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Rev: V2 4

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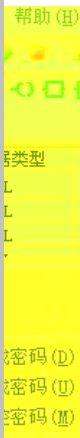
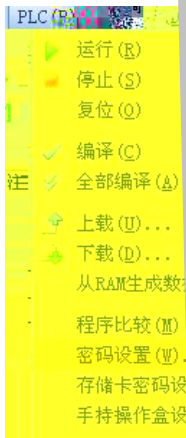


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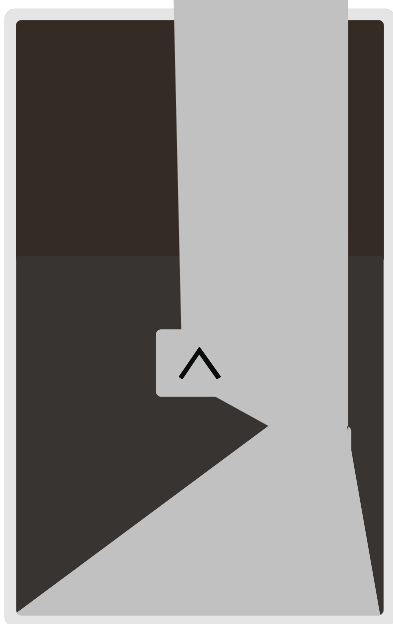
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M80			
MC80-1006BRA	10	6	
MC80-1006BTA	10	6	
MC80-1410BRA	14	10	
MC80-1410BTA	14	10	
MC80-1614BRA	16	14	
MC80-1614BTA	16	14	
MC80-2416BRA	24	16	
MC80-2416BTA	24	16	
MC80-3624BRA	36	24	
MC80-3624BTA	36	24	
MC100			
MC100-1006BRA	10	6	
MC100-1006BTA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

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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	

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MC100-DPS	Profi bus DP (MC100-DPS)
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MC200-CPM	CANopen
MC200-RS485	
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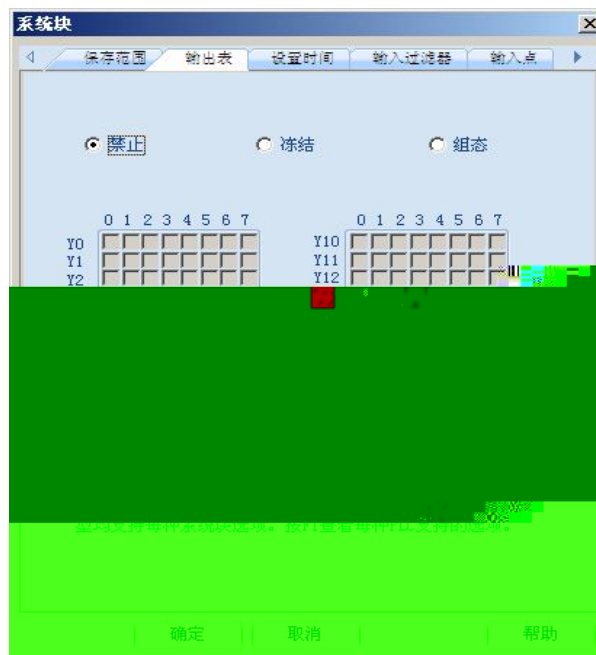
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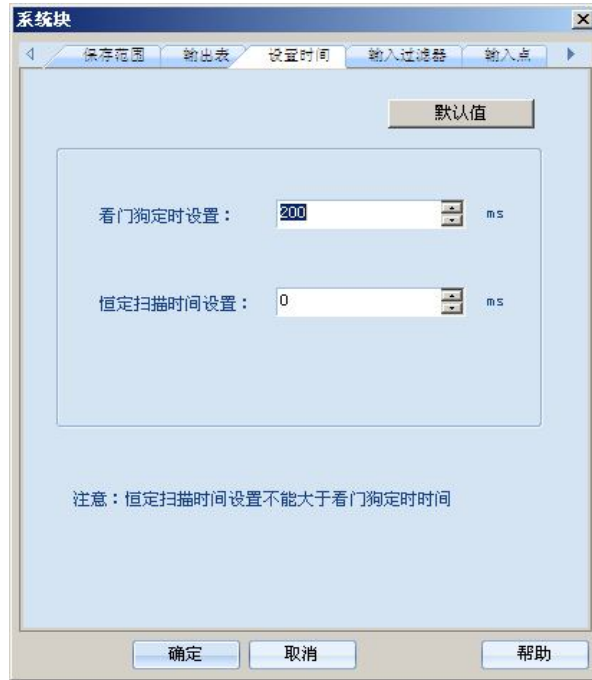
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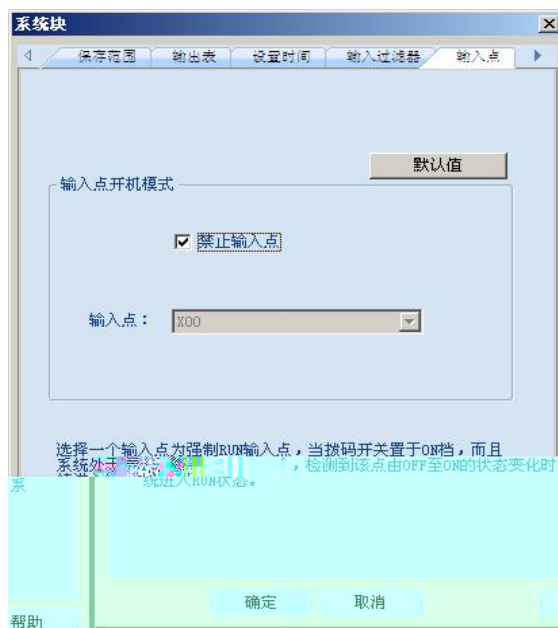
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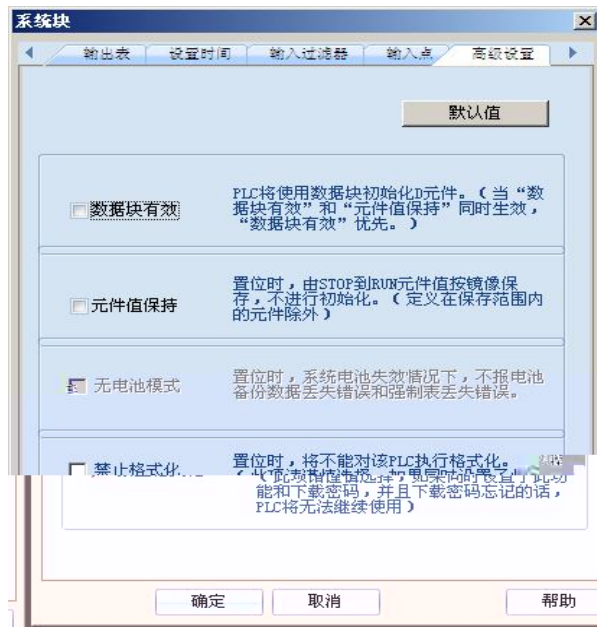
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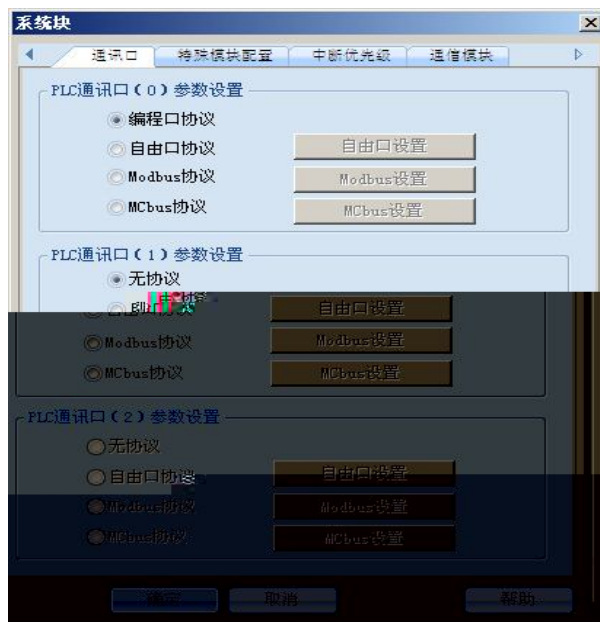


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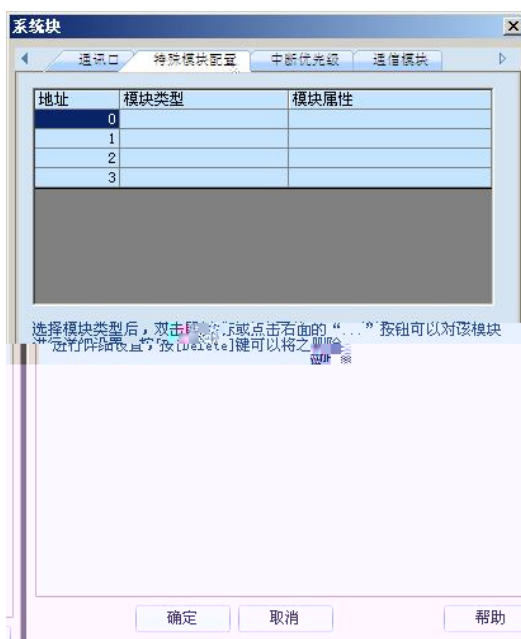
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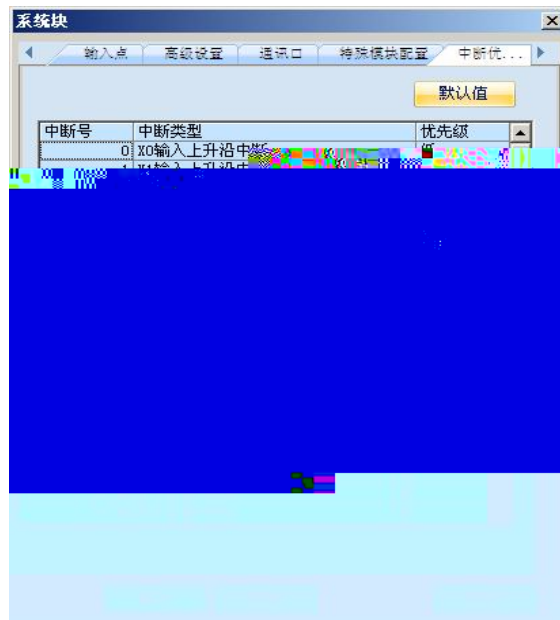
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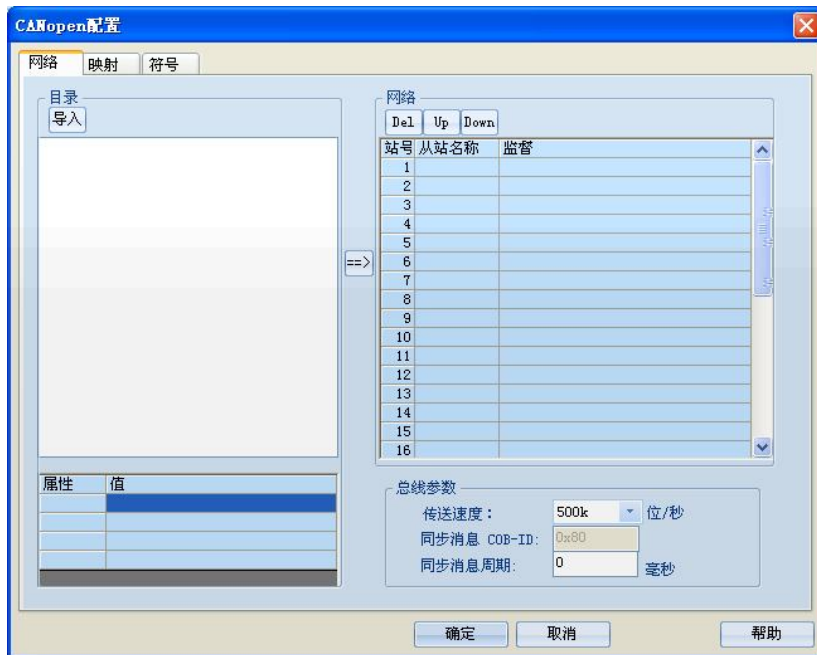
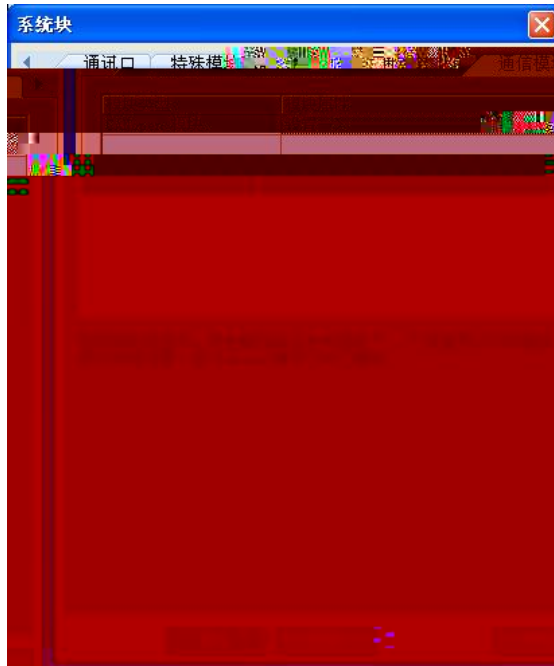


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2 反向点动	X3	反向点动
3 正向点动	X2	正向点动
4 原点回归	X1	原点回归
5 停止按钮	X0	停止按钮

信息输出

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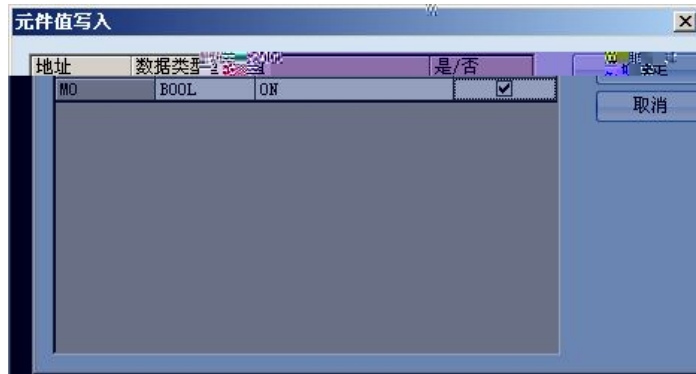
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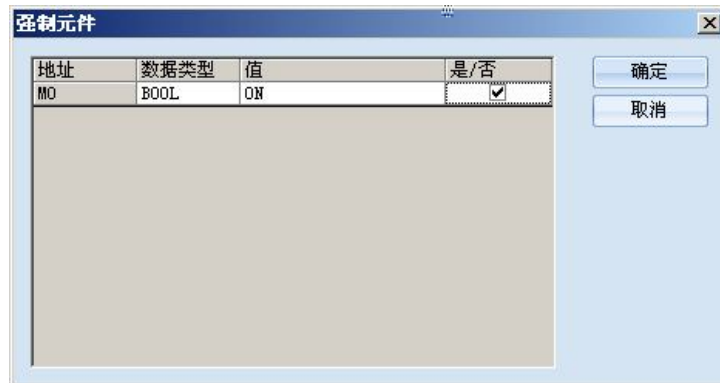
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
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变量地址	变量名称	变量类型	数据类型	注释
		TEMP	BOOL	
		TEMP	BOOL	
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		TEMP	BOOL	

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

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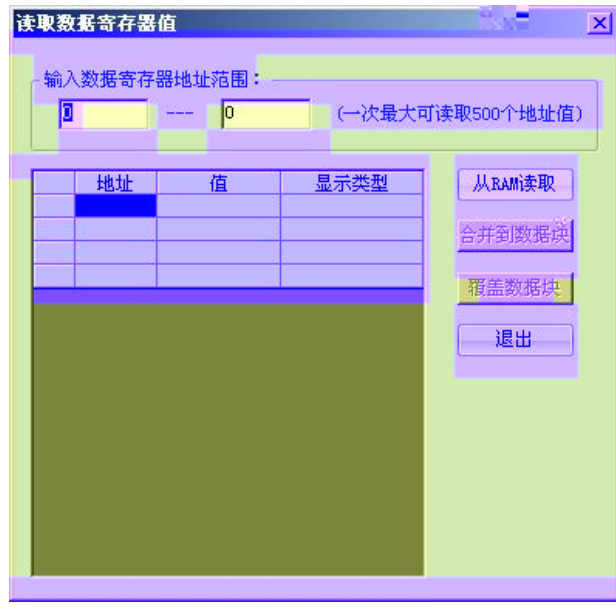
元件名称	数据类型	显示格式	当前值	新数值
X1	BOOL	二进制	OFF	
Y1	BOOL	二进制	OFF	
D1	十进制	十进制	0	
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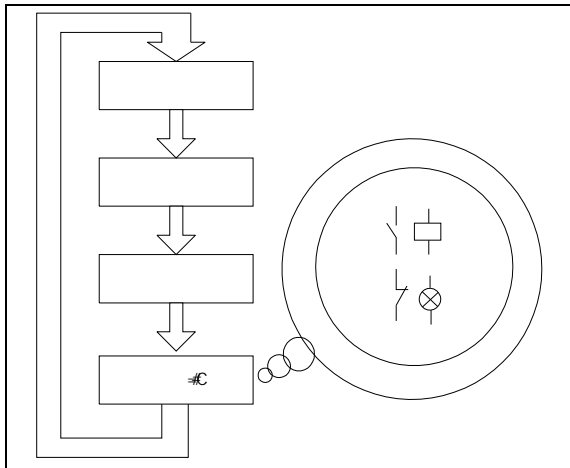
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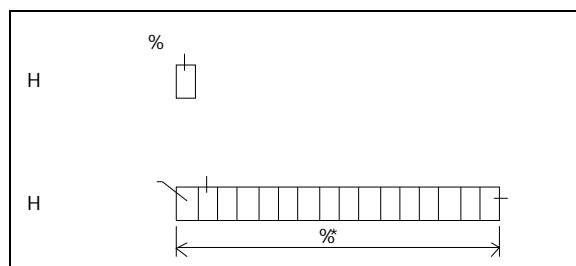
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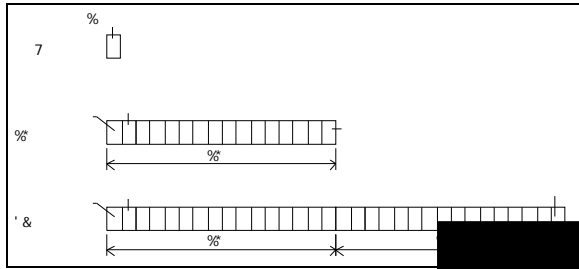
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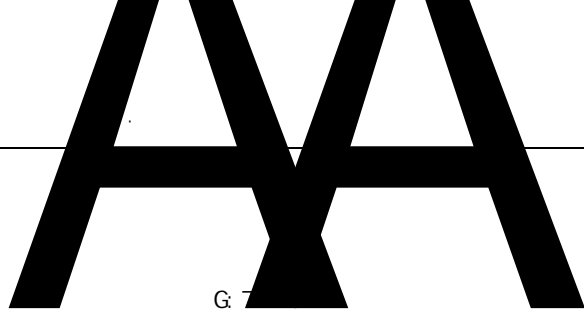
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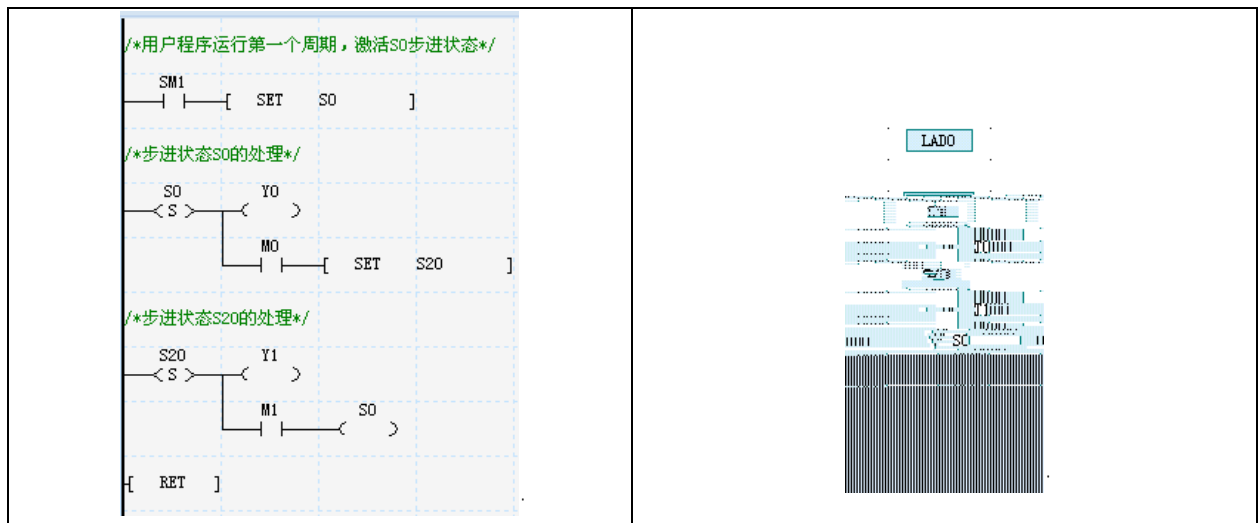
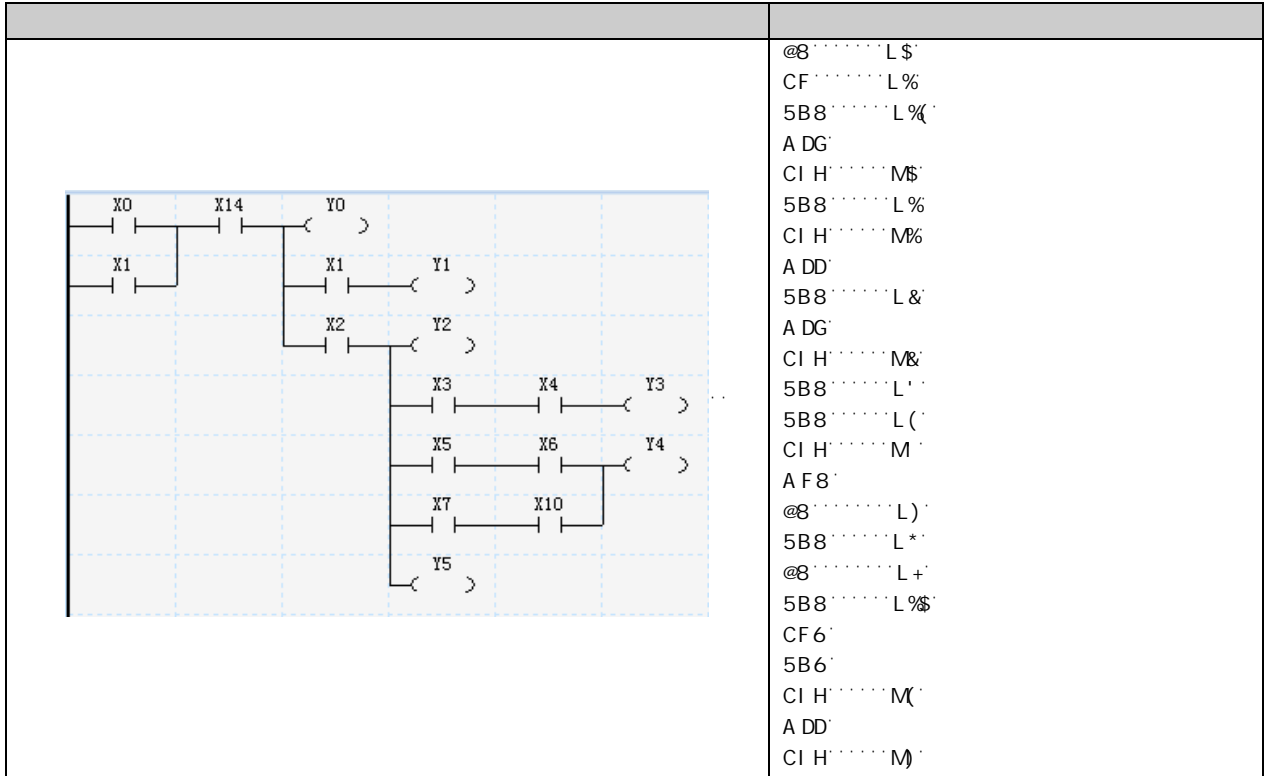
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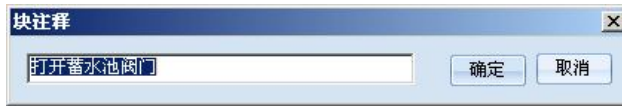
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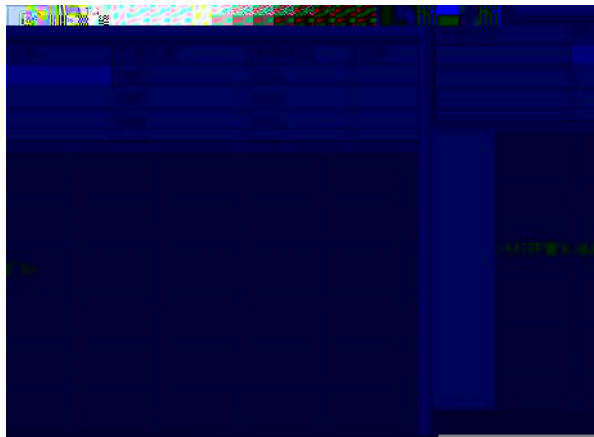
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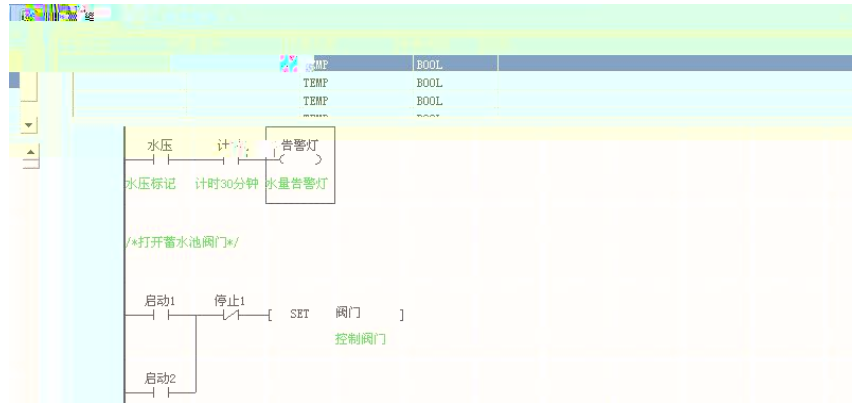


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变量	变量地址	注释
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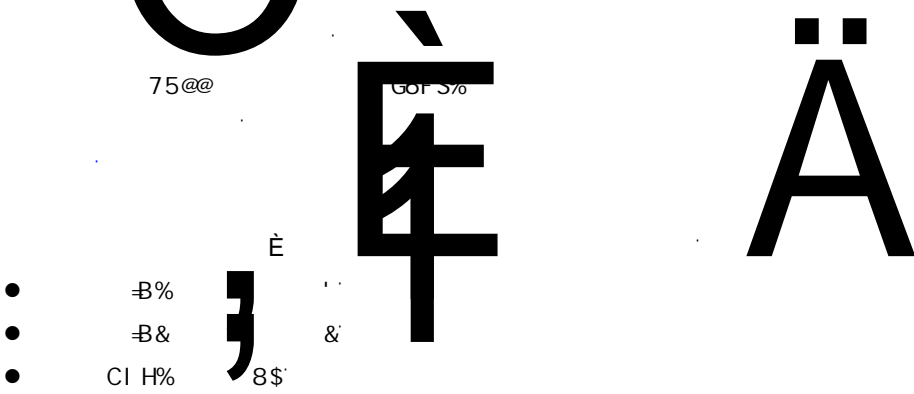
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变量地址	变量名称	变量类型	数据类型	注释
V0	IN1	IN	INT	
V1	IN2	IN_OUT	INT	
		OUT	BOOL	
V2	OUT1	TEMP	INT	
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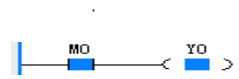
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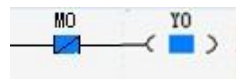
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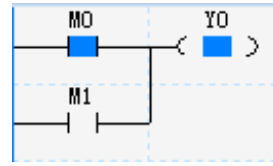
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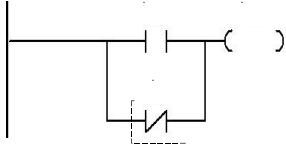
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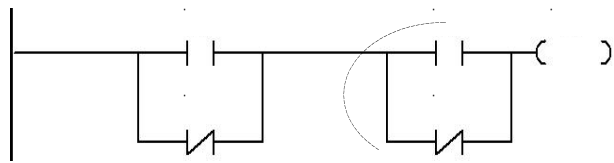
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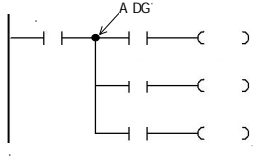


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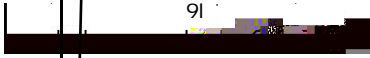




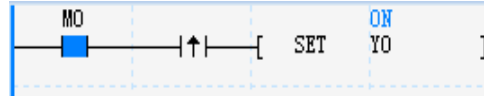
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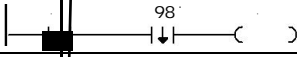
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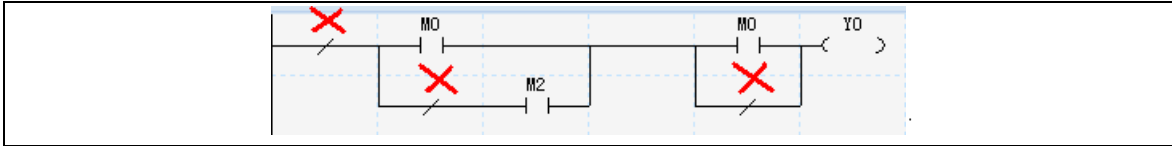
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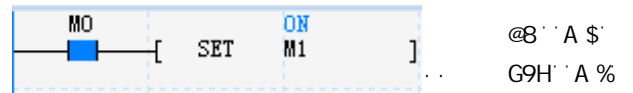
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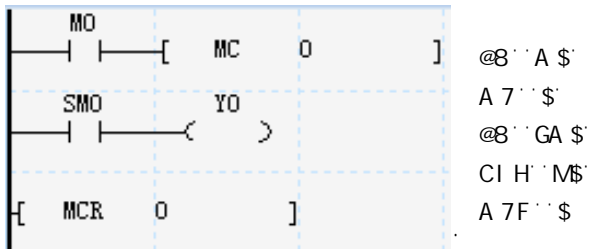
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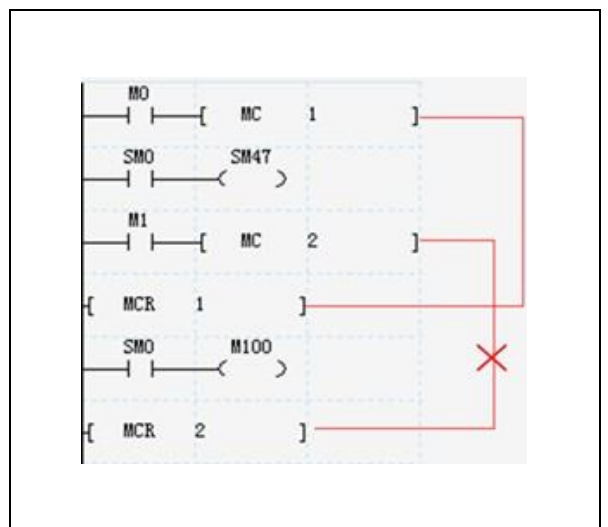
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*) '% 5H= 5G7= % % %& (
*) "%$@7BJ %& (
*) "%&F@7BJ %& )
* " + %& +
*) "%K 5B8 %& +
*) "%&K CF %& +
*) "% K LCF %& +
*) "%( 'K #BJ %& ,
*) "%) '8K 5B8 %& ,
*) "%* "8K CF %& -
*) "%+ '8K LCF %& -
*) "% , '8K #BJ %& -
* " + % $
*) "%+ FCF % % % $
*) "%+ "&FC@ % % % %
*) "%+ ' F7F % % % %
*) "%+ '( ' F7@ % % &
*) "%+)' 8FCF ' & % &
*) "%+ '* 8FC@ ' & % '
*) "%+ '+ 8F7F ' & % '
*) "%+ ', 8F7@ ' & % (
*) "%+ '- G<F % % % (
*) "%+ '%$G<@ % % % )
*) "%+ '%%8G<F ' & % % )
*) "%+ '%&8G<@ ' & % *
*) "%+ '% G: HF % % *
*) "%+ '% G: H@ % % +
* " , % ,
*) "%: FCA % ,
*) "% '&8: FCA % -
*) "% ' HC % $
*) "% '( '8HC % %
*) "% ,)' J FF8 % %
*) "% , '* F9: % &
*) "% , '+ F9: #C % &
*) "% , ' 9FCA K F 99DFCA % '
*) "% , '- DF % (
*) "% , '%$H? M % *
* " _ % +
*) "%_ '%HF 8 % +

```

```

*"- "&HK F
*"- "'H588
*"- "( 'HG I 6
*"- )" <CI F
*"- "x' 87A D 1 0 2
*"- "+ 'H7A D 1 0 2
*"- ", <HCG
*"- "- 'GHC <
*"%$' €
*"%$%'< 7BH
*"%$"&8< G7G
*"%$"' 8< G7=
*"%$"( '8< GD=
*"%$)" 8< G7F
*"%$"*' 8< GN
*"%$"+' 8< GH
*"%$",' 8< GD
*"%$"- 'GD8
*"%$"$'D@GM
*"%$"%D@GF
*"%$"%&D@G
*"%$"% 'D@G6
*"%$"% 'DK A
*"%%%
*"%%%D=8
*"%%%&F 5A D
*"%%%" '< 57? @9
*"%%%( 'HF =5B; @9
*"%%%)' 56G8
*"%%%*' 856G8
*"%%%+' 5@H
*"%&:
*"%&'%A cXvi g

```

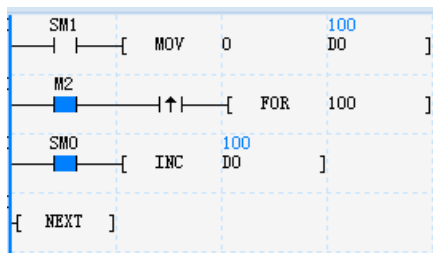

*"%" 'GHFA CJ&&
*"&%&&-
*"&%"NF B&&-
*"&%"D@GJ&' \$
*"&%" '8FJ =&' %
*"&%"('8FJ 5&' &
*"&%" '56G&' '
"&%" '8GNF 8C;&' (
*"&%"+'GHCD8J&' *
*"&%" '@B&' +
*"&%"-'7K&' -
*"&%"%'77K&(\$
*"&%"%'A CJ 9@B?&(&
*"&%"%' ; 95F6CL&' .
*"&%"%' '8FJ 7&' .
*"&%"%' '75A H56@9&' (
*"&%"%' '75A 6CL&') .
*"&%"&(+
*"&%"%'A 95B&(+
*"&%"%'&'K HC6&(+
*"&%"%' '6HCK&(-
*"&%"%'('I B= 16 4&)\$
*"&%"%' '8-€ 16 4 4

[FOR (S)]													M200 M100 M80 M280			
													3			
G	-BH		?bL	?bM	?bA	?bG	?b@A	?bGA	8	G8	7	H	J	N	F	

[NEXT]													M200 M100 M80 M280			
													1			

% :CF B9LH :CFIB9LH
 & :CF
 :CFIB9LH
 :CFIB9LH
 :CF
 :CFIB9LH
 :CFIB9LH

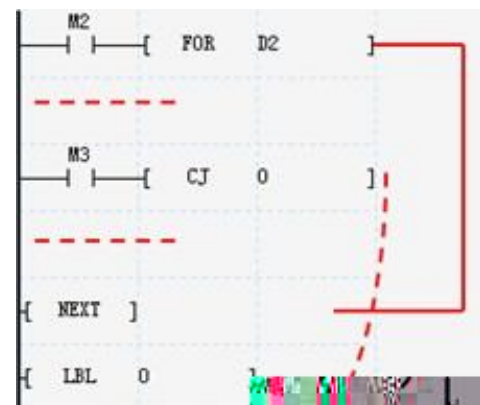
% :CF!B9LH DCI
 & :CFIB9LH A 7&\$ 7DI
 :CFIB9LH
 :CFIB9LH



@B GA %
 A C J '\$ ' 8\$
 @B A &
 9I
 :CF %\$\$
 @B GA \$
 -B7 ' 8%\$\$
 B9LH'



8\$1\$ A &1C:: A & C:: CB
 :CFIB9LH %\$ 8\$
 %\$\$ 8\$1%\$\$



(7>

) A 7!A 7F :CF!B9LH

```

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

```

```

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

```



:CF!B9LH

K 8H

[LBL (S)]		M200 M100 M80 M280	
		3	
G	=BH		

%

&

7>

%

&

\$ %&+

```

[ 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				
										3				
G	BH													

— — [WDT]		M200 M100 M80 M280
		1

M200 M100 M80 M280

|—| |—| [EI]

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

75@@

% 75@@

75@@

& 75@@

G6F%

8-BH#8K CF8

- 75@@G6F%N\$ N
- 75@@G6F%7%- 7\$ 7%-
- 75@@G6F%? &L\$?b % b ' G6F%
- 75@@G6F%7&\$ 7&\$ 7&)
- 75@@G6F%? &L\$?b (b ,

- 8-BH#8K CF8
- 8-BH#8K CF8
- 8-BH#8K CF8
- BH#K CF8
- BH#K CF8
- BH#K CF8

75@@

G6F%

CI H BSCI H

- 75@@G6F%' &%
- 75@@G6F%?(L\$?(L\$
- 75@@G6F%G8\$ G8\$

- CI H BSCI H
- CI H BSCI H
- CI H BSCI H

(75@@

		M200 M100 M80 M280
[CSRET]		
CSRET		1

— — [MOV (S) (D)]												M200	M100	M80	M280	
												5				
G	=BH		?bL	?bM	?bA	?bG	?b@A	?bGA	8	G8	7	H	J	N	F	
8	=BH			?bM	?bA	?bG	?b@A		8	G8	7	H	J	N	F	

% A C J

%\$

%%\$

%%\$ ()')

& 7 7\$ 7%-

X0	MOV	500	500
		D0	D10

@8 L\$

A C J 8\$ 8%

L\$1CB 8\$ 8\$ 8\$1)\$

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

8 G8

RMOV (S) (D)										M200 M100 M80 M280					
										7					
G	F95@								8				J		F
8	F95@								8				J		F

```

X0 [ RMOV D0 D10 ] @8 L$
5.000050... 5.000050...
FA CJ 8$ 8$
L $1CB 8$8% 8$8% 8$8% 1) "$$$) $

```

BMOV (S1) (D) (S2)										M200 M100 M80 M280					
										7					
G%	-BH		? bL	? bM	? bA	? bG	? b@A		8	G8	7	H	J		F
8	-BH		? bM	? bA	? bG	? b@A		8		7	H	J		F	
G&	-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F

```

X0 [ BMOV D0 D100 10 ]
300 300
@8 L$
6A CJ 8$
8$ $ $ $

```

										M200 M100 M80 M280					
										7					
G%	=BH'		? bL'	? bM'	? bA'	? bG'	? b@A'	? bGA'	8'	G8'	7'	H'	J'	N'	F'
8'	=BH'			? bM'	? bA'	? bG'	? b@A'		8'		7'	H'	J'		F'
G&	=BH'		? bL'	? bM'	? bA'	? bG'	? b@A'	? bGA'	8'	G8'	7'	H'	J'	N'	F'

% 7 7\$ 7%-
 & \$
 ' ?b ?b

X0 [FMOV 300 300 @8' L\$
 DO D100 10] : A C J ' 8\$ ' 8\$ \$
 %\$
 L \$1CB 8\$ 8\$ \$ %\$ 8\$ \$18\$ %1
 18\$ - 18\$ 1' \$ \$

										M200 M100 M80 M280					
										9					
G%	8=BH'		? bL'	? bM'	? bA'	? bG'	? b@A'	? bGA'	8'	G8'	7'		J'		F'
8'	8=BH'			? bM'	? bA'	? bG'	? b@A'		8'		7'		J'		F'
G&	=BH'		? bL'	? bM'	? bA'	? bG'	? b@A'	? bGA'	8'	G8'	7'	H'	J'	N'	F'

% 7 7&\$ \$ 7&))
 & \$
 ' ?b ?b

X0 [DFMOV 100000 100000 @8' L\$
 DO D10 10] : A C J ' 8\$ ' 8\$ \$
 %\$
 L \$1CB 8\$ 8\$ %\$ x & 8\$ 8\$ % 1
 8\$ 8\$ % 1 1 8& 8&- 1 8\$ 8\$ % 1\$ \$\$\$\$

--- --- [SWAP (D)]										M200 M100 M80 M280					
										3					
8	=BH			?bM	?bA	?bG	?b@A		8		7	H	J	N	F

XO 10000
 [SWAP DO]

@8 L\$
 GK 5D 8\$

L \$1CB 8 \$1\$1 %&+ (%)
 %\$\$\$

8\$ 8\$1\$1 &+ %\$

--- --- [XCH (D1) (D2)]										M200 M100 M80 M280					
										5					
8%	=BH			?bM	?bA	?bG	?b@A		8		7	H	J	N	F
8&	=BH			?bM	?bA	?bG	?b@A		8		7	H	J	N	F

%

A 7 D@7

&

/*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*/

?b D1
 D2 ?b "

%

XO 1000 5000
 [XCH DO D10]

@8
 L 7<

L \$1CB 8\$ 8\$
 8\$1) \$\$\$

8\$1%\$\$\$

8\$1%\$\$\$ 8\$1) \$\$\$

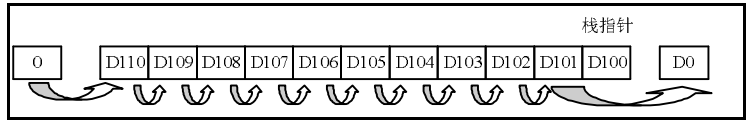
&

FIFO										M200 M100 M50 M250					
										7					
8%	-BH								8			J	F		
8&	-BH		? bM	? bA	? bG	? b@A			8	7	H	J	N	F	
G	-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	GS	7	H	J	N	F

1



%



%

% A \$1CB 8%\$% 8\$ 8%\$% 8%\$

\$

8%\$ \$

&

& 8\$1\$ 8%\$1\$ 8%\$1\$\$\$ 8%\$&1\$\$\$

GA % \$

8%\$-1-\$\$\$ 8%\$1\$\$\$\$

%

' 8\$1\$\$\$ 8%\$1- 8%\$&1\$\$\$ 8%\$&1' \$\$\$

8%\$-1\$\$\$\$ 8%\$1\$

&

\$

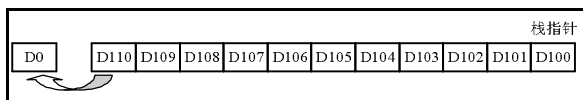
--- ---[LIFO (D1) (D2) (S)]										M200 M100 M80 M280					
										7					
8%	=BH								8				J		F
8&	=BH		? bM	? bA	? bG	? b@A			8		7	H	J	N	F
G	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F

%

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

@8 A \$

@= C 8%\$ 8\$ %



% A \$1CB 8%\$ 8\$ 8%\$ 8%\$

%

%

&

\$

GA % \$

%

& 8\$1\$ 8%\$1%\$ 8%\$1%\$\$\$

8%\$1&\$\$\$ 8%-1-\$\$\$ 8%\$1%\$\$\$

8\$1%\$\$\$ 8%\$1- 8%\$1%\$\$\$

8%\$1&\$\$\$ 8%-1-\$\$\$ 8%\$1%\$\$\$

%

&

\$

M200 M100 M80 M280

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

M200

7

C200

 WSE! (S1) (D) (S2) (S3)

[ADD (S1) (S2) (D)]										M200 M100 M80 M280					
										7					
G%	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8	=BH			? bM	? bA	? bG	? b@A		8		7	H	J	N	F

%
&

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

@8 L \$

588 8\$ 8% 8%\$

L \$1CB 8\$ %\$\$\$ 8% &\$\$\$

8% 8%\$1' \$\$\$

%

&

' &+*+

GA % %

\$

GA % \$

' &+*,

GA % &

[SUB (S1) (S2) (D)]										M200 M100 M80 M280					
										7					
G%	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8	=BH			? bM	? bA	? bG	? b@A		8		7	H	J	N	F

									M200 M100 M80 M280						
[]															
									8						
G%	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8	8=BH			? bM	? bA	? bG	? b@A		8		7		J		F

%

A I @

' &

&

X0		1000	2000	2000000
[]	MUL	D0	D1	D10

@8 L \$

A I @ ' 8\$ ' 8% ' 8%

L \$1CB 8\$ %\$\$\$ 8% &\$\$\$

8%8% 8%8% 1&\$\$\$\$\$

									M200 M100 M80 M280						
[DIV (S1) (S2) (D)]															
									7						
G%	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8	=BH			? bM	? bA	? bG	? b@A		8		7	H	J	N	F

%

\$

\$

&

X0		2500	1000	2
[]	DIV	D0	D1	D10

@8 L \$

8

8= 8\$ ' 8%8%

L \$1CB 8\$ &\$\$\$ 8% %\$\$\$

8%8% 8%1& 8%1)\$

— — [SQT (S) (D)]										M200 M100 M50 M250					
										5					
G	-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8	-BH			? bM	? bA	? bG	? b@A		8		7	H	J	N	F

