[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : ALARMAS]

000000 (000248)

[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : ALIMENTADORES]

ALIMENTACION INYECTOR 1

384.06 — Q: 5.08

ACTIVACI
ON_ALIM
ENTACIO
N_INY_1

ALIMENT
ADOR_IN
Y_1

000001 (000250)

384.07 — Q: 5.09

ACTIVACI
ON_ALIM
ENTACIO
N_INY_2

ALIMENT
ADOR_IN
Y_2

000002 (000252)

384.08 — Q: 5.10

ACTIVACI
ON_ALIM
ENTACIO
N_INY_3

ALIMENT
ADOR_IN
Y_3

000003 (000254)

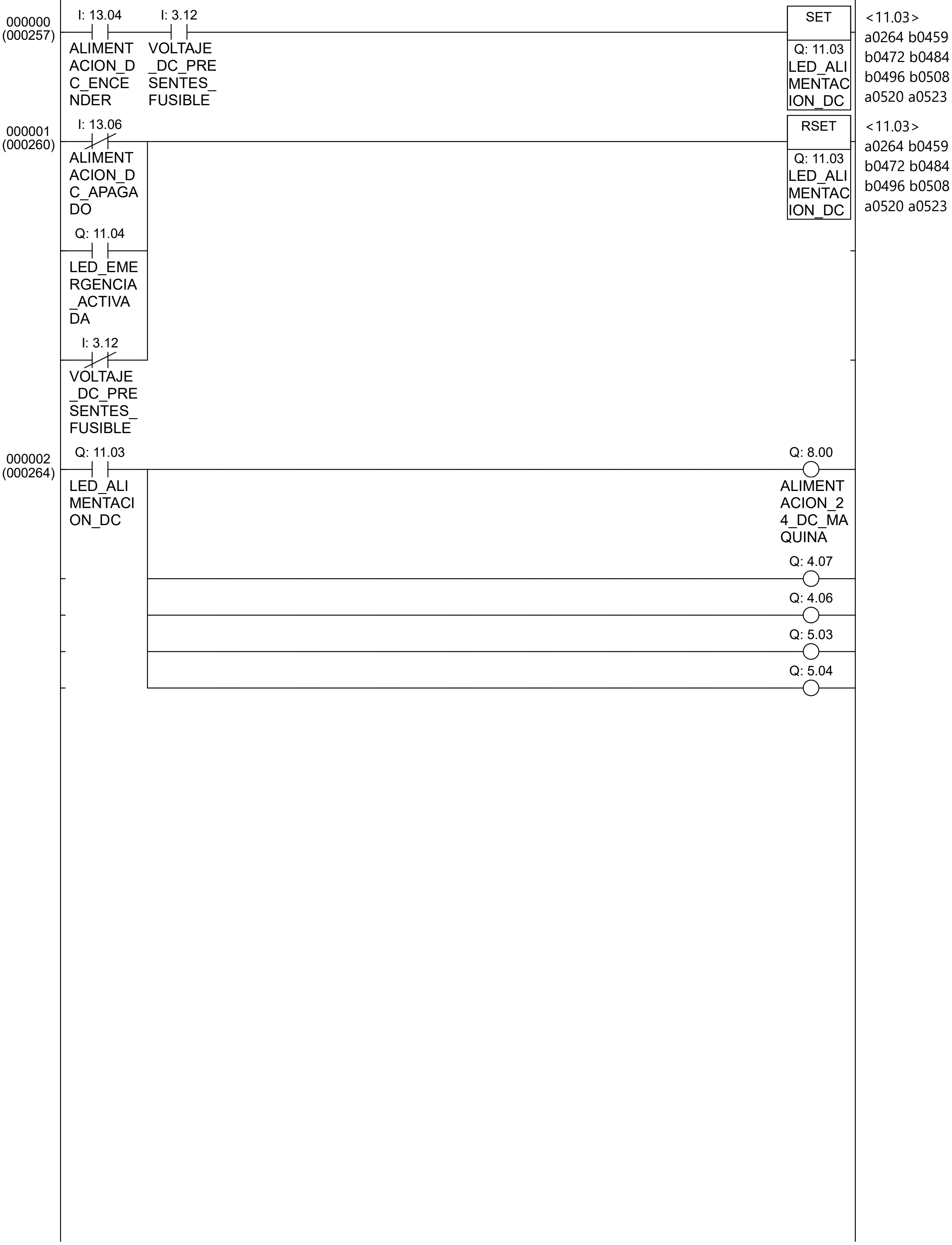
384.09 — Q: 5.11

ACTIVACI
ON_ALIM
ENTACIO
N_INY_4

ALIMENT
ADOR_IN
Y_4

[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : ALIMENTACION_DC]



[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : ASIGNACION_INYECTOR_EN_ESTACIONES]

000000
(000741)

CF113
P_On
Indicador de siempre ON

+ (400)
D76
&1
D77

[OP1]
<cD00076>
c0699 c0758
[OP2]
[OP3]

+ (400)
D78
&1
D79

[OP1]
<cD00078>
c0702 c0761
[OP2]
[OP3]

+ (400)
D80
&1
D81

[OP1]
<cD00080>
c0705 c0764
[OP2]
[OP3]

+ (400)
D82
&1
D83

[OP1]
<cD00082>
c0708 c0767
[OP2]
[OP3]

+ (400)
D84
&1
D85

[OP1]
<cD00084>
c0711 c0770
[OP2]
[OP3]

+ (400)
D86
&1
D87

[OP1]
<cD00086>
c0714 c0773
[OP2]
[OP3]

+ (400)
D88
&1
D89

[OP1]
<cD00088>
c0717 c0776
[OP2]
[OP3]

+ (400)
D90
&1
D91

[OP1]
<cD00090>
c0720 c0779
[OP2]
[OP3]

+ (400)
D92
&1
D93

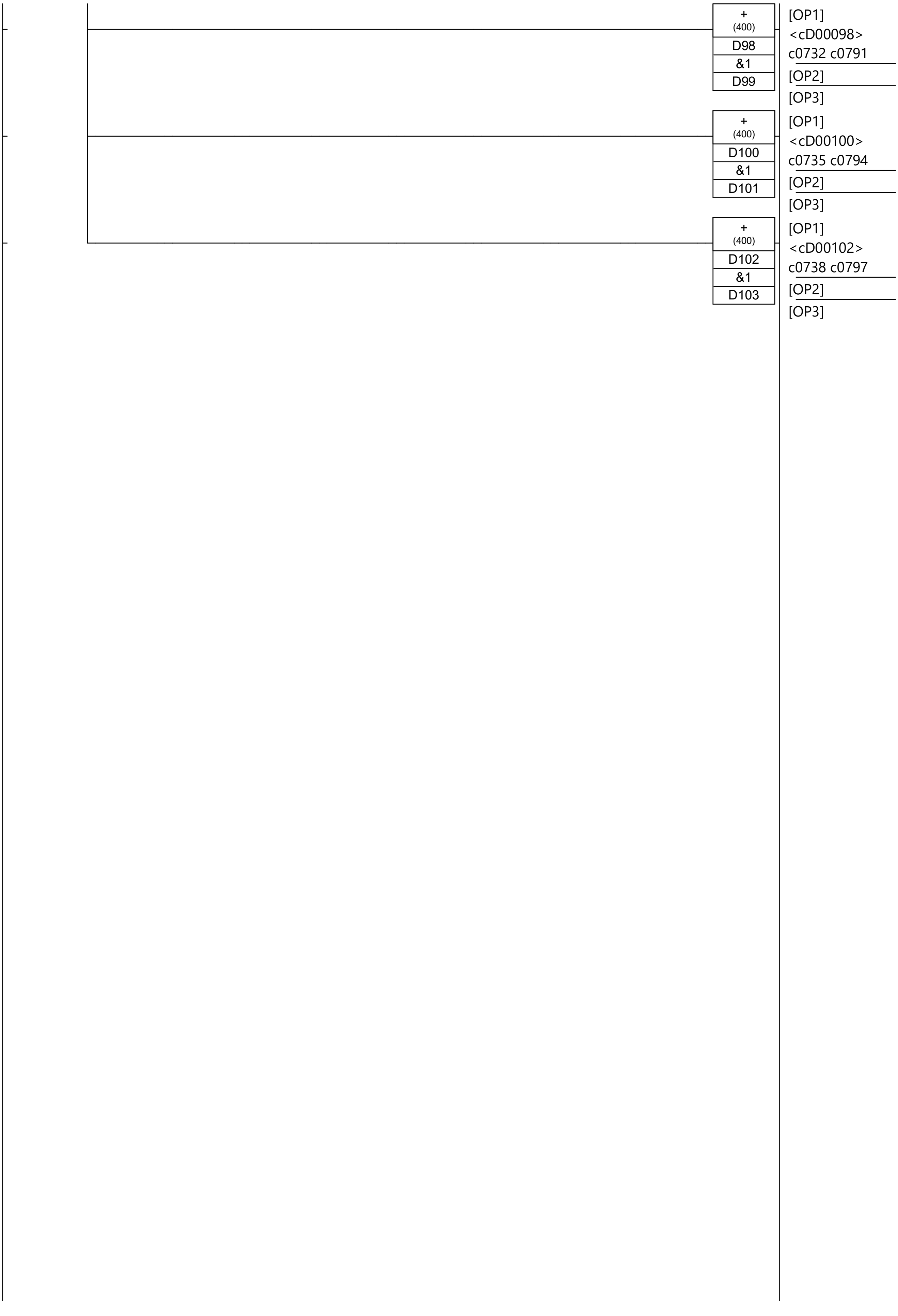
[OP1]
<cD00092>
c0723 c0782
[OP2]
[OP3]

+ (400)
D94
&1
D95

[OP1]
<cD00094>
c0726 c0785
[OP2]
[OP3]

+ (400)
D96
&1
D97

[OP1]
<cD00096>
c0729 c0788
[OP2]
[OP3]


+
(400)
D98
&1
D99
[OP1]
<cD00098>
c0732 c0791
[OP2]
[OP3]
+
(400)
D100
&1
D101
[OP1]
<cD00100>
c0735 c0794
[OP2]
[OP3]
+
(400)
D102
&1
D103
[OP1]
<cD00102>
c0738 c0797
[OP2]
[OP3]

[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : AUTOMATICO_INY_1]

000000 (001288)

W100.02 automatico — D384.10 (↑) — SET W100.04

INICIO CICLO AUTOMATICO INYECTORES
<W100.04>
b0429 a1291
a1295 a1309
a1312 a1331
a1334 a1343
a1348 a1365
a1370 a1375

000001 (001291)

W100.04 (↑) INICIO CICLO AUTOMATICO INYECTORES — Q: 11.15 LED_POSICION_INYECCION_DX_INY_1 — I: 10.05 SELECTOR_AUTO_INY_1 — SET W101.06

AUTORIZACION INYECTAR BOQUILLA DERECHA INY 1
<W101.06>
a0858 a0864
a0874 a0878
a1300 a1304
a1315 a1337
b1344 a1349
b1394

000002 (001295)

W100.04 (↑) INICIO CICLO AUTOMATICO INYECTORES — Q: 11.12 LED_POSICION_INYECCION_SX_INY_1 — I: 10.05 SELECTOR_AUTO_INY_1 — SET W101.08

AUTORIZACION INYECTAR BOQUILLA IZQUIERDA INY 1
<W101.08>
b0865 a0873
a0891 a0897
a0905 a0908
a1322 a1326
b1345 a1350
b1395

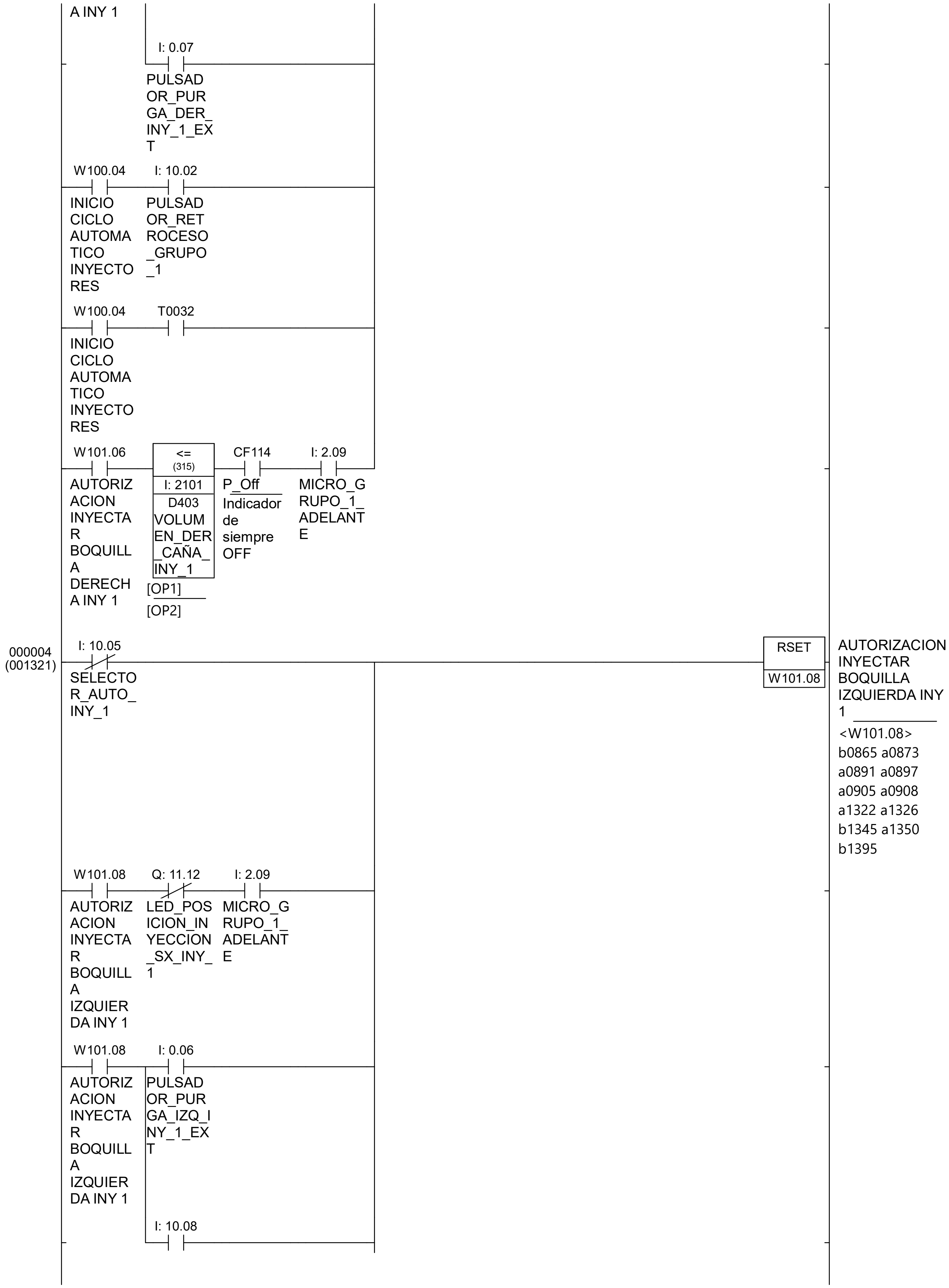
000003 (001299)

I: 10.05 (/) SELECTOR_AUTO_INY_1 — RSET W101.06

W101.06 AUTORIZACION INYECTAR BOQUILLA DERECHA INY 1 — Q: 11.15 (/) LED_POSICION_INYECCION_DX_INY_1 — I: 2.09 MICRO_GRUPO_1_ADELANTE

W101.06 AUTORIZACION INYECTAR BOQUILLA DERECH — I: 10.07 PULSADOR_PURGA_DER_INY_1

AUTORIZACION INYECTAR BOQUILLA DERECHA INY 1
<W101.06>
a0858 a0864
a0874 a0878
a1300 a1304
a1315 a1337
b1344 a1349
b1394


A INY 1
I: 0.07
PULSADOR_PURGA_DER_INY_1_EXT
W100.04
INICIO CICLO AUTOMATICO INYECTORES
I: 10.02
PULSADOR_RETROCESO_GRUPO_1
W100.04
INICIO CICLO AUTOMATICO INYECTORES
T0032
W101.06
AUTORIZACION INYECTAR BOQUILLA DERECHA INY 1
<=
(315)
I: 2101
D403
VOLUMEN_DER_CAÑA_INY_1
[OP1]
[OP2]
CF114
P_Off
Indicador de siempre OFF
I: 2.09
MICRO_GRUPO_1_ADELANTE
000004
(001321)
I: 10.05
SELECTOR_AUTO_INY_1
RSET
W101.08
AUTORIZACION INYECTAR BOQUILLA IZQUIERDA INY 1
<W101.08>
b0865 a0873
a0891 a0897
a0905 a0908
a1322 a1326
b1345 a1350
b1395
W101.08
AUTORIZACION INYECTAR BOQUILLA IZQUIERDA INY 1
Q: 11.12
LED_POSICION_INYECCION_SX_INY_1
I: 2.09
MICRO_GRUPO_1_ADELANTE
W101.08
AUTORIZACION INYECTAR BOQUILLA IZQUIERDA INY 1
I: 0.06
PULSADOR_PURGA_IZQ_INY_1_EXT
I: 10.08

PULSADOR_PURGA_IZQ_INY_1

W100.04 INICIO CICLO AUTOMATICO INYECTORES — I: 10.02 PULSADOR_RETROCESO_GRUPO_1

W100.04 INICIO CICLO AUTOMATICO INYECTORES — T0033

W101.06 AUTORIZACION INYECTAR BOQUILLA DERECHA INY 1 — <= (315) I: 2101 D404 VOLUMEN_IZQ_CAÑA_INY_1 [OP1] [OP2] — CF114 P_Off Indicador de siempre OFF — I: 2.09 MICRO_GRUPO_1_ADELANTE

000005 (001343)
W100.04 INICIO CICLO AUTOMATICO INYECTORES — W101.06 AUTORIZACION INYECTAR BOQUILLA DERECHA INY 1 — W101.08 AUTORIZACION INYECTAR BOQUILLA IZQUIERDA INY 1 — I: 2.10 MICRO_GRUPO_1_ATRAS — RSET W100.04
INICIO CICLO AUTOMATICO INYECTORES
<W100.04>
b0429 a1291 a1295 a1309 a1312 a1331 a1334 a1343 a1348 a1365 a1370 a1375

000006 (001348)
W100.04 INICIO CICLO AUTOMATICO INYECTORES — W101.06 AUTORIZACION INYECTAR BOQUILLA DERECHA INY 1 / W101.08 AUTORIZACION INYECTAR BOQUILLA IZQUIERDA INY 1 — W103.02 — W103.03 RETIRADA — SET W101.00
<W101.00>
a0597 a1355 a1358 a1361

000007 (001355)
W101.00 — I: 3.07 MICRO_CUÑA_ADELANTE_GR_1 — Q: 4.04 PRENSA_SUPERIOR_GR_1
<4.04>
b0344 b0448 a0598

000008 (001358)
W101.00 — Q: 11.13 LED_PURGA_INY1 — TIM 0032 D401
[OP1]
<T0032(bit)>
a1313

_DX

TIEMPO_MAX_DER_CAÑA_INY_1

[OP2]

000009 (001361)

W101.00

Q: 11.14 LED_PURGA_INY1_SX

TIM 0033 D402 TIEMPO_MAX_IZQ_CAÑA_INY_1

[OP1] <T0033(bit)> a1335

[OP2]

000010 (001364)

W103.04

W100.04 INICIO CICLO AUTOMATICO INYECTORES

I: 10.02 PULSADOR_RETROCESO_GRUPO_1

I: 10.05 SELECTOR_AUTO_INY_1

RSET W101.00

<W101.00> a0597 a1355 a1358 a1361

000011 (001370)

W100.04 INICIO CICLO AUTOMATICO INYECTORES

I: 2.09 MICRO_GRUPO_1_ADELANTE

W101.05 INICIO CICLO INYECCION MOLDE

I: 3.02 MICRO_CARGA_INY_1

SET W101.05

INICIO CICLO INYECCION MOLDE

<W101.05> a0856 a0862 a0871 a0876 a0889 a0895 a0903 a0906 b1372 a1379 a1383 a1388 a1393 a1400

000012 (001375)

W100.04 INICIO CICLO AUTOMATICO INYECTORES

I: 10.02 PULSADOR_RETROCESO_GRUPO_1

W103.04

RSET W101.05

INICIO CICLO INYECCION MOLDE

<W101.05> a0856 a0862 a0871 a0876 a0889 a0895 a0903 a0906 b1372 a1379 a1383 a1388 a1393 a1400

000013 (001379)

W101.05 INICIO CICLO INYECCION MOLDE

D409.00

MOV (021) D407 VELOCIDAD_INY_DER_CAÑA_INY_1 Q: 2111

[OP1] <cD00407> c1386

[OP2] . <c2111> c0822 c0919 c1386 c1391

MOV (021) D405 PRESION_INY_DERECHA_CAÑA_INY_1

[OP1] <cD00405> c1387

[OP2] <c2115> c0823 c0922 c1387 c1392

Q: 2115

000014
(001383)

W101.05 INICIO CICLO INYECCI ON MOLDE — D409.00 — Q: 11.13 LED_PUR GA_INY1 _DX

MOV (021) D407 VELOCI DAD_IN Y_DER_ CAÑA_I NY_1 Q: 2111

[OP1]
<cD00407>
c1381
[OP2]
.
<c2111>
c0822 c0919
c1381 c1391

MOV (021) D405 PRESIO N_INY_ DEREC HA_CAÑ A_INY_1 Q: 2115

[OP1]
<cD00405>
c1382
[OP2]
<c2115>
c0823 c0922
c1382 c1392

000015
(001388)

W101.05 INICIO CICLO INYECCI ON MOLDE — D409.00 — Q: 11.14 LED_PUR GA_INY1 _SX

MOV (021) D408 VELOCI DAD_IN Y_IZQ_ CAÑA_I NY_1 Q: 2111

[OP1]
[OP2]
.
<c2111>
c0822 c0919
c1381 c1386

MOV (021) D406 PRESIO N_INY_I ZQUIER DA_CAÑ A_INY_1 Q: 2115

[OP1]
[OP2]
<c2115>
c0823 c0922
c1382 c1387

000016
(001393)

W101.05 INICIO CICLO INYECCI ON MOLDE — W101.06 AUTORIZ ACION INYECTA R BOQUILL A DERECH A INY 1 — W101.08 AUTORIZ ACION INYECTA R BOQUILL A IZQUIER DA INY 1

SET W101.07

CONTRAPRESI ON
<W101.07>
a0869 a0901
a1397

000017
(001397)

W101.07 CONTRA PRESION

TIM 0030 D56 CONTR APRESI ON_INY _1

[OP1]
<T0030(bit)>
a1399
[OP2]

000018
(001399)

T0030 — W101.05 INICIO CICLO INYECCI ON MOLDE

SET W103.05

<W103.05>
a1402 a1404
a1406

000019
(001402)

W103.05

RSET W101.07

CONTRAPRESI ON
<W101.07>
a0869 a0901
a1397

000020
(001404)

W103.05

TIM 0041

[OP1]
<T0041(bit)>

D400
TIEMPO_APOYO_CAÑA_INY_1

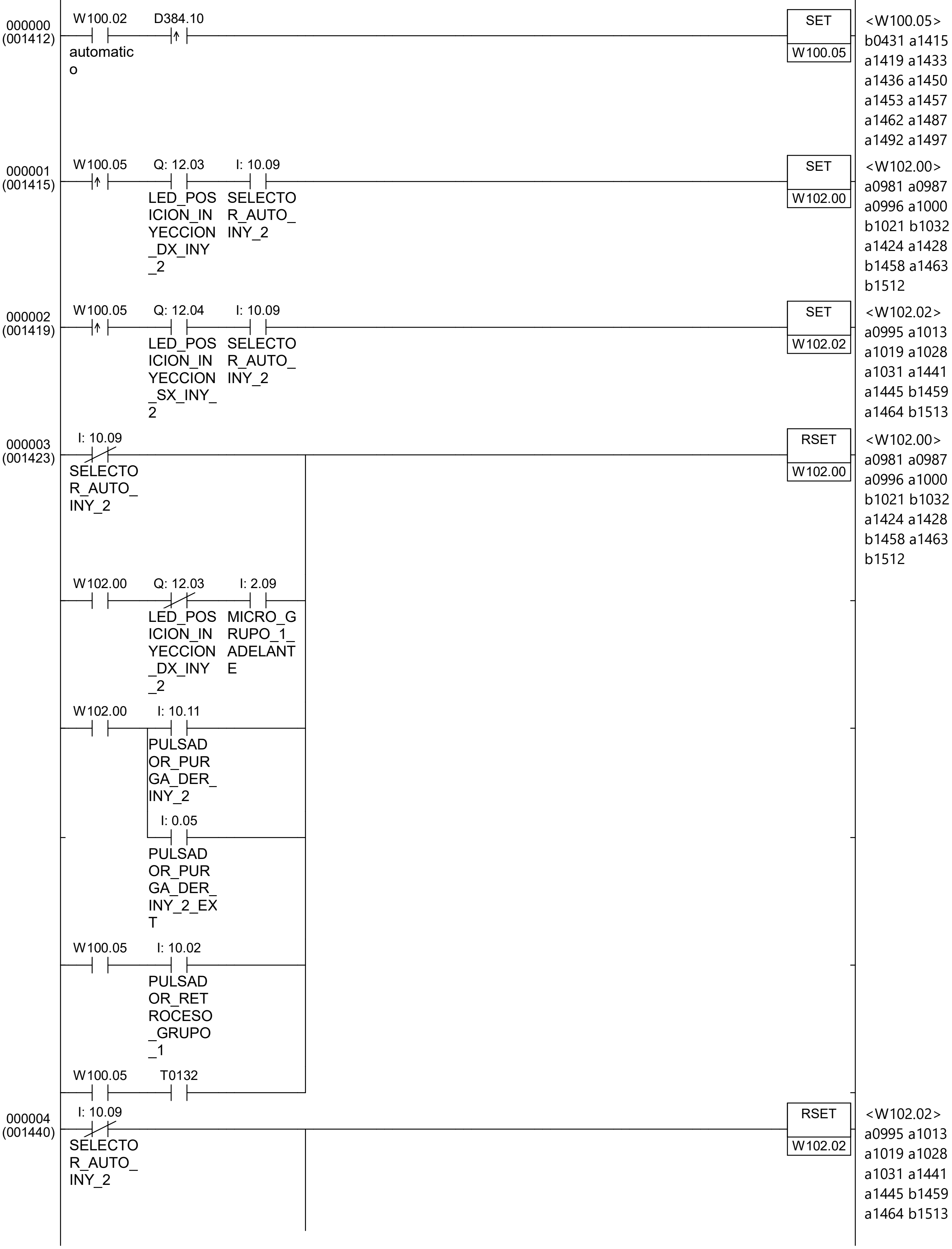
a1407
[OP2]
<cD00400>
c0700 c0703
c0706 c0709
c0712 c0715
c0718 c0721
c0724 c0727
c0730 c0733
c0736 c0739

