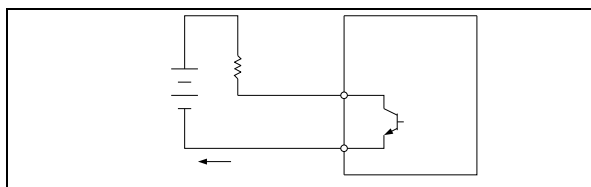
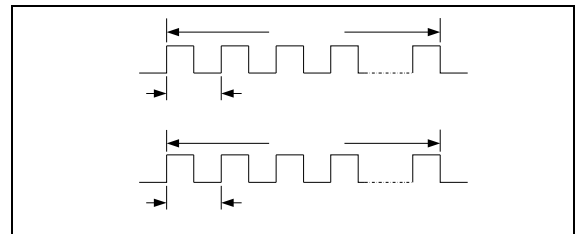
S2

S2

S2

D

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



" x x x x " x "

PLSR (S1) (S2) (S3) (D)										MC200 MC100 MC80 MC280										
PLSR	S1	S2	S3	D																



S1

S1

S2

D

S3

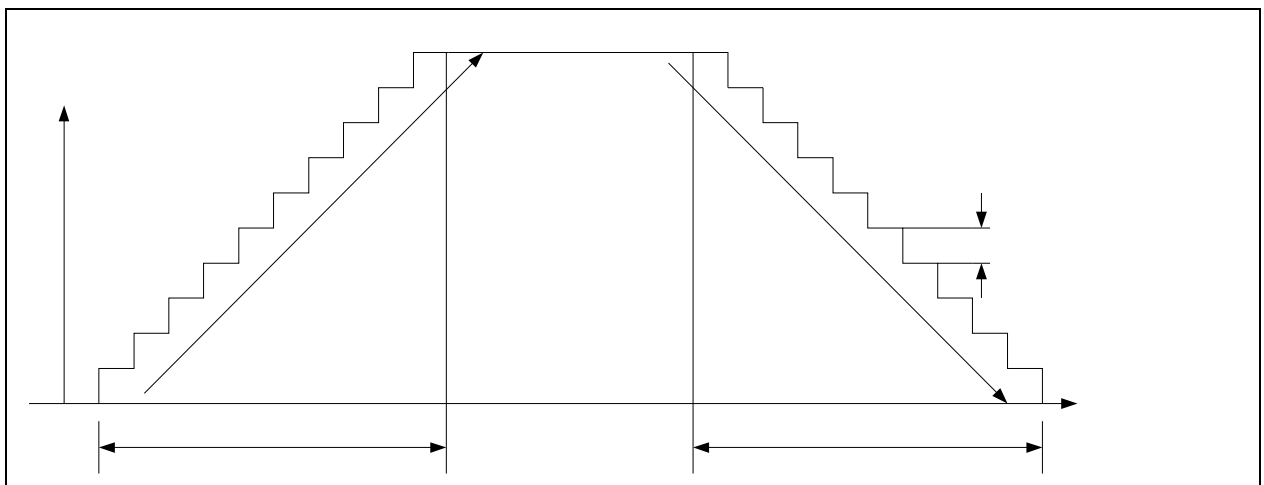
S1 x S3

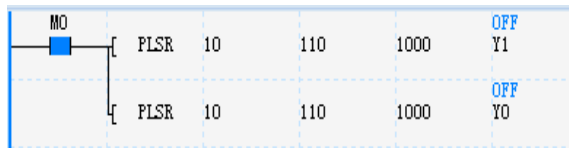
S3

S1

S1 x S3 x

S3 x S1





x x x x x x x x

— — [PLS (S1) (S2) (D1)]										MC200 MC100 MC280					
PLS S1 S2 D1										7					

S1
S2
D

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

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

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

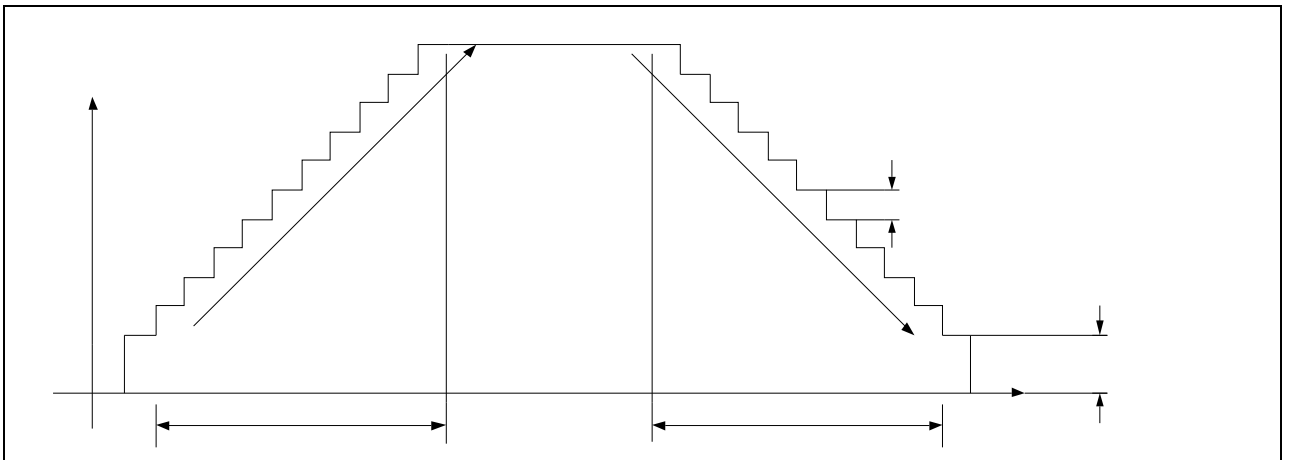
F

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

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

.....

										MC100 MC280							
PLSB (S1) (S2) (S3) (S4) (D)										12							



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

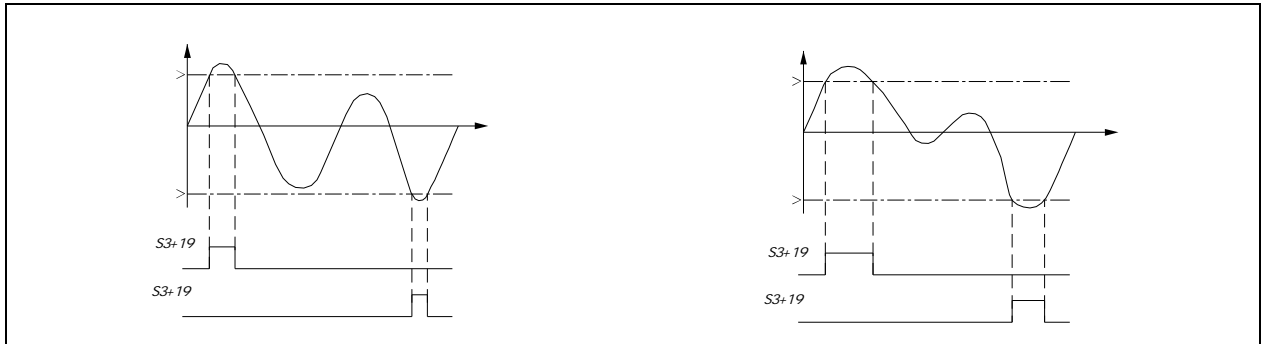
x x x

x

x x x

x

										MC200 MC100 MC80 MC280				
— — [PID (S1) (S2) (S3) (D)														
PID S1 S2 S3 D										9				



	$\Delta MV = KP \left\{ (EV_n - EV_{n-1}) + \frac{T_s}{T_I} EV_n + D_n \right\}$ <p style="text-align: center;">_____</p>
	$\Delta MV = KP \left\{ (EV_n - EV_{n-1}) + \frac{T_s}{T_I} EV_n + D_n \right\}$ <p style="text-align: center;">_____</p>

x

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	D500	D501	D510	D502	24349]
	[TO	0	8	24349	D502	1]			

D

S3

S3 15 S3

18

S3 1

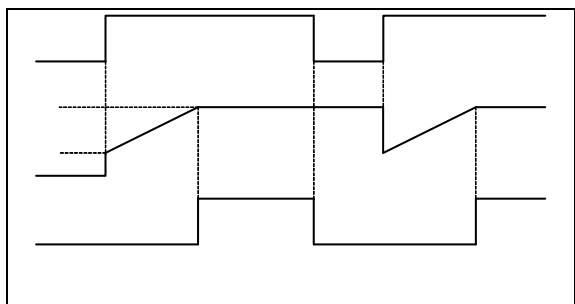
S3 S3 6

[RAMP (S1) (S2) (D1) (S3) (D2)]							MC200 MC100 MC80 MC280								
RAMP S1 S2 D1 S3 D2							12								

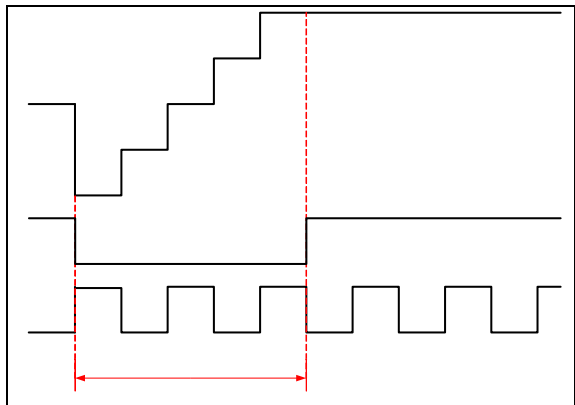
S1
S2
D1
S3 S3
D2

" "

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 ]