\$

%

X0	1000	31
— [SQT	D0	D10

 @8 L\$
GEH 8\$ 8\$

& \$ L\$1CB 8\$ %\$\$\$ 8\$ 8\$1' %
GA % \$

GA % &

— — [INC (D)]										M200 M100 M50 M250					
										3					
8	-BH			? bM	? bA	? bG	? b@A		8		7	H	J	N	F

[DEC (D)]										M200 M100 M80 M280					
										3					
8	=BH			?bM	?bA	?bG	?b@A		8		7	H	J	N	F

!'&+*, ' &+*

%

X0	999
[DEC D0]	

@8`L\$`
8A7`8\$`

L\$1CB 8\$ %\$\$\$ % 8\$1---

[VABS (S) (D)]										M200 M100 M80 M280					
										5					
G	=BH		?bL	?bM	?bA	?bG	?b@A	?bGA	8	G8	7	H	J	N	F
8	=BH			?bM	?bA	?bG	?b@A		8		7	H	J	N	F

!'&+*+ ' &+*+ !' &+*,

X0	-1000	1000
[VABS D0 D10]		

@8`L\$`
J56G`8\$`8\$`

L\$1CB 8\$!\$\$\$ 8% 8%!\$\$\$

[NEG (S) (D)]										M200 M100 M80 M280					
										5					
G	=BH		?bL	?bM	?bA	?bG	?b@A	?bGA	8	G8	7	H	J	N	F
8	=BH			?bM	?bA	?bG	?b@A		8		7	H	J	N	F

!'&+*+ ' &+*+ !' &+*,

@8`L\$`
B9;`8\$`8\$`

X0	1000	-1000
[NEG D0 D10]		

L\$1CB 8\$ %\$\$\$ 8% 8%!\$\$\$

[DADD (S1) (S2) (D)]										M200 M100 M80 M280					
										10					
G%	8=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F
G&	8=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F
8	8=BH			? bM	? bA	? bG	? b@A		8		7		J		F

%
&

%
&
GA % %
GA % \$
GA % &

X0	100000	200000	300000
[DADD D0	D2	D10	

@8 L \$
8588 8\$ 8& 8%\$
L \$1CB 8\$8% %\$\$\$\$ 8&8'
&\$\$\$\$ 8%8% 8%8%
1' \$\$\$\$\$

[DSUB (S1) (S2) (D)]										M200 M100 M80 M280					
										10					
G%	8=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F
G&	8=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F
8	8=BH			? bM	? bA	? bG	? b@A		8		7		J		F

%
&

%
&
GA % %
GA % \$
GA % &

X0	100000	200000	-100000
[DSUB D0	D2	D10	

@8 L \$
8G 6 8\$ 8& 8%\$
L \$1CB 8\$8% %\$\$\$\$ 8&8'
&\$\$\$\$ 8%8% 8%8%
%\$\$\$\$

— — [DMUL (S1) (S2) (D)]										M200 M100 M80 M280					
										10					
G%	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F
G&	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8						

— — [DSQT (S) (D)]										M200 M100 M80 M280					
										7					
G	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F
8	8-BH			? bM	? bA	? bG	? b@A		8		7		J		F

\$

%

X0	83000	288
[DSQT]	D0	D10

@8 L \$

8GEH 8\$ 8\$

&É

\$

L \$1CB

8 \$8 %

, ' \$\$\$

8 \$8 %

8 \$8 %

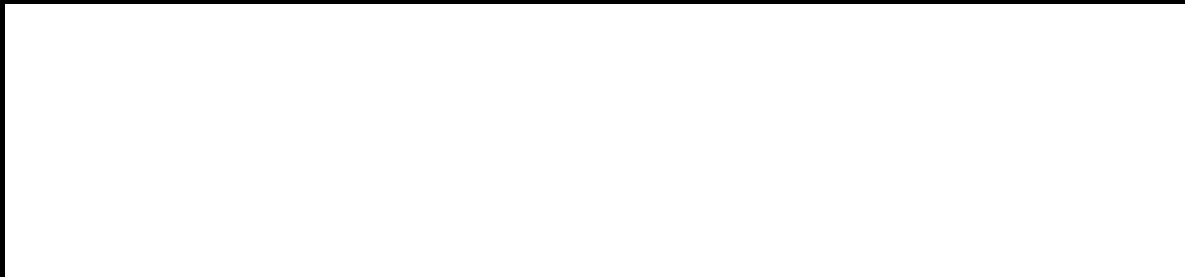
GA % \$

1& ,

GA % &

— — [DINC (D)]										M200 M100 M80 M280					
										4					
8															

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



A 7

(D)]

— — [DSUM (S1) (S2) (D)]										M200 M100 M80 M280					
										9					
G%	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	J		F	
G&	-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8	8-BH			? bM	? bA	? bG	? b@A		8		7	J		F	

x &

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

@8 GA \$
 8A CJ '\$\$\$\$\$' 8\$
 8A CJ '&\$\$\$\$' 8&
 8A CJ '\$\$\$\$\$' 8(
 8A CJ '(\$\$\$\$\$' 8*
 8A CJ '\$\$\$\$\$' 8,
 @8 L \$
 8G A '8\$)' 8%\$

\$ &))

L \$1CB 8\$) x &

8%\$Z8%\$%

8%\$Z8%\$% 1 8\$Z8% 8,Z- 1% \$\$\$\$\$

— — [RADD (S1) (S2) (D)]										M200 M100 M280				
										10				
G%	F95@								8			J		F
G&	F95@								8			J		F
8	F95@								8			J		F

GA %%

\$

GA % \$

%

&

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

@8 L \$
 F588 8\$8&8%

%

L \$1CB 8\$Z8% !\$\$\$\$8\$ 8&Z' &\$\$\$) \$\$

8%\$Z8% 8%\$Z8% 1!\$\$\$\$ \$ \$

&

%+\$%(%&Y \$,

%+\$%(%&Y \$,

n

y

z

				RSUB	(S1)	(S2)	(D)]		F2+X c',9/0Tr	NC208	NC100-NC	G'd	TM€ D g7v
S										10				
G%	F95@							8				J	F	
								8				J	F	
								8				J	F	\$*P9 RAfTr 5

6

%
&

%

3 -

9

3

[RVABS (S) (D)]										M200 M100 M280		
										7		
G	F95@							8			J	F
8	F95@							8			J	F

XO		-10000.2	10000.20
[RVABS	DO	D10

@ L \$
 FJ56G 8\$ 8%
 L\$1CB 8\$8% 1\$\$\$\$&
 8\$8% 8\$8% 1\$\$\$\$&

[RNEG (S) (D)]										M200 M100 M280		
										7		
G	F95@							8			J	F
8	F95@							8			J	F

XO		10000.20	-10000.2
[RNEG	DO	D10

@ L \$
 FB9 8\$ 8%
 L\$1CB 8\$8% 1\$\$\$\$&
 8\$8% 8\$8% 1\$\$\$\$&

[SIN (S) (D)]										M200 M100 M280		
										7		
G	F95@							8			J	F
8	F95@							8			J	F

& \$ GA % \$

XO		1.570000	1.000000
[SIN	DO	D10

% G-B @ L \$
 G-B 8\$ 8%

L \$1CB 8% 1% + G-B

8% 8% 1%

										M200 M100 M280			
[COS (S) (D)]													
										7			
G	F95@							8			J		F
8	F95@							8			J		F

X0		3.140000	-1.000000
[COS	D0	D10

@8 L\$
7CG 8 8

L \$1CB 8% 1% 7CG

8% 8%

1!\$\$\$\$\$

%

7CG

&

GA % \$

										M200 M100 M280			
[TAN (S) (D)]													
										7			
G	F95@							8			J		F
8	F95@							8			J		F

X0		1.570000	1255.848
[TAN	D0	D10

@8 L\$
H5B 8 8

L \$1CB 8% 1% + H5B

8% 8%

1%)", (, '-,

%

H5B

&

!%+\$%&Y \$,

!%+\$%&Y \$,

GA % %

\$

GA % \$

— — [POWER (S1) (S2) (D)]										M200 M100 M280						
										10						
G%	F95@								8				J			F
G&	F95@								8				J			F
8	F95@								8				J			F

[EXP (S) (D)]										M200 M100 M280					
										7					
G	F95@								8				J		F
8	F95@								8				J		F

X0	[EXP	10.00000	22026.46
	DO	D10]

@8 L\$
9LD 8\$ 8%

L \$1CB 8\$8% 1%\$ 9LD 8\$8% 8\$8%

% 9LD 1&&\$*(.(

&

+\$%&Y \$,

+\$%&Y \$,

GA %%

\$ GA % \$

5

[RSLM (S1) (S2) (D)]										M200 M100 M280					
										9					
G%	F95@								8				J		F
G&	=BH	? bL	? bM	? bA	? bG	? b@A	? bGA		8				J		F
8	F95@								8				J		F

x &

F 4'hr #q 9 CE

% \$ &))

/

[ACOS (S) (D)]										MC280				
5H5B f8 fD										7				
G	F95@							8				J	F	
8	F95@							8				J	F	

& \$ GA % \$

SMD	[ATAN	3.140000	1.262481	@8 GA \$
	DO	D10		5H5B 8 8

%
H5B!

GA \$1CB f8 8 % H5B! f8 8 % f8
8 % 1 % & % , %

[LOG (S) (D)]										MC280				
@C; f8 fD										7				
G	F95@							8				J	F	
8	F95@							8				J	F	

& \$ GA % \$

SMD	[LOG	3.000000	0.477121	@8 GA \$
	DO	D10		@C; 8 8

% @C;
@C; %

GA \$1CB 8 f8 % '\$ 8 f8 % 8 f8 % 1 \$ (+ % %

[RAD (S) (D)]										MC280				
F58 f8 fD										7				
G	F95@							8				J	F	
8	F95@							8				J	F	

%
& \$ GA % \$

SMD	[RAD	180.0000	3.141593	@8 GA \$
	DO	D10		F58 8 8

6CC@		%	CB C::	% @A
BH		%	! &+*, Z' &+*	% J
8-BH		' &	!&%+(, '* (, Z&%+(, '* (+	& J
K CF8		%	\$ *)')'	% J
8K CF8		' &	\$ (& (-*+&-)	& J
F 95@		' &	-%%+)(-(')%9!' , r-'('\$& & (**'9Z" ,	& J

678

!!

678 6]bUfm7cXYX'8Y]a U

678

, (&%678

, (&%678

\$	\$\$\$\$	\$\$\$\$
%	\$\$\$\$%	\$\$\$\$%
&	\$\$%\$	\$\$%\$
'	\$\$%\$	\$\$%\$
(\$%\$	%\$
)	\$%\$%	%\$%
*	\$%\$	%\$%
+	\$%\$%	%\$%
,	%\$	%\$
-	%\$%	%\$

[DTI (S) (D)]										M200 M100 M80 M280					
										6					
G	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	J	F		
8	BH			? bM	? bA	? bG	? b@A		8		7	H	J	N	F

' &+*+ !' &+*,

X0	10000	10000
[DTI	D0	D10

@8 L\$
8H= 8\$ 8\$

L \$1CB 8 \$z8% 1\$ \$\$\$

8% 8% 1\$ \$\$\$

[INT (S) (D)]										M200 M100 M280					
										6					
G	F95@								8				J		F
8	=BH			? bM	? bA	? bG	? b@A		8		7	H	J	N	F

' &+*+ 1' &+*+ !' &+*, 1!' &+*,

%

X0	10000.50	10000
[INT D0 D10]		
XO=ON		

@8 L\$
=BH 8\$ 8\$

&

M L\$1CB 8\$8% 1%\$\$\$) 8%
8%1%\$\$\$

M200 M100 M280

| | [DINT (S) (D)]



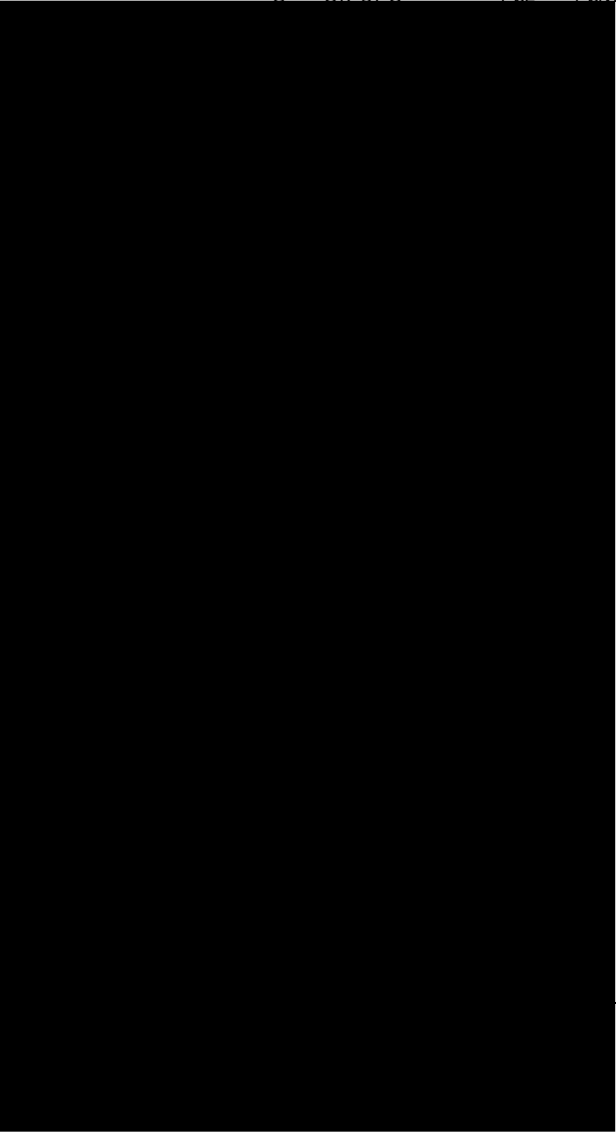
[BCD (S) (D)]			
-----------------	--	--	--



L \$1CB 8 \$1\$ \$8\$) ' ' ' ' % 678 8 % \$
 8 % \$1\$ ' ' ' ' % % +

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

G 8K CF8 ?bl ?bM ?bA ?bG ?b@A ?bGA 8



		M200 M100 M80 M280
[BIN (S) (D)]		

[GRY (S) (D)]										M200 N200 M80 M280					
										5					
G	K CF8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8	K CF8			? bM	? bA	? bG	? b@A		8		7	H	J	N	F

XO [GRY 43690 85535 @8 L\$] ; FM —

g

%*



[DGBIN (S) (D)]										M200 M100 M80 M280			
										7			
G	8K CF8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	J	F
8	8K CF8			? bM	? bA	? bG	? b@A		8		7	J	F

XO 3435973836 2290649224
 [DGBIN D0 D10]

@B L\$
 8; 6-B 8\$ *8\$

L \$1CB 8\$8% 1\$ 77777777 (')-+', * #* @ = \$| +0' Y TM of/c
 8\$8% 8\$8% 1\$ && \$*(-&&

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

										M200 M100 M80 M280			
[ASC (S1~S8) (D)]													
										19			
G%	K CF8												
G&	K CF8												
G'	K CF8												
G(K CF8												
G)	K CF8												
G*	K CF8												
G+	K CF8												
G.	K CF8												
8	K CF8							8		7	H	J	N F

5G7 = \$! 8% \$! +9
 \$L \$\$

\$

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

@B A \$

5G7 %& () *+, ' 8\$

A \$1CB 5G7 =

- GA % *1C: : 8\$1\$' & %
8%1\$' (' 8&1\$' *) 8' 1\$' , '+
- GA % *1CB 8\$1\$' % 8\$1\$' &
8&1\$' ' 8' 1\$' (8(1\$') 8)1\$' * 8*1\$' +
8+1\$' ,

5G7 =

GA % *1C: :

5G7 = GA % *1CB

% 5G7 =

M200 M100 M80 M280

| | [ITA (S1) (D) (S2)]

● GA % *1C::
8&9d \$! ' * ' +

8&\$1\$! ' , ' -

● GA % *1CB

8&\$1\$! ' - 8&9d \$! ' ,

8&&1\$! ' + 8& 1\$! ' *

— — [ATI (S1) (D) (S2)]										M200 M100 M80 M280					
										7					
G%	WORD		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8	WORD			? bM	? bA	? bG	? b@A		8		7	H	J	N	F
G&	WORD		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F

5G7=

\$! '\$ \$! ' - \$! (% \$! (* GA % *1C::

% *(

D@7



D_n

A fV_{SL} V_{SH} fV_{ML} V_{MH} fV_{SL}

B V_{SL} fV_{ML} fA#

D_n fV_{SL} fA#

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]

@8 = A %

FA CJ ' & & ' 8\$\$\$

FA CJ ' ')' \$ ' 8\$\$\$

FA CJ ' &* \$ ' 8\$\$\$

FA CJ ' ' *) \$ ' 8\$\$\$

@8 = A (

FA CJ ' & & ' 8\$\$\$

FA CJ ' ')' \$ ' 8\$\$\$

FA CJ ' ' % * ' 8\$\$\$

FA CJ ' ' \$ ' ' 8\$\$\$

FA CJ ' ') \$\$\$ ' 8\$\$\$

FA CJ ' ' ! %) ' 8\$\$\$

@8 = A &

F@7BJ : 8\$\$\$ 8\$\$\$ 8\$\$\$ 8\$\$\$ *

A &1CB @7BJ

8&fB&\$%L1' &* \$

8&fB&\$% L1' *) \$

8&fB&\$% L1' %))

8&*fB&\$%L1' ! (" & ,

8&\$, fB&\$%L1') % (" &* +

8&fB&\$%L1' ! % (") +

[ROR (S1) (D) (S2)]																
G%	K CF8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F	
8	K CF8			? bM	? bA	? bG	? b@A		8		7	H	J	N	F	
G&	BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F	

%

&

GA % %

\$

? b

? b

(

[ROL (S1) (D) (S2)]																
G%	K CF 8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F	
8	K CF 8			? bM	? bA	? bG	? b@A		8		7	H	J	N	F	
G&	BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F	

%

&



--- --- [RCL (S1) (D) (S2)]																
G%	K	CF8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F

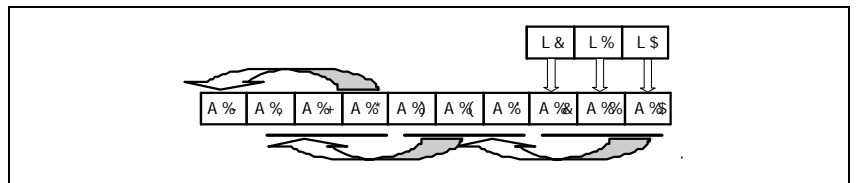
— — [DSHL (S1) (D) (S2)]		
-------------------------------	--	--

[SFTL (S1) (D) (S2) (S3)														
G%	6CC@	L	M	A	G	@A	GA	7	H					
8	6CC@		M	A	G	@A		7	H					
G&	=BH	?bL	?bM	?bA	?bG	?b@A	?bGA	8	G8	7	H	J	N	F
G	=BH	?bL	?bM	?bA	?bG	?b@A	?bGA	8	G8	7	H	J	N	F

%

MO | | | [SFTL ON XO ON M10 10 3] @8...A\$
 G:H@L\$A%\$%\$

&



%

% A \$1CB A %\$ %\$

&

A %+ A % L \$

& L \$1% L %1\$ L &1% A %1\$ A %1% A %1% A %1\$ A %1\$

A %1% A %1\$ A %-1\$ A %1\$ A %1%

' L \$ L & A %1% A %1\$ A %1% A %1\$ A %1% A %1%

A %1\$ A %-1\$ A %1% A %1\$

										M280					
FROM (S1) (S2) (D)															
G%	=BH'														
G&	=BH'														
8	=BH'							8					J	F	
G	=BH'														

6: A

\$ +

: FCA

6: A

\$ '&+*+

6: A

6: A

MO	[FROM	0	3	997	D100	2]	@8'' A \$
									: FCA \$' 8%%\$&

A \$ CB \$

6: A

&

8%%\$ 8%%\$

6: A

% '&+*+

6: A

6: A

[DFROM (S1) (S2) (D) (S3)]																
G%	=BH'	
G&	=BH'	
8'	8=BH'		8'	.	.	.	J'	.	F'	.
G'	=BH'	

6: A

\$ +

6: A

6: A

8: FCA

\$ '&+*+

6: A

6: A

MO	[DFROM	0	3	16580857	D200	1]
----	---	-------	---	---	----------	------	---	---

@8' A \$'

8: FCA '\$' '8&\$'\$ %

A \$ CB \$

6: A

%

6: A

8&\$Z&\$%

% '&+*+

6: A

----- ----- ----- ----- ----- ----- ----- ----- ----- ----- ----- -----															
----- ----- ----- ----- ----- ----- ----- ----- ----- ----- ----- -----															
----- ----- ----- ----- ----- ----- ----- ----- ----- ----- ----- -----															
G%	=BH'														
G&	=BH'														
G'	=BH'								8'				J'		F'
G(=BH'														

\$ + 6: A

6: A HC

\$ '&+*+
6: A
6: A

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

@8 GA \$
HC \$', %\$\$\$ &
%\$\$\$

D@7 \$ 6: A , 6: A -

6: A

% '&+*+
6: A
6: A

[DTQ (S1) (S2) (S3) (S4)]														
G%	=BH'													
G&	=BH'													
G'	8-BH'							8				J		F
G(=BH'													

\$ +

6: A

8HC

6: A

\$ '&+*+

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

@8 ' ' GA \$
8HC ' \$ ' , ' % + % % ') ' %

6: A

6: A

D@7

\$

6: A , , -

%

% + % % ')

6: A

% '&+*+

6: A

6: A

[VRRD (S) (D)]														
G'	K CF8'													
8'	K CF8'							8				J		

\$ &))

MO	[VRRD	0	T8	D10]
----	---	------	---	----	-----	---

\$ &))

@8 ' ' A \$

J FF8 ' \$ ' 8 % \$

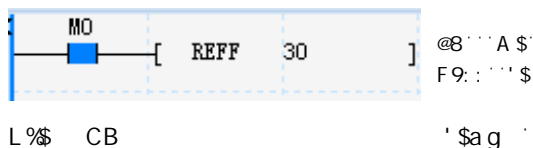
A \$ CB

\$

8 % \$

--- --- [REFF (S)]															
G	K CF8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F

- A 7&\$\$ \$ *(ag *(
- A 7%\$\$ \$, % ' & *(



L\$ L%+

--- --- [REF (D) (S)]														
8	6CC@		L	M										
G	-BH													

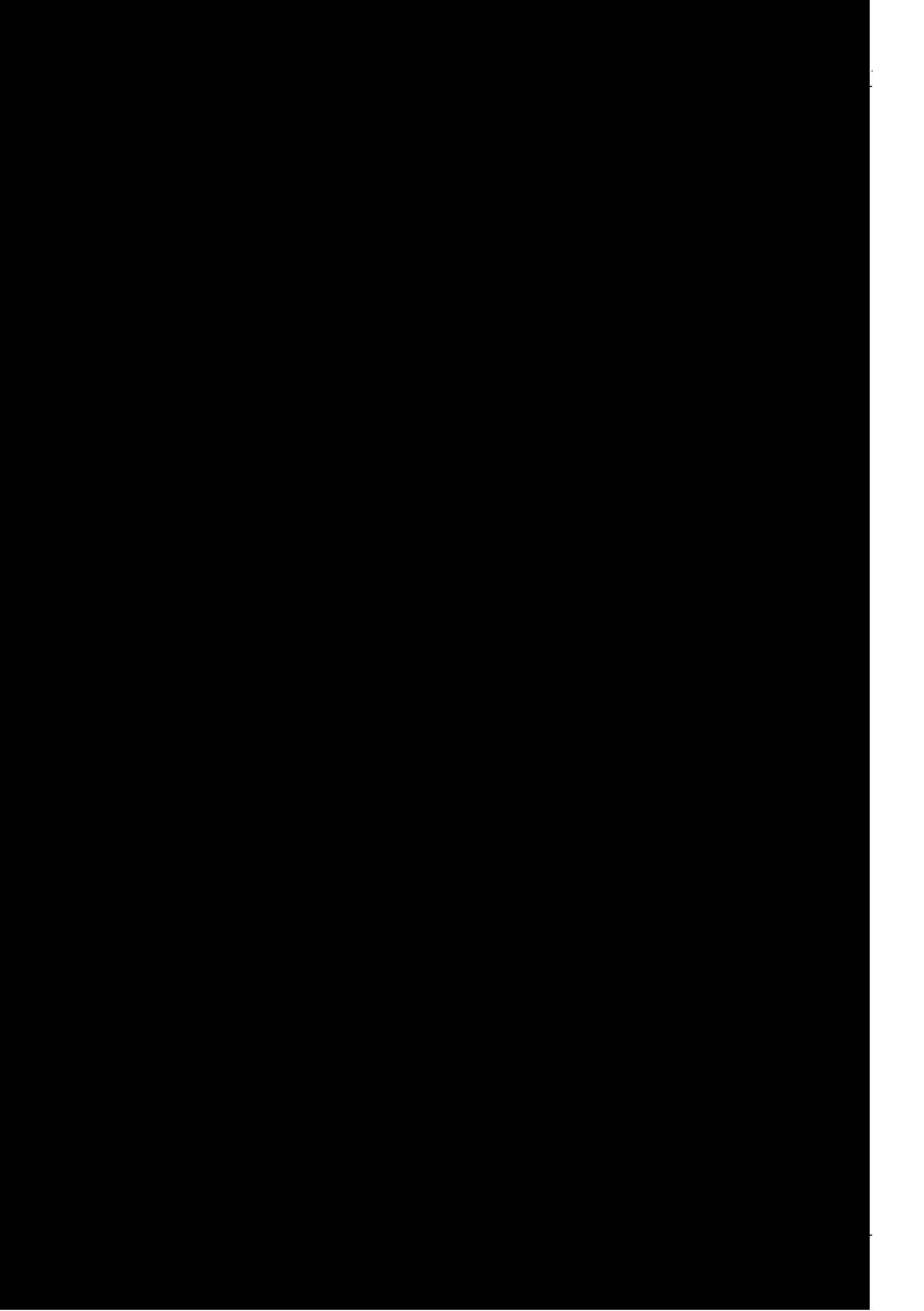
L#M
L\$ L% L&\$
M\$ M% M&\$ \$

% Lb Mb
& :CFIB9LH 7>
F9:
(
F9:
)

D@7



A \$ CB M\$ M+



[FR]														
G	K CF8								8		7	H		F
8	6CC@			M										

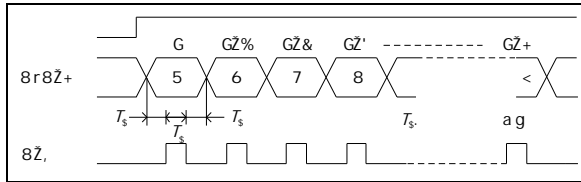
M

% G GZ+ , %
& GA +%

8 8Z+

M

GA +%

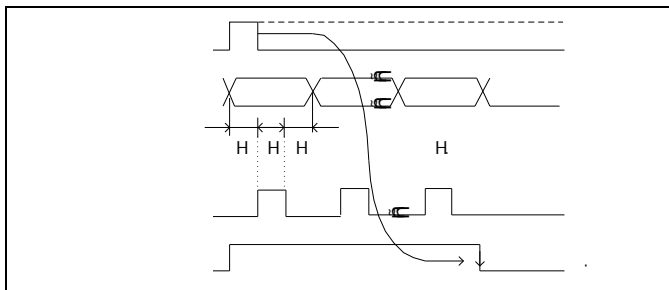


GA +\$ C: :

CB % %

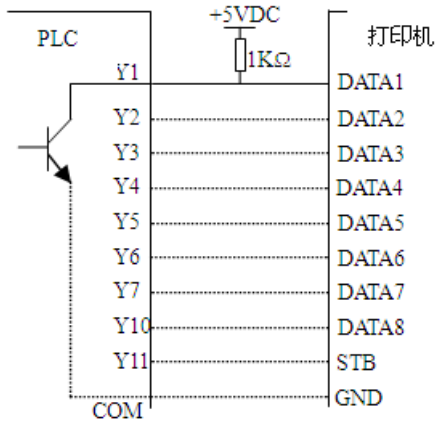
<\$ \$ BI @

GA +\$ CB



%

&



% Ω " \$")J 87 " % M0%

8\$!8+

5G7=

```

/*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 ]
    
```

%
&

GA +% "



--- --- [TRD (D)]														
8	K CF8									8			J	F

HF 8

+

8

MO	2000
--- [TRD D10]	

@8... A \$
HF 8... 8%

A \$ CB

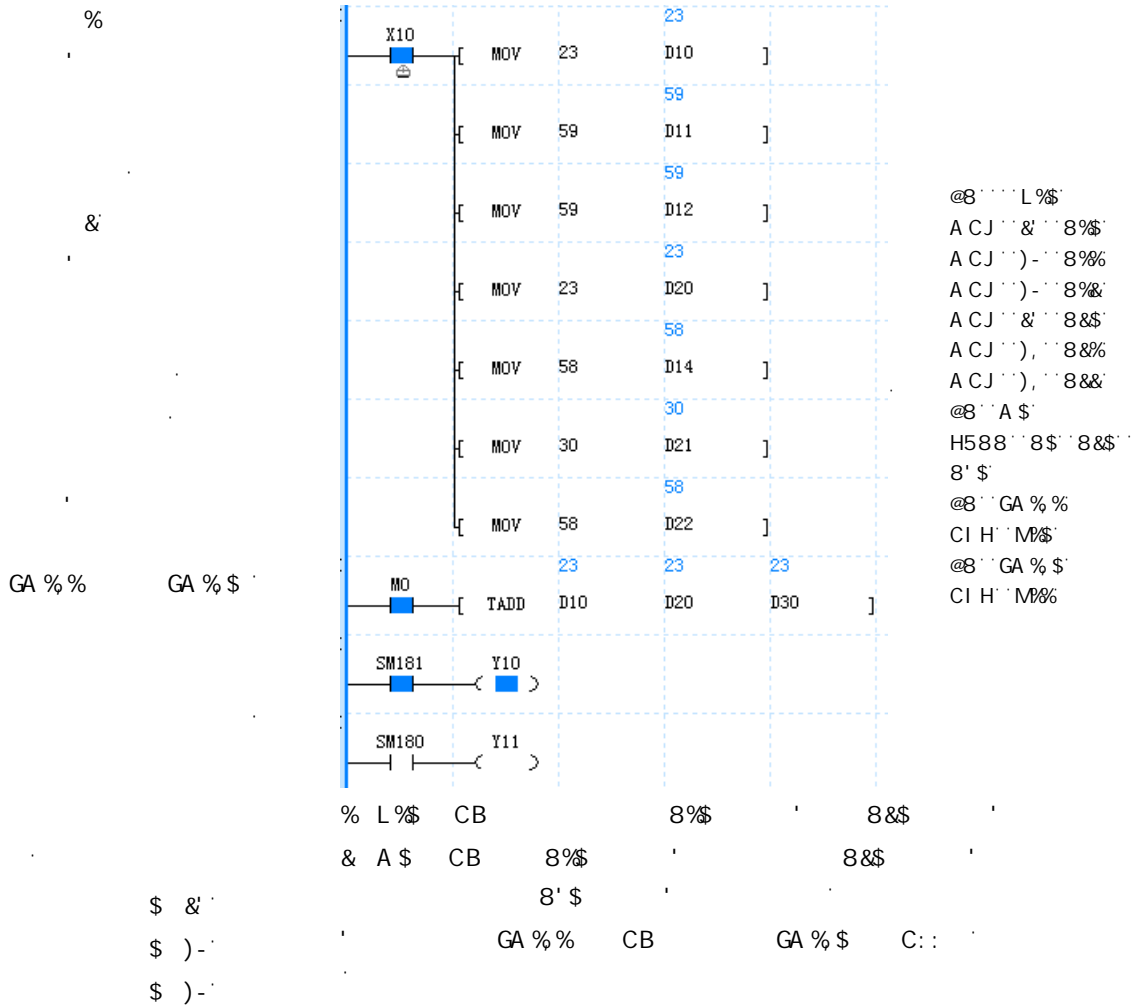
8% +

	G8%\$\$		&\$\$\$ &\$-		8%\$	
	G8%\$%		% %&		8%	
	G8%\$&		% ' %		8%&	
	G8%\$'		\$ &'		8%'	
	G8%\$(\$)-		8%('	
	G8%\$)		\$)-		8%)'	
	G8%\$*		\$ *		8%*	

— — [TWR (S)]		

TADD (S1) (S2) (D)]												
G%	K CF8								8	G8	J	F
G&	K CF8								8	G8	J	F
8	K CF8								8		J	F

8&)-		8&&),		8' &)+
----	----	--	-----	----	--	------	----



G%			G&			8	
8%\$	&		8&\$	&		8' \$	&
8%&)-		8&&),		8' %),

[TSUB (S1) (S2) (D)]								M280								
G%	K CF8							8	G8					J		F
G&	K CF8							8	G8					J		F
8	K CF8							8						J		F

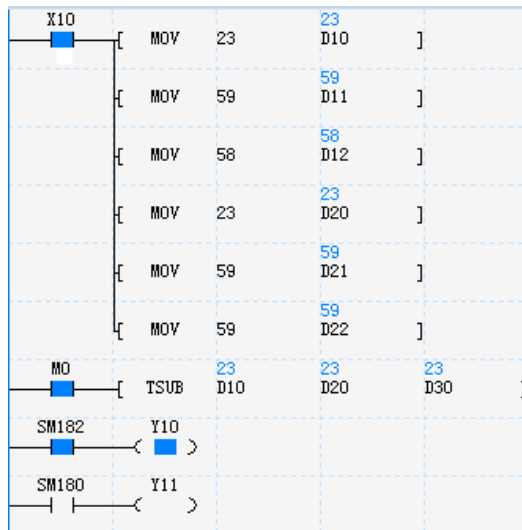
%

G%		G&		8	
8%\$	&	8&\$	&	8' \$	&
8%%)-	8&%)-	8' %)-
8%&),	8&&)-	8' &)-

&

GA % &

GA % \$



@8' L%\$
 ACJ' &' 8%\$
 ACJ')- 8%%
 ACJ'), 8%&
 ACJ' &' 8&\$
 ACJ')- 8&%
 ACJ')- 8&&
 @8' A \$
 HGI 6' 8%\$ 8&\$ 8' \$
 @8' GA % &
 CI H' M%\$
 @8' GA % \$
 CI H' M%\$

% L%\$ CB 8%\$ 8&\$
 & A \$ CB 8%\$ 8&\$
 8' \$

" " \$ &
 " " \$)-
 " " \$)-

GA % & CB GA % \$ C: :

[HOUR (S) (D1) (D2)]								M280							
G	=BH		?bL	?bM	?bA	?bG	?b@A	?bGA	8	G8	7	H	J	N	F
8%	=BH								8				J		F
8&	6CC@			M	A	G	@A								

D@7

\$ & CB % &+*+ \$

FI B' GHCD

%

CB

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

@8 ' ' A \$
 A C J ' ' %\$\$\$ ' 8%\$\$
 @8 ' ' A %
 <C I F ' ' 8%\$\$\$ ' 8&\$\$\$ ' ' A %\$
 @8 ' ' A %\$
 C I H ' ' M\$

CB

% A \$ CB <C I F

& A % CB <C I F

' A % CB %\$\$\$ A % CB

%

D@7

.....

										M280					
[]	[]	DCMP=	(S1)	(S2)	(D)]							
[]	[]	DCMP<	(S1)	(S2)	(D)]							
[]	[]	DCMP>	(S1)	(S2)	(D)]							
[]	[]	DCMP<>	(S1)	(S2)	(D)]							
[]	[]	DCMP>=	(S1)	(S2)	(D)]							
[]	[]	DCMP<=	(S1)	(S2)	(D)]							
G%	-BH'								8	G8			J		F
G&	-BH'								8	G8			J		F
8	6CC@			M	A	G	@A				7	H'			

%

&

8 CB

C: :

6-B

&&&(-

'% &&&' & &-

SMO	[MOV	2004	2004	D0]			
	[MOV	10	10	D1]			
	[MOV	25	25	D2]			
	[MOV	2004	2004	D10]			
	[MOV	10	10	D11]			
	[MOV	24	24	D12]			
X0	[DCMP=	2004	2004	D0	D10	OFF	M0]
	[DCMP<	2004	2004	D0	D10	OFF	M1]
	[DCMP>	2004	2004	D0	D10	ON	M2]
	[DCMP<>	2004	2004	D0	D10	ON	M3]
	[DCMP>=	2004	2004	D0	D10	ON	M4]
	[DCMP<=	2004	2004	D0	D10	OFF	M5]

@8' GA \$

A CJ &&&('8\$

A CJ %\$' 8%

A CJ &' 8&

A CJ &&&('8%\$

A CJ %\$' 8%&

A CJ &(' 8%&

@8' L\$

87A D1'8\$8%\$A \$

87A D0'8\$8%\$A %

87A D2'8\$8%\$A &

87A D02'8\$8%\$A '

87A D21'8\$8%\$A (

										M280																																																																	
<table border="0"> <tr> <td> </td><td> </td><td>[</td><td>TCMP=</td><td>(S1)</td><td>(S2)</td><td>(D)</td><td>]</td><td></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><td></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><td></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><td></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><td></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><td></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)]								
		[TCMP=	(S1)	(S2)	(D)]																																																																				
		[TCMP<	(S1)	(S2)	(D)]																																																																				
		[TCMP>	(S1)	(S2)	(D)]																																																																				
		[TCMP<>	(S1)	(S2)	(D)]																																																																				
		[TCMP>=	(S1)	(S2)	(D)]																																																																				
		[TCMP<=	(S1)	(S2)	(D)]																																																																				
G%	=BH	8	G8	J	F																																																						
G&	=BH	8	G8	J	F																																																						

8

HTOS (S) (D)												
G	K	CF8	?bL	?bM	?bA	?bG	H	7	8	G8		

[HCNT (D) (S)]																
8	8-BH											7				
G	8-BH		?bL	?bM	?bA	?bG	?b@A	?bGA	8	G8	7		J		F	

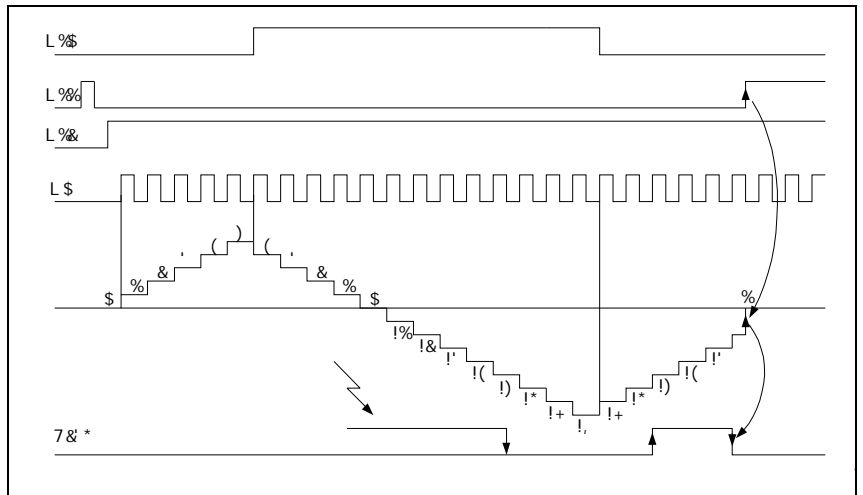
7&* 7&-

'&

&%+(,'*(, &%+(,'*(+

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

@8'''' L%
 CI H'' GA &''
 @8'''' L%
 FGH'''' 7&''
 @8'''' L%
 <7BH'' 7&''!