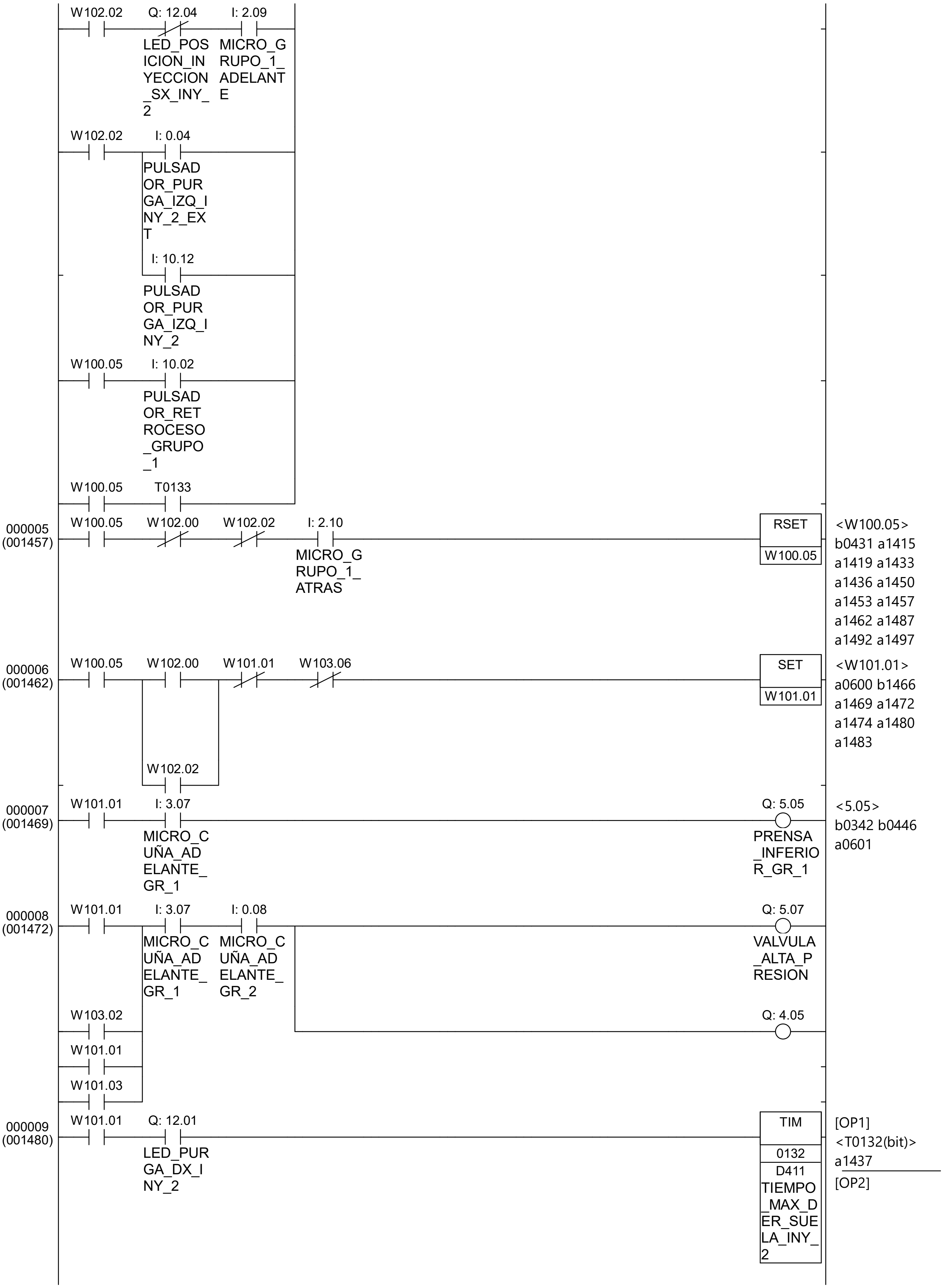
000021
(001406)
W103.05 T0041
SET
W103.04
<W103.04>
a1364 a1377
a1409

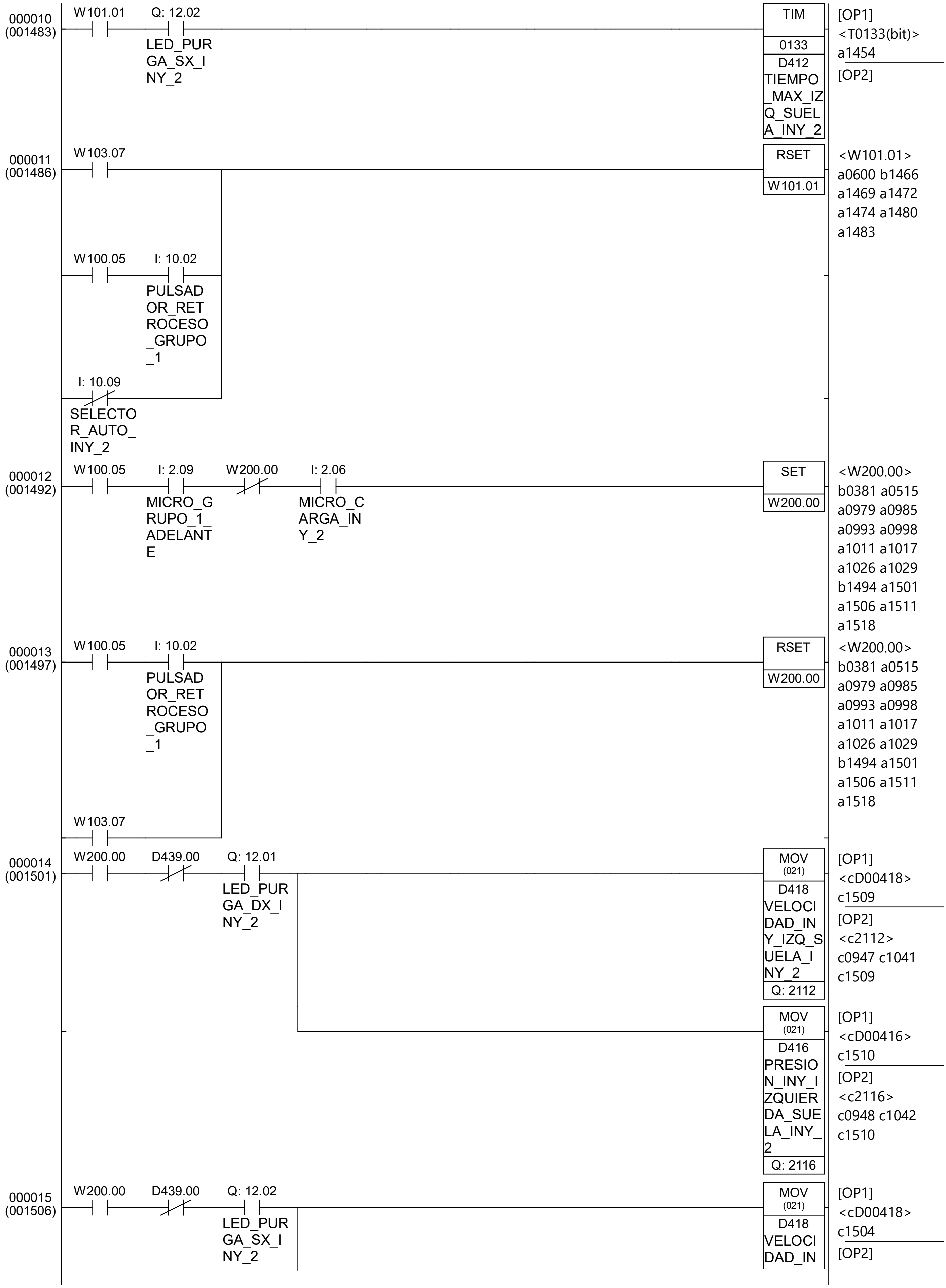
000022
(001409)
W103.04
RSET
W103.05
<W103.05>
a1402 a1404
a1406

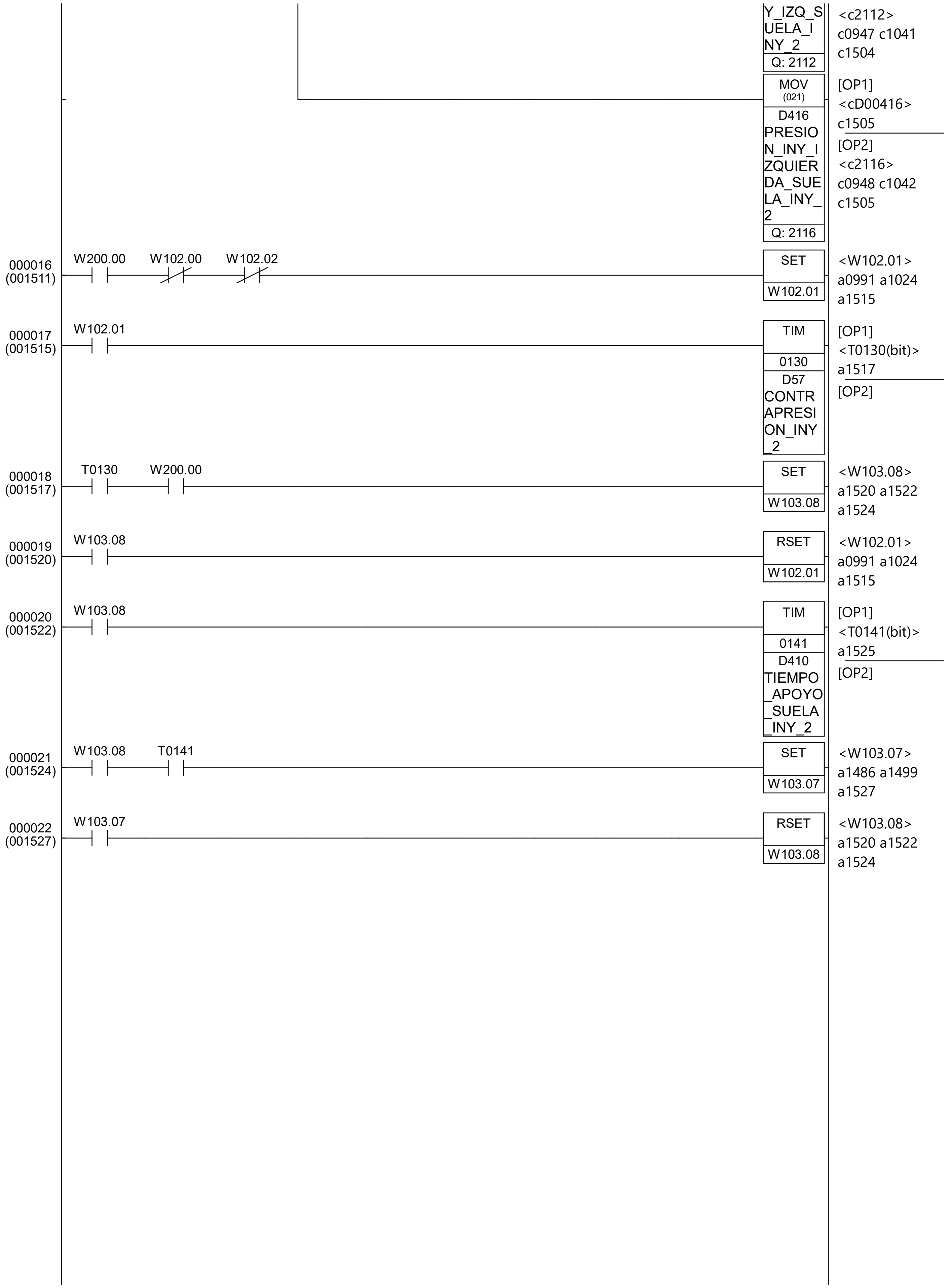
[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : AUTOMATICO_INY_2]




W102.02
Q: 12.04
I: 2.09
LED_POSICION_INYECCION_SX_INY_2
MICRO_GRUPO_1_ADELANTE
W102.02
I: 0.04
PULSADOR_PURGA_IZQ_INY_2_EXT
I: 10.12
PULSADOR_PURGA_IZQ_INY_2
W100.05
I: 10.02
PULSADOR_RETROCESO_GRUPO_1
W100.05
T0133
000005
(001457)
W100.05
W102.00
W102.02
I: 2.10
MICRO_GRUPO_1_ATRAS
RSET
W100.05
<W100.05>
b0431 a1415
a1419 a1433
a1436 a1450
a1453 a1457
a1462 a1487
a1492 a1497
000006
(001462)
W100.05
W102.00
W101.01
W103.06
W102.02
SET
W101.01
<W101.01>
a0600 b1466
a1469 a1472
a1474 a1480
a1483
000007
(001469)
W101.01
I: 3.07
MICRO_CUÑA_ADELANTE_GR_1
Q: 5.05
PRENSA_INFERIOR_GR_1
<5.05>
b0342 b0446
a0601
000008
(001472)
W101.01
I: 3.07
I: 0.08
MICRO_CUÑA_ADELANTE_GR_1
MICRO_CUÑA_ADELANTE_GR_2
Q: 5.07
VALVULA_ALTA_PRESION
W103.02
W101.01
W101.03
Q: 4.05
000009
(001480)
W101.01
Q: 12.01
LED_PURGA_DX_INY_2
TIM
0132
D411
TIEMPO_MAX_DER_SUELA_INY_2
[OP1]
<T0132(bit)>
a1437
[OP2]

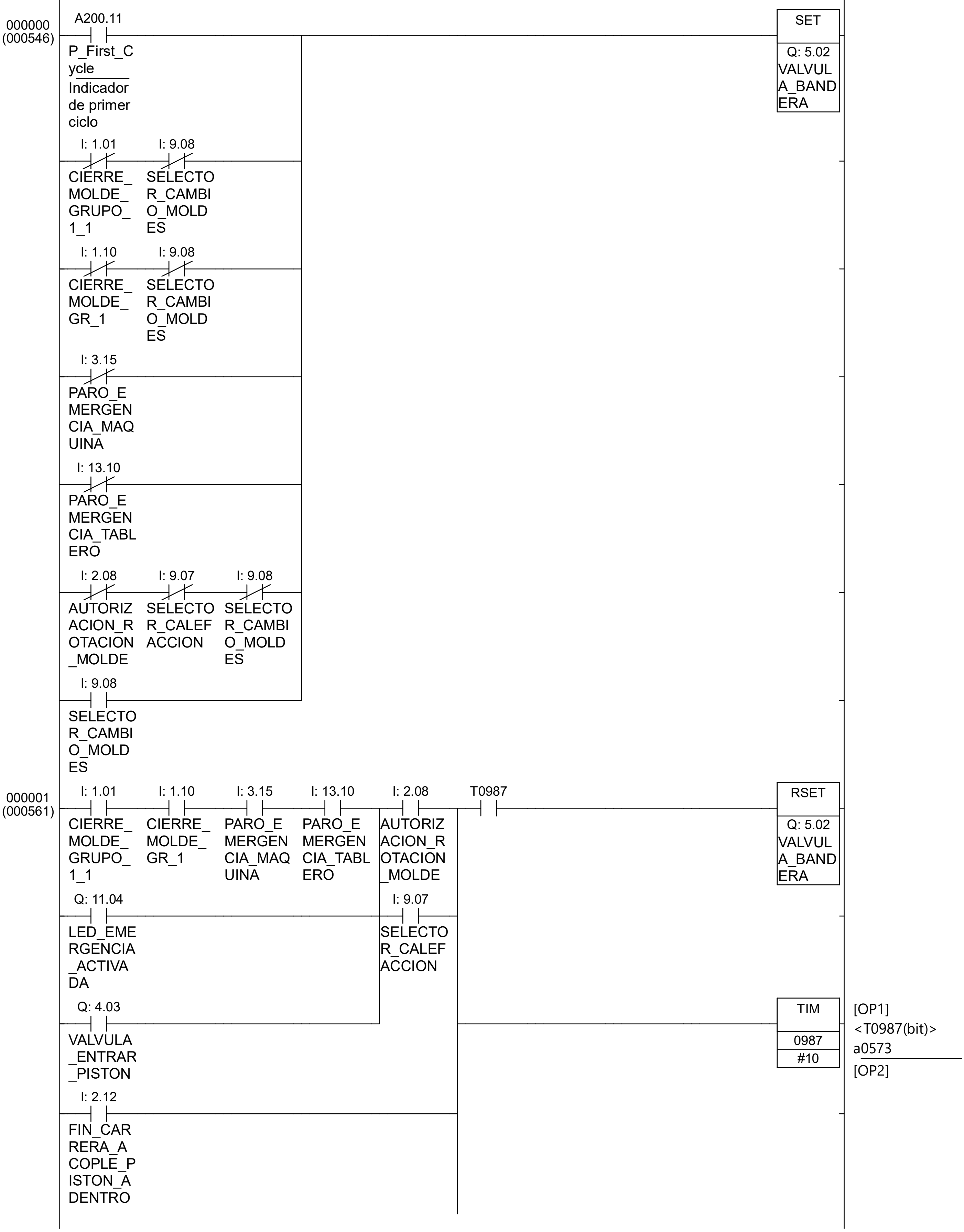

000010
(001483)
W101.01
Q: 12.02
LED_PURGA_SX_INY_2
TIM
0133
D412
TIEMPO_MAX_IZQ_SUELA_INY_2
[OP1]
<T0133(bit)>
a1454
[OP2]
000011
(001486)
W103.07
W100.05
I: 10.02
PULSADOR_RETROCESO_GRUPO_1
I: 10.09
SELECTOR_AUTO_INY_2
RSET
W101.01
<W101.01>
a0600 b1466
a1469 a1472
a1474 a1480
a1483
000012
(001492)
W100.05
I: 2.09
MICRO_GRUPO_1_ADELANTE
W200.00
I: 2.06
MICRO_CARGA_INY_2
SET
W200.00
<W200.00>
b0381 a0515
a0979 a0985
a0993 a0998
a1011 a1017
a1026 a1029
b1494 a1501
a1506 a1511
a1518
000013
(001497)
W100.05
I: 10.02
PULSADOR_RETROCESO_GRUPO_1
W103.07
RSET
W200.00
<W200.00>
b0381 a0515
a0979 a0985
a0993 a0998
a1011 a1017
a1026 a1029
b1494 a1501
a1506 a1511
a1518
000014
(001501)
W200.00
D439.00
Q: 12.01
LED_PURGA_DX_INY_2
MOV
(021)
D418
VELOCIDAD_INY_IZQ_SUELA_INY_2
Q: 2112
[OP1]
<cD00418>
c1509
[OP2]
<c2112>
c0947 c1041
c1509
MOV
(021)
D416
PRESION_INY_IZQUIERDA_SUELA_INY_2
Q: 2116
[OP1]
<cD00416>
c1510
[OP2]
<c2116>
c0948 c1042
c1510
000015
(001506)
W200.00
D439.00
Q: 12.02
LED_PURGA_SX_INY_2
MOV
(021)
D418
VELOCIDAD_IN
[OP1]
<cD00418>
c1504
[OP2]



Y_IZQ_SUELA_INY_2
Q: 2112
<c2112>
c0947 c1041 c1504
MOV (021)
D416
PRESION_INY_IZQUIERDA_SUELA_INY_2
Q: 2116
[OP1]
<cD00416>
c1505
[OP2]
<c2116>
c0948 c1042 c1505
000016 (001511)
W200.00
W102.00
W102.02
SET
W102.01
<W102.01>
a0991 a1024 a1515
000017 (001515)
W102.01
TIM
0130
D57
CONTRAPRESION_INY_2
[OP1]
<T0130(bit)>
a1517
[OP2]
000018 (001517)
T0130
W200.00
SET
W103.08
<W103.08>
a1520 a1522 a1524
000019 (001520)
W103.08
RSET
W102.01
<W102.01>
a0991 a1024 a1515
000020 (001522)
W103.08
TIM
0141
D410
TIEMPO_APOYO_SUELA_INY_2
[OP1]
<T0141(bit)>
a1525
[OP2]
000021 (001524)
W103.08
T0141
SET
W103.07
<W103.07>
a1486 a1499 a1527
000022 (001527)
W103.07
RSET
W103.08
<W103.08>
a1520 a1522 a1524

[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : BANDERA_DE_SEGURIDAD]

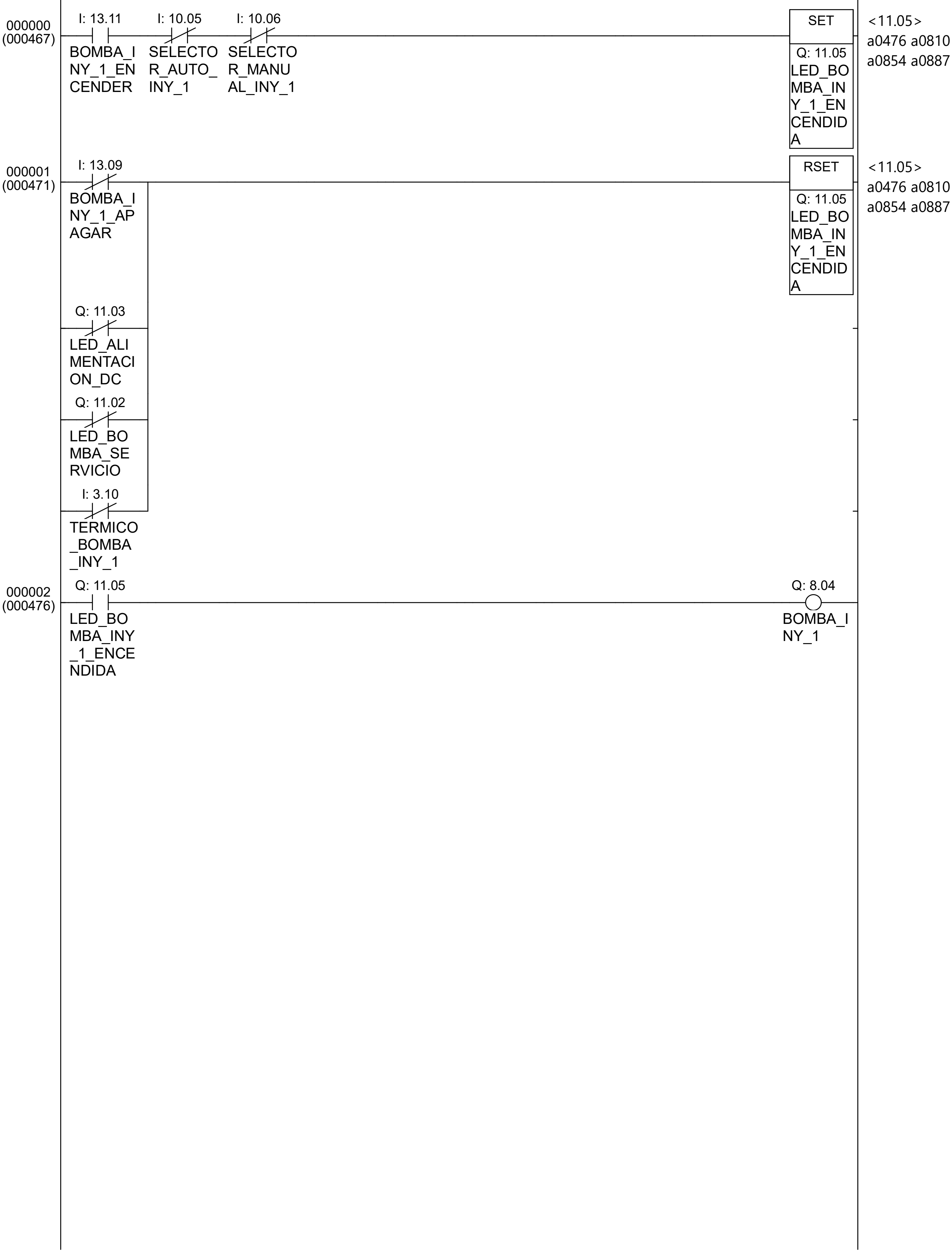


Q: 4.00

VALVULA
_GIRO_M
ESA

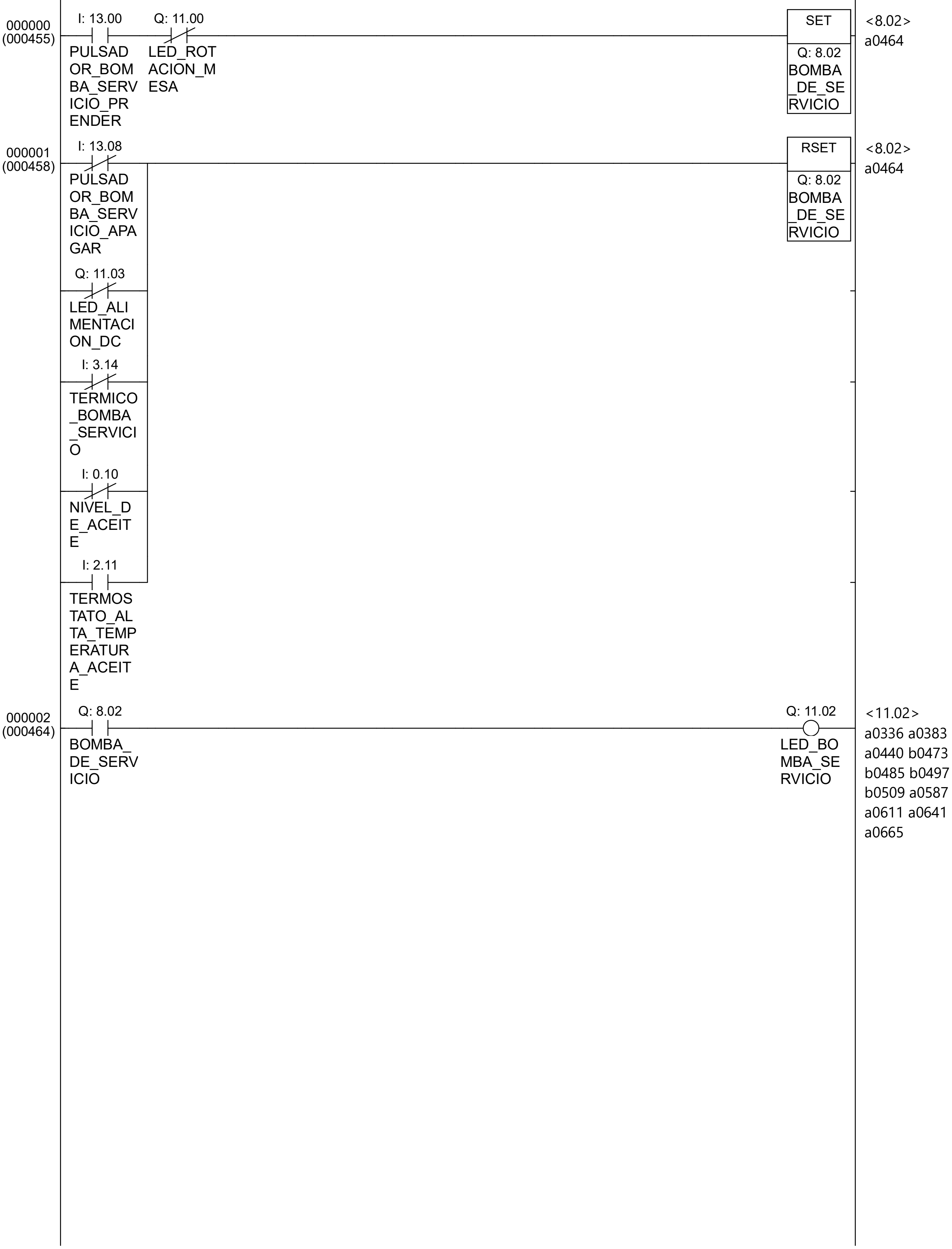
[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : BOMBA_INY_1]