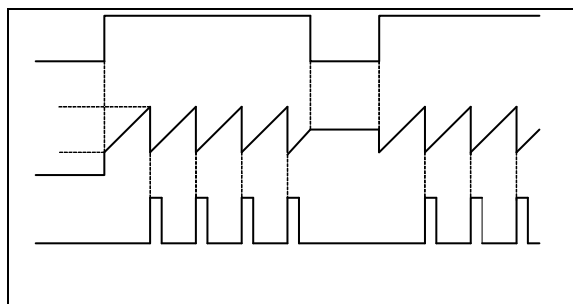
```

D1 D2

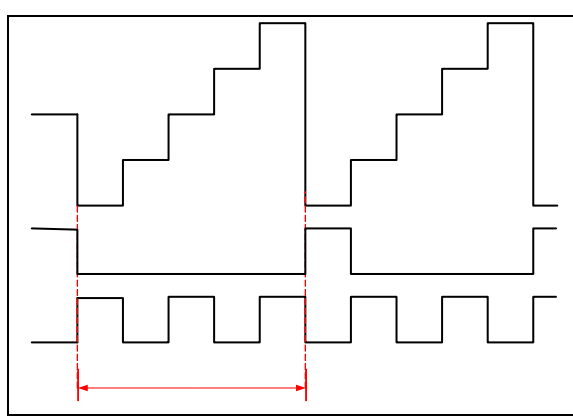
						MC200 MC100 MC80 MC280			
HACKLE S1 S2 D1 S3 D2						12			

S1 " "
 S2 " "
 D1 S1 S2 D1 S2 D2
 S3 S3
 D2

S1 D1 S2
 S1 D2 D2
 D2 D1 D1
 S1



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



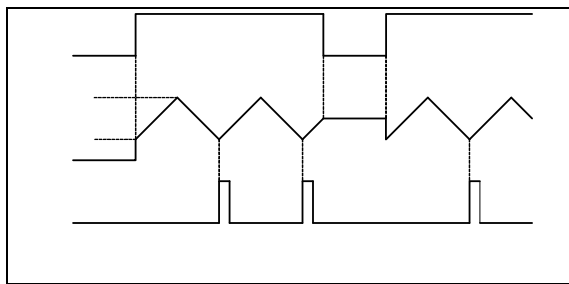
D1 D1 S1 D2

[TRIANGLE (S1) (S2) (D1) (S3) (D2)]						MC200	MC100	MC80	MC280
TRIANGLE	S1	S2	D1	S3	D2	12			

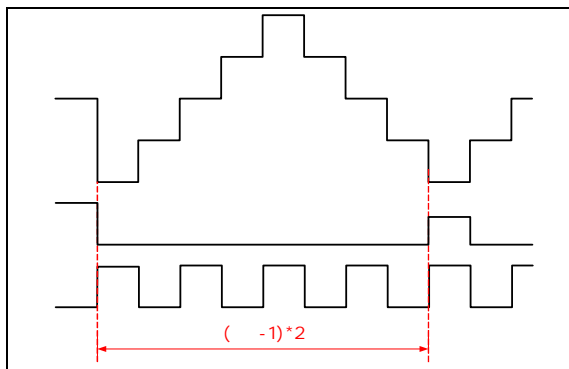
S1
S2
D1
S3
D2

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	D0	2000	D1	1364	D10	1000	OFF	MO]
X1	[TO	0	1	1364	D10	1]	

D2 D1 D1 S1

[ABSD]		MC200 MC280	
ABSD (S1) (S2) (D) (S3)		9	

S1

S2

D

S3

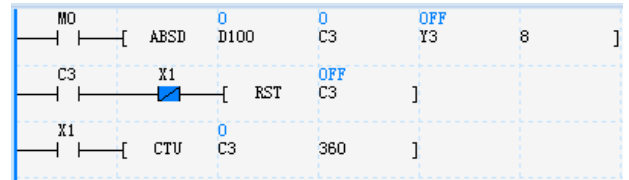
S3

S1

S2

x
D

S1 S1 x

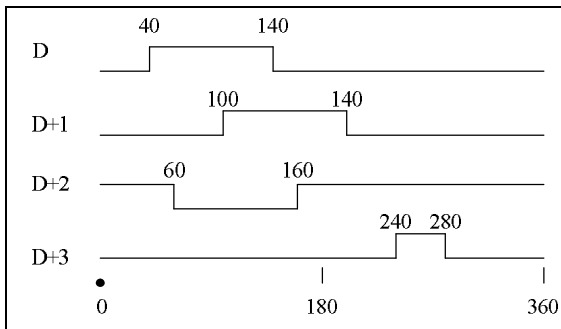


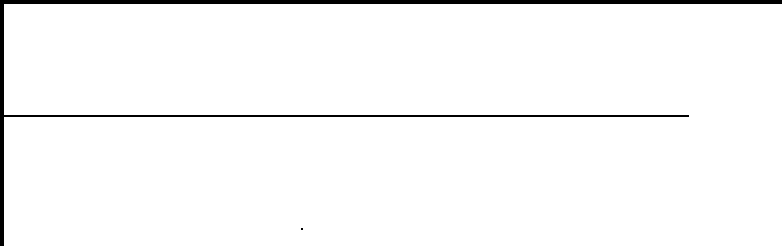
S1

S2

S1		S1		D
S1		S1		D
S1		S1		D
S1		S1		D
S1		S1		D

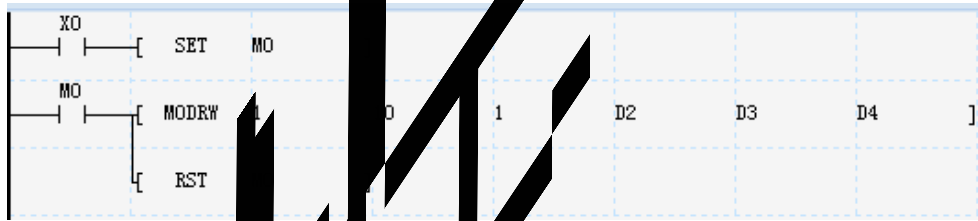
D





— — [ALT]		MC200 MC280
ALT <i>D</i>		11

|—|—|



SM30

SM135

T1

帧间间隔

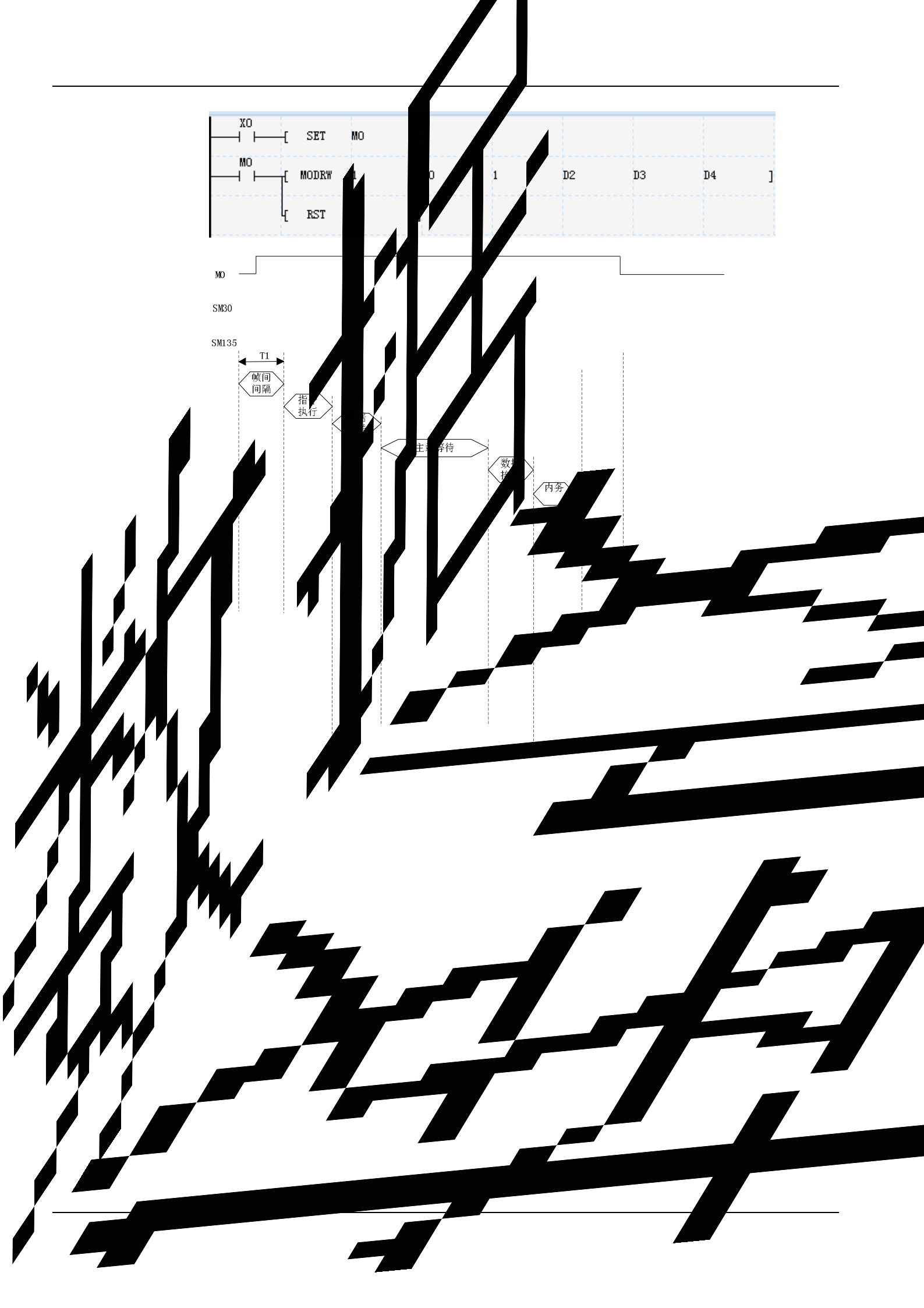
指令执行

数据接收

主站等待

数据发送

内务



T — ms

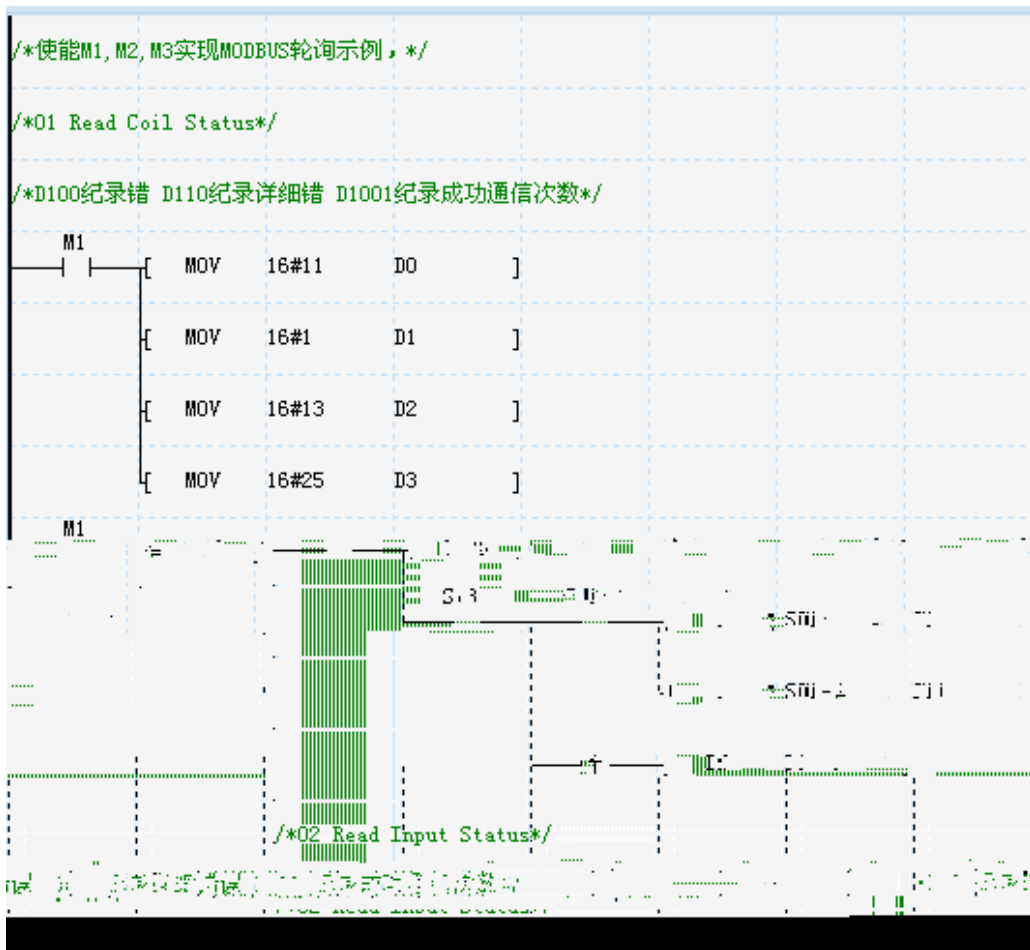
T T T ms

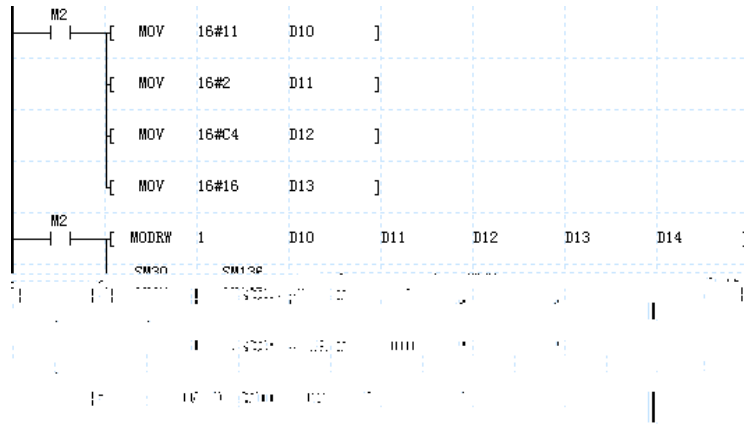
T ms

T ms

T INT — ms

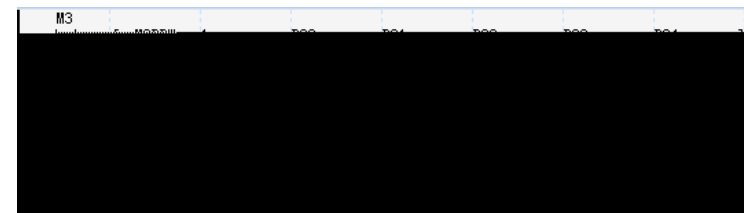
T ms





gister*/ /*read holding re
 12记录详细错误 D1002记录成功通讯次数*/ /*D102记录错误 D1

...	M: 0	M: 0
...
...
...
...



1		
2		
3		
4-15		
16		
17		
18		/
19	S2	

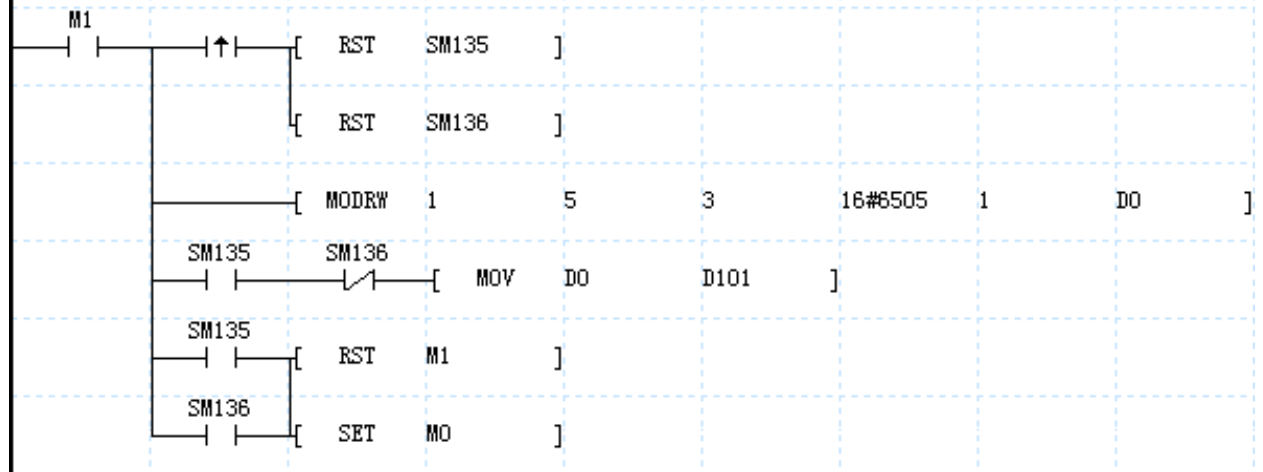
20	D	
21		
22		
23		

24		
25		
26	CRC/LRC	
27		
28	S3	

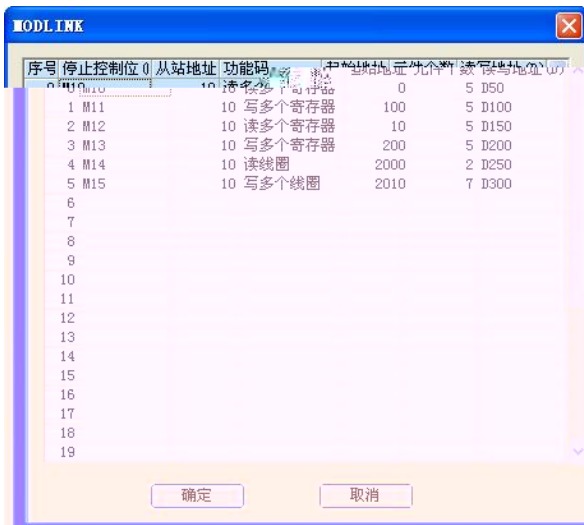
29	S4	
30	S5	
31		
32		
33		EV3000
34		

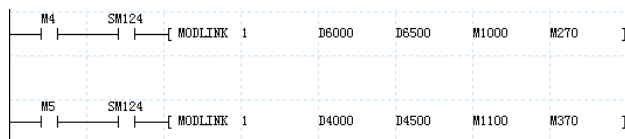


/*读频率：变频器当前运行频率MODBUS寄存器地址为16#6505*/



M90										MC100 3000 MC200 3008				
MODLINK 1 D200 D46 M114 M156														
Modlink S1 S2 S3 S4 S5										12				





— — [XMT (S1) (S2) (S3)]				MC200 MC100 MC80 MC280			
XMT S1 S2 S3				7			

										MC200 MC100 MC80 MC280			
RCV (S1) (D) (S2)													
RCV S1 D S2										7			

S1
D
S2

6 0 3 5 6 7 8 9
f } W p 2 5 & 9 3

D

3

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

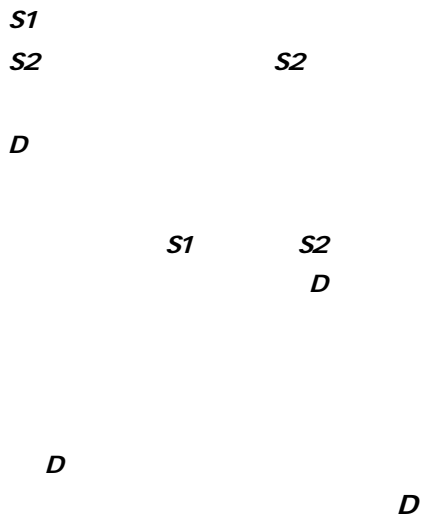
43 Kô OMT

--- --- [CCITT (S1) (S2) (D)]										MC200 MC100 MC80 MC280					
CCITT S1 S2 D										7					



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

----- ----- ----- ----- ----- ----- ----- ----- ----- -----										MC200 MC100 MC80 MC280					
[CRC16 (S1) (S2) (D)]															
CRC16 S1 S2 D										7					



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	D0	8	57708	D100

3

[LRC (S1) (S2) (D)]										MC200 MC100 MC80 MC280			
LRC S1 S2 D										7			

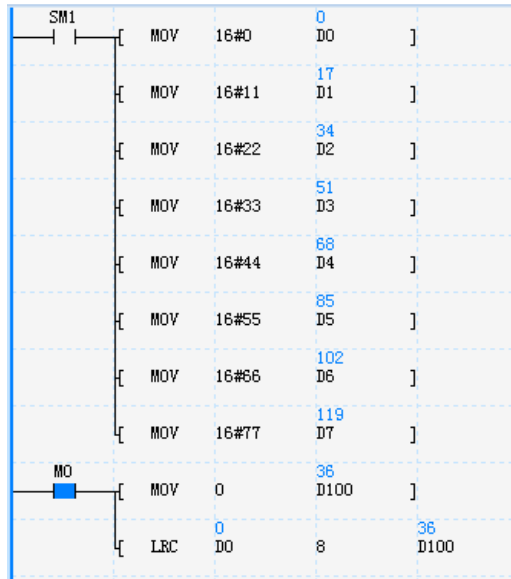
S1
S2 *S2*

D

 S1 *S2*
 D

 D *D*

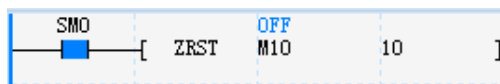
 8



[ZRST (D) (S)]										MC200 MC100 MC80 MC280			
ZRST D S										5			

D
S

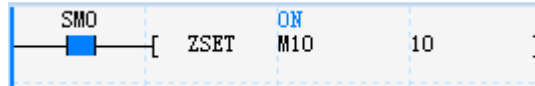
D *S*



...

--- --- ZSET (D) (S)										MC200 MC100 MC80 MC280				
ZSET D S										5				

D
S



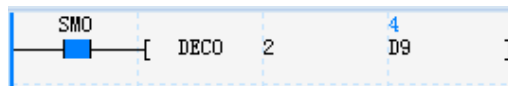
D S

--- --- DECO (S) (D)										MC200 MC100 MC80 MC280				
DMCO S D										5				

S
D

1
2

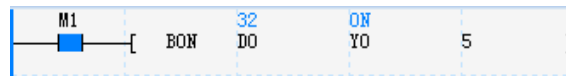
S D



— — [ENCO (S) (D)]		MC200 MC100 MC80 MC280
ENCO S D		5

										MC280					
BON S1 D S2										7					

S D



S1

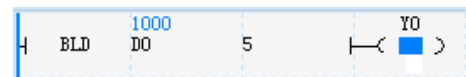
S1
D

										MC200 MC100 MC80 MC280					
BLD S1 S2										5					

S1

S2

S2



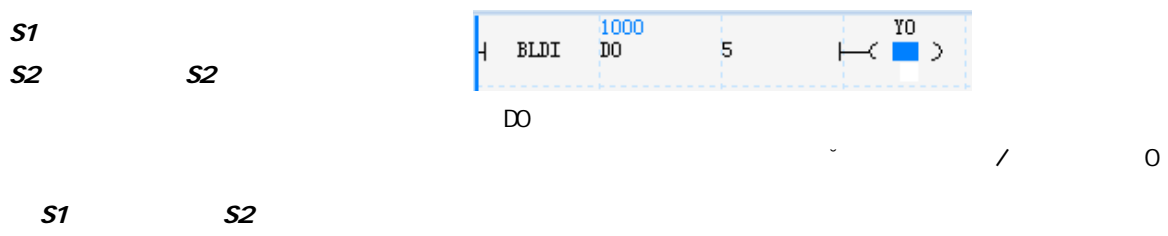
S1

S2

----- BLDI (S1) (S2) -()										MC200 MC100 MC80 MC280			
BLDI S1 S2										5			



----- BLD (S1) (S2) -()										MC200 MC100 MC80MC280			
BAND S1 S2										5			



										MC200 MC100 MC80 MC280				
BANI S1 S2										5				

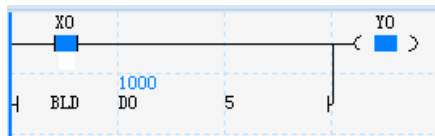
S1
S2



S1 S2

										MC200 MC100 MC80 MC280				
BOR S1 S2										5				

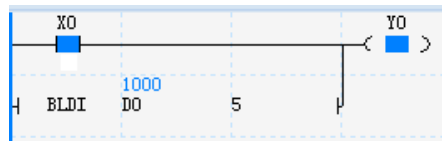
S1
S2



S1 S2

		MC200 MC100 MC80 MC280
BORI S1 S2		5

S1
S2

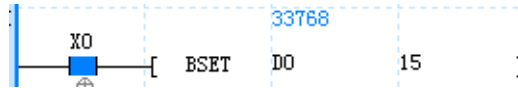


S1 S2

		MC200 MC100 MC80 MC280
BOUT D S		5

[BSET (D) (S)]										MC200 MC100 MC80MC280				
BSET D S										5				

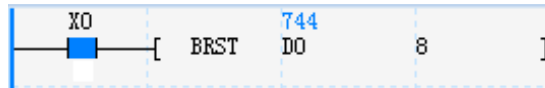
D
S2 S2



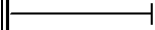
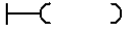
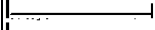
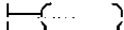
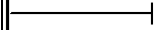

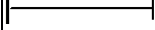

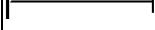

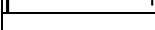
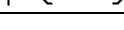
D S

[BRST (D) (S)]										MC200 MC100 MC80 MC280				
BRST D S										5				

D
S2 S2



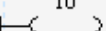
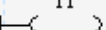


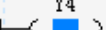
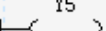
D S

	=	(S1)	(S2)			MC200 MC100 MC80 MC280
	<	(S1)	(S2)			
	>	(S1)	(S2)			
	◇	(S1)	(S2)			
	≥	(S1)	(S2)			
	≤	(S1)	(S2)			
LD		S1	S2			
LD		S1	S2			
LD		S1	S2			
LD		S1	S2			5
LD		S1	S2			
LD		S1	S2			

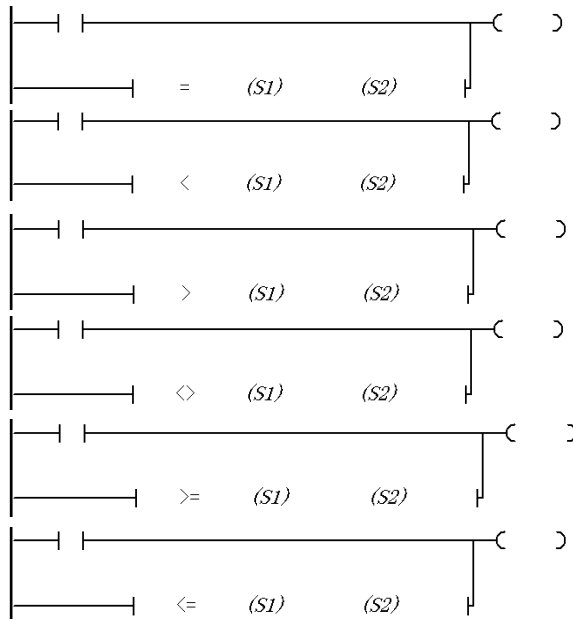
S1

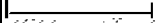





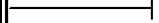





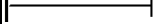





S2

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

			MC200	MC100	MC80	MC280
$\text{---} \text{---} \text{---}$	=	(S1) (S2) $\text{---} \text{---} \text{---}$				
$\text{---} \text{---} \text{---}$	<	(S1) (S2) $\text{---} \text{---} \text{---}$				
$\text{---} \text{---} \text{---}$	>	(S1) (S2) $\text{---} \text{---} \text{---}$				
$\text{---} \text{---} \text{---}$	<>	(S1) (S2) $\text{---} \text{---} \text{---}$				
$\text{---} \text{---} \text{---}$	>=	(S1) (S2) $\text{---} \text{---} \text{---}$				
$\text{---} \text{---} \text{---}$	<=	(S1) (S2) $\text{---} \text{---} \text{---}$				
AND		S1 S2				
AND		S1 S2				
AND		S1 S2				
AND		S1 S2				5
		S1 S2				
		S1 S2				



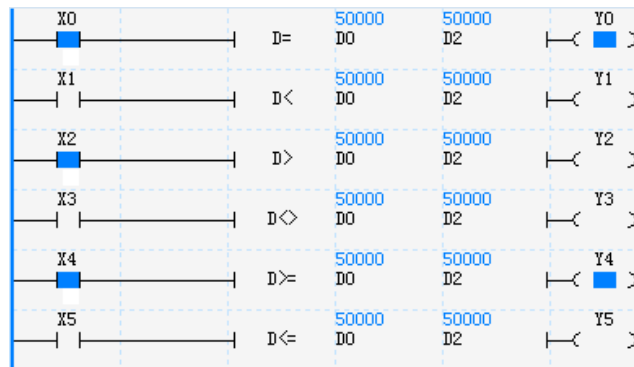
						MC200	MC100	MC80	MC280
	D=	(S1)	(S2)						
	D<	(S1)	(S2)						
	D>	(S1)	(S2)						
	D<>	(S1)	(S2)						
	D>=	(S1)	(S2)						
	D<=	(S1)	(S2)						

<table border="1"> <tr> <td>┌──┐ ┌──┐</td> <td>D=</td> <td>(S1)</td> <td>(S2)</td> <td>┌──┐</td> <td>)</td> </tr> <tr> <td>┌──┐ ┌──┐</td> <td>D<</td> <td>(S1)</td> <td>(S2)</td> <td>┌──┐</td> <td>)</td> </tr> <tr> <td>┌──┐ ┌──┐</td> <td>D></td> <td>(S1)</td> <td>(S2)</td> <td>┌──┐</td> <td>)</td> </tr> <tr> <td>┌──┐ ┌──┐</td> <td>D<></td> <td>(S1)</td> <td>(S2)</td> <td>┌──┐</td> <td>)</td> </tr> <tr> <td>┌──┐ ┌──┐</td> <td>D>=</td> <td>(S1)</td> <td>(S2)</td> <td>┌──┐</td> <td>)</td> </tr> <tr> <td>┌──┐ ┌──┐</td> <td>D<=</td> <td>(S1)</td> <td>(S2)</td> <td>┌──┐</td> <td>)</td> </tr> </table>	┌──┐ ┌──┐	D=	(S1)	(S2)	┌──┐)	┌──┐ ┌──┐	D<	(S1)	(S2)	┌──┐)	┌──┐ ┌──┐	D>	(S1)	(S2)	┌──┐)	┌──┐ ┌──┐	D<>	(S1)	(S2)	┌──┐)	┌──┐ ┌──┐	D>=	(S1)	(S2)	┌──┐)	┌──┐ ┌──┐	D<=	(S1)	(S2)	┌──┐)		MC200 MC100 MC80 MC280
┌──┐ ┌──┐	D=	(S1)	(S2)	┌──┐)																																	
┌──┐ ┌──┐	D<	(S1)	(S2)	┌──┐)																																	
┌──┐ ┌──┐	D>	(S1)	(S2)	┌──┐)																																	
┌──┐ ┌──┐	D<>	(S1)	(S2)	┌──┐)																																	
┌──┐ ┌──┐	D>=	(S1)	(S2)	┌──┐)																																	
┌──┐ ┌──┐	D<=	(S1)	(S2)	┌──┐)																																	
<table border="1"> <tr> <td></td> <td>ANDD</td> <td>S1</td> <td>S2</td> </tr> <tr> <td>ANDD</td> <td>S1</td> <td>S2</td> <td></td> </tr> <tr> <td>ANDD</td> <td>S1</td> <td>S2</td> <td></td> </tr> <tr> <td>ANDD</td> <td>S1</td> <td>S2</td> <td></td> </tr> <tr> <td>ANDD</td> <td>S1</td> <td>S2</td> <td></td> </tr> <tr> <td>ANDD</td> <td>S1</td> <td>S2</td> <td></td> </tr> </table>		ANDD	S1	S2	ANDD	S1	S2		ANDD	S1	S2		ANDD	S1	S2		ANDD	S1	S2		ANDD	S1	S2			7												
	ANDD	S1	S2																																			
ANDD	S1	S2																																				
ANDD	S1	S2																																				
ANDD	S1	S2																																				
ANDD	S1	S2																																				
ANDD	S1	S2																																				

S1

S2

S1 S2

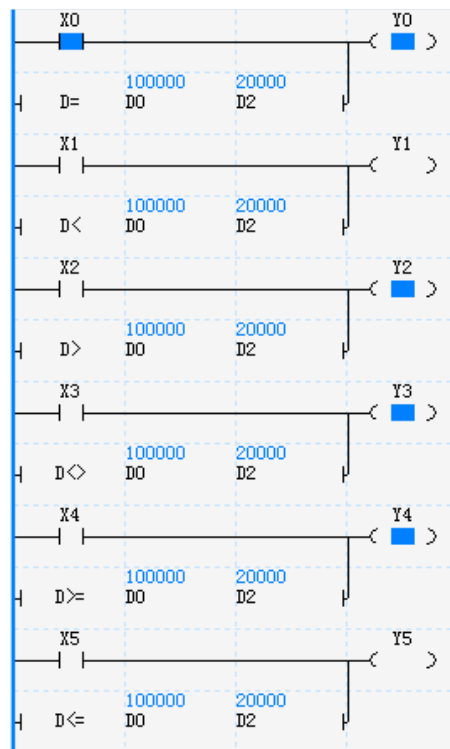


			MC200	MC100	MC80	MC280
)				
	D= (S1) (S2)					
)				
	D< (S1) (S2)					
)				
	D> (S1) (S2)					
)				
	D<> (S1) (S2)					
)				
	D>= (S1) (S2)					
)				
	D<= (S1) (S2)					
ORD	S1 S2					
ORD	S1 S2					
ORD	S1 S2					
ORD	S1 S2					7
ORD	S1 S2					
ORD	S1 S2					

S1

S2

S1 S2



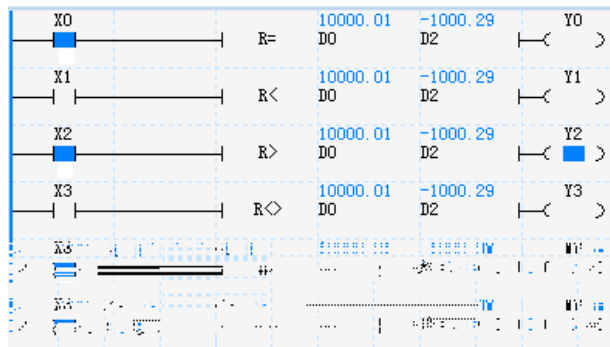
						MC200 MC100 MC280
	R=	(S1)	(S2))	
	R<	(S1)	(S2))	
	R>	(S1)	(S2))	
	R<>	(S1)	(S2))	
	R>=	(S1)	(S2))	
	R<=	(S1)	(S2))	

						MC200	MC100	MC280
		R=	(S1)	(S2)				
		R<	(S1)	(S2)				
		R>	(S1)	(S2)				
		R<>	(S1)	(S2)				
		R>=	(S1)	(S2)				
		R<=	(S1)	(S2)				
ANDR	S1	S2						
ANDR	S1	S2						
ANDR	S1	S2						
ANDR	S1	S2						
ANDR	S1	S2						
ANDR	S1	S2						
7								

S1

S2

S1 S2

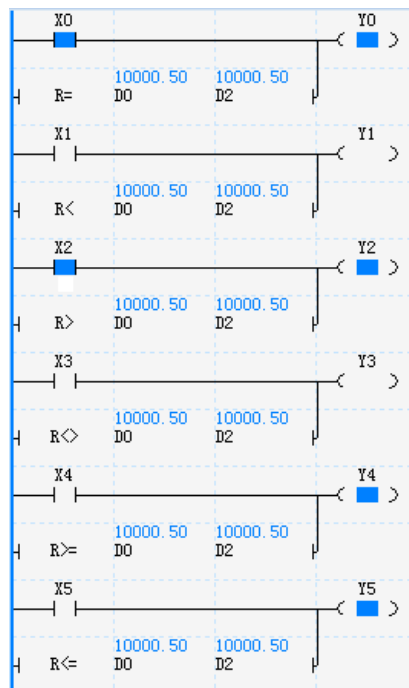


		<p>MC200 MC100 MC280</p>
<p> ORR S1 S2 ORR S1 S2 ORR S1 S2 ORR S1 S2 ORR S1 S2 ORR S1 S2 </p>		<p>7</p>

S1

S2

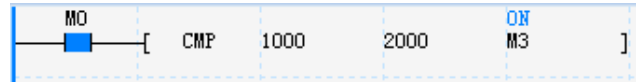
S1 S2



[CMP]		MC200 MC280	
CMP S1 S2 D		7	

S1
S2
D

S1 S2
D D D



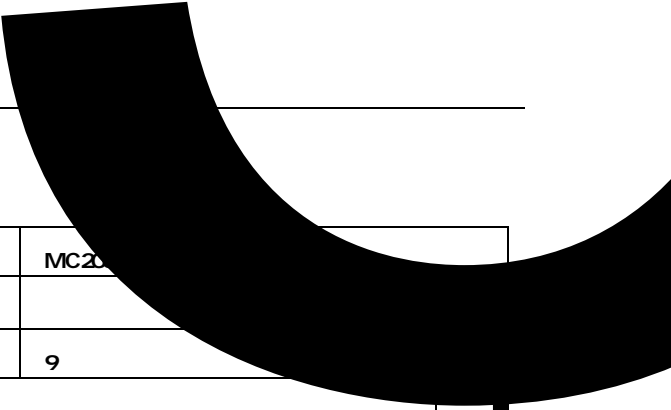
[]		MC200 MC280	
LCMP S1 S2 D		9	

S1
S2
D

D D D



S1 S2



— — [RCMP]													MC20		
RCMP S1 S2 D													9		



										MC280				
[BKSUB (S1) (S2) (D) (S3)]														
BKSUB										9				

S1

ON

S2

D

S3

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

S1 s3 16

S2 S3 16 (BIN)

D S3

S2 16 , S2

S1 s3 16 S2

D S3

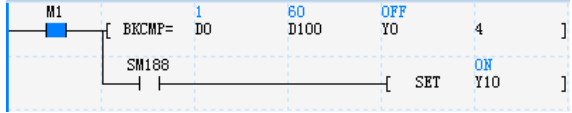
.....

		MC280													
----- ----- [BKCMP= (S1) (S2) (D) (S3)]															
----- ----- [BKCMP< (S1) (S2) (D) (S3)]															
----- ----- [BKCMP> (S1) (S2) (D) (S3)]															
----- ----- [BKCMP<= (S1) (S2) (D) (S3)]															
----- ----- [BKCMP>= (S1) (S2) (D) (S3)]															
----- ----- [BKCMP<= (S3) (S2) (D) (S3)]															
BKCMP=, >, <, <=, >= (S1) (S2) (D) (S3)		9													

S1
S2
D
S3

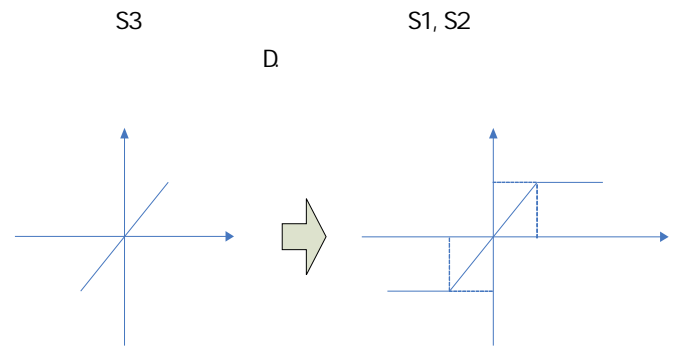
ON

S1 S3 16 S2 S3
16 (BIN) D
S3



										MC280				
LIMIT (S1) (S2) (S3) (D)														
LIMIT (S1) (S2) (S3) (D)										9				

S1
S2
S3
D:

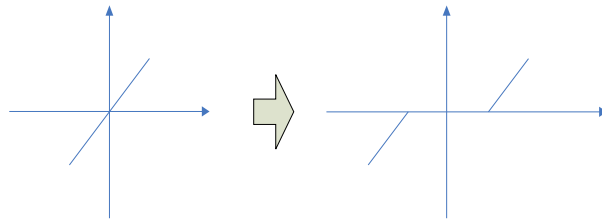


M1	[LIMIT	10	100	30	30]
			D0	D10	D100	D1000	

M=CN D100 D0-D10
D1000 D0(10) <= D100(30) <= D10(100), D1000=30

----- ----- [DBAND (S1) (S2) (S3) (D)]										MC280				
DBAND (S1) (S2) (S3) (D)										9				

S1
S2
S3
D:



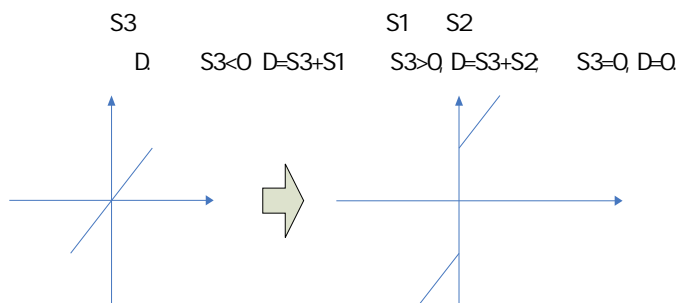
M1	[DBAND	-100	100	30	0
	DO	D10	D100	D1000	

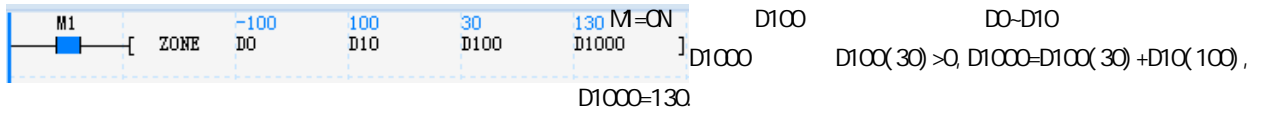
S3
S1, S2
D

M=CN D100 DO-D10
D1000 DO (-100) < D100(30) < D10(100), D1000=0

----- ----- [ZONE (S1) (S2) (S3) (D)]										MC280				
ZONE (S1) (S2) (S3) (D)										9				

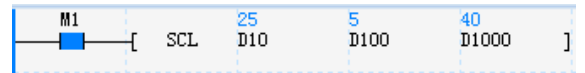
S1
S2
S3
D:





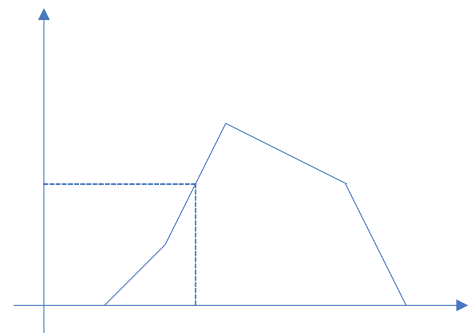
										MC280				
SCL (S1) (S2) (D)														
SCL (S1) (S2) (S3) (D)										7				

S1




S2

D:



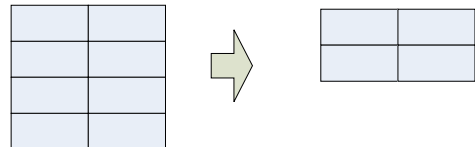
D (S1) (D) (S2)]		MC280															
S2 D		7															


		MC280
STRLEN S D		5

										MC280				
STRIGHT														
STRIGHT S1 D S2										7				

S1
D
S2

M1	12849	13363	
[STRIGHT D10	D100	3]



														MC280	
STRLEFT S1 D S2														7	

S1
D
S2

		MC280
STRMIDR S1 D S2		7

										MC280					
----- ----- [STRMIDW (S1) (D) (S2)]															
STRMIDW S1 D S2										7					

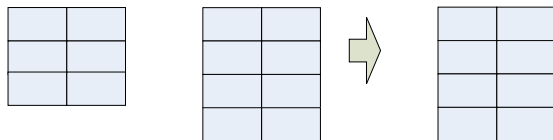
S1

D

S2

S2+1

M1	12849	12596	2
[STRMIDW	D10	D100	D0]



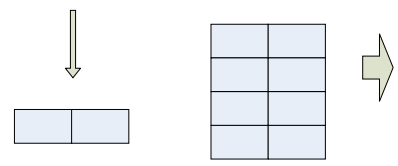
										MC28D				
[STRINSTR (S1) (S2) (D) (S3)]														
STRINSTR S1 S2 D S3										9				

S1
S2
D
S3

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

" "

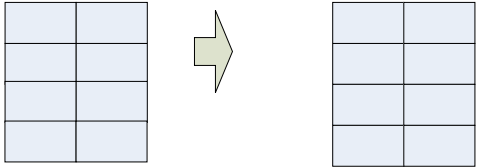
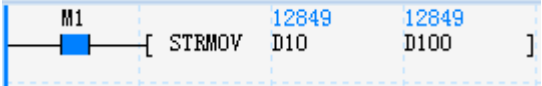
" "



		MC280															
----- ----- [STRMOV (S) (D)]																	
STRMOV (S) (D)		5															

S

D:



										MC200 MC100 MC280									
										11									

F_{acc}

S1

S2

S3

D

3

8

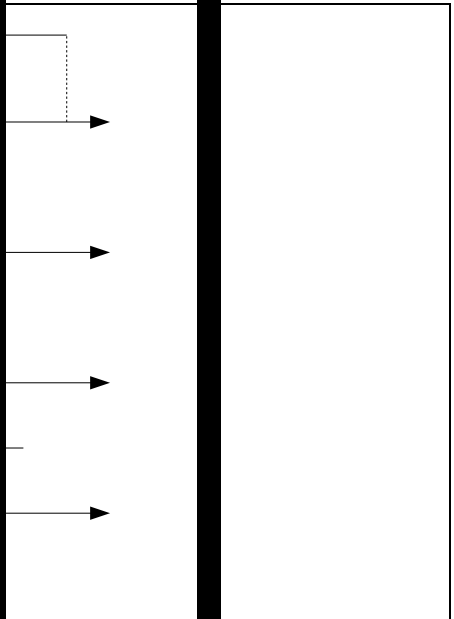
$$F_{acc} \sqrt{\frac{F}{T}}$$

9

F

10.

T



	MC100 MC280
8	



— — [DRVI (S1) (S2) (D1) (D2)]										MC200 MC100 MC80 MC280					
DRVI S1 S2 D1 D2										11					

S1

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

S2

F

T

F_{acc}

D1

3

D2

S1

● S1

● S1

S1

●

●

S1

1

8

2

9

--- --- [DRVA (S1) (S2) (D1) (D2)]											MC200 MC100 MC280				
DRVA S1 S2 D1 D2											11				

2

S1

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

S2

$$\frac{F}{T}$$

D1

$$F_{acc}$$

3

D2

D2

D2

S1

-
-

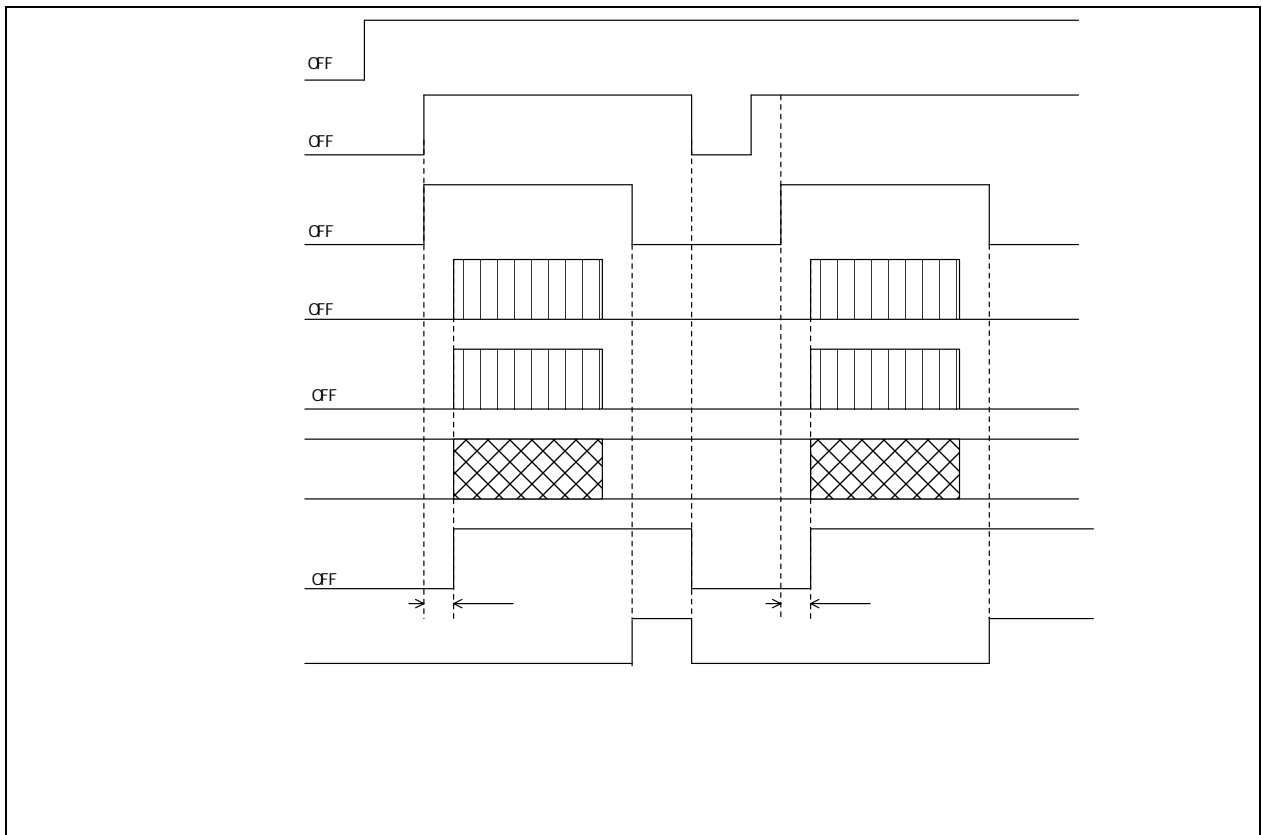
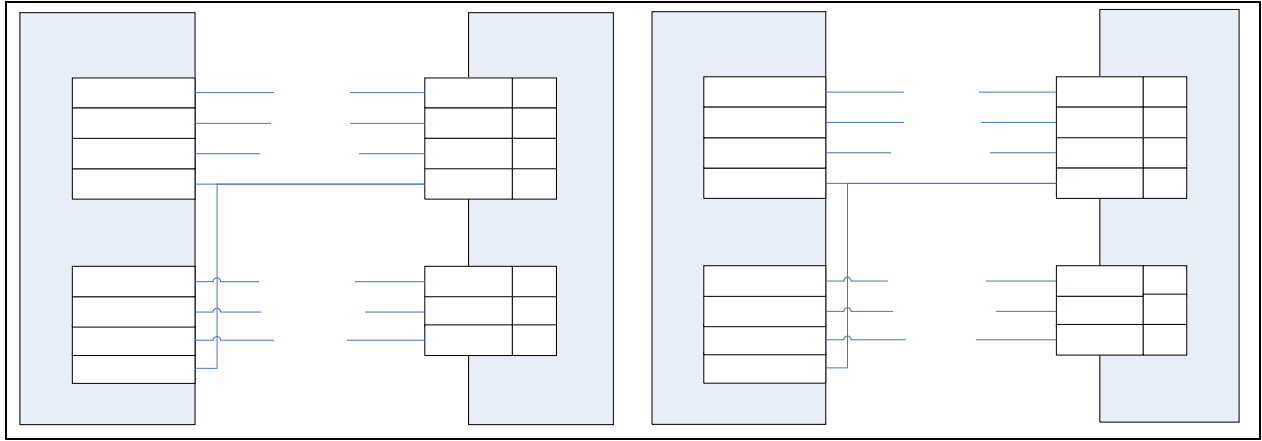
S1

— — [ABS (S) (D1) (D2)]										MC200 MC100 MC280		
ABS S D1 D2										8		

S

D1

D2



		MC200 MC280	
		9	
DSZR (S1) (S2) (D1) (D2)			

5
6

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

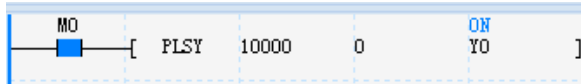
M8	[DSZR	OFF	OFF	OFF	OFF]
			M100	X0	Y0	Y4	

[STOPDV]							MC280						
STOPDV S1 S2 S3 D							12						

÷ ×

S2

D



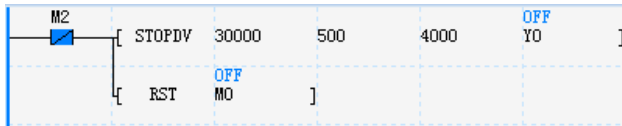
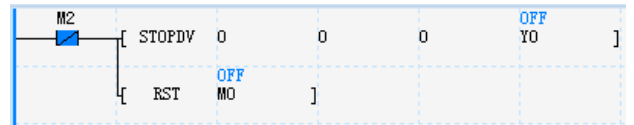
INT_1

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: _____

确定 取消



[L N]							MC280						
L I N							12						



X
Y0 Y4 Y5 Y6 Y7

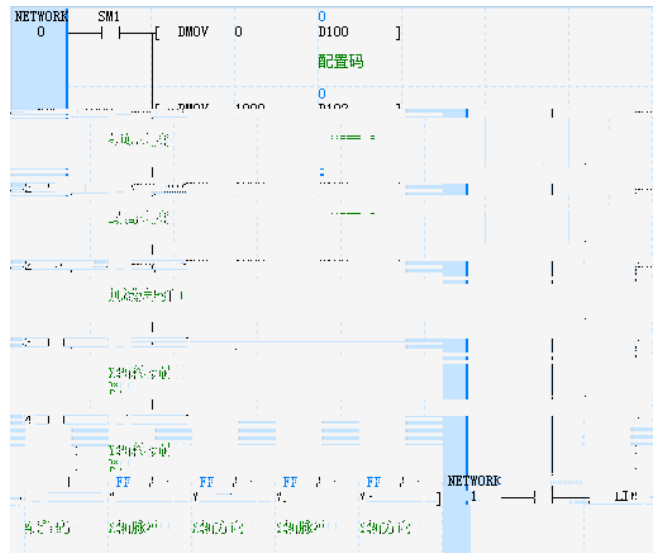
X

Y
Y2 Y4 Y5 Y6 Y7

Y

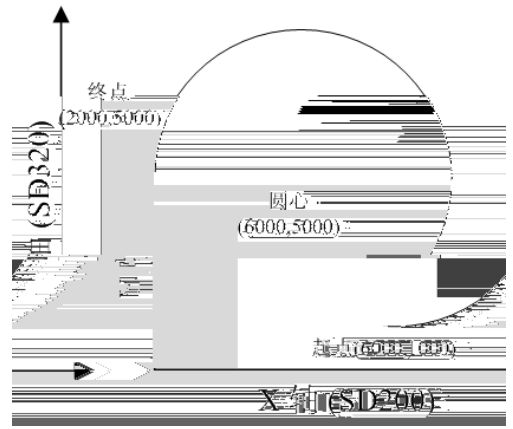
			!“ A _v A

D1 D3



D1 D3

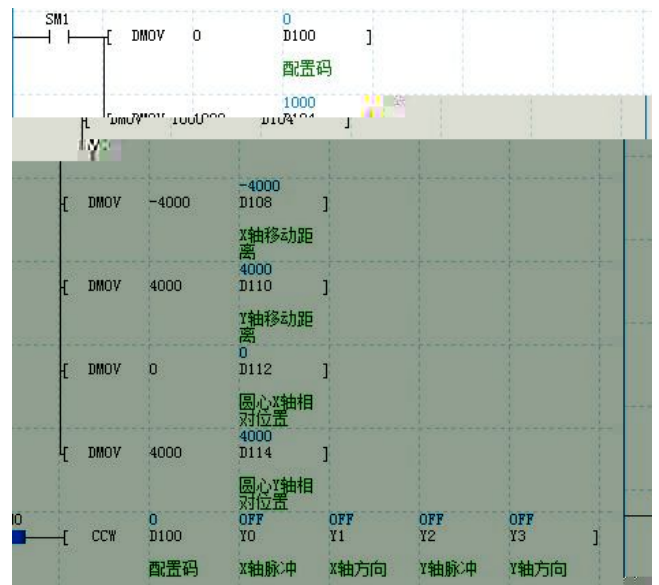
" " " "



-4000

4000

0 4000



[GEARBOX]		MC280
GEARBOX D1 S1 D2 S2		9

[DRVC (S1) (D1) (S2) (D2)]										MC280					
DRVC (S1) (D1) (S2) (D2)										9					

: C236-C400

AB

: - 2147483647~2147483648

;

;

SM1			[DMOV	100000	100000	D0]		
			[DMOV	100000	100000	D2]		
			[DMOV	150000	141072	D4]		
SMD	■		[HCNT	0	100000	D0]		
M10			[DRVC	OFF	100000	D0	OFF	OFF	Y4
					C236	D0		Y0		

——[CAMTABLE (S1) (S2) (S3) (S4) (S5)]										MC280					
CAMTABLE (S1) (S2) (S3) (S4) (S5)										11					

0° -360°

1.

CAMTABLE

360

2

4

S1

32

1~4

4

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

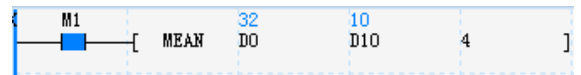
360

[CAMBOX (S1) (D1) (D2) (D3) (D4)]											MC280				
CAMBOX (S1) (D1) (D2) (D3) (D4)											9				