<7BH
 <7BH GD8

€

€

% L%& C:: CB 7&* L\$ 7&*
 L%& C:: L\$ 7&*
 L\$
 & 7&* *) 7&*
 7&*) * 7&*
 L%& CB FGH 7&* 7&*

[DHSCS (S1) (S2) (D)]															
G%	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F
G&	8-BH										7				
8	6CC@			M	A	G									

' & 8-BH
 &%+(, '* (, &%+(, '* (+

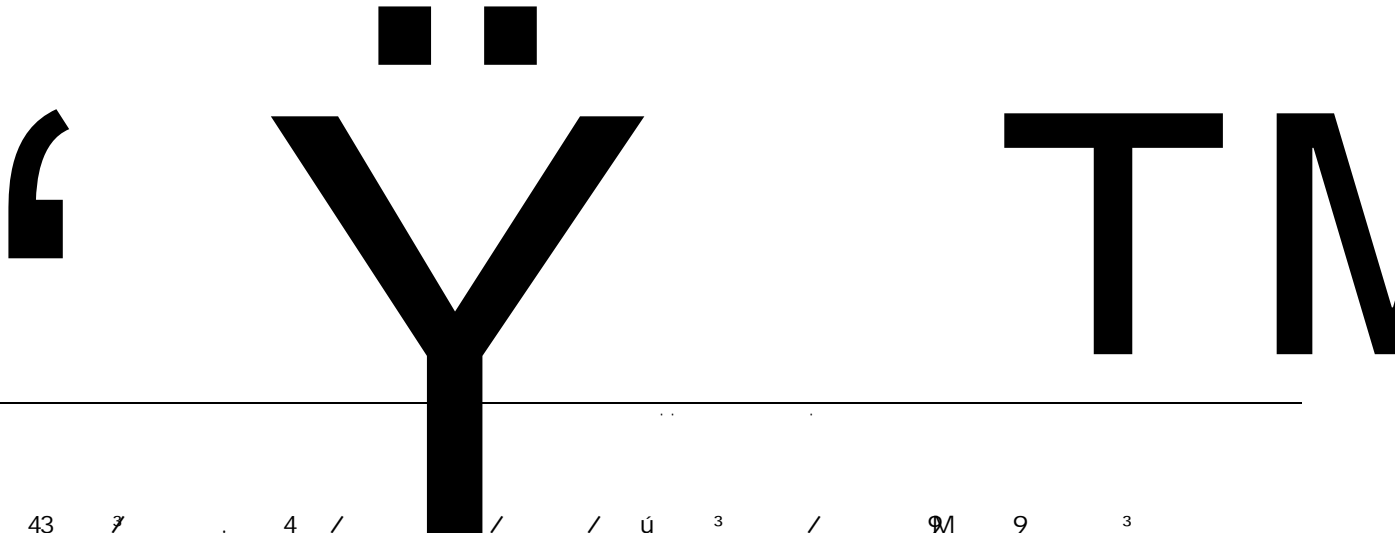
7& * 7&)-
 M`ØT...q¿8

G

% 8<G7G
 <7BH
 <7BH
 8<G7G
 &Ë8<G7G

¿9 TMø TM€•r6 ""(pEÃ • &

Â Ë: ÿ TM~ —(R4@ FOAÑ «ó' ÿ TM" —#•à 333 TMø TM€ r...#D D 79 Ø Æ



----- ----- ----- DHSCI (S1) (S2) (S3)]														
G%	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J	F
G&	8-BH										7			
G	K CF8													

(D@7 8<G7G 8<G7= 8<G7F 8<GN
 8<GD 8<GH €

' & 8-BH
 &%(+, '* (, &%(+, '* (+

7&* 7&)-
 &\$

&)
 <7BH

C:: CB
 8<G7=

M1 SM236

M0 [HCNT C236 1000]

M2 [DHSCI 2000 C236 20]

C236 Y11

M10 Y20

[>= DO 100]

[MOV 0 DO]

@8 A %
 CI H GA &*
 @8 A \$
 8<G7= &\$\$\$ 7&* &\$
 @8 7&*
 CI H M%%

@8 A %
 CI H M&\$
 @821 8\$ %\$\$
 CI H M%%
 A C J \$ 8\$

% 8<G7=
 <7BH
 <7BH
 8<G7=
 & 8<G7=
 8A C J A C J
 8<G7=
 ' 8<G7= 8<G7G 8<G7F
 8<GN 8<GD 8<GH

% A % CB 7&* L\$ C:: CB L\$
 € 7&* --- %\$\$\$ 7&* %\$\$\$
 %\$\$\$ 7&* 7&* M%% M%%
 & A & CB 8<G7=
 7&* &\$\$\$ &\$
 ' A \$ CB GA &* 7&* A \$ C:: GA &*
 7&*
 (7&* 7&* &\$\$\$ &\$
 A %\$ CB M&\$ M&\$
 8\$ %\$\$ M%% 8\$

*

----- -----[DHSPI (S1) (S2) (S3)]															
G%	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F
G&	8-BH									G8					
G	K CF 8														

' & 8-BH

&%(+,'*(, &%(+,'*(+

ž

G8&\$G8' &\$G8' (\$G8') \$G8' *\$G8' +\$

)' ž (ž) ž *ž +ž, "

8 < GD1 :

GD1

DHSCR (S1) (S2) (D)																
G%	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F	
G&	8-BH										7					
8	6CC@			M	A	G					7					

& 8<G7F

8A CJ A CJ

8<G7F

' & 8-BH

' 8<G7F 8<G7= 8<G7G 8<GN 8<GD 8<GH

8%+(,'*(, 8%+(,'*(+

*

*

7&* 7&)-

(D@7

8<G7G R

M A

G 7

7

<7BH

C: : CB

8<G7F

M

M

8<G7F

% 8<G7F

<7BH

<7BH

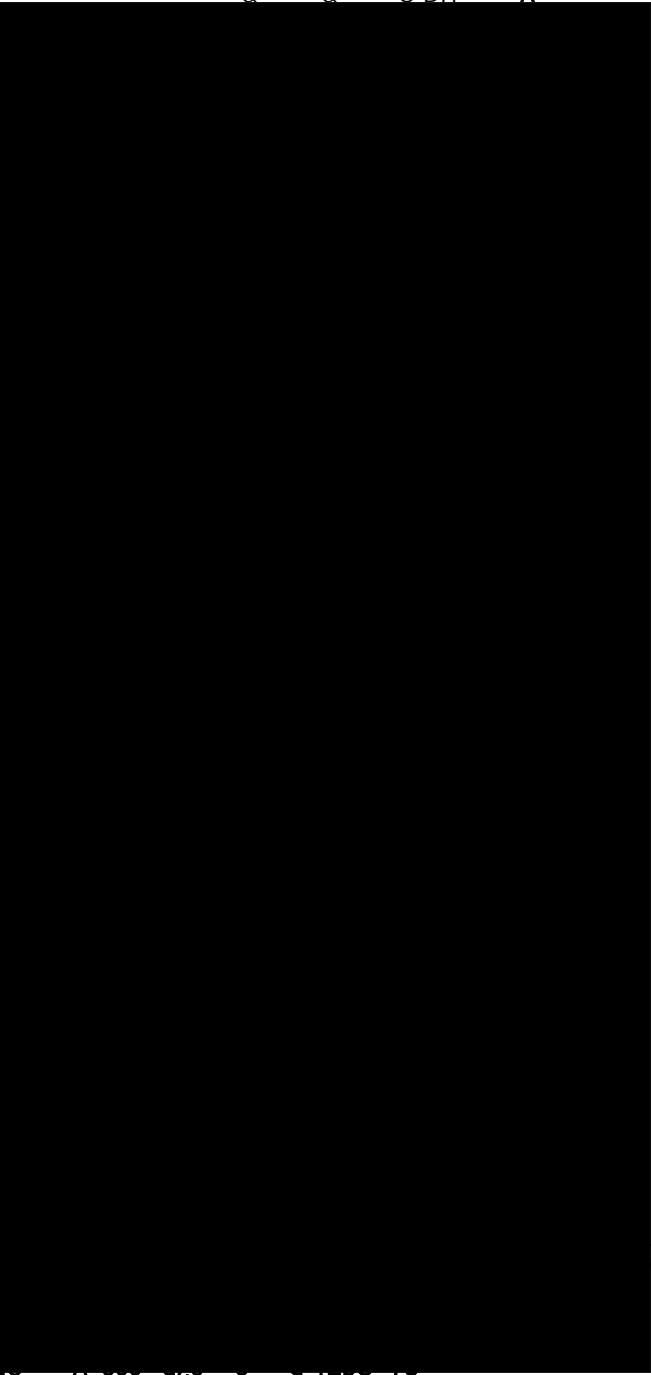
8<G7F

DHSZ (S1) (S2) (S3) (D)															
G%	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F
G&	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F
G	8-BH										7				
8	6CC@			M	A	G									

A' & v `H Ž0ò' Ÿ 7M~ & v b1àtäÁN 3

% ' & 8-BH
 &%(, ' *(,
 &%(, ' *(+'

& ' & 8-BH A -# "

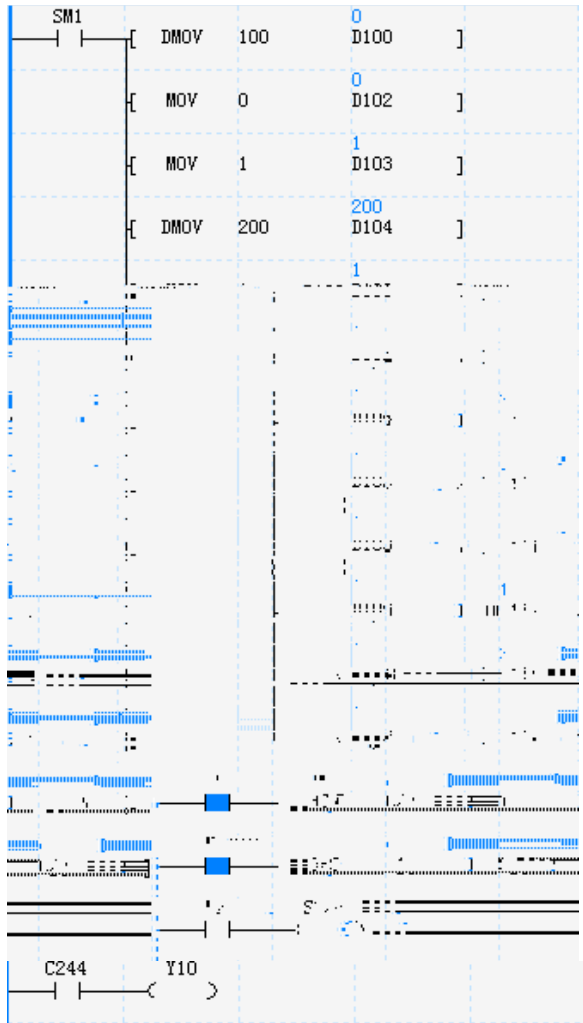


3 M

--- --- [DHST (S1) (S2) (S3)]																
G%	8-BH									8						F
G&	-BH															
G	8-BH											7				

8
 8
 M
 8
 % %&
 7& * 7&)-
 % <7BH * *
 C: : CB
 & 8<GD 8<GH
 8<GH 8<GD
 Y 8<GH 8<GD
 Y
 Y (D@7 8<G7G
 8<G7= 8<G7F 8<GN 8<GD 8<GH
 (#C
 Y 8<GH

8%\$\$1\$	8%\$%1%\$\$	8%\$\$&1\$	8%\$' 1%	%
8%\$(1\$	8%) 1&\$\$	8%\$* 1%	8%\$+1\$	&
8%\$, 1\$	8%\$- 1' \$\$	8%\$\$1&	8%\$\$1%	
8%\$\$1\$	8%\$' 1' \$\$	8%\$\$ 1'	8%\$\$ 1%	(%



```

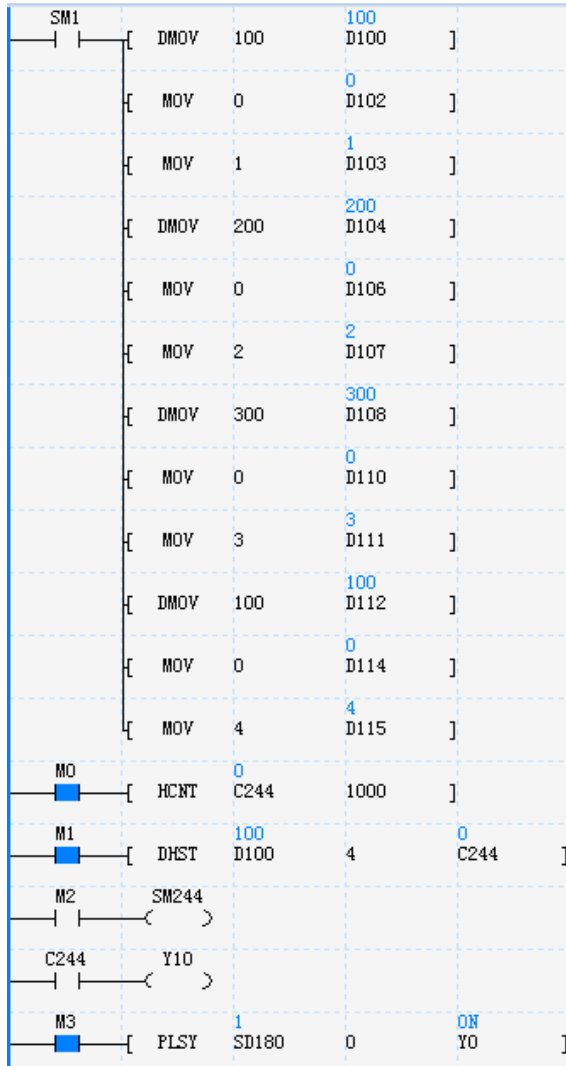
@8'''' GA %
8A CJ'' '$$' 8%$$
A CJ'' '$' 8%$$
A CJ'' '% ' 8%$
8A CJ'' '&$$' 8%$(
A CJ'' '% ' 8%$*
A CJ'' '$' 8%$+
8A CJ'' '$$' 8%$,
A CJ'' '&' 8%$$
A CJ'' '% ' 8%$$
8A CJ'' '$$' 8%$$&
A CJ'' '' '' 8%$(
A CJ'' '% ' 8%$$
@8'''' A $
<7BH'' 7&(' '$$$
@8'''' A %
8<GH'' 8%$$'' (' 7&((
@8'''' A &
CI H'' '' GA &((
@8'''' 7&((
CI H'' '' M%$
    
```

```

%
8%$$ 8%$$
& A $ L* CB 7&(( L$ C:: CB € 7&(( --- %$$$
7&(( %$$$ %$$$ 7&(( 7&(( M%$ M%$
' A % CB 8<GH % %
& %
GA %) G8%( G8%& G8%'
( A & CB GA &(( CB 7&(( A & C:: GA &(( C:: 7&((
) L* C:: 7&((
* A $ L* CB L& CB 7&(( $ 7&((
    
```

— — [DHSP (S1) (S2) (S3)]																			
G%	8-BH									8								F	
G&	-BH																		

8%\$1\$	8%\$%1%\$	8%\$&1\$	8%\$' 1%	%
8%\$(1\$	8%\$)1&\$	8%\$*1\$	8%\$+1&	&
8%\$, 1\$	8%\$-1' \$\$	8%\$%1\$	8%\$%d'	'
8%\$&1\$	8%\$' 1' \$\$	8%\$(1\$	8%\$)1((
				%



```

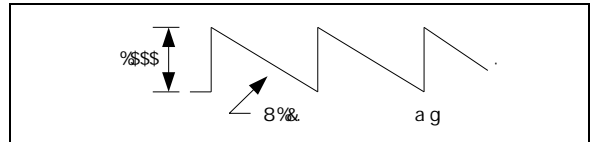
@8 ..... GA %
8A CJ ... %$ 8%$
A CJ ... $ 8%$&
A CJ ... % 8%$
8A CJ ... &$ 8%$(
A CJ ... $ 8%$*
A CJ ... & 8%$+
8A CJ ... $$ 8%$,
A CJ ... $ 8%$%
A CJ ... 8%$%
8A CJ ... %$ 8%$&
A CJ ... $ 8%$(
A CJ ... ( 8%$)
@8 ..... A $
<7BH ... 7&( ... %$
@8 ..... A %
8<GD ... 8%$ ( ... 7&(
@8 ..... A &
CI H ... GA &(
@8 ..... 7&(
CI H ... M$
@8 ..... A '
D@GM ... G8% $ ' M$
    
```

```

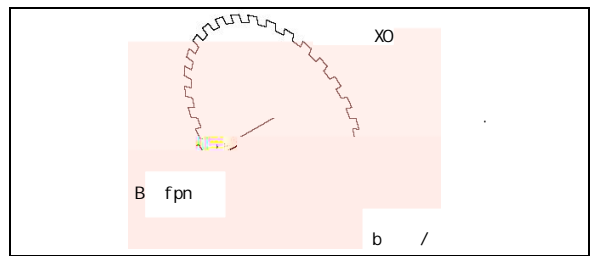
%                               8%$ 8%)
& A $ L*      CB  7&( L$ C:: CB      €                7&( --- %$$$
7&(          %$$$ %$$$ 7&(          7&(          M$ M$
'   A % CB    8<GD
&
      GA %)      G8%(          G8%& G8%'
          G8% $ G8% %
      G8% $ G8% %      $
(   A & CB    GA &( CB 7&(          A & C::   GA &( C:: 7&(
)   L* C::   7&(
*   A $ L*    CB      L& CB 7&(          $ 7&(
    
```

— — [SPD (S1) (S2) (D)]			
G%	6CC@	L	
G&	K CF8	? bL	? bM
8	K CF8		

L\$ L)
ag G&2\$
)'))



L\$ L) ag

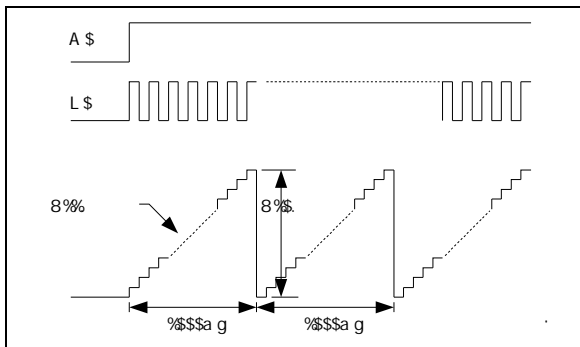


% GD8 <7BH
610 IO
& GD8 L\$ L)
' GD8 %<n %<n
(GD8

% A \$ CB L\$ \$\$\$a g
8% 8%
\$\$\$a g 8% \$\$\$a g
& 8%
' L\$ C:: CB \$\$\$a g
8%

SMD	PLSY	10000	0	ON
MO	SPD	XO	1000	D10

@8 GA \$
D@GM '\$\$\$\$ '\$ M\$
@8 A \$
GD8 L\$ '\$\$\$\$ 8%



* D@GM

DK A D@GF

[PLSY (S1) (S2) (D)] +									DK A D@GM D@GF						
G%	8-BH'		?bL'	?bM'	?bA'	?bG'	?b@A'	?bGA''	8<G8	G8<7B	7<D@GM	8<G7G	8<G7F	8<GN	8<GD
G&	8-BH'		?bL'	?bM'	?bA'	?bG'	?b@A'	?bGA''	8<G8	G8<7B	7<D@GM	J		F	
8'	6CC@			M											

<n
 A 7%\$\$ A 7&\$\$ % %\$\$\$\$ <n A 7&,\$
 % &\$\$\$\$ <n \$ %\$\$\$\$

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

D@G

\$ &%+(, '*(+

\$

A 7%\$\$ A 7&\$\$ M\$

M% A 7&,\$ M\$ M% M& M M(
 M) M* M+

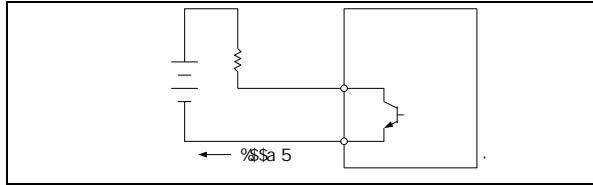
D@7

% D@7

& D@7

D@7

D@GM DK A D@GF



(C:: DK A D@GM
 D@GF

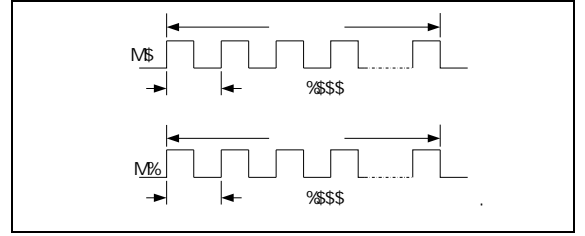
\$\$a 5

)

@B`A %

D@GM%\$\$\$%\$\$\$M%

D@GF %\$\$\$%\$\$\$M\$



% A % CB M\$ M% %\$\$\$

\$\$\$<n %\$\$\$

A \$ C:: CB

A \$ C:: C::

&)\$ CB)\$ C::

M

M\$

DCFH\$ M% DCFH%

' GA , \$ M\$ GA , % M%

%

(GA , & GA , ' M\$ M%

A \$ C::

) G8)\$ M\$ D@GM D@GF

G8)% M\$ D@GM D@GF

G8)& M% D@GM D@GF

G8)' M% D@GM D@GF

G8)(M\$ M% D@GM

D@GF

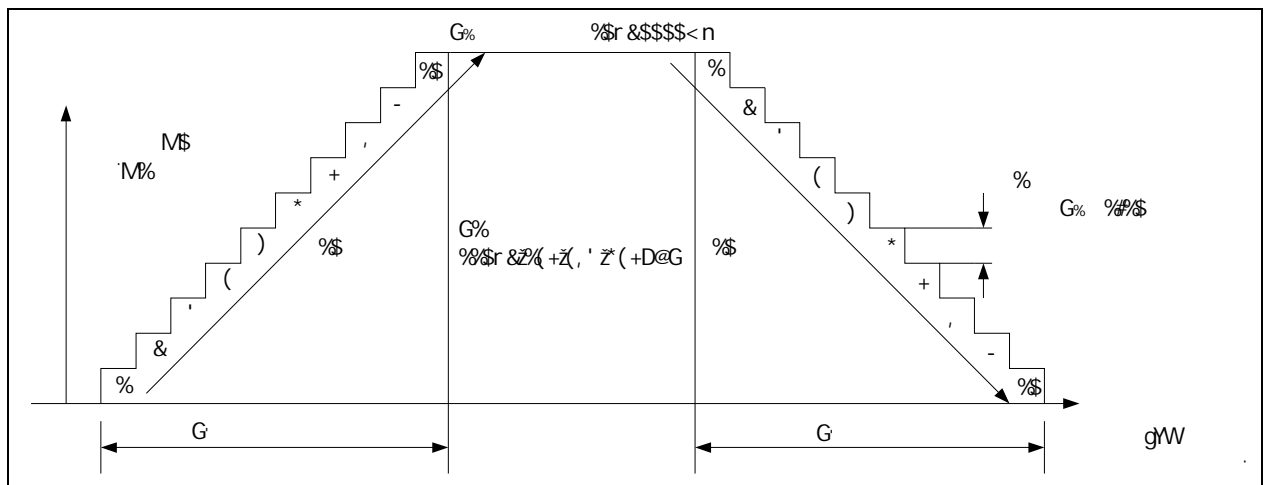
G8)) M\$ M% D@GM D@GF

* (G8)\$ (G8)) " 8A CJ 'x x x ' (G8)x "
 " A CJ 'x x x ' (G8)x "
 + D@GM
 8<GD

		PLSR	(S1)	(S2)	(S3)	(D)									
G%	K CF8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F
G	K CF8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8%	6CC@			M											



<n %\$ &\$\$\$\$ <n A 7%\$\$)\$ag
 &\$\$\$\$ &\$\$\$\$
 %\$ %\$ #/\$ %\$
 D@G %\$ A 7%\$\$ A 7&\$\$z
 M\$ M% A 7& \$z M\$ M% M& M
 M(M) M* M#
 a g
 x 0%\$\$\$\$ 1%\$\$\$\$#
 D@GF
 x 2G&x -\$- 1G&x -\$- #
 D@GF



% %\$ &\$\$\$<n

% A \$ CB

M\$ M%

%\$

A \$

C::

CB

A \$ C::

& D@7

C::

M\$ DCFH\$

&

M% DCFH%

A \$

CB C::

CB

' GA , \$ M\$

GA , %

M%

GA , \$ GA , % %

(& D@GF

(GA , & GA , '

M\$

M%

A \$ C::

GA , & GA , '

C::

DK A D@GM

GA , & GA , ' CB

) DK A D@GM D@GF

) G8)\$ G8))

* 8<G7G 8<G7F 8<GN 8<GD
8<GH <7BH D@GF

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

@8 ' ' A \$

D@GF ' '\$ ' '\$ ' '\$\$ ' M%

D@GF ' '\$ ' '\$ ' '\$\$ ' M\$

* G8)\$ G8))

8A CJ ' ' x x x ' G8) x

A CJ ' ' x x x ' G8) x

--- --- [PLS (S1) (S2) (D1)]															
G%	K CF 8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F
8%	6CC@			M											

8
\$ 8))
A 7%\$\$ A 7&\$\$
M\$ M% A 7& \$Z M\$ M% M& M
M(M) M* M+

%

D@G

&

\$
GA, \$ GA, %

(

8

A

D@GSG9H

b

& P
 F_{aU} F_{aJb} F_N B
 T_{down} T_{up}

$$P \frac{fF_N F_N \% \& fF_N F_N \% \& T_{up}}{\&\&\& fF_{aU} F_{aJb} \&}$$

$$P \frac{fF_N F_N \% \& fF_N F_N \% \& T_{down}}{\&\&\& fF_{aU} F_{aJb} \&}$$

F_{aJb}

$$P \frac{fF_{\%} F_{aJb} \& fF_{\%} F_{aJb} \& fV_{up} T_{down} \&}{\&\&\& fF_{aU} F_{aJb} \&}$$

$$P \frac{fF_M F_M \% \& fF_M F_M \% \& fV_{up} T_{down} \&}{\&\&\& fF_{aU} F_{aJb} \&}$$

.....

(D@7

)

%

D@G

DHC

D@G

* D@GMD@GF D@G

[]															
G%	K CF8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	K CF8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F
G(K CF8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8%	6CC@			M											

fa GL

\$ &\$\$\$<n

\$!%\$\$\$

<N

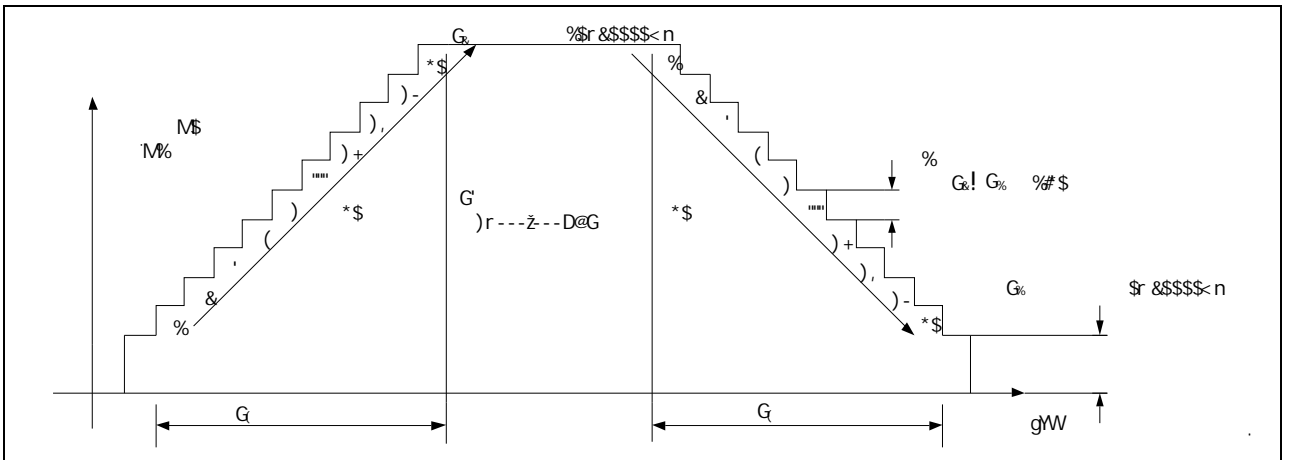
% &\$\$\$<n

A 7%\$ A 7&\$z M\$ M% A 7& \$z

M\$ M% M& M M(M) M* M+

fD@GL

)!-----



% %!&\$\$\$\$<n

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

&

@8 ' ' ' A \$

D@GF ' '\$\$ ' '\$\$\$\$ ' '\$\$\$\$ ' '\$\$\$ ' M%

D@GF ' '\$\$ ' '\$\$\$\$ ' '\$\$\$\$ ' '\$\$\$ ' M\$

% A \$ CB M\$ M%

\$\$\$\$ A \$ C::

CB A \$ C::

C::

&

A \$ CB C:: CB

(

' GA , \$ M\$ GA , % M%

GA , \$ GA , % %

)

fl t

(GA , & GA , ' M\$ M%

A \$ C:: GA , & GA , ' C::

GA , & GA , ' CB

*

& D@G6

M\$\$\$ M\$\$%

DK A D@GM

) G8)\$ G8))

+

DK A D@GM D@G6

, 8<G7G 8<G7F 8<GN 8<GD
8<GH <7BH D@G6

-

M\$ M%

* G8)\$ G8)) 8A CJ ' ' x x x ' ' G8) x

A CJ ' ' x x x ' ' G8) x

[PWM (S1) (S2) (D)]											
G%	=BH'		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7
G&	=BH'		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7
8	6CC@			M							

ag# g
\$ '&+*+ ag '&+*+

GA, (\$ GA, (%
μ g

ag
% '&+*+

GA, (\$ GA, (%
μ g

M% A 7%\$ - 7.8\$\$Z M\$

OK A 79I TM Y ó Y TM 3

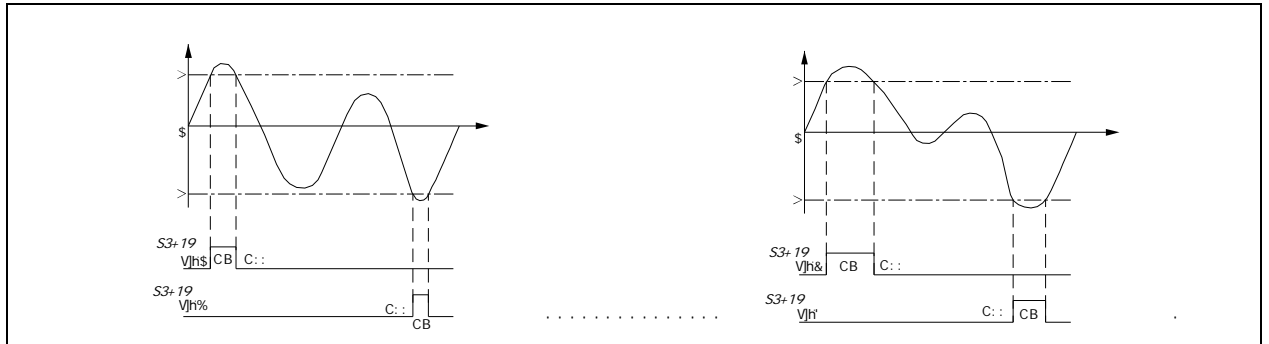
%É G% G%
% ! +

PID (S1) (S2) (S3) (D)															
G%	-BH									8					F
G&	-BH									8					F
G	-BH									8					F
8	-BH									8					F

6+H&1CB 6+H&1CB 6+H)1C:: D-8

D-8

D-8



- D-8

	$\Delta MV = KP \left\{ (EV_n - EV_{n-1}) + \frac{T_s}{T_i} EV_n + D_n \right\}$ $9J_b \quad DJ_{bz} \% \quad GJ$ $8_b \quad \frac{H_b}{H_c} \quad \frac{8}{s} \quad H_b \quad DJ_{bz} \quad DJ_{bz} \quad \& \quad DJ_{bz} \% \quad \frac{8}{H_c} \quad \frac{8}{s} \quad H_b \quad 8_b \%$ $A J_b \quad A J$
	$\Delta MV = KP \left\{ (EV_n - EV_{n-1}) + \frac{T_s}{T_i} EV_n + D_n \right\}$ $9J_b \quad GJ \quad DJ_{bz} \%$ $8_b \quad \frac{H_b}{H_c} \quad \frac{8}{s} \quad H_b \quad \& DJ_{bz} \% \quad DJ_{bz} \quad DJ_{bz} \quad \& \quad \frac{8}{H_c} \quad \frac{8}{s} \quad H_b \quad 8_b \%$ $A J_b \quad A J$

9J _b		8 _b	
9J _b %	%	8 _b %	%
GJ		? D	
DJ _{bz}		H _c	
DJ _{bz} %	%	H ₋	
DJ _{bz} &	&	H _s	
A J		8	
A J			

#D-8

@8 GA % #
 A C J %\$\$\$ 8)\$\$ #
 A C J)\$\$ 8)%\$ # Hg % '&+*+ ag
 #
 A C J + 8)%% #
 A C J +\$ 8)%& # \$ --O Q \$
 A C J %\$\$\$ 8)% " # ?d % '&+*+O Q
 A C J &) 8)%(" # H= \$ '&+*+ x %\$\$\$ ag \$
 #

```

A CJ    $    8)% "  #    ? 8    $ %$O Q    $
A CJ    *    8)% "  #    H8    $ ' &+*+ x %$a g    $
      #
: A CJ  $    8)%+ "  #    D-8
A CJ    &$ $$    8) & "  #    $ ' &+*+
A CJ    &$ $$    8) &* "  #    $ ' &+*+
A CJ    &$ $$    8) &+ "  #    $ ' &+*+
A CJ    &$ $$    8) & "  #    $ ' &+*+
#D-8
@8      A $    #    D-8
: FCA   $ )    8) $ %    %    #
D-8     8) $ $ 8) $ % 8) $ % 8) $ &    #D-8    D-8 G%G&G ' 8
HC      $    8) $ &    %    #D-8
      #    D-8
    
```

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

```

%
$ @8 GA $ ' ' A CJ $ 8| | | |
& D-8 &$
' HG % %a g
% HG D-8
( D-8 D-8
) D-8
* 6+H& 6+H) CB
6+H& 6+H) C::
+ D-8 D-8
% D-8
- D-8
D-8
    
```

L & 1CB

5#8

8#5

D-8

D-8

D-8

D-8

D-8

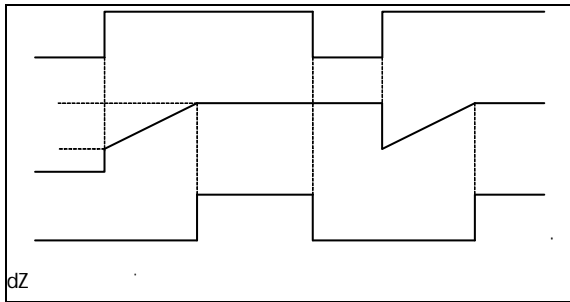
RAMP (S1) (S2) (D1) (S3) (D2)															
G%	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8%	=BH								8				J		F
G	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8&	6CC@			M	A	G	@A				7	H			

\$
\$

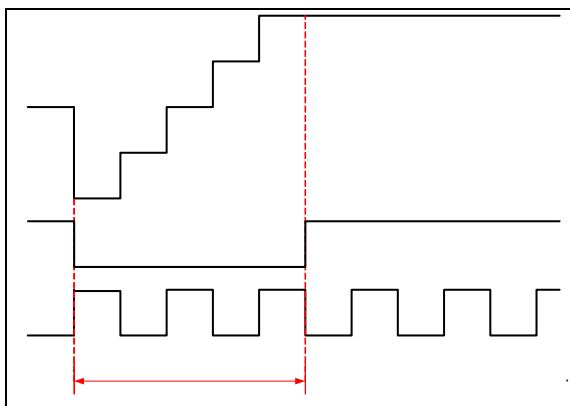
CB

CB

C: :



1)



%
&
' G%G& 8%G& 8&1CB
(F5A D <57?@9 HF =5B; @9
%\$\$
)"F5A D <57?@9 HF =5B; @9

@8 GA %
A CJ \$'8\$
A CJ &\$\$\$8%
#L \$1CB
@8 L \$
F5A D 8\$8%8%\$\$\$A \$
#L %1CB 85
@8 L %
HC \$*8%\$%

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

% L \$1CB 8%\$
8%\$18\$1\$ & &\$\$\$#\$\$\$ 8%\$18%&\$\$\$
8%\$ A \$1CB
C: :

8%\$18\$
&

HACKLE (S1) (S2) (D1) (D2) (D3)															
G%	-BH'		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H'	J'	N'	F'
G&	-BH'		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H'	J'	N'	F'
8%	-BH'								8				J'		F'
G	-BH'		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H'	J'	N'	F'
8&	6CC@			M	A	G	@A				7	H'			

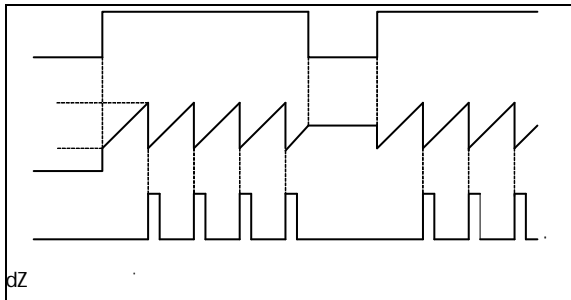
\$

CB

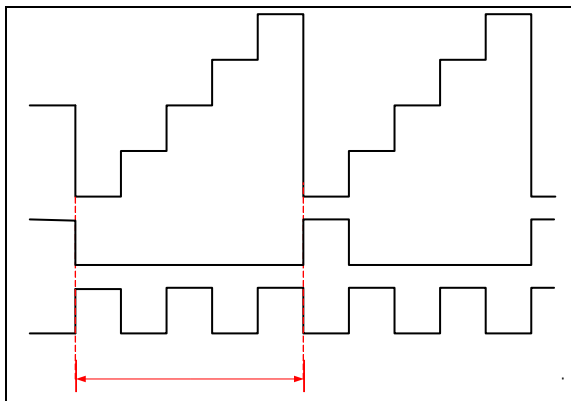
CB

C::

C::



1)



%

& 1 1 1CB
 F5AD <57? @9 HF-5B; @9
 %\$\$

##

@8 GA %

A CJ \$8\$

A CJ &\$\$\$8%

##L \$1CB

@8 L \$

<57? @9 8\$8%8%\$%\$\$\$A \$

##L %1CB

85

@8 L %

HC \$%8%\$%

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

% L \$1CB

8%

8%18\$1\$

& &\$\$\$#&\$\$\$

8%18%&\$\$\$

A \$1CB

L \$ CB

8%18\$1\$

A \$1C::

C::

&

[TRIANGLE (S1) (S2) (D1) (S3) (D2)]															
G%	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8%	=BH								8				J		F
G	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8&	6CC@			M	A	G	@A				7	H			

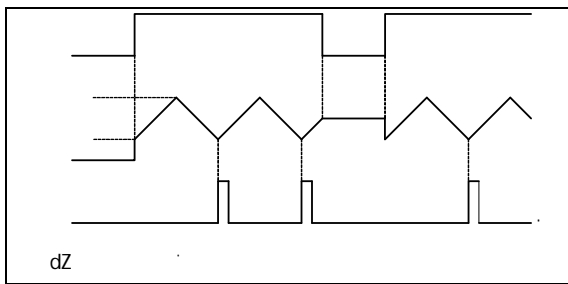
G \$

CB

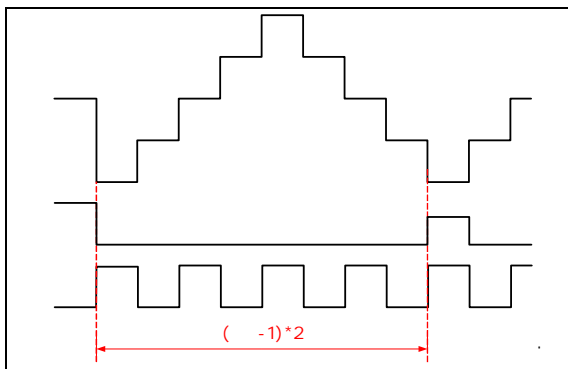
CB

C::

C::



1)



%
&
1 1 1CB
(1 % x &
) F5A D <57?@9 HF-5B; @9
%\$

@8 GA %
A CJ \$8\$
A CJ &\$\$\$8%
##L \$1CB
@8 L \$
HF-5B; @9 8\$8%8%\$%\$\$\$A \$
##L %1CB 85

@8 L %
HC \$%8%\$%

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

% L \$1CB 8%\$
8%\$18\$1\$ & &\$\$\$#\$\$\$ 8%\$18%&\$\$\$
8%\$ &
8%\$18\$1\$ A \$1CB
L \$ CB A \$1C::
C::

&

[ABSD]														
G%	-BH		? bL	? bM	? bA	? bG			8		7	H		F
G&	-BH										7			
8	6CC@			M	A	G								
G	K CF8													

b (

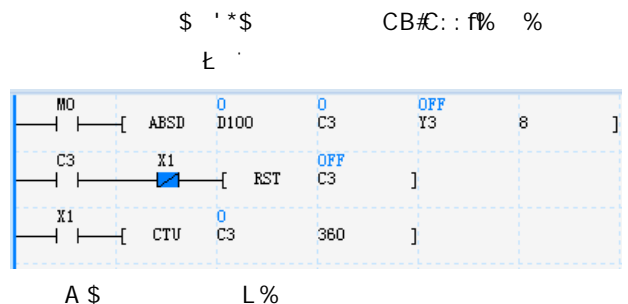
% *

% b fl b x & t

b CB#C::

& # bx &

G% G% &b %

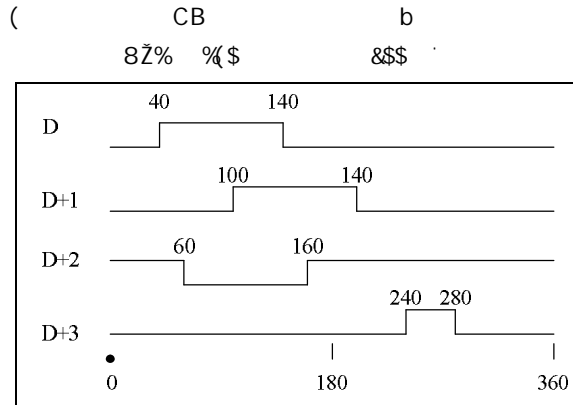


	(\$	Z%	% \$	
Z&	%% \$	Z'	&\$ \$	Z%
Z(% \$	Z)	* \$	Z&
Z*	&(\$	Z+	& \$	Z'
A	A	A	A	A
Z&b		Z&bZ%		Zb!%

%

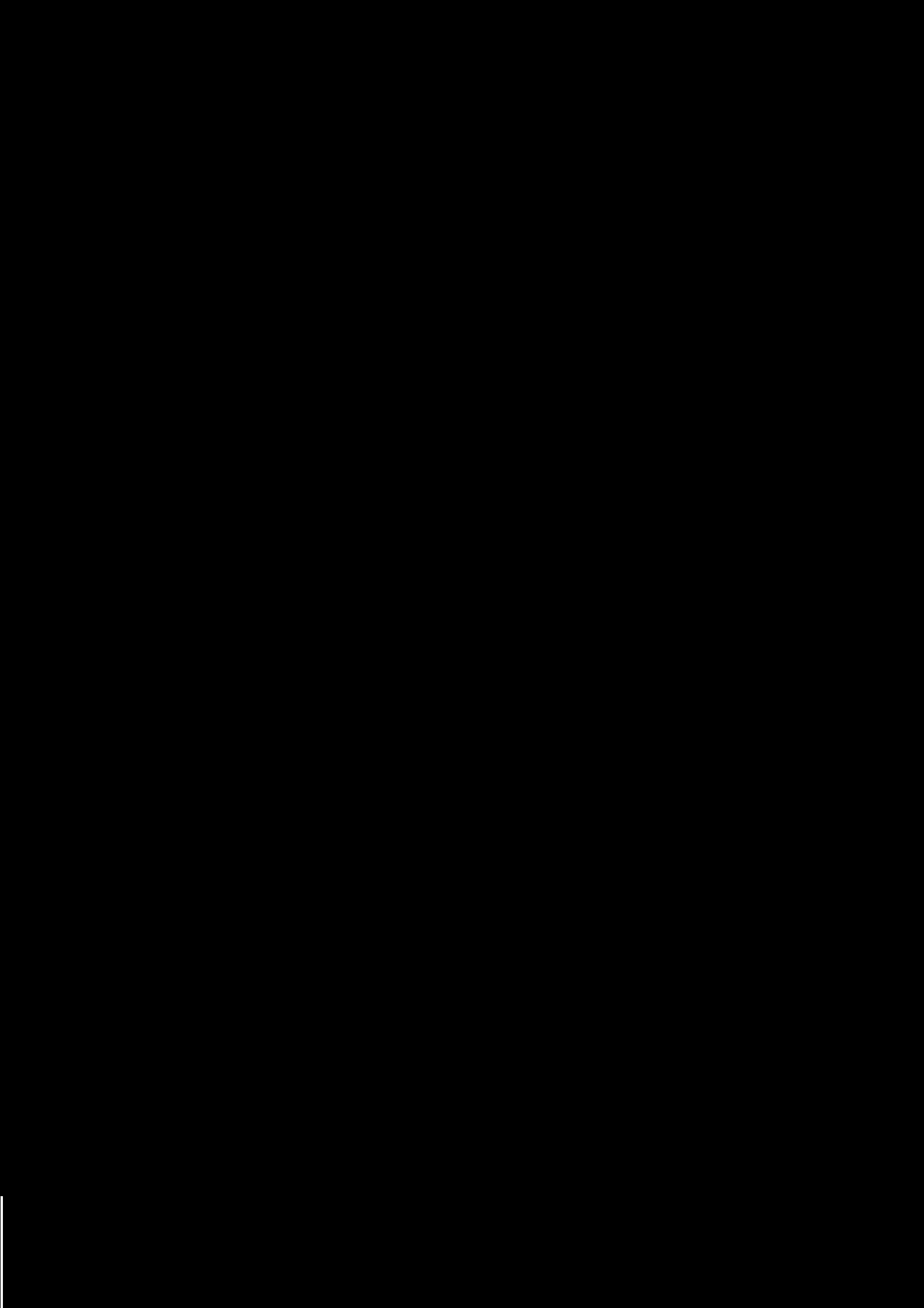
& - (

G& 7\$ 7%-

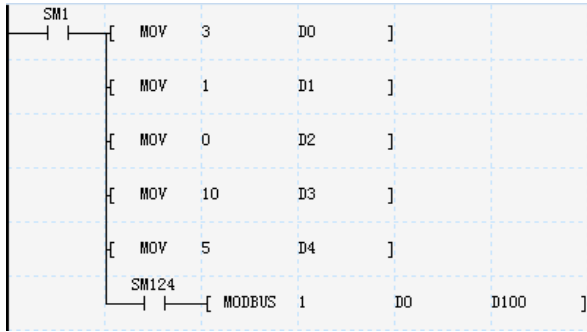


	7	H		F	
	7				





(



@8 GA %

A CJ 8\$

A CJ % 8%

A CJ \$ 8&

A CJ %\$ 8'

A CJ) 8(

5B8 GA %&(

A cXVi g%8\$8%\$\$

% A cXVi g 8\$

& 8%\$\$

' A cXVi g 7F7

GA % *

G8% -

(GA %& GA %&

A C86I G A C86I G

A cXVi g

\$! \$%	
\$! \$&	
\$! \$'	
\$! %\$	
\$! %&	
\$! %&	#
\$! %'	

|—| —|

]

T+ &\$ %\$ %\$\$\$ % %%(ms

T(T T %ms

T. ')ms

T. % *& ') %%(% %))**ms

%ag

T& fVNTf) ** % % % *\$ms

A 7%\$ D@7

A' A C8FK

A % A &

A

A C8FK

A C8FK

A &

A % A'

A C8FK

A C8FK

T% *& % % %%(' ' **ms

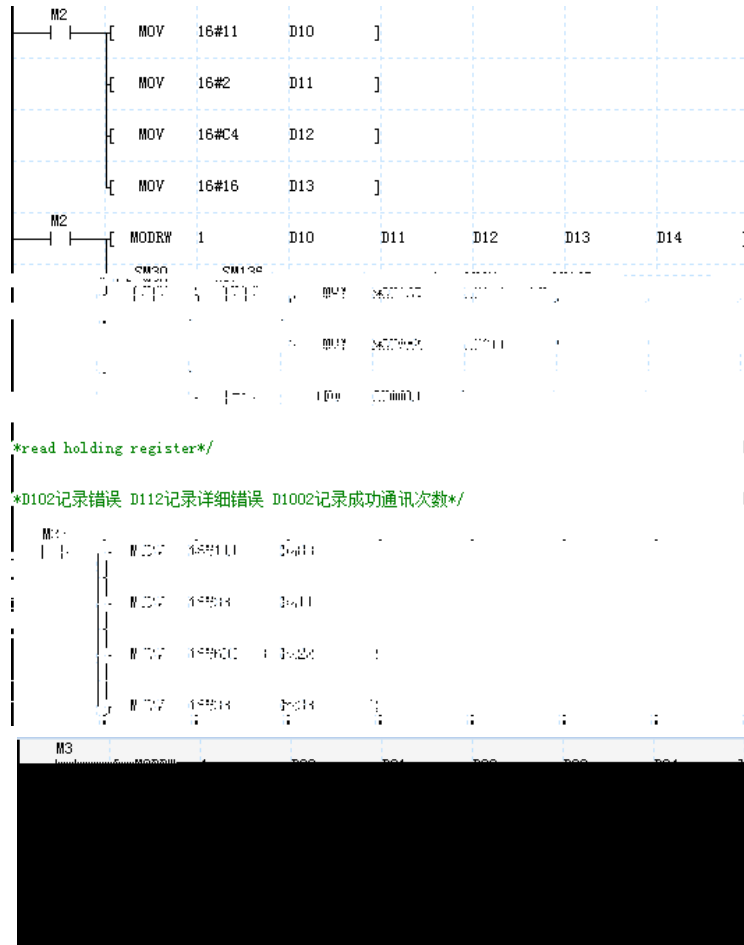
A &

A C8FK

```

/*使能M1,M2,M3实现MODBUS轮询示例,*/
/*01 Read Coil Status*/
/*D100纪录错 D110纪录详细错 D1001纪录成功通信次数*/
M1
|-----|-----[ MOV 16#11 D0 ]
|-----|-----[ MOV 16#1 D1 ]
|-----|-----[ MOV 16#13 D2 ]
|-----|-----[ MOV 16#25 D3 ]
M1
=====
S0.3
|-----|-----[ S0.3 ]
|-----|-----[ S0.3 ]
|-----|-----[ I0.3 ]
/*02 Read Input Status*/
.....
/*D100纪录错 D110纪录详细错 D1001纪录成功通信次数*/

```



GA '\$ A C8FK A C8FK GA %* G8% -
 A C8FK GA '\$ A C8FK G8% (GA %* G8% - G8% (
 GA '\$ & A C8FK
 GA '\$ GA %) A C8FK A C8FK
 A C8FK GA '\$ A C8FK
 A C8FK
 GA '\$ A C8FK
 GA '\$

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		

& A 7%\$\$ A J *\$\$

H\$

A 7%\$\$

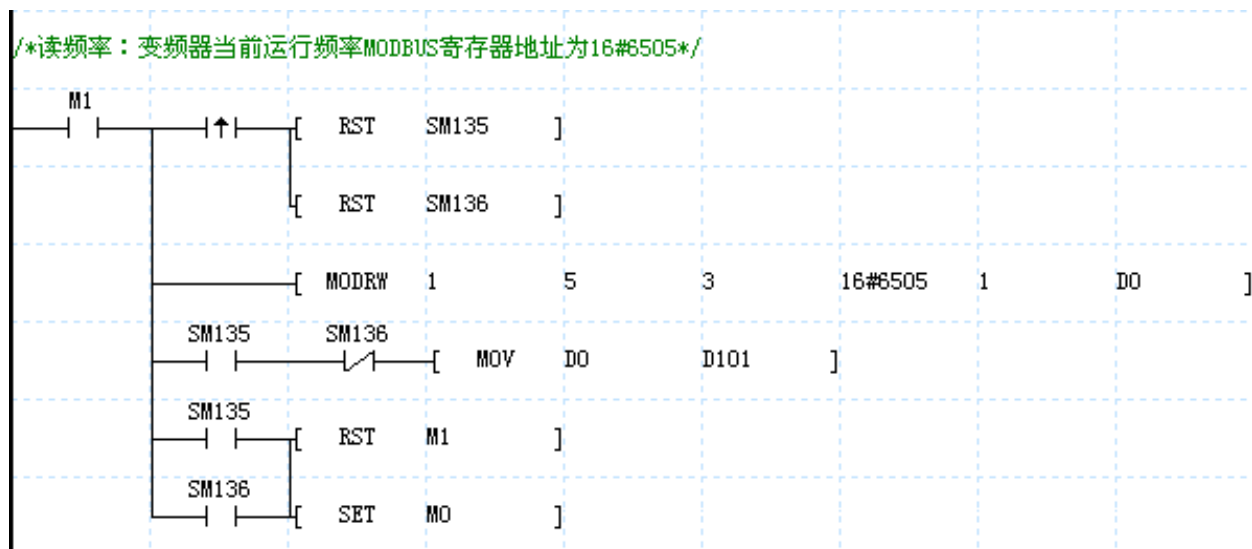
A J *\$\$

GA %)

H\$

GA % *





M90																
[MODLINK 1 D200 D46 M114 M156]																
G%	-BH'															
G&	-BH'	8'														
G	-BH'	8'														
G(6CC@			A	G					7	H'					
G)	6CC@			A	G					7	H'					

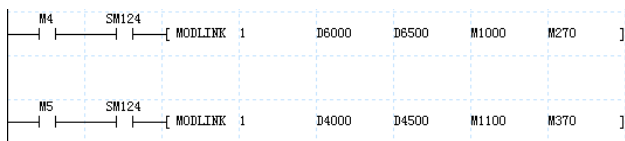
%

A C8@B? A C86I G
 A C8@B? A C8@B? -
 A C8@B?
 A C8@B? A C86I G
 A C8@B?