[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : BOMBA_DE_SERVICIO]



[Nombre de programa : OTTOGALLI_5]

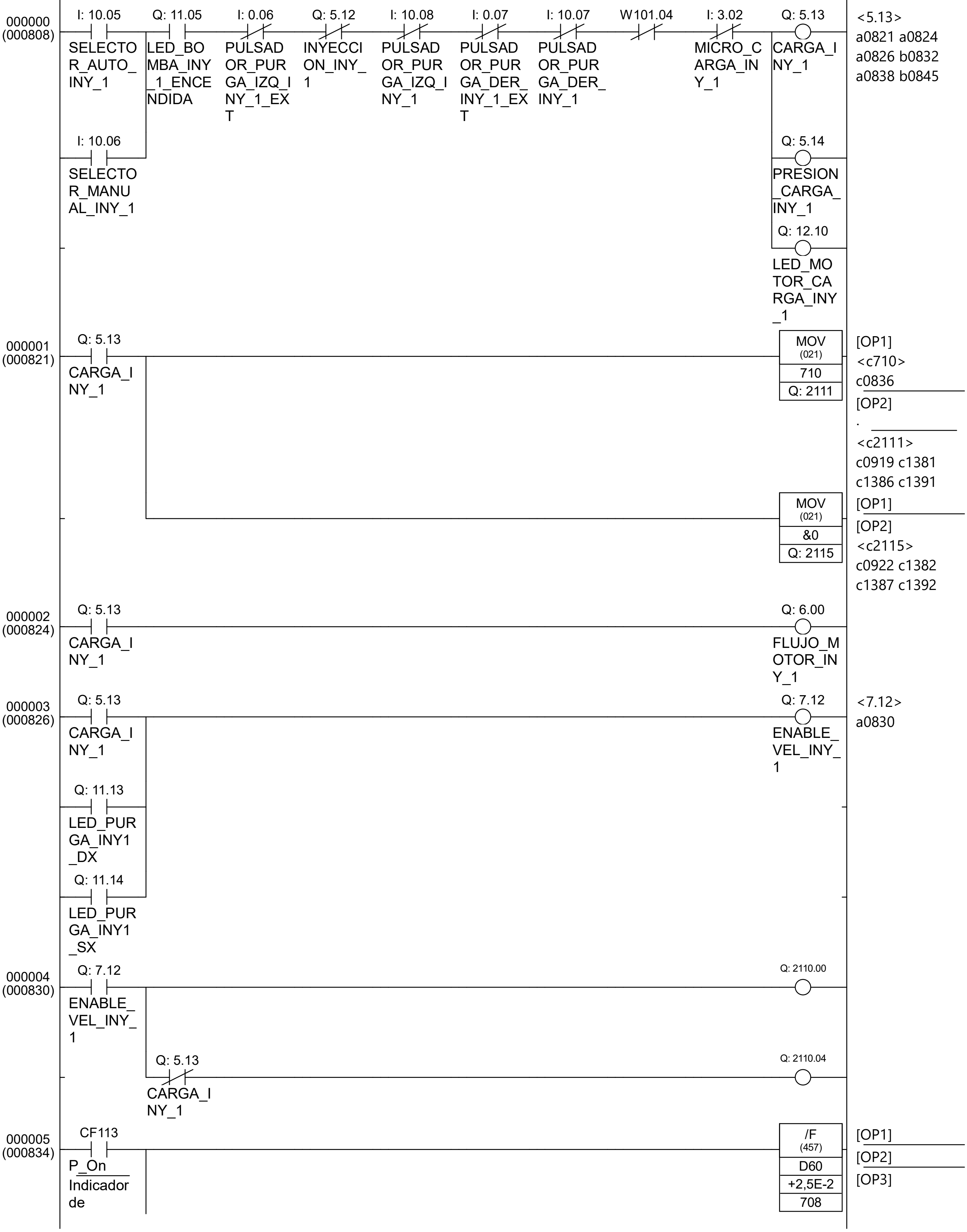
[Nombre de sección : CAMBIO_DE_MOLDES]

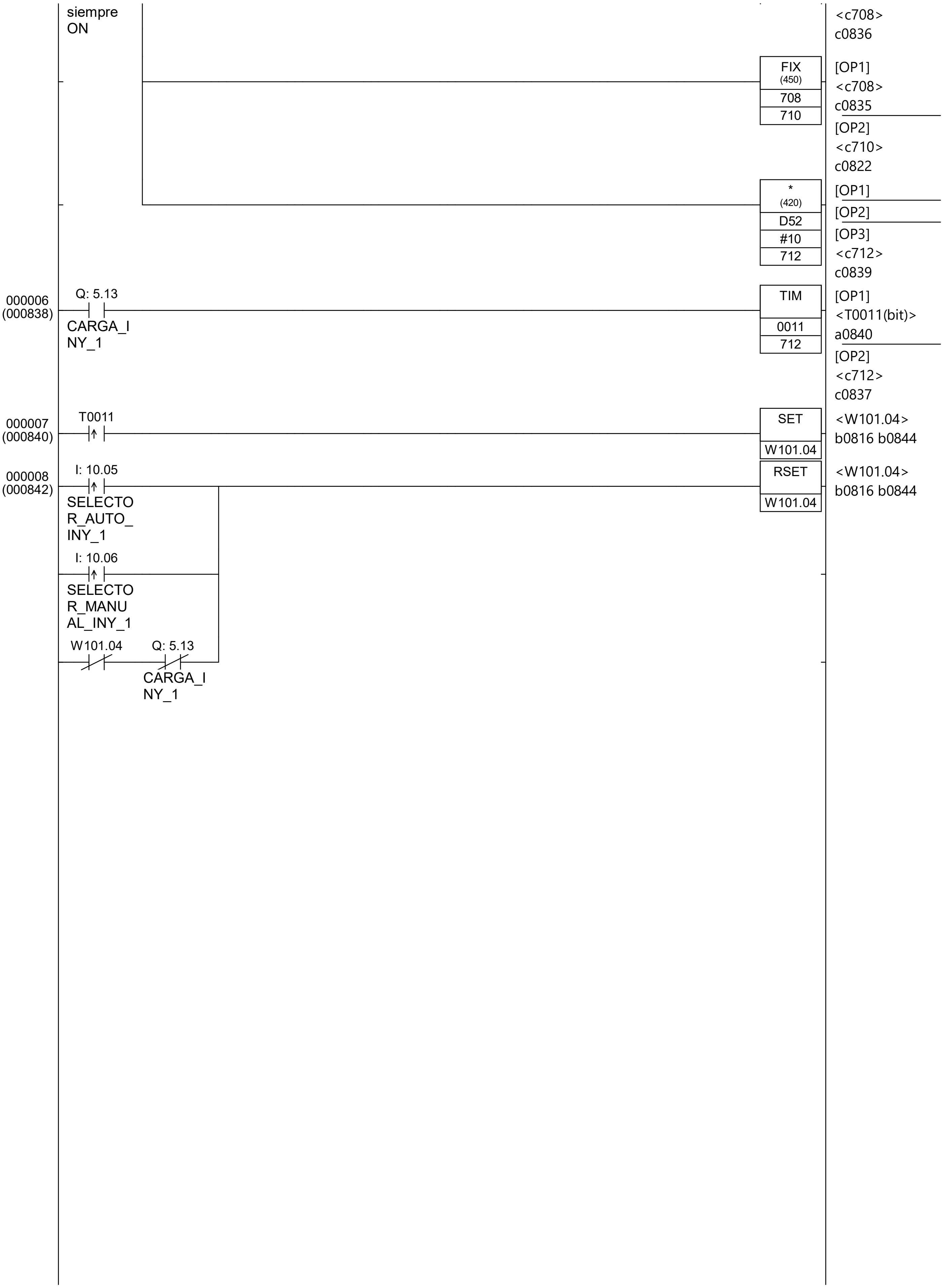
000000
(000686)

I: 9.08	Q: 7.06
SELECTOR_CAMBIO_MOLDES	SALIDA_CAMBIO_DE_MOLDES

[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : CARGA_INY_1]




siempre ON
<c708>
c0836
FIX
(450)
708
710
[OP1]
<c708>
c0835
[OP2]
<c710>
c0822
*
(420)
D52
#10
712
[OP1]
[OP2]
[OP3]
<c712>
c0839
000006
(000838)
Q: 5.13
CARGA_INY_1
TIM
0011
712
[OP1]
<T0011(bit)>
a0840
[OP2]
<c712>
c0837
000007
(000840)
T0011
SET
W101.04
<W101.04>
b0816 b0844
000008
(000842)
I: 10.05
SELECTOR_AUTO_INY_1
I: 10.06
SELECTOR_MANUAL_INY_1
W101.04
Q: 5.13
CARGA_INY_1
RSET
W101.04
<W101.04>
b0816 b0844

[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : CARGA_INY_2]

000000 (000933)

I: 10.09 SELECTOR_AUTO_INY_2
I: 10.10 SELECTOR_MANUAL_INY_2
Q: 11.06 LED_BOMBA_INY_2
I: 0.04 PULSADOR_PURGA_IZQ_INY_2_EXT
Q: 6.03 INYECCION_INY_2
I: 10.12 PULSADOR_PURGA_IZQ_INY_2
I: 0.05 PULSADOR_PURGA_DER_INY_2_EXT
I: 10.11 PULSADOR_PURGA_DER_INY_2
W101.09
I: 2.06 MICRO_CARGA_INY_2
Q: 6.04 CARGA_INY_2
Q: 6.05 PRESION_CARGA_INY_2
Q: 12.15 LED_MOTOR_CARGA_INY_2

<6.04> a0946 a0949 b0955 a0961 b0968

000001 (000946)

Q: 6.04 CARGA_INY_2

MOV (021) D730 Q: 2112

[OP1] <cD00730> c0959

[OP2] <c2112> c1041 c1504 c1509

MOV (021) &0 Q: 2116

[OP1]

[OP2] <c2116> c1042 c1505 c1510

000002 (000949)

Q: 6.04 CARGA_INY_2
Q: 12.01 LED_PURGA_DX_INY_2
Q: 12.02 LED_PURGA_SX_INY_2
Q: 7.11 ENABLE_VEL_INY_2

<7.11> a0953

000003 (000953)

Q: 7.11 ENABLE_VEL_INY_2
Q: 2110.01
Q: 6.04 CARGA_INY_2
Q: 2110.05

000004 (000957)

CF113 P_On Indicador de siempre ON

/F (457) D900 +2,5E-2 D728

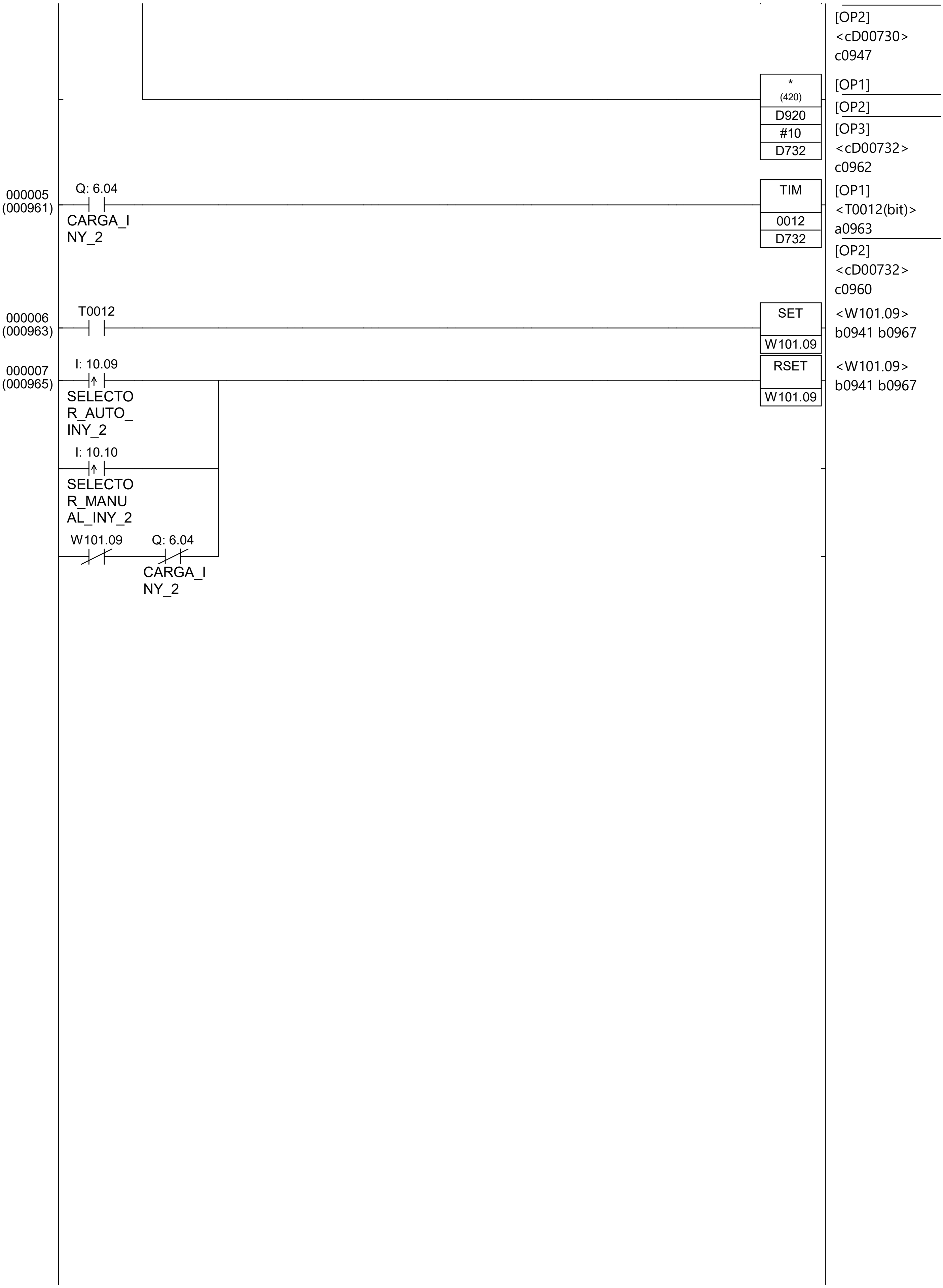
[OP1]

[OP2]

[OP3] <cD00728> c0959

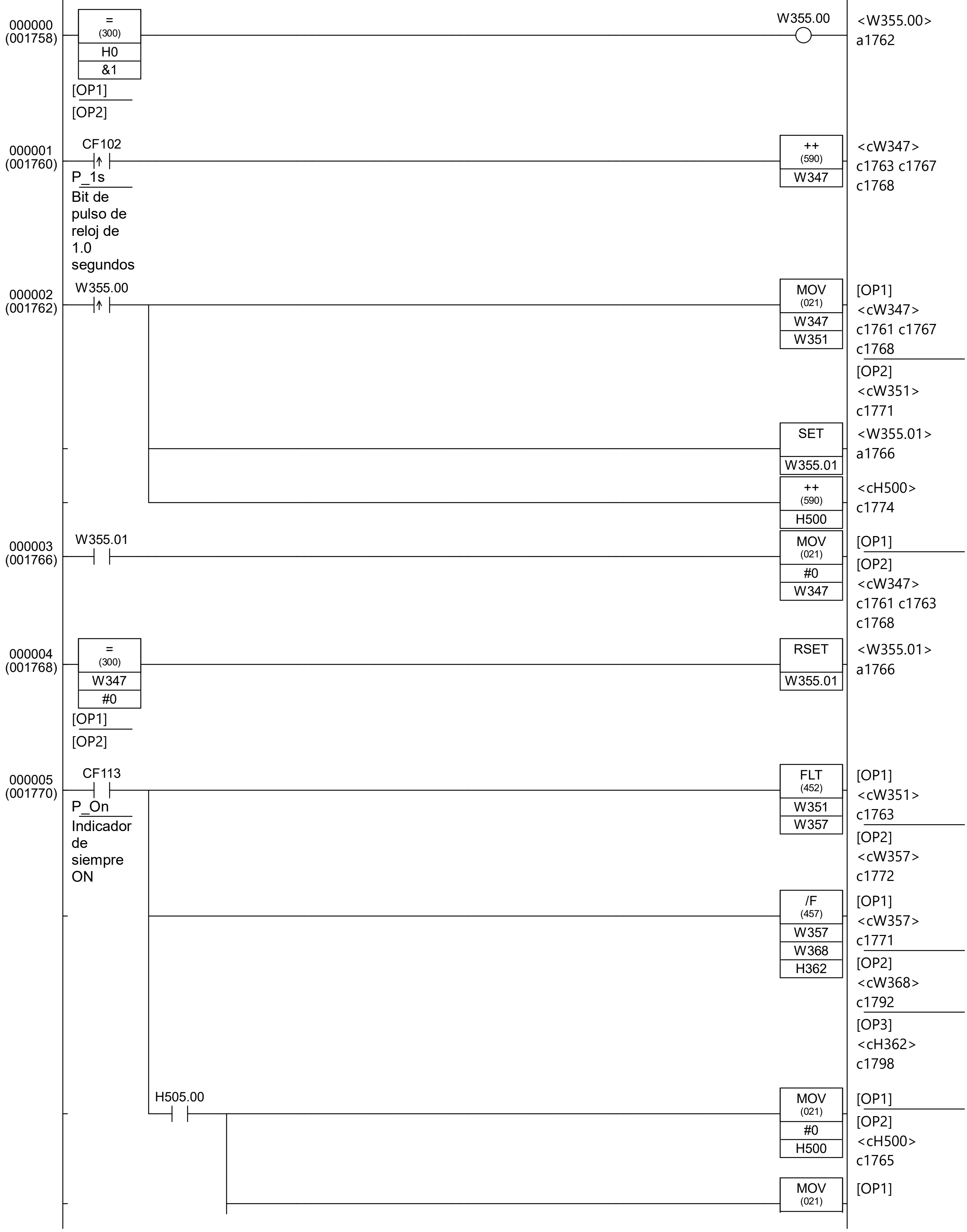
FIX (450) D728 D730

[OP1] <cD00728> c0958


[OP2]
<cD00730>
c0947
*
(420)
D920
#10
D732
[OP1]
[OP2]
[OP3]
<cD00732>
c0962
000005
(000961)
Q: 6.04
CARGA_INY_2
TIM
0012
D732
[OP1]
<T0012(bit)>
a0963
[OP2]
<cD00732>
c0960
000006
(000963)
T0012
SET
W101.09
<W101.09>
b0941 b0967
000007
(000965)
I: 10.09
SELECTOR_AUTO_INY_2
I: 10.10
SELECTOR_MANUAL_INY_2
W101.09
Q: 6.04
CARGA_INY_2
RSET
W101.09
<W101.09>
b0941 b0967

[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : CICLOS]



#0
H504
[OP2]
<cH504>
c1796 c1803

MOV
(021)
#0
W500
[OP1]
[OP2]
<cW500>
c1813

MOV
(021)
#0
W501
[OP1]
[OP2]
<cW501>
c1852

MOV
(021)
#0
W502
[OP1]
[OP2]
<cW502>
c1818

MOV
(021)
#0
W503
[OP1]
[OP2]
<cW503>
c1859

MOV
(021)
#0
W504
[OP1]
[OP2]
<cW504>
c1823

MOV
(021)
#0
W505
[OP1]
[OP2]
<cW505>
c1866

MOV
(021)
#0
W506
[OP1]
[OP2]
<cW506>
c1828

MOV
(021)
#0
W507
[OP1]
[OP2]
<cW507>
c1873

MOV
(021)
#0
W508
[OP1]
[OP2]
<cW508>
c1833

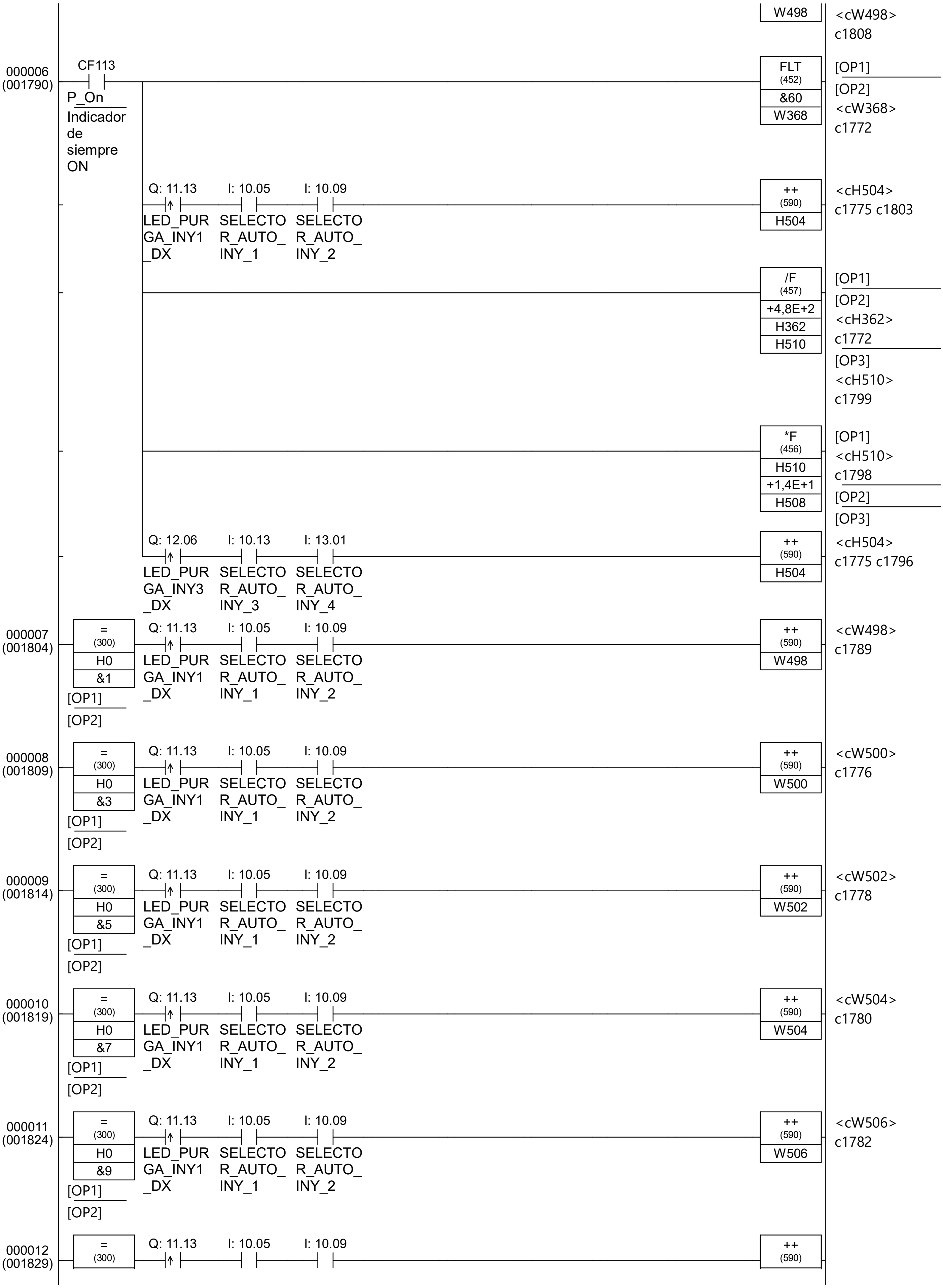
MOV
(021)
#0
W509
[OP1]
[OP2]
<cW509>
c1880

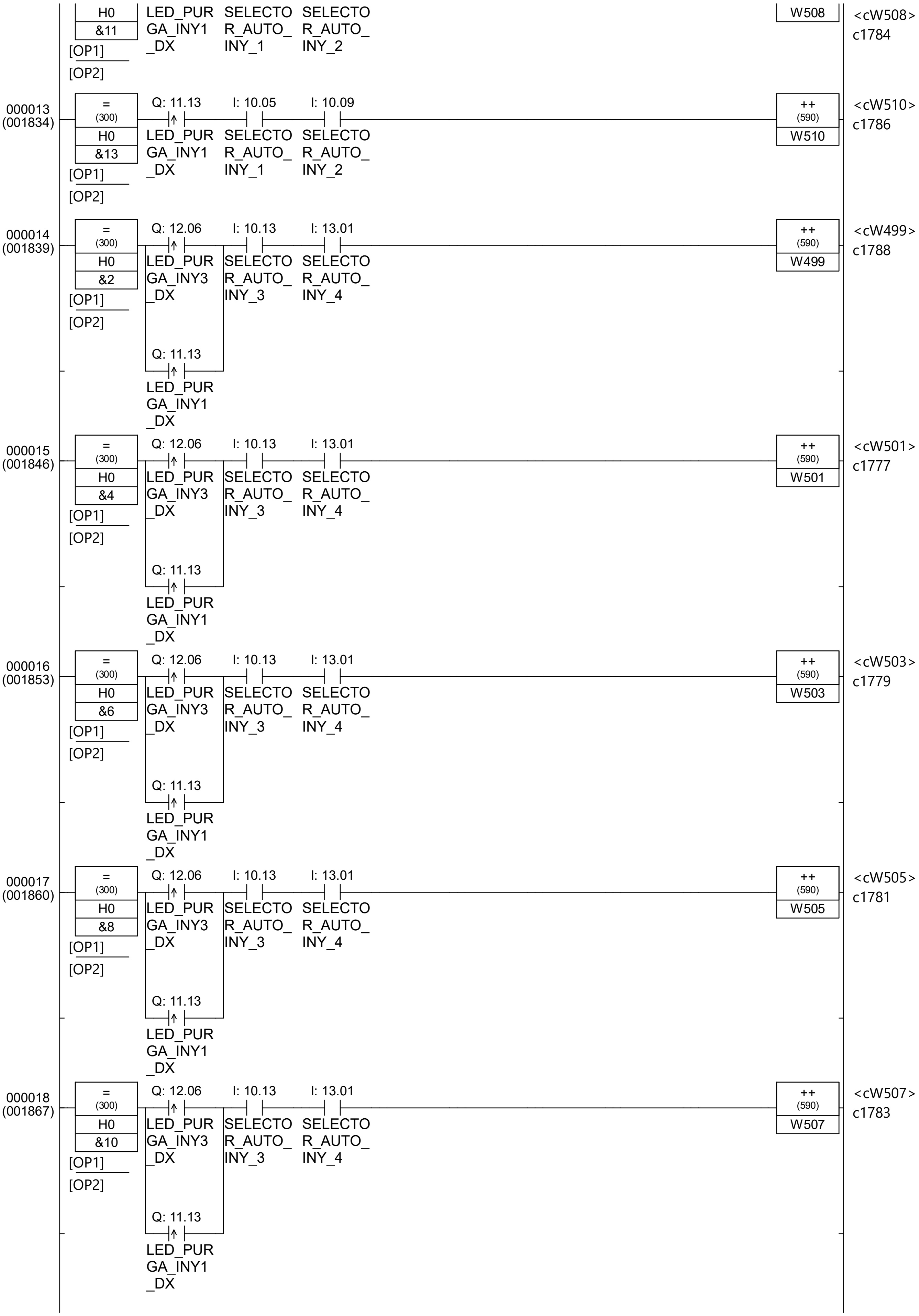
MOV
(021)
#0
W510
[OP1]
[OP2]
<cW510>
c1838

