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OPERAND	SYMBOL	KOMMENTAR
E 0.0	45A3	UP.EXTR. MOTOR EXCESS TEMP MOT WINDING
E 0.1	45A6	UP.EXTR. CARBON BRUSH CONTROL
E 0.2	43A1.1	UP.EXTR. DC-CONVERTER TEMP. CONTROL
E 0.3	43A1.2	UP.EXTR. DC-CONVERTER FAULT
E 0.4	E 0.4	SPARE
E 0.5	45K1	UP.EXTR. MAIN CONTACTOR ATTRACTED
E 0.6	46Q1	UP.EXTR. AUX DRIVE GEAR LUBR. FAULT
E 0.7	46Q3	UP.EXTR. AUX DRIVE EXTERNAL FAN FAULT
E 1.0	50A3.1	BOT.EXTR. EXCESS TEMP MOT WINDING
E 1.1	50A3.2	BOT.EXTR. CARBON BRUSH CONTROL
E 1.2	48A1.1	BOT.EXTR. DC-CONVERTER TEMP. CONTROL
E 1.3	48A1.2	BOT.EXTR. DC-CONVERTER FAULT
E 1.4	E 1.4	SPARE
E 1.5	50K1	BOT.EXTR. MAIN CONTACTOR ATTRACTED
E 1.6	51Q1	BOT.EXTR. AUX DRIVE GEAR LUBR. FAULT
E 1.7	51Q3	BOT.EXTR. AUX DRIVE EXTERNAL FAN FAULT
E 2.0	64Q2	HYDRAULICS PUMP FAULT
E 2.1	72Q1	EXHAUST FRONT PLANT SECTION FAULT
E 2.2	72A7	EXHAUST FRONT PL. EXCESS TEM MOT WINDING
E 2.3	74K5	DRAW-OFF + SHRINKAGE CONVEYOR FAULT
E 2.4	78K5	CONVEYOR LINEAR CHECK WEIGHER FAULT
E 2.5	79Q2	EXHAUST CEMENTING 1 FAULT
E 2.6	79A7	EXHAUST CEM1 FAULT EXCESS TEMP MOT WIND
E 2.7	80Q2	SLAB FEEDER FAULT KNIFE MOTOR
E 3.0	82K5	SLAB FEEDER FAULT DC-CONV. CONVEYOR
E 3.1	86A3	EXTR.CAL. EXCESS TEMP MOT WINDING
E 3.2	84A1/1	EXTR.CAL. TEMPERATURE CONTROL
E 3.3	84A1/2	EXTR.CAL. DC-CONVERTER FAULT
E 3.4	E 3.4	SPARE
E 3.5	86K1	EXTR.CAL. MAIN CONTACTOR ATTRACTED
E 3.6	87Q1	EXTR.CAL. AUX DRIVE GEAR LUBR. FAULT
E 3.7	87Q3	EXTR.CAL. AUX DRIVE EXT.FAN FAULT OUTS.
E 4.0	87Q5	EXTR.CAL. AUX DRIVE EXT.FAN FAULT INSIDE
E 4.1	90K5	FEEDING BELT CALENDER FAULT
E 4.2	93A3	CALENDER FAULT EXCESS TEMP MOT WINDING
E 4.3	93A6	CALENDER CARBON BRUSH CONTROL
E 4.4	91A1/1	CALENDER FAULT DC-CONVERTER TEMP.
E 4.5	91A1/2	CALENDER FAULT DC-CONVERTER
E 4.6	E 4.6	SPARE
E 4.7	93K1	CALENDER MAIN CONTACTOR ATTRACTED
E 5.0	96Q1	CALENDER FAULT OIL PUMP
E 5.1	96Q4	CALENDER FAULT EXTERNAL FAN OUTSIDE
E 5.2	96Q6	CALENDER FAULT EXTERNAL FAN INSIDE
E 5.3	97Q1	CALENDER FAULT MOTOR HYDRAULIC BRAKE
E 5.4	94Q1	ROLLSLIT DRIVE 1 FAULT
E 5.5	95Q1	ROLLSLIT DRIVE 2 FAULT
E 5.6	98Q1	CALENDER KNIFE DRIVE 1 FAULT
E 5.7	98Q3	CALENDER KNIFE DRIVE 2 FAULT
E 6.0	101K5	CONVEYOR CEMENTING 2 FAULT
E 6.1	102Q2	EXHAUST CEMENTING 2 FAULT
E 6.2	102A6	EXHAUST CEMENTING 2 EXCESS TEMP.MOT WIND
E 6.3	104K5	COOLING LINE PART 1 FAULT
E 6.4	106K5	COOLING LINE PART 2 FAULT
E 6.5	109K5	COOLING LINE PART 3 FAULT
E 6.6	111K5	COOLING LINE PART 4 FAULT
E 6.7	E 6.7	SPARE
E 7.0	107F1	WATER STATION FAULT
E 7.1	102A8	WATER EXCESS TEMP MOT WINDING
E 7.2	E 7.2	TEMPER. UNIT OPERATION
E 7.3	E 7.3	TEMPER. UNIT FAULT
E 7.4	114K5	KNIFE MIDDLE SEP.DEVICE FAULT
E 7.5	116K5	CENTERING CONVEYOR FAULT
E 7.6	121K5	ACCELERATING CONVEYOR FAULT
E 7.7	129K5	TREAD CHECK WEIGHER CONVEYOR FAULT
E 8.0	131Q1	SLOW-DOWN CONVEYOR FAULT
E 8.1	132Q1/Q3	END CEM. FAULT
E 8.2	133Q1	END CEM. EXHAUST FAULT
E 8.3	133A7	END CEM. EXHAUST EXCESS TEMP MOT WINDING
E 8.4	136Q1/Q3	TAKE-AWAY CONVEYOR FAULT
E 8.5	137Q1	LENGHT CUTTER RELEASE FAULT
E 8.6	27F2	CONTROL FUSE TRIGGERED 220V/50Hz
E 8.7	28SP0	E-STOP FEEDING LINE

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OPERAND	SYMBOL	KOMMENTAR
E 9.0	86A6	EXTR.CAL. CARBON BRUSH CONTROL
E 9.1	E 9.1	FEEDER CONVEYOR BELT FAN FAULT
E 9.2	E 9.2	SPARE
E 9.3	E 9.3	SPARE
E 9.4	E 9.4	SPARE
E 9.5	E 9.5	SPARE
E 9.6	E 9.6	SPARE
E 9.7	E 9.7	SPARE
E 10.0	E 10.0	DRIVE OVERTEMP 73M2 CONV. SHRINKING
E 10.1	E 10.1	DRIVE OVERTEMP 77M2 CONV. SCALE
E 10.2	E 10.2	DRIVE OVERTEMP 100M2 CONV. BOT. CEMENTER
E 10.3	E 10.3	FAN FAULT 141M1 CONV. SHRINKING
E 10.4	E 10.4	FAN FAULT 141M7 CONV. SCALE
E 10.5	E 10.5	FAN FAULT 142M2 CONV. BOTTOM CEMENTER
E 10.6	E 10.6	DRIVE OVERTEMP 115M2 CONV. CENT.+FEEDING
E 10.7	E 10.7	FAN FAULT 118M1 CONV. CENTERING+FEEDING
E 11.0	E 11.0	DRIVE OVERTEMP 128M2 CONV.CHECK WEIGHTER
E 11.1	E 11.1	FAN FAULT 130M1 CONV. CHECK WEIGHTER
E 11.2	E 11.2	SPARE
E 11.3	E 11.3	SPARE
E 11.4	E 11.4	SPARE
E 11.5	E 11.5	SPARE
E 11.6	E 11.6	SPARE
E 11.7	E 11.7	SPARE
E 20.0	A320	UPPER EXTRUDER E-STOP HOPPER
E 20.1	234S2	UPPER EXTRUDER WATERCOOLING
E 20.2	234S3	UPPER EXTRUDER OIL FLOW TO LOW
E 20.3	234S4	UPPER EXTRUDER OIL PRESSURE TO LOW
E 20.4	234S5	UPPER EXTRUDER OIL COOLING ON
E 20.5	234S6	UPPER EXTRUDER TEMP TO HIGH
E 20.6	E 20.6	SPARE
E 20.7	E 20.7	SPARE
E 25.0	A420	BOTTOM EXTRUDER E-STOP HOPPER
E 25.1	239S2	BOTTOM EXTRUDER WATERCOOLING
E 25.2	239S3	BOTTOM EXTRUDER OIL FLOW TO LOW
E 25.3	239S4	BOTTOM EXTRUDER OIL PRESSURE TO LOW
E 25.4	239S5	BOTTOM EXTRUDER OIL COOLING ON
E 25.5	239S6	BOTTOM EXTRUDER TEMP TO HIGH
E 25.6	E 25.6	PRESSURE COOLING WATER OK
E 25.7	E 25.7	SPARE
E 30.0	244S1	CLAMPING RIGHT SIDE DOWN CLOSED
E 30.1	244S2	CLAMPING LEFT SIDE DOWN CLOSED
E 30.2	244S3	CLAMPING RIGHT SIDE UP CLOSED
E 30.3	244S4	CLAMPING LEFT SIDE UP CLOSED
E 30.4	244S5	CLAMPING RIGHT SIDE DOWN OPEN
E 30.5	244S6	CLAMPING LEFT SIDE DOWN OPEN
E 30.6	244S7	CLAMPING RIGHT SIDE UP OPEN
E 30.7	244S8	CLAMPING LEFT SIDE UP OPEN
E 31.0	245S9	INTERMEDIATE PART RIGHT SIDE CLOSED
E 31.1	245S10	INTERMEDIATE PART LEFT SIDE CLOSED
E 31.2	245S11	PROX.SWITCH MEDIUM PART OPEN
E 31.3	245S12	UPPER PART RIGHT SIDE CLOSED
E 31.4	245S13	UPPER PART LEFT SIDE CLOSED
E 31.5	245S14	PROX.SWITCH UPPER PART OPEN
E 31.6	245S15	RIGHT LOCKING CYLINDER LOCKING POSITION
E 31.7	245S16	LEFT LOCKING CYLINDER LOCKING POSITION
E 32.0	246S17	RIGHT LOCKING CYLINDER MOVED OUT
E 32.1	246S18	LEFT LOCKING CYLINDER MOVED OUT
E 32.2	246S19	RIGHT LOCKING CYLINDER HOME POSITION
E 32.3	246S20	LEFT LOCKING CYLINDER HOME POSITION
E 32.4	246S21	EJECTING DEVICE RIGHT SIDE CLOSED
E 32.5	246S22	EJECTING DEVICE LEFT SIDE CLOSED
E 32.6	246S23	EJECTING DEVICE RIGHT SIDE OPEN
E 32.7	246S24	EJECTING DEVICE LEFT SIDE OPEN
E 33.0	247S25	PROX.SWITCH MEDIUM PART UNLOCKED
E 33.1	247S26	PROX.SWITCH UPPER PART UNLOCKED
E 33.2	247S27	CASSETTE RIGHT SIDE INSTALLED
E 33.3	247S28	CASSETTE LEFT SIDE INSTALLED
E 33.4	247S29	PROX.SWITCH PRESS.TRANSDUCER MOVED OUT
E 33.5	247S30	CLAMPING HIGH PRESSURE BUILT UP : MIN HP
E 33.6	247S31	CLAMPING HIGH PRESSURE BUILT UP : MAX HP
E 33.7	247S32	CLAMPING HIGH PRESSURE FALL BELOW MIN

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E 34.0	248S33	CLAMPING HIGH PRESSURE PASSED OVER MAX
E 34.1	248S34	LOCK.CYL. HIGH PRESS. BUILT UP : MIN. HP
E 34.2	248S35	LOCK.CYL. HIGH PRESS. BUILT UP : MAX. HP
E 34.3	248S36	LOCK.CYL. HIGH PRESS. FALL BELOW MIN
E 34.4	248S37	LOCK.CYL. HIGH PRESS. PASSED OVER MAX
E 34.5	248S53	DEH CASSETTE PREHEATING TABLE INSTALLED
E 34.6	248S46	CASSETTE MOUNTING DEVICE AT DEH
E 34.7	248S47	CASSETTE MOUNTING DEVICE LOWERED
E 35.0	249S1	CASSETTE MOUNTING DEVICE RETURNED
E 35.1	249S2.1	SWITCH : LIFT CASSETTE MOUNTING DEVICE
E 35.2	249S2.2	SWITCH : LOWER CASSETTE MOUNTING DEVICE
E 35.3	249S4.1	SWITCH : SLIP-IN CASSETTE
E 35.4	249S4.2	SWITCH : SLIP-OUT CASSETTE
E 35.5	E 35.5	DEH SYSTEM PRESSURE OVERFLOW
E 35.6	E 35.6	OIL FILTER FAULT
E 35.7	E 35.7	E-STOP CONTROL PANEL EXTRUSION HEAD
E 36.0	250S41.1	SWITCH : CLOSE CLAMPING
E 36.1	250S41.2	SWITCH : OPEN CLAMPING
E 36.2	250S42.1	SWITCH : CLOSE CLAMP.FOR FINAL DIE CHANG
E 36.3	250S42.2	SWITCH : OPEN CLAMP.FOR FINAL DIE CHANGE
E 36.4	250S43.1	SWITCH : CLOSE UPPER PART
E 36.5	250S43.2	SWITCH : OPEN UPPER PART
E 36.6	250S44.1	SWITCH : CLOSE MEDIUM PART
E 36.7	250S44.2	SWITCH : OPEN MEDIUM PART
E 37.0	E37.0	251 PRESSURE TRANSDUCER IN HOME POSITION
E 37.1	E37.1	SPARE
E 37.2	E37.2	SPARE
E 37.3	E37.3	SPARE
E 37.4	E37.4	SPARE
E 37.5	E37.5	SPARE
E 37.6	E37.6	SPARE
E 37.7	E37.7	SPARE
E 40.0	E 40.0	SPARE
E 40.1	A925.11	WIDTH MEASURING DEVICE 1 DECADE
E 40.2	A925.12	WIDTH MEASURING DEVICE 1 DECADE
E 40.3	A925.13	WIDTH MEASURING DEVICE 1 DECADE
E 40.4	A925.14	WIDTH MEASURING DEVICE 1 DECADE
E 40.5	A925.21	WIDTH MEASURING DEVICE 2 DECADE
E 40.6	A925.22	WIDTH MEASURING DEVICE 2 DECADE
E 40.7	A925.23	WIDTH MEASURING DEVICE 2 DECADE
E 41.0	A925.24	WIDTH MEASURING DEVICE 2 DECADE
E 41.1	A925.31	WIDTH MEASURING DEVICE 3 DECADE
E 41.2	A925.32	WIDTH MEASURING DEVICE 3 DECADE
E 41.3	A925.33	WIDTH MEASURING DEVICE 3 DECADE
E 41.4	A925.34	WIDTH MEASURING DEVICE 3 DECADE
E 41.5	A925.41	WIDTH MEASURING DEVICE 4 DECADE
E 41.6	A925.42	WIDTH MEASURING DEVICE 4 DECADE
E 41.7	A925.43	WIDTH MEASURING DEVICE 4 DECADE
E 42.0	A925.44	WIDTH MEASURING DEVICE 4 DECADE
E 42.1	A925.01	WIDTH MEASURING DEVICE CAMERA DIRTY
E 42.2	A925.02	WIDTH MEASURING DEVICE LIMIT RIGHT
E 42.3	A925.03	WIDTH MEASURING DEVICE LIMIT LEFT
E 42.4	A925.04	WIDTH MEASURING DEVICE FAULT
E 42.5	260B6	PULSE GENERATOR LINE SPEED
E 42.6	E 42.6	CEM 1 EXHAUST PRESSURE OK
E 42.7	E 42.7	CEM 1 CEMENTER PRESSURE
E 43.0	A925.5	CONTINUOUS WEIGHER 1 DECADE
E 43.1	A925.61	CONTINUOUS WEIGHER 2 DECADE
E 43.2	A925.62	CONTINUOUS WEIGHER 2 DECADE
E 43.3	A925.63	CONTINUOUS WEIGHER 2 DECADE
E 43.4	A925.64	CONTINUOUS WEIGHER 2 DECADE
E 43.5	A925.71	CONTINUOUS WEIGHER 3 DECADE
E 43.6	A925.72	CONTINUOUS WEIGHER 3 DECADE
E 43.7	A925.73	CONTINUOUS WEIGHER 3 DECADE
E 44.0	A925.74	CONTINUOUS WEIGHER 3 DECADE
E 44.1	A925.81	CONTINUOUS WEIGHER 4 DECADE
E 44.2	A925.82	CONTINUOUS WEIGHER 4 DECADE
E 44.3	A925.83	CONTINUOUS WEIGHER 4 DECADE
E 44.4	A925.84	CONTINUOUS WEIGHER 4 DECADE
E 44.5	A925.91	CONTINUOUS WEIGHER 5 DECADE
E 44.6	A925.92	CONTINUOUS WEIGHER 5 DECADE
E 45.0	A925.94	CONTINUOUS WEIGHER 5 DECADE

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OPERAND	SYMBOL	KOMMENTAR
E 45.1	A925.0	LINEAR CHECK WEIGHER BCD DATA PENDING
E 45.2	A925	LINEAR CHECK WEIGHER FAULT
E 45.3	E 45.3	PULSE GENERATOR TRACKING (CENTERING 2)
E 45.4	E 45.4	SPARE
E 45.5	E 45.5	KNIFE MIDDLE SEPARATING DEVICE SLOWLIER
E 45.6	E 45.6	KNIFE MIDDLE SEPARATING DEVICE FASTER
E 45.7	E 45.7	SPARE
E 46.0	264S1	CEM 2 CEMENTER PRESSURE
E 46.1	264S2	CEM 2 PRESSURE EXHAUST OK
E 46.2	A900.0	E-STOP RIPCORD UP FRONT LEFT SIDE
E 46.3	A900.1	E-STOP RIPCORD UP FRONT RIGHT SIDE
E 46.4	A900.2	E-STOP RIPCORD DOWN PART 1 RIGHT SIDE
E 46.5	E 46.5	PRESSURE WATERSYSTEM OK
E 46.6	E 46.6	SPARE
E 46.7	E 46.7	SPARE
E 47.0	E 47.0	SPARE
E 47.1	E 47.1	SPARE
E 47.2	E 47.2	SPARE
E 47.3	E 47.3	SPARE
E 47.4	E 47.4	SPARE
E 47.5	E 47.5	SPARE
E 47.6	E 47.6	SPARE
E 47.7	E 47.7	SPARE
E 50.0	273S2	FEEDER LOOP UP
E 50.1	273S3.	FEEDER LOOP DOWN
E 50.2	E 50.2	SPARE
E 50.3	83A3	FEEDER METAL DETECTOR
E 50.4	273B8	FEEDER PULSE GENERATOR
E 50.5	273S5	FEEDER KNIFE HOME POSITION
E 50.6	273S6	FEEDER BALL-UP UPPER CONVEYOR
E 50.7	273S7	FEEDER LOWER CONVEYOR BELT CENTER POS.
E 51.0	274S8	FEEDER UPPER CONVEYOR BELT CENTER POS.
E 51.1	274S9	FEEDER PINCH ROLL UP
E 51.2	274S10	FEEDER BALL-UP PINCH ROLL
E 51.3	274S11	FEEDER SCRAP CONVEYOR TOP
E 51.4	274S12	FEEDER SCRAP CONVEYOR DOWN
E 51.5	274S13	FEEDER FAULT COMPRESSED AIR SUPPLY
E 51.6	A700.1	FEEDER E-STOP RIPCORD OR PANEL RIGHT S.
E 51.7	A700.2	FEEDER E-STOP RIPCORD LEFT SIDE
E 52.0	A700.3	FEEDER E-STOP RIPCORD FRONT
E 52.1	275S33.1	FEEDER REVERSE (PALLET STATION)
E 52.2	275S30.1	FEEDER ON (PALLET STATION)
E 52.3	275S30.2	FEEDER OFF (PALLET STATION)
E 52.4	A700.4	FEEDER E-STOP (HOPPER STATION)
E 52.5	275S34	FEEDER MAX SPEED (HOPPER STATION)
E 52.6	275S32	START EXTRUDER + FEEDER (HOPPER STATION)
E 52.7	275S33.2	STOP EXTRUDER + FEEDER (HOPPER STATION)
E 53.0	276S31.1	FEEDER ON (HOPPER STATION)
E 53.1	276S31.2	FEEDER OFF (HOPPER STATION)
E 53.2	276S36	FEEDER CUT (HOPPER STATION)
E 53.3	E 53.3	CEMENTING 2 ROLL DOWN (EXTR.CAL.PAN.)
E 53.4	E 53.4	CEMENTING 2 ROLL UP (EXTR.CAL.PAN.)
E 53.5	E 53.5	FEED.CONV.CAL. FASTER (EXTR.CAL.PAN.)
E 53.6	E 53.6	FEED.CONV.CAL. SLOWLIER (EXTR.CAL.PAN.)
E 53.7	E 53.7	SPARE
E 54.0	E 54.0	SPARE
E 54.1	A700.6	EXTRUDER CALENDER HOPPER E-STOP
E 54.2	277S2	EXTRUDER CALENDER OIL FLOW TO LOW
E 54.3	277S3	EXTRUDER CALENDER PRESSURE TO LOW
E 54.4	277S4	EXTRUDER CALENDER TEMP. OILCOOLING
E 54.5	277S5	EXTRUDER CALENDER MAX OIL TEMP
E 54.6	277S6	SPARE
E 54.7	277B1	EXTRUDER CALENDER HOPPER PULSE GENERATOR
E 55.0	278S10	EXTRUDER START (EXTR.CAL.PAN.)
E 55.1	278S11	EXTRUDER STOP (EXTR.CAL.PAN.)
E 55.2	278S12	EXTRUDER AUX DRIVES ON (EXTR.CAL.PAN.)
E 55.3	278S13	EXTRUDER AUX DRIVES OFF (EXTR.CAL.PAN.)
E 55.4	278S14.1	EXTRUDER FASTER (EXTR.CAL.PAN.)
E 55.5	278S14.2	EXTRUDER SLOWER (EXTR.CAL.PAN.)
E 55.6	A700.8	E-STOP (EXTR.CAL.PAN.)
E 55.7	278S8	PRODUCT DISCHARG. (EXTR.CAL.PAN.)
E 60.0	285S17	CALENDER BRAKE VENTED

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E 60.1	285S2	CALENDER MAX OIL PRESSURE	
E 60.2	285S3	CALENDER MIN OIL PRESSURE	
E 60.3	285S4	CALENDER FAULT OIL LUBRICATION	
E 60.4	E 60.4	CALENDER KNIFE 1 MAX FORWARD	
E 60.5	E 60.5	CALENDER KNIFE 1 MAX REVERSE	
E 60.6	E 60.6	CALENDER KNIFE 2 MAX REVERSE	
E 60.7	E 60.7	CALENDER KNIFE 2 MAX FORWARD	
E 61.0	286S9	CALENDER MAX ROLLSLIT RIGHT SIDE	
E 61.1	286S10	CALENDER MAX ROLLSLIT LEFT SIDE	
E 61.2	E 61.2	CALENDER MIN OIL LEVEL	
E 61.3	E 61.3	CALENDER MIN ROLLSLIT LEFT SIDE	
E 61.4	E 61.4	SPARE	
E 61.5	E 61.5	CALENDER MIN ROLLSLIT RIGHT SIDE	
E 61.6	286S40.1	AUX DRIVES ON	(CAL PANEL)
E 61.7	286S40.2	AUX DRIVES OFF	(CAL PANEL)
E 62.0	287S42	CALENDER START	(CAL PANEL)
E 62.1	287S43	CALENDER STOP	(CAL PANEL)
E 62.2	287S46.1	CALENDER PREHEATING	(CAL PANEL)
E 62.3	287S46.2	CALENDER AUTOMATIC/MANUAL	(CAL PANEL)
E 62.4	E 62.4	CEMENTING 1 EDGE CEMENT. ON	(CAL PANEL)
E 62.5	287S47.1	CALENDER FASTER	(CAL PANEL)
E 62.6	287S47.2	CALENDER SLOWLIER	(CAL PANEL)
E 62.7	A800	E-STOP	(CAL PANEL)
E 63.0	288S48.1	CLOSE ROLLSLIT	(CAL PANEL)
E 63.1	288S48.2	OPEN ROLLSLIT	(CAL PANEL)
E 63.2	288S50.1	ROLLSLIT RIGHT SIDE	(CAL PANEL)
E 63.3	288S50.2	ROLLSLIT LEFT SIDE	(CAL PANEL)
E 63.4	E 63.4	CEMENTING 1 ROLL DOWN	(CAL PANEL)
E 63.5	288S53.1	FEED.CONV.CAL. FASTER	(CAL PANEL)
E 63.6	288S53.2	FEED.CONV.CAL. SLOWLIER	(CAL PANEL)
E 63.7	E 63.7	CEMENTING 1 ROLL UP	(CAL PANEL)
E 64.0	E 64.0	CEMENTING 1 EDGE CEMENT. OFF	(CAL PANEL)
E 64.1	A800.2	E-STOP RIPCORD CALENDER REAR	
E 64.2	289S54.1	KNIFE 1 FORWARD	(CAL PANEL)
E 64.3	289S54.2	KNIFE 1 REVERSE	(CAL PANEL)
E 64.4	289S55.1	KNIFE 2 FORWARD	(CAL PANEL)
E 64.5	289S55.2	KNIFE 2 REVERSE	(CAL PANEL)
E 64.6	E 64.6	E-STOP RIPCORD CALENDER FRONT	
E 64.7	E 64.7	E-STOP CALENDER LEFT SIDE	
E 70.0	A942.01	TREAD CHECKER BCD DATA PENDING	
E 70.1	A942.02	TREAD CHECKER FAULT	
E 70.2	A942.11	TREAD CHECKER BCD-CODE 8 * 10^1	
E 70.3	A942.12	TREAD CKECKER BCD-CODE 4 * 10^1	
E 70.4	A942.13	TREAD CHECKER BCD-CODE 2 * 10^1	
E 70.5	A942.14	TREAD CHECKER BCD-CODE 1 * 10^1	
E 70.6	A942.21	TREAD CHECKER BCD-CODE 8 * 10^0	
E 70.7	A942.22	TREAD CHECKER BCD-CODE 4 * 10^0	
E 71.0	A942.23	TREAD CHECKER BCD-CODE 2 * 10^0	
E 71.1	A942.24	TREAD CHECKER BCD-CODE 1 * 10^0	
E 71.2	A942.31	TREAD CHECKER BCD-CODE 8 * 10^-1	
E 71.3	A942.32	TREAD CHECKER BCD-CODE 4 * 10^-1	
E 71.4	A942.33	TREAD CHECKER BCD-CODE 2 * 10^-1	
E 71.5	A942.34	TREAD CHECKER BCD-CODE 1 * 10^-1	
E 71.6	A942.41	TREAD CHECKER BCD-CODE 8 * 10^-2	
E 71.7	A942.42	TREAD CHECKER BCD-CODE 4 * 10^-2	
E 72.0	A942.43	TREAD CHECKER BCD-CODE 2 * 10^-2	
E 72.1	A942.44	TREAD CHECKER BCD-CODE 1 * 10^-2	
E 72.2	E 72.2	TREAD INLET LENGHT MEASURING DEVICE	
E 72.3	E 72.3	TREAD RETIREMENT LENGHT MEASURING DEVICE	
E 72.4	298S5	CUT END CEMENTING STRIP INLET	
E 72.5	298S6	CUT END CEMENTING FLAP CLOSED	
E 72.6	298S7	CUT END CEMENTING CEMENTER PRESSURE	
E 72.7	E 72.7	SPARE	
E 73.0	E 73.0	SPARE	
E 73.1	299S3	SCRAP DETECTED	
E 73.2	299S4	PHOTOEYE SCRAP CONVEYOR	
E 73.3	A950.1	E-STOP RIPCORD DOWN PART 4 RIGHT SIDE	
E 73.4	A950.2	E-STOP RIPCORD DOWN PART 3 RIGHT SIDE	
E 73.5	A950.3	E-STOP RIPCORD UP REAR RIGHT SIDE	
E 73.6	A950.4	E-STOP RIPCORD UP REAR LEFT SIDE	
E 73.7	E 73.7	END CEMENTING PRESSURE EXHAUST OK	
E 74.0	300S1.1	WIND UP DEVICE 1 ON	

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OPERAND	SYMBOL	KOMMENTAR
E 74.1	300S1.2	WIND UP DEVICE 1 OFF
E 74.2	300S3.1	WIND UP DEVICE 2 ON
E 74.3	300S3.2	WIND UP DEVICE 2 OFF
E 74.4	300S5.1	WIND UP DEVICE 3 ON
E 74.5	300S5.2	WIND UP DEVICE 3 OFF
E 74.6	300S7.1	WIND UP DEVICE 4 ON
E 74.7	300S7.2	WIND UP DEVICE 4 OFF
E 75.0	E 75.0	WIND UP DEVICE 1 E-STOP
E 75.1	E 75.1	WIND UP DEVICE 2 E-STOP
E 75.2	E 75.2	WIND UP DEVICE 3 E-STOP
E 75.3	E 75.3	WIND UP DEVICE 4 E-STOP
E 75.4	E 75.4	E-STOP RIPCORD DOWN PART 2 RIGHT SIDE
E 75.5	E 75.5	PHOTOEYE SCRAP MARKING TREAD WEIGHER
E 75.6	E 75.6	SPARE
E 75.7	E 75.7	SPARE
E 80.0	201S1	UP.EXTR. AUX DRIVE ON (MAIN CONTR.PAN.)
E 80.1	201S2	UP.EXTR. AUX DRIVE OFF (MAIN CONTR.PAN.)
E 80.2	201S3	UP.EXTR. START (MAIN CONTR.PAN.)
E 80.3	201S4	UP.EXTR. STOP (MAIN CONTR.PAN.)
E 80.4	201S5.1	UP.EXTR. FASTER (MAIN CONTR.PAN.)
E 80.5	201S5.2	UP.EXTR. SLOWER (MAIN CONTR.PAN.)
E 80.6	A310.1	UPPER EXTR. COMPOUND PRESSURE 1
E 80.7	A310.2	UPPER EXTR. COMPOUND PRESSURE 2 (LOW)
E 81.0	202S1	BOT.EXTR. AUX DRIVE ON (MAIN CONTR.PAN.)
E 81.1	202S2	BOT.EXTR. AUX DRIVE OFF (MAIN CONTR.PAN.)
E 81.2	202S3	BOT.EXTR. START (MAIN CONTR.PAN.)
E 81.3	202S4	BOT.EXTR. STOP (MAIN CONTR.PAN.)
E 81.4	202S5.1	BOT.EXTR. FASTER (MAIN CONTR.PAN.)
E 81.5	202S5.2	BOT.EXTR. SLOWER (MAIN CONTR.PAN.)
E 81.6	A410.1	BOTTOM EXTR. COMPOUND PRESSURE 1
E 81.7	A410.2	BOTTOM EXTR. COMPOUND PRESSURE 2 (LOW)
E 82.0	61K2	EMERGENCY CONTROL
E 82.1	203S2	CONV.BELT LINE UNCONTR. (MAIN CONTR.PAN.)
E 82.2	203S3	AUX DRIVE LINE ON (MAIN CONTR.PAN.)
E 82.3	203S4	AUX DRIVE LINE OFF (MAIN CONTR.PAN.)
E 82.4	203S5	LINE START (MAIN CONTR.PAN.)
E 82.5	203S6	LINE STOP (MAIN CONTR.PAN.)
E 82.6	203S7.1	LINE FASTER (MAIN CONTR.PAN.)
E 82.7	203S7.2	LINE SLOWER (MAIN CONTR.PAN.)
E 83.0	204S1	CONTROL VOLTAGE ON (MAIN CONTR.PAN.)
E 83.1	204S2	CONTROL VOLTAGE OFF (MAIN CONTR.PAN.)
E 83.2	204S3	LAMP TEST (MAIN CONTR.PAN.)
E 83.3	204S4	REBUILD HIGH PRESS. (MAIN CONTR.PAN.)
E 83.4	204S5	RESET PRODUCT. REPORT (MAIN CONTR.PAN.)
E 83.5	204S6.1	MANUAL (MAIN CONTR.PAN.)
E 83.6	204S6.2	AUTOMATIC (MAIN CONTR.PAN.)
E 83.7	E 83.7	E-STOP (MAIN CONTR.PAN.)
E 84.0	205S1.1	PROGRAM START (MAIN CONTR.PAN.)
E 84.1	205S1.2	PROGRAM STOP (MAIN CONTR.PAN.)
E 84.2	205S3.1	HORN OFF (MAIN CONTR.PAN.)
E 84.3	205S3.2	ACKNOWLEDGING FAULT (MAIN CONTR.PAN.)
E 84.4	205S5.1	TEMPERATURE UNIT ON (MAIN CONTR.PAN.)
E 84.5	205S6.2	PRODUCT DISCHARGING (MAIN CONTR.PAN.)
E 84.6	E 84.6	CO2 FIRE EXTINGUISHER FAULT
E 84.7	E 84.7	CO2 FIRE EXTINGUISHER ALARM
E 85.0	53A1.11	UPPER EXTRUDER MIN TEMP 1
E 85.1	53A1.12	UPPER EXTRUDER MAX TEMP 1
E 85.2	53A1.13	UPPER EXTRUDER MIN TEMP 2
E 85.3	53A1.14	UPPER EXTRUDER MAX TEMP 2
E 85.4	53A1.21	BOTTOM EXTRUDER MIN TEMP 1
E 85.5	53A1.22	BOTTOM EXTRUDER MAX TEMP 1
E 85.6	53A1.23	BOTTOM EXTRUDER MIN TEMP 2
E 85.7	53A1.24	BOTTOM EXTRUDER MAX TEMP 2
E 86.0	53A1.31	EXTRUSION HEAD MIN TEMP 1
E 86.1	53A1.32	EXTRUSION HEAD MAX TEMP 1
E 86.2	53A1.33	EXTRUSION HEAD MIN TEMP 2
E 86.3	53A1.34	EXTRUSION HEAD MAX TEMP 2
E 86.4	53A1.41	EXTRUDER CALENDER MIN TEMP 1
E 86.5	53A1.42	EXTRUDER CALENDER MAX TEMP 1
E 86.6	53A1.43	EXTRUDER CALENDER MIN TEMP 2
E 86.7	53A1.44	EXTRUDER CALENDER MAX TEMP 2
E 87.0	53A1.45	EXTRUDER CALENDER MIN TEMP 3

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OPERAND	SYMBOL	KOMMENTAR
E 87.1	53A1.46	EXTRUDER CALENDER MAX TEMP 3
E 87.2	53A1.51	CALENDER MIN TEMP 1
E 87.3	53A1.52	CALENDER MAX TEMP 1
E 87.4	53A1.53	CALENDER MIN TEMP 2
E 87.5	53A1.54	CALENDER MAX TEMP 2
E 87.6	E 87.6	ACCEPT PROFILE PART B OR/AND C
E 87.7	E 87.7	SPARE
E 92.0	E 92.0	TEMP.UNIT 3 : ON
E 92.1	E 92.1	TEMP.UNIT 3 : FAULT MOTOR PUMP 1
E 92.2	E 92.2	TEMP.UNIT 3 : FAULT FLOW
E 92.3	E 92.3	TEMP.UNIT 3 : PUMP 1 ON
E 92.4	E 92.4	TEMP.UNIT 3 : FAULT ANTI FREEZE PROT.
E 92.5	E 92.5	TEMP.UNIT 3 : FAULT OIL PRESS. COMP.1
E 92.6	E 92.6	TEMP.UNIT 3 : FAULT MOTOR COMPRESSOR1
E 92.7	E 92.7	TEMP.UNIT 3 : COMPRESSOR 1 ON
E 93.0	E 93.0	TEMP.UNIT 3 : FAULT OIL PRESS. COMP.2
E 93.1	E 93.1	TEMP.UNIT 3 : FAULT MOTOR COMPRESSOR2
E 93.2	E 93.2	TEMP.UNIT 3 : COMPRESSOR 2 ON
E 93.3	E 93.3	TEMP.UNIT 3 : FAULT HIGH PRES. COMP.1
E 93.4	E 93.4	TEMP.UNIT 3 : FAULT HIGH PRES. COMP.2
E 93.5	E 93.5	TEMP.UNIT 3 : FAULT MOTOR PUMP 2
E 93.6	E 93.6	TEMP.UNIT 3 : PUMP 2 ON
E 93.7	E 93.7	TEMP.UNIT 3 : FAULT FLOW
E 94.0	E 94.0	TEMP.UNIT 3 : FAULT PRESSURE FILTER 1
E 94.1	E 94.1	TEMP.UNIT 3 : FAULT PRESSURE FILTER 1
E 94.2	E 94.2	TEMP.UNIT 3 : FILLING LEVEL MIN.ALARM
E 94.3	E 94.3	SPARE
E 94.4	E 94.4	SPARE
E 94.5	E 94.5	SPARE
E 94.6	E 94.6	SPARE
E 94.7	E 94.7	SPARE
E 95.0	E 95.0	TEMP.UNIT 2 : FAULT PRESS. SCREW KG90
E 95.1	E 95.1	TEMP.UNIT 2 : PUMP ON SCREW KG90
E 95.2	E 95.2	TEMP.UNIT 2 : FAULT PUMP SCREW KG90
E 95.3	E 95.3	TEMP.UNIT 2 : OVERTEMPERATURE SCREW KG90
E 95.4	E 95.4	TEMP.UNIT 2 : FAULT PRESSURE PIN KG90
E 95.5	E 95.5	TEMP.UNIT 2 : PUMP ON PIN KG90
E 95.6	E 95.6	TEMP.UNIT 2 : FAULT PUMP PIN KG90
E 95.7	E 95.7	TEMP.UNIT 2 : OVERTEMPERATURE PIN KG90
E 96.0	E 96.0	TEMP.UNIT 2 : FAULT PRESSURE HEAD KG90
E 96.1	E 96.1	TEMP.UNIT 2 : PUMP ON HEAD KG90
E 96.2	E 96.2	TEMP.UNIT 2 : FAULT PUMP HEAD KG90
E 96.3	E 96.3	TEMP.UNIT 2 : OVERTEMPERATURE HEAD KG90
E 96.4	E 96.4	TEMP.UNIT 2 : FAULT PRESS. TOP ROLL CAL
E 96.5	E 96.5	TEMP.UNIT 2 : PUMP ON TOP ROLL CAL
E 96.6	E 96.6	TEMP.UNIT 2 : FAULT PUMP TOP ROLL CAL
E 96.7	E 96.7	TEMP.UNIT 2 : OVERTEMP. TOP ROLL CAL
E 97.0	E 97.0	TEMP.UNIT 2 : FAULT PRESS. BOT ROLL CAL
E 97.1	E 97.1	TEMP.UNIT 2 : PUMP ON BOT ROLL CAL
E 97.2	E 97.2	TEMP.UNIT 2 : FAULT PUMP BOT ROLL CAL
E 97.3	E 97.3	TEMP.UNIT 2 : OVERTEMP. BOT ROLL CAL
E 97.4	E 97.4	SPARE
E 97.5	E 97.5	SPARE
E 97.6	E 97.6	SPARE
E 97.7	E 97.7	SPARE
E 98.0	E 98.0	TEMP.UNIT 1 : FAULT PRESS. SCREW BOT EX.
E 98.1	E 98.1	TEMP.UNIT 1 : PUMP ON SCREW BOT EX.
E 98.2	E 98.2	TEMP.UNIT 1 : FAULT PUMP SCREW BOT EX.
E 98.3	E 98.3	TEMP.UNIT 1 : OVERTEMP. SCREW BOT EX.
E 98.4	E 98.4	TEMP.UNIT 1 : FAULT PRESS. CYL. BOT EX.
E 98.5	E 98.5	TEMP.UNIT 1 : PUMP ON CYL. BOT EX.
E 98.6	E 98.6	TEMP.UNIT 1 : FAULT PUMP CYL. BOT EX.
E 98.7	E 98.7	TEMP.UNIT 1 : OVERTEMP. CYL. BOT EX.
E 99.0	E 99.0	TEMP.UNIT 1 : FAULT PRESS. SCREW TOP EX.
E 99.1	E 99.1	TEMP.UNIT 1 : PUMP ON SCREW TOP EX.
E 99.2	E 99.2	TEMP.UNIT 1 : FAULT PUMP SCREW TOP EX.
E 99.3	E 99.3	TEMP.UNIT 1 : OVERTEMP. SCREW TOP EX.
E 99.4	E 99.4	TEMP.UNIT 1 : FAULT PRESS. CYL. TOP EX.
E 99.5	E 99.5	TEMP.UNIT 1 : PUMP ON CYL. TOP EX.
E 99.6	E 99.6	TEMP.UNIT 1 : FAULT PUMP CYL. TOP EX.
E 99.7	E 99.7	TEMP.UNIT 1 : OVERTEMP. CYL. TOP EX.
E 100.0	E100.0	TEMP.UNIT 1 : FAULT PRESS. MIDDLE S. DEH

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E 100.1	E100.1	TEMP.UNIT 1 : PUMP ON MIDDLE S. DEH
E 100.2	E100.2	TEMP.UNIT 1 : FAULT PUMP MIDDLE S. DEH
E 100.3	E100.3	TEMP.UNIT 1 : OVERTEMP. MIDDLE S. DEH
E 100.4	E100.4	TEMP.UNIT 1 : FAULT PRESS. UPPER S. DEH
E 100.5	E100.5	TEMP.UNIT 1 : PUMP ON UPPER S. DEH
E 100.6	E100.6	TEMP.UNIT 1 : FAULT PUMP UPPER S. DEH
E 100.7	E100.7	TEMP.UNIT 1 : OVERTEMP. UPPER S. DEH
A 0.0	43A1/1	UPPER EXTRUDER ON/OFF
A 0.1	43A1/2	UPPER EXTRUDER CONTROLLER RELEASE
A 0.2	43A1/3	UPPER EXTRUDER CREEP
A 0.3	45K3/1	UPPER EXTRUDER RELAY REVERSE
A 0.4	45K3/2	UPPER EXTRUDER RELAY FORWARD
A 0.5	46K5	UPPER EXTRUDER AUXILIARY DRIVES ON
A 0.6	A 0.6	UPPER EXTRUDER FIELD ON
A 0.7	97K6	DRIVE MOTOR BRAKE ON/OFF
A 1.0	A 1.0	BOTTOM EXTRUDER ON/OFF
A 1.1	A 1.1	BOTTOM EXTRUDER CONTROLLER RELEASE
A 1.2	A 1.2	BOTTOM EXTRUDER CREEP
A 1.3	50K3.1	BOTTOM EXTRUDER RELAY REVERSE
A 1.4	50K3.2	BOTTOM EXTRUDER RELAY FORWARD
A 1.5	A 1.5	BOTTOM EXTRUDER AUXILIARY DRIVES ON
A 1.6	A 1.6	BOTTOM EXTRUDER FIELD ON
A 1.7	A 1.7	FEEDER REVERSE
A 2.0	A 2.0	HYDRAULIC-PUMP ON
A 2.1	64A1.1	PROPORTIONAL VALVE 50 BAR
A 2.2	64A1.2	PROPORTIONAL VALVE 120 BAR
A 2.3	64A1.3	PROPORTIONAL VALVE 130 BAR
A 2.4	64A1.4	PROPORTIONAL VALVE 180 BAR
A 2.5	A 2.5	SPARE
A 2.6	A 2.6	SPARE
A 2.7	87K8	EXTRUDER CALENDER FIELD ON
A 3.0	72K5	EXHAUSTER FRONT PLANT PART ON/OFF
A 3.1	73K6	DRAW-OFF CONVEYOR MAIN CONTACTOR ON/OFF
A 3.2	73A1	DRAW-OFF CONVEYOR ON
A 3.3	77K6	CONVEYOR LIN.CHECKER MAIN CONTACTOR ON
A 3.4	77A1	CONVEYOR LINEAR CHECKER ON
A 3.5	79K5	CEMENTING EXHAUSTER 1 ON/OFF
A 3.6	80K5	DRIVE MOTOR CUTTER ON/OFF (VMI)
A 3.7	81K5	FEEDER MAINCONTACTOR ON/OFF
A 4.0	81A1.1	FEEDER ON
A 4.1	81A1.2	SPARE
A 4.2	84A1.1	EXTRUDER CALENDER DC-CONVERTER ON/OFF
A 4.3	A 4.3	SPARE
A 4.4	84A1.2	EXTRUDER CALENDER CONTROLLER RELEASE
A 4.5	84A1.3	EXTRUDER CALENDER CREEP
A 4.6	86K3	EXTRUDER CALENDER FORWARD
A 4.7	87K7	EXTRUDER CALENDER AUX DRIVES ON/OFF
A 5.0	90A1	CALENDER FEEDING BELT ON/OFF
A 5.1	89K6	CALENDER FEEDING BELT MAIN CONTACTOR ON
A 5.2	91A1.1	CALENDER START/STOP
A 5.3	91A1.2	CALENDER CONTROLLER RELEASE
A 5.4	91A1.3	CALENDER CREEP
A 5.5	86K3.1	EXTRUDER CALENDER REVERSE
A 5.6	96K7	CALENDER AUX DRIVES ON/OFF
A 5.7	A 5.7	SPARE
A 6.0	94K6	CLOSE ROLLSLIT LEFT SIDE
A 6.1	94K6.1	OPEN ROLLSLIT LEFT SIDE
A 6.2	95K6	CLOSE ROLLSLIT RIGHT SIDE
A 6.3	95K6.1	OPEN ROLLSLIT RIGHT SIDE
A 6.4	A 6.4	CALENDER KNIFE 1 FORWARD
A 6.5	A 6.5	CALENDER KNIFE 1 REVERSE
A 6.6	A 6.6	CALENDER KNIFE 2 FORWARD
A 6.7	A 6.7	CALENDER KNIFE 2 REVERSE
A 7.0	100K6	CONVEYOR CEMENTING 2 MAIN CONTACTOR ON
A 7.1	100A1	CONVEYOR CEMENTING 2 ON
A 7.2	102K5	CEMENTING EXHAUST
A 7.3	103K6	COOLING SECTION 1 MAIN CONTACTOR ON
A 7.4	103A1	COOLING SECT 1 ON
A 7.5	105K5	COOLING SECT 2 MAIN CONTACTOR ON
A 7.6	105A1	COOLING SECT 2 ON
A 7.7	A 7.7	SPARE
A 8.0	108K6	COOLING SECT 3 MAIN CONTACTOR ON

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A 8.1	108A1	COOLING SECT 3 ON
A 8.2	110K6	COOLING SECT 4 MAIN CONTACTOR ON
A 8.3	110A1	COOLING SECT 4 ON
A 8.4	A 8.4	SPARE
A 8.5	113K6	CENTERING 2 KNIFE DRIVE 1 MAIN CONT ON
A 8.6	113A1	CENTERING 2 KNIFE DRIVE 1 ON
A 8.7	115K6	CONVEYOR CENTERING 2 MAIN CONTACTOR ON
A 9.0	115A1	CONVEYOR CENTERING 2 ON
A 9.1	120K6	FREEWHEEL ACCELERATING CONV MAIN CONT ON
A 9.2	120A1	FREEWHEEL ACCELERATING CONVEYER ON
A 9.3	128K6	CHECK WEIGHER MAIN CONTACTOR ON
A 9.4	128A1	CONVEYOR CHECK WEIGHER ON
A 9.5	131K5	SLOW-DOWN ROLLER CONVEYOR FAST
A 9.6	131K6	SLOW-DOWN ROLLER CONVEYOR SLOW
A 9.7	132K5	END CEMENTING FAST
A 10.0	132K6	END CEMENTING SLOW
A 10.1	133K5	END CEMENTING EXHAUSTER MAIN CONTACT ON
A 10.2	136K5	TAKE-AWAY CONVEYOR FAST
A 10.3	136K6	TAKE-AWAY CONVEYOR SLOW
A 10.4	137K5	LENGHT CUTTER MAIN CONTACTOR ON
A 10.5	A 10.5	WATER STATION MAIN CONTACTOR ON
A 10.6	A 10.6	SPARE
A 10.7	33K7	CONTROL VOLTAGE 220V ON
A 11.0	122K7	WIND-UP STATION 1 MAIN CONTACTOR ON
A 11.1	123K7	WIND-UP STATION 2 MAIN CONTACTOR ON
A 11.2	124K7	WIND-UP STATION 3 MAIN CONTACTOR ON
A 11.3	125K7	WIND-UP STATION 4 MAIN CONTACTOR ON
A 11.4	A 11.4	SPARE
A 11.5	A 11.5	SPARE
A 11.6	A 11.6	SPARE
A 11.7	A 11.7	SPARE
A 20.0	235B1	UPPER EXTRUDER OIL COOLING ON
A 20.1	235B2	UPPER EXTRUDER COOLING INLET
A 20.2	235B3	UPPER EXTRUDER WATER COOLING
A 20.3	A 20.3	SPARE
A 20.4	A 20.4	SPARE
A 20.5	A 20.5	SPARE
A 20.6	A 20.6	SPARE
A 20.7	A 20.7	SPARE
A 25.0	240B1	BOTTOM EXTRUDER OIL COOLING ON
A 25.1	240B2	BOTTOM EXTRUDER COOLING INLET
A 25.2	240B3	BOTTOM EXTRUDER WATER COOLING
A 25.3	A 25.3	SPARE
A 25.4	A 25.4	SPARE
A 25.5	A 25.5	SPARE
A 25.6	A 25.6	SPARE
A 25.7	A 25.7	SPARE
A 30.0	252B1	SV CLOSE CLAMPING
A 30.1	252B2	SV OPEN CLAMPING
A 30.2	252B3	SV EJECTING DEVICE : PRESS IN CASSETTE
A 30.3	252B4	SV EJECTING DEVICE : PRESS OUT CASSETTE
A 30.4	252B5	SV CLOSE MEDIUM PART
A 30.5	252B6	SV OPEN MEDIUM PART
A 30.6	252B7	SV CLOSE UPPER PART
A 30.7	252B8	SV OPEN UPPER PART
A 31.0	253B1	SV MOVE LOCKING CYLINDER REVERSE
A 31.1	253B2	SV MOVE LOCKING CYLINDER FORWARD
A 31.2	253B3	SV OIL PUMP BUILD UP PRESSURE Q1
A 31.3	253B4	SV PRESSURE TRANSDUCER HIGH PRESSURE ON
A 31.4	253B5	SV PRESSURE TRANSDUCER HOME POSITION
A 31.5	253B6	SV LOCKING CYLINDER REBUILT HIGH PRESS.
A 31.6	253K7	DEH UNLOCKING MEDIUM PART
A 31.7	253K8	DEH UNLOCKING UPPER PART
A 32.0	254B1	SV DOWN CASSETTE MOUNTING DEVICE
A 32.1	254B2	SV UP CASSETTE MOUNTING DEVICE
A 32.2	254B3	SV SLIP-IN CASSETTE
A 32.3	254B4	SV MOVE CASSETTE MOUNTING DEV. REVERSE
A 32.4	254H5	START ALARM LAMP
A 32.5	254K6	START ALARM HORN
A 32.6	A 32.6	SPARE
A 32.7	A 32.7	SPARE
A 40.0	A 40.0	WIDTH MEASURING DEV. REQUIRE WIDTH

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A 40.1	A 40.1	WARM AIR STEP 1/2/3
A 40.2	A 40.2	CEMENTING 1 EDGE CEMENTING ON
A 40.3	A925.1	LINEAR CHECK WEIGHER DEMAND ACTUAL WEIG.
A 40.4	A925.2	LINEAR CHECK WEIGHER RESET OUTPUTS
A 40.5	A925.3	LINEAR CHECK WEIGHER FAULT ACKNOWLEDGING
A 40.6	A925.4	LINEAR WEIGHT IS TO LOW
A 40.7	A 40.7	CONTINUOUS WEIGHT IS O.K.
A 41.0	A925.6	LINEAR WEIGHT IS TO HIGH
A 41.1	267B2	COLOUR MARKING DEVICE
A 41.2	267B3	CEMENTING 1 ROLL UP LEFT SIDE
A 41.3	267B4	CEMENTING 1 ROLL DOWN LEFT SIDE
A 41.4	267K5	CENTERING DEVICE 1 CENTER/AUTO
A 41.5	267K6	CENTERING DEVICE 1 BLOCKING
A 41.6	A 41.6	CEMENTING 1 ROLL UP RIGHT SIDE
A 41.7	A 41.7	CEMENTING 1 ROLL DOWN RIGHT SIDE
A 42.0	A 42.0	CEMENTING 2 ROLL UP LEFT SIDE
A 42.1	A 42.1	CEMENTING 2 ROLL DOWN LEFT SIDE
A 42.2	A 42.2	CEMENTING 2 ROLL UP RIGHT SIDE
A 42.3	A 42.3	CEMENTING 2 ROLL DOWN RIGHT SIDE
A 42.4	A 42.4	SPARE
A 42.5	A 42.5	SPARE
A 42.6	A 42.6	SPARE
A 42.7	A 42.7	SPARE
A 50.0	279B1	FEEDER SCRAP ROLLER CONVEYOR
A 50.1	279H1	SPARE
A 50.2	279B3	FEEDER LOWER CONVEYER BELT GUIDING
A 50.3	279B4	FEEDER UPPER CONVEYOR BELT GUIDING
A 50.4	279B5	FEEDER UPPER CONVEYOR BELT DOWN
A 50.5	279B6	FEEDER PINCH ROLL DOWN
A 50.6	279B7	EXTRUDER CALENDER OIL COOLING ON
A 50.7	279B8	EXTRUDER CALENDER COOLING INLET
A 51.0	280H1	EXT.READY TO START (LAMP) (EXTR.CAL.PAN.)
A 51.1	280H2	EXTRUDER FAULT (LAMP) (EXTR.CAL.PAN.)
A 51.2	280H3	EXTRUDER ON (LAMP) (EXTR.CAL.PAN.)
A 51.3	30H5	FEEDER RIPCORD RIGHT SIDE (LAMP)
A 51.4	30H7	FEEDER RIPCORD LEFT SIDE (LAMP)
A 51.5	30H8	LAMP CEMENTING 2 ON (EXTR.CAL.PAN)
A 51.6	A 51.6	FEEDER HORN
A 51.7	A 51.7	FEEDER LAMP
A 60.0	A 60.0	CALENDER FEEDING BELT LEFT
A 60.1	A 60.1	CALENDER FEEDING BELT RIGHT
A 60.2	A 60.2	LAMP CEMENTING 1 EDGE CEM.ON (CAL PANEL)
A 60.3	A 60.3	SPARE
A 60.4	290H5	CAL READY TO START (LAMP) (CAL PANEL)
A 60.5	290H6	CALENDER FAULT (LAMP) (CAL PANEL)
A 60.6	290H7	FAULT LINE (LAMP) (CAL PANEL)
A 60.7	290H8	CALENDER PREHEATING (LAMP) (CAL PANEL)
A 61.0	291H1	CAL ON (LAMP) (CAL PANEL)
A 61.1	A 61.1	DISKROLL DOWN
A 61.2	A 61.2	LAMP CEMENTING 1 ON (CAL PANEL)
A 61.3	A 61.3	SPARE
A 61.4	A 61.4	SPARE
A 61.5	A 61.5	SPARE
A 61.6	A 61.6	SPARE
A 61.7	A 61.7	SPARE
A 70.0	A942.1	TREAD CHECKER DEMAND ACTUAL WEIGHT
A 70.1	A942.2	TREAD CHECKER RESET OUTPUTS
A 70.2	A942.3	TREAD CHECKER FAULT ACKNOWLEDGING
A 70.3	A942.4	TREAD CHECKER UNDERWEIGHT
A 70.4	A942.5	TREAD CHECKER WEIGHT OK
A 70.5	A942.6	TREAD CHECKER OVERWEIGHT
A 70.6	302B7	CUT END CEMENTING IN THE FRONT
A 70.7	302B8	CUT END CEMENTING IN THE BACK
A 71.0	303B1	CUT END CEMENTING CLOSE FLAP
A 71.1	A 71.1	SPARE
A 71.2	303B3	SCRAP FLAP UP
A 71.3	A960.1	SPARE
A 71.4	A960.2	CENTERING 2 CENTER/AUTO
A 71.5	A960.3	CENTERING 2 BLOCKING
A 71.6	A960.4	UNUSED
A 71.7	A 71.7	SCRAP FLAP DOWN
A 72.0	304K1	WIND-UP STAT 1 CONTROLLER RELEASE

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OPERAND	SYMBOL	KOMMENTAR
A 72.1	304K2	WIND-UP STAT 2 CONTROLLER RELEASE
A 72.2	304K3	WIND-UP STAT 3 CONTROLLER RELEASE
A 72.3	304K4	WIND-UP STAT 4 CONTROLLER RELEASE
A 72.4	304H4	WARNING
A 72.5	304K6	HORN
A 72.6	A 72.6	FLAP CUT END CEMENTING
A 72.7	A 72.7	SCRAP MARKING 1
A 80.0	209H1	UP.EXT.READY TO START (MAIN CONTR.PAN.)
A 80.1	209H2	UPPER EXTRUDER ON (MAIN CONTR.PAN.)
A 80.2	209H3	BOT.EXT.READY TO START (MAIN CONTR.PAN.)
A 80.3	209H4	BOTTOM EXTRUDER ON (MAIN CONTR.PAN.)
A 80.4	209H5	LINE READY TO START (MAIN CONTR.PAN.)
A 80.5	209H6	CALENDER PREHEATING (MAIN CONTR.PAN.)
A 80.6	209H7	CAL. READY TO START (MAIN CONTR.PAN.)
A 80.7	209H8	TREAD SKIVER READY TO START
A 81.0	210H1	FAULT (MAIN CONTROL PANEL)
A 81.1	210H2	CONTROL VOLTAGE ON (MAIN CONTROL PANEL)
A 81.2	210H3	PROGRAM IS RUNNING (MAIN CONTROL PANEL)
A 81.3	210H4	AUTOMATIC (MAIN CONTROL PANEL)
A 81.4	210H5	MANUAL (MAIN CONTROL PANEL)
A 81.5	210H6	LINE ON (MAIN CONTROL PANEL)
A 81.6	A 81.6	LAMP DIFFERENT PROFILE PART A/B
A 81.7	A 81.7	SPARE
A 82.0	A 82.0	SPARE
A 82.1	A 82.1	SPARE
A 82.2	A 82.2	SPARE
A 82.3	A 82.3	SPARE
A 82.4	A 82.4	SPARE
A 82.5	A 82.5	SPARE
A 82.6	A 82.6	SPARE
A 82.7	A 82.7	SPARE
A 83.0	A 83.0	SPARE
A 83.1	A 83.1	SPARE
A 83.2	A 83.2	SPARE
A 83.3	A 83.3	SPARE
A 83.4	A 83.4	SPARE
A 83.5	A 83.5	SPARE
A 83.6	A 83.6	SPARE
A 83.7	A 83.7	SPARE
A 92.0	A 92.0	TEMPER. UNIT 3 : ON
A 92.1	A 92.1	SPARE
A 92.2	A 92.2	SPARE
A 92.3	A 92.3	SPARE
A 92.4	A 92.4	SPARE
A 92.5	A 92.5	SPARE
A 92.6	A 92.6	SPARE
A 92.7	A 92.7	SPARE
A 93.0	A 93.0	TEMPER. UNIT 2 : ON
A 93.1	A 93.1	SPARE
A 93.2	A 93.2	SPARE
A 93.3	A 93.3	SPARE
A 93.4	A 93.4	SPARE
A 93.5	A 93.5	SPARE
A 93.6	A 93.6	SPARE
A 93.7	A 93.7	SPARE
A 94.0	A 94.0	TEMPER. UNIT 1 : ON
A 94.1	A 94.1	SPARE
A 94.2	A 94.2	SPARE
A 94.3	A 94.3	SPARE
A 94.4	A 94.4	SPARE
A 94.5	A 94.5	SPARE
A 94.6	A 94.6	SPARE
A 94.7	A 94.7	SPARE
M 0.0	M 0.0	"0"-SIGNAL
M 0.1	M 0.1	"1"-SIGNAL
M 0.2	M 0.2	SPARE
M 0.3	M 0.3	TACT 0.5 HZ
M 0.4	M 0.4	TACT 1 HZ
M 0.5	M 0.5	TACT 2 HZ
M 0.6	M 0.6	HF IMPULSE PER SECOND
M 0.7	M 0.7	IMPULSE PER SECOND
M 1.0	M 1.0	TACT 5 HZ

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OPERAND	SYMBOL	KOMMENTAR
M 1.1	M 1.1	HF TACT 1 HZ
M 1.2	M 1.2	HF TACT 2 HZ
M 1.3	M 1.3	HF TACT 5 HZ
M 1.4	M 1.4	HF TACT 0.5 HZ
M 1.5	M 1.5	HF TACT O.5 HZ
M 1.6	M 1.6	HF TACT 1 HZ
M 1.7	M 1.7	HF TACT 2 HZ
M 2.0	M 2.0	HF TACT 5 HZ
M 2.1	M 2.1	OPERATOR CHANGE
M 2.2	M 2.2	INSTALL PROFILE
M 2.3	M 2.3	SPARE
M 2.4	M 2.4	FAULT + START ALARM
M 2.5	M 2.5	WIND-UP
M 2.6	M 2.6	HF SET CP525-TIME
M 2.7	M 2.7	BOOKING
M 3.0	M 3.0	SPARE
M 3.1	M 3.1	SPARE
M 3.2	M 3.2	DIFFERENT PROFILE PARTS A/B
M 3.3	M 3.3	DIFFERENT PROFILE PARTS A/C
M 3.4	M 3.4	COPY PART B V(new) <= 1.1 V(old)
M 3.5	M 3.5	LOAD AND SELECTED PROF. = ACTUAL PROF.
M 3.6	M 3.6	NO MATERIAL IN LINE
M 3.7	M 3.7	FLAG FOR FIRST SCAN
M 4.0	M 4.0	MATERIAL AT PART C
M 4.1	M 4.1	NO MATERIAL ON WEIGHER
M 4.2	M 4.2	HF NO MATERIAL ON WEIGHER
M 4.3	M 4.3	IMPULSE NO MATERIAL ON WEIGHER
M 4.4	M 4.4	TRACKING ON
M 4.5	M 4.5	TRACKING COUNTER 1 = 900
M 4.6	M 4.6	LOAD PROFILE
M 4.7	M 4.7	PROFILE PART A=B=C
M 5.0	M 5.0	TIME FOR PRODUCTION REPORT
M 5.1	M 5.1	TIME FOR PRODUCTION REPORT
M 5.2	M 5.2	RESET PRODUCTION DATAS
M 5.3	M 5.3	COPY PROFILE PART C
M 5.4	M 5.4	IMPULSE SET CP525-TIME
M 5.5	M 5.5	SPARE
M 5.6	M 5.6	SPARE
M 5.7	M 5.7	SPARE
M 6.0	M 6.0	SPARE
M 6.1	M 6.1	SPARE
M 6.2	M 6.2	SPARE
M 6.3	M 6.3	SPARE
M 6.4	M 6.4	SPARE
M 6.5	M 6.5	SPARE
M 6.6	M 6.6	SPARE
M 6.7	M 6.7	SPARE
M 7.0	M 7.0	SPARE
M 7.1	M 7.1	SPARE
M 7.2	M 7.2	SPARE
M 7.3	M 7.3	SPARE
M 7.4	M 7.4	SPARE
M 7.5	M 7.5	FAULT LAMP
M 7.6	M 7.6	V-LINE PRESET > V-LINE LIMIT
M 7.7	M 7.7	FAULT HORN + LAMP
M 8.0	M 8.0	TREAD SKIVER : SWITCH IS IN AUTOMAT
M 8.1	M 8.1	TREAD SKIVER : READY FOR START
M 8.2	M 8.2	TREAD SKIVER : AUX DRIVES ON
M 8.3	M 8.3	TREAD SKIVER : FAULT (MACHINE OFF)
M 8.4	M 8.4	TREAD SKIVER : KNIFE RETURNED
M 8.5	M 8.5	TREAD SKIVER : KNIFE NORMAL POSITION
M 8.6	M 8.6	TREAD SKIVER : LENGTH MEASURING ACTIVE
M 8.7	M 8.7	SPARE
M 9.0	M 9.0	E-STOP TRIGGERED
M 9.1	M 9.1	CONTROL VOLTAGE IS ON
M 9.2	M 9.2	RELEASE AUTOATIC "PROGRAM START"
M 9.3	M 9.3	PROGRAM IS RUNNING (AUTOMATIC)
M 9.4	M 9.4	FAULT COLLECTION
M 9.5	M 9.5	FAULT IS ACKNOWLEDGED
M 9.6	M 9.6	PROGRAM STOP
M 9.7	M 9.7	PLANT IS OPERATING
M 10.0	M 10.0	CLAMPING CLOSED

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OPERAND	SYMBOL	KOMMENTAR
M 10.1	M 10.1	CLAMPING OPEN
M 10.2	M 10.2	MEDIUM PART CLOSED
M 10.3	M 10.3	UPPER PART CLOSED
M 10.4	M 10.4	LOCKING CYLINDER : LOCKING POSITION
M 10.5	M 10.5	LOCKING CYLINDER MOVED OUT
M 10.6	M 10.6	LOCKING CYLINDER HOME POSITION
M 10.7	M 10.7	EJECTING DEVICE CLOSED
M 11.0	M 11.0	EJECTING DEVICE OPEN
M 11.1	M 11.1	CASSETTE INSTALLED
M 11.2	M 11.2	SPARE
M 11.3	M 11.3	RELEASE EXTRUSION HEAD PARTS
M 11.4	M 11.4	RELEASE CLAMPING
M 11.5	M 11.5	SPARE
M 11.6	M 11.6	NO FAULT DUPLEX EXTRUSION HEAD
M 11.7	M 11.7	RELEASE DUPLEX EXTRUSION HEAD
M 12.0	M 12.0	DEMAND 50 BAR
M 12.1	M 12.1	IMPULSE DEMAND 50 BAR
M 12.2	M 12.2	HF DEMAND 50 BAR
M 12.3	M 12.3	DEMAND 120 BAR
M 12.4	M 12.4	IMPULSE DEMAND 120 BAR
M 12.5	M 12.5	HF DEMAND 120 BAR
M 12.6	M 12.6	DEMAND 130 BAR
M 12.7	M 12.7	IMPULSE DEMAND 130 BAR
M 13.0	M 13.0	HF DEMAND 130 BAR
M 13.1	M 13.1	DEMAND 180 BAR
M 13.2	M 13.2	IMPULSE DEMAND 180 BAR
M 13.3	M 13.3	HF DEMAND 180 BAR
M 13.4	M 13.4	PRESSURE 50 BAR
M 13.5	M 13.5	PRESSURE 120 BAR
M 13.6	M 13.6	PRESSURE 130 BAR
M 13.7	M 13.7	PRESSURE 180 BAR
M 14.0	M 14.0	HYDRAULIC PUMP ON
M 14.1	M 14.1	RELEASE SOLENOID VALVE 50 BAR
M 14.2	M 14.2	RELEASE SOLENOID VALVE 120 BAR
M 14.3	M 14.3	RELEASE SOLENOID VALVE 130 BAR
M 14.4	M 14.4	RELEASE SOLENOID VALVE 180 BAR
M 14.5	M 14.5	SPARE
M 14.6	M 14.6	SPARE
M 14.7	M 14.7	SPARE
M 15.0	M 15.0	LOCKING : OPEN MEDIUM PART
M 15.1	M 15.1	OPEN MEDIUM PART
M 15.2	M 15.2	LOCKING : CLOSE MEDIUM PART
M 15.3	M 15.3	CLOSE M.P. S1 / PROP.VALVE 180 BAR
M 15.4	M 15.4	CLOSE M.P. S2 / SV OPEN M.P.
M 15.5	M 15.5	CLOSE M.P. S3 / VALVE UNLOCKING M.P.
M 15.6	M 15.6	CLOSE M.P. S4 / PROP.VALVE 50 BAR
M 15.7	M 15.7	CLOSE M.P. S5 / SV CLOSE M.P.
M 16.0	M 16.0	CLOSE M.P. S6 / CICLE FINISHED
M 16.1	M 16.1	CLOSE M.P. CICLE MARK
M 16.2	M 16.2	SPARE
M 16.3	M 16.3	LOCKING : CLOSE M.P. JOG MODE
M 16.4	M 16.4	VALVE UNLOCKING M.P.(CICLE CLOSE M.P.)
M 16.5	M 16.5	SV OPEN M.P. (CICLE CLOSE M.P.)
M 16.6	M 16.6	SPARE
M 16.7	M 16.7	SPARE
M 17.0	M 17.0	EXTR. POSITION LOOP LINEAR CHECK WEIGHER
M 17.1	M 17.1	EXTR. POSITION LOOP CONVEYOR CEMENTING 2
M 17.2	M 17.2	EXTR. POSITION LOOP COOLING SECTION 1
M 17.3	M 17.3	EXTR. POSITION LOOP COOLING SECTION 2
M 17.4	M 17.4	EXTR. POSITION LOOP COOLING SECTION 3
M 17.5	M 17.5	EXTR. POSITION LOOP COOLING SECTION 4
M 17.6	M 17.6	EXTR. POSITION LOOP CALENDER
M 17.7	M 17.7	SPARE
M 18.0	M 18.0	LOCKING : OPEN UPPER PART
M 18.1	M 18.1	OPEN UPPER PART
M 18.2	M 18.2	LOCKING : CLOSE UPPER PART
M 18.3	M 18.3	CLOSE U.P. S1 / PROP.VALVE 180 BAR
M 18.4	M 18.4	CLOSE U.P. S2 / SV OPEN U.P.
M 18.5	M 18.5	CLOSE U.P. S3 / VALVE UNLOCKING U.P.
M 18.6	M 18.6	CLOSE U.P. S4 / PROP.VALVE 50 BAR
M 18.7	M 18.7	CLOSE U.P. S5 / SV CLOSE U.P.
M 19.0	M 19.0	CLOSE U.P. S6 / CICLE FINISHED

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OPERAND	SYMBOL	KOMMENTAR
M 19.1	M 19.1	CLOSE U.P. CICLE MARK
M 19.2	M 19.2	SPARE
M 19.3	M 19.3	LOCKING : CLOSE U.P. JOG MODE
M 19.4	M 19.4	VALVE UNLOCKING U.P.(CICLE CLOSE U.P.)
M 19.5	M 19.5	SV OPEN U.P. (CICLE CLOSE U.P.)
M 19.6	M 19.6	BUILT SENDIMPULSE
M 19.7	M 19.7	BUILT SENDIMPULSE
M 20.0	M 20.0	START CONDITION CLOSE LOCKING CYLINDER
M 20.1	M 20.1	CLOSE L.C. S1 / PROP.VALVE 180 BAR
M 20.2	M 20.2	CLOSE L.C. S2 / SV FORWARD LOCK.CYL.
M 20.3	M 20.3	CLOSE L.C. S3 / PROP.VALVE 50 BAR
M 20.4	M 20.4	CLOSE L.C. S4 / SV REVERSE LOCK.CYL.
M 20.5	M 20.5	CLOSE L.C. S5 / PROP.VALVE 130 BAR
M 20.6	M 20.6	CLOSE L.C. S6 / HIGH PRESSURE BUILT UP
M 20.7	M 20.7	CLOSE L.C. S7 / CICLE FINISHED
M 21.0	M 21.0	CLOSE L.C. CICLE MARK
M 21.1	M 21.1	CLOSE L.C. PART 1 ACTIVE
M 21.2	M 21.2	CLOSE L.C. PART 2 ACTIVE
M 21.3	M 21.3	CLOSE L.C. PART 3 ACTIVE
M 21.4	M 21.4	CLOSE L.C. S4a / Q1 OFF
M 21.5	M 21.5	M.P. / U.P. / Q1 (CICLE CLOSE L.C)
M 21.6	M 21.6	HF MOVE L.C. START AFTER E-STOP
M 21.7	M 21.7	IMPULSE MOVE L.C. START AFTER E-STOP
M 22.0	M 22.0	START CONDITION OPEN LOCKING CYLINDER
M 22.1	M 22.1	OPEN L.C. S1 / PROP.VALVE 130 BAR
M 22.2	M 22.2	OPEN L.C. S2 / PR.TRANSDUCER HOME POS.
M 22.3	M 22.3	OPEN L.C. S3 / REBUILT HIGH PRESSURE
M 22.4	M 22.4	OPEN L.C. S4 / PROP.VALVE 50 BAR
M 22.5	M 22.5	OPEN L.C. S5 / SV FORWARD L.C.
M 22.6	M 22.6	OPEN L.C. S6 / PROP.VALVE 50 BAR
M 22.7	M 22.7	OPEN L.C. S7 / SV REVERSE L.C.
M 23.0	M 23.0	OPEN L.C. S8 / PROP.VALVE 180 BAR
M 23.1	M 23.1	OPEN L.C. S9 / SV OPEN UPPER PART
M 23.2	M 23.2	OPEN L.C. S10 / CICLE FINISHED
M 23.3	M 23.3	OPEN LOCKING CYLINDER CICLE MARK
M 23.4	M 23.4	OPEN L.C. PART 1 ACTIVE
M 23.5	M 23.5	OPEN L.C. PART 2 ACTIVE
M 23.6	M 23.6	OPEN L.C. PART 3 ACTIVE
M 23.7	M 23.7	OPEN L.C. PART 4 ACTIVE
M 24.0	M 24.0	OPEN L.C. STEP S7a / Q1 OFF
M 24.1	M 24.1	M.P. / U.P. / Q1 (CICLE OPEN L.C.)
M 24.2	M 24.2	PRESSURE FEEDING LOCKING CYLINDER ON
M 24.3	M 24.3	HF PRESSURE FEED. LOCK.CYLINDER ON
M 24.4	M 24.4	PRESSURE FEEDING LOCK.CYLINDER ACTIVE
M 24.5	M 24.5	TIMECONTROL PR.FEED. L.C. TERMINATED
M 24.6	M 24.6	PRESSURE TRANSDUCER MOVE HOME BY FEEDING
M 24.7	M 24.7	SPARE
M 25.0	M 25.0	LOCKING : CLAMPING
M 25.1	M 25.1	OPEN CLAMPING
M 25.2	M 25.2	CLOSE CLAMPING
M 25.3	M 25.3	LOCKING : CASSETTE
M 25.4	M 25.4	PRESS OUT CASSETTE
M 25.5	M 25.5	INSTALL CASSETTE
M 25.6	M 25.6	IMPULSE POS.FLANK PRESS.FEED.CLAMPING ON
M 25.7	M 25.7	HF POS.FLANK PRESSURE FEED.CLAMPING ON
M 26.0	M 26.0	IMPULSE NEG.FLANK PRESS.FEED.CLAMP. OFF
M 26.1	M 26.1	HF NEG.FLANK PRESSURE FEED.CLAMPING OFF
M 26.2	M 26.2	PREESURE FEEDING CLAMPING ON
M 26.3	M 26.3	HF PRESSURE FEEDING CLAMPING ON
M 26.4	M 26.4	PRESSURE FEEDING CLAMPING ACTIVE
M 26.5	M 26.5	TIMECONTROL PR.FEED. CLAMP. TERMINATED
M 26.6	M 26.6	RUN AFTER TIME OPEN CLAMPS
M 26.7	M 26.7	RELEASE EXTRUDER HEAD OPEN
M 27.0	M 27.0	RELEASE EXTRUDER WITHOUT CASSETTE
M 27.1	M 27.1	RELEASE EXTRUDER WITH CASSETTE
M 27.2	M 27.2	PRESSURE CHANNEL 1 (UP.EXTR.) <= 15 BAR
M 27.3	M 27.3	PRESSURE CHANNEL 2 (BOT.EXTR.) <= 15 BAR
M 27.4	M 27.4	SPARE
M 27.5	M 27.5	PRESSURE CHANNEL 1 >= MAX PRESSURE
M 27.6	M 27.6	SPARE
M 27.7	M 27.7	PRESSURE CHANNEL 2 >= MAX PRESSURE
M 28.0	M 28.0	LIFT CASSETTE MOUNTING DEVICE

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OPERAND	SYMBOL	KOMMENTAR
M 28.1	M 28.1	LOWER CASSETTE MOUNTING DEVICE
M 28.2	M 28.2	SLIP-IN CASSETTE
M 28.3	M 28.3	REVERSE SLIP-IN DEVICE
M 28.4	M 28.4	KEYSWITCH REBUILD HIGH PRESSURE
M 28.5	M 28.5	PRESSURE TRANSDUCER HOMEPOSITION
M 28.6	M 28.6	SPARE
M 28.7	M 28.7	SPARE
M 29.0	M 29.0	SPARE
M 29.1	M 29.1	SPARE
M 29.2	M 29.2	SPARE
M 29.3	M 29.3	SPARE
M 29.4	M 29.4	SPARE
M 29.5	M 29.5	SPARE
M 29.6	M 29.6	PRESS.DIFF.EXCEEDED : UPPER EXTR. OFF
M 29.7	M 29.7	PRESS.DIFF.EXCEEDED : BOTTOM EXTR. OFF
M 30.0	M 30.0	SEND CICLE No. 1 : COUNTER
M 30.1	M 30.1	SEND CICLE No. 1 : HF RUN
M 30.2	M 30.2	SEND CICLE No. 1 : RUN
M 30.3	M 30.3	SEND CICLE No. 1 : FAIL
M 30.4	M 30.4	SEND CICLE No. 2 : COUNTER
M 30.5	M 30.5	SEND CICLE No. 2 : HF RUN
M 30.6	M 30.6	SEND CICLE No. 2 : RUN
M 30.7	M 30.7	SEND CICLE No. 2 : FAIL
M 31.0	M 31.0	SEND CICLE No. 3 : COUNTER
M 31.1	M 31.1	SEND CICLE No. 3 : HF RUN
M 31.2	M 31.2	SEND CICLE No. 3 : RUN
M 31.3	M 31.3	SEND CICLE No. 3 : FAIL
M 31.4	M 31.4	SEND CICLE No. 4 : COUNTER
M 31.5	M 31.5	SEND CICLE No. 4 : HF RUN
M 31.6	M 31.6	SEND CICLE No. 4 : RUN
M 31.7	M 31.7	SEND CICLE No. 4 : FAIL
M 32.0	M 32.0	SEND CICLE No. 5 : COUNTER
M 32.1	M 32.1	SEND CICLE No. 5 : HF RUN
M 32.2	M 32.2	SEND CICLE No. 5 : RUN
M 32.3	M 32.3	SEND CICLE No. 5 : FAIL
M 32.4	M 32.4	SEND CICLE No. 6 : COUNTER
M 32.5	M 32.5	SEND CICLE No. 6 : HF RUN
M 32.6	M 32.6	SEND CICLE No. 6 : RUN
M 32.7	M 32.7	SEND CICLE No. 6 : FAIL
M 33.0	M 33.0	SEND CICLE No. 7 : COUNTER
M 33.1	M 33.1	SEND CICLE No. 7 : HF RUN
M 33.2	M 33.2	SEND CICLE No. 7 : RUN
M 33.3	M 33.3	SEND CICLE No. 7 : FAIL
M 33.4	M 33.4	SEND CICLE No. 8 : COUNTER
M 33.5	M 33.5	SEND CICLE No. 8 : HF RUN
M 33.6	M 33.6	SEND CICLE No. 8 : RUN
M 33.7	M 33.7	SEND CICLE No. 8 : FAIL
M 34.0	M 34.0	SEND CICLE No. 9 : COUNTER
M 34.1	M 34.1	SEND CICLE No. 9 : HF RUN
M 34.2	M 34.2	SEND CICLE No. 9 : RUN
M 34.3	M 34.3	SEND CICLE No. 9 : FAIL
M 34.4	M 34.4	SEND CICLE No.10 : COUNTER
M 34.5	M 34.5	SEND CICLE No.10 : HF RUN
M 34.6	M 34.6	SEND CICLE No.10 : RUN
M 34.7	M 34.7	SEND CICLE No.10 : FAIL
M 35.0	M 35.0	SEND CICLE No.11 : COUNTER
M 35.1	M 35.1	SEND CICLE No.11 : HF RUN
M 35.2	M 35.2	SEND CICLE No.11 : RUN
M 35.3	M 35.3	SEND CICLE No.11 : FAIL
M 35.4	M 35.4	SEND CICLE No.12 : COUNTER
M 35.5	M 35.5	SEND CICLE No.12 : HF RUN
M 35.6	M 35.6	SEND CICLE No.12 : RUN
M 35.7	M 35.7	SEND CICLE No.12 : FAIL
M 36.0	M 36.0	SEND CICLE No.13 : COUNTER
M 36.1	M 36.1	SEND CICLE No.13 : HF RUN
M 36.2	M 36.2	SEND CICLE No.13 : RUN
M 36.3	M 36.3	SEND CICLE No.13 : FAIL
M 36.4	M 36.4	SEND CICLE No.14 : COUNTER
M 36.5	M 36.5	SEND CICLE No.14 : HF RUN
M 36.6	M 36.6	SEND CICLE No.14 : RUN
M 36.7	M 36.7	SEND CICLE No.14 : FAIL
M 37.0	M 37.0	SEND CICLE No.15 : COUNTER

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OPERAND	SYMBOL	KOMMENTAR
M 37.1	M 37.1	SEND CICLE No.15 : HF RUN
M 37.2	M 37.2	SEND CICLE No.15 : RUN
M 37.3	M 37.3	SEND CICLE No.15 : FAIL
M 37.4	M 37.4	SEND CICLE No.16 : COUNTER
M 37.5	M 37.5	SEND CICLE No.16 : HF RUN
M 37.6	M 37.6	SEND CICLE No.16 : RUN
M 37.7	M 37.7	SEND CICLE No.16 : FAIL
M 38.0	M 38.0	TIMER : LIFTING CASSETTE MOUNTING DEVICE
M 38.1	M 38.1	TIMER : SLIP-IN CASSETTE
M 38.2	M 38.2	SPARE
M 38.3	M 38.3	SPARE
M 38.4	M 38.4	READ CICLE No. 1-16 : COUNTER
M 38.5	M 38.5	READ CICLE No. 1-16 : HF RUN
M 38.6	M 38.6	READ CICLE No. 1-16 : RUN
M 38.7	M 38.7	READ CICLE No. 1-16 : FAIL
M 39.0	M 39.0	SPARE
M 39.1	M 39.1	SPARE
M 39.2	M 39.2	SPARE
M 39.3	M 39.3	SPARE
M 39.4	M 39.4	SPARE
M 39.5	M 39.5	SPARE
M 39.6	M 39.6	SPARE
M 39.7	M 39.7	SPARE
M 40.0	M 40.0	UP.EXTR. : GENERAL FAULTS
M 40.1	M 40.1	UP.EXTR. : AUXILIARY DRIVES ON
M 40.2	M 40.2	UP.EXTR. : HF EXTRUDER OFF
M 40.3	M 40.3	UP.EXTR. : IMPULSE EXTRUDER OFF
M 40.4	M 40.4	UP.EXTR. : RUN AFTER TIME AUX DRIVES
M 40.5	M 40.5	UP.EXTR. : EXTRUDER START
M 40.6	M 40.6	UP.EXTR. : AUX DRIVES READY FOR WORK
M 40.7	M 40.7	CALENDER FEEDING BELT LEFT
M 41.0	M 41.0	UP.EXTR. : IMPULSE TOPM REVERSE START
M 41.1	M 41.1	UP.EXTR. : CICLE UPPER EXTRUDER REVERSE
M 41.2	M 41.2	UP.EXTR. : RELEASE UPPER EXTRUDER
M 41.3	M 41.3	UP.EXTR. : DISCHARGING
M 41.4	M 41.4	UP.EXTR. : MIN ARMATURE CURRENT
M 41.5	M 41.5	UP.EXTR. : HF FASTER/SLOWLIER
M 41.6	M 41.6	UP.EXTR. : HF FASTER/SLOWLIER
M 41.7	M 41.7	UP.EXTR. : HF FASTER/SLOWLIER
M 42.0	M 42.0	UP.EXTR. : HF FASTER/SLOWLIER
M 42.1	M 42.1	UP.EXTR. : HF FASTER/SLOWLIER
M 42.2	M 42.2	UP.EXTR. : PRESSURE >= 50 BAR
M 42.3	M 42.3	UP.EXTR. : CONDITION REVERSE SET
M 42.4	M 42.4	UP.EXTR. : HF IMPULSE START
M 42.5	M 42.5	UP.EXTR. : FAULT EXTRUDER OFF
M 42.6	M 42.6	UP.EXTR. : MAINCONTACTOR ON
M 42.7	M 42.7	SPARE
M 43.0	M 43.0	BOT.EXTR. : GENERAL FAULTS
M 43.1	M 43.1	BOT.EXTR. : AUXILIARY DRIVES ON
M 43.2	M 43.2	BOT.EXTR. : HF EXTRUDER OFF
M 43.3	M 43.3	BOT.EXTR. : IMPULSE EXTRUDER OFF
M 43.4	M 43.4	BOT.EXTR. : RUN AFTER TIME AUX DRIVES
M 43.5	M 43.5	BOT.EXTR. : EXTRUDER START
M 43.6	M 43.6	BOT.EXTR. : AUX DRIVES READY FOR WORK
M 43.7	M 43.7	SPARE
M 44.0	M 44.0	BOT.EXTR. : IMPULSE BOTTOM EXTR. START
M 44.1	M 44.1	BOT.EXTR. : CICLE BOTTOM EXTR. REVERSE
M 44.2	M 44.2	BOT.EXTR. : RELEASE BOTTOM EXTRUDER
M 44.3	M 44.3	BOT.EXTR. : DISCHARGING
M 44.4	M 44.4	BOT.EXTR. : MIN ARMATURE CURRENT
M 44.5	M 44.5	BOT.EXTR. : HF FASTER/SLOWLIER
M 44.6	M 44.6	BOT.EXTR. : HF FASTER/SLOWLIER
M 44.7	M 44.7	BOT.EXTR. : HF FASTER/SLOWLIER
M 45.0	M 45.0	BOT.EXTR. : HF FASTER/SLOWLIER
M 45.1	M 45.1	BOT.EXTR. : HF FASTER/SLOWLIER
M 45.2	M 45.2	BOT.EXTR. : PRESSURE >= 50 BAR
M 45.3	M 45.3	BOT.EXTR. : CONDITION REVERSE SET
M 45.4	M 45.4	SLAB FEEDER OUTPUT BRAKE
M 45.5	M 45.5	BOT.EXTR. : MAINCONTACTOR ON
M 45.6	M 45.6	BOT.EXTR. : HF IMPULSE START
M 45.7	M 45.7	BOT.EXTR. : FAULT EXTRUDER OFF
M 46.0	M 46.0	FAULT TEMPER. UNIT 1 UPPER EXTRUDER