```
0 M1 | [ CAMTABLE R10 D12 D14 D16 D18 ]
C M3 | [ CAMBOX D0 X0 Y2 Y3 X10 ]
```

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

S1
S2
D

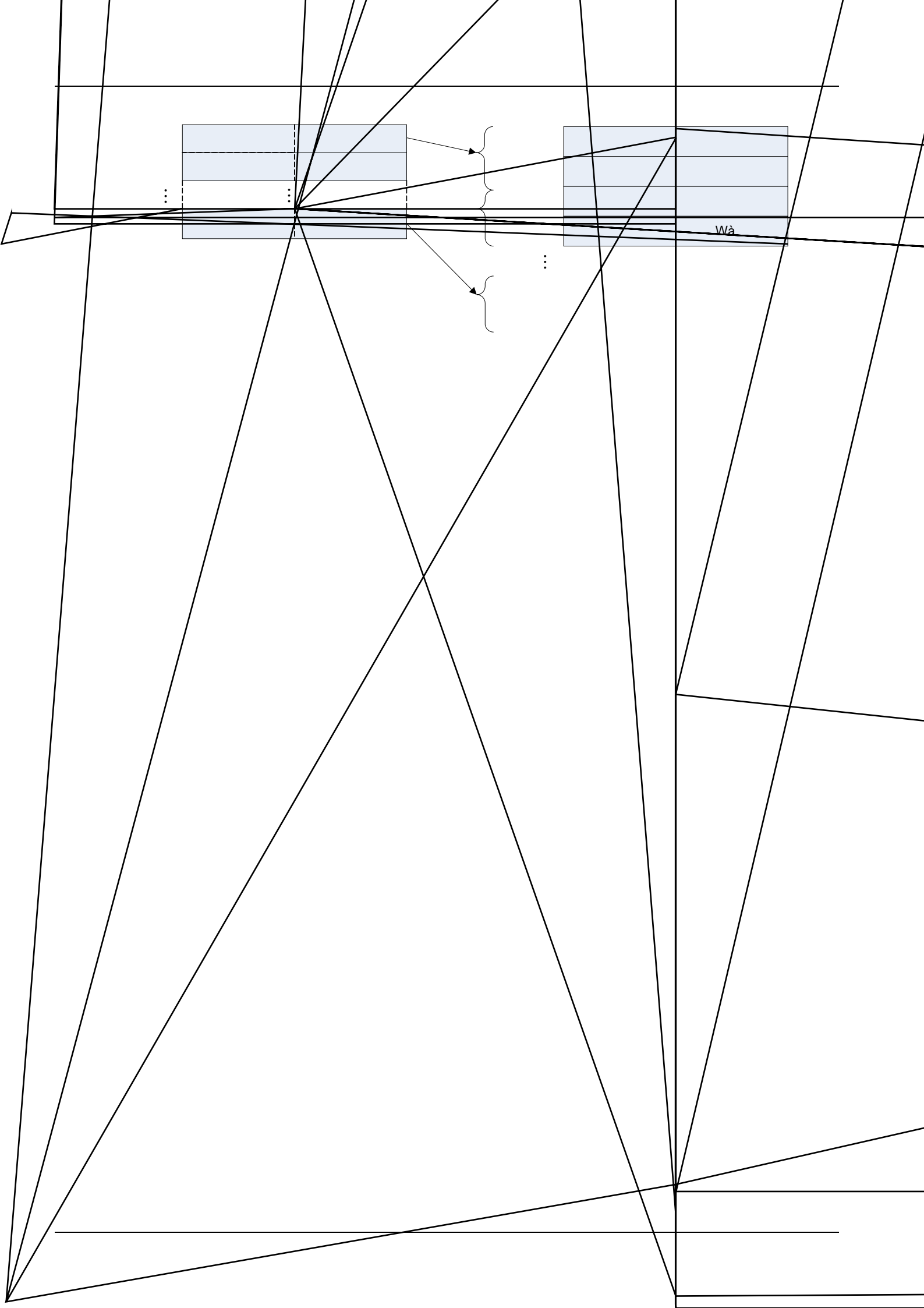


S1 S2 16 D

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

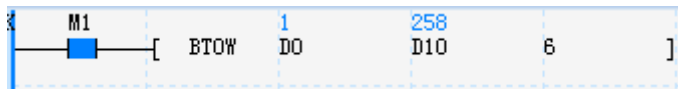
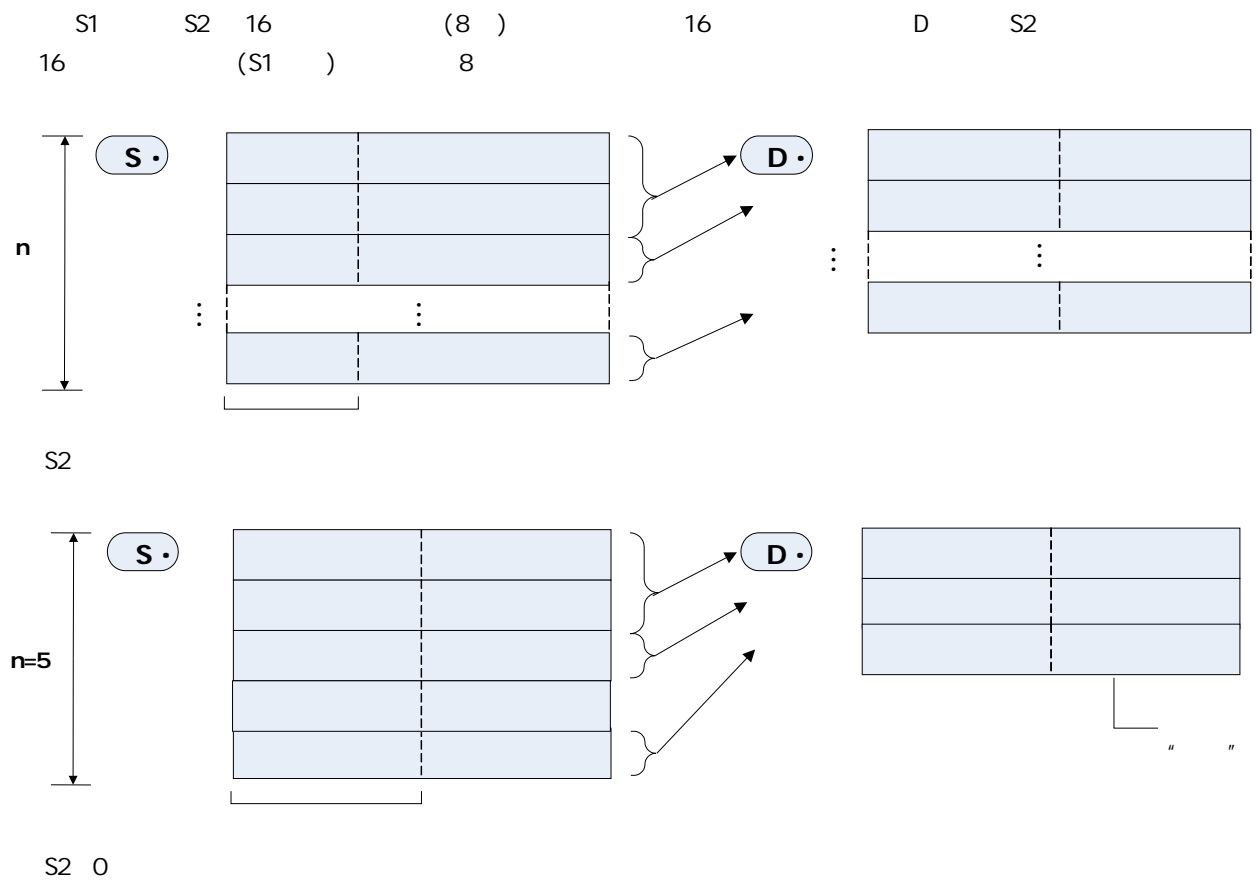
S1
S2
D

S1 S2/2 16 S2 D S2

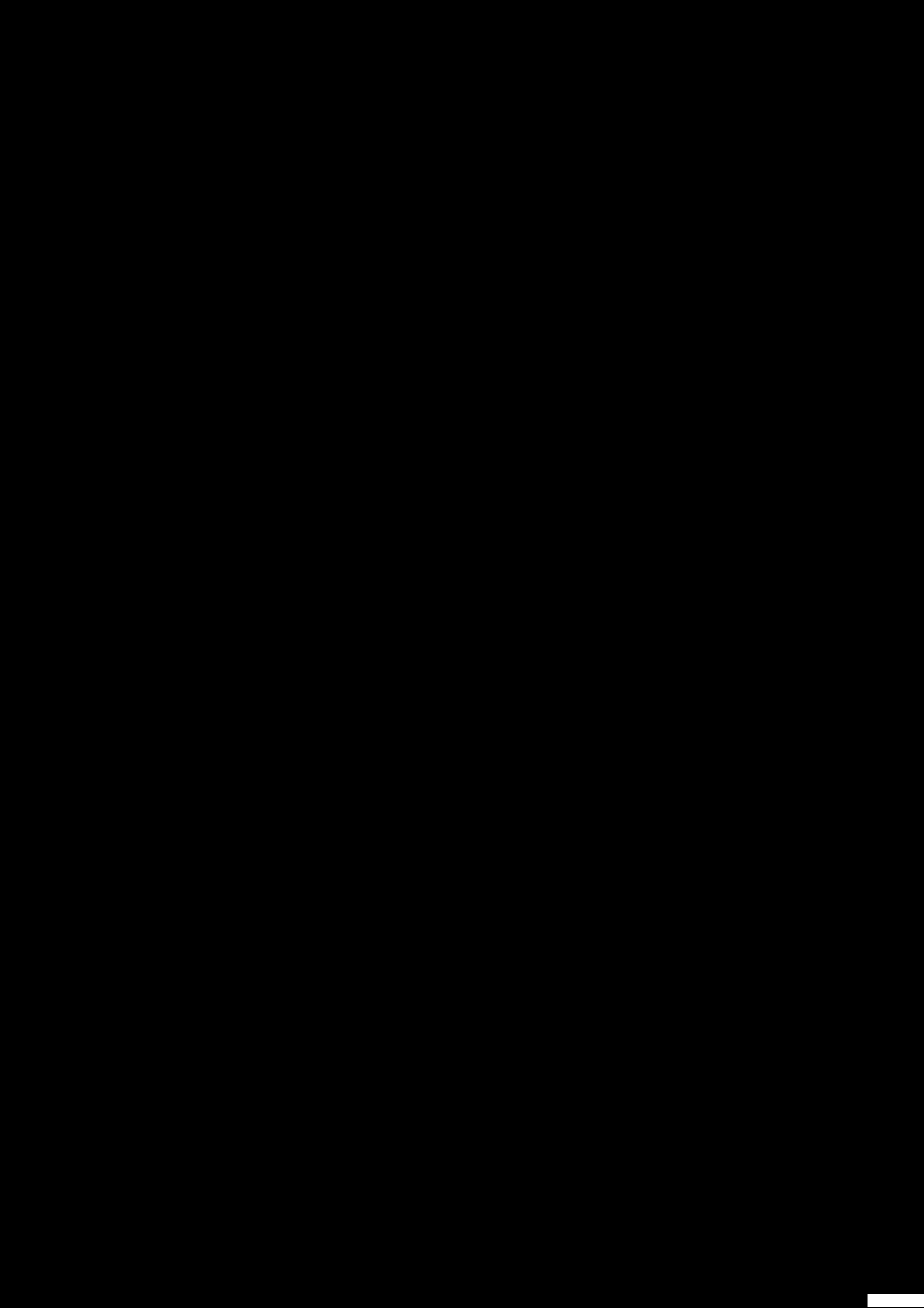


[BTOW (S1) (D) (S2)]										MC280	
BTOW (S1) (D) (S2)										7	






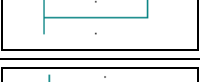


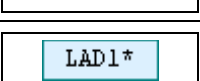
S1
S2
D

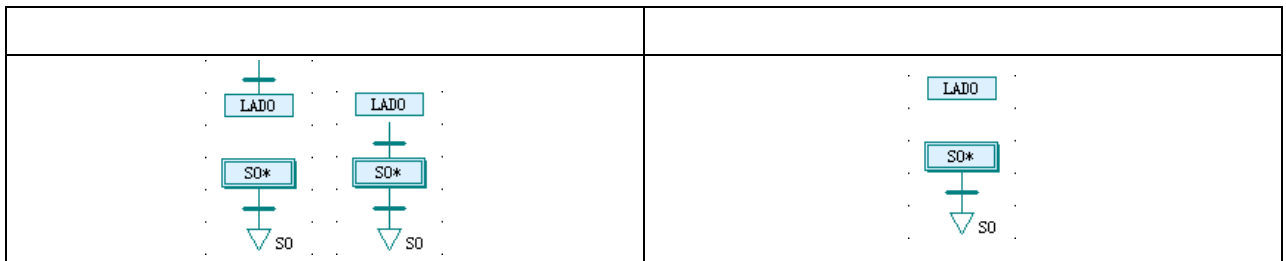
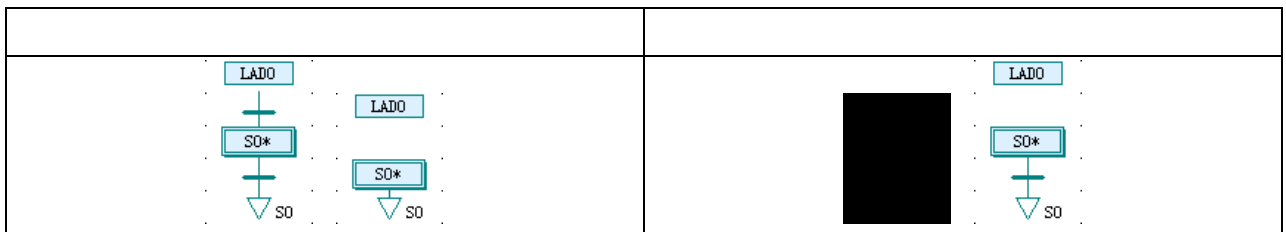


|—| — [UNI (S1) (D) (S2)]

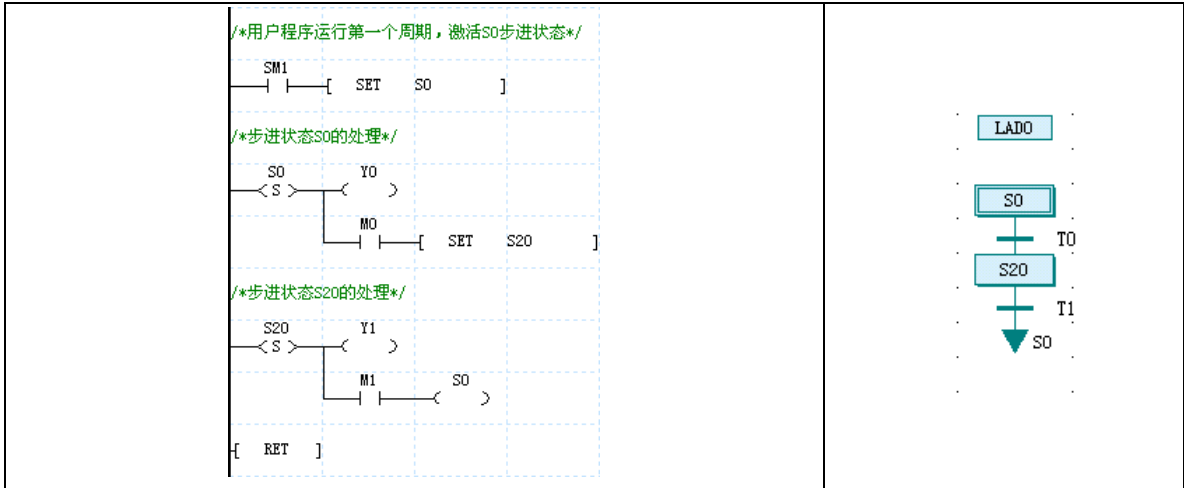
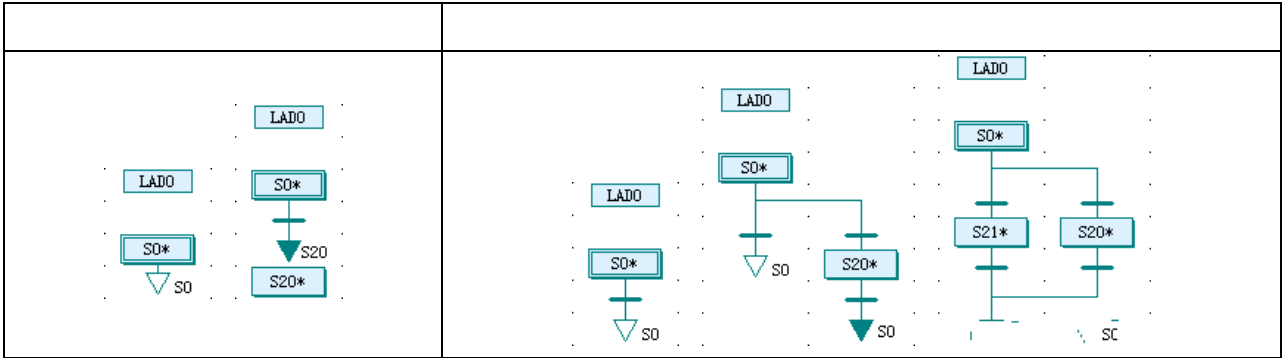
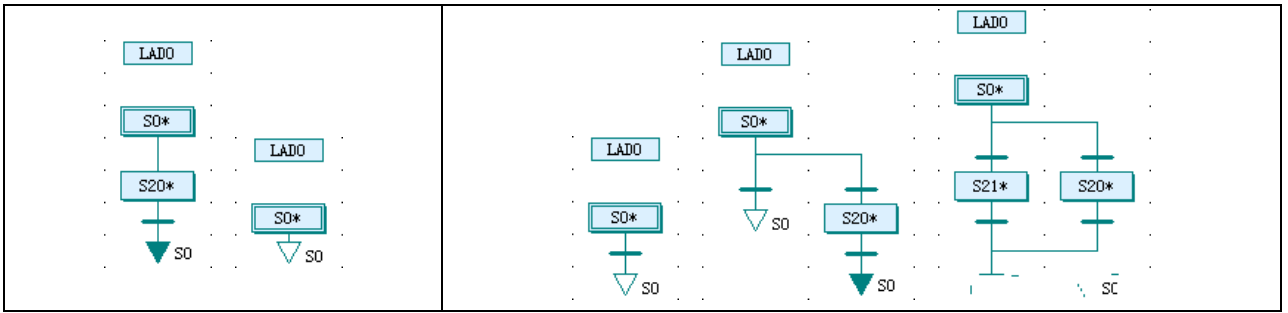


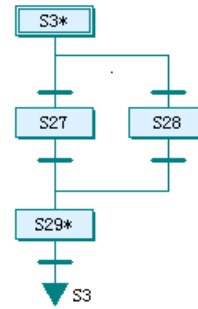
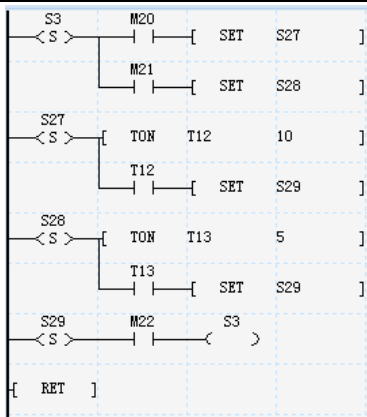


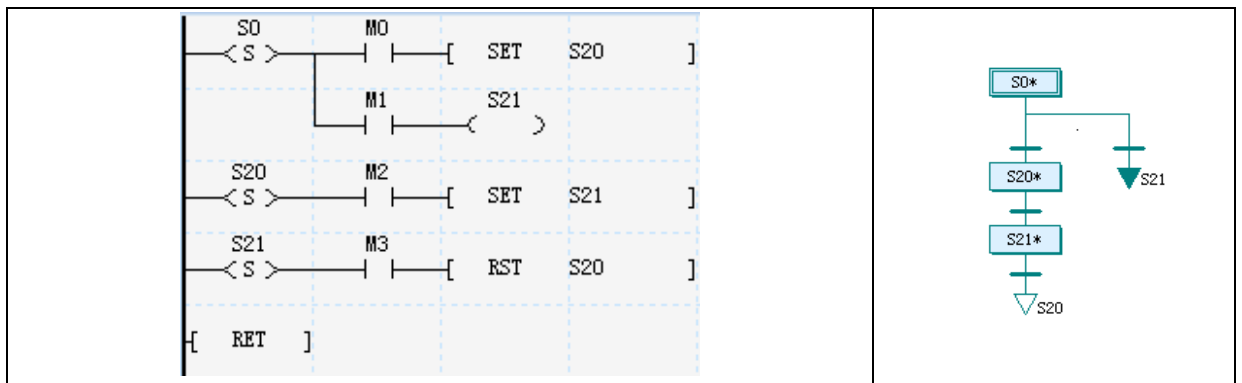
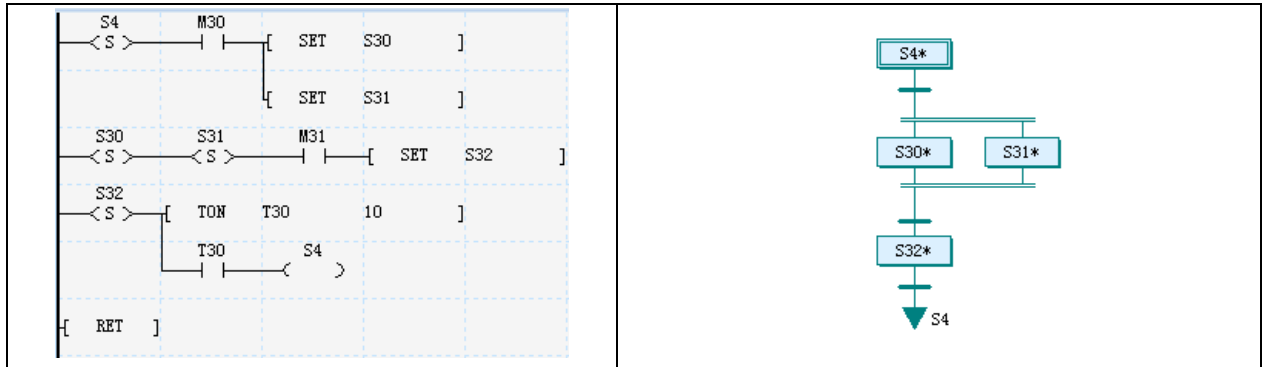
		
		
		
		
		
		
		
		
		

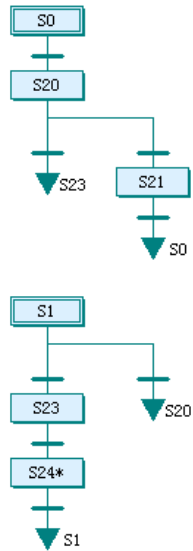
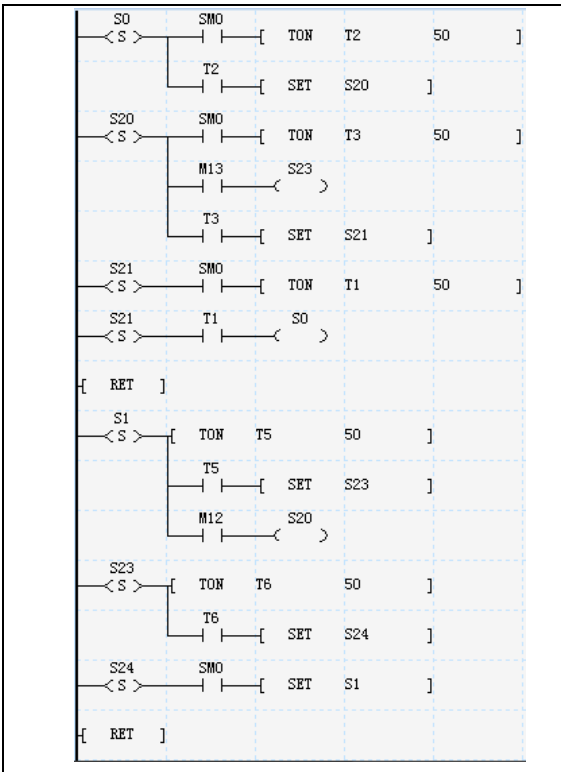
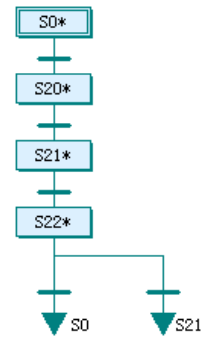
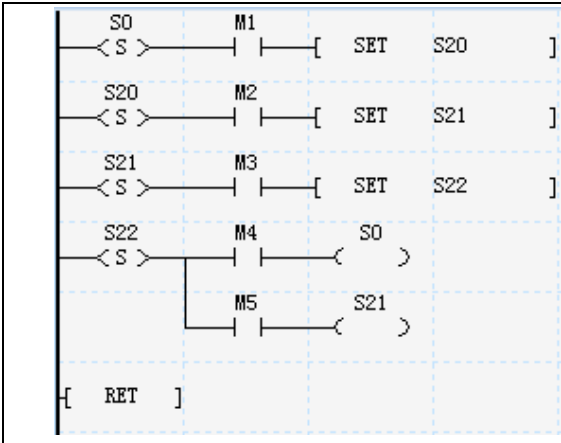


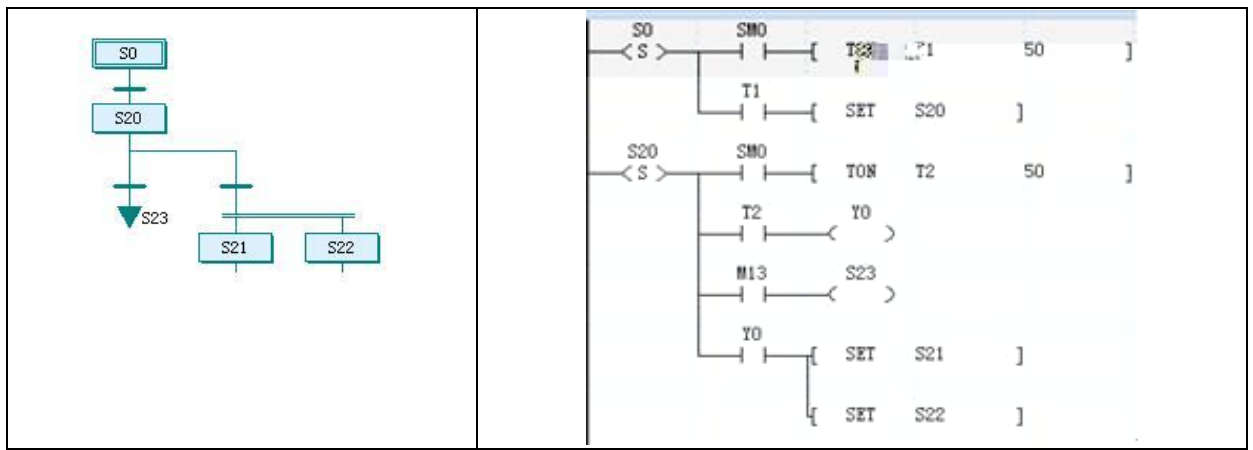
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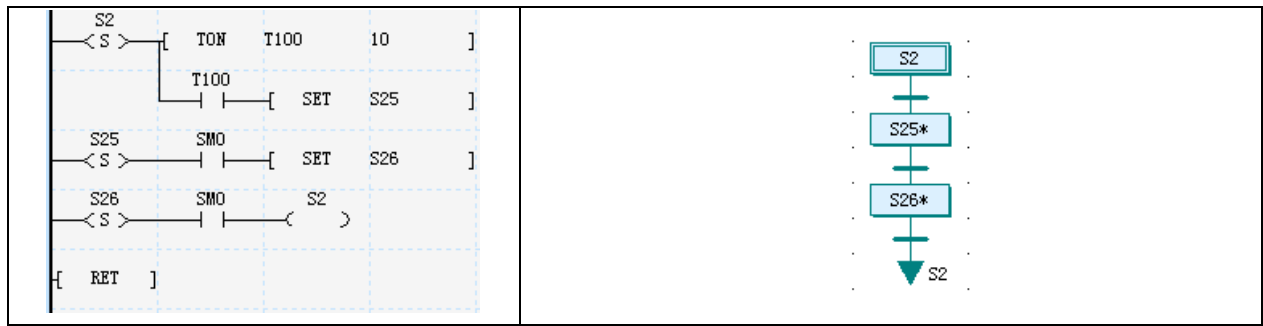