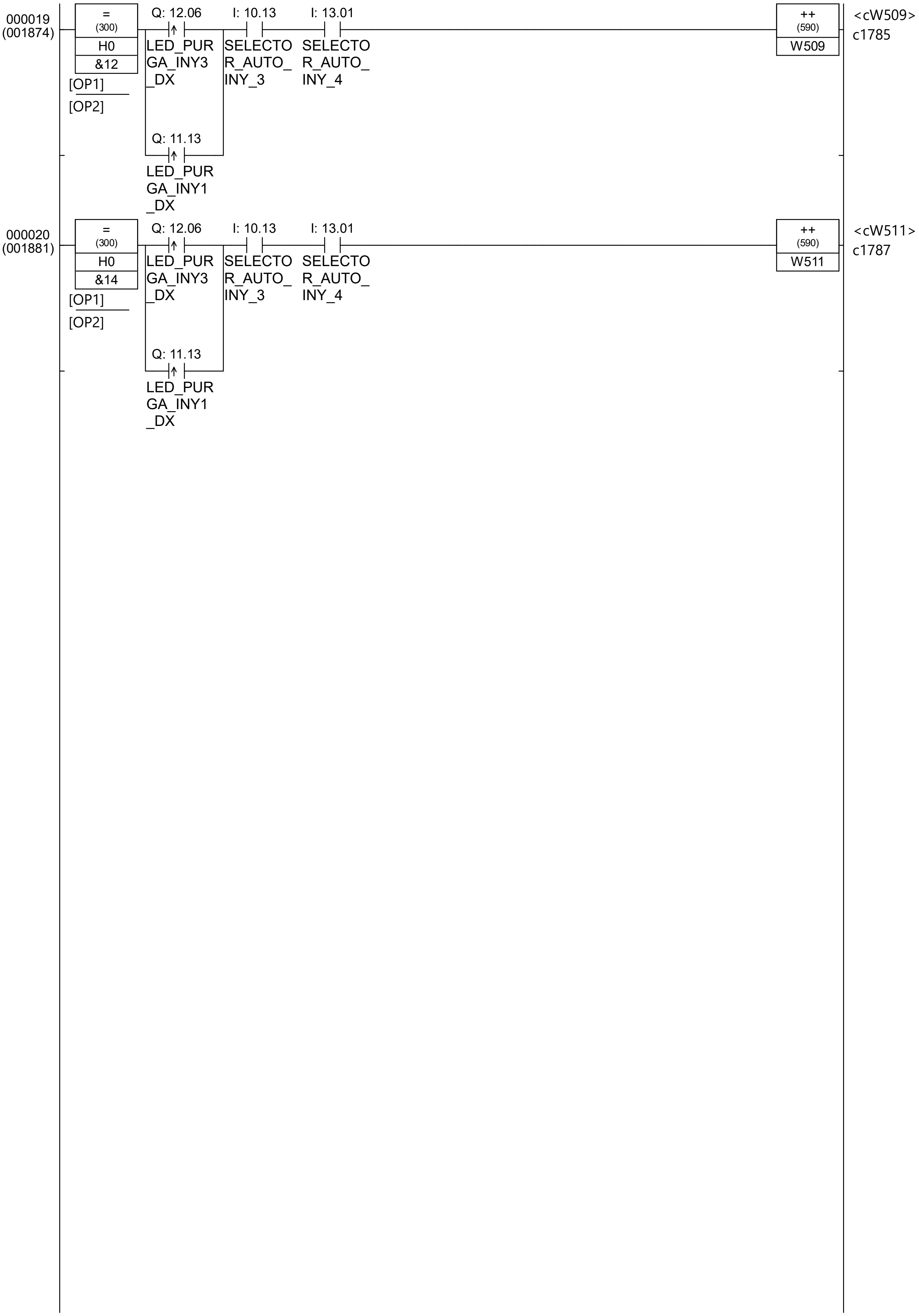
MOV
(021)
#0
W511
[OP1]
[OP2]
<cW511>
c1887

MOV
(021)
#0
W499
[OP1]
[OP2]
<cW499>
c1845

MOV
(021)
#0
[OP1]
[OP2]

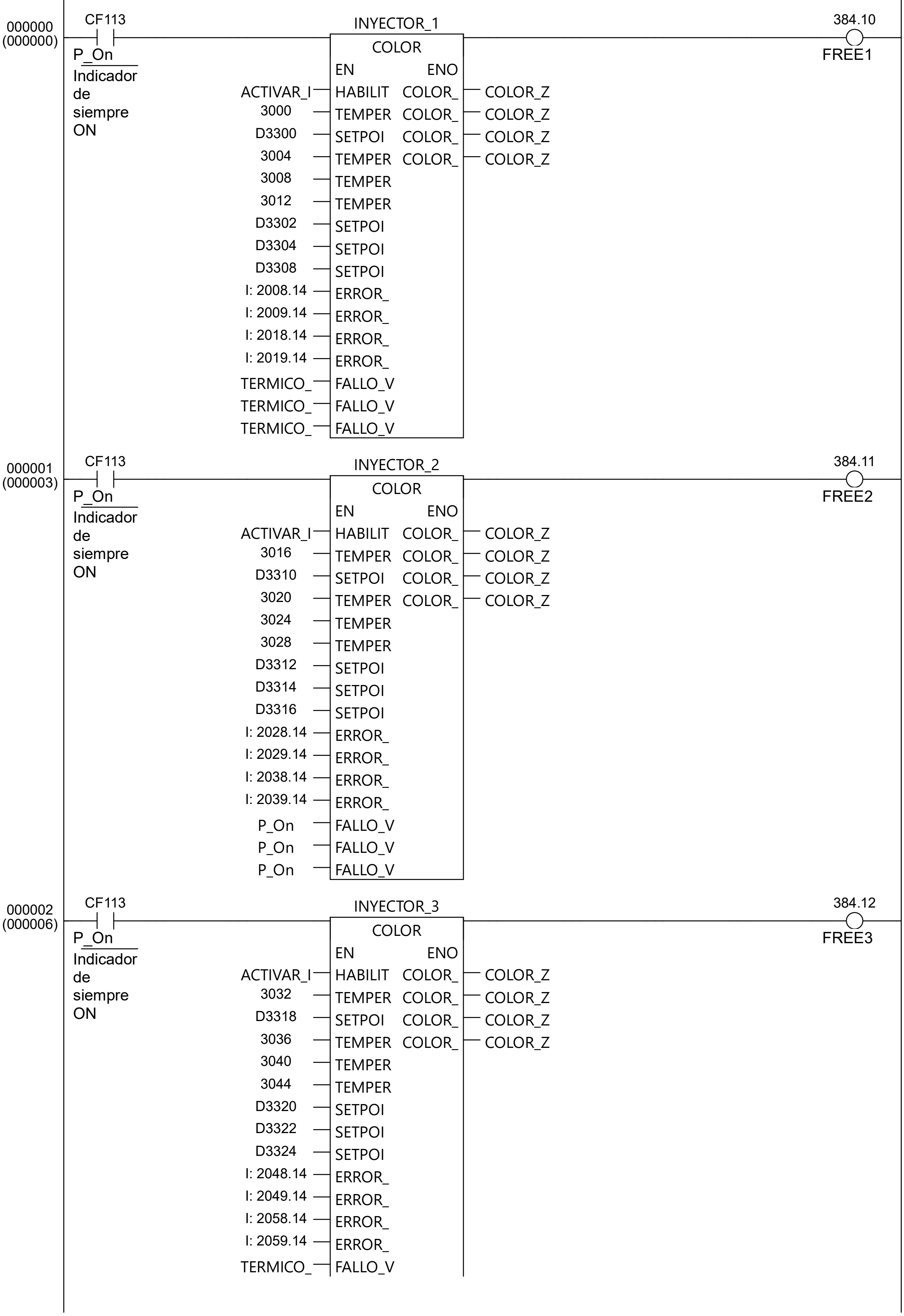

W498
<cW498>
c1808
000006
(001790)
CF113
P_On
Indicador
de
siempre
ON
FLT
(452)
&60
W368
[OP1]
[OP2]
<cW368>
c1772
Q: 11.13
I: 10.05
I: 10.09
LED_PURGA_INY1_DX
SELECTOR_AUTO_INY_1
SELECTOR_AUTO_INY_2
++
(590)
H504
<cH504>
c1775 c1803
/F
(457)
+4,8E+2
H362
H510
[OP1]
[OP2]
<cH362>
c1772
[OP3]
<cH510>
c1799
*F
(456)
H510
+1,4E+1
H508
[OP1]
<cH510>
c1798
[OP2]
[OP3]
Q: 12.06
I: 10.13
I: 13.01
LED_PURGA_INY3_DX
SELECTOR_AUTO_INY_3
SELECTOR_AUTO_INY_4
++
(590)
H504
<cH504>
c1775 c1796
000007
(001804)
=
(300)
H0
&1
[OP1]
[OP2]
Q: 11.13
I: 10.05
I: 10.09
LED_PURGA_INY1_DX
SELECTOR_AUTO_INY_1
SELECTOR_AUTO_INY_2
++
(590)
W498
<cW498>
c1789
000008
(001809)
=
(300)
H0
&3
[OP1]
[OP2]
Q: 11.13
I: 10.05
I: 10.09
LED_PURGA_INY1_DX
SELECTOR_AUTO_INY_1
SELECTOR_AUTO_INY_2
++
(590)
W500
<cW500>
c1776
000009
(001814)
=
(300)
H0
&5
[OP1]
[OP2]
Q: 11.13
I: 10.05
I: 10.09
LED_PURGA_INY1_DX
SELECTOR_AUTO_INY_1
SELECTOR_AUTO_INY_2
++
(590)
W502
<cW502>
c1778
000010
(001819)
=
(300)
H0
&7
[OP1]
[OP2]
Q: 11.13
I: 10.05
I: 10.09
LED_PURGA_INY1_DX
SELECTOR_AUTO_INY_1
SELECTOR_AUTO_INY_2
++
(590)
W504
<cW504>
c1780
000011
(001824)
=
(300)
H0
&9
[OP1]
[OP2]
Q: 11.13
I: 10.05
I: 10.09
LED_PURGA_INY1_DX
SELECTOR_AUTO_INY_1
SELECTOR_AUTO_INY_2
++
(590)
W506
<cW506>
c1782
000012
(001829)
=
(300)
Q: 11.13
I: 10.05
I: 10.09
++
(590)

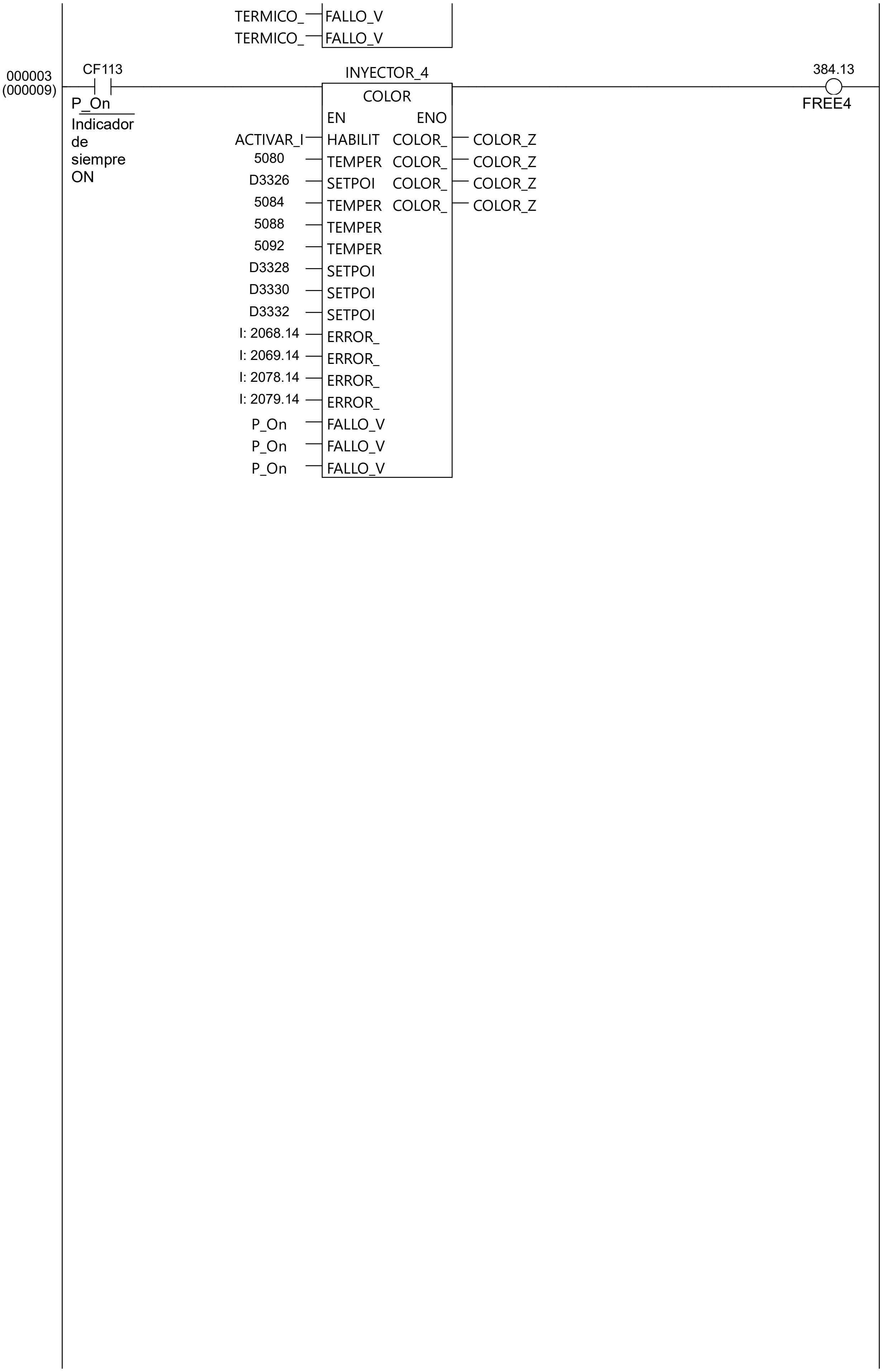

H0
&11
[OP1]
[OP2]
LED_PUR GA_INY1 _DX
SELECTO R_AUTO_ INY_1
SELECTO R_AUTO_ INY_2
W508
<cW508>
c1784
000013
(001834)
=
(300)
H0
&13
[OP1]
[OP2]
Q: 11.13
LED_PUR GA_INY1 _DX
I: 10.05
SELECTO R_AUTO_ INY_1
I: 10.09
SELECTO R_AUTO_ INY_2
++
(590)
W510
<cW510>
c1786
000014
(001839)
=
(300)
H0
&2
[OP1]
[OP2]
Q: 12.06
LED_PUR GA_INY3 _DX
I: 10.13
SELECTO R_AUTO_ INY_3
I: 13.01
SELECTO R_AUTO_ INY_4
Q: 11.13
LED_PUR GA_INY1 _DX
++
(590)
W499
<cW499>
c1788
000015
(001846)
=
(300)
H0
&4
[OP1]
[OP2]
Q: 12.06
LED_PUR GA_INY3 _DX
I: 10.13
SELECTO R_AUTO_ INY_3
I: 13.01
SELECTO R_AUTO_ INY_4
Q: 11.13
LED_PUR GA_INY1 _DX
++
(590)
W501
<cW501>
c1777
000016
(001853)
=
(300)
H0
&6
[OP1]
[OP2]
Q: 12.06
LED_PUR GA_INY3 _DX
I: 10.13
SELECTO R_AUTO_ INY_3
I: 13.01
SELECTO R_AUTO_ INY_4
Q: 11.13
LED_PUR GA_INY1 _DX
++
(590)
W503
<cW503>
c1779
000017
(001860)
=
(300)
H0
&8
[OP1]
[OP2]
Q: 12.06
LED_PUR GA_INY3 _DX
I: 10.13
SELECTO R_AUTO_ INY_3
I: 13.01
SELECTO R_AUTO_ INY_4
Q: 11.13
LED_PUR GA_INY1 _DX
++
(590)
W505
<cW505>
c1781
000018
(001867)
=
(300)
H0
&10
[OP1]
[OP2]
Q: 12.06
LED_PUR GA_INY3 _DX
I: 10.13
SELECTO R_AUTO_ INY_3
I: 13.01
SELECTO R_AUTO_ INY_4
Q: 11.13
LED_PUR GA_INY1 _DX
++
(590)
W507
<cW507>
c1783


000019
(001874)
=
(300)
H0
&12
[OP1]
[OP2]
Q: 12.06
LED_PURGA_INY3_DX
I: 10.13
SELECTOR_AUTO_INY_3
I: 13.01
SELECTOR_AUTO_INY_4
Q: 11.13
LED_PURGA_INY1_DX
++
(590)
W509
<cW509>
c1785
000020
(001881)
=
(300)
H0
&14
[OP1]
[OP2]
Q: 12.06
LED_PURGA_INY3_DX
I: 10.13
SELECTOR_AUTO_INY_3
I: 13.01
SELECTOR_AUTO_INY_4
Q: 11.13
LED_PURGA_INY1_DX
++
(590)
W511
<cW511>
c1787

[Nombre de programa : OTTOGALLI_5]

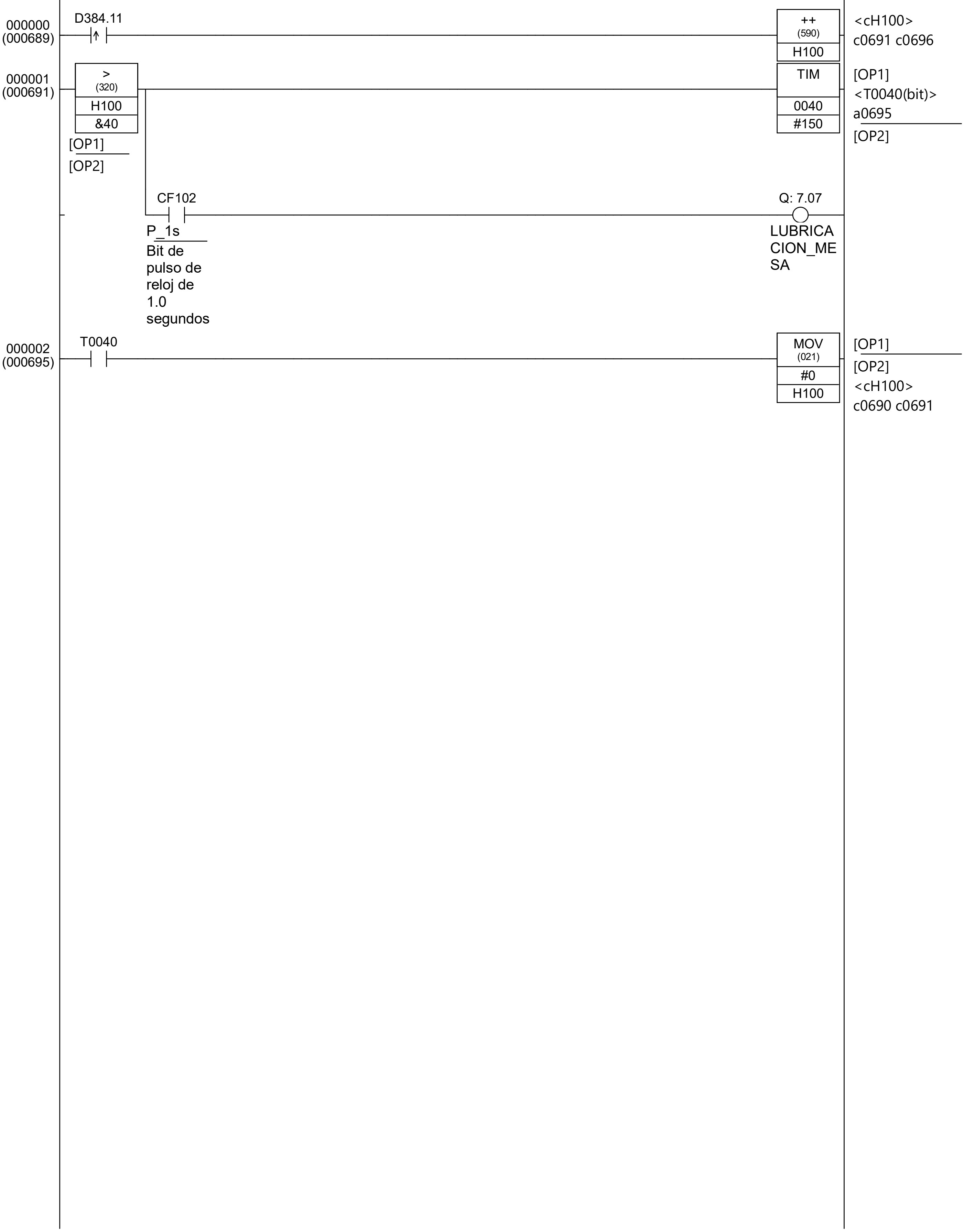
[Nombre de sección : GENERACION_COLOR_ZONAS]




TERMICO_ FALLO_V
TERMICO_ FALLO_V
000003
(000009)
CF113
P_On
Indicador
de
siempre
ON
INYECTOR_4
COLOR
EN ENO
ACTIVAR_I HABILIT COLOR_ COLOR_Z
5080 TEMPER COLOR_ COLOR_Z
D3326 SETPOI COLOR_ COLOR_Z
5084 TEMPER COLOR_ COLOR_Z
5088 TEMPER
5092 TEMPER
D3328 SETPOI
D3330 SETPOI
D3332 SETPOI
I: 2068.14 ERROR_
I: 2069.14 ERROR_
I: 2078.14 ERROR_
I: 2079.14 ERROR_
P_On FALLO_V
P_On FALLO_V
P_On FALLO_V
384.13
FREE4

[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : LUBRICACION_MESA]



000000
(000244)

[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : MODULO_ANALOGO]

INICIALIZAR

A200.11

P_First_Cycle

Indicador de primer ciclo

MOV (021)
#FF
D21100

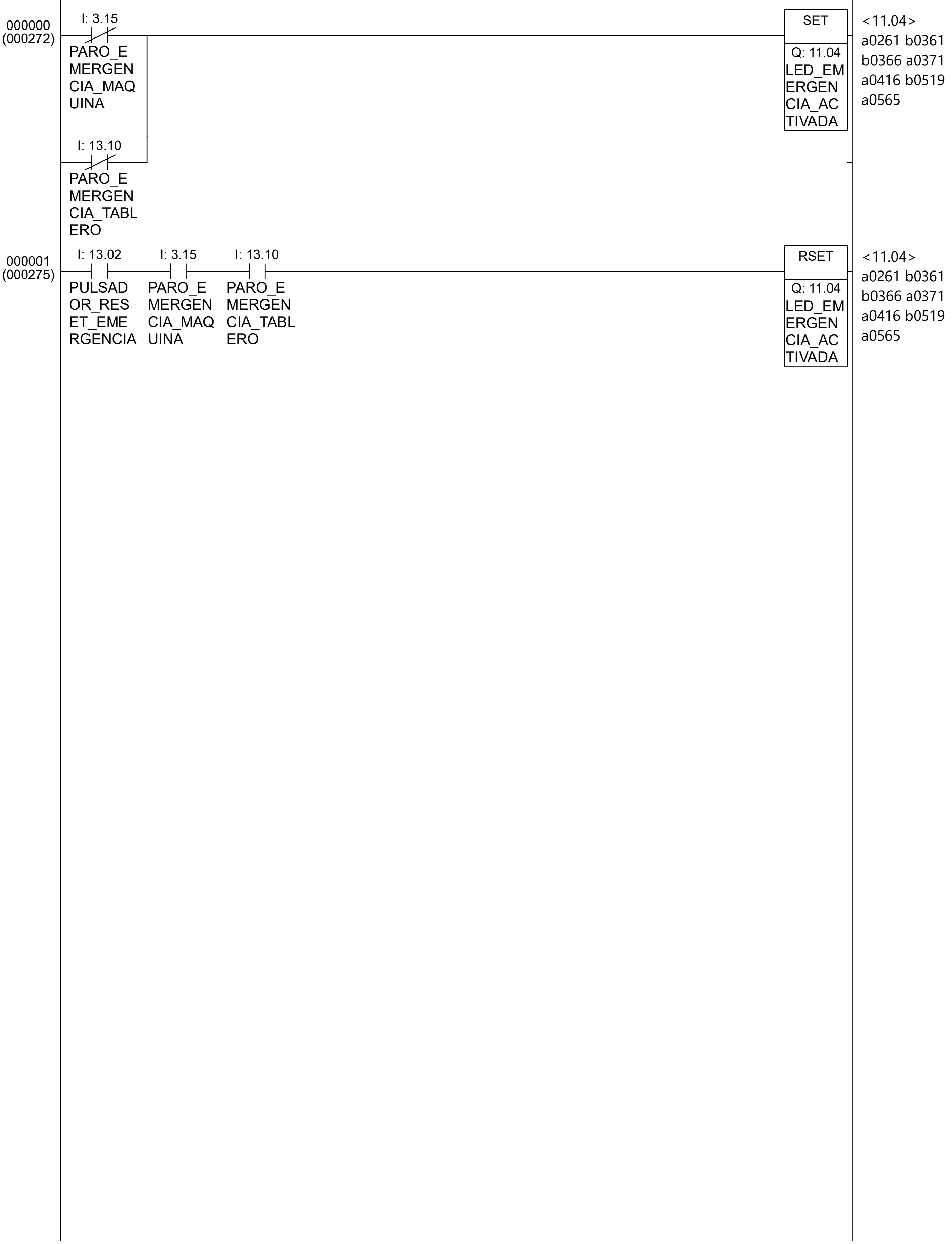
[OP1]
[OP2]

BSET (071)
#0
D21102
D21109

[OP1]
[OP2]
[OP3]

[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : PARO_EMERGENCIA]