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OPERAND	SYMBOL	KOMMENTAR
M 46.1	M 46.1	FAULT TEMPER. UNIT 1 BOTTOM EXTRUDER
M 46.2	M 46.2	FAULT TEMPER. UNIT 1 EXTRUSION HEAD
M 46.3	M 46.3	FAULT TEMPER. UNIT 3 (PUMP+COMPRESSOR 1)
M 46.4	M 46.4	FAULT TEMPER. UNIT 3 (PUMP+COMPRESSOR 2)
M 46.5	M 46.5	FAULT TEMPER. UNIT 3 (GENERAL)
M 46.6	M 46.6	FAULT TEMPER. UNIT 2 KG90 SCREW + PIN
M 46.7	M 46.7	FAULT TEMPER. UNIT 2 KG90 HEAD
M 47.0	M 47.0	FAULT TEMPER. UNIT 2 CALENDER ROLL
M 47.1	M 47.1	SPARE
M 47.2	M 47.2	SPARE
M 47.3	M 47.3	SPARE
M 47.4	M 47.4	SPARE
M 47.5	M 47.5	SPARE
M 47.6	M 47.6	SPARE
M 47.7	M 47.7	SPARE
M 48.0	M 48.0	FEEDER : GENERAL FAULT
M 48.1	M 48.1	FEEDER : FEEDER START
M 48.2	M 48.2	FEEDER : LOOP EMPTY
M 48.3	M 48.3	FEEDER : HF EXTRUDER ON
M 48.4	M 48.4	FEEDER : IMPULSE EXTRUDER ON
M 48.5	M 48.5	FEEDER : HF EXTRUDER OFF
M 48.6	M 48.6	FEEDER : IMPULSE EXTRUDER OFF
M 48.7	M 48.7	FEEDER : REVERSE
M 49.0	M 49.0	FEEDER : CUTTING KNIFE ON NORMAL
M 49.1	M 49.1	FEEDER : CUTTING TEST
M 49.2	M 49.2	FEEDER : METAL ALARM
M 49.3	M 49.3	FEEDER : DO DOUBLE CUT 1
M 49.4	M 49.4	FEEDER : DOUBLE CUT 1 DONE
M 49.5	M 49.5	FEEDER : KNIFE ON NORMAL
M 49.6	M 49.6	FEEDER : HF ACKNOWLEDGING METALALARM
M 49.7	M 49.7	FEEDER : IMPULSE ACKNOWL. METALALARM
M 50.0	M 50.0	FEEDER : METALALARM ACKNOWLEDGED
M 50.1	M 50.1	FEEDER : DO DOUBLE CUT 2
M 50.2	M 50.2	FEEDER : DOUBLE CUT 2 DONE
M 50.3	M 50.3	FEEDER : SCRAP CONVEYOR UP
M 50.4	M 50.4	FEEDER : HORN METALALARM
M 50.5	M 50.5	FEEDER : RESET METALALARM BEGIN
M 50.6	M 50.6	FEEDER : HF METALALARM ON
M 50.7	M 50.7	FEEDER : IMPULSE METALALARM ON
M 51.0	M 51.0	FEEDER : LAMP METALALARM
M 51.1	M 51.1	SPARE
M 51.2	M 51.2	SPARE
M 51.3	M 51.3	SPARE
M 51.4	M 51.4	SPARE
M 51.5	M 51.5	SPARE
M 51.6	M 51.6	SPARE
M 51.7	M 51.7	SPARE
M 52.0	M 52.0	SPARE
M 52.1	M 52.1	SPARE
M 52.2	M 52.2	SPARE
M 52.3	M 52.3	SPARE
M 52.4	M 52.4	SPARE
M 52.5	M 52.5	SPARE
M 52.6	M 52.6	SPARE
M 52.7	M 52.7	SPARE
M 53.0	M 53.0	SPARE
M 53.1	M 53.1	SPARE
M 53.2	M 53.2	SPARE
M 53.3	M 53.3	SPARE
M 53.4	M 53.4	SPARE
M 53.5	M 53.5	SPARE
M 53.6	M 53.6	SPARE
M 53.7	M 53.7	SPARE
M 54.0	M 54.0	SPARE
M 54.1	M 54.1	SPARE
M 54.2	M 54.2	SPARE
M 54.3	M 54.3	SPARE
M 54.4	M 54.4	SPARE
M 54.5	M 54.5	SPARE
M 54.6	M 54.6	SPARE
M 54.7	M 54.7	SPARE
M 55.0	M 55.0	RELEASE UPPER EXTR. FROM HEATING DEVICE

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OPERAND	SYMBOL	KOMMENTAR
M 55.1	M 55.1	RELEASE BOTTOM EXTR. FROM HEATING DEVICE
M 55.2	M 55.2	RELEASE EXTR.CAL. FROM HEATING DEVICE
M 55.3	M 55.3	RELEASE CALENDER FROM HEATING DEVICE
M 55.4	M 55.4	RELEASE DEH FROM HEATING EQUIPMENT
M 55.5	M 55.5	SPARE
M 55.6	M 55.6	SPARE
M 55.7	M 55.7	SPARE
M 56.0	M 56.0	SPARE
M 56.1	M 56.1	SPARE
M 56.2	M 56.2	SPARE
M 56.3	M 56.3	SPARE
M 56.4	M 56.4	SPARE
M 56.5	M 56.5	EX.CAL. : MAINCONTACTOR ON
M 56.6	M 56.6	EX.CAL. : HF FASTER/SLOWLIER
M 56.7	M 56.7	EX.CAL. : HF FASTER/SLOWLIER
M 57.0	M 57.0	EX.CAL. : GENERAL FAULT EXTRUDER 3
M 57.1	M 57.1	EX.CAL. : AUX DRIVES ON
M 57.2	M 57.2	EX.CAL. : HF EXTRUDER 3 OFF
M 57.3	M 57.3	EX.CAL. : IMPULSE EXTRUDER 3 OFF
M 57.4	M 57.4	EX.CAL. : RUN AFTER TIME AUX DRIVES
M 57.5	M 57.5	EX.CAL. : EXTRUDER START
M 57.6	M 57.6	EX.CAL. : AUX DRIVES READY FOR WORK
M 57.7	M 57.7	EX.CAL. : FAULT EXTRUDER OFF
M 58.0	M 58.0	EX.CAL. : IMPULSE EXTRUDER REVERSE START
M 58.1	M 58.1	EX.CAL. : CICLE EXTRUDER REVERSE
M 58.2	M 58.2	EX.CAL. : RELEASE EXTRUDER 3
M 58.3	M 58.3	EX.CAL. : DISCHARGING
M 58.4	M 58.4	EX.CAL. : MIN ARMATURE CURRENT
M 58.5	M 58.5	EX.CAL. : HF FASTER/SLOWLIER
M 58.6	M 58.6	EX.CAL. : HF FASTER/SLOWLIER
M 58.7	M 58.7	EX.CAL. : HF FASTER/SLOWLIER
M 59.0	M 59.0	SEND PARAMETERS BOTTOMMACHINE SCREW
M 59.1	M 59.1	SEND PARAMETERS BOTTOMMACHINE SCREW
M 59.2	M 59.2	SEND PARAMETERS BOTTOMMACHINE BARREL
M 59.3	M 59.3	SEND PARAMETERS BOTTOMMACHINE BARREL
M 59.4	M 59.4	SEND PARAMETERS TOPMACHINE SCREW
M 59.5	M 59.5	SEND PARAMETERS TOPMACHINE SCREW
M 59.6	M 59.6	SEND PARAMETERS TOPMACHINE BARREL
M 59.7	M 59.7	SEND PARAMETERS TOPMACHINE BARREL
M 60.0	M 60.0	COUNTER 49 DONE
M 60.1	M 60.1	COUNTER 49 > 110
M 60.2	M 60.2	HF COUNTER 49 > 110
M 60.3	M 60.3	IMPULSE COUNTER 49 > 110
M 60.4	M 60.4	HF SCRAP CONVEYOR
M 60.5	M 60.5	IMPULSE SCRAP CONVEYOR
M 60.6	M 60.6	SCRAP CONVEYOR ON
M 60.7	M 60.7	FIRST SCAN
M 61.0	M 61.0	EX.CAL. : CONDITION REVERSE
M 61.1	M 61.1	EX.CAL. : CONDITION REVERSE SET
M 61.2	M 61.2	EX.CAL. : CONDITION REVERSE OFF
M 61.3	M 61.3	TREAD CHECKER : HF TREAD OUTLET
M 61.4	M 61.4	EX.CAL. : HF IMPULSE REVERSE
M 61.5	M 61.5	EX.CAL. : HF MATERIAL OK
M 61.6	M 61.6	EX.CAL. : IMPULSE MATERIAL OK
M 61.7	M 61.7	TREAD CHECKER : IMPULSE TREAD OUTLET
M 62.0	M 62.0	TREAD CHECKER : IMPULSE DEMAND WEIGHT
M 62.1	M 62.1	TREAD CHECKER : HF DEMAND WEIGHT
M 62.2	M 62.2	TREAD CHECKER : HF TREAD UNDER SCRAP M.
M 62.3	M 62.3	TREAD CHECKER : SCRAP (FB87)
M 62.4	M 62.4	TREAD CHECKER : WEIGHT OK (FB87)
M 62.5	M 62.5	TREAD CHECKER : IMP. TREAD UNDER SCRAP M
M 62.6	M 62.6	SPARE
M 62.7	M 62.7	HF ADD TO TREADS TOTAL
M 63.0	M 63.0	IMPULSE ADD TO TREADS TOTAL
M 63.1	M 63.1	HF SCRAP IDENTIFICATION
M 63.2	M 63.2	IMPULSE SCRAP IDENTIFICATION
M 63.3	M 63.3	SCRAP : HF SCRAP DETECTED
M 63.4	M 63.4	SCRAP : IMPULSE SCRAP DETECTED
M 63.5	M 63.5	SCRAP : SV OPEN SCRAP FLAP
M 63.6	M 63.6	SCRAP : RESET SV OPEN SCRAP FLAP
M 63.7	M 63.7	SCRAP : HF CLOSE SCRAP FLAP
M 64.0	M 64.0	SCRAP : IMPULSE CLOSE SCRAP FLAP

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OPERAND	SYMBOL	KOMMENTAR
M 64.1	M 64.1	SCRAP : SCRAP DETECTED
M 64.2	M 64.2	TREAD CHECKER : COUNTER 1 SCRAP = 900
M 64.3	M 64.3	TREAD CHECKER : COUNTER 1 OK = 900
M 64.4	M 64.4	TREAD CHECKER : COUNTER 1 TOTAL = 900
M 64.5	M 64.5	SCRAP DETECTED : COUNTER 1 = 900
M 64.6	M 64.6	SCRAP : RESET SCRAP DETECTED
M 64.7	M 64.7	SPARE
M 65.0	M 65.0	SPARE
M 65.1	M 65.1	SPARE
M 65.2	M 65.2	SPARE
M 65.3	M 65.3	SPARE
M 65.4	M 65.4	SPARE
M 65.5	M 65.5	SPARE
M 65.6	M 65.6	SPARE
M 65.7	M 65.7	SPARE
M 66.0	M 66.0	SPARE
M 66.1	M 66.1	SPARE
M 66.2	M 66.2	SPARE
M 66.3	M 66.3	SPARE
M 66.4	M 66.4	SPARE
M 66.5	M 66.5	SPARE
M 66.6	M 66.6	SPARE
M 66.7	M 66.7	SPARE
M 67.0	M 67.0	SPARE
M 67.1	M 67.1	SPARE
M 67.2	M 67.2	SPARE
M 67.3	M 67.3	SPARE
M 67.4	M 67.4	SPARE
M 67.5	M 67.5	SPARE
M 67.6	M 67.6	SPARE
M 67.7	M 67.7	SPARE
M 68.0	M 68.0	SPARE
M 68.1	M 68.1	SPARE
M 68.2	M 68.2	SPARE
M 68.3	M 68.3	SPARE
M 68.4	M 68.4	SPARE
M 68.5	M 68.5	SPARE
M 68.6	M 68.6	SPARE
M 68.7	M 68.7	SPARE
M 69.0	M 69.0	SPARE
M 69.1	M 69.1	SPARE
M 69.2	M 69.2	SPARE
M 69.3	M 69.3	SPARE
M 69.4	M 69.4	SPARE
M 69.5	M 69.5	SPARE
M 69.6	M 69.6	SPARE
M 69.7	M 69.7	SPARE
M 70.0	M 70.0	FAULT CONV. CONVERTER DRAW+SHRINK
M 70.1	M 70.1	FAULT CONV. DRIVE TEMP. DRAW+&SHRINK
M 70.2	M 70.2	FAULT CONV. DRIVE FAN DRAW+SHRINK
M 70.3	M 70.3	FAULT CONV. CONVERTER CONT. SCALE
M 70.4	M 70.4	FAULT CONV. DRIVE TEMP. CONT. SCALE
M 70.5	M 70.5	FAULT CONV. DRIVE FAN CONT. SCALE
M 70.6	M 70.6	FAULT CONV. CONVERTER BOT.-CEMENTER
M 70.7	M 70.7	FAULT CONV. DRIVE TEMP. BOT.-CEMENTER
M 71.0	M 71.0	FAULT CONV. DRIVE FAN BOT.-CEMENTER
M 71.1	M 71.1	FAULT CONV. CONVERTER COOLING LINE 1
M 71.2	M 71.2	FAULT CONV. CONVERTER COOLING LINE 2
M 71.3	M 71.3	FAULT CONV. CONVERTER COOLING LINE 3
M 71.4	M 71.4	FAULT CONV. CONVERTER COOLING LINE 4
M 71.5	M 71.5	FAULT CONV. CONVERTER CENTERING
M 71.6	M 71.6	FAULT CONV. DRIVE TEMP. CENT.+FEED
M 71.7	M 71.7	FAULT CONV. DRIVE FAN CENT. + FEEDING
M 72.0	M 72.0	FAULT CONV. CONVERTER KNIFE M.-SEP. DEV.
M 72.1	M 72.1	FAULT CONV. CONVERTER ACCELERATING
M 72.2	M 72.2	FAULT CONV. CONVERTER CHECK WEIGHTER
M 72.3	M 72.3	FAULT CONV. DRIVE TEMP. CHECK WEIGHTER
M 72.4	M 72.4	FAULT CONV. DRIVE FAN CHECK WEIGHTER
M 72.5	M 72.5	FAULT CONV. CONVERTER SLOW-DOWN
M 72.6	M 72.6	FAULT CONV. CONVERTER END CEMENTING
M 72.7	M 72.7	FAULT CONV. CONVERTER TAKE-AWAY
M 73.0	M 73.0	DATA TRANSFER GTR-9000

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OPERAND	SYMBOL	KOMMENTAR
M 73.1	M 73.1	DATA TRANSFER GTR-9000
M 73.2	M 73.2	DATA TRANSFER GTR-9000
M 73.3	M 73.3	DATA TRANSFER GTR-9000
M 73.4	M 73.4	DATA TRANSFER GTR-9000
M 73.5	M 73.5	DATA TRANSFER GTR-9000
M 73.6	M 73.6	DATA TRANSFER GTR-9000
M 73.7	M 73.7	DATA TRANSFER GTR-9000
M 74.0	M 74.0	DATA TRANSFER GTR-9000
M 74.1	M 74.1	DATA TRANSFER GTR-9000
M 74.2	M 74.2	DATA TRANSFER GTR-9000
M 74.3	M 74.3	DATA TRANSFER GTR-9000
M 74.4	M 74.4	DATA TRANSFER GTR-9000
M 74.5	M 74.5	DATA TRANSFER GTR-9000
M 74.6	M 74.6	DATA TRANSFER GTR-9000
M 74.7	M 74.7	DATA TRANSFER GTR-9000
M 75.0	M 75.0	RECEIVE FROM SLAVE 1
M 75.1	M 75.1	RECEIVE FROM SLAVE 1
M 75.2	M 75.2	RECEIVE FROM SLAVE 1
M 75.3	M 75.3	RECEIVE FROM SLAVE 1
M 75.4	M 75.4	RECEIVE FROM SLAVE 1
M 75.5	M 75.5	RECEIVE FROM SLAVE 1
M 75.6	M 75.6	RECEIVE FROM SLAVE 1
M 75.7	M 75.7	RECEIVE FROM SLAVE 1
M 76.0	M 76.0	RECEIVE FROM SLAVE 1
M 76.1	M 76.1	RECEIVE FROM SLAVE 1
M 76.2	M 76.2	RECEIVE FROM SLAVE 1
M 76.3	M 76.3	RECEIVE FROM SLAVE 1
M 76.4	M 76.4	RECEIVE FROM SLAVE 1
M 76.5	M 76.5	RECEIVE FROM SLAVE 1
M 76.6	M 76.6	RECEIVE FROM SLAVE 1
M 76.7	M 76.7	RECEIVE FROM SLAVE 1
M 77.0	M 77.0	RECEIVE FROM SLAVE 1
M 77.1	M 77.1	RECEIVE FROM SLAVE 1
M 77.2	M 77.2	RECEIVE FROM SLAVE 1
M 77.3	M 77.3	RECEIVE FROM SLAVE 1
M 77.4	M 77.4	RECEIVE FROM SLAVE 1
M 77.5	M 77.5	RECEIVE FROM SLAVE 1
M 77.6	M 77.6	RECEIVE FROM SLAVE 1
M 77.7	M 77.7	RECEIVE FROM SLAVE 1
M 78.0	M 78.0	RECEIVE FROM SLAVE 1
M 78.1	M 78.1	RECEIVE FROM SLAVE 1
M 78.2	M 78.2	RECEIVE FROM SLAVE 1
M 78.3	M 78.3	RECEIVE FROM SLAVE 1
M 78.4	M 78.4	RECEIVE FROM SLAVE 1
M 78.5	M 78.5	RECEIVE FROM SLAVE 1
M 78.6	M 78.6	RECEIVE FROM SLAVE 1
M 78.7	M 78.7	RECEIVE FROM SLAVE 1
M 79.0	M 79.0	SPARE
M 79.1	M 79.1	SPARE
M 79.2	M 79.2	SPARE
M 79.3	M 79.3	SPARE
M 79.4	M 79.4	SPARE
M 79.5	M 79.5	SPARE
M 79.6	M 79.6	SPARE
M 79.7	M 79.7	SPARE
M 80.0	M 80.0	LINE : FAULT
M 80.1	M 80.1	LINE : LINE IS OPERATING
M 80.2	M 80.2	LINE : CONVEYORS CONTROLLED
M 80.3	M 80.3	HF-FAULT SKIVER
M 80.4	M 80.4	IMPULSE FAULT SKIVER
M 80.5	M 80.5	SPARE
M 80.6	M 80.6	LINE : LINE OFF
M 80.7	M 80.7	LINE : LINE FAULT (DRIVE MOTORS,ETC)
M 81.0	M 81.0	LINE : HF CONVEYORS LINE FAULT
M 81.1	M 81.1	LINE : AUXILIARY DRIVES ON
M 81.2	M 81.2	SPARE
M 81.3	M 81.3	LINE : LINE READY FOR WORK
M 81.4	M 81.4	LINE : START ALARM HORN ON
M 81.5	M 81.5	LINE : LINE ON
M 81.6	M 81.6	LINE : HF LINE OFF
M 81.7	M 81.7	LINE : IMPULSE LINE OFF
M 82.0	M 82.0	FAULT SPEED DRAW-OFF CONVEYOR

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OPERAND	SYMBOL	KOMMENTAR
M 82.1	M 82.1	FAULT SPEED CONT. SCALE CONVEYOR
M 82.2	M 82.2	FAULT SPEED CEMENTING 2 CONVEYOR
M 82.3	M 82.3	FAULT SPEED COOLING SECTION 1 CONVEYOR
M 82.4	M 82.4	FAULT SPEED COOLING SECTION 2 CONVEYOR
M 82.5	M 82.5	FAULT SPEED COOLING SECTION 3 CONVEYOR
M 82.6	M 82.6	FAULT SPEED COOLING SECTION 4 CONVEYOR
M 82.7	M 82.7	FAULT SPEED CENTERING 2 CONVEYOR
M 83.0	M 83.0	SPARE
M 83.1	M 83.1	LINE : HF FASTER/SLOWLIER
M 83.2	M 83.2	LINE : HF FASTER/SLOWLIER
M 83.3	M 83.3	LINE : HF FASTER/SLOWLIER
M 83.4	M 83.4	LINE : HF FASTER/SLOWLIER
M 83.5	M 83.5	LINE : HF FASTER/SLOWLIER
M 83.6	M 83.6	SPARE
M 83.7	M 83.7	SETTLEMENT LINE SPEED
M 84.0	M 84.0	BCD-INPUT LINEAR CHECK WEIGHER 1*10^-3
M 84.1	M 84.1	BCD-INPUT LINEAR CHECK WEIGHER 2*10^-3
M 84.2	M 84.2	BCD-INPUT LINEAR CHECK WEIGHER 4*10^-3
M 84.3	M 84.3	BCD-INPUT LINEAR CHECK WEIGHER 8*10^-3
M 84.4	M 84.4	BCD-INPUT LINEAR CHECK WEIGHER 1*10^-2
M 84.5	M 84.5	BCD-INPUT LINEAR CHECK WEIGHER 2*10^-2
M 84.6	M 84.6	BCD-INPUT LINEAR CHECK WEIGHER 4*10^-2
M 84.7	M 84.7	BCD-INPUT LINEAR CHECK WEIGHER 8*10^-2
M 85.0	M 85.0	BCD-INPUT LINEAR CHECK WEIGHER 1*10^-1
M 85.1	M 85.1	BCD-INPUT LINEAR CHECK WEIGHER 2*10^-1
M 85.2	M 85.2	BCD-INPUT LINEAR CHECK WEIGHER 4*10^-1
M 85.3	M 85.3	BCD-INPUT LINEAR CHECK WEIGHER 8*10^-1
M 85.4	M 85.4	BCD-INPUT LINEAR CHECK WEIGHER 1*10^0
M 85.5	M 85.5	BCD-INPUT LINEAR CHECK WEIGHER 2*10^0
M 85.6	M 85.6	BCD-INPUT LINEAR CHECK WEIGHER 4*10^0
M 85.7	M 85.7	BCD-INPUT LINEAR CHECK WEIGHER 8*10^0
M 86.0	M 86.0	BCD-INPUT LINEAR CHECK WEIGHER 1*10^1
M 86.1	M 86.1	0-SIGNAL BCD 2*10^1
M 86.2	M 86.2	0-SIGNAL BCD 4*10^1
M 86.3	M 86.3	0-SIGNAL BCD 8*10^1
M 86.4	M 86.4	0-SIGNAL BCD 1*10^2
M 86.5	M 86.5	0-SIGNAL BCD 2*10^2
M 86.6	M 86.6	0-SIGNAL BCD 4*10^2
M 86.7	M 86.7	0-SIGNAL BCD 8*10^2
M 87.0	M 87.0	0-SIGNAL BCD 1*10^3
M 87.1	M 87.1	0-SIGNAL BCD 2*10^3
M 87.2	M 87.2	0-SIGNAL BCD 4*10^3
M 87.3	M 87.3	0-SIGNAL BCD 8*10^3
M 87.4	M 87.4	0-SIGNAL
M 87.5	M 87.5	0-SIGNAL
M 87.6	M 87.6	0-SIGNAL
M 87.7	M 87.7	0-SIGNAL
M 88.0	M 88.0	CEMENTING 1 ROLL DOWN/UP
M 88.1	M 88.1	CEMENTING 1 EDGE CEMENTING ON
M 88.2	M 88.2	CEMENTING 2 ROLL DOWN/UP
M 88.3	M 88.3	TREAD CHECKER : HF EVALUATE TREAD WEIGHT
M 88.4	M 88.4	TREAD CHECKER : IMPULSE EVALUATE WEIGHT
M 88.5	M 88.5	SPARE
M 88.6	M 88.6	SPARE
M 88.7	M 88.7	SPARE
M 89.0	M 89.0	HF TREAD INLET
M 89.1	M 89.1	IMPULSE TREAD INLET
M 89.2	M 89.2	TREAD IN THE FRONT FAST
M 89.3	M 89.3	TREAD IN THE FRONT SLOW
M 89.4	M 89.4	HF TREAD OUTLET
M 89.5	M 89.5	IMPULSE TREAD OUTLET
M 89.6	M 89.6	SPRAYING CUT END FRONT
M 89.7	M 89.7	SPRAYING CUT END BACK
M 90.0	M 90.0	TREAD IN THE BACK FAST
M 90.1	M 90.1	TREAD IN TRE BACK SLOW
M 90.2	M 90.2	SPRAYING CUT END BACK
M 90.3	M 90.3	HF CLOSE FLAP SPRAYING THE FRONT
M 90.4	M 90.4	IMPULSE CLOSE FLAP SPRAYING THE FRONT
M 90.5	M 90.5	CALENDER : MAINCONTACTOR ON
M 90.6	M 90.6	CALENDER : READY TO START
M 90.7	M 90.7	SCRAP FROM LENGHT MEAS. OR TREAD CHECKER
M 91.0	M 91.0	CALENDER : GENERAL FAULTS

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OPERAND	SYMBOL	KOMMENTAR
M 91.1	M 91.1	CALENDER : AUX.DRIVES ON
M 91.2	M 91.2	CALENDER : AUX.DRIVES READY TO START
M 91.3	M 91.3	CALENDER : HF CALENDER OFF
M 91.4	M 91.4	CALENDER : IMPULSE CALENDER OFF
M 91.5	M 91.5	CALENDER : RUN AFTER TIME AUX.DRIVES
M 91.6	M 91.6	CALENDER : READY TO START
M 91.7	M 91.7	CALENDER : HF FOR NEG. FLANC E 4.7
M 92.0	M 92.0	CALENDER : FAULTS CALENDER OFF
M 92.1	M 92.1	CALENDER : START
M 92.2	M 92.2	CALENDER : IMPULSE FOR NEG. FLANC E 4.7
M 92.3	M 92.3	CALENDER : HF FASTER/SLOWLIER
M 92.4	M 92.4	CALENDER : HF FASTER/SLOWLIER
M 92.5	M 92.5	CALENDER : HF FASTER/SLOWLIER
M 92.6	M 92.6	CALENDER : HF FASTER/SLOWLIER
M 92.7	M 92.7	CALENDER : HF FASTER/SLOWLIER
M 93.0	M 93.0	KNIFE MIDDLE SEP.DEV.: HF FASTER/SLOWER
M 93.1	M 93.1	KNIFE MIDDLE SEP.DEV.: HF FASTER/SLOWER
M 93.2	M 93.2	KNIFE MIDDLE SEP.DEV.: HF FASTER/SLOWER
M 93.3	M 93.3	KNIFE MIDDLE SEP.DEV.: HF FASTER/SLOWER
M 93.4	M 93.4	KNIFE MIDDLE SEP.DEV.: HF FASTER/SLOWER
M 93.5	M 93.5	CALENDER FEEDING BELT : HF FASTER/SLOWER
M 93.6	M 93.6	CALENDER FEEDING BELT : HF FASTER/SLOWER
M 93.7	M 93.7	CALENDER FEEDING BELT : HF FASTER/SLOWER
M 94.0	M 94.0	CALENDER FEEDING BELT : HF FASTER/SLOWER
M 94.1	M 94.1	CALENDER FEEDING BELT : HF FASTER/SLOWER
M 94.2	M 94.2	CONVEYOR CENTERING 2 : HF FASTER/SLOWER
M 94.3	M 94.3	CONVEYOR CENTERING 2 : HF FASTER/SLOWER
M 94.4	M 94.4	CONVEYOR CENTERING 2 : HF FASTER/SLOWER
M 94.5	M 94.5	CONVEYOR CENTERING 2 : HF FASTER/SLOWER
M 94.6	M 94.6	CONVEYOR CENTERING 2 : HF FASTER/SLOWER
M 94.7	M 94.7	SPARE
M 95.0	M 95.0	FAULT DRAW-OFF CONVEYOR
M 95.1	M 95.1	FAULT CONVEYOR LINEAR CHECK WEIGHER
M 95.2	M 95.2	FAULT CONVEYOR CEMENTING 2
M 95.3	M 95.3	FAULT COOLING SECTION 1
M 95.4	M 95.4	FAULT COOLING SECTION 2
M 95.5	M 95.5	FAULT COOLING SECTION 3
M 95.6	M 95.6	FAULT COOLING SECTION 4
M 95.7	M 95.7	FAULT CONVEYOR CENTERING 2
M 104.0	M 104.0	CICLE MOVE REGISTER
M 104.1	M 104.1	CICLE MOVE REGISTER
M 104.2	M 104.2	CICLE MOVE REGISTER
M 104.3	M 104.3	CICLE MOVE REGISTER
M 104.4	M 104.4	CICLE MOVE REGISTER
M 104.5	M 104.5	CICLE MOVE REGISTER
M 104.6	M 104.6	CICLE MOVE REGISTER
M 104.7	M 104.7	CICLE MOVE REGISTER
M 105.0	M 105.0	CICLE MOVE REGISTER
M 105.1	M 105.1	CICLE MOVE REGISTER
M 105.2	M 105.2	CICLE MOVE REGISTER
M 105.3	M 105.3	CICLE MOVE REGISTER
M 105.4	M 105.4	CICLE MOVE REGISTER
M 105.5	M 105.5	CICLE MOVE REGISTER
M 105.6	M 105.6	CICLE MOVE REGISTER
M 105.7	M 105.7	CICLE MOVE REGISTER
M 124.4	M 124.4	BCD-DISPLAY WIDTH MEASURING DEVICE
M 128.0	M 128.0	SEND ORDER
M 128.1	M 128.1	FLANK INTERPRETATION SEND ORDER
M 128.2	M 128.2	FLANK INTERPRETATION SEND ORDER
M 132.0	M 132.0	SEND TO SLAVE 1
M 132.1	M 132.1	SEND TO SLAVE 1
M 132.2	M 132.2	SEND TO SLAVE 1
M 132.3	M 132.3	SEND TO SLAVE 1
M 132.4	M 132.4	SEND TO SLAVE 1
M 132.5	M 132.5	SEND TO SLAVE 1
M 132.6	M 132.6	SEND TO SLAVE 1
M 132.7	M 132.7	SEND TO SLAVE 1
M 135.0	M 135.0	SEND TO SLAVE 1
M 135.1	M 135.1	SEND TO SLAVE 1
M 135.2	M 135.2	SEND TO SLAVE 1
M 135.3	M 135.3	SEND TO SLAVE 1
M 135.4	M 135.4	SEND TO SLAVE 1

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OPERAND	SYMBOL	KOMMENTAR
M 175.5	M0218	METAL DETECTED FEEDER
M 175.6	M0219	MAIN DRIVE CARBON BRUSH CALENDER
M 175.7	M0220	EXTERNAL FAN OUTSIDE MAIN DRIVE CALENDER
M 176.0	M0237	EXTERNAL FAN INSIDE MAIN DRIVE CALENDER
M 176.1	M0238	MAX ROLLSLIT LEFT SIDE CALENDER
M 176.2	M0239	MAX ROLLSLIT RIGHT SIDE CALENDER
M 176.3	M0240	MOTOR OIL PUMP FAULT CALENDER
M 176.4	M0241	HYDRAULICS PUMP FAULT CALENDER
M 176.5	M0242	DRIVE MOTOR TEMPERATURE CALENDER
M 176.6	M0243	DC-CONVERTER FAULT CALENDER
M 176.7	M0244	DC-CONVERTER TEMPERATURE FAULT CALENDER
M 177.0	M0229	FAULT OIL LUBRICATION CALENDER
M 177.1	M0230	MAX OIL PRESSURE CALENDER
M 177.2	M0231	MIN OIL PRESSURE CALENDER
M 177.3	M0232	MIN OIL LEVEL CALENDER
M 177.4	M0233	NO MATERIAL EXTR. CALENDER
M 177.5	M0234	AIR CONDITIONER ELECTRICAL CONTROL ROOM
M 177.6	M0235	DRIVE MOT FAULT WATER BLOW-OFF STATION
M 177.7	M0236	DRIVE MOT TEMP. WATER BLOW-OFF STATION
M 178.0	M0253	PRESSURE FAULT WATER BLOW-OFF STATION
M 178.1	M0254	TREAD CHECK WEIGHER FAULT
M 178.2	M0255	DRIVE MOT. FAULT EXHAUSTER TREAD END CEM
M 178.3	M0256	DRIVE MOT. TEMP. EXHAUSTER TREAD END CEM
M 178.4	M0257	PRESSURE FAULT EXHAUSTER TREAD END CEM.
M 178.5	M0258	FESTOONER LOOP CALENDER
M 178.6	M0259	FAULT TEMPER. UNIT 1
M 178.7	M0260	FAULT TEMPER. UNIT 2
M 179.0	M0245	FAULT TEMPER. UNIT 3
M 179.1	M0246	WARNING : OILCOOLING BOTTOM EXTR. IS ON
M 179.2	M0247	WARNING : OILCOOLING UPPER EXTR. IS ON
M 179.3	M0248	NO RELEASE FROM EXTRUSION HEAD EXTR. OFF
M 179.4	M0249	PRESSURE COOLING WATER TO LOW
M 179.5	M0250	PRESSURE DIFFERENCE BOTTOM EXTRUDER OFF
M 179.6	M0251	PRESSURE DIFFERENCE UPPER EXTRUDER OFF
M 179.7	M0252	WARNING : OILCOOLING EXTR.CALENDER IS ON
M 180.0	M0269	PRESSURE FAULT SOFT WATER
M 180.1	M0270	E-STOP HOPPER UPPER EXTRUDER
M 180.2	M0271	E-STOP HOPPER BOTTOM EXTRUDER
M 180.3	M0272	E-STOP HOPPER EXTR. CALENDER
M 180.4	M0273	E-STOP OPERATOR PANEL EXTR. CALENDER
M 180.5	M0274	DRIVE MOTOR EXTERNAL FAN UPPER EXTRUDER
M 180.6	M0275	DRIVE MOTOR EXTERNAL FAN BOTTOM EXTRUDER
M 180.7	M0276	DRIVE MOTOR EXTERNAL FAN OUT. EXTR. CAL.
M 181.0	M0261	DRIVE MOTOR EXTERNAL FAN INS. EXTR. CAL.
M 181.1	M0262	DRIVE MOTOR OIL PUMP EXTRUDER CALENDER
M 181.2	M0263	PRESSURE OIL LUBRICATION UPPER EXTRUDER
M 181.3	M0264	PRESSURE OIL LUBRICATION BOTTOM EXTRUDER
M 181.4	M0265	PRESSURE OIL LUBRICATION EXTR. CALENDER
M 181.5	M0266	OIL FLOW OIL LUBRICATION UPPER EXTRUDER
M 181.6	M0267	OIL FLOW OIL LUBRICATION BOTTOM EXTRUDER
M 181.7	M0268	OIL FLOW OIL LUBRICATION EXTR. CALENDER
M 182.0	M0285	TEMP. OIL LUBRICATION UPPER EXTRUDER
M 182.1	M0286	TEMP. OIL LUBRICATION BOTTOM EXTRUDER
M 182.2	M0287	TEMP. OIL LUBRICATION EXTRUDER CALENDER
M 182.3	M0288	PRESSURE WATER-COOLING UPPER EXTRUDER
M 182.4	M0289	PRESSURE WATER-COOLING BOTTOM EXTRUDER
M 182.5	M0290	MOTOR OIL PUMP FAULT UPPER EXTRUDER
M 182.6	M0291	MOTOR OIL PUMP FAULT BOTTOM EXTRUDER
M 182.7	M0292	MAIN DRIVE TEMP. FAULT UPPER EXTRUDER
M 183.0	M0277	MAIN DRIVE TEMP. FAULT BOTTOM EXTRUDER
M 183.1	M0278	MAIN DRIVE TEMP. FAULT EXTRUDER CALENDER
M 183.2	M0279	MAIN DRIVE CARBON BRUSH UPPER EXTRUDER
M 183.3	M0280	MAIN DRIVE CARBON BRUSH BOTTOM EXTRUDER
M 183.4	M0281	MAIN DRIVE CARBON BRUSH EXTR. CALENDER
M 183.5	M0282	DC-CONVERTER TEMP. FAULT UPPER EXTRUDER
M 183.6	M0283	DC-CONVERTER TEMP. FAULT BOTTOM EXTRUDER
M 183.7	M0284	DC-CONVERTER TEMP. FAULT EXTR. CALENDER
M 184.0	M0301	DC-CONVERTER FAULT UPPER EXTRUDER
M 184.1	M0302	DC-CONVERTER FAULT BOTTOM EXTRUDER
M 184.2	M0303	DC-CONVERTER FAULT EXTRUDER CALENDER
M 184.3	M0304	LOW ARMATURE CURRENT UPPER EXTRUDER
M 184.4	M0305	LOW ARMATURE CURRENT BOTTOM EXTRUDER

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M 135.5	M 135.5	SEND TO SLAVE 1
M 135.6	M 135.6	SEND TO SLAVE 1
M 135.7	M 135.7	SEND TO SLAVE 1
M 136.0	M 136.0	SEND TO SLAVE 1
M 136.1	M 136.1	SEND TO SLAVE 1
M 136.2	M 136.2	SEND TO SLAVE 1
M 136.3	M 136.3	SEND TO SLAVE 1
M 136.4	M 136.4	SEND TO SLAVE 1
M 136.5	M 136.5	SEND TO SLAVE 1
M 136.6	M 136.6	SEND TO SLAVE 1
M 136.7	M 136.7	SEND TO SLAVE 1
M 137.0	M 137.0	SEND TO SLAVE 1
M 137.1	M 137.1	SEND TO SLAVE 1
M 137.2	M 137.2	SEND TO SLAVE 1
M 137.3	M 137.3	SEND TO SLAVE 1
M 137.4	M 137.4	SEND TO SLAVE 1
M 137.5	M 137.5	SEND TO SLAVE 1
M 137.6	M 137.6	SEND TO SLAVE 1
M 137.7	M 137.7	SEND TO SLAVE 1
M 138.0	M 138.0	SEND TO SLAVE 1
M 138.1	M 138.1	SEND TO SLAVE 1
M 138.2	M 138.2	SEND TO SLAVE 1
M 138.3	M 138.3	SEND TO SLAVE 1
M 138.4	M 138.4	SEND TO SLAVE 1
M 138.5	M 138.5	SEND TO SLAVE 1
M 138.6	M 138.6	SEND TO SLAVE 1
M 138.7	M 138.7	SEND TO SLAVE 1
M 170.0	M0189	CONTROL FUSE 220V/50Hz TRIGGERED
M 170.1	M0190	EXHAUSTER FAULT DRAW-OFF CONVEYOR
M 170.2	M0191	DRIVE MOTOR FAULT DRAW-OFF CONVEYOR
M 170.3	M0192	DRIVE MOTOR FAULT SHRINKAGE CONVEYOR
M 170.4	M0193	DRIVE MOTOR FAULT LIN.WEIGHER CONVEYOR
M 170.5	M0194	DRIVE MOTOR FAULT CEMENTING CONVEYOR
M 170.6	M0195	DRIVE MOTOR FAULT COOLING SECTION 1
M 170.7	M0196	DRIVE MOTOR FAULT COOLING SECTION 2
M 171.0	M0181	DRIVE MOTOR FAULT COOLING SECTION 3
M 171.1	M0182	DRIVE MOTOR FAULT COOLING SECTION 4
M 171.2	M0183	DRIVE MOTOR FAULT ACCELERATING CONVEYOR
M 171.3	M0184	DRIVE MOTOR FAULT TREAD CHECK WEIGHER
M 171.4	M0185	DRIVE MOTOR FAULT SLOW-DOWN ROLLER CONV.
M 171.5	M0186	DRIVE MOTOR FAULT TREAD END CEMENTER
M 171.6	M0187	MOTOR FAULT TAKE-AWAY + SCRAP CONVEYOR
M 171.7	M0188	DRIVE MOTOR FAULT CENTERING DEVICE
M 172.0	M0205	FESTOONER LOOP MIDDLE SEPARATE DEVICE
M 172.1	M0206	FESTOONER LOOP LINEAR CHECK WEIGHER
M 172.2	M0207	FESTOONER LOOP TREAD BOTTOM CEMENTER
M 172.3	M0208	FESTOONER LOOP COOLING SECTION 1
M 172.4	M0209	FESTOONER LOOP COOLING SECTION 2
M 172.5	M0210	FESTOONER LOOP COOLING SECTION 3
M 172.6	M0211	FESTOONER LOOP COOLING SECTION 4
M 172.7	M0212	FESTOONER LOOP CENTERING DEVICE
M 173.0	M0197	FESTOONER LOOP TREAD SKIVER
M 173.1	M0198	FAULT LINEAR WEIGHT SCALE
M 173.2	M0199	FAULT WIDTH MEASURING DEVICE
M 173.3	M0200	CAMERA DIRTY WIDTH MEASURING DEVICE
M 173.4	M0201	MEAS.RANGE LIMIT RIGHT WIDTH MEAS.DEV
M 173.5	M0202	MEAS.RANGE LIMIT LEFT WIDTH MEAS.DEV
M 173.6	M0203	DRIVE MOTOR FAULT EXHAUSTER CEM.DEVICE 1
M 173.7	M0204	DRIVE MOTOR TEMP. EXHAUSTER CEM.DEVICE 1
M 174.0	M0221	PRESSURE FAULT EXHAUSTER CEM.DEVICE 1
M 174.1	M0222	DRIVE MOTOR FAULT EXHAUSTER CEM.DEVICE 2
M 174.2	M0223	DRIVE MOTOR TEMP. EXHAUSTER CEM.DEVICE 2
M 174.3	M0224	PRESSURE FAULT EXHAUSTER CEM.DEVICE 2
M 174.4	M0225	CO2 FIRE EXTINGUISHER ALARM
M 174.5	M0226	CO2 FIRE EXTINGUISHER FAULT
M 174.6	M0227	MOTOR CONVEYOR FAULT FEEDER
M 174.7	M0228	MOTOR CUTTER FAULT FEEDER
M 175.0	M0213	FESTOONER LOOP EMPTY FEEDER
M 175.1	M0214	FESTOONER LOOP FILLED FEEDER
M 175.2	M0215	BALL-UP PINCH ROLL FEEDER
M 175.3	M0216	COMPRESSED AIR FAULT FEEDER
M 175.4	M0217	BALL-UP UPPER CONVEYOR FEEDER

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OPERAND	SYMBOL	KOMMENTAR
M 184.5	M0306	LOW ARMATURE CURRENT EXTRUDER CALENDER
M 184.6	M0307	HIGH CURRENT MACHI.VALUE UPPER EXTRUDER
M 184.7	M0308	HIGH CURRENT MACH. VALUE BOTTOM EXTRUDER
M 185.0	M0293	HIGH CURRENT MACH. VALUE EXTR. CALENDER
M 185.1	M0294	HIGH CURRENT MATER.VALUE UPPER EXTRUDER
M 185.2	M0295	HIGH CURRENT MATER.VALUE BOTTOM EXTRUDER
M 185.3	M0296	HIGH CURRENT MATER.VALUE EXTR. CALENDER
M 185.4	M0297	MAX EXTRUSION PRESS. EXCEEDED CH1 DEH
M 185.5	M0298	MAX EXTRUSION PRESS. EXCEEDED CH2 DEH
M 185.6	M0299	WARNING EXTRUSION PRESSURE CH1 DEH
M 185.7	M0300	WARNING EXTRUSION PRESSURE CH2 DEH
M 186.0	M0317	AIR PRESSURE CEMENTING 1
M 186.1	M0318	AIR PRESSURE CEMENTING 2
M 186.2	M0319	AIR PRESSURE CUT END CEMENTING
M 186.3	M0320	CONV. FAULT IS POSSIBLE CONVERTER FAULT
M 186.4	M0321	CONV. FAULT IS POSSIBLE OVERTEMP FAULT
M 186.5	M0322	CONV. FAULT IS POSSIBLE FAN FAULT
M 186.6	M0323	CONV. FAULT IS POSSIBLE OVERSPEED FAULT
M 186.7	M0324	HYDRAULICS PUMP FAULT DEH
M 187.0	M0309	CLAMPS MIN LOCKING PRESSURE FALLEN BELOW
M 187.1	M0310	LOCK.CYL. MIN LOCKING PRESS FALLEN BELOW
M 187.2	M0311	CLAMPS MAX LOCKING PRESSURE EXCEEDED
M 187.3	M0312	LOCK.CYL. MAX LOCKING PRESSURE EXCEEDED
M 187.4	M0313	LOCKING CYLINDER HIGH PRESSURE EXCEEDED
M 187.5	M0314	TIME PRESSURE FEEDING CLAMP DEH
M 187.6	M0315	TIME PRESSURE FEEDING LOCK.CYLINDER DEH
M 187.7	M0316	SYSTEM PRESSURE OVERFLOW DEH
M 188.0	M0333	NO TEMPERATURE RELEASE UPPER EXTRUDER
M 188.1	M0334	NO TEMPERATURE RELEASE BOTTOM EXTRUDER
M 188.2	M0335	E-STOP LEFT SIDE CALENDER
M 188.3	M0336	E-STOP OPERATOR PANEL DEH
M 188.4	M0337	OIL FILTER DIRTY DEH
M 188.5	M0338	LOCK.CYLINDER HIGH PRESSURE NOT BUILT UP
M 188.6	M0339	EXCESS TEMPERATURE CHANNEL 1 DEH
M 188.7	M0340	EXCESS TEMPERATURE CHANNEL 2 DEH
M 189.0	M0325	E-STOP RIPCORD DOWN PART 1 RIGHT LINE
M 189.1	M0326	E-STOP RIPCORD DOWN PART 2 RIGHT LINE
M 189.2	M0327	E-STOP RIPCORD DOWN PART 3 RIGHT LINE
M 189.3	M0328	E-STOP RIPCORD DOWN PART 4 RIGHT LINE
M 189.4	M0329	E-STOP RIPCORD UP FRONT LEFT SIDE LINE
M 189.5	M0330	E-STOP RIPCORD UP FRONT RIGHT SIDE LINE
M 189.6	M0331	E-STOP RIPCORD UP REAR LEFT SIDE LINE
M 189.7	M0332	E-STOP RIPCORD UP REAR RIGHT SIDE LINE
M 190.0	M0349	E-STOP ELECTRIC CONTROL ROOM
M 190.1	M0350	E-STOP RIPCORD REAR CALENDER
M 190.2	M0351	E-STOP RIPCORD FRONT CALENDER
M 190.3	M0352	E-STOP OPERATOR PANEL CALENDER
M 190.4	M0353	E-STOP MAIN OPERATOR PANEL
M 190.5	M0354	E-STOP OPERATOR PANEL EXTRUSION HEAD
M 190.6	M0355	NO RELEASE FOR PROGRAM START
M 190.7	M0356	E-STOP HOPPER STATION FEEDER
M 191.0	M0341	TIME PROGRAM START TERMINATED
M 191.1	M0342	SPARE
M 191.2	M0343	E-STOP RIPCORD OR PANEL RIGHT S. FEEDER
M 191.3	M0344	E-STOP RIPCORD LEFT SIDE FEEDER
M 191.4	M0345	E-STOP RIPCORD FRONT FEEDER
M 191.5	M0346	CONTROL START UPPER EXTRUDER
M 191.6	M0347	CONTROL START BOTTOM EXTRUDER
M 191.7	M0348	CONTROL START EXTRUDER CALENDER
M 192.0	M0365	MOTOR KNIFE TRANSFER FAULT TREAD SKIVER
M 192.1	M0366	FAULT : SKIVER
M 192.2	M0367	BALL-UP NO CUTTING TREAD SKIVER
M 192.3	M0368	BALL-UP CONVEYOR STOP TREAD SKIVER
M 192.4	M0369	MATERIAL OUT OF MEAS.RANGE TREAD SKIVER
M 192.5	M0370	TIMER KNIFE FEED CUTTING TREAD SKIVER
M 192.6	M0371	TIMER LIFTING KNIFE TREAD SKIVER
M 192.7	M0372	TIMER KNIFE REVERSE TREAD SKIVER
M 193.0	M0357	TIMER KNIFE NORMAL POSITION TREAD SKIVER
M 193.1	M0358	CONVEYOR BELT MOTOR FAULT TREAD SKIVER
M 193.2	M0359	EXTERNAL FAN MOTOR FAULT TREAD SKIVER
M 193.3	M0360	KNIFE MOTOR FAULT TREAD SKIVER
M 193.4	M0361	MIN. FIELD CURRENT TREAD SKIVER

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M 193.5	M0362	SPARE
M 193.6	M0363	SPARE
M 193.7	M0364	AC-CONTROL VOLTAGE FAULT TREAD SKIVER
M 194.0	M0381	SPARE
M 194.1	M0382	COMPRESSED AIR FAULT TREAD SKIVER
M 194.2	M0383	E-STOP CABINET TREAD SKIVER
M 194.3	M0384	E-STOP OPERATOR PANEL TREAD SKIVER
M 194.4	M0385	START LOOK LIGHT CURTAIN TREAD SKIVER
M 194.5	M0386	MATERIAL OUT OF MEAS.RANGE TREAD SKIVER
M 194.6	M0387	STRIP IS LEAVING MEAS.RANGE TREAD SKIVER
M 194.7	M0388	SPARE
M 195.0	M0373	DRIVE OVERTEMP 128M2 CONV.CHECK WEIGHTER
M 195.1	M0374	FAN FAULT 130M1 CONV. CHECK WEIGHTER
M 195.2	M0375	FAULT SWITCH CLAMPS DOWN CLOSED
M 195.3	M0376	FAULT SWITCH CLAMPS UP CLOSED
M 195.4	M0377	FAULT SWITCH CLAMPS DOWN OPEN
M 195.5	M0378	FAULT SWITCH CLAMPS UP OPEN
M 195.6	M0379	TIMECONTROL : OPEN CASSETTE EJECT.DEVICE
M 195.7	M0380	TIMECONTROL : INSTALL CASSETTE
M 196.0	M0397	TIMECONTROL : CLOSE CLAMP
M 196.1	M0398	TIMECONTROL : OPEN CLAMP
M 196.2	M0399	TIMECONTROL : CLOSE MEDIUM PART
M 196.3	M0400	TIMECONTROL : CLOSE UPPER PART
M 196.4	M0401	TIMECONTROL : LOCK.CYLINDER LOCKING POS.
M 196.5	M0402	TIMECONTROL : LOCK.CYLINDER MOVED OUT
M 196.6	M0403	TIMECONTROL : LOCKING CYLINDER HOME POS.
M 196.7	M0404	TIMECONTROL : CLOSE CASS.EJECTING DEVICE
M 197.0	M0389	FAULT SWITCH MIDDLE PART CLOSED
M 197.1	M0390	FAULT SWITCH UPPER PART CLOSED
M 197.2	M0391	FAULT SWITCH LOCKING CYL. LOCK POS.
M 197.3	M0392	FAULT SWITCH LOCKING CYL. HOME POS.
M 197.4	M0393	FAULT SWITCH EJECTING DEVICE CLOSED
M 197.5	M0394	FAULT SWITCH EJECTING DEVICE OPEN
M 197.6	M0395	FAULT SWITCH CASSETTE INSTALLED
M 197.7	M0396	SPARE
M 198.0	M198.0	SPARE
M 198.1	M198.1	SPARE
M 198.2	M198.2	SPARE
M 198.3	M198.3	SPARE
M 198.4	M198.4	SPARE
M 198.5	M198.5	SPARE
M 198.6	M198.6	SPARE
M 198.7	M198.7	SPARE
MB 130	MB 130	PARAMETRIER FAULT (FB90)
MB 131	MB 131	PARAMETRIER FAULT (FB91)
MB 132	MB 132	PARAMETRIER FAULT (FB91)
MB 133	MB 133	PARAMETRIER FAULT (FB92)
MB 134	MB 134	PARAMETRIER FAULT (FB92)
MB 160	MB 160	PROFILE MANAGEMENT
MB 161	MB 161	PROFILE MANAGEMENT
MB 162	MB 162	PROFILE MANAGEMENT
MB 163	MB 163	PROFILE MANAGEMENT
MB 164	MB 164	PROFILE MANAGEMENT
MB 165	MB 165	PROFILE MANAGEMENT
MB 166	MB 166	PROFILE MANAGEMENT
MB 167	MB 167	PROFILE MANAGEMENT
MB 168	MB 168	PROFILE MANAGEMENT
MB 199	MB 199	COM PMC
MW 75	MW 75	SEND TO 115U
MW 104	MW 104	ZYKLUSMERKER
MW 135	MW 135	SEND DATAS TO SLAVE 1 (FB91)
MW 137	MW 137	SEND DATAS TO SLAVE 1 (FB91)
MW 150	MW 110	FLAG-W. GTR-9000
MW 152	MW 112	FLAG-W. GTR-9000
MW 154	MW 114	FLAG-W. GTR-9000
MW 156	MW 116	FLAG-W. GTR-9000
MW 158	MW 158	FLAG-W. GTR-9000
MW 160	MW 160	PROFILE MANAGEMENT
MW 162	MW 162	PROFILE MANAGEMENT
MW 164	MW 164	PROFILE MANAGEMENT
MW 166	MW 166	PROFILE MANAGEMENT
PW 128	43A1S	SPEED UPPER EXTRUDER

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OPERAND	SYMBOL	KOMMENTAR	
PW 130	43A1C	CURRENT UPPER EXTRUDER	
PW 132	48A1S	SPEED BOTTOM EXTRUDER	
PW 134	48A1C	CURRENT BOTTOM EXTRUDER	
PW 136	84A1S	SPEED EXTRUDER CALENDER	
PW 138	84A1C	CURRENT EXTRUDER CALENDER	
PW 140	91A1S	SPEED CALENDER	
PW 142	91A1C	CURRENT CALENDER	
PW 144	PW 144	SPEED DRAW-OFF CONVEYOR / LINE SPEED	
PW 146	PW 146	SPEED CONVEYOR CENTERING 2	
PW 148	PW 148	SPEED CONVEYOR LINEAR CHECK WEIGHER	
PW 150	PW 150	SPEED CONVEYOR CEMENTING 2	
PW 152	PW 152	SPEED COOLING SECTION 1	
PW 154	PW 154	SPEED COOLING SECTION 2	
PW 156	PW 156	SPEED COOLING SECTION 3	
PW 158	PW 158	SPEED COOLING SECTION 4	
PW 160	PW 160	PRESSURE UPPER EXTRUDER	
PW 162	PW 162	PRESSURE BOTTOM EXTRUDER	
PW 164	PW 164	SPARE	
PW 166	PW 166	SPARE	
PW 168	PW 168	SPARE	
PW 170	PW 170	SPARE	
PW 172	PW 172	SPARE	
PW 174	PW 174	SPARE	
PW 176	PW 176	SPARE	
PW 178	PW 178	SPARE	
PW 180	PW 180	SPARE	
PW 182	PW 182	SPARE	
PW 184	PW 184	SPARE	
PW 186	PW 186	SPARE	
PW 188	PW 188	SPARE	
PW 190	PW 190	SPARE	
PW 192	269B1	LOOP LINEAR CHECK WEIGHER	ET 100
PW 194	269B3	LOOP CALENDER	ET 100
PW 196	269B5	LOOP COOLING SECTION 1	ET 100
PW 198	296B7	LOOP COOLING SECTION 2	ET 100
PW 200	305B1	LOOP COOLING SECTION 3	ET 100
PW 202	305B3	LOOP COOLING SECTION 4	ET 100
PW 204	305B5	LOOP CEMENTING 2	ET 100
PW 206	PW 208	LOOP CENTERING 2	ET 100
T 1	T 1	SPARE	
T 2	T 2	TIMER 2 SENDIMPULSE	
T 3	T 3	TIMER 3 SENDIMPULSE	
T 4	T 4	TIMER FOR LINE SPEED	
T 5	T 5	DATATRANSFER 135U - R-9000	
T 6	T 6	CEMENTING 1 ROLL DOWN	
T 7	T 7	CEMENTING 1 ROLL UP	
T 8	T 8	CEMENTING 2 ROLL DOWN	
T 9	T 9	CONTROL SWITCH "PROGRAM START"	
T 10	T 10	TIMECONTROL : CLAMPING CLOSED	
T 11	T 11	TIMECONTROL : CLAMPING OPENED	
T 12	T 12	TIMECONTROL : INTERMEDIATE PART CLOSED	
T 13	T 13	TIMECONTROL : UPPER PART CLOSED	
T 14	T 14	TIMECONTROL : LOCK.CYL. LOCKING POSITION	
T 15	T 15	TIMECONTROL : LOCKING CYLINDER MOVED OUT	
T 16	T 16	TIMECONTROL : LOCK.CYL. HOME POSITION	
T 17	T 17	TIMECONTROL : EJECTING DEVICE CLOSED	
T 18	T 18	TIMECONTROL : EJECTING DEVICE OPENED	
T 19	T 19	TIMECONTROL : CASSETTE INSTALLED	
T 20	T 20	START TIME HYDRAULIC-PUMP	
T 21	T 21	TIME BUILT UP PRESSURE PROP.VALVE	
T 22	T 22	RUN AFTER TIME HYDRAULICS PUMP	
T 23	T 23	TREAD CHECKER : DEMAND WEIGHT	
T 24	T 24	BOT.EXTR. : FAULT OIL FLOW TO LOW	
T 25	T 25	BOT.EXTR. : FAULT PRESSURE OIL	
T 26	T 26	BOT.EXTR. : FAULT TEMPERATURE TO HIGH	
T 27	T 27	BOT.EXTR. : CONTROL START	
T 28	T 28	BOT.EXTR. : CONTROL REVERSE	
T 29	T 29	BOT.EXTR. : RUN AFTER TIME AUX DRIVES	
T 30	T 30	BOT.EXTR. : REVERSE	
T 31	T 31	BOT.EXTR. : FAULT MIN ARMATURE CURRENT	
T 32	T 32	CALENDER : START ALARM	
T 33	T 33	LINE : BY-PASS FAULT	

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OPERAND	SYMBOL	KOMMENTAR
T 34	T 34	RESET SCRAP FLAP UP
T 35	T 35	CALENDER : MIN OIL PRESSURE
T 36	T 36	CALENDER : FAULT MOTOR TEMP
T 37	T 37	TIME PRESSURE FEEDING LOCKING CYLINDER
T 38	T 38	TIME PRESSURE FEEDING CLAMP
T 39	T 39	LINE : TIMER START ALARM
T 40	T 40	UP.EXTR. : CONTROL START
T 41	T 41	UP.EXTR. : CONTROL REVERSE
T 42	T 42	UP.EXTR. : RUN AFTER TIME AUX DRIVES
T 43	T 43	UP.EXTR. : FAULT OIL FLOW TO LOW
T 44	T 44	UP.EXTR. : FAULT OIL PRESSURE TO LOW
T 45	T 45	UP.EXTR. : FAULT TEMPERATURE TO HIGH
T 46	T 46	UP.EXTR. : FAULT MIN ARMATURE CURRENT
T 47	T 47	UP.EXTR. : REVERSE
T 48	T 48	UP.EXTR. : START ALARM
T 49	T 49	CEMENTING 2 ROLL UP
T 50	T 50	FEEDER : BALL-UP PINCH ROLL
T 51	T 51	FEEDER : BALL-UP UPPER CONVEYOR
T 52	T 52	EXTR.CAL. : NO MATERIAL
T 53	T 53	EXTR.CAL. : FAULT OIL FLOW TO LOW
T 54	T 54	EXTR.CAL. : FAULT OIL PRESSURE TO LOW
T 55	T 55	EXTR.CAL. : FAULT MAX OIL TEMP
T 56	T 56	EXTR.CAL. : FAULT START CONTROL
T 57	T 57	EXTR.CAL. : FAULT CONTROL REVERSE
T 58	T 58	EXTR.CAL. : RUN AFTER TIME AUX DRIVES
T 59	T 59	EXTR.CAL. : REVERSE
T 60	T 60	FEEDER : KNIFE ON
T 61	T 61	FEEDER : METALALARM NOT ACKNOW.
T 62	T 62	PRESSURE ON MEDIUM PART OPENED
T 63	T 63	CLOSE MEDIUM PART
T 64	T 64	CALENDER FEEDING BELT LEFT
T 65	T 65	CALENDER FEEDING BELT RIGHT
T 66	T 66	PRESSURE UP UPPER PART OPENED
T 67	T 67	CLOSE UPPER PART
T 68	T 68	CONTROL TEMP. MAIN DRIVE UPPER EXTRUDER
T 69	T 69	CONTROL TEMP. MAIN DRIVE BOTTOM EXTRUDER
T 70	T 70	CONTROL TEMP. MAIN DRIVE EXTR. CALENDER
T 71	T 71	OPEN SCRAP FLAP
T 72	T 72	TREAD END CEM : SPRAYING THE FRONT SLOW
T 73	T 73	RELEASE EXTRUDER MIN HP LOCKING CYLINDER
T 74	T 74	TREAD END CEM : SPRAYING THE BACK FAST
T 75	T 75	TREAD END CEM : TREAD IN THE FRONT FAST
T 76	T 76	TREAD END CEM : TREAD IN THE FRONT SLOW
T 77	T 77	TREAD END CEM : SPRAYING THE FRONT FAST
T 78	T 78	TREAD END CEM : TREAD IN THE BACK FAST
T 79	T 79	TREAD END CEM : TREAD IN THE BACK SLOW
T 80	T 80	LINE : START ALARM
T 81	T 81	SEND PARAMETER GTR-9000
T 82	T 82	CALENDER : RUN AFTER TIME AUX.DRIVES
T 83	T 83	RELEASE SLOW-DOWN CONVEYOR FAST
T 84	T 84	RELEASE SLOW-DOWN CONVEYOR SLOW
T 85	T 85	RELEASE LENGTH M. + END CEMENTING FAST
T 86	T 86	RELEASE LENGTH M. + END CEMENTING SLOW
T 87	T 87	RELEASE TAKE-AWAY CONVEYOR FAST
T 88	T 88	RELEASE TAKE-AWAY CONVEYOR SLOW
T 89	T 89	CUT END CEM : SPRAYING THE BACK SLOW
T 90	T 90	TIME PRESSURE TRANS. HOMEPOSITION
T 91	T 91	TIME REBUILD HIGH PRESSURE
T 92	T 92	SPARE
T 93	T 93	BUILD UP HIGH PRESSURE / OPEN LOCK.CYL.
T 94	T 94	SPARE
T 95	T 95	CONTROL DRAW-OFF CONVEYOR
T 96	T 96	CONTROL CONVEYOR LINEAR CHECK WEIGHER
T 97	T 97	CONTROL CONVEYOR CEMENTING 2
T 98	T 98	CONTROL COOLING SECTION 1
T 99	T 99	CONTROL COOLING SECTION 2
T 100	T 100	RESET SCRAP DETECTED
T 101	T 101	FAULT : LOOP CONTINUOUS WEIGHER
T 102	T 102	FAULT : LOOP CEMENTING 2
T 103	T 103	FAULT : LOOP COOLING SECTION 1
T 104	T 104	FAULT : LOOP COOLING SECTION 2
T 105	T 105	FAULT : LOOP COOLING SECTION 3

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OPERAND	SYMBOL	KOMMENTAR
T 106	T 106	FAULT : LOOP COOLING SECTION 4
T 107	T 107	FAULT : LOOP CALENDER
T 108	T 108	SPARE
T 109	T 109	CICLETIME
T 110	T 110	TIMER FOR TACT 0.5 Hz
T 111	T 111	TIMER FOR TACT 1 Hz
T 112	T 112	TIMER FOR TACT 2 Hz
T 113	T 113	TIMER FOR TACT 5 Hz
T 114	T 114	RELEASE EXTRUDER MIN HP CLAMPS
T 115	T 115	TAKE OVER PROFILE PART C
T 116	T 116	OPEN FLAP END CEMENTING FAST
T 117	T 117	OPEN FLAP END CEMENTING SLOW
T 118	T 118	CONTROL COOLING SECTION 3
T 119	T 119	CONTROL COOLING SECTION 4
T 120	T 120	CONTROL CONVEYOR CENTERING 2
T 121	T 121	TIME FOR PRODUCTION REPORT
T 122	T 122	TIME FOR RESET PRODUCTION DATAS
T 123	T 123	FAULT PRESSURE COOLING WATER
T 124	T 124	SPARE
T 125	T 125	SPARE
T 126	T 126	SPARE
T 127	T 127	SPARE
T 128	T 128	SPARE
T 129	T 129	SPARE
T 130	T 130	CONTROL BALL-UP PINCH ROLL SLAB FEEDER
T 131	T 131	CUTTING TWO TIMES
T 132	T 132	SCRAP CONVEYOR ON
T 133	T 133	CONVEYOR BELT GUIDING
T 134	T 134	HUGGER BELT GUIDING
T 135	T 135	START ALARM FOR AUTOMTIC START
T 136	T 136	UP.EXTR.: WAIT AFTER CHANGE REVERSE/FORW
T 137	T 137	UP.EXTR.: WAIT AFTER FIELD OFF
T 138	T 138	UP.EXTR.: WAIT AFTER CHANGE FORW/REVERSE
T 139	T 139	UP.EXTR.: WAIT AFTER FIELD OFF
T 140	T 140	BOT.EXTR.: START ALARM
T 141	T 141	BOT.EXTR.: WAIT AFTER CHANGE REVERSE/FOR
T 142	T 142	BOT.EXTR.: WAIT AFTER FIELD OFF
T 143	T 143	BOT.EXTR.: WAIT AFTER CHANGE FORW/REVERS
T 144	T 144	BOT.EXTR.: WAIT AFTER FIELD OFF
T 145	T 145	EXTR.CAL. : FAULT MIN ARMATURE CURRENT
T 146	T 146	EXTR.CAL. : START ALARM
T 147	T 147	EXTR.CAL. : WAIT AFTER CHANGE REV./FORW.
T 148	T 148	EXTR.CAL. : WAIT AFTER FIELD OFF
T 149	T 149	EXTR.CAL. : WAIT AFTER CHANGE FORW./REV.
T 150	T 150	EXTR.CAL. : WAIT AFTER FIELD OFF
T 151	T 151	SETTLEMENT LINE SPEED
T 152	T 152	READ PARAMETERS GTR-9000
T 153	T 153	SPARE
T 154	T 154	TREAD CHECKER : SCRAP MARKING ON
T 155	T 155	LINE : RUN AFTER TIME AUX DRIVES
T 156	T 156	ACKNOWLEDGING FAULT LINEAR CHECK WEIGHER
T 157	T 157	ACKNOWLEDGING FAULT TREAD WEIGHER
T 158	T 158	SPARE
T 159	T 159	SPARE
T 170	T 170	SEND CICLE No. 1 : TIME FAIL
T 171	T 171	SEND CICLE No. 2 : TIME FAIL
T 172	T 172	SEND CICLE No. 3 : TIME FAIL
T 173	T 173	SEND CICLE No. 4 : TIME FAIL
T 174	T 174	SEND CICLE No. 5 : TIME FAIL
T 175	T 175	SEND CICLE No. 6 : TIME FAIL
T 176	T 176	SEND CICLE No. 7 : TIME FAIL
T 177	T 177	SEND CICLE No. 8 : TIME FAIL
T 178	T 178	SEND CICLE No. 9 : TIME FAIL
T 179	T 179	SEND CICLE No.10 : TIME FAIL
T 180	T 180	SEND CICLE No.11 : TIME FAIL
T 181	T 181	SEND CICLE No.12 : TIME FAIL
T 182	T 182	SEND CICLE No.13 : TIME FAIL
T 183	T 183	SEND CICLE No.14 : TIME FAIL
T 184	T 184	SEND CICLE No.15 : TIME FAIL
T 185	T 185	SWITCH CONTROL CLAMPS DOWN CLOSED
T 186	T 186	SWITCH CONTROL CLAMPS UP CLOSED
T 187	T 187	SWITCH CONTROL CLAMPS DOWN OPEN

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OPERAND	SYMBOL	KOMMENTAR
T 188	T 188	SWITCH CONTROL CLAMPS UP OPEN
T 189	T 189	SWITCH CONTROL MIDDLE PART CLOSED
T 190	T 190	SWITCH CONTROL UPPER PART CLOSED
T 191	T 191	SWITCH FAULT LOCKING CYLINDER LOCK POS.
T 192	T 192	SWITCH CONTROL LOCKING CYL. HOME POS.
T 193	T 193	SWITCH CONTROL EJECTING DEVICE CLOSED
T 194	T 194	SWITCH CONTROL EJECTING DEVICE OPEN
T 195	T 195	SWITCH CONTROL CASSETTE INSTALLED
Z 1	Z 1	SPARE
Z 2	Z 2	FEEDER : UPPER CONVEYOR BELT DOWN
Z 3	Z 3	FEEDER : CUT 1 METALALARM
Z 4	Z 4	FEEDER : DOUBLE CUT 1
Z 5	Z 5	FEEDER : CUT 2 METALALARM
Z 6	Z 6	FEEDER : DOUBLE CUT 2
Z 7	Z 7	TRACKING COUNTER 1
Z 8	Z 8	TRACKING COUNTER 2
Z 9	Z 9	SPARE
Z 10	Z 10	SPARE
Z 11	Z 11	SPARE
Z 12	Z 12	SPARE
Z 13	Z 13	SPARE
Z 14	Z 14	SPARE
Z 15	Z 15	CHANGING VALUE UP
Z 16	Z 16	SEND/READ PARAMETERS GTR-9000
Z 17	Z 17	CHANGING VALUE DOWN
Z 18	Z 18	SPARE
Z 19	Z 19	SPARE
Z 20	Z 20	TREAD CHECKER : SCRAP COUNTER 1
Z 21	Z 21	TREAD CHECKER : SCRAP COUNTER 2
Z 22	Z 22	TREAD CHECKER : OK COUNTER 1
Z 23	Z 23	TREAD CHECKER : OK COUNTER 2
Z 24	Z 24	TREAD CHECKER : TOTAL COUNTER 1
Z 25	Z 25	TREAD CHECKER : TOTAL COUNTER 2
Z 26	Z 26	SCRAP DETECTED : COUNTER 1
Z 27	Z 27	SCRAP DETECTED : COUNTER 2
Z 28	Z 28	SPARE
Z 29	Z 29	SPARE
Z 30	Z 30	SPARE
Z 31	Z 31	SPARE
Z 32	Z 32	SPARE
Z 33	Z 33	SPARE
Z 34	Z 34	SPARE
Z 35	Z 35	SPARE
Z 36	Z 36	SPARE
Z 37	Z 37	SPARE
Z 38	Z 38	SPARE
Z 39	Z 39	SPARE
Z 40	Z 40	SPARE
Z 41	Z 41	SPARE
Z 42	Z 42	SPARE
Z 43	Z 43	SPARE
Z 44	Z 44	SPARE
Z 45	Z 45	SPARE
Z 46	Z 46	SPARE
Z 47	Z 47	SPARE
Z 48	Z 48	SPARE
Z 49	Z 49	COUNTER METAL ALARM
Z 50	Z 50	CALENDER : SPEED +/-
Z 51	Z 51	CALENDER : CONVEYOR SPEED +/-
Z 52	Z 52	UP.EXTR. : FASTER/SLOWLIER
Z 53	Z 53	BOT.EXTR. : FASTER/SLOWLIER
Z 54	Z 54	EXTR.CAL. : FASTER/SLOWLIER
Z 55	Z 55	KNIFE MIDDLE SEP.DEV.: HF FASTER/SLOWER
Z 56	Z 56	SPARE
Z 57	Z 57	LINE : FASTER/SLOLIER
Z 58	Z 58	SPARE
Z 59	Z 59	SPARE
Z 60	Z 60	SPARE
FB 20	FB 20	SPARE
FB 21	FB 21	SPARE
FB 22	FB 22	SPARE
FB 23	FB 23	PRESSURE EVALUATION EXTRUSION HEAD

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OPERAND	SYMBOL	KOMMENTAR
FB 24	FB 24	SPARE
FB 25	FB 25	SPARE
FB 26	FB 26	SPARE
FB 27	FB 27	SPARE
FB 28	FB 28	SPARE
FB 29	FB 29	SPARE
FB 30	FB 30	SPARE
FB 31	FB 31	SPARE
FB 32	FB 32	SPARE
FB 33	FB 33	CHECK LOOP
FB 34	FB 34	SPARE
FB 35	FB 35	SPARE
FB 36	FB 36	SPARE
FB 37	FB 37	SPARE
FB 38	FB 38	SPARE
FB 39	FB 39	DATAS FOR PROD.REPORT (TREADS+SCRAP)
FB 40	FB 40	(S)
FB 41	FB 41	ANALOG OUTPUT (S)
FB 42	FB 42	ANALOG INPUT (S)
FB 43	FB 43	ANALOG INPUT 4 -20 mA
FB 44	FB 44	ANALOG OUTPUT
FB 45	FB 45	SPARE
FB 46	FB 46	ANALOG INPUT 0 - 10 V
FB 47	FB 47	SPARE
FB 48	FB 48	CALCULATION FOR ANALOG DISPLAY
FB 49	FB 49	SPARE
FB 50	FB 50	MB ---> DB
FB 51	FB 51	DB ---> MB
FB 52	FB 52	TEMPERATURE RELEASE
FB 53	FB 53	DATATRANSFER TO PARAMETER DB 60-75
FB 54	FB 54	SEND/RECEIVE BLOCKS GTR-9000
FB 55	FB 55	DATA TRANSFER 135U <----> 115U
FB 56	FB 56	SPARE
FB 57	FB 57	CONTROL ANALOG INPUT
FB 58	FB 58	TRANSFER DD-WORD
FB 59	FB 59	SPARE
FB 60	FB 60	SPARE
FB 61	FB 61	SPARE
FB 62	FB 62	SPARE
FB 63	FB 63	SPARE
FB 64	FB 64	SPARE
FB 65	FB 65	SPARE
FB 66	FB 66	SPARE
FB 67	FB 67	SPARE
FB 68	FB 68	SPARE
FB 69	FB 69	SPARE
FB 70	FB 70	SPARE
FB 71	FB 71	SPARE
FB 72	FB 72	SPEED FEEDER
FB 73	FB 73	HYSTERESE
FB 74	FB 74	CONVEYOR DRIVE CTRL NEG. LOOP MAX= 0%
FB 75	FB 75	CONVEYOR DRIVE CTRL POS. LOOP MAX=100%
FB 76	FB 76	CALCULATE CURRENT CALENDER FOR DISPLAY
FB 77	FB 77	CALCULATE CURRENT EXTR.CAL. FOR DISPLAY
FB 78	FB 78	FASTER/SLOWLIER FOR 2 SWITCHES
FB 79	FB 79	SPARE
FB 80	FB 80	FASTER/SLOWLIER FOR 1 SWITCH
FB 81	FB 81	SPARE
FB 82	FB 82	CALCULATE LINE SPEED IN % FOR OUTPUT
FB 83	FB 83	LINEAR CHECK WEIGHER BCD-DATAS
FB 84	FB 84	EVALUATION AND PICTURES LINEAR CHECK W.
FB 85	FB 85	SPARE
FB 86	FB 86	TREAD CHECK WEIGHER BCD-DATAS
FB 87	FB 87	EVALUATION TREAD WEIGHT
FB 88	FB 88	WIDTH MEASURING DEVICE
FB 89	FB 89	SETTLEMENT LINE SPEED FROM WIDTH MEAS.D.
FB 90	FB 90	SYNCHRONISATION CP530
FB 91	FB 91	SEND DATAS TO SLAVE-No1
FB 92	FB 92	RECEIVE DATAS FROM SLAVE-No1
FB 93	FB 93	EVALUATION + PICTURES WIDTH MEASURING D.
FB 94	FB 94	SPARE
FB 95	FB 95	PICTURES LENGTH MEASURING DEVICE

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OPERAND	SYMBOL	KOMMENTAR
FB 96	FB 96	CALCULATE SPEED CALENDER
FB 97	FB 97	SPARE
FB 98	FB 98	SPARE
FB 99	FB 99	SPARE
FB 100	FB 100	CICLE MOVE REGISTER
FB 110	FB 110	CALCULATE Smax(STOPPING DISTANCE SKIVER)
FB 120	FB 120	SEND (S)
FB 121	FB 121	RECEIVE (S)
FB 123	FB 123	CONTROL (S)
FB 125	FB 125	SYNCHRON (S)
FB 126	FB 126	SEND-ALL (S)
FB 127	FB 127	RECEIVE-ALL (S)
FB 130	FB 130	STANDARD SIEMENS
FB 148	FB 148	TRANSFER BLOCK TO R-9000
FB 149	FB 149	TRANSFER SET TO R-9000
FB 150	FB 150	CALL PARAMETER-BLOCK FROM R-9000
FB 170	FB 170	PROFILE MANAGEMENT
FB 171	FB 171	LOAD PROFILE
FB 172	FB 172	SAVE PROFILE
FB 173	FB 173	EDIT PROFILE
FB 174	FB 174	EDIT ACTUAL PROFILE
FB 175	FB 175	COPY PROFILE
FB 176	FB 176	RENEAME PROFILE
FB 177	FB 177	PRINT PROFILE
FB 178	FB 178	DELETE PROFILE
FB 179	FB 179	PRODUCTION REPORT
FB 180	FB 180	CHOICE PROFILE
FB 181	FB 181	SPARE
FB 182	FB 182	RESET CP
FB 183	FB 183	PRODUCTION START
FB 184	FB 184	COPY < 254 WORDS
FB 185	FB 185	COPY DATA BLOCK
FB 186	FB 186	CONTROL CP527/525
FB 187	FB 187	FLAGS CP527
FB 188	FB 188	ORDER TO CP525
FB 189	FB 189	ORDER TO CP527
FB 190	FB 190	LEARNFUNCTION
FB 191	FB 191	PICTURES
FB 192	FB 192	COPY PROFILE PART A
FB 193	FB 193	COPY PROFILE PART B
FB 194	FB 194	COPY PROFILE PART C
FB 195	FB 195	CHECK ACTUAL PROFILE PARTS
FB 196	FB 196	PERE:ET (S)
FB 197	FB 197	SPARE
FB 198	FB 198	SPARE
FB 199	FB 199	ACTUAL TIME
FB 202	FB 202	POSITIVE FLANC
FB 203	FB 203	NEGATIVE FLANC
FB 254	FB 254	RESET FLAGS BEFORE START
FB 255	FB 255	RESET FLAGS EXTRUSION HEAD (FIRST SCAN)
PB 1	PB 1	TACT
PB 2	PB 2	SPARE
PB 3	PB 3	PB FOR CP527
PB 4	PB 4	SPARE
PB 5	PB 5	SPARE
PB 6	PB 6	PB FOR CP527
PB 7	PB 7	PB FOR CP527
PB 8	PB 8	PB FOR CP527
PB 9	PB 9	GENERAL SIGNALS
PB 10	PB 10	DEH : PROXIMITY SWITCHES AND TIMECONTROL
PB 11	PB 11	EXTRUSION HEAD : HYDRAULIC PUMP
PB 12	PB 12	EXTRUSION HEAD : INTERMEDIATE PART
PB 13	PB 13	EXTRUSION HEAD : UPPER PART
PB 14	PB 14	EXTRUSION HEAD : LOCKING CYLINDER
PB 15	PB 15	EXTRUSION HEAD : CLAMPING & EJECT.DEVICE
PB 16	PB 16	EXTRUSION HEAD : CASSETTE MOUNTING DEV.
PB 17	PB 17	EXTRUSION HEAD : RELEASE EXTRUDER
PB 18	PB 18	DATA TRANSFER BETWEEN CP524 AND GTR-9000
PB 19	PB 19	FAULT HEAD PROXIMITY SWITCHES LOGICAL
PB 20	PB 20	UPPER EXTRUDER : GENERAL
PB 21	PB 21	UPPER EXTRUDER : FIELD
PB 22	PB 22	SPARE

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OPERAND	SYMBOL	KOMMENTAR
PB 23	PB 23	SPARE
PB 24	PB 24	SPARE
PB 25	PB 25	SPARE
PB 26	PB 26	SPARE
PB 27	PB 27	SPARE
PB 28	PB 28	SPARE
PB 29	PB 29	SPARE
PB 30	PB 30	BOTTOM EXTRUDER : GENERAL
PB 31	PB 31	BOTTOM EXTRUDER : FIELD
PB 32	PB 32	SPARE
PB 33	PB 33	SPARE
PB 34	PB 34	SPARE
PB 35	PB 35	SPARE
PB 36	PB 36	SPARE
PB 37	PB 37	SPARE
PB 38	PB 38	SPARE
PB 39	PB 39	SPARE
PB 40	PB 40	EXTRUDER CALENDER : GENERAL
PB 41	PB 41	EXTRUDER CALENDER : FIELD
PB 42	PB 42	EXTRUDER CALENDER : FEEDER
PB 43	PB 43	SPARE
PB 44	PB 44	SPARE
PB 45	PB 45	SPARE
PB 46	PB 46	SPARE
PB 47	PB 47	SPARE
PB 48	PB 48	SPARE
PB 49	PB 49	SPARE
PB 50	PB 50	SPARE
PB 51	PB 51	SPARE
PB 52	PB 52	SPARE
PB 53	PB 53	SPARE
PB 54	PB 54	SPARE
PB 55	PB 55	TEMPERATURE UNIT 1-3
PB 56	PB 56	SPARE
PB 57	PB 57	SPARE
PB 58	PB 58	SPARE
PB 59	PB 59	SPARE
PB 60	PB 60	WIND UP STATION AND CENTERING DEVICE
PB 61	PB 61	TREAD END CEMENTING DEVICE
PB 62	PB 62	SPARE
PB 63	PB 63	SPARE
PB 64	PB 64	SPARE
PB 65	PB 65	SPARE
PB 66	PB 66	SPARE
PB 67	PB 67	SPARE
PB 68	PB 68	SPARE
PB 69	PB 69	SPARE
PB 70	PB 70	SPARE
PB 71	PB 71	SPARE
PB 72	PB 72	SPARE
PB 73	PB 73	SPARE
PB 74	PB 74	SPARE
PB 75	PB 75	SPARE
PB 76	PB 76	SPARE
PB 77	PB 77	SPARE
PB 78	PB 78	SPARE
PB 79	PB 79	LINE : NEW FAULTS BY KS
PB 80	PB 80	LINE : GENERAL
PB 81	PB 81	LINE : NOMINAL VALUE DRIVE MOTORS
PB 82	PB 82	LINE : FAULTS
PB 83	PB 83	LINE : SCRAP
PB 84	PB 84	LINE : LINEAR CHECK WEIGHER
PB 85	PB 85	LINE : TREAD CHECK WEIGHER
PB 86	PB 86	LINE : CONTROL RUNNING CONVEYOR
PB 87	PB 87	LINE : SCRAP MARKING TREAD CHECK WEIGHER
PB 88	PB 88	LINE : WIDTH MEASURING DEVICE
PB 89	PB 89	SPARE
PB 90	PB 90	CALENDER : FAULTS
PB 91	PB 91	CALENDER : GENERAL
PB 92	PB 92	CALENDER : ROLLSLIT AND KNIFE
PB 93	PB 93	ANALOG INPUT
PB 94	PB 94	SPARE

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OPERAND	SYMBOL	KOMMENTAR
DB 160	DB 160	PROFILE CP
DB 170	DB 170	ACTUAL DATAS
DB 180	DB 180	PROFILE AG
DB 184	DB 184	PROFILE NAME
DB 185	DB 185	PROFILE MANAGEMENT
DB 188	DB 188	PICTURES
DB 199	DB 199	TIME
DB 201	DB 201	DB M-ALTNEU (MESSAGEBITS FOR FLANCEVAL.)
DB 202	DB 202	DB M-QUITT1 (QUIT RECEIVE FOR CP526/1)
DB 203	DB 203	DB M-QUITT2 (QUIT RECEIVE FOR CP526/2)
DB 204	DB 204	DB M-NUMMER (MESSAGE AND -QUITNUMBERS)
DB 205	DB 205	DB M-SATZ (MESSAGESETS)
DB 206	DB 206	DB M-SEND (MESSAGE OUTPUTBUFFER)
DB 208	DB 208	DB M-GEBER (ADDRESS FROM FIELDS)