8*\$\$\$

G&		
G&Z%	A	\$
G&Z&		
G&Z'		
G&Z(
G&Z)		
G&Z*		
G&Z+		
G&Z,		
G&Z-		
G&Z%\$		
G&Z%%		
G&Z%&		
G&Z%'		
G&Z%(
G&Z)%		
A		
A		



GA %&(

			8
\$%		% &\$\$\$	G) % #%
\$&		% &\$\$\$	G) % #%
\$'		% %&)	G)
\$(% %&)	G)
\$)		\$fZl YXL	%
\$*		\$fZl YXL	%
%		% % *	G) % #%
%'		% %&)	G)

A C8@B?

A C86I G

\$ B

G

G'	\$
G'Z%	%
G'Z&	&
A	
A	
G'ZB	B

G

A cXVi g

\$I \$%	
\$I \$&	
\$I \$'	
\$I %\$	
\$I %&	
\$I %'	
\$I %&(#
\$I %)	

G'	\$
G'Z%	%
G'Z&	&
A	
A	
G'ZB	B

— — [XMT (S1) (S2) (S3)]			
G%	BH		
G&	K CF8		

[RCV (S1) (D) (S2)]														
G%	=BH													
8	K CF8	8	J											F
G&	=BH		?bL	?bM	?bA	?bG	?b@A		8	G8	7	H	J	N F



\$ %

GA %% GA %%

F7J

3

o

1

%

8

J

8+---

J**

&

3

\$ %

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

@8 GA %

F7J % 8&\$)

@8 GA %&

=B7 8%\$\$

%

F7J

GA %

--- --- [CRC16 (S1) (S2) (D)]															
G%	K CF8								8				J		F
G&	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8	K CF8								8				J		F

\$

%

7F7%

& 7F7%

LR% %

LR% LR%

%

&

8

3

16

SM1	[MOV	16#0	0	D0]	
	[MOV	16#11	17	D1]	
	[MOV	16#22	34	D2]	@8 GA %
	[MOV	16#33	51	D3]	A CJ % \$ \$ 8%
	[MOV	16#44	68	D4]	A CJ % % 8%
	[MOV	16#55	85	D5]	A CJ % & & 8%
	[MOV	16#66	102	D6]	A CJ % ' ' 8'
	[MOV	16#77	119	D7]	A CJ % ((' 8 (
	[MOV	0	57708	D100]	A CJ %)) ' 8'
	[MOV	0	57708	D100]	A CJ % * * * 8 *
	[MOV	0	57708	D100]	A CJ % + + ' 8 +
	[MOV	0	57708	D100]	@8 L \$
	[MOV	0	57708	D100]	A CJ \$ ' ' 8 \$ \$
	[MOV	0	57708	D100]	7F7% ' 8 \$, ' 8 \$ \$ \$
	[CRC16	D0	8	D100]	

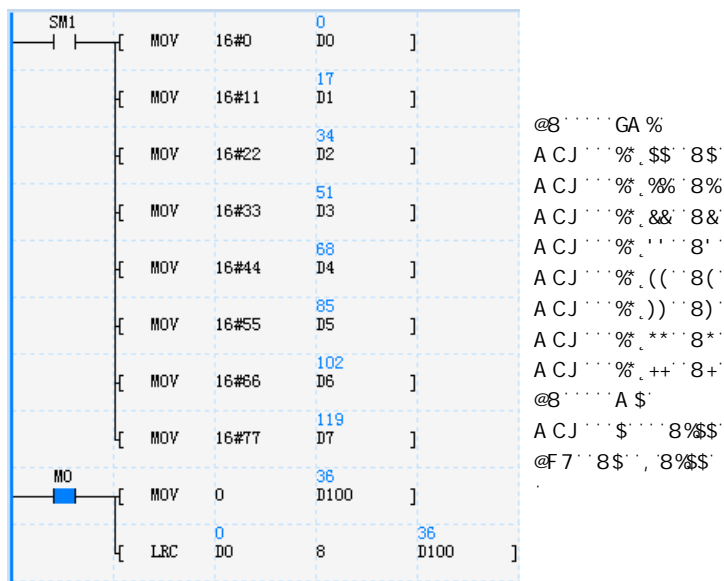
L \$1CB 8\$ 7F7%

8%\$

--- --- [LRC (S1) (S2) (D)]															
G%	K CF8								8				J		F
G&	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8	K CF8								8				J		F

\$
@F7
%
&

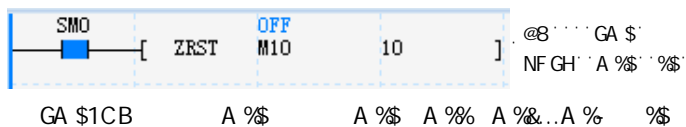
8



L \$1CB 8\$, @F7
8%\$ \$

--- --- [ZRST (D) (S)]															
8	6CC@			M	A	G	@A				7	H			
G	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F

% 7 7
& H H



[ZSET (D) (S)]																
8	6CC@			M	A	G	@A				7	H				
G	=BH		?bL	?bM	?bA	?bG	?b@A	?bGA	8	G8	7	H	J	N	F	

SMD [ZSET ON M10 10]
@8 GA \$ NG9H A % \$

GA \$1CB A %\$ A %\$ A %% A %&...A % %\$
 %

%

[DECO (S) (D)]																
G	K CF8		?bL	?bM	?bA	?bG	?b@A	?bGA	8	G8	7	H	J	N	F	
8	=BH			?bM	?bA	?bG	?b@A	?bGA	8	G8	7	H	J	N	F	

- 1 \$ %
- 2 % \$

SMD [DECO 2 4 D9]
@8 GA \$ 8A 7C & 8-

8- & %

— — [ENCO (S) (D)]															
G	≠BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8	≠BH		? bM	? bA	? bG	? b@A			8	G8	7	H	J	N	F

----- ----- [BON (S1) (D) (S2)]															
G%	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		
8	6CC@		M	A	G										
G&	=BH								8				J		F

M1 [BON 32 DO ON YO 5] @8 A %
6CB 8\$M\$)

G& 6CB 8\$) fCBŁ 8 fM\$Ł

----- ----- BLD (S1) (S2) -----)															
G%	K CF8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F

| BLD 1000 DO 5 |-----| YO) 6@8 .. 8\$)
CI H M\$

8\$ %\$\$\$ & \$\$\$\$\$%0000%\$%\$\$\$ 6+) CB
M\$

----- BLDI (S1) (S2) -()															
G%	K CF8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F

\$ %

| BLDI DO 1000 5 |-(Y0)

6@8= 8\$)

8\$ %\$\$\$ & \$\$\$\$\$%0000\$%\$\$\$ 6+)
CB

C::
M\$

----- BLD (S1) (S2) -()															
6@8 65B8															
G%	K CF8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F

\$ %

| BLDI DO 1000 5 |-(Y0)

@8 L\$

DO %\$\$\$ & \$\$\$\$\$%0000\$%\$\$\$ 6+)
CB
L \$1CB

M\$

<p>6@8=</p>															
<p>65B=</p>															
G%	K CF 8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F

\$ %

8\$ %\$\$\$ & \$\$\$\$\$%0000\$%\$\$\$ 6#) CB C::

L\$1CB M\$

@8 L\$
65B= 8\$)
CI H M\$

<p>6@8</p>															
<p>6CF</p>															
G%	K CF 8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F

\$ %

8\$ %\$\$\$ & \$\$\$\$\$%0000\$%\$\$\$ 6#) CB

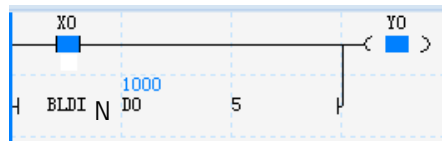
L\$1CB M\$

@8 L\$
6CF 8\$)
CI H M\$

6@8=															
G%	K CF 8		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F

7 6 5 4 3 2 1 0

5



@8 L\$
6CF= 8\$)
CI H M\$

8\$ %\$\$\$ & \$\$\$\$\$%\$\$\$ 6-\$

CB

C: :

S

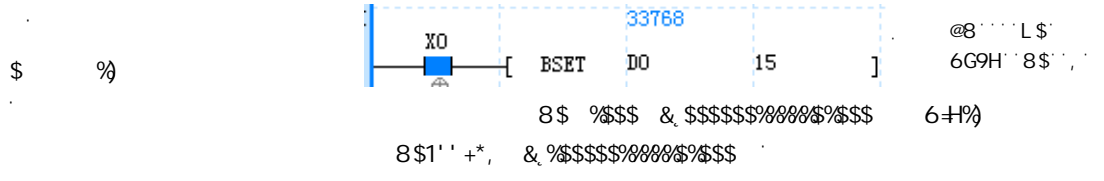
L \$1CB

M\$

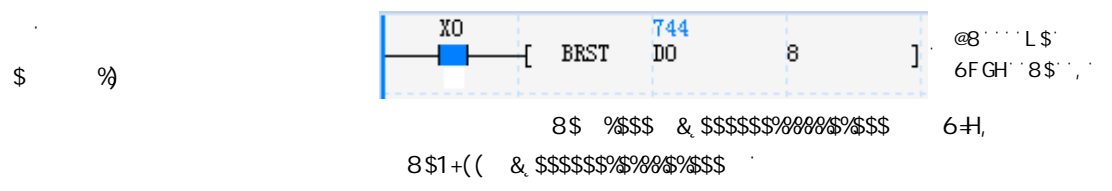
â€º>9 TMö TM€ 4TM%

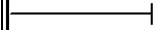



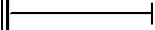

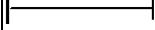

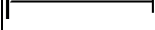

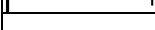

8	K CF 8			? bM	? bA	? bG	? b@A		8		7	H	J	N	F
G	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F

[BSET (D) (S)]															
8	K CF8			? bM	? bA	? bG	? b@A		8		7	H	J	N	F
G	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F









[BRST (D) (S)]															
8	K CF8			? bM	? bA	? bG	? b@A		8		7	H	J	N	F
G	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F



	=	(S1)	(S2)	)											
	<	(S1)	(S2)	)											
	>	(S1)	(S2)	)											
	◇	(S1)	(S2)	)											
	>=	(S1)	(S2)	)											
	<=	(S1)	(S2)	)											
G%	-BH'		? bL'	? bM'	? bA'	? bG'	? b@A'	? bGA'	8'	G8'	7'	H'	J'	N'	F'	
G&	-BH'		? bL'	? bM'	? bA'	? bG'	? b@A'	? bGA'	8'	G8'	7'	H'	J'	N'	F'	

%
&

6-B

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

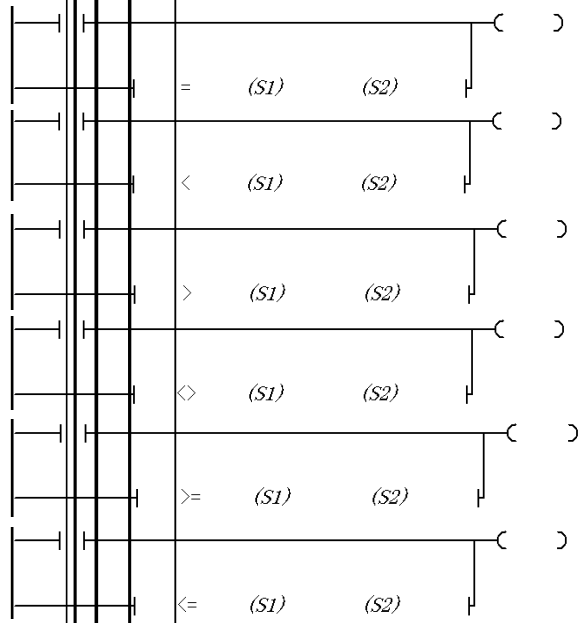
8\$ 8%

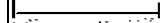



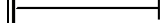



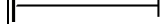



6-B

@81'' 8\$8%
 CI H'' M\$
 @80'' 8\$8%
 CI H'' M%
 @82'' 8\$8%
 CI H'' &
 @802'' 8\$8%
 CI H'' M''
 @821'' 8\$8%
 CI H'' M(
 @801'' 8\$8%
 CI H'' M)

$\text{---} \text{---} = (S1) (S2) \text{---} \text{---}$		
$\text{---} \text{---} < (S1) (S2) \text{---} \text{---}$		
$\text{---} \text{---} > (S1) (S2) \text{---} \text{---}$		
$\text{---} \text{---} \diamond (S1) (S2) \text{---} \text{---}$		
$\text{---} \text{---} \geq (S1) (S2) \text{---} \text{---}$		
$\text{---} \text{---} \leq (S1) (S2) \text{---} \text{---}$		

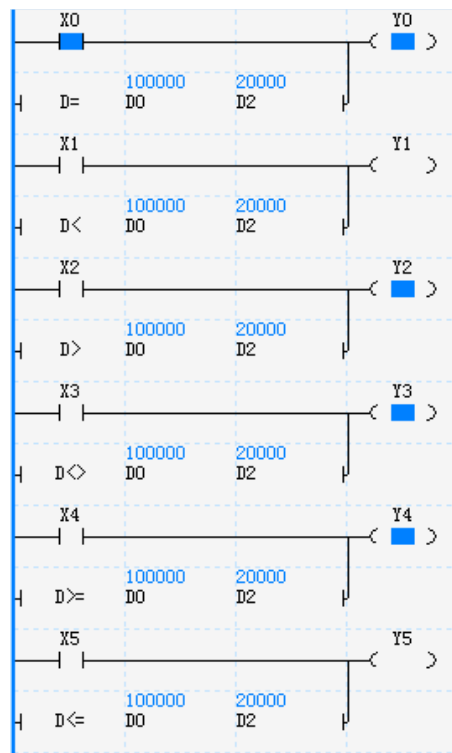
G% -BH5 ?bL ?bM ?bA ?bG 3



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

G%	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F			
G&	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F			

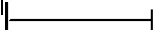

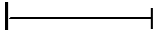

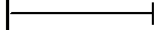







%
&



```

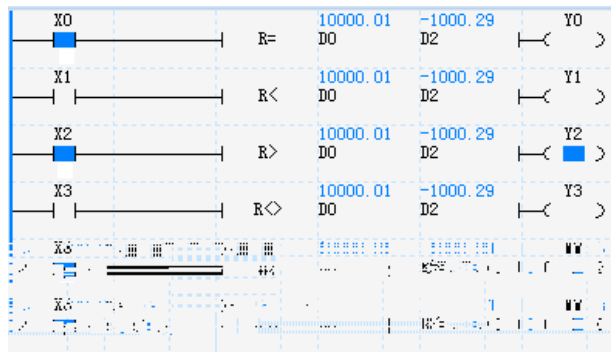
@8 ..... L$
CF81 ..... 8$8&
CI H ..... M$
@8 ..... L%
CF80 ..... 8$8&
CI H ..... M%
@8 ..... L&
CF802 ..... 8$8&
CI H ..... M&
@8 ..... L'
CF821 ..... 8$8&
CI H ..... M'
@8 ..... L(
CF821 ..... 8$8&
CI H ..... M(
@8 ..... L)
CF801 ..... 8$8&
CI H ..... M)
    
```

8\$8% 8&8'

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

		R=	(S1)	(S2)	HC)		
		R<	(S1)	(S2)	HC)		
		R>	(S1)	(S2)	HC)		
		R<>	(S1)	(S2)	HC)		
		R>=	(S1)	(S2)	HC)		
		R<=	(S1)	(S2)	HC)		
G%	F95@						8	J F
G&	F95@						8	J F

%
&

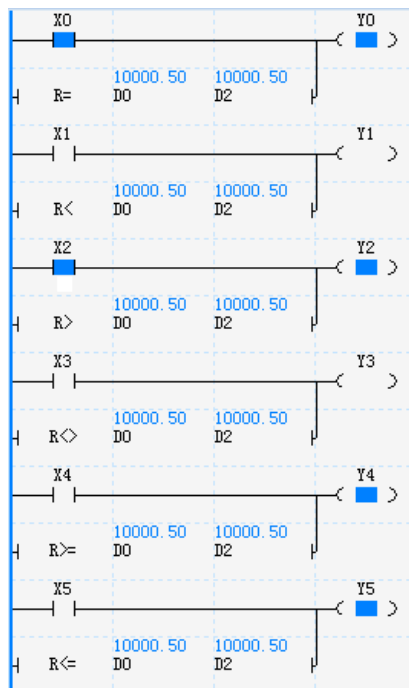


@8 L\$
5B8F1' 8\$8&
CI H' M\$
@8 L%
5B8F0' 8\$8&
CI H' M%
@8 L&
5B8F02' 8\$8&
CI H' M&
@8
5B8F02' M
@8 L(
5B8F21' 8\$8&
CI H' M
@8 L)
5B8F01' 8\$8&
CI H' M)

8\$8% 8&8'

G%	F 95@		
G&	F 95@		

%
&

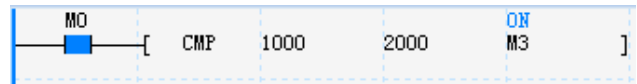


@8 L\$
 CFF1 8\$8&
 CI H M\$
 @8 L%
 CFF0 8\$8&
 CI H M%
 @8 L&
 CFF2 8\$8&
 CI H M&
 @8 L'
 CFF02 8\$8&
 CI H M'
 @8 L(
 CFF21 8\$8&
 CI H M(
 @8 L)
 CFF01 8\$8&
 CI H M)

8\$8% 8&8'

[CMP]															
G%	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
G&	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	N	F
8	6CC@			M	A	G									

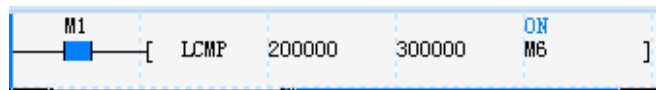
Ž% Ž& CB



[]															
G%	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J	N	F
G&	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J	N	F
8	6CC@			M	A	G									

Ž% Ž& CB

%
&



[RCP]																
G%	F 95@									8					F	
G&	F 95@									8					F	
8	6CC@			M	A											

----- ----- [BKSUB (S1) (S2) (D) (S3)]															
BKSUB															
G%	=BH'	8'	G8'	7'	H'	J'	F'
G&	=BH'	8'	G8'	7'	H'	J'	F'
8'	=BH'	8'	G8'	7'	H'	J'	F'
G'	=BH'	8'	.	.	.	J'	F'

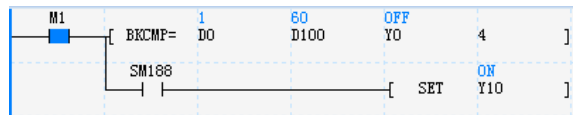
ON

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

% S2 S3 16 S1 s3 16 A %CB 8%\$) 8%\$\$
)
 8%\$\$\$) 8%\$\$\$18%18%\$\$
 & S2 16 , S2 8%\$\$\$18%18%\$% 8%\$\$ (18%18%\$(
 S1 s3 16 S2
 D S3

<p>[BKCMP= (S1) (S2) (D) (S3)]</p> <p>[BKCMP< (S1) (S2) (D) (S3)]</p> <p>[BKCMP> (S1) (S2) (D) (S3)]</p> <p>[BKCMP<= (S1) (S2) (D) (S3)]</p> <p>[BKCMP>= (S1) (S2) (D) (S3)]</p>			
BKMP			
G%	-BH'		
G&	-BH'		
8'	6CC@	M	A G @A GA
G'	-BH'		

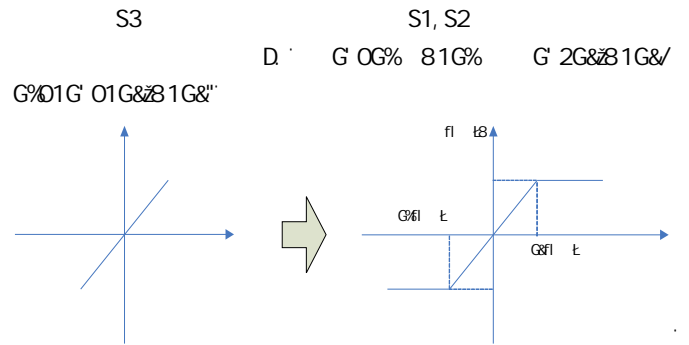
ON



% S1 S3 16 S2 S3
 16 (BIN) D
 S3
 & G% % ZG%
 G% G& g %
 8 G
 8 G CB
 GA %,

@8 A %
 6? 7A D1 8% 8%\$ M\$ (
 @8 GA %, ,
 G9HM\$
 A %CB 8%\$ (8%\$
 (M\$
 (CB M\$
 CB

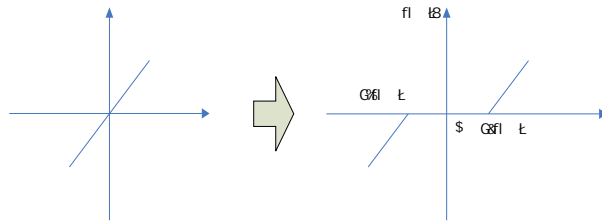
LIMIT (S1) (S2) (S3) (D)															
G%	BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	F	
G&	BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	F	
G	BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H	J	F	
8	BH			? bM	? bA	? bG	? b@A		8	G8	7	H	J	F	



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

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

[DBAND (S1) (S2) (S3) (D)]														
G%	-BH'		? bL'	? bM'	? bA'	? bG'	? b@A'	? bGA'	8'	G8'	7'	H'	J'	F'
G&	-BH'		? bL'	? bM'	? bA'	? bG'	? b@A'	? bGA'	8'	G8'	7'	H'	J'	F'
G'	-BH'		? bL'	? bM'	? bA'	? bG'	? b@A'	? bGA'	8'	G8'	7'	H'	J'	F'
8'	-BH'			? bM'	? bA'	? bG'	? b@A'		8'	G8'	7'	H'	J'	F'



M1				
	-100	100	30	0
	D0	D10	D100	D1000

S3

S1, S2

D' G OG% 81G' IG%
G 2G&81G' !G&/ G%01G' 01G&81\$"

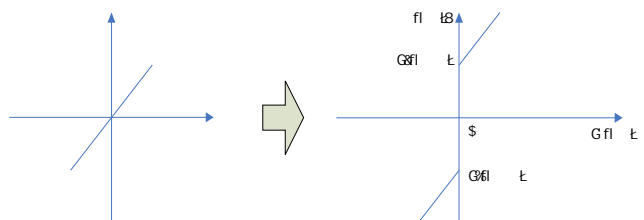
M=CN D100 D0-D10
D1000 D0 (-100) <D100(30) <D10(100), D1000=0,

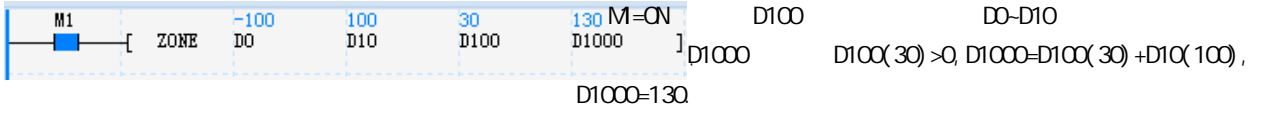
[ZONE (S1) (S2) (S3) (D)]														
G%	-BH'		? bL'	? bM'	? bA'	? bG'	? b@A'	? bGA'	8'	G8'	7'	H'	J'	F'
G&	-BH'		? bL'	? bM'	? bA'	? bG'	? b@A'	? bGA'	8'	G8'	7'	H'	J'	F'
G'	-BH'		? bL'	? bM'	? bA'	? bG'	? b@A'	? bGA'	8'	G8'	7'	H'	J'	F'
8'	-BH'			? bM'	? bA'	? bG'	? b@A'		8'	G8'	7'	H'	J'	F'

S3

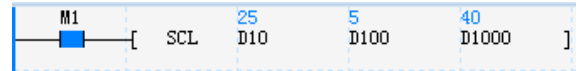
S1 S2

D S3<0 D=S3+S1 S3>0 D=S3+S2 S3=0, D=0





SCL										(S1)	(S2)	(D)				
G%	-BH'		? bL	? bM	? bA	? bG	? b@A	? bGA	8'	G8'	7'	H'	J'	F'		
G&	-BH'								8'				J'	F'		
8'	-BH'			? bM	? bA	? bG	? b@A		8'	G8'	7'	H'	J'	F'		



% G%

8

& G&

%

A %CB 8%

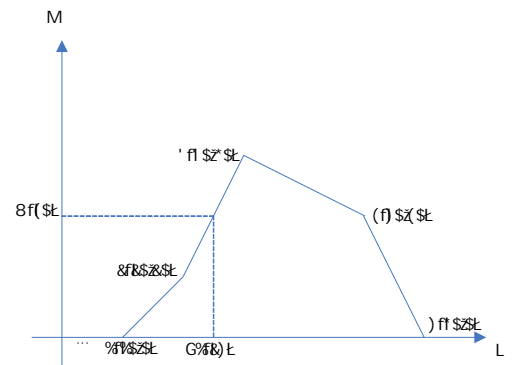
8%\$\$\$

%	L	G&Z%
	M	G&Z&
&	L	G&Z'
	M	G&Z(
A	A	A
bfl t'	L	G&Z &b1%
	m	G&Z &b'

%	L	8%\$\$	%\$
	M	8%\$\$	\$
&	L	8%\$	&\$
	M	8%(\$	&\$
...	L	8%\$)	' \$
	m	8%\$*	*\$
(L	8%\$+)\$
	m	8%\$,	(\$
)	L	8%\$-	*\$
	m	8%\$\$	\$

% L

& G%




----- ----- [SER (S1) (S2) (D) (S3)]			
G%	-BH		? bL ? bM ? bA ? bG ? b@A ? bGA 8 G8 7 H J F
G&	-BH		? bL ? bM ? bA ? bG ? b@A ? bGA 8 G8 7 H J F
8	-BH		? bM ? bA ? bG ? b@A 8 G8 7 H J F
G	-BH		8 J F

y M

%) (0 1 2 3 4 5 6 7 8 9 A B C D E F G H I J K L M N O P Q R S T U V W X Y Z [\] ^ _ ` a b c d e f g h i j k l m n o p q r s t u v w x y z { | } ~ 8dSV60
 Ž! 5 Tmāay i Ÿ Tm tE5h / 0

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STRIGHT														
G%	=BH'		? bL'	? bM'	? bA'	? bG'	? b@A'	? bGA'	8'	G8'	7'	H'	J'	F'
8'	=BH'			? bM'	? bA'	? bG'	? b@A'		8'	G8'	7'	H'	J'	F'
G&	=BH'								8'				J'	F'

% G% '\$\$<'

& G& \$
' G& G%

% G%
' \$\$<'

G& 8
& G& 8
" \$\$<"

M1	12849	13363	
[STRIGHT	D10	D100
			3
]			

A %!CB 8%\$
8%\$\$

6%!!!V, V+!!!V\$

8%\$	\$' &	\$' %
8%\$	\$' (\$' ''
8%\$	\$' *	\$')
8%	\$' \$\$	\$' \$\$



6%!!!V, V+!!!V\$

8%\$\$	\$')	\$' (
8%\$%	\$' \$	\$' *

' \$\$\$<'

(

' \$\$<'

----- ----- [STRLEFT (S1) (D) (S2)]			
G%	-BH		? bL ? bM ? bA ? bG ? b@A ? bGA 8 G8 7 H J F
8	-BH		? bM ? bA ? bG ? b@A 8 G8 7 H J F
G&	-BH		J F

%

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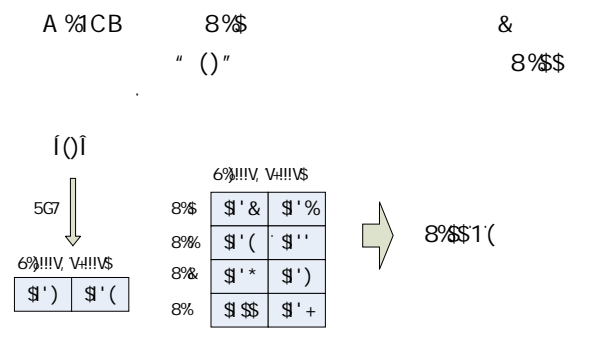
----- ----- [STRMIDR (S1) (D) (S2)]															
G%	-BH'		? bL'	? bM'	? bA'	? bG'	? b@A'	? bGA'	8'	G8'	7'	H'	J'	F'	
8'	-BH'			? bM'	? bA'	? bG'	? b@A'		8'	G8'	7'	H'	J'	F'	

----- ----- [STRINSTR (S1) (S2) (D) (S3)]															
G%	=BH'									8'	G8'	7'	H'	J'	F'
G&	=BH'									8'	G8'	7'	H'	J'	F'
8'	=BH'									8'	G8'	7'	H'	J'	F'
G'	=BH'									8'				J'	F'

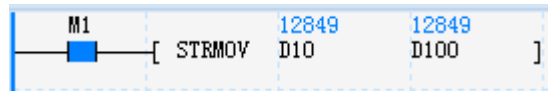
& G' G&
 ' G% ' & z
 (G% '\$\$<' G&
 '\$\$<' G&
 '\$\$<'

% G& G'
 G%
 & 8
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 G " \$"
 ('\$\$<'

M1	[STRINSTR "45"	12849	4
		D10	D100
			2



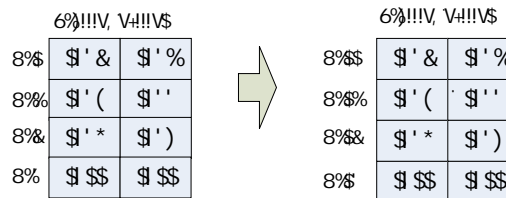
----- ----- [STRMOV (S) (D)]															
G	-BH		?bL	?bM	?bA	?bG	?b@A	?bGA	8	G8	7	H	J	F	
8	-BH			?bM	?bA	?bG	?b@A		8	G8	7	H	J	F	



% G ' \$\$<' /

A %CB 8\$ 8%%\$

& ' \$\$<'



% G ' \$\$<' " " ' \$\$<' & G 8 ' \$\$<' ' G% ' & z

(11) (11) (11) (11) (11) (11) (11) (11) (11) (11)													
G%	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	J	F
G&	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	J	F
G	6CC@		L	M	A	G							
8%	6CC@			M									

$F_{a} bS_{acc}$

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8C; CB

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D@7

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$$F_{a} bS_{acc} \sqrt{\frac{F_{au}}{T}} \text{) } \$\$$$

9

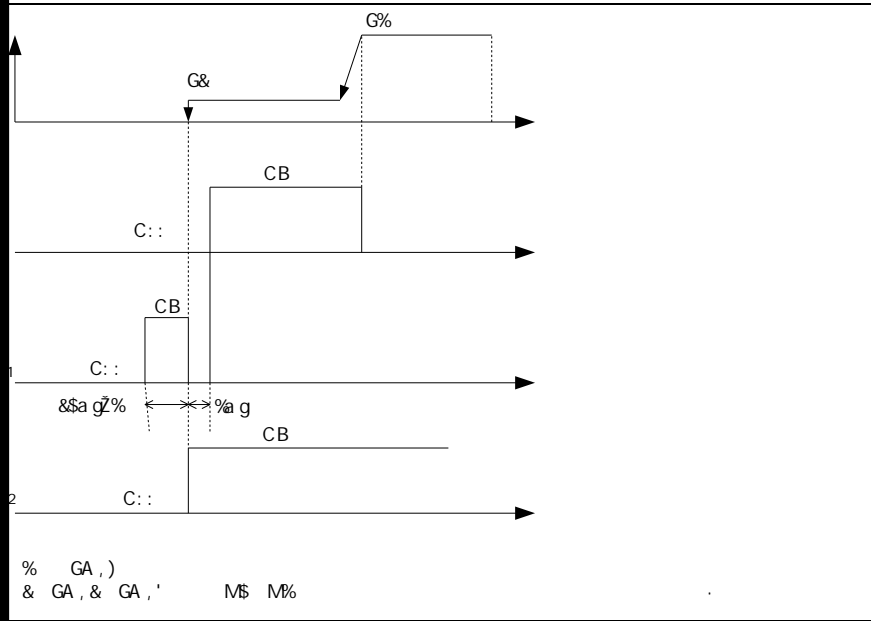
F_{au}

G8 ,) G8 , *

10

T

G8 , +



(D1)	(D2)]		

? bM ? bA ? bG ? b@A ? bGA 8 G 7 J F

--- --- [DRVI (S1) (S2) (D1) (D2)]														
G%	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J	F
G&	8-BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J	F
8%	6CC@			M										
8&	6CC@			M	A	G								

$$F_{a|bSacc} \sqrt{\frac{F_{au}}{T}}$$

$$\frac{F_{au}}{T} \quad G8,) \quad G8, *$$

' & -----
 <n

' & A 7%\$\$ A 7&\$\$ % \$\$\$\$\$ <n A 7& \$
 % \$\$\$\$\$ <n

$$F_{a|bSacc}$$

A 7%\$\$ A 7&\$\$

3

M\$ M% A 7& \$z M\$ M% M&
 M M(M) M* M+

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- 8& CB
- 8& C::

%

- M\$ G8, \$ G8, % ' &
- M% G8, & G8, ' ' &

&

(

)

C::

GA

*

*

C::

GA, \$GA, % CB

+ GA ((\$ GA ((% GA ((' M\$M% M&M

M*#M+ 56 CB 56 C::

C::

+

1 A 7&\$\$ A 7& \$ G8 A 7%\$\$ z 8

9

2

--- --- DRVA (S1) (S2) (D1) (D2)]															
G%	8-BH'		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F
G&	8-BH'		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J		F
8%	6CC@			M											
8&	6CC@			M	A	G									

2

' & -----
 <n
 ' & A 7%\$\$ A 7&\$\$ %\$ %\$\$\$\$\$ <n A 7& \$
 %\$ &\$\$\$\$\$ <n
 A 7%\$\$ A 7&\$\$
 M\$ M% A 7& \$Z M\$ M% M&
 M M(M) M* M+
 D@7

$$F_{a|bSacc} \sqrt{\frac{F_{au}}{T}} \text{ $$}$$

G8,) G8, *
 G8, +
 $F_{a|bSacc}$

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CB C: : (

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- M% G8, & G8, ' ' &

&

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) C: :

* GA
 C: :
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+'' GA ((\$ GA ((% GA ((' M\$M% M&M
 M*#M+ 56 CB 56 C: :
 C: :

+

1 A 7&\$\$ A 7& \$ G8 A 7%\$\$ ž

8
 9

--- --- [ABS (S) (D1) (D2)]															
G	6CC@	L	M	A	G										
8%	6CC@		M	A	G										
8&	8-BH		?bM	?bA	?bG					8	G8	7			F

) 56G CB 56G

G& %G & L

* 56G

' & *

8% 8% % 8% & M + 56GV]H\$ V]H% &

, \$

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8& 8& % &

56G

G8, \$ G8, & ' &

G8, \$ G8, &

% D@7

D@7

& 56G 8&

G8, \$

G8, &

' 56G 56G

56G

CB C::

(GA, & GA, ' M\$ M%

)'' A 7&\$ A 7& \$ G8 A 7%\$ ž

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6

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

8C;

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

[STOPDV]														
G%	8-BH'		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J	
G&	8-BH'		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J	
G	8-BH'		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7		J	
8	6CC@			M										

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M& M M(M) M* M+ M% M
M\$ M&

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@B 7K

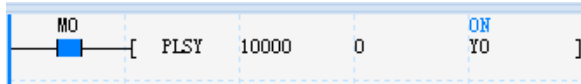
77K

(

D@GM M\$

CB#C: :

A \$



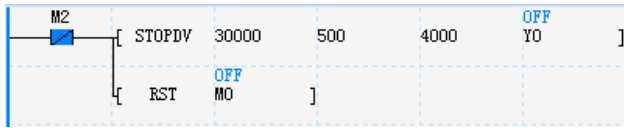
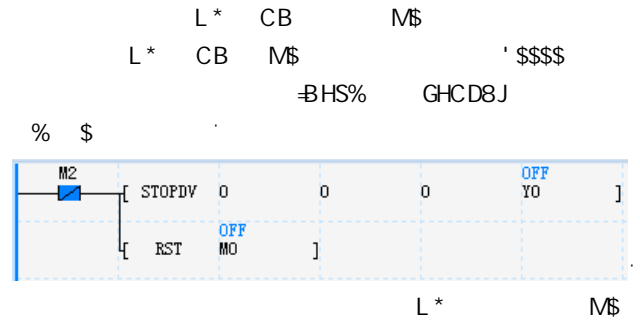
INT_1

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* CB M\$ ' \$\$\$\$

L* CB M\$ -BHS% GHCD8J

% \$

L* M\$

GHCD8J

M\$

M\$

[LUN]																				
		%																		
G	8-BH																			
8%	6CC@				M															
8&	6CC@				M															
8'	6CC@				M															
8(6CC@				M															

8		
	%	
	\$	CB# C::
GZ%	\$	Z
	%	Z

X
Y0 Y4 Y5 Y6 Y7

X
Y
Y2 Y4 Y5 Y6 Y7

Y

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G	

GZM

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M\$ M& M% M M\$ M&

8% 8' M(AM) AM* AM+ &

& M\$ M& " Z "

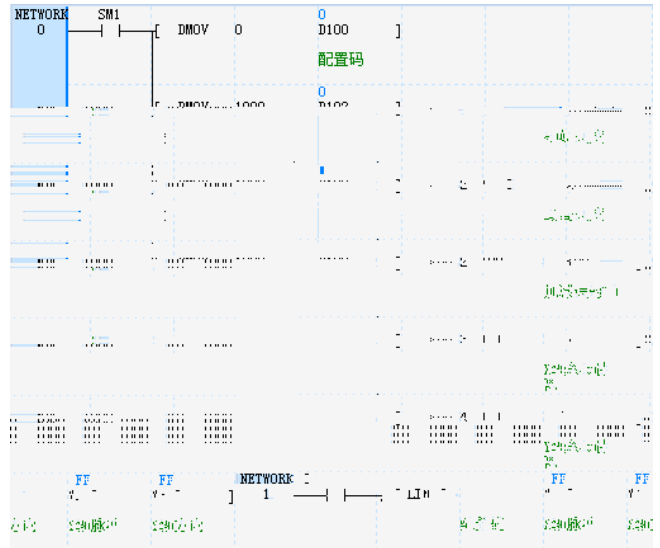
" Z " %\$_ M(M)

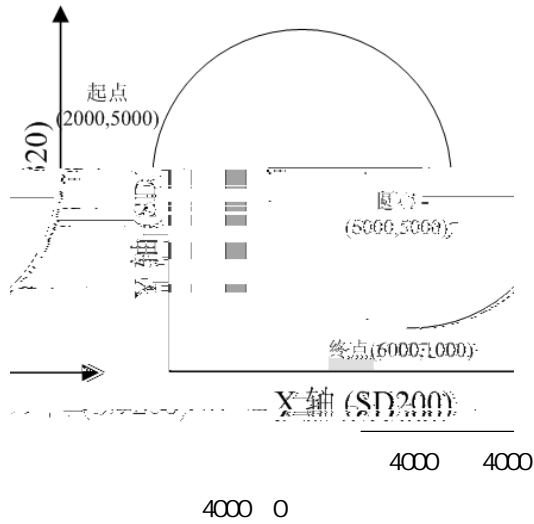
M* M+ " Z "

&\$_

'

(





NETWORK 0	SM1	[DMOV	0	0	D100]							
						配置码								
		[DMOV	1000	0	D104]							
						配置码								
		[DMOV	4000	0	D108]							
						X轴移动距离								
		[DMOV	-4000	0	D110]							
						Y轴移动距离								
		[DMOV	4000	0	D112]							
						圆心X轴相对位置								
		[DMOV	0	0	D114]							
						圆心Y轴相对位置								
NETWORK 1	MO	[CW	0	OFF	OFF	OFF	OFF						
				D100	Y0	Y1	Y2	Y3						
				配置码	X轴脉冲	X轴方向	Y轴脉冲	Y轴方向						

[CW]														
G	8-BH									8				
8%	6CC@			M										
8&	6CC@			M										
8'	6CC@			M										
8(6CC@			M										

X
Y0 Y4 Y5 Y6 Y7

X
Y
Y2 Y4 Y5 Y6 Y7

Y

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8	%S		
GZ%	\$S		CB# C::
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GZ&			
GZ'			
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GZ)			
GZ*			
GZ+			
GZ,	L		
GZ-	L		
GZ%S	M		
GZ%%	M		
GZ&	L	#	L
GZ'	L	#	L
GZ(M	#	M
GZ)	M	#	M

%

L M

&

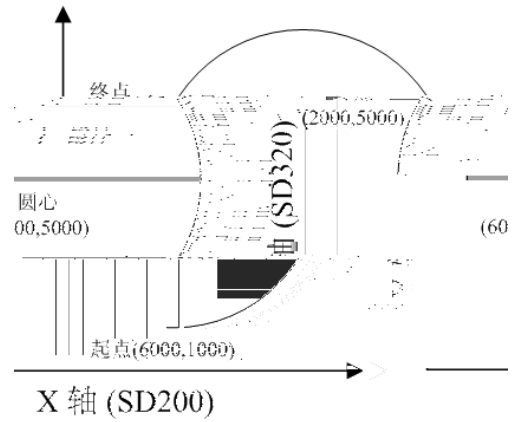
L M

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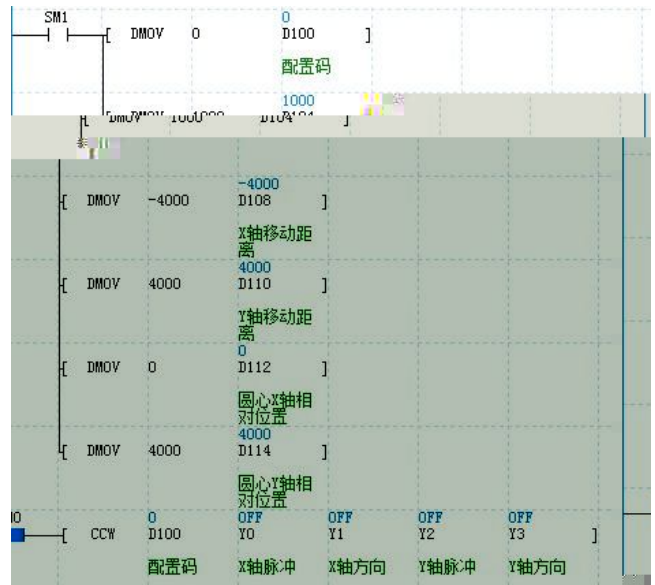
G8