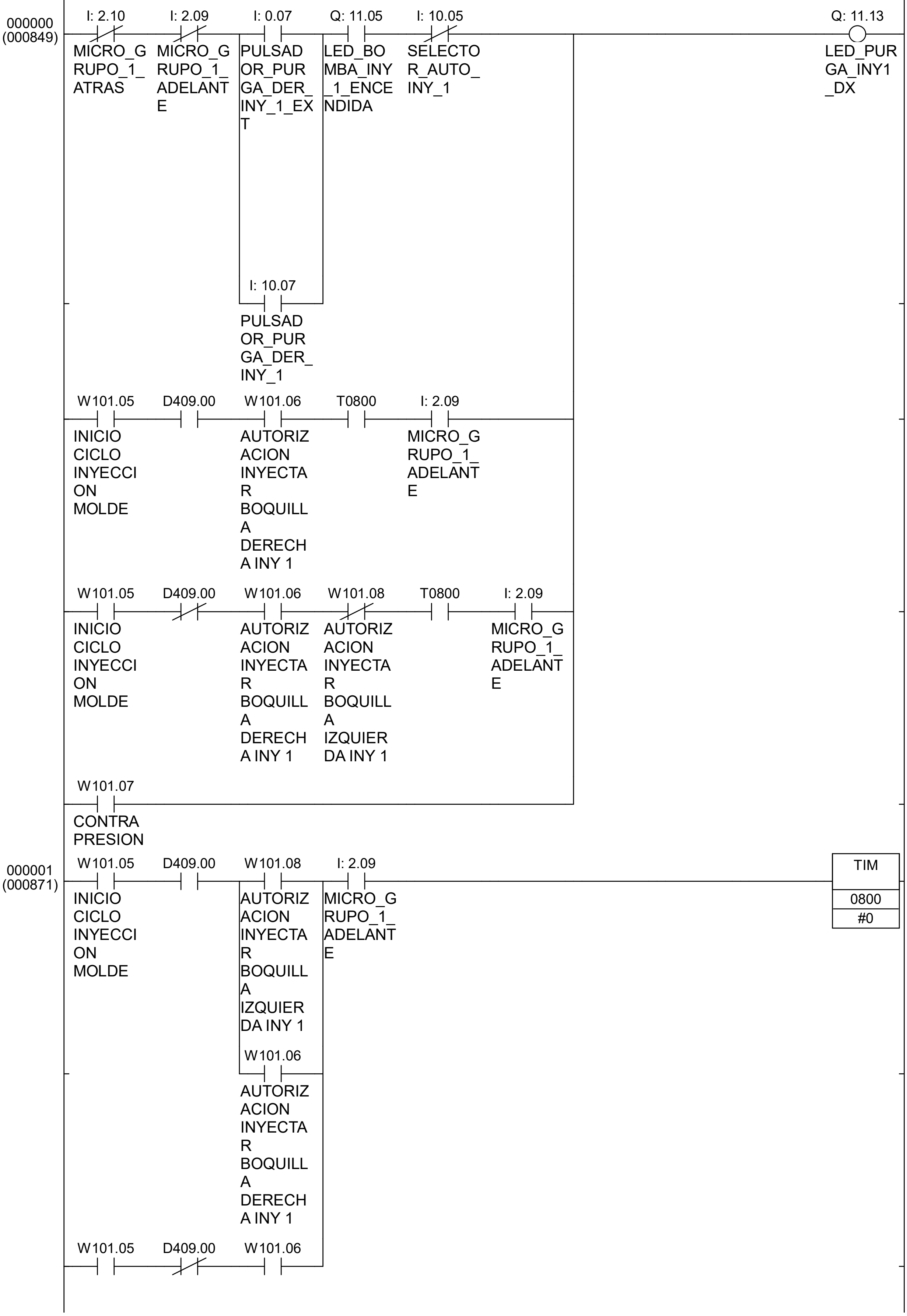
[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : POSICION_INYECCION]

000000 (000529)	I: 3.05	POSICION_INY_DER_INY_1	Q: 11.15	LED_POSICION_INYECCION_DX_INY_1	<11.15> a1292 b1301
000001 (000531)	I: 3.04	POSICION_INY_IZQ_INY_1	Q: 11.12	LED_POSICION_INYECCION_SX_INY_1	<11.12> a1296 b1323
000002 (000533)	I: 3.01	POSICION_INY_DER_INY_2	Q: 12.03	LED_POSICION_INYECCION_DX_INY_2	<12.03> a1416 b1425
000003 (000535)	I: 3.00	POSICION_INY_IZQ_INY_2	Q: 12.04	LED_POSICION_INYECCION_SX_INY_2	<12.04> a1420 b1442
000004 (000537)	I: 2.04	POSICION_INY_DER_INY_3	Q: 12.08	LED_POSICION_INYECCION_DX_INY_3	<12.08> a1534 b1543
000005 (000539)	I: 2.03	POSICION_INY_IZQ_INY_3	Q: 12.09	LED_POSICION_INYECCION_SX_INY_3	<12.09> a1538 b1560
000006 (000541)	I: 1.13	POSICION_INY_DER_INY_4	Q: 12.13	LED_POSICION_INYECCION_DX_INY_4	<12.13> a1648 b1657
000007 (000543)	I: 1.12	POSICION_INY_IZQ_INY_4	Q: 12.14	LED_POSICION_INYECCION_SX_INY_4	<12.14> a1652 b1674

[Nombre de programa : OTTOGALLI_5]

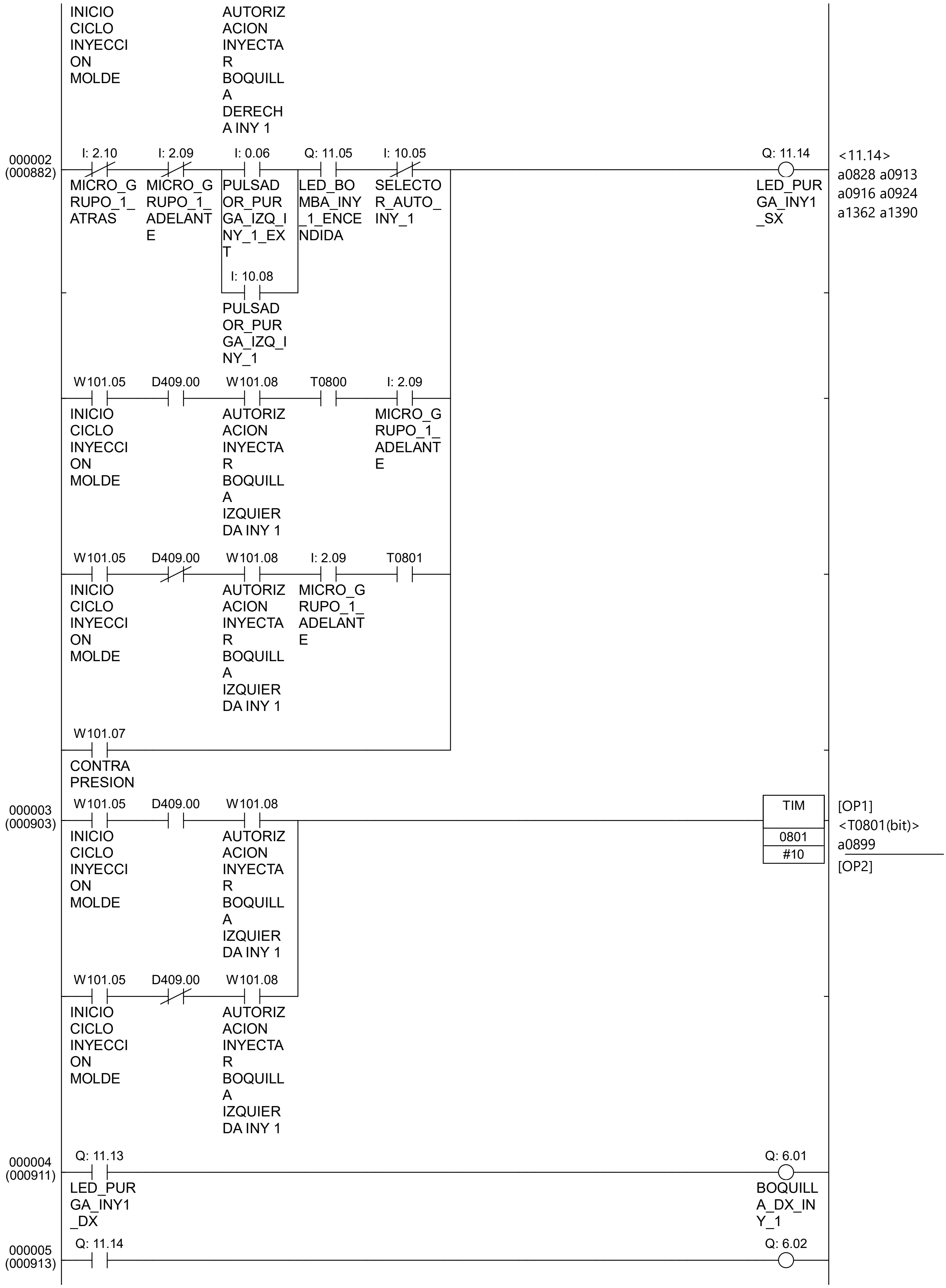
[Nombre de sección : PURGA_INY_1]

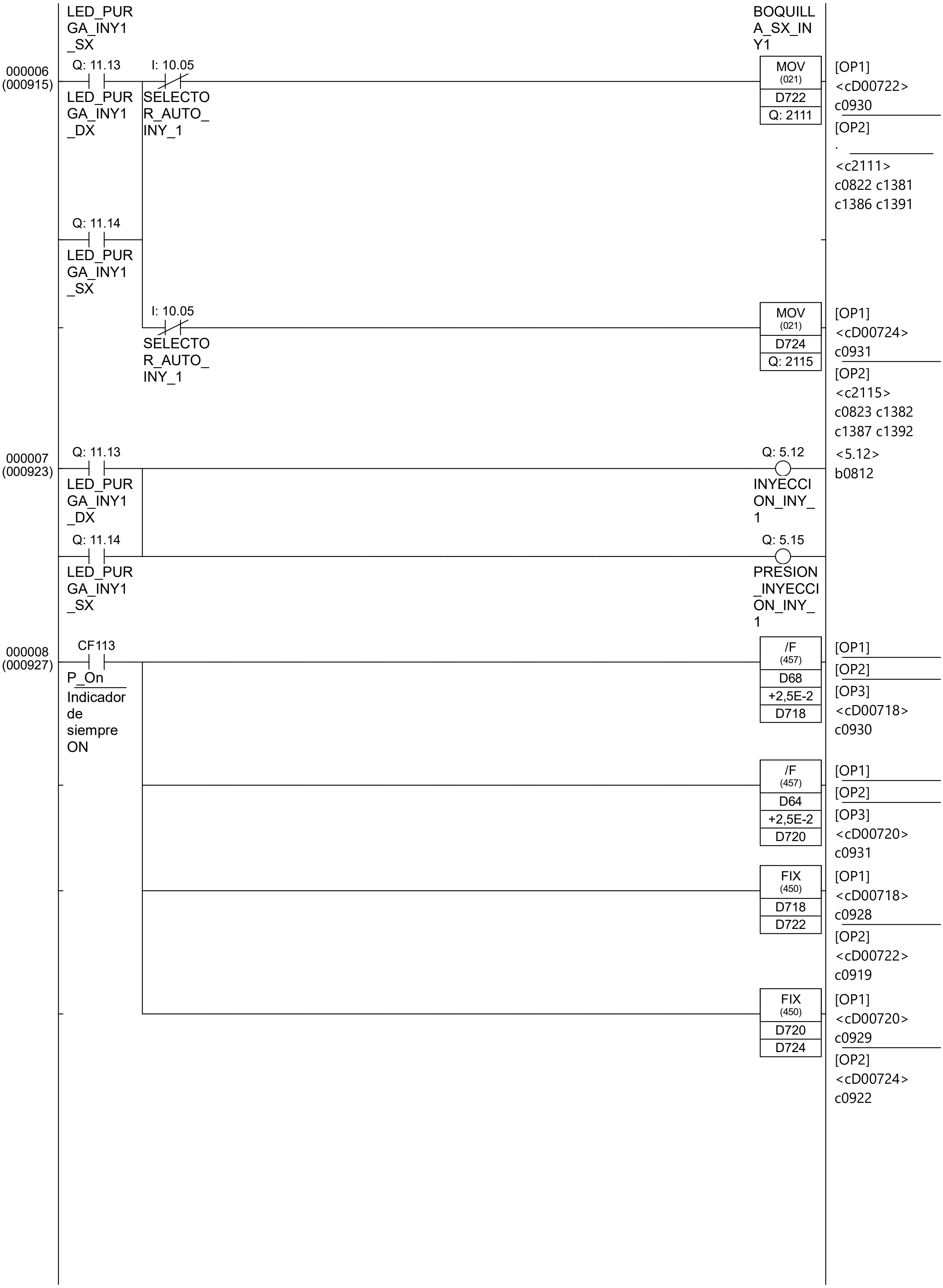


<11.13>
a0827 a0911
a0915 a0923
a1359 a1385
a1793 a1805
a1810 a1815
a1820 a1825
a1830 a1835
a1841 a1848
a1855 a1862
a1869 a1876
a1883

[OP1]
<T0800(bit)>
a0859 a0866
a0892

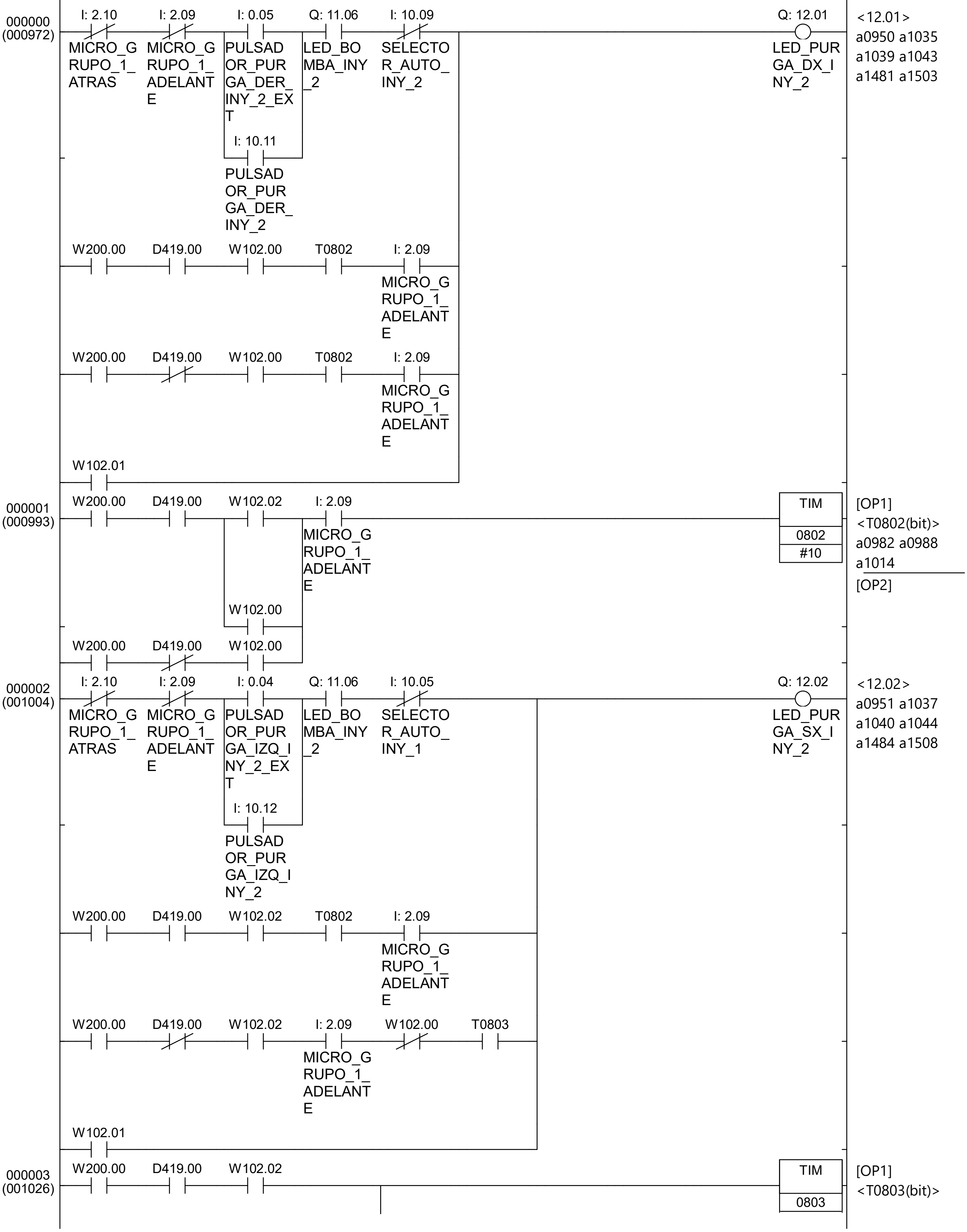
[OP2]

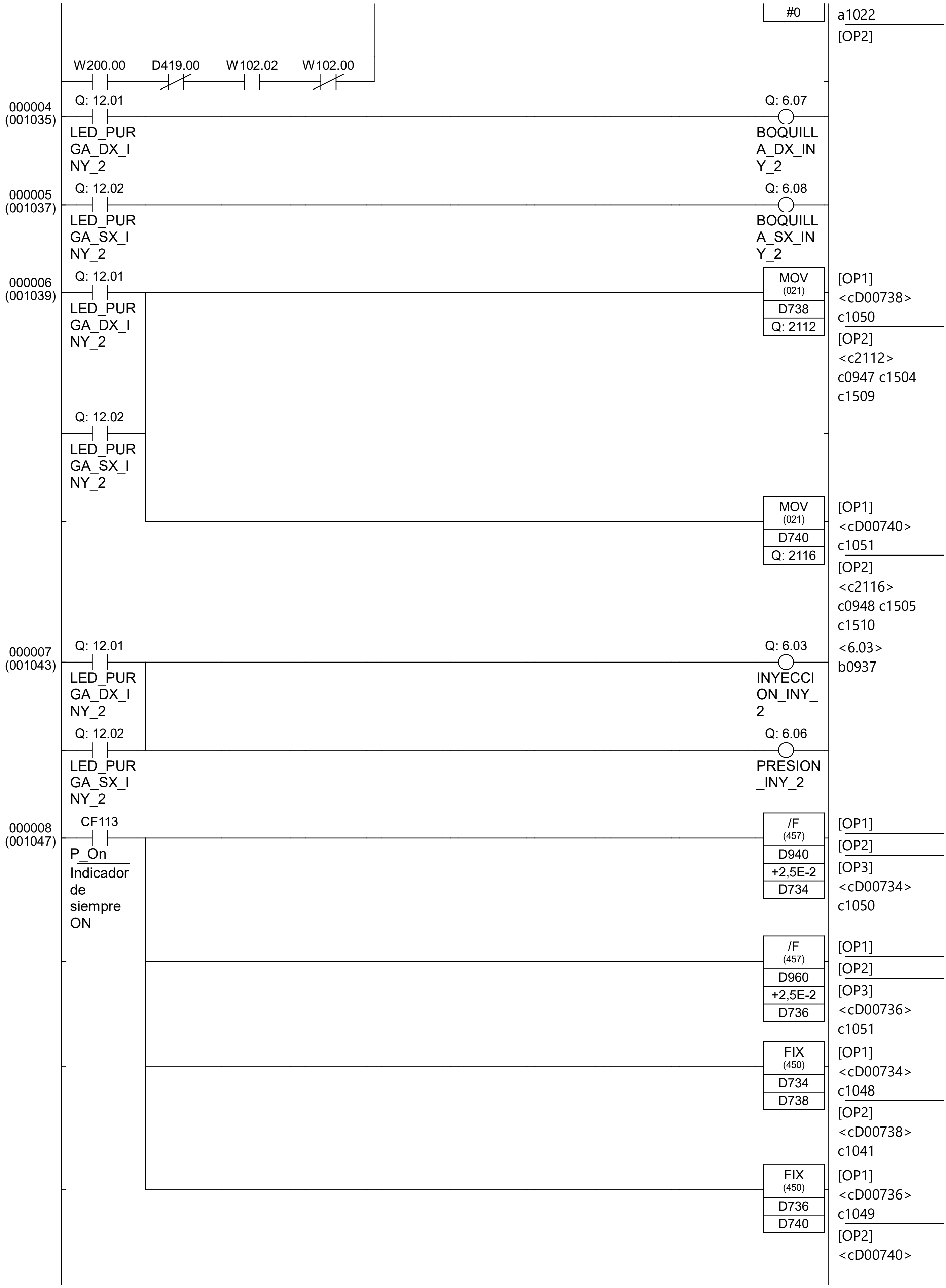

000002
(000882)
INICIO CICLO INYECCION MOLDE
AUTORIZACION INYECTAR BOQUILLA DERECHA INY 1
I: 2.10
MICRO_GRUPO_1_ATRAS
I: 2.09
MICRO_GRUPO_1_ADELANTE
I: 0.06
PULSADOR_PURGA_IZQ_INY_1_EXT
Q: 11.05
LED_BOMBA_INY_1_ENCENDIDA
I: 10.05
SELECTOR_AUTO_INY_1
Q: 11.14
LED_PURGA_INY1_SX
<11.14>
a0828 a0913
a0916 a0924
a1362 a1390
I: 10.08
PULSADOR_PURGA_IZQ_INY_1
W101.05
INICIO CICLO INYECCION MOLDE
D409.00
W101.08
AUTORIZACION INYECTAR BOQUILLA IZQUIERDA INY 1
T0800
I: 2.09
MICRO_GRUPO_1_ADELANTE
W101.05
INICIO CICLO INYECCION MOLDE
D409.00
W101.08
AUTORIZACION INYECTAR BOQUILLA IZQUIERDA INY 1
I: 2.09
MICRO_GRUPO_1_ADELANTE
T0801
W101.07
CONTRAPRESION
000003
(000903)
W101.05
INICIO CICLO INYECCION MOLDE
D409.00
W101.08
AUTORIZACION INYECTAR BOQUILLA IZQUIERDA INY 1
TIM
0801
#10
[OP1]
<T0801(bit)>
a0899
[OP2]
W101.05
INICIO CICLO INYECCION MOLDE
D409.00
W101.08
AUTORIZACION INYECTAR BOQUILLA IZQUIERDA INY 1
000004
(000911)
Q: 11.13
LED_PURGA_INY1_DX
Q: 6.01
BOQUILLA_DX_INY_1
000005
(000913)
Q: 11.14
Q: 6.02


000006
(000915)
LED_PUR
GA_INY1
_SX
Q: 11.13
LED_PUR
GA_INY1
_DX
I: 10.05
SELECTO
R_AUTO_
INY_1
BOQUILL
A_SX_IN
Y1
MOV
(021)
D722
Q: 2111
[OP1]
<cD00722>
c0930
[OP2]
.
<c2111>
c0822 c1381
c1386 c1391
Q: 11.14
LED_PUR
GA_INY1
_SX
I: 10.05
SELECTO
R_AUTO_
INY_1
MOV
(021)
D724
Q: 2115
[OP1]
<cD00724>
c0931
[OP2]
<c2115>
c0823 c1382
c1387 c1392
000007
(000923)
Q: 11.13
LED_PUR
GA_INY1
_DX
Q: 5.12
INYECCI
ON_INY_
1
<5.12>
b0812
Q: 11.14
LED_PUR
GA_INY1
_SX
Q: 5.15
PRESION
_INYECCI
ON_INY_
1
000008
(000927)
CF113
P_On
Indicador
de
siempre
ON
/F
(457)
D68
+2,5E-2
D718
[OP1]
[OP2]
[OP3]
<cD00718>
c0930
/F
(457)
D64
+2,5E-2
D720
[OP1]
[OP2]
[OP3]
<cD00720>
c0931
FIX
(450)
D718
D722
[OP1]
<cD00718>
c0928
[OP2]
<cD00722>
c0919
FIX
(450)
D720
D724
[OP1]
<cD00720>
c0929
[OP2]
<cD00724>
c0922

[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : PURGA_INY_2]

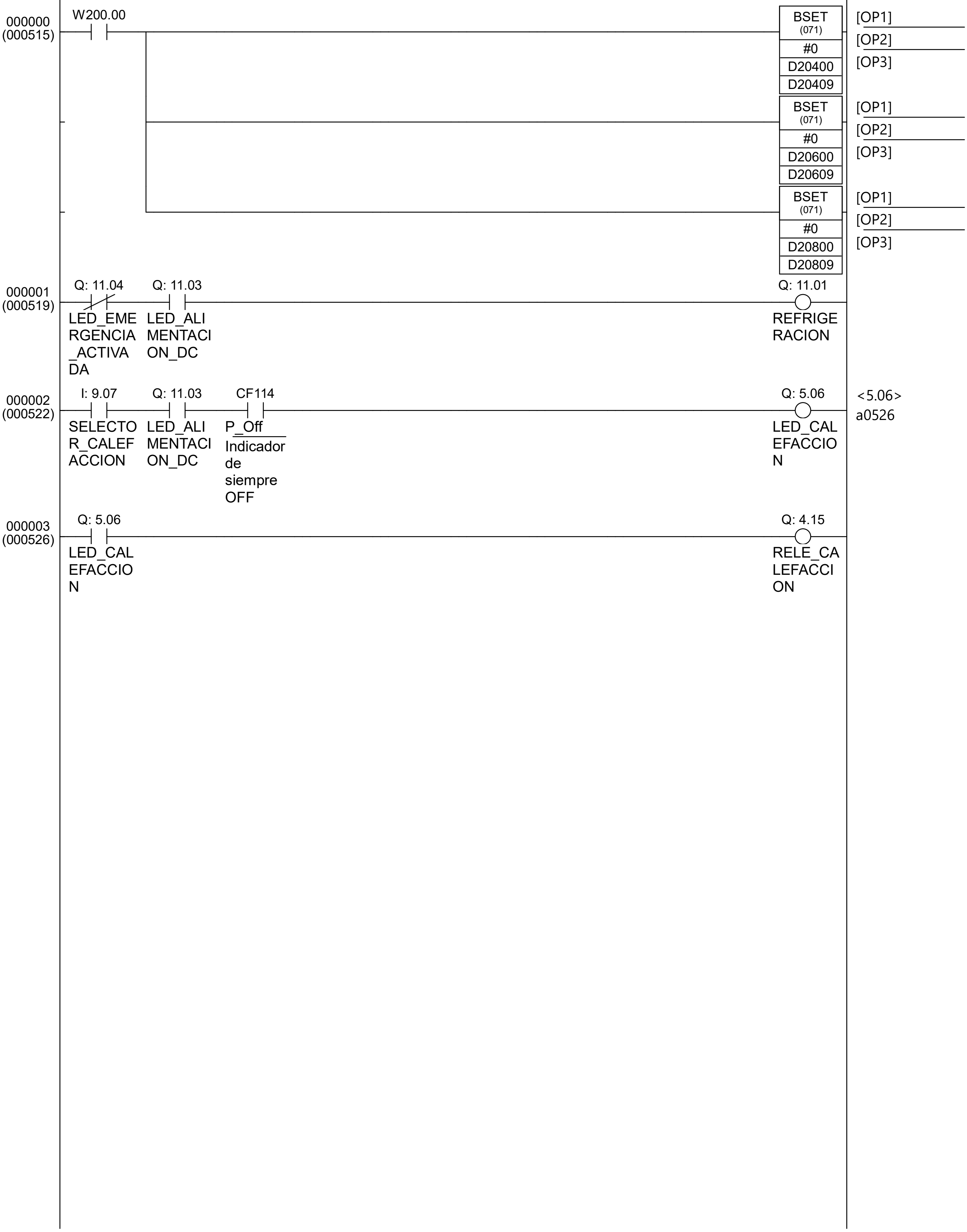




#0
a1022
[OP2]
W200.00
D419.00
W102.02
W102.00
000004
(001035)
Q: 12.01
LED_PURGA_DX_INY_2
Q: 6.07
BOQUILLA_DX_INY_2
000005
(001037)
Q: 12.02
LED_PURGA_SX_INY_2
Q: 6.08
BOQUILLA_SX_INY_2
000006
(001039)
Q: 12.01
LED_PURGA_DX_INY_2
MOV
(021)
D738
Q: 2112
[OP1]
<cD00738>
c1050
[OP2]
<c2112>
c0947 c1504
c1509
Q: 12.02
LED_PURGA_SX_INY_2
MOV
(021)
D740
Q: 2116
[OP1]
<cD00740>
c1051
[OP2]
<c2116>
c0948 c1505
c1510
000007
(001043)
Q: 12.01
LED_PURGA_DX_INY_2
Q: 6.03
INYECCION_INY_2
<6.03>
b0937
Q: 12.02
LED_PURGA_SX_INY_2
Q: 6.06
PRESION_INY_2
000008
(001047)
CF113
P_On
Indicador de siempre ON
/F
(457)
D940
+2,5E-2
D734
[OP1]
[OP2]
[OP3]
<cD00734>
c1050
/F
(457)
D960
+2,5E-2
D736
[OP1]
[OP2]
[OP3]
<cD00736>
c1051
FIX
(450)
D734
D738
[OP1]
<cD00734>
c1048
[OP2]
<cD00738>
c1041
FIX
(450)
D736
D740
[OP1]
<cD00736>
c1049
[OP2]
<cD00740>