OB

```
OB 1                                    C:KERM06ST.S5D        BIB=13033   LAE=74

NETZWERK 1          0000
0000       :AWL
0001       :SPA PB   1     -PB   1          TACT
0002       :NOP 0                           ##### VISUALATION ##############
0003       :A   DB   6     -DB   6
0004       :SPA FB 130     -FB 130          COM PMC
0005 NAME  :ANLAUF
0006       :SPA PB   3     -PB   3          COM PMC
0007       :SPA PB 100     -PB 100          PB100 PROFILE MANAGEMENT
0008       :NOP 0                           ##### DATA TRANSFER ############
0009       :SPA FB  55     -FB  55
000A NAME  :DATA
000B       :SPA PB  18     -PB  18
000C       :NOP 0                           ##### GENERAL SIGNALS ##########
000D       :SPA PB   9     -PB   9          GENERAL SIGNALS
000E       :SPA PB  93     -PB  93          ANALOG INPUT
000F       :SPA FB  57     -FB  57          CONTROL ANALOG INPUT
0010 NAME  :CONT-DAT
0011       :***

DB   6   = DB   6                           DB FOR CP527

PB   1   = PB   1                           TACT
PB   3   = PB   3                           PB FOR CP527
PB 100   = PB 100                           PROFILE MANAGEMENT
PB  18   = PB  18                           DATA TRANSFER BETWEEN CP524 AND GTR-9000
PB   9   = PB   9                           GENERAL SIGNALS
PB  93   = PB  93                           ANALOG INPUT

FB 130   = FB 130                           STANDARD SIEMENS
FB  55   = FB  55                           DATA TRANSFER   135U <----> 115U
FB  57   = FB  57                           CONTROL ANALOG INPUT

NETZWERK 2          0012
0012       :AWL                             ##### DUPLEX EXTRUSION HEAD ####
0013       :U   M    3.7   -M   3.7
0014       :SPB FB 255     -FB 255          RESET FLAGS AFTER START
0015 NAME  :RES-HEAD
0016       :SPA PB  10     -PB  10          PROXIMITY SWITCHES & TIMECONTROL
0017       :SPA PB  11     -PB  11          HYDRAULIC PUMP
0018       :SPA PB  12     -PB  12          MEDIUM PART
0019       :SPA PB  13     -PB  13          UPPER PART
001A       :SPA PB  14     -PB  14          LOCKING CYLINDER
001B       :SPA PB  15     -PB  15          CLAMPING & EJECTING DEVICE
001C       :SPA PB  16     -PB  16          CASSETTE MOUNTING DEVICE
001D       :SPA PB  17     -PB  17          RELEASE EXTRUDER
001E       :SPA FB  23     -FB  23          PRESSURE EVALUATION
001F NAME  :PRESSURE
0020       :SPA PB  19     -PB  19          FAULT PROXIMITY SWITCHES LOGICAL
0021       :***

M    3.7 = M   3.7                          FLAG FOR FIRST SCAN

PB  10   = PB  10                           DEH : PROXIMITY SWITCHES AND TIMECONTROL
PB  11   = PB  11                           EXTRUSION HEAD : HYDRAULIC PUMP
PB  12   = PB  12                           EXTRUSION HEAD : INTERMEDIATE PART
PB  13   = PB  13                           EXTRUSION HEAD : UPPER PART
PB  14   = PB  14                           EXTRUSION HEAD : LOCKING CYLINDER
PB  15   = PB  15                           EXTRUSION HEAD : CLAMPING & EJECT.DEVICE
PB  16   = PB  16                           EXTRUSION HEAD : CASSETTE MOUNTING DEV.
PB  17   = PB  17                           EXTRUSION HEAD : RELEASE EXTRUDER
PB  19   = PB  19                           FAULT HEAD PROXIMITY SWITCHES LOGICAL

FB 255   = FB 255                           RESET FLAGS EXTRUSION HEAD (FIRST SCAN)
FB  23   = FB  23                           PRESSURE EVALUATION EXTRUSION HEAD

NETZWERK 3          0022
0022       :AWL                             ##### UPPER EXTRUDER ############
0023       :SPA PB  20     -PB  20          UPPER EXTRUDER
0024       :SPA PB  21     -PB  21          FIELD
0025       :                                ##### BOTTOM EXTRUDER ###########
0026       :SPA PB  30     -PB  30          BOTTOM EXTRUDER
0027       :SPA PB  31     -PB  31          FIELD
0028       :                                ##### EXTRUDER CALENDER ########
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                     1!
+-------------------------------------------------------------------------------+
```

```
0029      :SPA PB  40     -PB  40          EXTRUDER CALANDER
002A      :SPA PB  41     -PB  41          FIELD
002B      :SPA PB  42     -PB  42          FEEDER
002C      :***

PB  20    = PB  20                         UPPER EXTRUDER : GENERAL
PB  21    = PB  21                         UPPER EXTRUDER : FIELD
PB  30    = PB  30                         BOTTOM EXTRUDER : GENERAL
PB  31    = PB  31                         BOTTOM EXTRUDER : FIELD
PB  40    = PB  40                         EXTRUDER CALENDER : GENERAL
PB  41    = PB  41                         EXTRUDER CALENDER : FIELD
PB  42    = PB  42                         EXTRUDER CALENDER : FEEDER

NETZWERK 4          002D
002D      :AWL                             ##### LINE ####################
002E      :SPA PB  79     -PB  79          NEW FAULTS by KS
002F      :SPA PB  82     -PB  82          FAULTS
0030      :SPA PB  80     -PB  80          GENERAL
0031      :SPA PB  81     -PB  81          DRIVE MOTORS
0032      :SPA PB  55     -PB  55          KELVI-PLAST
0033      :SPA PB  95     -PB  95          ANALOG OUTPUT
0034      :SPA PB  60     -PB  60          WIND UP STATION + CENTERING D.
0035      :SPA PB  90     -PB  90          CALANDER : FAULTS
0036      :SPA PB  91     -PB  91          CALANDER : GENERAL
0037      :SPA PB  92     -PB  92          CALANDER : ROLL + KNIFE
0038      :SPA PB  83     -PB  83          SCRAP FLAP
0039      :SPA PB  61     -PB  61          TREAD END CEMENTING
003A      :SPA PB  84     -PB  84          LINEAR CHECK WEIGHER
003B      :SPA PB  85     -PB  85          TREAD CHECK WEIGHER
003C      :SPA PB  86     -PB  86          CONTROL RUNNING CONVEYOR
003D      :SPA PB  87     -PB  87          SCRAP MARKING TREAD CHECKER
003E      :SPA PB  88     -PB  88          WIDTH MEASURING DEVICE
003F      :SPA FB  39     -FB  39          DATAS FOR PRODUCTION REPORT
0040 NAME :P-REPORT
0041      :SPA FB  99     -FB  99          CICLETIME
0042 NAME :ZYKLZEIT
0043      :***

PB  79    = PB  79                         LINE : NEW FAULTS BY KS
PB  82    = PB  82                         LINE : FAULTS
PB  80    = PB  80                         LINE : GENERAL
PB  81    = PB  81                         LINE : NOMINAL VALUE DRIVE MOTORS
PB  55    = PB  55                         TEMPERATURE UNIT 1-3
PB  95    = PB  95                         ANALOG OUTPUT
PB  60    = PB  60                         WIND UP STATION AND CENTERING DEVICE
PB  90    = PB  90                         CALENDER : FAULTS
PB  91    = PB  91                         CALENDER : GENERAL
PB  92    = PB  92                         CALENDER : ROLLSLIT AND KNIFE
PB  83    = PB  83                         LINE : SCRAP
PB  61    = PB  61                         TREAD END CEMENTING DEVICE
PB  84    = PB  84                         LINE : LINEAR CHECK WEIGHER
PB  85    = PB  85                         LINE : TREAD CHECK WEIGHER
PB  86    = PB  86                         LINE : CONTROL RUNNING CONVEYOR
PB  87    = PB  87                         LINE : SCRAP MARKING TREAD CHECK WEIGHER
PB  88    = PB  88                         LINE : WIDTH MEASURING DEVICE

FB  39    = FB  39                         DATAS FOR PROD.REPORT (TREADS+SCRAP)
FB  99    = FB  99                         SPARE

NETZWERK 5          0044
0044      :BE
```

```
NETZWERK 1          0000
0000       :A   DB   6     -DB   6
0001       :UN  D    8.8
0003       :=   D    8.8
0005       :BE

DB   6   = DB   6                    DB FOR CP527
```

```
NETZWERK 1          0000      START CP527
0000       :AWL
0001       :SPA PB   6     -PB   6              START PROGRAM FAULTS
0002       :SPA PB 255     -PB 255              START PB
0003       :UN  M  255.7                        SYNCHRONISATION CP530
0004       :S   M  255.7
0005       :SPA FB  90     -FB  90
0006 NAME  :START
0007       :SPA FB 125     -FB 125              SYNCHRONISATION GTR-9000
0008 NAME  :SYNCHRON
0009 SSNR  :    KY 0,4
000A BLGR  :    KY 0,4
000B PAFE  :    MB 202
000C       :SPA FB 254     -FB 254              FIRST SCAN AND RESET FLAGS
000D NAME  :STARTRES
000E       :***


PB   6   = PB   6                    PB FOR CP527
PB 255   = PB 255                    START UP PROFILE MANAGEMENT

FB  90   = FB  90                    SYNCHRONISATION CP530
FB 125   = FB 125                    SYNCHRON (S)
FB 254   = FB 254                    RESET FLAGS BEFORE START

NETZWERK 2          000F
000F       :AWL
0010       :BE
```

```
NETZWERK 1          0000
0000       :AWL
0001       :SPA PB   8     -PB   8              START PROGRAM FAULTS
0002       :SPA PB 255     -PB 255              START PROGRAM
0003       :UN  M  255.7                        SYNCHRONISATION CP530
0004       :S   M  255.7
0005       :SPA FB  90     -FB  90
0006 NAME  :START
0007       :SPA FB 125     -FB 125              SYNCHRONISATION GTR-9000
0008 NAME  :SYNCHRON
0009 SSNR  :    KY 0,4
000A BLGR  :    KY 0,4
000B PAFE  :    MB 202
000C       :SPA FB 254     -FB 254              FIRST SCAN AND RESET FLAGS
000D NAME  :STARTRES
000E       :***


PB   8   = PB   8                    PB FOR CP527
PB 255   = PB 255                    START UP PROFILE MANAGEMENT

FB  90   = FB  90                    SYNCHRONISATION CP530
FB 125   = FB 125                    SYNCHRON (S)
FB 254   = FB 254                    RESET FLAGS BEFORE START

NETZWERK 2          000F
000F       :AWL
0010       :BE
```

```
NETZWERK 1          0000
0000       :AWL
0001       :SPA PB   8     -PB   8          START PROGRAM FAULTS
0002       :SPA PB 255     -PB 255          START PROGRAM
0003       :U   M  255.7                    SYNCHRONISATION CP530
0004       :R   M  255.7
0005       :SPA FB  90     -FB  90
0006 NAME  :START
0007       :SPA FB 125     -FB 125          SYNCHRONISATION GTR-9000
0008 NAME  :SYNCHRON
0009 SSNR  :    KY 0,4
000A BLGR  :    KY 0,4
000B PAFE  :    MB 201
000C       :SPA FB 254     -FB 254          FIRST SCAN AND RESET FLAGS
000D NAME  :STARTRES
000E       :***


PB   8   = PB   8                    PB FOR CP527
PB 255   = PB 255                    START UP PROFILE MANAGEMENT

FB  90   = FB  90                    SYNCHRONISATION CP530
FB 125   = FB 125                    SYNCHRON (S)
FB 254   = FB 254                    RESET FLAGS BEFORE START

NETZWERK 2          000F
000F       :AWL
0010       :BE
```

```
     0:     KH = 4D41;                    ANFANGSKENNUNG
     1:     KH = 534B;                       FUER DB1
     2:     KH = 3031;
```

11
14
10

P3

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                    TACT                                     *
*                                                                             *
*******************************************************************************
0000      :***

NETZWERK 2          0001      TACT 0.5 HZ ( M0.3 )
0001      :UN  M    1.4  -M   1.4
0002      :L   KT 100.0
0004      :SE  T  110    -T 110
0005      :U   T  110    -T 110
0006      :=   M    1.4  -M   1.4
0007      :U   M    1.4  -M   1.4
0008      :UN  M    1.5  -M   1.5
0009      :S   M    0.3  -M   0.3
000A      :U   M    1.4  -M   1.4
000B      :U   M    1.5  -M   1.5
000C      :R   M    0.3  -M   0.3
000D      :UN  M    1.4  -M   1.4
000E      :U   M    0.3  -M   0.3
000F      :S   M    1.5  -M   1.5
0010      :UN  M    1.4  -M   1.4
0011      :UN  M    0.3  -M   0.3
0012      :R   M    1.5  -M   1.5
0013      :***

M    1.4 = M   1.4                  HF TACT 0.5 HZ
T  110   = T 110                    TIMER FOR TACT 0.5 Hz
M    1.5 = M   1.5                  HF TACT O.5 HZ
M    0.3 = M   0.3                  TACT 0.5 HZ

NETZWERK 3          0014      TACT 1 HZ ( M 0.4)
0014      :UN  M    1.1  -M   1.1
0015      :L   KT 050.0
0017      :SE  T  111    -T 111
0018      :U   T  111    -T 111
0019      :=   M    1.1  -M   1.1
001A      :U   M    1.1  -M   1.1
001B      :UN  M    1.6  -M   1.6
001C      :S   M    0.4  -M   0.4
001D      :U   M    1.1  -M   1.1
001E      :U   M    1.6  -M   1.6
001F      :R   M    0.4  -M   0.4
0020      :UN  M    1.1  -M   1.1
0021      :U   M    0.4  -M   0.4
0022      :S   M    1.6  -M   1.6
0023      :UN  M    1.1  -M   1.1
0024      :UN  M    0.4  -M   0.4
0025      :R   M    1.6  -M   1.6
0026      :***

M    1.1 = M   1.1                  HF TACT 1 HZ
T  111   = T 111                    TIMER FOR TACT 1 Hz
M    1.6 = M   1.6                  HF TACT 1 HZ
M    0.4 = M   0.4                  TACT 1 HZ

NETZWERK 4          0027      TACT 2 HZ ( M 0.5 )
0027      :UN  M    1.2  -M   1.2
0028      :L   KT 025.0
002A      :SE  T  112    -T 112
002B      :U   T  112    -T 112
002C      :=   M    1.2  -M   1.2
002D      :U   M    1.2  -M   1.2
002E      :UN  M    1.7  -M   1.7
002F      :S   M    0.5  -M   0.5
0030      :U   M    1.2  -M   1.2
0031      :U   M    1.7  -M   1.7
0032      :R   M    0.5  -M   0.5
0033      :UN  M    1.2  -M   1.2
0034      :U   M    0.5  -M   0.5
0035      :S   M    1.7  -M   1.7
```

```
0036       :UN  M    1.2  -M   1.2
0037       :UN  M    0.5  -M   0.5
0038       :R   M    1.7  -M   1.7
0039       :***

M    1.2 = M   1.2                    HF TACT 2 HZ
T  112   = T 112                      TIMER FOR TACT 2 Hz
M    1.7 = M   1.7                    HF TACT 2 HZ
M    0.5 = M   0.5                    TACT 2 HZ

NETZWERK 5          003A        TACT 5 HZ ( M 1.0 )
003A       :UN  M    1.3  -M   1.3
003B       :L   KT 010.0
003D       :SE  T  113    -T 113
003E       :U   T  113    -T 113
003F       :=   M    1.3  -M   1.3
0040       :U   M    1.3  -M   1.3
0041       :UN  M    2.0  -M   2.0
0042       :S   M    1.0  -M   1.0
0043       :U   M    1.3  -M   1.3
0044       :U   M    2.0  -M   2.0
0045       :R   M    1.0  -M   1.0
0046       :UN  M    1.3  -M   1.3
0047       :U   M    1.0  -M   1.0
0048       :S   M    2.0  -M   2.0
0049       :UN  M    1.3  -M   1.3
004A       :UN  M    1.0  -M   1.0
004B       :R   M    2.0  -M   2.0
004C       :***

M    1.3 = M   1.3                    HF TACT 5 HZ
T  113   = T 113                      TIMER FOR TACT 5 Hz
M    2.0 = M   2.0                    HF TACT 5 HZ
M    1.0 = M   1.0                    TACT 5 HZ

NETZWERK 6          004D
004D       :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  PB FOR CP527                               *
*                                                                             *
*******************************************************************************
0000       :AWL
0001       :A   DB    6     -DB    6
0002       :***

DB    6    = DB    6                    DB FOR CP527

NETZWERK 2          0003

                                 FB 144
                                  +--------------+
                                  !   GET-A      !
                                  +--------------+

NETZWERK 3          0006

                                 FB 153
                                  +--------------+
                                  !   QUITT      !
                    +39        --!DWNR          !
                                  +--------------+

NETZWERK 4          000A

                                 FB 153
                                  +--------------+
                                  !   QUITT      !
                    +40        --!DWNR          !
                                  +--------------+

NETZWERK 5          000E

                                 FB 151
                                  +--------------+
                                  !   AUSWAHL    !
                                  +--------------+

NETZWERK 6          0011

                                 FB 152
                                  +--------------+
                                  !   FLANKE     !
                                  +--------------+

NETZWERK 7          0014

                                 FB 154
                                  +--------------+
                                  !   MELD       !
                                  +--------------+

NETZWERK 8          0017

                                 FB 155
                                  +--------------+
                                  !   TRANS      !
                                  +--------------+
```

```
NETZWERK 9          001A
001A       :AWL
001B       :U   D    5.8
001D       :SPB FB 141
001E NAME  :PUT
001F BLNR  :    KF +5
0020       :***


NETZWERK 10         0021
0021       :AWL
0022       :U   D    5.9
0024       :SPB FB 141
0025 NAME  :PUT
0026 BLNR  :    KF +6
0027       :***


NETZWERK 11         0028
0028       :AWL
0029       :U   D    5.10
002B       :SPB FB 141
002C NAME  :PUT
002D BLNR  :    KF +7
002E       :***


NETZWERK 12         002F
002F       :AWL
0030       :U   D    5.11
0032       :SPB FB 141
0033 NAME  :PUT
0034 BLNR  :    KF +8
0035       :***


NETZWERK 13         0036

                              FB 143
                               +--------------+
                               !   PUT-A      !
                               +--------------+  :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  PB FOR CP527                               *
*                                                                             *
*******************************************************************************
0000       :AWL
0001       :***

NETZWERK 2          0002
0002       :AWL
0003       :A    DB   6     -DB   6
0004       :L    KB 0
0005       :T    DL   8
0006       :UN   D    8.15
0008       :S    D    8.15
000A       :SPA FB 130      -FB 130
000B NAME  :ANLAUF
000C       :U    D    8.15
000E       :R    D    8.15
0010       :UN   D    8.13
0012       :S    D    8.13
0014       :BE


DB   6    = DB   6                    DB FOR CP527

FB 130    = FB 130                    STANDARD SIEMENS
```

```
PB 7    -PB   7                          C:KERM06ST.S5D        BIB=18031   LAE=81

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  PB FOR CP527                               *
*                                                                             *
*******************************************************************************
0000       :AWL
0001       :***

NETZWERK 2          0002
0002       :AWL
0003       :A   DB   6     -DB   6
0004       :U   D   92.8
0006       :SPB FB 126     -FB 126
0007 NAME  :SEND-A
0008 SSNR  :     KY 255,18
0009 A-NR  :     KY 0,0
000A ANZW  :     MW   0
000B PAFE  :     MB 199     -MB 199
000C       :U   D   92.9
000E       :SPB FB 127     -FB 127
000F NAME  :REC-A
0010 SSNR  :     KY 255,18
0011 A-NR  :     KY 0,0
0012 ANZW  :     MW   0
0013 PAFE  :     MB 199     -MB 199
0014       :U   D   92.10
0016       :SPB FB 123     -FB 123
0017 NAME  :CONTROL
0018 SSNR  :     KY 255,18
0019 A-NR  :     KY 0,0
001A ANZW  :     MW   0
001B PAFE  :     MB 199     -MB 199
001C       :U   D   92.11
001E       :SPB FB 120     -FB 120
001F NAME  :SEND
0020 SSNR  :     KY 255,18
0021 A-NR  :     KY 0,0
0022 ANZW  :     MW   0
0023 QTYP  :     KC XX
0024 DBNR  :     KY 0,6
0025 QANF  :     KF +22
0026 QLAE  :     KF +0
0027 PAFE  :     MB 199     -MB 199
0028       :U   D   92.12
002A       :SPB FB 120     -FB 120
002B NAME  :SEND
002C SSNR  :     KY 255,18
002D A-NR  :     KY 0,0
002E ANZW  :     MW   0
002F QTYP  :     KC NN
0030 DBNR  :     KY 0,6
0031 QANF  :     KF +22
0032 QLAE  :     KF +0
0033 PAFE  :     MB 199     -MB 199
0034       :U   D   92.13
0036       :SPB FB 121     -FB 121
0037 NAME  :RECEIVE
0038 SSNR  :     KY 255,18
0039 A-NR  :     KY 0,0
003A ANZW  :     MW   0
003B ZTYP  :     KC XX
003C DBNR  :     KY 0,6
003D ZANF  :     KF +22
003E ZLAE  :     KF +0
003F PAFE  :     MB 199     -MB 199
0040       :U   D   92.14
0042       :SPB FB 125     -FB 125
0043 NAME  :SYNCHRON
0044 SSNR  :     KY 255,18
0045 BLGR  :     KY 0,0
0046 PAFE  :     MB 199     -MB 199
0047       :L   MB 199     -MB 199
+-------------------------------------------------------------------------------+
!       KRUPP KUNSTOFFTECHNIK          !                                       !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                        !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE         :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER   :                    1!
+-------------------------------------------------------------------------------+
```

```
0048      :T   DR  92
0049      :L   KB 0
004A      :T   DL  92
004B      :BE

MB 199   = MB 199                    COM PMC

DB   6   = DB   6                    DB FOR CP527

FB 126   = FB 126                    SEND-ALL (S)
FB 127   = FB 127                    RECEIVE-ALL (S)
FB 123   = FB 123                    CONTROL (S)
FB 120   = FB 120                    SEND (S)
FB 121   = FB 121                    RECEIVE (S)
FB 125   = FB 125                    SYNCHRON (S)
```

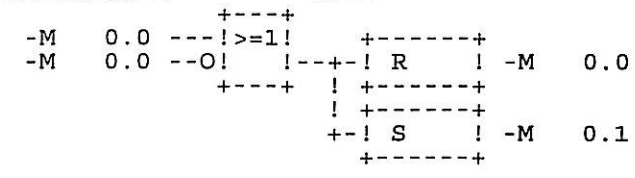
```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  PB FOR CP527                               *
*                                                                             *
*******************************************************************************
0000       :AWL
0001       :***

NETZWERK 2          0002
0002       :AWL
0003       :A    DB   6     -DB   6
0004       :L    KB 0
0005       :T    DL   8
0006       :UN   D    8.14
0008       :S    D    8.14
000A       :SPA FB 130      -FB 130
000B NAME  :ANLAUF
000C       :U    D    8.14
000E       :R    D    8.14
0010       :UN   D    8.13
0012       :S    D    8.13
0014       :BE


DB   6    = DB   6                    DB FOR CP527

FB 130    = FB 130                    STANDARD SIEMENS
```

NETZWERK 1 0000

```
*******************************************************************************
*                                                                             *
*                                GENERAL SIGNALS                              *
*                                                                             *
*******************************************************************************
```

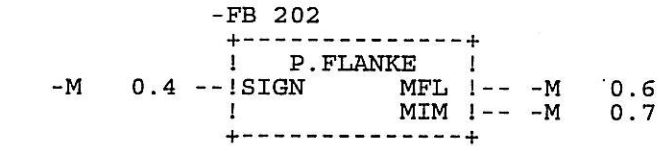
0000 :***

NETZWERK 2 0001



M 0.0 = M 0.0 "0"-SIGNAL
M 0.1 = M 0.1 "1"-SIGNAL

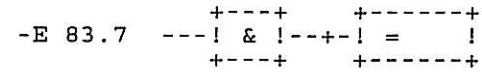
NETZWERK 3 0006 IMPULSE PER SECOND



M 0.4 = M 0.4 TACT 1 HZ
M 0.6 = M 0.6 HF IMPULSE PER SECOND
M 0.7 = M 0.7 IMPULSE PER SECOND

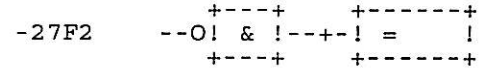
FB 202 = FB 202 POSITIVE FLANC

NETZWERK 4 000C E-STOP MAIN OPERATOR PANEL



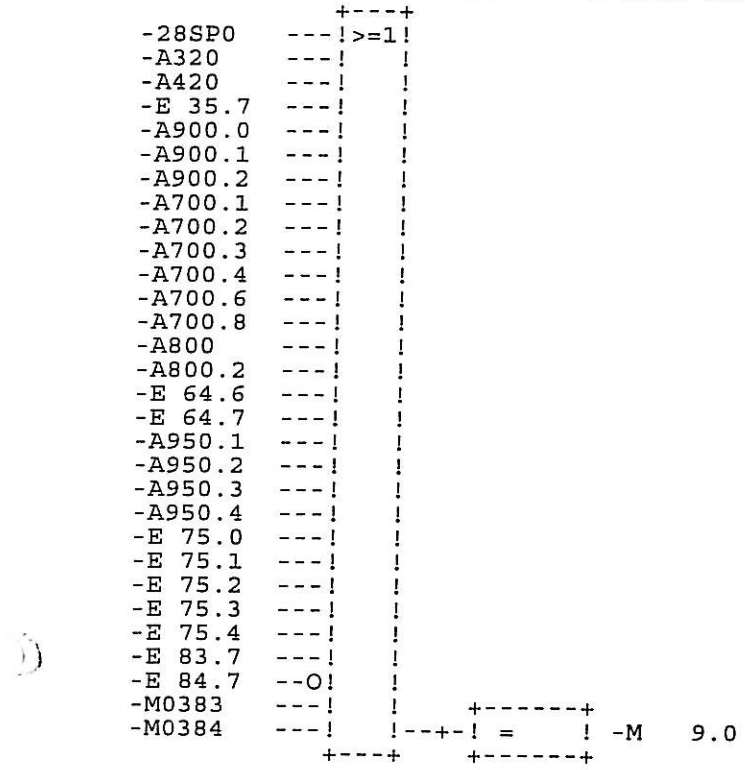
E 83.7 = E 83.7 E-STOP (MAIN CONTR.PAN.)
M 190.4 = M0353 E-STOP MAIN OPERATOR PANEL

NETZWERK 5 000F CONTROL FUSE TRIGGERED



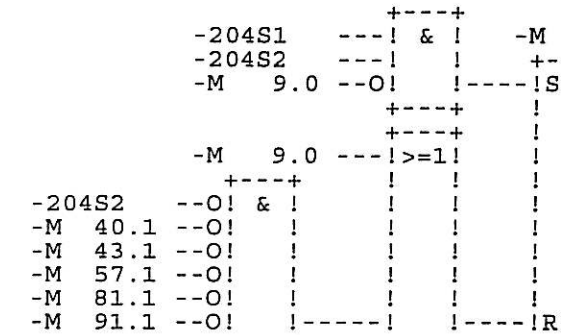
E 8.6 = 27F2 CONTROL FUSE TRIGGERED 220V/50Hz
M 170.0 = M0189 CONTROL FUSE 220V/50Hz TRIGGERED

NETZWERK 6 0012 E-STOP TRIGGERED



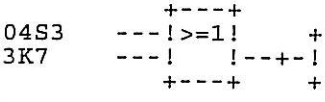
E	8.7	= 28SP0	E-STOP FEEDING LINE
E	20.0	= A320	UPPER EXTRUDER E-STOP HOPPER
E	25.0	= A420	BOTTOM EXTRUDER E-STOP HOPPER
E	35.7	= E 35.7	E-STOP CONTROL PANEL EXTRUSION HEAD
E	46.2	= A900.0	E-STOP RIPCORD UP FRONT LEFT SIDE
E	46.3	= A900.1	E-STOP RIPCORD UP FRONT RIGHT SIDE
E	46.4	= A900.2	E-STOP RIPCORD DOWN PART 1 RIGHT SIDE
E	51.6	= A700.1	FEEDER E-STOP RIPCORD OR PANEL RIGHT S.
E	51.7	= A700.2	FEEDER E-STOP RIPCORD LEFT SIDE
E	52.0	= A700.3	FEEDER E-STOP RIPCORD FRONT
E	52.4	= A700.4	FEEDER E-STOP (HOPPER STATION)
E	54.1	= A700.6	EXTRUDER CALENDER HOPPER E-STOP
E	55.6	= A700.8	E-STOP (EXTR.CAL.PAN.)
E	62.7	= A800	E-STOP (CAL PANEL)
E	64.1	= A800.2	E-STOP RIPCORD CALENDER REAR
E	64.6	= E 64.6	E-STOP RIPCORD CALENDER FRONT
E	64.7	= E 64.7	E-STOP CALENDER LEFT SIDE
E	73.3	= A950.1	E-STOP RIPCORD DOWN PART 4 RIGHT SIDE
E	73.4	= A950.2	E-STOP RIPCORD DOWN PART 3 RIGHT SIDE
E	73.5	= A950.3	E-STOP RIPCORD UP REAR RIGHT SIDE
E	73.6	= A950.4	E-STOP RIPCORD UP REAR LEFT SIDE
E	75.0	= E 75.0	WIND UP DEVICE 1 E-STOP
E	75.1	= E 75.1	WIND UP DEVICE 2 E-STOP
E	75.2	= E 75.2	WIND UP DEVICE 3 E-STOP
E	75.3	= E 75.3	WIND UP DEVICE 4 E-STOP
E	75.4	= E 75.4	E-STOP RIPCORD DOWN PART 2 RIGHT SIDE
E	83.7	= E 83.7	E-STOP (MAIN CONTR.PAN.)
E	84.7	= E 84.7	CO2 FIRE EXTINGUISHER ALARM
M	194.2	= M0383	E-STOP CABINET TREAD SKIVER
M	194.3	= M0384	E-STOP OPERATOR PANEL TREAD SKIVER
M	9.0	= M 9.0	E-STOP TRIGGERED

NETZWERK 7 0032 CONTROL VOLTAGE ON



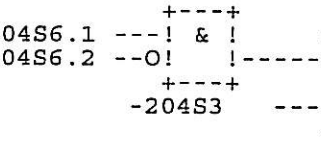
E	83.0 = 204S1	CONTROL VOLTAGE ON	(MAIN CONTR.PAN.)
E	83.1 = 204S2	CONTROL VOLTAGE OFF	(MAIN CONTR.PAN.)
M	9.0 = M 9.0	E-STOP TRIGGERED	
M	9.1 = M 9.1	CONTROL VOLTAGE IS ON	
M	40.1 = M 40.1	UP.EXTR. : AUXILIARY DRIVES ON	
M	43.1 = M 43.1	BOT.EXTR. : AUXILIARY DRIVES ON	
M	57.1 = M 57.1	EX.CAL. : AUX DRIVES ON	
M	81.1 = M 81.1	LINE : AUXILIARY DRIVES ON	
M	91.1 = M 91.1	CALENDER : AUX.DRIVES ON	
A	10.7 = 33K7	CONTROL VOLTAGE 220V ON	

NETZWERK 8 0042 LAMP CONTROL VOLTAGE



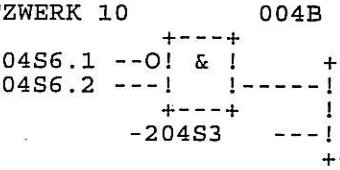
E	83.2 = 204S3	LAMP TEST	(MAIN CONTR.PAN.)
A	10.7 = 33K7	CONTROL VOLTAGE 220V ON	
A	81.1 = 210H2	CONTROL VOLTAGE ON	(MAIN CONTROL PANEL)

NETZWERK 9 0046 LAMP MANUAL



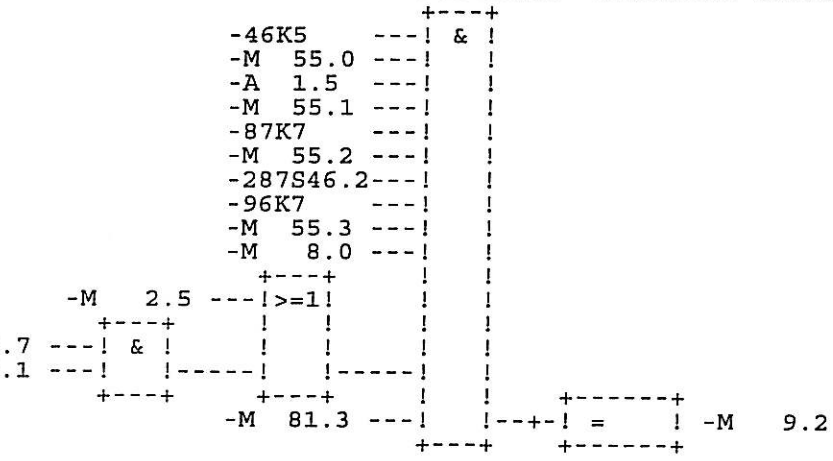
E	83.5 = 204S6.1	MANUAL	(MAIN CONTR.PAN.)
E	83.6 = 204S6.2	AUTOMATIC	(MAIN CONTR.PAN.)
E	83.2 = 204S3	LAMP TEST	(MAIN CONTR.PAN.)
A	81.4 = 210H5	MANUAL	(MAIN CONTROL PANEL)

NETZWERK 10 004B LAMP AUTOMATIC



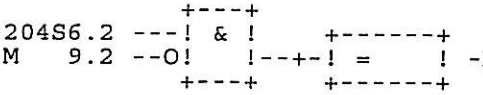
E	83.5 = 204S6.1	MANUAL	(MAIN CONTR.PAN.)
E	83.6 = 204S6.2	AUTOMATIC	(MAIN CONTR.PAN.)
E	83.2 = 204S3	LAMP TEST	(MAIN CONTR.PAN.)
A	81.3 = 210H4	AUTOMATIC	(MAIN CONTROL PANEL)

NETZWERK 11 0050 RELEASE AUTO. "PROGRAMME START"



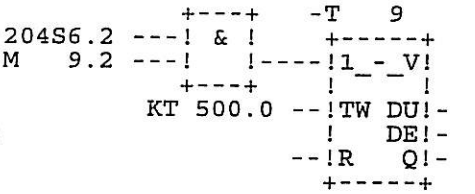

```
A    0.5 = 46K5                    UPPER EXTRUDER AUXILIARY DRIVES ON
M   55.0 = M  55.0                 RELEASE UPPER EXTR. FROM HEATING DEVICE
A    1.5 = A  1.5                  BOTTOM EXTRUDER AUXILIARY DRIVES ON
M   55.1 = M  55.1                 RELEASE BOTTOM EXTR. FROM HEATING DEVICE
A    4.7 = 87K7                    EXTRUDER CALENDER AUX DRIVES ON/OFF
M   55.2 = M  55.2                 RELEASE EXTR.CAL. FROM HEATING DEVICE
E   62.3 = 287S46.2                CALENDER AUTOMATIC/MANUAL     (CAL PANEL)
A    5.6 = 96K7                    CALENDER AUX DRIVES ON/OFF
M   55.3 = M  55.3                 RELEASE CALENDER FROM HEATING DEVICE
M    8.0 = M   8.0                 TREAD SKIVER : SWITCH IS IN AUTOMAT
M    2.5 = M   2.5                 WIND-UP
M    2.7 = M   2.7                 BOOKING
M    8.1 = M   8.1                 TREAD SKIVER : READY FOR START
M   81.3 = M  81.3                 LINE : LINE READY FOR WORK
M    9.2 = M   9.2                 RELEASE AUTOATIC "PROGRAM START"
```

NETZWERK 12 0063 MESSAGE NO RELEASE PROGRAM START



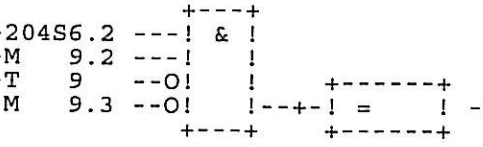

```
E   83.6 = 204S6.2                 AUTOMATIC                (MAIN CONTR.PAN.)
M    9.2 = M   9.2                 RELEASE AUTOATIC "PROGRAM START"
M  190.6 = M0355                   NO RELEASE FOR PROGRAM START
```

NETZWERK 13 0067 CONTROL "PROGRAM START"




```
E   83.6 = 204S6.2                 AUTOMATIC                (MAIN CONTR.PAN.)
M    9.2 = M   9.2                 RELEASE AUTOATIC "PROGRAM START"
T    9   = T   9                   CONTROL SWITCH "PROGRAM START"
```

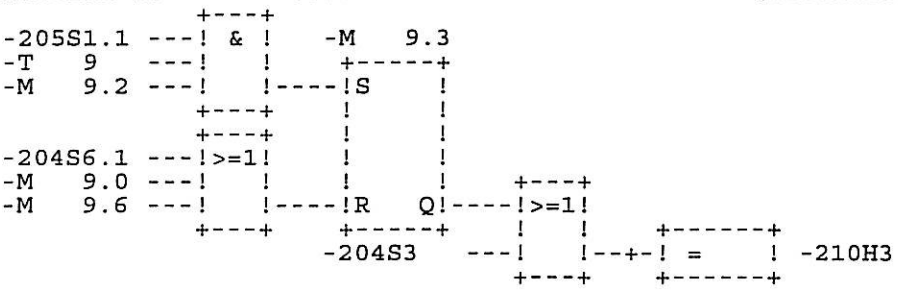
NETZWERK 14 0071 TIME PROGRAM START TERMINATED




```
E   83.6 = 204S6.2                 AUTOMATIC                (MAIN CONTR.PAN.)
M    9.2 = M   9.2                 RELEASE AUTOATIC "PROGRAM START"
```

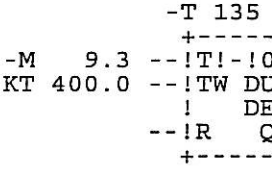
```
T    9   = T   9                    CONTROL SWITCH "PROGRAM START"
M    9.3 = M   9.3                  PROGRAM IS RUNNING (AUTOMATIC)
M  191.0 = M0341                    TIME PROGRAM START TERMINATED
```

NETZWERK 15 0077 PROGRAM IS STARTED (AUTOMATIC)



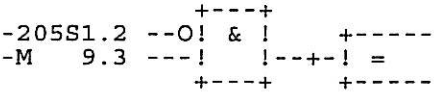

```
E   84.0 = 205S1.1                  PROGRAM START          (MAIN CONTR.PAN.)
T    9   = T   9                    CONTROL SWITCH "PROGRAM START"
M    9.2 = M   9.2                  RELEASE AUTOATIC "PROGRAM START"
M    9.3 = M   9.3                  PROGRAM IS RUNNING (AUTOMATIC)
E   83.5 = 204S6.1                  MANUAL                 (MAIN CONTR.PAN.)
M    9.0 = M   9.0                  E-STOP TRIGGERED
M    9.6 = M   9.6                  PROGRAM STOP
E   83.2 = 204S3                    LAMP TEST              (MAIN CONTR.PAN.)
A   81.2 = 210H3                    PROGRAM IS RUNNING  (MAIN CONTROL PANEL)
```

NETZWERK 16 0085 START ALARM LINE AUTOMATIC START



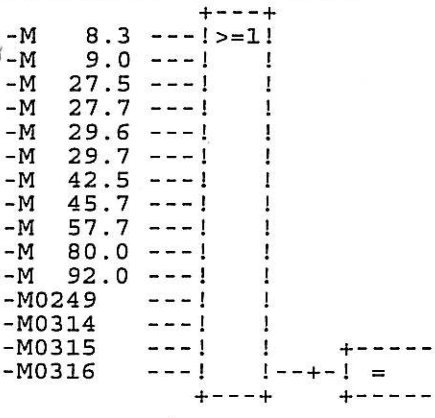

```
M    9.3 = M   9.3                  PROGRAM IS RUNNING (AUTOMATIC)
T  135   = T 135                    START ALARM FOR AUTOMTIC START
```

NETZWERK 17 008E PROGRAM STOP




```
E   84.1 = 205S1.2                  PROGRAM STOP           (MAIN CONTR.PAN.)
M    9.3 = M   9.3                  PROGRAM IS RUNNING (AUTOMATIC)
M    9.6 = M   9.6                  PROGRAM STOP
```

NETZWERK 18 0092 FAULTS HORN + LAMP

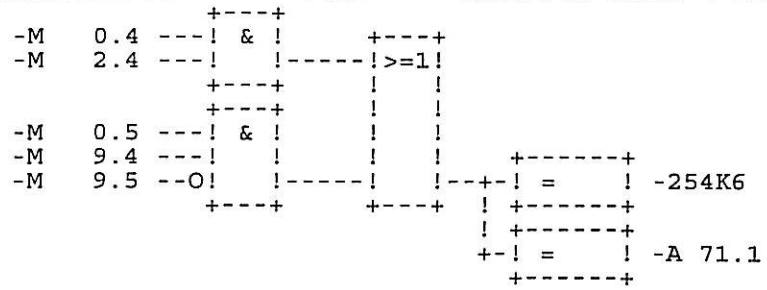



```
M    8.3 = M   8.3                  TREAD SKIVER : FAULT (MACHINE OFF)
M    9.0 = M   9.0                  E-STOP TRIGGERED
```

```
M   27.5 = M  27.5                  PRESSURE CHANNEL 1 >= MAX PRESSURE
M   27.7 = M  27.7                  PRESSURE CHANNEL 2 >= MAX PRESSURE
M   29.6 = M  29.6                  PRESS.DIFF.EXCEEDED : UPPER EXTR. OFF
M   29.7 = M  29.7                  PRESS.DIFF.EXCEEDED : BOTTOM EXTR. OFF
M   42.5 = M  42.5                  UP.EXTR. : FAULT EXTRUDER OFF
M   45.7 = M  45.7                  BOT.EXTR. : FAULT EXTRUDER OFF
M   57.7 = M  57.7                  EX.CAL. : FAULT EXTRUDER OFF
M   80.0 = M  80.0                  LINE : FAULT
M   92.0 = M  92.0                  CALENDER : FAULTS CALENDER OFF
M  179.4 = M0249                    PRESSURE COOLING WATER TO LOW
M  187.5 = M0314                    TIME PRESSURE FEEDING CLAMP          DEH
M  187.6 = M0315                    TIME PRESSURE FEEDING LOCK.CYLINDER  DEH
M  187.7 = M0316                    SYSTEM PRESSURE OVERFLOW             DEH
M    7.7 = M   7.7                  FAULT HORN + LAMP

NETZWERK 19          00A4       FAULT COLLECTION
              -M   9.4
               +-----+
 -205S3.2 --!R     !
            !      !
 -M   7.7 --!S    Q!-
            +-----+

E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
M    9.4 = M   9.4                  FAULT COLLECTION
M    7.7 = M   7.7                  FAULT HORN + LAMP

NETZWERK 20          00AA       ACKNOWLEDGING FAULT
             +---+    -M   9.5
 -205S3.1 --O! & !     +-----+
 -M   9.4 ---!   !-----!S    !
             +---+     !     !
             +---+     !     !
 -205S3.2 ---!>=1!     !     !
 -M   9.4 --O!   !-----!R   Q!-
             +---+     +-----+

E   84.2 = 205S3.1                  HORN OFF                (MAIN CONTR.PAN.)
M    9.4 = M   9.4                  FAULT COLLECTION
M    9.5 = M   9.5                  FAULT IS ACKNOWLEDGED
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)

NETZWERK 21          00B2       FAULT LAMP
             +---+
 -M0266   ---!>=1!
 -M0267   ---!   !
 -M0333   ---!   !    +-------+
 -M0334   ---!   !--+-! =     ! -M   7.5
             +---+    +-------+

M  181.5 = M0266                    OIL FLOW OIL LUBRICATION  UPPER EXTRUDER
M  181.6 = M0267                    OIL FLOW OIL LUBRICATION BOTTOM EXTRUDER
M  188.0 = M0333                    NO TEMPERATURE RELEASE    UPPER EXTRUDER
M  188.1 = M0334                    NO TEMPERATURE RELEASE   BOTTOM EXTRUDER
M    7.5 = M   7.5                  FAULT LAMP

NETZWERK 22          00B8       LAMP FAULT
                       +---+
            -M   9.4 ---! & !
              +---+     !   !
 -M   0.4 ---!>=1!      !   !     +---+
 -M   9.5 ---!   !------!   !-----!>=1!
              +---+     +---+     !   !
                     -204S3   ---!   !    +-------+
                     -M   7.5 ---!   !--+-! =     ! -210H1
                                  +---+   +-------+

M    9.4 = M   9.4                      FAULT COLLECTION
M    0.4 = M   0.4                      TACT 1 HZ
M    9.5 = M   9.5                      FAULT IS ACKNOWLEDGED
E   83.2 = 204S3                        LAMP TEST               (MAIN CONTR.PAN.)
```

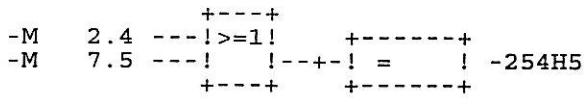
```
M    7.5 = M   7.5                    FAULT LAMP
A   81.0 = 210H1                      FAULT                (MAIN CONTROL PANEL)

NETZWERK 23        00C1      HORN FOR FAULT + START ALARM
              +---+
 -M   9.4 ---! & !
 -M   9.5 --O!   !     +---+
 -M   0.0 ---!   !-----!>=1!
              +---+     !   !
              +---+     !   !
 -M   9.3 ---! & !     !   !
 -T 135   --O!   !-----!   !
              +---+     !   !
              +---+     !   !
 -M   9.3 --O! & !     !   !
 -M  81.4 ---!   !     !   !
 -T  80   --O!   !-----!   !
              +---+     !   !
              +---+     !   !
 -M  40.1 ---! & !     !   !
 -M  40.5 ---!   !     !   !
 -M  40.6 ---!   !     !   !
 -T  48   --O!   !     !   !
 -T 135   --O!   !-----!   !
              +---+     !   !
              +---+     !   !
 -M  43.1 ---! & !     !   !
 -M  43.5 ---!   !     !   !
 -M  43.6 ---!   !     !   !
 -T 140   --O!   !     !   !
 -T 135   --O!   !-----!   !
              +---+     !   !
              +---+     !   !
 -M  57.1 ---! & !     !   !
 -M  57.5 ---!   !     !   !
 -M  57.6 ---!   !     !   !
 -T 146   --O!   !     !   !
 -T 135   --O!   !-----!   !
              +---+     !   !
              +---+     !   !
 -M  91.1 ---! & !     !   !
 -M  91.2 ---!   !     !   !
 -M  92.1 ---!   !     !   !
 -T  32   --O!   !     !   !    +------+
 -T 135   --O!   !-----!   !--+-! =    ! -M   2.4
              +---+     +---+    +------+

M    9.4 = M   9.4                    FAULT COLLECTION
M    9.5 = M   9.5                    FAULT IS ACKNOWLEDGED
M    0.0 = M   0.0                    "0"-SIGNAL
M    9.3 = M   9.3                    PROGRAM IS RUNNING (AUTOMATIC)
T  135   = T 135                      START ALARM FOR AUTOMTIC START
M   81.4 = M  81.4                    LINE : START ALARM HORN ON
T   80   = T  80                      LINE : START ALARM
M   40.1 = M  40.1                    UP.EXTR. : AUXILIARY DRIVES ON
M   40.5 = M  40.5                    UP.EXTR. : EXTRUDER START
M   40.6 = M  40.6                    UP.EXTR. : AUX DRIVES READY FOR WORK
T   48   = T  48                      UP.EXTR. : START ALARM
M   43.1 = M  43.1                    BOT.EXTR. : AUXILIARY DRIVES ON
M   43.5 = M  43.5                    BOT.EXTR. : EXTRUDER START
M   43.6 = M  43.6                    BOT.EXTR. : AUX DRIVES READY FOR WORK
T  140   = T 140                      BOT.EXTR.: START ALARM
M   57.1 = M  57.1                    EX.CAL. : AUX DRIVES ON
M   57.5 = M  57.5                    EX.CAL. : EXTRUDER START
M   57.6 = M  57.6                    EX.CAL. : AUX DRIVES READY FOR WORK
T  146   = T 146                      EXTR.CAL. : START ALARM
M   91.1 = M  91.1                    CALENDER : AUX.DRIVES ON
M   91.2 = M  91.2                    CALENDER : AUX.DRIVES READY TO START
M   92.1 = M  92.1                    CALENDER : START
T   32   = T  32                      CALENDER : START ALARM
M    2.4 = M   2.4                    FAULT + START ALARM
```

NETZWERK 24 00E5 HORN FOR FAULT + START ALARM



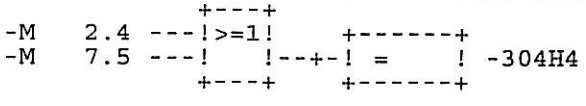

```
M     0.4 = M    0.4                    TACT 1 HZ
M     2.4 = M    2.4                    FAULT + START ALARM
M     0.5 = M    0.5                    TACT 2 HZ
M     9.4 = M    9.4                    FAULT COLLECTION
M     9.5 = M    9.5                    FAULT IS ACKNOWLEDGED
A    32.5 = 254K6                       START ALARM HORN
A    71.1 = A 71.1                      SPARE
```

NETZWERK 25 00EE LAMP FAULT + START ALARM FRONT



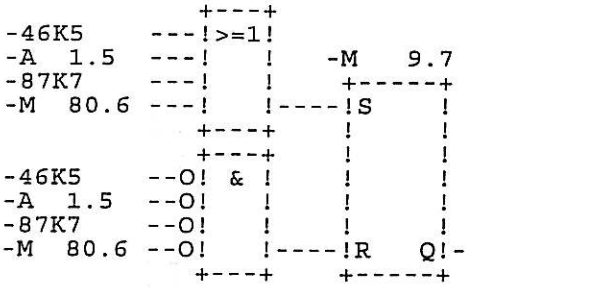

```
M     2.4 = M    2.4                    FAULT + START ALARM
M     7.5 = M    7.5                    FAULT LAMP
A    32.4 = 254H5                       START ALARM LAMP
```

NETZWERK 26 00F2 LAMP FAULT + START ALARM REAR




```
M     2.4 = M    2.4                    FAULT + START ALARM
M     7.5 = M    7.5                    FAULT LAMP
A    72.4 = 304H4                       WARNING
```

NETZWERK 27 00F6 PLANT IS OPERATING

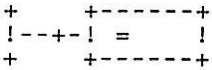



```
A     0.5 = 46K5                        UPPER EXTRUDER AUXILIARY DRIVES ON
A     1.5 = A  1.5                      BOTTOM EXTRUDER AUXILIARY DRIVES ON
A     4.7 = 87K7                        EXTRUDER CALENDER AUX DRIVES ON/OFF
M    80.6 = M  80.6                     LINE : LINE OFF
M     9.7 = M    9.7                    PLANT IS OPERATING
```

NETZWERK 28 0102
0102 :BE

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                     PROXIMITY SWITCHES AND TIMECONTROL                      *
*                                                                             *
*******************************************************************************
0000       :AWL
0001       :***
```

NETZWERK 2 0002 E-STOP EXTRUDION HEAD

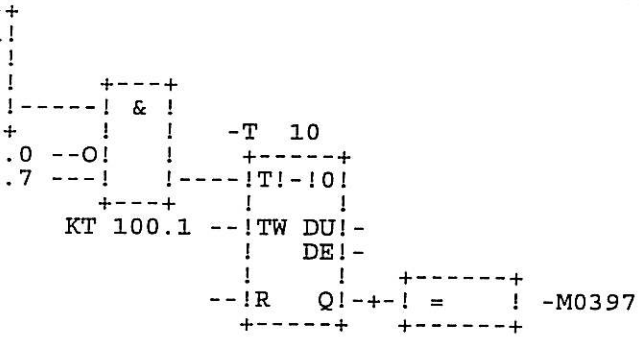



```
E   35.7 = E 35.7                    E-STOP CONTROL PANEL EXTRUSION HEAD
M  188.3 = M0336                     E-STOP OPERATOR PANEL                DEH
```

NETZWERK 3 0005 CLAMPING CLOSED

```
E   30.0 = 244S1                     CLAMPING RIGHT SIDE DOWN CLOSED
E   30.1 = 244S2                     CLAMPING LEFT  SIDE DOWN CLOSED
E   30.2 = 244S3                     CLAMPING RIGHT SIDE UP   CLOSED
E   30.3 = 244S4                     CLAMPING LEFT  SIDE UP   CLOSED
M   10.0 = M  10.0                   CLAMPING CLOSED
```

NETZWERK 4 000B TIMECONTROL : CLAMPING CLOSED

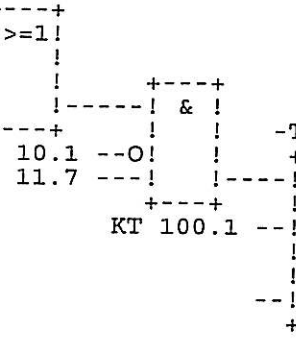



```
E   30.0 = 244S1                     CLAMPING RIGHT SIDE DOWN CLOSED
E   30.1 = 244S2                     CLAMPING LEFT  SIDE DOWN CLOSED
E   30.2 = 244S3                     CLAMPING RIGHT SIDE UP   CLOSED
E   30.3 = 244S4                     CLAMPING LEFT  SIDE UP   CLOSED
M   10.0 = M  10.0                   CLAMPING CLOSED
M   11.7 = M  11.7                   RELEASE DUPLEX EXTRUSION HEAD
T   10   = T  10                     TIMECONTROL : CLAMPING CLOSED
M  196.0 = M0397                     TIMECONTROL : CLOSE CLAMP
```

NETZWERK 5 001C CLAMPING OPENED

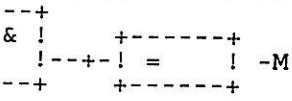

```
E   30.4 = 244S5                     CLAMPING RIGHT SIDE DOWN OPEN
E   30.5 = 244S6                     CLAMPING LEFT  SIDE DOWN OPEN
E   30.6 = 244S7                     CLAMPING RIGHT SIDE UP   OPEN
E   30.7 = 244S8                     CLAMPING LEFT  SIDE UP   OPEN
M   10.1 = M  10.1                   CLAMPING OPEN
```

NETZWERK 6 0022 TIMECONTROL : CLAMPING OPENED



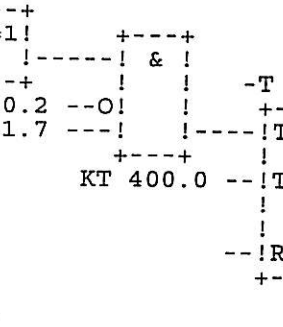
E	30.4 = 244S5	CLAMPING RIGHT SIDE DOWN OPEN
E	30.5 = 244S6	CLAMPING LEFT SIDE DOWN OPEN
E	30.6 = 244S7	CLAMPING RIGHT SIDE UP OPEN
E	30.7 = 244S8	CLAMPING LEFT SIDE UP OPEN
M	10.1 = M 10.1	CLAMPING OPEN
M	11.7 = M 11.7	RELEASE DUPLEX EXTRUSION HEAD
T	11 = T 11	TIMECONTROL : CLAMPING OPENED
M	196.1 = M0398	TIMECONTROL : OPEN CLAMP

NETZWERK 7 0033 MEDIUM PART CLOSED



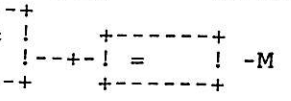
E	31.0 = 245S9	INTERMEDIATE PART RIGHT SIDE CLOSED
E	31.1 = 245S10	INTERMEDIATE PART LEFT SIDE CLOSED
M	10.2 = M 10.2	MEDIUM PART CLOSED

NETZWERK 8 0037 TIMECONTROL : MEDIUM PART CLOSED



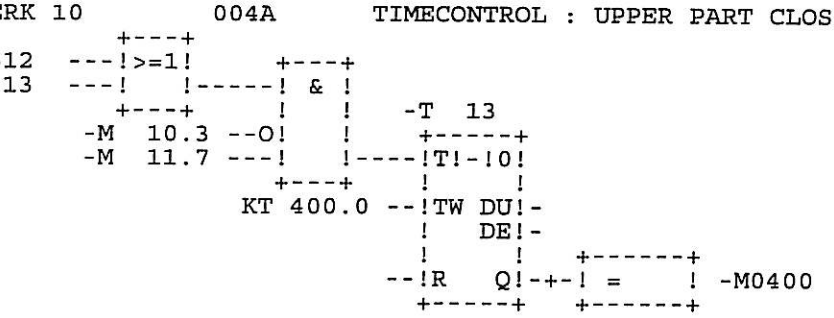
E	31.0 = 245S9	INTERMEDIATE PART RIGHT SIDE CLOSED
E	31.1 = 245S10	INTERMEDIATE PART LEFT SIDE CLOSED
M	10.2 = M 10.2	MEDIUM PART CLOSED
M	11.7 = M 11.7	RELEASE DUPLEX EXTRUSION HEAD
T	12 = T 12	TIMECONTROL : INTERMEDIATE PART CLOSED
M	196.2 = M0399	TIMECONTROL : CLOSE MEDIUM PART

NETZWERK 9 0046 UPPER PART CLOSED



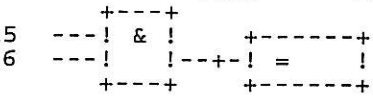
E	31.3 = 245S12	UPPER PART RIGHT SIDE CLOSED
E	31.4 = 245S13	UPPER PART LEFT SIDE CLOSED
M	10.3 = M 10.3	UPPER PART CLOSED

NETZWERK 10 004A TIMECONTROL : UPPER PART CLOSED



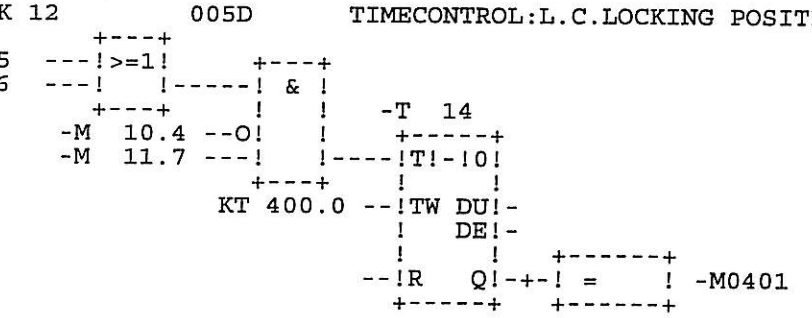
E 31.3	= 245S12	UPPER PART RIGHT SIDE CLOSED
E 31.4	= 245S13	UPPER PART LEFT SIDE CLOSED
M 10.3	= M 10.3	UPPER PART CLOSED
M 11.7	= M 11.7	RELEASE DUPLEX EXTRUSION HEAD
T 13	= T 13	TIMECONTROL : UPPER PART CLOSED
M 196.3	= M0400	TIMECONTROL : CLOSE UPPER PART

NETZWERK 11 0059 LOCKING CYLINDER : LOCKING POS.



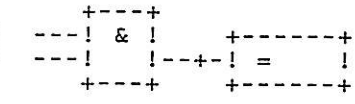
E 31.6	= 245S15	RIGHT LOCKING CYLINDER LOCKING POSITION
E 31.7	= 245S16	LEFT LOCKING CYLINDER LOCKING POSITION
M 10.4	= M 10.4	LOCKING CYLINDER : LOCKING POSITION

NETZWERK 12 005D TIMECONTROL:L.C.LOCKING POSITION



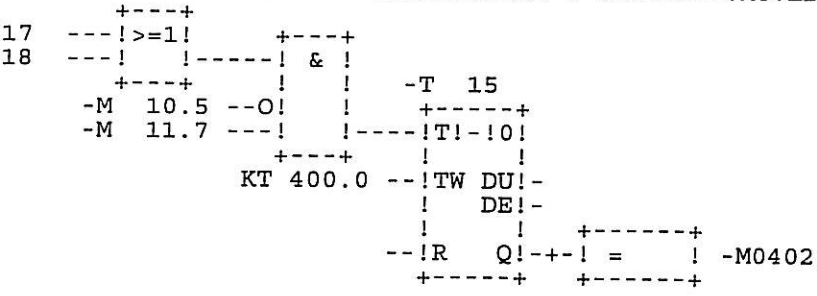
E 31.6	= 245S15	RIGHT LOCKING CYLINDER LOCKING POSITION
E 31.7	= 245S16	LEFT LOCKING CYLINDER LOCKING POSITION
M 10.4	= M 10.4	LOCKING CYLINDER : LOCKING POSITION
M 11.7	= M 11.7	RELEASE DUPLEX EXTRUSION HEAD
T 14	= T 14	TIMECONTROL : LOCK.CYL. LOCKING POSITION
M 196.4	= M0401	TIMECONTROL : LOCK.CYLINDER LOCKING POS.

NETZWERK 13 006C LOCKING CYLINDER MOVED OUT



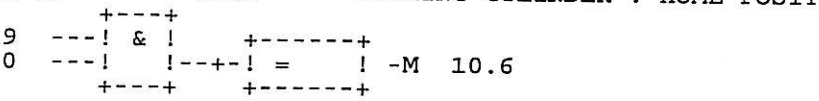
E 32.0	= 246S17	RIGHT LOCKING CYLINDER MOVED OUT
E 32.1	= 246S18	LEFT LOCKING CYLINDER MOVED OUT
M 10.5	= M 10.5	LOCKING CYLINDER MOVED OUT

NETZWERK 14 0070 TIMECONTROL : CLOS.CYL.MOVED OUT



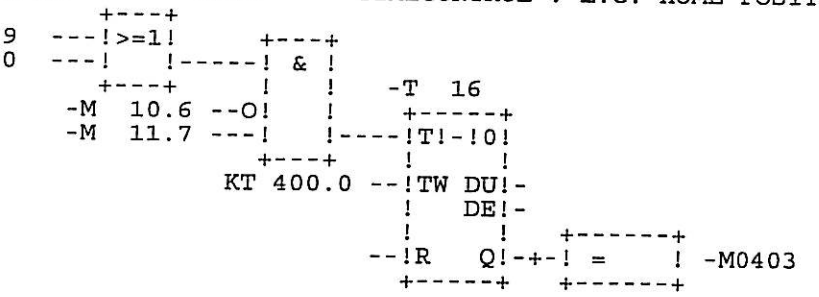
E	32.0 = 246S17	RIGHT LOCKING CYLINDER MOVED OUT
E	32.1 = 246S18	LEFT LOCKING CYLINDER MOVED OUT
M	10.5 = M 10.5	LOCKING CYLINDER MOVED OUT
M	11.7 = M 11.7	RELEASE DUPLEX EXTRUSION HEAD
T	15 = T 15	TIMECONTROL : LOCKING CYLINDER MOVED OUT
M	196.5 = M0402	TIMECONTROL : LOCK.CYLINDER MOVED OUT

NETZWERK 15 007F LOCKING CYLINDER : HOME POSITION



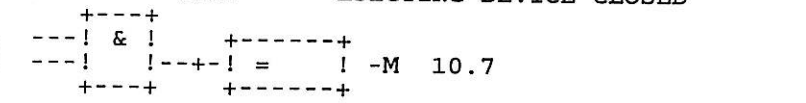
E	32.2 = 246S19	RIGHT LOCKING CYLINDER HOME POSITION
E	32.3 = 246S20	LEFT LOCKING CYLINDER HOME POSITION
M	10.6 = M 10.6	LOCKING CYLINDER HOME POSITION

NETZWERK 16 0083 TIMECONTROL : L.C. HOME POSITION



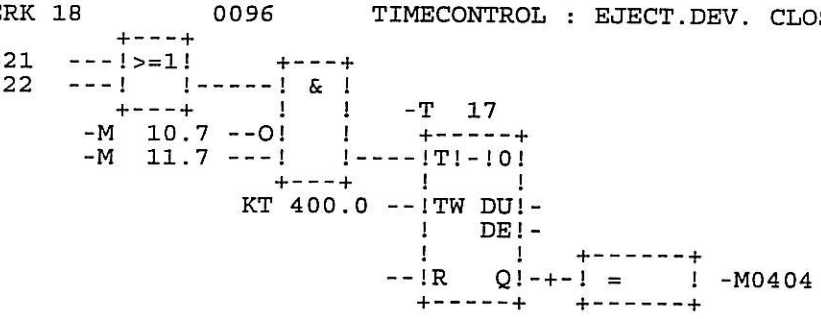
E	32.2 = 246S19	RIGHT LOCKING CYLINDER HOME POSITION
E	32.3 = 246S20	LEFT LOCKING CYLINDER HOME POSITION
M	10.6 = M 10.6	LOCKING CYLINDER HOME POSITION
M	11.7 = M 11.7	RELEASE DUPLEX EXTRUSION HEAD
T	16 = T 16	TIMECONTROL : LOCK.CYL. HOME POSITION
M	196.6 = M0403	TIMECONTROL : LOCKING CYLINDER HOME POS.

NETZWERK 17 0092 EJECTING DEVICE CLOSED



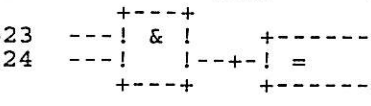
E	32.4 = 246S21	EJECTING DEVICE RIGHT SIDE CLOSED
E	32.5 = 246S22	EJECTING DEVICE LEFT SIDE CLOSED
M	10.7 = M 10.7	EJECTING DEVICE CLOSED

NETZWERK 18 0096 TIMECONTROL : EJECT.DEV. CLOSED



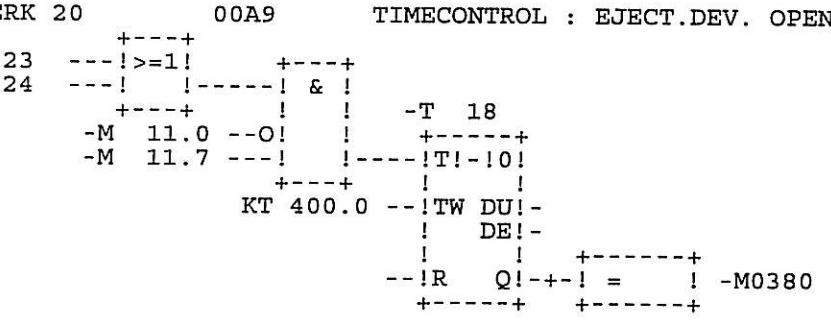
E 32.4 = 246S21		EJECTING DEVICE RIGHT SIDE CLOSED
E 32.5 = 246S22		EJECTING DEVICE LEFT SIDE CLOSED
M 10.7 = M 10.7		EJECTING DEVICE CLOSED
M 11.7 = M 11.7		RELEASE DUPLEX EXTRUSION HEAD
T 17 = T 17		TIMECONTROL : EJECTING DEVICE CLOSED
M 196.7 = M0404		TIMECONTROL : CLOSE CASS.EJECTING DEVICE

NETZWERK 19 00A5 EJECTING DEVICE OPENED



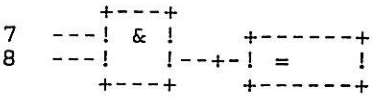
E 32.6 = 246S23		EJECTING DEVICE RIGHT SIDE OPEN
E 32.7 = 246S24		EJECTING DEVICE LEFT SIDE OPEN
M 11.0 = M 11.0		EJECTING DEVICE OPEN

NETZWERK 20 00A9 TIMECONTROL : EJECT.DEV. OPENED



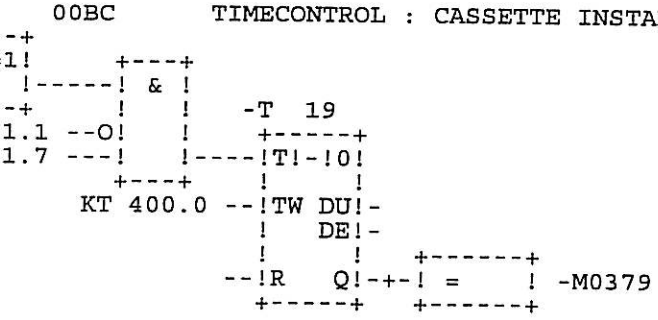
E 32.6 = 246S23		EJECTING DEVICE RIGHT SIDE OPEN
E 32.7 = 246S24		EJECTING DEVICE LEFT SIDE OPEN
M 11.0 = M 11.0		EJECTING DEVICE OPEN
M 11.7 = M 11.7		RELEASE DUPLEX EXTRUSION HEAD
T 18 = T 18		TIMECONTROL : EJECTING DEVICE OPENED
M 195.7 = M0380		TIMECONTROL : INSTALL CASSETTE

NETZWERK 21 00B8 CASSETTE INSTALLED



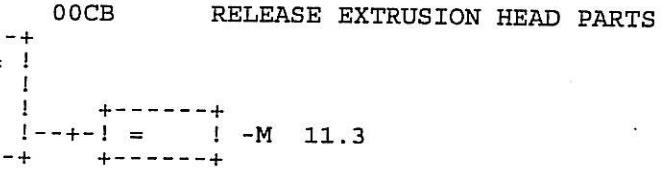
E 33.2 = 247S27		CASSETTE RIGHT SIDE INSTALLED
E 33.3 = 247S28		CASSETTE LEFT SIDE INSTALLED
M 11.1 = M 11.1		CASSETTE INSTALLED

NETZWERK 22 00BC TIMECONTROL : CASSETTE INSTALLED



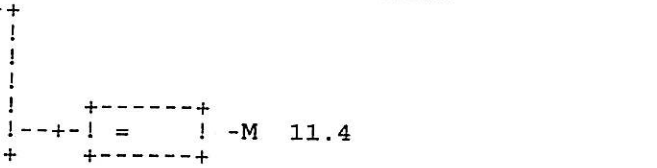
E	33.2 = 247S27	CASSETTE RIGHT SIDE INSTALLED
E	33.3 = 247S28	CASSETTE LEFT SIDE INSTALLED
M	11.1 = M 11.1	CASSETTE INSTALLED
M	11.7 = M 11.7	RELEASE DUPLEX EXTRUSION HEAD
T	19 = T 19	TIMECONTROL : CASSETTE INSTALLED
M	195.6 = M0379	TIMECONTROL : OPEN CASSETTE EJECT.DEVICE

NETZWERK 23 00CB RELEASE EXTRUSION HEAD PARTS



M	10.1 = M 10.1	CLAMPING OPEN
M	10.6 = M 10.6	LOCKING CYLINDER HOME POSITION
M	11.0 = M 11.0	EJECTING DEVICE OPEN
M	11.1 = M 11.1	CASSETTE INSTALLED
M	11.3 = M 11.3	RELEASE EXTRUSION HEAD PARTS

NETZWERK 24 00D1 RELEASE CLAMPING

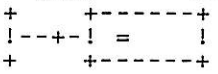


M	10.2 = M 10.2	MEDIUM PART CLOSED
M	10.3 = M 10.3	UPPER PART CLOSED
M	10.4 = M 10.4	LOCKING CYLINDER : LOCKING POSITION
M	11.1 = M 11.1	CASSETTE INSTALLED
E	34.1 = 248S34	LOCK.CYL. HIGH PRESS. BUILT UP : MIN. HP
M	11.4 = M 11.4	RELEASE CLAMPING

NETZWERK 25 00D8
00D8 :AWL
00D9 :BE

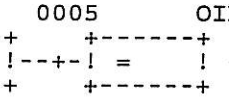
```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                HYDRAULIC-PUMP                               *
*                                                                             *
*******************************************************************************
0000       :AWL
0001       :***
```

NETZWERK 2 0002 HYDRAULIC PUMP FAULT



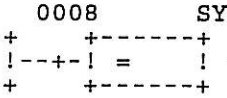

```
E    2.0 = 64Q2                          HYDRAULICS PUMP FAULT
M  186.7 = M0324                         HYDRAULICS PUMP FAULT                DEH
```

NETZWERK 3 0005 OIL FILTER DIRTY



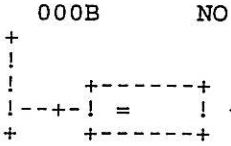

```
E   35.6 = E 35.6                        OIL FILTER FAULT
M  188.4 = M0337                         OIL FILTER DIRTY                     DEH
```

NETZWERK 4 0008 SYSTEM PRESSURE OVERFLOW



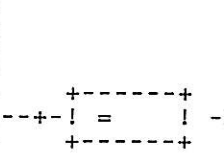

```
E   35.5 = E 35.5                        DEH SYSTEM PRESSURE OVERFLOW
M  187.7 = M0316                         SYSTEM PRESSURE OVERFLOW             DEH
```

NETZWERK 5 000B NO FAULT EXTRUSION HEAD



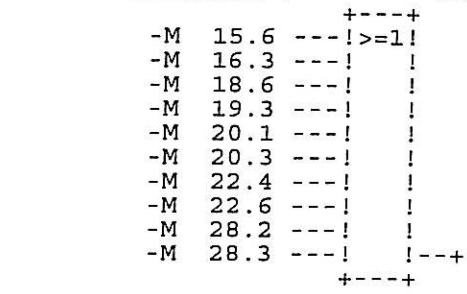

```
E    2.0 = 64Q2                          HYDRAULICS PUMP FAULT
M    9.0 = M   9.0                       E-STOP TRIGGERED
M    9.1 = M   9.1                       CONTROL VOLTAGE IS ON
M   11.6 = M  11.6                       NO FAULT DUPLEX EXTRUSION HEAD
```

NETZWERK 6 0010 RELEASE EXTRUSION HEAD



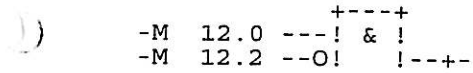

```
A    0.0 = 43A1/1                        UPPER EXTRUDER ON/OFF
A    1.0 = A  1.0                        BOTTOM EXTRUDER ON/OFF
M   11.6 = M  11.6                       NO FAULT DUPLEX EXTRUSION HEAD
M   40.5 = M  40.5                       UP.EXTR. : EXTRUDER START
M   43.5 = M  43.5                       BOT.EXTR. : EXTRUDER START
M   11.7 = M  11.7                       RELEASE DUPLEX EXTRUSION HEAD
```

NETZWERK 7 0017 DEMAND 50 BAR



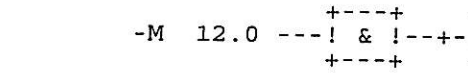
M	15.6 = M	15.6	CLOSE M.P. S4 / PROP.VALVE 50 BAR
M	16.3 = M	16.3	LOCKING : CLOSE M.P. JOG MODE
M	18.6 = M	18.6	CLOSE U.P. S4 / PROP.VALVE 50 BAR
M	19.3 = M	19.3	LOCKING : CLOSE U.P. JOG MODE
M	20.1 = M	20.1	CLOSE L.C. S1 / PROP.VALVE 180 BAR
M	20.3 = M	20.3	CLOSE L.C. S3 / PROP.VALVE 50 BAR
M	22.4 = M	22.4	OPEN L.C. S4 / PROP.VALVE 50 BAR
M	22.6 = M	22.6	OPEN L.C. S6 / PROP.VALVE 50 BAR
M	28.2 = M	28.2	SLIP-IN CASSETTE
M	28.3 = M	28.3	REVERSE SLIP-IN DEVICE
M	12.0 = M	12.0	DEMAND 50 BAR

NETZWERK 8 0023 FLANK EVALUATION



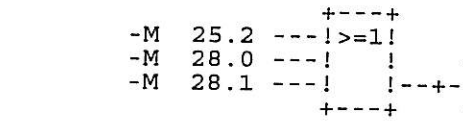
M	12.0 = M	12.0	DEMAND 50 BAR
M	12.2 = M	12.2	HF DEMAND 50 BAR
M	12.1 = M	12.1	IMPULSE DEMAND 50 BAR

NETZWERK 9 0027 H-MARK FLANK EVALUATION 50 BAR



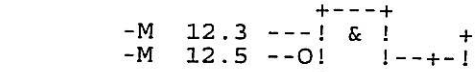
M	12.0 = M	12.0	DEMAND 50 BAR
M	12.2 = M	12.2	HF DEMAND 50 BAR

NETZWERK 10 002A DEMAND 120 BAR



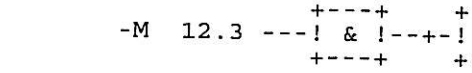
M	25.2 = M	25.2	CLOSE CLAMPING
M	28.0 = M	28.0	LIFT CASSETTE MOUNTING DEVICE
M	28.1 = M	28.1	LOWER CASSETTE MOUNTING DEVICE
M	12.3 = M	12.3	DEMAND 120 BAR

NETZWERK 11 002F FLANK EVALUATION DEMAND 120 BAR



M	12.3 = M	12.3	DEMAND 120 BAR
M	12.5 = M	12.5	HF DEMAND 120 BAR
M	12.4 = M	12.4	IMPULSE DEMAND 120 BAR

NETZWERK 12 0033 H-MARK FLANK EVALUATION 120 BAR

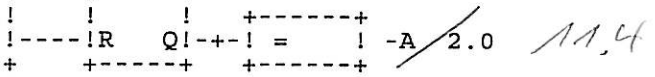


```
M   12.3 = M  12.3                    DEMAND 120 BAR
M   12.5 = M  12.5                    HF DEMAND 120 BAR

NETZWERK 13          0036      DEMAND 130 BAR
                +---+
 -M  20.5 ---!>=1!
 -M  22.1 ---!   !
 -M  24.4 ---!   !
 -M  26.4 ---!   !    +------+
 -M  28.4 ---!   !--+-! =    ! -M  12.6
                +---+    +------+

M   20.5 = M  20.5                    CLOSE L.C. S5 / PROP.VALVE 130 BAR
M   22.1 = M  22.1                    OPEN L.C. S1 / PROP.VALVE 130 BAR
M   24.4 = M  24.4                    PRESSURE FEEDING LOCK.CYLINDER ACTIVE
M   26.4 = M  26.4                    PRESSURE FEEDING CLAMPING ACTIVE
M   28.4 = M  28.4                    KEYSWITCH REBUILD HIGH PRESSURE
M   12.6 = M  12.6                    DEMAND 130 BAR

NETZWERK 14          003D      FLANK EVALUATION DEMAND 130 BAR
                +---+
 -M  12.6 ---! & !    +------+
 -M  13.0 --O!   !--+-! =    ! -M  12.7
                +---+    +------+

M   12.6 = M  12.6                    DEMAND 130 BAR
M   13.0 = M  13.0                    HF DEMAND 130 BAR
M   12.7 = M  12.7                    IMPULSE DEMAND 130 BAR

NETZWERK 15          0041      H-MARK FLANK EVALUATION 130 BAR
                +---+    +------+
 -M  12.6 ---! & !--+-! =    ! -M  13.0
                +---+    +------+

M   12.6 = M  12.6                    DEMAND 130 BAR
M   13.0 = M  13.0                    HF DEMAND 130 BAR

NETZWERK 16          0044      DEMAND 180 BAR
                +---+
 -M  15.0 ---!>=1!
 -M  15.3 ---!   !
 -M  18.0 ---!   !
 -M  18.3 ---!   !
 -M  23.0 ---!   !
 -M  25.1 ---!   !
 -M  25.4 ---!   !    +------+
 -M  25.5 ---!   !--+-! =    ! -M  13.1
                +---+    +------+

M   15.0 = M  15.0                    LOCKING : OPEN MEDIUM PART
M   15.3 = M  15.3                    CLOSE M.P. S1 / PROP.VALVE 180 BAR
M   18.0 = M  18.0                    LOCKING : OPEN UPPER PART
M   18.3 = M  18.3                    CLOSE U.P. S1 / PROP.VALVE 180 BAR
M   23.0 = M  23.0                    OPEN L.C. S8 / PROP.VALVE 180 BAR
M   25.1 = M  25.1                    OPEN CLAMPING
M   25.4 = M  25.4                    PRESS OUT CASSETTE
M   25.5 = M  25.5                    INSTALL CASSETTE
M   13.1 = M  13.1                    DEMAND 180 BAR

NETZWERK 17          004E      FLANK EVALUATION DEMAND 180 BAR
                +---+
 -M  13.1 ---! & !    +------+
 -M  13.3 --O!   !--+-! =    ! -M  13.2
                +---+    +------+

M   13.1 = M  13.1                    DEMAND 180 BAR
M   13.3 = M  13.3                    HF DEMAND 180 BAR
M   13.2 = M  13.2                    IMPULSE DEMAND 180 BAR

NETZWERK 18          0052      H-MARK FLANK EVALUATION 180 BAR
                +---+    +------+
 -M  13.1 ---! & !--+-! =    ! -M  13.3
                +---+    +------+
```

```
M   13.1 = M  13.1                    DEMAND 180 BAR
M   13.3 = M  13.3                    HF DEMAND 180 BAR

NETZWERK 19          0055      PRESSURE 50 BAR
                       -M  13.4
                        +-----+
              -M  12.1 --!S    !
                +---+    !     !
 -M  12.4 ---!>=1!    !     !
 -M  12.7 ---!   !    !     !
 -M  13.2 ---!   !    !     !
 -T  22   ---!   !    !     !
 -M  11.6 --O!   !----!R   Q!-
             +---+    +-----+

M   12.1 = M  12.1                    IMPULSE DEMAND 50 BAR
M   13.4 = M  13.4                    PRESSURE  50 BAR
M   12.4 = M  12.4                    IMPULSE DEMAND 120 BAR
M   12.7 = M  12.7                    IMPULSE DEMAND 130 BAR
M   13.2 = M  13.2                    IMPULSE DEMAND 180 BAR
T   22   = T  22                      RUN AFTER TIME HYDRAULICS PUMP
M   11.6 = M  11.6                    NO FAULT DUPLEX EXTRUSION HEAD

NETZWERK 20          005F      PRESSURE 120 BAR
                       -M  13.5
                        +-----+
              -M  12.4 --!S    !
                +---+    !     !
 -M  12.1 ---!>=1!    !     !
 -M  12.7 ---!   !    !     !
 -M  13.2 ---!   !    !     !
 -T  22   ---!   !    !     !
 -M  11.6 --O!   !----!R   Q!-
             +---+    +-----+

M   12.4 = M  12.4                    IMPULSE DEMAND 120 BAR
M   13.5 = M  13.5                    PRESSURE 120 BAR
M   12.1 = M  12.1                    IMPULSE DEMAND 50 BAR
M   12.7 = M  12.7                    IMPULSE DEMAND 130 BAR
M   13.2 = M  13.2                    IMPULSE DEMAND 180 BAR
T   22   = T  22                      RUN AFTER TIME HYDRAULICS PUMP
M   11.6 = M  11.6                    NO FAULT DUPLEX EXTRUSION HEAD

NETZWERK 21          0069      PRESSURE 130 BAR
                       -M  13.6
                        +-----+
              -M  12.7 --!S    !
                +---+    !     !
 -M  12.1 ---!>=1!    !     !
 -M  12.4 ---!   !    !     !
 -M  13.2 ---!   !    !     !
 -T  22   ---!   !    !     !
 -M  11.6 --O!   !----!R   Q!-
             +---+    +-----+

M   12.7 = M  12.7                    IMPULSE DEMAND 130 BAR
M   13.6 = M  13.6                    PRESSURE 130 BAR
M   12.1 = M  12.1                    IMPULSE DEMAND 50 BAR
M   12.4 = M  12.4                    IMPULSE DEMAND 120 BAR
M   13.2 = M  13.2                    IMPULSE DEMAND 180 BAR
T   22   = T  22                      RUN AFTER TIME HYDRAULICS PUMP
M   11.6 = M  11.6                    NO FAULT DUPLEX EXTRUSION HEAD

NETZWERK 22          0073      PRESSURE 180 BAR
                       -M  13.7
                        +-----+
              -M  13.2 --!S    !
                +---+    !     !
 -M  12.1 ---!>=1!    !     !
 -M  12.4 ---!   !    !     !
 -M  12.7 ---!   !    !     !
 -T  22   ---!   !    !     !
 -M  11.6 --O!   !----!R   Q!-
             +---+    +-----+
```

```
M   13.2 = M  13.2                    IMPULSE DEMAND 180 BAR
M   13.7 = M  13.7                    PRESSURE 180 BAR
M   12.1 = M  12.1                    IMPULSE DEMAND 50 BAR
M   12.4 = M  12.4                    IMPULSE DEMAND 120 BAR
M   12.7 = M  12.7                    IMPULSE DEMAND 130 BAR
T   22   = T  22                      RUN AFTER TIME HYDRAULICS PUMP
M   11.6 = M  11.6                    NO FAULT DUPLEX EXTRUSION HEAD
```

NETZWERK 23 007D HYDRAULIC-PUMP ON



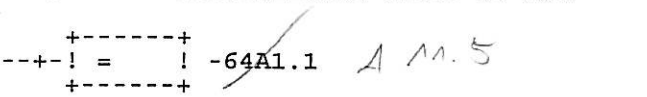
11.4

```
M   12.1 = M  12.1                    IMPULSE DEMAND 50 BAR
M   12.4 = M  12.4                    IMPULSE DEMAND 120 BAR
M   12.7 = M  12.7                    IMPULSE DEMAND 130 BAR
M   13.2 = M  13.2                    IMPULSE DEMAND 180 BAR
M   14.0 = M  14.0                    HYDRAULIC PUMP ON
T   22   = T  22                      RUN AFTER TIME HYDRAULICS PUMP
M   11.6 = M  11.6                    NO FAULT DUPLEX EXTRUSION HEAD
E   35.5 = E 35.5                     DEH SYSTEM PRESSURE OVERFLOW
E   34.0 = 248S33                     CLAMPING HIGH PRESSURE PASSED OVER MAX
E   34.4 = 248S37                     LOCK.CYL. HIGH PRESS. PASSED OVER MAX
A    2.0 = A  2.0                     HYDRAULIC-PUMP ON
```

NETZWERK 24 008B START TIME HYDAULIC-PUMP

```
M   14.0 = M  14.0                    HYDRAULIC PUMP ON
T   20   = T  20                      START TIME HYDRAULIC-PUMP
```

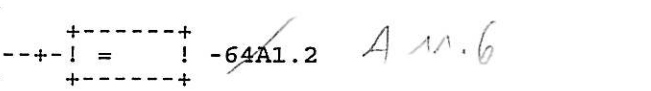
NETZWERK 25 0094 PROPORTIONAL VALVE 50 BAR



A 11.5

```
T   20   = T  20                      START TIME HYDRAULIC-PUMP
M   13.4 = M  13.4                    PRESSURE  50 BAR
A    2.1 = 64A1.1                     PROPORTIONAL VALVE  50 BAR
```

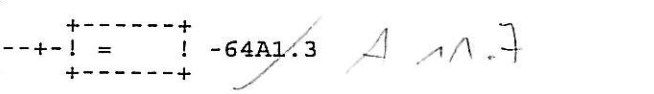
NETZWERK 26 0098 PROPORTIONAL VALVE 120 BAR



A 11.6

```
M   13.5 = M  13.5                    PRESSURE 120 BAR
T   20   = T  20                      START TIME HYDRAULIC-PUMP
A    2.2 = 64A1.2                     PROPORTIONAL VALVE 120 BAR
```

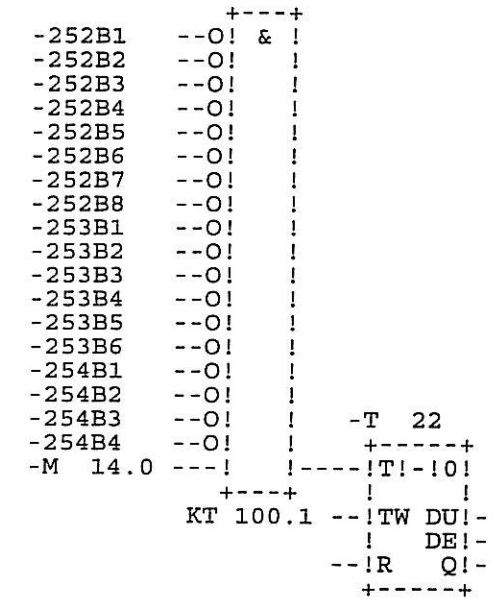
NETZWERK 27 009C PROPORTIONAL VALVE 130 BAR