5.31 STL SFC





5.31 STL SFC

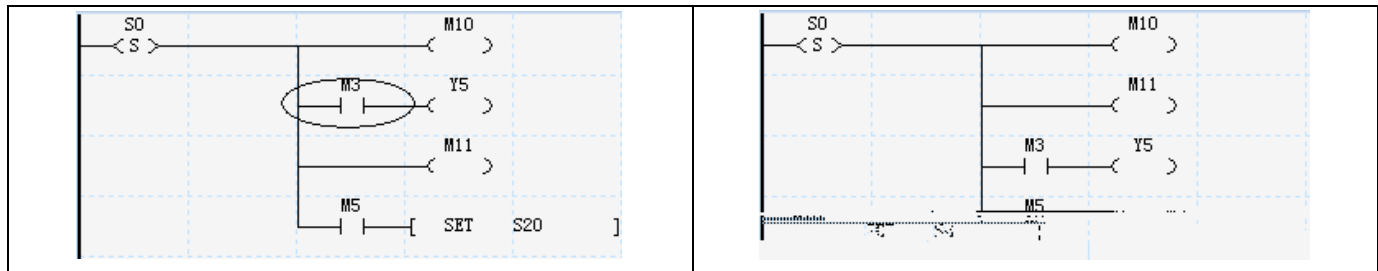
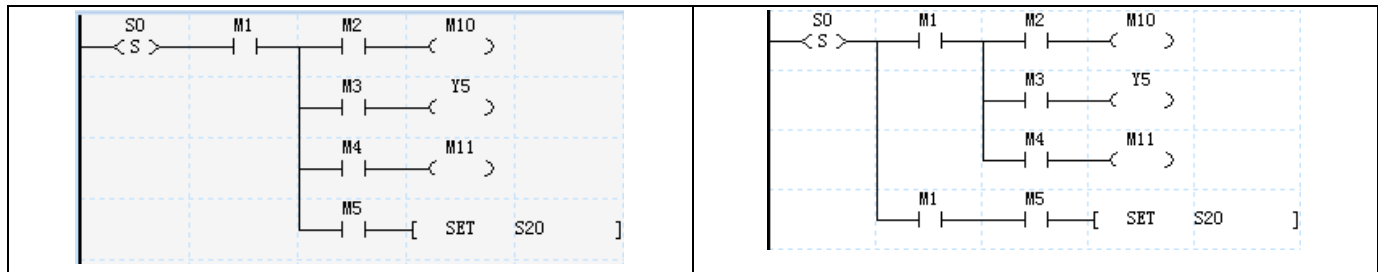
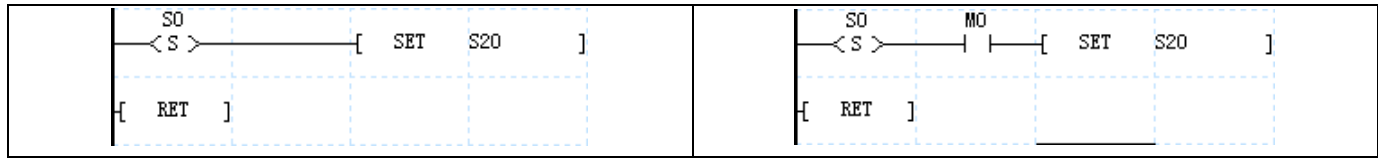


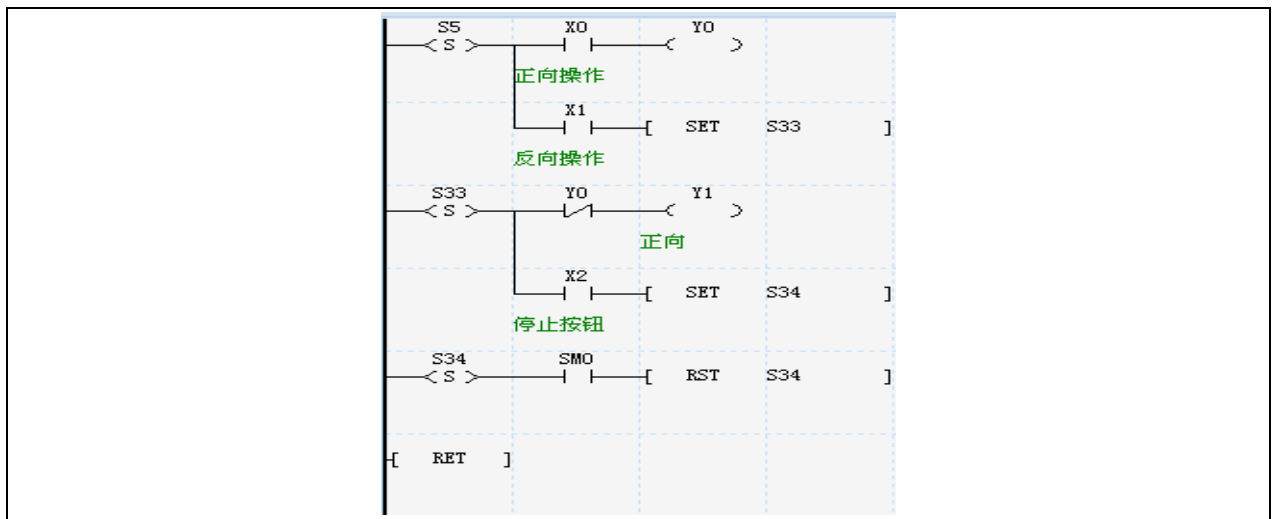
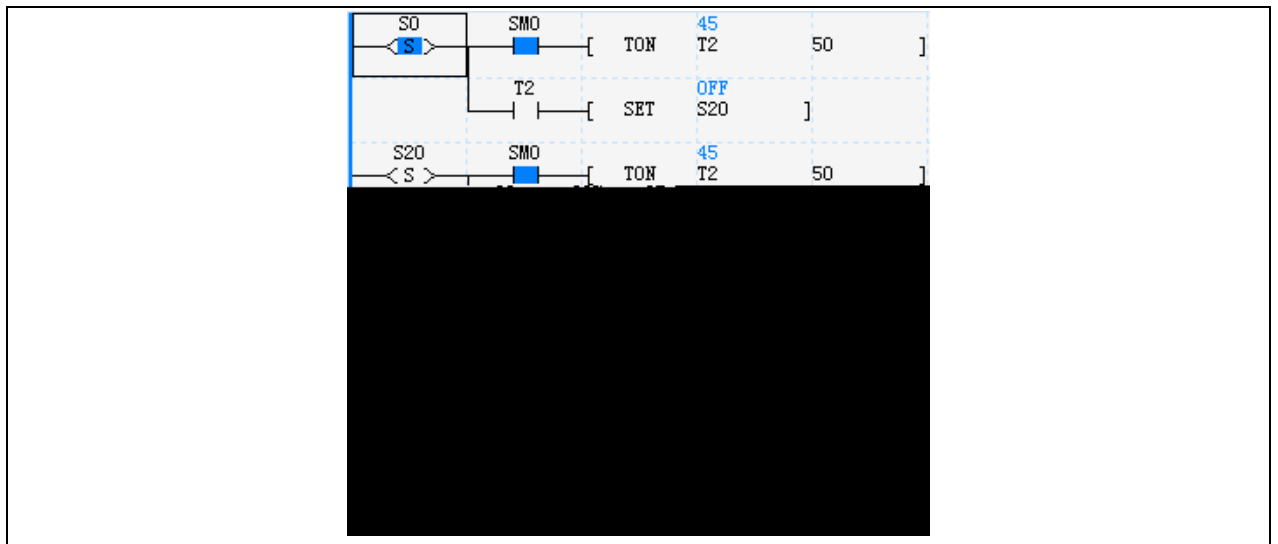
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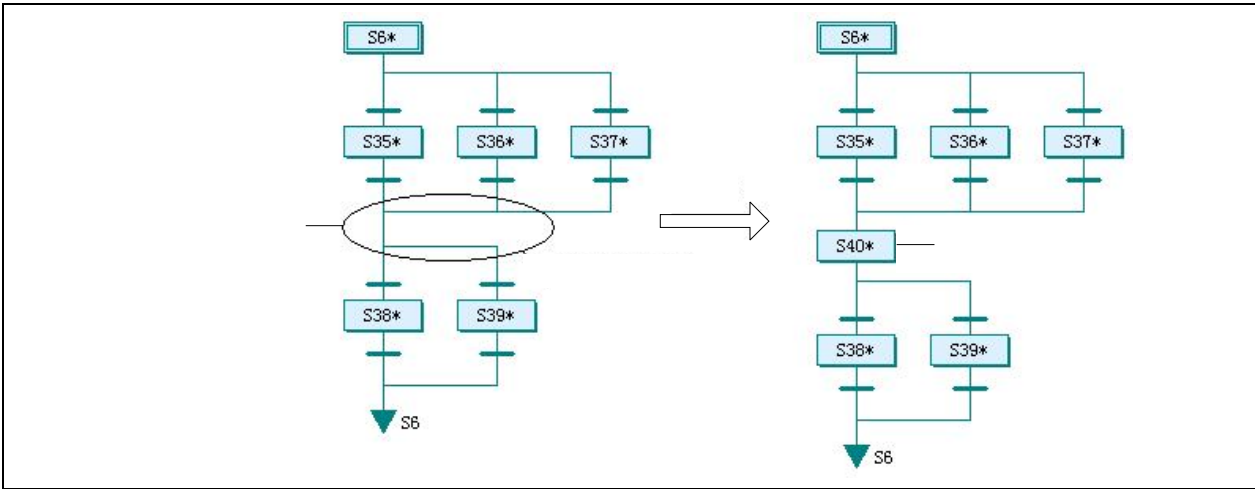
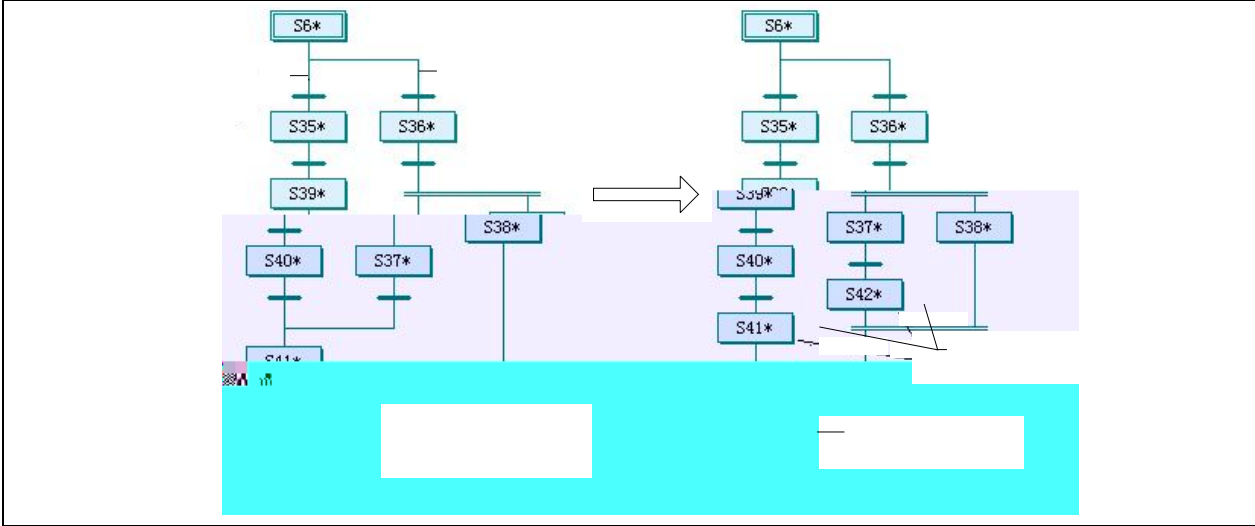
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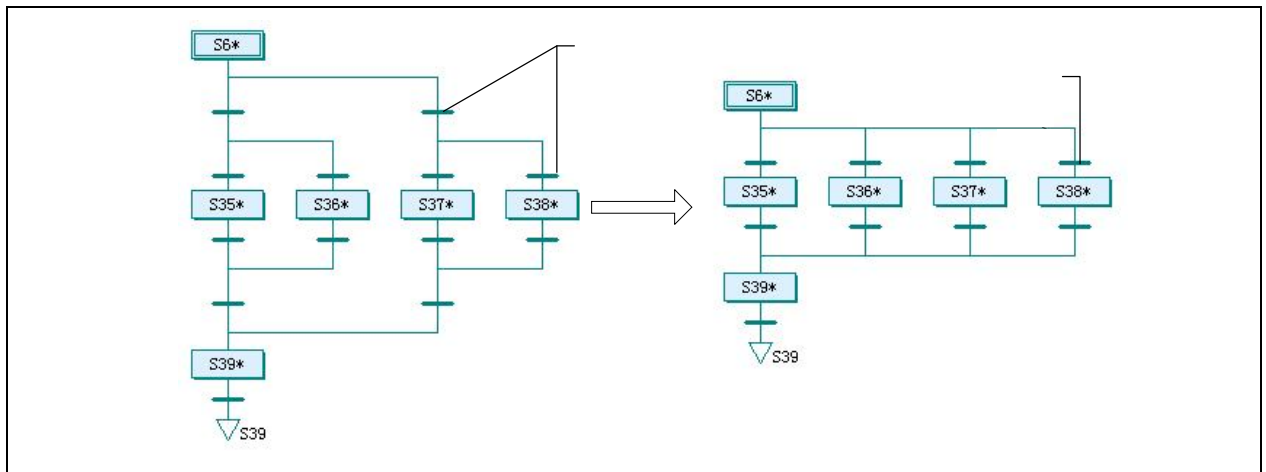
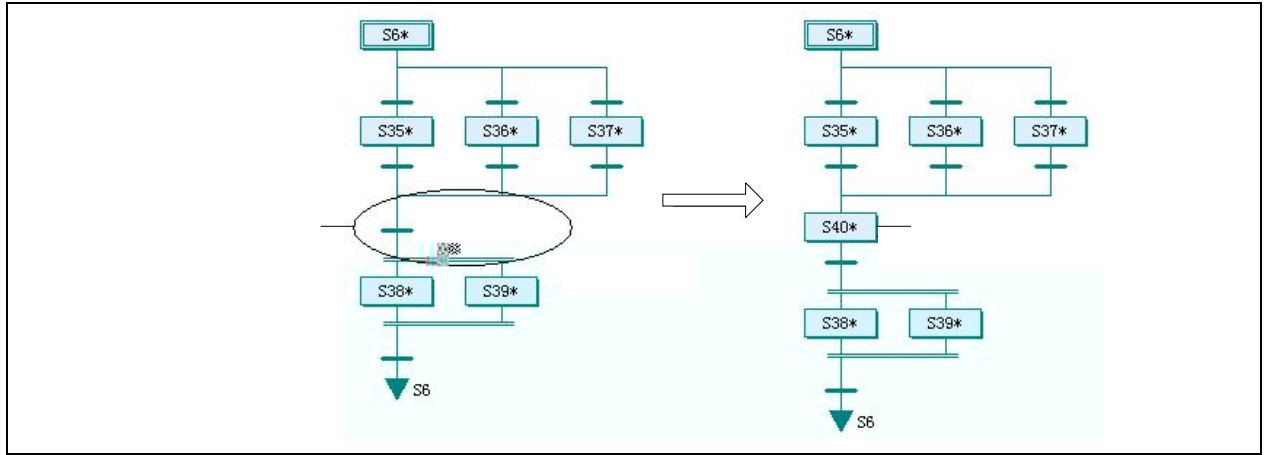
7.1.5

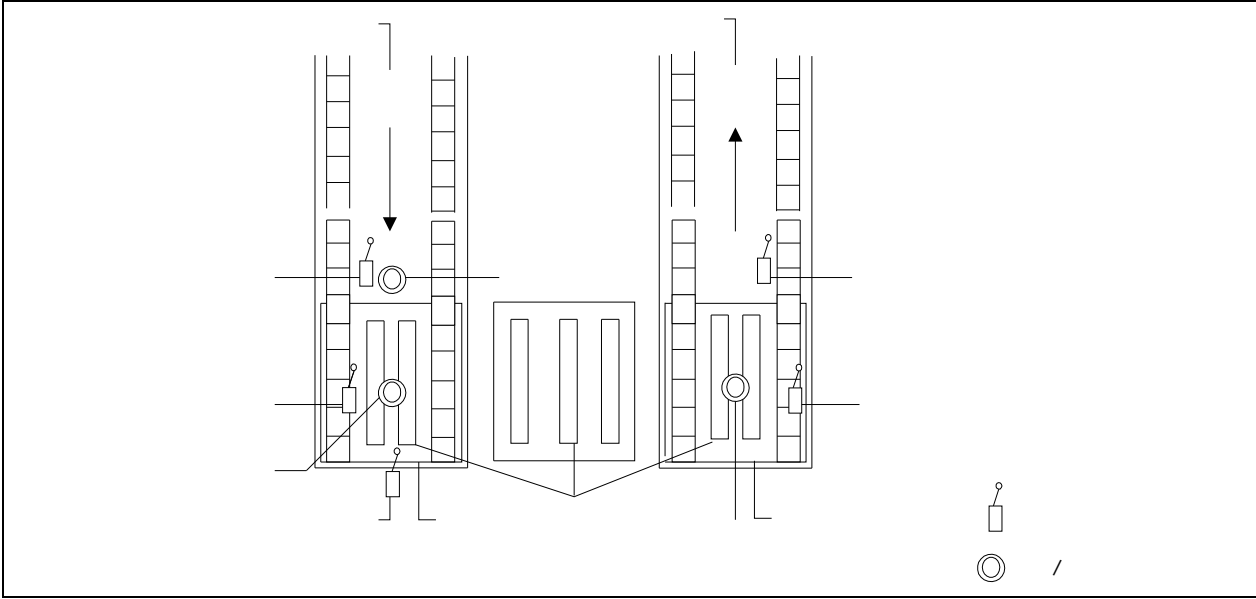












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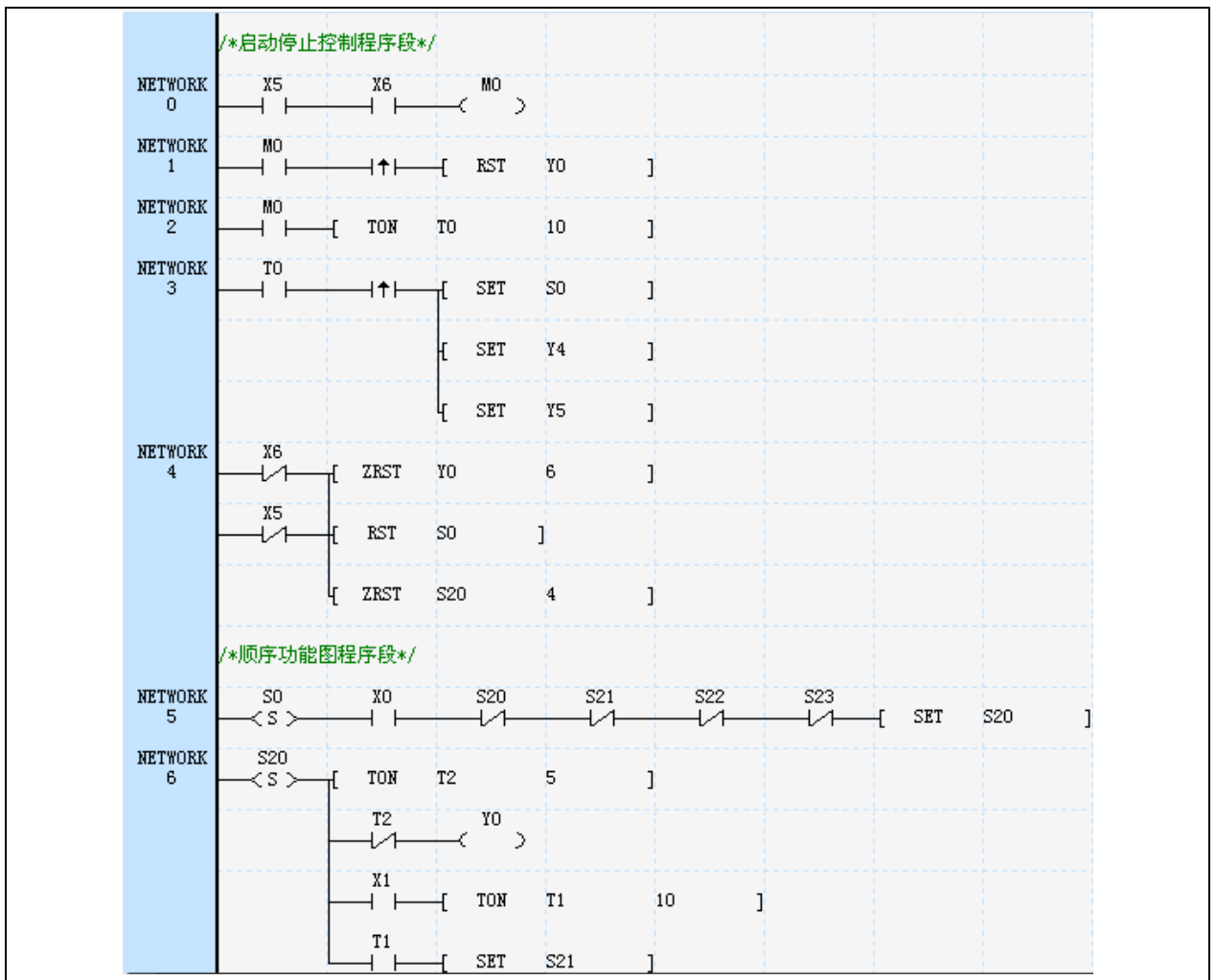
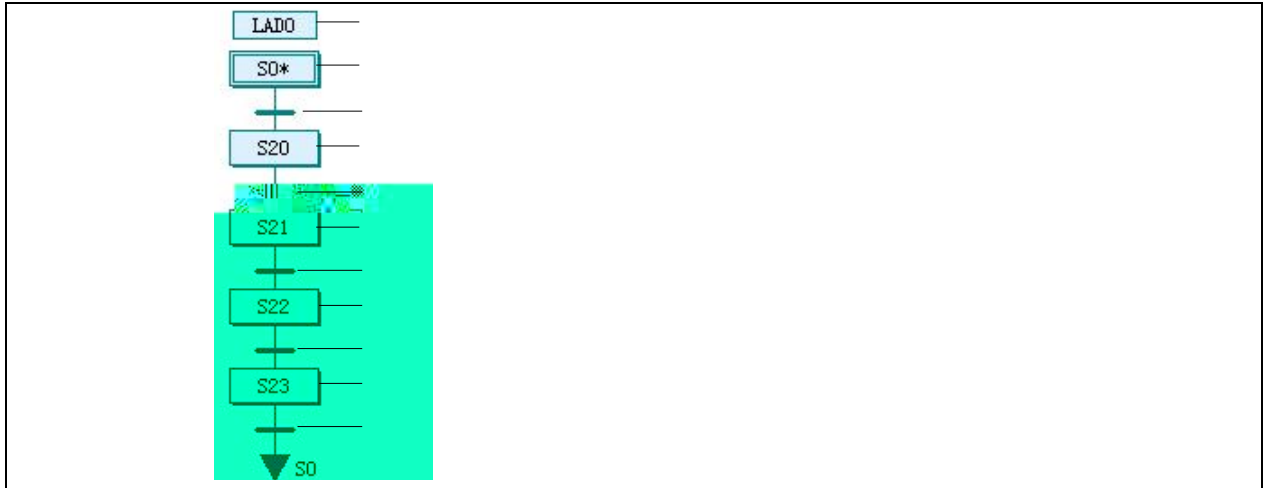
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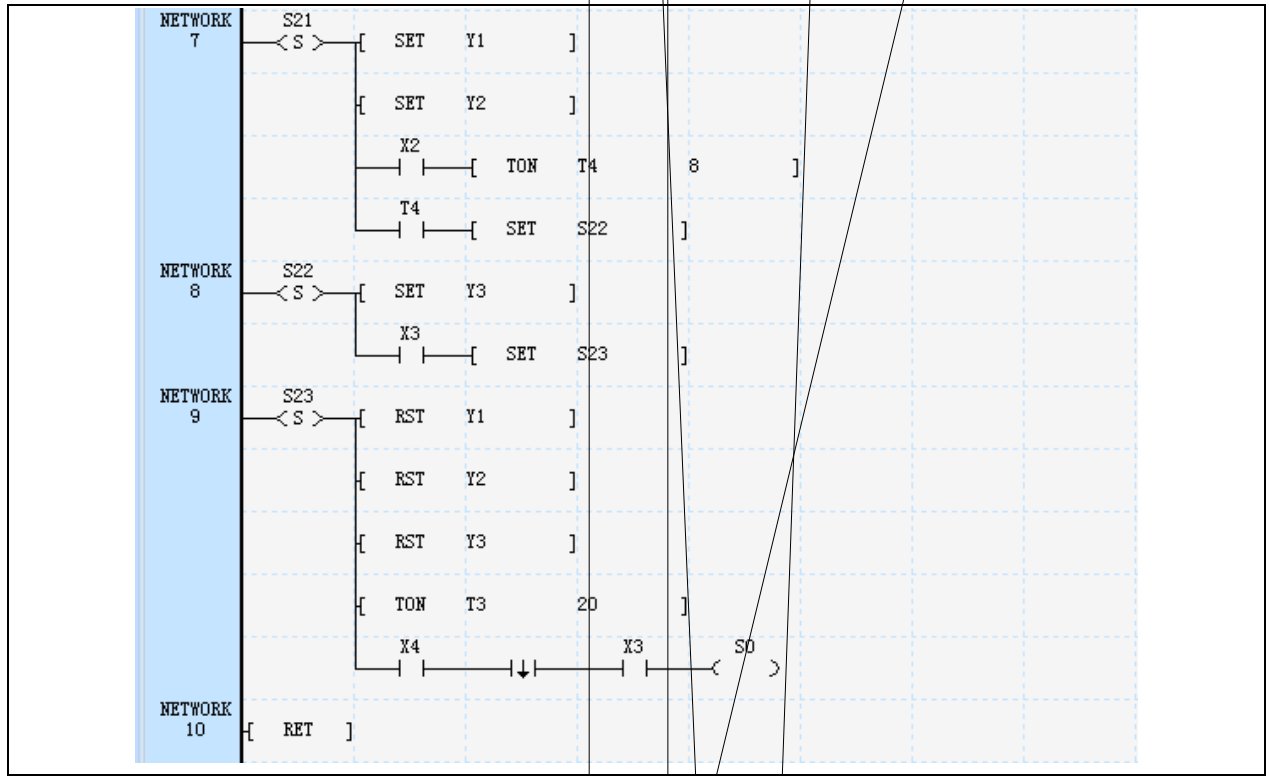
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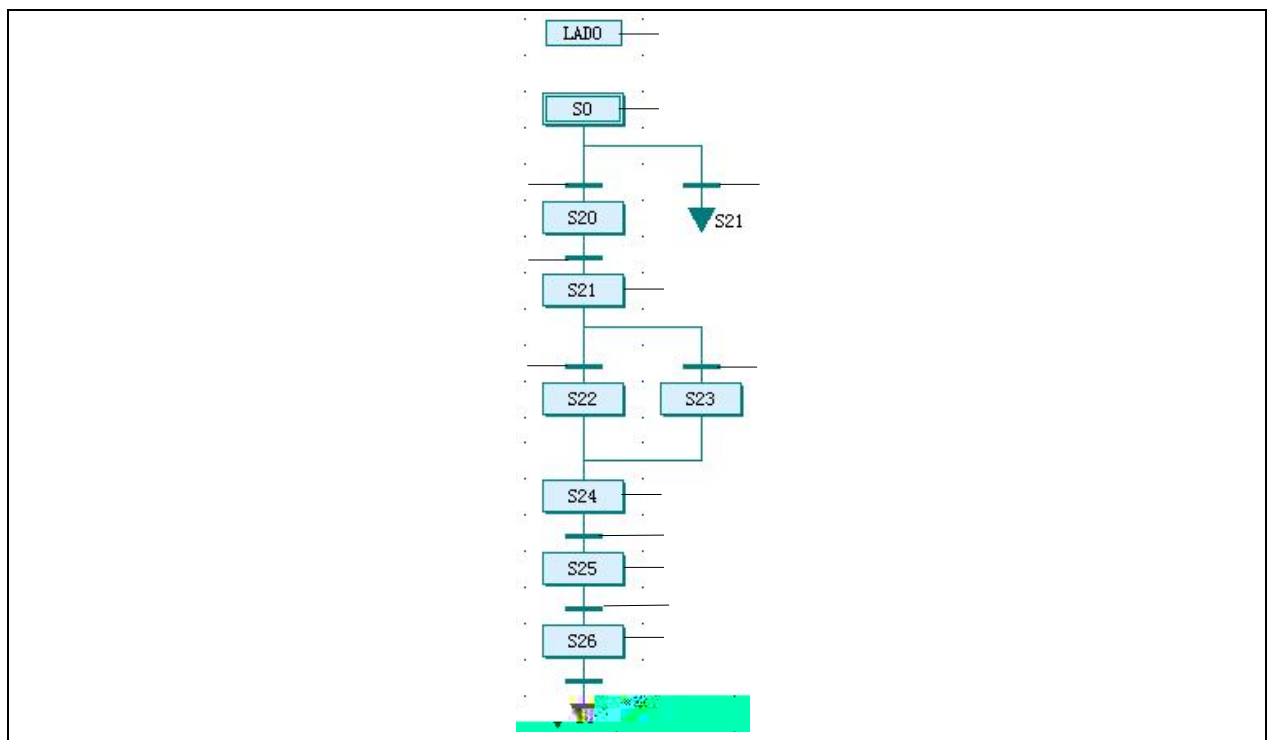
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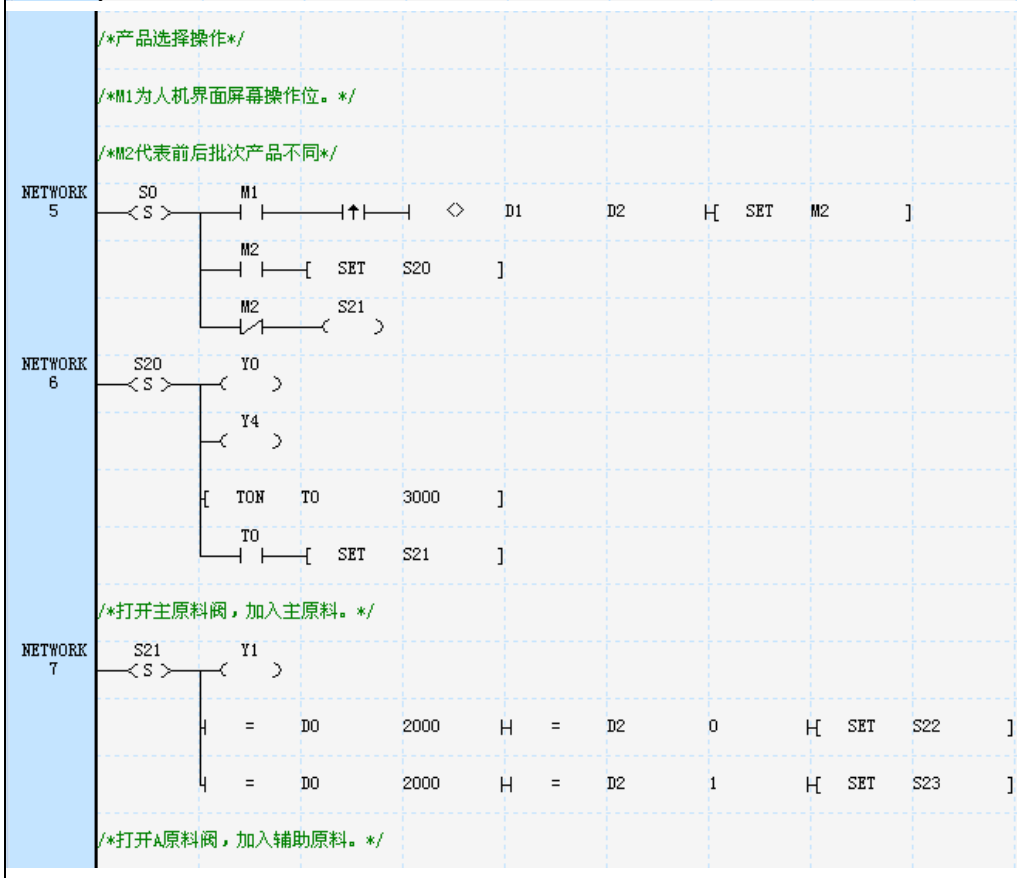
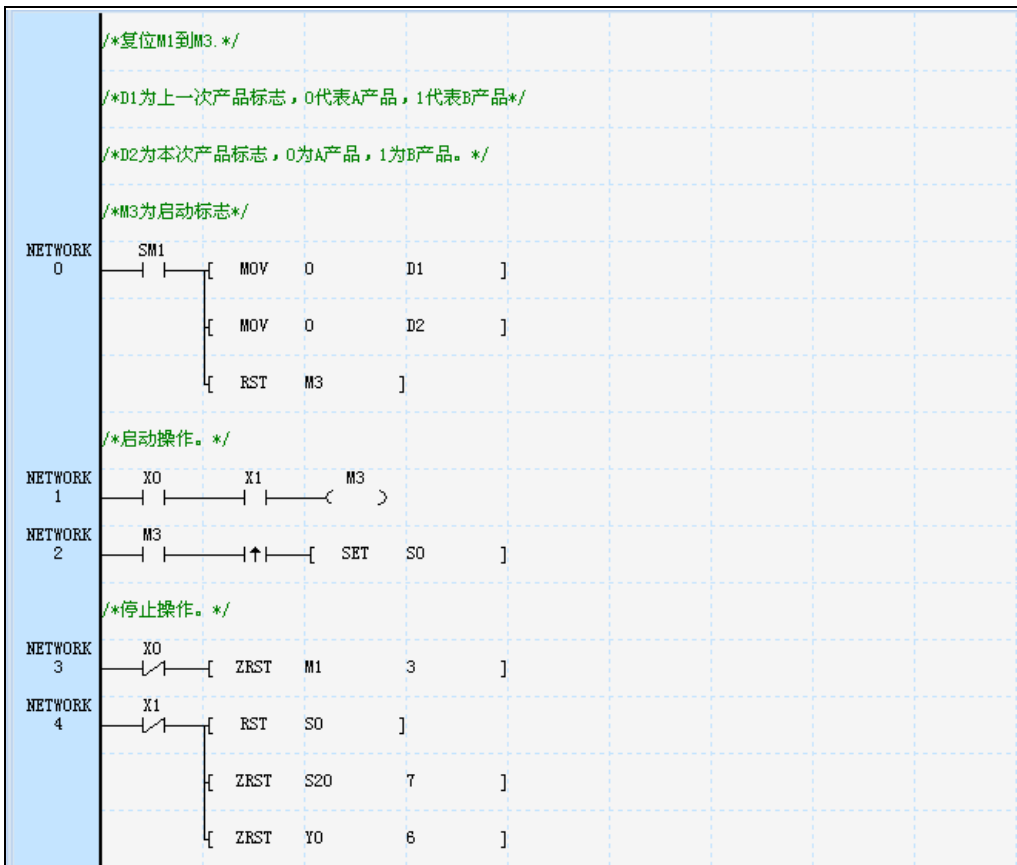
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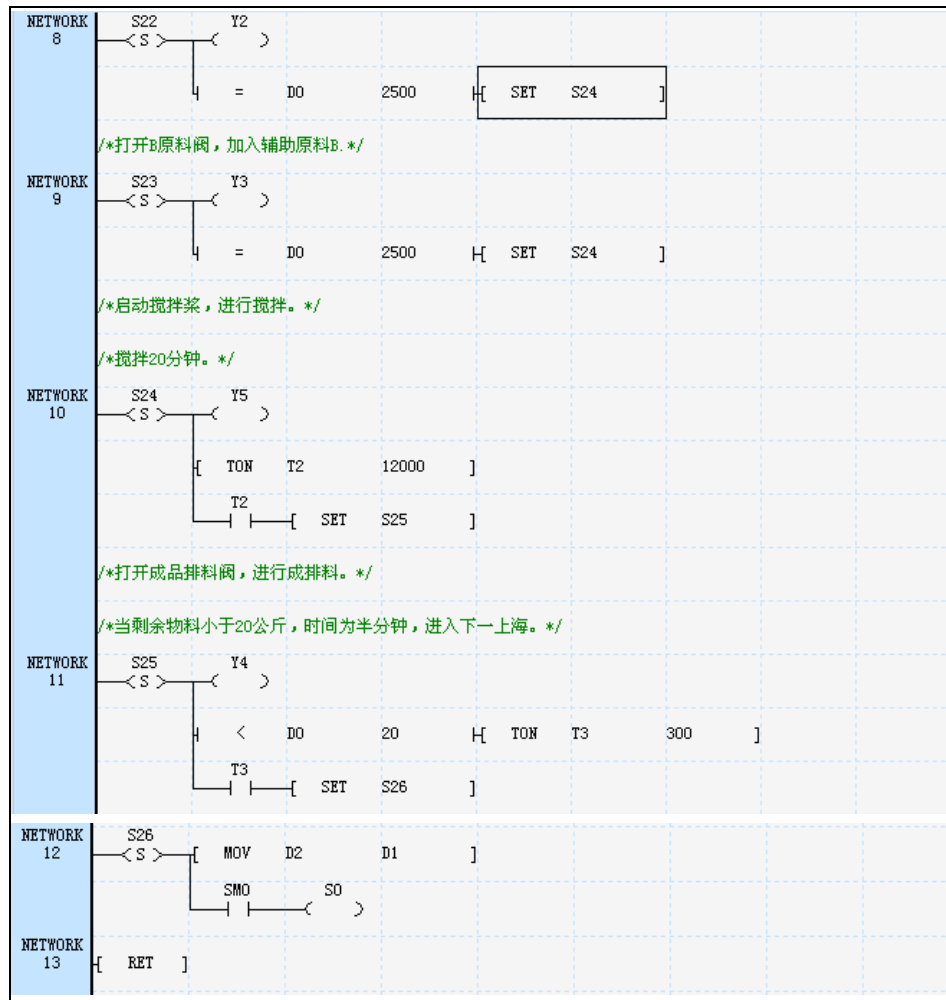
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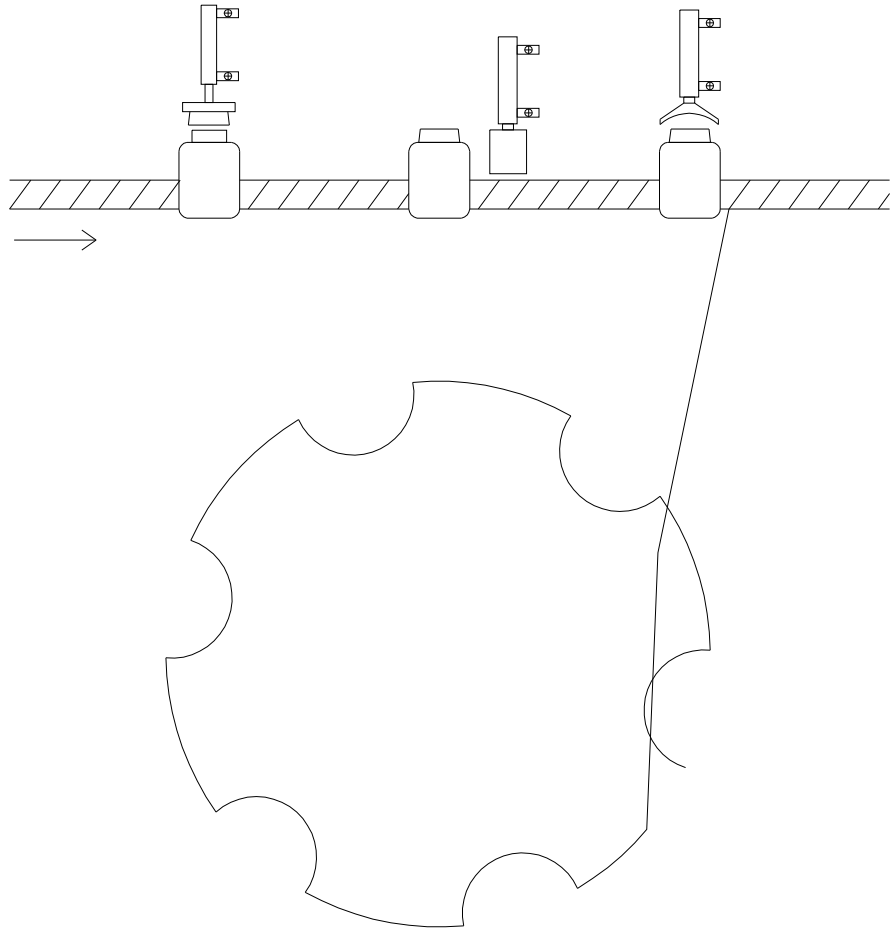


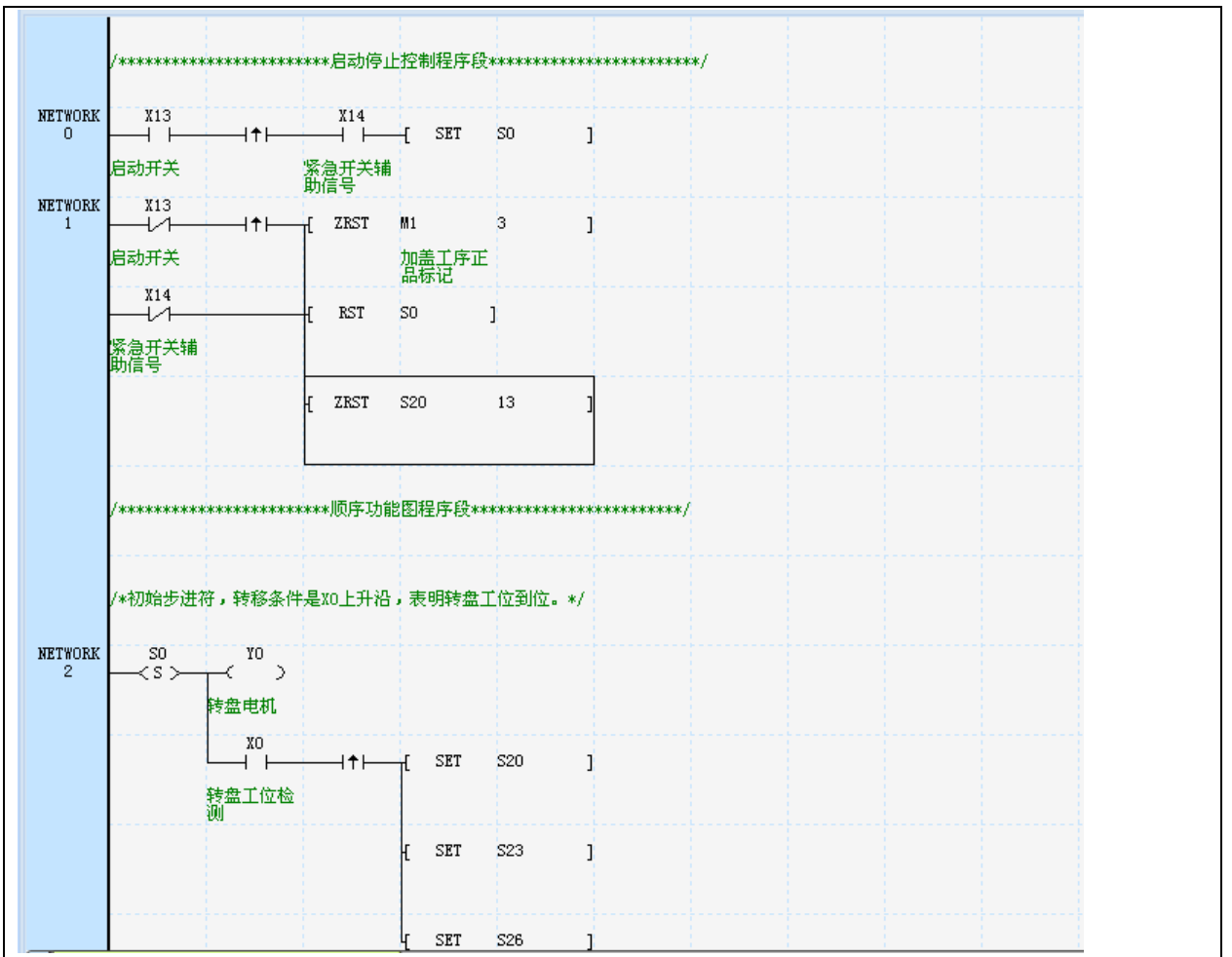