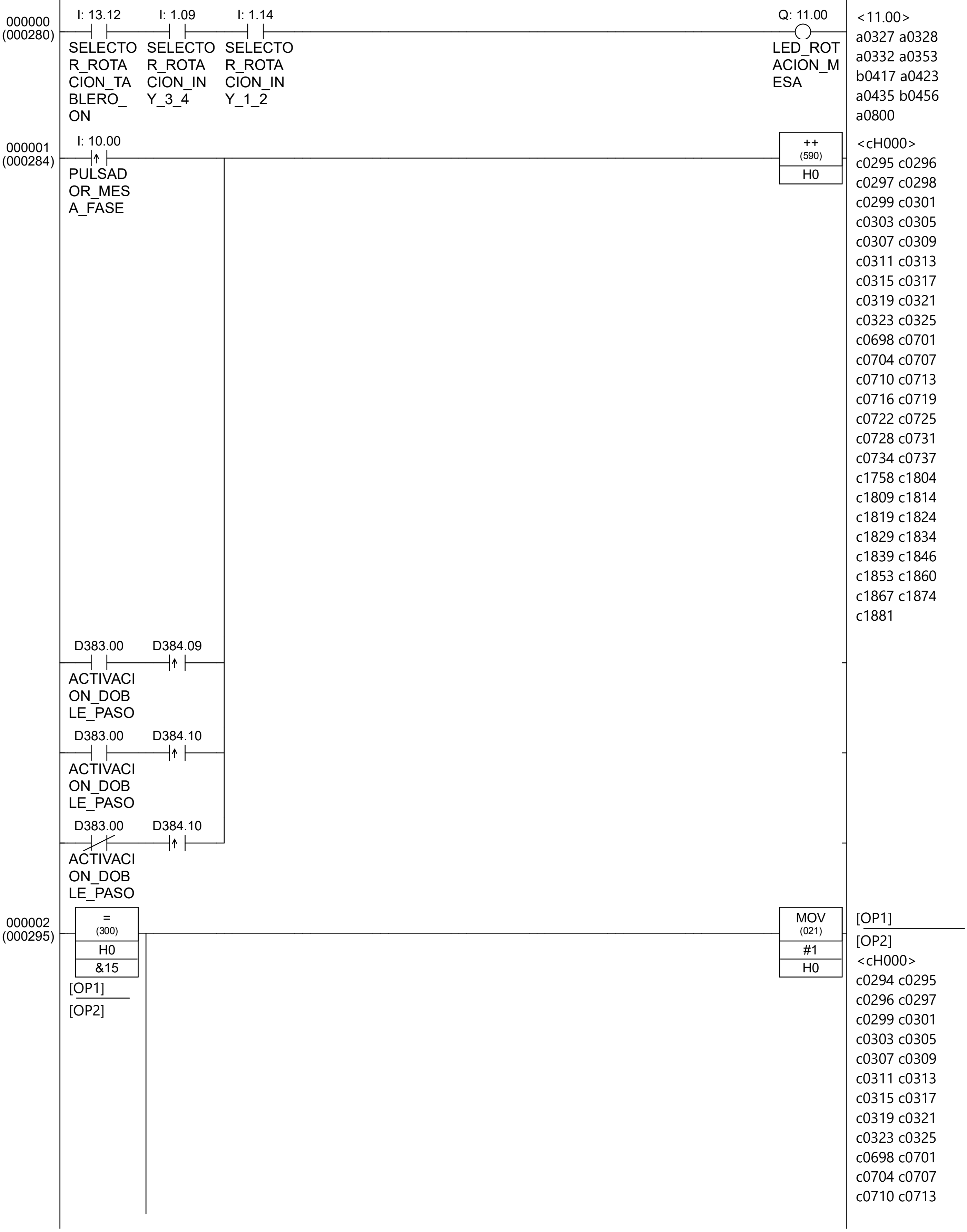
[Nombre de programa : OTTOGALLI_5]

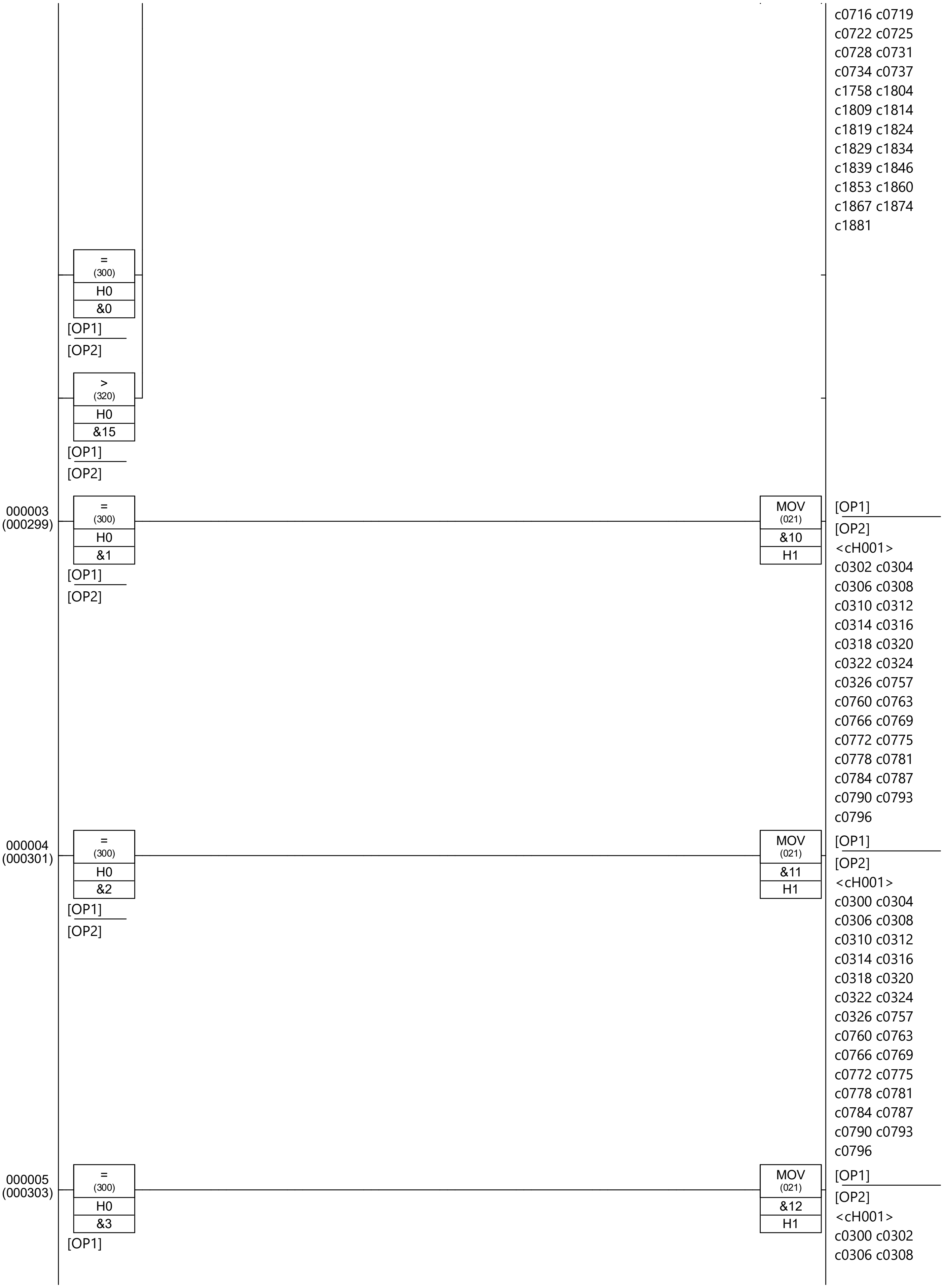
[Nombre de sección : REFRIGERACION_Y_CALEFACCION]



[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : ROTACION_MESA]




c0716 c0719
c0722 c0725
c0728 c0731
c0734 c0737
c1758 c1804
c1809 c1814
c1819 c1824
c1829 c1834
c1839 c1846
c1853 c1860
c1867 c1874
c1881
=
(300)
H0
&0
[OP1]
[OP2]
>
(320)
H0
&15
[OP1]
[OP2]
000003
(000299)
=
(300)
H0
&1
[OP1]
[OP2]
MOV
(021)
&10
H1
[OP1]
[OP2]
<cH001>
c0302 c0304
c0306 c0308
c0310 c0312
c0314 c0316
c0318 c0320
c0322 c0324
c0326 c0757
c0760 c0763
c0766 c0769
c0772 c0775
c0778 c0781
c0784 c0787
c0790 c0793
c0796
000004
(000301)
=
(300)
H0
&2
[OP1]
[OP2]
MOV
(021)
&11
H1
[OP1]
[OP2]
<cH001>
c0300 c0304
c0306 c0308
c0310 c0312
c0314 c0316
c0318 c0320
c0322 c0324
c0326 c0757
c0760 c0763
c0766 c0769
c0772 c0775
c0778 c0781
c0784 c0787
c0790 c0793
c0796
000005
(000303)
=
(300)
H0
&3
[OP1]
MOV
(021)
&12
H1
[OP1]
[OP2]
<cH001>
c0300 c0302
c0306 c0308

[OP2]

c0310 c0312
c0314 c0316
c0318 c0320
c0322 c0324
c0326 c0757
c0760 c0763
c0766 c0769
c0772 c0775
c0778 c0781
c0784 c0787
c0790 c0793
c0796

000006
(000305)

= (300)
H0
&4

[OP1]
[OP2]

MOV (021)
&13
H1

[OP1]
[OP2]
<cH001>
c0300 c0302
c0304 c0308
c0310 c0312
c0314 c0316
c0318 c0320
c0322 c0324
c0326 c0757
c0760 c0763
c0766 c0769
c0772 c0775
c0778 c0781
c0784 c0787
c0790 c0793
c0796

000007
(000307)

= (300)
H0
&5

[OP1]
[OP2]

MOV (021)
&14
H1

[OP1]
[OP2]
<cH001>
c0300 c0302
c0304 c0306
c0310 c0312
c0314 c0316
c0318 c0320
c0322 c0324
c0326 c0757
c0760 c0763
c0766 c0769
c0772 c0775
c0778 c0781
c0784 c0787
c0790 c0793
c0796

000008
(000309)

= (300)
H0
&6

[OP1]
[OP2]

MOV (021)
&1
H1

[OP1]
[OP2]
<cH001>
c0300 c0302
c0304 c0306
c0308 c0312
c0314 c0316
c0318 c0320
c0322 c0324
c0326 c0757
c0760 c0763
c0766 c0769
c0772 c0775
c0778 c0781
c0784 c0787
c0790 c0793
c0796

000009
(000311)

= (300) H0 &7

[OP1]
[OP2]

MOV (021) &2 H1

[OP1]
[OP2]
<cH001>
c0300 c0302
c0304 c0306
c0308 c0310
c0314 c0316
c0318 c0320
c0322 c0324
c0326 c0757
c0760 c0763
c0766 c0769
c0772 c0775
c0778 c0781
c0784 c0787
c0790 c0793
c0796

000010
(000313)

= (300) H0 &8

[OP1]
[OP2]

MOV (021) &3 H1

[OP1]
[OP2]
<cH001>
c0300 c0302
c0304 c0306
c0308 c0310
c0312 c0316
c0318 c0320
c0322 c0324
c0326 c0757
c0760 c0763
c0766 c0769
c0772 c0775
c0778 c0781
c0784 c0787
c0790 c0793
c0796

000011
(000315)

= (300) H0 &9

[OP1]
[OP2]

MOV (021) &4 H1

[OP1]
[OP2]
<cH001>
c0300 c0302
c0304 c0306
c0308 c0310
c0312 c0314
c0318 c0320
c0322 c0324
c0326 c0757
c0760 c0763
c0766 c0769
c0772 c0775
c0778 c0781
c0784 c0787
c0790 c0793
c0796

000012
(000317)

= (300) H0 &10

[OP1]
[OP2]

MOV (021) &5 H1

[OP1]
[OP2]
<cH001>
c0300 c0302
c0304 c0306
c0308 c0310
c0312 c0314
c0316 c0320
c0322 c0324
c0326 c0757
c0760 c0763
c0766 c0769
c0772 c0775

c0778 c0781
c0784 c0787
c0790 c0793
c0796

000013
(000319)

= (300)
H0
&11
[OP1]
[OP2]

MOV (021)
&6
H1
[OP1]
[OP2]
<cH001>
c0300 c0302
c0304 c0306
c0308 c0310
c0312 c0314
c0316 c0318
c0322 c0324
c0326 c0757
c0760 c0763
c0766 c0769
c0772 c0775
c0778 c0781
c0784 c0787
c0790 c0793
c0796

000014
(000321)

= (300)
H0
&12
[OP1]
[OP2]

MOV (021)
&7
H1
[OP1]
[OP2]
<cH001>
c0300 c0302
c0304 c0306
c0308 c0310
c0312 c0314
c0316 c0318
c0320 c0324
c0326 c0757
c0760 c0763
c0766 c0769
c0772 c0775
c0778 c0781
c0784 c0787
c0790 c0793
c0796

000015
(000323)

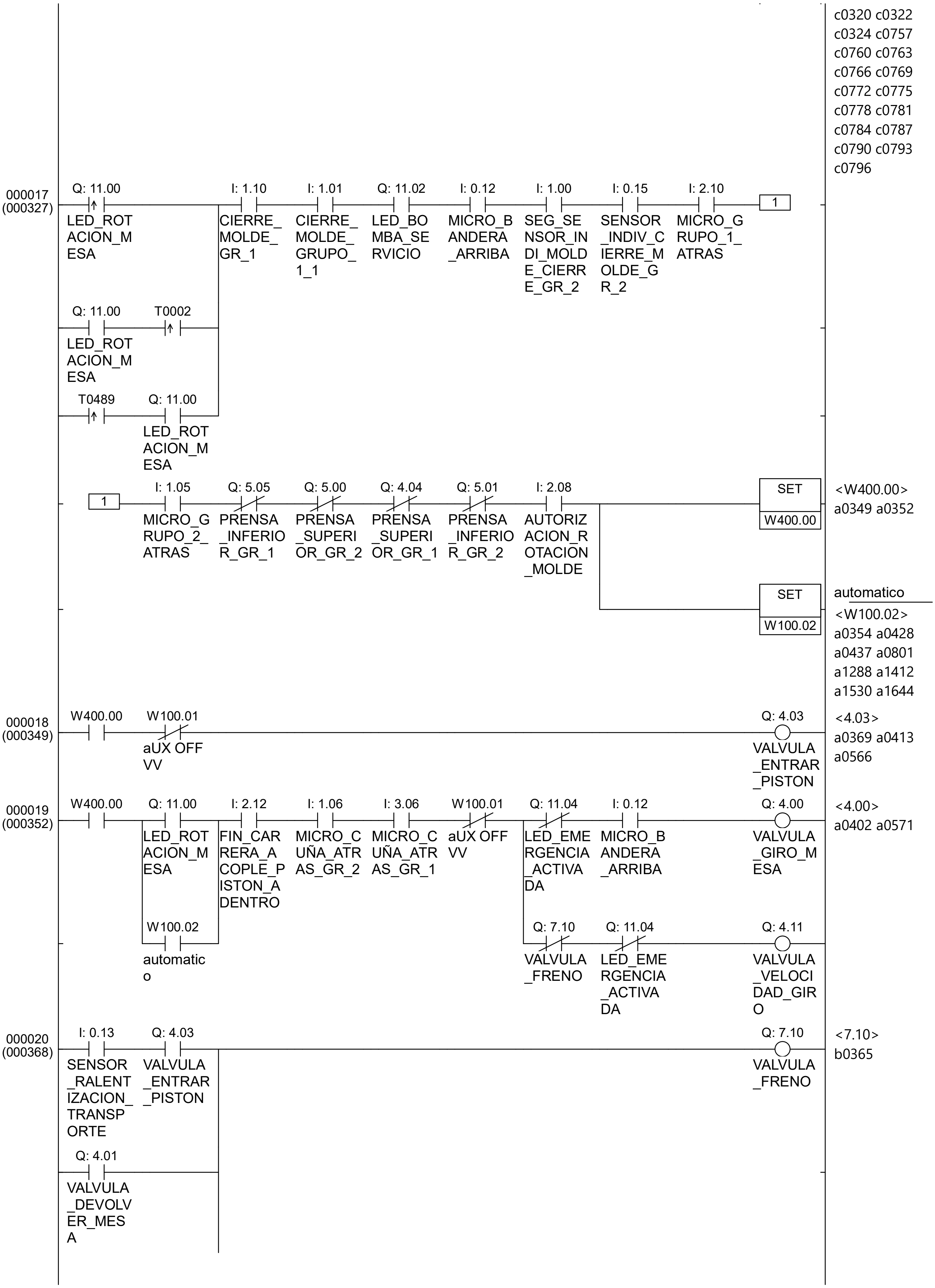
= (300)
H0
&13
[OP1]
[OP2]

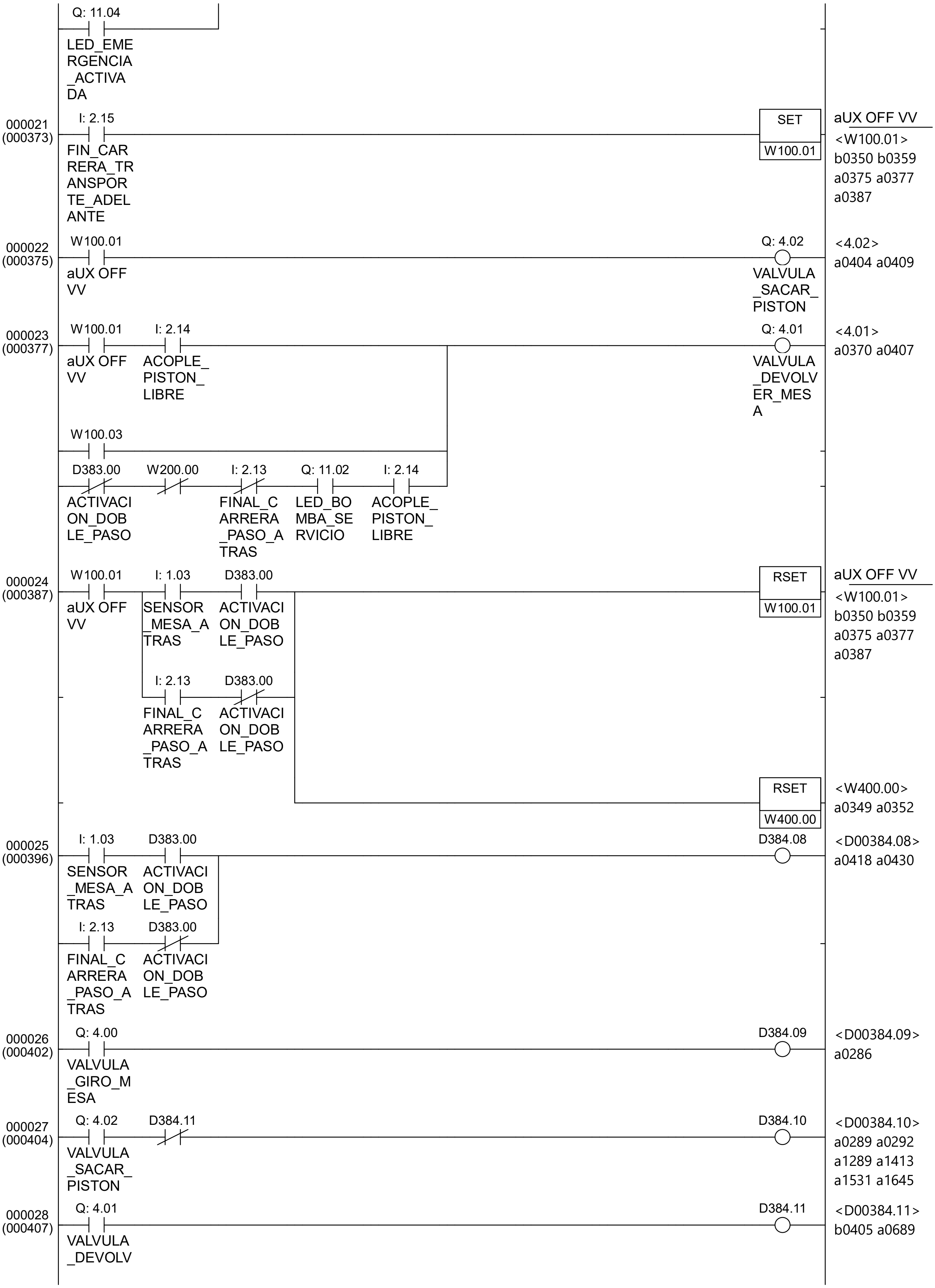
MOV (021)
&8
H1
[OP1]
[OP2]
<cH001>
c0300 c0302
c0304 c0306
c0308 c0310
c0312 c0314
c0316 c0318
c0320 c0322
c0326 c0757
c0760 c0763
c0766 c0769
c0772 c0775
c0778 c0781
c0784 c0787
c0790 c0793
c0796

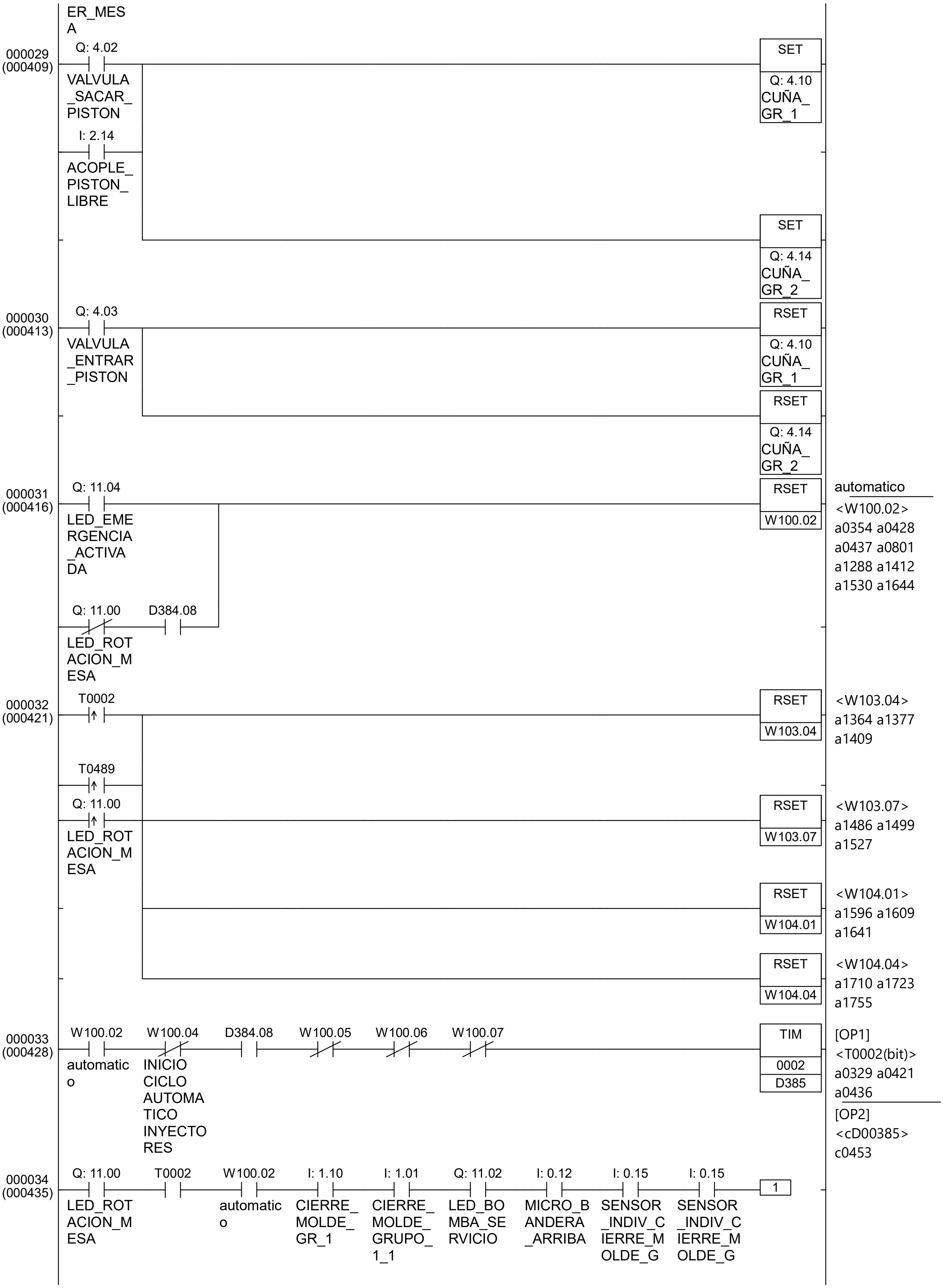
000016
(000325)