*\$\$\$ %\$\$\$

M\$ M& M% M M\$ M&
 8% 8' M(Z) ZM+ ZM+ &
 & M\$ M& " Z "
 " Z " %\$_ M(M)
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 ' %Z+++Z%)
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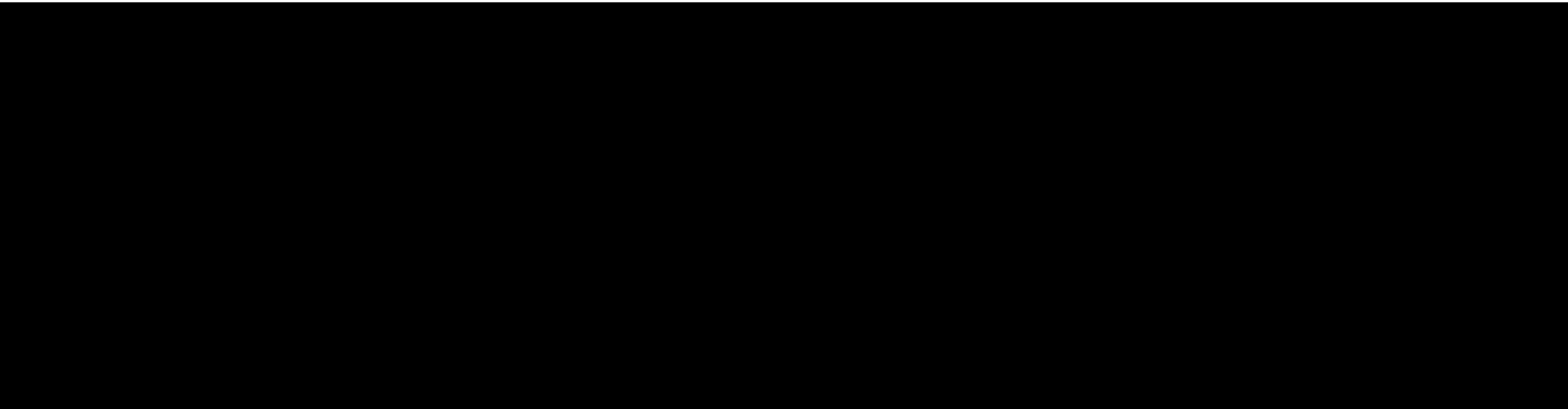


4000 -4000
 0 4000



G%	bL	? bM	? bA	? bG	? b@A	? bGA	8		
G&	bL	? bM	? bA	? bG	? b@A	? bGA	8		
G	bL	? bM	? bA	? bG	? b@A	? bGA	8		
G(bL	? bM	? bA	? bG	? b@A	? bGA	8		
G)		M							
G*		M							

[GEARBOX]		



[DRVC (S1) (D1) (S2) (D2)]														
G%	6CC@										7			
8%	8-BH								8					
G&	6CC@			M										
8&	8-BH								8					

h1 G8&\$) fZ g&\$ (L fG8&\$&G8&\$ (L
 : C236-C400 &'' g f#\$\$\$L fZ G8&\$ (L

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

[CAMBOX (S1) (D1) (D2) (D3) (D4)]														
G%	=BH'			M					8'	G8'	7'		J'	
8%	6CC@	L'	M'								7'			
8&	6CC@		M											
8'	6CC@		M'	A										
8('	6CC@		L'											

75A H56@9

%

L \$rL + M \$rM+

&

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\Wdh

7& *r7' \$+

M \$rM+

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L \$rL +

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

%

HU'YS

[MEAN (S1) (D) (S2)]										MC280				
G%	=BH		? bL	? bM	? bA	? bG	? b@A	? bGA	8	G8	7	H		F
8	=BH			? bM	? bA	? bG	? b@A		8	G8	7			F
G&	=BH								8					F

%
&

M1	[MEAN	32	10	4]
			D0	D10		

@8 A %

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A %CB 8\$ (ž

8\$ 8\$1' & 8%1\$ 8&1% 8' 1!%

8\$1%

% S1 S2 16 D

[WTOB (S1) (D) (S2)]										MC280				
										7				
G%	=BH								8	G8	7	H		F
G&	=BH								8	G8	7	H		F
8	=BH								8					F

%
&

% S1 S2/2 16 S2 D S2



FIV

W3

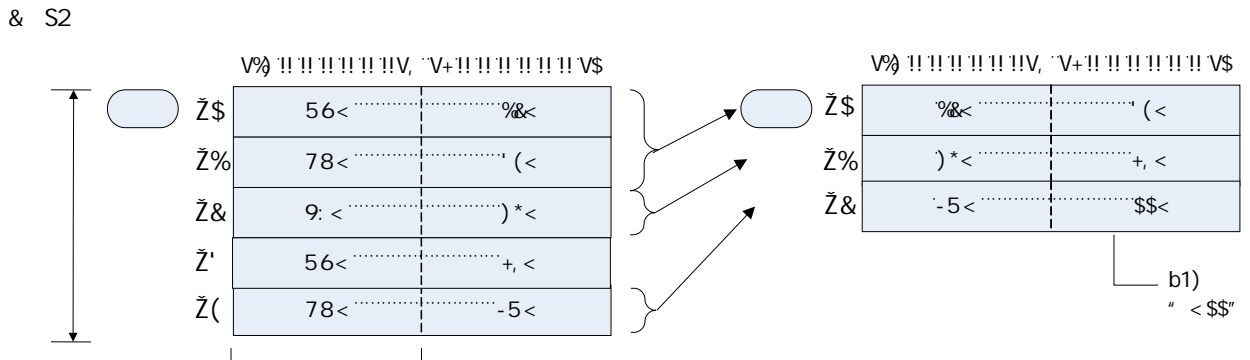
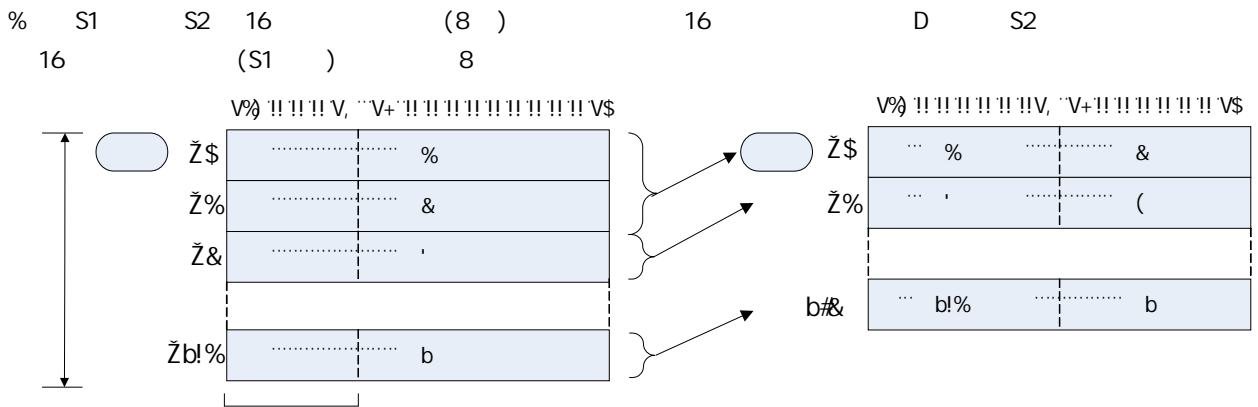
8PYF_ 5\$V 44

60 T

Z

BTOW (S1) (D) (S2)													
G%	-BH							8	G8	7	H		F
G&	-BH							8	G8	7	H		F
8	-BH							8					F

%
&



S2 0
(

M1	[BTOW	1	258	8]
		DO	D10			

@8 A %
6HCK 8\$ 8%
A %CB 8\$ * 8% 8\$1\$ %8%1\$ \$Z
8&1\$ \$ Z8' 1\$ \$(Z8(1\$ \$) Z8) 1\$ \$* 8%1\$ \$8&8%1\$ '\$(Z8&1\$) \$*

16

4

|—| — [**UNI** (*S1*) (*D*) (*S2*)]

16 4

[DIS (S1) (D) (S2)]														
G%	-BH								8	G8	7	H		F
G&														
8	-BH								8					F

----- ----- [RND (D)]															
8'	K CF8'		? bL'	? bM'	? bA'	? bG'	? b@A'	? bGA'	8'	G8'	7'	H'		N'	F'

M1 26406
 |-----|-----| [RND DO]

@8' L\$ a,Éy.¿7™ö™€
 FB8'8\$ A %CB 8\$ 8\$1&*(\$*

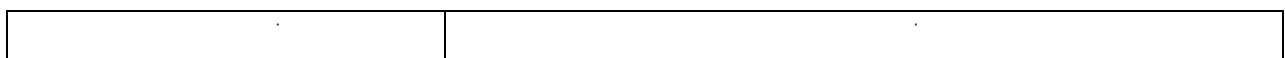
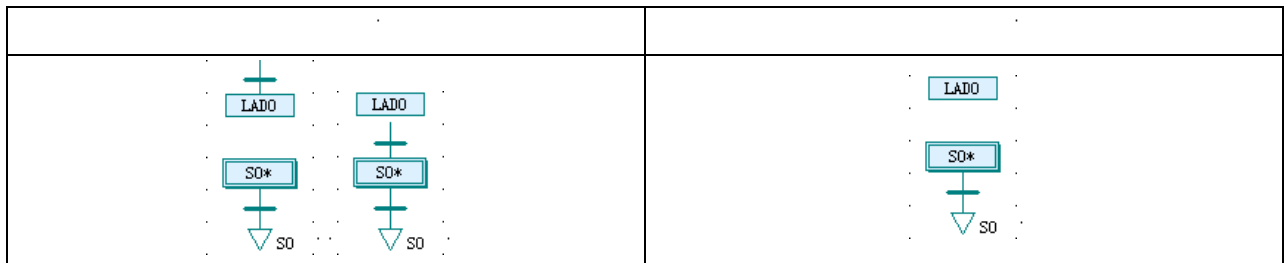
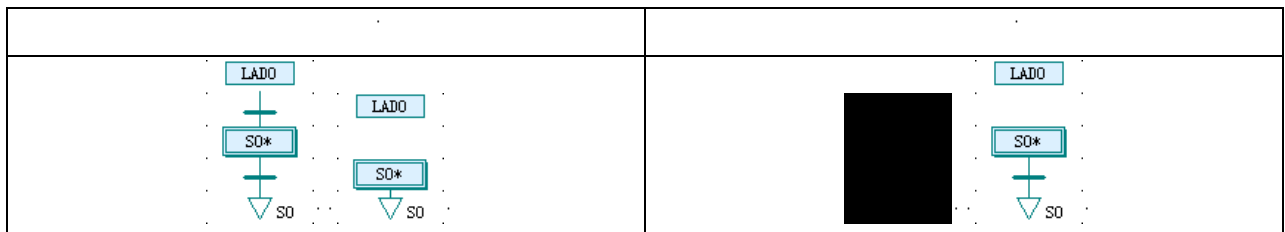
----- ----- [DUTY (S1) (S2) (D)]													

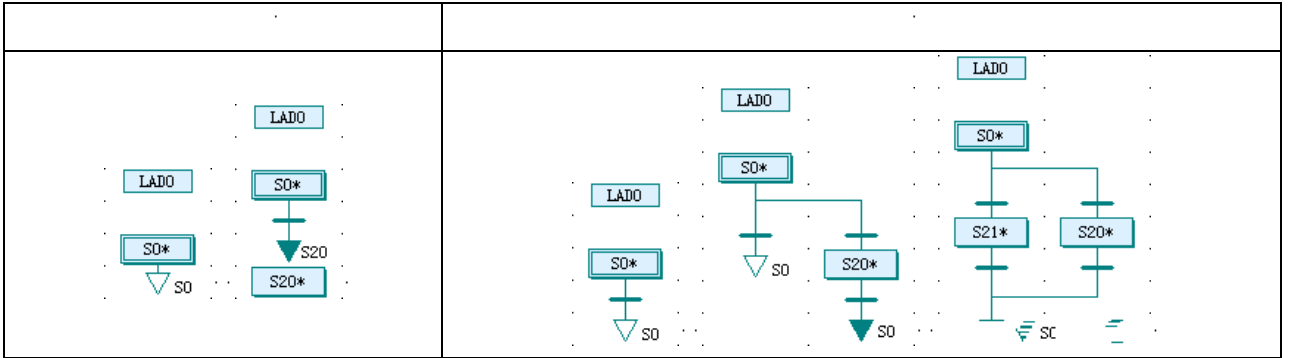
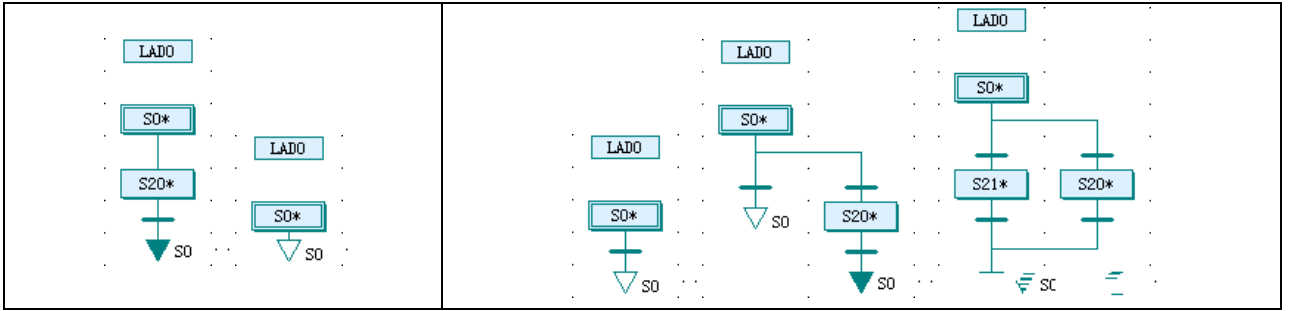
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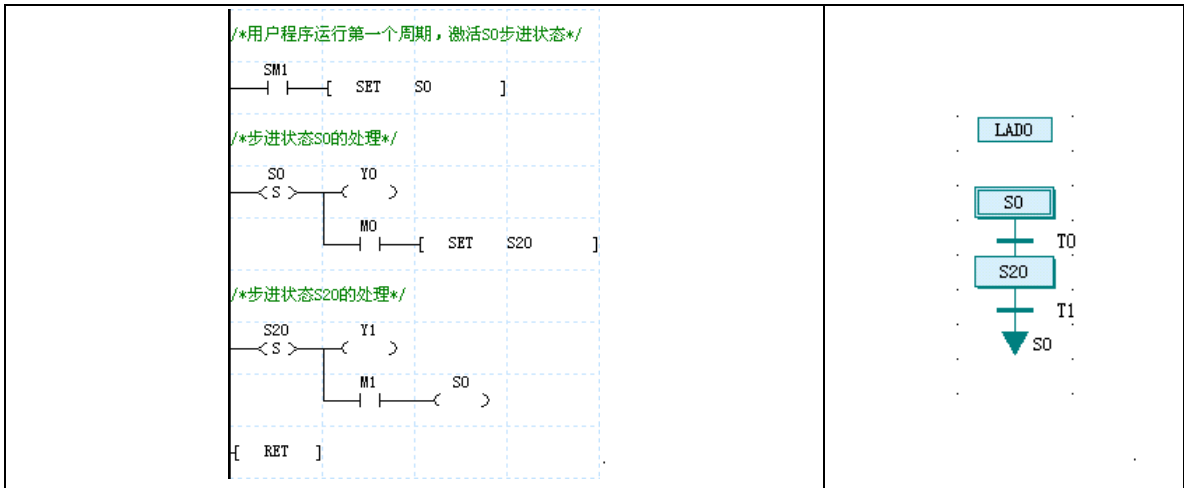
+!%&)
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+!%& A 7 D@7&)
+!%&)

		G
		G CB
		G C::





G. 7



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G CB

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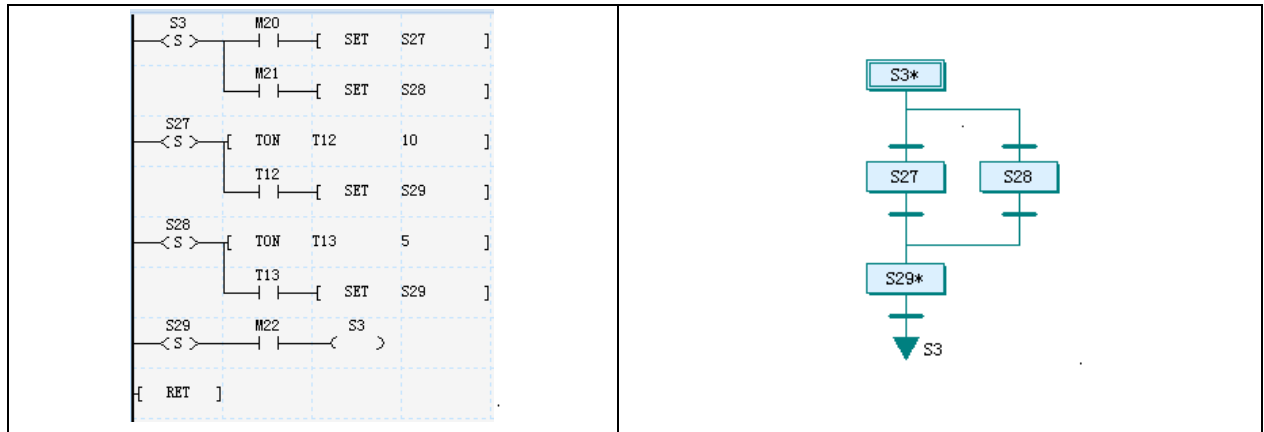
G \$ %

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G &\$ --% A 7&\$

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B\$ G&+ G&
G&+ G&

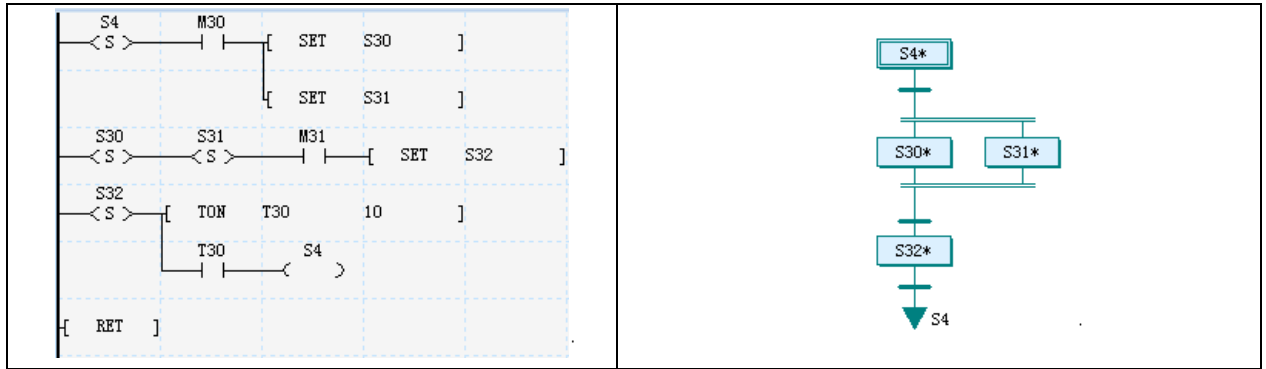
&"

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B& G&

H%

B% G&+



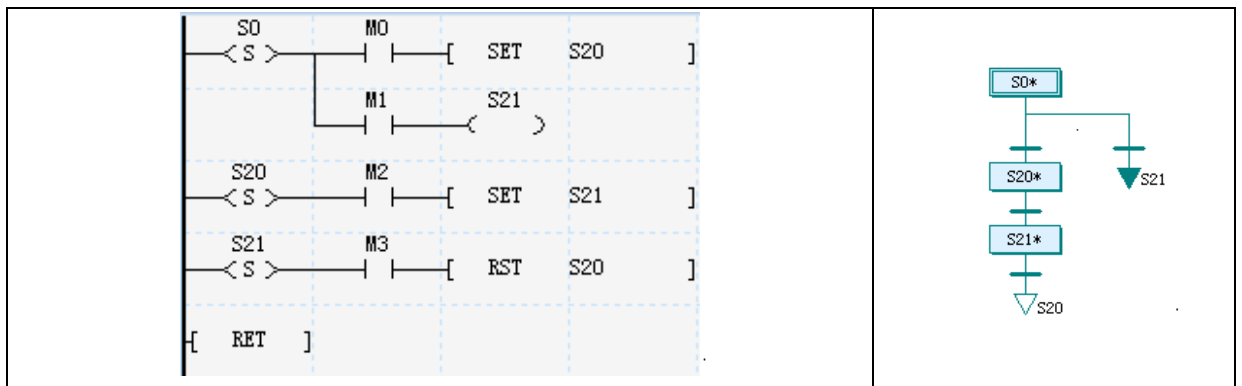
B\$ A '\$ A '\$ G \$ G %

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G \$ G % A ' % G & G \$ G %

B*

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G&% G&\$

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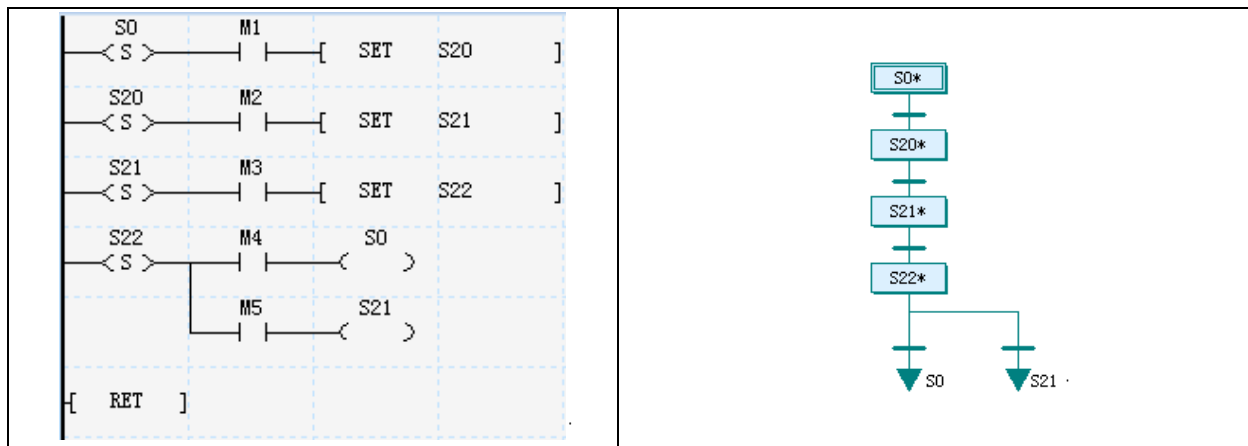
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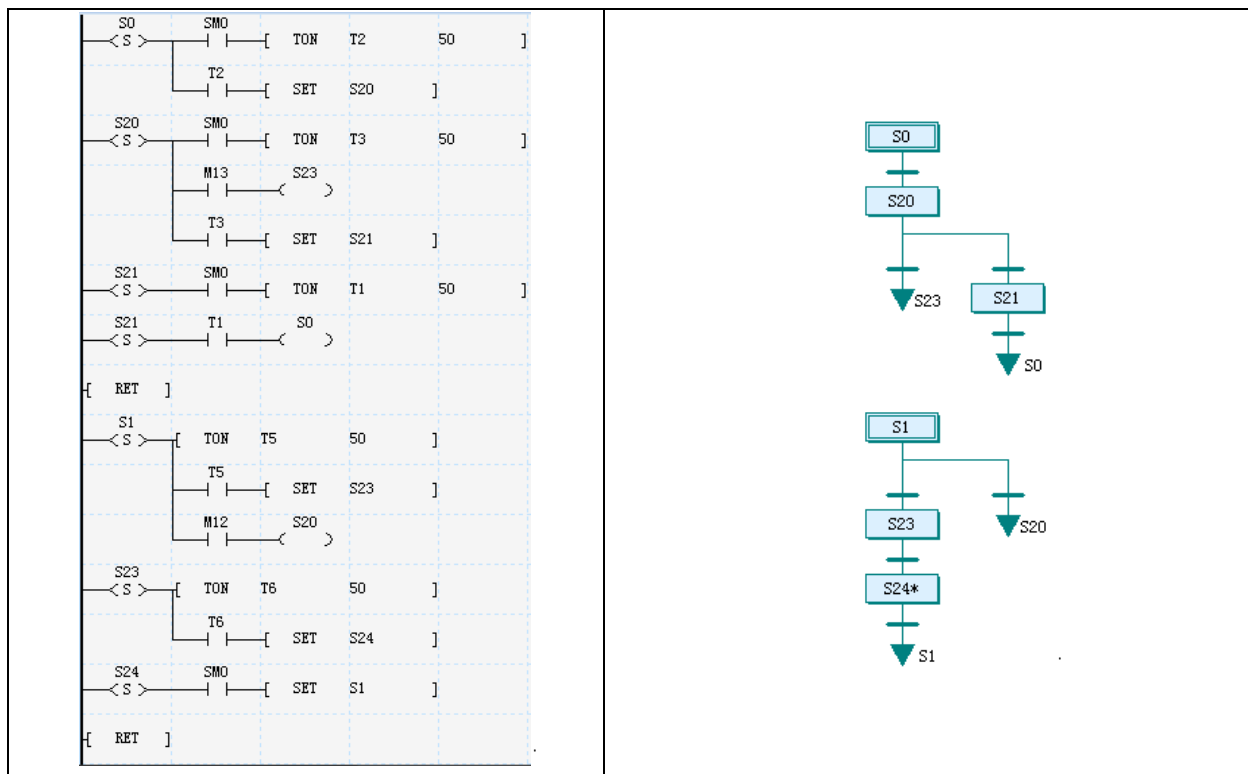
CI H

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D@7



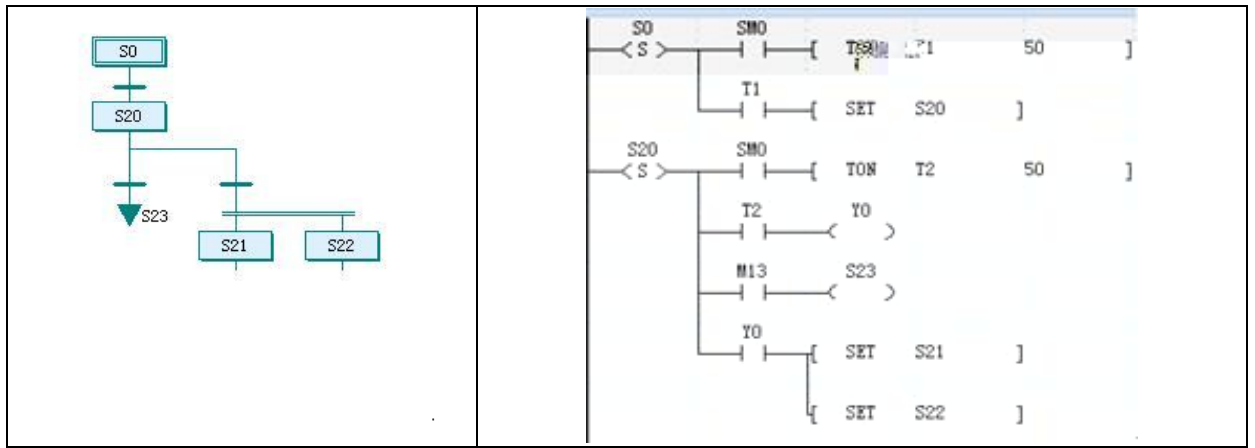
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G CB C:: CB#C:: 5.31 STL SFC G



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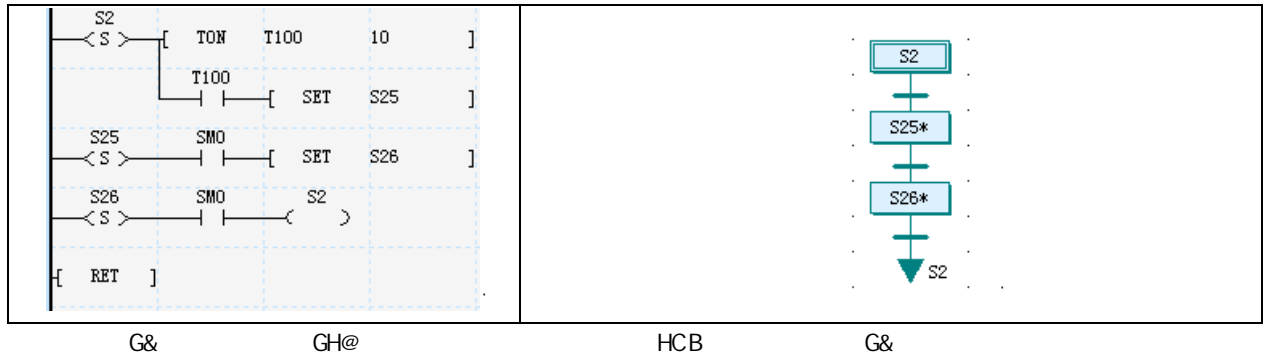
G: 7

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GH@ 5.31 STL SFC CB C::

CI H HCB HC: DK A <7BH D@GM D@GF 8<G7G GD8 8<G7= 8<G7F 8<GN 8<GH

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D@7

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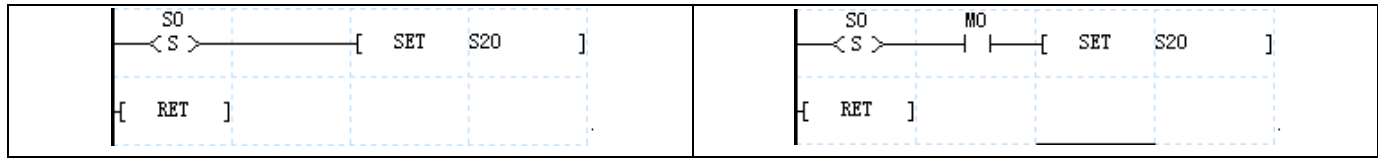
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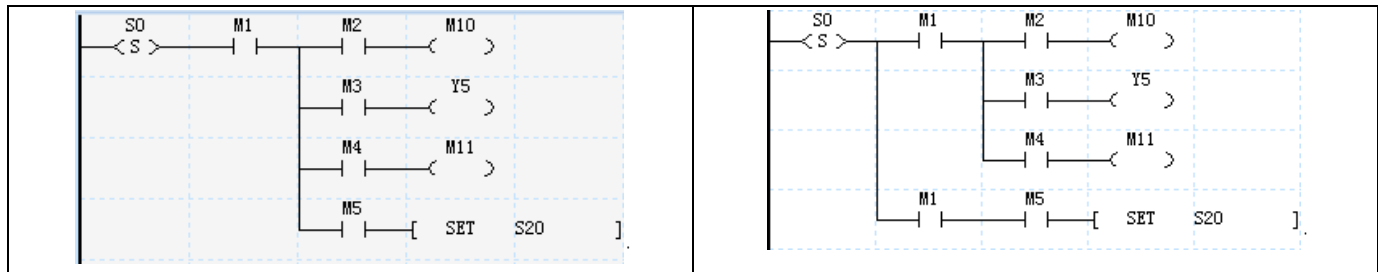
CI H HCB HC: DK A <7BH D@GM D@GF 8<G7G GD8 8<G7=
8<G7F 8<GN 8<GH 8<GD 6CI H

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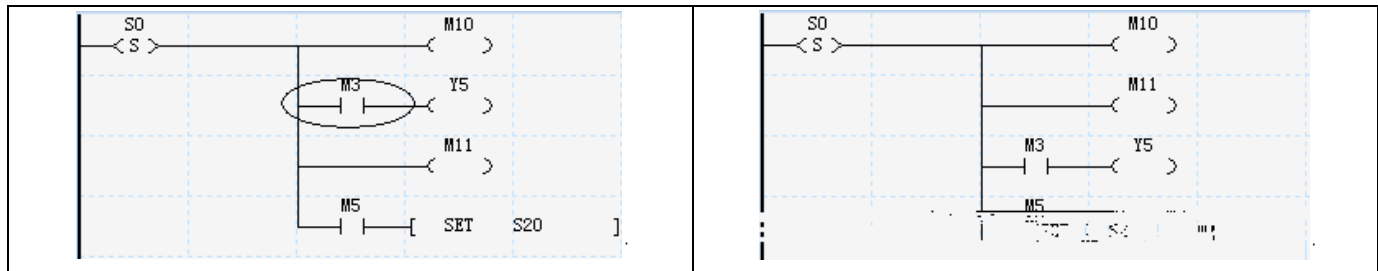


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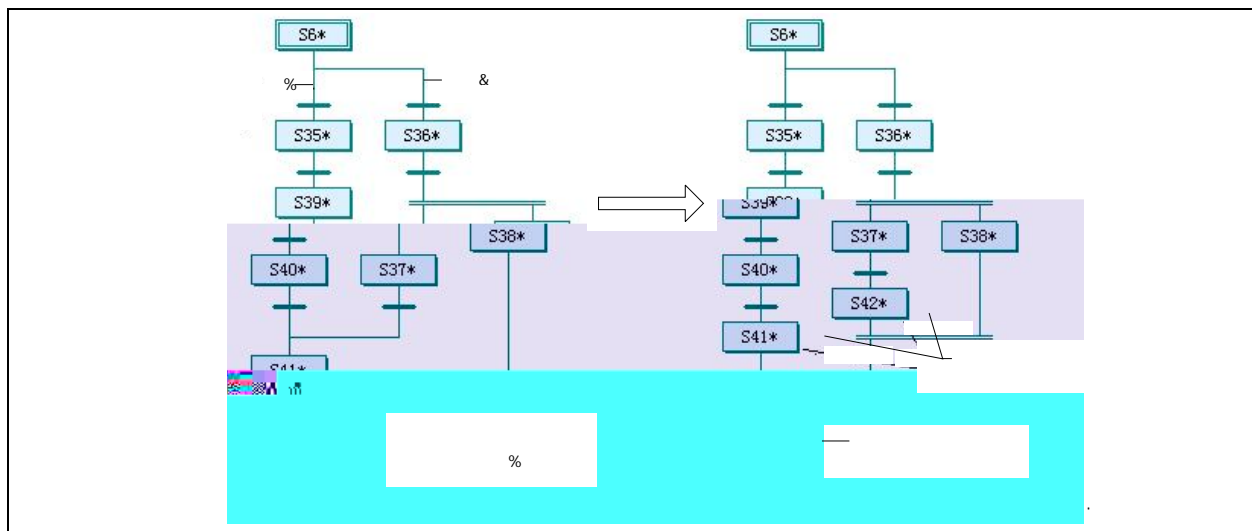
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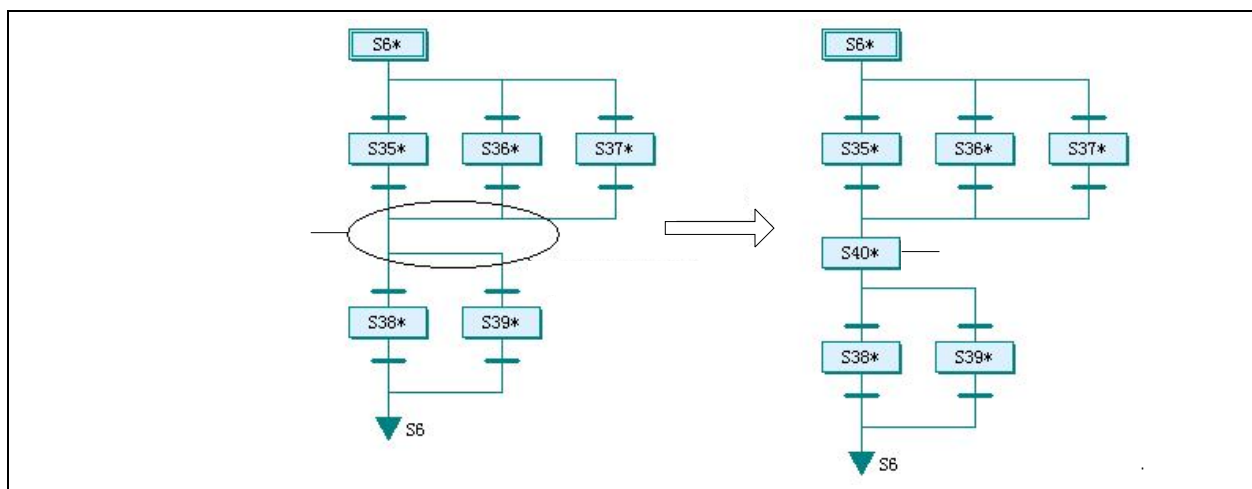


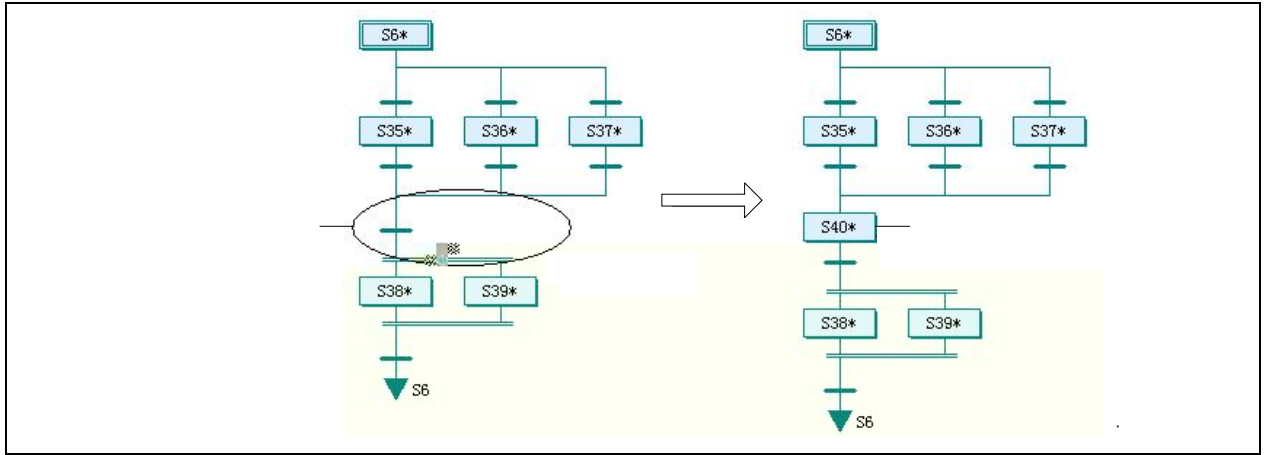
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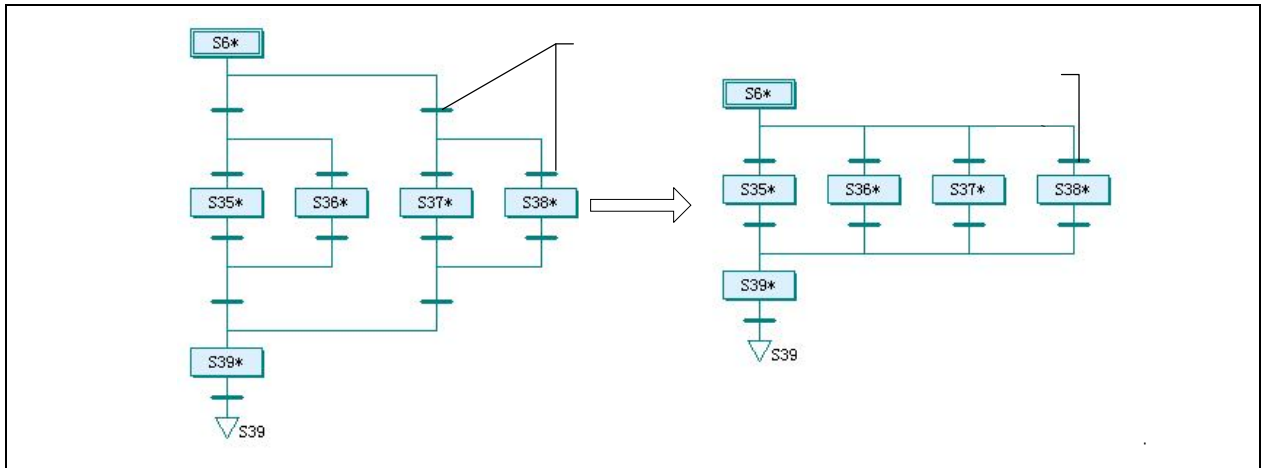
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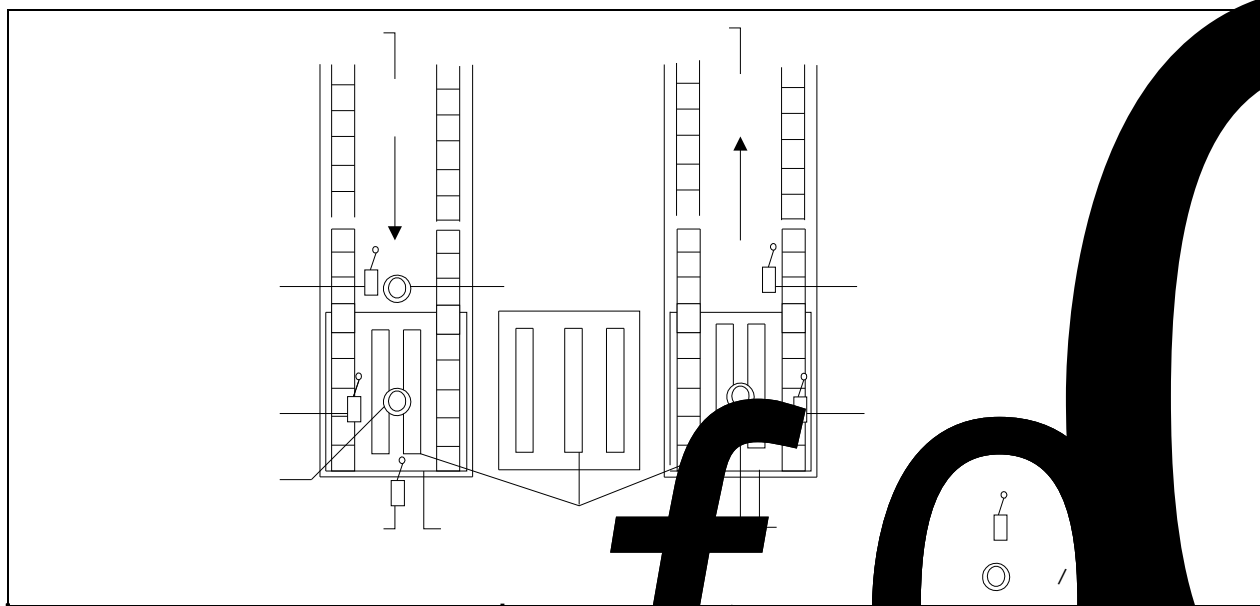