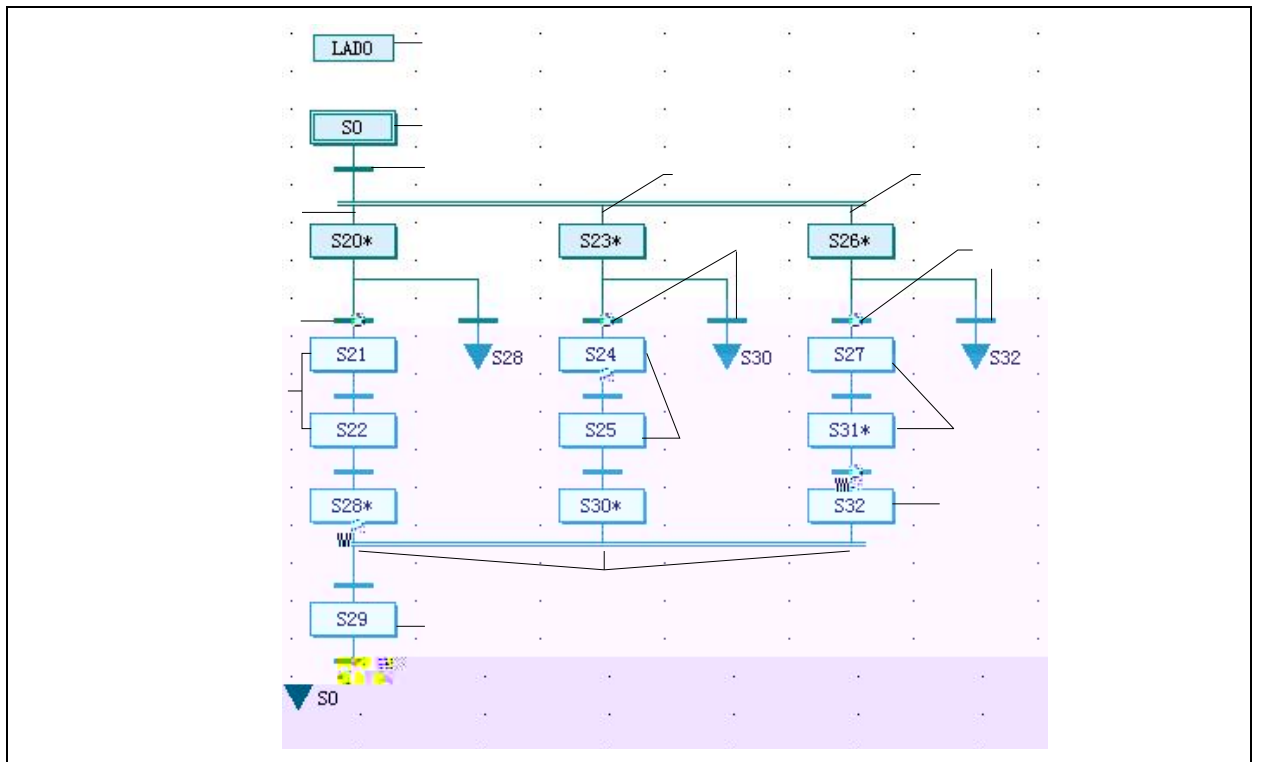




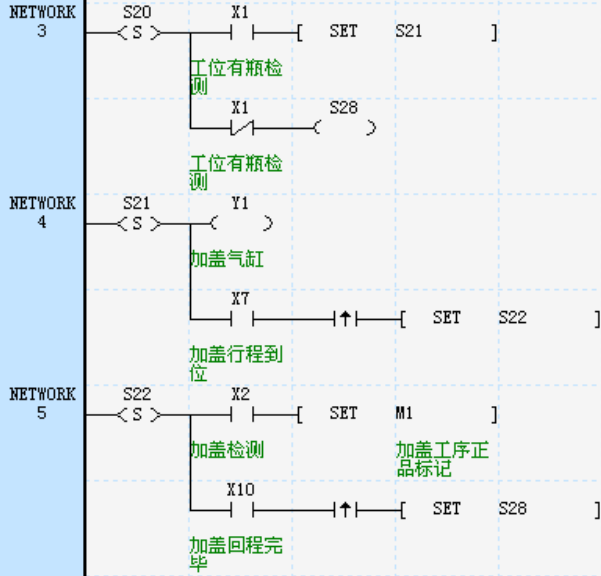




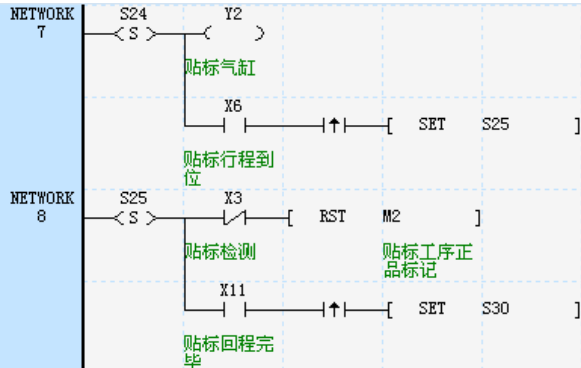
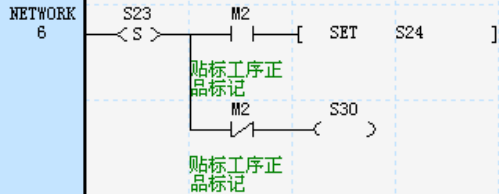




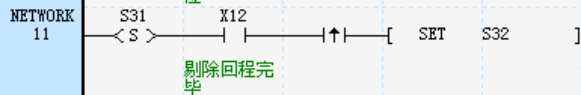
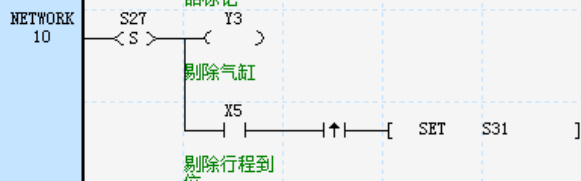
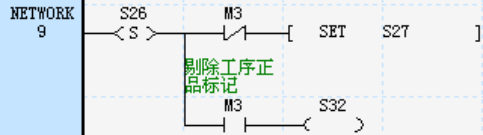
/*加盖工序流程*/

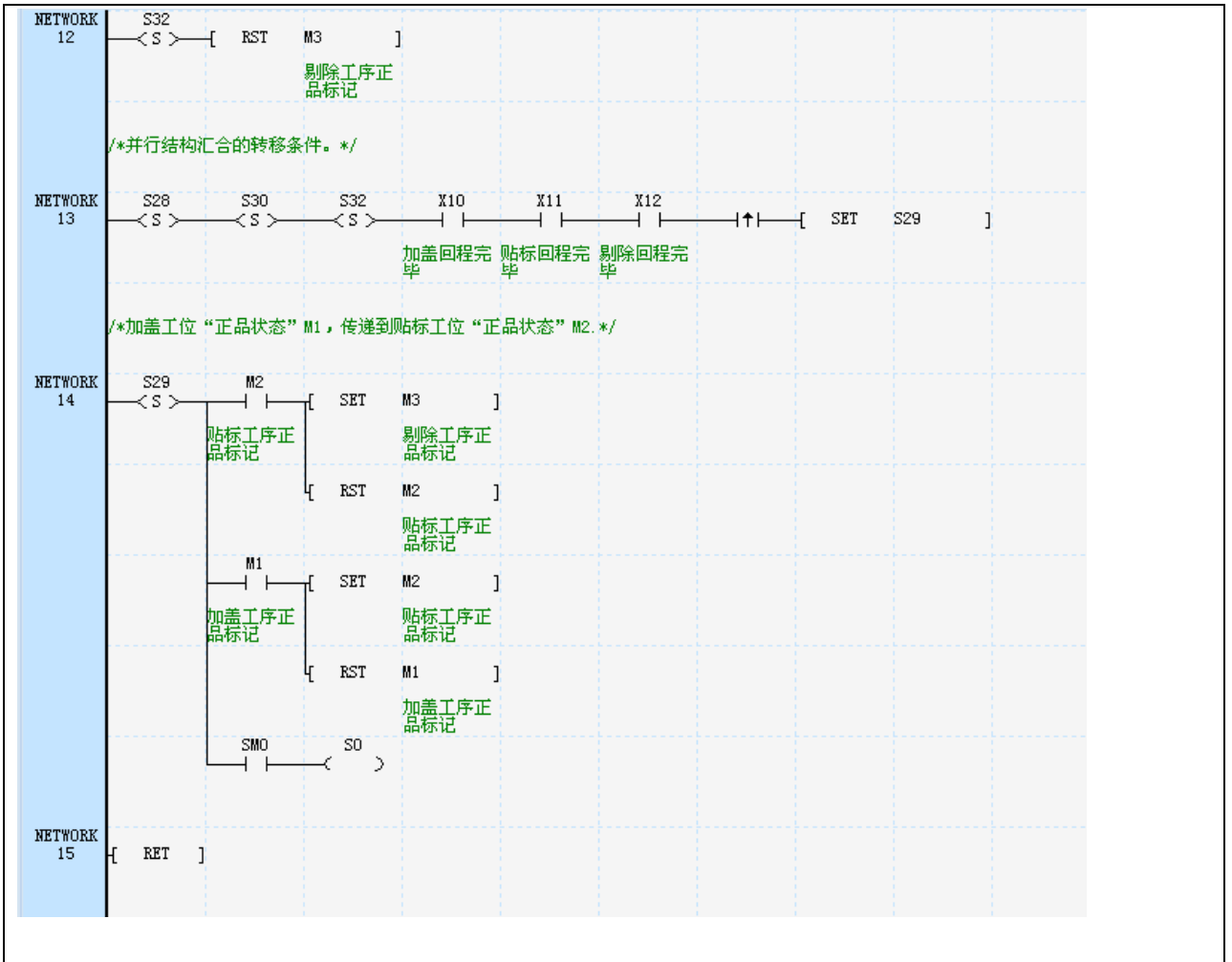


/*贴标工序流程*/



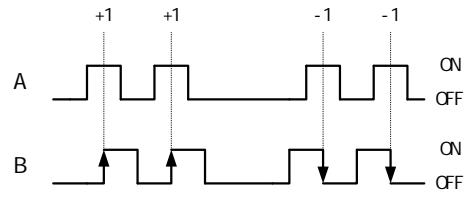
/*剔除工序流程*/

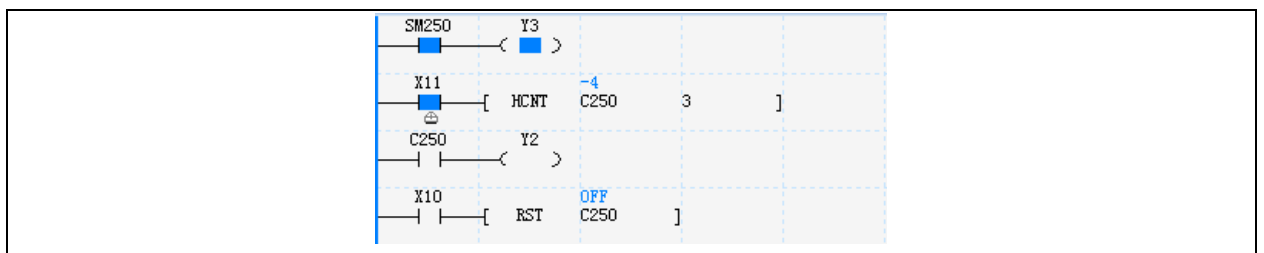
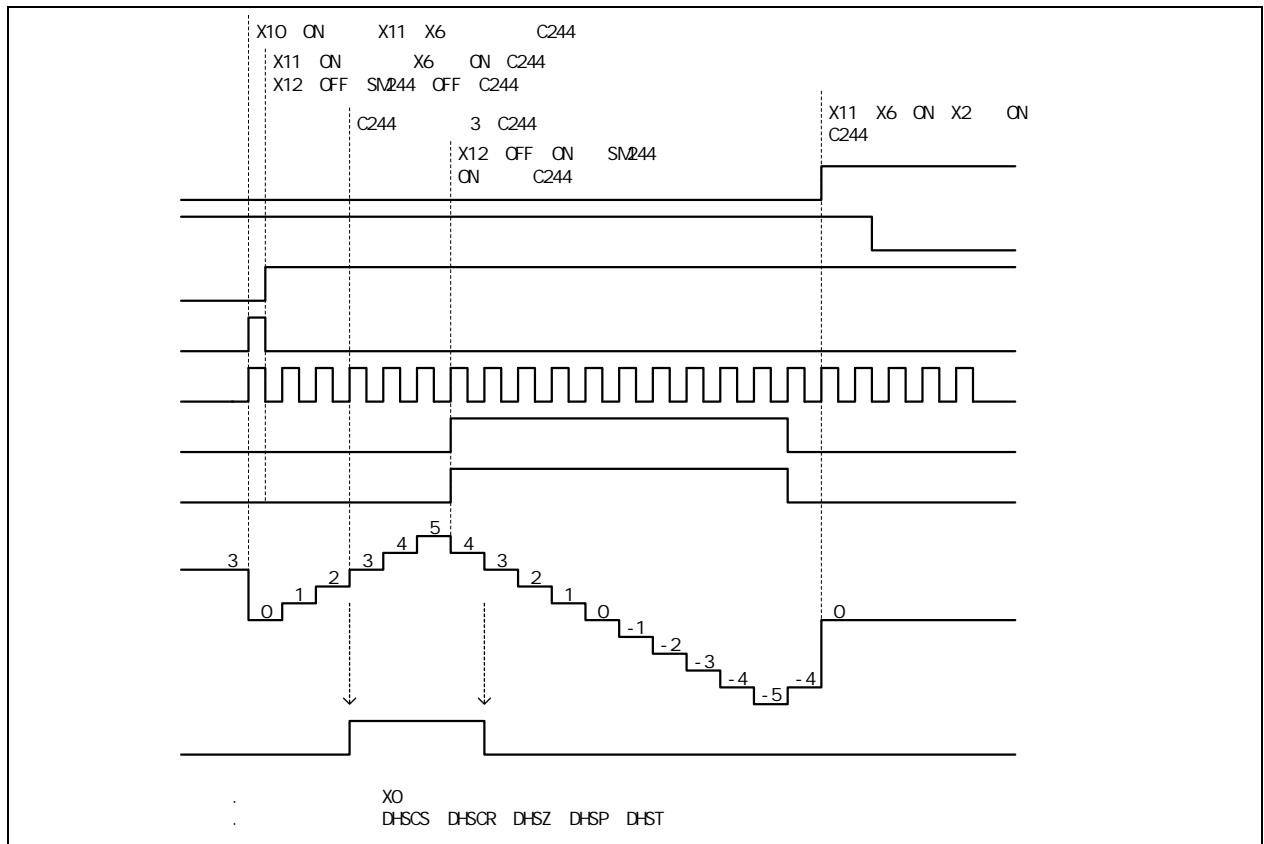
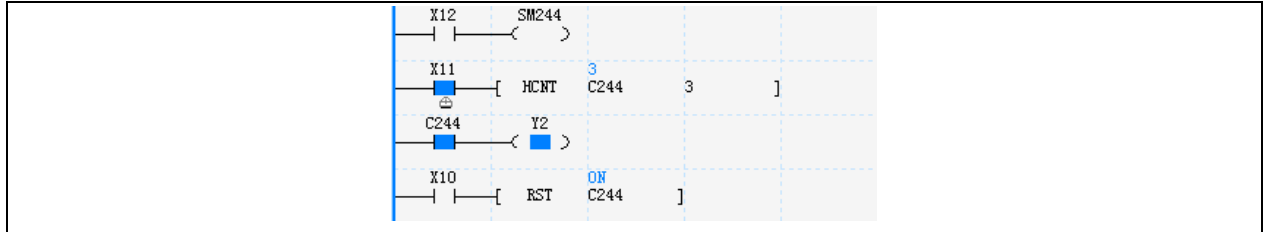


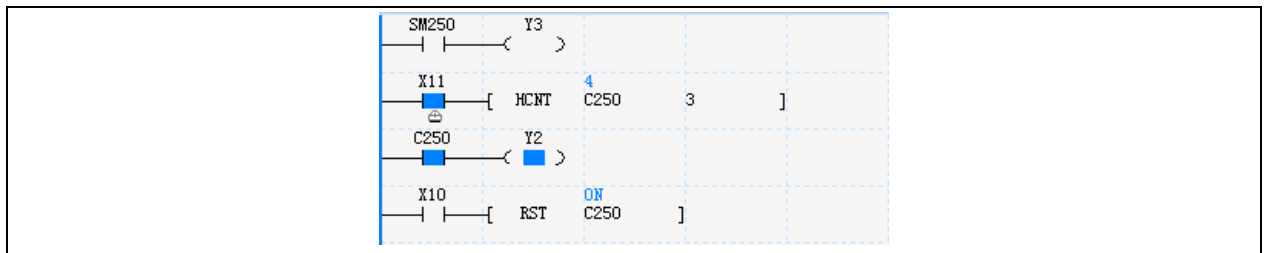
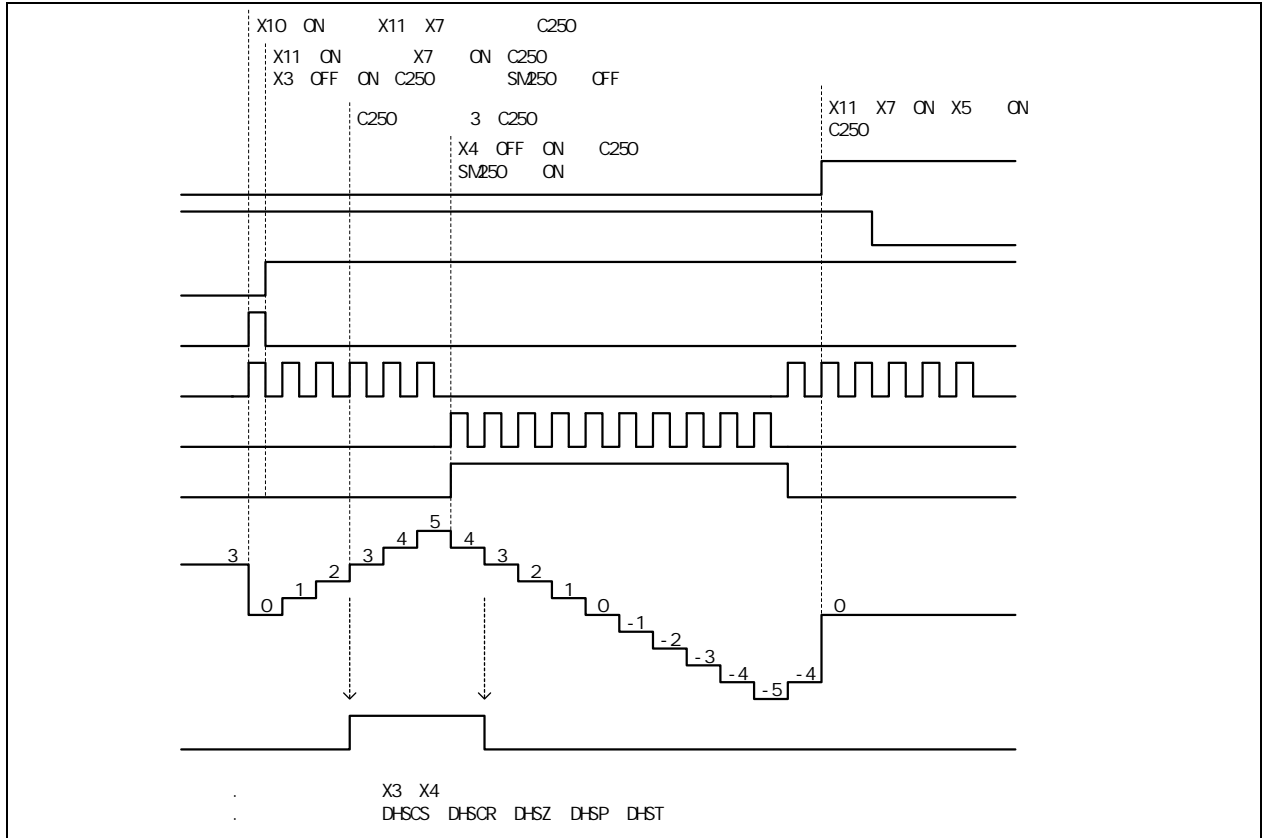


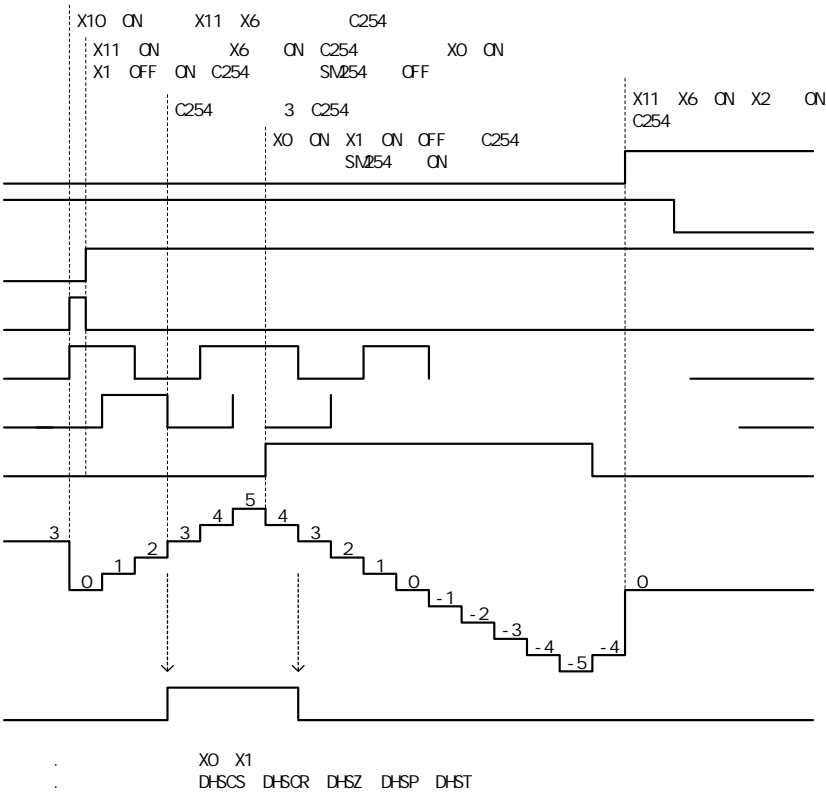
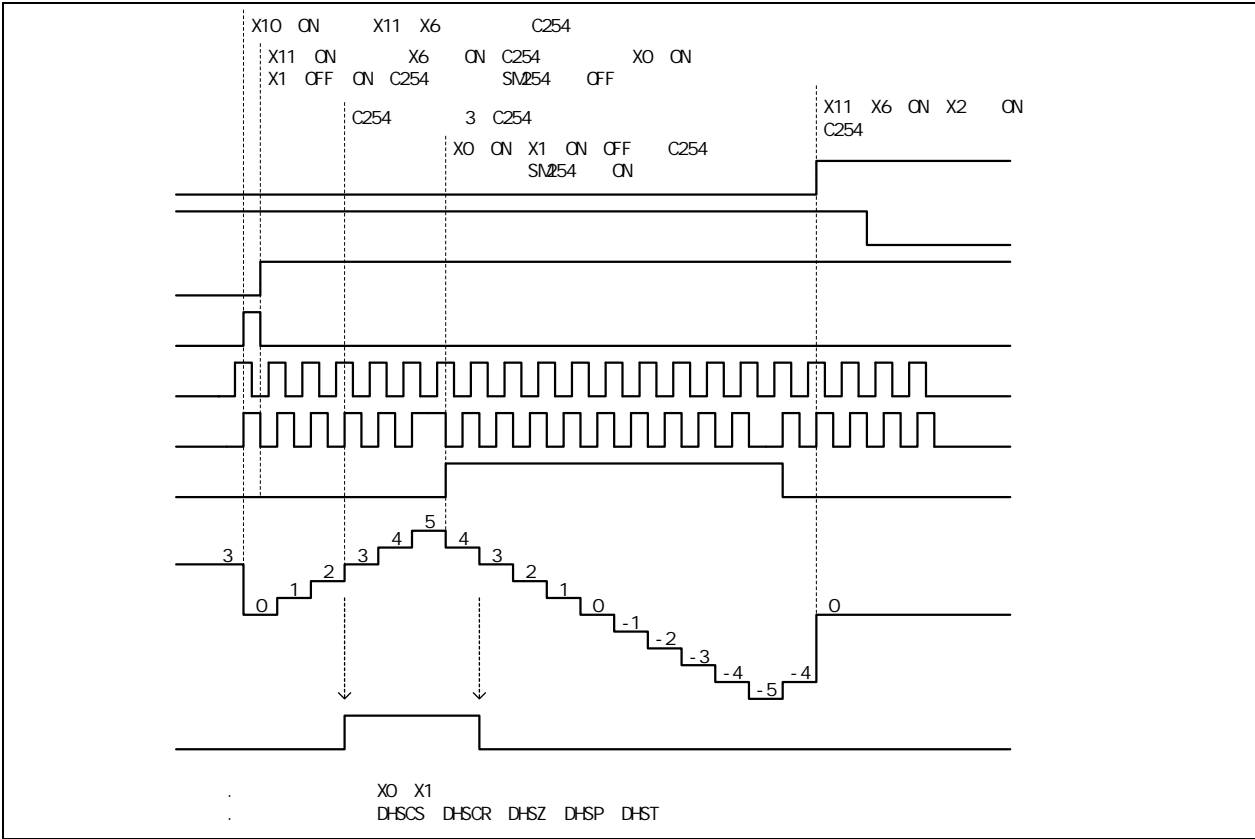
										Date	
										Month	Year

Total	



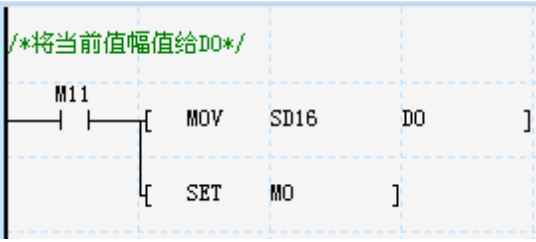






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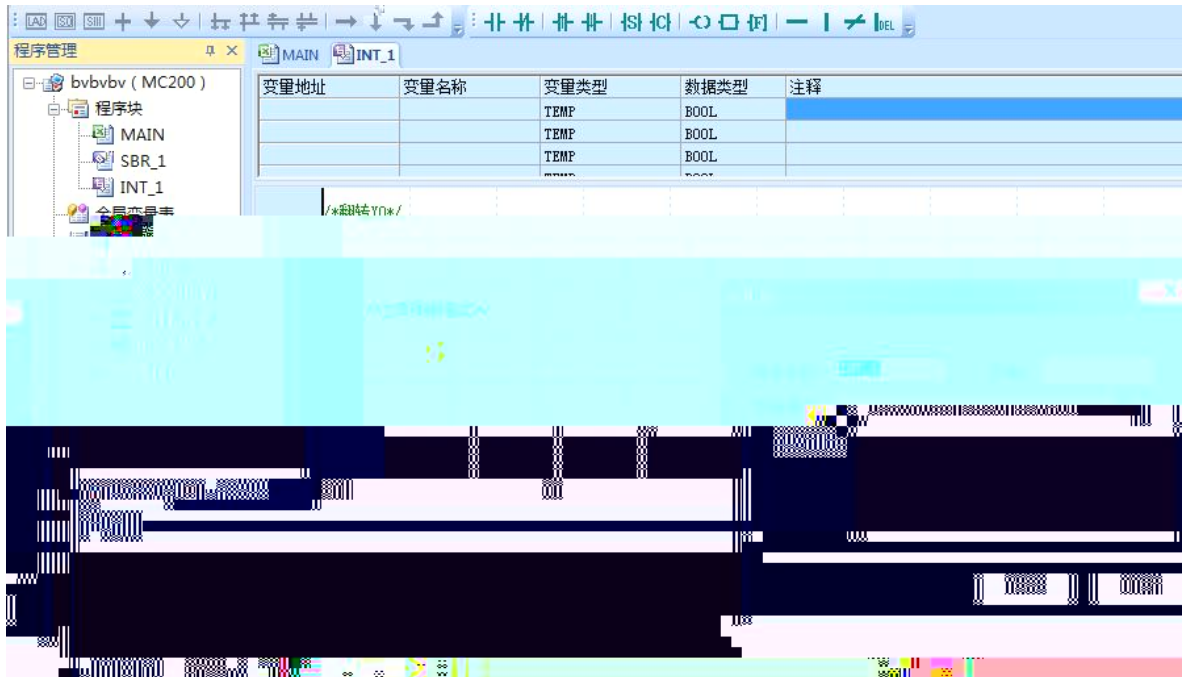
tsa

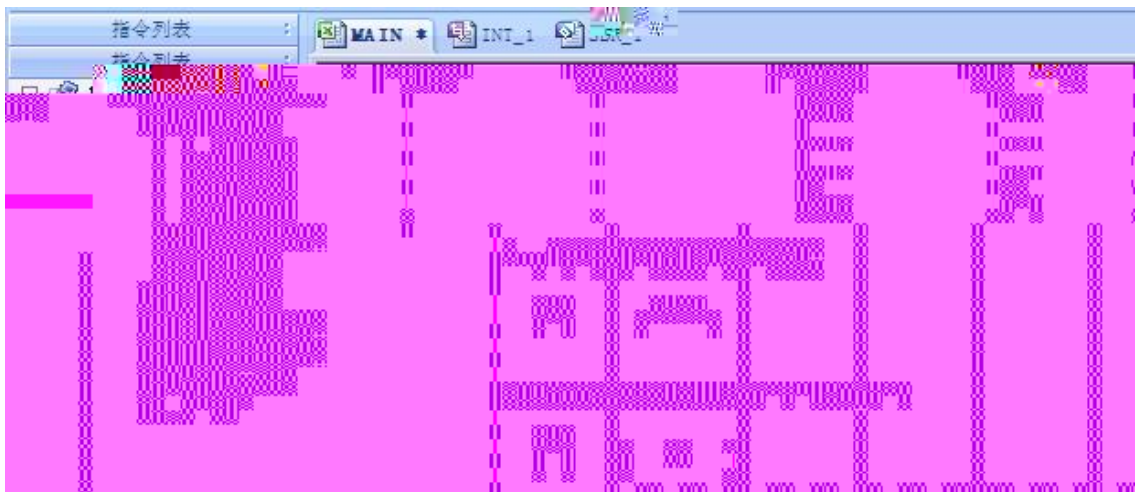
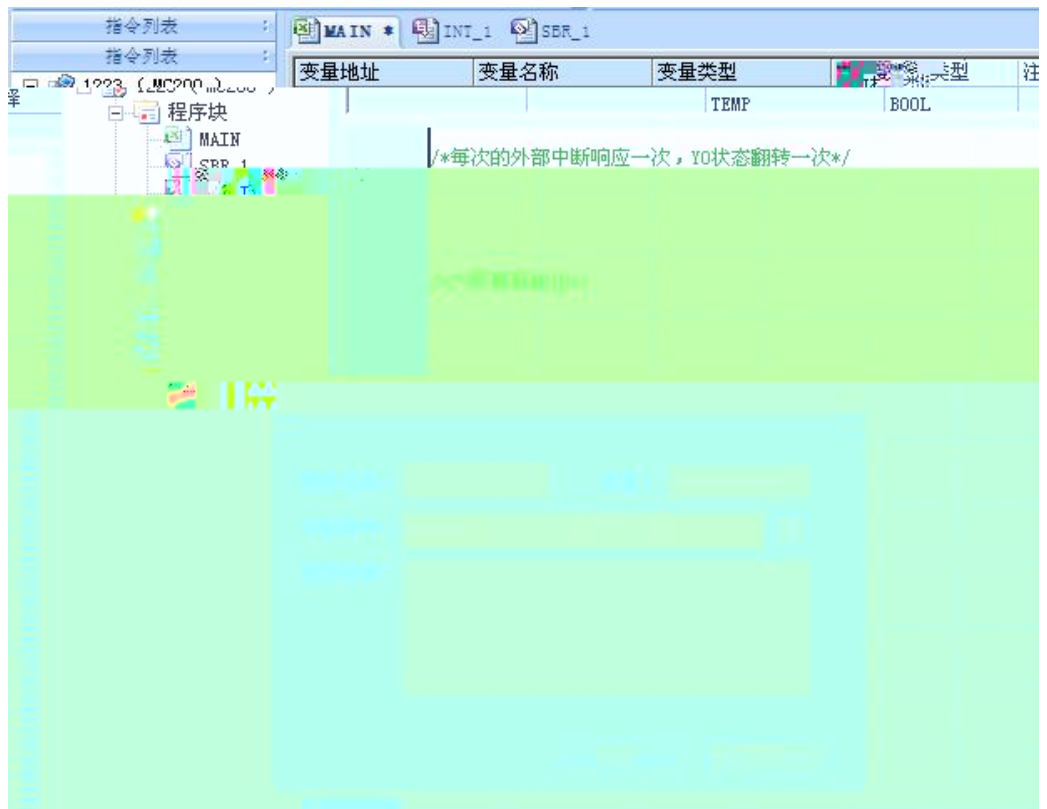
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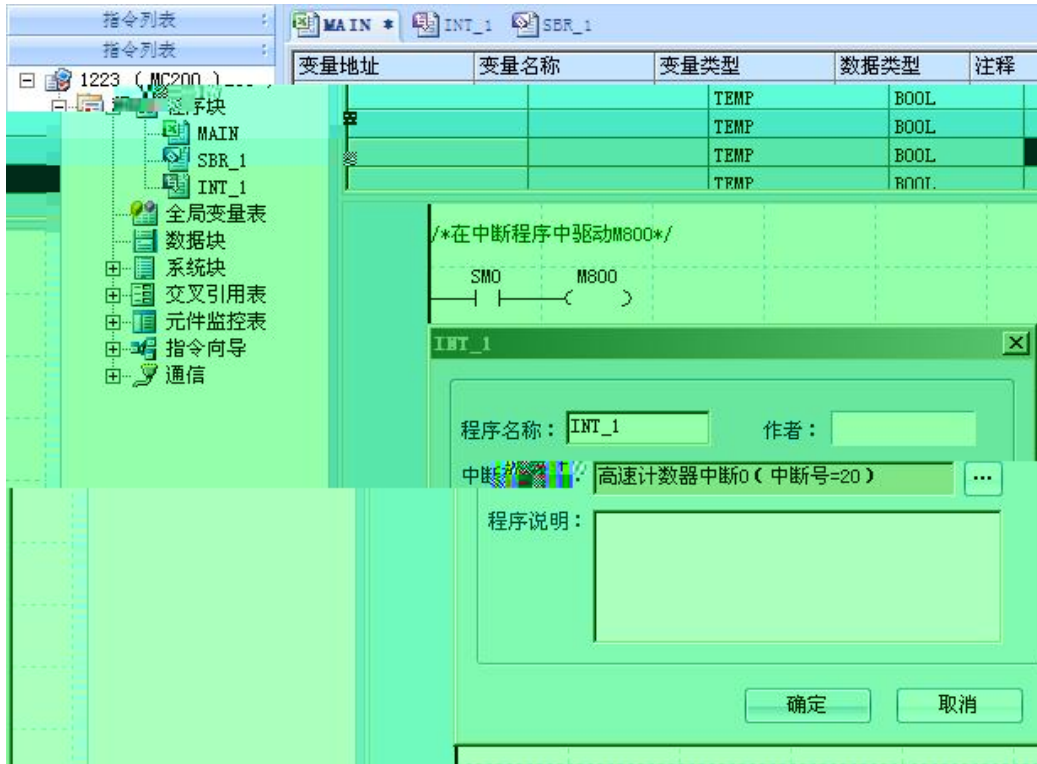












指令列表

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: 作者:

中断事件: ...

程序说明:

确定 取消

指令列表

1223 (MC200)

- 程序块
 - MAIN
 - MATN
 - 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 ]
  