A 11.7

```
M   13.6 = M  13.6                    PRESSURE 130 BAR
T   20   = T  20                      START TIME HYDRAULIC-PUMP
A    2.3 = 64A1.3                     PROPORTIONAL VALVE 130 BAR

NETZWERK 28          00A0       PROPORTIONAL VALVE 180 BAR
              +---+
 -M  13.7 ---! & !    +------+
 -T  20   ---!   !--+-! =    ! -64A1.4
              +---+    +------+

M   13.7 = M  13.7                    PRESSURE 180 BAR
T   20   = T  20                      START TIME HYDRAULIC-PUMP
A    2.4 = 64A1.4                     PROPORTIONAL VALVE 180 BAR

NETZWERK 29          00A4       BUILT UP PRESSURE PROP.VALVE
            -T  21
             +-----+
 -T  20   --!T!-!0!
 KT 150.0 --!TW DU!-
             !   DE!-
           --!R   Q!-
             +-----+

T   20   = T  20                      START TIME HYDRAULIC-PUMP
T   21   = T  21                      TIME BUILT UP PRESSURE PROP.VALVE

NETZWERK 30          00AD       RELEASE SOLENOID VALVE 50 BAR
              +---+
 -T  21   ---! & !    +------+
 -64A1.1  ---!   !--+-! =    ! -M  14.1
              +---+    +------+

T   21   = T  21                      TIME BUILT UP PRESSURE PROP.VALVE
A    2.1 = 64A1.1                     PROPORTIONAL VALVE  50 BAR
M   14.1 = M  14.1                    RELEASE SOLENOID VALVE  50 BAR

NETZWERK 31          00B1       RELEASE SOLENOID VALVE 120 BAR
              +---+
 -T  21   ---! & !    +------+
 -64A1.2  ---!   !--+-! =    ! -M  14.2
              +---+    +------+

T   21   = T  21                      TIME BUILT UP PRESSURE PROP.VALVE
A    2.2 = 64A1.2                     PROPORTIONAL VALVE 120 BAR
M   14.2 = M  14.2                    RELEASE SOLENOID VALVE 120 BAR

NETZWERK 32          00B5       RELEASE SOLENOID VALVE 130 BAR
              +---+
 -T  21   ---! & !    +------+
 -64A1.3  ---!   !--+-! =    ! -M  14.3
              +---+    +------+

T   21   = T  21                      TIME BUILT UP PRESSURE PROP.VALVE
A    2.3 = 64A1.3                     PROPORTIONAL VALVE 130 BAR
M   14.3 = M  14.3                    RELEASE SOLENOID VALVE 130 BAR

NETZWERK 33          00B9       RELEASE SOLENOID VALVE 180 BAR
              +---+
 -T  21   ---! & !    +------+
 -64A1.4  ---!   !--+-! =    ! -M  14.4
              +---+    +------+

T   21   = T  21                      TIME BUILT UP PRESSURE PROP.VALVE
A    2.4 = 64A1.4                     PROPORTIONAL VALVE 180 BAR
M   14.4 = M  14.4                    RELEASE SOLENOID VALVE 180 BAR
```

NETZWERK 34 00BD RUN AFTER TIME HYDRAULIC-PUMP

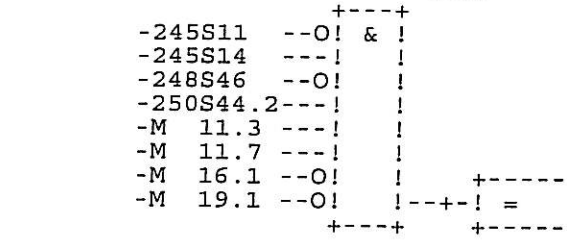


A	30.0	= 252B1	SV CLOSE CLAMPING
A	30.1	= 252B2	SV OPEN CLAMPING
A	30.2	= 252B3	SV EJECTING DEVICE : PRESS IN CASSETTE
A	30.3	= 252B4	SV EJECTING DEVICE : PRESS OUT CASSETTE
A	30.4	= 252B5	SV CLOSE MEDIUM PART
A	30.5	= 252B6	SV OPEN MEDIUM PART
A	30.6	= 252B7	SV CLOSE UPPER PART
A	30.7	= 252B8	SV OPEN UPPER PART
A	31.0	= 253B1	SV MOVE LOCKING CYLINDER REVERSE
A	31.1	= 253B2	SV MOVE LOCKING CYLINDER FORWARD
A	31.2	= 253B3	SV OIL PUMP BUILD UP PRESSURE Q1
A	31.3	= 253B4	SV PRESSURE TRANSDUCER HIGH PRESSURE ON
A	31.4	= 253B5	SV PRESSURE TRANSDUCER HOME POSITION
A	31.5	= 253B6	SV LOCKING CYLINDER REBUILT HIGH PRESS.
A	32.0	= 254B1	SV DOWN CASSETTE MOUNTING DEVICE
A	32.1	= 254B2	SV UP CASSETTE MOUNTING DEVICE
A	32.2	= 254B3	SV SLIP-IN CASSETTE
A	32.3	= 254B4	SV MOVE CASSETTE MOUNTING DEV. REVERSE
M	14.0	= M 14.0	HYDRAULIC PUMP ON
T	22	= T 22	RUN AFTER TIME HYDRAULICS PUMP

```
NETZWERK 35          00D8
00D8        :AWL
00D9        :BE
```

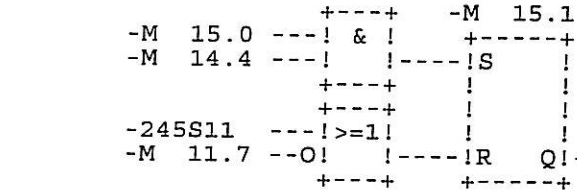
```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  MEDIUM PART                                *
*                                                                             *
*******************************************************************************

0000       :AWL
0001       :***
```

NETZWERK 2 0002 LOCKING : OPEN MEDIUM PART



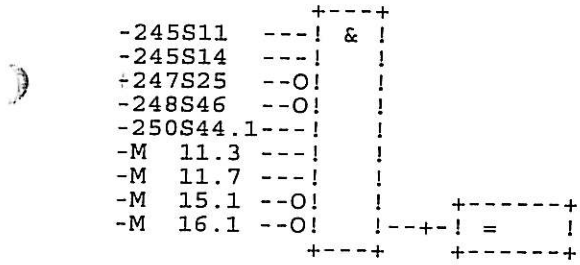

```
E   31.2 = 245S11                    PROX.SWITCH MEDIUM PART OPEN
E   31.5 = 245S14                    PROX.SWITCH UPPER PART OPEN
E   34.6 = 248S46                    CASSETTE MOUNTING DEVICE AT DEH
E   36.7 = 250S44.2                  SWITCH : OPEN MEDIUM PART
M   11.3 = M  11.3                   RELEASE EXTRUSION HEAD PARTS
M   11.7 = M  11.7                   RELEASE DUPLEX EXTRUSION HEAD
M   16.1 = M  16.1                   CLOSE M.P. CICLE MARK
M   19.1 = M  19.1                   CLOSE U.P. CICLE MARK
M   15.0 = M  15.0                   LOCKING : OPEN MEDIUM PART
```

NETZWERK 3 000C OPEN MEDIUM PART




```
M   15.0 = M  15.0                   LOCKING : OPEN MEDIUM PART
M   14.4 = M  14.4                   RELEASE SOLENOID VALVE 180 BAR
M   15.1 = M  15.1                   OPEN MEDIUM PART
E   31.2 = 245S11                    PROX.SWITCH MEDIUM PART OPEN
M   11.7 = M  11.7                   RELEASE DUPLEX EXTRUSION HEAD
```

NETZWERK 4 0014 LOCKING : CLOSE MEDIUM PART

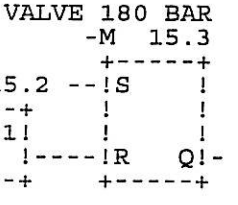



```
E   31.2 = 245S11                    PROX.SWITCH MEDIUM PART OPEN
E   31.5 = 245S14                    PROX.SWITCH UPPER PART OPEN
E   33.0 = 247S25                    PROX.SWITCH MEDIUM PART UNLOCKED
E   34.6 = 248S46                    CASSETTE MOUNTING DEVICE AT DEH
E   36.6 = 250S44.1                  SWITCH : CLOSE MEDIUM PART
M   11.3 = M  11.3                   RELEASE EXTRUSION HEAD PARTS
M   11.7 = M  11.7                   RELEASE DUPLEX EXTRUSION HEAD
M   15.1 = M  15.1                   OPEN MEDIUM PART
M   16.1 = M  16.1                   CLOSE M.P. CICLE MARK
```

M 15.2 = M 15.2 LOCKING : CLOSE MEDIUM PART

NETZWERK 5 001F CLOSE MEDIUM PART STEP 1

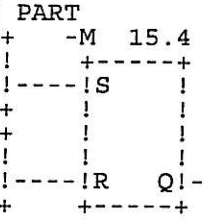
>>>PROPORTIONAL VALVE 180 BAR




```
M   15.2 = M  15.2                    LOCKING : CLOSE MEDIUM PART
M   15.3 = M  15.3                    CLOSE M.P. S1 / PROP.VALVE 180 BAR
M   15.4 = M  15.4                    CLOSE M.P. S2 / SV OPEN M.P.
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD
```

NETZWERK 6 0026 CLOSE MEDIUM PART STEP 2

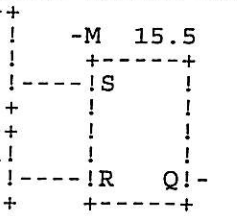
>>>SV OPEN MEDIUM PART




```
M   15.3 = M  15.3                    CLOSE M.P. S1 / PROP.VALVE 180 BAR
M   14.4 = M  14.4                    RELEASE SOLENOID VALVE 180 BAR
M   15.4 = M  15.4                    CLOSE M.P. S2 / SV OPEN M.P.
M   15.5 = M  15.5                    CLOSE M.P. S3 / VALVE UNLOCKING M.P.
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD
```

NETZWERK 7 002E CLOSE MEDIUM PART STEP 3

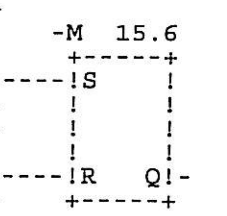
>>>SOLENOID UNLOCKING MEDIUM PART




```
M   15.4 = M  15.4                    CLOSE M.P. S2 / SV OPEN M.P.
T   62   = T  62                     PRESSURE ON MEDIUM PART OPENED
E   31.2 = 245S11                     PROX.SWITCH MEDIUM PART OPEN
M   15.5 = M  15.5                    CLOSE M.P. S3 / VALVE UNLOCKING M.P.
M   15.6 = M  15.6                    CLOSE M.P. S4 / PROP.VALVE 50 BAR
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD
```

NETZWERK 8 0037 CLOSE MEDIUM PART STEP 4

>>>PROPORTIONAL VALVE 50 BAR




```
M   15.5 = M  15.5                    CLOSE M.P. S3 / VALVE UNLOCKING M.P.
E   33.0 = 247S25                     PROX.SWITCH MEDIUM PART UNLOCKED
```

```
E   31.2 = 245S11                    PROX.SWITCH MEDIUM PART OPEN
M   15.6 = M  15.6                   CLOSE M.P. S4 / PROP.VALVE 50 BAR
M   15.7 = M  15.7                   CLOSE M.P. S5 / SV CLOSE M.P.
M   11.7 = M  11.7                   RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 9          0040      CLOSE MEDIUM PART STEP 5

>>>SV CLOSE MEDIUM PART
                  +---+    -M  15.7
 -M  15.6 ---! & !     +-----+
 -M  14.1 ---!    !----!S     !
                  +---+     !     !
                  +---+     !     !
 -M  16.0 ---!>=1!     !     !
 -M  11.7 --O!    !----!R    Q!-
                  +---+     +-----+

M   15.6 = M  15.6                   CLOSE M.P. S4 / PROP.VALVE 50 BAR
M   14.1 = M  14.1                   RELEASE SOLENOID VALVE  50 BAR
M   15.7 = M  15.7                   CLOSE M.P. S5 / SV CLOSE M.P.
M   16.0 = M  16.0                   CLOSE M.P. S6 / CICLE FINISHED
M   11.7 = M  11.7                   RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 10         0048      CLOSE MEDIUM PART STEP 6

>>>CICLE FINISHED
                +---+
 -M  15.7 ---! & !
 -M  11.7 ---!    !     +------+
 -T  63   ---!    !--+-! =    ! -M  16.0
                +---+     +------+

M   15.7 = M  15.7                   CLOSE M.P. S5 / SV CLOSE M.P.
M   11.7 = M  11.7                   RELEASE DUPLEX EXTRUSION HEAD
T   63   = T  63                     CLOSE MEDIUM PART
M   16.0 = M  16.0                   CLOSE M.P. S6 / CICLE FINISHED

NETZWERK 11         004D      CICLE MARK : CLOSE MEDIUM PART
                        -M  16.1
                        +-----+
              -M  15.3 --!S     !
                +---+    !     !
 -M  16.0 ---!>=1!     !     !
 -M  11.7 --O!    !----!R    Q!-
              +---+     +-----+

M   15.3 = M  15.3                   CLOSE M.P. S1 / PROP.VALVE 180 BAR
M   16.1 = M  16.1                   CLOSE M.P. CICLE MARK
M   16.0 = M  16.0                   CLOSE M.P. S6 / CICLE FINISHED
M   11.7 = M  11.7                   RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 12         0054      PRESSURE ON MEDIUM PART OPENED
            -T  62
             +-----+
 -M  15.4 --!T!-!0!
 KT 200.0 --!TW DU!-
             !   DE!-
           --!R   Q!-
             +-----+

M   15.4 = M  15.4                   CLOSE M.P. S2 / SV OPEN M.P.
T   62   = T  62                     PRESSURE ON MEDIUM PART OPENED

NETZWERK 13         005D      CLOSE MEDIUM PART
            -T  63
             +-----+
 -M  15.7 --!T!-!0!
 KT 400.0 --!TW DU!-
             !   DE!-
           --!R   Q!-
             +-----+
```

```
M   15.7 = M  15.7                    CLOSE M.P. S5 / SV CLOSE M.P.
T   63   = T  63                      CLOSE MEDIUM PART

NETZWERK 14        0066      CLOSE MEDIUM PART JOG MODE
              +---+
 -245S11  --O! & !
 -245S14  ---!   !
 -250S44.1---!   !
 -M  10.2 --O!   !
 -M  11.3 ---!   !
 -M  11.7 ---!   !
 -M  15.1 --O!   !    +------+
 -M  16.1 --O!   !--+-! =    ! -M  16.3
              +---+    +------+

E   31.2 = 245S11                     PROX.SWITCH MEDIUM PART OPEN
E   31.5 = 245S14                     PROX.SWITCH UPPER PART OPEN
E   36.6 = 250S44.1                   SWITCH : CLOSE MEDIUM PART
M   10.2 = M  10.2                    MEDIUM PART CLOSED
M   11.3 = M  11.3                    RELEASE EXTRUSION HEAD PARTS
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD
M   15.1 = M  15.1                    OPEN MEDIUM PART
M   16.1 = M  16.1                    CLOSE M.P. CICLE MARK
M   16.3 = M  16.3                    LOCKING : CLOSE M.P. JOG MODE

NETZWERK 15        0070      SOLENOID UNLOCKING MEDIUM PART
                     -M  16.4
                      +-----+
           -M  15.5 --!S    !
             +---+    !     !
 -M  16.0 ---!>=1!    !     !   +------+
 -M  11.7 --O!   !----!R   Q!-+-! =    ! -253K7
             +---+    +-----+   +------+

M   15.5 = M  15.5                    CLOSE M.P. S3 / VALVE UNLOCKING M.P.
M   16.4 = M  16.4                    VALVE UNLOCKING M.P.(CICLE CLOSE M.P.)
M   16.0 = M  16.0                    CLOSE M.P. S6 / CICLE FINISHED
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD
A   31.6 = 253K7                      DEH UNLOCKING MEDIUM PART

NETZWERK 16        0078      SOLENOID VALVE OPEN MEDIUM PART
                     -M  16.5
                      +-----+
           -M  15.4 --!S    !
             +---+    !     !
 -M  15.7 ---!>=1!    !     !    +---+
 -M  11.7 --O!   !----!R   Q!----!>=1!
             +---+    +-----+    !   !    +------+
                     -M  15.1 ---!   !--+-! =    ! -252B6
                                 +---+    +------+

M   15.4 = M  15.4                    CLOSE M.P. S2 / SV OPEN M.P.
M   16.5 = M  16.5                    SV OPEN M.P. (CICLE CLOSE M.P.)
M   15.7 = M  15.7                    CLOSE M.P. S5 / SV CLOSE M.P.
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD
M   15.1 = M  15.1                    OPEN MEDIUM PART
A   30.5 = 252B6                      SV OPEN MEDIUM PART

NETZWERK 17        0083      SOLENOID VALVE CLOSE MEDIUM PART
                      +---+
           -M  15.7 ---!>=1!
           -M  19.3 ---!   !
           -M  20.2 ---!   !
           -M  20.3 ---!   !
           -M  20.4 ---!   !
           -M  24.1 ---!   !
             +---+     !   !
 -M  16.3 ---! & !     !   !    +------+
 -M  14.1 ---!   !-----!   !--+-! =    ! -252B5
             +---+     +---+    +------+
```

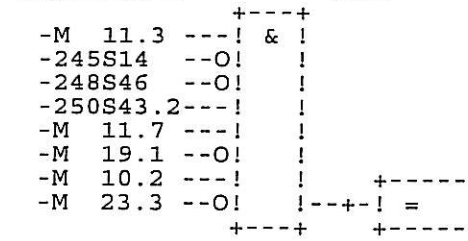
```
M   15.7 = M  15.7          CLOSE M.P. S5 / SV CLOSE M.P.
M   19.3 = M  19.3          LOCKING : CLOSE U.P. JOG MODE
M   20.2 = M  20.2          CLOSE L.C. S2 / SV FORWARD LOCK.CYL.
M   20.3 = M  20.3          CLOSE L.C. S3 / PROP.VALVE 50 BAR
M   20.4 = M  20.4          CLOSE L.C. S4 / SV REVERSE LOCK.CYL.
M   24.1 = M  24.1          M.P. / U.P. / Q1 (CICLE OPEN L.C.)
M   16.3 = M  16.3          LOCKING : CLOSE M.P. JOG MODE
M   14.1 = M  14.1          RELEASE SOLENOID VALVE  50 BAR
A   30.4 = 252B5            SV CLOSE MEDIUM PART

NETZWERK 18        008E
008E       :AWL
008F       :BE
```

NETZWERK 1 0000

```
*******************************************************************************
*                                                                             *
*                                  UPPER PART                                 *
*                                                                             *
*******************************************************************************
```

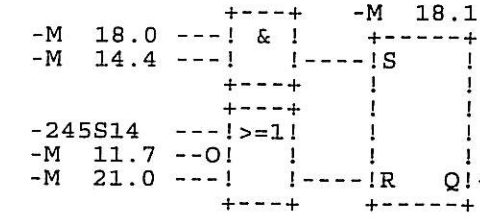
```
0000      :AWL
0001      :***
```

NETZWERK 2 0002 LOCKING : OPEN UPPER PART



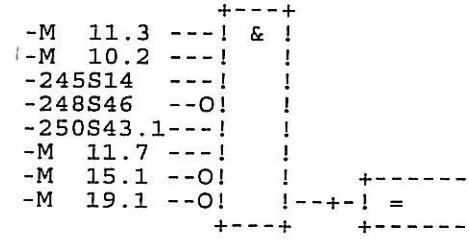

```
M   11.3 = M  11.3                    RELEASE EXTRUSION HEAD PARTS
E   31.5 = 245S14                     PROX.SWITCH UPPER PART OPEN
E   34.6 = 248S46                     CASSETTE MOUNTING DEVICE AT DEH
E   36.5 = 250S43.2                   SWITCH : OPEN UPPER PART
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD
M   19.1 = M  19.1                    CLOSE U.P. CICLE MARK
M   10.2 = M  10.2                    MEDIUM PART CLOSED
M   23.3 = M  23.3                    OPEN LOCKING CYLINDER CICLE MARK
M   18.0 = M  18.0                    LOCKING : OPEN UPPER PART
```

NETZWERK 3 000C OPEN UPPER PART



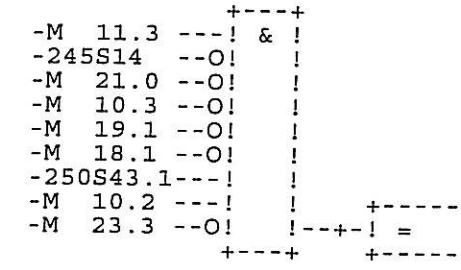

```
M   18.0 = M  18.0                    LOCKING : OPEN UPPER PART
M   14.4 = M  14.4                    RELEASE SOLENOID VALVE 180 BAR
M   18.1 = M  18.1                    OPEN UPPER PART
E   31.5 = 245S14                     PROX.SWITCH UPPER PART OPEN
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD
M   21.0 = M  21.0                    CLOSE L.C. CICLE MARK
```

NETZWERK 4 0015 LOCKING : CLOSE UPPER PART



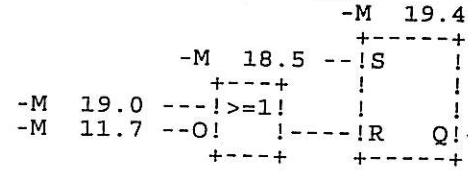

```
M   11.3 = M  11.3                    RELEASE EXTRUSION HEAD PARTS
M   10.2 = M  10.2                    MEDIUM PART CLOSED
E   31.5 = 245S14                     PROX.SWITCH UPPER PART OPEN
E   34.6 = 248S46                     CASSETTE MOUNTING DEVICE AT DEH
E   36.4 = 250S43.1                   SWITCH : CLOSE UPPER PART
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD
M   15.1 = M  15.1                    OPEN MEDIUM PART
M   19.1 = M  19.1                    CLOSE U.P. CICLE MARK
M   18.2 = M  18.2                    LOCKING : CLOSE UPPER PART
```

NETZWERK 14 0065 CLOSE UPPER PART JOG MODE



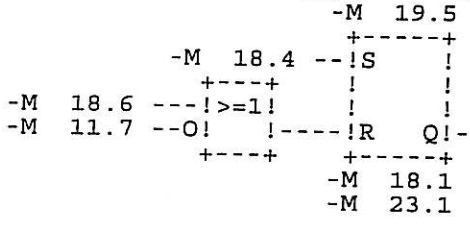
M 11.3 = M 11.3		RELEASE EXTRUSION HEAD PARTS
E 31.5 = 245S14		PROX.SWITCH UPPER PART OPEN
M 21.0 = M 21.0		CLOSE L.C. CICLE MARK
M 10.3 = M 10.3		UPPER PART CLOSED
M 19.1 = M 19.1		CLOSE U.P. CICLE MARK
M 18.1 = M 18.1		OPEN UPPER PART
E 36.4 = 250S43.1		SWITCH : CLOSE UPPER PART
M 10.2 = M 10.2		MEDIUM PART CLOSED
M 23.3 = M 23.3		OPEN LOCKING CYLINDER CICLE MARK
M 19.3 = M 19.3		LOCKING : CLOSE U.P. JOG MODE

NETZWERK 15 0070 SOLENOID UNLOCKING UPPER PART



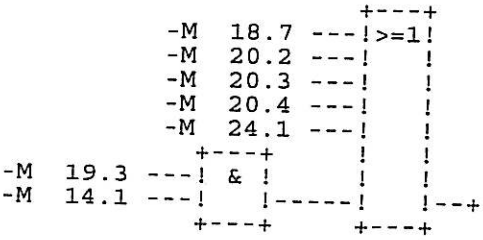
M 18.5 = M 18.5		CLOSE U.P. S3 / VALVE UNLOCKING U.P.
M 19.4 = M 19.4		VALVE UNLOCKING U.P.(CICLE CLOSE U.P.)
M 19.0 = M 19.0		CLOSE U.P. S6 / CICLE FINISHED
M 11.7 = M 11.7		RELEASE DUPLEX EXTRUSION HEAD
A 31.7 = 253K8		DEH UNLOCKING UPPER PART

NETZWERK 16 0078 SOLENOID VALVE OPEN UPPER PART



M 18.4 = M 18.4		CLOSE U.P. S2 / SV OPEN U.P.
M 19.5 = M 19.5		SV OPEN U.P. (CICLE CLOSE U.P.)
M 18.6 = M 18.6		CLOSE U.P. S4 / PROP.VALVE 50 BAR
M 11.7 = M 11.7		RELEASE DUPLEX EXTRUSION HEAD
M 18.1 = M 18.1		OPEN UPPER PART
M 23.1 = M 23.1		OPEN L.C. S9 / SV OPEN UPPER PART
A 30.7 = 252B8		SV OPEN UPPER PART

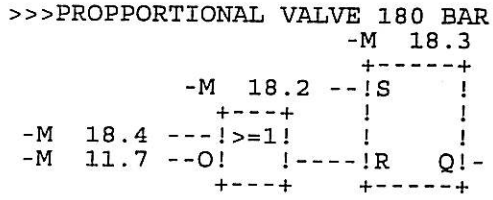
NETZWERK 17 0084 SOLENOID VALVE CLOSE UPPER PART



```
M   18.7 = M  18.7    CLOSE U.P. S5 / SV CLOSE U.P.
M   20.2 = M  20.2    CLOSE L.C. S2 / SV FORWARD LOCK.CYL.
M   20.3 = M  20.3    CLOSE L.C. S3 / PROP.VALVE 50 BAR
M   20.4 = M  20.4    CLOSE L.C. S4 / SV REVERSE LOCK.CYL.
M   24.1 = M  24.1    M.P. / U.P. / Q1 (CICLE OPEN L.C.)
M   19.3 = M  19.3    LOCKING : CLOSE U.P. JOG MODE
M   14.1 = M  14.1    RELEASE SOLENOID VALVE  50 BAR
A   30.6 = 252B7      SV CLOSE UPPER PART

NETZWERK 18         008E
008E       :AWL
008F       :BE
```

NETZWERK 5 001F CLOSE UPPER PART STEP 1

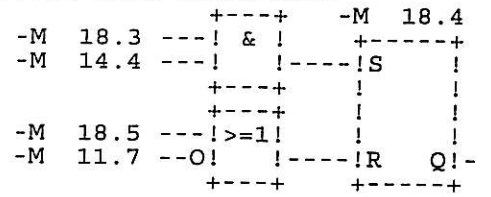
>>>PROPPORTIONAL VALVE 180 BAR



M 18.2 = M 18.2		LOCKING : CLOSE UPPER PART
M 18.3 = M 18.3		CLOSE U.P. S1 / PROP.VALVE 180 BAR
M 18.4 = M 18.4		CLOSE U.P. S2 / SV OPEN U.P.
M 11.7 = M 11.7		RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 6 0026 CLOSE UPPER PART STEP 2

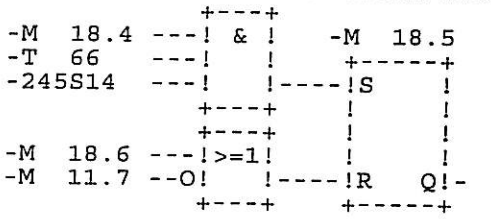
>>>SV OPEN UPPER PART



M 18.3 = M 18.3		CLOSE U.P. S1 / PROP.VALVE 180 BAR
M 14.4 = M 14.4		RELEASE SOLENOID VALVE 180 BAR
M 18.4 = M 18.4		CLOSE U.P. S2 / SV OPEN U.P.
M 18.5 = M 18.5		CLOSE U.P. S3 / VALVE UNLOCKING U.P.
M 11.7 = M 11.7		RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 7 002E CLOSE UPPER PART STEP 3

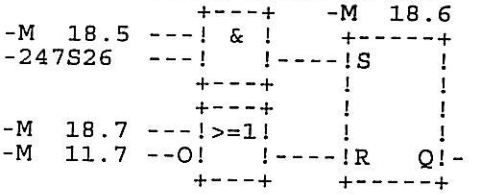
>>>SOLENOID UNLOCKING UPPER PART



M 18.4 = M 18.4		CLOSE U.P. S2 / SV OPEN U.P.
T 66 = T 66		PRESSURE UP UPPER PART OPENED
E 31.5 = 245S14		PROX.SWITCH UPPER PART OPEN
M 18.5 = M 18.5		CLOSE U.P. S3 / VALVE UNLOCKING U.P.
M 18.6 = M 18.6		CLOSE U.P. S4 / PROP.VALVE 50 BAR
M 11.7 = M 11.7		RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 8 0037 CLOSE UPPER PART STEP 4

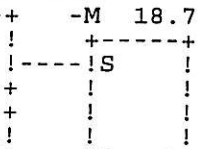
>>>PROPORTIONAL VALVE 50 BAR



M 18.5 = M 18.5		CLOSE U.P. S3 / VALVE UNLOCKING U.P.
E 33.1 = 247S26		PROX.SWITCH UPPER PART UNLOCKED
M 18.6 = M 18.6		CLOSE U.P. S4 / PROP.VALVE 50 BAR
M 18.7 = M 18.7		CLOSE U.P. S5 / SV CLOSE U.P.
M 11.7 = M 11.7		RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 9 003F CLOSE UPPER PART STEP 5

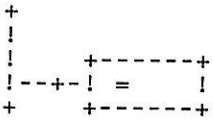
>>>SV CLOSE UPPER PART



M	18.6 = M	18.6	CLOSE U.P. S4 / PROP.VALVE 50 BAR
M	14.1 = M	14.1	RELEASE SOLENOID VALVE 50 BAR
M	18.7 = M	18.7	CLOSE U.P. S5 / SV CLOSE U.P.
M	19.0 = M	19.0	CLOSE U.P. S6 / CICLE FINISHED
M	11.7 = M	11.7	RELEASE DUPLEX EXTRUSION HEAD

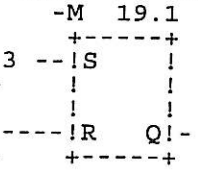
NETZWERK 10 0047 CLOSE UPPER PART STEP 6

>>>CICLE FINISHED



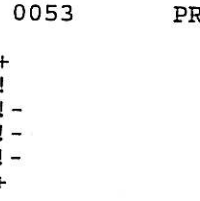
M	18.7 = M	18.7	CLOSE U.P. S5 / SV CLOSE U.P.
M	11.7 = M	11.7	RELEASE DUPLEX EXTRUSION HEAD
T	67 = T	67	CLOSE UPPER PART
M	19.0 = M	19.0	CLOSE U.P. S6 / CICLE FINISHED

NETZWERK 11 004C CLOSE UPPER PART CICLE MARK



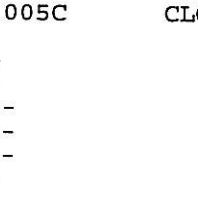
M	18.3 = M	18.3	CLOSE U.P. S1 / PROP.VALVE 180 BAR
M	19.1 = M	19.1	CLOSE U.P. CICLE MARK
M	19.0 = M	19.0	CLOSE U.P. S6 / CICLE FINISHED
M	11.7 = M	11.7	RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 12 0053 PRESSURE UP UPPER PART OPENED



M	18.4 = M	18.4	CLOSE U.P. S2 / SV OPEN U.P.
T	66 = T	66	PRESSURE UP UPPER PART OPENED

NETZWERK 13 005C CLOSE UPPER PART



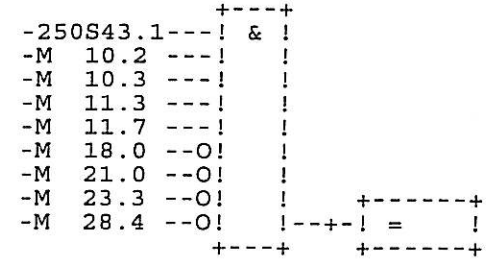
M	18.7 = M	18.7	CLOSE U.P. S5 / SV CLOSE U.P.
T	67 = T	67	CLOSE UPPER PART

NETZWERK 1 0000

```
*******************************************************************************
*                                                                             *
*                                LOCKING CYLINDER                             *
*                                                                             *
*******************************************************************************
```

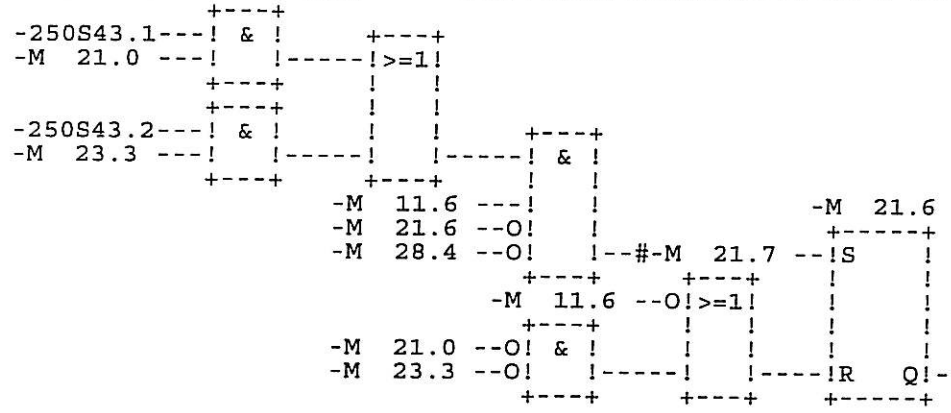
```
0000      :AWL
0001      :***
```

NETZWERK 2 0002 START CONDITION CLOSE LOCK.ZYL.




```
E   36.4 = 250S43.1                 SWITCH : CLOSE UPPER PART
M   10.2 = M  10.2                  MEDIUM PART CLOSED
M   10.3 = M  10.3                  UPPER PART CLOSED
M   11.3 = M  11.3                  RELEASE EXTRUSION HEAD PARTS
M   11.7 = M  11.7                  RELEASE DUPLEX EXTRUSION HEAD
M   18.0 = M  18.0                  LOCKING : OPEN UPPER PART
M   21.0 = M  21.0                  CLOSE L.C. CICLE MARK
M   23.3 = M  23.3                  OPEN LOCKING CYLINDER CICLE MARK
M   28.4 = M  28.4                  KEYSWITCH REBUILD HIGH PRESSURE
M   20.0 = M  20.0                  START CONDITION CLOSE LOCKING CYLINDER
```

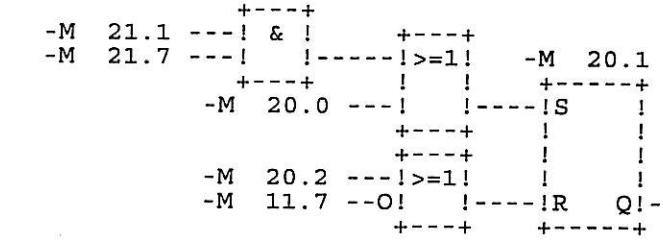
NETZWERK 3 000D MOVE LOCK.CYL.START AFTER E-STOP



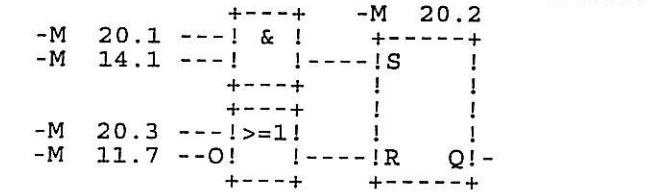

```
E   36.4 = 250S43.1                 SWITCH : CLOSE UPPER PART
M   21.0 = M  21.0                  CLOSE L.C. CICLE MARK
E   36.5 = 250S43.2                 SWITCH : OPEN UPPER PART
M   23.3 = M  23.3                  OPEN LOCKING CYLINDER CICLE MARK
M   11.6 = M  11.6                  NO FAULT DUPLEX EXTRUSION HEAD
M   21.6 = M  21.6                  HF MOVE L.C. START AFTER E-STOP
M   28.4 = M  28.4                  KEYSWITCH REBUILD HIGH PRESSURE
M   21.7 = M  21.7                  IMPULSE MOVE L.C. START AFTER E-STOP
```

NETZWERK 4 0021 CLOSE L.C. STEP 1 / 50 BAR

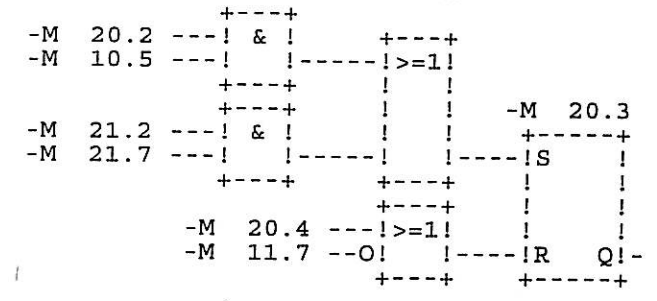
>>>PROPORTIONAL VALVE 50 BAR



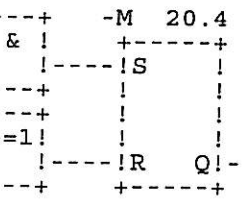

```
M   21.1 = M  21.1                    CLOSE L.C. PART 1 ACTIVE
M   21.7 = M  21.7                    IMPULSE MOVE L.C. START AFTER E-STOP
M   20.0 = M  20.0                    START CONDITION CLOSE LOCKING CYLINDER
M   20.1 = M  20.1                    CLOSE L.C. S1 / PROP.VALVE 180 BAR
M   20.2 = M  20.2                    CLOSE L.C. S2 / SV FORWARD LOCK.CYL.
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 5          002A      CLOSE L.C. STEP 2 / SV LC FORW.

>>>SV CLOSE MEDIUM PART   A 30.4
>>>SV CLOSE UPPER PART   A 30.6
>>>SV PUMP BUILD UP PRESSURE Q1   A 31.2
>>>SV LOCKING CYLINDER FORWARD   A 31.1
```




```
M   20.1 = M  20.1                    CLOSE L.C. S1 / PROP.VALVE 180 BAR
M   14.1 = M  14.1                    RELEASE SOLENOID VALVE  50 BAR
M   20.2 = M  20.2                    CLOSE L.C. S2 / SV FORWARD LOCK.CYL.
M   20.3 = M  20.3                    CLOSE L.C. S3 / PROP.VALVE 50 BAR
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 6          0032      CLOSE L.C. STEP 3 / 50 BAR

>>>PROPORTIONAL VALVE 50 BAR
```



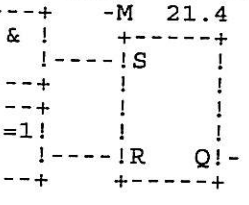

```
M   20.2 = M  20.2                    CLOSE L.C. S2 / SV FORWARD LOCK.CYL.
M   10.5 = M  10.5                    LOCKING CYLINDER MOVED OUT
M   21.2 = M  21.2                    CLOSE L.C. PART 2 ACTIVE
M   21.7 = M  21.7                    IMPULSE MOVE L.C. START AFTER E-STOP
M   20.3 = M  20.3                    CLOSE L.C. S3 / PROP.VALVE 50 BAR
M   20.4 = M  20.4                    CLOSE L.C. S4 / SV REVERSE LOCK.CYL.
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 7          003D      CLOSE L.C. STEP 4 / SV LC REVER.

>>>SV CLOSE MEDIUM PART   A 30.4
>>>SV CLOSE UPPER PART   A 30.6
>>>SV PUMP BUILD UP PRESSURE Q1   A 31.2
>>>SV LOCKING CYLINDER REVERSE   A 31.0
```




```
M   20.3 = M  20.3
M   14.1 = M  14.1
M   20.4 = M  20.4
M   21.4 = M  21.4
M   11.7 = M  11.7
```

CLOSE L.C. S3 / PROP.VALVE 50 BAR
RELEASE SOLENOID VALVE 50 BAR
CLOSE L.C. S4 / SV REVERSE LOCK.CYL.
CLOSE L.C. S4a / Q1 OFF
RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 8 0045 CLOSE L.C. STEP 4a

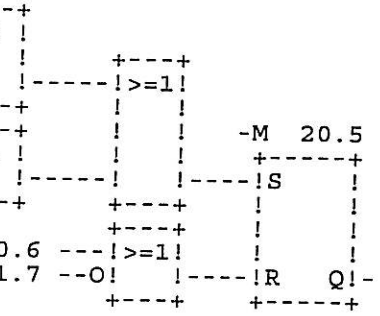



```
M   20.4 = M  20.4
M   10.4 = M  10.4
M   21.4 = M  21.4
M   20.5 = M  20.5
M   11.7 = M  11.7
```

CLOSE L.C. S4 / SV REVERSE LOCK.CYL.
LOCKING CYLINDER : LOCKING POSITION
CLOSE L.C. S4a / Q1 OFF
CLOSE L.C. S5 / PROP.VALVE 130 BAR
RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 9 004D CLOSE L.C STEP 5 / 130 BAR

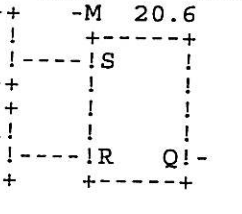
>>>PROPORTIONAL VALVE 130 BAR




```
M   21.4 = M  21.4
M   10.4 = M  10.4
A   31.2 = 253B3
M   21.3 = M  21.3
M   21.7 = M  21.7
M   20.5 = M  20.5
M   20.6 = M  20.6
M   11.7 = M  11.7
```

CLOSE L.C. S4a / Q1 OFF
LOCKING CYLINDER : LOCKING POSITION
SV OIL PUMP BUILD UP PRESSURE Q1
CLOSE L.C. PART 3 ACTIVE
IMPULSE MOVE L.C. START AFTER E-STOP
CLOSE L.C. S5 / PROP.VALVE 130 BAR
CLOSE L.C. S6 / HIGH PRESSURE BUILT UP
RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 10 0059 CLOSE L.C. STEP 6 / BUILD UP HP



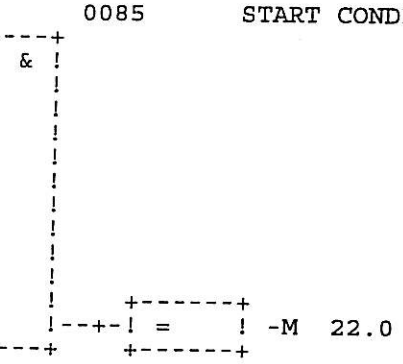

```
M   20.5 = M  20.5
M   14.3 = M  14.3
M   20.6 = M  20.6
M   20.7 = M  20.7
```

CLOSE L.C. S5 / PROP.VALVE 130 BAR
RELEASE SOLENOID VALVE 130 BAR
CLOSE L.C. S6 / HIGH PRESSURE BUILT UP
CLOSE L.C. S7 / CICLE FINISHED

```
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 11          0061      CLOSE L.C. STEP 7 / CICLE FINISH
                  +---+
 -248S35  ---! & !
 -M  11.7 ---!   !     +------+
 -M  20.6 ---!   !--+-! =    ! -M  20.7
                +---+    +------+

E   34.2 = 248S35                     LOCK.CYL. HIGH PRESS. BUILT UP : MAX. HP
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD
M   20.6 = M  20.6                    CLOSE L.C. S6 / HIGH PRESSURE BUILT UP
M   20.7 = M  20.7                    CLOSE L.C. S7 / CICLE FINISHED

NETZWERK 12          0066      CICLE MARK CLOSE LOCK.CYLINDER
             -M  21.0
              +-----+
 -M  20.1 --!S    !
            !     !
 -M  20.7 --!R   Q!-
            +-----+

M   20.1 = M  20.1                    CLOSE L.C. S1 / PROP.VALVE 180 BAR
M   21.0 = M  21.0                    CLOSE L.C. CICLE MARK
M   20.7 = M  20.7                    CLOSE L.C. S7 / CICLE FINISHED

NETZWERK 13          006C      CLOSE LOCK.CYL. PART 1 ACTIVE
             -M  21.1
              +-----+
 -M  20.1 --!S    !
            !     !
 -M  20.3 --!R   Q!-
            +-----+

M   20.1 = M  20.1                    CLOSE L.C. S1 / PROP.VALVE 180 BAR
M   21.1 = M  21.1                    CLOSE L.C. PART 1 ACTIVE
M   20.3 = M  20.3                    CLOSE L.C. S3 / PROP.VALVE 50 BAR

NETZWERK 14          0072      CLOSE LOCK.CYL. PART 2 ACTIVE
             -M  21.2
              +-----+
 -M  20.3 --!S    !
            !     !
 -M  21.4 --!R   Q!-
            +-----+

M   20.3 = M  20.3                    CLOSE L.C. S3 / PROP.VALVE 50 BAR
M   21.2 = M  21.2                    CLOSE L.C. PART 2 ACTIVE
M   21.4 = M  21.4                    CLOSE L.C. S4a / Q1 OFF

NETZWERK 15          0078      CLOSE LOCK.CYL. PART 3 ACTIVE
             -M  21.3
              +-----+
 -M  21.4 --!S    !
            !     !
 -M  20.7 --!R   Q!-
            +-----+

M   21.4 = M  21.4                    CLOSE L.C. S4a / Q1 OFF
M   21.3 = M  21.3                    CLOSE L.C. PART 3 ACTIVE
M   20.7 = M  20.7                    CLOSE L.C. S7 / CICLE FINISHED

NETZWERK 16          007E      M.P. / U.P. / Q1 / L.C. REVERSE
                       -M  21.5
                        +-----+
               -M  20.2 --!S    !
                +---+    !     !
 -M  21.4 ---!>=1!    !     !
 -M  11.7 --O!   !----!R   Q!-
                +---+    +-----+
```

```
M   20.2 = M  20.2                  CLOSE L.C. S2 / SV FORWARD LOCK.CYL.
M   21.5 = M  21.5                  M.P. / U.P. / Q1 (CICLE CLOSE L.C)
M   21.4 = M  21.4                  CLOSE L.C. S4a / Q1 OFF
M   11.7 = M  11.7                  RELEASE DUPLEX EXTRUSION HEAD
```

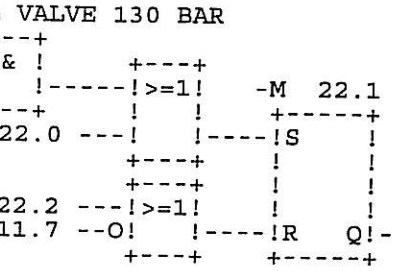
NETZWERK 17 0085 START CONDITION OPEN LOCK.CYL.




```
E   34.6 = 248S46                   CASSETTE MOUNTING DEVICE AT DEH
E   36.5 = 250S43.2                 SWITCH : OPEN UPPER PART
M   10.1 = M  10.1                  CLAMPING OPEN
M   10.2 = M  10.2                  MEDIUM PART CLOSED
M   10.3 = M  10.3                  UPPER PART CLOSED
M   10.4 = M  10.4                  LOCKING CYLINDER : LOCKING POSITION
M   11.0 = M  11.0                  EJECTING DEVICE OPEN
M   11.1 = M  11.1                  CASSETTE INSTALLED
M   11.7 = M  11.7                  RELEASE DUPLEX EXTRUSION HEAD
M   21.0 = M  21.0                  CLOSE L.C. CICLE MARK
M   23.3 = M  23.3                  OPEN LOCKING CYLINDER CICLE MARK
M   28.4 = M  28.4                  KEYSWITCH REBUILD HIGH PRESSURE
M   22.0 = M  22.0                  START CONDITION OPEN LOCKING CYLINDER
```

NETZWERK 18 0093 OPEN L.C. STEP 1 / 130 BAR

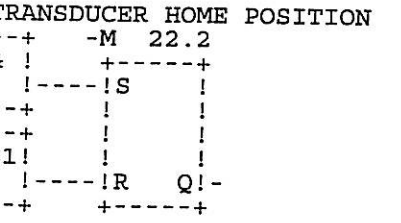
>>>PROPORTIONAL VALVE 130 BAR




```
M   21.7 = M  21.7                  IMPULSE MOVE L.C. START AFTER E-STOP
M   23.4 = M  23.4                  OPEN L.C. PART 1 ACTIVE
M   22.0 = M  22.0                  START CONDITION OPEN LOCKING CYLINDER
M   22.1 = M  22.1                  OPEN L.C. S1 / PROP.VALVE 130 BAR
M   22.2 = M  22.2                  OPEN L.C. S2 / PR.TRANSDUCER HOME POS.
M   11.7 = M  11.7                  RELEASE DUPLEX EXTRUSION HEAD
```

NETZWERK 19 009C OPEN L.C. STEP 2 / P.T.HOME POS.

>>>SV PRESSURE TRANSDUCER HOME POSITION A 31.4

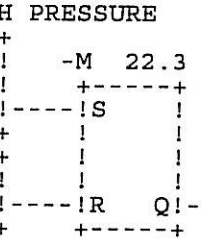



```
M   22.1 = M  22.1                  OPEN L.C. S1 / PROP.VALVE 130 BAR
M   14.3 = M  14.3                  RELEASE SOLENOID VALVE 130 BAR
M   22.2 = M  22.2                  OPEN L.C. S2 / PR.TRANSDUCER HOME POS.
```

```
M   22.3 = M  22.3                    OPEN L.C. S3 / REBUILT HIGH PRESSURE
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD
```

NETZWERK 20 00A4 OPEN L.C. STEP 3 / REBUILD H.P.

>>>SV REBUILD HIGH PRESSURE A 31.5



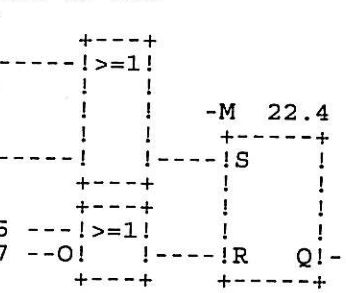

```
M   22.2 = M  22.2                    OPEN L.C. S2 / PR.TRANSDUCER HOME POS.
M   14.3 = M  14.3                    RELEASE SOLENOID VALVE 130 BAR
E   37.0 = E37.0                      251 PRESSURE TRANSDUCER IN HOME POSITION
M   22.3 = M  22.3                    OPEN L.C. S3 / REBUILT HIGH PRESSURE
M   22.4 = M  22.4                    OPEN L.C. S4 / PROP.VALVE 50 BAR
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD
```

NETZWERK 21 00AD TIME REBUILD HIGH PRESSURE

```
M   22.3 = M  22.3                    OPEN L.C. S3 / REBUILT HIGH PRESSURE
T   93   = T  93                     BUILD UP HIGH PRESSURE / OPEN LOCK.CYL.
```

NETZWERK 22 00B6 OPEN L.C. STEP 4 / 50 BAR

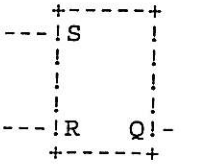
>>>PROPORTIONAL VALVE 50 BAR




```
M   22.3 = M  22.3                    OPEN L.C. S3 / REBUILT HIGH PRESSURE
T   93   = T  93                     BUILD UP HIGH PRESSURE / OPEN LOCK.CYL.
M   21.7 = M  21.7                    IMPULSE MOVE L.C. START AFTER E-STOP
M   23.5 = M  23.5                    OPEN L.C. PART 2 ACTIVE
M   22.4 = M  22.4                    OPEN L.C. S4 / PROP.VALVE 50 BAR
M   22.5 = M  22.5                    OPEN L.C. S5 / SV FORWARD L.C.
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD
```

NETZWERK 23 00C1 OPEN L.C. STEP 5 / L.C. FORWARD

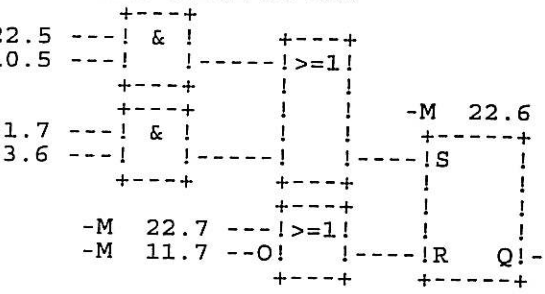
>>>SV CLOSE MEDIUM PART A 30.4
>>>SV CLOSE UPPER PART A 30.6
>>>SV PUMP BUILD UP PRESSURE Q1 A 31.2
>>>SV LOCKING CYLINDER FORWARD A 31.1



```
M   22.4 = M  22.4          OPEN L.C. S4 / PROP.VALVE 50 BAR
M   14.1 = M  14.1          RELEASE SOLENOID VALVE  50 BAR
M   22.5 = M  22.5          OPEN L.C. S5 / SV FORWARD L.C.
M   22.6 = M  22.6          OPEN L.C. S6 / PROP.VALVE 50 BAR
M   11.7 = M  11.7          RELEASE DUPLEX EXTRUSION HEAD
```

NETZWERK 24 00C9 OPEN L.C. STEP 6 / 50 BAR

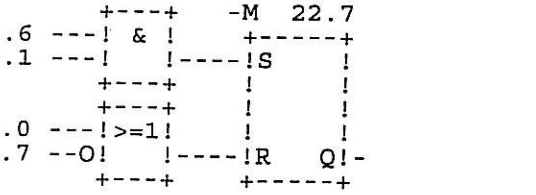
>>>PROPORTIONAL VALVE 50 BAR




```
M   22.5 = M  22.5          OPEN L.C. S5 / SV FORWARD L.C.
M   10.5 = M  10.5          LOCKING CYLINDER MOVED OUT
M   21.7 = M  21.7          IMPULSE MOVE L.C. START AFTER E-STOP
M   23.6 = M  23.6          OPEN L.C. PART 3 ACTIVE
M   22.6 = M  22.6          OPEN L.C. S6 / PROP.VALVE 50 BAR
M   22.7 = M  22.7          OPEN L.C. S7 / SV REVERSE L.C.
M   11.7 = M  11.7          RELEASE DUPLEX EXTRUSION HEAD
```

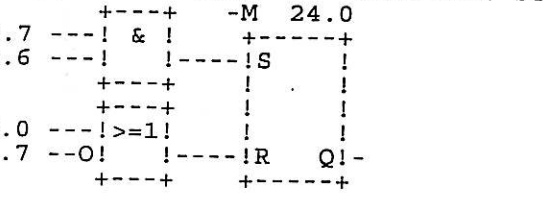
NETZWERK 25 00D4 OPEN L.C. STEP 7 / L.C. REVERSE

>>>SV CLOSE MEDIUM PART A 30.4
>>>SV CLOSE UPPER PART A 30.6
>>>SV PUMP BUILD UP PRESSURE Q1 A 31.2
>>>SV LOCKING CYLINDER REVERSE A 31.0




```
M   22.6 = M  22.6          OPEN L.C. S6 / PROP.VALVE 50 BAR
M   14.1 = M  14.1          RELEASE SOLENOID VALVE  50 BAR
M   22.7 = M  22.7          OPEN L.C. S7 / SV REVERSE L.C.
M   24.0 = M  24.0          OPEN L.C. STEP S7a / Q1 OFF
M   11.7 = M  11.7          RELEASE DUPLEX EXTRUSION HEAD
```

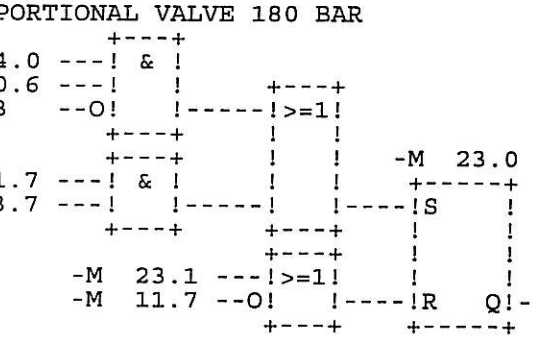
NETZWERK 26 00DC OPEN L.C. STEP 7a




```
M   22.7 = M  22.7          OPEN L.C. S7 / SV REVERSE L.C.
M   10.6 = M  10.6          LOCKING CYLINDER HOME POSITION
M   24.0 = M  24.0          OPEN L.C. STEP S7a / Q1 OFF
M   23.0 = M  23.0          OPEN L.C. S8 / PROP.VALVE 180 BAR
M   11.7 = M  11.7          RELEASE DUPLEX EXTRUSION HEAD
```

NETZWERK 27 00E4 OPEN L.C. STEP 8 / 180 BAR

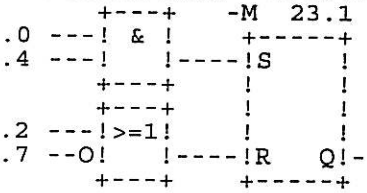
>>>PROPORTIONAL VALVE 180 BAR



M	24.0 = M 24.0		OPEN L.C. STEP S7a / Q1 OFF
M	10.6 = M 10.6		LOCKING CYLINDER HOME POSITION
A	31.2 = 253B3		SV OIL PUMP BUILD UP PRESSURE Q1
M	21.7 = M 21.7		IMPULSE MOVE L.C. START AFTER E-STOP
M	23.7 = M 23.7		OPEN L.C. PART 4 ACTIVE
M	23.0 = M 23.0		OPEN L.C. S8 / PROP.VALVE 180 BAR
M	23.1 = M 23.1		OPEN L.C. S9 / SV OPEN UPPER PART
M	11.7 = M 11.7		RELEASE DUPLEX EXTRUSION HEAD

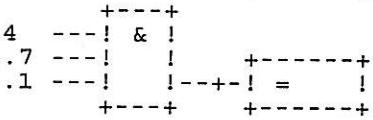
NETZWERK 28 00F0 OPEN L.C. STEP 9 / OPEN U.P.

>>>SV OPEN UPPER PART A 30.6



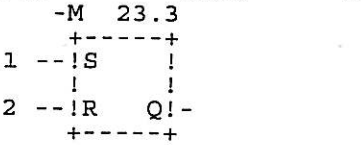
M	23.0 = M 23.0		OPEN L.C. S8 / PROP.VALVE 180 BAR
M	14.4 = M 14.4		RELEASE SOLENOID VALVE 180 BAR
M	23.1 = M 23.1		OPEN L.C. S9 / SV OPEN UPPER PART
M	23.2 = M 23.2		OPEN L.C. S10 / CICLE FINISHED
M	11.7 = M 11.7		RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 29 00F8 OPEN L.C. STEP 10 / CICLE FINISH



E	31.5 = 245S14		PROX.SWITCH UPPER PART OPEN
M	11.7 = M 11.7		RELEASE DUPLEX EXTRUSION HEAD
M	23.1 = M 23.1		OPEN L.C. S9 / SV OPEN UPPER PART
M	23.2 = M 23.2		OPEN L.C. S10 / CICLE FINISHED

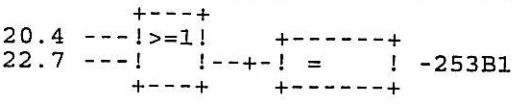
NETZWERK 30 00FD CICLE MARK OPEN LOCK.CYLINDER



M	22.1 = M 22.1		OPEN L.C. S1 / PROP.VALVE 130 BAR
M	23.3 = M 23.3		OPEN LOCKING CYLINDER CICLE MARK
M	23.2 = M 23.2		OPEN L.C. S10 / CICLE FINISHED

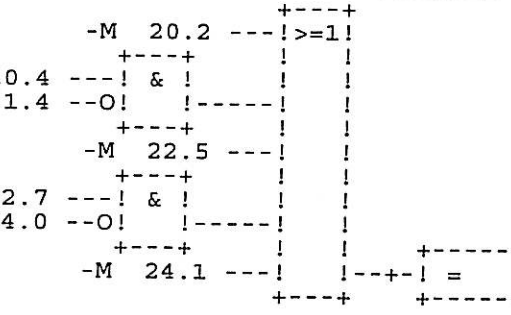
```
NETZWERK 31          0103      OPEN LOCK.CYL. PART 1 ACTIVE
              -M  23.4
               +-----+
 -M  22.1 --!S     !
            !      !
 -M  22.4 --!R    Q!-
            +-----+

M   22.1 = M  22.1                  OPEN L.C. S1 / PROP.VALVE 130 BAR
M   23.4 = M  23.4                  OPEN L.C. PART 1 ACTIVE
M   22.4 = M  22.4                  OPEN L.C. S4 / PROP.VALVE 50 BAR

NETZWERK 32          0109      OPEN LOCK.CYL. PART 2 ACTIVE
              -M  23.5
               +-----+
 -M  22.4 --!S     !
            !      !
 -M  22.6 --!R    Q!-
            +-----+

M   22.4 = M  22.4                  OPEN L.C. S4 / PROP.VALVE 50 BAR
M   23.5 = M  23.5                  OPEN L.C. PART 2 ACTIVE
M   22.6 = M  22.6                  OPEN L.C. S6 / PROP.VALVE 50 BAR

NETZWERK 33          010F      OPEN LOCK.CYL. PART 3 ACTIVE
              -M  23.6
               +-----+
 -M  22.6 --!S     !
            !      !
 -M  24.0 --!R    Q!-
            +-----+

M   22.6 = M  22.6                  OPEN L.C. S6 / PROP.VALVE 50 BAR
M   23.6 = M  23.6                  OPEN L.C. PART 3 ACTIVE
M   24.0 = M  24.0                  OPEN L.C. STEP S7a / Q1 OFF

NETZWERK 34          0115      OPEN LOCK.CYL. PART 4 ACTIVE
              -M  23.7
               +-----+
 -M  24.0 --!S     !
            !      !
 -M  23.2 --!R    Q!-
            +-----+

M   24.0 = M  24.0                  OPEN L.C. STEP S7a / Q1 OFF
M   23.7 = M  23.7                  OPEN L.C. PART 4 ACTIVE
M   23.2 = M  23.2                  OPEN L.C. S10 / CICLE FINISHED

NETZWERK 35          011B      M.P. / U.P. / Q1 / OPEN L.C
                      -M  24.1
                       +-----+
             -M  22.5 --!S     !
              +---+     !      !
 -M  24.0 ---!>=1!      !      !
 -M  11.7 --O!   !------!R    Q!-
              +---+     +------+

M   22.5 = M  22.5                  OPEN L.C. S5 / SV FORWARD L.C.
M   24.1 = M  24.1                  M.P. / U.P. / Q1 (CICLE OPEN L.C.)
M   24.0 = M  24.0                  OPEN L.C. STEP S7a / Q1 OFF
M   11.7 = M  11.7                  RELEASE DUPLEX EXTRUSION HEAD

NETZWERK 36          0122      SOLENOID VALVE LOCK.CYL. FORWARD
              +---+
 -M  20.2 ---!>=1!     +------+
 -M  22.5 ---!   !--+-! =    ! -253B2
              +---+     +------+

M   20.2 = M  20.2                  CLOSE L.C. S2 / SV FORWARD LOCK.CYL.
M   22.5 = M  22.5                  OPEN L.C. S5 / SV FORWARD L.C.
A   31.1 = 253B2                    SV MOVE LOCKING CYLINDER FORWARD
```

NETZWERK 37 0126 SOLENOID VALVE LOCK.CYL. REVERSE



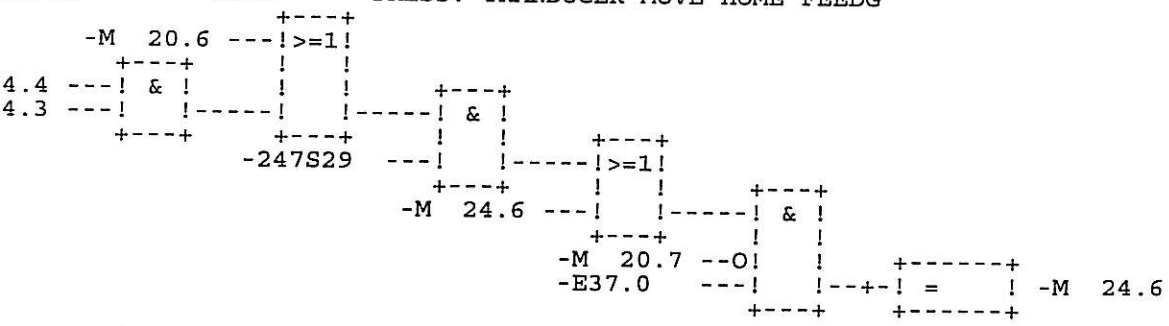
M	20.4 = M 20.4	CLOSE L.C. S4 / SV REVERSE LOCK.CYL.
M	22.7 = M 22.7	OPEN L.C. S7 / SV REVERSE L.C.
A	31.0 = 253B1	SV MOVE LOCKING CYLINDER REVERSE

NETZWERK 38 012A SOLENOID VALVE PUMP Q1



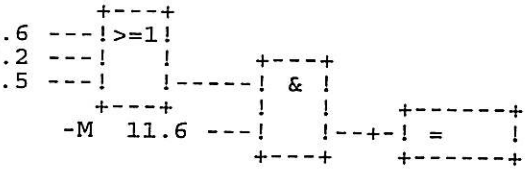
M	20.2 = M 20.2	CLOSE L.C. S2 / SV FORWARD LOCK.CYL.
M	20.4 = M 20.4	CLOSE L.C. S4 / SV REVERSE LOCK.CYL.
M	21.4 = M 21.4	CLOSE L.C. S4a / Q1 OFF
M	22.5 = M 22.5	OPEN L.C. S5 / SV FORWARD L.C.
M	22.7 = M 22.7	OPEN L.C. S7 / SV REVERSE L.C.
M	24.0 = M 24.0	OPEN L.C. STEP S7a / Q1 OFF
M	24.1 = M 24.1	M.P. / U.P. / Q1 (CICLE OPEN L.C.)
A	31.2 = 253B3	SV OIL PUMP BUILD UP PRESSURE Q1

NETZWERK 39 0135 PRESS. TRANDUCER MOVE HOME FEEDG



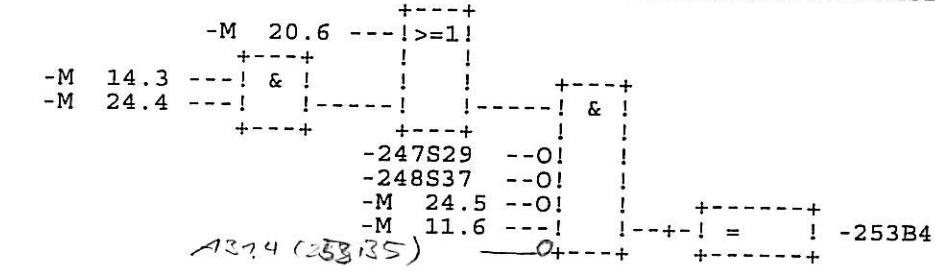
M	20.6 = M 20.6	CLOSE L.C. S6 / HIGH PRESSURE BUILT UP
M	24.4 = M 24.4	PRESSURE FEEDING LOCK.CYLINDER ACTIVE
M	14.3 = M 14.3	RELEASE SOLENOID VALVE 130 BAR
E	33.4 = 247S29	PROX.SWITCH PRESS.TRANSDUCER MOVED OUT
M	24.6 = M 24.6	PRESSURE TRANSDUCER MOVE HOME BY FEEDING
M	20.7 = M 20.7	CLOSE L.C. S7 / CICLE FINISHED
E	37.0 = E37.0	251 PRESSURE TRANSDUCER IN HOME POSITION

NETZWERK 40 0143 SV PRESSURE TRANSDUCER MOVE HOME



M	24.6 = M 24.6	PRESSURE TRANSDUCER MOVE HOME BY FEEDING
M	22.2 = M 22.2	OPEN L.C. S2 / PR.TRANSDUCER HOME POS.
M	28.5 = M 28.5	PRESSURE TRANSDUCER HOMEPOSITION
M	11.6 = M 11.6	NO FAULT DUPLEX EXTRUSION HEAD
A	31.4 = 253B5	SV PRESSURE TRANSDUCER HOME POSITION

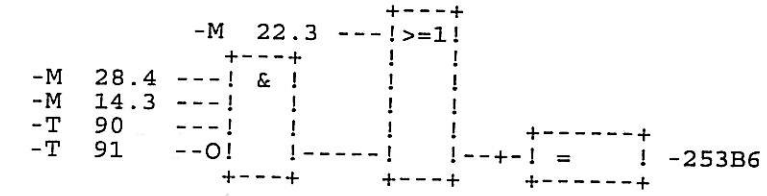
NETZWERK 41 014B SV PRESS.TRANSDUCER HI.PRESS.ON



A31.4 (253B5)

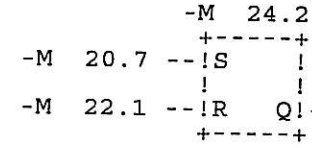
M	20.6 = M 20.6	CLOSE L.C. S6 / HIGH PRESSURE BUILT UP
M	14.3 = M 14.3	RELEASE SOLENOID VALVE 130 BAR
M	24.4 = M 24.4	PRESSURE FEEDING LOCK.CYLINDER ACTIVE
E	33.4 = 247S29	PROX.SWITCH PRESS.TRANSDUCER MOVED OUT
E	34.4 = 248S37	LOCK.CYL. HIGH PRESS. PASSED OVER MAX
M	24.5 = M 24.5	TIMECONTROL PR.FEED. L.C. TERMINATED
M	11.6 = M 11.6	NO FAULT DUPLEX EXTRUSION HEAD
A	31.3 = 253B4	SV PRESSURE TRANSDUCER HIGH PRESSURE ON
A	31.4 = 253B5	

NETZWERK 42 0157 SOLENOID VALVE REBUILD HI.PRESS.



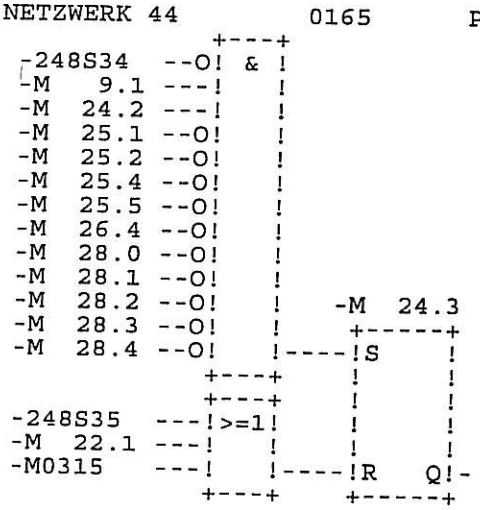
M	22.3 = M 22.3	OPEN L.C. S3 / REBUILT HIGH PRESSURE
M	28.4 = M 28.4	KEYSWITCH REBUILD HIGH PRESSURE
M	14.3 = M 14.3	RELEASE SOLENOID VALVE 130 BAR
T	90 = T 90	TIME PRESSURE TRANS. HOMEPOSITION
T	91 = T 91	TIME REBUILD HIGH PRESSURE
A	31.5 = 253B6	SV LOCKING CYLINDER REBUILT HIGH PRESS.

NETZWERK 43 015F PRESSURE FEEDING LOCK.CYL. ON



M	20.7 = M 20.7	CLOSE L.C. S7 / CICLE FINISHED
M	24.2 = M 24.2	PRESSURE FEEDING LOCKING CYLINDER ON
M	22.1 = M 22.1	OPEN L.C. S1 / PROP.VALVE 130 BAR

NETZWERK 44 0165 PRESSURE FEEDING LOCK.CYL. ON

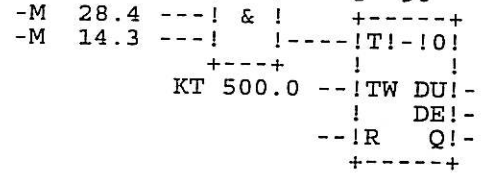


```
E   34.1 = 248S34                    LOCK.CYL. HIGH PRESS. BUILT UP : MIN. HP
M    9.1 = M   9.1                   CONTROL VOLTAGE IS ON
M   24.2 = M  24.2                   PRESSURE FEEDING LOCKING CYLINDER ON
M   25.1 = M  25.1                   OPEN CLAMPING
M   25.2 = M  25.2                   CLOSE CLAMPING
M   25.4 = M  25.4                   PRESS OUT CASSETTE
M   25.5 = M  25.5                   INSTALL CASSETTE
M   26.4 = M  26.4                   PRESSURE FEEDING CLAMPING ACTIVE
M   28.0 = M  28.0                   LIFT CASSETTE MOUNTING DEVICE
M   28.1 = M  28.1                   LOWER CASSETTE MOUNTING DEVICE
M   28.2 = M  28.2                   SLIP-IN CASSETTE
M   28.3 = M  28.3                   REVERSE SLIP-IN DEVICE
M   28.4 = M  28.4                   KEYSWITCH REBUILD HIGH PRESSURE
M   24.3 = M  24.3                   HF PRESSURE FEED. LOCK.CYLINDER ON
E   34.2 = 248S35                    LOCK.CYL. HIGH PRESS. BUILT UP : MAX. HP
M   22.1 = M  22.1                   OPEN L.C. S1 / PROP.VALVE 130 BAR
M  187.6 = M0315                     TIME PRESSURE FEEDING LOCK.CYLINDER  DEH

NETZWERK 45          0179       PRESS.FEEDING LOCK.CYL. ACTIVE
              +---+
 -250S44.2--O! & !
 -M  11.6 ---!   !
 -M  22.0 --O!   !    +------+
 -M  24.3 ---!   !--+-! =    ! -M  24.4
              +---+    +------+

E   36.7 = 250S44.2                  SWITCH : OPEN MEDIUM PART
M   11.6 = M  11.6                   NO FAULT DUPLEX EXTRUSION HEAD
M   22.0 = M  22.0                   START CONDITION OPEN LOCKING CYLINDER
M   24.3 = M  24.3                   HF PRESSURE FEED. LOCK.CYLINDER ON
M   24.4 = M  24.4                   PRESSURE FEEDING LOCK.CYLINDER ACTIVE

NETZWERK 46          017F       FAULT : TIME PRESSURE FEEDING
            -T  38
             +-----+
 -M  24.4 --!T!-!0!
 KT 300.1 --!TW DU!-
             !   DE!-
             !     !  -M0315
             !     !   +-----+
           --!R   Q!---!S    !
             +-----+   !     !
            -205S3.2 --!R   Q!-
                       +-----+

M   24.4 = M  24.4                   PRESSURE FEEDING LOCK.CYLINDER ACTIVE
T   38   = T  38                     TIME PRESSURE FEEDING CLAMP
M  187.6 = M0315                     TIME PRESSURE FEEDING LOCK.CYLINDER  DEH
E   84.3 = 205S3.2                   ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)

NETZWERK 47          018C       KEYSWITCH REBUILD HIGH PRESSURE
             +---+
 -204S4   ---! & !
 -M  24.2 ---!   !
 -M  24.4 --O!   !
 -M  25.1 --O!   !
 -M  25.2 --O!   !
 -M  25.4 --O!   !
 -M  26.4 --O!   !
 -M  28.0 --O!   !
 -M  28.1 --O!   !
 -M  28.2 --O!   !
 -M  28.3 --O!   !
 -M  28.4 --O!   !
 -M   9.1 ---!   !   -M  28.4
 -M  10.2 ---!   !    +-----+
 -M  10.3 ---!   !----!S    !
             +---+    !     !
           -204S4   -O!R   Q!-
                      +-----+
```

```
E   83.3 = 204S4
M   24.2 = M  24.2
M   24.4 = M  24.4
M   25.1 = M  25.1
M   25.2 = M  25.2
M   25.4 = M  25.4
M   26.4 = M  26.4
M   28.0 = M  28.0
M   28.1 = M  28.1
M   28.2 = M  28.2
M   28.3 = M  28.3
M   28.4 = M  28.4
M    9.1 = M   9.1
M   10.2 = M  10.2
M   10.3 = M  10.3
```

REBUILD HIGH PRESS. (MAIN CONTR.PAN.)
PRESSURE FEEDING LOCKING CYLINDER ON
PRESSURE FEEDING LOCK.CYLINDER ACTIVE
OPEN CLAMPING
CLOSE CLAMPING
PRESS OUT CASSETTE
PRESSURE FEEDING CLAMPING ACTIVE
LIFT CASSETTE MOUNTING DEVICE
LOWER CASSETTE MOUNTING DEVICE
SLIP-IN CASSETTE
REVERSE SLIP-IN DEVICE
KEYSWITCH REBUILD HIGH PRESSURE
CONTROL VOLTAGE IS ON
MEDIUM PART CLOSED
UPPER PART CLOSED

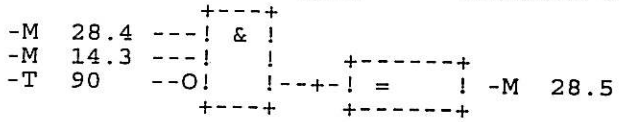
NETZWERK 48 01A0 TIME FOR PRESSURE TRANSDUCER




```
M   28.4 = M  28.4
M   14.3 = M  14.3
T   90   = T  90
```

KEYSWITCH REBUILD HIGH PRESSURE
RELEASE SOLENOID VALVE 130 BAR
TIME PRESSURE TRANS. HOMEPOSITION

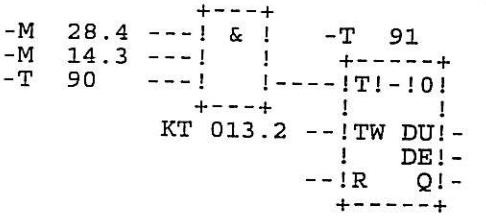
NETZWERK 49 01AA PRESSURE TRANSDUCER HOMEPOSITION




```
M   28.4 = M  28.4
M   14.3 = M  14.3
T   90   = T  90
M   28.5 = M  28.5
```

KEYSWITCH REBUILD HIGH PRESSURE
RELEASE SOLENOID VALVE 130 BAR
TIME PRESSURE TRANS. HOMEPOSITION
PRESSURE TRANSDUCER HOMEPOSITION

NETZWERK 50 01AF TIME REBUILD HIGH PRESSURE




```
M   28.4 = M  28.4
M   14.3 = M  14.3
T   90   = T  90
T   91   = T  91
```

KEYSWITCH REBUILD HIGH PRESSURE
RELEASE SOLENOID VALVE 130 BAR
TIME PRESSURE TRANS. HOMEPOSITION
TIME REBUILD HIGH PRESSURE

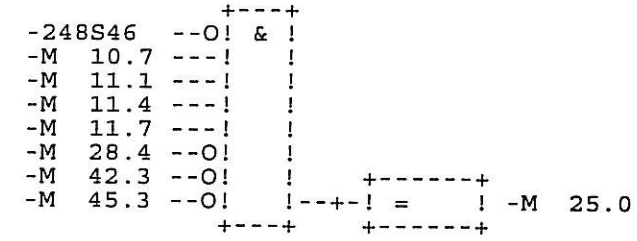
```
NETZWERK 51        01BA
01BA       :AWL
01BB       :BE
```

NETZWERK 1 0000

```
*******************************************************************************
*                                                                             *
*                              CLAMPING AND CASSETTE                          *
*                                                                             *
*******************************************************************************
```

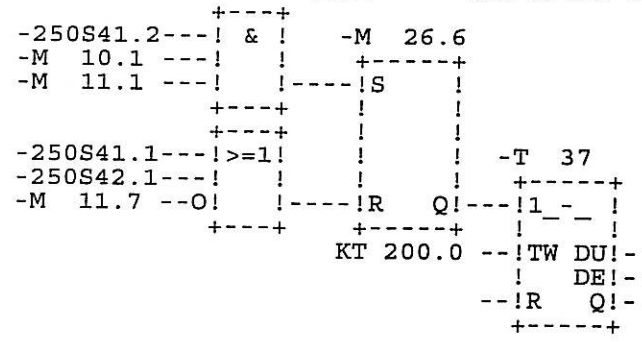
0000 :***

NETZWERK 2 0001 LOCKING : CLAMPING



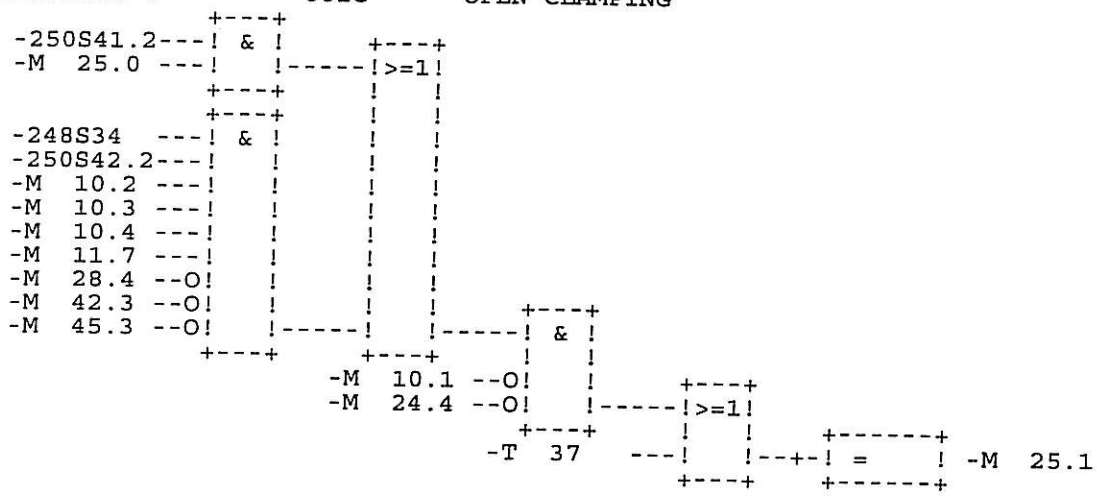
E	34.6 = 248S46		CASSETTE MOUNTING DEVICE AT DEH
M	10.7 = M 10.7		EJECTING DEVICE CLOSED
M	11.1 = M 11.1		CASSETTE INSTALLED
M	11.4 = M 11.4		RELEASE CLAMPING
M	11.7 = M 11.7		RELEASE DUPLEX EXTRUSION HEAD
M	28.4 = M 28.4		KEYSWITCH REBUILD HIGH PRESSURE
M	42.3 = M 42.3		UP.EXTR. : CONDITION REVERSE SET
M	45.3 = M 45.3		BOT.EXTR. : CONDITION REVERSE SET
M	25.0 = M 25.0		LOCKING : CLAMPING

NETZWERK 3 000B RUN AFTER TIME OPEN CLAMPING



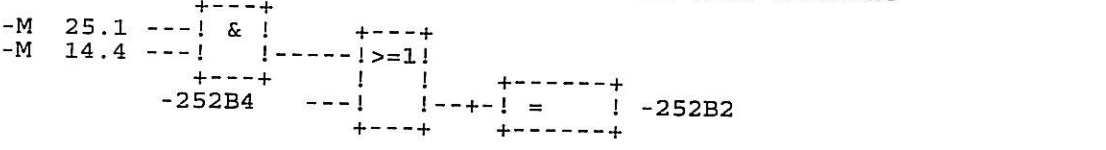
E	36.1 = 250S41.2		SWITCH : OPEN CLAMPING
M	10.1 = M 10.1		CLAMPING OPEN
M	11.1 = M 11.1		CASSETTE INSTALLED
M	26.6 = M 26.6		RUN AFTER TIME OPEN CLAMPS
E	36.0 = 250S41.1		SWITCH : CLOSE CLAMPING
E	36.2 = 250S42.1		SWITCH : CLOSE CLAMP.FOR FINAL DIE CHANG
M	11.7 = M 11.7		RELEASE DUPLEX EXTRUSION HEAD
T	37 = T 37		TIME PRESSURE FEEDING LOCKING CYLINDER

NETZWERK 4 001C OPEN CLAMPING



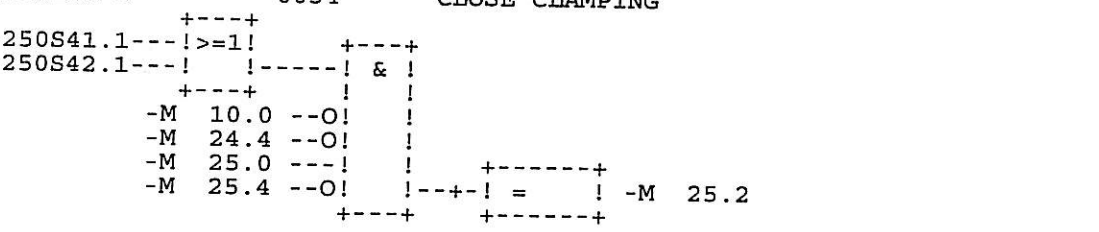
E	36.1 = 250S41.2	SWITCH : OPEN CLAMPING
M	25.0 = M 25.0	LOCKING : CLAMPING
E	34.1 = 248S34	LOCK.CYL. HIGH PRESS. BUILT UP : MIN. HP
E	36.3 = 250S42.2	SWITCH : OPEN CLAMP.FOR FINAL DIE CHANGE
M	10.2 = M 10.2	MEDIUM PART CLOSED
M	10.3 = M 10.3	UPPER PART CLOSED
M	10.4 = M 10.4	LOCKING CYLINDER : LOCKING POSITION
M	11.7 = M 11.7	RELEASE DUPLEX EXTRUSION HEAD
M	28.4 = M 28.4	KEYSWITCH REBUILD HIGH PRESSURE
M	42.3 = M 42.3	UP.EXTR. : CONDITION REVERSE SET
M	45.3 = M 45.3	BOT.EXTR. : CONDITION REVERSE SET
M	10.1 = M 10.1	CLAMPING OPEN
M	24.4 = M 24.4	PRESSURE FEEDING LOCK.CYLINDER ACTIVE
T	37 = T 37	TIME PRESSURE FEEDING LOCKING CYLINDER
M	25.1 = M 25.1	OPEN CLAMPING

NETZWERK 5 002F SOLENOID VALVE OPEN CLAMPING



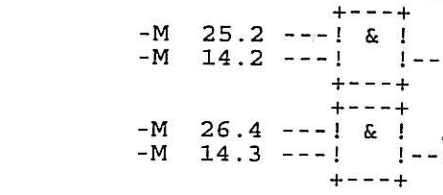
M	25.1 = M 25.1	OPEN CLAMPING
M	14.4 = M 14.4	RELEASE SOLENOID VALVE 180 BAR
A	30.3 = 252B4	SV EJECTING DEVICE : PRESS OUT CASSETTE
A	30.1 = 252B2	SV OPEN CLAMPING

NETZWERK 6 0034 CLOSE CLAMPING



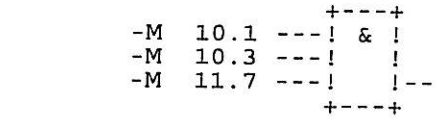
E	36.0 = 250S41.1	SWITCH : CLOSE CLAMPING
E	36.2 = 250S42.1	SWITCH : CLOSE CLAMP.FOR FINAL DIE CHANG
M	10.0 = M 10.0	CLAMPING CLOSED
M	24.4 = M 24.4	PRESSURE FEEDING LOCK.CYLINDER ACTIVE
M	25.0 = M 25.0	LOCKING : CLAMPING
M	25.4 = M 25.4	PRESS OUT CASSETTE
M	25.2 = M 25.2	CLOSE CLAMPING