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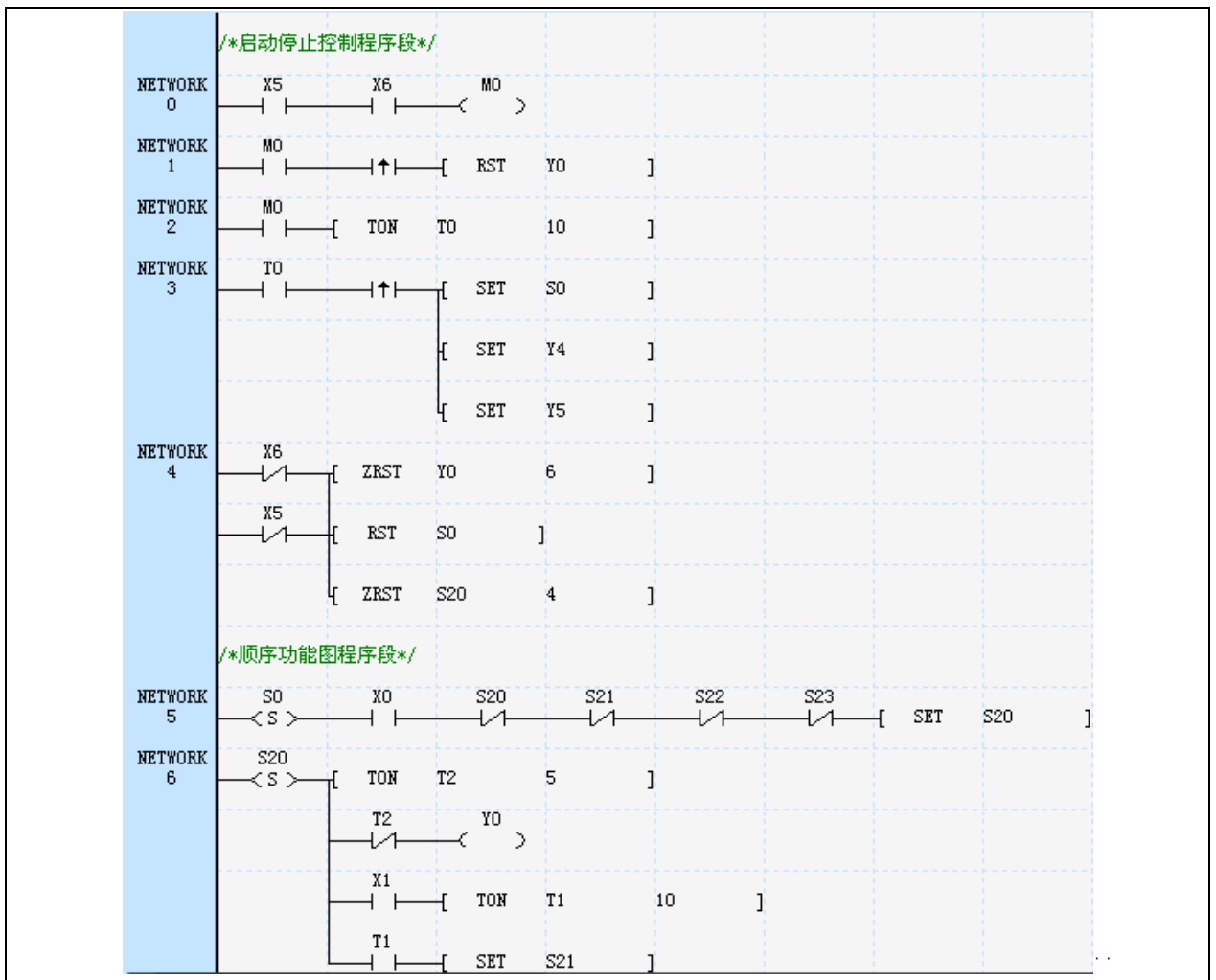
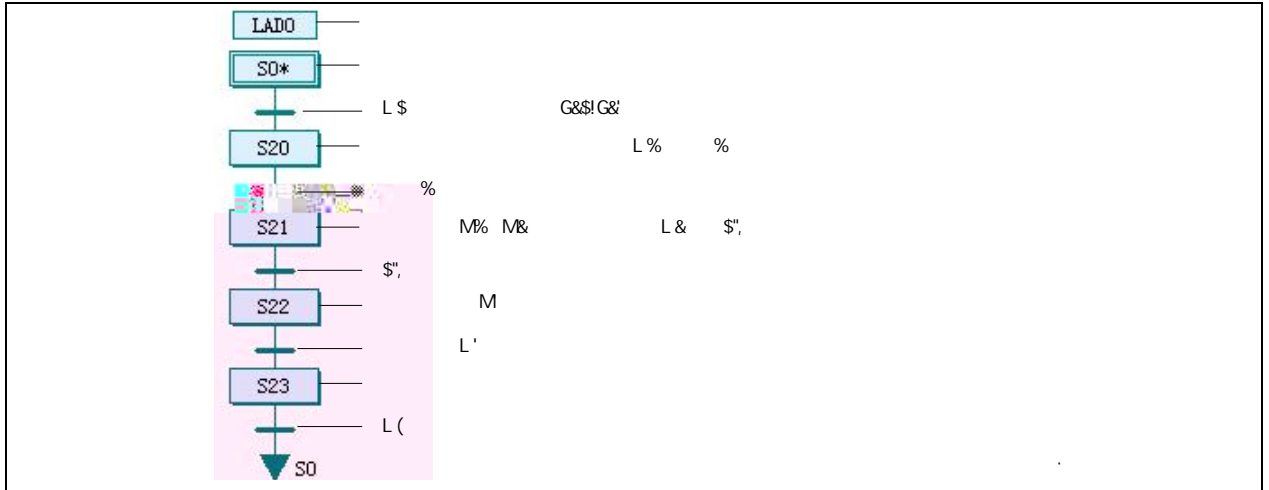
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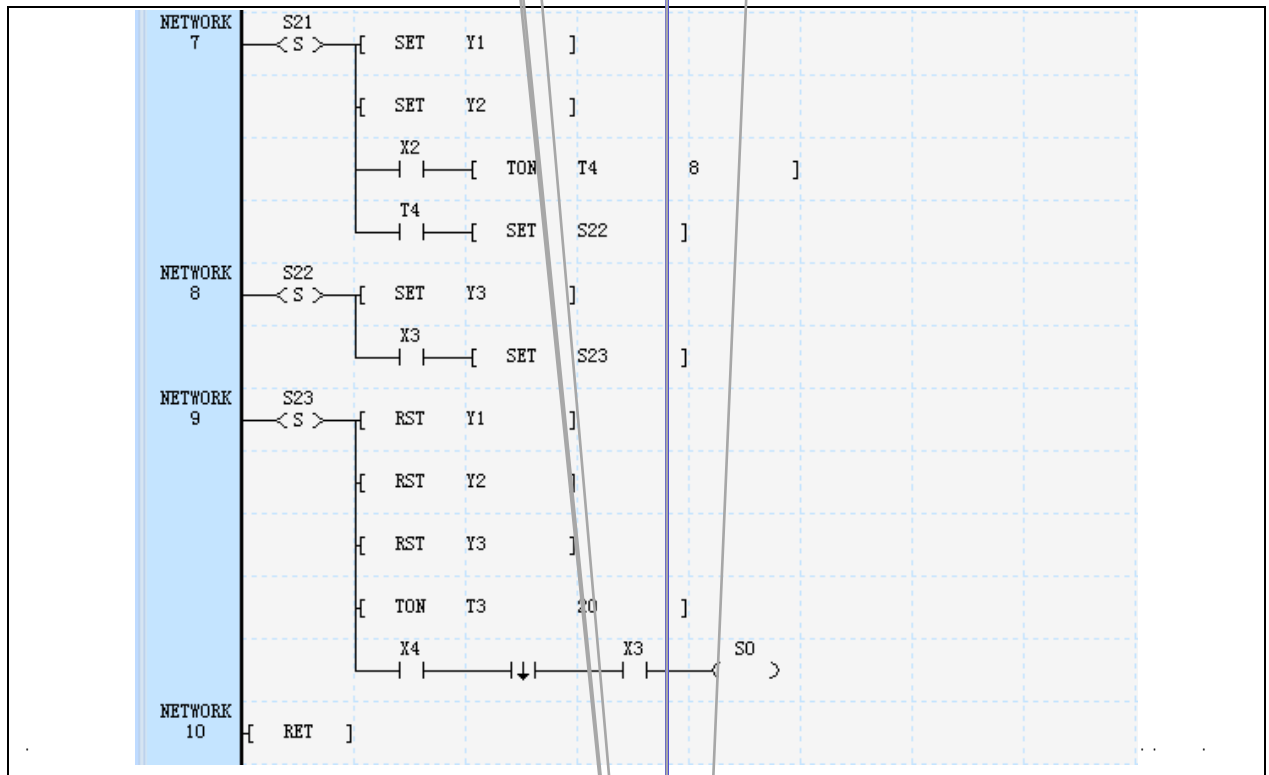
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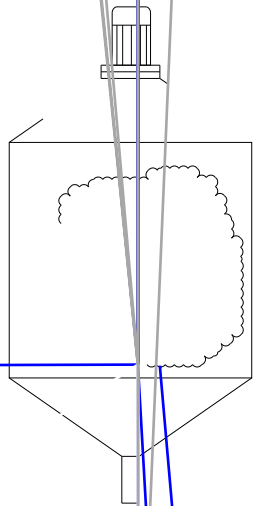
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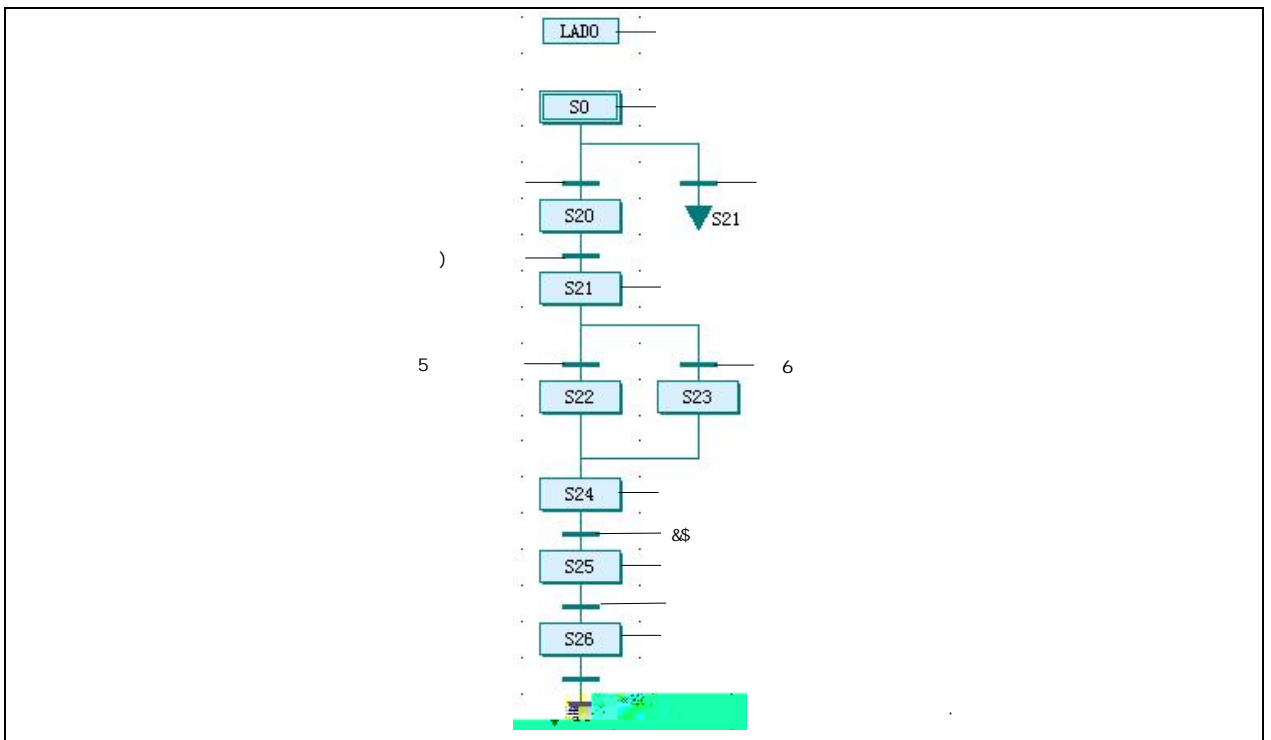


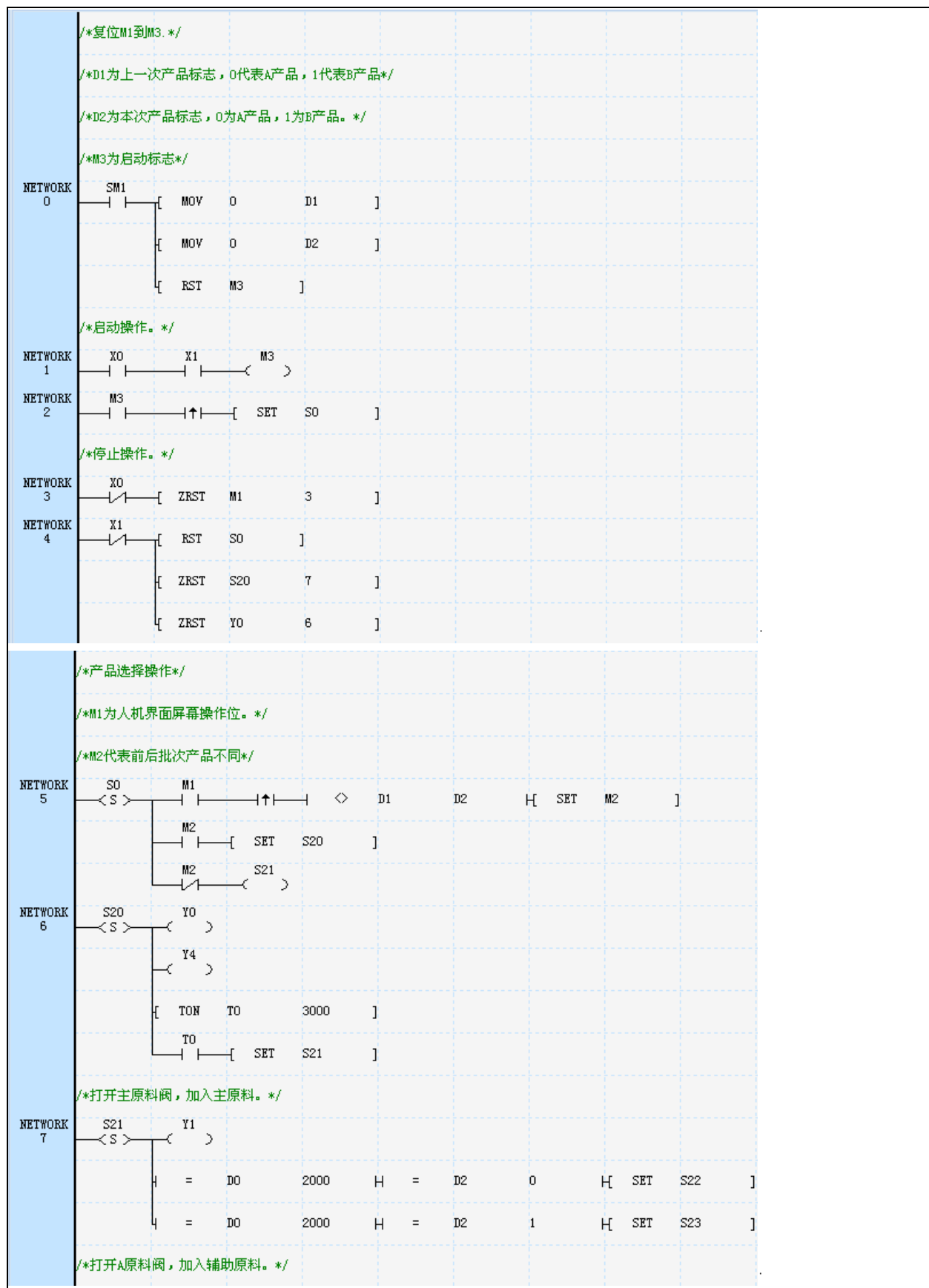
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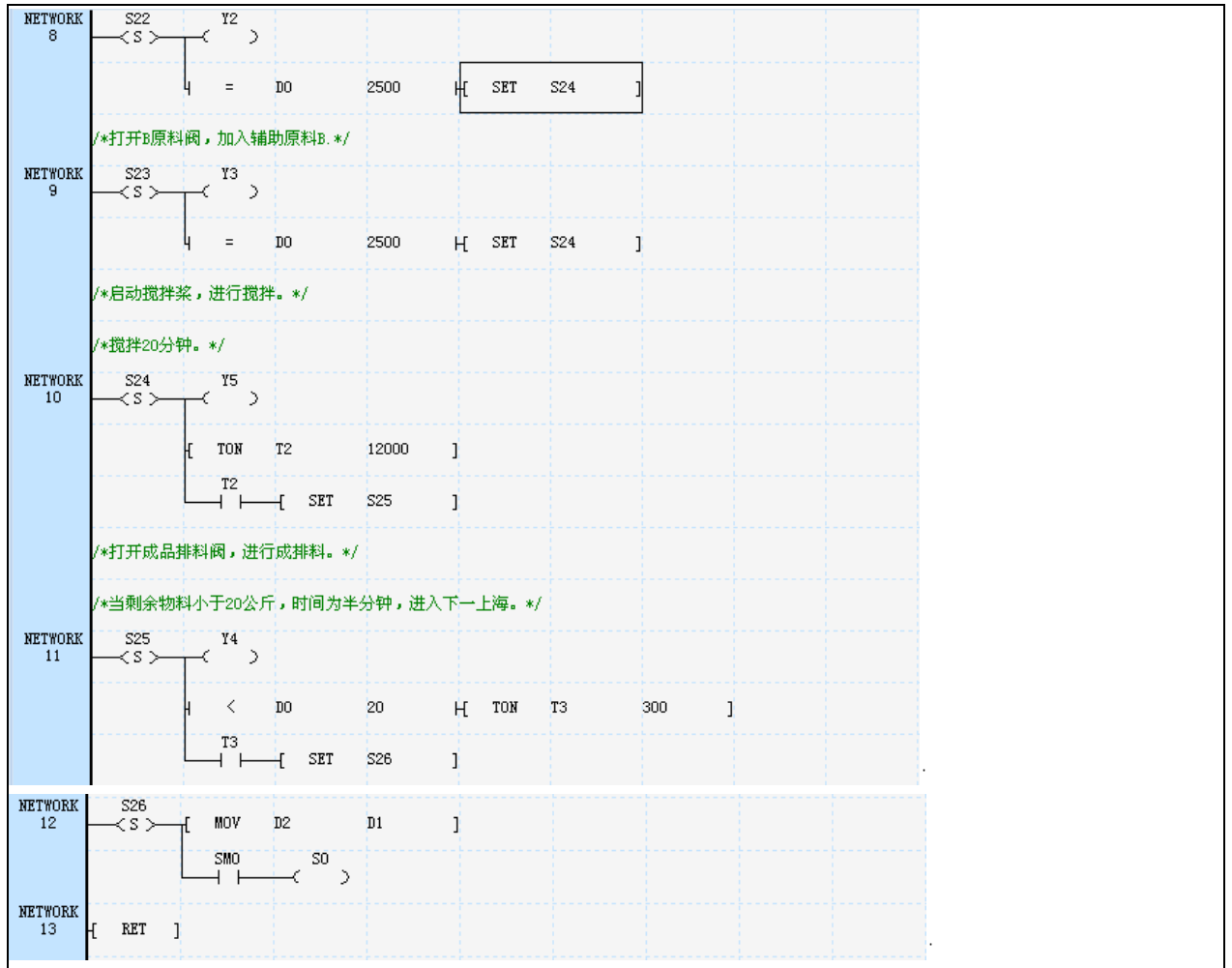


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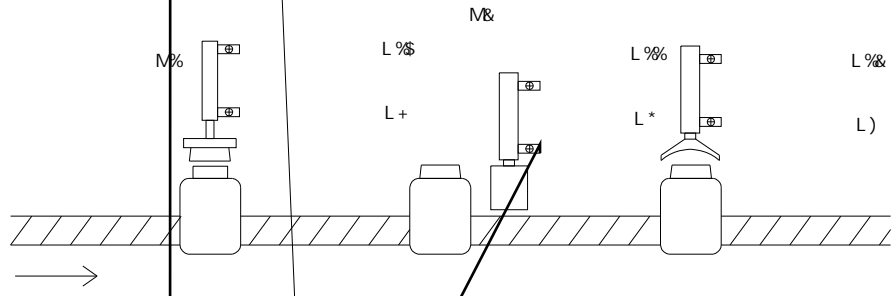
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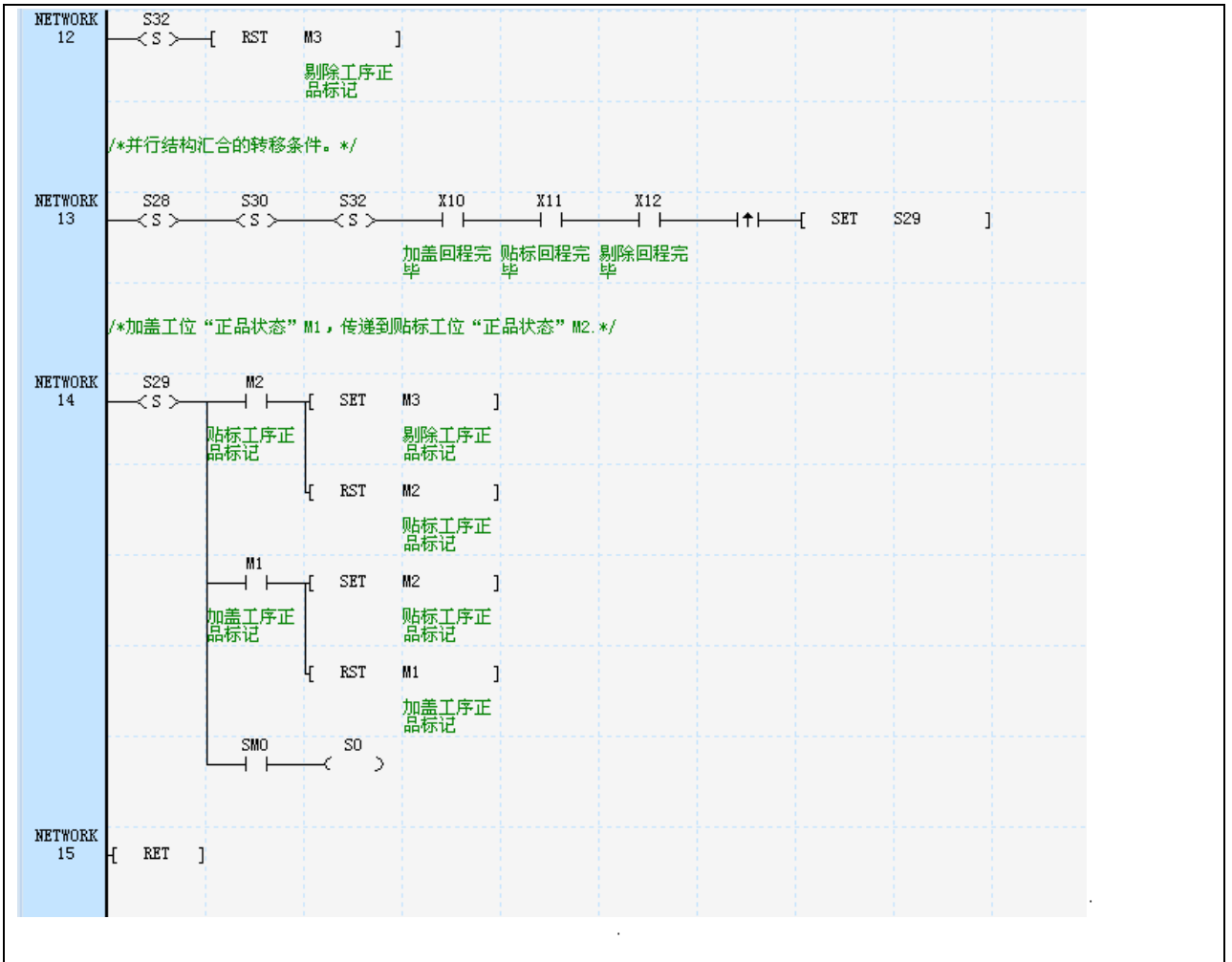


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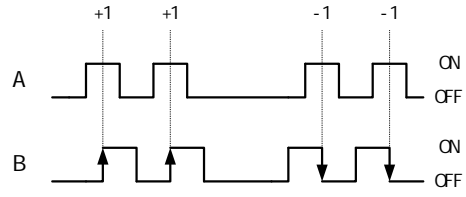
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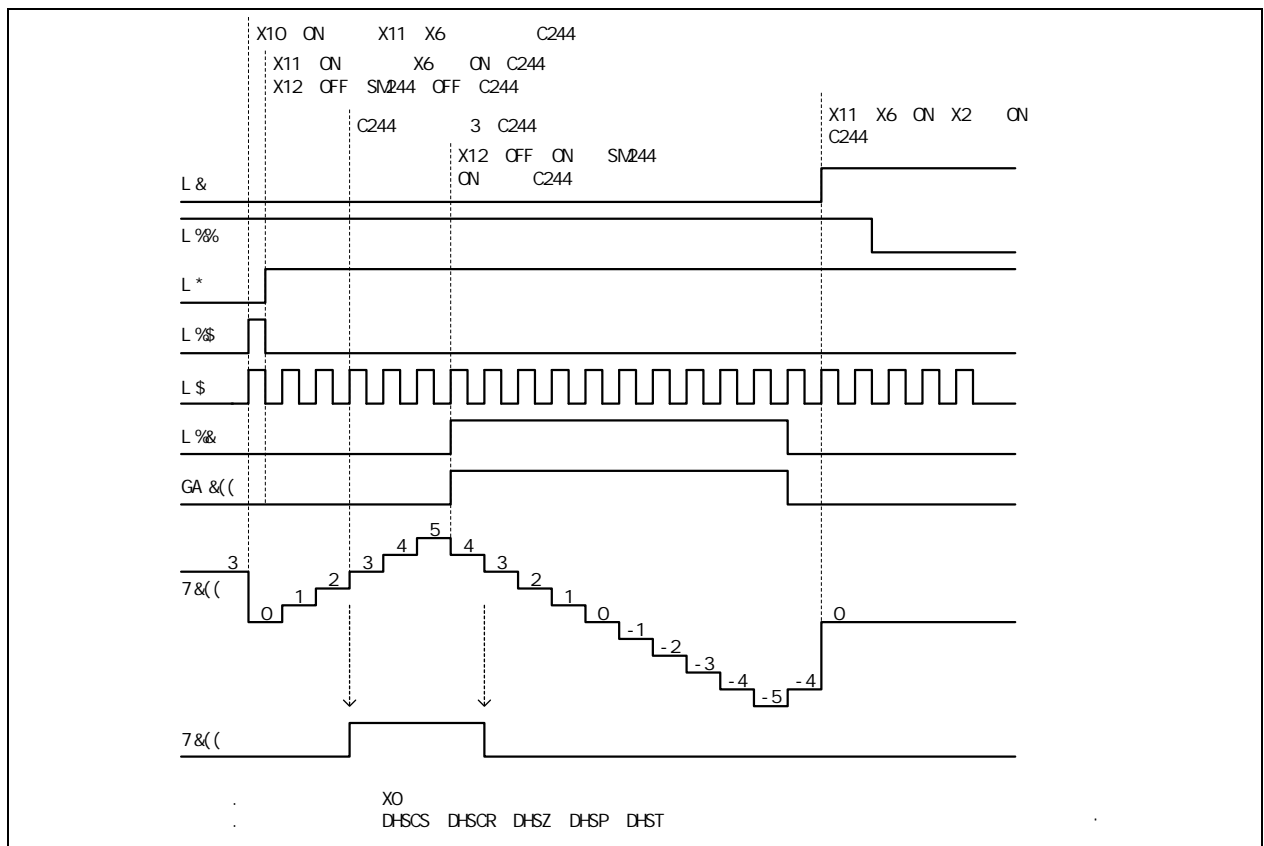
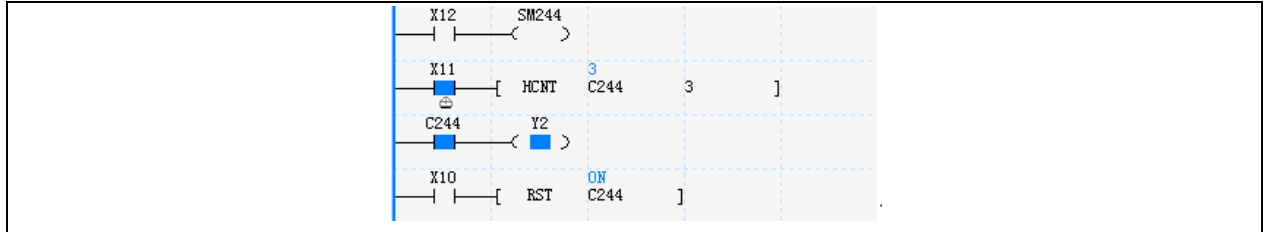


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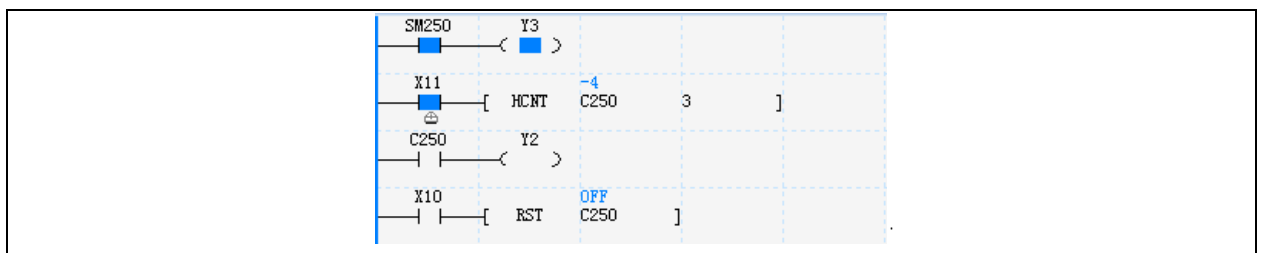
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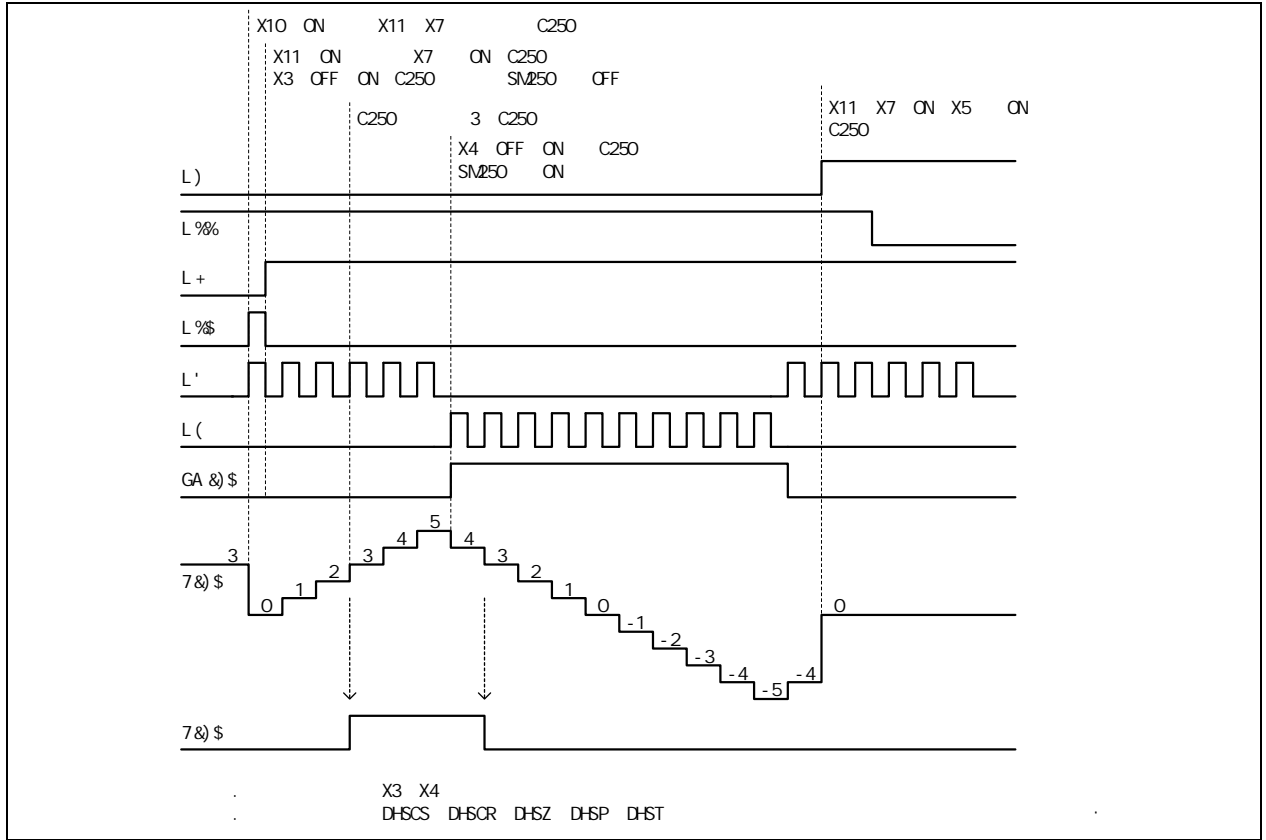
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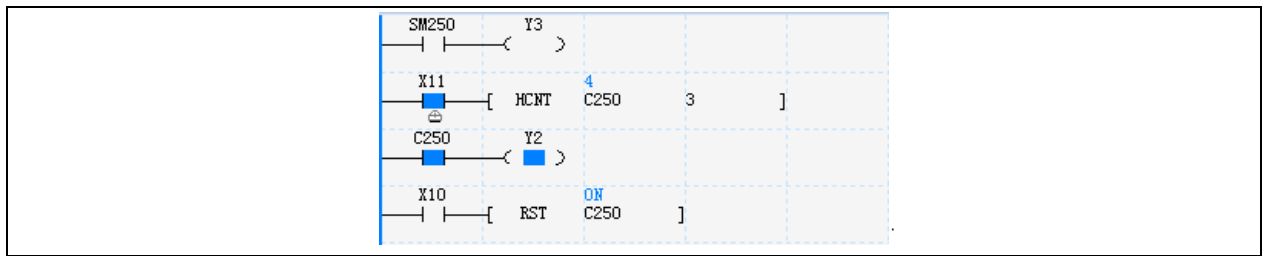
GA

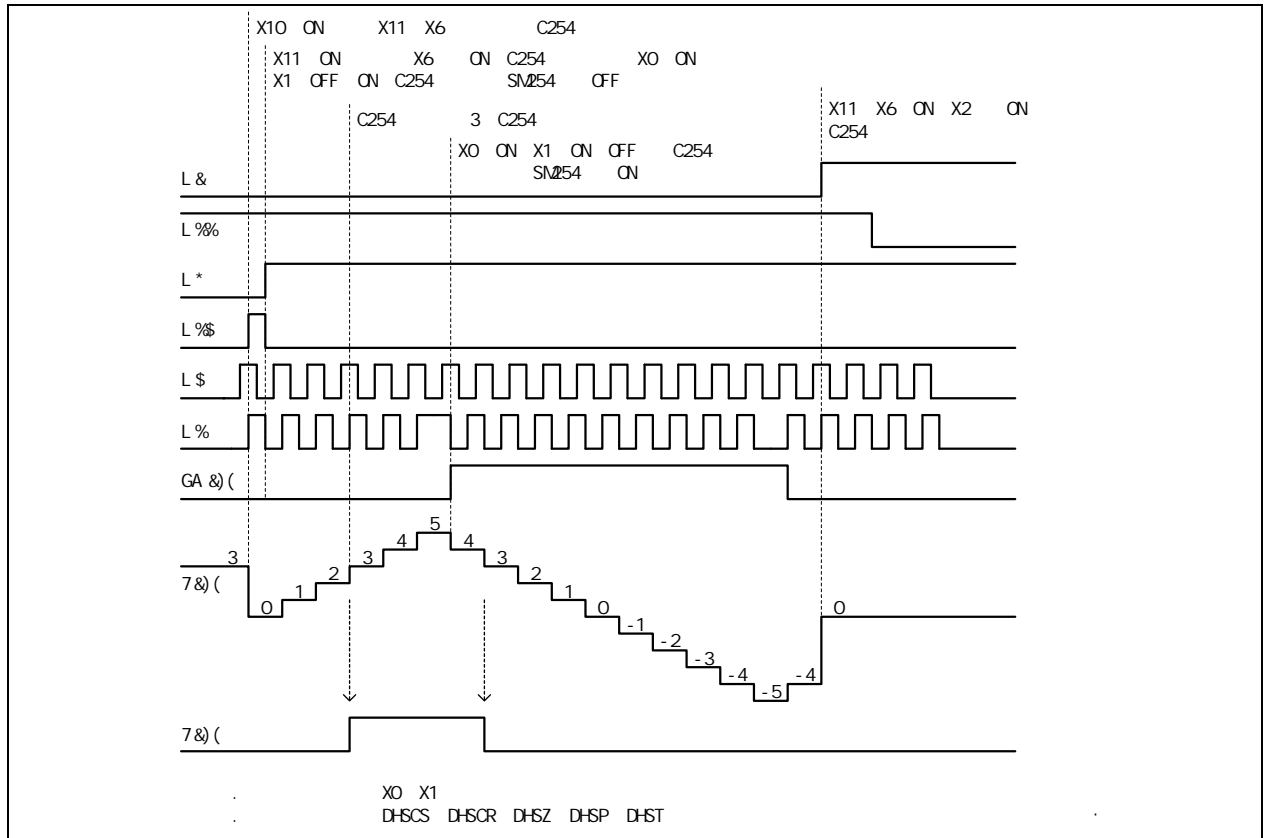




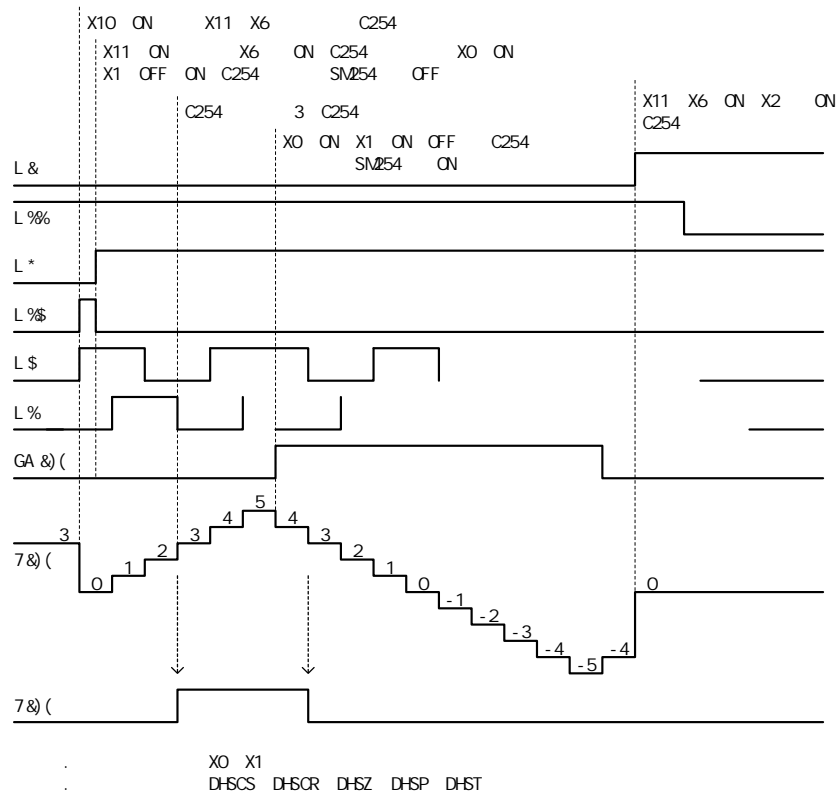
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C.: CB CB C.:
GA



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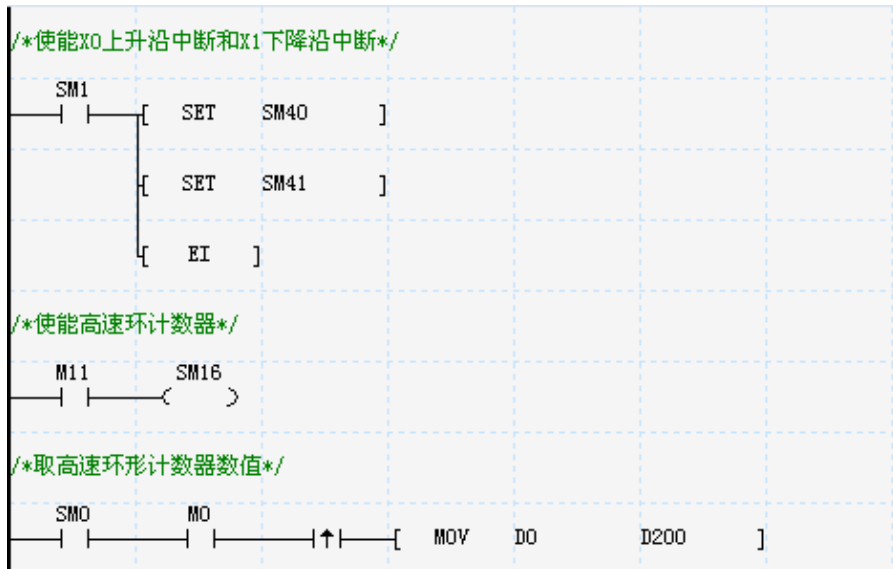
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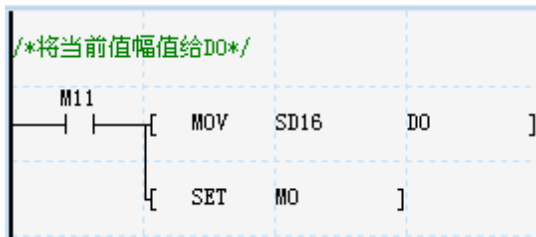
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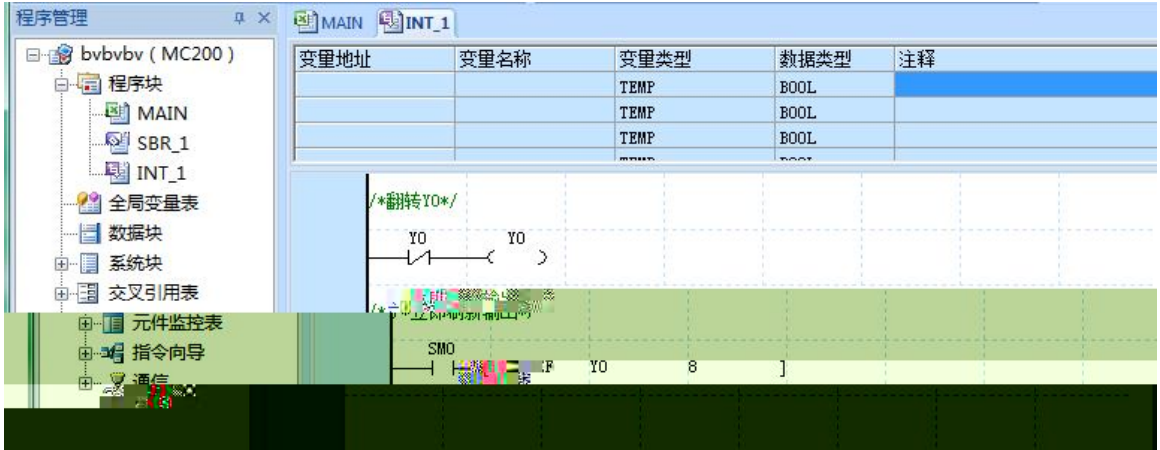
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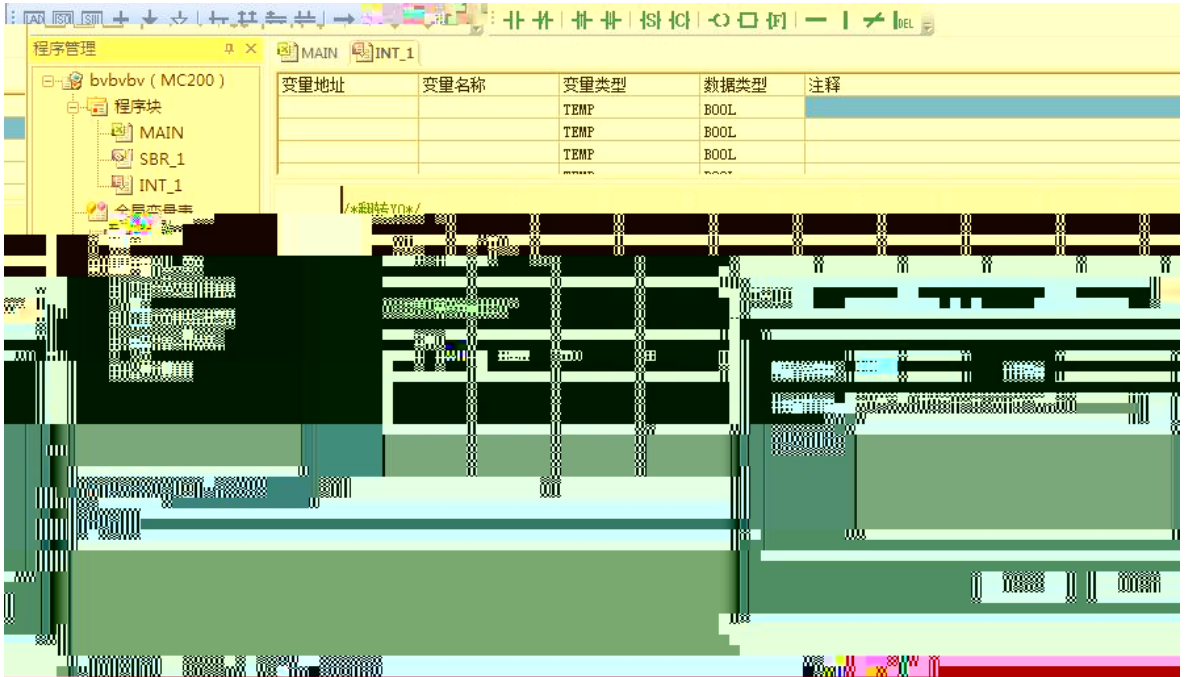
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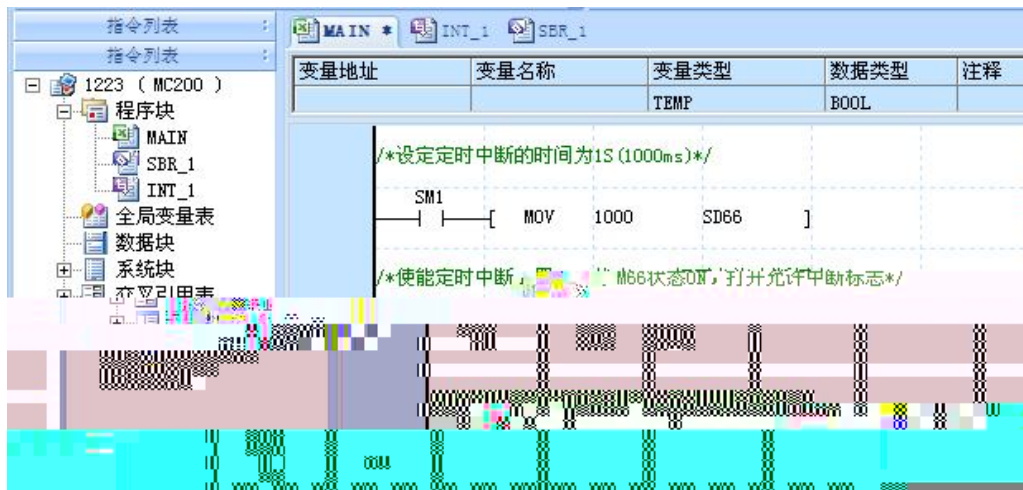
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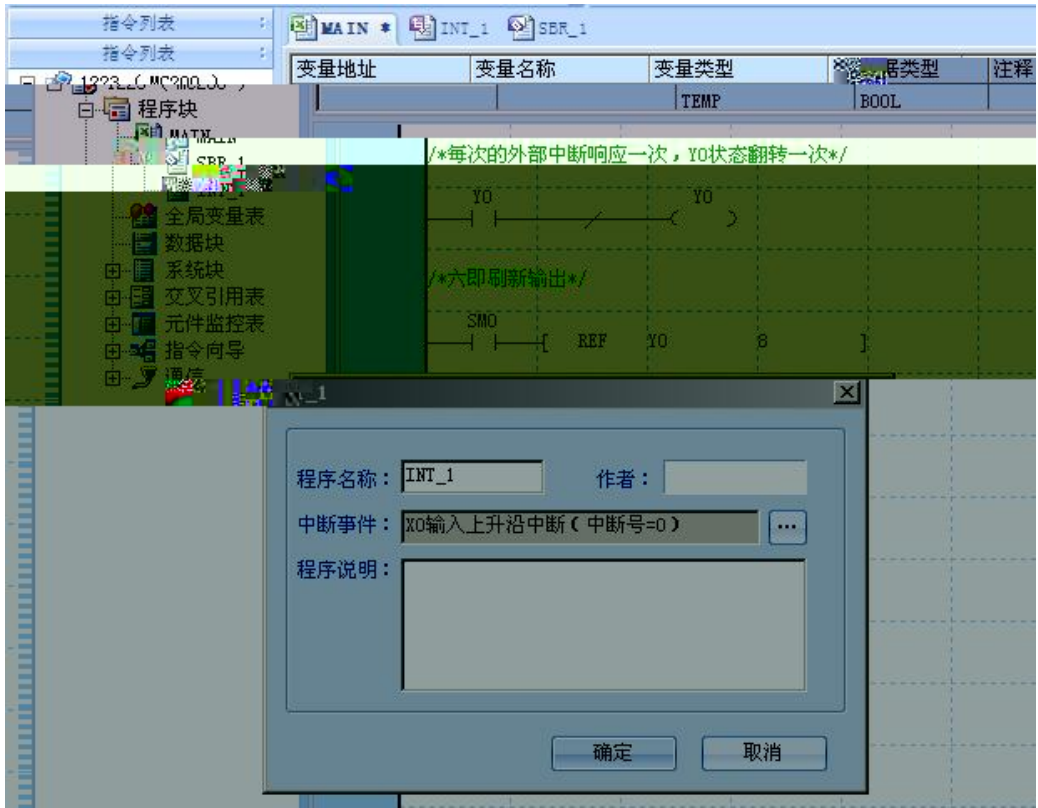
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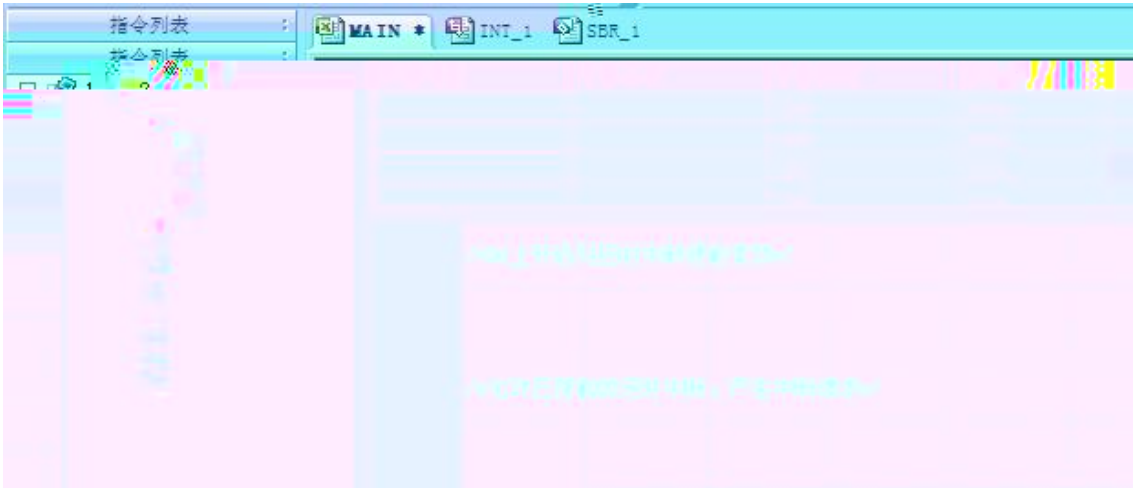
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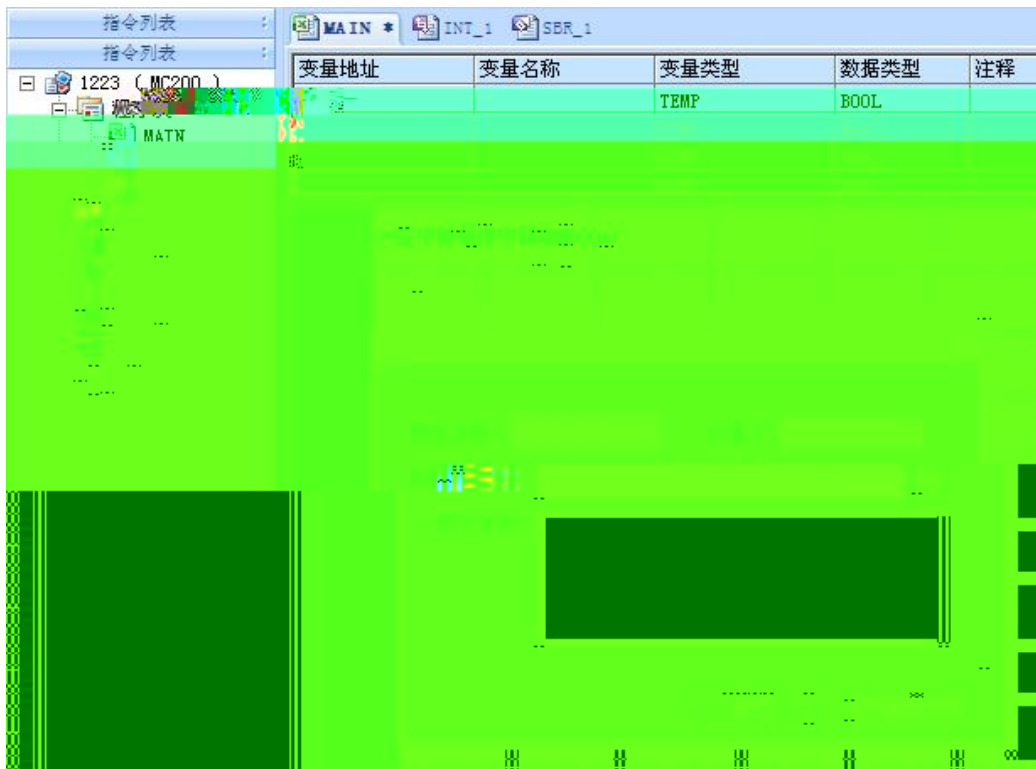
<7BH 8<G7=

