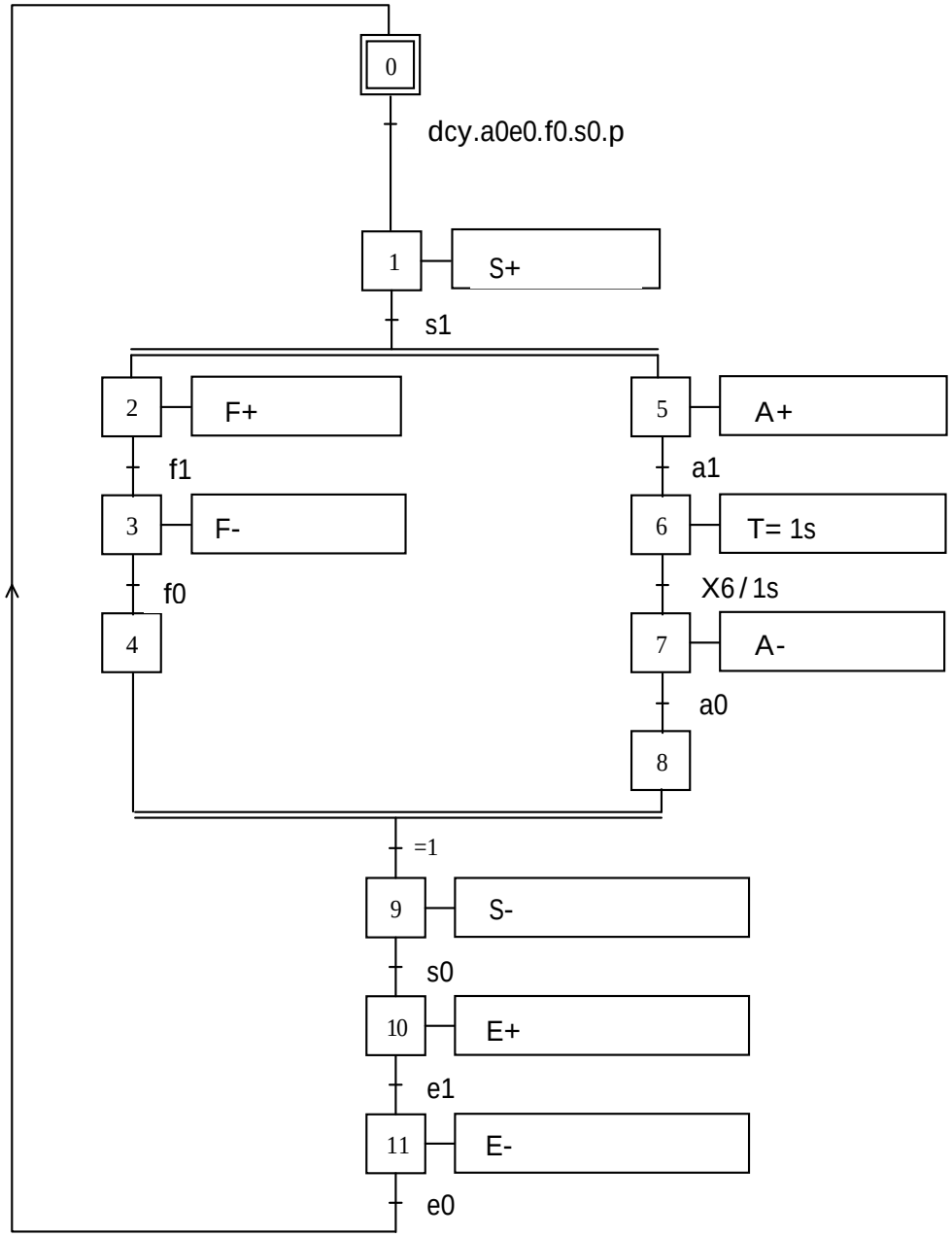
Grafcet de point de vue partie commande



Mise en équations partielle

$X0 = (X11.e0 + X0).\overline{X1}$
$X1 = (X0.\ dcy.a0e0.f0.s0.p + X1).\overline{X2.X5}$
$X2 = (X1.s1 + X2).\overline{X3}$
$X5 = (X1.s1 + X5).\overline{X6}$
$X4 = (X3.f0 + X4).\overline{X9}$
$X9 = (X3.X8 + X9).\overline{X10}$
$A+ = X5$

Programme Abel partiel

```
Module usinage

Declarations

Usinage device ‘P22V10’ ;
dcy, a0, a1, e0, e1 f0, f1 ,s0, s1, p  pin 1, 2, 3, 4, 5 ,6, 7, 8, 9, 10 ;
A1 , A0, E1 , E0-, F1 , F0, S1 , S0, T  pin 14, 15, 16, 17, 18, 19, 20, 21, 22  istype ‘com’;
X0..X11 node istype’reg’;

equations

X0 :=  (X11&e0 # X0)& ! X1 ;
…..

A1 = X5 ;
….

End usinage
```