NETZWERK 7 003E SOLENOID VALVE CLOSE CLAMPING



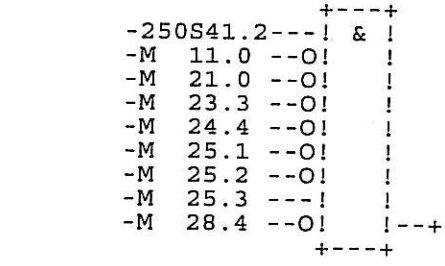
M 25.2 = M 25.2		CLOSE CLAMPING
M 14.2 = M 14.2		RELEASE SOLENOID VALVE 120 BAR
M 26.4 = M 26.4		PRESSURE FEEDING CLAMPING ACTIVE
M 14.3 = M 14.3		RELEASE SOLENOID VALVE 130 BAR
A 30.0 = 252B1		SV CLOSE CLAMPING

NETZWERK 8 0045 LOCKING : CASSETTE



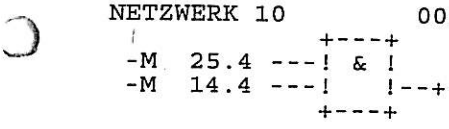
M 10.1 = M 10.1		CLAMPING OPEN
M 10.3 = M 10.3		UPPER PART CLOSED
M 11.7 = M 11.7		RELEASE DUPLEX EXTRUSION HEAD
M 25.3 = M 25.3		LOCKING : CASSETTE

NETZWERK 9 004A EXTEND CASSETTE



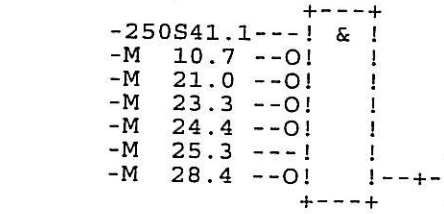
E 36.1 = 250S41.2		SWITCH : OPEN CLAMPING
M 11.0 = M 11.0		EJECTING DEVICE OPEN
M 21.0 = M 21.0		CLOSE L.C. CICLE MARK
M 23.3 = M 23.3		OPEN LOCKING CYLINDER CICLE MARK
M 24.4 = M 24.4		PRESSURE FEEDING LOCK.CYLINDER ACTIVE
M 25.1 = M 25.1		OPEN CLAMPING
M 25.2 = M 25.2		CLOSE CLAMPING
M 25.3 = M 25.3		LOCKING : CASSETTE
M 28.4 = M 28.4		KEYSWITCH REBUILD HIGH PRESSURE
M 25.4 = M 25.4		PRESS OUT CASSETTE

NETZWERK 10 0055 SV EJECT.DEV.:PRESS OUT CASSETTE



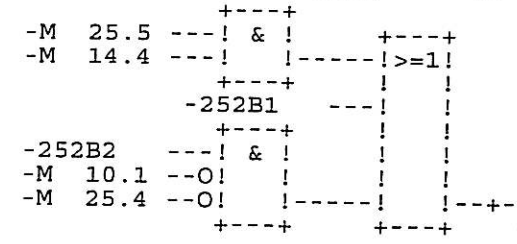
M 25.4 = M 25.4		PRESS OUT CASSETTE
M 14.4 = M 14.4		RELEASE SOLENOID VALVE 180 BAR
A 30.3 = 252B4		SV EJECTING DEVICE : PRESS OUT CASSETTE

NETZWERK 11 0059 EJECTING DEVICE:INSTALL CASSETTE



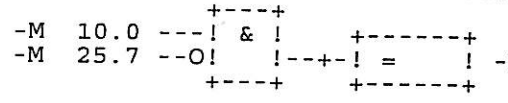
```
E   36.0 = 250S41.1          SWITCH : CLOSE CLAMPING
M   10.7 = M  10.7           EJECTING DEVICE CLOSED
M   21.0 = M  21.0           CLOSE L.C. CICLE MARK
M   23.3 = M  23.3           OPEN LOCKING CYLINDER CICLE MARK
M   24.4 = M  24.4           PRESSURE FEEDING LOCK.CYLINDER ACTIVE
M   25.3 = M  25.3           LOCKING : CASSETTE
M   28.4 = M  28.4           KEYSWITCH REBUILD HIGH PRESSURE
M   25.5 = M  25.5           INSTALL CASSETTE
```

NETZWERK 12 0062 SV EJECT.DEV.:INSTALL CASSETTE



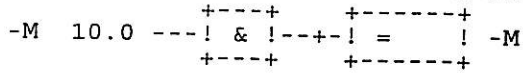

```
M   25.5 = M  25.5           INSTALL CASSETTE
M   14.4 = M  14.4           RELEASE SOLENOID VALVE 180 BAR
A   30.0 = 252B1             SV CLOSE CLAMPING
A   30.1 = 252B2             SV OPEN CLAMPING
M   10.1 = M  10.1           CLAMPING OPEN
M   25.4 = M  25.4           PRESS OUT CASSETTE
A   30.2 = 252B3             SV EJECTING DEVICE : PRESS IN CASSETTE
```

NETZWERK 13 006B POS.FL. PRESS.FEED. CLAMPING ON



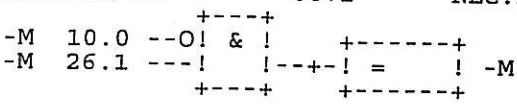

```
M   10.0 = M  10.0           CLAMPING CLOSED
M   25.7 = M  25.7           HF POS.FLANK PRESSURE FEED.CLAMPING ON
M   25.6 = M  25.6           IMPULSE POS.FLANK PRESS.FEED.CLAMPING ON
```

NETZWERK 14 006F H-MARK FLANK EVALUATION CLAMP.ON



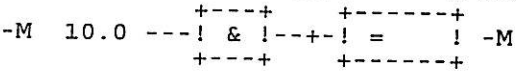

```
M   10.0 = M  10.0           CLAMPING CLOSED
M   25.7 = M  25.7           HF POS.FLANK PRESSURE FEED.CLAMPING ON
```

NETZWERK 15 0072 NEG.FLANK PRESS.FEED.CLAMPING ON



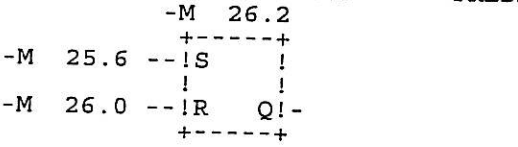

```
M   10.0 = M  10.0           CLAMPING CLOSED
M   26.1 = M  26.1           HF NEG.FLANK PRESSURE FEED.CLAMPING OFF
M   26.0 = M  26.0           IMPULSE NEG.FLANK PRESS.FEED.CLAMP. OFF
```

NETZWERK 16 0076 H-MARK FLANK EVALUATION CLAMP.ON



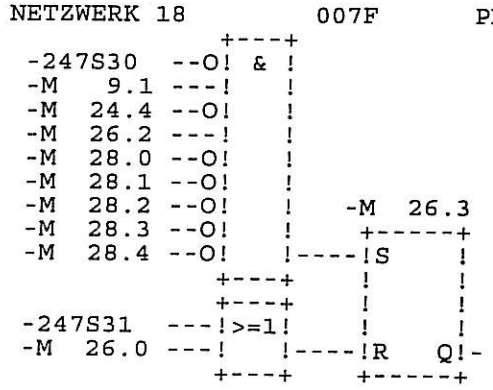

```
M   10.0 = M  10.0           CLAMPING CLOSED
M   26.1 = M  26.1           HF NEG.FLANK PRESSURE FEED.CLAMPING OFF
```

NETZWERK 17 0079 PRESS.FEEDING CLAMPING ON



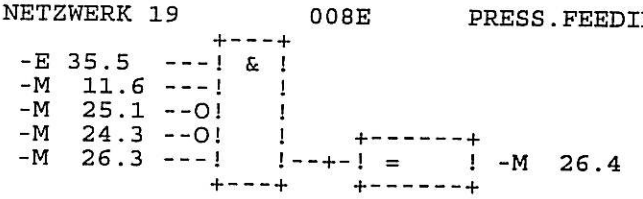
```
M   25.6 = M  25.6      IMPULSE POS.FLANK PRESS.FEED.CLAMPING ON
M   26.2 = M  26.2      PREESURE FEEDING CLAMPING ON
M   26.0 = M  26.0      IMPULSE NEG.FLANK PRESS.FEED.CLAMP. OFF
```

NETZWERK 18 007F PRESS.FEEDING CLAMPING ON



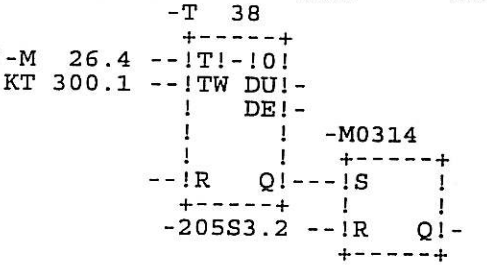

```
E   33.5 = 247S30       CLAMPING HIGH PRESSURE BUILT UP : MIN HP
M    9.1 = M   9.1      CONTROL VOLTAGE IS ON
M   24.4 = M  24.4      PRESSURE FEEDING LOCK.CYLINDER ACTIVE
M   26.2 = M  26.2      PREESURE FEEDING CLAMPING ON
M   28.0 = M  28.0      LIFT CASSETTE MOUNTING DEVICE
M   28.1 = M  28.1      LOWER CASSETTE MOUNTING DEVICE
M   28.2 = M  28.2      SLIP-IN CASSETTE
M   28.3 = M  28.3      REVERSE SLIP-IN DEVICE
M   28.4 = M  28.4      KEYSWITCH REBUILD HIGH PRESSURE
M   26.3 = M  26.3      HF PRESSURE FEEDING CLAMPING ON
E   33.6 = 247S31       CLAMPING HIGH PRESSURE BUILT UP : MAX HP
M   26.0 = M  26.0      IMPULSE NEG.FLANK PRESS.FEED.CLAMP. OFF
```

NETZWERK 19 008E PRESS.FEEDING CLAMPING ACTIVE




```
E   35.5 = E 35.5       DEH SYSTEM PRESSURE OVERFLOW
M   11.6 = M  11.6      NO FAULT DUPLEX EXTRUSION HEAD
M   25.1 = M  25.1      OPEN CLAMPING
M   24.3 = M  24.3      HF PRESSURE FEED. LOCK.CYLINDER ON
M   26.3 = M  26.3      HF PRESSURE FEEDING CLAMPING ON
M   26.4 = M  26.4      PRESSURE FEEDING CLAMPING ACTIVE
```

NETZWERK 20 0095 FAULT : TIME PRESSURE FEEDING




```
M   26.4 = M  26.4      PRESSURE FEEDING CLAMPING ACTIVE
T   38   = T  38       TIME PRESSURE FEEDING CLAMP
M  187.5 = M0314        TIME PRESSURE FEEDING CLAMP          DEH
E   84.3 = 205S3.2      ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
```

```
NETZWERK 21         00A2
00A2       :AWL
00A3       :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                          CASSETTE MOUNTING DEVICE                           *
*                                                                             *
*******************************************************************************

0000      :AWL
0001      :***

NETZWERK 2          0002      LIFT CASSETTE MOUNTING DEVICE
              +---+
 -248S46  ---! & !
 -249S1   ---!   !
 -249S2.1 ---!   !
 -M  10.3 ---!   !
 -M  10.4 ---!   !
 -M  11.7 ---!   !
 -M  24.4 --O!   !    +------+
 -M  26.4 --O!   !--+-! =    ! -M  28.0
              +---+    +------+

E   34.6 = 248S46                    CASSETTE MOUNTING DEVICE AT DEH
E   35.0 = 249S1                     CASSETTE MOUNTING DEVICE RETURNED
E   35.1 = 249S2.1                   SWITCH : LIFT CASSETTE MOUNTING DEVICE
M   10.3 = M  10.3                   UPPER PART CLOSED
M   10.4 = M  10.4                   LOCKING CYLINDER : LOCKING POSITION
M   11.7 = M  11.7                   RELEASE DUPLEX EXTRUSION HEAD
M   24.4 = M  24.4                   PRESSURE FEEDING LOCK.CYLINDER ACTIVE
M   26.4 = M  26.4                   PRESSURE FEEDING CLAMPING ACTIVE
M   28.0 = M  28.0                   LIFT CASSETTE MOUNTING DEVICE

NETZWERK 3          000C      SV LIFT CASSETTE MOUNTING DEVICE
              +---+
 -M  14.2 ---! & !    +------+
 -M  28.0 ---!   !--+-! =    ! -254B2
              +---+    +------+

M   14.2 = M  14.2                   RELEASE SOLENOID VALVE 120 BAR
M   28.0 = M  28.0                   LIFT CASSETTE MOUNTING DEVICE
A   32.1 = 254B2                     SV UP CASSETTE MOUNTING DEVICE

NETZWERK 4          0010      LOWER CASSETTE MOUNTING DEVICE
              +---+
 -248S46  ---! & !
 -249S2.2 ---!   !
 -248S47  --O!   !
 -M  10.3 ---!   !
 -M  10.4 ---!   !
 -M  11.7 ---!   !
 -M  24.4 --O!   !    +------+
 -M  26.4 --O!   !--+-! =    ! -M  28.1
              +---+    +------+

E   34.6 = 248S46                    CASSETTE MOUNTING DEVICE AT DEH
E   35.2 = 249S2.2                   SWITCH : LOWER CASSETTE MOUNTING DEVICE
E   34.7 = 248S47                    CASSETTE MOUNTING DEVICE LOWERED
M   10.3 = M  10.3                   UPPER PART CLOSED
M   10.4 = M  10.4                   LOCKING CYLINDER : LOCKING POSITION
M   11.7 = M  11.7                   RELEASE DUPLEX EXTRUSION HEAD
M   24.4 = M  24.4                   PRESSURE FEEDING LOCK.CYLINDER ACTIVE
M   26.4 = M  26.4                   PRESSURE FEEDING CLAMPING ACTIVE
M   28.1 = M  28.1                   LOWER CASSETTE MOUNTING DEVICE

NETZWERK 5          001A      SOLENOID VALVE LOWERING CASS.
              +---+
 -M  14.2 ---! & !    +------+
 -M  28.1 ---!   !--+-! =    ! -254B1
              +---+    +------+
```

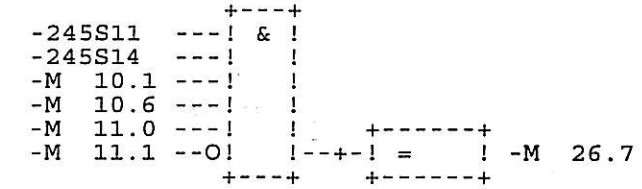
```
M   14.2 = M  14.2                    RELEASE SOLENOID VALVE 120 BAR
M   28.1 = M  28.1                    LOWER CASSETTE MOUNTING DEVICE
A   32.0 = 254B1                      SV DOWN CASSETTE MOUNTING DEVICE

NETZWERK 6          001E      SLIP IN CASSETTE
                  +---+
 -248S46   ---! & !
 -248S47   ---!   !
 -249S4.1  ---!   !
 -M  10.1  ---!   !
 -M  10.3  ---!   !
 -M  10.4  ---!   !
 -M  11.7  ---!   !
 -M  24.4  --O!   !     +------+
 -M  26.4  --O!   !--+-! =    ! -M  28.2
                  +---+     +------+

E   34.6 = 248S46                     CASSETTE MOUNTING DEVICE AT DEH
E   34.7 = 248S47                     CASSETTE MOUNTING DEVICE LOWERED
E   35.3 = 249S4.1                    SWITCH : SLIP-IN CASSETTE
M   10.1 = M  10.1                    CLAMPING OPEN
M   10.3 = M  10.3                    UPPER PART CLOSED
M   10.4 = M  10.4                    LOCKING CYLINDER : LOCKING POSITION
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD
M   24.4 = M  24.4                    PRESSURE FEEDING LOCK.CYLINDER ACTIVE
M   26.4 = M  26.4                    PRESSURE FEEDING CLAMPING ACTIVE
M   28.2 = M  28.2                    SLIP-IN CASSETTE

NETZWERK 7          0029      SOLENOID VALVE SLIP-IN CASSETTE
                  +---+
 -M  14.1  ---! & !     +------+
 -M  28.2  ---!   !--+-! =    ! -254B3
                  +---+     +------+

M   14.1 = M  14.1                    RELEASE SOLENOID VALVE  50 BAR
M   28.2 = M  28.2                    SLIP-IN CASSETTE
A   32.2 = 254B3                      SV SLIP-IN CASSETTE

NETZWERK 8          002D      SLIP OUT CASSETTE
                  +---+
 -248S46   ---! & !
 -248S47   ---!   !
 -249S1    --O!   !
 -249S4.2  ---!   !
 -M  10.1  ---!   !
 -M  10.3  ---!   !
 -M  10.4  ---!   !
 -M  11.7  ---!   !
 -M  24.4  --O!   !     +------+
 -M  26.4  --O!   !--+-! =    ! -M  28.3
                  +---+     +------+

E   34.6 = 248S46                     CASSETTE MOUNTING DEVICE AT DEH
E   34.7 = 248S47                     CASSETTE MOUNTING DEVICE LOWERED
E   35.0 = 249S1                      CASSETTE MOUNTING DEVICE RETURNED
E   35.4 = 249S4.2                    SWITCH : SLIP-OUT CASSETTE
M   10.1 = M  10.1                    CLAMPING OPEN
M   10.3 = M  10.3                    UPPER PART CLOSED
M   10.4 = M  10.4                    LOCKING CYLINDER : LOCKING POSITION
M   11.7 = M  11.7                    RELEASE DUPLEX EXTRUSION HEAD
M   24.4 = M  24.4                    PRESSURE FEEDING LOCK.CYLINDER ACTIVE
M   26.4 = M  26.4                    PRESSURE FEEDING CLAMPING ACTIVE
M   28.3 = M  28.3                    REVERSE SLIP-IN DEVICE

NETZWERK 9          0039      MOVE OUT CASSETTE MOUNT.DEVICE
                  +---+
 -M  14.1  ---! & !     +------+
 -M  28.3  ---!   !--+-! =    ! -254B4
                  +---+     +------+

M   14.1 = M  14.1                    RELEASE SOLENOID VALVE  50 BAR
```

```
PB 16    -PB  16                        C:KERM06ST.S5D        BIB=30092    LAE=68

M    28.3 = M  28.3                     REVERSE SLIP-IN DEVICE
A    32.3 = 254B4                       SV MOVE CASSETTE MOUNTING DEV. REVERSE

NETZWERK 10          003D
003D        :AWL
003E        :BE
```

NETZWERK 1 0000

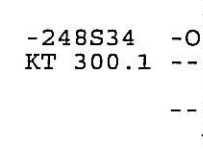
```
*******************************************************************************
*                                                                             *
*                              RELEASE EXTRUDER                               *
*                                                                             *
*******************************************************************************
0000    :***
```

NETZWERK 2 0001 HEAD IS OPEN



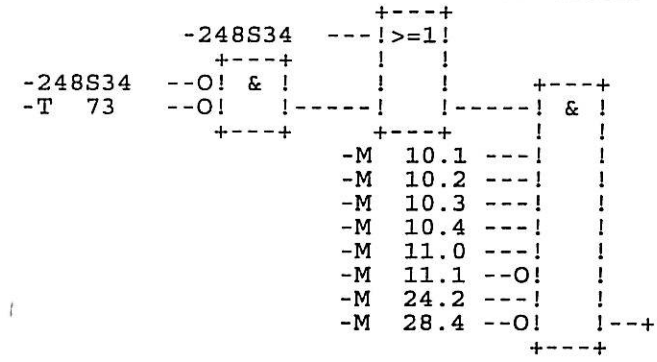
E	31.2	= 245S11	PROX.SWITCH MEDIUM PART OPEN
E	31.5	= 245S14	PROX.SWITCH UPPER PART OPEN
M	10.1	= M 10.1	CLAMPING OPEN
M	10.6	= M 10.6	LOCKING CYLINDER HOME POSITION
M	11.0	= M 11.0	EJECTING DEVICE OPEN
M	11.1	= M 11.1	CASSETTE INSTALLED
M	26.7	= M 26.7	RELEASE EXTRUDER HEAD OPEN

NETZWERK 3 0009 TIME PRESSURE FEEDING L.C.



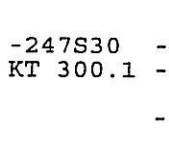
E	34.1	= 248S34	LOCK.CYL. HIGH PRESS. BUILT UP : MIN. HP
T	73	= T 73	RELEASE EXTRUDER MIN HP LOCKING CYLINDER

NETZWERK 4 0012 HEAD CLOSED WITHOUT CASSETTE



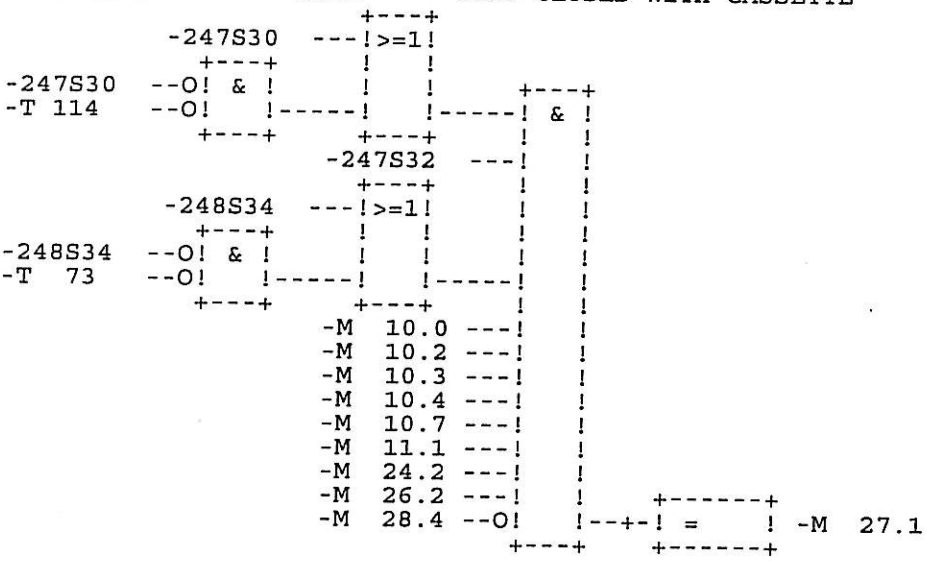
E	34.1	= 248S34	LOCK.CYL. HIGH PRESS. BUILT UP : MIN. HP
T	73	= T 73	RELEASE EXTRUDER MIN HP LOCKING CYLINDER
M	10.1	= M 10.1	CLAMPING OPEN
M	10.2	= M 10.2	MEDIUM PART CLOSED
M	10.3	= M 10.3	UPPER PART CLOSED
M	10.4	= M 10.4	LOCKING CYLINDER : LOCKING POSITION
M	11.0	= M 11.0	EJECTING DEVICE OPEN
M	11.1	= M 11.1	CASSETTE INSTALLED
M	24.2	= M 24.2	PRESSURE FEEDING LOCKING CYLINDER ON
M	28.4	= M 28.4	KEYSWITCH REBUILD HIGH PRESSURE
M	27.0	= M 27.0	RELEASE EXTRUDER WITHOUT CASSETTE

NETZWERK 5 0022 TIME PRESSURE FEEDING CLAMPS



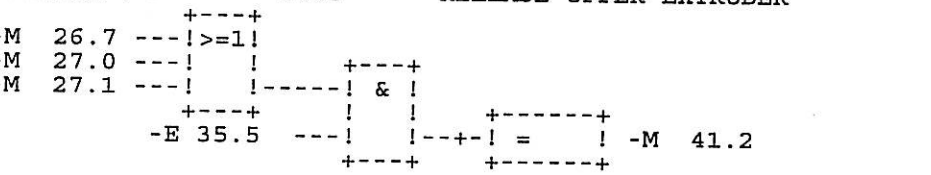

```
E   33.5 = 247S30                    CLAMPING HIGH PRESSURE BUILT UP : MIN HP
T  114   = T 114                     RELEASE EXTRUDER MIN HP CLAMPS
```

NETZWERK 6 002B HEAD CLOSED WITH CASSETTE



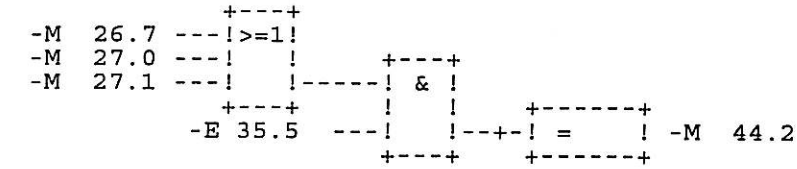

```
E   33.5 = 247S30                    CLAMPING HIGH PRESSURE BUILT UP : MIN HP
T  114   = T 114                     RELEASE EXTRUDER MIN HP CLAMPS
E   33.7 = 247S32                    CLAMPING HIGH PRESSURE FALL BELOW MIN
E   34.1 = 248S34                    LOCK.CYL. HIGH PRESS. BUILT UP : MIN. HP
T   73   = T  73                     RELEASE EXTRUDER MIN HP LOCKING CYLINDER
M   10.0 = M  10.0                   CLAMPING CLOSED
M   10.2 = M  10.2                   MEDIUM PART CLOSED
M   10.3 = M  10.3                   UPPER PART CLOSED
M   10.4 = M  10.4                   LOCKING CYLINDER : LOCKING POSITION
M   10.7 = M  10.7                   EJECTING DEVICE CLOSED
M   11.1 = M  11.1                   CASSETTE INSTALLED
M   24.2 = M  24.2                   PRESSURE FEEDING LOCKING CYLINDER ON
M   26.2 = M  26.2                   PREESURE FEEDING CLAMPING ON
M   28.4 = M  28.4                   KEYSWITCH REBUILD HIGH PRESSURE
M   27.1 = M  27.1                   RELEASE EXTRUDER WITH CASSETTE
```

NETZWERK 7 0043 RELEASE UPPER EXTRUDER



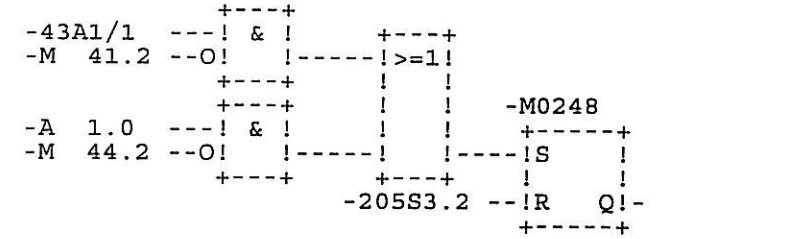

```
M   26.7 = M  26.7                   RELEASE EXTRUDER HEAD OPEN
M   27.0 = M  27.0                   RELEASE EXTRUDER WITHOUT CASSETTE
M   27.1 = M  27.1                   RELEASE EXTRUDER WITH CASSETTE
E   35.5 = E 35.5                    DEH SYSTEM PRESSURE OVERFLOW
M   41.2 = M  41.2                   UP.EXTR. : RELEASE UPPER EXTRUDER
```

NETZWERK 8 004B RELEASE BOTTOM EXTRUDER



M 26.7 = M 26.7		RELEASE EXTRUDER HEAD OPEN
M 27.0 = M 27.0		RELEASE EXTRUDER WITHOUT CASSETTE
M 27.1 = M 27.1		RELEASE EXTRUDER WITH CASSETTE
E 35.5 = E 35.5		DEH SYSTEM PRESSURE OVERFLOW
M 44.2 = M 44.2		BOT.EXTR. : RELEASE BOTTOM EXTRUDER

NETZWERK 9 0053 NO RELEASE EXTRUDER OFF



A 0.0 = 43A1/1		UPPER EXTRUDER ON/OFF
M 41.2 = M 41.2		UP.EXTR. : RELEASE UPPER EXTRUDER
A 1.0 = A 1.0		BOTTOM EXTRUDER ON/OFF
M 44.2 = M 44.2		BOT.EXTR. : RELEASE BOTTOM EXTRUDER
M 179.3 = M0248		NO RELEASE FROM EXTRUSION HEAD EXTR. OFF
E 84.3 = 205S3.2		ACKNOWLEDGING FAULT (MAIN CONTR.PAN.)

NETZWERK 10 005D
005D :AWL
005E :BE

NETZWERK 1 0000

```
**********************************************************************************
*                                                                                *
*                                    R - 9000                                    *
*                                                                                *
**********************************************************************************
```

WRITE TEMPERATURES FROM PROFILE DB180 TO DB60-75

```
                              -FB  53
                               +--------------+
                               !   PARAM.DB   !
                               +--------------+
```

FB 53 = FB 53 DATATRANSFER TO PARAMETER DB 60-75

NETZWERK 2 0003

IMPULSES FOR BLOCKTRANSFER BETWEEN CP524 AND GTR-9000

```
                              -FB  54
                               +--------------+
                               !   BLOCK-S.   !
                               +--------------+
```

FB 54 = FB 54 SEND/RECEIVE BLOCKS GTR-9000

NETZWERK 3 0006

CALL SEND ALL ABSOLUT FOR DATATRANSFER

```
                              -FB 126
                               +--------------+
                               !   SEND-A     !
                    0,4      --!SSNR      PAFE!-- MB 220
                    0,0      --!A-NR          !
                    MW 230   --!ANZW          !
                               +--------------+
```

FB 126 = FB 126 SEND-ALL (S)

NETZWERK 4 000D

COMPARE DATAS PROFILE DB180 AND GTR-9000 AND CHECK TEMPERATURE RELEASE

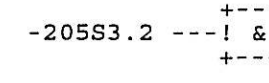
```
                              -FB  52
                               +--------------+
                               !   GTR-9000   !
                               +--------------+
```

FB 52 = FB 52 TEMPERATURE RELEASE

NETZWERK 5 0010

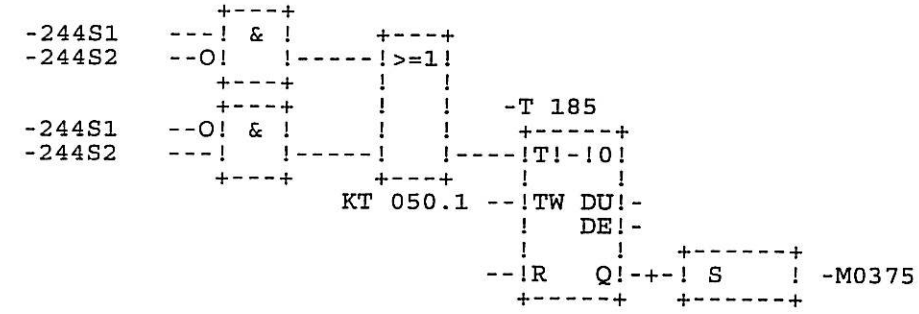
```
0010      :BE
```

NETZWERK 1 0000 FAULT SW CLAMPS DOWN CLOSED



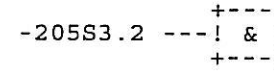

```
E   84.3 = 205S3.2                    ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
M  195.2 = M0375                      FAULT SWITCH CLAMPS DOWN CLOSED
```

NETZWERK 2 0003 FAULT SW CLAMPS DOWN CLOSED



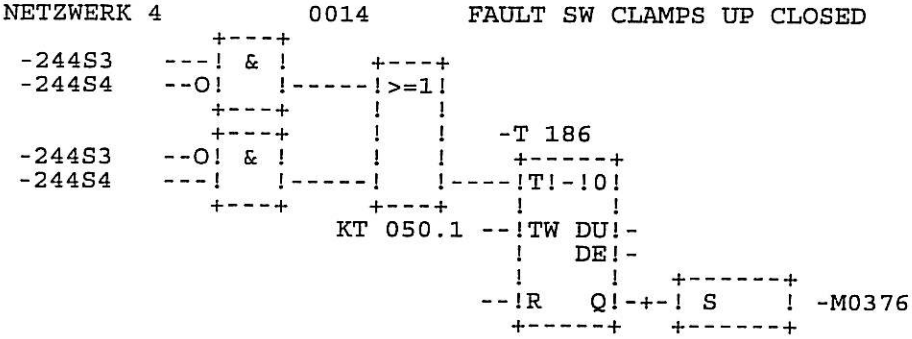

```
E   30.0 = 244S1                      CLAMPING RIGHT SIDE DOWN CLOSED
E   30.1 = 244S2                      CLAMPING LEFT  SIDE DOWN CLOSED
T  185   = T 185                      SWITCH CONTROL CLAMPS DOWN CLOSED
M  195.2 = M0375                      FAULT SWITCH CLAMPS DOWN CLOSED
```

NETZWERK 3 0011 FAULT SW CLAMPS UP CLOSED



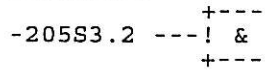

```
E   84.3 = 205S3.2                    ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
M  195.3 = M0376                      FAULT SWITCH CLAMPS UP CLOSED
```

NETZWERK 4 0014 FAULT SW CLAMPS UP CLOSED



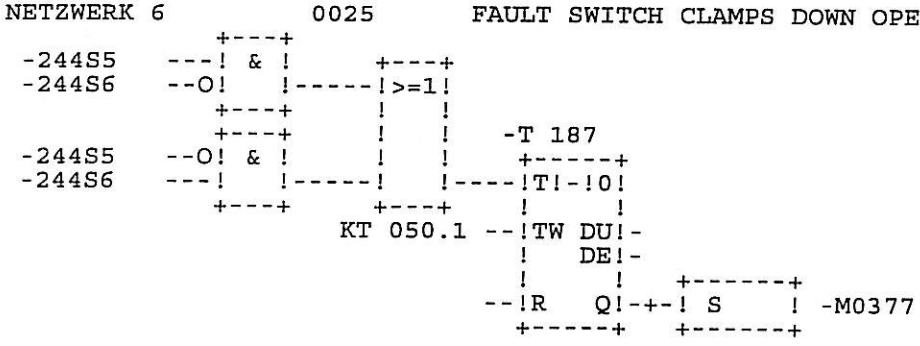

```
E   30.2 = 244S3                      CLAMPING RIGHT SIDE UP   CLOSED
E   30.3 = 244S4                      CLAMPING LEFT  SIDE UP   CLOSED
T  186   = T 186                      SWITCH CONTROL CLAMPS UP CLOSED
M  195.3 = M0376                      FAULT SWITCH CLAMPS UP CLOSED
```

NETZWERK 5 0022 FAULT SWITCH CLAMPS DOWN OPEN



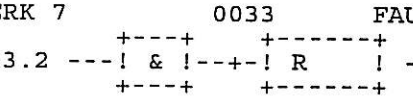

```
E   84.3 = 205S3.2                    ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
M  195.4 = M0377                      FAULT SWITCH CLAMPS DOWN OPEN
```

NETZWERK 6 0025 FAULT SWITCH CLAMPS DOWN OPEN



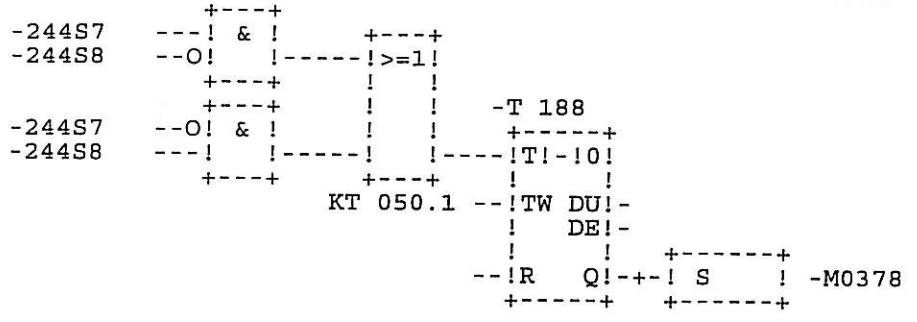
E 30.4 = 244S5 CLAMPING RIGHT SIDE DOWN OPEN
E 30.5 = 244S6 CLAMPING LEFT SIDE DOWN OPEN
T 187 = T 187 SWITCH CONTROL CLAMPS DOWN OPEN
M 195.4 = M0377 FAULT SWITCH CLAMPS DOWN OPEN

NETZWERK 7 0033 FAULT SWITCH CLAMPS UP OPEN



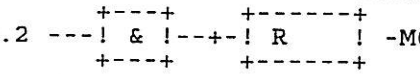
E 84.3 = 205S3.2 ACKNOWLEDGING FAULT (MAIN CONTR.PAN.)
M 195.5 = M0378 FAULT SWITCH CLAMPS UP OPEN

NETZWERK 8 0036 FAULT SWITCH CLAMPS UP OPEN



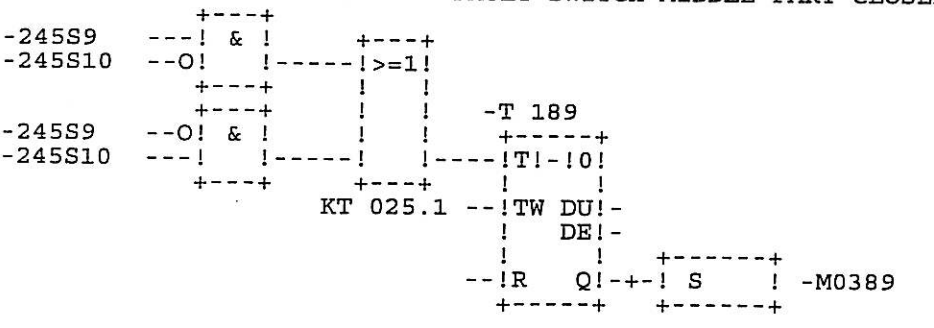
E 30.6 = 244S7 CLAMPING RIGHT SIDE UP OPEN
E 30.7 = 244S8 CLAMPING LEFT SIDE UP OPEN
T 188 = T 188 SWITCH CONTROL CLAMPS UP OPEN
M 195.5 = M0378 FAULT SWITCH CLAMPS UP OPEN

NETZWERK 9 0044 FAULT SWITCH MIDDLE PART CLOSED



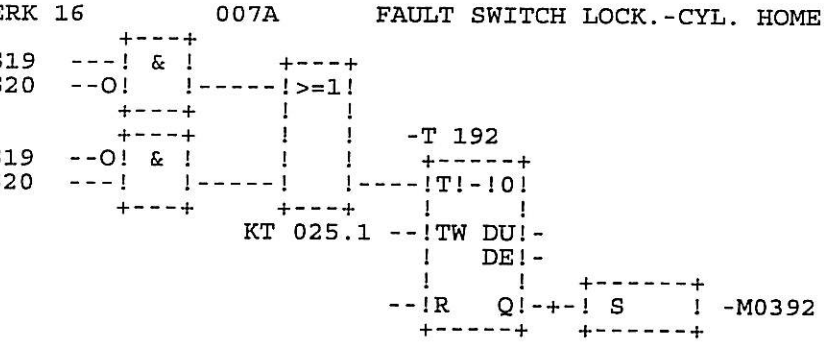
E 84.3 = 205S3.2 ACKNOWLEDGING FAULT (MAIN CONTR.PAN.)
M 197.0 = M0389 FAULT SWITCH MIDDLE PART CLOSED

NETZWERK 10 0047 FAULT SWITCH MIDDLE PART CLOSED



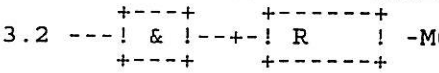
```
E   31.0 = 245S9                    INTERMEDIATE PART RIGHT SIDE CLOSED
E   31.1 = 245S10                   INTERMEDIATE PART LEFT  SIDE CLOSED
T  189   = T 189                    SWITCH CONTROL MIDDLE PART CLOSED
M  197.0 = M0389                    FAULT SWITCH MIDDLE PART CLOSED

NETZWERK 11        0055      FAULT SWITCH UPPER PART CLOSED
              +---+    +------+
 -205S3.2 ---! & !--+-! R    ! -M0390
              +---+    +------+

E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
M  197.1 = M0390                    FAULT SWITCH UPPER PART CLOSED

NETZWERK 12        0058      FAULT SWITCH UPPER PART CLOSED
              +---+
 -245S12  ---! & !     +---+
 -245S13  --O!   !-----!>=1!
              +---+     !   !
              +---+     !   !   -T 190
 -245S12  --O! & !     !   !    +-----+
 -245S13  ---!   !-----!   !----!T!-!0!
              +---+     +---+    !     !
                     KT 025.1 --!TW DU!-
                                !   DE!-
                                !     !   +------+
                               --!R   Q!-+-! S    ! -M0390
                                 +-----+   +------+

E   31.3 = 245S12                   UPPER PART RIGHT SIDE CLOSED
E   31.4 = 245S13                   UPPER PART LEFT  SIDE CLOSED
T  190   = T 190                    SWITCH CONTROL UPPER PART CLOSED
M  197.1 = M0390                    FAULT SWITCH UPPER PART CLOSED

NETZWERK 13        0066      FAULT SWITCH LOCK.-CYL. LOCK POS
              +---+    +------+
 -205S3.2 ---! & !--+-! R    ! -M0391
              +---+    +------+

E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
M  197.2 = M0391                    FAULT SWITCH LOCKING CYL. LOCK POS.

NETZWERK 14        0069      FAULT SWITCH LOCK.-CYL. LOCK POS
              +---+
 -245S15  ---! & !     +---+
 -245S16  --O!   !-----!>=1!
              +---+     !   !
              +---+     !   !   -T 191
 -245S15  --O! & !     !   !    +-----+
 -245S16  ---!   !-----!   !----!T!-!0!
              +---+     +---+    !     !
                     KT 025.1 --!TW DU!-
                                !   DE!-
                                !     !   +------+
                               --!R   Q!-+-! S    ! -M0391
                                 +-----+   +------+

E   31.6 = 245S15                   RIGHT LOCKING CYLINDER LOCKING POSITION
E   31.7 = 245S16                   LEFT  LOCKING CYLINDER LOCKING POSITION
T  191   = T 191                    SWITCH FAULT LOCKING CYLINDER LOCK POS.
M  197.2 = M0391                    FAULT SWITCH LOCKING CYL. LOCK POS.

NETZWERK 15        0077      FAULT SWITCH LOCK.-CYL. HOME POS
              +---+    +------+
 -205S3.2 ---! & !--+-! R    ! -M0392
              +---+    +------+

E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
M  197.3 = M0392                    FAULT SWITCH LOCKING CYL. HOME POS.
```

NETZWERK 16 007A FAULT SWITCH LOCK.-CYL. HOME POS



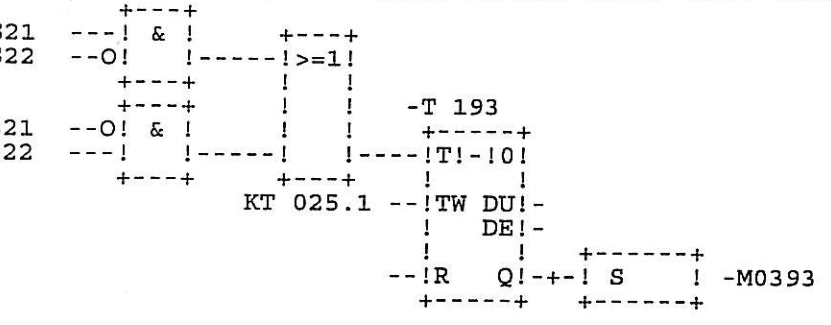
E 32.2 = 246S19 RIGHT LOCKING CYLINDER HOME POSITION
E 32.3 = 246S20 LEFT LOCKING CYLINDER HOME POSITION
T 192 = T 192 SWITCH CONTROL LOCKING CYL. HOME POS.
M 197.3 = M0392 FAULT SWITCH LOCKING CYL. HOME POS.

NETZWERK 17 0088 FAULT SWITCH EJECT.-DEV. CLOSED



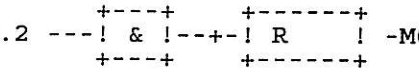
E 84.3 = 205S3.2 ACKNOWLEDGING FAULT (MAIN CONTR.PAN.)
M 197.4 = M0393 FAULT SWITCH EJECTING DEVICE CLOSED

NETZWERK 18 008B FAULT SWITCH EJECT.-DEV. CLOSED



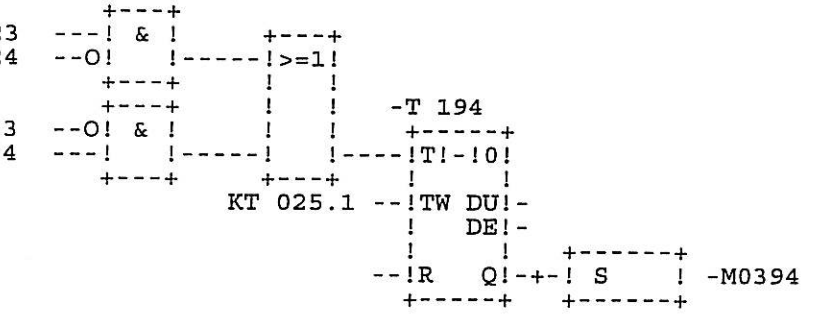
E 32.4 = 246S21 EJECTING DEVICE RIGHT SIDE CLOSED
E 32.5 = 246S22 EJECTING DEVICE LEFT SIDE CLOSED
T 193 = T 193 SWITCH CONTROL EJECTING DEVICE CLOSED
M 197.4 = M0393 FAULT SWITCH EJECTING DEVICE CLOSED

NETZWERK 19 0099 FAULT SWITCH EJECT.-DEV. OPEN



E 84.3 = 205S3.2 ACKNOWLEDGING FAULT (MAIN CONTR.PAN.)
M 197.5 = M0394 FAULT SWITCH EJECTING DEVICE OPEN

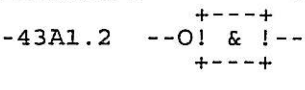
NETZWERK 20 009C FAULT SWITCH EJECT.-DEV. OPEN



```
E   32.6 = 246S23                    EJECTING DEVICE RIGHT SIDE OPEN
E   32.7 = 246S24                    EJECTING DEVICE LEFT  SIDE OPEN
T  194   = T 194                     SWITCH CONTROL EJECTING DEVICE OPEN
M  197.5 = M0394                     FAULT SWITCH EJECTING DEVICE OPEN

NETZWERK 21          00AA      FAULT SWITCH CASSETTE INSTALLED
                  +---+    +------+
 -205S3.2 ---! & !--+-! R    ! -M0395
                  +---+    +------+

E   84.3 = 205S3.2                   ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
M  197.6 = M0395                     FAULT SWITCH CASSETTE INSTALLED

NETZWERK 22          00AD      FAULT SWITCH CASSETTE INSTALLED
                  +---+
 -247S27  ---! & !     +---+
 -247S28  --O!   !-----!>=1!
                  +---+    !   !
                  +---+    !   !   -T 195
 -247S27  --O! & !     !   !    +-----+
 -247S28  ---!   !-----!   !----!T!-!0!
                  +---+    +---+   !     !
                        KT 025.1 --!TW DU!-
                                   !   DE!-
                                   !     !   +------+
                                  --!R   Q!-+-! S    ! -M0395
                                    +-----+   +------+:BE

E   33.2 = 247S27                    CASSETTE RIGHT SIDE INSTALLED
E   33.3 = 247S28                    CASSETTE LEFT  SIDE INSTALLED
T  195   = T 195                     SWITCH CONTROL CASSETTE INSTALLED
M  197.6 = M0395                     FAULT SWITCH CASSETTE INSTALLED
```

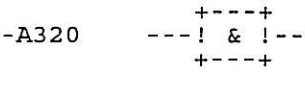
```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                EXTRUDER TOPMACHINE                          *
*                                                                             *
*******************************************************************************
0000      :***

NETZWERK 2          0001      FAULT : OIL LUBRICATION
              +---+    +------+
 -46Q1     ---! & !--+-! =    ! -M0290
              +---+    +------+

E    0.6 = 46Q1                          UP.EXTR. AUX DRIVE GEAR LUBR. FAULT
M  182.5 = M0290                         MOTOR OIL PUMP FAULT      UPPER EXTRUDER

NETZWERK 3          0004      FAULT : EXTERNAL FAN
              +---+    +------+
 -46Q3     ---! & !--+-! =    ! -M0274
              +---+    +------+

E    0.7 = 46Q3                          UP.EXTR. AUX DRIVE EXTERNAL FAN FAULT
M  180.5 = M0274                         DRIVE MOTOR EXTERNAL FAN  UPPER EXTRUDER

NETZWERK 4          0007      FAULT : CARBON BRUSH CONTROL
              +---+    +------+
 -45A6     ---! & !--+-! =    ! -M0279
              +---+    +------+

E    0.1 = 45A6                          UP.EXTR. CARBON BRUSH CONTROL
M  183.2 = M0279                         MAIN DRIVE CARBON BRUSH   UPPER EXTRUDER

NETZWERK 5          000A      FAULT : WATER-COOLING
              +---+
 -234S2    --O! & !    +------+
 -43A1/2   ---!   !--+-! =    ! -M0288
              +---+    +------+

E   20.1 = 234S2                         UPPER EXTRUDER WATERCOOLING
A    0.1 = 43A1/2                        UPPER EXTRUDER CONTROLLER RELEASE
M  182.3 = M0288                         PRESSURE WATER-COOLING    UPPER EXTRUDER

NETZWERK 6          000E      FAULT : TEMP. MAIN DRIVE
              +---+    +------+
 -45A3     --O! & !--+-! =    ! -M0292
              +---+    +------+

E    0.0 = 45A3                          UP.EXTR. MOTOR EXCESS TEMP MOT WINDING
M  182.7 = M0292                         MAIN DRIVE TEMP. FAULT    UPPER EXTRUDER

NETZWERK 7          0011      FAULT : MOTOR WINDING EXTR. OFF
            -T  68
             +-----+
 -45A3     -O!T!-!0!
 KT 300.2  --!TW DU!-
             !   DE!-
           --!R   Q!-
             +-----+

E    0.0 = 45A3                          UP.EXTR. MOTOR EXCESS TEMP MOT WINDING
T   68   = T  68                         CONTROL TEMP. MAIN DRIVE UPPER EXTRUDER

NETZWERK 8          001A      FAULT : TEMP. DC-CONVERTER
              +---+    +------+
 -43A1.1   --O! & !--+-! =    ! -M0282
              +---+    +------+

E    0.2 = 43A1.1                        UP.EXTR. DC-CONVERTER TEMP. CONTROL
M  183.5 = M0282                         DC-CONVERTER TEMP. FAULT  UPPER EXTRUDER
```

NETZWERK 9 001D FAULT : DC-CONVERTER



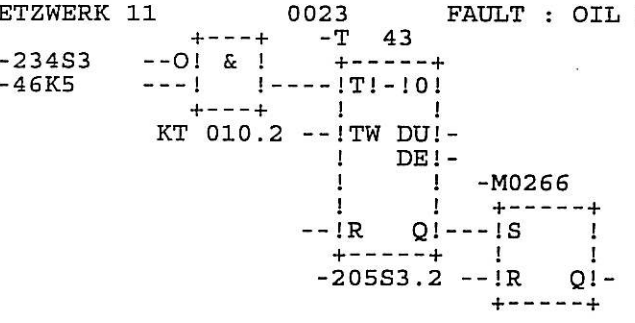

```
E    0.3 = 43A1.2                    UP.EXTR. DC-CONVERTER FAULT
M  184.0 = M0301                     DC-CONVERTER FAULT        UPPER EXTRUDER
```

NETZWERK 10 0020 FAULT : E-STOP HOPPER



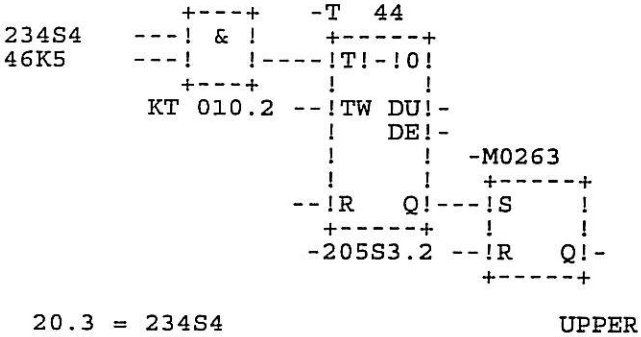

```
E   20.0 = A320                      UPPER EXTRUDER E-STOP HOPPER
M  180.1 = M0270                     E-STOP HOPPER             UPPER EXTRUDER
```

NETZWERK 11 0023 FAULT : OIL FLOW TO LOW



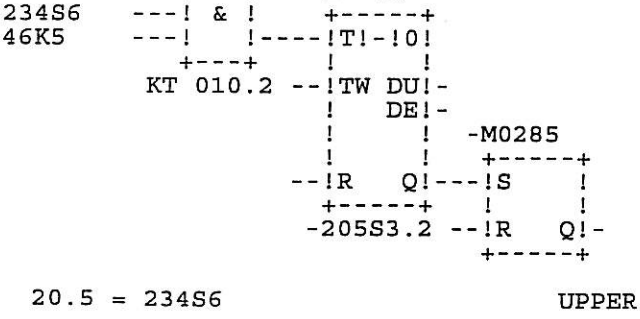

```
E   20.2 = 234S3                     UPPER EXTRUDER OIL FLOW TO LOW
A    0.5 = 46K5                      UPPER EXTRUDER AUXILIARY DRIVES ON
T   43   = T  43                     UP.EXTR. : FAULT OIL FLOW TO LOW
M  181.5 = M0266                     OIL FLOW OIL LUBRICATION  UPPER EXTRUDER
E   84.3 = 205S3.2                   ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
```

NETZWERK 12 0031 FAULT : PRESSURE TO LOW




```
E   20.3 = 234S4                     UPPER EXTRUDER OIL PRESSURE TO LOW
A    0.5 = 46K5                      UPPER EXTRUDER AUXILIARY DRIVES ON
T   44   = T  44                     UP.EXTR. : FAULT OIL PRESSURE TO LOW
M  181.2 = M0263                     PRESSURE OIL LUBRICATION  UPPER EXTRUDER
E   84.3 = 205S3.2                   ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
```

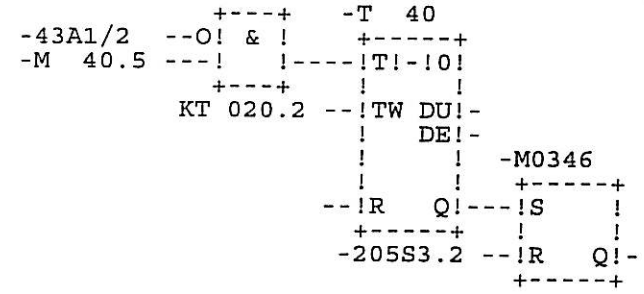
NETZWERK 13 003F FAULT : TEMP. TO HIGH EXTR. OFF




```
E   20.5 = 234S6                     UPPER EXTRUDER TEMP TO HIGH
```

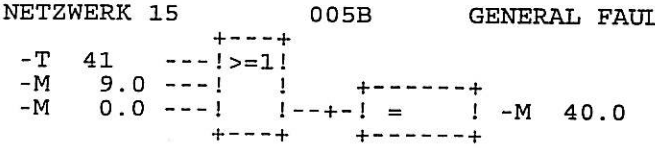
```
A    0.5 = 46K5                    UPPER EXTRUDER AUXILIARY DRIVES ON
T   45   = T  45                   UP.EXTR. : FAULT TEMPERATURE TO HIGH
M  182.0 = M0285                   TEMP. OIL LUBRICATION     UPPER EXTRUDER
E   84.3 = 205S3.2                 ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
```

NETZWERK 14 004D FAULT : CONTROL START



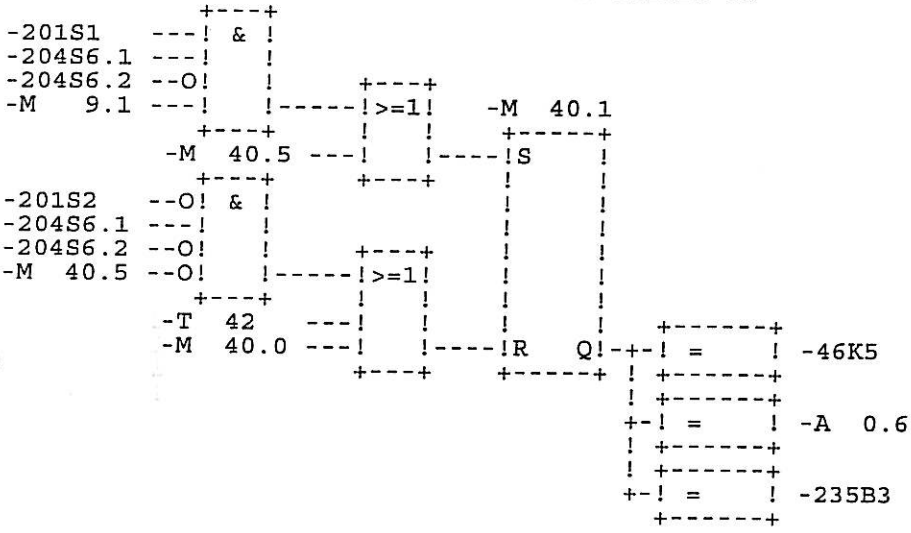

```
A    0.1 = 43A1/2                  UPPER EXTRUDER CONTROLLER RELEASE
M   40.5 = M  40.5                 UP.EXTR. : EXTRUDER START
T   40   = T  40                   UP.EXTR. : CONTROL START
M  191.5 = M0346                   CONTROL START             UPPER EXTRUDER
E   84.3 = 205S3.2                 ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
```

NETZWERK 15 005B GENERAL FAULTS UPPER EXTRUDER




```
T   41   = T  41                   UP.EXTR. : CONTROL REVERSE
M    9.0 = M   9.0                 E-STOP TRIGGERED
M    0.0 = M   0.0                 "0"-SIGNAL
M   40.0 = M  40.0                 UP.EXTR. : GENERAL FAULTS
```

NETZWERK 16 0060 AUXILIARY DRIVES ON

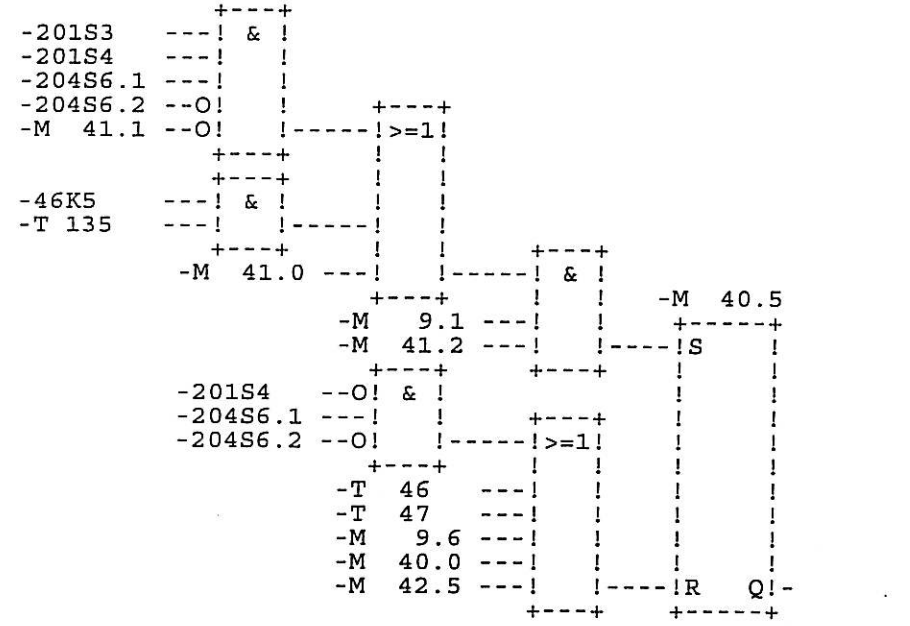



```
E   80.0 = 201S1                   UP.EXTR. AUX DRIVE ON   (MAIN CONTR.PAN.)
E   83.5 = 204S6.1                 MANUAL                  (MAIN CONTR.PAN.)
E   83.6 = 204S6.2                 AUTOMATIC               (MAIN CONTR.PAN.)
M    9.1 = M   9.1                 CONTROL VOLTAGE IS ON
M   40.5 = M  40.5                 UP.EXTR. : EXTRUDER START
M   40.1 = M  40.1                 UP.EXTR. : AUXILIARY DRIVES ON
E   80.1 = 201S2                   UP.EXTR. AUX DRIVE OFF (MAIN CONTR.PAN.)
T   42   = T  42                   UP.EXTR. : RUN AFTER TIME AUX DRIVES
M   40.0 = M  40.0                 UP.EXTR. : GENERAL FAULTS
A    0.5 = 46K5                    UPPER EXTRUDER AUXILIARY DRIVES ON
```

```
A    0.6 = A  0.6                    UPPER EXTRUDER FIELD ON
A   20.2 = 235B3                     UPPER EXTRUDER WATER COOLING

NETZWERK 17          0072      IMPULSE EXTRUDER OFF
0072       :UN  A    0.1  -43A1/2
0073       :UN  M   40.2  -M  40.2
0074       :=   M   40.3  -M  40.3
0075       :UN  A    0.1  -43A1/2
0076       :=   M   40.2  -M  40.2
0077       :***

A    0.1 = 43A1/2                    UPPER EXTRUDER CONTROLLER RELEASE
M   40.2 = M  40.2                   UP.EXTR. : HF EXTRUDER OFF
M   40.3 = M  40.3                   UP.EXTR. : IMPULSE EXTRUDER OFF

NETZWERK 18          0078      RUN AFTER TIME AUX DRIVES
                       -M  40.4
                        +-----+
            -M  40.3 --!S    !
              +---+    !     !
 -201S1   ---!>=1!     !     !
 -43A1/2  ---!   !     !     !
 -T  42   ---!   !     !     !
 -M  40.1 --O!   !----!R   Q!-
              +---+    +-----+

M   40.3 = M  40.3                   UP.EXTR. : IMPULSE EXTRUDER OFF
M   40.4 = M  40.4                   UP.EXTR. : RUN AFTER TIME AUX DRIVES
E   80.0 = 201S1                     UP.EXTR. AUX DRIVE ON  (MAIN CONTR.PAN.)
A    0.1 = 43A1/2                    UPPER EXTRUDER CONTROLLER RELEASE
T   42   = T  42                     UP.EXTR. : RUN AFTER TIME AUX DRIVES
M   40.1 = M  40.1                   UP.EXTR. : AUXILIARY DRIVES ON

NETZWERK 19          0081      RUN AFTER TIME AUX DRIVES
            -T  42
             +-----+
 -M  40.4 --!T!-!0!
 KT 180.3 --!TW DU!-
             !   DE!-
           --!R   Q!-
             +-----+

M   40.4 = M  40.4                   UP.EXTR. : RUN AFTER TIME AUX DRIVES
T   42   = T  42                     UP.EXTR. : RUN AFTER TIME AUX DRIVES

NETZWERK 20          008A      OIL COOLING ON
             +---+
 -234S5   ---! & !    +------+
 -M  40.1 ---!   !--+-! =    ! -235B1
             +---+    +------+

E   20.4 = 234S5                     UPPER EXTRUDER OIL COOLING ON
M   40.1 = M  40.1                   UP.EXTR. : AUXILIARY DRIVES ON
A   20.0 = 235B1                     UPPER EXTRUDER OIL COOLING ON

NETZWERK 21          008E      WARNING : OILCOOLING IS ON
             +---+
 -234S5   ---! & !
 -235B1   ---!   !    +------+
 -M  40.1 ---!   !--+-! =    ! -M0247
             +---+    +------+

E   20.4 = 234S5                     UPPER EXTRUDER OIL COOLING ON
A   20.0 = 235B1                     UPPER EXTRUDER OIL COOLING ON
M   40.1 = M  40.1                   UP.EXTR. : AUXILIARY DRIVES ON
M  179.2 = M0247                     WARNING : OILCOOLING UPPER EXTR. IS ON

NETZWERK 22          0093      AUX DRIVES READY FOR WORK
             +---+
 -M   0.0 --O! & !
 -234S4   --O!   !
 -234S6   --O!   !    +------+
 -M  40.1 ---!   !--+-! =    ! -M  40.6
             +---+    +------+
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                    !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                    !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                    !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                    4!
+-----------------------------------------------------------------------------+
```

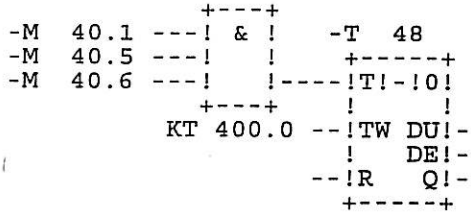
```
M    0.0 = M   0.0                    "0"-SIGNAL
E   20.3 = 234S4                      UPPER EXTRUDER OIL PRESSURE TO LOW
E   20.5 = 234S6                      UPPER EXTRUDER TEMP TO HIGH
M   40.1 = M  40.1                    UP.EXTR. : AUXILIARY DRIVES ON
M   40.6 = M  40.6                    UP.EXTR. : AUX DRIVES READY FOR WORK

NETZWERK 23          0099      LAMP UPPER EXTR. READY TO START
              +---+
 -204S3   ---!>=1!    +------+
 -M  40.6 ---!   !--+-! =    ! -209H1
              +---+    +------+

E   83.2 = 204S3                      LAMP TEST              (MAIN CONTR.PAN.)
M   40.6 = M  40.6                    UP.EXTR. : AUX DRIVES READY FOR WORK
A   80.0 = 209H1                      UP.EXT.READY TO START  (MAIN CONTR.PAN.)

NETZWERK 24          009D      FAULT : EXTRUDER OFF
              +---+
 -43A1.1  --O!>=1!
 -43A1.2  --O!   !
 -46Q1    ---!   !
 -46Q3    ---!   !
 -M0248   ---!   !
 -M0250   ---!   !
 -M0263   ---!   !
 -M   0.0 ---!   !
 -M0285   ---!   !
 -M0288   ---!   !
 -M0304   ---!   !
 -M0297   ---!   !   -M  42.5
 -M0346   ---!   !    +-----+
 -T  68   ---!   !----!S    !
             +---+    !     !
          -205S3.2 --!R   Q!-
                     +-----+

E    0.2 = 43A1.1                     UP.EXTR. DC-CONVERTER TEMP. CONTROL
E    0.3 = 43A1.2                     UP.EXTR. DC-CONVERTER FAULT
E    0.6 = 46Q1                       UP.EXTR. AUX DRIVE GEAR LUBR. FAULT
E    0.7 = 46Q3                       UP.EXTR. AUX DRIVE EXTERNAL FAN FAULT
M  179.3 = M0248                      NO RELEASE FROM EXTRUSION HEAD EXTR. OFF
M  179.5 = M0250                      PRESSURE DIFFERENCE BOTTOM EXTRUDER OFF
M  181.2 = M0263                      PRESSURE OIL LUBRICATION  UPPER EXTRUDER
M    0.0 = M   0.0                    "0"-SIGNAL
M  182.0 = M0285                      TEMP. OIL LUBRICATION     UPPER EXTRUDER
M  182.3 = M0288                      PRESSURE WATER-COOLING    UPPER EXTRUDER
M  184.3 = M0304                      LOW ARMATURE CURRENT      UPPER EXTRUDER
M  185.4 = M0297                      MAX EXTRUSION PRESS. EXCEEDED  CH1  DEH
M  191.5 = M0346                      CONTROL START             UPPER EXTRUDER
T   68   = T  68                      CONTROL TEMP. MAIN DRIVE UPPER EXTRUDER
M   42.5 = M  42.5                    UP.EXTR. : FAULT EXTRUDER OFF
E   84.3 = 205S3.2                    ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)

NETZWERK 25          00B0      NO TEMPERATURE RELEASE
             +---+   -M0333
 -201S3   ---! & !    +-----+
 -M  55.0 --O!   !----!S    !
             +---+    !     !
          -205S3.2 --!R   Q!-
                     +-----+

E   80.2 = 201S3                      UP.EXTR. START         (MAIN CONTR.PAN.)
M   55.0 = M  55.0                    RELEASE UPPER EXTR. FROM HEATING DEVICE
M  188.0 = M0333                      NO TEMPERATURE RELEASE    UPPER EXTRUDER
E   84.3 = 205S3.2                    ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
```

NETZWERK 26 00B7 UPPER EXTRUDER START



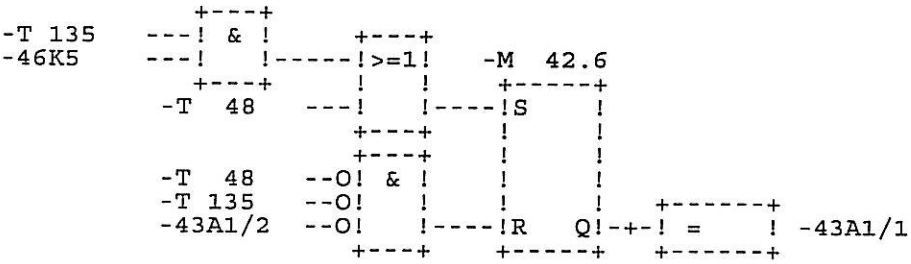
E	80.2 = 201S3	UP.EXTR. START	(MAIN CONTR.PAN.)
E	80.3 = 201S4	UP.EXTR. STOP	(MAIN CONTR.PAN.)
E	83.5 = 204S6.1	MANUAL	(MAIN CONTR.PAN.)
E	83.6 = 204S6.2	AUTOMATIC	(MAIN CONTR.PAN.)
M	41.1 = M 41.1	UP.EXTR. : CICLE UPPER EXTRUDER REVERSE	
A	0.5 = 46K5	UPPER EXTRUDER AUXILIARY DRIVES ON	
T	135 = T 135	START ALARM FOR AUTOMTIC START	
M	41.0 = M 41.0	UP.EXTR. : IMPULSE TOPM REVERSE START	
M	9.1 = M 9.1	CONTROL VOLTAGE IS ON	
M	41.2 = M 41.2	UP.EXTR. : RELEASE UPPER EXTRUDER	
M	40.5 = M 40.5	UP.EXTR. : EXTRUDER START	
T	46 = T 46	UP.EXTR. : FAULT MIN ARMATURE CURRENT	
T	47 = T 47	UP.EXTR. : REVERSE	
M	9.6 = M 9.6	PROGRAM STOP	
M	40.0 = M 40.0	UP.EXTR. : GENERAL FAULTS	
M	42.5 = M 42.5	UP.EXTR. : FAULT EXTRUDER OFF	

NETZWERK 27 00D0 START ALARM UPPER EXTRUDER



M	40.1 = M 40.1	UP.EXTR. : AUXILIARY DRIVES ON	
M	40.5 = M 40.5	UP.EXTR. : EXTRUDER START	
M	40.6 = M 40.6	UP.EXTR. : AUX DRIVES READY FOR WORK	
T	48 = T 48	UP.EXTR. : START ALARM	

NETZWERK 28 00DB MAINCONTACTOR ON



```
T  135   = T 135                    START ALARM FOR AUTOMTIC START
A    0.5 = 46K5                     UPPER EXTRUDER AUXILIARY DRIVES ON
T   48   = T  48                    UP.EXTR. : START ALARM
M   42.6 = M  42.6                  UP.EXTR. : MAINCONTACTOR ON
A    0.1 = 43A1/2                   UPPER EXTRUDER CONTROLLER RELEASE
A    0.0 = 43A1/1                   UPPER EXTRUDER ON/OFF

NETZWERK 29        00E6      CONTROLLER RELEASE + COOL. INLET
              +---+
 -T 135   ---! & !     +---+
 -46K5    ---!   !-----!>=1!
              +---+     !   !     +---+
           -T  48   ---!   !-----! & !
                       +---+     !   !    +------+
                    -45K1    ---!   !--+-! =    ! -43A1/2
                                +---+  ! +------+
                                       ! +------+
                                       +-! =    ! -235B2
                                         +------+

T  135   = T 135                    START ALARM FOR AUTOMTIC START
A    0.5 = 46K5                     UPPER EXTRUDER AUXILIARY DRIVES ON
T   48   = T  48                    UP.EXTR. : START ALARM
E    0.5 = 45K1                     UP.EXTR. MAIN CONTACTOR ATTRACTED
A    0.1 = 43A1/2                   UPPER EXTRUDER CONTROLLER RELEASE
A   20.1 = 235B2                    UPPER EXTRUDER COOLING INLET

NETZWERK 30        00EF      LAMP EXTRUDER ON
              +---+
 -204S3   ---!>=1!    +------+
 -43A1/2  ---!   !--+-! =    ! -209H2
              +---+    +------+

E   83.2 = 204S3                    LAMP TEST              (MAIN CONTR.PAN.)
A    0.1 = 43A1/2                   UPPER EXTRUDER CONTROLLER RELEASE
A   80.1 = 209H2                    UPPER EXTRUDER ON      (MAIN CONTR.PAN.)

NETZWERK 31        00F3      DISCHARGING UPPER EXTRUDER
              +---+
 -204S6.1 ---! & !
 -204S6.2 --O!   !   -M  41.3
 -205S6.2 ---!   !    +-----+
 -M  40.5 --O!   !----!S    !
              +---+    !     !
              +---+    !     !
 -205S6.2 --O! & !    !     !
 -M  40.5 --O!   !----!R   Q!-
              +---+    +-----+

E   83.5 = 204S6.1                  MANUAL                 (MAIN CONTR.PAN.)
E   83.6 = 204S6.2                  AUTOMATIC              (MAIN CONTR.PAN.)
E   84.5 = 205S6.2                  PRODUCT DISCHARGING    (MAIN CONTR.PAN.)
M   40.5 = M  40.5                  UP.EXTR. : EXTRUDER START
M   41.3 = M  41.3                  UP.EXTR. : DISCHARGING

NETZWERK 32        00FD      UPPER EXTRUDER CREEP
              +---+
 -45K3/1  ---!>=1!
 -M  41.1 ---!   !     +---+
 -M  41.3 ---!   !-----! & !
              +---+     !   !    +------+
           -43A1/2  ---!   !--+-! =    ! -43A1/3
                       +---+    +------+

A    0.3 = 45K3/1                   UPPER EXTRUDER RELAY REVERSE
M   41.1 = M  41.1                  UP.EXTR. : CICLE UPPER EXTRUDER REVERSE
M   41.3 = M  41.3                  UP.EXTR. : DISCHARGING
A    0.1 = 43A1/2                   UPPER EXTRUDER CONTROLLER RELEASE
A    0.2 = 43A1/3                   UPPER EXTRUDER CREEP

NETZWERK 33        0105      MIN ARMATURE CURRENT
0105      :A   DB 170    -DB 170              DB ACTUAL DATAT
0106      :L   DD  20                         ARMATURE CURRENT
0107      :L   KG +1000000+01                 10 A
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                    !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                    !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE        :                     !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER  :                     7!
+-----------------------------------------------------------------------------+
```

```
010A      :<=G
010B      :=   M  41.4  -M  41.4          JA >> MIN. CURRENT
010C      :***

M  41.4 = M  41.4                  UP.EXTR. : MIN ARMATURE CURRENT

DB 170   = DB 170                  ACTUAL DATAS

NETZWERK 34        010D      MIN ARMATURE CURRENT
              +---+   -T  46
 -43A1/2  ---! & !    +-----+
 -M  41.4 ---!   !----!T!-!0!
              +---+    !     !
           KT 200.2 --!TW DU!-
                      !   DE!-
                      !    !   +------+
                    --!R   Q!-+-! =    ! -M0304
                      +-----+   +------+

A    0.1 = 43A1/2                  UPPER EXTRUDER CONTROLLER RELEASE
M   41.4 = M  41.4                 UP.EXTR. : MIN ARMATURE CURRENT
T   46   = T  46                   UP.EXTR. : FAULT MIN ARMATURE CURRENT
M  184.3 = M0304                   LOW ARMATURE CURRENT      UPPER EXTRUDER

NETZWERK 35        0118      CHANGE SPEED UPPER EXTRUDER

                                  -FB  80
                                   +--------------+
                                   !   SLIT +/-   !
                     -DB 180  --!DBNR      SOLL!-- DD 18
                     -M   0.4 --!TAKT      H-DD!-- DD 128
                     -Z  52   --!ZAEH           !
                     -201S5.1 --!SIG+           !
                     -201S5.2 --!SIG-           !
                     005      --!XMAL           !
           +4800000+02        --!SMAX           !
           +4000000+01        --!SMIN           !
           +4000000+01        --!FMAX           !
           +1000000+01        --!FMIN           !
                     -M  41.5 --!MFL1           !
                     -M  41.6 --!MIM1           !
                     -M  41.7 --!HM2            !
                     -M  42.0 --!MFL2           !
                     -M  42.1 --!MIM2           !
                                +--------------+

M    0.4 = M   0.4                 TACT 1 HZ
Z   52   = Z  52                   UP.EXTR. : FASTER/SLOWLIER
E   80.4 = 201S5.1                 UP.EXTR. FASTER          (MAIN CONTR.PAN.)
E   80.5 = 201S5.2                 UP.EXTR. SLOWER          (MAIN CONTR.PAN.)
M   41.5 = M  41.5                 UP.EXTR. : HF FASTER/SLOWLIER
M   41.6 = M  41.6                 UP.EXTR. : HF FASTER/SLOWLIER
M   41.7 = M  41.7                 UP.EXTR. : HF FASTER/SLOWLIER
M   42.0 = M  42.0                 UP.EXTR. : HF FASTER/SLOWLIER
M   42.1 = M  42.1                 UP.EXTR. : HF FASTER/SLOWLIER

DB 180   = DB 180                  PROFILE AG

FB  80   = FB  80                  FASTER/SLOWLIER FOR 1 SWITCH

NETZWERK 36        0130      TRANSFER TO DB-CP
0130      :A   DB 185     -DB 185
0131      :U   E   80.4   -201S5.1
0132      :O   E   80.5   -201S5.2
0133      :U   D    1.11
0135      :SPB FB  58     -FB  58
0136 NAME :TRANS-DD
0137 DB-Q :    DB 180     -DB 180
0138 QUEL :    DD  18
0139 DB-Z :    DB 160     -DB 160
013A ZIEL :    DD  18
013B      :***
```

```
PB 20    -PB  20                          C:KERM06ST.S5D        BIB=8033    LAE=370

E    80.4 = 201S5.1                       UP.EXTR. FASTER        (MAIN CONTR.PAN.)
E    80.5 = 201S5.2                       UP.EXTR. SLOWER        (MAIN CONTR.PAN.)

DB 185    = DB 185                        PROFILE MANAGEMENT
DB 180    = DB 180                        PROFILE AG
DB 160    = DB 160                        PROFILE CP

FB  58    = FB  58                        TRANSFER DD-WORD

NETZWERK 37          013C       SPEED UPPER EXTRUDER

                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                       +128      --!PERE          !
                       DD 18     --!SOLL          !
             +5000000+02         --!EINH          !
                       -M    0.1 --!INVE          !
                       -M    0.1 --!FREI          !
                       -DB 180   --!DBNR          !
                                   +--------------+

M     0.1 = M    0.1                       "1"-SIGNAL

DB 180    = DB 180                        PROFILE AG

FB  44    = FB  44                        ANALOG OUTPUT

NETZWERK 38          0146       CALCULATE SPEED UPPER EXTRUDER

                                  -FB  48
                                   +--------------+
                                   !   DISP-10V   !
                       -DB 170   --!DBNR          !
                       DD 18     --!IN            !
                       DD 40     --!OUT           !
             +5500000+02         --!RANG          !
                       -43A1/2   --!RESE          !
                                   +--------------+

A     0.1 = 43A1/2                        UPPER EXTRUDER CONTROLLER RELEASE

DB 170    = DB 170                        ACTUAL DATAS

FB  48    = FB  48                        CALCULATION FOR ANALOG DISPLAY

NETZWERK 39          014F       DISPLAY SPEED UPPER EXTRUDER

                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                       +176      --!PERE          !
                       DD 40     --!SOLL          !
             +1000000+02         --!EINH          !
                       -M    0.0 --!INVE          !
                       -M    0.1 --!FREI          !
                       -DB 170   --!DBNR          !
                                   +--------------+

M     0.0 = M    0.0                       "0"-SIGNAL
M     0.1 = M    0.1                       "1"-SIGNAL

DB 170    = DB 170                        ACTUAL DATAS

FB  44    = FB  44                        ANALOG OUTPUT
```

NETZWERK 40 0159 CALCULATE CURRENT FOR DISPLAY

```
                                  -FB  48
                                   +--------------+
                                   !   DISP-10V   !
                        -DB 170  --!DBNR          !
                        DD 20    --!IN            !
                        DD 36    --!OUT           !
              +4920000+03        --!RANG          !
                        -43A1/2  --!RESE          !
                                   +--------------+
```

A 0.1 = 43A1/2 UPPER EXTRUDER CONTROLLER RELEASE

DB 170 = DB 170 ACTUAL DATAS

FB 48 = FB 48 CALCULATION FOR ANALOG DISPLAY

NETZWERK 41 0162 DISPLAY CURRENT UPPER EXTRUDER

```
                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                         +178     --!PERE          !
                         DD 36    --!SOLL          !
               +1000000+02        --!EINH          !
                         -M   0.0 --!INVE          !
                         -M   0.1 --!FREI          !
                         -DB 170  --!DBNR          !
                                   +--------------+
```

M 0.0 = M 0.0 "0"-SIGNAL
M 0.1 = M 0.1 "1"-SIGNAL

DB 170 = DB 170 ACTUAL DATAS

FB 44 = FB 44 ANALOG OUTPUT

NETZWERK 42 016C
016C :BE

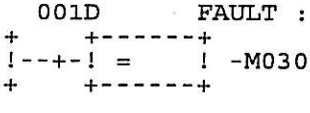
```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                  EXTRUDER TOPMACHINE : FORWARD <---> REVERSE                *
*                                                                             *
*******************************************************************************
0000      :AWL
0001      :***

NETZWERK 2          0002      PRESSURE CHANNEL 1 > 50 BAR
0002      :AWL
0003      :A   DB 170    -DB 170
0004      :L   DD 172
0005      :L   KG +5000000+02
0008      :>=G
0009      :=   M   42.2  -M  42.2
000A      :***

M   42.2 = M  42.2                    UP.EXTR. : PRESSURE >= 50 BAR

DB 170   = DB 170                     ACTUAL DATAS

NETZWERK 3          000B      CONDITION REVERSE
                          +---+
            -43A1/2  ---! & !    -M  42.3
            -45K3/2  ---!   !     +-----+
            -M  42.2 ---!   !-----!S    !
                          +---+   !     !
                          +---+   !     !
            -M  27.2 ---!>=1!     !     !
              +---+      !   !    !     !
 -43A1/2  ---! & !       !   !    !     !
 -45K3/1  ---!   !-------!   !----!R   Q!-
              +---+      +---+    +-----+

A    0.1 = 43A1/2                     UPPER EXTRUDER CONTROLLER RELEASE
A    0.4 = 45K3/2                     UPPER EXTRUDER RELAY FORWARD
M   42.2 = M  42.2                    UP.EXTR. : PRESSURE >= 50 BAR
M   42.3 = M  42.3                    UP.EXTR. : CONDITION REVERSE SET
M   27.2 = M  27.2                    PRESSURE CHANNEL 1 (UP.EXTR.) <= 15 BAR
A    0.3 = 45K3/1                     UPPER EXTRUDER RELAY REVERSE

NETZWERK 4          0016      START TOPMACHINE REVERSE
              +---+
 -250S41.2---!>=1!      +---+
 -250S42.2---!   !------! & !
              +---+      !   !
            -M  10.0 ---!   !   -M  41.1
            -M  40.1 --O!   !    +-----+
            -M  42.3 ---!   !----!S    !
                        +---+   !     !
                        +---+   !     !
            -T 136   ---!>=1!   !     !
            -M  40.0 ---!   !---!R   Q!-
                        +---+   +-----+

E   36.1 = 250S41.2                   SWITCH : OPEN CLAMPING
E   36.3 = 250S42.2                   SWITCH : OPEN CLAMP.FOR FINAL DIE CHANGE
M   10.0 = M  10.0                    CLAMPING CLOSED
M   40.1 = M  40.1                    UP.EXTR. : AUXILIARY DRIVES ON
M   42.3 = M  42.3                    UP.EXTR. : CONDITION REVERSE SET
M   41.1 = M  41.1                    UP.EXTR. : CICLE UPPER EXTRUDER REVERSE
T  136   = T 136                      UP.EXTR.: WAIT AFTER CHANGE REVERSE/FORW
M   40.0 = M  40.0                    UP.EXTR. : GENERAL FAULTS

NETZWERK 5          0023      WAIT AFTER FIELD OFF
           -T 139
            +-----+
 -M  41.1 --!T!-!0!
 KT 020.1 --!TW DU!-
            !   DE!-
          --!R   Q!-
            +-----+
```

```
M   41.1 = M  41.1                    UP.EXTR. : CICLE UPPER EXTRUDER REVERSE
T  139   = T 139                      UP.EXTR.: WAIT AFTER FIELD OFF

NETZWERK 6          002C      WAIT AFTER CHANGE FORW/REVERSE
              +---+    -T 138
 -T 139   ---! & !     +-----+
 -M  41.1 ---!   !-----!T!-!0!
              +---+     !     !
           KT 020.1 --!TW DU!-
                      !   DE!-
                    --!R   Q!-
                      +-----+

T  139   = T 139                      UP.EXTR.: WAIT AFTER FIELD OFF
M   41.1 = M  41.1                    UP.EXTR. : CICLE UPPER EXTRUDER REVERSE
T  138   = T 138                      UP.EXTR.: WAIT AFTER CHANGE FORW/REVERSE

NETZWERK 7          0036      IMPULSE EXTRUDER START
0036       :AWL
0037       :U   T  138    -T 138
0038       :UN  M   42.4  -M  42.4
0039       :=   M   41.0  -M  41.0
003A       :U   T  138    -T 138
003B       :=   M   42.4  -M  42.4
003C       :***

T  138   = T 138                      UP.EXTR.: WAIT AFTER CHANGE FORW/REVERSE
M   42.4 = M  42.4                    UP.EXTR. : HF IMPULSE START
M   41.0 = M  41.0                    UP.EXTR. : IMPULSE TOPM REVERSE START

NETZWERK 8          003D      TIME TOPMACHINE REVERSE
              +---+
 -43A1/2  ---! & !   -T  47
 -T 138   ---!   !    +-----+
 -M  41.1 ---!   !----!T!-!0!
              +---+    !     !
           KT 005.2 --!TW DU!-
                      !   DE!-
                    --!R   Q!-
                      +-----+

A    0.1 = 43A1/2                     UPPER EXTRUDER CONTROLLER RELEASE
T  138   = T 138                      UP.EXTR.: WAIT AFTER CHANGE FORW/REVERSE
M   41.1 = M  41.1                    UP.EXTR. : CICLE UPPER EXTRUDER REVERSE
T   47   = T  47                      UP.EXTR. : REVERSE

NETZWERK 9          0048      WAIT AFTER FIELD OFF
              +---+
 -T  47   --O! & !
 -T 138   ---!   !   -T 137
 -M  40.1 --O!   !    +-----+
 -M  41.1 ---!   !----!T!-!0!
              +---+    !     !
           KT 020.1 --!TW DU!-
                      !   DE!-
                    --!R   Q!-
                      +-----+

T   47   = T  47                      UP.EXTR. : REVERSE
T  138   = T 138                      UP.EXTR.: WAIT AFTER CHANGE FORW/REVERSE
M   40.1 = M  40.1                    UP.EXTR. : AUXILIARY DRIVES ON
M   41.1 = M  41.1                    UP.EXTR. : CICLE UPPER EXTRUDER REVERSE
T  137   = T 137                      UP.EXTR.: WAIT AFTER FIELD OFF

NETZWERK 10         0054      WAIT AFTER CHANGE REVERSE/FORW
              +---+   -T 136
 -T 137   ---! & !    +-----+
 -M  41.1 ---!   !----!T!-!0!
              +---+    !     !
           KT 020.1 --!TW DU!-
                      !   DE!-
                    --!R   Q!-
                      +-----+
```

```
PB 21   -PB  21                          C:KERM06ST.S5D        BIB=5112    LAE=117

T  137    = T 137                        UP.EXTR.: WAIT AFTER FIELD OFF
M   41.1 = M  41.1                       UP.EXTR. : CICLE UPPER EXTRUDER REVERSE
T  136    = T 136                        UP.EXTR.: WAIT AFTER CHANGE REVERSE/FORW

NETZWERK 11          005E      CICLE CONTROL TOPMACHINE REVERSE
             -T  41
              +-----+
 -M  41.1 --!T!-!0!
 KT 040.2 --!TW DU!-
           !   DE!-
          --!R   Q!-
            +-----+

M    41.1 = M  41.1                      UP.EXTR. : CICLE UPPER EXTRUDER REVERSE
T    41   = T  41                        UP.EXTR. : CONTROL REVERSE

NETZWERK 12          0067      TOPMACHINE REVERSE
              +---+
 -T 137    --O! & !    +------+
 -T 139    ---!   !--+-! =    ! -45K3/1
              +---+    +------+

T  137    = T 137                        UP.EXTR.: WAIT AFTER FIELD OFF
T  139    = T 139                        UP.EXTR.: WAIT AFTER FIELD OFF
A    0.3  = 45K3/1                       UPPER EXTRUDER RELAY REVERSE

NETZWERK 13          006B      TOPMACHINE FORWARD
              +---+    +------+
 -45K3/1   --O! & !--+-! =    ! -45K3/2
              +---+    +------+

A    0.3  = 45K3/1                       UPPER EXTRUDER RELAY REVERSE
A    0.4  = 45K3/2                       UPPER EXTRUDER RELAY FORWARD

NETZWERK 14          006E
006E       :AWL
006F       :BE
```

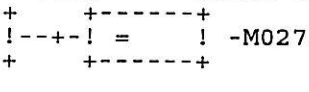
```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                              EXTRUDER BOTTOMMACHINE                         *
*                                                                             *
*******************************************************************************
0000      :***

NETZWERK 2          0001      FAULT : OIL LUBRICATION
              +---+    +------+
 -51Q1     ---! & !--+-! =    ! -M0291
              +---+    +------+

E    1.6 = 51Q1                          BOT.EXTR. AUX DRIVE GEAR LUBR. FAULT
M  182.6 = M0291                         MOTOR OIL PUMP FAULT     BOTTOM EXTRUDER

NETZWERK 3          0004      FAULT : EXTERNAL FAN
              +---+    +------+
 -51Q3     ---! & !--+-! =    ! -M0275
              +---+    +------+

E    1.7 = 51Q3                          BOT.EXTR. AUX DRIVE EXTERNAL FAN FAULT
M  180.6 = M0275                         DRIVE MOTOR EXTERNAL FAN BOTTOM EXTRUDER

NETZWERK 4          0007      FAULT : CARBON BRUSH CONTROL
              +---+    +------+
 -50A3.2   ---! & !--+-! =    ! -M0280
              +---+    +------+

E    1.1 = 50A3.2                        BOT.EXTR. CARBON BRUSH CONTROL
M  183.3 = M0280                         MAIN DRIVE CARBON BRUSH  BOTTOM EXTRUDER

NETZWERK 5          000A      FAULT : WATER-COOLING
              +---+
 -239S2    --O! & !    +------+
 -A  1.1   ---!   !--+-! =    ! -M0289
              +---+    +------+

E   25.1 = 239S2                         BOTTOM EXTRUDER WATERCOOLING
A    1.1 = A  1.1                        BOTTOM EXTRUDER CONTROLLER RELEASE
M  182.4 = M0289                         PRESSURE WATER-COOLING   BOTTOM EXTRUDER

NETZWERK 6          000E      FAULT : TEMP. MAIN DRIVE
              +---+    +------+
 -50A3.1   --O! & !--+-! =    ! -M0277
              +---+    +------+

E    1.0 = 50A3.1                        BOT.EXTR. EXCESS TEMP MOT WINDING
M  183.0 = M0277                         MAIN DRIVE TEMP. FAULT   BOTTOM EXTRUDER

NETZWERK 7          0011      FAULT : MOTOR WINDING EXTR. OFF
           -T  69
            +-----+
 -50A3.1  -O!T!-!0!
 KT 300.2 --!TW DU!-
            !   DE!-
           --!R   Q!-
            +-----+

E    1.0 = 50A3.1                        BOT.EXTR. EXCESS TEMP MOT WINDING
T   69   = T  69                         CONTROL TEMP. MAIN DRIVE BOTTOM EXTRUDER

NETZWERK 8          001A      FAULT : TEMP. DC-CONVERTER
              +---+    +------+
 -48A1.1   --O! & !--+-! =    ! -M0283
              +---+    +------+

E    1.2 = 48A1.1                        BOT.EXTR. DC-CONVERTER TEMP. CONTROL
M  183.6 = M0283                         DC-CONVERTER TEMP. FAULT BOTTOM EXTRUDER
```

NETZWERK 9 001D FAULT : DC-CONVERTER



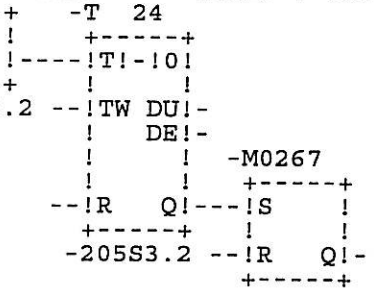
E 1.3 = 48A1.2 BOT.EXTR. DC-CONVERTER FAULT
M 184.1 = M0302 DC-CONVERTER FAULT BOTTOM EXTRUDER

NETZWERK 10 0020 FAULT : E-STOP HOPPER



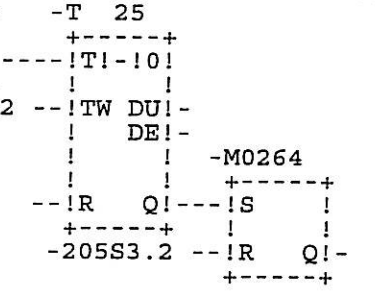
E 25.0 = A420 BOTTOM EXTRUDER E-STOP HOPPER
M 180.2 = M0271 E-STOP HOPPER BOTTOM EXTRUDER

NETZWERK 11 0023 FAULT : OIL FLOW TO LOW



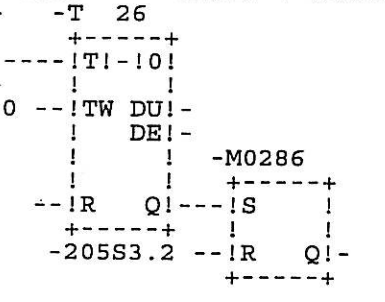
E 25.2 = 239S3 BOTTOM EXTRUDER OIL FLOW TO LOW
A 1.5 = A 1.5 BOTTOM EXTRUDER AUXILIARY DRIVES ON
T 24 = T 24 BOT.EXTR. : FAULT OIL FLOW TO LOW
M 181.6 = M0267 OIL FLOW OIL LUBRICATION BOTTOM EXTRUDER
E 84.3 = 205S3.2 ACKNOWLEDGING FAULT (MAIN CONTR.PAN.)