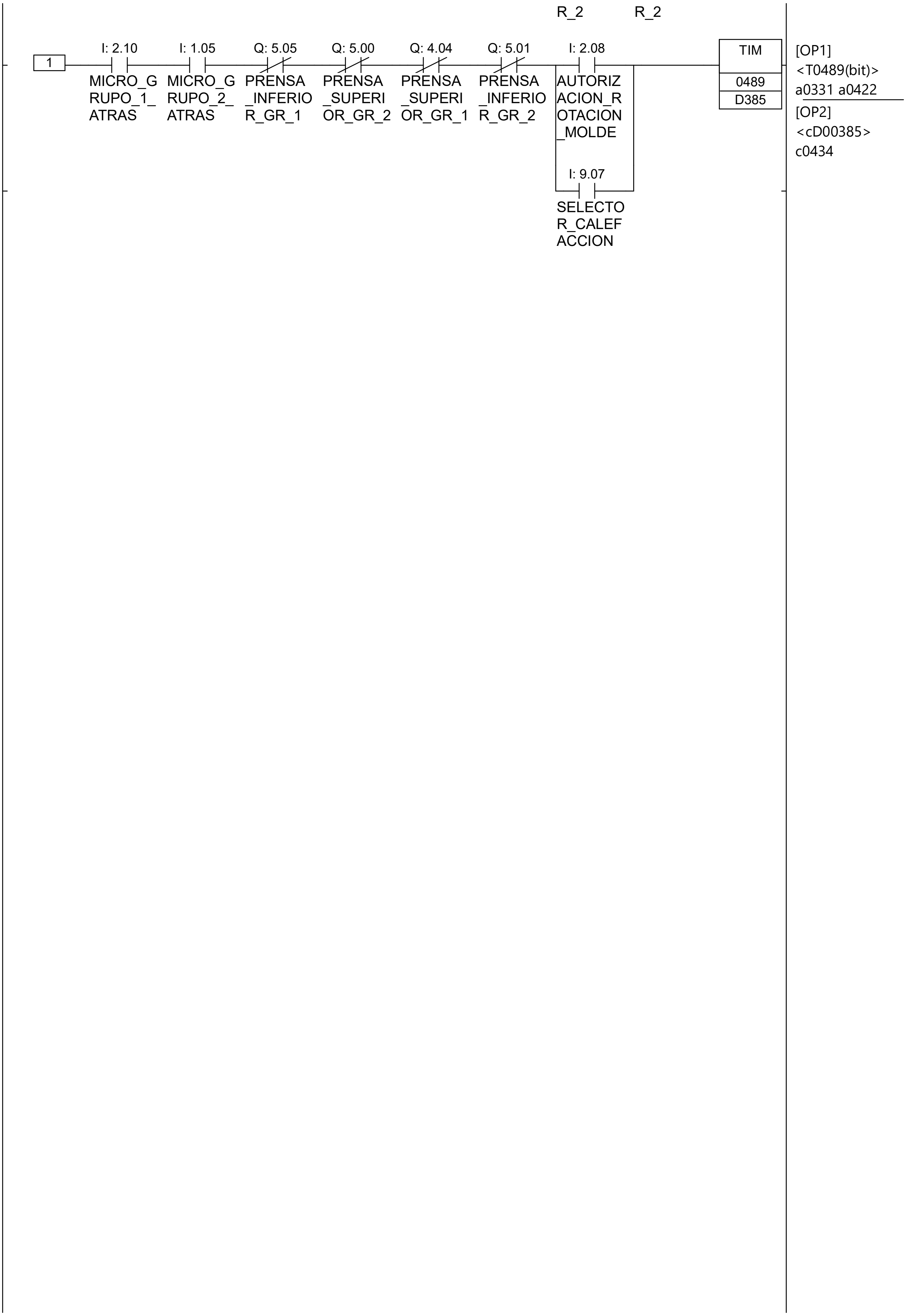
= (300)
H0
&14
[OP1]
[OP2]

MOV (021)
&9
H1
[OP1]
[OP2]
<cH001>
c0300 c0302
c0304 c0306
c0308 c0310
c0312 c0314
c0316 c0318


c0320 c0322 c0324 c0757 c0760 c0763 c0766 c0769 c0772 c0775 c0778 c0781 c0784 c0787 c0790 c0793 c0796
000017 (000327)
Q: 11.00 LED_ROTACION_MESA
I: 1.10 CIERRE_MOLDE_GR_1
I: 1.01 CIERRE_MOLDE_GRUPO_1_1
Q: 11.02 LED_BOMBA_SERVICIO
I: 0.12 MICRO_BANDERA_ARRIBA
I: 1.00 SEG_SENSOR_INDI_MOLDE_CIERRE_GR_2
I: 0.15 SENSOR_INDIV_CIERRE_MOLDE_GR_2
I: 2.10 MICRO_GRUPO_1_ATRAS
1
Q: 11.00 LED_ROTACION_MESA
T0002
T0489
Q: 11.00 LED_ROTACION_MESA
1
I: 1.05 MICRO_GRUPO_2_ATRAS
Q: 5.05 PRENSA_INFERIOR_GR_1
Q: 5.00 PRENSA_SUPERIOR_GR_2
Q: 4.04 PRENSA_SUPERIOR_GR_1
Q: 5.01 PRENSA_INFERIOR_GR_2
I: 2.08 AUTORIZACION_ROTACION_MOLDE
SET W400.00
<W400.00> a0349 a0352
SET W100.02
automatico
<W100.02> a0354 a0428 a0437 a0801 a1288 a1412 a1530 a1644
000018 (000349)
W400.00
W100.01 aUX OFF VV
Q: 4.03 VALVULA_ENTRAR_PISTON
<4.03> a0369 a0413 a0566
000019 (000352)
W400.00
Q: 11.00 LED_ROTACION_MESA
I: 2.12 FIN_CARRERA_ACOPLE_PISTON_ADENTRO
I: 1.06 MICRO_CUÑA_ATRAS_GR_2
I: 3.06 MICRO_CUÑA_ATRAS_GR_1
W100.01 aUX OFF VV
Q: 11.04 LED_EMERGENCIA_ACTIVADA
I: 0.12 MICRO_BANDERA_ARRIBA
Q: 4.00 VALVULA_GIRO_MESA
<4.00> a0402 a0571
W100.02 automatico
Q: 7.10 VALVULA_FRENO
Q: 11.04 LED_EMERGENCIA_ACTIVADA
Q: 4.11 VALVULA_VELOCIDAD_GIRO
000020 (000368)
I: 0.13 SENSOR_RALENTIZACION_TRANSPORTE
Q: 4.03 VALVULA_ENTRAR_PISTON
Q: 7.10 VALVULA_FRENO
<7.10> b0365
Q: 4.01 VALVULA_DEVOLVER_MESA

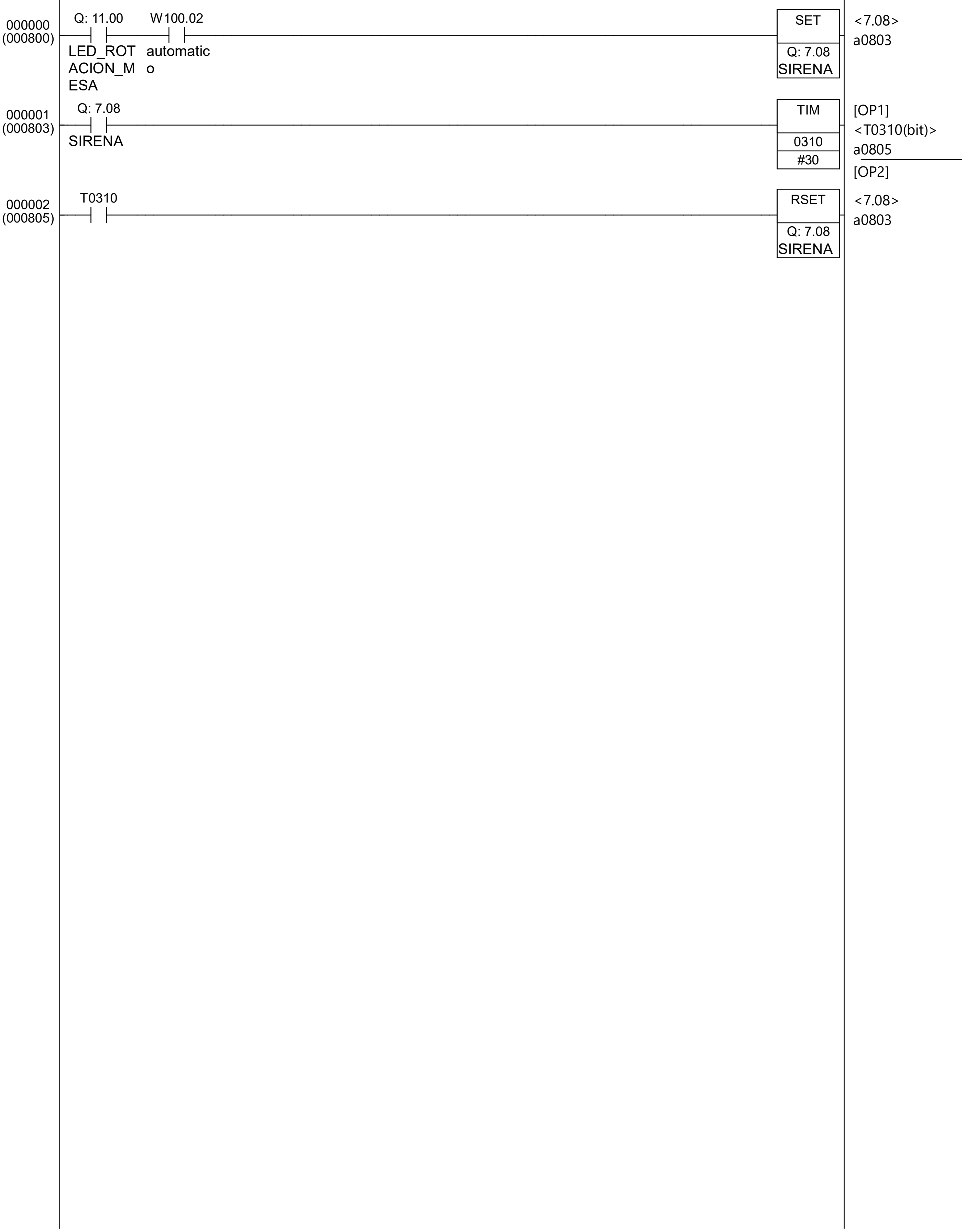

Q: 11.04
LED_EMERGENCIA_ACTIVADA
000021 (000373)
I: 2.15
FIN_CARRERA_TRANSPORTE_ADELANTE
SET
W100.01
aUX OFF VV
<W100.01>
b0350 b0359 a0375 a0377 a0387
000022 (000375)
W100.01
aUX OFF VV
Q: 4.02
VALVULA_SACAR_PISTON
<4.02>
a0404 a0409
000023 (000377)
W100.01
aUX OFF VV
I: 2.14
ACOPLE_PISTON_LIBRE
Q: 4.01
VALVULA_DEVOLVER_MESA
<4.01>
a0370 a0407
W100.03
D383.00
ACTIVACION_DOBLE_PASO
W200.00
I: 2.13
FINAL_CARRERA_PASO_ATRAS
Q: 11.02
LED_BOMBA_SERVICIO
I: 2.14
ACOPLE_PISTON_LIBRE
000024 (000387)
W100.01
aUX OFF VV
I: 1.03
SENSOR_MESA_ATRAS
D383.00
ACTIVACION_DOBLE_PASO
RSET
W100.01
aUX OFF VV
<W100.01>
b0350 b0359 a0375 a0377 a0387
I: 2.13
FINAL_CARRERA_PASO_ATRAS
D383.00
ACTIVACION_DOBLE_PASO
RSET
W400.00
<W400.00>
a0349 a0352
000025 (000396)
I: 1.03
SENSOR_MESA_ATRAS
D383.00
ACTIVACION_DOBLE_PASO
D384.08
<D00384.08>
a0418 a0430
I: 2.13
FINAL_CARRERA_PASO_ATRAS
D383.00
ACTIVACION_DOBLE_PASO
000026 (000402)
Q: 4.00
VALVULA_GIRO_MESA
D384.09
<D00384.09>
a0286
000027 (000404)
Q: 4.02
VALVULA_SACAR_PISTON
D384.11
D384.10
<D00384.10>
a0289 a0292 a1289 a1413 a1531 a1645
000028 (000407)
Q: 4.01
VALVULA_DEVOLV
D384.11
<D00384.11>
b0405 a0689


ER_MESA
000029
(000409)
Q: 4.02
VALVULA_SACAR_PISTON
I: 2.14
ACOPLE_PISTON_LIBRE
SET
Q: 4.10
CUÑA_GR_1
SET
Q: 4.14
CUÑA_GR_2
000030
(000413)
Q: 4.03
VALVULA_ENTRAR_PISTON
RSET
Q: 4.10
CUÑA_GR_1
RSET
Q: 4.14
CUÑA_GR_2
000031
(000416)
Q: 11.04
LED_EMERGENCIA_ACTIVADA
Q: 11.00
LED_ROTACION_MESA
D384.08
RSET
W100.02
automatico
<W100.02>
a0354 a0428
a0437 a0801
a1288 a1412
a1530 a1644
000032
(000421)
T0002
T0489
Q: 11.00
LED_ROTACION_MESA
RSET
W103.04
<W103.04>
a1364 a1377
a1409
RSET
W103.07
<W103.07>
a1486 a1499
a1527
RSET
W104.01
<W104.01>
a1596 a1609
a1641
RSET
W104.04
<W104.04>
a1710 a1723
a1755
000033
(000428)
W100.02
automatico
W100.04
INICIO CICLO AUTOMATICO INYECTORES
D384.08
W100.05
W100.06
W100.07
TIM
0002
D385
[OP1]
<T0002(bit)>
a0329 a0421
a0436
[OP2]
<cD00385>
c0453
000034
(000435)
Q: 11.00
LED_ROTACION_MESA
T0002
W100.02
automatico
I: 1.10
CIERRE_MOLDE_GR_1
I: 1.01
CIERRE_MOLDE_GRUPO_1_1
Q: 11.02
LED_BOMBA_SERVICIO
I: 0.12
MICRO_BANDERA_ARRIBA
I: 0.15
SENSOR_INDIV_CIERRE_MOLDE_G
I: 0.15
SENSOR_INDIV_CIERRE_MOLDE_G
1


R_2
R_2
1
I: 2.10
MICRO_GRUPO_1_ATRAS
I: 1.05
MICRO_GRUPO_2_ATRAS
Q: 5.05
PRENSA_INFERIOR_GR_1
Q: 5.00
PRENSA_SUPERIOR_GR_2
Q: 4.04
PRENSA_SUPERIOR_GR_1
Q: 5.01
PRENSA_INFERIOR_GR_2
I: 2.08
AUTORIZACION_ROTACION_MOLDE
I: 9.07
SELECTOR_CALEFACCION
TIM
0489
D385
[OP1]
<T0489(bit)>
a0331 a0422
[OP2]
<cD00385>
c0434

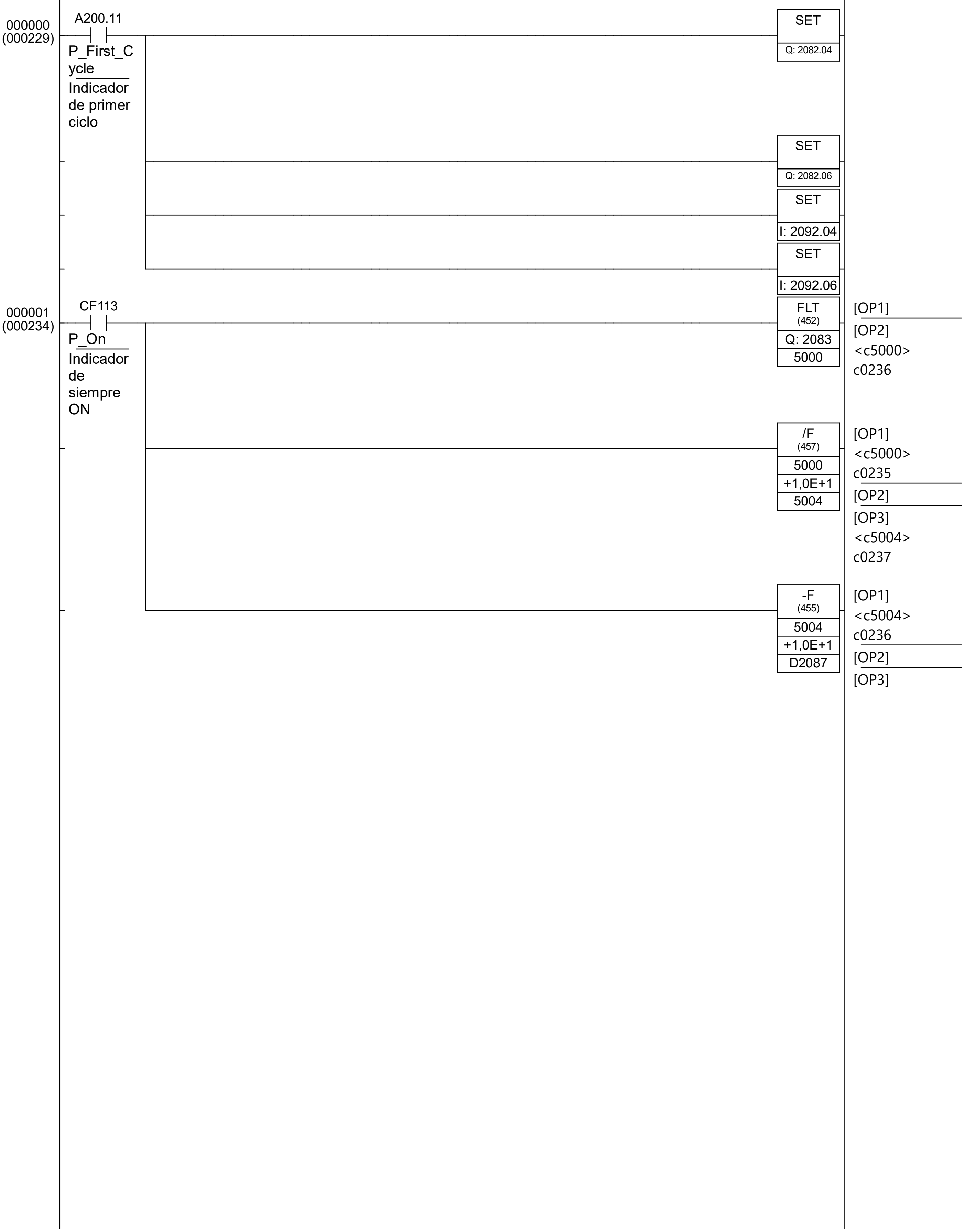
[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : SIRENA]



[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : TEMPERATURA_ACEITE]



000000 (000013)

[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : TEMPERATURA_INYECTOR_1]

inicio inyector

A200.11
P_First_Cycle
Indicador de primer ciclo

D31.00
ACTIVAR_INY_1

SET Q: 2002.04

SET Q: 2002.06

SET I: 2012.04

SET I: 2012.06

RSET D31.00 ACTIVAR_INY_1

<D00031.00>
a0001 b0014
a0020 a0045
a0051 a0057

000001 (000020)

prender inyector

D31.00
ACTIVAR_INY_1

RSET Q: 2002.04

RSET Q: 2002.06

RSET I: 2012.04

RSET I: 2012.06

000002 (000025)

set point ZONA 1

CF113
P_On
Indicador de siempre ON

/F (457)
D3300
+1,0E+0
3200

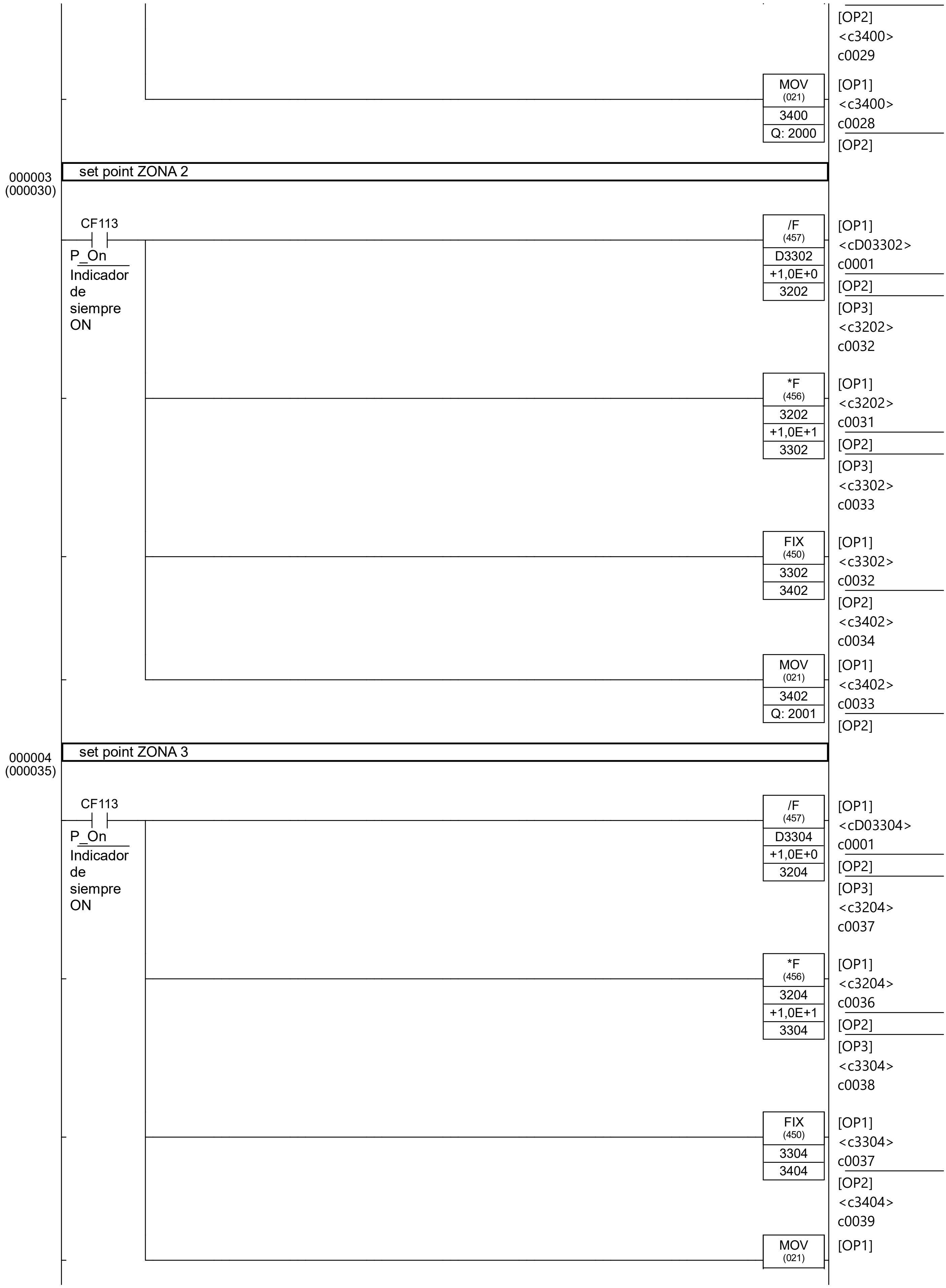
[OP1]
<cD03300>
c0001
[OP2]
[OP3]
<c3200>
c0027

*F (456)
3200
+1,0E+1
3300

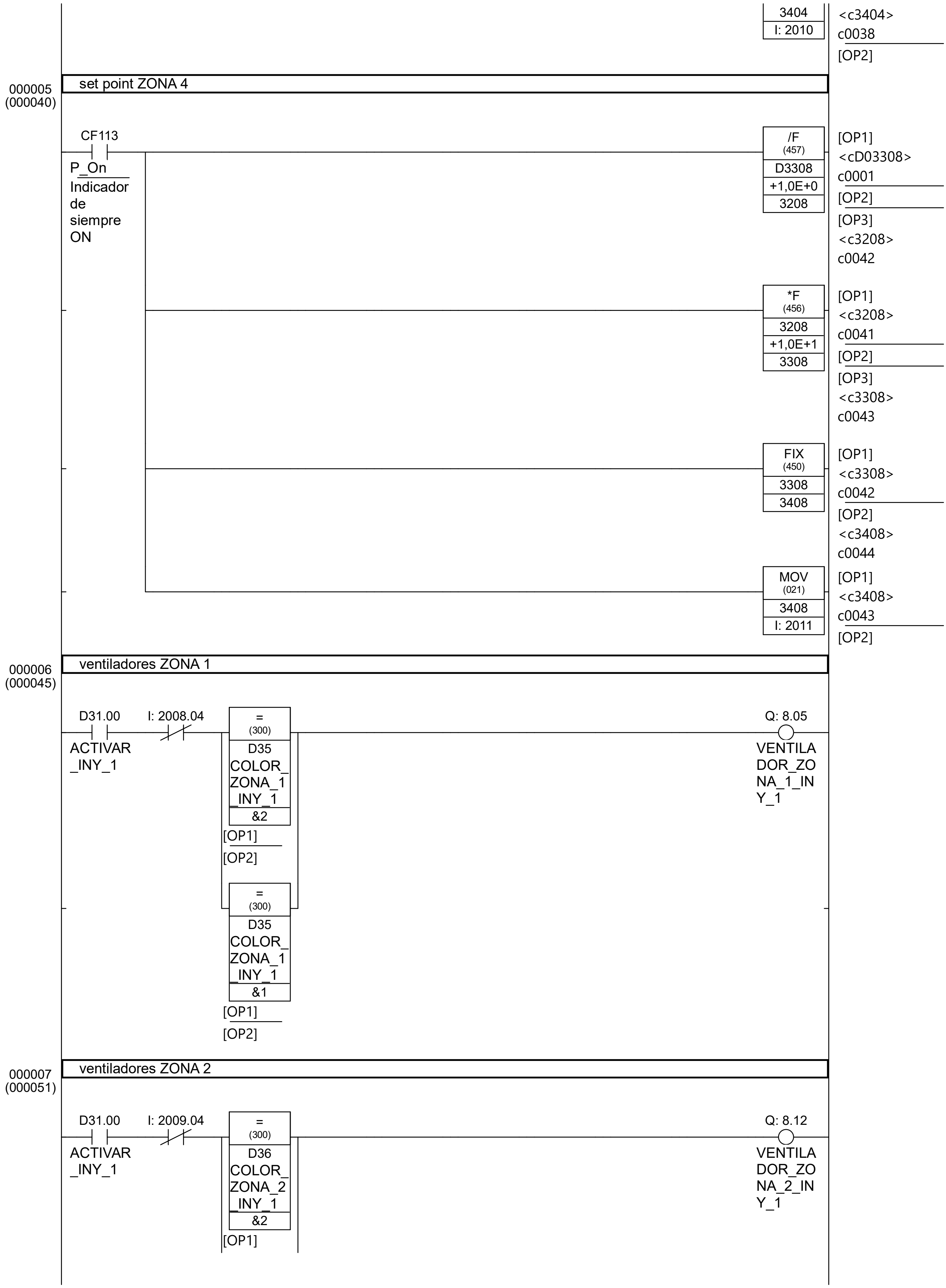
[OP1]
<c3200>
c0026
[OP2]
[OP3]
<c3300>
c0028