```

}

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

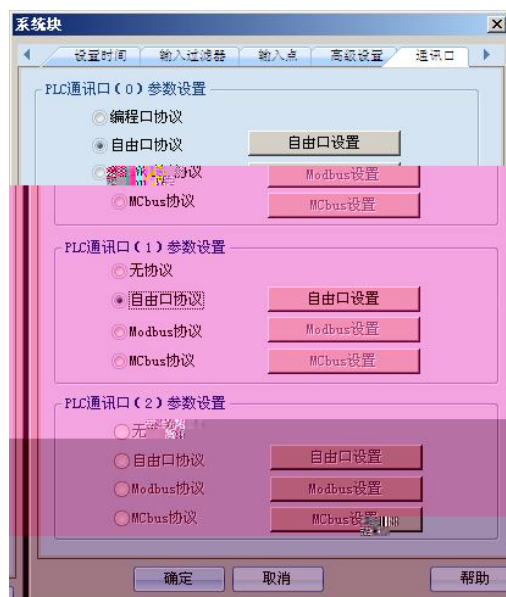
变量地址 | 变量名称 | 变量类型 | 数据类型 | 注释

		TEMP	BOOL	
		TEMP	BOOL	
		TEMP	BOOL	

```

/*使系统中断使能有效*/
SMO
|-----| [ EI ]

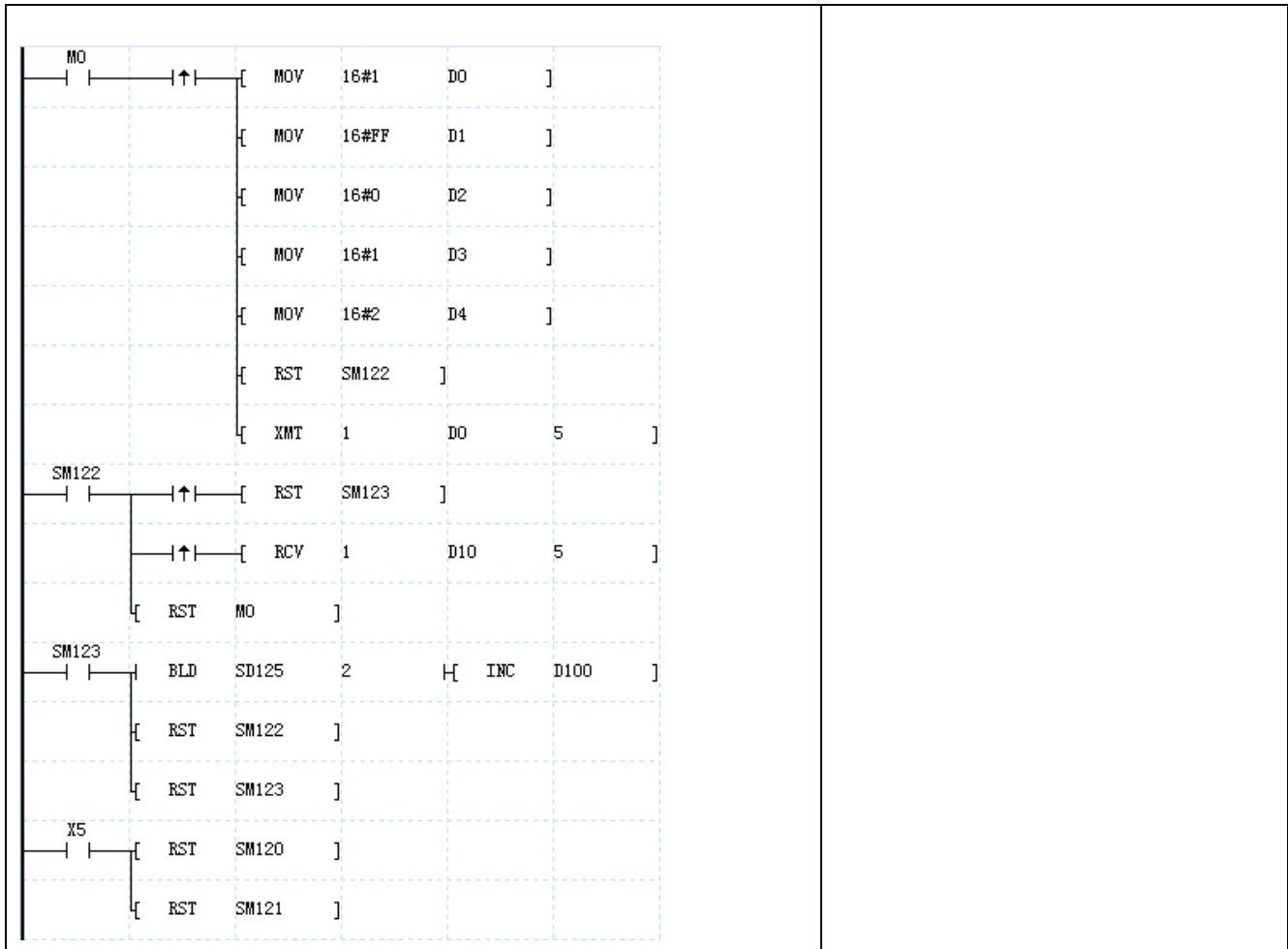
/*使XOM1发送帧中断有效*/
SM1
|-----| [ SET SM54 ]
  
```



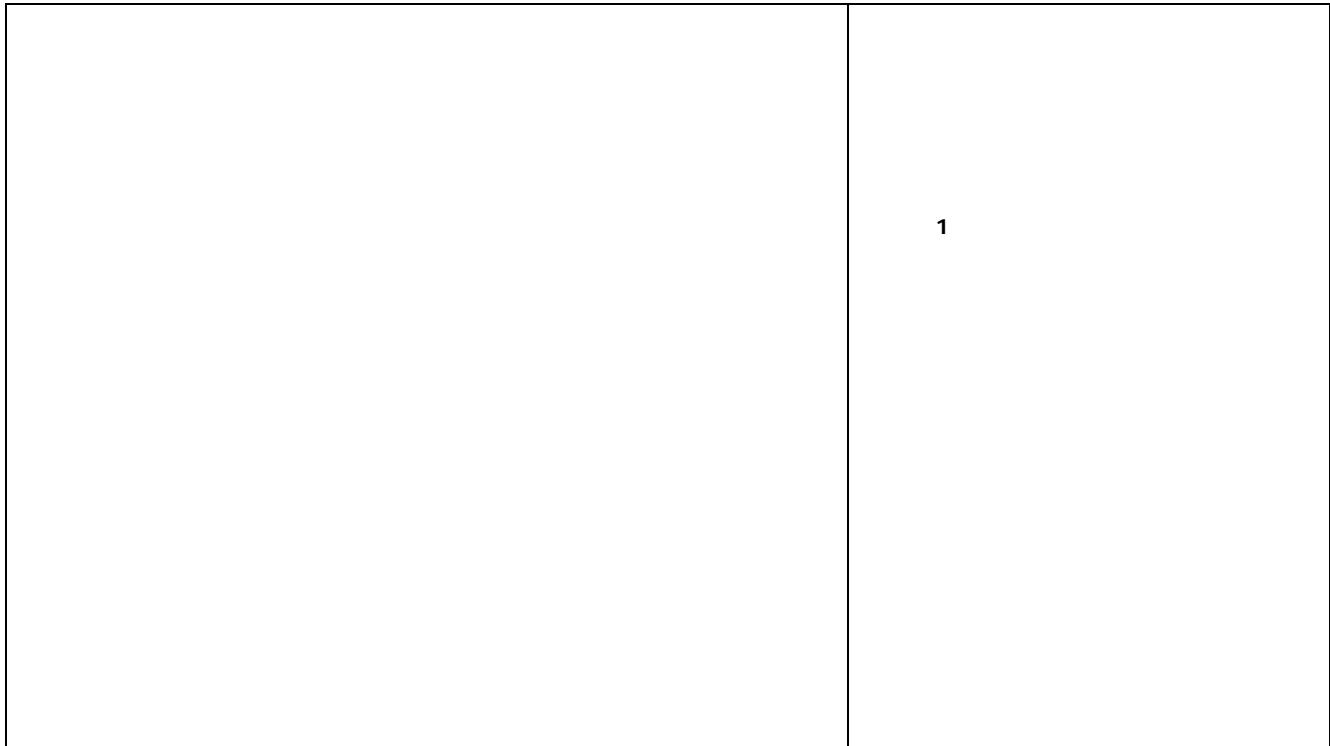


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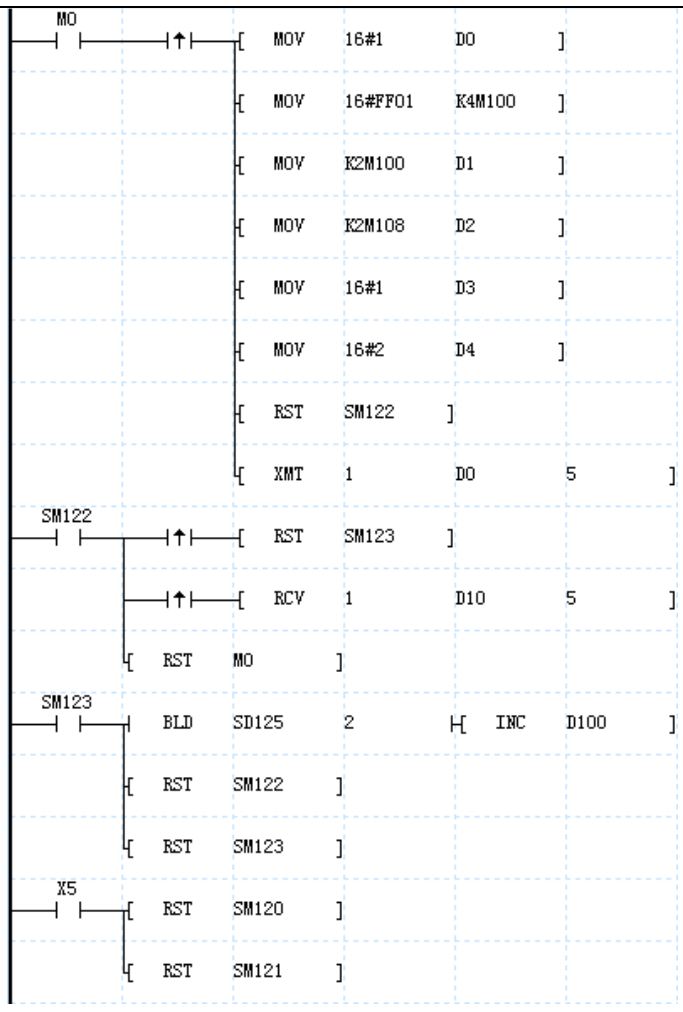




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x x x

x x x

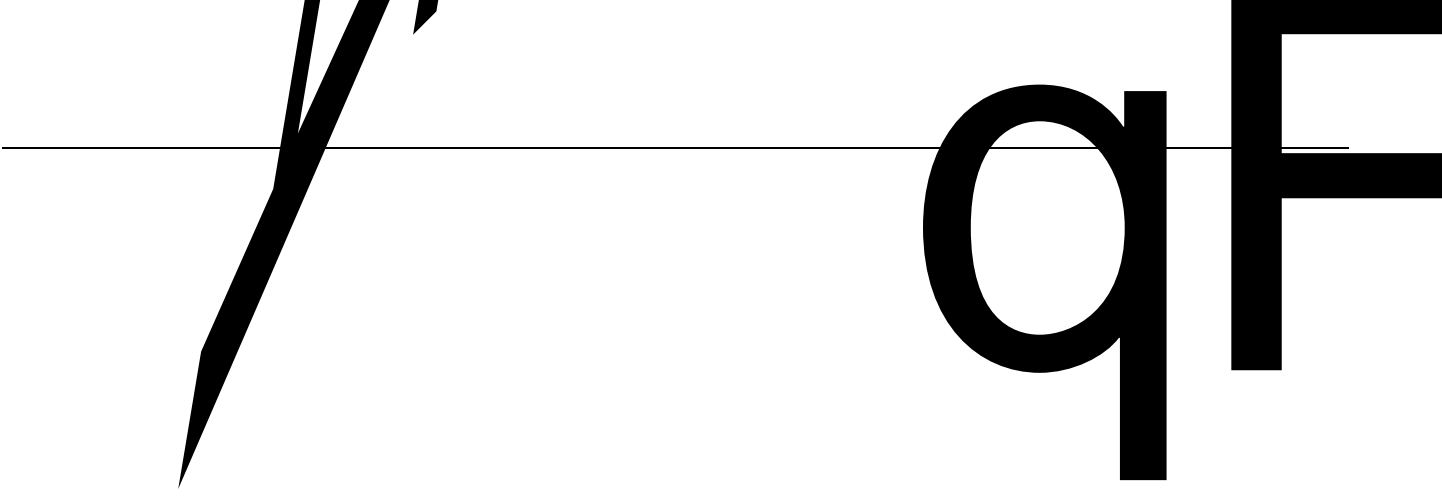
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" "

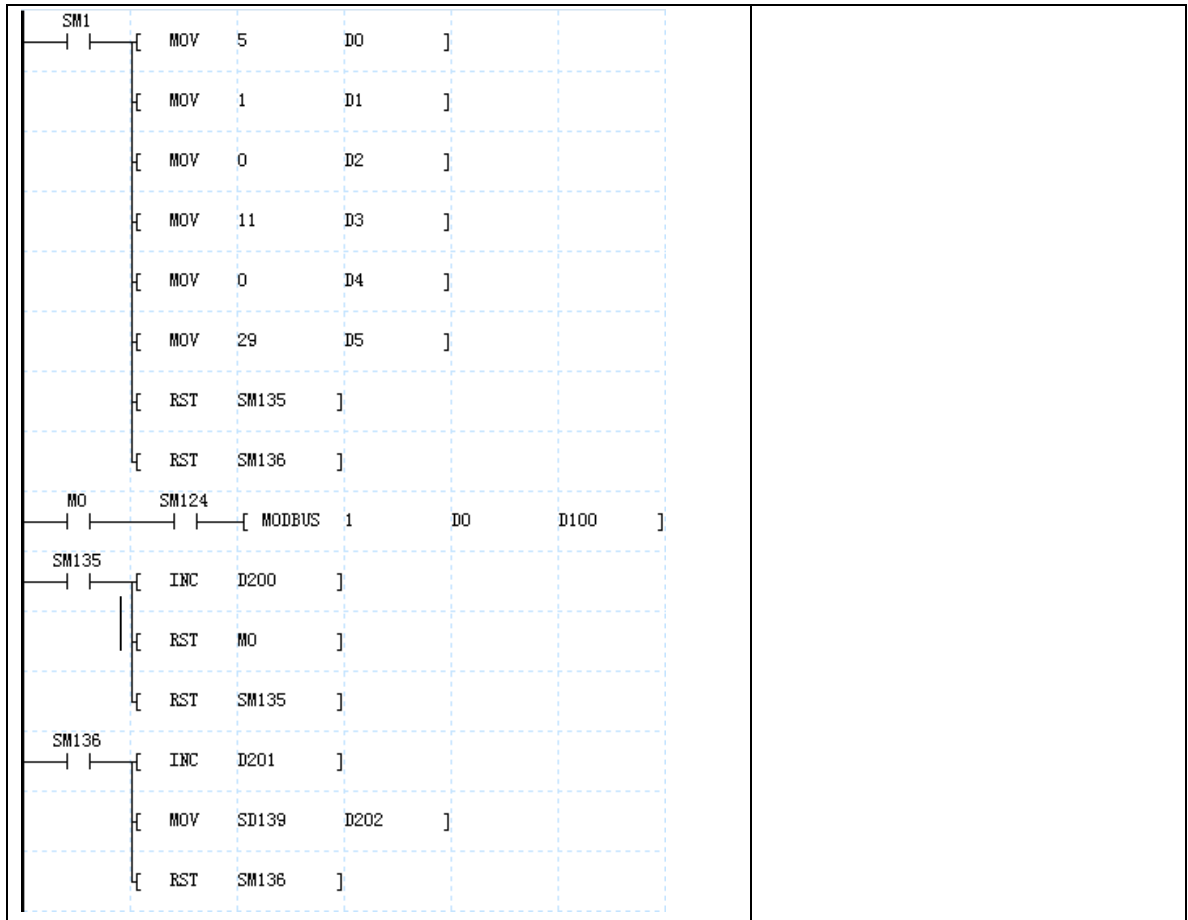
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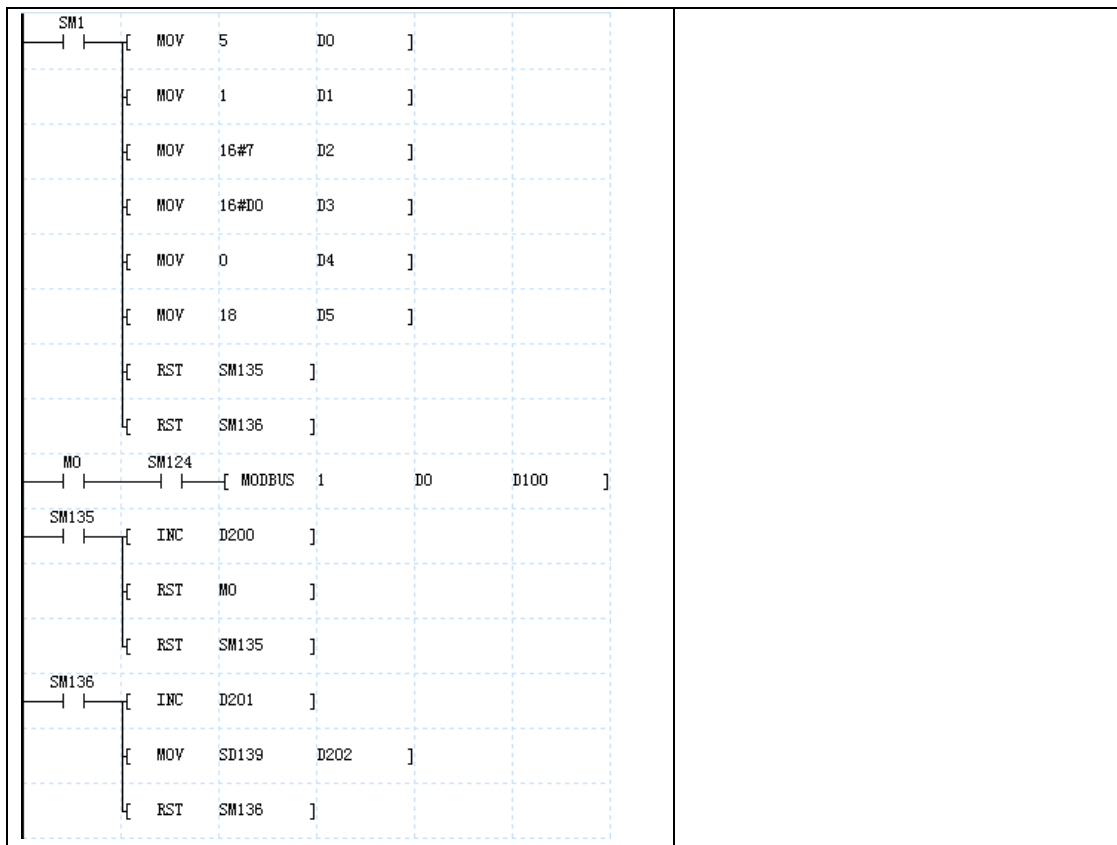
6121 Modbus

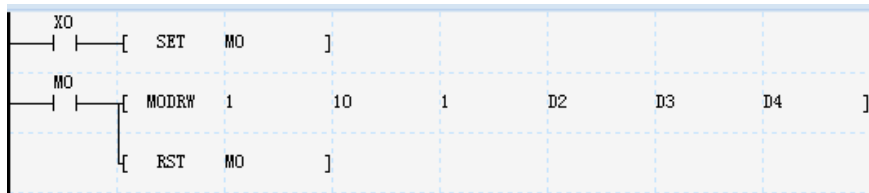
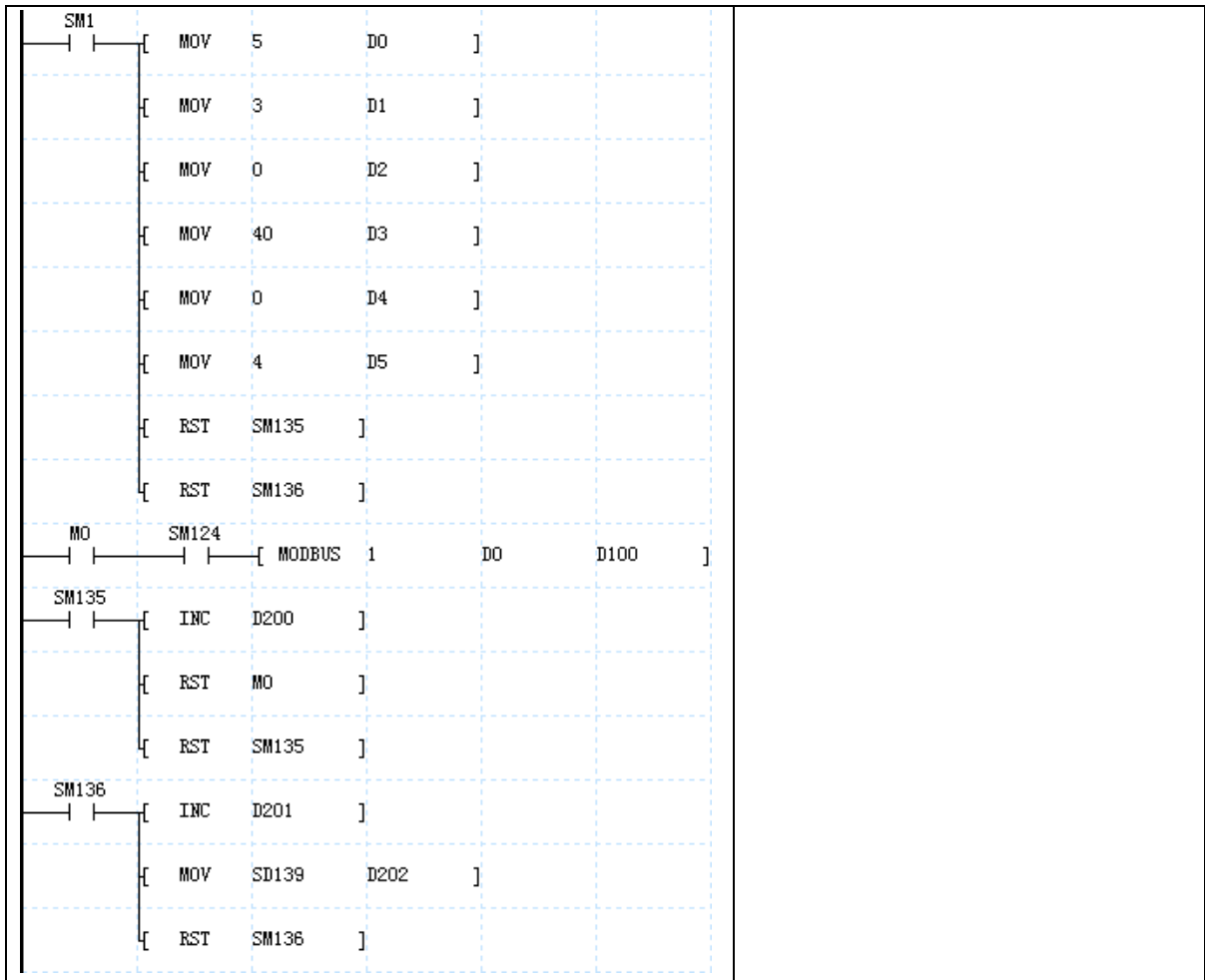
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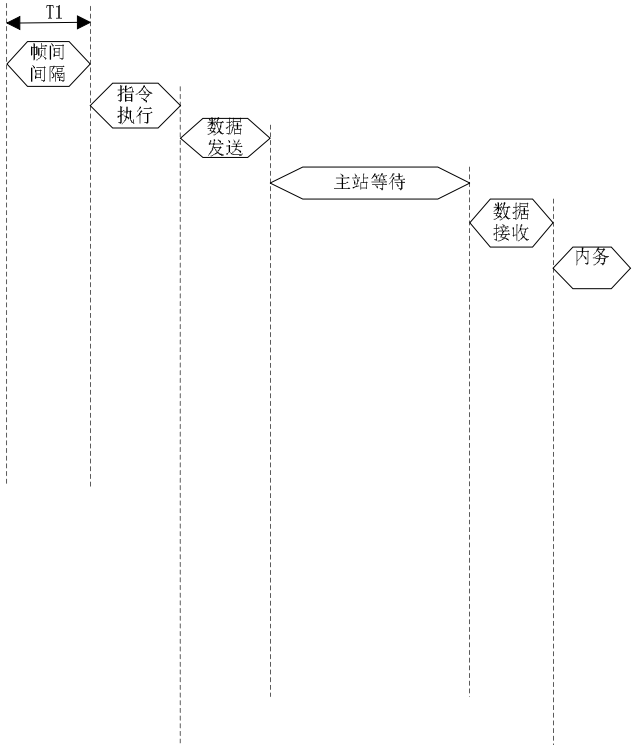




M0

SM30

SM135



T

T — *ms*

T — *ms*

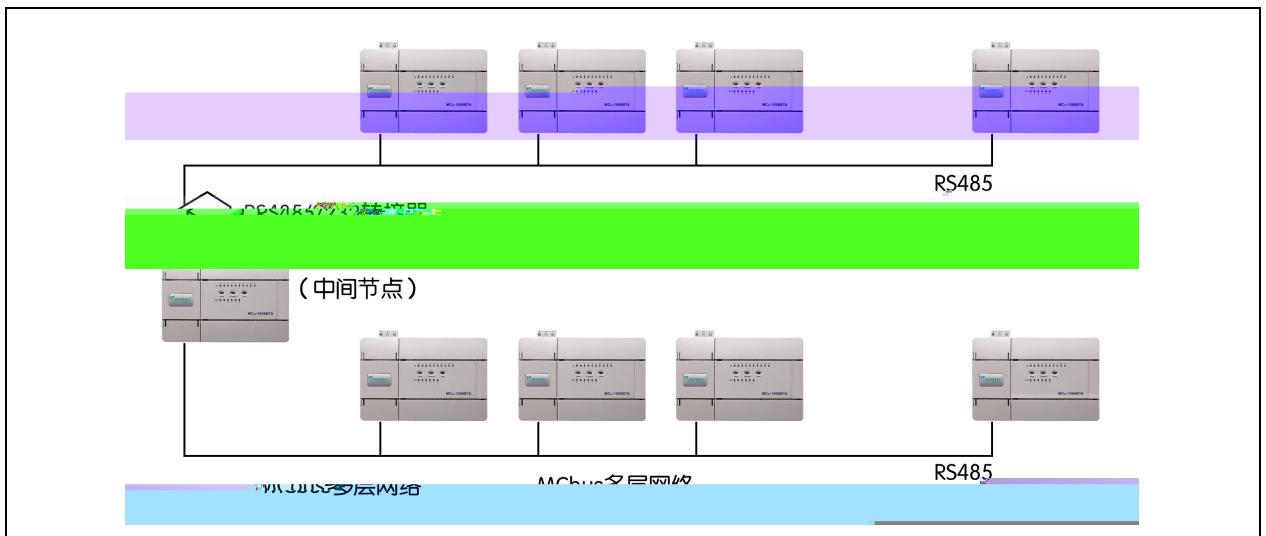
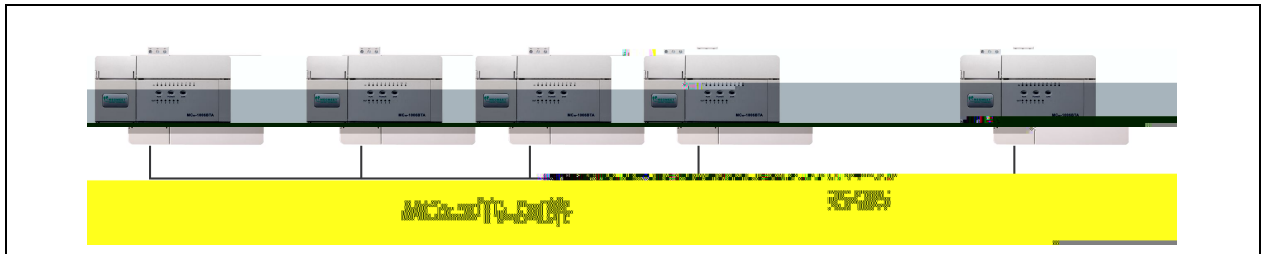
T T T ms

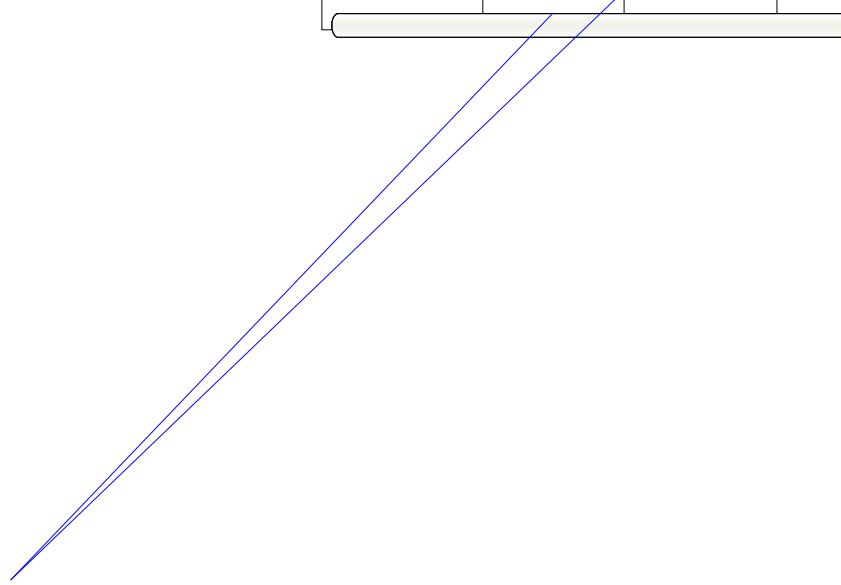
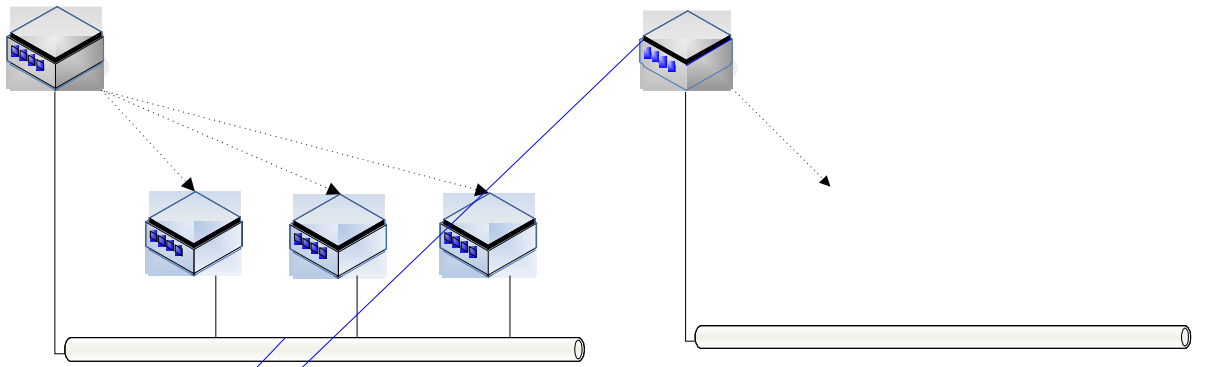
T ms