NETZWERK 12 0031 FAULT : PRESSURE TO LOW



E 25.3 = 239S4 BOTTOM EXTRUDER OIL PRESSURE TO LOW
A 1.5 = A 1.5 BOTTOM EXTRUDER AUXILIARY DRIVES ON
T 25 = T 25 BOT.EXTR. : FAULT PRESSURE OIL
M 181.3 = M0264 PRESSURE OIL LUBRICATION BOTTOM EXTRUDER
E 84.3 = 205S3.2 ACKNOWLEDGING FAULT (MAIN CONTR.PAN.)

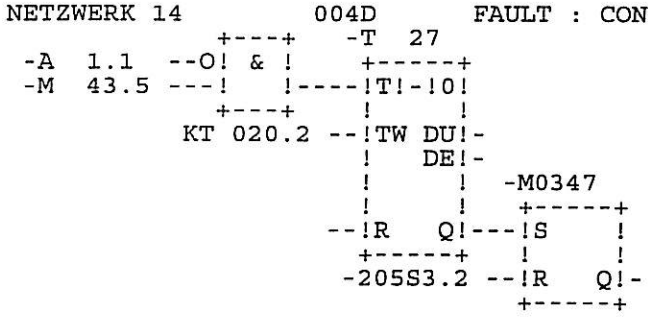
NETZWERK 13 003F FAULT : TEMP. TO HIGH EXTR. OFF



E 25.5 = 239S6 BOTTOM EXTRUDER TEMP TO HIGH

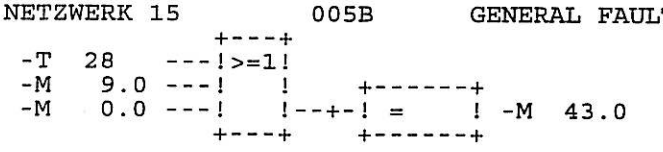
```
A    1.5 = A  1.5                    BOTTOM EXTRUDER AUXILIARY DRIVES ON
T   26   = T  26                     BOT.EXTR. : FAULT TEMPERATURE TO HIGH
M  182.1 = M0286                    TEMP. OIL LUBRICATION    BOTTOM EXTRUDER
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
```

NETZWERK 14 004D FAULT : CONTROL START



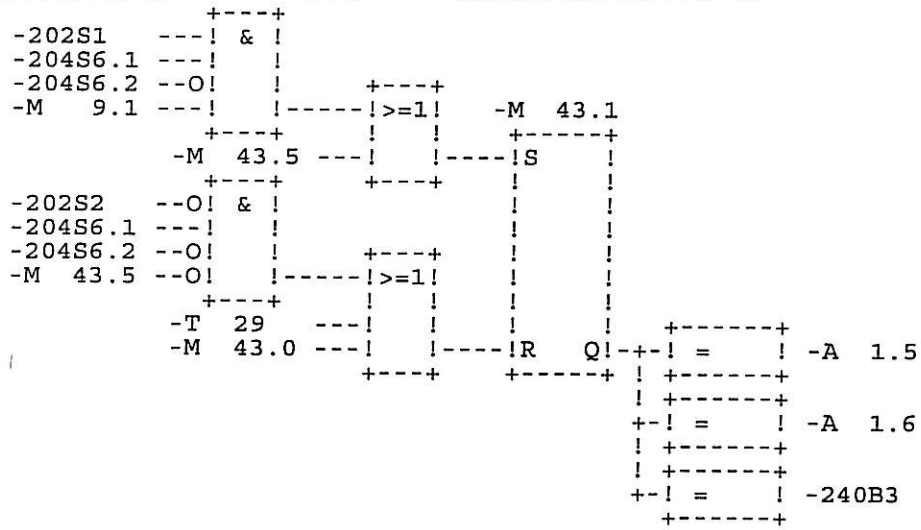

```
A    1.1 = A  1.1                    BOTTOM EXTRUDER CONTROLLER RELEASE
M   43.5 = M  43.5                   BOT.EXTR. : EXTRUDER START
T   27   = T  27                     BOT.EXTR. : CONTROL START
M  191.6 = M0347                    CONTROL START            BOTTOM EXTRUDER
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
```

NETZWERK 15 005B GENERAL FAULTS BOTTOM EXTR.




```
T   28   = T  28                     BOT.EXTR. : CONTROL REVERSE
M    9.0 = M   9.0                   E-STOP TRIGGERED
M    0.0 = M   0.0                   "0"-SIGNAL
M   43.0 = M  43.0                   BOT.EXTR. : GENERAL FAULTS
```

NETZWERK 16 0060 AUXILIARY DRIVES ON

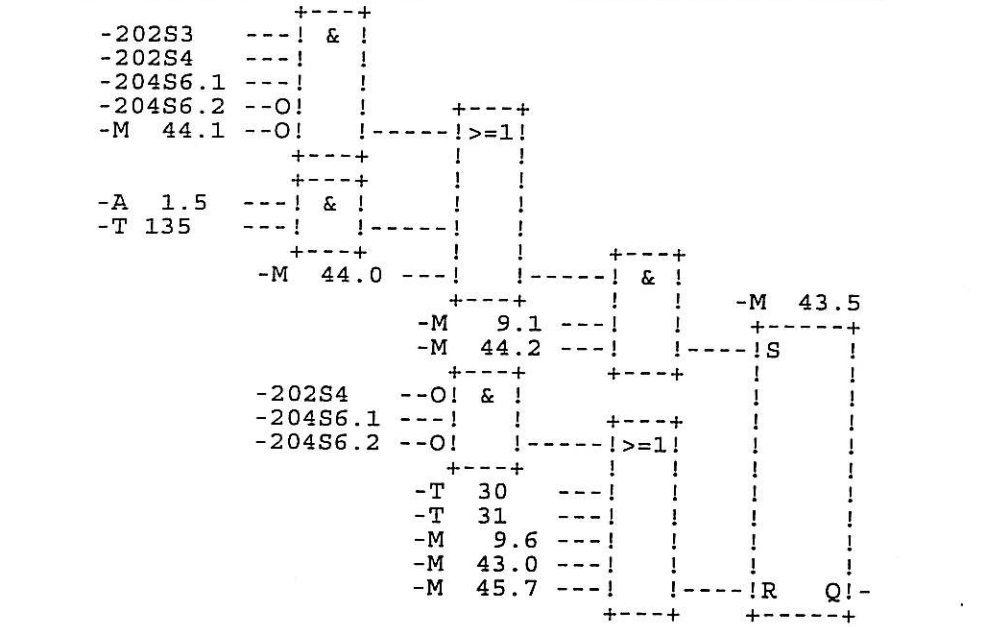



```
E   81.0 = 202S1                    BOT.EXTR. AUX DRIVE ON  (MAIN CONTR.PAN.)
E   83.5 = 204S6.1                  MANUAL                  (MAIN CONTR.PAN.)
E   83.6 = 204S6.2                  AUTOMATIC               (MAIN CONTR.PAN.)
M    9.1 = M   9.1                  CONTROL VOLTAGE IS ON
M   43.5 = M  43.5                  BOT.EXTR. : EXTRUDER START
M   43.1 = M  43.1                  BOT.EXTR. : AUXILIARY DRIVES ON
E   81.1 = 202S2                    BOT.EXTR. AUX DRIVE OFF(MAIN CONTR.PAN.)
T   29   = T  29                     BOT.EXTR. : RUN AFTER TIME AUX DRIVES
M   43.0 = M  43.0                  BOT.EXTR. : GENERAL FAULTS
A    1.5 = A  1.5                   BOTTOM EXTRUDER AUXILIARY DRIVES ON
```

```
A    1.6 = A  1.6                    BOTTOM EXTRUDER FIELD ON
A   25.2 = 240B3                     BOTTOM EXTRUDER WATER COOLING

NETZWERK 17          0072       IMPULSE BOTTOM EXTRUDER OFF
0072       :UN  A    1.1  -A  1.1
0073       :UN  M   43.2  -M  43.2
0074       :=   M   43.3  -M  43.3
0075       :UN  A    1.1  -A  1.1
0076       :=   M   43.2  -M  43.2
0077       :***

A    1.1 = A  1.1                    BOTTOM EXTRUDER CONTROLLER RELEASE
M   43.2 = M  43.2                   BOT.EXTR. : HF EXTRUDER OFF
M   43.3 = M  43.3                   BOT.EXTR. : IMPULSE EXTRUDER OFF

NETZWERK 18          0078       RUN AFTER TIME AUX DRIVES
                       -M  43.4
                        +-----+
            -M  43.3 --!S    !
              +---+    !     !
 -202S1   ---!>=1!     !     !
 -A  1.1  ---!   !     !     !
 -T  29   ---!   !     !     !
 -M  43.1 --O!   !----!R   Q!-
              +---+    +-----+

M   43.3 = M  43.3                   BOT.EXTR. : IMPULSE EXTRUDER OFF
M   43.4 = M  43.4                   BOT.EXTR. : RUN AFTER TIME AUX DRIVES
E   81.0 = 202S1                     BOT.EXTR. AUX DRIVE ON (MAIN CONTR.PAN.)
A    1.1 = A  1.1                    BOTTOM EXTRUDER CONTROLLER RELEASE
T   29   = T  29                     BOT.EXTR. : RUN AFTER TIME AUX DRIVES
M   43.1 = M  43.1                   BOT.EXTR. : AUXILIARY DRIVES ON

NETZWERK 19          0081       RUN AFTER TIME AUX DRIVES
            -T  29
             +-----+
 -M  43.4 --!T!-!0!
 KT 180.3 --!TW DU!-
            !   DE!-
          --!R   Q!-
             +-----+

M   43.4 = M  43.4                   BOT.EXTR. : RUN AFTER TIME AUX DRIVES
T   29   = T  29                     BOT.EXTR. : RUN AFTER TIME AUX DRIVES

NETZWERK 20          008A       OIL COOLING ON
             +---+
 -239S5   ---! & !    +------+
 -M  43.1 ---!   !--+-! =    ! -240B1
             +---+    +------+

E   25.4 = 239S5                     BOTTOM EXTRUDER OIL COOLING ON
M   43.1 = M  43.1                   BOT.EXTR. : AUXILIARY DRIVES ON
A   25.0 = 240B1                     BOTTOM EXTRUDER OIL COOLING ON

NETZWERK 21          008E       WARNING : OILCOOLING IS ON
             +---+
 -239S5   ---! & !
 -240B1   ---!   !    +------+
 -M  43.1 ---!   !--+-! =    ! -M0246
             +---+    +------+

E   25.4 = 239S5                     BOTTOM EXTRUDER OIL COOLING ON
A   25.0 = 240B1                     BOTTOM EXTRUDER OIL COOLING ON
M   43.1 = M  43.1                   BOT.EXTR. : AUXILIARY DRIVES ON
M  179.1 = M0246                     WARNING : OILCOOLING BOTTOM EXTR. IS ON

NETZWERK 22          0093       AUX DRIVES READY TO START
             +---+
 -M   0.0 --O! & !
 -239S4   ---!   !
 -239S6   --O!   !    +------+
 -M  43.1 ---!   !--+-! =    ! -M  43.6
             +---+    +------+
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                    !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                    !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE        :                     !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER  :                     4!
+-----------------------------------------------------------------------------+
```

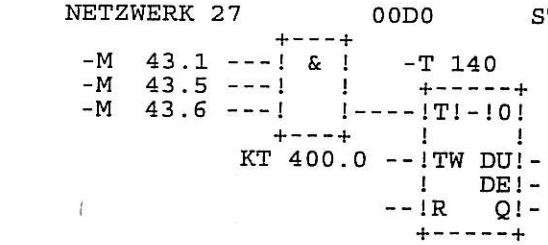
```
M    0.0 = M   0.0                    "0"-SIGNAL
E   25.3 = 239S4                      BOTTOM EXTRUDER OIL PRESSURE TO LOW
E   25.5 = 239S6                      BOTTOM EXTRUDER TEMP TO HIGH
M   43.1 = M  43.1                    BOT.EXTR. : AUXILIARY DRIVES ON
M   43.6 = M  43.6                    BOT.EXTR. : AUX DRIVES READY FOR WORK

NETZWERK 23          0099      LAMP BOTTOM EXTR. READY TO START
                +---+
 -204S3    ---!>=1!    +------+
 -M  43.6 ---!   !--+-! =    ! -209H3
                +---+    +------+

E   83.2 = 204S3                      LAMP TEST              (MAIN CONTR.PAN.)
M   43.6 = M  43.6                    BOT.EXTR. : AUX DRIVES READY FOR WORK
A   80.2 = 209H3                      BOT.EXT.READY TO START (MAIN CONTR.PAN.)

NETZWERK 24          009D      FAULT : EXTRUDER OFF
                +---+
 -48A1.1   --O!>=1!
 -48A1.2   --O!   !
 -51Q1     ---!   !
 -51Q3     ---!   !
 -M0248    ---!   !
 -M0251    ---!   !
 -M0264    ---!   !
 -M   0.0  ---!   !
 -M0286    ---!   !
 -M0289    ---!   !
 -M0305    ---!   !
 -M0298    ---!   !   -M  45.7
 -M0347    ---!   !    +-----+
 -T  69    ---!   !----!S    !
              +---+    !     !
           -205S3.2 --!R   Q!-
                      +-----+

E    1.2 = 48A1.1                     BOT.EXTR. DC-CONVERTER TEMP. CONTROL
E    1.3 = 48A1.2                     BOT.EXTR. DC-CONVERTER FAULT
E    1.6 = 51Q1                       BOT.EXTR. AUX DRIVE GEAR LUBR. FAULT
E    1.7 = 51Q3                       BOT.EXTR. AUX DRIVE EXTERNAL FAN FAULT
M  179.3 = M0248                      NO RELEASE FROM EXTRUSION HEAD EXTR. OFF
M  179.6 = M0251                      PRESSURE DIFFERENCE UPPER EXTRUDER OFF
M  181.3 = M0264                      PRESSURE OIL LUBRICATION BOTTOM EXTRUDER
M    0.0 = M   0.0                    "0"-SIGNAL
M  182.1 = M0286                      TEMP. OIL LUBRICATION    BOTTOM EXTRUDER
M  182.4 = M0289                      PRESSURE WATER-COOLING   BOTTOM EXTRUDER
M  184.4 = M0305                      LOW ARMATURE CURRENT     BOTTOM EXTRUDER
M  185.5 = M0298                      MAX EXTRUSION PRESS. EXCEEDED  CH2  DEH
M  191.6 = M0347                      CONTROL START            BOTTOM EXTRUDER
T   69   = T  69                      CONTROL TEMP. MAIN DRIVE BOTTOM EXTRUDER
M   45.7 = M  45.7                    BOT.EXTR. : FAULT EXTRUDER OFF
E   84.3 = 205S3.2                    ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)

NETZWERK 25          00B0      NO TEMPERATURE RELEASE
             +---+   -M0334
 -202S3   ---! & !    +-----+
 -M  55.1 --O!   !----!S    !
             +---+    !     !
          -205S3.2 --!R   Q!-
                     +-----+

E   81.2 = 202S3                      BOT.EXTR. START        (MAIN CONTR.PAN.)
M   55.1 = M  55.1                    RELEASE BOTTOM EXTR. FROM HEATING DEVICE
M  188.1 = M0334                      NO TEMPERATURE RELEASE   BOTTOM EXTRUDER
E   84.3 = 205S3.2                    ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
```

NETZWERK 26 00B7 BOTTOM EXTRUDER START



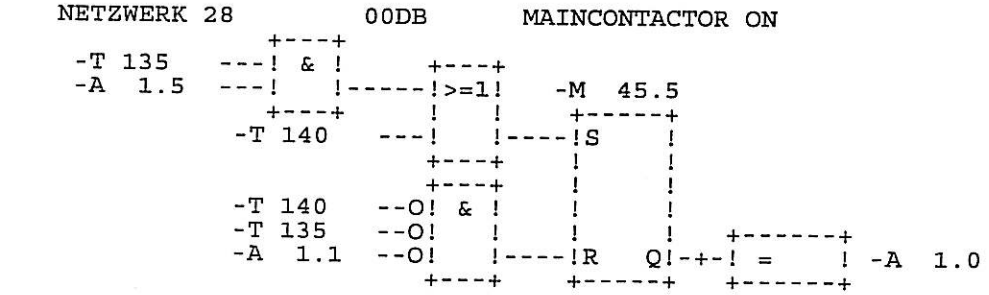
E	81.2 = 202S3	BOT.EXTR. START	(MAIN CONTR.PAN.)
E	81.3 = 202S4	BOT.EXTR. STOP	(MAIN CONTR.PAN.)
E	83.5 = 204S6.1	MANUAL	(MAIN CONTR.PAN.)
E	83.6 = 204S6.2	AUTOMATIC	(MAIN CONTR.PAN.)
M	44.1 = M 44.1	BOT.EXTR. : CICLE BOTTOM EXTR. REVERSE	
A	1.5 = A 1.5	BOTTOM EXTRUDER AUXILIARY DRIVES ON	
T	135 = T 135	START ALARM FOR AUTOMTIC START	
M	44.0 = M 44.0	BOT.EXTR. : IMPULSE BOTTOM EXTR. START	
M	9.1 = M 9.1	CONTROL VOLTAGE IS ON	
M	44.2 = M 44.2	BOT.EXTR. : RELEASE BOTTOM EXTRUDER	
M	43.5 = M 43.5	BOT.EXTR. : EXTRUDER START	
T	30 = T 30	BOT.EXTR. : REVERSE	
T	31 = T 31	BOT.EXTR. : FAULT MIN ARMATURE CURRENT	
M	9.6 = M 9.6	PROGRAM STOP	
M	43.0 = M 43.0	BOT.EXTR. : GENERAL FAULTS	
M	45.7 = M 45.7	BOT.EXTR. : FAULT EXTRUDER OFF	

NETZWERK 27 00D0 START ALARM BOTTOM EXTRUDER



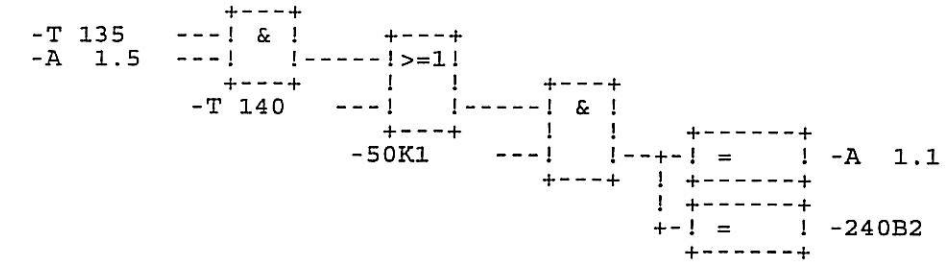
M	43.1 = M 43.1	BOT.EXTR. : AUXILIARY DRIVES ON	
M	43.5 = M 43.5	BOT.EXTR. : EXTRUDER START	
M	43.6 = M 43.6	BOT.EXTR. : AUX DRIVES READY FOR WORK	
T	140 = T 140	BOT.EXTR.: START ALARM	

NETZWERK 28 00DB MAINCONTACTOR ON



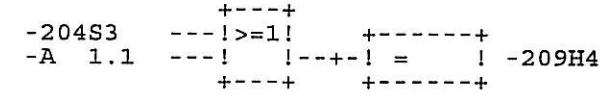
```
T  135   = T 135          START ALARM FOR AUTOMTIC START
A    1.5 = A  1.5        BOTTOM EXTRUDER AUXILIARY DRIVES ON
T  140   = T 140          BOT.EXTR.: START ALARM
M   45.5 = M  45.5        BOT.EXTR. : MAINCONTACTOR ON
A    1.1 = A  1.1         BOTTOM EXTRUDER CONTROLLER RELEASE
A    1.0 = A  1.0         BOTTOM EXTRUDER ON/OFF
```

```
NETZWERK 29        00E6      CONTROLLER RELEASE + COOL.INLET
```



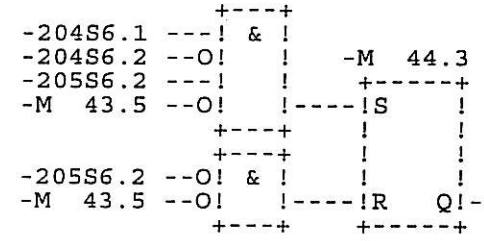

```
T  135   = T 135          START ALARM FOR AUTOMTIC START
A    1.5 = A  1.5        BOTTOM EXTRUDER AUXILIARY DRIVES ON
T  140   = T 140          BOT.EXTR.: START ALARM
E    1.5 = 50K1           BOT.EXTR. MAIN CONTACTOR ATTRACTED
A    1.1 = A  1.1         BOTTOM EXTRUDER CONTROLLER RELEASE
A   25.1 = 240B2          BOTTOM EXTRUDER COOLING INLET
```

```
NETZWERK 30        00EF      LAMP EXTRUDER ON
```



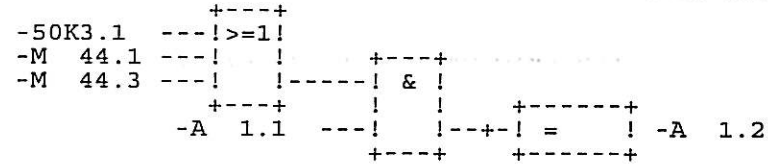

```
E   83.2 = 204S3          LAMP TEST              (MAIN CONTR.PAN.)
A    1.1 = A  1.1         BOTTOM EXTRUDER CONTROLLER RELEASE
A   80.3 = 209H4          BOTTOM EXTRUDER ON     (MAIN CONTR.PAN.)
```

```
NETZWERK 31        00F3      DISCHARGING BOTTOM EXTRUDER
```




```
E   83.5 = 204S6.1        MANUAL                 (MAIN CONTR.PAN.)
E   83.6 = 204S6.2        AUTOMATIC              (MAIN CONTR.PAN.)
E   84.5 = 205S6.2        PRODUCT DISCHARGING    (MAIN CONTR.PAN.)
M   43.5 = M  43.5        BOT.EXTR. : EXTRUDER START
M   44.3 = M  44.3        BOT.EXTR. : DISCHARGING
```

```
NETZWERK 32        00FD      BOTTOM EXTRUDER CREEP
```




```
A    1.3 = 50K3.1         BOTTOM EXTRUDER RELAY REVERSE
M   44.1 = M  44.1        BOT.EXTR. : CICLE BOTTOM EXTR. REVERSE
M   44.3 = M  44.3        BOT.EXTR. : DISCHARGING
A    1.1 = A  1.1         BOTTOM EXTRUDER CONTROLLER RELEASE
A    1.2 = A  1.2         BOTTOM EXTRUDER CREEP
```

```
NETZWERK 33        0105      MIN ARMATURE CURRENT
0105      :A   DB 170    -DB 170          DB ACTUAL DATA
0106      :L   DD  24                     ARMATURE CURRENT
0107      :L   KG +1000000+01             10 A
```

```
PB 30   -PB  30                          C:KERM06ST.S5D        BIB=8033    LAE=370

010A       :<=G
010B       :=    M   44.4  -M  44.4                YES >> MIN. CURRENT
010C       :***

M   44.4 = M  44.4                       BOT.EXTR. : MIN ARMATURE CURRENT

DB 170   = DB 170                        ACTUAL DATAS

NETZWERK 34          010D       MIN ARMATURE CURRENT
                +---+    -T  31
 -A  1.1   ---! & !     +-----+
 -M  44.4  ---!   !-----!T!-!0!
               +---+     !     !
            KT 200.2 --!TW DU!-
                       !   DE!-
                       !     !   +------+
                     --!R   Q!-+-! =    ! -M0305
                       +-----+   +------+

A    1.1 = A  1.1                        BOTTOM EXTRUDER CONTROLLER RELEASE
M   44.4 = M  44.4                       BOT.EXTR. : MIN ARMATURE CURRENT
T   31   = T  31                         BOT.EXTR. : FAULT MIN ARMATURE CURRENT
M  184.4 = M0305                         LOW ARMATURE CURRENT     BOTTOM EXTRUDER

NETZWERK 35          0118       EXTRUDER FASTER/SLOWER

                                    -FB  80
                                    +--------------+
                                    !   SLIT +/-   !
                      -DB 180   --!DBNR       SOLL!-- DD 22
                      -M   0.4  --!TAKT       H-DD!-- DD 130
                      -Z  53    --!ZAEH            !
                      -202S5.1  --!SIG+            !
                      -202S5.2  --!SIG-            !
                      005       --!XMAL            !
             +5500000+02        --!SMAX            !
             +4000000+01        --!SMIN            !
             +4000000+01        --!FMAX            !
             +1000000+01        --!FMIN            !
                      -M  44.5  --!MFL1            !
                      -M  44.6  --!MIM1            !
                      -M  44.7  --!HM2             !
                      -M  45.0  --!MFL2            !
                      -M  45.1  --!MIM2            !
                                  +--------------+

M    0.4 = M   0.4                       TACT 1 HZ
Z   53   = Z  53                         BOT.EXTR. : FASTER/SLOWLIER
E   81.4 = 202S5.1                       BOT.EXTR. FASTER        (MAIN CONTR.PAN.)
E   81.5 = 202S5.2                       BOT.EXTR. SLOWER        (MAIN CONTR.PAN.)
M   44.5 = M  44.5                       BOT.EXTR. : HF FASTER/SLOWLIER
M   44.6 = M  44.6                       BOT.EXTR. : HF FASTER/SLOWLIER
M   44.7 = M  44.7                       BOT.EXTR. : HF FASTER/SLOWLIER
M   45.0 = M  45.0                       BOT.EXTR. : HF FASTER/SLOWLIER
M   45.1 = M  45.1                       BOT.EXTR. : HF FASTER/SLOWLIER

DB 180   = DB 180                        PROFILE AG

FB  80   = FB  80                        FASTER/SLOWLIER FOR 1 SWITCH

NETZWERK 36          0130       TRANSFER TO DB-CP
0130       :A   DB 185     -DB 185
0131       :U   E   81.4   -202S5.1
0132       :O   E   81.5   -202S5.2
0133       :U   D    1.11
0135       :SPB FB  58     -FB  58
0136 NAME  :TRANS-DD
0137 DB-Q  :    DB 180     -DB 180
0138 QUEL  :    DD  22
0139 DB-Z  :    DB 160     -DB 160
013A ZIEL  :    DD  22
013B       :***
```

```
E   81.4 = 202S5.1                  BOT.EXTR. FASTER       (MAIN CONTR.PAN.)
E   81.5 = 202S5.2                  BOT.EXTR. SLOWER       (MAIN CONTR.PAN.)

DB 185   = DB 185                   PROFILE MANAGEMENT
DB 180   = DB 180                   PROFILE AG
DB 160   = DB 160                   PROFILE CP

FB  58   = FB  58                   TRANSFER DD-WORD

NETZWERK 37         013C      SPEED EXTRUDER BOTTOM EXTRUDER

                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                      +130      --!PERE          !
                      DD 22     --!SOLL          !
           +5800000+02          --!EINH          !
                      -M   0.1  --!INVE          !
                      -M   0.1  --!FREI          !
                      -DB 180   --!DBNR          !
                                   +--------------+

M    0.1 = M   0.1                  "1"-SIGNAL

DB 180   = DB 180                   PROFILE AG

FB  44   = FB  44                   ANALOG OUTPUT

NETZWERK 38         0146      CALCULATE SPEED FOR DISPLAY

                                  -FB  48
                                   +--------------+
                                   !   DISP-10V   !
                      -DB 170   --!DBNR          !
                      DD 22     --!IN            !
                      DD 42     --!OUT           !
           +6450000+02          --!RANG          !
                      -A  1.1   --!RESE          !
                                   +--------------+

A    1.1 = A  1.1                   BOTTOM EXTRUDER CONTROLLER RELEASE

DB 170   = DB 170                   ACTUAL DATAS

FB  48   = FB  48                   CALCULATION FOR ANALOG DISPLAY

NETZWERK 39         014F      DISPLAY SPEED BOTTOM EXTRUDER

                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                      +180      --!PERE          !
                      DD 42     --!SOLL          !
          +1000000+02           --!EINH          !
                      -M   0.0  --!INVE          !
                      -M   0.1  --!FREI          !
                      -DB 170   --!DBNR          !
                                   +--------------+

M    0.0 = M   0.0                  "0"-SIGNAL
M    0.1 = M   0.1                  "1"-SIGNAL

DB 170   = DB 170                   ACTUAL DATAS

FB  44   = FB  44                   ANALOG OUTPUT
```

NETZWERK 40 0159 CALCULATE CURRENT FOR DISPLAY

```
                                  -FB  48
                                   +--------------+
                                   !   DISP-10V   !
                       -DB 170  --!DBNR          !
                       DD 24    --!IN            !
                       DD 38    --!OUT           !
             +2570000+03        --!RANG          !
                       -A  1.1  --!RESE          !
                                   +--------------+
```

```
A    1.1 = A  1.1                    BOTTOM EXTRUDER CONTROLLER RELEASE

DB 170   = DB 170                    ACTUAL DATAS

FB  48   = FB  48                    CALCULATION FOR ANALOG DISPLAY
```

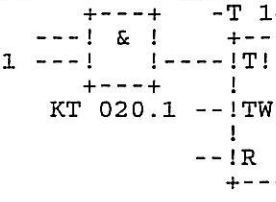
NETZWERK 41 0162 DISPLAY CURRENT BOTTOM EXTRUDER

```
                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                       +182     --!PERE          !
                       DD 38    --!SOLL          !
             +1000000+02        --!EINH          !
                       -M   0.0 --!INVE          !
                       -M   0.1 --!FREI          !
                       -DB 170  --!DBNR          !
                                   +--------------+
```

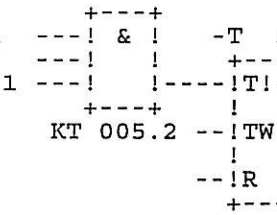
```
M    0.0 = M   0.0                   "0"-SIGNAL
M    0.1 = M   0.1                   "1"-SIGNAL

DB 170   = DB 170                    ACTUAL DATAS

FB  44   = FB  44                    ANALOG OUTPUT
```

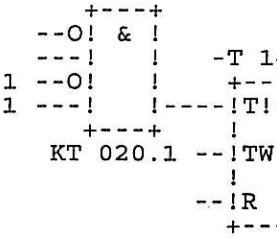
NETZWERK 42 016C
016C :BE

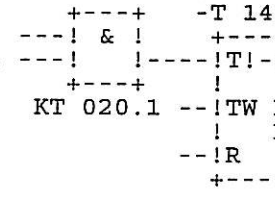
```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                EXTRUDER BOTTOMMACHINE : FORWARD <---> REVERSE               *
*                                                                             *
*******************************************************************************
0000       :AWL
0001       :***

NETZWERK 2          0002       PRESSURE CHANNEL 2 > 50 BAR
0002       :AWL
0003       :A    DB 170     -DB 170
0004       :L    DD 174
0005       :L    KG +5000000+02
0008       :>=G
0009       :=    M   45.2   -M  45.2
000A       :***

M   45.2 = M  45.2                      BOT.EXTR. : PRESSURE >= 50 BAR

DB 170   = DB 170                       ACTUAL DATAS

NETZWERK 3          000B       CONDITION REVERSE
                          +---+
            -A  1.1   ---! & !    -M  45.3
            -50K3.2   ---!   !     +-----+
            -M  45.2  ---!   !-----!S    !
                          +---+     !     !
                          +---+     !     !
            -M  27.3  ---!>=1!     !     !
              +---+       !   !     !     !
 -A  1.1   ---! & !       !   !     !     !
 -50K3.1   ---!   !-------!   !-----!R   Q!-
              +---+       +---+     +-----+

A    1.1 = A  1.1                       BOTTOM EXTRUDER CONTROLLER RELEASE
A    1.4 = 50K3.2                       BOTTOM EXTRUDER RELAY FORWARD
M   45.2 = M  45.2                      BOT.EXTR. : PRESSURE >= 50 BAR
M   45.3 = M  45.3                      BOT.EXTR. : CONDITION REVERSE SET
M   27.3 = M  27.3                      PRESSURE CHANNEL 2 (BOT.EXTR.) <= 15 BAR
A    1.3 = 50K3.1                       BOTTOM EXTRUDER RELAY REVERSE

NETZWERK 4          0016       START BOTTOM MACHINE REVERSE
              +---+
 -250S41.2---!>=1!      +---+
 -250S42.2---!   !------! & !
              +---+      !   !
            -M  10.0 ---!   !    -M  44.1
            -M  43.1 --O!   !     +-----+
            -M  45.3 ---!   !-----!S    !
                        +---+     !     !
                        +---+     !     !
            -T 141   ---!>=1!     !     !
            -M  43.0 ---!   !-----!R   Q!-
                        +---+     +-----+

E   36.1 = 250S41.2                     SWITCH : OPEN CLAMPING
E   36.3 = 250S42.2                     SWITCH : OPEN CLAMP.FOR FINAL DIE CHANGE
M   10.0 = M  10.0                      CLAMPING CLOSED
M   43.1 = M  43.1                      BOT.EXTR. : AUXILIARY DRIVES ON
M   45.3 = M  45.3                      BOT.EXTR. : CONDITION REVERSE SET
M   44.1 = M  44.1                      BOT.EXTR. : CICLE BOTTOM EXTR. REVERSE
T  141   = T 141                        BOT.EXTR.: WAIT AFTER CHANGE REVERSE/FOR
M   43.0 = M  43.0                      BOT.EXTR. : GENERAL FAULTS

NETZWERK 5          0023       WAIT AFTER FIELD OFF
            -T 142
             +-----+
 -M  44.1 --!T!-!0!
 KT 020.1 --!TW DU!-
             !   DE!-
           --!R   Q!-
             +-----+
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE         :                      !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO! !
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER   :                    1! !
+-------------------------------------------------------------------------------+
```



```
M   44.1 = M  44.1                    BOT.EXTR. : CICLE BOTTOM EXTR. REVERSE
T  142   = T 142                      BOT.EXTR.: WAIT AFTER FIELD OFF

NETZWERK 6          002C      WAIT AFTER CHANGE FORW/REVERSE
              +---+   -T 143
 -T 142   ---! & !    +-----+
 -M  44.1 ---!   !----!T!-!0!
              +---+    !     !
           KT 020.1 --!TW DU!-
                      !   DE!-
                    --!R   Q!-
                      +-----+

T  142   = T 142                      BOT.EXTR.: WAIT AFTER FIELD OFF
M   44.1 = M  44.1                    BOT.EXTR. : CICLE BOTTOM EXTR. REVERSE
T  143   = T 143                      BOT.EXTR.: WAIT AFTER CHANGE FORW/REVERS

NETZWERK 7          0036      IMPULSE EXTRUDER START
0036       :AWL
0037       :U   T  143    -T 143
0038       :UN  M   45.6  -M  45.6
0039       :=   M   44.0  -M  44.0
003A       :U   T  143    -T 143
003B       :=   M   45.6  -M  45.6
003C       :***

T  143   = T 143                      BOT.EXTR.: WAIT AFTER CHANGE FORW/REVERS
M   45.6 = M  45.6                    BOT.EXTR. : HF IMPULSE START
M   44.0 = M  44.0                    BOT.EXTR. : IMPULSE BOTTOM EXTR. START

NETZWERK 8          003D      TIME EXTRUDER REVERSE
              +---+
 -A  1.1  ---! & !   -T  30
 -T 143   ---!   !    +-----+
 -M  44.1 ---!   !----!T!-!0!
              +---+    !     !
           KT 005.2 --!TW DU!-
                      !   DE!-
                    --!R   Q!-
                      +-----+

A    1.1 = A  1.1                     BOTTOM EXTRUDER CONTROLLER RELEASE
T  143   = T 143                      BOT.EXTR.: WAIT AFTER CHANGE FORW/REVERS
M   44.1 = M  44.1                    BOT.EXTR. : CICLE BOTTOM EXTR. REVERSE
T   30   = T  30                      BOT.EXTR. : REVERSE

NETZWERK 9          0048      WAIT AFTER FIELD OFF
              +---+
 -T  30   --O! & !
 -T 143   ---!   !   -T 144
 -M  43.1 --O!   !    +-----+
 -M  44.1 ---!   !----!T!-!0!
              +---+    !     !
           KT 020.1 --!TW DU!-
                      !   DE!-
                    --!R   Q!-
                      +-----+

T   30   = T  30                      BOT.EXTR. : REVERSE
T  143   = T 143                      BOT.EXTR.: WAIT AFTER CHANGE FORW/REVERS
M   43.1 = M  43.1                    BOT.EXTR. : AUXILIARY DRIVES ON
M   44.1 = M  44.1                    BOT.EXTR. : CICLE BOTTOM EXTR. REVERSE
T  144   = T 144                      BOT.EXTR.: WAIT AFTER FIELD OFF

NETZWERK 10         0054      WAIT AFTER CHANGE REVERSE/FORW
              +---+   -T 141
 -T 144   ---! & !    +-----+
 -M  44.1 ---!   !----!T!-!0!
              +---+    !     !
           KT 020.1 --!TW DU!-
                      !   DE!-
                    --!R   Q!-
                      +-----+
```







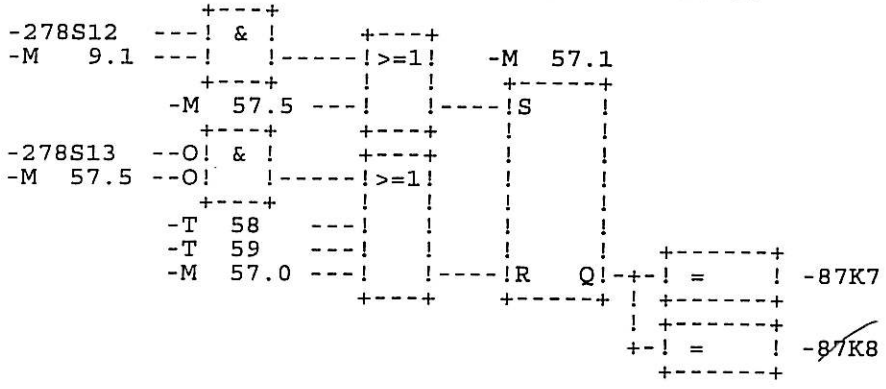
```
PB 31   -PB  31                          C:KERM06ST.S5D        BIB=28012   LAE=117

T  144   = T 144                         BOT.EXTR.: WAIT AFTER FIELD OFF
M   44.1 = M  44.1                       BOT.EXTR. : CICLE BOTTOM EXTR. REVERSE
T  141   = T 141                         BOT.EXTR.: WAIT AFTER CHANGE REVERSE/FOR

NETZWERK 11          005E      CICLE CONTROL EXTRUDER REVERSE
            -T  28
             +-----+
 -M  44.1 --!T!-!0!
 KT 040.2 --!TW DU!-
            !   DE!-
           --!R   Q!-
             +-----+

M   44.1 = M  44.1                       BOT.EXTR. : CICLE BOTTOM EXTR. REVERSE
T   28   = T  28                         BOT.EXTR. : CONTROL REVERSE

NETZWERK 12          0067      BOTTOM MACHINE REVERSE
               +---+
 -T 144   --O! & !    +------+
 -T 142   ---!   !--+-! =    ! -50K3.1
               +---+    +------+

T  144   = T 144                         BOT.EXTR.: WAIT AFTER FIELD OFF
T  142   = T 142                         BOT.EXTR.: WAIT AFTER FIELD OFF
A    1.3 = 50K3.1                        BOTTOM EXTRUDER RELAY REVERSE

NETZWERK 13          006B      BOTTOM MACHINE FORWARD
               +---+    +------+
 -50K3.1  --O! & !--+-! =    ! -50K3.2
               +---+    +------+

A    1.3 = 50K3.1                        BOTTOM EXTRUDER RELAY REVERSE
A    1.4 = 50K3.2                        BOTTOM EXTRUDER RELAY FORWARD

NETZWERK 14          006E
006E       :AWL
006F       :BE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                                EXTRUDER 3                                 *
*                                                                           *
*****************************************************************************
0000      :***

NETZWERK 2          0001      FAULT : OIL LUBRICATION
              +---+    +------+
 -87Q1     ---! & !--+-! =    ! -M0262
              +---+    +------+

E    3.6 = 87Q1                          EXTR.CAL. AUX DRIVE GEAR LUBR. FAULT
M  181.1 = M0262                         DRIVE MOTOR OIL PUMP   EXTRUDER CALENDER

NETZWERK 3          0004      FAULT : EXTERNAL FAN OUTSIDE
              +---+    +------+
 -87Q3     ---! & !--+-! =    ! -M0276
              +---+    +------+

E    3.7 = 87Q3                          EXTR.CAL. AUX DRIVE EXT.FAN FAULT OUTS.
M  180.7 = M0276                         DRIVE MOTOR EXTERNAL FAN OUT. EXTR. CAL.

NETZWERK 4          0007      FAULT : EXTERNAL FAN INSIDE
              +---+    +------+
 -87Q5     ---! & !--+-! =    ! -M0261
              +---+    +------+

E    4.0 = 87Q5                          EXTR.CAL. AUX DRIVE EXT.FAN FAULT INSIDE
M  181.0 = M0261                         DRIVE MOTOR EXTERNAL FAN INS. EXTR. CAL.

NETZWERK 5          000A      FAULT : MAIN DRIVE CURRENT
              +---+    +------+
 -86A3     --O! & !--+-! =    ! -M0281
              +---+    +------+

E    3.1 = 86A3                          EXTR.CAL. EXCESS TEMP MOT WINDING
M  183.4 = M0281                         MAIN DRIVE CARBON BRUSH   EXTR. CALENDER

NETZWERK 6          000D      FAULT : MOTOR WINDING EXTR. OFF
            -T  70
             +-----+
 -86A3     -O!T!-!0!
 KT 300.2 --!TW DU!-
           !   DE!-
          --!R   Q!-
            +-----+

E    3.1 = 86A3                          EXTR.CAL. EXCESS TEMP MOT WINDING
T   70   = T  70                         CONTROL TEMP. MAIN DRIVE EXTR. CALENDER

NETZWERK 7          0016      FAULT : CARBON BRUSH CONTROL
              +---+    +------+
 -86A6     ---! & !--+-! =    ! -M0278
              +---+    +------+

E    9.0 = 86A6                          EXTR.CAL. CARBON BRUSH CONTROL
M  183.1 = M0278                         MAIN DRIVE TEMP. FAULT EXTRUDER CALENDER

NETZWERK 8          0019      FAULT : TEMP. DC-CONVERTER
              +---+    +------+
 -84A1/1   --O! & !--+-! =    ! -M0284
              +---+    +------+

E    3.2 = 84A1/1                        EXTR.CAL. TEMPERATURE CONTROL
M  183.7 = M0284                         DC-CONVERTER TEMP. FAULT  EXTR. CALENDER

NETZWERK 9          001C      FAULT : DC-CONVERTER
              +---+    +------+
 -84A1/2   --O! & !--+-! =    ! -M0303
              +---+    +------+
```

```
E    3.3 = 84A1/2                    EXTR.CAL. DC-CONVERTER FAULT
M  184.2 = M0303                     DC-CONVERTER FAULT     EXTRUDER CALENDER

NETZWERK 10          001F       FAULT : E-STOP PANEL
              +---+     +------+
 -A700.8   ---! & !--+-! =    ! -M0273
              +---+     +------+

E   55.6 = A700.8                    E-STOP                        (EXTR.CAL.PAN.)
M  180.4 = M0273                     E-STOP  OPERATOR PANEL     EXTR. CALENDER

NETZWERK 11          0022       FAULT : E-STOP HOPPER
              +---+     +------+
 -A700.6   ---! & !--+-! =    ! -M0272
              +---+     +------+

E   54.1 = A700.6                    EXTRUDER CALENDER HOPPER E-STOP
M  180.3 = M0272                     E-STOP HOPPER                EXTR. CALENDER

NETZWERK 12          0025       FAULT : OIL FLOW TO LOW
            +---+    -T  53
 -277S2   --O! & !    +-----+
 -87K7    ---!   !----!T!-!0!
            +---+     !     !
          KT 010.2 --!TW DU!-
                     !   DE!-
                     !     !   +------+
                   --!R   Q!-+-! =    ! -M0268
                     +-----+   +------+

E   54.2 = 277S2                     EXTRUDER CALENDER OIL FLOW TO LOW
A    4.7 = 87K7                      EXTRUDER CALENDER AUX DRIVES ON/OFF
T   53   = T  53                     EXTR.CAL. : FAULT OIL FLOW TO LOW
M  181.7 = M0268                     OIL FLOW OIL LUBRICATION  EXTR. CALENDER

NETZWERK 13          0030       FAULT : PRESSURE TO LOW
            +---+    -T  54
 -277S3   --O! & !    +-----+
 -87K7    ---!   !----!T!-!0!
            +---+     !     !
          KT 010.2 --!TW DU!-
                     !   DE!-
                     !     !  -M0265
                     !     !   +-----+
                   --!R   Q!---!S    !
                     +-----+   !     !
                  -205S3.2 --!R   Q!-
                               +-----+

E   54.3 = 277S3                     EXTRUDER CALENDER PRESSURE TO LOW
A    4.7 = 87K7                      EXTRUDER CALENDER AUX DRIVES ON/OFF
T   54   = T  54                     EXTR.CAL. : FAULT OIL PRESSURE TO LOW
M  181.4 = M0265                     PRESSURE OIL LUBRICATION  EXTR. CALENDER
E   84.3 = 205S3.2                   ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)

NETZWERK 14          003E       FAULT : TEMPERATURE TO HIGH
            +---+    -T  55
 -277S5   ---! & !    +-----+
 -87K7    ---!   !----!T!-!0!
            +---+     !     !
          KT 010.2 --!TW DU!-
                     !   DE!-
                     !     !  -M0287
                     !     !   +-----+
                   --!R   Q!---!S    !
                     +-----+   !     !
                  -205S3.2 --!R   Q!-
                               +-----+

E   54.5 = 277S5                     EXTRUDER CALENDER MAX OIL TEMP
A    4.7 = 87K7                      EXTRUDER CALENDER AUX DRIVES ON/OFF
```

```
T   55   = T  55                    EXTR.CAL. : FAULT MAX OIL TEMP
M  182.2 = M0287                   TEMP. OIL LUBRICATION  EXTRUDER CALENDER
E   84.3 = 205S3.2                 ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)

NETZWERK 15        004C      FAULT : CONTROL START
              +---+   -T  56
 -84A1.2  --O! & !    +-----+
 -M  57.5 ---!   !----!T!-!0!
              +---+    !     !
           KT 020.2 --!TW DU!-
                      !   DE!-
                      !     !  -M0348
                      !     !   +-----+
                    --!R   Q!---!S    !
                      +-----+   !     !
                     -205S3.2 --!R   Q!-
                               +-----+

A    4.4 = 84A1.2                  EXTRUDER CALENDER CONTROLLER RELEASE
M   57.5 = M  57.5                 EX.CAL. : EXTRUDER START
T   56   = T  56                   EXTR.CAL. : FAULT START CONTROL
M  191.7 = M0348                   CONTROL START          EXTRUDER CALENDER
E   84.3 = 205S3.2                 ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)

NETZWERK 16        005A      IMPULSE FOR MATERIAL
005A      :U   E   54.7  -277B1
005B      :UN  M   61.5  -M  61.5
005C      :=   M   61.6  -M  61.6
005D      :U   E   54.7  -277B1
005E      :=   M   61.5  -M  61.5
005F      :***

E   54.7 = 277B1                   EXTRUDER CALENDER HOPPER PULSE GENERATOR
M   61.5 = M  61.5                 EX.CAL. : HF MATERIAL OK
M   61.6 = M  61.6                 EX.CAL. : IMPULSE MATERIAL OK

NETZWERK 17        0060      NO MATERIAL
             +---+
 -84A1.2  ---! & !   -T  52
 -M  61.6 --O!   !    +-----+
 -278S8   --O!   !----!T!-!0!
             +---+    !     !
          KT 015.2 --!TW DU!-
                     !   DE!-
                     !     !   +------+
                   --!R   Q!-+-! =    ! -M0233
                     +-----+   +------+

A    4.4 = 84A1.2                  EXTRUDER CALENDER CONTROLLER RELEASE
M   61.6 = M  61.6                 EX.CAL. : IMPULSE MATERIAL OK
E   55.7 = 278S8                   PRODUCT DISCHARG.          (EXTR.CAL.PAN.)
T   52   = T  52                   EXTR.CAL. : NO MATERIAL
M  177.4 = M0233                   NO MATERIAL                 EXTR. CALENDER

NETZWERK 18        006C      GENERAL FAULTS EXTRUDER 3
             +---+
 -T  57   ---!>=1!
 -M   9.0 ---!   !    +------+
 -M0268   ---!   !--+-! =    ! -M  57.0
             +---+    +------+

T   57   = T  57                   EXTR.CAL. : FAULT CONTROL REVERSE
M    9.0 = M   9.0                 E-STOP TRIGGERED
M  181.7 = M0268                   OIL FLOW OIL LUBRICATION  EXTR. CALENDER
M   57.0 = M  57.0                 EX.CAL. : GENERAL FAULT EXTRUDER 3
```

NETZWERK 19 0071 AUXILIARY DRIVES ON



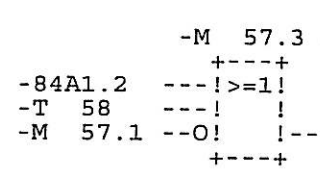
A 5.7

```
E   55.2 = 278S12                    EXTRUDER AUX DRIVES ON    (EXTR.CAL.PAN.)
M    9.1 = M   9.1                   CONTROL VOLTAGE IS ON
M   57.5 = M  57.5                   EX.CAL. : EXTRUDER START
M   57.1 = M  57.1                   EX.CAL. : AUX DRIVES ON
E   55.3 = 278S13                    EXTRUDER AUX DRIVES OFF   (EXTR.CAL.PAN.)
T   58   = T  58                     EXTR.CAL. : RUN AFTER TIME AUX DRIVES
T   59   = T  59                     EXTR.CAL. : REVERSE
M   57.0 = M  57.0                   EX.CAL. : GENERAL FAULT EXTRUDER 3
A    4.7 = 87K7                      EXTRUDER CALENDER AUX DRIVES ON/OFF
A    2.7 = 87K8                      EXTRUDER CALENDER FIELD ON
```

```
NETZWERK 20        007F      IMPULSE EXTRUDER 3 OFF
007F      :UN  A    4.4  -84A1.2
0080      :UN  M   57.2  -M  57.2
0081      :=   M   57.3  -M  57.3
0082      :UN  A    4.4  -84A1.2
0083      :=   M   57.2  -M  57.2
0084      :***
```

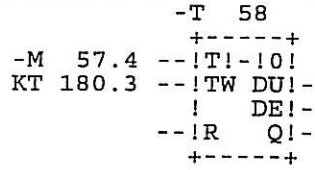
```
A    4.4 = 84A1.2                    EXTRUDER CALENDER CONTROLLER RELEASE
M   57.2 = M  57.2                   EX.CAL. : HF EXTRUDER 3 OFF
M   57.3 = M  57.3                   EX.CAL. : IMPULSE EXTRUDER 3 OFF
```

NETZWERK 21 0085 RUN AFTER TIME AUX DRIVES



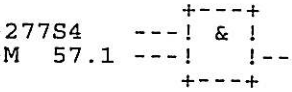

```
M   57.3 = M  57.3                   EX.CAL. : IMPULSE EXTRUDER 3 OFF
M   57.4 = M  57.4                   EX.CAL. : RUN AFTER TIME AUX DRIVES
A    4.4 = 84A1.2                    EXTRUDER CALENDER CONTROLLER RELEASE
T   58   = T  58                     EXTR.CAL. : RUN AFTER TIME AUX DRIVES
M   57.1 = M  57.1                   EX.CAL. : AUX DRIVES ON
```

NETZWERK 22 008D RUN AFTER TIME AUX DRIVES



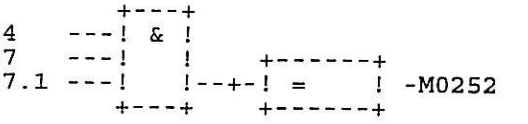

```
M   57.4 = M  57.4                   EX.CAL. : RUN AFTER TIME AUX DRIVES
T   58   = T  58                     EXTR.CAL. : RUN AFTER TIME AUX DRIVES
```

NETZWERK 23 0096 OIL COOLING ON



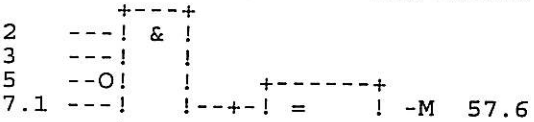
```
E   54.4 = 277S4                    EXTRUDER CALENDER TEMP. OILCOOLING
M   57.1 = M  57.1                  EX.CAL. : AUX DRIVES ON
A   50.6 = 279B7                    EXTRUDER CALENDER OIL COOLING ON
```

NETZWERK 24 009A WARNING : OILCOOLING IS ON



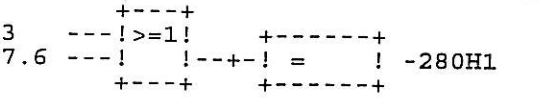

```
E   54.4 = 277S4                    EXTRUDER CALENDER TEMP. OILCOOLING
A   50.6 = 279B7                    EXTRUDER CALENDER OIL COOLING ON
M   57.1 = M  57.1                  EX.CAL. : AUX DRIVES ON
M  179.7 = M0252                    WARNING : OILCOOLING EXTR.CALENDER IS ON
```

NETZWERK 25 009F AUX DRIVES READY FOR WORK



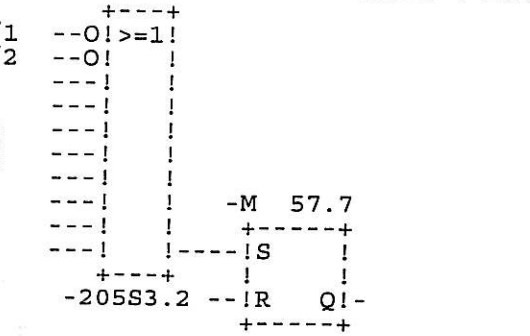

```
E   54.2 = 277S2                    EXTRUDER CALENDER OIL FLOW TO LOW
E   54.3 = 277S3                    EXTRUDER CALENDER PRESSURE TO LOW
E   54.5 = 277S5                    EXTRUDER CALENDER MAX OIL TEMP
M   57.1 = M  57.1                  EX.CAL. : AUX DRIVES ON
M   57.6 = M  57.6                  EX.CAL. : AUX DRIVES READY FOR WORK
```

NETZWERK 26 00A5 LAMP EXTRUDER 3 READY FOR WORK



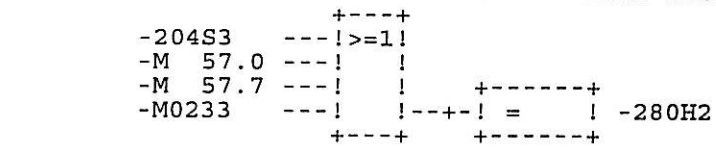

```
E   83.2 = 204S3                    LAMP TEST                (MAIN CONTR.PAN.)
M   57.6 = M  57.6                  EX.CAL. : AUX DRIVES READY FOR WORK
A   51.0 = 280H1                    EXT.READY TO START (LAMP)(EXTR.CAL.PAN.)
```

NETZWERK 27 00A9 FAULT : EXTRUDER OFF



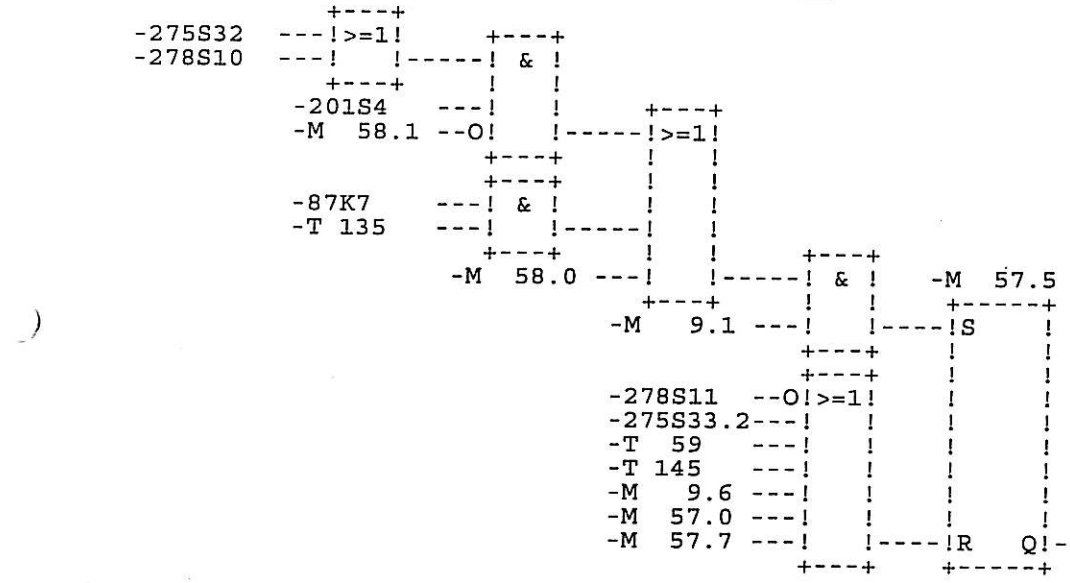

```
E    3.2 = 84A1/1                   EXTR.CAL. TEMPERATURE CONTROL
E    3.3 = 84A1/2                   EXTR.CAL. DC-CONVERTER FAULT
E    3.6 = 87Q1                     EXTR.CAL. AUX DRIVE GEAR LUBR. FAULT
E    3.7 = 87Q3                     EXTR.CAL. AUX DRIVE EXT.FAN FAULT OUTS.
M  179.7 = M0252                    WARNING : OILCOOLING EXTR.CALENDER IS ON
M  181.4 = M0265                    PRESSURE OIL LUBRICATION  EXTR. CALENDER
M  182.2 = M0287                    TEMP. OIL LUBRICATION  EXTRUDER CALENDER
M  184.5 = M0306                    LOW ARMATURE CURRENT   EXTRUDER CALENDER
M  191.7 = M0348                    CONTROL START          EXTRUDER CALENDER
T   70   = T  70                    CONTROL TEMP. MAIN DRIVE EXTR. CALENDER
M   57.7 = M  57.7                  EX.CAL. : FAULT EXTRUDER OFF
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
```

NETZWERK 28 00B8 LAMP FAULT



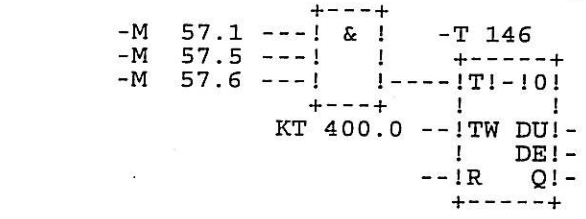
E	83.2 = 204S3	LAMP TEST	(MAIN CONTR.PAN.)
M	57.0 = M 57.0	EX.CAL. : GENERAL FAULT EXTRUDER 3	
M	57.7 = M 57.7	EX.CAL. : FAULT EXTRUDER OFF	
M	177.4 = M0233	NO MATERIAL	EXTR. CALENDER
A	51.1 = 280H2	EXTRUDER FAULT (LAMP)	(EXTR.CAL.PAN.)

NETZWERK 29 00BE EXTRUDER 3 START



E	52.6 = 275S32	START EXTRUDER + FEEDER	(HOPPER STATION)
E	55.0 = 278S10	EXTRUDER START	(EXTR.CAL.PAN.)
E	80.3 = 201S4	UP.EXTR. STOP	(MAIN CONTR.PAN.)
M	58.1 = M 58.1	EX.CAL. : CICLE EXTRUDER REVERSE	
A	4.7 = 87K7	EXTRUDER CALENDER AUX DRIVES ON/OFF	
T	135 = T 135	START ALARM FOR AUTOMTIC START	
M	58.0 = M 58.0	EX.CAL. : IMPULSE EXTRUDER REVERSE START	
M	9.1 = M 9.1	CONTROL VOLTAGE IS ON	
M	57.5 = M 57.5	EX.CAL. : EXTRUDER START	
E	55.1 = 278S11	EXTRUDER STOP	(EXTR.CAL.PAN.)
E	52.7 = 275S33.2	STOP EXTRUDER + FEEDER	(HOPPER STATION)
T	59 = T 59	EXTR.CAL. : REVERSE	
T	145 = T 145	EXTR.CAL. : FAULT MIN ARMATURE CURRENT	
M	9.6 = M 9.6	PROGRAM STOP	
M	57.0 = M 57.0	EX.CAL. : GENERAL FAULT EXTRUDER 3	
M	57.7 = M 57.7	EX.CAL. : FAULT EXTRUDER OFF	

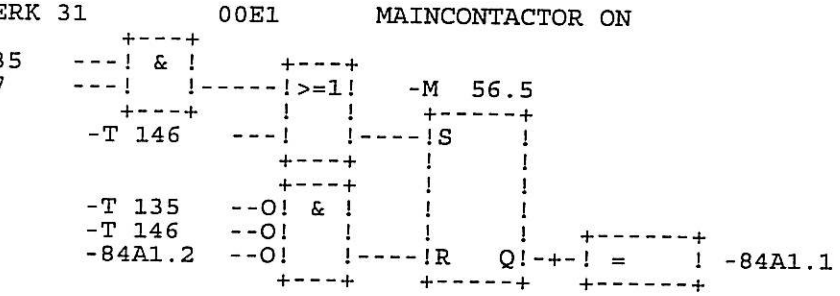
NETZWERK 30 00D6 START ALARM EXTRUDER 3



M	57.1 = M 57.1	EX.CAL. : AUX DRIVES ON	
M	57.5 = M 57.5	EX.CAL. : EXTRUDER START	
M	57.6 = M 57.6	EX.CAL. : AUX DRIVES READY FOR WORK	

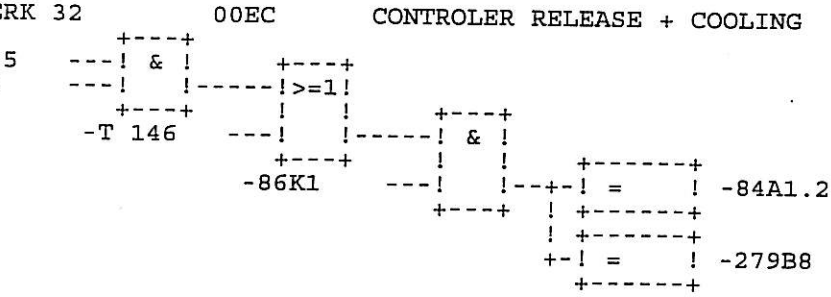
T 146 = T 146 EXTR.CAL. : START ALARM

NETZWERK 31 00E1 MAINCONTACTOR ON



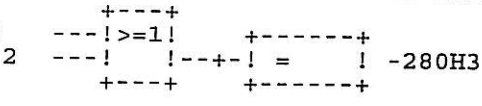
T 135	= T 135	START ALARM FOR AUTOMTIC START
A 4.7	= 87K7	EXTRUDER CALENDER AUX DRIVES ON/OFF
T 146	= T 146	EXTR.CAL. : START ALARM
M 56.5	= M 56.5	EX.CAL. : MAINCONTACTOR ON
A 4.4	= 84A1.2	EXTRUDER CALENDER CONTROLLER RELEASE
A 4.2	= 84A1.1	EXTRUDER CALENDER DC-CONVERTER ON/OFF

NETZWERK 32 00EC CONTROLER RELEASE + COOLING



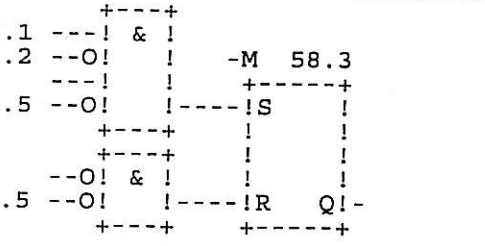
T 135	= T 135	START ALARM FOR AUTOMTIC START
A 4.7	= 87K7	EXTRUDER CALENDER AUX DRIVES ON/OFF
T 146	= T 146	EXTR.CAL. : START ALARM
E 3.5	= 86K1	EXTR.CAL. MAIN CONTACTOR ATTRACTED
A 4.4	= 84A1.2	EXTRUDER CALENDER CONTROLLER RELEASE
A 50.7	= 279B8	EXTRUDER CALENDER COOLING INLET

NETZWERK 33 00F5 LAMP EXTRUDER ON



E 83.2	= 204S3	LAMP TEST (MAIN CONTR.PAN.)
A 4.4	= 84A1.2	EXTRUDER CALENDER CONTROLLER RELEASE
A 51.2	= 280H3	EXTRUDER ON (LAMP) (EXTR.CAL.PAN.)

NETZWERK 34 00F9 DISCHARGING EXTRUDER 3



E 83.5	= 204S6.1	MANUAL (MAIN CONTR.PAN.)
E 83.6	= 204S6.2	AUTOMATIC (MAIN CONTR.PAN.)
E 55.7	= 278S8	PRODUCT DISCHARG. (EXTR.CAL.PAN.)
M 57.5	= M 57.5	EX.CAL. : EXTRUDER START
M 58.3	= M 58.3	EX.CAL. : DISCHARGING

```
NETZWERK 35        0103      EXTRUDER 3 CREEP
                +---+
 -A  4.3  ---!>=1!
 -M  58.1 ---!   !     +---+
 -M  58.3 ---!   !-----! & !
              +---+     !   !    +------+
           -84A1.2  ---!   !--+-! =    ! -84A1.3
                        +---+    +------+
```

```
A    4.3 = A  4.3                    SPARE
M   58.1 = M  58.1                   EX.CAL. : CICLE EXTRUDER REVERSE
M   58.3 = M  58.3                   EX.CAL. : DISCHARGING
A    4.4 = 84A1.2                    EXTRUDER CALENDER CONTROLLER RELEASE
A    4.5 = 84A1.3                    EXTRUDER CALENDER CREEP
```

```
NETZWERK 36        010B      MIN ARMATURE CURRENT
010B      :A   DB 170    -DB 170              DB ACTUAL DATA
010C      :L   DD  28                         ARMATURE CURRENT
010D      :L   KG +1000000+01                 10 A
0110      :<=G
0111      :=   M   58.4  -M  58.4             JA >> MIN. CURRENT
0112      :***
```

```
M   58.4 = M  58.4                   EX.CAL. : MIN ARMATURE CURRENT
```

```
DB 170   = DB 170                    ACTUAL DATAS
```

```
NETZWERK 37        0113      MIN ARMATURE CURRENT
              +---+   -T 145
 -84A1.2  ---! & !    +-----+
 -M  58.4 ---!   !----!T!-!0!
              +---+    !     !
           KT 200.2 --!TW DU!-
                      !   DE!-
                      !     !  -M0306
                      !     !   +-----+
                    --!R   Q!---!S    !
                      +-----+   !     !
                     -205S3.2 --!R   Q!-
                               +-----+
```

```
A    4.4 = 84A1.2                    EXTRUDER CALENDER CONTROLLER RELEASE
M   58.4 = M  58.4                   EX.CAL. : MIN ARMATURE CURRENT
T  145   = T 145                     EXTR.CAL. : FAULT MIN ARMATURE CURRENT
M  184.5 = M0306                     LOW ARMATURE CURRENT   EXTRUDER CALENDER
E   84.3 = 205S3.2                   ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
```

```
NETZWERK 38        0121      CHANGE SPEED EXTRUDER 3
0121      :UN  A    4.5  -84A1.3
0122      :U   A    4.4  -84A1.2
0123      :SPB FB  80    -FB  80
0124 NAME :SLIT +/-
0125 DBNR :    DB 180    -DB 180
0126 SOLL :    DD  26
0127 H-DD :    DD 132
0128 TAKT :    M    0.5  -M   0.5
0129 ZAEH :    Z   54    -Z  54
012A SIG+ :    E   55.4  -278S14.1
012B SIG- :    E   55.5  -278S14.2
012C XMAL :    KZ 010
012D SMAX :    KG +4000000+02
012F SMIN :    KG +1000000+01
0131 FMAX :    KG +1000000+02
0133 FMIN :    KG +9999999-01
0135 MFL1 :    M   58.5  -M  58.5
0136 MIM1 :    M   58.6  -M  58.6
0137 HM2  :    M   58.7  -M  58.7
0138 MFL2 :    M   56.6  -M  56.6
0139 MIM2 :    M   56.7  -M  56.7
013A      :***
```

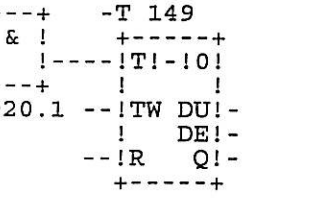
```
 PB 40   -PB  40                          C:KERM06ST.S5D        BIB=13023   LAE=363

 A    4.5 = 84A1.3                        EXTRUDER CALENDER CREEP
 A    4.4 = 84A1.2                        EXTRUDER CALENDER CONTROLLER RELEASE
 M    0.5 = M   0.5                       TACT 2 HZ
 Z   54   = Z  54                         EXTR.CAL. : FASTER/SLOWLIER
 E   55.4 = 278S14.1                      EXTRUDER FASTER          (EXTR.CAL.PAN.)
 E   55.5 = 278S14.2                      EXTRUDER SLOWER          (EXTR.CAL.PAN.)
 M   58.5 = M  58.5                       EX.CAL. : HF FASTER/SLOWLIER
 M   58.6 = M  58.6                       EX.CAL. : HF FASTER/SLOWLIER
 M   58.7 = M  58.7                       EX.CAL. : HF FASTER/SLOWLIER
 M   56.6 = M  56.6                       EX.CAL. : HF FASTER/SLOWLIER
 M   56.7 = M  56.7                       EX.CAL. : HF FASTER/SLOWLIER

 DB 180   = DB 180                       PROFILE AG

 FB  80   = FB  80                        FASTER/SLOWLIER FOR 1 SWITCH

 NETZWERK 39          013B      TRANSFER TO DB-CP
 013B       :U   E   55.4  -278S14.1
 013C       :O   E   55.5  -278S14.2
 013D       :SPB FB  58    -FB  58
 013E NAME  :TRANS-DD
 013F DB-Q  :    DB 180    -DB 180
 0140 QUEL  :    DD  26
 0141 DB-Z  :    DB 160    -DB 160
 0142 ZIEL  :    DD  26
 0143       :***

 E   55.4 = 278S14.1                      EXTRUDER FASTER          (EXTR.CAL.PAN.)
 E   55.5 = 278S14.2                      EXTRUDER SLOWER          (EXTR.CAL.PAN.)

 DB 180   = DB 180                       PROFILE AG
 DB 160   = DB 160                       PROFILE CP

 FB  58   = FB  58                        TRANSFER DD-WORD

 NETZWERK 40          0144      SPEED EXTRUDER 3

                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                        +138      --!PERE         !
                        DD 26     --!SOLL         !
                +4000000+02       --!EINH         !
                        -M   0.1  --!INVE         !
                        -M   0.1  --!FREI         !
                        -DB 180   --!DBNR         !
                                   +--------------+

 M    0.1 = M   0.1                       "1"-SIGNAL

 DB 180   = DB 180                       PROFILE AG

 FB  44   = FB  44                        ANALOG OUTPUT

 NETZWERK 41          014E      DISPLAY SPEED EXTRUDER 3

 FACTOR 3 FOR DISPLAY !!!

                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                        +192      --!PERE         !
                        DD 26     --!SOLL         !
                +1200000+03       --!EINH         !
                        -M   0.0  --!INVE         !
                        -M   0.1  --!FREI         !
                        -DB 170   --!DBNR         !
                                   +--------------+

 M    0.0 = M   0.0                       "0"-SIGNAL
 M    0.1 = M   0.1                       "1"-SIGNAL

+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE         :                      !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO! !
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER   :                    9! !
+-------------------------------------------------------------------------------+
```

```
PB 40    -PB  40                        C:KERM06ST.S5D        BIB=13023   LAE=363

DB 170   = DB 170                       ACTUAL DATAS

FB  44   = FB  44                       ANALOG OUTPUT

NETZWERK 42          0158

                                  -FB  77
                                   +--------------+
                                   !   CURR-DIS   !
                                   +--------------+

FB  77   = FB  77                       CALCULATE CURRENT EXTR.CAL. FOR DISPLAY

NETZWERK 43          015B       DISPLAY CURRENT EXTRUDER 3

                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                        +194      --!PERE        !
                        DD 30     --!SOLL        !
              +1000000+02         --!EINH        !
                        -M   0.0  --!INVE        !
                        -M   0.1  --!FREI        !
                        -DB 170   --!DBNR        !
                                   +--------------+

M    0.0 = M   0.0                          "0"-SIGNAL
M    0.1 = M   0.1                          "1"-SIGNAL

DB 170   = DB 170                       ACTUAL DATAS

FB  44   = FB  44                       ANALOG OUTPUT

NETZWERK 44          0165
0165       :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                      EXTRUDER 3 : FORWARD <---> REVERSE                     *
*                                                                             *
*******************************************************************************
0000      :AWL
0001      :***

NETZWERK 2          0002      CONDITION REVERSE (M 61.0)
0002      :AWL
0003      :***

NETZWERK 3          0004      CONDITION REVERSE
                              +---+
            -84A1.2  ---! & !
            -86K3    ---!   !   -M  61.1
            -M  61.0 ---!   !    +-----+
            -M   0.0 ---!   !----!S    !
                        +---+    !     !
                        +---+    !     !
            -M  61.2 ---!>=1!    !     !
              +---+     !   !    !     !
 -84A1.2  ---! & !      !   !    !     !
 -86K3.1  ---!   !------!   !----!R   Q!-
              +---+     +---+    +-----+

A    4.4 = 84A1.2                   EXTRUDER CALENDER CONTROLLER RELEASE
A    4.6 = 86K3                     EXTRUDER CALENDER FORWARD
M   61.0 = M  61.0                  EX.CAL. : CONDITION REVERSE
M    0.0 = M   0.0                  "0"-SIGNAL
M   61.1 = M  61.1                  EX.CAL. : CONDITION REVERSE SET
M   61.2 = M  61.2                  EX.CAL. : CONDITION REVERSE OFF
A    5.5 = 86K3.1                   EXTRUDER CALENDER REVERSE

NETZWERK 4          0010      START EXTRUDER 3 REVERSE
              +---+
 -250S41.2---!>=1!      +---+
 -250S42.2---!   !------! & !
              +---+     !   !
            -M  10.0 ---!   !
            -M  57.1 --O!   !   -M  58.1
            -M  61.1 ---!   !    +-----+
            -M   0.0 ---!   !----!S    !
                        +---+    !     !
                        +---+    !     !
            -T 147   ---!>=1!    !     !
            -M  57.0 ---!   !----!R   Q!-
                        +---+    +-----+

E   36.1 = 250S41.2                 SWITCH : OPEN CLAMPING
E   36.3 = 250S42.2                 SWITCH : OPEN CLAMP.FOR FINAL DIE CHANGE
M   10.0 = M  10.0                  CLAMPING CLOSED
M   57.1 = M  57.1                  EX.CAL. : AUX DRIVES ON
M   61.1 = M  61.1                  EX.CAL. : CONDITION REVERSE SET
M    0.0 = M   0.0                  "0"-SIGNAL
M   58.1 = M  58.1                  EX.CAL. : CICLE EXTRUDER REVERSE
T  147   = T 147                    EXTR.CAL. : WAIT AFTER CHANGE REV./FORW.
M   57.0 = M  57.0                  EX.CAL. : GENERAL FAULT EXTRUDER 3

NETZWERK 5          001E      WAIT AFTER FIELD OFF
            -T 148
             +-----+
 -M  58.1 --!T!-!0!
 KT 020.1 --!TW DU!-
             !   DE!-
           --!R   Q!-
             +-----+

M   58.1 = M  58.1                  EX.CAL. : CICLE EXTRUDER REVERSE
```

```
T  148   = T 148                          EXTR.CAL. : WAIT AFTER FIELD OFF
```

NETZWERK 6 0027 WAIT AFTER CHANGE FORW/REVERSE

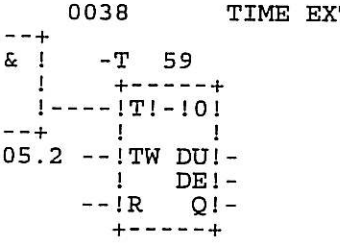



```
T  148   = T 148                          EXTR.CAL. : WAIT AFTER FIELD OFF
M   58.1 = M  58.1                        EX.CAL. : CICLE EXTRUDER REVERSE
T  149   = T 149                          EXTR.CAL. : WAIT AFTER CHANGE FORW./REV.
```

NETZWERK 7 0031 IMPULSE EXTRUDER START

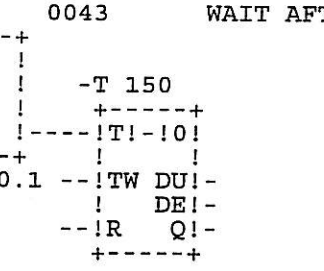
```
0031      :AWL
0032      :U   T  149    -T 149
0033      :UN  M   61.4  -M  61.4
0034      :=   M   58.0  -M  58.0
0035      :U   T  149    -T 149
0036      :=   M   61.4  -M  61.4
0037      :***

T  149   = T 149                          EXTR.CAL. : WAIT AFTER CHANGE FORW./REV.
M   61.4 = M  61.4                        EX.CAL. : HF IMPULSE REVERSE
M   58.0 = M  58.0                        EX.CAL. : IMPULSE EXTRUDER REVERSE START
```

NETZWERK 8 0038 TIME EXTRUDER 3 REVERSE



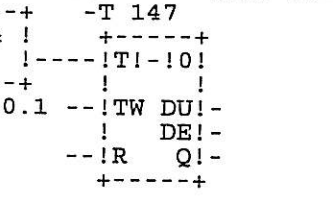

```
A    4.4 = 84A1.2                         EXTRUDER CALENDER CONTROLLER RELEASE
T  149   = T 149                          EXTR.CAL. : WAIT AFTER CHANGE FORW./REV.
M   58.1 = M  58.1                        EX.CAL. : CICLE EXTRUDER REVERSE
T   59   = T  59                          EXTR.CAL. : REVERSE
```