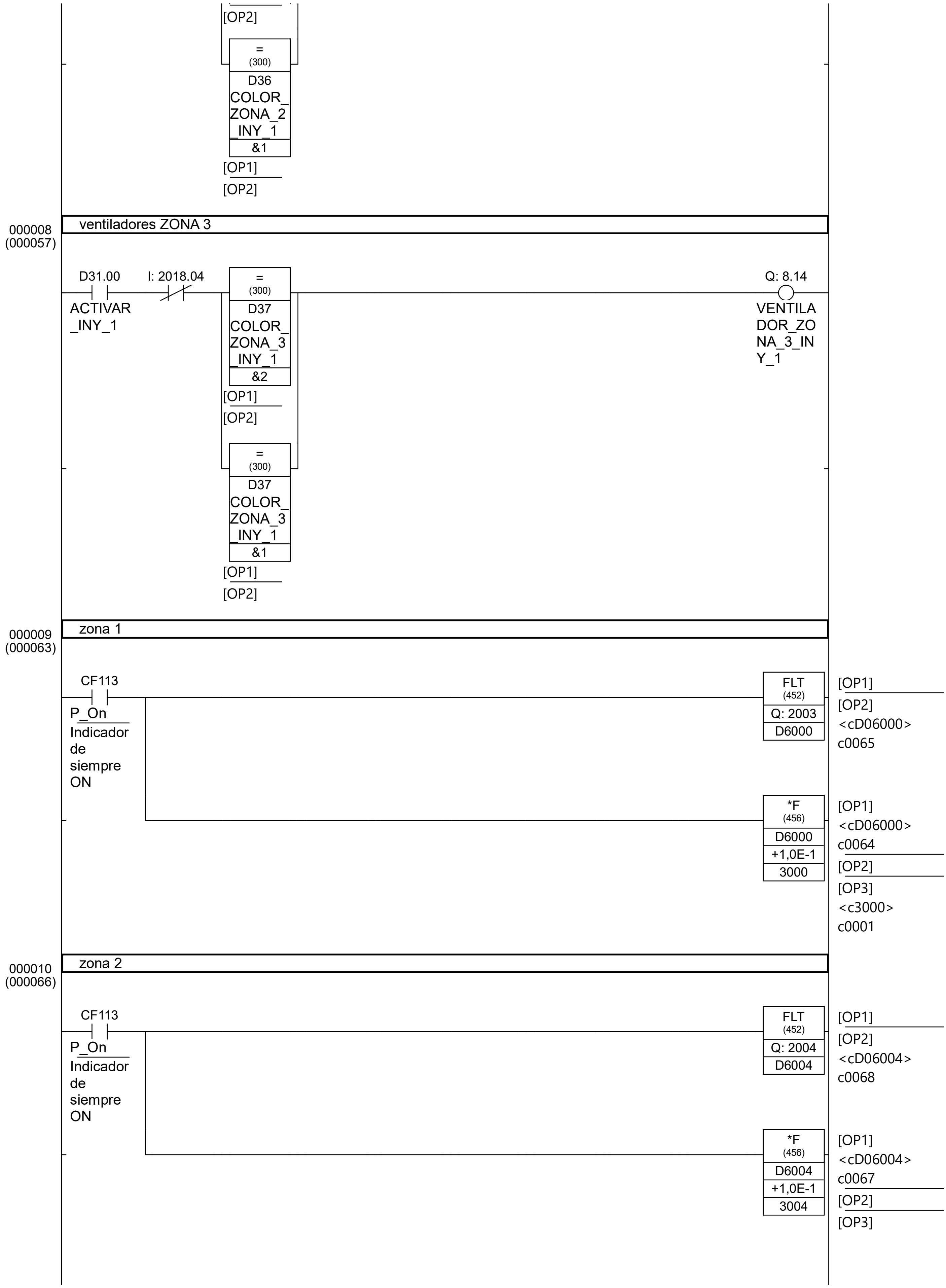
FIX (450)
3300
3400

[OP1]
<c3300>
c0027



[OP2]
<c3400>
c0029
MOV
(021)
3400
Q: 2000
[OP1]
<c3400>
c0028
[OP2]
000003
(000030)
set point ZONA 2
CF113
P_On
Indicador
de
siempre
ON
/F
(457)
D3302
+1,0E+0
3202
[OP1]
<cD03302>
c0001
[OP2]
[OP3]
<c3202>
c0032
*F
(456)
3202
+1,0E+1
3302
[OP1]
<c3202>
c0031
[OP2]
[OP3]
<c3302>
c0033
FIX
(450)
3302
3402
[OP1]
<c3302>
c0032
[OP2]
<c3402>
c0034
MOV
(021)
3402
Q: 2001
[OP1]
<c3402>
c0033
[OP2]
000004
(000035)
set point ZONA 3
CF113
P_On
Indicador
de
siempre
ON
/F
(457)
D3304
+1,0E+0
3204
[OP1]
<cD03304>
c0001
[OP2]
[OP3]
<c3204>
c0037
*F
(456)
3204
+1,0E+1
3304
[OP1]
<c3204>
c0036
[OP2]
[OP3]
<c3304>
c0038
FIX
(450)
3304
3404
[OP1]
<c3304>
c0037
[OP2]
<c3404>
c0039
MOV
(021)
[OP1]


3404
I: 2010
<c3404>
c0038
[OP2]
000005
(000040)
set point ZONA 4
CF113
P_On
Indicador de siempre ON
/F
(457)
D3308
+1,0E+0
3208
[OP1]
<cD03308>
c0001
[OP2]
[OP3]
<c3208>
c0042
*F
(456)
3208
+1,0E+1
3308
[OP1]
<c3208>
c0041
[OP2]
[OP3]
<c3308>
c0043
FIX
(450)
3308
3408
[OP1]
<c3308>
c0042
[OP2]
<c3408>
c0044
MOV
(021)
3408
I: 2011
[OP1]
<c3408>
c0043
[OP2]
000006
(000045)
ventiladores ZONA 1
D31.00
ACTIVAR_INY_1
I: 2008.04
=
(300)
D35
COLOR_ZONA_1_INY_1
&2
[OP1]
[OP2]
=
(300)
D35
COLOR_ZONA_1_INY_1
&1
[OP1]
[OP2]
Q: 8.05
VENTILADOR_ZONA_1_INY_1
000007
(000051)
ventiladores ZONA 2
D31.00
ACTIVAR_INY_1
I: 2009.04
=
(300)
D36
COLOR_ZONA_2_INY_1
&2
[OP1]
Q: 8.12
VENTILADOR_ZONA_2_INY_1


[OP2]
=
(300)
D36
COLOR_
ZONA_2
_INY_1
&1
[OP1]
[OP2]
000008
(000057)
ventiladores ZONA 3
D31.00
ACTIVAR
_INY_1
I: 2018.04
=
(300)
D37
COLOR_
ZONA_3
_INY_1
&2
[OP1]
[OP2]
=
(300)
D37
COLOR_
ZONA_3
_INY_1
&1
[OP1]
[OP2]
Q: 8.14
VENTILA
DOR_ZO
NA_3_IN
Y_1
000009
(000063)
zona 1
CF113
P_On
Indicador
de
siempre
ON
FLT
(452)
Q: 2003
D6000
[OP1]
[OP2]
<cD06000>
c0065
*F
(456)
D6000
+1,0E-1
3000
[OP1]
<cD06000>
c0064
[OP2]
[OP3]
<c3000>
c0001
000010
(000066)
zona 2
CF113
P_On
Indicador
de
siempre
ON
FLT
(452)
Q: 2004
D6004
[OP1]
[OP2]
<cD06004>
c0068
*F
(456)
D6004
+1,0E-1
3004
[OP1]
<cD06004>
c0067
[OP2]
[OP3]

<c3004>
c0001

000011
(000069)
zona 3

CF113
P_On
Indicador
de
siempre
ON

FLT
(452)
I: 2013
D6013

[OP1]
[OP2]
<cD06013>
c0071

*F
(456)
D6013
+1,0E-1
3008

[OP1]
<cD06013>
c0070
[OP2]
[OP3]
<c3008>
c0001

000012
(000072)
zona 4

CF113
P_On
Indicador
de
siempre
ON

FLT
(452)
I: 2014
D6016

[OP1]
[OP2]
<cD06016>
c0074

*F
(456)
D6016
+1,0E-1
3012

[OP1]
<cD06016>
c0073
[OP2]
[OP3]
<c3012>
c0001

000000 (000076) [Nombre de programa : OTTOGALLI_5]

[Nombre de sección : TEMPERATURA_INYECTOR_2]

INICIO INYECTOR

A200.11
P_First_Cycle
Indicador de primer ciclo

D31.01
ACTIVAR_INY_2

SET Q: 2022.04

SET Q: 2022.06

SET I: 2032.04

SET I: 2032.06

RSET D31.01 ACTIVAR_INY_2 <D00031.01> a0004 b0077 a0083

000001 (000083) PRENDER INYECTOR

D31.01
ACTIVAR_INY_2

RSET Q: 2022.04

RSET Q: 2022.06

RSET I: 2032.04

RSET I: 2032.06

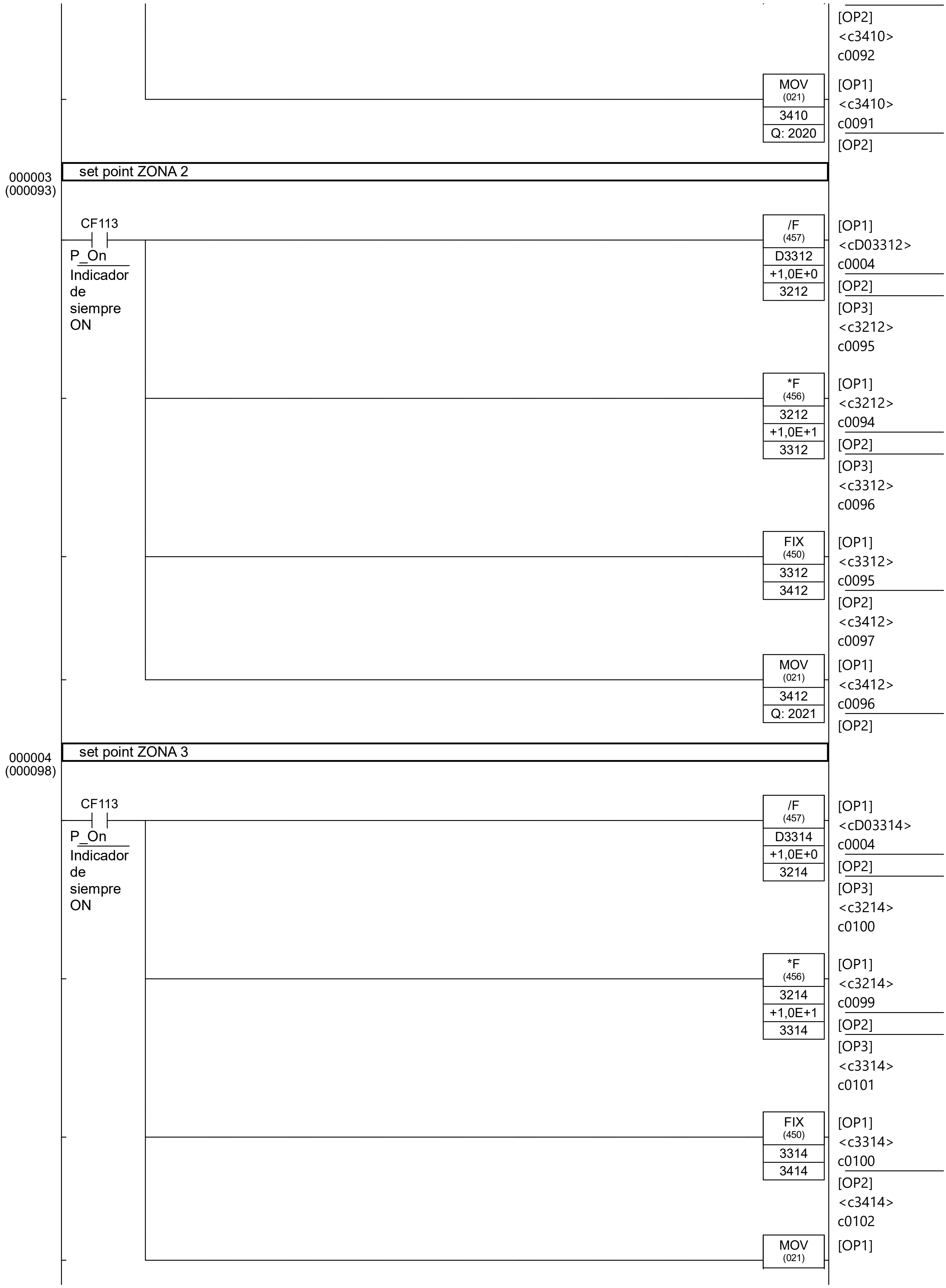
000002 (000088) set point ZONA 1

CF113
P_On
Indicador de siempre ON

/F (457) D3310 +1,0E+0 3210 [OP1] <cD03310> c0004 [OP2] [OP3] <c3210> c0090

*F (456) 3210 +1,0E+1 3310 [OP1] <c3210> c0089 [OP2] [OP3] <c3310> c0091

FIX (450) 3310 3410 [OP1] <c3310> c0090


[OP2]
<c3410>
c0092
MOV
(021)
3410
Q: 2020
[OP1]
<c3410>
c0091
[OP2]
000003
(000093)
set point ZONA 2
CF113
P_On
Indicador
de
siempre
ON
/F
(457)
D3312
+1,0E+0
3212
[OP1]
<cD03312>
c0004
[OP2]
[OP3]
<c3212>
c0095
*F
(456)
3212
+1,0E+1
3312
[OP1]
<c3212>
c0094
[OP2]
[OP3]
<c3312>
c0096
FIX
(450)
3312
3412
[OP1]
<c3312>
c0095
[OP2]
<c3412>
c0097
MOV
(021)
3412
Q: 2021
[OP1]
<c3412>
c0096
[OP2]
000004
(000098)
set point ZONA 3
CF113
P_On
Indicador
de
siempre
ON
/F
(457)
D3314
+1,0E+0
3214
[OP1]
<cD03314>
c0004
[OP2]
[OP3]
<c3214>
c0100
*F
(456)
3214
+1,0E+1
3314
[OP1]
<c3214>
c0099
[OP2]
[OP3]
<c3314>
c0101
FIX
(450)
3314
3414
[OP1]
<c3314>
c0100
[OP2]
<c3414>
c0102
MOV
(021)
[OP1]

3414
I: 2030
<c3414>
c0101
[OP2]

000005
(000103)
set point ZONA 4

CF113
P_On
Indicador de siempre ON

/F (457)
D3316
+1,0E+0
3216
[OP1]
<cD03316>
c0004
[OP2]
[OP3]
<c3216>
c0105

*F (456)
3216
+1,0E+1
3316
[OP1]
<c3216>
c0104
[OP2]
[OP3]
<c3316>
c0106

FIX (450)
3316
3416
[OP1]
<c3316>
c0105
[OP2]
<c3416>
c0107

MOV (021)
3416
I: 2031
[OP1]
<c3416>
c0106
[OP2]

000006
(000108)
ZONA 1

CF113
P_On
Indicador de siempre ON

FLT (452)
Q: 2023
D6023
[OP1]
[OP2]
<cD06023>
c0110

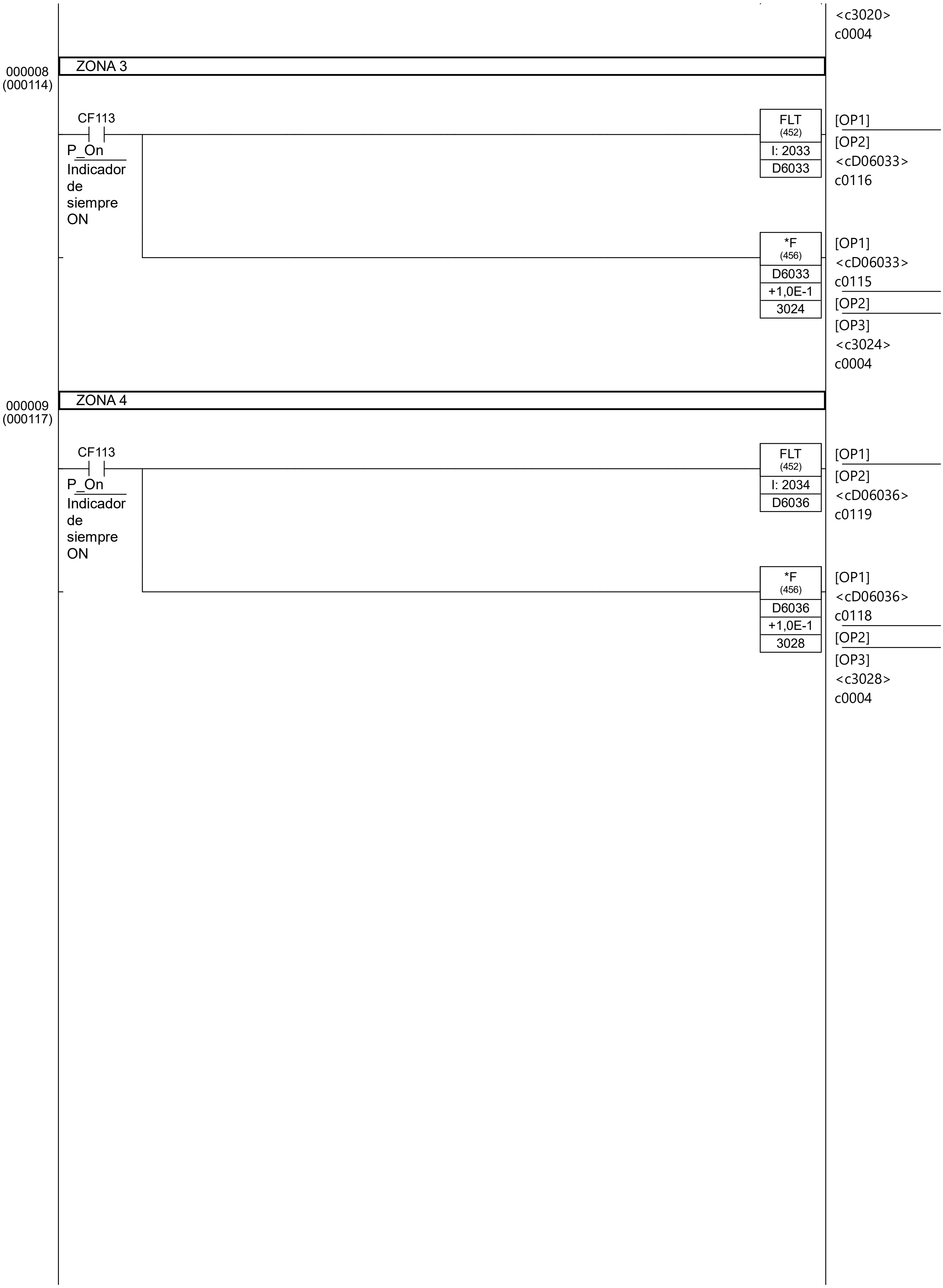
*F (456)
D6023
+1,0E-1
3016
[OP1]
<cD06023>
c0109
[OP2]
[OP3]
<c3016>
c0004

000007
(000111)
ZONA 2

CF113
P_On
Indicador de siempre ON

FLT (452)
Q: 2024
D6026
[OP1]
[OP2]
<cD06026>
c0113

*F (456)
D6026
+1,0E-1
3020
[OP1]
<cD06026>
c0112
[OP2]
[OP3]



<c3020>
c0004
000008
(000114)
ZONA 3
CF113
P_On
Indicador
de
siempre
ON
FLT
(452)
I: 2033
D6033
[OP1]
[OP2]
<cD06033>
c0116
*F
(456)
D6033
+1,0E-1
3024
[OP1]
<cD06033>
c0115
[OP2]
[OP3]
<c3024>
c0004
000009
(000117)
ZONA 4
CF113
P_On
Indicador
de
siempre
ON
FLT
(452)
I: 2034
D6036
[OP1]
[OP2]
<cD06036>
c0119
*F
(456)
D6036
+1,0E-1
3028
[OP1]
<cD06036>
c0118
[OP2]
[OP3]
<c3028>
c0004

[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : TRANSFERENCIA_DATOS_INY_1_2]

000000
(000698)

= (300) H0 &1 [OP1] [OP2]

= (300) D76 &1 [OP1] [OP2]

XFER (070) &20 D3000 T_A_C_1 D400 TIEMPO_APOYO_CAÑA_INY_1

[OP1]
[OP2]
<cD03000>
c0759
[OP3]
<cD00400>
c0703 c0706
c0709 c0712
c0715 c0718
c0721 c0724
c0727 c0730
c0733 c0736
c0739 c1405

000001
(000701)

= (300) H0 &2 [OP1] [OP2]

= (300) D78 &1 [OP1] [OP2]

XFER (070) &20 D3020 T_A_C_2 D400 TIEMPO_APOYO_CAÑA_INY_1

[OP1]
[OP2]
<cD03020>
c0762
[OP3]
<cD00400>
c0700 c0706
c0709 c0712
c0715 c0718
c0721 c0724
c0727 c0730
c0733 c0736
c0739 c1405

000002
(000704)

= (300) H0 &3 [OP1] [OP2]

= (300) D80 &1 [OP1] [OP2]

XFER (070) &20 D3040 T_A_C_3 D400 TIEMPO_APOYO_CAÑA_INY_1

[OP1]
[OP2]
<cD03040>
c0765
[OP3]
<cD00400>
c0700 c0703
c0709 c0712
c0715 c0718
c0721 c0724
c0727 c0730
c0733 c0736
c0739 c1405

000003
(000707)

= (300) H0 &4 [OP1] [OP2]

= (300) D82 &1 [OP1] [OP2]

XFER (070) &20 D3060 T_A_C_4 D400 TIEMPO_APOYO_CAÑA_INY_1

[OP1]
[OP2]
<cD03060>
c0768
[OP3]
<cD00400>
c0700 c0703
c0706 c0712
c0715 c0718
c0721 c0724
c0727 c0730
c0733 c0736
c0739 c1405

000004
(000710)

= (300) H0 &5 [OP1] [OP2]

= (300) D84 &1 [OP1] [OP2]

XFER (070) &20 D3080 T_A_C_5 D400

[OP1]
[OP2]
<cD03080>
c0771
[OP3]

TIEMPO
_APOYO
CAÑA
INY_1

<cD00400>
c0700 c0703
c0706 c0709
c0715 c0718
c0721 c0724
c0727 c0730
c0733 c0736
c0739 c1405

000005
(000713)

= (300) H0 &6 [OP1] [OP2]

= (300) D86 &1 [OP1] [OP2]

XFER (070) &20 D3100 T_A_C_6 D400 TIEMPO_APOYO_CAÑA_INY_1

[OP1]
[OP2]
<cD03100>
c0774
[OP3]
<cD00400>
c0700 c0703
c0706 c0709
c0712 c0718
c0721 c0724
c0727 c0730
c0733 c0736
c0739 c1405

000006
(000716)

= (300) H0 &7 [OP1] [OP2]

= (300) D88 &1 [OP1] [OP2]

XFER (070) &20 D3120 T_A_C_7 D400 TIEMPO_APOYO_CAÑA_INY_1

[OP1]
[OP2]
<cD03120>
c0777
[OP3]
<cD00400>
c0700 c0703
c0706 c0709
c0712 c0715
c0721 c0724
c0727 c0730
c0733 c0736
c0739 c1405

000007
(000719)

= (300) H0 &8 [OP1] [OP2]

= (300) D90 &1 [OP1] [OP2]

XFER (070) &20 D3140 T_A_C_8 D400 TIEMPO_APOYO_CAÑA_INY_1

[OP1]
[OP2]
<cD03140>
c0780
[OP3]
<cD00400>
c0700 c0703
c0706 c0709
c0712 c0715
c0718 c0724
c0727 c0730
c0733 c0736
c0739 c1405

000008
(000722)

= (300) H0 &9 [OP1] [OP2]

= (300) D92 &1 [OP1] [OP2]

XFER (070) &20 D3160 T_A_C_9 D400 TIEMPO_APOYO_CAÑA_INY_1

[OP1]
[OP2]
<cD03160>
c0783
[OP3]
<cD00400>
c0700 c0703
c0706 c0709
c0712 c0715
c0718 c0721
c0727 c0730
c0733 c0736
c0739 c1405

000009
(000725)

= (300) H0

= (300) D94

XFER (070) &20

[OP1]
[OP2]

&10 [OP1] [OP2]
&1 [OP1] [OP2]

D3180 T_A_C_10
D400 TIEMPO_APOYO_CAÑA_INY_1

<cD03180>
c0786
[OP3]
<cD00400>
c0700 c0703
c0706 c0709
c0712 c0715
c0718 c0721
c0724 c0730
c0733 c0736
c0739 c1405

000010
(000728)

= (300) H0 &11 [OP1] [OP2]
= (300) D96 &1 [OP1] [OP2]

XFER (070) &20 D3200 T_A_C_11 D400 TIEMPO_APOYO_CAÑA_INY_1

[OP1]
[OP2]
<cD03200>
c0789
[OP3]
<cD00400>
c0700 c0703
c0706 c0709
c0712 c0715
c0718 c0721
c0724 c0727
c0733 c0736
c0739 c1405

000011
(000731)

= (300) H0 &12 [OP1] [OP2]
= (300) D98 &1 [OP1] [OP2]

XFER (070) &20 D3220 T_A_C_12 D400 TIEMPO_APOYO_CAÑA_INY_1

[OP1]
[OP2]
<cD03220>
c0792
[OP3]
<cD00400>
c0700 c0703
c0706 c0709
c0712 c0715
c0718 c0721
c0724 c0727
c0730 c0736
c0739 c1405

000012
(000734)

= (300) H0 &13 [OP1] [OP2]
= (300) D100 &1 [OP1] [OP2]

XFER (070) &20 D3240 T_A_C_13 D400 TIEMPO_APOYO_CAÑA_INY_1

[OP1]
[OP2]
<cD03240>
c0795
[OP3]
<cD00400>
c0700 c0703
c0706 c0709
c0712 c0715
c0718 c0721
c0724 c0727
c0730 c0733
c0739 c1405

000013
(000737)

= (300) H0 &14 [OP1] [OP2]
= (300) D102 &1 [OP1] [OP2]

XFER (070) &20 D3260 T_A_C_14 D400 TIEMPO_APOYO_CAÑA_INY_1

[OP1]
[OP2]
<cD03260>
c0798
[OP3]
<cD00400>
c0700 c0703
c0706 c0709
c0712 c0715
c0718 c0721
c0724 c0727
c0730 c0733

c0736 c1405

000000
(000239)

[Nombre de programa : OTTOGALLI_5]

[Nombre de sección : VALOR_VOLUMEN]

INICIALIZAR

A200.11
P_First_Cycle
Indicador de primer ciclo

MOV (021)	
#F	[OP1]
D21000	[OP2]

MOV (021)	
&85	[OP1]
D21001	[OP2]

MOV (021)	
#0	[OP1]
D21018	[OP2]