T ms

T INT — ms

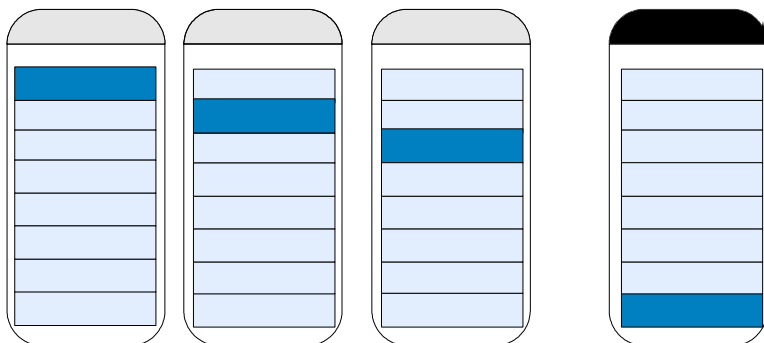
T ms

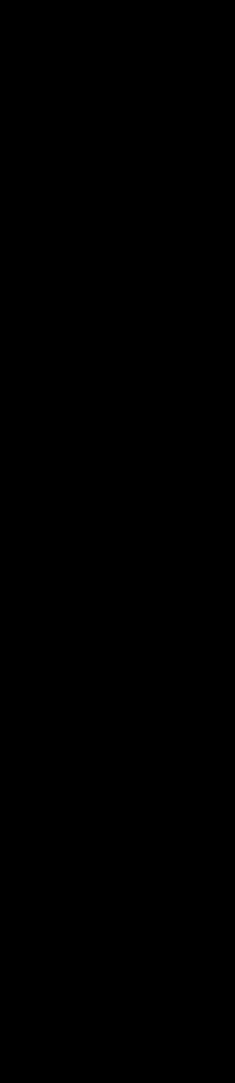




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MCbus

PLC

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PLC

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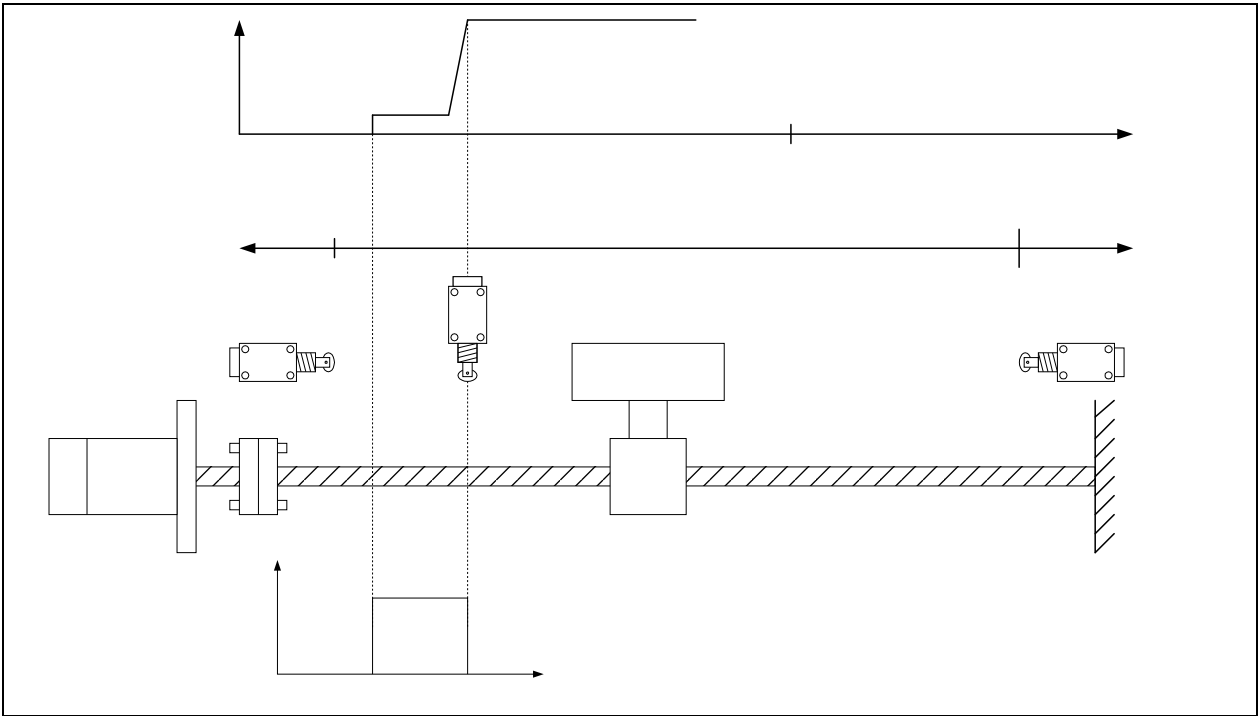
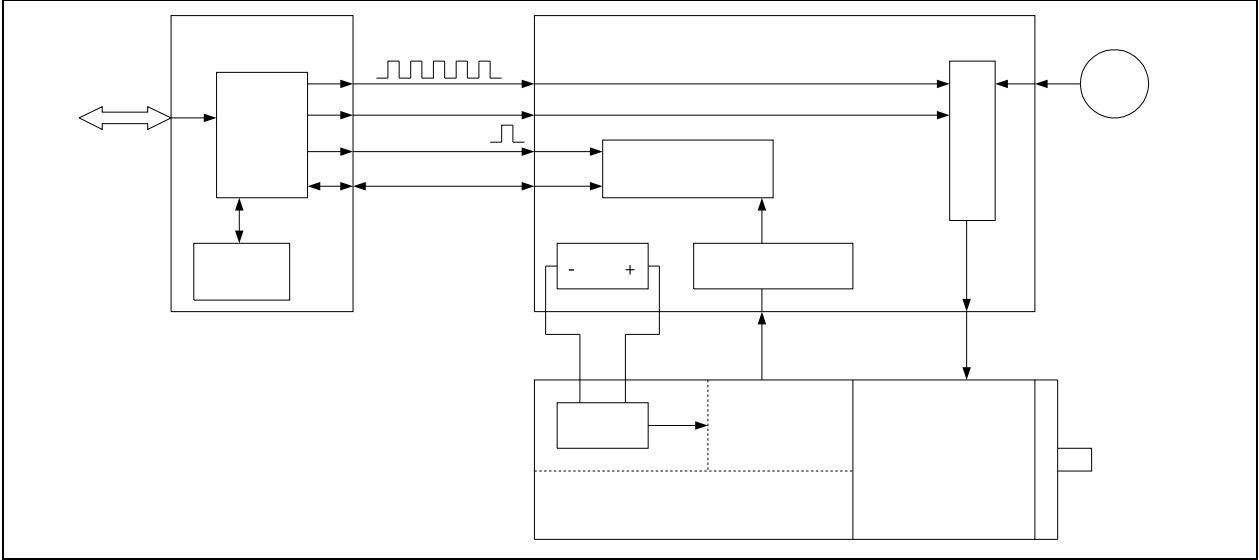
MCbus

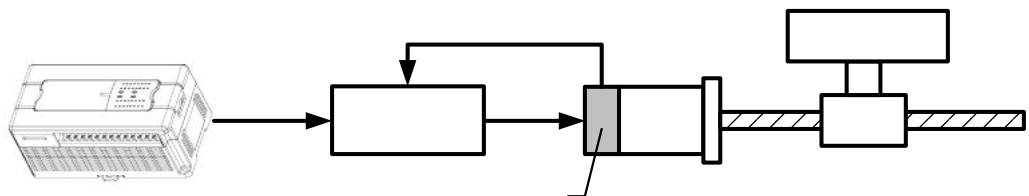
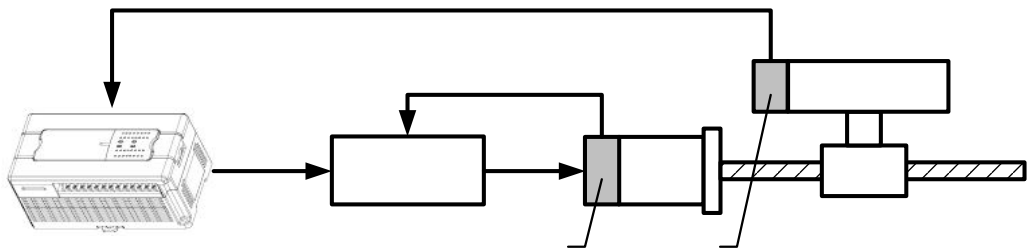
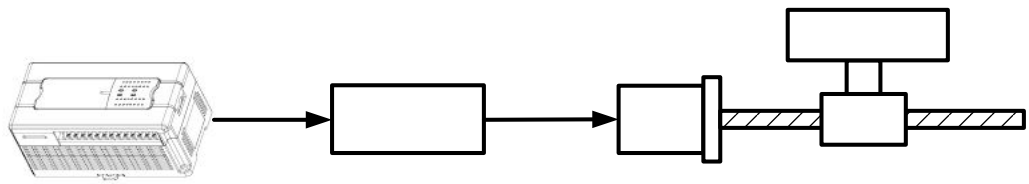


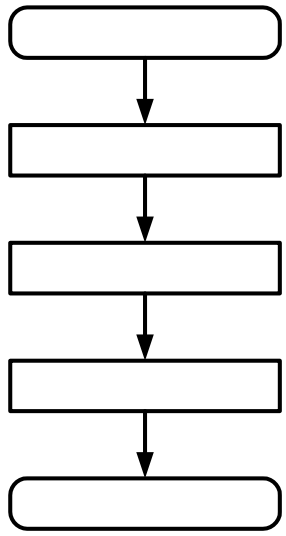
MCbus

MCbus

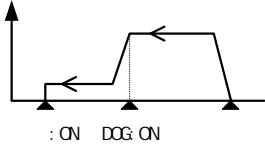
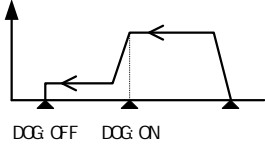

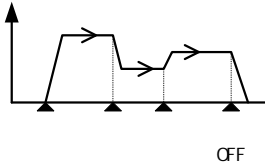
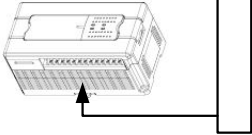

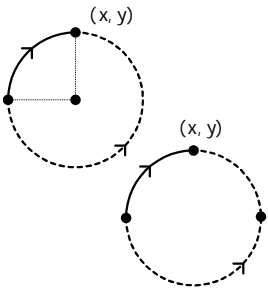
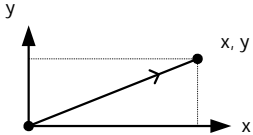








11. 2 PLC

	 <p>: ON DOG ON</p>					
	 <p>DOG OFF DOG ON</p>					
						
	 <p>OFF</p>					
						
						
						
						

610 10

				KHZ		KHZ	

				KHZ		KHZ	

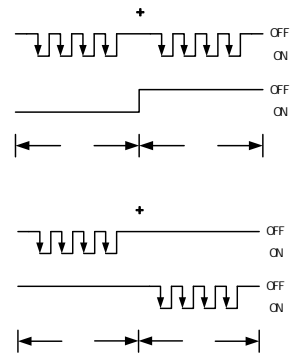
				KHZ		KHZ	

				KHZ		KHZ	


The diagrams illustrate timing relationships for OFF and ON states. The top diagram shows a high-frequency pulse train for OFF and a step function for ON. The bottom diagram shows a high-frequency pulse train for OFF and a low-frequency pulse train for ON. Arrows indicate pulse width and period.

				KHZ		KHZ	

				KHZ		KHZ	



				KHZ		KHZ	



				KHZ			KHZ		
			DP						

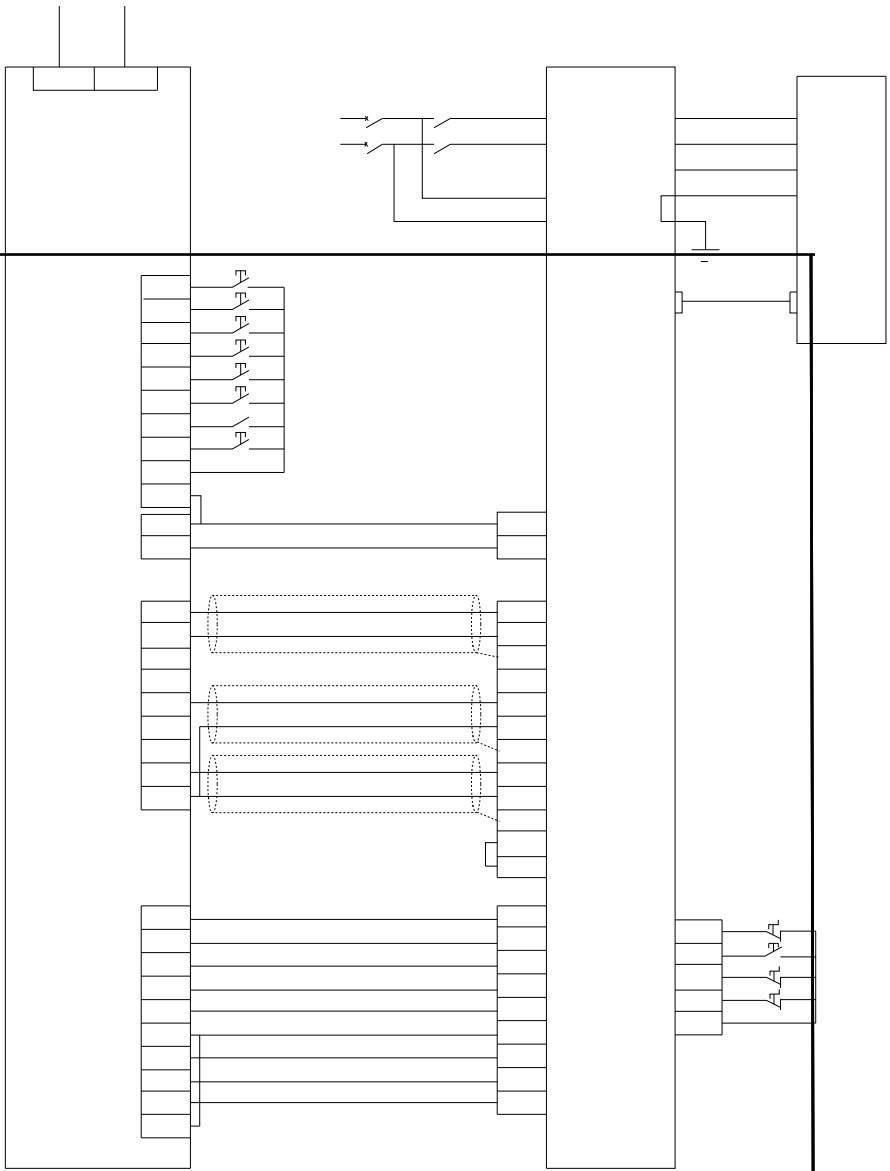
				KHZ		KHZ	
					3	3	
			# /				



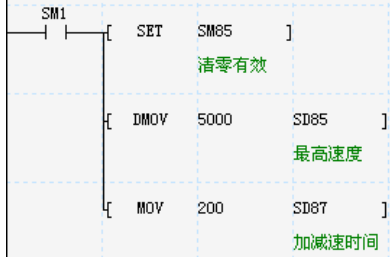
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" "

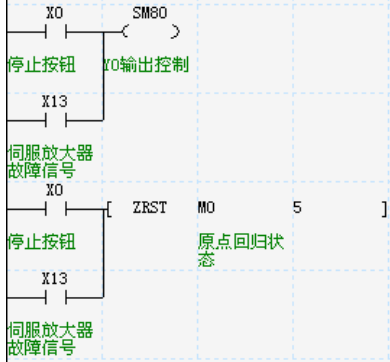
|--|--|--|--|



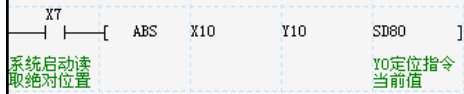
/*上电初始化*/



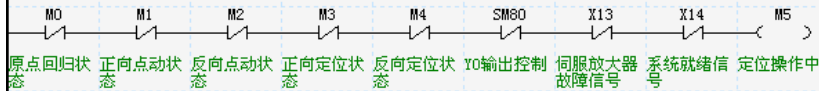
/*故障和停止时停止输出脉冲，并停止所有的定位操作*/



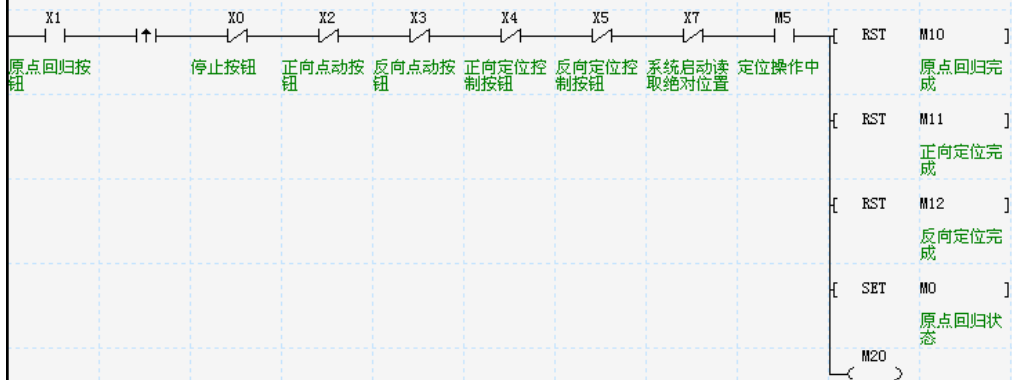
/*绝对位置值读取*/

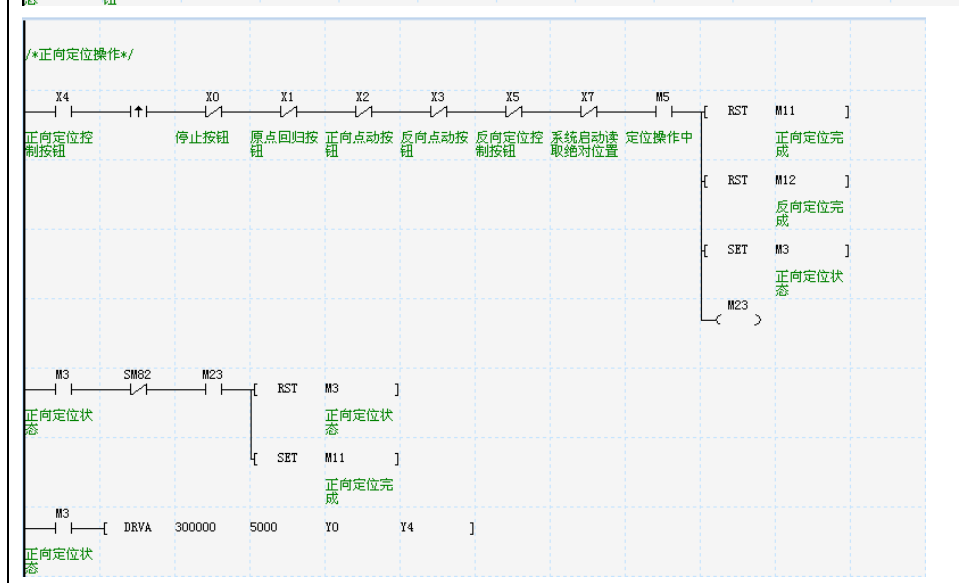
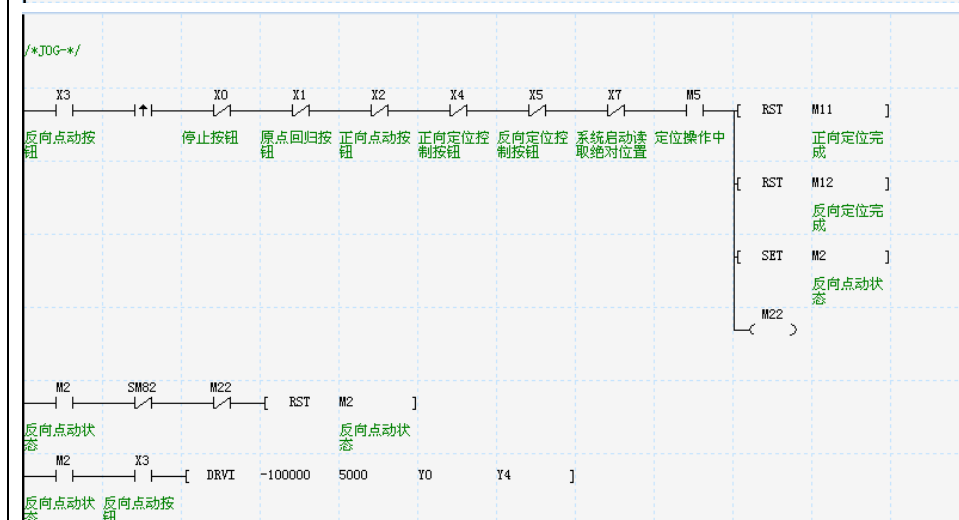
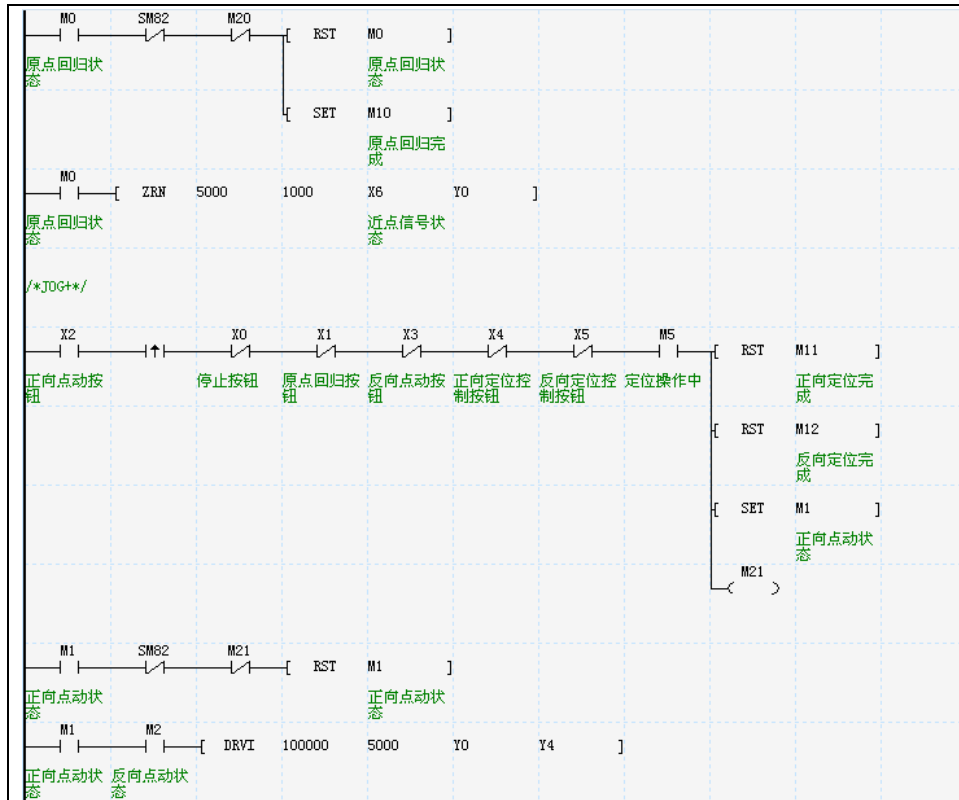


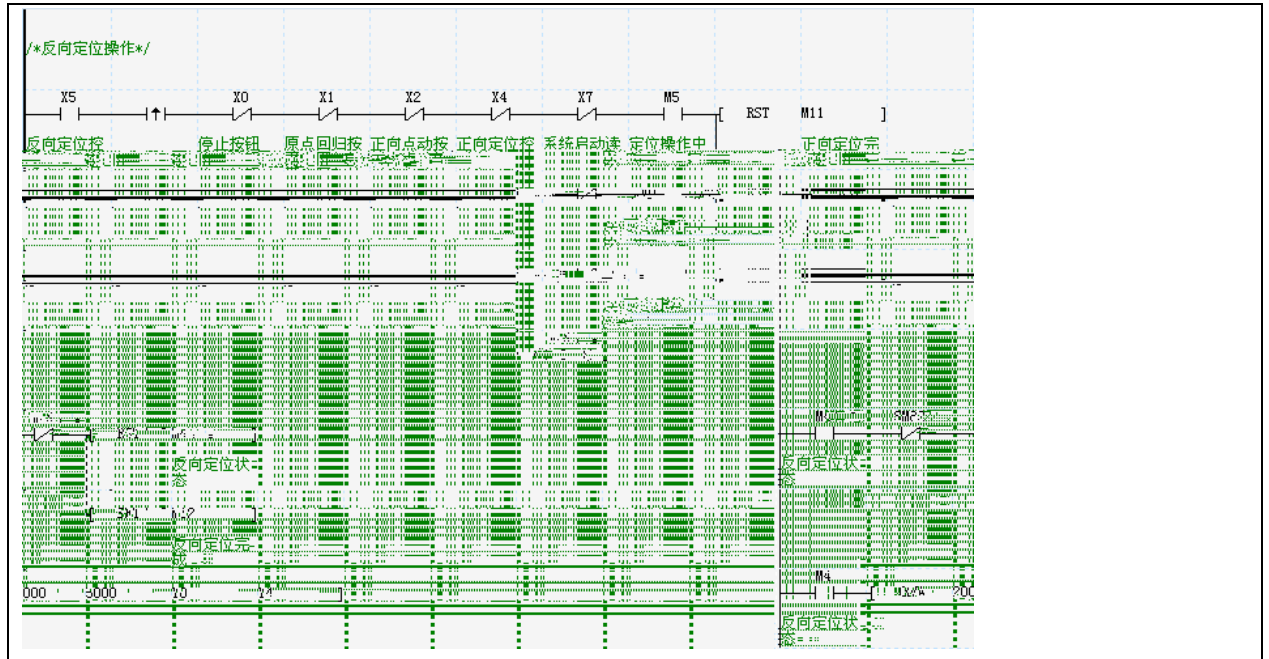
/*检测是否正在进行定位操作。M5为0X表示当前没有进行操作。*/



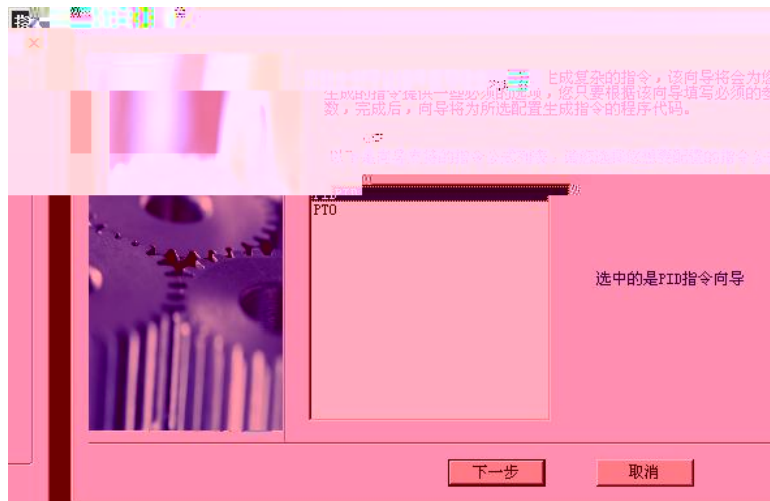
/*原点回归*/







→ ...