NETZWERK 9 0043 WAIT AFTER FIELD OFF




```
T   59   = T  59                          EXTR.CAL. : REVERSE
T  149   = T 149                          EXTR.CAL. : WAIT AFTER CHANGE FORW./REV.
M   57.1 = M  57.1                        EX.CAL. : AUX DRIVES ON
M   58.1 = M  58.1                        EX.CAL. : CICLE EXTRUDER REVERSE
T  150   = T 150                          EXTR.CAL. : WAIT AFTER FIELD OFF
```

NETZWERK 10 004F WAIT AFTER CHANGE REVERSE/FORW

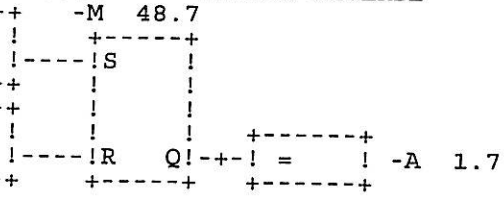


```
T  150   = T 150                    EXTR.CAL. : WAIT AFTER FIELD OFF
M   58.1 = M  58.1                  EX.CAL. : CICLE EXTRUDER REVERSE
T  147   = T 147                    EXTR.CAL. : WAIT AFTER CHANGE REV./FORW.

NETZWERK 11          0059      CICLE CONTROL EXTRUDER 3 REVERSE
            -T  57
             +-----+
 -M  58.1 --!T!-!0!
 KT 040.2 --!TW DU!-
            !   DE!-
          --!R   Q!-
            +-----+

M   58.1 = M  58.1                  EX.CAL. : CICLE EXTRUDER REVERSE
T   57   = T  57                    EXTR.CAL. : FAULT CONTROL REVERSE

NETZWERK 12          0062      EXTRUDER 3 REVERSE
              +---+
 -T 150   --O! & !    +------+
 -T 148   ---!   !--+-! =    ! -A  4.3
              +---+   +------+

T  150   = T 150                    EXTR.CAL. : WAIT AFTER FIELD OFF
T  148   = T 148                    EXTR.CAL. : WAIT AFTER FIELD OFF
A    4.3 = A  4.3                   SPARE

NETZWERK 13          0066      EXTRUDER 3 FORWARD
              +---+   +------+
 -86K3.1  --O! & !--+-! =    ! -86K3
              +---+   +------+

A    5.5 = 86K3.1                   EXTRUDER CALENDER REVERSE
A    4.6 = 86K3                     EXTRUDER CALENDER FORWARD

NETZWERK 14          0069
0069       :AWL
006A       :BE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                        FEEDING DEVICE EXTRUDER CALANDER                   *
*                                                                           *
*****************************************************************************
0000      :***

NETZWERK 2          0001      E-STOP RIP.RIGHT SIDE OR PANEL
              +---+    +------+
 -A700.1  ---! & !--+-! =    ! -M0343
              +---+    +------+

E   51.6 = A700.1                    FEEDER E-STOP RIPCORD OR PANEL RIGHT S.
M  191.2 = M0343                     E-STOP RIPCORD OR PANEL RIGHT S.  FEEDER

NETZWERK 3          0004      LAMP E-STOP RIGHT SIDE
              +---+    +------+
 -A700.1  ---! & !--+-! =    ! -30H5
              +---+    +------+

E   51.6 = A700.1                    FEEDER E-STOP RIPCORD OR PANEL RIGHT S.
A   51.3 = 30H5                      FEEDER RIPCORD RIGHT SIDE (LAMP)

NETZWERK 4          0007      E-STOP RIPCORD LEFT SIDE
              +---+    +------+
 -A700.2  ---! & !--+-! =    ! -M0344
              +---+    +------+

E   51.7 = A700.2                    FEEDER E-STOP RIPCORD LEFT  SIDE
M  191.3 = M0344                     E-STOP RIPCORD LEFT SIDE          FEEDER

NETZWERK 5          000A      LAMP E-STOP LEFT SIDE
              +---+    +------+
 -A700.2  ---! & !--+-! =    ! -30H7
              +---+    +------+

E   51.7 = A700.2                    FEEDER E-STOP RIPCORD LEFT  SIDE
A   51.4 = 30H7                      FEEDER RIPCORD LEFT SIDE (LAMP)

NETZWERK 6          000D      E-STOP RIPCORD IN FRONT
              +---+    +------+
 -A700.3  ---! & !--+-! =    ! -M0345
              +---+    +------+

E   52.0 = A700.3                    FEEDER E-STOP RIPCORD FRONT
M  191.4 = M0345                     E-STOP RIPCORD FRONT              FEEDER

NETZWERK 7          0010      E-STOP HOPPER STATION
              +---+    +------+
 -A700.4  ---! & !--+-! =    ! -M0356
              +---+    +------+

E   52.4 = A700.4                    FEEDER E-STOP          (HOPPER STATION)
M  190.7 = M0356                     E-STOP HOPPER STATION             FEEDER

NETZWERK 8          0013      FAULT MOTOR CONVEYOR FEEDER
              +---+    +------+
 -82K5    ---! & !--+-! =    ! -M0227
              +---+    +------+

E    3.0 = 82K5                      SLAB FEEDER FAULT DC-CONV. CONVEYOR
M  174.6 = M0227                     MOTOR CONVEYOR FAULT              FEEDER

NETZWERK 9          0016      FAULT FEEDER KNIFE
              +---+    +------+
 -80Q2    ---! & !--+-! =    ! -M0228
              +---+    +------+

E    2.7 = 80Q2                      SLAB FEEDER FAULT KNIFE MOTOR


+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                     !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                     !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                     !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                   PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                     1!
+-----------------------------------------------------------------------------+
```

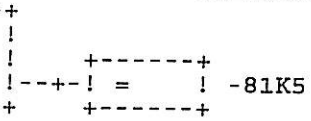
```
E   52.2 = 275S30.1          FEEDER ON                    (PALLET STATION)
E   53.0 = 276S31.1          FEEDER ON                    (HOPPER STATION)
E   55.7 = 278S8             PRODUCT DISCHARG.             (EXTR.CAL.PAN.)
M   48.4 = M  48.4           FEEDER : IMPULSE EXTRUDER ON
E   52.1 = 275S33.1          FEEDER REVERSE               (PALLET STATION)
A    1.7 = A  1.7            FEEDER REVERSE
M    9.1 = M   9.1           CONTROL VOLTAGE IS ON
M   48.1 = M  48.1           FEEDER : FEEDER START
E   52.3 = 275S30.2          FEEDER OFF                   (PALLET STATION)
E   52.7 = 275S33.2          STOP  EXTRUDER + FEEDER      (HOPPER STATION)
E   53.1 = 276S31.2          FEEDER OFF                   (HOPPER STATION)
M   48.0 = M  48.0           FEEDER : GENERAL FAULT
M   48.6 = M  48.6           FEEDER : IMPULSE EXTRUDER OFF
M  175.2 = M0215             BALL-UP PINCH ROLL                      FEEDER
M  175.4 = M0217             BALL-UP UPPER CONVEYOR                  FEEDER
T   61   = T  61             FEEDER : METALALARM NOT ACKNOW.
```

NETZWERK 15 0044 FEEDER REVERSE



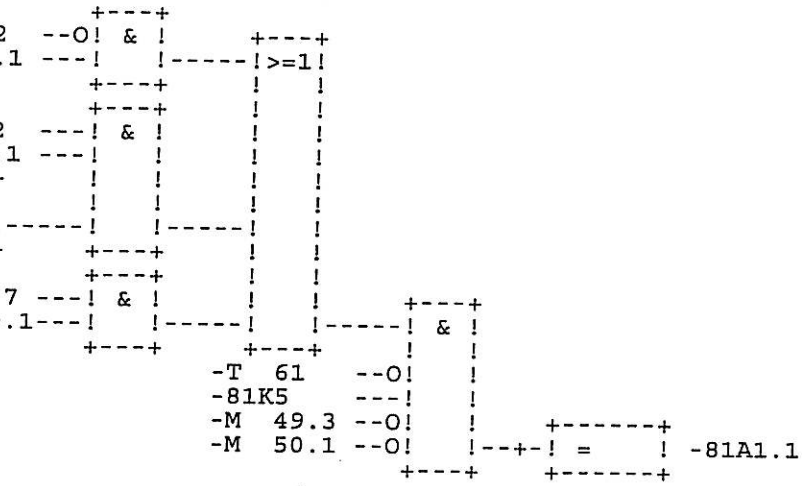

```
E   52.1 = 275S33.1          FEEDER REVERSE               (PALLET STATION)
M   48.1 = M  48.1           FEEDER : FEEDER START
M   48.7 = M  48.7           FEEDER : REVERSE
A    1.7 = A  1.7            FEEDER REVERSE
```

NETZWERK 16 004D MAINCONTACTOR FEEDER ON




```
E    3.0 = 82K5              SLAB FEEDER FAULT DC-CONV. CONVEYOR
M    9.0 = M   9.0           E-STOP TRIGGERED
M    9.1 = M   9.1           CONTROL VOLTAGE IS ON
A    3.7 = 81K5              FEEDER MAINCONTACTOR ON/OFF
```

NETZWERK 17 0052 FEEDER ON




```
A    4.4 = 84A1.2            EXTRUDER CALENDER CONTROLLER RELEASE
M   48.1 = M  48.1           FEEDER : FEEDER START
M   48.2 = M  48.2           FEEDER : LOOP EMPTY
E   52.5 = 275S34            FEEDER MAX SPEED             (HOPPER STATION)
M   48.7 = M  48.7           FEEDER : REVERSE
```

```
PB 42   -PB  42                          C:KERM06ST.S5D        BIB=3033    LAE=389

E   52.2 = 275S30.1                      FEEDER ON                  (PALLET STATION)
T   61   = T  61                         FEEDER : METALALARM NOT ACKNOW.
A    3.7 = 81K5                         FEEDER MAINCONTACTOR ON/OFF
M   49.3 = M  49.3                      FEEDER : DO DOUBLE CUT 1
M   50.1 = M  50.1                      FEEDER : DO DOUBLE CUT 2
A    4.0 = 81A1.1                       FEEDER ON

NETZWERK 18         0066        LOOP EMPTY
                                  -M  48.2
                                   +-----+
                        -273S2    -O!S   !
                          +---+     !    !
            -M  48.0 ---!>=1!     !    !
              +---+      !   !     !    !
 -273S3.   --O! & !      !   !     !    !
 -273S5    --O!   !------!   !-----!R   Q!-
              +---+       +---+     +-----+

E   50.0 = 273S2                        FEEDER LOOP UP
M   48.2 = M  48.2                      FEEDER : LOOP EMPTY
M   48.0 = M  48.0                      FEEDER : GENERAL FAULT
E   50.1 = 273S3.                       FEEDER LOOP DOWN
E   50.5 = 273S5                        FEEDER KNIFE HOME POSITION

NETZWERK 19         006F        ANALOG OUTPUT SPEED

                                  -FB  72
                                   +--------------+
                                   !   FEED-SPE   !
                                   +--------------+

FB  72   = FB  72                        SPEED FEEDER

NETZWERK 20         0072        PINCHROLL DOWN
              +---+     +------+
 -M  48.1 ---! & !--+-! =    ! -279B6
              +---+     +------+

M   48.1 = M  48.1                       FEEDER : FEEDER START
A   50.5 = 279B6                         FEEDER PINCH ROLL DOWN

NETZWERK 21         0075        PINCH ROLL IS DOWN
            -T  50
             +-----+
 -279B6   --!T!-!0!
 KT 005.2 --!TW DU!-
            !   DE!-
           --!R   Q!-
             +-----+

A   50.5 = 279B6                         FEEDER PINCH ROLL DOWN
T   50   = T  50                         FEEDER : BALL-UP PINCH ROLL

NETZWERK 22         007E        BALL-UP PINCH ROLL
             +---+
 -T  50   ---! & !   -M0215
 -274S10  ---!   !    +-----+
 -M   0.0 ---!   !----!S    !
             +---+     !     !
             +---+     !     !
 -275S30.1---!>=1!     !     !
 -205S3.2 ---!   !-----!R   Q!-
             +---+     +-----+

T   50   = T  50                         FEEDER : BALL-UP PINCH ROLL
E   51.2 = 274S10                        FEEDER BALL-UP PINCH ROLL
M    0.0 = M   0.0                       "0"-SIGNAL
M  175.2 = M0215                         BALL-UP PINCH ROLL                FEEDER
E   52.2 = 275S30.1                      FEEDER ON                  (PALLET STATION)
E   84.3 = 205S3.2                       ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
```

```
NETZWERK 23          0087      LOWER CONVEYOR BELT GUIDING
                +---+
 -273S7    --O! & !
 -81K5     ---!   !    +------+
 -81A1.1   ---!   !--+-! =    ! -279B3
                +---+    +------+
```

```
E   50.7 = 273S7                    FEEDER LOWER CONVEYOR BELT CENTER POS.
A    3.7 = 81K5                     FEEDER MAINCONTACTOR ON/OFF
A    4.0 = 81A1.1                   FEEDER ON
A   50.2 = 279B3                    FEEDER LOWER CONVEYER BELT GUIDING
```

```
NETZWERK 24          008C      UPPER CONVEYOR BELT GUIDING
                +---+
 -274S8    ---! & !
 -81K5     ---!   !    +------+
 -81A1.1   ---!   !--+-! =    ! -279B4
                +---+    +------+
```

```
E   51.0 = 274S8                    FEEDER UPPER CONVEYOR BELT CENTER POS.
A    3.7 = 81K5                     FEEDER MAINCONTACTOR ON/OFF
A    4.0 = 81A1.1                   FEEDER ON
A   50.3 = 279B4                    FEEDER UPPER CONVEYOR BELT GUIDING
```

```
NETZWERK 25          0091      COUNTER FOR UPPER CONV.BELT DOWN

>>> 50 IMPULSES = 160 CM
                +---+
 -81A1.1   ---! & !   -Z   2
 -A  1.7   --O!   !    +-----+
 -273B8    ---!   !----!ZV   !
                +---+    !     !
                       --!ZR   !
                       --!S    !
                       --!ZW DU!-
                         !   DE!-
              -81A1.1  -O!R   Q!-
                         +-----+
```

```
A    4.0 = 81A1.1                   FEEDER ON
A    1.7 = A  1.7                   FEEDER REVERSE
E   50.4 = 273B8                    FEEDER PULSE GENERATOR
Z    2   = Z   2                    FEEDER : UPPER CONVEYOR BELT DOWN
```

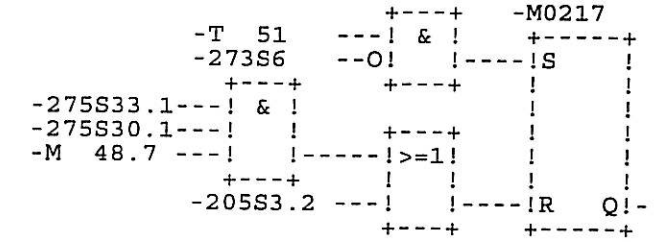
```
NETZWERK 26          009E      UPPER CONVEYOR BELT DOWN
               +-----+
 -Z   2    --!Z1  F!
               !>=   !   +------+
 KF +70    --!Z2  Q!-+-! =    ! -279B5
               +-----+   +------+
```

```
Z    2   = Z   2                    FEEDER : UPPER CONVEYOR BELT DOWN
A   50.4 = 279B5                    FEEDER UPPER CONVEYOR BELT DOWN
```

```
NETZWERK 27          00A4      UPPER CONVEYOR IS DOWN
             -T  51
              +-----+
 -279B5    --!T!-!0!
 KT 005.2  --!TW DU!-
              !   DE!-
            --!R   Q!-
              +-----+
```

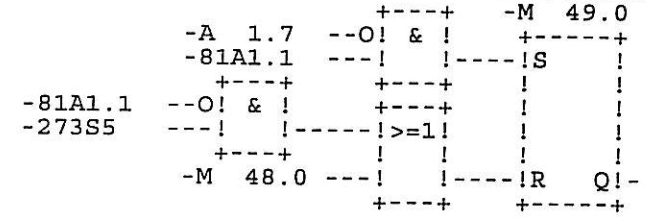
```
A   50.4 = 279B5                    FEEDER UPPER CONVEYOR BELT DOWN
T   51   = T  51                    FEEDER : BALL-UP UPPER CONVEYOR
```

NETZWERK 28 00AD BALL-UP UPPER CONVEYOR



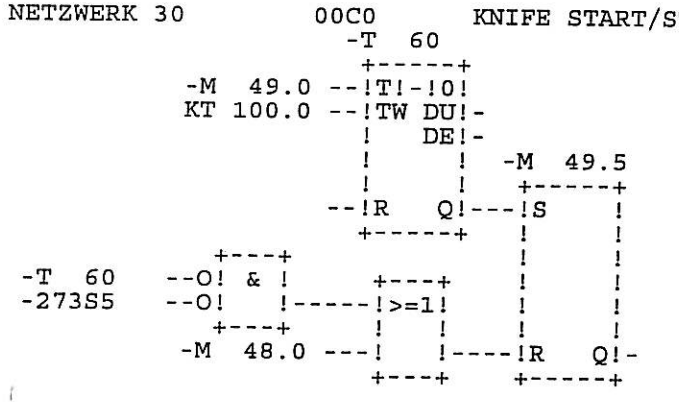
T 51 = T 51	FEEDER : BALL-UP UPPER CONVEYOR	
E 50.6 = 273S6	FEEDER BALL-UP UPPER CONVEYOR	
M 175.4 = M0217	BALL-UP UPPER CONVEYOR	FEEDER
E 52.1 = 275S33.1	FEEDER REVERSE	(PALLET STATION)
E 52.2 = 275S30.1	FEEDER ON	(PALLET STATION)
M 48.7 = M 48.7	FEEDER : REVERSE	
E 84.3 = 205S3.2	ACKNOWLEDGING FAULT	(MAIN CONTR.PAN.)

NETZWERK 29 00B7 KNIFE START NORMAL



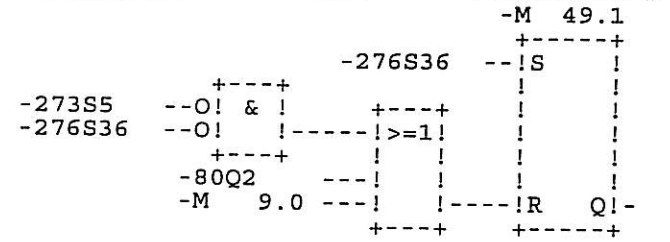
A 1.7 = A 1.7	FEEDER REVERSE	
A 4.0 = 81A1.1	FEEDER ON	
M 49.0 = M 49.0	FEEDER : CUTTING KNIFE ON NORMAL	
E 50.5 = 273S5	FEEDER KNIFE HOME POSITION	
M 48.0 = M 48.0	FEEDER : GENERAL FAULT	

NETZWERK 30 00C0 KNIFE START/STOP NORMAL



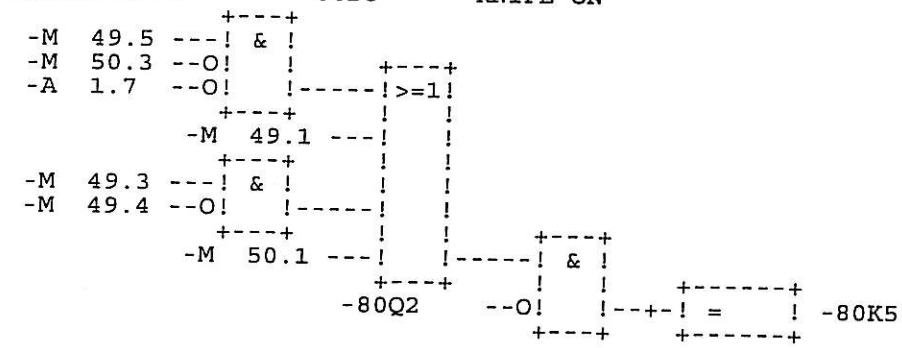
M 49.0 = M 49.0	FEEDER : CUTTING KNIFE ON NORMAL	
T 60 = T 60	FEEDER : KNIFE ON	
M 49.5 = M 49.5	FEEDER : KNIFE ON NORMAL	
E 50.5 = 273S5	FEEDER KNIFE HOME POSITION	
M 48.0 = M 48.0	FEEDER : GENERAL FAULT	

NETZWERK 31 00CF CUTTING TEST



```
E   53.2 = 276S36                    FEEDER CUT                (HOPPER STATION)
M   49.1 = M  49.1                   FEEDER : CUTTING TEST
E   50.5 = 273S5                     FEEDER KNIFE HOME POSITION
E    2.7 = 80Q2                      SLAB FEEDER FAULT KNIFE MOTOR
M    9.0 = M   9.0                   E-STOP TRIGGERED
```

NETZWERK 32 00D8 KNIFE ON

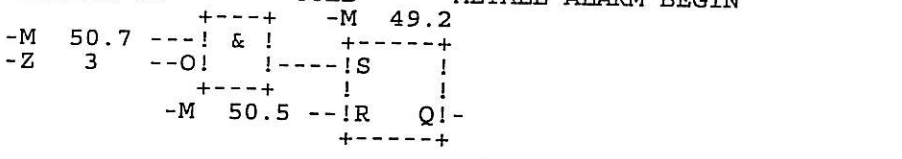



```
M   49.5 = M  49.5                   FEEDER : KNIFE ON NORMAL
M   50.3 = M  50.3                   FEEDER : SCRAP CONVEYOR UP
A    1.7 = A  1.7                    FEEDER REVERSE
M   49.1 = M  49.1                   FEEDER : CUTTING TEST
M   49.3 = M  49.3                   FEEDER : DO DOUBLE CUT 1
M   49.4 = M  49.4                   FEEDER : DOUBLE CUT 1 DONE
M   50.1 = M  50.1                   FEEDER : DO DOUBLE CUT 2
E    2.7 = 80Q2                      SLAB FEEDER FAULT KNIFE MOTOR
A    3.6 = 80K5                      DRIVE MOTOR CUTTER ON/OFF (VMI)
```

```
NETZWERK 33          00E5      IMPULSE FIRST METALALARM
00E5       :U   E   50.3  -83A3
00E6       :UN  M   50.6  -M  50.6
00E7       :=   M   50.7  -M  50.7
00E8       :U   E   50.3  -83A3
00E9       :=   M   50.6  -M  50.6
00EA       :***
```

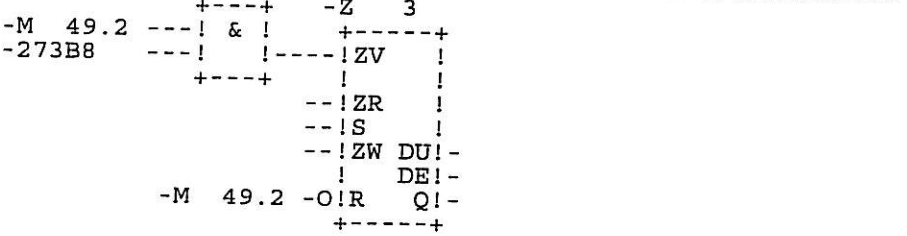
```
E   50.3 = 83A3                      FEEDER METAL DETECTOR
M   50.6 = M  50.6                   FEEDER : HF METALALARM ON
M   50.7 = M  50.7                   FEEDER : IMPULSE METALALARM ON
```

NETZWERK 34 00EB METALL ALARM BEGIN




```
M   50.7 = M  50.7                   FEEDER : IMPULSE METALALARM ON
Z    3   = Z   3                     FEEDER : CUT 1 METALALARM
M   49.2 = M  49.2                   FEEDER : METAL ALARM
M   50.5 = M  50.5                   FEEDER : RESET METALALARM BEGIN
```

NETZWERK 35 00F2 COUNTER FOR CUT 1 METALALARM

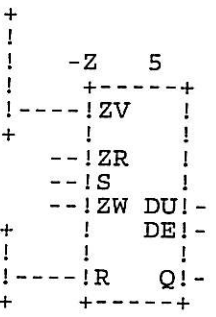



```
M   49.2 = M  49.2                   FEEDER : METAL ALARM
E   50.4 = 273B8                     FEEDER PULSE GENERATOR
```

```
Z    3   = Z   3                          FEEDER : CUT 1 METALALARM

NETZWERK 36        00FE      DO DOUBLE CUT 1
              +-----+
 -Z   3    --!Z1  F!
             !>=   !   +------+
 KF +100   --!Z2  Q!-+-! =    ! -M  49.3
             +-----+   +------+

Z    3   = Z   3                          FEEDER : CUT 1 METALALARM
M   49.3 = M  49.3                        FEEDER : DO DOUBLE CUT 1

NETZWERK 37        0104      DOUBLE CUT 1 DONE
              +-----+
 -Z   4    --!Z1  F!
             !>=   !   +------+
 KF +3     --!Z2  Q!-+-! =    ! -M  49.4
             +-----+   +------+

Z    4   = Z   4                          FEEDER : DOUBLE CUT 1
M   49.4 = M  49.4                        FEEDER : DOUBLE CUT 1 DONE

NETZWERK 38        010A      COUNTER FOR DOUBLE CUT 1
              +---+
 -273S5    --O! & !   -Z   4
 -80K5     ---!   !    +-----+
 -M  49.3  ---!   !----!ZV   !
              +---+    !     !
                    --!ZR   !
                    --!S    !
                    --!ZW DU!-
                      !   DE!-
           -M  49.4 --!R   Q!-
                      +-----+

E   50.5 = 273S5                          FEEDER KNIFE HOME POSITION
A    3.6 = 80K5                           DRIVE MOTOR CUTTER ON/OFF (VMI)
M   49.3 = M  49.3                        FEEDER : DO DOUBLE CUT 1
Z    4   = Z   4                          FEEDER : DOUBLE CUT 1
M   49.4 = M  49.4                        FEEDER : DOUBLE CUT 1 DONE

NETZWERK 39        0117      RESET METALALARM BEGIN
              +-----+
 -Z   4    --!Z1  F!
             !>=   !   +------+
 KF +3     --!Z2  Q!-+-! =    ! -M  50.5
             +-----+   +------+

Z    4   = Z   4                          FEEDER : DOUBLE CUT 1
M   50.5 = M  50.5                        FEEDER : RESET METALALARM BEGIN

NETZWERK 40        011D      ACKNOWLEDGING METALALARM
011D      :UN  E   50.3  -83A3
011E      :UN  M   49.6  -M  49.6
011F      :=   M   49.7  -M  49.7
0120      :UN  E   50.3  -83A3
0121      :=   M   49.6  -M  49.6
0122      :***

E   50.3 = 83A3                           FEEDER METAL DETECTOR
M   49.6 = M  49.6                        FEEDER : HF ACKNOWLEDGING METALALARM
M   49.7 = M  49.7                        FEEDER : IMPULSE ACKNOWL. METALALARM

NETZWERK 41        0123      METALALARM ACKNOWLEDGED
                     -M  50.0
                      +-----+
            -M  49.7 --!S    !
              +---+    !     !
 -83A3     ---!>=1!    !     !
 -M  50.2  ---!   !----!R   Q!-
              +---+    +-----+
```

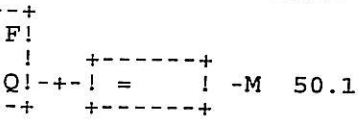
```
M   49.7 = M  49.7                    FEEDER : IMPULSE ACKNOWL. METALALARM
M   50.0 = M  50.0                    FEEDER : METALALARM ACKNOWLEDGED
E   50.3 = 83A3                       FEEDER METAL DETECTOR
M   50.2 = M  50.2                    FEEDER : DOUBLE CUT 2 DONE
```

NETZWERK 42 012A COUNTER FOR CUT 2 METALALARM



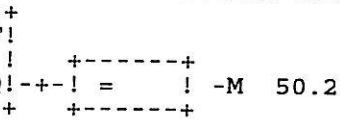

```
E   50.4 = 273B8                      FEEDER PULSE GENERATOR
M   50.0 = M  50.0                    FEEDER : METALALARM ACKNOWLEDGED
A    3.7 = 81K5                       FEEDER MAINCONTACTOR ON/OFF
A    4.0 = 81A1.1                     FEEDER ON
Z    5   = Z   5                      FEEDER : CUT 2 METALALARM
M   50.2 = M  50.2                    FEEDER : DOUBLE CUT 2 DONE
E   50.3 = 83A3                       FEEDER METAL DETECTOR
```

NETZWERK 43 0139 DO DOUBLE CUT 2



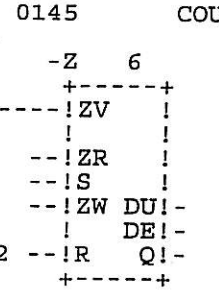

```
Z    5   = Z   5                      FEEDER : CUT 2 METALALARM
M   50.1 = M  50.1                    FEEDER : DO DOUBLE CUT 2
```

NETZWERK 44 013F DOUBLE CUT 2 DOWN



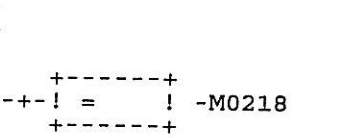

```
Z    6   = Z   6                      FEEDER : DOUBLE CUT 2
M   50.2 = M  50.2                    FEEDER : DOUBLE CUT 2 DONE
```

NETZWERK 45 0145 COUNTER FOR DOUBLE CUT 2



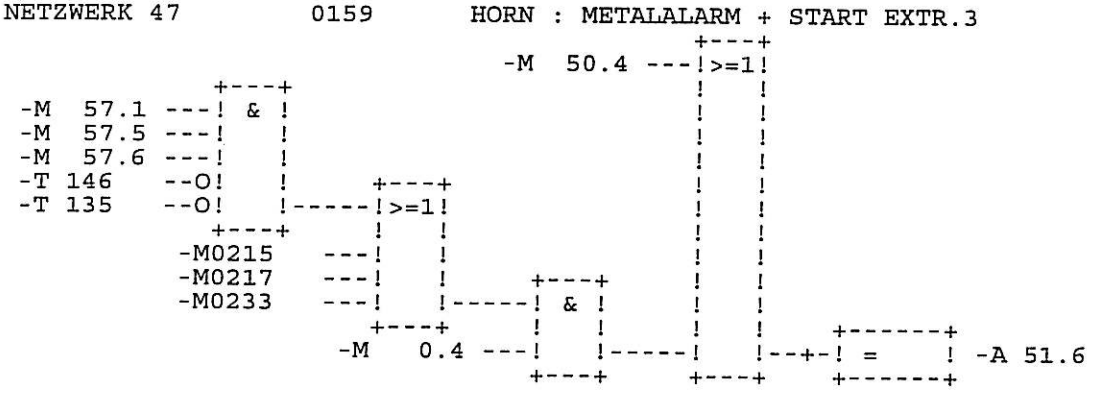

```
E   50.5 = 273S5                      FEEDER KNIFE HOME POSITION
A    3.6 = 80K5                       DRIVE MOTOR CUTTER ON/OFF (VMI)
M   50.1 = M  50.1                    FEEDER : DO DOUBLE CUT 2
Z    6   = Z   6                      FEEDER : DOUBLE CUT 2
M   50.2 = M  50.2                    FEEDER : DOUBLE CUT 2 DONE
```

NETZWERK 46 0152 HORN + MESSAGE METALALARM



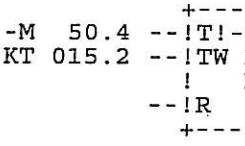
```
M   50.7 = M  50.7                    FEEDER : IMPULSE METALALARM ON
M   50.4 = M  50.4                    FEEDER : HORN METALALARM
M   49.7 = M  49.7                    FEEDER : IMPULSE ACKNOWL. METALALARM
M  175.5 = M0218                      METAL DETECTED                  FEEDER
```

NETZWERK 47 0159 HORN : METALALARM + START EXTR.3



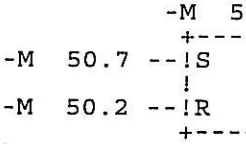

```
M   50.4 = M  50.4                    FEEDER : HORN METALALARM
M   57.1 = M  57.1                    EX.CAL. : AUX DRIVES ON
M   57.5 = M  57.5                    EX.CAL. : EXTRUDER START
M   57.6 = M  57.6                    EX.CAL. : AUX DRIVES READY FOR WORK
T  146   = T 146                      EXTR.CAL. : START ALARM
T  135   = T 135                      START ALARM FOR AUTOMTIC START
M  175.2 = M0215                      BALL-UP PINCH ROLL                FEEDER
M  175.4 = M0217                      BALL-UP UPPER CONVEYOR            FEEDER
M  177.4 = M0233                      NO MATERIAL                 EXTR. CALENDER
M    0.4 = M   0.4                    TACT 1 HZ
A   51.6 = A 51.6                     FEEDER HORN
```

NETZWERK 48 0168 METALALARM NOT ACKNOWLEGED



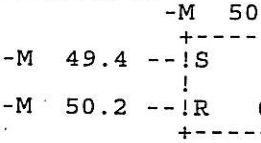

```
M   50.4 = M  50.4                    FEEDER : HORN METALALARM
T   61   = T  61                      FEEDER : METALALARM NOT ACKNOW.
```

NETZWERK 49 0171 LAMP METALALARM




```
M   50.7 = M  50.7                    FEEDER : IMPULSE METALALARM ON
M   51.0 = M  51.0                    FEEDER : LAMP METALALARM
M   50.2 = M  50.2                    FEEDER : DOUBLE CUT 2 DONE
A   51.7 = A 51.7                     FEEDER LAMP
```

NETZWERK 50 0178 SCRAP CONVEYOR UP



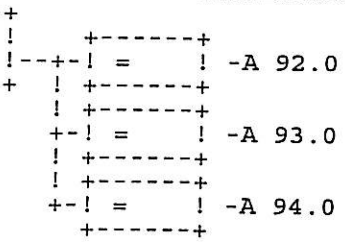

```
M   49.4 = M  49.4                    FEEDER : DOUBLE CUT 1 DONE
M   50.3 = M  50.3                    FEEDER : SCRAP CONVEYOR UP
M   50.2 = M  50.2                    FEEDER : DOUBLE CUT 2 DONE
A   50.0 = 279B1                      FEEDER SCRAP ROLLER CONVEYOR
```

NETZWERK 51 017F
017F :BE

NETZWERK 1 0000

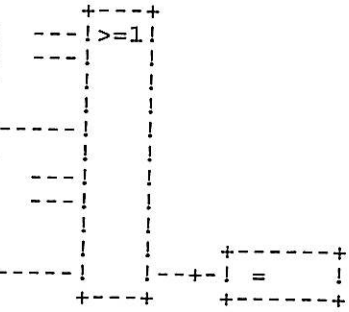
```
*********************************************************************************
*                                                                               *
*                                TEMPERATURE UNIT 1 -3                          *
*                                                                               *
*********************************************************************************
0000      :AWL
0001      :***
```

NETZWERK 2 0002 TEMPERATURE UNIT 1-3 ON



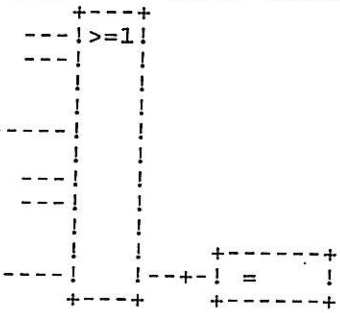

```
E   84.4 = 205S5.1                    TEMPERATURE UNIT ON     (MAIN CONTR.PAN.)
M    9.1 = M   9.1                    CONTROL VOLTAGE IS ON
A   92.0 = A 92.0                     TEMPER. UNIT 3 : ON
A   93.0 = A 93.0                     TEMPER. UNIT 2 : ON
A   94.0 = A 94.0                     TEMPER. UNIT 1 : ON
```

NETZWERK 3 0008 FAULT TEMP. UNIT 1 TOP MACHINE




```
E   98.0 = E 98.0                     TEMP.UNIT 1 : FAULT PRESS. SCREW BOT EX.
E   98.2 = E 98.2                     TEMP.UNIT 1 : FAULT PUMP   SCREW BOT EX.
E   98.1 = E 98.1                     TEMP.UNIT 1 : PUMP ON      SCREW BOT EX.
E   98.3 = E 98.3                     TEMP.UNIT 1 : OVERTEMP.    SCREW BOT EX.
E   98.4 = E 98.4                     TEMP.UNIT 1 : FAULT PRESS.  CYL. BOT EX.
E   98.6 = E 98.6                     TEMP.UNIT 1 : FAULT PUMP    CYL. BOT EX.
E   98.5 = E 98.5                     TEMP.UNIT 1 : PUMP ON       CYL. BOT EX.
E   98.7 = E 98.7                     TEMP.UNIT 1 : OVERTEMP.     CYL. BOT EX.
M   46.0 = M  46.0                    FAULT TEMPER. UNIT 1 UPPER EXTRUDER
```

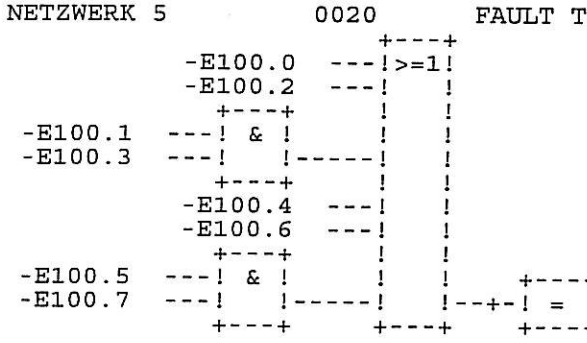
NETZWERK 4 0014 FAULT TEMP. UNIT 1 BOTTOM MACH.




```
E   99.0 = E 99.0                     TEMP.UNIT 1 : FAULT PRESS. SCREW TOP EX.
E   99.2 = E 99.2                     TEMP.UNIT 1 : FAULT PUMP   SCREW TOP EX.
E   99.1 = E 99.1                     TEMP.UNIT 1 : PUMP ON      SCREW TOP EX.
```

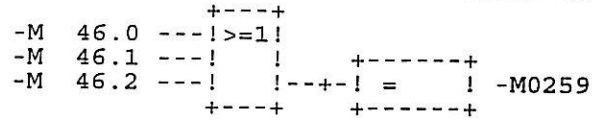
```
E   99.3 = E 99.3                    TEMP.UNIT 1 : OVERTEMP.     SCREW TOP EX.
E   99.4 = E 99.4                    TEMP.UNIT 1 : FAULT PRESS.  CYL. TOP EX.
E   99.6 = E 99.6                    TEMP.UNIT 1 : FAULT PUMP    CYL. TOP EX.
E   99.5 = E 99.5                    TEMP.UNIT 1 : PUMP ON       CYL. TOP EX.
E   99.7 = E 99.7                    TEMP.UNIT 1 : OVERTEMP.     CYL. TOP EX.
M   46.1 = M  46.1                   FAULT TEMPER. UNIT 1 BOTTOM EXTRUDER
```

NETZWERK 5 0020 FAULT TEMP. UNIT 1 EXTRUSION H.



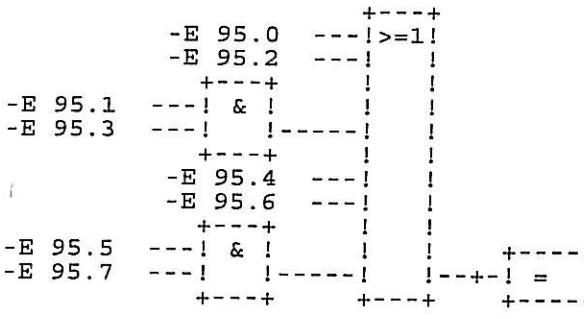

```
E  100.0 = E100.0                    TEMP.UNIT 1 : FAULT PRESS. MIDDLE S. DEH
E  100.2 = E100.2                    TEMP.UNIT 1 : FAULT PUMP   MIDDLE S. DEH
E  100.1 = E100.1                    TEMP.UNIT 1 : PUMP ON      MIDDLE S. DEH
E  100.3 = E100.3                    TEMP.UNIT 1 : OVERTEMP.    MIDDLE S. DEH
E  100.4 = E100.4                    TEMP.UNIT 1 : FAULT PRESS.  UPPER S. DEH
E  100.6 = E100.6                    TEMP.UNIT 1 : FAULT PUMP    UPPER S. DEH
E  100.5 = E100.5                    TEMP.UNIT 1 : PUMP ON       UPPER S. DEH
E  100.7 = E100.7                    TEMP.UNIT 1 : OVERTEMP.     UPPER S. DEH
M   46.2 = M  46.2                   FAULT TEMPER. UNIT 1 EXTRUSION HEAD
```

NETZWERK 6 002C FAULT TEMPERATURE UNIT 1



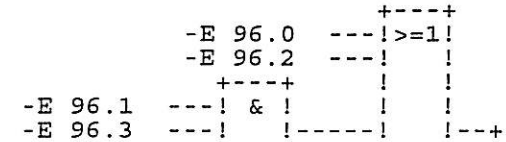

```
M   46.0 = M  46.0                   FAULT TEMPER. UNIT 1 UPPER EXTRUDER
M   46.1 = M  46.1                   FAULT TEMPER. UNIT 1 BOTTOM EXTRUDER
M   46.2 = M  46.2                   FAULT TEMPER. UNIT 1 EXTRUSION HEAD
M  178.6 = M0259                     FAULT TEMPER. UNIT 1
```

NETZWERK 7 0031 FAULT TEMP. UNIT 2 EXTRUDER 3



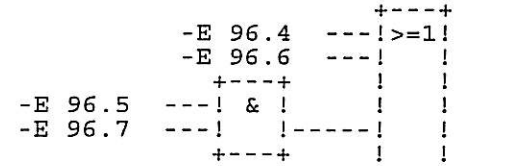

```
E   95.0 = E 95.0                    TEMP.UNIT 2 : FAULT PRESS.     SCREW KG90
E   95.2 = E 95.2                    TEMP.UNIT 2 : FAULT PUMP       SCREW KG90
E   95.1 = E 95.1                    TEMP.UNIT 2 : PUMP ON          SCREW KG90
E   95.3 = E 95.3                    TEMP.UNIT 2 : OVERTEMPERATURE SCREW KG90
E   95.4 = E 95.4                    TEMP.UNIT 2 : FAULT PRESSURE     PIN KG90
E   95.6 = E 95.6                    TEMP.UNIT 2 : FAULT PUMP         PIN KG90
E   95.5 = E 95.5                    TEMP.UNIT 2 : PUMP ON            PIN KG90
E   95.7 = E 95.7                    TEMP.UNIT 2 : OVERTEMPERATURE    PIN KG90
M   46.6 = M  46.6                   FAULT TEMPER. UNIT 2 KG90 SCREW + PIN
```

NETZWERK 8 003D FAULT TEMP. UNIT 2 EXTRUDER HEAD



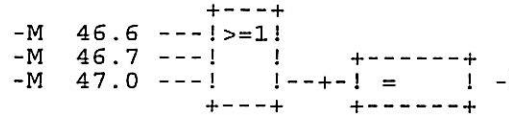
E 96.0 = E 96.0	TEMP.UNIT 2 : FAULT PRESSURE	HEAD KG90
E 96.2 = E 96.2	TEMP.UNIT 2 : FAULT PUMP	HEAD KG90
E 96.1 = E 96.1	TEMP.UNIT 2 : PUMP ON	HEAD KG90
E 96.3 = E 96.3	TEMP.UNIT 2 : OVERTEMPERATURE	HEAD KG90
M 46.7 = M 46.7	FAULT TEMPER. UNIT 2 KG90 HEAD	

NETZWERK 9 0044 FAULT TEMP. UNIT 2 CALANDER ROLL



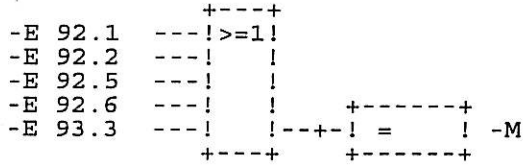
E 96.4 = E 96.4	TEMP.UNIT 2 : FAULT PRESS.	TOP ROLL CAL
E 96.6 = E 96.6	TEMP.UNIT 2 : FAULT PUMP	TOP ROLL CAL
E 96.5 = E 96.5	TEMP.UNIT 2 : PUMP ON	TOP ROLL CAL
E 96.7 = E 96.7	TEMP.UNIT 2 : OVERTEMP.	TOP ROLL CAL
E 97.0 = E 97.0	TEMP.UNIT 2 : FAULT PRESS.	BOT ROLL CAL
E 97.2 = E 97.2	TEMP.UNIT 2 : FAULT PUMP	BOT ROLL CAL
E 97.1 = E 97.1	TEMP.UNIT 2 : PUMP ON	BOT ROLL CAL
E 97.3 = E 97.3	TEMP.UNIT 2 : OVERTEMP.	BOT ROLL CAL
M 47.0 = M 47.0	FAULT TEMPER. UNIT 2 CALENDER ROLL	

NETZWERK 10 0050 FAULT TEMPERATURE UNIT 2



M 46.6 = M 46.6	FAULT TEMPER. UNIT 2 KG90 SCREW + PIN
M 46.7 = M 46.7	FAULT TEMPER. UNIT 2 KG90 HEAD
M 47.0 = M 47.0	FAULT TEMPER. UNIT 2 CALENDER ROLL
M 178.7 = M0260	FAULT TEMPER. UNIT 2

NETZWERK 11 0055 FAULT COOLING UNIT 3 (PPE.+CO.1)



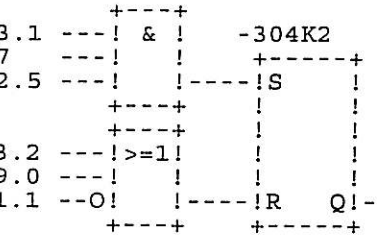
E 92.1 = E 92.1	TEMP.UNIT 3 : FAULT MOTOR PUMP 1	
E 92.2 = E 92.2	TEMP.UNIT 3 : FAULT FLOW	
E 92.5 = E 92.5	TEMP.UNIT 3 : FAULT OIL PRESS. COMP.1	
E 92.6 = E 92.6	TEMP.UNIT 3 : FAULT MOTOR COMPRESSOR1	
E 93.3 = E 93.3	TEMP.UNIT 3 : FAULT HIGH PRES. COMP.1	
M 46.3 = M 46.3	FAULT TEMPER. UNIT 3 (PUMP+COMPRESSOR 1)	

```
NETZWERK 12        005C      FAULT COOLING UNIT 3 (PPE.+CO.2)
              +---+
 -E 93.0  ---!>=1!
 -E 93.1  ---!   !
 -E 93.4  ---!   !
 -E 93.5  ---!   !    +------+
 -E 93.7  ---!   !--+-! =    ! -M  46.4
              +---+    +------+

E   93.0 = E 93.0                    TEMP.UNIT 3 : FAULT OIL PRESS. COMP.2
E   93.1 = E 93.1                    TEMP.UNIT 3 : FAULT MOTOR COMPRESSOR2
E   93.4 = E 93.4                    TEMP.UNIT 3 : FAULT HIGH PRES. COMP.2
E   93.5 = E 93.5                    TEMP.UNIT 3 : FAULT MOTOR PUMP 2
E   93.7 = E 93.7                    TEMP.UNIT 3 : FAULT FLOW
M   46.4 = M  46.4                   FAULT TEMPER. UNIT 3 (PUMP+COMPRESSOR 2)

NETZWERK 13        0063      FAULT COOLING UNIT 3 (GENERAL)
              +---+
 -E 92.4  ---!>=1!
 -E 94.0  ---!   !
 -E 94.1  ---!   !    +------+
 -E 94.2  ---!   !--+-! =    ! -M  46.5
              +---+    +------+

E   92.4 = E 92.4                    TEMP.UNIT 3 : FAULT ANTI FREEZE PROT.
E   94.0 = E 94.0                    TEMP.UNIT 3 : FAULT PRESSURE FILTER 1
E   94.1 = E 94.1                    TEMP.UNIT 3 : FAULT PRESSURE FILTER 1
E   94.2 = E 94.2                    TEMP.UNIT 3 : FILLING LEVEL MIN.ALARM
M   46.5 = M  46.5                   FAULT TEMPER. UNIT 3 (GENERAL)

NETZWERK 14        0069      FAULT COOLING UNIT 3
              +---+
 -M  46.3 ---!>=1!
 -M  46.4 ---!   !    +------+
 -M  46.5 ---!   !--+-! =    ! -M0245
              +---+    +------+

M   46.3 = M  46.3                   FAULT TEMPER. UNIT 3 (PUMP+COMPRESSOR 1)
M   46.4 = M  46.4                   FAULT TEMPER. UNIT 3 (PUMP+COMPRESSOR 2)
M   46.5 = M  46.5                   FAULT TEMPER. UNIT 3 (GENERAL)
M  179.0 = M0245                     FAULT TEMPER. UNIT 3

NETZWERK 15        006E
006E       :AWL
006F       :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                     WIND UP STATION   AND   CENTERING DEVICE                *
*                                                                             *
*******************************************************************************
0000      :***

NETZWERK 2          0001      CENTERING DEVICE BLOCKING
              +---+
 -M  81.1 ---!>=1!    +------+
 -M  81.5 ---!   !--+-! =    ! -267K6
              +---+  ! +------+
                     ! +------+
                     +-! =    ! -A960.3
                       +------+

M   81.1 = M  81.1                    LINE : AUXILIARY DRIVES ON
M   81.5 = M  81.5                    LINE : LINE ON
A   41.5 = 267K6                      CENTERING DEVICE 1 BLOCKING
A   71.5 = A960.3                     CENTERING 2 BLOCKING

NETZWERK 3          0006      CENTERING DEVICE CENTER/AUTO
              +---+    +------+
 -M  81.5 ---! & !--+-! =    ! -267K5
              +---+  ! +------+
                     ! +------+
                     +-! =    ! -A960.2
                       +------+

M   81.5 = M  81.5                    LINE : LINE ON
A   41.4 = 267K5                      CENTERING DEVICE 1 CENTER/AUTO
A   71.4 = A960.2                     CENTERING 2 CENTER/AUTO

NETZWERK 4          000A      MAIN CONTACTOR WIND UP ST. 1-4
              +---+    +------+
 -M  81.1 ---! & !--+-! =    ! -122K7
              +---+  ! +------+
                     ! +------+
                     +-! =    ! -123K7
                     ! +------+
                     ! +------+
                     +-! =    ! -124K7
                     ! +------+
                     ! +------+
                     +-! =    ! -125K7
                       +------+

M   81.1 = M  81.1                    LINE : AUXILIARY DRIVES ON
A   11.0 = 122K7                      WIND-UP STATION 1 MAIN CONTACTOR ON
A   11.1 = 123K7                      WIND-UP STATION 2 MAIN CONTACTOR ON
A   11.2 = 124K7                      WIND-UP STATION 3 MAIN CONTACTOR ON
A   11.3 = 125K7                      WIND-UP STATION 4 MAIN CONTACTOR ON

NETZWERK 5          0010
0010      :AWL
0011      :BEA
0012      :***

NETZWERK 6          0013      WIND UP STATION 1 ON
              +---+
 -300S1.1 ---! & !   -304K1
 -122K7   ---!   !    +-----+
 -M   2.5 ---!   !----!S    !
              +---+    !     !
              +---+    !     !
 -300S1.2 ---!>=1!    !     !
 -M   9.0 ---!   !    !     !
 -M  81.1 --O!   !----!R   Q!-
              +---+    +-----+
```

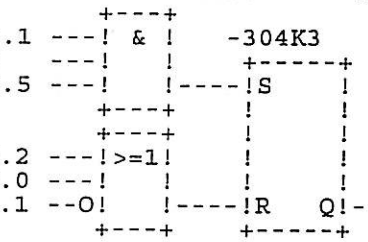
```
E   74.0 = 300S1.1          WIND UP DEVICE 1 ON
A   11.0 = 122K7            WIND-UP STATION 1 MAIN CONTACTOR ON
M    2.5 = M   2.5          WIND-UP
A   72.0 = 304K1            WIND-UP STAT 1 CONTROLLER RELEASE
E   74.1 = 300S1.2          WIND UP DEVICE 1 OFF
M    9.0 = M   9.0          E-STOP TRIGGERED
M   81.1 = M  81.1          LINE : AUXILIARY DRIVES ON
```

NETZWERK 7 001D WIND UP STATION 2 ON



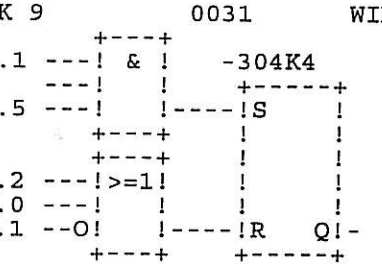

```
E   74.2 = 300S3.1          WIND UP DEVICE 2 ON
A   11.1 = 123K7            WIND-UP STATION 2 MAIN CONTACTOR ON
M    2.5 = M   2.5          WIND-UP
A   72.1 = 304K2            WIND-UP STAT 2 CONTROLLER RELEASE
E   74.3 = 300S3.2          WIND UP DEVICE 2 OFF
M    9.0 = M   9.0          E-STOP TRIGGERED
M   81.1 = M  81.1          LINE : AUXILIARY DRIVES ON
```

NETZWERK 8 0027 WIND UP STATION 3 ON




```
E   74.4 = 300S5.1          WIND UP DEVICE 3 ON
A   11.2 = 124K7            WIND-UP STATION 3 MAIN CONTACTOR ON
M    2.5 = M   2.5          WIND-UP
A   72.2 = 304K3            WIND-UP STAT 3 CONTROLLER RELEASE
E   74.5 = 300S5.2          WIND UP DEVICE 3 OFF
M    9.0 = M   9.0          E-STOP TRIGGERED
M   81.1 = M  81.1          LINE : AUXILIARY DRIVES ON
```

NETZWERK 9 0031 WIND UP STATION 4 ON




```
E   74.6 = 300S7.1          WIND UP DEVICE 4 ON
A   11.3 = 125K7            WIND-UP STATION 4 MAIN CONTACTOR ON
M    2.5 = M   2.5          WIND-UP
A   72.3 = 304K4            WIND-UP STAT 4 CONTROLLER RELEASE
E   74.7 = 300S7.2          WIND UP DEVICE 4 OFF
M    9.0 = M   9.0          E-STOP TRIGGERED
M   81.1 = M  81.1          LINE : AUXILIARY DRIVES ON
```

```
NETZWERK 10         003B
003B       :AWL
003C       :BE
```

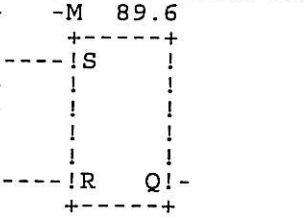
```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                              CUT EDGE CEMENTING DEVICE                      *
*                                                                             *
*******************************************************************************
0000      :***

NETZWERK 2          0001      STRIP INLET (FRONT)
0001      :L    PY  72
0002      :T    EB  72
0003      :UN   E   72.4  -298S5
0004      :UN   M   89.0  -M  89.0
0005      :=    M   89.1  -M  89.1
0006      :UN   E   72.4  -298S5
0007      :=    M   89.0  -M  89.0
0008      :***

E   72.4 = 298S5                    CUT END CEMENTING STRIP INLET
M   89.0 = M  89.0                  HF TREAD INLET
M   89.1 = M  89.1                  IMPULSE TREAD INLET

NETZWERK 3          0009      TREAD IN THE FRONT FAST
                +---+   -M  89.2
 -132K5   ---! & !    +-----+
 -M  89.1 ---!   !----!S    !
              +---+    !     !
              +---+    !     !
 -132K6   ---!>=1!    !     !
 -M   9.0 ---!   !    !     !
 -M  63.5 ---!   !    !     !
 -M  63.6 ---!   !    !     !
 -T  77   ---!   !----!R   Q!-
              +---+    +-----+

A    9.7 = 132K5                    END CEMENTING FAST
M   89.1 = M  89.1                  IMPULSE TREAD INLET
M   89.2 = M  89.2                  TREAD IN THE FRONT FAST
A   10.0 = 132K6                    END CEMENTING SLOW
M    9.0 = M   9.0                  E-STOP TRIGGERED
M   63.5 = M  63.5                  SCRAP : SV OPEN SCRAP FLAP
M   63.6 = M  63.6                  SCRAP : RESET SV OPEN SCRAP FLAP
T   77   = T  77                   TREAD END CEM : SPRAYING THE FRONT FAST

NETZWERK 4          0014      TIMER TREAD IN THE FRONT FAST
           -T  75
            +-----+
 -M  89.2 --!T!-!0!
KT 340.0 --!TW DU!-
           !   DE!-
          --!R   Q!-
            +-----+

M   89.2 = M  89.2                  TREAD IN THE FRONT FAST
T   75   = T  75                   TREAD END CEM : TREAD IN THE FRONT FAST

NETZWERK 5          001D      TREAD IN THE FRONT SLOW
                +---+   -M  89.3
 -132K6   ---! & !    +-----+
 -M  89.1 ---!   !----!S    !
              +---+    !     !
              +---+    !     !
 -132K5   ---!>=1!    !     !
 -M   9.0 ---!   !    !     !
 -M  63.5 ---!   !    !     !
 -M  63.6 ---!   !    !     !
 -T  72   ---!   !----!R   Q!-
              +---+    +-----+

A   10.0 = 132K6                    END CEMENTING SLOW
```

```
M   89.1 = M  89.1                    IMPULSE TREAD INLET
M   89.3 = M  89.3                    TREAD IN THE FRONT SLOW
A    9.7 = 132K5                      END CEMENTING FAST
M    9.0 = M   9.0                    E-STOP TRIGGERED
M   63.5 = M  63.5                    SCRAP : SV OPEN SCRAP FLAP
M   63.6 = M  63.6                    SCRAP : RESET SV OPEN SCRAP FLAP
T   72   = T  72                      TREAD END CEM : SPRAYING THE FRONT SLOW
```

NETZWERK 6 0028 TIMER TREAD IN THE FRONT SLOW

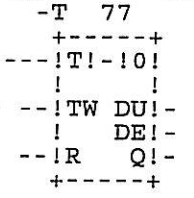
```
M   89.3 = M  89.3                    TREAD IN THE FRONT SLOW
T   76   = T  76                      TREAD END CEM : TREAD IN THE FRONT SLOW
```

NETZWERK 7 0031 SPRAYING TREAD IN THE FRONT



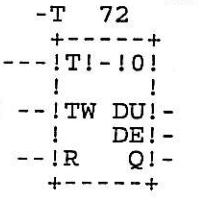

```
T   75   = T  75                      TREAD END CEM : TREAD IN THE FRONT FAST
T   76   = T  76                      TREAD END CEM : TREAD IN THE FRONT SLOW
M   89.6 = M  89.6                    SPRAYING CUT END FRONT
T   72   = T  72                      TREAD END CEM : SPRAYING THE FRONT SLOW
T   77   = T  77                      TREAD END CEM : SPRAYING THE FRONT FAST
M    9.0 = M   9.0                    E-STOP TRIGGERED
```

NETZWERK 8 003A TIMER SPRAYING THE FRONT FAST



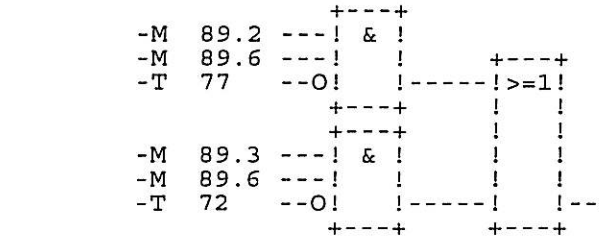

```
M   89.2 = M  89.2                    TREAD IN THE FRONT FAST
M   89.6 = M  89.6                    SPRAYING CUT END FRONT
T   77   = T  77                      TREAD END CEM : SPRAYING THE FRONT FAST
```

NETZWERK 9 0044 TIMER SPRAYING THE FRONT SLOW




```
M   89.3 = M  89.3                    TREAD IN THE FRONT SLOW
M   89.6 = M  89.6                    SPRAYING CUT END FRONT
T   72   = T  72                      TREAD END CEM : SPRAYING THE FRONT SLOW
```

NETZWERK 10 004E SV SPRAYING THE FRONT

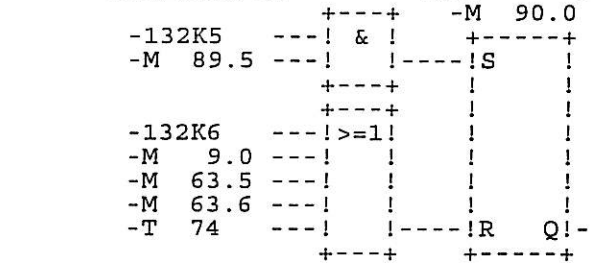



```
M   89.2 = M  89.2                  TREAD IN THE FRONT FAST
M   89.6 = M  89.6                  SPRAYING CUT END FRONT
T   77   = T  77                    TREAD END CEM : SPRAYING THE FRONT FAST
M   89.3 = M  89.3                  TREAD IN THE FRONT SLOW
T   72   = T  72                    TREAD END CEM : SPRAYING THE FRONT SLOW
A   70.6 = 302B7                    CUT END CEMENTING IN THE FRONT
```

```
NETZWERK 11         0057      TREAD OUTLET (BACK)
0057       :U   E   72.4  -298S5
0058       :UN  M   89.4  -M  89.4
0059       :=   M   89.5  -M  89.5
005A       :U   E   72.4  -298S5
005B       :=   M   89.4  -M  89.4
005C       :***
```

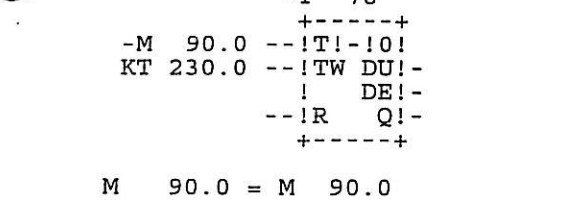
```
E   72.4 = 298S5                    CUT END CEMENTING STRIP INLET
M   89.4 = M  89.4                  HF TREAD OUTLET
M   89.5 = M  89.5                  IMPULSE TREAD OUTLET
```

NETZWERK 12 005D TREAD IN THE BACK FAST



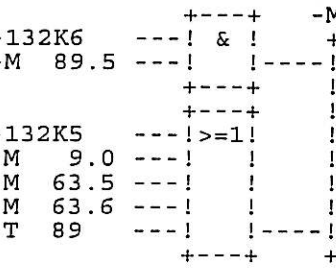

```
A    9.7 = 132K5                    END CEMENTING FAST
M   89.5 = M  89.5                  IMPULSE TREAD OUTLET
M   90.0 = M  90.0                  TREAD IN THE BACK FAST
A   10.0 = 132K6                    END CEMENTING SLOW
M    9.0 = M   9.0                  E-STOP TRIGGERED
M   63.5 = M  63.5                  SCRAP : SV OPEN SCRAP FLAP
M   63.6 = M  63.6                  SCRAP : RESET SV OPEN SCRAP FLAP
T   74   = T  74                    TREAD END CEM : SPRAYING THE BACK FAST
```

NETZWERK 13 0068 TIMER TREAD IN THE BACK FAST



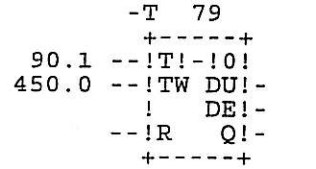

```
M   90.0 = M  90.0                  TREAD IN THE BACK FAST
T   78   = T  78                    TREAD END CEM : TREAD IN THE BACK FAST
```

NETZWERK 14 0071 TREAD IN THE BACK SLOW



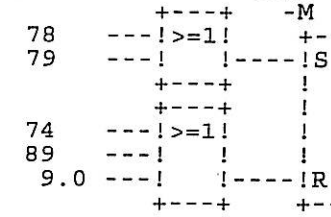

```
A   10.0 = 132K6                    END CEMENTING SLOW
M   89.5 = M  89.5                  IMPULSE TREAD OUTLET
M   90.1 = M  90.1                  TREAD IN TRE BACK SLOW
A    9.7 = 132K5                    END CEMENTING FAST
M    9.0 = M   9.0                  E-STOP TRIGGERED
M   63.5 = M  63.5                  SCRAP : SV OPEN SCRAP FLAP
M   63.6 = M  63.6                  SCRAP : RESET SV OPEN SCRAP FLAP
T   89   = T  89                    CUT END CEM : SPRAYING THE BACK SLOW
```

NETZWERK 15 007C TIMER TREAD IN THE BACK SLOW



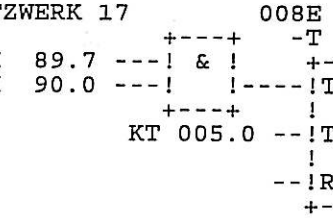

```
M   90.1 = M  90.1                  TREAD IN TRE BACK SLOW
T   79   = T  79                    TREAD END CEM : TREAD IN THE BACK SLOW
```

NETZWERK 16 0085 SPRAYING TREAD IN THE BACK




```
T   78   = T  78                    TREAD END CEM : TREAD IN THE BACK FAST
T   79   = T  79                    TREAD END CEM : TREAD IN THE BACK SLOW
M   89.7 = M  89.7                  SPRAYING CUT END BACK
T   74   = T  74                    TREAD END CEM : SPRAYING THE BACK FAST
T   89   = T  89                    CUT END CEM : SPRAYING THE BACK SLOW
M    9.0 = M   9.0                  E-STOP TRIGGERED
```

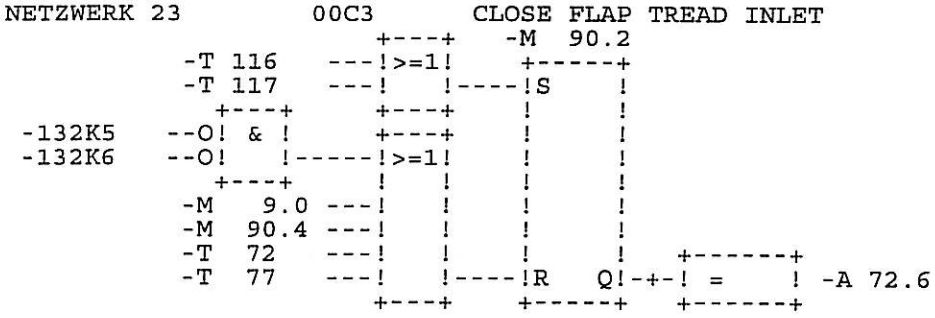
NETZWERK 17 008E TIMER SPRAYING THE BACK FAST




```
M   89.7 = M  89.7                  SPRAYING CUT END BACK
M   90.0 = M  90.0                  TREAD IN THE BACK FAST
T   74   = T  74                    TREAD END CEM : SPRAYING THE BACK FAST
```

```
NETZWERK 18        0098      TIMER SPRAYING THE BACK SLOW
              +---+   -T  89
 -M  89.7 ---! & !    +-----+
 -M  90.1 ---!   !----!T!-!0!
              +---+    !     !
          KT 005.0 --!TW DU!-
                     !   DE!-
                   --!R   Q!-
                     +-----+

M   89.7 = M  89.7                    SPRAYING CUT END BACK
M   90.1 = M  90.1                    TREAD IN TRE BACK SLOW
T   89   = T  89                      CUT END CEM : SPRAYING THE BACK SLOW

NETZWERK 19        00A2      SV SPRAYING THE BACK
              +---+
 -M  89.7 ---! & !
 -M  90.0 ---!   !      +---+
 -T  74   --O!   !------!>=1!
              +---+     !   !
              +---+     !   !
 -M  89.7 ---! & !      !   !
 -M  90.1 ---!   !      !   !     +------+
 -T  89   --O!   !------!   !--+-! =    ! -302B8
              +---+     +---+    +------+

M   89.7 = M  89.7                    SPRAYING CUT END BACK
M   90.0 = M  90.0                    TREAD IN THE BACK FAST
T   74   = T  74                      TREAD END CEM : SPRAYING THE BACK FAST
M   90.1 = M  90.1                    TREAD IN TRE BACK SLOW
T   89   = T  89                      CUT END CEM : SPRAYING THE BACK SLOW
A   70.7 = 302B8                      CUT END CEMENTING IN THE BACK

NETZWERK 20        00AB      IMPULSE SPRAYING THE FRONT OFF
00AB      :UN  A   70.6  -302B7
00AC      :UN  M   90.3  -M  90.3
00AD      :=   M   90.4  -M  90.4
00AE      :UN  A   70.6  -302B7
00AF      :=   M   90.3  -M  90.3
00B0      :***

A   70.6 = 302B7                      CUT END CEMENTING IN THE FRONT
M   90.3 = M  90.3                    HF CLOSE FLAP SPRAYING THE FRONT
M   90.4 = M  90.4                    IMPULSE CLOSE FLAP SPRAYING THE FRONT

NETZWERK 21        00B1      OPEN FLAP END CEMENTING FAST
           -T 116
            +-----+
 -M  89.2 --!T!-!0!
KT 100.0 --!TW DU!-
            !   DE!-
          --!R   Q!-
            +-----+

M   89.2 = M  89.2                    TREAD IN THE FRONT FAST
T  116   = T 116                     OPEN FLAP END CEMENTING FAST

NETZWERK 22        00BA      OPEN FLAP END CEMENTING SLOW
           -T 117
            +-----+
 -M  89.3 --!T!-!0!
KT 400.0 --!TW DU!-
            !   DE!-
          --!R   Q!-
            +-----+

M   89.3 = M  89.3                    TREAD IN THE FRONT SLOW
T  117   = T 117                     OPEN FLAP END CEMENTING SLOW
```

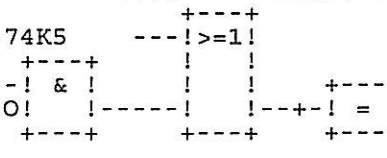
NETZWERK 23 00C3 CLOSE FLAP TREAD INLET



T 116	= T 116	OPEN FLAP END CEMENTING FAST
T 117	= T 117	OPEN FLAP END CEMENTING SLOW
M 90.2	= M 90.2	SPRAYING CUT END BACK
A 9.7	= 132K5	END CEMENTING FAST
A 10.0	= 132K6	END CEMENTING SLOW
M 9.0	= M 9.0	E-STOP TRIGGERED
M 90.4	= M 90.4	IMPULSE CLOSE FLAP SPRAYING THE FRONT
T 72	= T 72	TREAD END CEM : SPRAYING THE FRONT SLOW
T 77	= T 77	TREAD END CEM : SPRAYING THE FRONT FAST
A 72.6	= A 72.6	FLAP CUT END CEMENTING

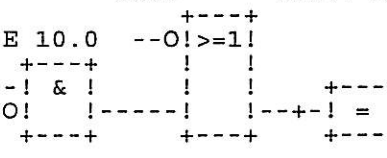
NETZWERK 24 00D0
00D0 :BE

NETZWERK 1 0000 CONV. CONVERTER DRAW & SHRINK



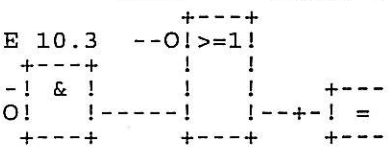
E 2.3 = 74K5 DRAW-OFF + SHRINKAGE CONVEYOR FAULT
M 70.0 = M 70.0 FAULT CONV. CONVERTER DRAW+SHRINK
E 84.3 = 205S3.2 ACKNOWLEDGING FAULT (MAIN CONTR.PAN.) N.)

NETZWERK 2 0006 CONV. DRIVE TEMP. DRAW & SHRINK



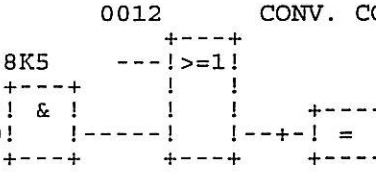
E 10.0 = E 10.0 DRIVE OVERTEMP 73M2 CONV. SHRINKING
M 70.1 = M 70.1 FAULT CONV. DRIVE TEMP. DRAW+&SHRINK
E 84.3 = 205S3.2 ACKNOWLEDGING FAULT (MAIN CONTR.PAN.) TER

NETZWERK 3 000C CONV. DRIVE FAN DRAW & SHRINK N.)



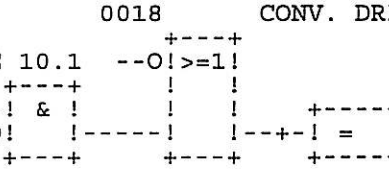
E 10.3 = E 10.3 FAN FAULT 141M1 CONV. SHRINKING
M 70.2 = M 70.2 FAULT CONV. DRIVE FAN DRAW+SHRINK
E 84.3 = 205S3.2 ACKNOWLEDGING FAULT (MAIN CONTR.PAN.)

NETZWERK 4 0012 CONV. CONVERTER CONT. SCALE N.)



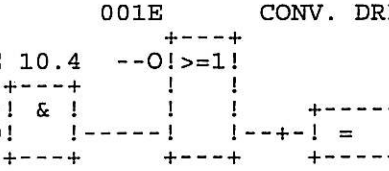
E 2.4 = 78K5 CONVEYOR LINEAR CHECK WEIGHER FAULT
M 70.3 = M 70.3 FAULT CONV. CONVERTER CONT. SCALE
E 84.3 = 205S3.2 ACKNOWLEDGING FAULT (MAIN CONTR.PAN.)

NETZWERK 5 0018 CONV. DRIVE TEMP. CONT. SCALE J.)



E 10.1 = E 10.1 DRIVE OVERTEMP 77M2 CONV. SCALE
M 70.4 = M 70.4 FAULT CONV. DRIVE TEMP. CONT. SCALE
E 84.3 = 205S3.2 ACKNOWLEDGING FAULT (MAIN CONTR.PAN.)

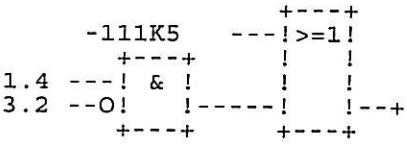
NETZWERK 6 001E CONV. DRIVE FAN CONT. SCALE I.)



E 10.4 = E 10.4 FAN FAULT 141M7 CONV. SCALE
M 70.5 = M 70.5 FAULT CONV. DRIVE FAN CONT. SCALE
E 84.3 = 205S3.2 ACKNOWLEDGING FAULT (MAIN CONTR.PAN.)

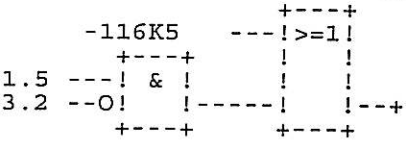
```
E    6.5 = 109K5                    COOLING LINE PART 3 FAULT
M   71.3 = M  71.3                  FAULT CONV. CONVERTER COOLING LINE 3
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
```

NETZWERK 13 004B CONV. CONVERTER COOLING LINE 4



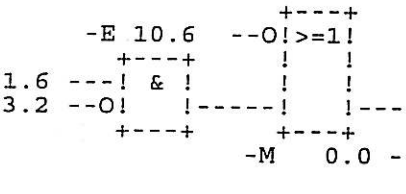

```
E    6.6 = 111K5                    COOLING LINE PART 4 FAULT
M   71.4 = M  71.4                  FAULT CONV. CONVERTER COOLING LINE 4
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
```

NETZWERK 14 0051 CONV. CONVERTER CENTERING



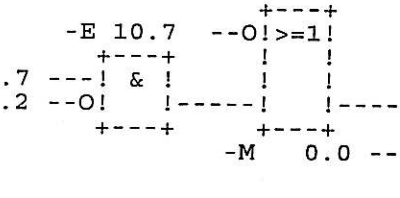

```
E    7.5 = 116K5                    CENTERING CONVEYOR FAULT
M   71.5 = M  71.5                  FAULT CONV. CONVERTER CENTERING
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
```

NETZWERK 15 0057 CONV. DRIVE TEMP. CENT.+FEEDING



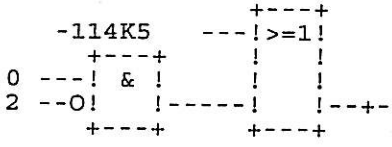

```
E   10.6 = E 10.6                   DRIVE OVERTEMP 115M2 CONV. CENT.+FEEDING
M   71.6 = M  71.6                  FAULT CONV. DRIVE TEMP. CENT.+FEED
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
M    0.0 = M   0.0                  "0"-SIGNAL
```

NETZWERK 16 0060 CONV. DRIVE FAN CENT.+FEEDING



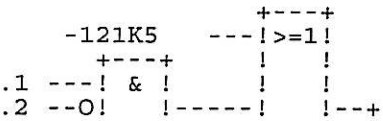

```
E   10.7 = E 10.7                   FAN FAULT 118M1 CONV. CENTERING+FEEDING
M   71.7 = M  71.7                  FAULT CONV. DRIVE FAN CENT. + FEEDING
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
M    0.0 = M   0.0                  "0"-SIGNAL
```

NETZWERK 17 0069 CONV. CONVERTER M.-SEP. DEVICE



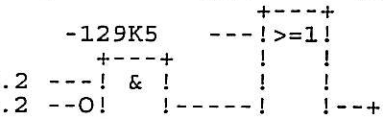

```
E    7.4 = 114K5                    KNIFE MIDDLE SEP.DEVICE FAULT
M   72.0 = M  72.0                  FAULT CONV. CONVERTER KNIFE M.-SEP. DEV.
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
```

NETZWERK 18 006F CONV. CONVERTER ACCELERATING



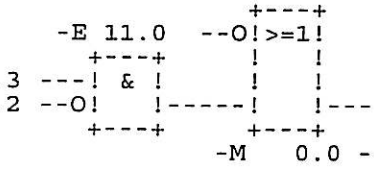

```
E    7.6 = 121K5                    ACCELERATING CONVEYOR FAULT
M   72.1 = M  72.1                  FAULT CONV. CONVERTER ACCELERATING
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
```

NETZWERK 19 0075 CONV. CONVERTER CHECK WEIGHTER



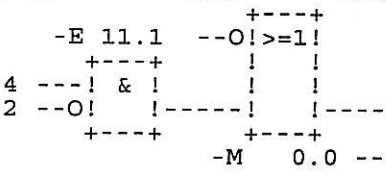

```
E    7.7 = 129K5                    TREAD CHECK WEIGHER CONVEYOR FAULT
M   72.2 = M  72.2                  FAULT CONV. CONVERTER CHECK WEIGHTER
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
```

NETZWERK 20 007B CONV. DRIVE TEMP. CHECK WEIGHTER



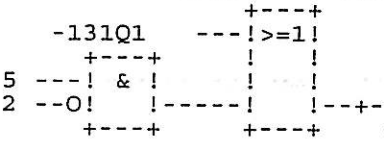

```
E   11.0 = E 11.0                   DRIVE OVERTEMP 128M2 CONV.CHECK WEIGHTER
M   72.3 = M  72.3                  FAULT CONV. DRIVE TEMP. CHECK WEIGHTER
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
M    0.0 = M   0.0                  "0"-SIGNAL
```

NETZWERK 21 0084 CONV. DRIVE FAN CHECK WEIGHTER



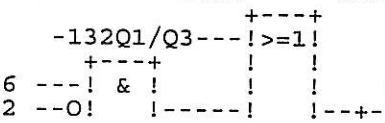

```
E   11.1 = E 11.1                   FAN FAULT 130M1 CONV. CHECK WEIGHTER
M   72.4 = M  72.4                  FAULT CONV. DRIVE FAN CHECK WEIGHTER
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
M    0.0 = M   0.0                  "0"-SIGNAL
```

NETZWERK 22 008D CONV. CONVERTER SLOW-DOWN



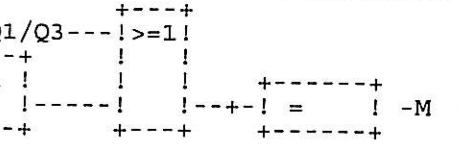

```
E    8.0 = 131Q1                    SLOW-DOWN CONVEYOR FAULT
M   72.5 = M  72.5                  FAULT CONV. CONVERTER SLOW-DOWN
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
```

NETZWERK 23 0093 CONV. CONVERTER END CEMENTING



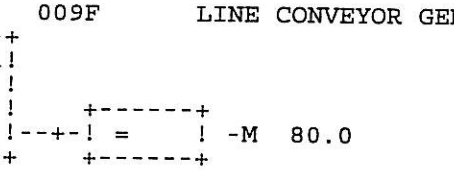
```
E    8.1 = 132Q1/Q3                 END CEM. FAULT
M   72.6 = M  72.6                  FAULT CONV. CONVERTER END CEMENTING
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
```

NETZWERK 24 0099 CONV. CONVERTER TAKE-AWAY



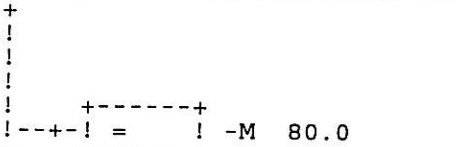

```
E    8.4 = 136Q1/Q3                 TAKE-AWAY CONVEYOR FAULT
M   72.7 = M  72.7                  FAULT CONV. CONVERTER TAKE-AWAY
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
```

NETZWERK 25 009F LINE CONVEYOR GENERAL FAULT



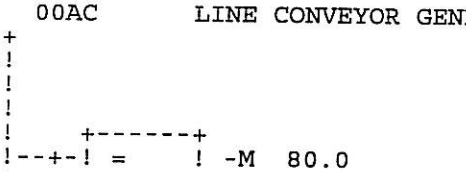

```
M   70.0 = M  70.0                  FAULT CONV. CONVERTER DRAW+SHRINK
M   70.1 = M  70.1                  FAULT CONV. DRIVE TEMP. DRAW+&SHRINK
M   70.2 = M  70.2                  FAULT CONV. DRIVE FAN DRAW+SHRINK
M   70.3 = M  70.3                  FAULT CONV. CONVERTER CONT. SCALE
M   80.0 = M  80.0                  LINE : FAULT
```

NETZWERK 26 00A5 LINE CONVEYOR GENERAL FAULT



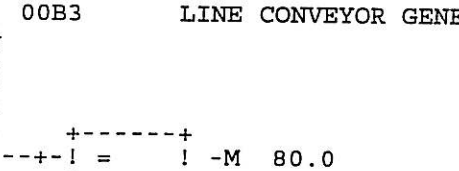

```
M   80.0 = M  80.0                  LINE : FAULT
M   70.4 = M  70.4                  FAULT CONV. DRIVE TEMP. CONT. SCALE
M   70.5 = M  70.5                  FAULT CONV. DRIVE FAN CONT. SCALE
M   70.6 = M  70.6                  FAULT CONV. CONVERTER BOT.-CEMENTER
M   70.7 = M  70.7                  FAULT CONV. DRIVE TEMP. BOT.-CEMENTER
```

NETZWERK 27 00AC LINE CONVEYOR GENERAL FAULT




```
M   80.0 = M  80.0                  LINE : FAULT
M   71.0 = M  71.0                  FAULT CONV. DRIVE FAN BOT.-CEMENTER
M   71.1 = M  71.1                  FAULT CONV. CONVERTER COOLING LINE 1
M   71.2 = M  71.2                  FAULT CONV. CONVERTER COOLING LINE 2
M   71.3 = M  71.3                  FAULT CONV. CONVERTER COOLING LINE 3
```

NETZWERK 28 00B3 LINE CONVEYOR GENERAL FAULT

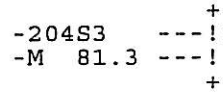



```
M   80.0 = M  80.0                  LINE : FAULT
M   71.4 = M  71.4                  FAULT CONV. CONVERTER COOLING LINE 4
```

```
M   71.5 = M  71.5                    FAULT CONV. CONVERTER CENTERING
M   71.6 = M  71.6                    FAULT CONV. DRIVE TEMP. CENT.+FEED
M   71.7 = M  71.7                    FAULT CONV. DRIVE FAN CENT. + FEEDING

NETZWERK 29          00BA      LINE CONVEYOR GENERAL FAULT
              +---+
 -M  80.0 ---!>=1!
 -M  72.0 ---!   !
 -M  72.1 ---!   !
 -M  72.2 ---!   !    +------+
 -M  72.3 ---!   !--+-! =    ! -M  80.0
              +---+    +------+

M   80.0 = M  80.0                    LINE : FAULT
M   72.0 = M  72.0                    FAULT CONV. CONVERTER KNIFE M.-SEP. DEV.
M   72.1 = M  72.1                    FAULT CONV. CONVERTER ACCELERATING
M   72.2 = M  72.2                    FAULT CONV. CONVERTER CHECK WEIGHTER
M   72.3 = M  72.3                    FAULT CONV. DRIVE TEMP. CHECK WEIGHTER

NETZWERK 30          00C1      LINE CONVEYOR GENERAL FAULT
              +---+
 -M  80.0 ---!>=1!
 -M  72.4 ---!   !
 -M  72.5 ---!   !
 -M  72.6 ---!   !    +------+
 -M  72.7 ---!   !--+-! =    ! -M  80.0
              +---+    +------+

M   80.0 = M  80.0                    LINE : FAULT
M   72.4 = M  72.4                    FAULT CONV. DRIVE FAN CHECK WEIGHTER
M   72.5 = M  72.5                    FAULT CONV. CONVERTER SLOW-DOWN
M   72.6 = M  72.6                    FAULT CONV. CONVERTER END CEMENTING
M   72.7 = M  72.7                    FAULT CONV. CONVERTER TAKE-AWAY

NETZWERK 31          00C8      LINE CONVEYOR GENERAL FAULT
              +---+
 -M  80.0 ---!>=1!
 -M  82.0 ---!   !
 -M  82.1 ---!   !
 -M  82.2 ---!   !    +------+
 -M  82.3 ---!   !--+-! =    ! -M  80.0
              +---+    +------+

M   80.0 = M  80.0                    LINE : FAULT
M   82.0 = M  82.0                    FAULT SPEED DRAW-OFF CONVEYOR
M   82.1 = M  82.1                    FAULT SPEED CONT. SCALE CONVEYOR
M   82.2 = M  82.2                    FAULT SPEED CEMENTING 2 CONVEYOR
M   82.3 = M  82.3                    FAULT SPEED COOLING SECTION 1 CONVEYOR

NETZWERK 32          00CF      LINE CONVEYOR GENERAL FAULT
              +---+
 -M  80.0 ---!>=1!
 -M  82.4 ---!   !
 -M  82.5 ---!   !
 -M  82.6 ---!   !    +------+
 -M  82.7 ---!   !--+-! =    ! -M  80.0
              +---+    +------+:BE

M   80.0 = M  80.0                    LINE : FAULT
M   82.4 = M  82.4                    FAULT SPEED COOLING SECTION 2 CONVEYOR
M   82.5 = M  82.5                    FAULT SPEED COOLING SECTION 3 CONVEYOR
M   82.6 = M  82.6                    FAULT SPEED COOLING SECTION 4 CONVEYOR
M   82.7 = M  82.7                    FAULT SPEED CENTERING 2 CONVEYOR
```

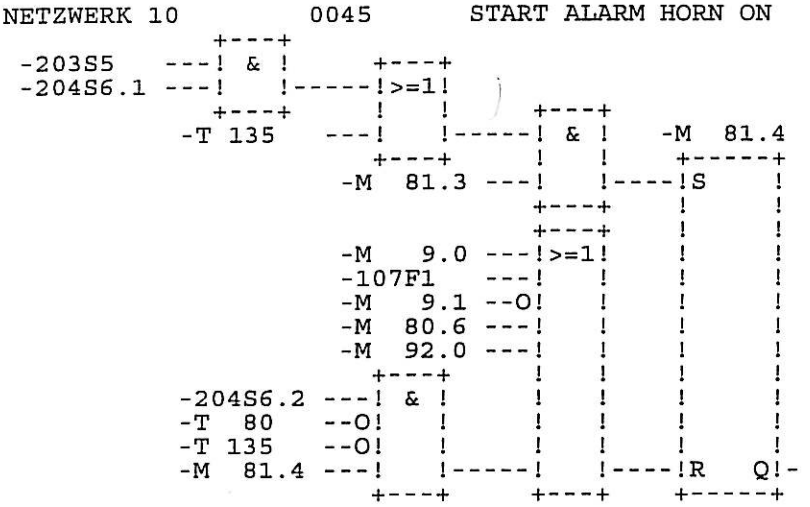
```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                    LINE                                     *
*                                                                             *
*******************************************************************************
0000      :***

NETZWERK 2          0001      LAMP FAULT LINE (CALANDER PANEL)
              +---+    +------+
 -M  80.0 ---! & !--+-! =    ! -290H7
              +---+    +------+

M   80.0 = M  80.0                    LINE : FAULT
A   60.6 = 290H7                      FAULT LINE (LAMP)          (CAL PANEL)

NETZWERK 3          0004      BY-PASS FAULTMESSAGES
            -T  33
             +-----+
 -M  81.1 --!T!-!0!
 KT 300.0 --!TW DU!-
            !   DE!-
          --!R   Q!-
            +-----+

M   81.1 = M  81.1                    LINE : AUXILIARY DRIVES ON
T   33   = T  33                     LINE : BY-PASS FAULT

NETZWERK 4          000D      RUN AFTER TIME AUX DRIVES
            -T 155
             +-----+
 -M  81.4 -O!1 - V!
 KT 100.1 --!TW DU!-
            !   DE!-
          --!R   Q!-
            +-----+

M   81.4 = M  81.4                    LINE : START ALARM HORN ON
T  155   = T 155                     LINE : RUN AFTER TIME AUX DRIVES

NETZWERK 5          0016      AUXILIARY DRIVES ON
                        +---+
            -203S3   ---! & !   -M  81.1
            -204S6.1 ---!   !    +-----+
            -204S6.2 --O!   !----!S    !
             +---+      +---+    !     !
 -203S4   --O! & !               !     !
 -204S6.1 ---!   !               !     !
 -T 155   --O!   !      +---+    !     !
 -M  81.4 --O!   !------!>=1!    !     !
             +---+      !   !    !     !
            -107F1   ---!   !    !     !
            -M   9.0 ---!   !    !     !
            -M   9.1 --O!   !----!R   Q!-
                        +---+    +-----+

E   82.2 = 203S3                      AUX DRIVE LINE ON       (MAIN CONTR.PAN.)
E   83.5 = 204S6.1                    MANUAL                  (MAIN CONTR.PAN.)
E   83.6 = 204S6.2                    AUTOMATIC               (MAIN CONTR.PAN.)
M   81.1 = M  81.1                    LINE : AUXILIARY DRIVES ON
E   82.3 = 203S4                      AUX DRIVE LINE OFF      (MAIN CONTR.PAN.)
T  155   = T 155                     LINE : RUN AFTER TIME AUX DRIVES
M   81.4 = M  81.4                    LINE : START ALARM HORN ON
E    7.0 = 107F1                      WATER STATION FAULT
M    9.0 = M   9.0                    E-STOP TRIGGERED
M    9.1 = M   9.1                    CONTROL VOLTAGE IS ON
```

NETZWERK 9 0041 LAMP LINE READY TO START



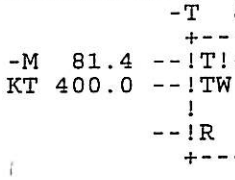
E	83.2 = 204S3	LAMP TEST	(MAIN CONTR.PAN.)
M	81.3 = M 81.3	LINE : LINE READY FOR WORK	
A	80.4 = 209H5	LINE READY TO START	(MAIN CONTR.PAN.)