&\$ &)

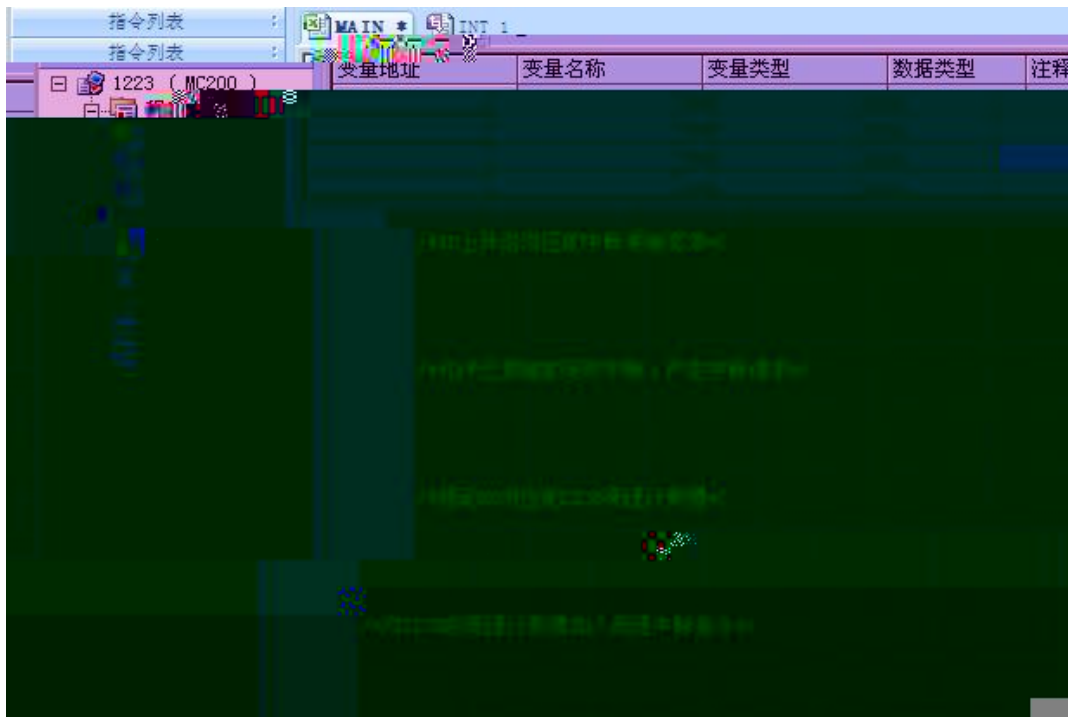
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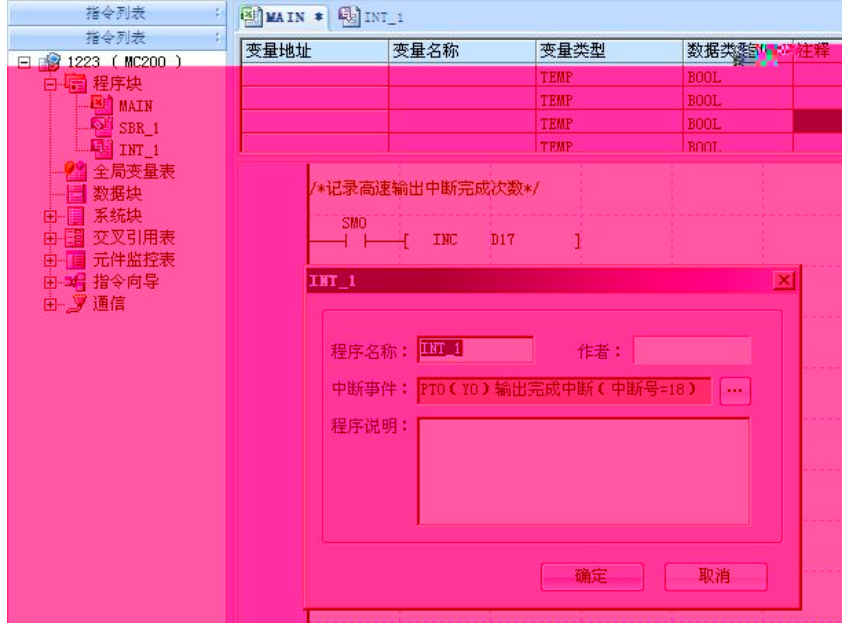


GA ** GA *(M\$ M% DHC

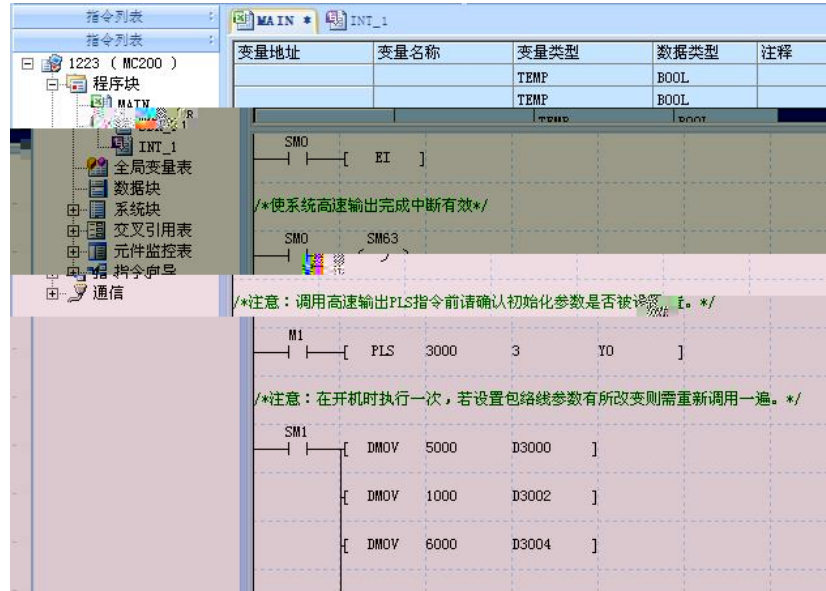
A 7%\$\$

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BHS%



& A 5-B DHC GA ** D@G



GA)*
A 7%\$\$

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

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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%\$" ", A cXVI g	\$
%\$" "- D@7	\$
%\$" "%A cXVI g	\$(
%\$" "%%	\$(
%\$" "%&	\$)
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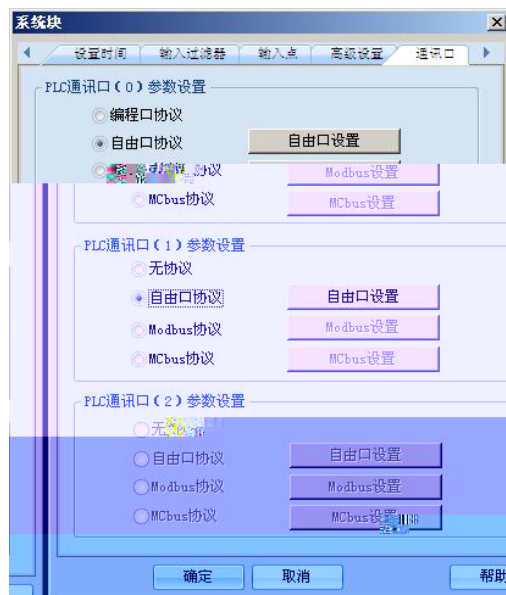
A 7&\$\$	\$	FG&' &	A cXVI g	A 7VI g
	%	FG&' & FG(,)	A cXVI g	A 7VI g
A 7%&\$\$	\$	FG&' &	A cXVI g	A 7VI g
	%	FG&' & FG(,)	A cXVI g	A 7VI g
A 7& \$	\$	FG&' &	A cXVI g	A 7VI g
	%	FG(,)	A cXVI g	A 7VI g
	&	FG(,)	A cXVI g	A 7VI g

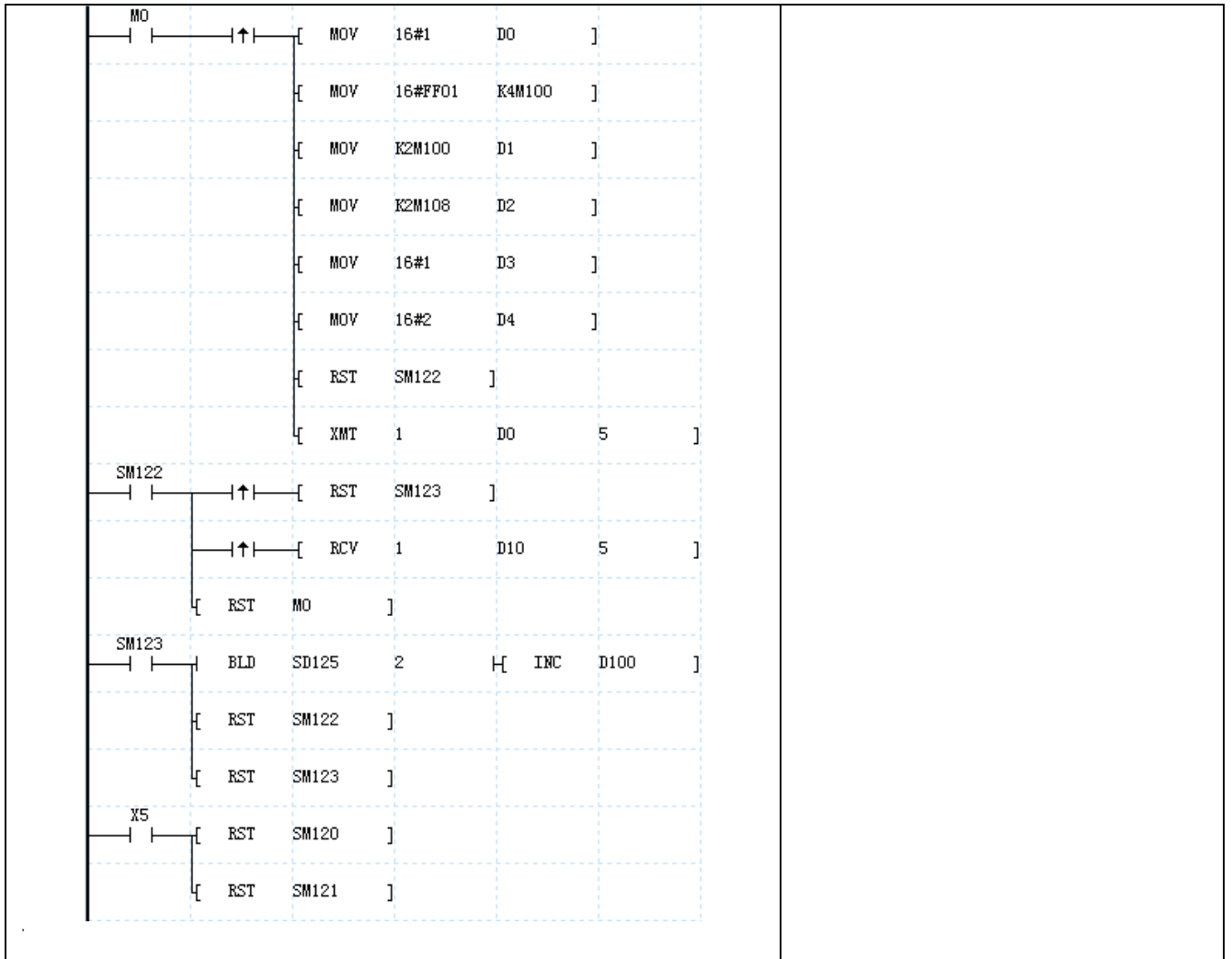
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D@7 FI B LAH F7J





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D@7A cXVI g

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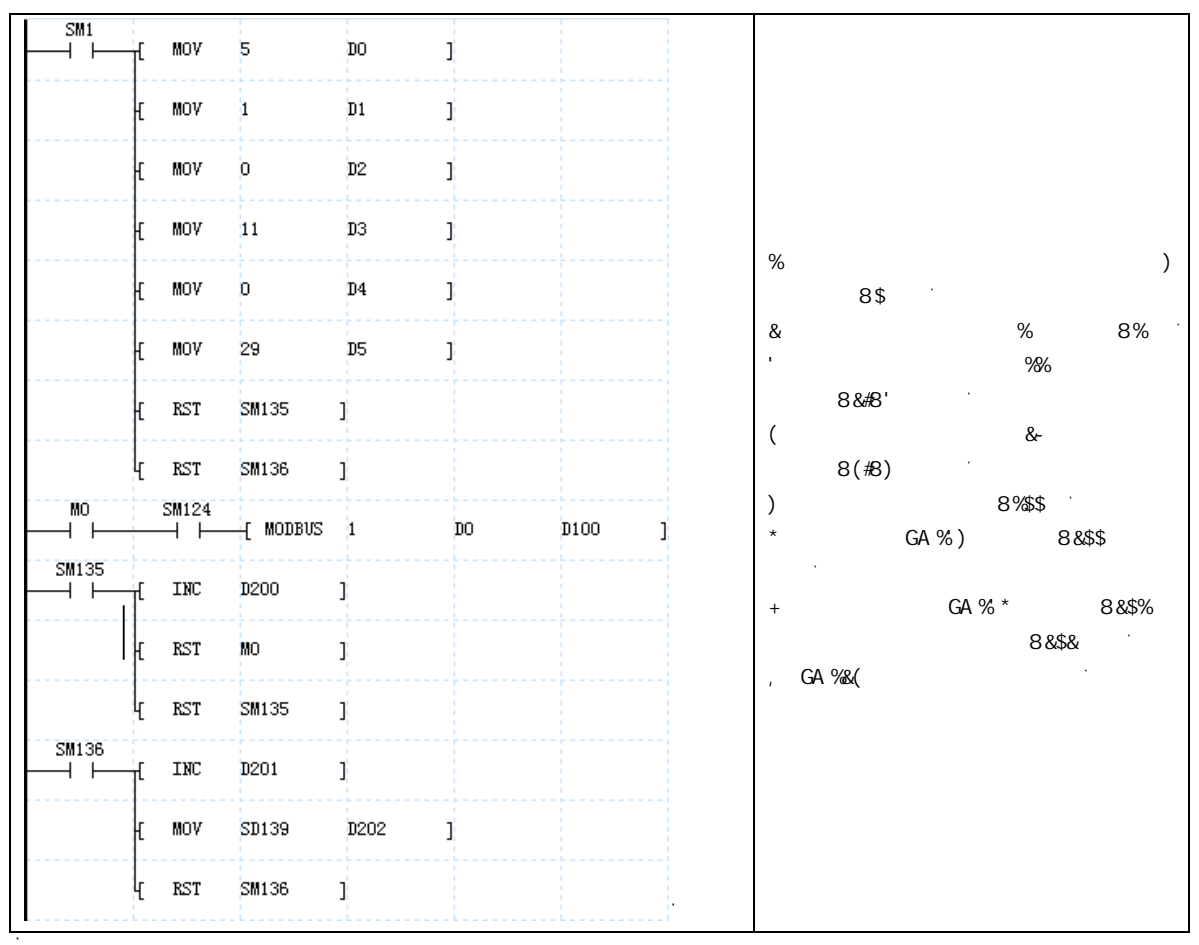
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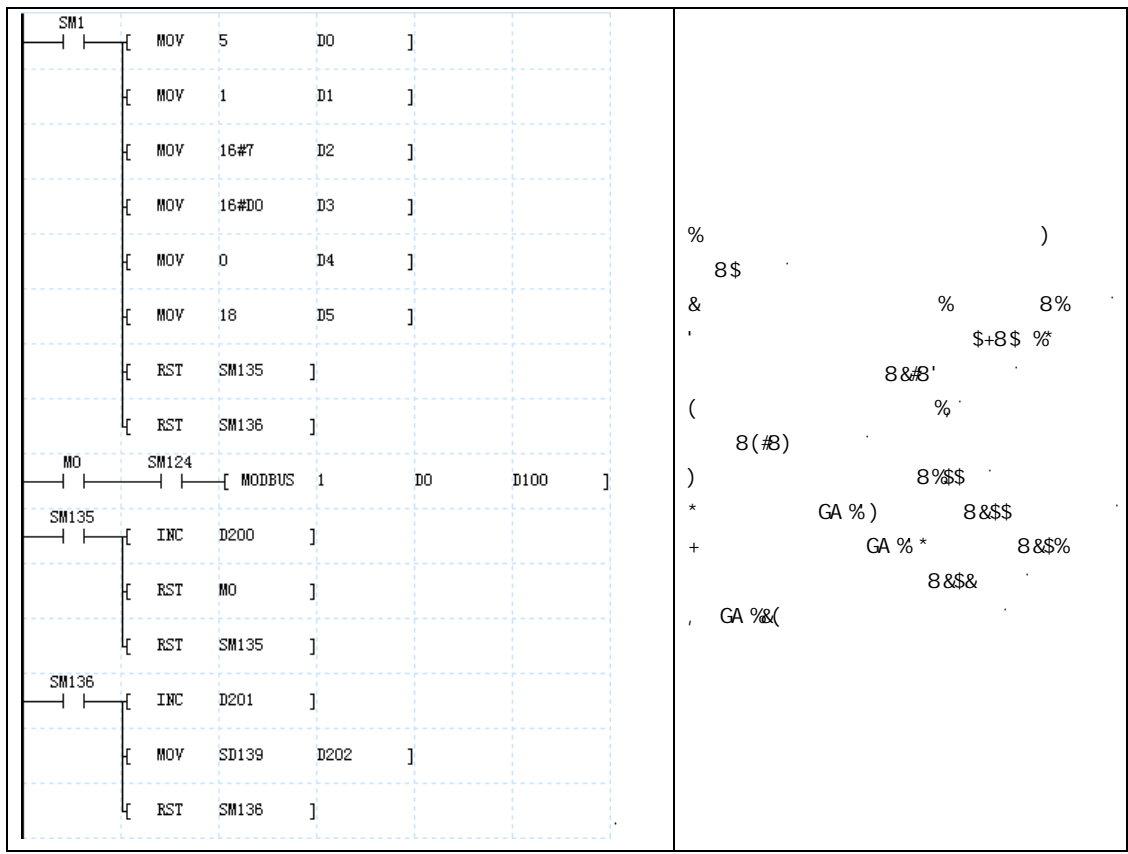
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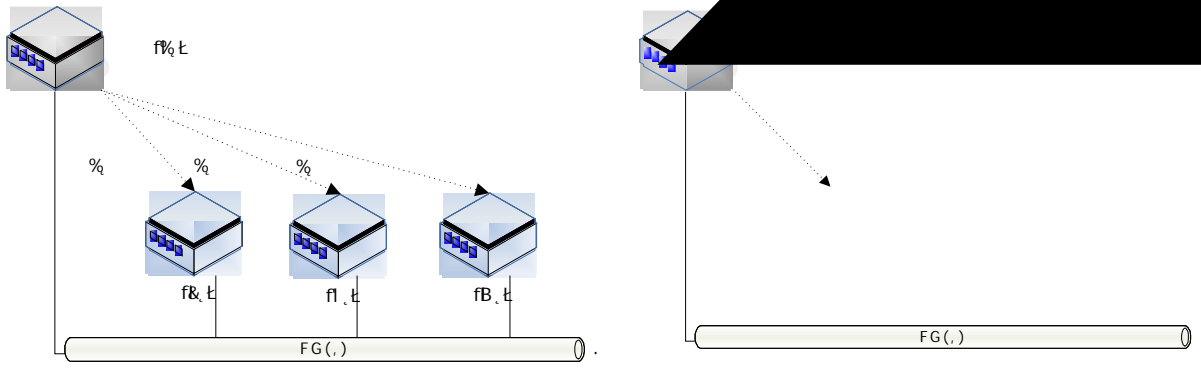
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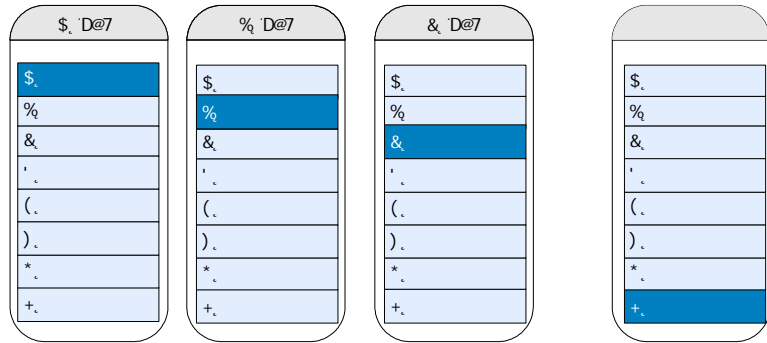
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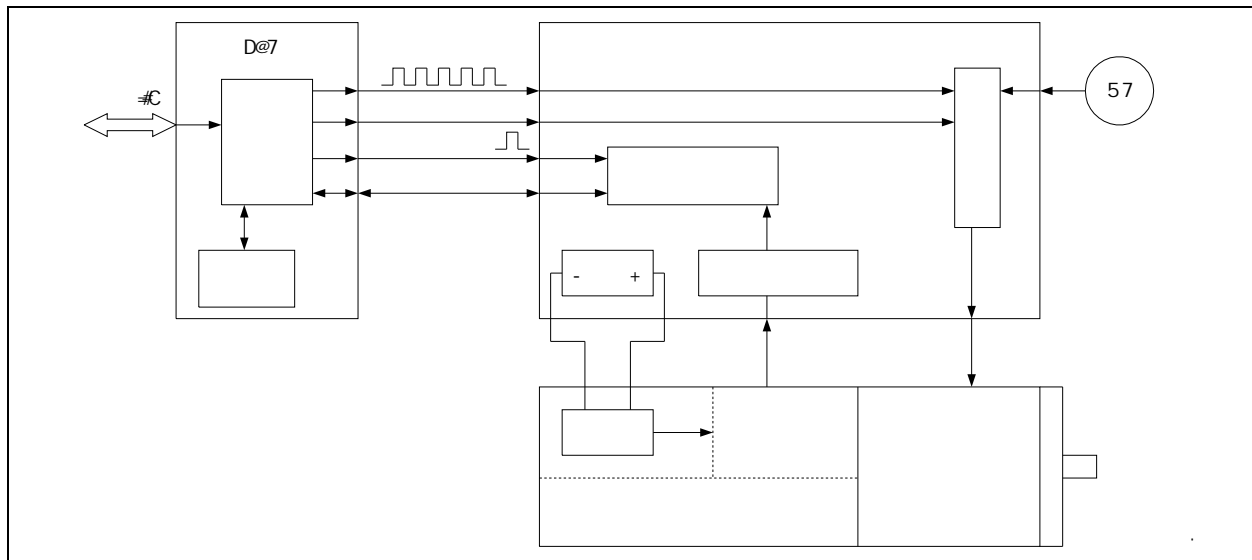
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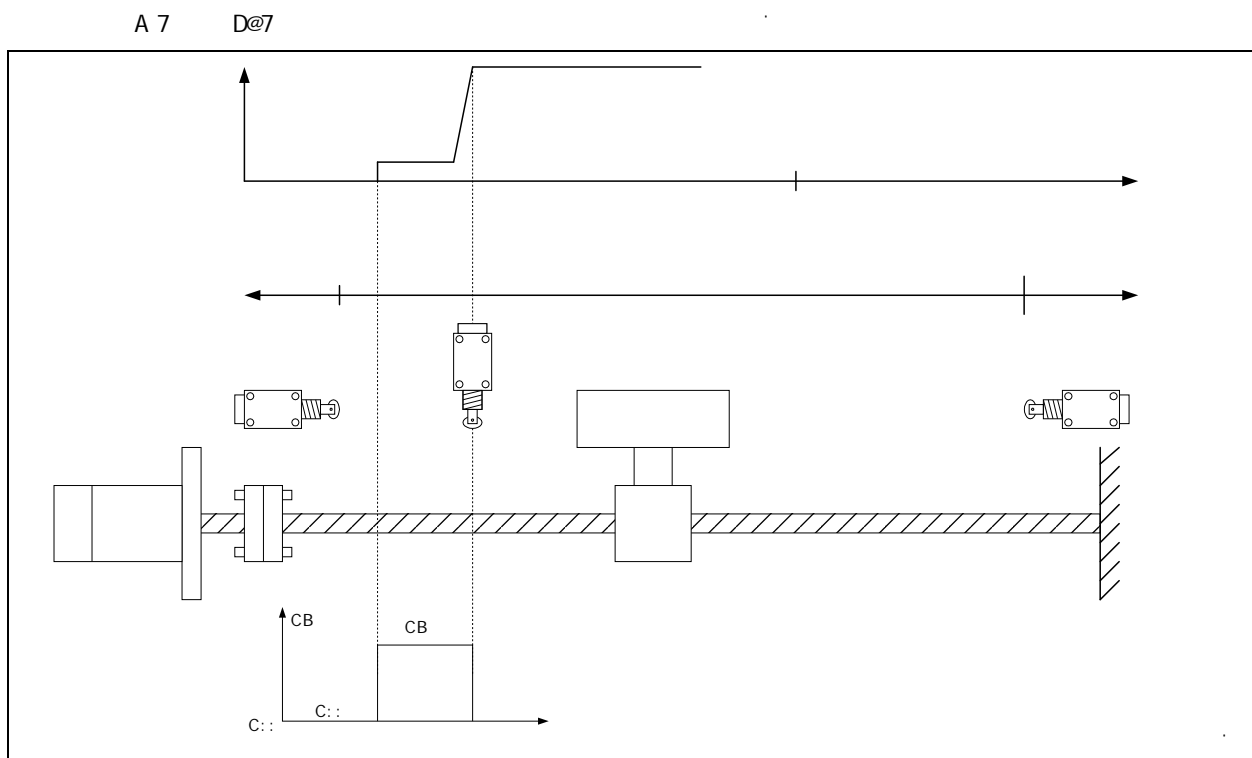
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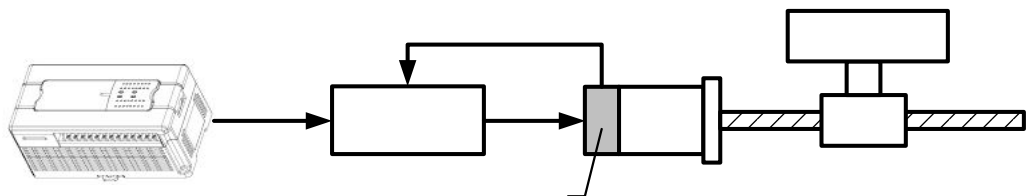
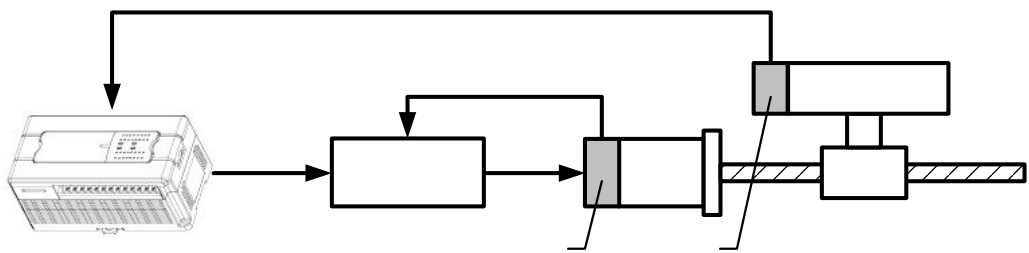
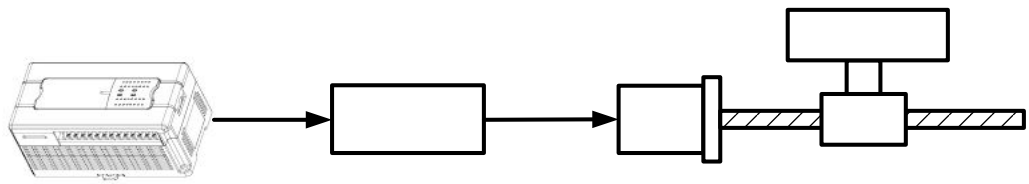
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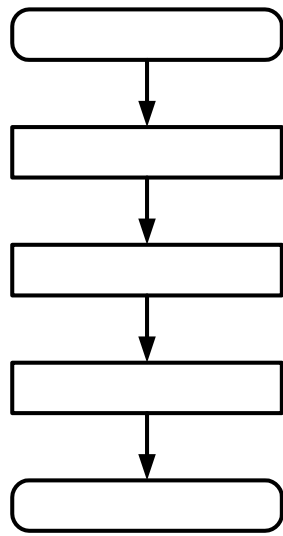
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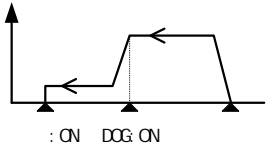
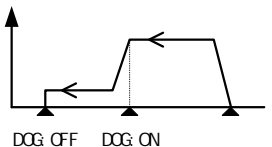
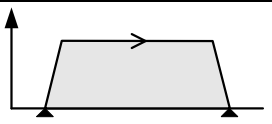
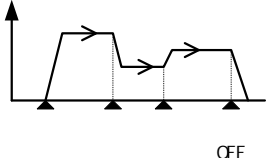
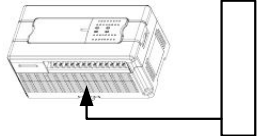
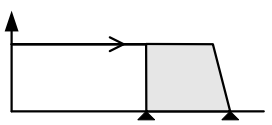
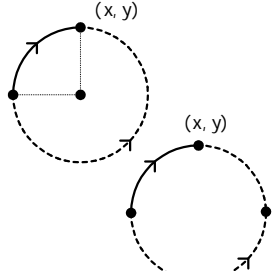
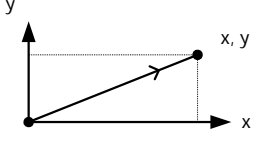
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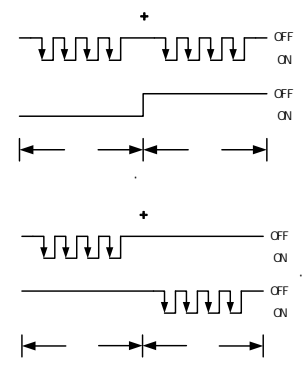
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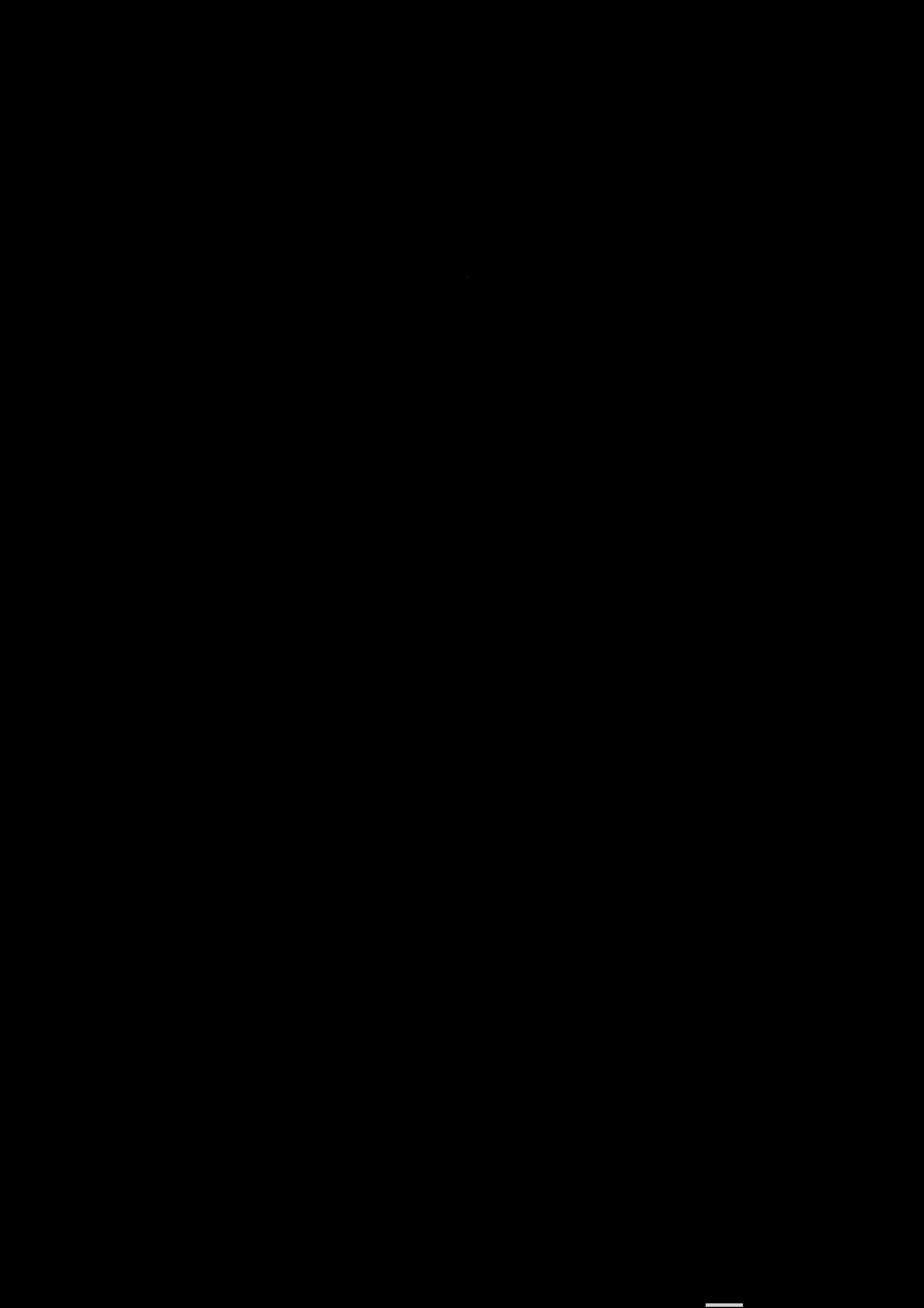
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GA &*		M&	F#
GA &+&		M& Vi gm CB fUXm C::	F
GA +&		M&	F#
GA ' &\$		8GNF #NFB M& 7@F	F#
GA ' &%		8GNF M& GB' &* B M M B M/&	F#
GA ' &&		8GNF M&	F#
GA ' &'		8GNF M&	F#
GA ' &(8GNF M&	F#
GA ' &)		8GNF M& C:: CB CB CB	F#
GA ' &*		8GNF M& C:: CB CB	F#
GA ' &+		M& 8J +'	
GA ' &		8GNF M& Vi gm CB fUXm C::	F#
GA ' &-		M& 8J +'	
GA ' &\$ M/& % 7@F &\$a g%			

GB' %\$	&	GB' %\$ GB' %%	F#
GB' %%	&		F#
GB' &\$	&	GB' &\$ GB' &%	F#
GB' &%	&	' & GB' &\$	F#
GB' &&	&	%\$ &\$\$\$\$	F#
GB' &'	&		F#
GB' &(&	%//\$	F#
GB' &)	&)\$)\$\$\$ a g	F#
GB' &*	&	GA ' &% B M M B	F#
GB' &+	&	8GNF	F#
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GB' &-	&		F#
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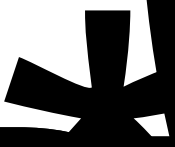
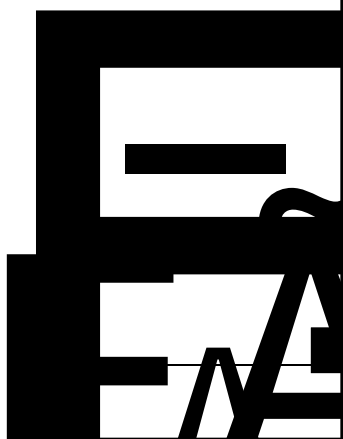
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		%#/\$	
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	B		



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		CB			CB	CB	
GA ')*		8 GNF M)			C::		F #
		CB			CB	CB	
GA '),		8 GNF	M)	Vi gn	CB fYUXm	C::	F #
	GA ')\$		M)	% 7@F			&\$a g%

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GA '* **		8 GNF	M*			C::	F #
		CB			CB	CB	
GA '* ,		8 GNF	M*	Vi gn	CB fYUXm	C::	F #
	GA '* \$		M*	% 7@F			&\$a g%

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G8' *)	*)\$)\$\$\$ a g	F#
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G8' *,	*		F#
G8' *-	*	8GNF	F#
G8' &&*	*	D@G	F
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GA' &+'		M+	F#
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GA' ++'		M+	F#
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GA & \$		8GNF #NF B M\$ 7@F		F#
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GA & ')		8GNF #BJ =H M\$		F#
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GA &)		8GNF M\$ CB CB C::		F#
GA & *		8GNF M\$ CB CB C::		F#
GA & +		8J =H M\$ CB C::		F#
GA & ,		8GNF #BJ =H M\$ Vi gn CB fYUXm C::		F#
GA & -	M\$	8J =H M\$ G8&(\$ L B L \$		F#
GA & * \$		8J =H M\$ M% GA & - GA & -		F#