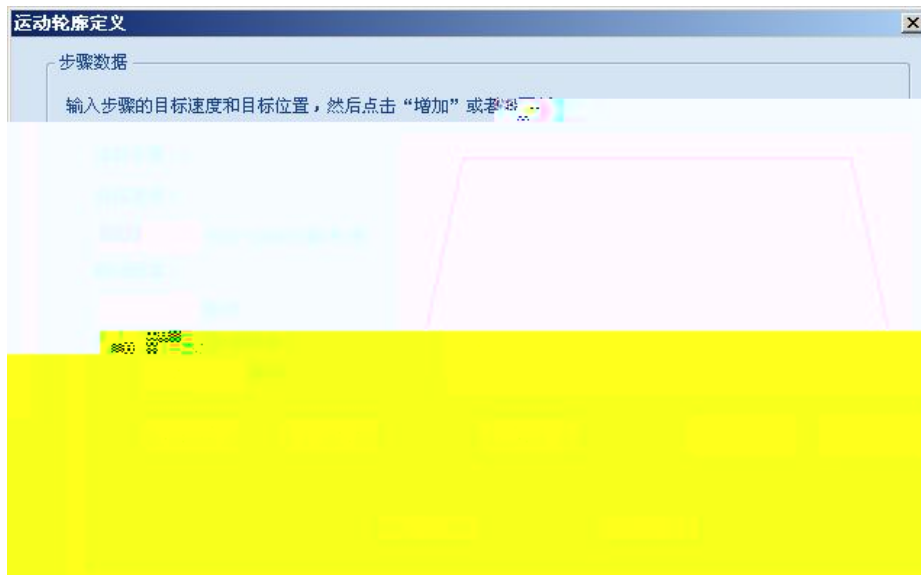


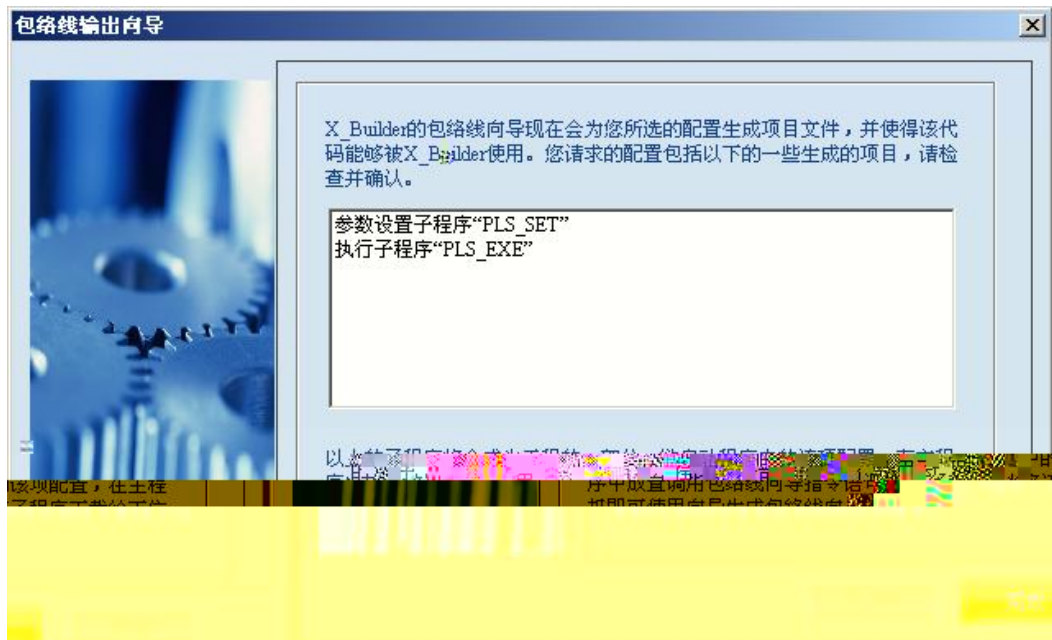
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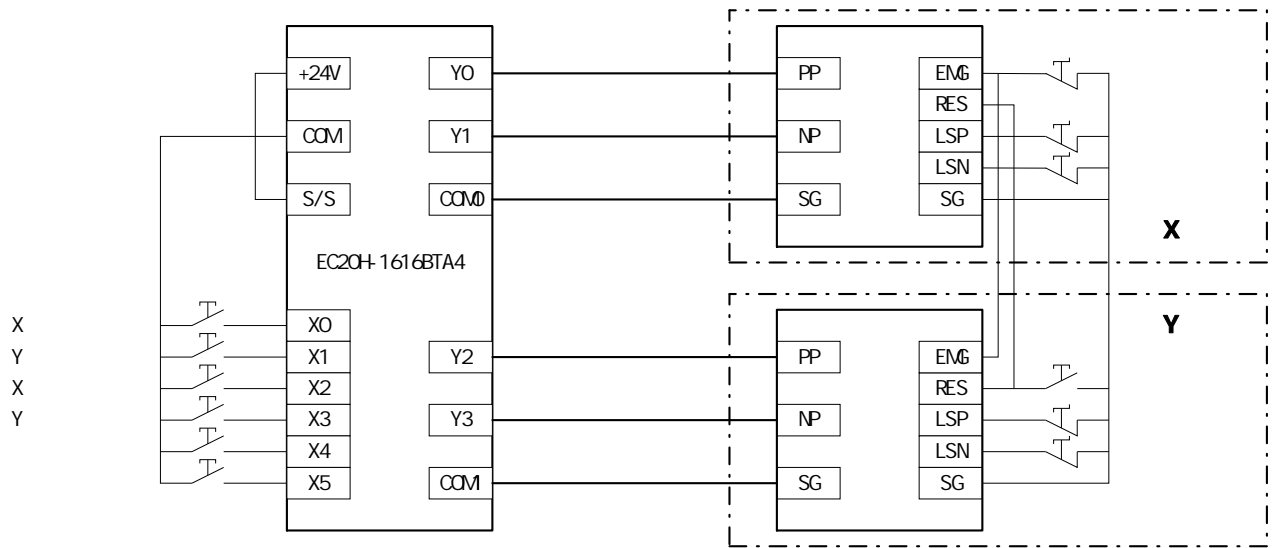
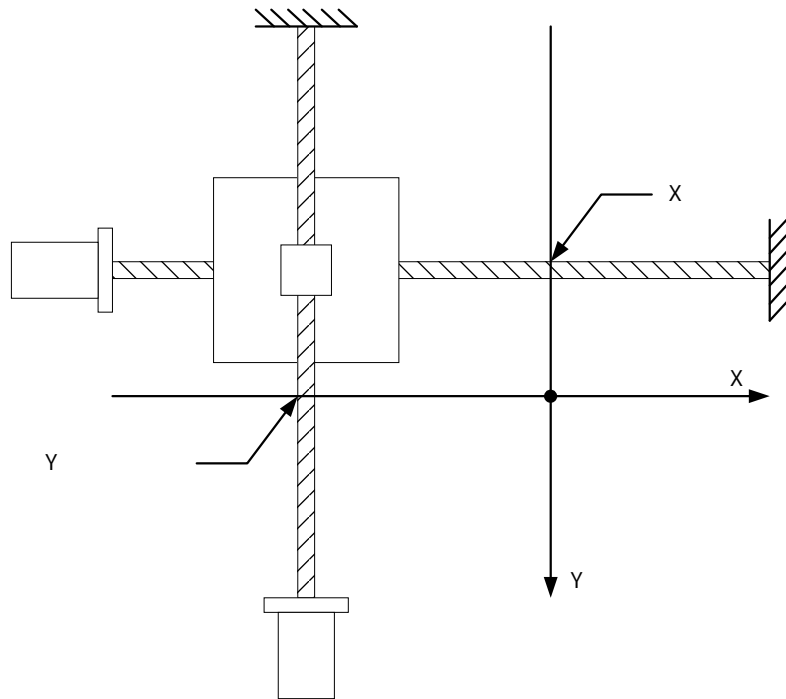
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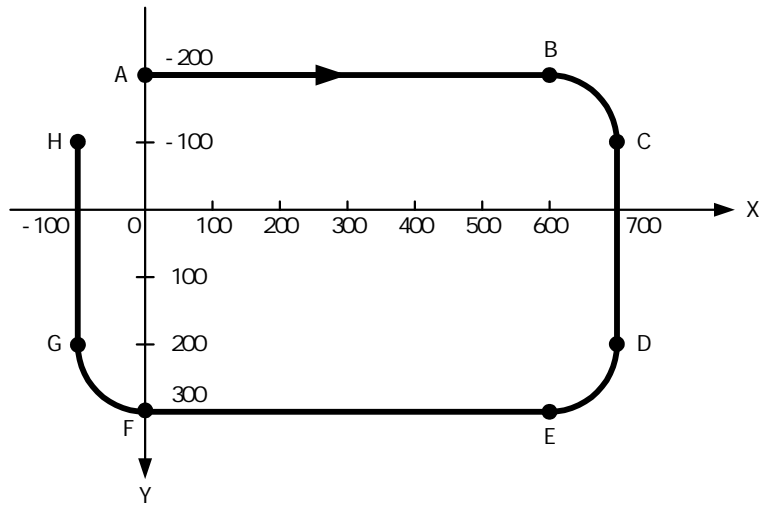
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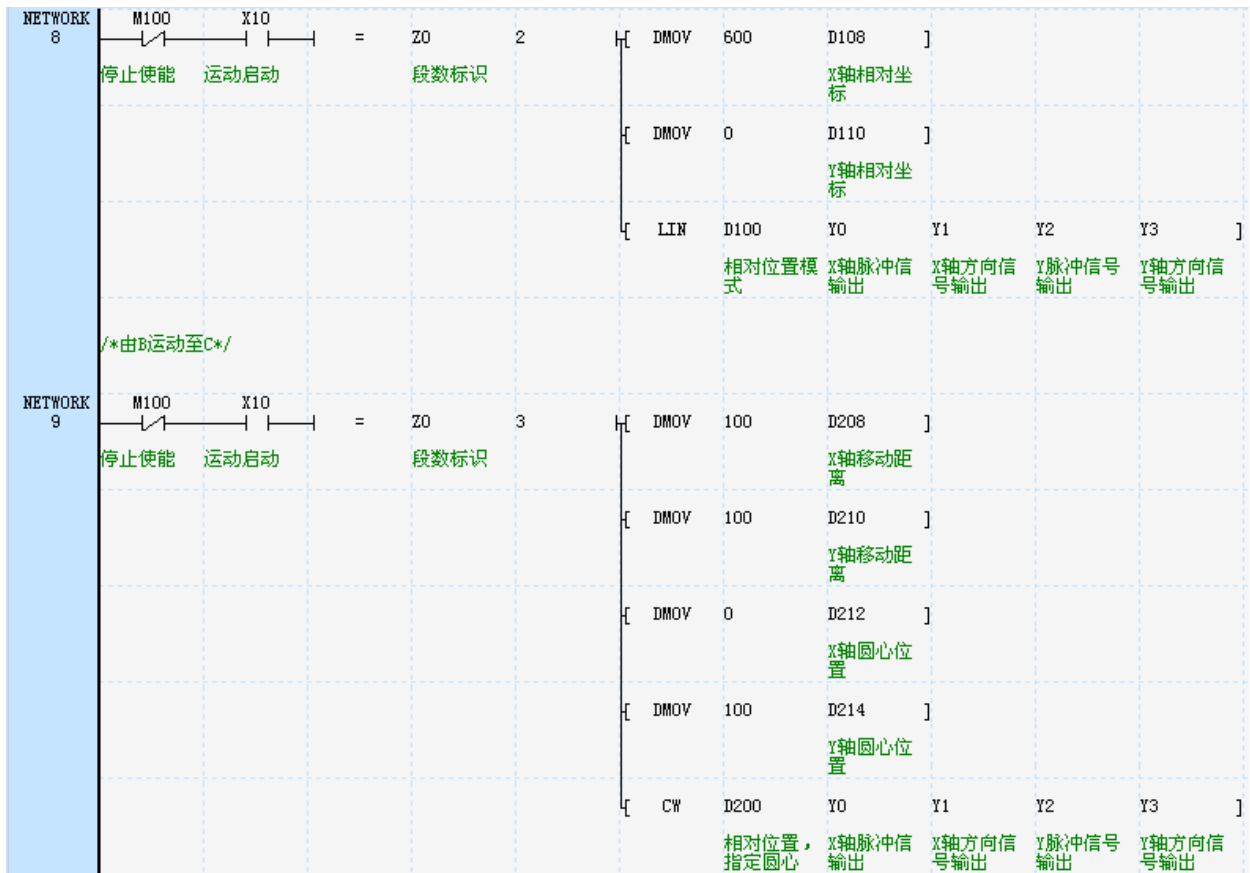
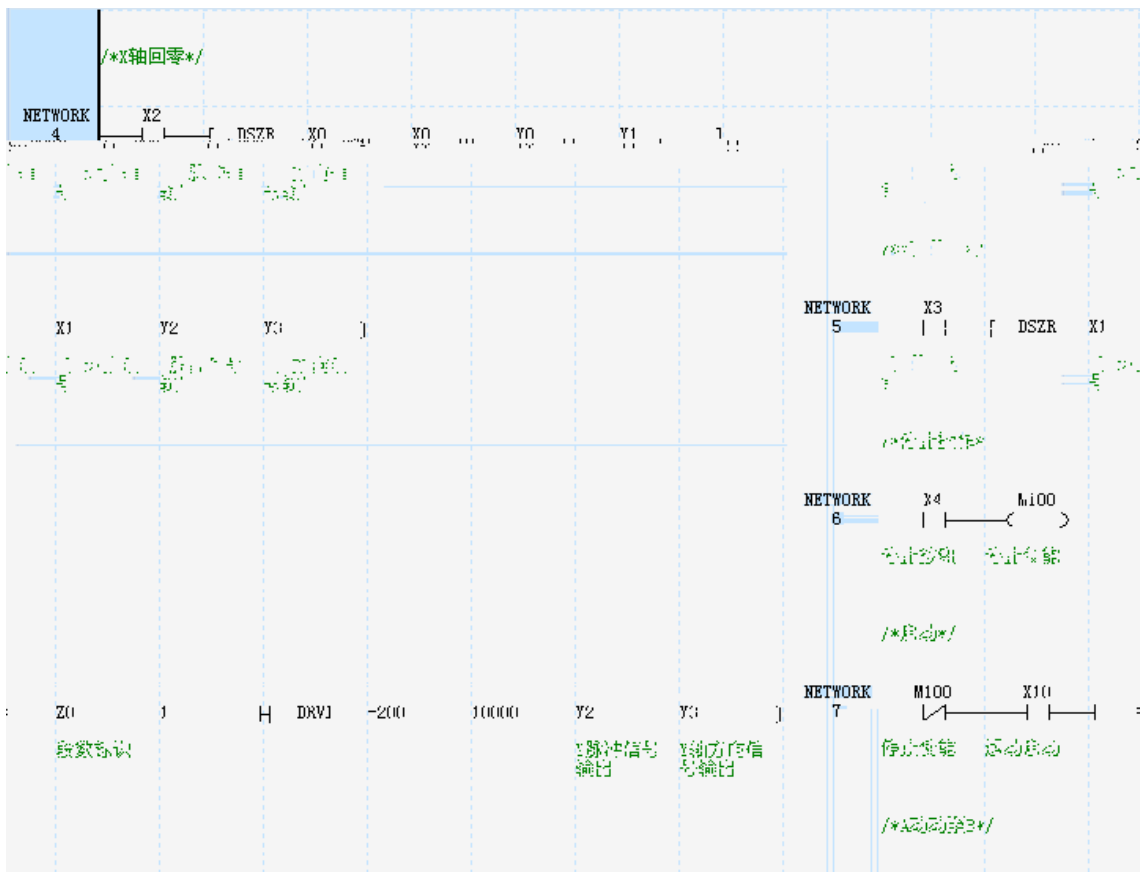


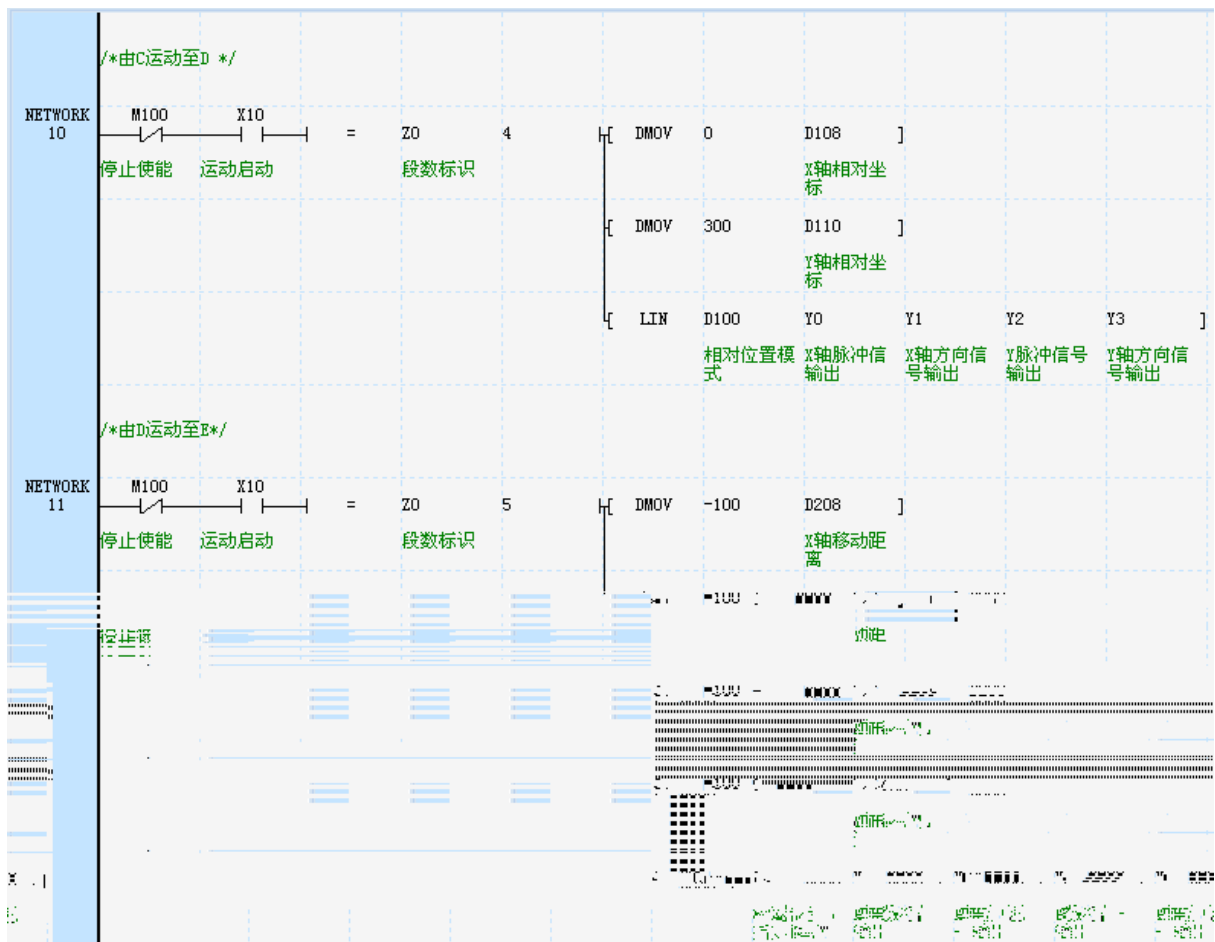


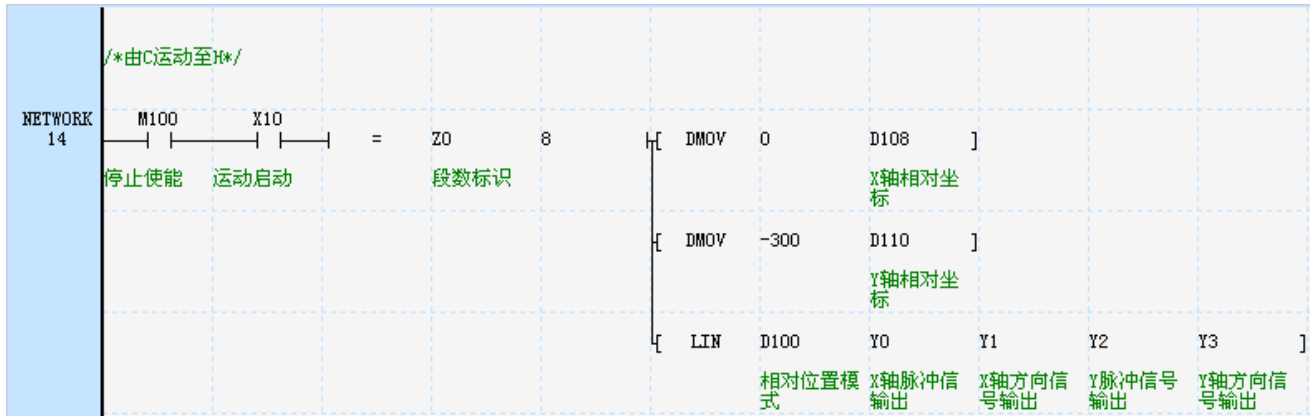
/*初始化运动控制指令相关软元件*/				
NETWORK 0	SM1	[DMOV 0	D100]
				相对位置模式
		[DMOV 10000	D102]
				直线插补初始速度
		[DMOV 10000	D104]
				直线插补合成速度
		[DMOV 100	D106]
				直线插补减速时间
		[DMOV 0	D108]
				X轴相对坐标
		[DMOV 0	D110]
				Y轴相对坐标
NETWORK 1	SM1	[DMOV 0	D200]
				相对位置, 指定圆心
		[DMOV 10000	D202]
				圆弧插补保留

[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







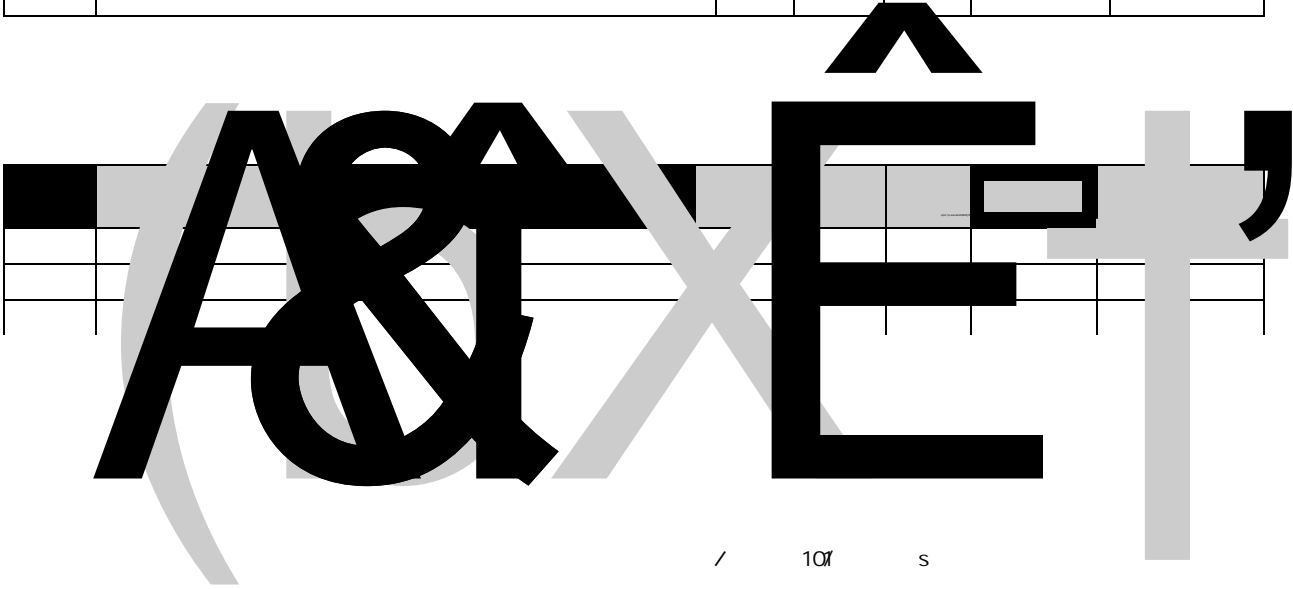
<i>6109 SPD 6101 HCNT</i>						

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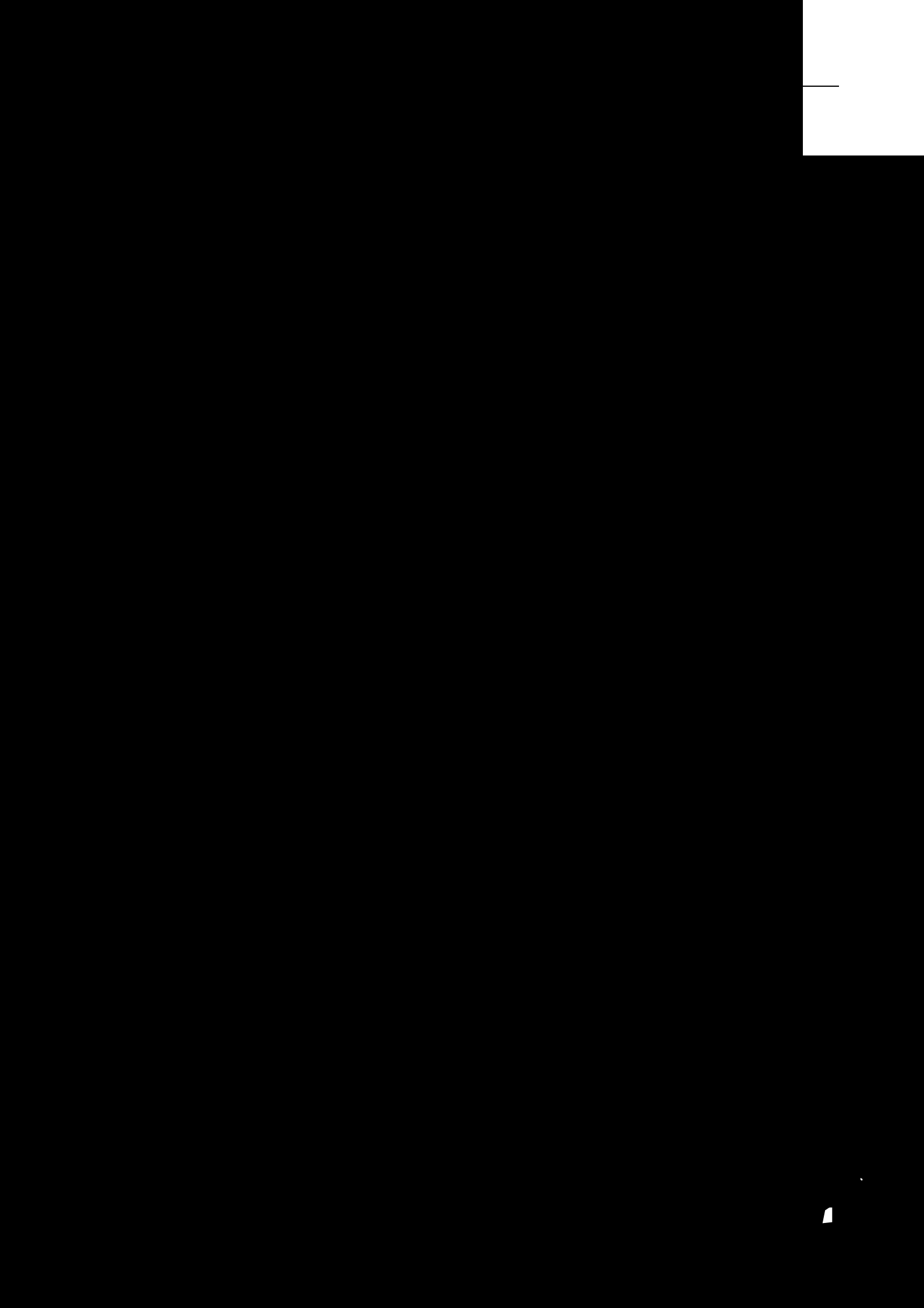




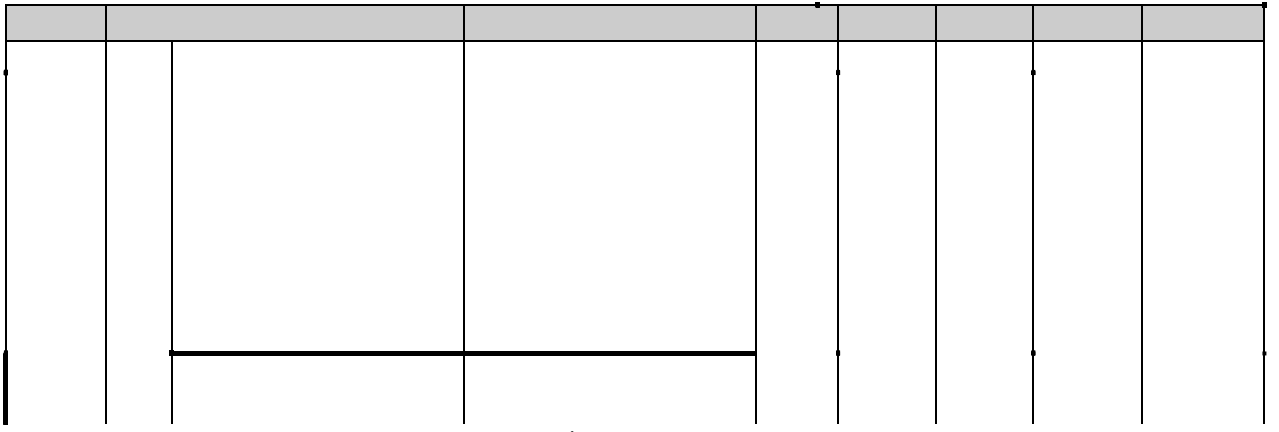
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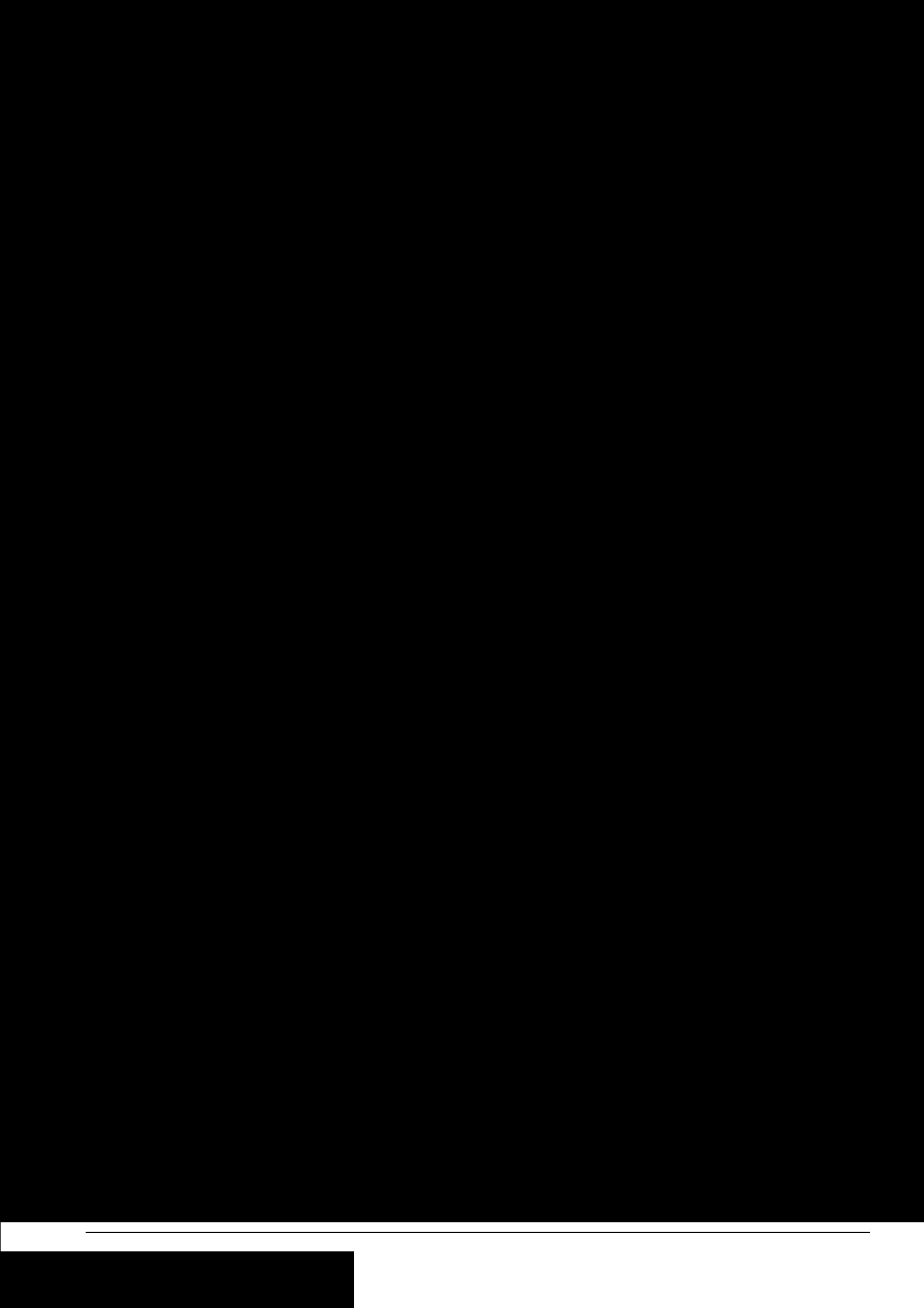
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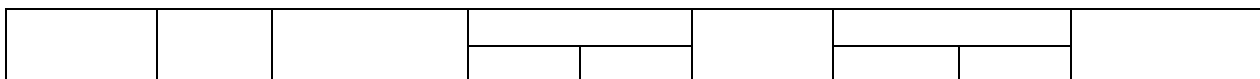
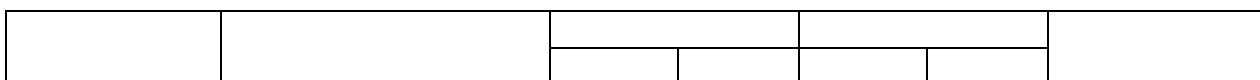
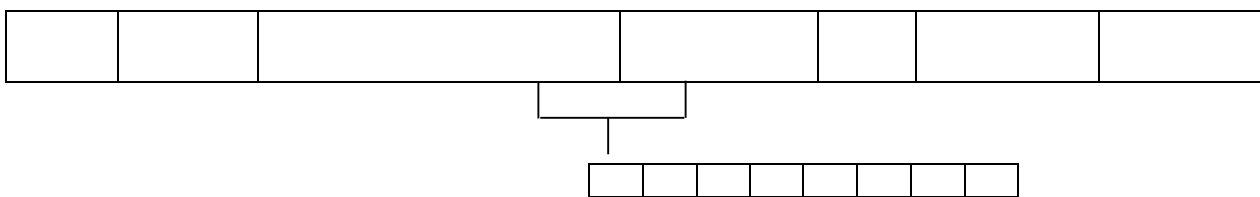
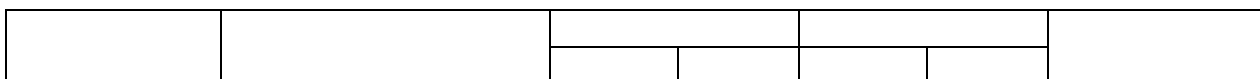
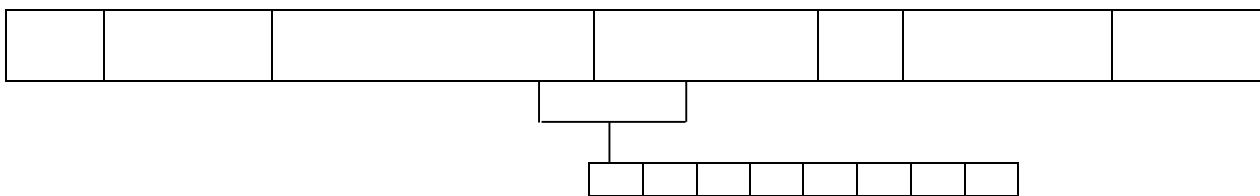
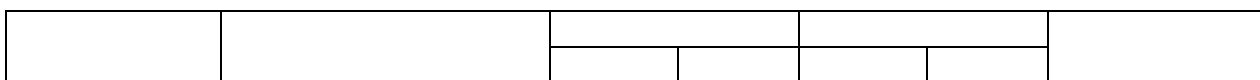
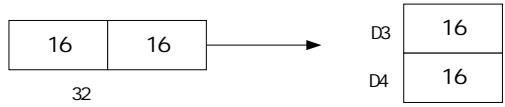


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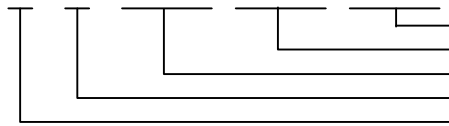
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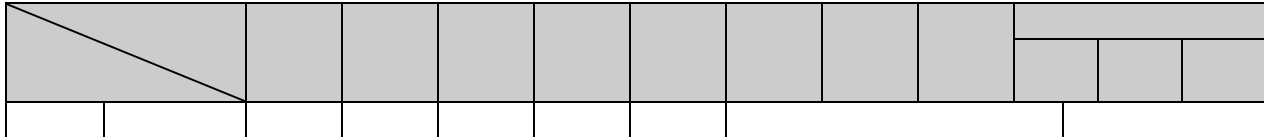


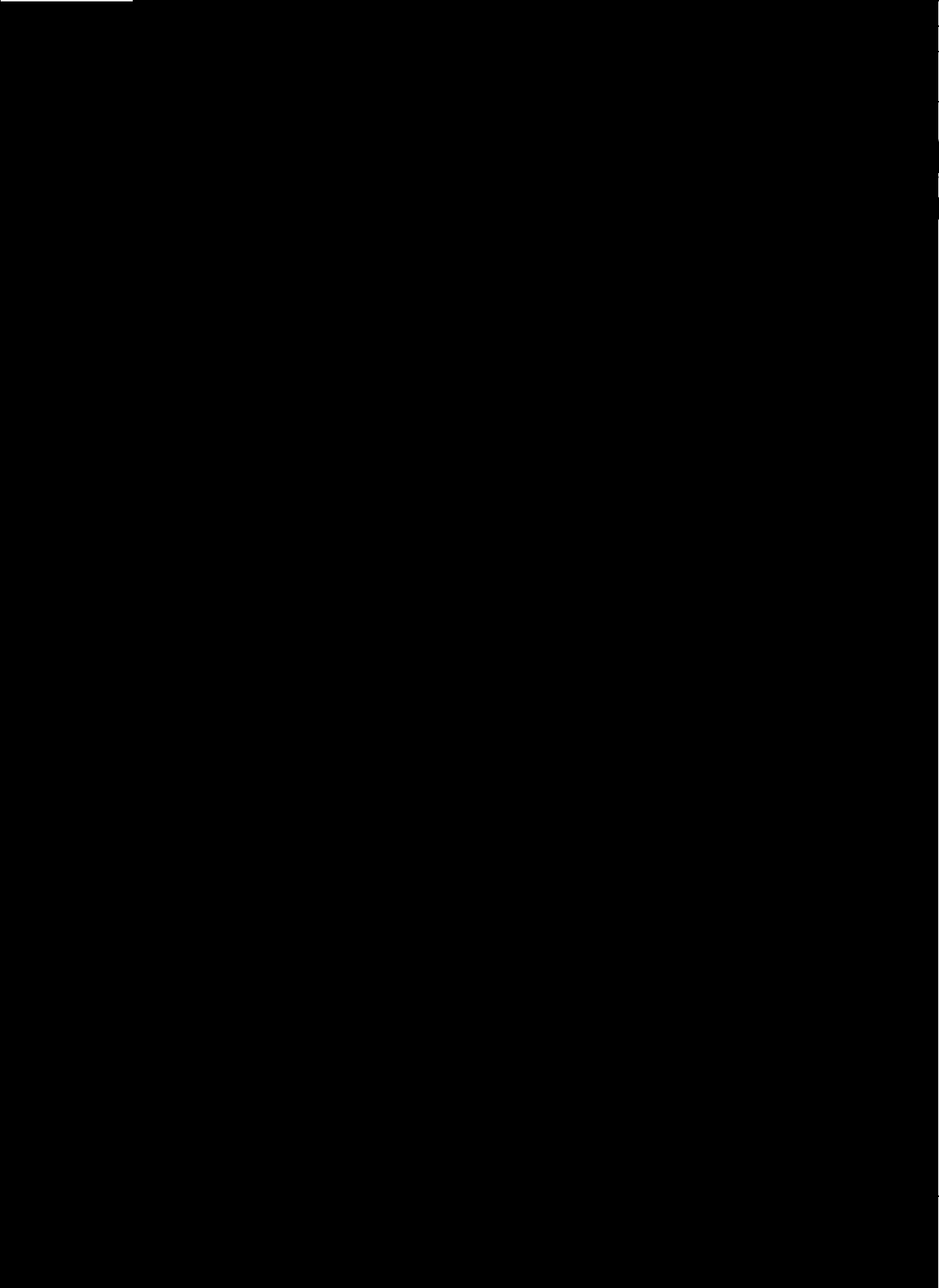
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