GA & \$

M/\$ % 7@F

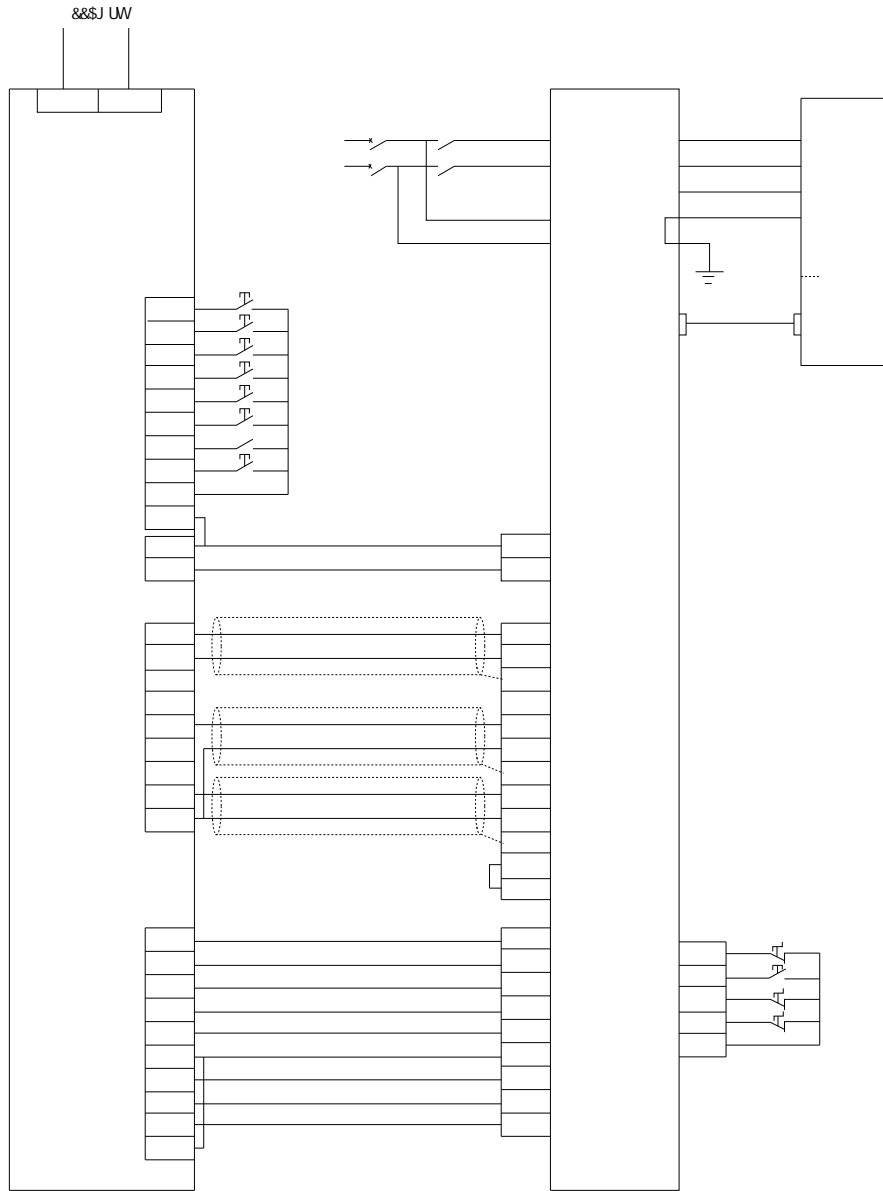
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G8 &)	\$) \$) \$ \$ a g	F #
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G8 & \$	\$	8 GNF		F #
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% G8 & \$ & G8 & \$)				
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GA & - \$		8 GNF #NF B	M% 7 @F	F #
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GA & - ' "		8 GNF #B J +H	M%	F #
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GA & -)		8 GNF CB	M% CB CB	F #
GA & - * "		8 GNF CB	M% CB CB	F #
GA & - +		8 J +H CB	M% CB CB	F #
GA & - ,		8 GNF #B J +H	M% Vi gm CB fYUXm	F #
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GA & - \$ M% % 7 @F & \$ a g %				

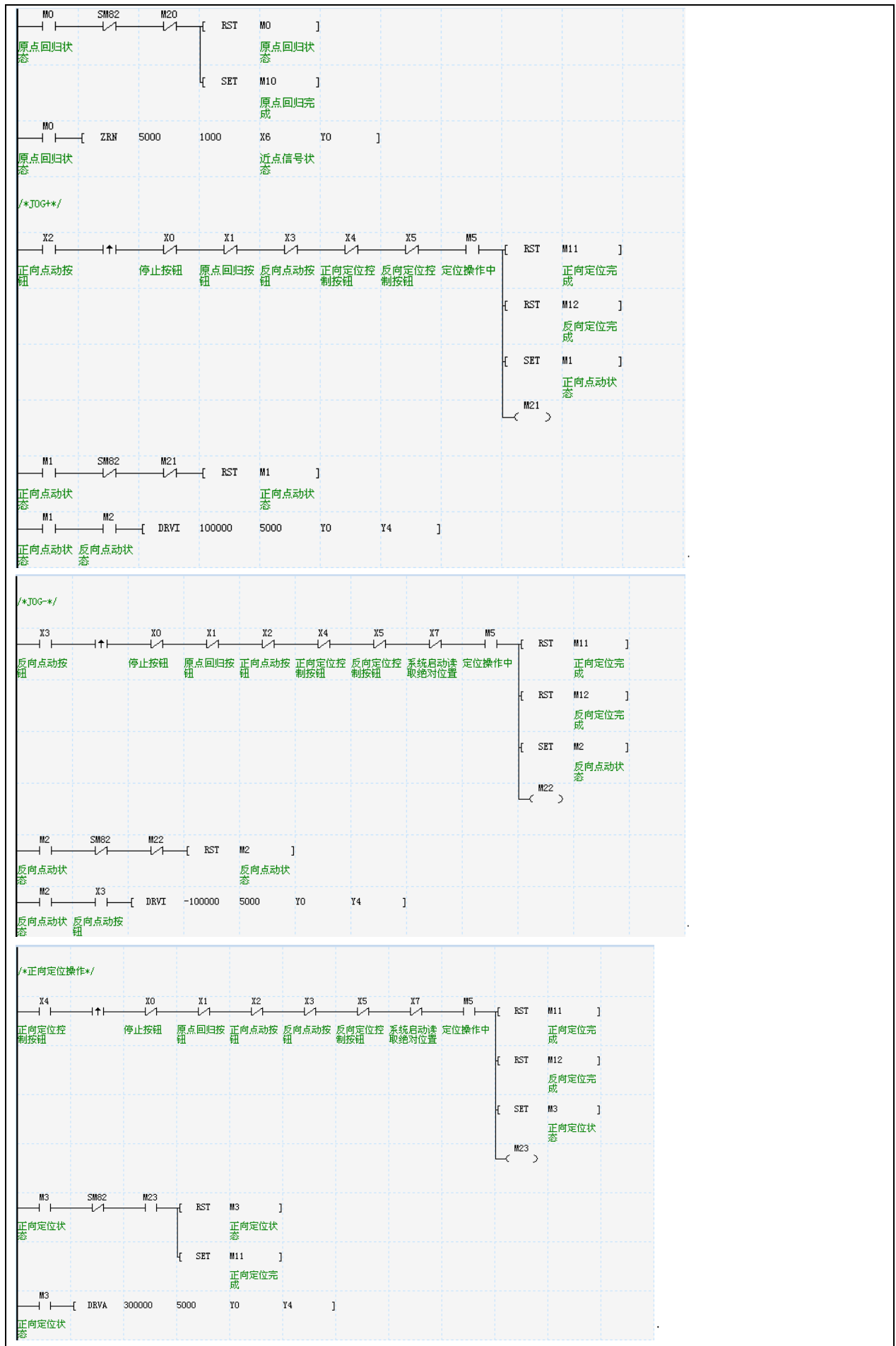
G8) \$	\$		F #
G8) %	\$	G8) \$ G8) %	F #
G8, \$	\$	G8, \$ G8, %	F #
G8, %	\$	' & G8, \$	F #
G8) &	%		F #
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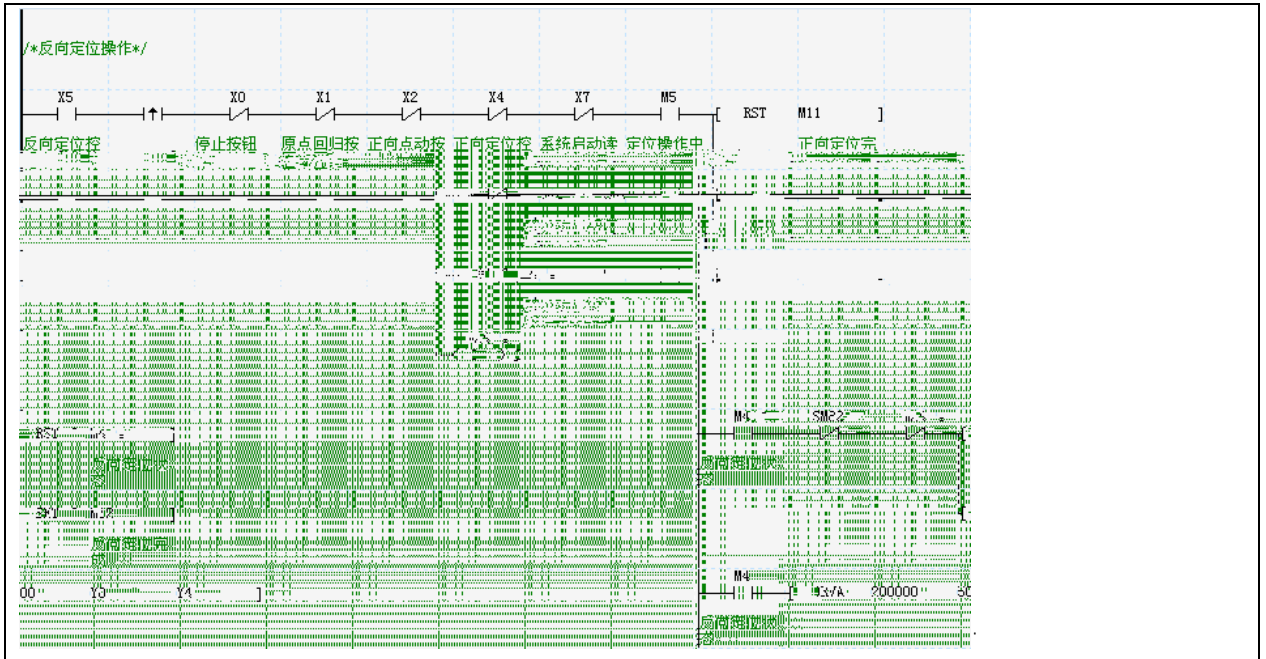
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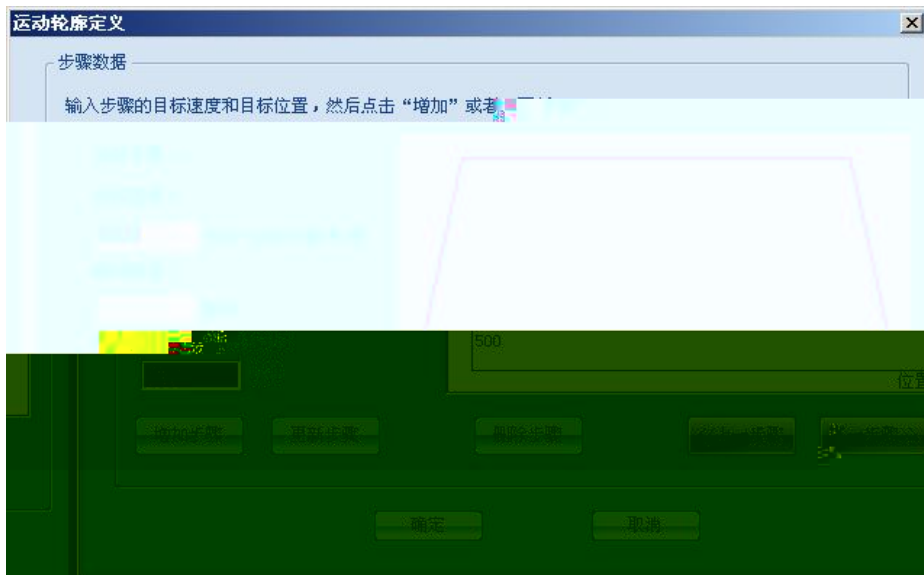
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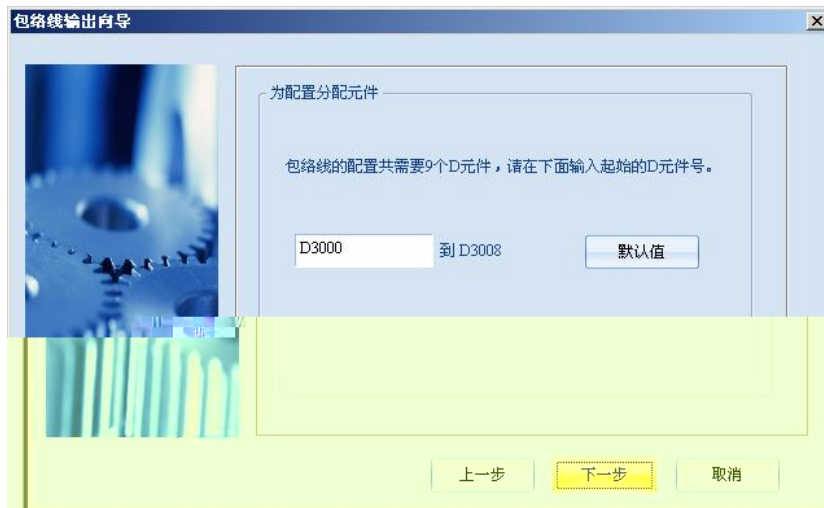
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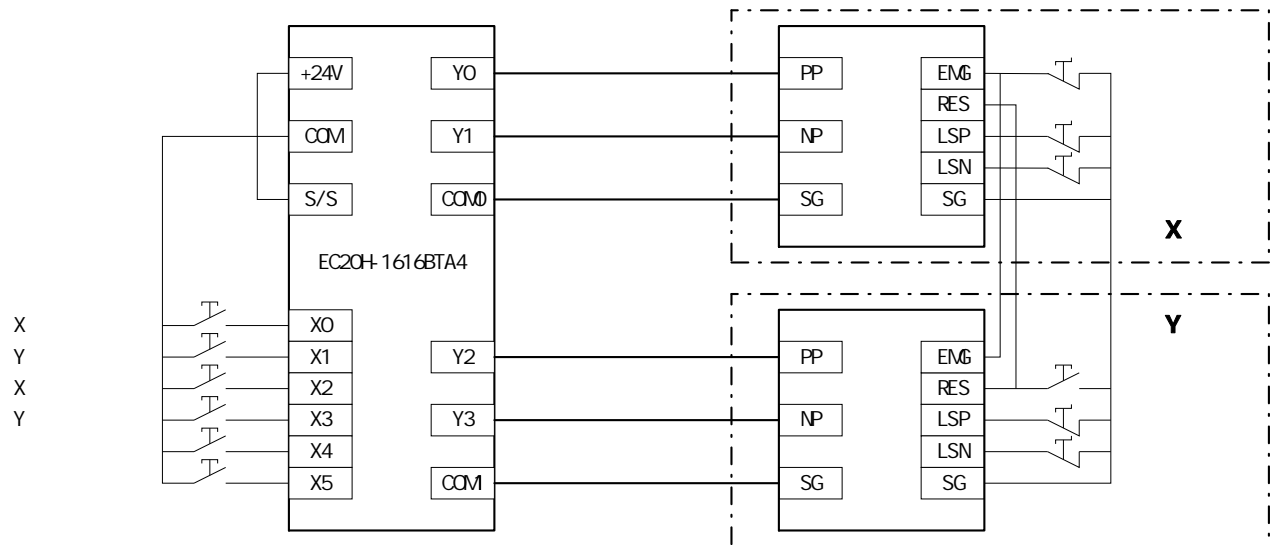
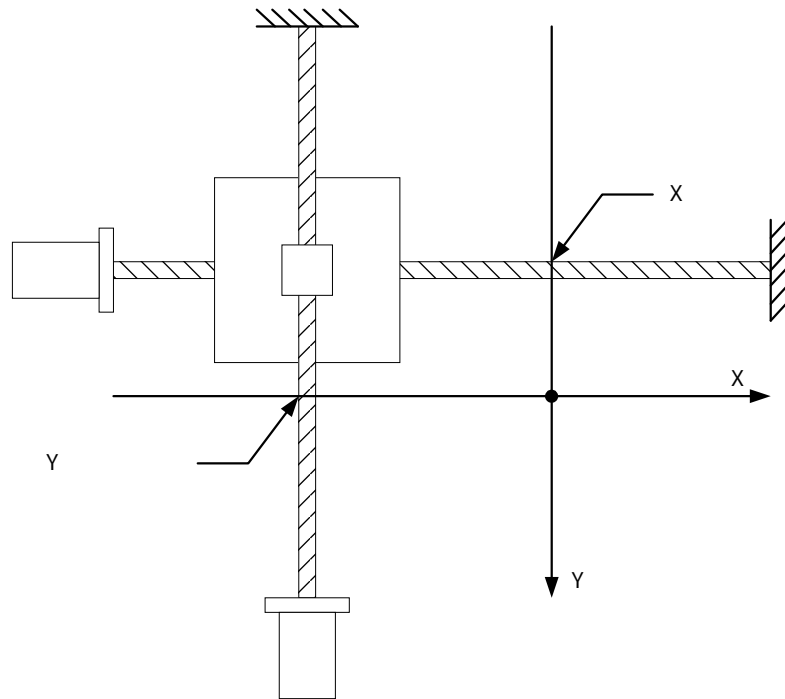
D@G

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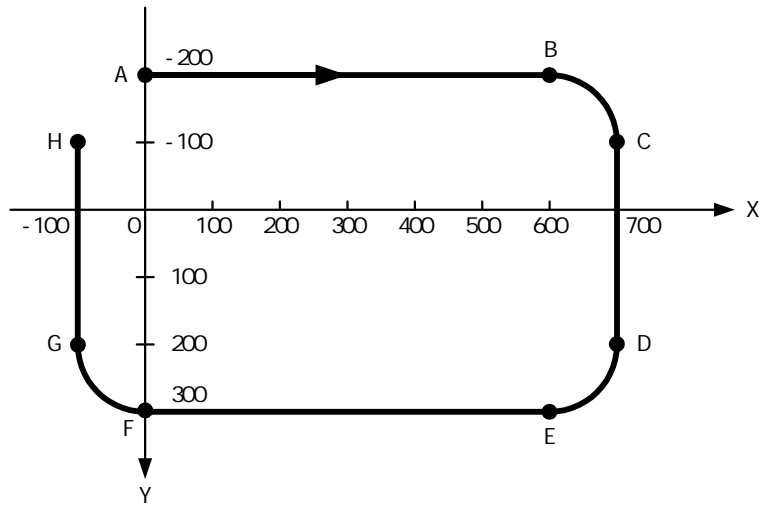
DHC





X
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X
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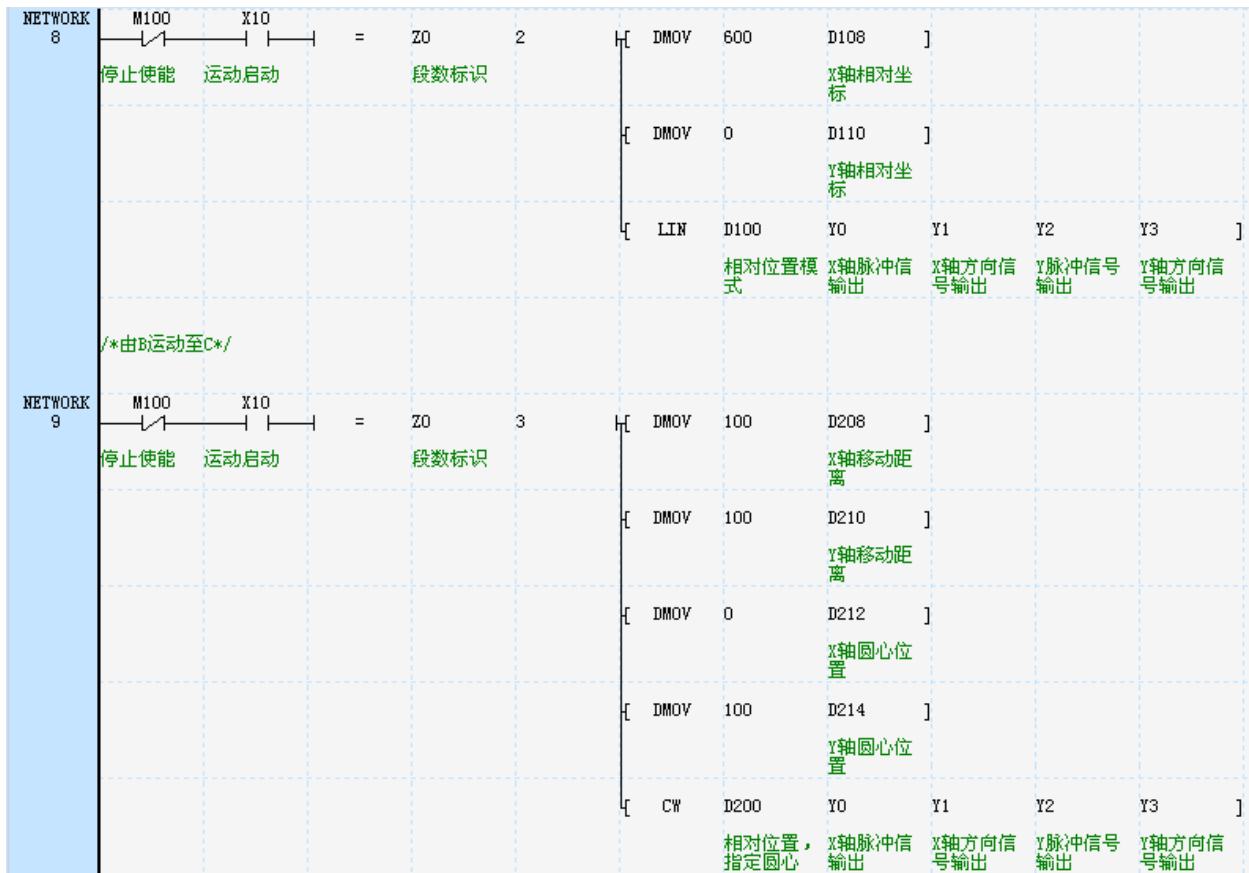
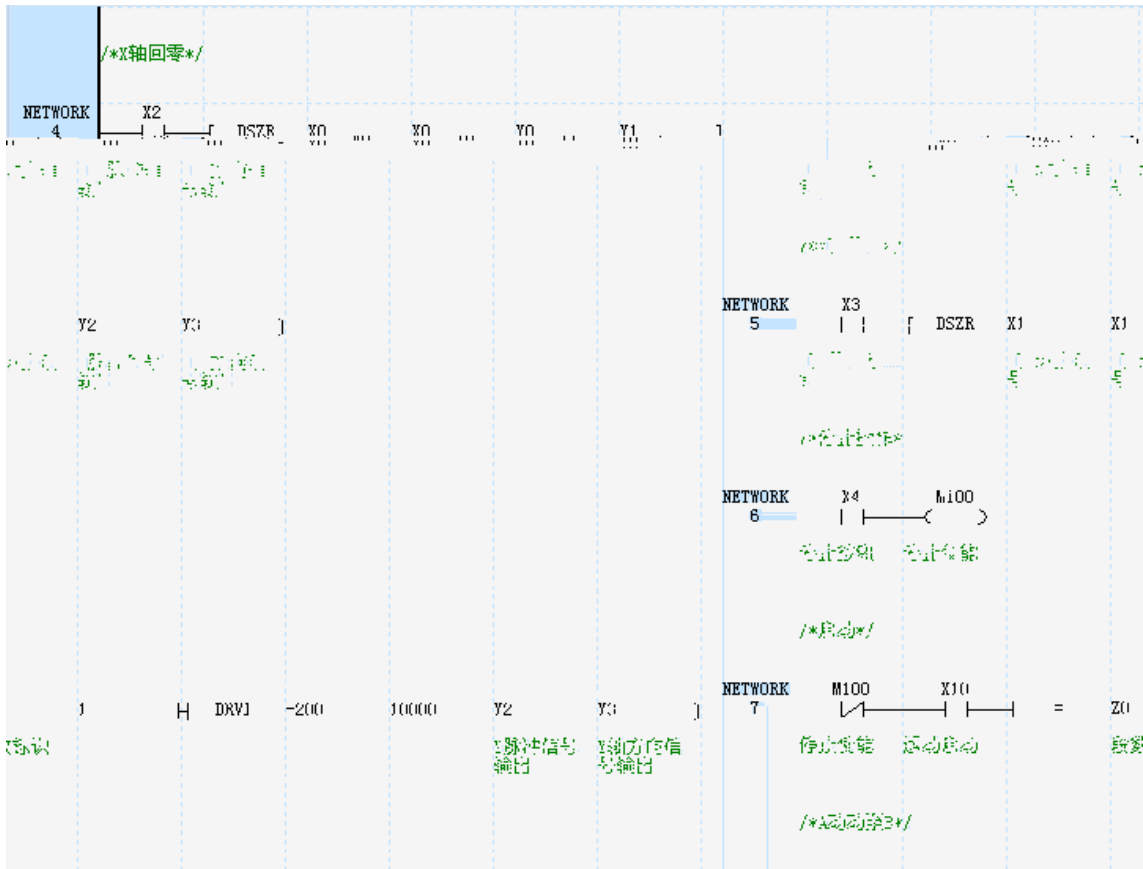
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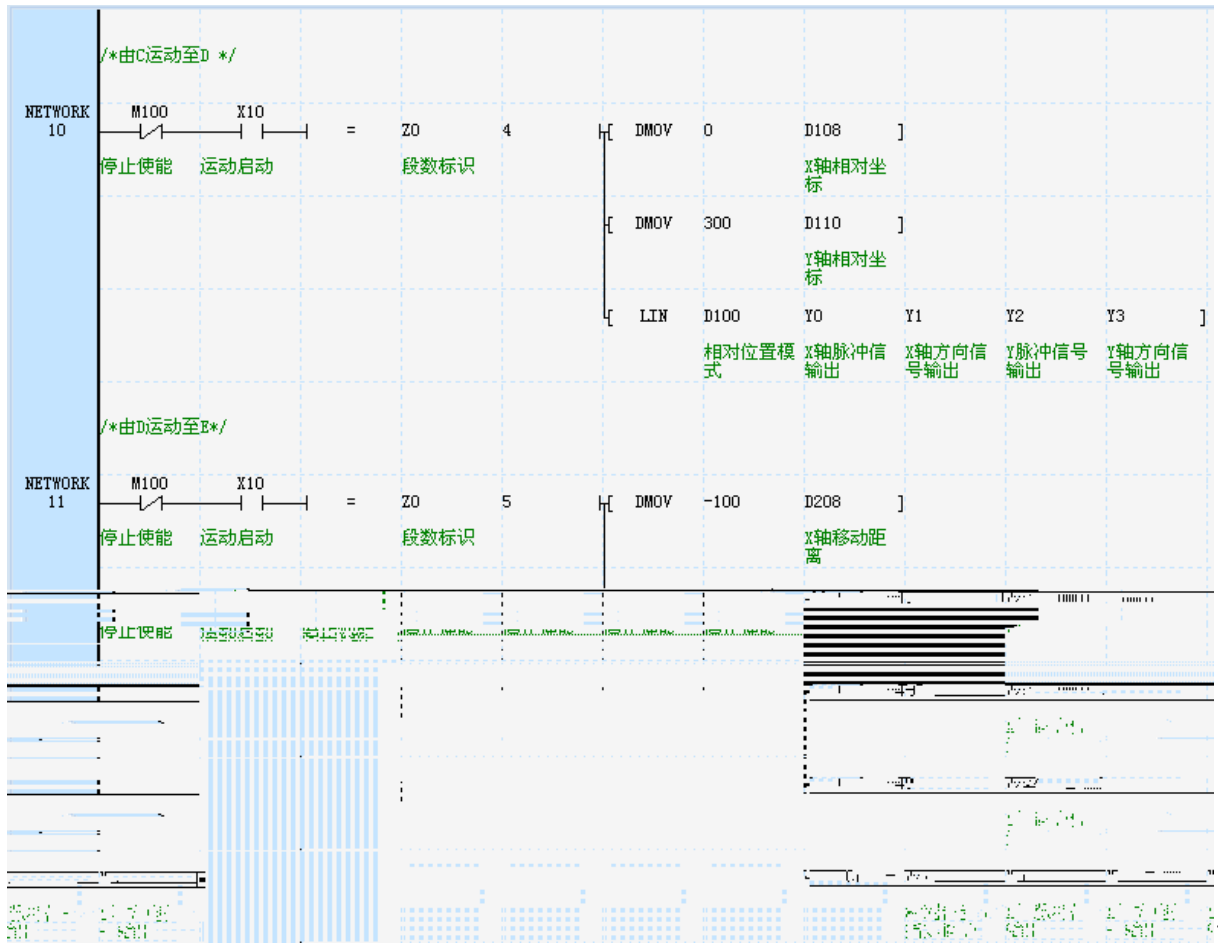


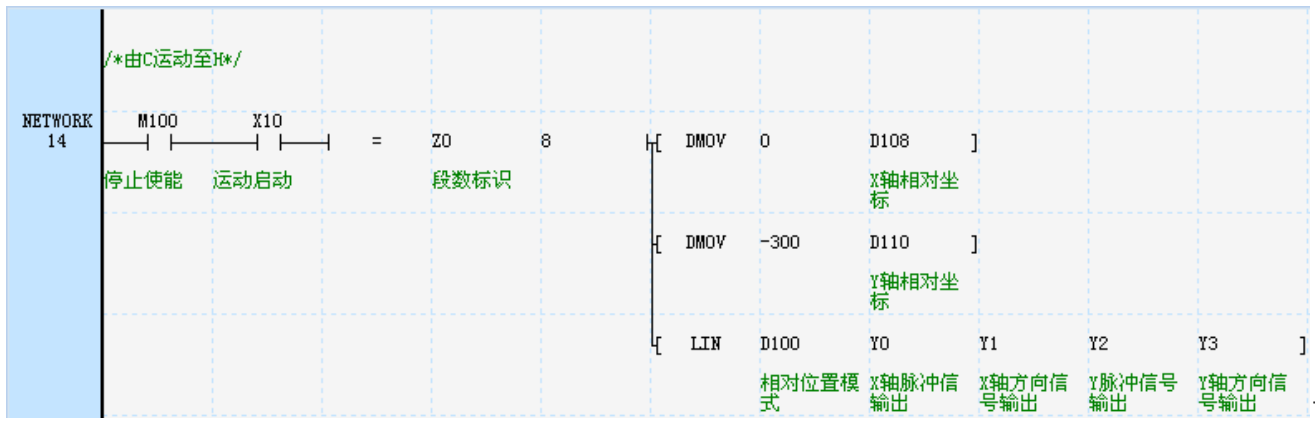
		/*初始化运动控制指令相关软元件*/			
NETWORK 0	SM1	[DMOV	0	D100]
					相对位置模式
		[DMOV	10000	D102]
					直线插补初始速度
		[DMOV	10000	D104]
					直线插补合成速度
		[DMOV	100	D106]
					直线插补减速时间
		[DMOV	0	D108]
					X轴相对坐标
		[DMOV	0	D110]
					Y轴相对坐标
NETWORK 1	SM1	[DMOV	0	D200]
					相对位置, 指定圆心
		[DMOV	10000	D202]
					圆弧插补保留

[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







GHCD→FI B



GB GA

GA

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GA + %		%			F			

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GA ,)			NFB	7@F			F #	
	M\$	CB			D@GM		F #	
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	D@GJ	CB					F #	

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GA - %	L%	L%			F #			
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GA - ' "	L'	L'			F #			
GA - (L(L(F #			
GA -)	L)	L)			F #			
GA - * "	L*	L*			F #			
GA - +	L+	L+			F #			
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GA %\$(L* L+ 56 %				F #			

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GA %&\$	%	LAH	%	F#	
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GA %&&GA %& DCFH% A 7%\$\$ D@7
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SM32-SM34

PORT 2
Modbus FREEPOR

SM32-SM34

MC200 PLC 485

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GA &\$\$+	7&\$\$+			F#		
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GA &\$\$-	7&\$\$-	F#				
GA &' \$	7&' \$	GA &SS	7&SS	F#		
GA &' %	7&' %	GA &SS	7&SS	F#		
GA &' &	7&' &			F#		
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GA &SS

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	GA ' \$%	7' \$%			F'		
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GA &*(M\$(\$	M\$(\$					F#
GA &*)	M\$)	M\$)					F#
GA &*\$	M\$*	M\$*					F#
GA &*\$	M\$+	M\$+					F#
GA &+%	M\$% Vi g#fYUXm	M\$%					F'
GA &+&	M\$& Vi g#fYUXm	M\$&					F'
GA &+'	M\$' Vi g#fYUXm	M\$'					F'
GA &+(\$	M\$(\$ Vi g#fYUXm	M\$(\$					F'
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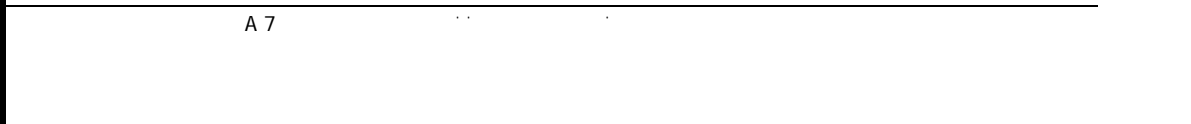
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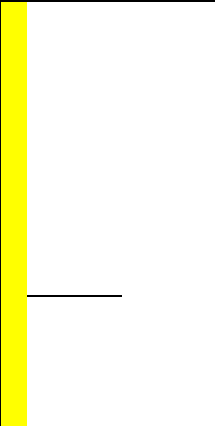
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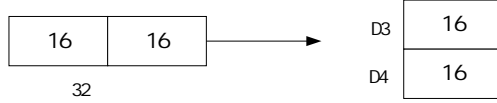
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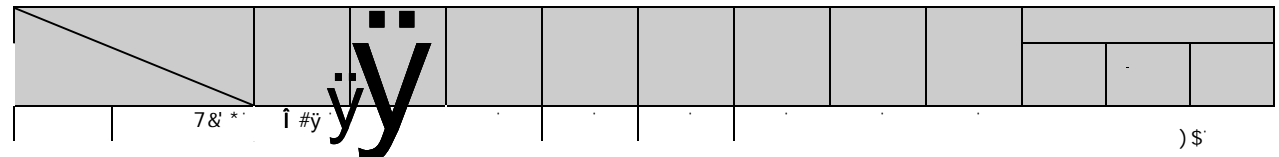
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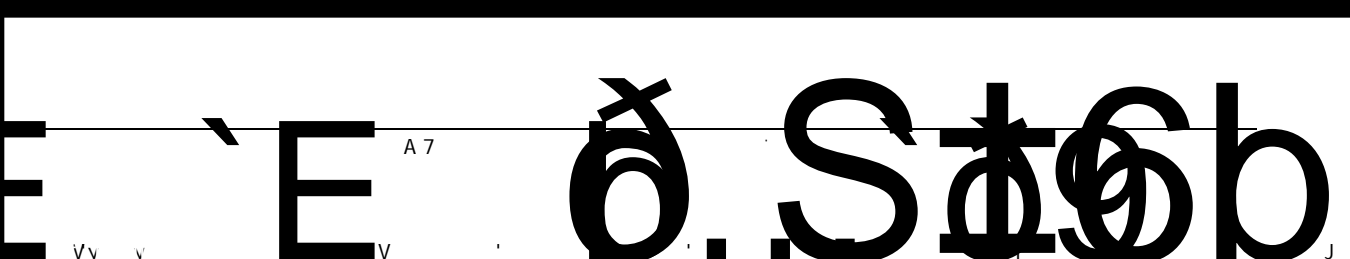
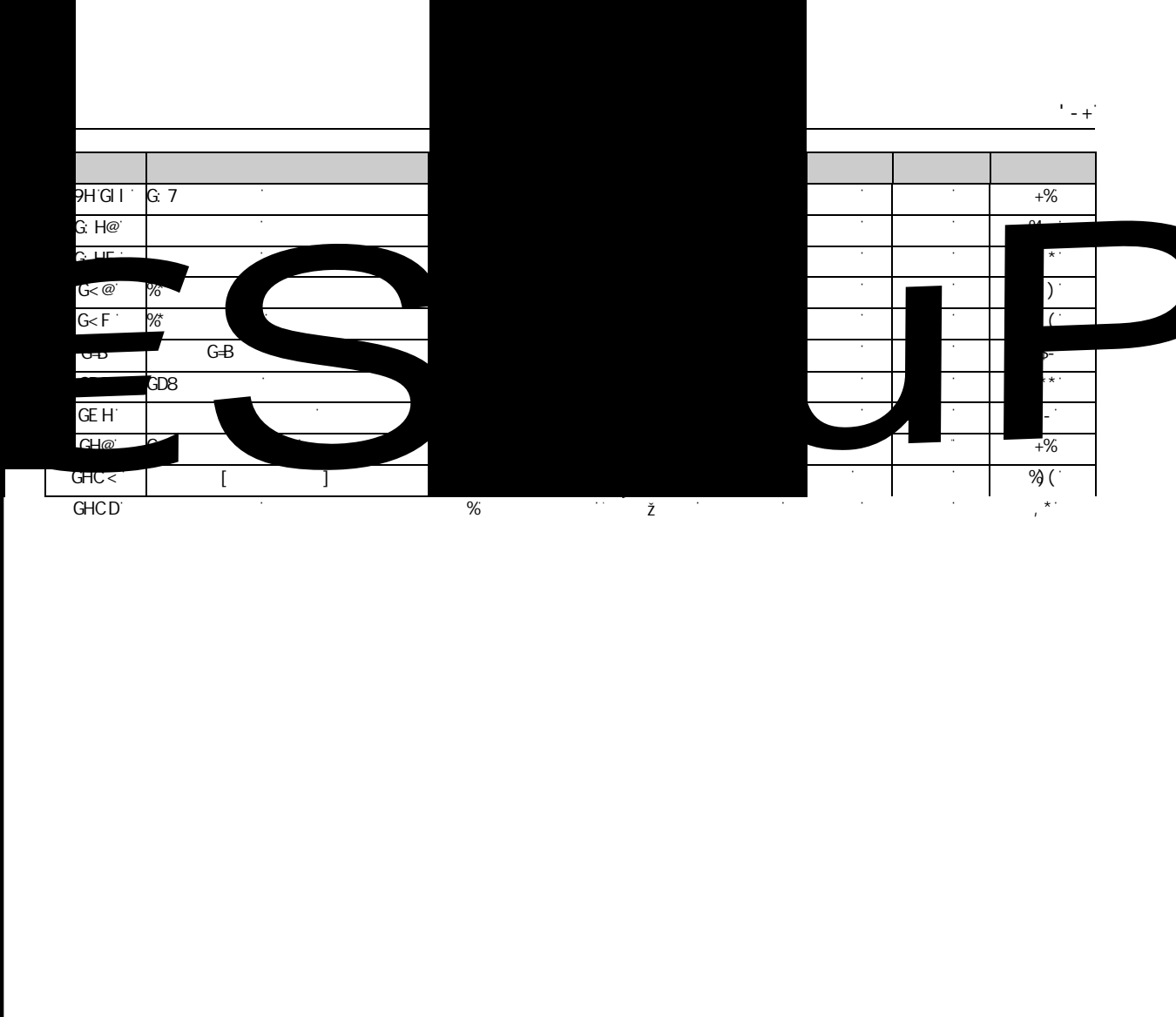
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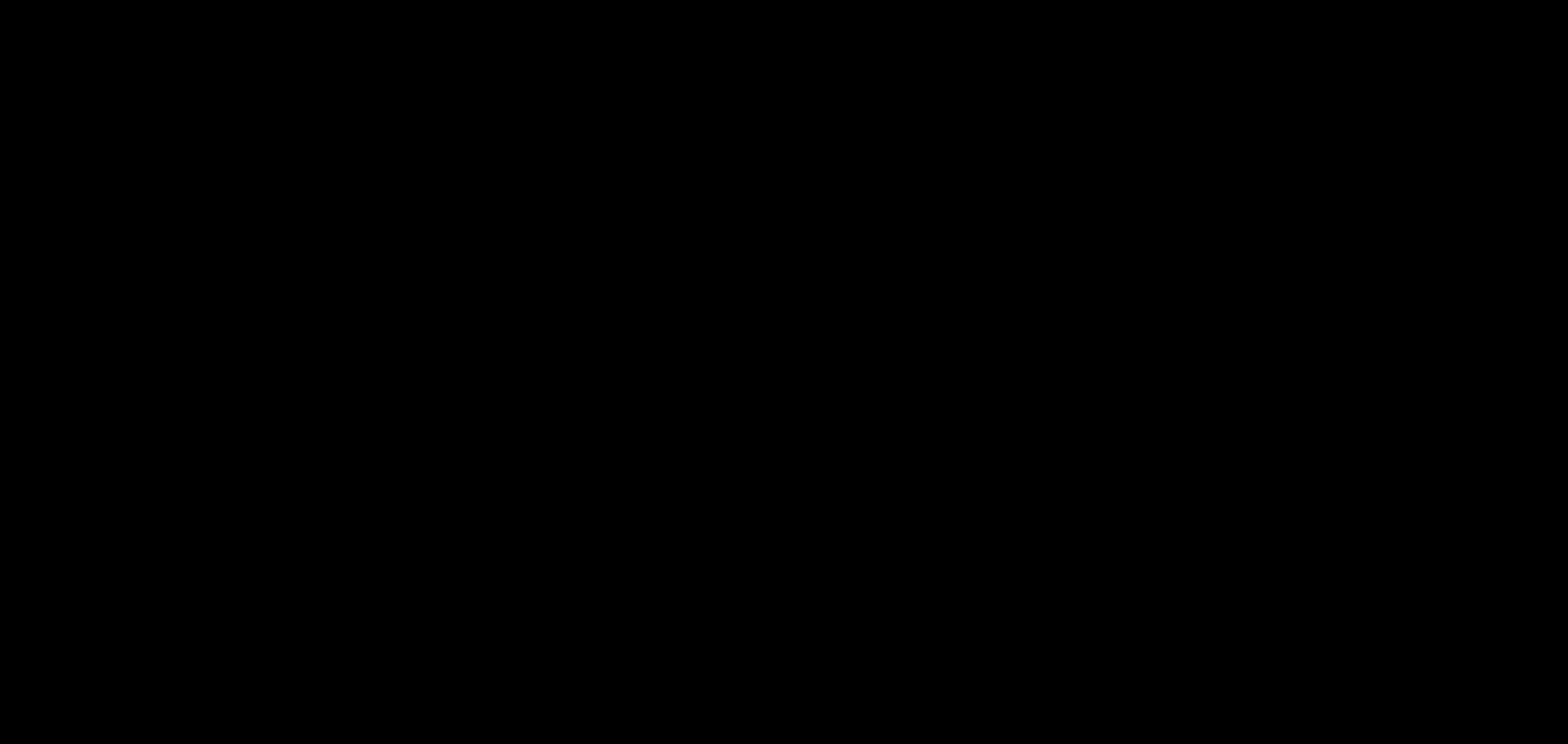
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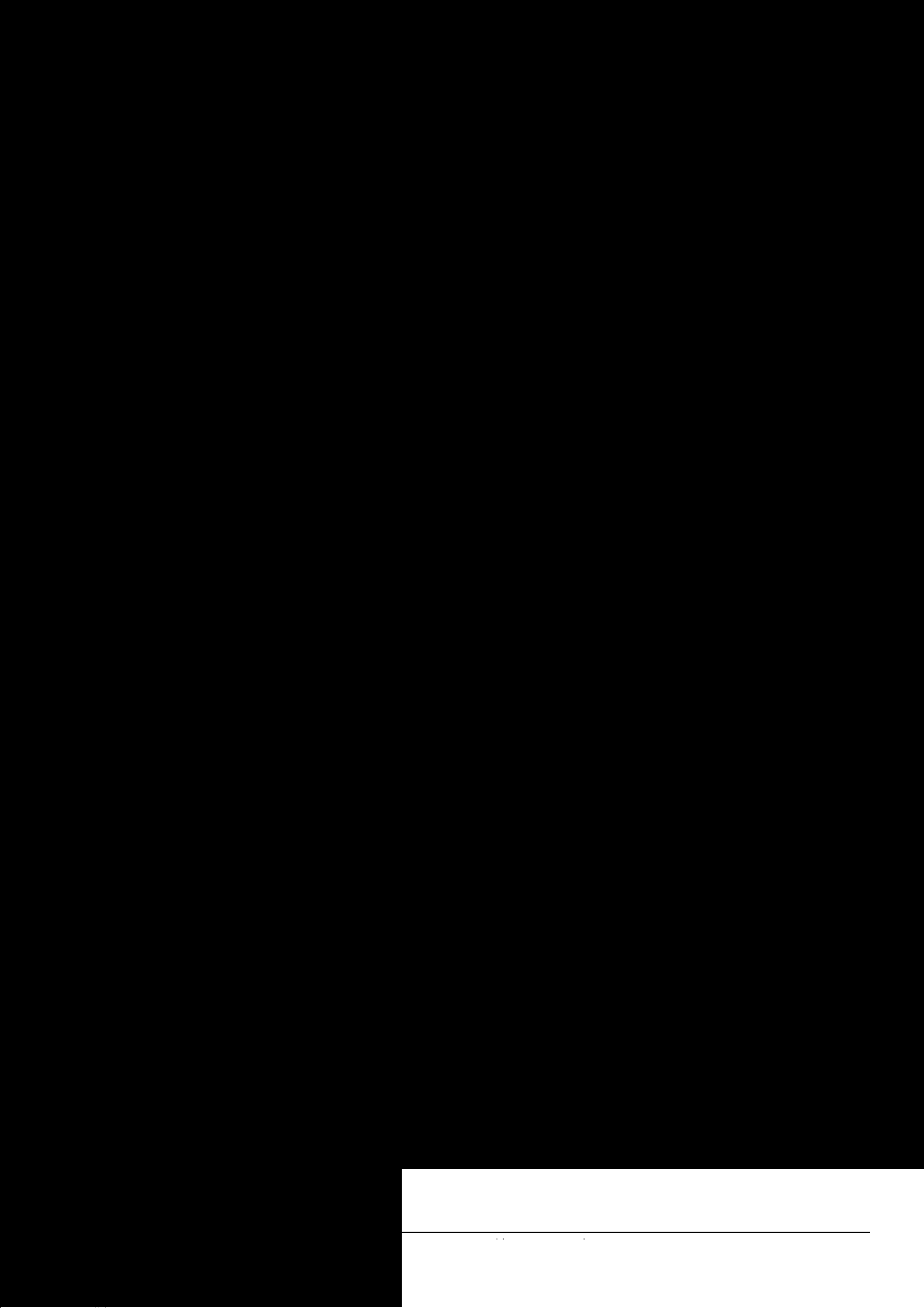


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