NETZWERK 10 0045 START ALARM HORN ON



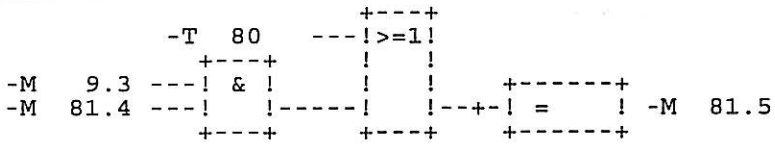
E	82.4 = 203S5	LINE START	(MAIN CONTR.PAN.)
E	83.5 = 204S6.1	MANUAL	(MAIN CONTR.PAN.)
T	135 = T 135	START ALARM FOR AUTOMTIC START	
M	81.3 = M 81.3	LINE : LINE READY FOR WORK	
M	81.4 = M 81.4	LINE : START ALARM HORN ON	
M	9.0 = M 9.0	E-STOP TRIGGERED	
E	7.0 = 107F1	WATER STATION FAULT	
M	9.1 = M 9.1	CONTROL VOLTAGE IS ON	
M	80.6 = M 80.6	LINE : LINE OFF	
M	92.0 = M 92.0	CALENDER : FAULTS CALENDER OFF	
E	83.6 = 204S6.2	AUTOMATIC	(MAIN CONTR.PAN.)
T	80 = T 80	LINE : START ALARM	

NETZWERK 11 0059 TIMER START ALARM IS RUNNING



M	81.4 = M 81.4	LINE : START ALARM HORN ON	
T	80 = T 80	LINE : START ALARM	

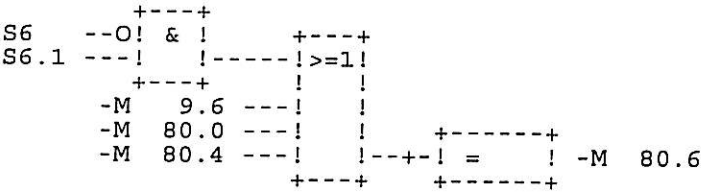
NETZWERK 12 0062 LINE ON



T	80 = T 80	LINE : START ALARM	
M	9.3 = M 9.3	PROGRAM IS RUNNING (AUTOMATIC)	
M	81.4 = M 81.4	LINE : START ALARM HORN ON	
M	81.5 = M 81.5	LINE : LINE ON	

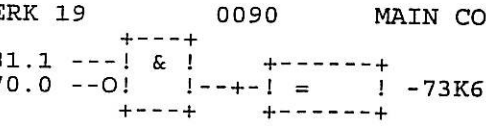
```
NETZWERK 13        0068      LAMP LINE ON
              +---+
 -M  81.5 ---!>=1!    +------+
 -204S3   ---!   !--+-! =    ! -210H6
              +---+    +------+

M   81.5 = M  81.5                  LINE : LINE ON
E   83.2 = 204S3                    LAMP TEST              (MAIN CONTR.PAN.)
A   81.5 = 210H6                    LINE ON              (MAIN CONTROL PANEL)

NETZWERK 14        006C      WARM AIR BLOWER ON
              +---+
 -M  81.5 ---! & !    +------+
 -A 10.5  ---!   !--+-! =    ! -A 40.1
              +---+    +------+

M   81.5 = M  81.5                  LINE : LINE ON
A   10.5 = A 10.5                   WATER STATION MAIN CONTACTOR ON
A   40.1 = A 40.1                   WARM AIR STEP 1/2/3

NETZWERK 15        0070      CALCULATE LINE SPEED FOR DISPLAY

                                  -FB  48
                                   +--------------+
                                   !   DISP-10V   !
                      -DB 170   --!DBNR          !
                      DD 62     --!IN            !
                      DD 34     --!OUT           !
          +3290000+02           --!RANG          !
                      -73A1     --!RESE          !
                                   +--------------+

A    3.2 = 73A1                     DRAW-OFF CONVEYOR ON

DB 170   = DB 170                   ACTUAL DATAS

FB  48   = FB  48                   CALCULATION FOR ANALOG DISPLAY

NETZWERK 16        0079      DISPLAY LINE SPEED

                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                      +184      --!PERE          !
                      DD 34     --!SOLL          !
          +1000000+02           --!EINH          !
                      -M   0.0  --!INVE          !
                      -M   0.1  --!FREI          !
                      -DB 170   --!DBNR          !
                                   +--------------+

M    0.0 = M   0.0                  "0"-SIGNAL
M    0.1 = M   0.1                  "1"-SIGNAL

DB 170   = DB 170                   ACTUAL DATAS

FB  44   = FB  44                   ANALOG OUTPUT

NETZWERK 17        0083      FAULT SKIVER
0083      :U   M    8.3  -M   8.3              FAULT SKIVER
0084      :UN  M   80.3  -M  80.3
0085      :=   M   80.4  -M  80.4
0086      :U   M    8.3  -M   8.3
0087      :=   M   80.3  -M  80.3
0088      :***

M    8.3 = M   8.3                  TREAD SKIVER : FAULT (MACHINE OFF)
M   80.3 = M  80.3                  HF-FAULT SKIVER
M   80.4 = M  80.4                  IMPULSE FAULT SKIVER
```

NETZWERK 18 0089 LINE STOP



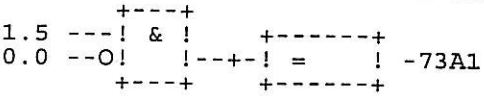
E	82.5 = 203S6	LINE STOP	(MAIN CONTR.PAN.)
E	83.5 = 204S6.1	MANUAL	(MAIN CONTR.PAN.)
M	9.6 = M 9.6	PROGRAM STOP	
M	80.0 = M 80.0	LINE : FAULT	
M	80.4 = M 80.4	IMPULSE FAULT SKIVER	
M	80.6 = M 80.6	LINE : LINE OFF	

NETZWERK 19 0090 MAIN CONTACTOR SHRINKAGE CONVEY.



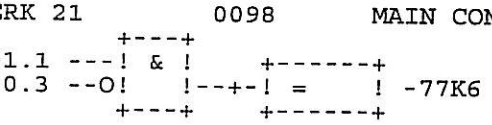
M	81.1 = M 81.1	LINE : AUXILIARY DRIVES ON
M	70.0 = M 70.0	FAULT CONV. CONVERTER DRAW+SHRINK
A	3.1 = 73K6	DRAW-OFF CONVEYOR MAIN CONTACTOR ON/OFF

NETZWERK 20 0094 DRAW-OFF/SHRINKAGE CONVEYOR ON



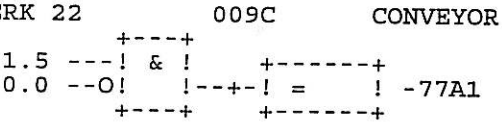
M	81.5 = M 81.5	LINE : LINE ON
M	80.0 = M 80.0	LINE : FAULT
A	3.2 = 73A1	DRAW-OFF CONVEYOR ON

NETZWERK 21 0098 MAIN CONTACTOR LINEAR WEIGHER



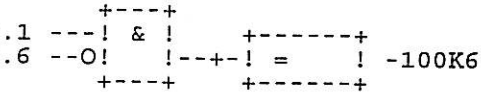
M	81.1 = M 81.1	LINE : AUXILIARY DRIVES ON
M	70.3 = M 70.3	FAULT CONV. CONVERTER CONT. SCALE
A	3.3 = 77K6	CONVEYOR LIN.CHECKER MAIN CONTACTOR ON

NETZWERK 22 009C CONVEYOR LINEAR WEIGHER ON



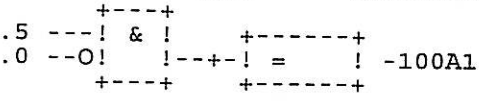
M	81.5 = M 81.5	LINE : LINE ON
M	80.0 = M 80.0	LINE : FAULT
A	3.4 = 77A1	CONVEYOR LINEAR CHECKER ON

NETZWERK 23 00A0 MAINCONTACTOR CEMENTING ON



M	81.1 = M 81.1	LINE : AUXILIARY DRIVES ON
M	70.6 = M 70.6	FAULT CONV. CONVERTER BOT.-CEMENTER
A	7.0 = 100K6	CONVEYOR CEMENTING 2 MAIN CONTACTOR ON

NETZWERK 24 00A4 CONVEYOR CEMENTING ON



```
M   81.5 = M  81.5                    LINE : LINE ON
M   80.0 = M  80.0                    LINE : FAULT
A    7.1 = 100A1                      CONVEYOR CEMENTING 2 ON

NETZWERK 25          00A8       MAIN CONTACTOR COOLING SECT.1 ON
              +---+
 -M  81.1 ---! & !    +------+
 -M  71.1 --O!   !--+-! =    ! -103K6
              +---+    +------+

M   81.1 = M  81.1                    LINE : AUXILIARY DRIVES ON
M   71.1 = M  71.1                    FAULT CONV. CONVERTER COOLING LINE 1
A    7.3 = 103K6                      COOLING SECTION 1 MAIN CONTACTOR ON

NETZWERK 26          00AC       COOLING SECTION 1 ON
              +---+
 -M  81.5 ---! & !    +------+
 -M  80.0 --O!   !--+-! =    ! -103A1
              +---+    +------+

M   81.5 = M  81.5                    LINE : LINE ON
M   80.0 = M  80.0                    LINE : FAULT
A    7.4 = 103A1                      COOLING SECT 1 ON

NETZWERK 27          00B0       MAIN CONTACTOR COOLING SECT.2 ON
              +---+
 -M  81.1 ---! & !    +------+
 -M  71.2 --O!   !--+-! =    ! -105K5
              +---+    +------+

M   81.1 = M  81.1                    LINE : AUXILIARY DRIVES ON
M   71.2 = M  71.2                    FAULT CONV. CONVERTER COOLING LINE 2
A    7.5 = 105K5                      COOLING SECT 2 MAIN CONTACTOR ON

NETZWERK 28          00B4       COOLING SECTION 2 ON
              +---+
 -M  81.5 ---! & !    +------+
 -M  80.0 --O!   !--+-! =    ! -105A1
              +---+    +------+

M   81.5 = M  81.5                    LINE : LINE ON
M   80.0 = M  80.0                    LINE : FAULT
A    7.6 = 105A1                      COOLING SECT 2 ON

NETZWERK 29          00B8       MAIN CONTACTOR COOLING SECT.3 ON
              +---+
 -M  81.1 ---! & !    +------+
 -M  71.3 --O!   !--+-! =    ! -108K6
              +---+    +------+

M   81.1 = M  81.1                    LINE : AUXILIARY DRIVES ON
M   71.3 = M  71.3                    FAULT CONV. CONVERTER COOLING LINE 3
A    8.0 = 108K6                      COOLING SECT 3 MAIN CONTACTOR ON

NETZWERK 30          00BC       COOLING SECTION 3 ON
              +---+
 -M  81.5 ---! & !    +------+
 -M  80.0 --O!   !--+-! =    ! -108A1
              +---+    +------+

M   81.5 = M  81.5                    LINE : LINE ON
M   80.0 = M  80.0                    LINE : FAULT
A    8.1 = 108A1                      COOLING SECT 3 ON

NETZWERK 31          00C0       MAIN CONTACTOR COOLING SECT.4 ON
              +---+
 -M  81.1 ---! & !    +------+
 -M  71.4 --O!   !--+-! =    ! -110K6
              +---+    +------+

M   81.1 = M  81.1                    LINE : AUXILIARY DRIVES ON
```

```
M   71.4 = M  71.4                    FAULT CONV. CONVERTER COOLING LINE 4
A    8.2 = 110K6                      COOLING SECT 4 MAIN CONTACTOR ON

NETZWERK 32          00C4       COOLING SECTION 4 ON
              +---+
 -M  81.5 ---! & !    +------+
 -M  80.0 --O!   !--+-! =    ! -110A1
              +---+    +------+

M   81.5 = M  81.5                    LINE : LINE ON
M   80.0 = M  80.0                    LINE : FAULT
A    8.3 = 110A1                      COOLING SECT 4 ON

NETZWERK 33          00C8       MAIN CONTACTOR CENTERING DEV. ON
              +---+
 -M  81.1 ---! & !    +------+
 -M  71.5 --O!   !--+-! =    ! -115K6
              +---+    +------+

M   81.1 = M  81.1                    LINE : AUXILIARY DRIVES ON
M   71.5 = M  71.5                    FAULT CONV. CONVERTER CENTERING
A    8.7 = 115K6                      CONVEYOR CENTERING 2 MAIN CONTACTOR ON

NETZWERK 34          00CC       CENTERING DEVICE ON
              +---+
 -M  81.5 ---! & !    +------+
 -M  80.0 --O!   !--+-! =    ! -115A1
              +---+    +------+

M   81.5 = M  81.5                    LINE : LINE ON
M   80.0 = M  80.0                    LINE : FAULT
A    9.0 = 115A1                      CONVEYOR CENTERING 2 ON

NETZWERK 35          00D0       MAIN CONTACTOR KNIFE MIDDLE SEP.
              +---+
 -M  81.1 ---! & !    +------+
 -M  72.0 --O!   !--+-! =    ! -113K6
              +---+    +------+

M   81.1 = M  81.1                    LINE : AUXILIARY DRIVES ON
M   72.0 = M  72.0                    FAULT CONV. CONVERTER KNIFE M.-SEP. DEV.
A    8.5 = 113K6                      CENTERING 2 KNIFE DRIVE 1 MAIN CONT ON

NETZWERK 36          00D4       KNIFE MIDDLE SEP. DEVICE ON
              +---+
 -M  81.5 ---! & !    +------+
 -M  80.0 --O!   !--+-! =    ! -113A1
              +---+    +------+

M   81.5 = M  81.5                    LINE : LINE ON
M   80.0 = M  80.0                    LINE : FAULT
A    8.6 = 113A1                      CENTERING 2 KNIFE DRIVE 1 ON

NETZWERK 37          00D8       MAIN CONTACTOR FREEWHEEL CONV.ON
              +---+
 -M  81.1 ---! & !    +------+
 -M  72.1 --O!   !--+-! =    ! -120K6
              +---+    +------+

M   81.1 = M  81.1                    LINE : AUXILIARY DRIVES ON
M   72.1 = M  72.1                    FAULT CONV. CONVERTER ACCELERATING
A    9.1 = 120K6                      FREEWHEEL ACCELERATING CONV MAIN CONT ON

NETZWERK 38          00DC       FREEWHEEL + ACCELER. CONVEYOR ON
              +---+
 -M  81.5 ---! & !    +------+
 -M  80.0 --O!   !--+-! =    ! -120A1
              +---+    +------+

M   81.5 = M  81.5                    LINE : LINE ON
M   80.0 = M  80.0                    LINE : FAULT
```

```
A    9.2 = 120A1                          FREEWHEEL ACCELERATING CONVEYER ON

NETZWERK 39          00E0      MAIN CONTACTOR TREAD CHECKER ON
              +---+
 -M  81.1 ---! & !    +------+
 -M  72.2 --O!   !--+-! =    ! -128K6
              +---+   +------+

M   81.1 = M  81.1                        LINE : AUXILIARY DRIVES ON
M   72.2 = M  72.2                        FAULT CONV. CONVERTER CHECK WEIGHTER
A    9.3 = 128K6                          CHECK WEIGHER MAIN CONTACTOR ON

NETZWERK 40          00E4      CONVEYOR TREAD CHECKER ON
              +---+
 -M  81.5 ---! & !    +------+
 -M  80.0 --O!   !--+-! =    ! -128A1
              +---+   +------+

M   81.5 = M  81.5                        LINE : LINE ON
M   80.0 = M  80.0                        LINE : FAULT
A    9.4 = 128A1                          CONVEYOR CHECK WEIGHER ON

NETZWERK 41          00E8      V line > V limit = M 7.6

                                 -FB  73
                                  +--------------+
                                  !   HYSTER.1   !
                       -DB 180  --!DB-I      AUSG!-- -M   7.6
                       DD 62    --!ISTW          !
            +1500000+02         --!OGR           !
            +1400000+02         --!UGR           !
                                  +--------------+

M    7.6 = M   7.6                        V-LINE PRESET > V-LINE LIMIT

DB 180   = DB 180                         PROFILE AG

FB  73   = FB  73                         HYSTERESE

NETZWERK 42          00F2      RELEASE SLOW-DOWN CONVEYOR FAST
              +---+   -T  83
 -M  81.5 ---! & !    +-----+
 -131K6   --O!   !----!T!-!0!
            +---+    !     !
          KT 050.0 --!TW DU!-
                     !   DE!-
                   --!R   Q!-
                     +-----+

M   81.5 = M  81.5                        LINE : LINE ON
A    9.6 = 131K6                          SLOW-DOWN ROLLER CONVEYOR SLOW
T   83   = T  83                          RELEASE SLOW-DOWN CONVEYOR FAST

NETZWERK 43          00FC      RELEASE SLOW-DOWN CONVEYOR SLOW
              +---+   -T  84
 -M  81.5 ---! & !    +-----+
 -131K5   --O!   !----!T!-!0!
            +---+    !     !
          KT 050.0 --!TW DU!-
                     !   DE!-
                   --!R   Q!-
                     +-----+

M   81.5 = M  81.5                        LINE : LINE ON
A    9.5 = 131K5                          SLOW-DOWN ROLLER CONVEYOR FAST
T   84   = T  84                          RELEASE SLOW-DOWN CONVEYOR SLOW

NETZWERK 44          0106      SLOW-DOWN CONVEYOR FAST
              +---+
 -M  81.5 ---! & !
 -M   7.6 ---!   !
 -M  80.0 --O!   !    +------+
 -T  83   ---!   !--+-! =    ! -131K5
              +---+   +------+
```

```
PB 80   -PB  80                          C:KERM06ST.S5D        BIB=28023   LAE=435

M   81.5 = M  81.5                       LINE : LINE ON
M    7.6 = M   7.6                       V-LINE PRESET > V-LINE LIMIT
M   80.0 = M  80.0                       LINE : FAULT
T   83   = T  83                         RELEASE SLOW-DOWN CONVEYOR FAST
A    9.5 = 131K5                         SLOW-DOWN ROLLER CONVEYOR FAST

NETZWERK 45         010C      SLOW-DOWN CONVEYOR SLOW
              +---+
 -M  81.5 ---! & !
 -M   7.6 --O!   !
 -M  80.0 --O!   !    +------+
 -T  84   ---!   !--+-! =    ! -131K6
             +---+    +------+

M   81.5 = M  81.5                       LINE : LINE ON
M    7.6 = M   7.6                       V-LINE PRESET > V-LINE LIMIT
M   80.0 = M  80.0                       LINE : FAULT
T   84   = T  84                         RELEASE SLOW-DOWN CONVEYOR SLOW
A    9.6 = 131K6                         SLOW-DOWN ROLLER CONVEYOR SLOW

NETZWERK 46         0112      RELEASE LENGHT M. + CEMENT. FAST
              +---+   -T  85
 -M  81.5 ---! & !    +-----+
 -132K6   --O!   !----!T!-!0!
              +---+    !     !
           KT 050.0 --!TW DU!-
                      !   DE!-
                    --!R   Q!-
                      +-----+

M   81.5 = M  81.5                       LINE : LINE ON
A   10.0 = 132K6                         END CEMENTING SLOW
T   85   = T  85                         RELEASE LENGTH M. + END CEMENTING FAST

NETZWERK 47         011C      RELEASE LENGHT.M. + CEMENT. SLOW
              +---+   -T  86
 -M  81.5 ---! & !    +-----+
 -132K5   --O!   !----!T!-!0!
              +---+    !     !
           KT 050.0 --!TW DU!-
                      !   DE!-
                    --!R   Q!-
                      +-----+

M   81.5 = M  81.5                       LINE : LINE ON
A    9.7 = 132K5                         END CEMENTING FAST
T   86   = T  86                         RELEASE LENGTH M. + END CEMENTING SLOW

NETZWERK 48         0126      LENGHT M. + CUT END CEMENT. FAST
             +---+
 -M  81.5 ---! & !
 -M   7.6 ---!   !
 -M  80.0 --O!   !    +------+
 -T  85   ---!   !--+-! =    ! -132K5
             +---+    +------+

M   81.5 = M  81.5                       LINE : LINE ON
M    7.6 = M   7.6                       V-LINE PRESET > V-LINE LIMIT
M   80.0 = M  80.0                       LINE : FAULT
T   85   = T  85                         RELEASE LENGTH M. + END CEMENTING FAST
A    9.7 = 132K5                         END CEMENTING FAST

NETZWERK 49         012C      LENGTH M. + CUT END CEMENT. SLOW
             +---+
 -M  81.5 ---! & !
 -M   7.6 --O!   !
 -M  80.0 --O!   !    +------+
 -T  86   ---!   !--+-! =    ! -132K6
             +---+    +------+

M   81.5 = M  81.5                       LINE : LINE ON
```

```
M    7.6 = M   7.6                    V-LINE PRESET > V-LINE LIMIT
M   80.0 = M  80.0                    LINE : FAULT
T   86   = T  86                      RELEASE LENGTH M. + END CEMENTING SLOW
A   10.0 = 132K6                      END CEMENTING SLOW
```

```
NETZWERK 50          0132       RELEASE TAKE-AWAY CONVEYOR FAST
                +---+    -T  87
 -M  81.5 ---! & !     +------+
 -136K6    --O!    !----!T!-!0!
                +---+    !     !
              KT 050.0 --!TW DU!-
                         !   DE!-
                       --!R   Q!-
                         +------+
```

```
M   81.5 = M  81.5                    LINE : LINE ON
A   10.3 = 136K6                      TAKE-AWAY CONVEYOR SLOW
T   87   = T  87                      RELEASE TAKE-AWAY CONVEYOR FAST
```

```
NETZWERK 51          013C       RELEASE TAKE-AWAY CONVEYOR SLOW
                +---+    -T  88
 -M  81.5 ---! & !     +------+
 -136K5    --O!    !----!T!-!0!
                +---+    !     !
              KT 050.0 --!TW DU!-
                         !   DE!-
                       --!R   Q!-
                         +------+
```

```
M   81.5 = M  81.5                    LINE : LINE ON
A   10.2 = 136K5                      TAKE-AWAY CONVEYOR FAST
T   88   = T  88                      RELEASE TAKE-AWAY CONVEYOR SLOW
```

```
NETZWERK 52          0146       TAKE-AWAY CONVEYOR FAST
              +---+
 -M  81.5 ---! & !
 -M   7.6 ---!   !
 -M  80.0 --O!   !     +------+
 -T  87   ---!   !--+-! =    ! -136K5
              +---+    +------+
```

```
M   81.5 = M  81.5                    LINE : LINE ON
M    7.6 = M   7.6                    V-LINE PRESET > V-LINE LIMIT
M   80.0 = M  80.0                    LINE : FAULT
T   87   = T  87                      RELEASE TAKE-AWAY CONVEYOR FAST
A   10.2 = 136K5                      TAKE-AWAY CONVEYOR FAST
```

```
NETZWERK 53          014C       TAKE-AWAY CONVEYOR SLOW
              +---+
 -M  81.5 ---! & !
 -M   7.6 --O!   !
 -M  80.0 --O!   !     +------+
 -T  88   ---!   !--+-! =    ! -136K6
              +---+    +------+
```

```
M   81.5 = M  81.5                    LINE : LINE ON
M    7.6 = M   7.6                    V-LINE PRESET > V-LINE LIMIT
M   80.0 = M  80.0                    LINE : FAULT
T   88   = T  88                      RELEASE TAKE-AWAY CONVEYOR SLOW
A   10.3 = 136K6                      TAKE-AWAY CONVEYOR SLOW
```

```
NETZWERK 54          0152       LENGHT CUTTER SCRAP ON
              +---+    +------+
 -M   9.1 ---! & !--+-! =    ! -137K5
              +---+    +------+
```

```
M    9.1 = M   9.1                    CONTROL VOLTAGE IS ON
A   10.4 = 137K5                      LENGHT CUTTER MAIN CONTACTOR ON
```

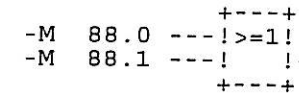
```
NETZWERK 55          0155       COLOUR MARKING DEVICE ON
              +---+    +------+
 -M  81.5 ---! & !--+-! =    ! -267B2
              +---+    +------+
```

```
M   81.5 = M  81.5                    LINE : LINE ON
A   41.1 = 267B2                      COLOUR MARKING DEVICE

NETZWERK 56          0158       CEMENTING 1 ROLL DOWN/UP
              +---+    -M  88.0
 -E 63.4  ---! & !     +-----+
 -M   9.1 ---!   !-----!S    !
              +---+     !     !
              +---+     !     !
 -E 63.7  --O!>=1!     !     !
 -M   9.0 ---!   !     !     !
 -M   9.1 --O!   !-----!R   Q!-
              +---+     +-----+

E   63.4 = E 63.4                     CEMENTING 1 ROLL DOWN          (CAL PANEL)
M    9.1 = M   9.1                    CONTROL VOLTAGE IS ON
M   88.0 = M  88.0                    CEMENTING 1 ROLL DOWN/UP
E   63.7 = E 63.7                     CEMENTING 1 ROLL UP            (CAL PANEL)
M    9.0 = M   9.0                    E-STOP TRIGGERED

NETZWERK 57          0161       CEMENTING 1 ROLL DOWN
            -T   6
             +-----+
 -M  88.0 --!1  -  !
 KT 050.0 --!TW DU!-
            !   DE!-
          --!R   Q!-
            +-----+

M   88.0 = M  88.0                    CEMENTING 1 ROLL DOWN/UP
T    6   = T   6                      CEMENTING 1 ROLL DOWN

NETZWERK 58          016A       CEMENTING 1 ROLL UP
            -T   7
             +-----+
 -M  88.0 -O!1  -  !
 KT 050.0 --!TW DU!-
            !   DE!-
          --!R   Q!-
            +-----+

M   88.0 = M  88.0                    CEMENTING 1 ROLL DOWN/UP
T    7   = T   7                      CEMENTING 1 ROLL UP

NETZWERK 59          0173       IMPULSE CEMENTING 1 ROLL DOWN/UP
0173       :U   T    6    -T   6
0174       :=   A   41.3  -267B4
0175       :=   A   41.7  -A 41.7
0176       :U   T    7    -T   7
0177       :=   A   41.2  -267B3
0178       :=   A   41.6  -A 41.6
0179       :***

T    6   = T   6                      CEMENTING 1 ROLL DOWN
A   41.3 = 267B4                      CEMENTING 1 ROLL DOWN LEFT SIDE
A   41.7 = A 41.7                     CEMENTING 1 ROLL DOWN RIGHT SIDE
T    7   = T   7                      CEMENTING 1 ROLL UP
A   41.2 = 267B3                      CEMENTING 1 ROLL UP LEFT SIDE
A   41.6 = A 41.6                     CEMENTING 1 ROLL UP RIGHT SIDE

NETZWERK 60          017A       CEMENTING 1 EDGE CEMENTING ON
              +---+    -M  88.1
 -E 62.4  ---! & !     +-----+
 -M   9.1 ---!   !-----!S    !
              +---+     !     !
              +---+     !     !
 -E 64.0  --O!>=1!     !     !
 -M   9.0 ---!   !     !     !   +------+
 -M   9.1 --O!   !-----!R   Q!-+-! =    ! -A 40.2
              +---+     +-----+   +------+
```

```
E   62.4 = E 62.4
M    9.1 = M   9.1
M   88.1 = M  88.1
E   64.0 = E 64.0
M    9.0 = M   9.0
A   40.2 = A 40.2
```

CEMENTING 1 EDGE CEMENT. ON (CAL PANEL)
CONTROL VOLTAGE IS ON
CEMENTING 1 EDGE CEMENTING ON
CEMENTING 1 EDGE CEMENT. OFF (CAL PANEL)
E-STOP TRIGGERED
CEMENTING 1 EDGE CEMENTING ON

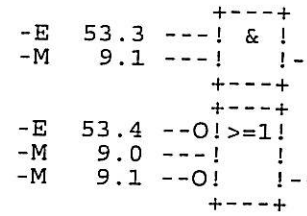
NETZWERK 61 0184 LAMP CEMENTING 1 ON




```
M   88.0 = M  88.0
M   88.1 = M  88.1
A   61.2 = A 61.2
```

CEMENTING 1 ROLL DOWN/UP
CEMENTING 1 EDGE CEMENTING ON
LAMP CEMENTING 1 ON (CAL PANEL)

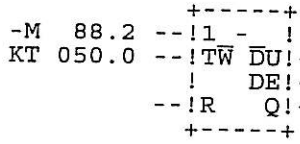
NETZWERK 62 0188 CEMENTING 2 ROLL DOWN/UP




```
E   53.3 = E  53.3
M    9.1 = M   9.1
M   88.2 = M  88.2
E   53.4 = E  53.4
M    9.0 = M   9.0
```

CEMENTING 2 ROLL DOWN (EXTR.CAL.PAN.)
CONTROL VOLTAGE IS ON
CEMENTING 2 ROLL DOWN/UP
CEMENTING 2 ROLL UP (EXTR.CAL.PAN.)
E-STOP TRIGGERED

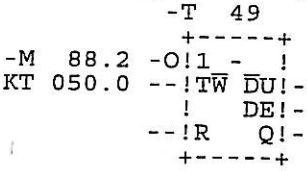
NETZWERK 63 0191 CEMENTING 2 ROLL DOWN




```
M   88.2 = M  88.2
T    8   = T   8
```

CEMENTING 2 ROLL DOWN/UP
CEMENTING 2 ROLL DOWN

NETZWERK 64 019A CEMENTING 2 ROLL UP




```
M   88.2 = M  88.2
T   49   = T  49
```

CEMENTING 2 ROLL DOWN/UP
CEMENTING 2 ROLL UP

```
NETZWERK 65          01A3       IMPULSE CEMENTING 2 ROLL DOWN/UP
01A3       :U   T    8     -T   8
01A4       :=   A   42.1   -A 42.1
01A5       :=   A   42.3   -A 42.3
01A6       :U   T   49     -T  49
01A7       :=   A   42.0   -A 42.0
01A8       :=   A   42.2   -A 42.2
01A9       :***
```

```
T    8   = T   8
A   42.1 = A 42.1
A   42.3 = A 42.3
T   49   = T  49
```

CEMENTING 2 ROLL DOWN
CEMENTING 2 ROLL DOWN LEFT SIDE
CEMENTING 2 ROLL DOWN RIGHT SIDE
CEMENTING 2 ROLL UP

```
A   42.0 = A 42.0                    CEMENTING 2 ROLL UP LEFT SIDE
A   42.2 = A 42.2                    CEMENTING 2 ROLL UP RIGHT SIDE

NETZWERK 66        01AA      LAMP CEMENTING 2 ON
              +---+    +------+
 -M  88.2 ---! & !--+-! =    ! -30H8
              +---+    +------+

M   88.2 = M  88.2                    CEMENTING 2 ROLL DOWN/UP
A   51.5 = 30H8                       LAMP CEMENTING 2 ON       (EXTR.CAL.PAN)

NETZWERK 67        01AD
01AD      :BE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                        NOMINAL VALUE FOR DRIVE MOTORS LINE                *
*                                                                           *
*****************************************************************************
0000      :***

NETZWERK 2          0001      LINE IS IN OPERATION
                +---+
 -73A1     ---!>=1!
 -77A1     ---!   !
 -100A1    ---!   !
 -103A1    ---!   !
 -105A1    ---!   !
 -108A1    ---!   !
 -110A1    ---!   !
 -113A1    ---!   !
 -115A1    ---!   !
 -120A1    ---!   !    +------+
 -M  81.5  ---!   !--+-! =    ! -M  80.1
               +---+    +------+

A    3.2 = 73A1                    DRAW-OFF CONVEYOR ON
A    3.4 = 77A1                    CONVEYOR LINEAR CHECKER ON
A    7.1 = 100A1                   CONVEYOR CEMENTING 2 ON
A    7.4 = 103A1                   COOLING SECT 1 ON
A    7.6 = 105A1                   COOLING SECT 2 ON
A    8.1 = 108A1                   COOLING SECT 3 ON
A    8.3 = 110A1                   COOLING SECT 4 ON
A    8.6 = 113A1                   CENTERING 2 KNIFE DRIVE 1 ON
A    9.0 = 115A1                   CONVEYOR CENTERING 2 ON
A    9.2 = 120A1                   FREEWHEEL ACCELERATING CONVEYER ON
M   81.5 = M  81.5                 LINE : LINE ON
M   80.1 = M  80.1                 LINE : LINE IS OPERATING

NETZWERK 3          000E      CONVEYOR UNCONTROLLED
               +---+   -M  80.2
 -203S2   ---! & !    +-----+
 -M  80.1 --O!   !----!S    !
               +---+    !    !
               +---+    !    !
 -203S2   --O! & !     !    !
 -M  80.1 --O!   !----!R   Q!-
               +---+    +-----+

E   82.1 = 203S2                   CONV.BELT LINE UNCONTR.(MAIN CONTR.PAN.)
M   80.1 = M  80.1                 LINE : LINE IS OPERATING
M   80.2 = M  80.2                 LINE : CONVEYORS CONTROLLED

NETZWERK 4          0016      COOLING SECTION 1 UNCONTROLLED
               +---+
 -M  80.2  ---!>=1!    +------+
 -E 46.7   ---!   !--+-! =    ! -M  79.0
               +---+    +------+

M   80.2 = M  80.2                 LINE : CONVEYORS CONTROLLED
E   46.7 = E 46.7                  SPARE
M   79.0 = M  79.0                 SPARE

NETZWERK 5          001A      COOLING SECTION 2 UNCONTROLLED
               +---+
 -M  80.2  ---!>=1!    +------+
 -E 45.7   ---!   !--+-! =    ! -M  79.1
               +---+    +------+

M   80.2 = M  80.2                 LINE : CONVEYORS CONTROLLED
E   45.7 = E 45.7                  SPARE
M   79.1 = M  79.1                 SPARE
```

```
NETZWERK 6          001E      LINE FASTER/SLOWER

                                  -FB  80
                                   +--------------+
                                   !   SLIT +/-   !
                        -DB 180  --!DBNR      SOLL!-- DD 62
                        -M   0.5 --!TAKT      H-DD!-- DD 136
                        -Z  57   --!ZAEH           !
                        -203S7.1 --!SIG+           !
                        -203S7.2 --!SIG-           !
                        005      --!XMAL           !
                  +2500000+02    --!SMAX           !
                  +3000000+01    --!SMIN           !
                  +2000000+01    --!FMAX           !
                  +9999999-01    --!FMIN           !
                        -M  83.1 --!MFL1           !
                        -M  83.2 --!MIM1           !
                        -M  83.3 --!HM2            !
                        -M  83.4 --!MFL2           !
                        -M  83.5 --!MIM2           !
                                   +--------------+

M    0.5 = M   0.5                  TACT 2 HZ
Z   57   = Z  57                    LINE : FASTER/SLOLIER
E   82.6 = 203S7.1                  LINE FASTER            (MAIN CONTR.PAN.)
E   82.7 = 203S7.2                  LINE SLOWER            (MAIN CONTR.PAN.)
M   83.1 = M  83.1                  LINE : HF FASTER/SLOWLIER
M   83.2 = M  83.2                  LINE : HF FASTER/SLOWLIER
M   83.3 = M  83.3                  LINE : HF FASTER/SLOWLIER
M   83.4 = M  83.4                  LINE : HF FASTER/SLOWLIER
M   83.5 = M  83.5                  LINE : HF FASTER/SLOWLIER

DB 180   = DB 180                   PROFILE AG

FB  80   = FB  80                   FASTER/SLOWLIER FOR 1 SWITCH

NETZWERK 7          0036      TRANSFER TO DB-CP
0036       :A   DB 185    -DB 185
0037       :U   E   82.6  -203S7.1
0038       :O   E   82.7  -203S7.2
0039       :U   D    1.11
003B       :SPB FB  58    -FB  58
003C NAME  :TRANS-DD
003D DB-Q  :    DB 180    -DB 180
003E QUEL  :    DD  62
003F DB-Z  :    DB 160    -DB 160
0040 ZIEL  :    DD  62
0041       :***

E   82.6 = 203S7.1                  LINE FASTER            (MAIN CONTR.PAN.)
E   82.7 = 203S7.2                  LINE SLOWER            (MAIN CONTR.PAN.)

DB 185   = DB 185                   PROFILE MANAGEMENT
DB 180   = DB 180                   PROFILE AG
DB 160   = DB 160                   PROFILE CP

FB  58   = FB  58                   TRANSFER DD-WORD

NETZWERK 8          0042      SPEED LINE IN % TO DB95

                                  -FB  82
                                   +--------------+
                                   !  CALSPEED    !
                                   +--------------+

FB  82   = FB  82                   CALCULATE LINE SPEED IN % FOR OUTPUT
```

NETZWERK 9 0045 CONVEYOR LINAER CHECK WEIGHER

```
                                  -FB  74
                                   +--------------+
                                   !   CONLOOP-   !
                      -DB  95   --!DBVE      SW  !-- DD 12
                      DD 2      --!VE            !
X          +1000000+01          --!KI            !
                      -M  80.2  --!UNGE          !
                      -DB 170   --!DBAE          !
Damage PV ------------> DD 48   --!IW            !
           +6000000+02          --!IW/2          !
           +1500000+02          --!RI/%          !
                      -DB  95   --!DBAA          !
                      -M   0.0  --!STOE          !
                                   +--------------+
```

1

```
M   80.2 = M  80.2                    LINE : CONVEYORS CONTROLLED
M    0.0 = M   0.0                    "0"-SIGNAL

DB  95   = DB  95                     GENERAL DATAS
DB 170   = DB 170                     ACTUAL DATAS

FB  74   = FB  74                     CONVEYOR DRIVE CTRL NEG. LOOP MAX=  0%
```

NETZWERK 10 0056 LOOP CALENDER

```
                                  -FB  74
                                   +--------------+
                                   !   CONLOOP-   !
                      -DB  95   --!DBVE      SW  !-- DD 4
                      DD 2      --!VE            !
           +1000000+01          --!KI            !
                      -M  80.2  --!UNGE          !
                      -DB 170   --!DBAE          !
                      DD 50     --!IW            !
           +5000000+02          --!IW/2          !
           +1500000+02          --!RI/%          !
                      -DB  95   --!DBAA          !
                      -M   0.0  --!STOE          !
                                   +--------------+
```

2

```
M   80.2 = M  80.2                    LINE : CONVEYORS CONTROLLED
M    0.0 = M   0.0                    "0"-SIGNAL

DB  95   = DB  95                     GENERAL DATAS
DB 170   = DB 170                     ACTUAL DATAS

FB  74   = FB  74                     CONVEYOR DRIVE CTRL NEG. LOOP MAX=  0%
```

NETZWERK 11 0067 CONVEYOR CEMENTING 2

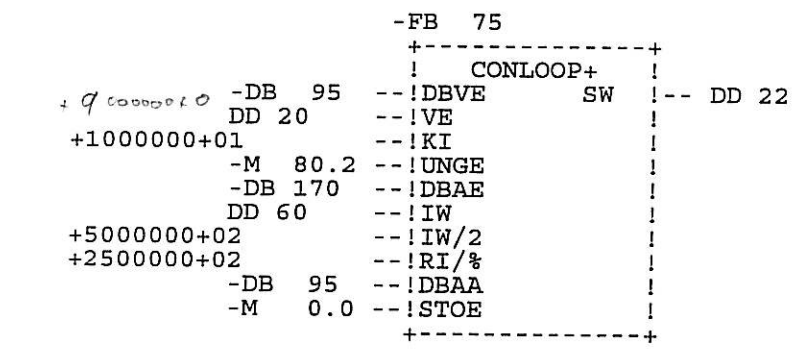
```
                                  -FB  75
                                   +--------------+
                                   !   CONLOOP+   !
                      -DB  95   --!DBVE      SW  !-- DD 14
                      DD 2      --!VE            !
           +1000000+01          --!KI            !
                      -M  80.2  --!UNGE          !
                      -DB 170   --!DBAE          !
                      DD 52     --!IW            !
           +5000000+02          --!IW/2          !
           +3500000+02          --!RI/%          !
                      -DB  95   --!DBAA          !
                      -M   0.0  --!STOE          !
                                   +--------------+
```

3

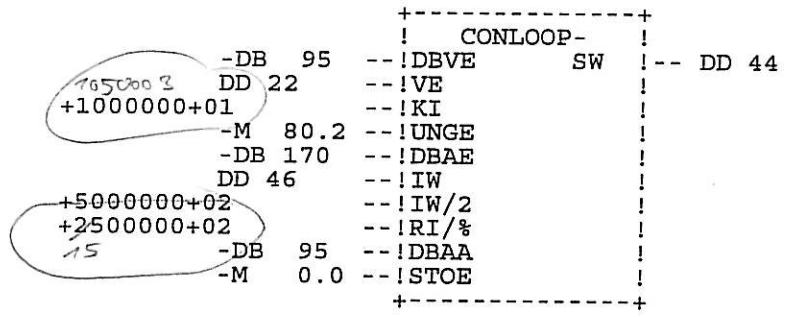
```
M   80.2 = M  80.2                    LINE : CONVEYORS CONTROLLED
M    0.0 = M   0.0                    "0"-SIGNAL

DB  95   = DB  95                     GENERAL DATAS
```

```
PB 81    -PB  81                        C:KERM06ST.S5D        BIB=8033     LAE=242

DB 170   = DB 170                       ACTUAL DATAS

FB  75   = FB  75                       CONVEYOR DRIVE CTRL POS. LOOP MAX=100%

NETZWERK 12          0078       COOLING SECTION 1

                                  -FB  75
                                   +--------------+
                                   !   CONLOOP+   !
                    -DB  95   --!DBVE       SW  !-- DD 16
                    DD 2      --!VE             !
          +1000000+01         --!KI             !
                    -M  80.2  --!UNGE           !
                    -DB 170   --!DBAE           !
                    DD 54     --!IW             !
          +5000000+02         --!IW/2           !
          +2000000+02         --!RI/%           !
                    -DB  95   --!DBAA           !
                    -M   0.0  --!STOE           !
                                +--------------+

M   80.2 = M  80.2                      LINE : CONVEYORS CONTROLLED
M    0.0 = M   0.0                      "0"-SIGNAL

DB  95   = DB  95                       GENERAL DATAS
DB 170   = DB 170                       ACTUAL DATAS

FB  75   = FB  75                       CONVEYOR DRIVE CTRL POS. LOOP MAX=100%

NETZWERK 13          0089       COOLING SECTION 2

                                  -FB  75
                                   +--------------+
                                   !   CONLOOP+   !
                    -DB  95   --!DBVE       SW  !-- DD 18
                    DD 16     --!VE             !
          +1000000+01         --!KI             !
                    -M  80.2  --!UNGE           !
                    -DB 170   --!DBAE           !
                    DD 56     --!IW             !
          +5000000+02         --!IW/2           !
          +2500000+02         --!RI/%           !
                    -DB  95   --!DBAA           !
                    -M   0.0  --!STOE           !
                                +--------------+

M   80.2 = M  80.2                      LINE : CONVEYORS CONTROLLED
M    0.0 = M   0.0                      "0"-SIGNAL

DB  95   = DB  95                       GENERAL DATAS
DB 170   = DB 170                       ACTUAL DATAS

FB  75   = FB  75                       CONVEYOR DRIVE CTRL POS. LOOP MAX=100%

NETZWERK 14          009A       COOLING SECTION 3

                                  -FB  74
                                   +--------------+
                                   !   CONLOOP-   !
                    -DB  95   --!DBVE       SW  !-- DD 20
                    DD 18     --!VE             !
          +1000000+01         --!KI             !
                    -M  80.2  --!UNGE           !
                    -DB 170   --!DBAE           !
                    DD 58     --!IW             !
          +5000000+02         --!IW/2           !
          +2500000+02         --!RI/%           !
                    -DB  95   --!DBAA           !
                    -M   0.0  --!STOE           !
                                +--------------+
```

```
PB 81   -PB  81                          C:KERM06ST.S5D        BIB=8033    LAE=242

M   80.2 = M  80.2                       LINE : CONVEYORS CONTROLLED
M    0.0 = M   0.0                       "0"-SIGNAL

DB  95   = DB  95                        GENERAL DATAS
DB 170   = DB 170                        ACTUAL DATAS

FB  74   = FB  74                        CONVEYOR DRIVE CTRL NEG. LOOP MAX=  0%

NETZWERK 15         00AB      COOLING SECTION 4
```




```
M   80.2 = M  80.2                       LINE : CONVEYORS CONTROLLED
M    0.0 = M   0.0                       "0"-SIGNAL

DB  95   = DB  95                        GENERAL DATAS
DB 170   = DB 170                        ACTUAL DATAS

FB  75   = FB  75                        CONVEYOR DRIVE CTRL POS. LOOP MAX=100%

NETZWERK 16         00BC      CONVEYOR CENTERING 2
```



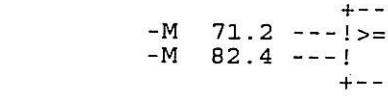

```
M   80.2 = M  80.2                       LINE : CONVEYORS CONTROLLED
M    0.0 = M   0.0                       "0"-SIGNAL

DB  95   = DB  95                        GENERAL DATAS
DB 170   = DB 170                        ACTUAL DATAS

FB  74   = FB  74                        CONVEYOR DRIVE CTRL NEG. LOOP MAX=  0%

NETZWERK 17         00CD      KNIFE MIDDLE SEPAR.DEVICE
00CD       :U   M   81.4   -M  81.4
00CE       :SPB FB  80     -FB  80
00CF NAME  :SLIT +/-
00D0 DBNR  :    DB  95     -DB  95
00D1 SOLL  :    DD  24
00D2 H-DD  :    DD  26
00D3 TAKT  :    M    0.5   -M   0.5
00D4 ZAEH  :    Z   55     -Z   55
00D5 SIG+  :    E   45.6   -E 45.6
00D6 SIG-  :    E   45.5   -E 45.5
00D7 XMAL  :    KZ 010
00D8 SMAX  :    KG +2000000+01
00DA SMIN  :    KG +5000000+00
00DC FMAX  :    KG +2000002+00
00DE FMIN  :    KG +2000000-01
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                    5!
+-------------------------------------------------------------------------------+
```

```
00E0 MFL1 :    M   93.0  -M  93.0
00E1 MIM1 :    M   93.1  -M  93.1
00E2 HM2  :    M   93.2  -M  93.2
00E3 MFL2 :    M   93.3  -M  93.3
00E4 MIM2 :    M   93.4  -M  93.4
00E5      :***

M   81.4 = M  81.4                  LINE : START ALARM HORN ON
M    0.5 = M   0.5                  TACT 2 HZ
Z   55   = Z  55                    KNIFE MIDDLE SEP.DEV.: HF FASTER/SLOWER
E   45.6 = E 45.6                   KNIFE MIDDLE SEPARATING DEVICE FASTER
E   45.5 = E 45.5                   KNIFE MIDDLE SEPARATING DEVICE SLOWLIER
M   93.0 = M  93.0                  KNIFE MIDDLE SEP.DEV.: HF FASTER/SLOWER
M   93.1 = M  93.1                  KNIFE MIDDLE SEP.DEV.: HF FASTER/SLOWER
M   93.2 = M  93.2                  KNIFE MIDDLE SEP.DEV.: HF FASTER/SLOWER
M   93.3 = M  93.3                  KNIFE MIDDLE SEP.DEV.: HF FASTER/SLOWER
M   93.4 = M  93.4                  KNIFE MIDDLE SEP.DEV.: HF FASTER/SLOWER

DB  95   = DB  95                   GENERAL DATAS

FB  80   = FB  80                   FASTER/SLOWLIER FOR 1 SWITCH

NETZWERK 18         00E6      CALCULATE SPEED MIDDLE SEP.DEV.
00E6      :A   DB  95    -DB  95
00E7      :L   DD  22
00E8      :L   DD  24
00E9      :XG
00EA      :T   DD  28
00EB      :***


DB  95   = DB  95                   GENERAL DATAS

NETZWERK 19         00EC
00EC      :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  FAULTS LINE                                *
*                                                                             *
*******************************************************************************
0000      :***

NETZWERK 2          0001      RIPCORD DOWN PART 1 RIGHT SIDE
             +---+    +------+
 -A900.2  ---! & !--+-! =    ! -M0325
             +---+    +------+

E   46.4 = A900.2                    E-STOP RIPCORD DOWN PART 1 RIGHT SIDE
M  189.0 = M0325                     E-STOP RIPCORD DOWN PART 1 RIGHT    LINE

NETZWERK 3          0004      RIPCORD DOWN PART 2 RIGHT SIDE
             +---+    +------+
 -E 75.4  ---! & !--+-! =    ! -M0326
             +---+    +------+

E   75.4 = E 75.4                    E-STOP RIPCORD DOWN PART 2 RIGHT SIDE
M  189.1 = M0326                     E-STOP RIPCORD DOWN PART 2 RIGHT    LINE

NETZWERK 4          0007      RIPCORD DOWN PART 3 RIGHT SIDE
             +---+    +------+
 -A950.2  ---! & !--+-! =    ! -M0327
             +---+    +------+

E   73.4 = A950.2                    E-STOP RIPCORD DOWN PART 3 RIGHT SIDE
M  189.2 = M0327                     E-STOP RIPCORD DOWN PART 3 RIGHT    LINE

NETZWERK 5          000A      RIPCORD DOWN PART 4 RIGHT SIDE
             +---+    +------+
 -A950.1  ---! & !--+-! =    ! -M0328
             +---+    +------+

E   73.3 = A950.1                    E-STOP RIPCORD DOWN PART 4 RIGHT SIDE
M  189.3 = M0328                     E-STOP RIPCORD DOWN PART 4 RIGHT    LINE

NETZWERK 6          000D      RIPCORD UP FRONT RIGHT SIDE
             +---+    +------+
 -A900.1  ---! & !--+-! =    ! -M0330
             +---+    +------+

E   46.3 = A900.1                    E-STOP RIPCORD UP FRONT RIGHT SIDE
M  189.5 = M0330                     E-STOP RIPCORD UP FRONT RIGHT SIDE  LINE

NETZWERK 7          0010      RIPCORD UP REAR RIGHT SIDE
             +---+    +------+
 -A950.3  ---! & !--+-! =    ! -M0332
             +---+    +------+

E   73.5 = A950.3                    E-STOP RIPCORD UP REAR RIGHT SIDE
M  189.7 = M0332                     E-STOP RIPCORD UP REAR RIGHT SIDE   LINE

NETZWERK 8          0013      RIPCORD UP FRONT LEFT SIDE
             +---+    +------+
 -A900.0  ---! & !--+-! =    ! -M0329
             +---+    +------+

E   46.2 = A900.0                    E-STOP RIPCORD UP FRONT LEFT SIDE
M  189.4 = M0329                     E-STOP RIPCORD UP FRONT LEFT SIDE   LINE

NETZWERK 9          0016      RIPCORD UP REAR LEFT SIDE
             +---+    +------+
 -A950.4  ---! & !--+-! =    ! -M0331
             +---+    +------+

E   73.6 = A950.4                    E-STOP RIPCORD UP REAR LEFT SIDE
```

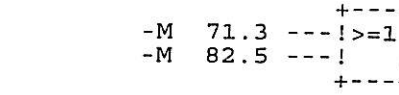
```
M  189.6 = M0331                          E-STOP RIPCORD UP REAR LEFT SIDE    LINE

NETZWERK 10        0019      EXHAUST DRAW-OFF CONVEYOR
                +---+    +------+
 -72Q1     ---! & !--+-! =    ! -M0190
                +---+    +------+

E    2.1 = 72Q1                           EXHAUST FRONT PLANT SECTION FAULT
M  170.1 = M0190                          EXHAUSTER FAULT        DRAW-OFF CONVEYOR

NETZWERK 11        001C      MOTOR TEMP. EXHAUST DRAW-OFF C.
                +---+    +------+
 -72A7     ---! & !--+-! =    ! -M0191
                +---+    +------+

E    2.2 = 72A7                           EXHAUST FRONT PL. EXCESS TEM MOT WINDING
M  170.2 = M0191                          DRIVE MOTOR FAULT      DRAW-OFF CONVEYOR

NETZWERK 12        001F      DRIVE MOTOR DRAW-OFF CONVEYOR
              +---+
 -M  70.0 ---!>=1!
 -M  70.1 ---!   !
 -M  70.2 ---!   !    +------+
 -M  82.0 ---!   !--+-! =    ! -M0192
              +---+    +------+

M   70.0 = M  70.0                        FAULT CONV. CONVERTER DRAW+SHRINK
M   70.1 = M  70.1                        FAULT CONV. DRIVE TEMP. DRAW+&SHRINK
M   70.2 = M  70.2                        FAULT CONV. DRIVE FAN DRAW+SHRINK
M   82.0 = M  82.0                        FAULT SPEED DRAW-OFF CONVEYOR
M  170.3 = M0192                          DRIVE MOTOR FAULT     SHRINKAGE CONVEYOR

NETZWERK 13        0025      DRIVE MOTOR LINEAR WEIGHER
              +---+
 -M  70.3 ---!>=1!
 -M  70.4 ---!   !
 -M  70.5 ---!   !    +------+
 -M  82.1 ---!   !--+-! =    ! -M0193
              +---+    +------+

M   70.3 = M  70.3                        FAULT CONV. CONVERTER CONT. SCALE
M   70.4 = M  70.4                        FAULT CONV. DRIVE TEMP. CONT. SCALE
M   70.5 = M  70.5                        FAULT CONV. DRIVE FAN CONT. SCALE
M   82.1 = M  82.1                        FAULT SPEED CONT. SCALE CONVEYOR
M  170.4 = M0193                          DRIVE MOTOR FAULT   LIN.WEIGHER CONVEYOR

NETZWERK 14        002B      DRIVE MOTOR CONVEYOR CEMENTING 2
              +---+
 -M  70.6 ---!>=1!
 -M  70.7 ---!   !
 -M  71.0 ---!   !    +------+
 -M  82.2 ---!   !--+-! =    ! -M0194
              +---+    +------+

M   70.6 = M  70.6                        FAULT CONV. CONVERTER BOT.-CEMENTER
M   70.7 = M  70.7                        FAULT CONV. DRIVE TEMP. BOT.-CEMENTER
M   71.0 = M  71.0                        FAULT CONV. DRIVE FAN BOT.-CEMENTER
M   82.2 = M  82.2                        FAULT SPEED CEMENTING 2 CONVEYOR
M  170.5 = M0194                          DRIVE MOTOR FAULT     CEMENTING CONVEYOR

NETZWERK 15        0031      DRIVE MOTOR COOLING SECTION 1
              +---+
 -M  71.1 ---!>=1!    +------+
 -M  82.3 ---!   !--+-! =    ! -M0195
              +---+    +------+

M   71.1 = M  71.1                        FAULT CONV. CONVERTER COOLING LINE 1
M   82.3 = M  82.3                        FAULT SPEED COOLING SECTION 1 CONVEYOR
M  170.6 = M0195                          DRIVE MOTOR FAULT      COOLING SECTION 1
```

NETZWERK 16 0035 DRIVE MOTOR COOLING SECTION 2



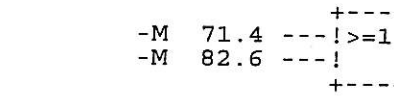
M 71.2 = M 71.2 FAULT CONV. CONVERTER COOLING LINE 2
M 82.4 = M 82.4 FAULT SPEED COOLING SECTION 2 CONVEYOR
M 170.7 = M0196 DRIVE MOTOR FAULT COOLING SECTION 2

NETZWERK 17 0039 DRIVE MOTOR COOLING SECTION 3



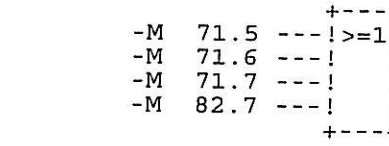
M 71.3 = M 71.3 FAULT CONV. CONVERTER COOLING LINE 3
M 82.5 = M 82.5 FAULT SPEED COOLING SECTION 3 CONVEYOR
M 171.0 = M0181 DRIVE MOTOR FAULT COOLING SECTION 3

NETZWERK 18 003D DRIVE MOTOR COOLING SECTION 4



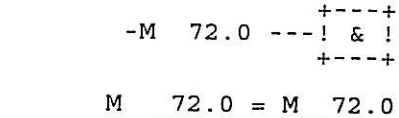
M 71.4 = M 71.4 FAULT CONV. CONVERTER COOLING LINE 4
M 82.6 = M 82.6 FAULT SPEED COOLING SECTION 4 CONVEYOR
M 171.1 = M0182 DRIVE MOTOR FAULT COOLING SECTION 4

NETZWERK 19 0041 DRIVE MOTOR CENTERING 2



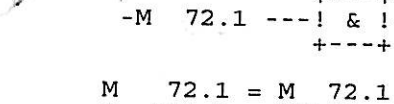
M 71.5 = M 71.5 FAULT CONV. CONVERTER CENTERING
M 71.6 = M 71.6 FAULT CONV. DRIVE TEMP. CENT.+FEED
M 71.7 = M 71.7 FAULT CONV. DRIVE FAN CENT. + FEEDING
M 82.7 = M 82.7 FAULT SPEED CENTERING 2 CONVEYOR
M 171.7 = M0188 DRIVE MOTOR FAULT CENTERING DEVICE

NETZWERK 20 0047 DRIVE MOTOR MIDDLE SEP. DEVICE



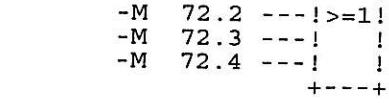
M 72.0 = M 72.0 FAULT CONV. CONVERTER KNIFE M.-SEP. DEV.
M 172.0 = M0205 FESTOONER LOOP MIDDLE SEPARATE DEVICE

NETZWERK 21 004A DRIVE MOTOR ACCELERATING CONVEY.



M 72.1 = M 72.1 FAULT CONV. CONVERTER ACCELERATING
M 171.2 = M0183 DRIVE MOTOR FAULT ACCELERATING CONVEYOR

NETZWERK 22 004D DRIVE MOTOR TREAD CHECKER



M 72.2 = M 72.2 FAULT CONV. CONVERTER CHECK WEIGHTER
M 72.3 = M 72.3 FAULT CONV. DRIVE TEMP. CHECK WEIGHTER
M 72.4 = M 72.4 FAULT CONV. DRIVE FAN CHECK WEIGHTER
M 171.3 = M0184 DRIVE MOTOR FAULT TREAD CHECK WEIGHER

NETZWERK 23 0052 DRIVE MOTOR SLOW-DOWN CONVEYOR

```
          +---+    +------+
 -M  72.5 ---! & !--+-! =    ! -M0185
          +---+    +------+
```

M 72.5 = M 72.5 FAULT CONV. CONVERTER SLOW-DOWN
M 171.4 = M0185 DRIVE MOTOR FAULT SLOW-DOWN ROLLER CONV.

NETZWERK 24 0055 DRIVE MOTOR TREAD END CEMENTER

```
          +---+    +------+
 -M  72.6 ---! & !--+-! =    ! -M0186
          +---+    +------+
```

M 72.6 = M 72.6 FAULT CONV. CONVERTER END CEMENTING
M 171.5 = M0186 DRIVE MOTOR FAULT TREAD END CEMENTER

NETZWERK 25 0058 DRIVE MOTOR TAKE-AWAY CONVEYOR

```
          +---+    +------+
 -M  72.7 ---! & !--+-! =    ! -M0187
          +---+    +------+
```

M 72.7 = M 72.7 FAULT CONV. CONVERTER TAKE-AWAY
M 171.6 = M0187 MOTOR FAULT TAKE-AWAY + SCRAP CONVEYOR

NETZWERK 26 005B CONV. FAULT IS CONVERTER FAULT

```
          +---+
 -M  70.0 ---!>=1!
 -M  70.3 ---!   !
 -M  70.6 ---!   !
 -M  71.1 ---!   !
 -M  71.2 ---!   !
 -M  71.3 ---!   !
 -M  71.4 ---!   !
 -M  71.5 ---!   !
 -M  72.0 ---!   !
 -M  72.1 ---!   !
 -M  72.2 ---!   !
 -M  72.5 ---!   !
 -M  72.6 ---!   !    +------+
 -M  72.7 ---!   !--+-! =    ! -M0320
          +---+    +------+
```

M 70.0 = M 70.0 FAULT CONV. CONVERTER DRAW+SHRINK
M 70.3 = M 70.3 FAULT CONV. CONVERTER CONT. SCALE
M 70.6 = M 70.6 FAULT CONV. CONVERTER BOT.-CEMENTER
M 71.1 = M 71.1 FAULT CONV. CONVERTER COOLING LINE 1
M 71.2 = M 71.2 FAULT CONV. CONVERTER COOLING LINE 2
M 71.3 = M 71.3 FAULT CONV. CONVERTER COOLING LINE 3
M 71.4 = M 71.4 FAULT CONV. CONVERTER COOLING LINE 4
M 71.5 = M 71.5 FAULT CONV. CONVERTER CENTERING
M 72.0 = M 72.0 FAULT CONV. CONVERTER KNIFE M.-SEP. DEV.
M 72.1 = M 72.1 FAULT CONV. CONVERTER ACCELERATING
M 72.2 = M 72.2 FAULT CONV. CONVERTER CHECK WEIGHTER
M 72.5 = M 72.5 FAULT CONV. CONVERTER SLOW-DOWN
M 72.6 = M 72.6 FAULT CONV. CONVERTER END CEMENTING
M 72.7 = M 72.7 FAULT CONV. CONVERTER TAKE-AWAY
M 186.3 = M0320 CONV. FAULT IS POSSIBLE CONVERTER FAULT

NETZWERK 27 006B CONV. FAULT IS OVERTEMP. FAULT

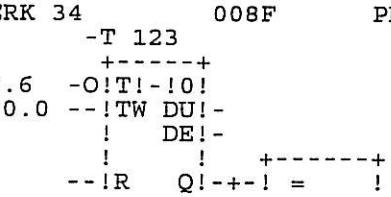
```
          +---+
 -M  70.1 ---!>=1!
 -M  70.4 ---!   !
 -M  70.7 ---!   !
 -M  71.6 ---!   !    +------+
 -M  72.3 ---!   !--+-! =    ! -M0321
          +---+    +------+
```

M 70.1 = M 70.1 FAULT CONV. DRIVE TEMP. DRAW+&SHRINK
M 70.4 = M 70.4 FAULT CONV. DRIVE TEMP. CONT. SCALE
M 70.7 = M 70.7 FAULT CONV. DRIVE TEMP. BOT.-CEMENTER
M 71.6 = M 71.6 FAULT CONV. DRIVE TEMP. CENT.+FEED

```
M   72.3 = M  72.3                    FAULT CONV. DRIVE TEMP. CHECK WEIGHTER
M  186.4 = M0321                      CONV. FAULT IS POSSIBLE OVERTEMP FAULT

NETZWERK 28          0072       CONV. FAULT IS FAN FAULT
                +---+
 -M  70.2 ---!>=1!
 -M  70.5 ---!   !
 -M  71.0 ---!   !
 -M  71.7 ---!   !    +------+
 -M  72.4 ---!   !--+-! =    ! -M0322
               +---+    +------+

M   70.2 = M  70.2                    FAULT CONV. DRIVE FAN DRAW+SHRINK
M   70.5 = M  70.5                    FAULT CONV. DRIVE FAN CONT. SCALE
M   71.0 = M  71.0                    FAULT CONV. DRIVE FAN BOT.-CEMENTER
M   71.7 = M  71.7                    FAULT CONV. DRIVE FAN CENT. + FEEDING
M   72.4 = M  72.4                    FAULT CONV. DRIVE FAN CHECK WEIGHTER
M  186.5 = M0322                      CONV. FAULT IS POSSIBLE FAN FAULT

NETZWERK 29          0079       CONV FAULT IS OVERSPEED FAULT
                +---+
 -M  82.0 ---!>=1!
 -M  82.1 ---!   !
 -M  82.2 ---!   !
 -M  82.3 ---!   !
 -M  82.4 ---!   !
 -M  82.5 ---!   !
 -M  82.6 ---!   !    +------+
 -M  82.7 ---!   !--+-! =    ! -M0323
               +---+    +------+

M   82.0 = M  82.0                    FAULT SPEED DRAW-OFF CONVEYOR
M   82.1 = M  82.1                    FAULT SPEED CONT. SCALE CONVEYOR
M   82.2 = M  82.2                    FAULT SPEED CEMENTING 2 CONVEYOR
M   82.3 = M  82.3                    FAULT SPEED COOLING SECTION 1 CONVEYOR
M   82.4 = M  82.4                    FAULT SPEED COOLING SECTION 2 CONVEYOR
M   82.5 = M  82.5                    FAULT SPEED COOLING SECTION 3 CONVEYOR
M   82.6 = M  82.6                    FAULT SPEED COOLING SECTION 4 CONVEYOR
M   82.7 = M  82.7                    FAULT SPEED CENTERING 2 CONVEYOR
M  186.6 = M0323                      CONV. FAULT IS POSSIBLE OVERSPEED FAULT

NETZWERK 30          0083       DRIVE MOTOR EXHAUST CEMENTING 1
              +---+    +------+
 -79Q2    ---! & !--+-! =    ! -M0203
              +---+    +------+

E    2.5 = 79Q2                       EXHAUST CEMENTING 1 FAULT
M  173.6 = M0203                      DRIVE MOTOR FAULT EXHAUSTER CEM.DEVICE 1

NETZWERK 31          0086       MOTOR TEMP. EXHAUST CEMENTING 1
              +---+    +------+
 -79A7    ---! & !--+-! =    ! -M0204
              +---+    +------+

E    2.6 = 79A7                       EXHAUST CEM1 FAULT EXCESS TEMP MOT WIND
M  173.7 = M0204                      DRIVE MOTOR TEMP. EXHAUSTER CEM.DEVICE 1

NETZWERK 32          0089       DRIVE MOTOR EXHAUST CEMENTING 2
              +---+    +------+
 -102Q2   ---! & !--+-! =    ! -M0222
              +---+    +------+

E    6.1 = 102Q2                      EXHAUST CEMENTING 2 FAULT
M  174.1 = M0222                      DRIVE MOTOR FAULT EXHAUSTER CEM.DEVICE 2

NETZWERK 33          008C       MOTOR TEMP. EXHAUST CEMENTING 2
              +---+    +------+
 -102A6   ---! & !--+-! =    ! -M0223
              +---+    +------+

E    6.2 = 102A6                      EXHAUST CEMENTING 2 EXCESS TEMP.MOT WIND
```

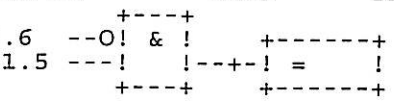
M 174.2 = M0223 DRIVE MOTOR TEMP. EXHAUSTER CEM.DEVICE 2

NETZWERK 34 008F PRESSURE COOLING WATER



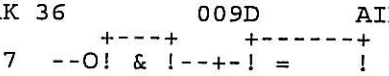
E 25.6 = E 25.6 PRESSURE COOLING WATER OK
T 123 = T 123 FAULT PRESSURE COOLING WATER
M 179.4 = M0249 PRESSURE COOLING WATER TO LOW

NETZWERK 35 0099 PRESSURE EXHAUST CEMENTING 1



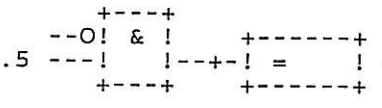
E 42.6 = E 42.6 CEM 1 EXHAUST PRESSURE OK
M 81.5 = M 81.5 LINE : LINE ON
M 174.0 = M0221 PRESSURE FAULT EXHAUSTER CEM.DEVICE 1

NETZWERK 36 009D AIR PRESSURE CEMENTER CEM.1



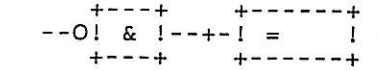
E 42.7 = E 42.7 CEM 1 CEMENTER PRESSURE
M 186.0 = M0317 AIR PRESSURE CEMENTING 1

NETZWERK 37 00A0 PRESSURE EXHAUST CEMENTING 2



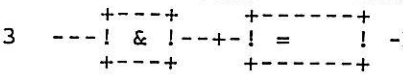
E 46.1 = 264S2 CEM 2 PRESSURE EXHAUST OK
M 81.5 = M 81.5 LINE : LINE ON
M 174.3 = M0224 PRESSURE FAULT EXHAUSTER CEM.DEVICE 2

NETZWERK 38 00A4 AIR PRESSURE CEMENTER CEM. 2



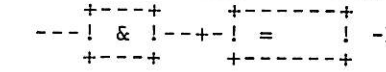
E 46.0 = 264S1 CEM 2 CEMENTER PRESSURE
M 186.1 = M0318 AIR PRESSURE CEMENTING 2

NETZWERK 39 00A7 COOLING UNIT



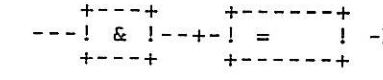
E 7.3 = E 7.3 TEMPER. UNIT FAULT
M 177.5 = M0234 AIR CONDITIONER ELECTRICAL CONTROL ROOM

NETZWERK 40 00AA DRIVE MOTOR WATER STATION



E 7.0 = 107F1 WATER STATION FAULT
M 177.6 = M0235 DRIVE MOT FAULT WATER BLOW-OFF STATION

NETZWERK 41 00AD MOTOR TEMP. WATER STATION



```
E    7.1 = 102A8                    WATER EXCESS TEMP MOT WINDING
M  177.7 = M0236                    DRIVE MOT TEMP.   WATER BLOW-OFF STATION

NETZWERK 42          00B0      DRIVE MOTOR TREAD END CEMENTING
              +---+    +------+
 -133Q1   ---! & !--+-! =    ! -M0255
              +---+    +------+

E    8.2 = 133Q1                    END CEM. EXHAUST FAULT
M  178.2 = M0255                    DRIVE MOT. FAULT EXHAUSTER TREAD END CEM

NETZWERK 43          00B3      MOTOR TEMP. EXHAUST TREAD END C.
              +---+    +------+
 -133A7   ---! & !--+-! =    ! -M0256
              +---+    +------+

E    8.3 = 133A7                    END CEM. EXHAUST EXCESS TEMP MOT WINDING
M  178.3 = M0256                    DRIVE MOT. TEMP. EXHAUSTER TREAD END CEM

NETZWERK 44          00B6      PRESSURE EXHAUST TREAD END CEM.
              +---+
 -E 73.7  --O! & !    +------+
 -M  81.5 ---!   !--+-! =    ! -M0257
              +---+    +------+

E   73.7 = E 73.7                   END CEMENTING PRESSURE EXHAUST OK
M   81.5 = M  81.5                  LINE : LINE ON
M  178.4 = M0257                    PRESSURE FAULT  EXHAUSTER TREAD END CEM.

NETZWERK 45          00BA      AIR PRESS. CEMENTER CUT END CEM.
              +---+    +------+
 -298S7   --O! & !--+-! =    ! -M0319
              +---+    +------+

E   72.6 = 298S7                    CUT END CEMENTING CEMENTER PRESSURE
M  186.2 = M0319                    AIR PRESSURE CUT END CEMENTING

NETZWERK 46          00BD      PRESSURE FAULT WATER BLOW-OFF S.
              +---+
 -E 46.5  --O! & !    +------+
 -M  81.5 ---!   !--+-! =    ! -M0253
              +---+    +------+

E   46.5 = E 46.5                   PRESSURE WATERSYSTEM OK
M   81.5 = M  81.5                  LINE : LINE ON
M  178.0 = M0253                    PRESSURE FAULT    WATER BLOW-OFF STATION

NETZWERK 47          00C1      C02-FIRE EXTINGUISHER ALARM
              +---+    +------+
 -E 84.7  --O! & !--+-! =    ! -M0225
              +---+    +------+

E   84.7 = E 84.7                   CO2 FIRE EXTINGUISHER ALARM
M  174.4 = M0225                    CO2 FIRE EXTINGUISHER ALARM

NETZWERK 48          00C4      CO2-FIRE EXTINGUISHER FAULT
              +---+    +------+
 -E 84.6  --O! & !--+-! =    ! -M0226
              +---+    +------+

E   84.6 = E 84.6                   CO2 FIRE EXTINGUISHER FAULT
M  174.5 = M0226                    CO2 FIRE EXTINGUISHER FAULT

NETZWERK 49          00C7      LOOP LINEAR WEIGHER
00C7       :BEA
00C8       :U   M   81.5  -M  81.5
00C9       :SPB FB  33    -FB  33
00CA NAME  :LOOP-FAU
00CB DBAE  :    DB 170    -DB 170
00CC IW-L  :    DD  48
00CD MAX   :    KG +9500000+02
00CF MIN   :    KG +2000000+01
00D1 MARK  :    M   17.0  -M  17.0
00D2 T-NR  :    T  101    -T 101
```

```
00D3 ST-M :    M  172.1  -M0206
00D4      :***

M   81.5 = M  81.5                  LINE : LINE ON
M   17.0 = M  17.0                  EXTR. POSITION LOOP LINEAR CHECK WEIGHER
T  101   = T 101                    FAULT : LOOP CONTINUOUS WEIGHER
M  172.1 = M0206                    FESTOONER LOOP      LINEAR CHECK WEIGHER

DB 170   = DB 170                   ACTUAL DATAS

FB  33   = FB  33                   CHECK LOOP

NETZWERK 50         00D5      LOOP CALANDER
00D5      :U   M   81.5  -M  81.5
00D6      :SPB FB  33    -FB  33
00D7 NAME :LOOP-FAU
00D8 DBAE :    DB 170    -DB 170
00D9 IW-L :    DD  50
00DA MAX  :    KG +9500000+02
00DC MIN  :    KG +2000000+01
00DE MARK :    M   17.6  -M  17.6
00DF T-NR :    T  107    -T 107
00E0 ST-M :    M  178.5  -M0258
00E1      :***

M   81.5 = M  81.5                  LINE : LINE ON
M   17.6 = M  17.6                  EXTR. POSITION LOOP CALENDER
T  107   = T 107                    FAULT : LOOP CALENDER
M  178.5 = M0258                    FESTOONER LOOP                  CALENDER

DB 170   = DB 170                   ACTUAL DATAS

FB  33   = FB  33                   CHECK LOOP

NETZWERK 51         00E2      LOOP CEMENTING 2
00E2      :U   M   81.5  -M  81.5
00E3      :SPB FB  33    -FB  33
00E4 NAME :LOOP-FAU
00E5 DBAE :    DB 170    -DB 170
00E6 IW-L :    DD  52
00E7 MAX  :    KG +9500000+02
00E9 MIN  :    KG +2000000+01
00EB MARK :    M   17.1  -M  17.1
00EC T-NR :    T  102    -T 102
00ED ST-M :    M  172.2  -M0207
00EE      :***

M   81.5 = M  81.5                  LINE : LINE ON
M   17.1 = M  17.1                  EXTR. POSITION LOOP CONVEYOR CEMENTING 2
T  102   = T 102                    FAULT : LOOP CEMENTING 2
M  172.2 = M0207                    FESTOONER LOOP     TREAD BOTTOM CEMENTER

DB 170   = DB 170                   ACTUAL DATAS

FB  33   = FB  33                   CHECK LOOP

NETZWERK 52         00EF      LOOP COOLING SECTION 1
00EF      :U   M   81.5  -M  81.5
00F0      :SPB FB  33    -FB  33
00F1 NAME :LOOP-FAU
00F2 DBAE :    DB 170    -DB 170
00F3 IW-L :    DD  54
00F4 MAX  :    KG +9500000+02
00F6 MIN  :    KG +2000000+01
00F8 MARK :    M   17.2  -M  17.2
00F9 T-NR :    T  103    -T 103
00FA ST-M :    M  172.3  -M0208
00FB      :***

M   81.5 = M  81.5                  LINE : LINE ON
M   17.2 = M  17.2                  EXTR. POSITION LOOP COOLING SECTION 1
```

```
PB 82   -PB  82                          C:KERM06ST.S5D        BIB=27023   LAE=297

T  103   = T 103                         FAULT : LOOP COOLING SECTION 1
M  172.3 = M0208                         FESTOONER LOOP          COOLING SECTION 1

DB 170   = DB 170                        ACTUAL DATAS

FB  33   = FB  33                        CHECK LOOP

NETZWERK 53          00FC       LOOP COOLING SECTION 2
00FC       :U   M   81.5   -M  81.5
00FD       :SPB FB  33     -FB  33
00FE NAME  :LOOP-FAU
00FF DBAE  :     DB 170     -DB 170
0100 IW-L  :     DD  56
0101 MAX   :     KG +9500000+02
0103 MIN   :     KG +2000000+01
0105 MARK  :     M   17.3   -M  17.3
0106 T-NR  :     T  104     -T 104
0107 ST-M  :     M  172.4   -M0209
0108       :***

M   81.5 = M  81.5                       LINE : LINE ON
M   17.3 = M  17.3                       EXTR. POSITION LOOP COOLING SECTION 2
T  104   = T 104                         FAULT : LOOP COOLING SECTION 2
M  172.4 = M0209                         FESTOONER LOOP          COOLING SECTION 2

DB 170   = DB 170                        ACTUAL DATAS

FB  33   = FB  33                        CHECK LOOP

NETZWERK 54          0109       LOOP COOLING SECTION 3
0109       :U   M   81.5   -M  81.5
010A       :SPB FB  33     -FB  33
010B NAME  :LOOP-FAU
010C DBAE  :     DB 170     -DB 170
010D IW-L  :     DD  58
010E MAX   :     KG +9500000+02
0110 MIN   :     KG +2000000+01
0112 MARK  :     M   17.4   -M  17.4
0113 T-NR  :     T  105     -T 105
0114 ST-M  :     M  172.5   -M0210
0115       :***

M   81.5 = M  81.5                       LINE : LINE ON
M   17.4 = M  17.4                       EXTR. POSITION LOOP COOLING SECTION 3
T  105   = T 105                         FAULT : LOOP COOLING SECTION 3
M  172.5 = M0210                         FESTOONER LOOP          COOLING SECTION 3

DB 170   = DB 170                        ACTUAL DATAS

FB  33   = FB  33                        CHECK LOOP

NETZWERK 55          0116       LOOP COOLING SECTION 4
0116       :U   M   81.5   -M  81.5
0117       :SPB FB  33     -FB  33
0118 NAME  :LOOP-FAU
0119 DBAE  :     DB 170     -DB 170
011A IW-L  :     DD  60
011B MAX   :     KG +9500000+02
011D MIN   :     KG +2000000+01
011F MARK  :     M   17.5   -M  17.5
0120 T-NR  :     T  106     -T 106
0121 ST-M  :     M  172.6   -M0211
0122       :***

M   81.5 = M  81.5                       LINE : LINE ON
M   17.5 = M  17.5                       EXTR. POSITION LOOP COOLING SECTION 4
T  106   = T 106                         FAULT : LOOP COOLING SECTION 4
M  172.6 = M0211                         FESTOONER LOOP          COOLING SECTION 4

DB 170   = DB 170                        ACTUAL DATAS
```

PB 82 -PB 82 C:KERM06ST.S5D BIB=27023 LAE=297

FB 33 = FB 33 CHECK LOOP

NETZWERK 56 0123
0123 :BE

+----------+----------+----------

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  SCRAP FLAP                                 *
*                                                                             *
*******************************************************************************
0000      :***

NETZWERK 2          0001      IMPULSE SCRAP DETECTED
0001      :UN  E   73.1  -299S3
0002      :UN  M   63.3  -M  63.3
0003      :UN  M   64.1  -M  64.1
0004      :=   M   63.4  -M  63.4
0005      :UN  E   73.1  -299S3
0006      :UN  M   64.1  -M  64.1
0007      :=   M   63.3  -M  63.3
0008      :***

E   73.1 = 299S3                    SCRAP DETECTED
M   63.3 = M  63.3                  SCRAP : HF SCRAP DETECTED
M   64.1 = M  64.1                  SCRAP : SCRAP DETECTED
M   63.4 = M  63.4                  SCRAP : IMPULSE SCRAP DETECTED

NETZWERK 3          0009      SCRAP DETECTED
            -M  64.1
             +-----+
 -M  63.4 --!S    !
            !     !
 -M  64.6 --!R   Q!-
            +-----+

M   63.4 = M  63.4                  SCRAP : IMPULSE SCRAP DETECTED
M   64.1 = M  64.1                  SCRAP : SCRAP DETECTED
M   64.6 = M  64.6                  SCRAP : RESET SCRAP DETECTED

NETZWERK 4          000F      RESET SCRAP DETECTED
            -T 100
             +-----+
 -M  64.1 --!T!-!0!
 KT 200.0 --!TW DU!-
            !   DE!-
            !     !   +------+
          --!R   Q!-+-! =    ! -M  64.6
            +-----+   +------+

M   64.1 = M  64.1                  SCRAP : SCRAP DETECTED
T  100   = T 100                    RESET SCRAP DETECTED
M   64.6 = M  64.6                  SCRAP : RESET SCRAP DETECTED

NETZWERK 5          0019      OPEN SCRAP FLAP
                      -M  63.5
                       +-----+
           -M  63.4 --!S    !
            +---+     !     !
 -M   9.0 ---!>=1!    !     !
 -M  63.6 ---!    !    !     !   +------+
 -M  81.5 --O!    !----!R   Q!-+-! =    ! -A 71.7
            +---+     +-----+   +------+

M   63.4 = M  63.4                  SCRAP : IMPULSE SCRAP DETECTED
M   63.5 = M  63.5                  SCRAP : SV OPEN SCRAP FLAP
M    9.0 = M   9.0                  E-STOP TRIGGERED
M   63.6 = M  63.6                  SCRAP : RESET SV OPEN SCRAP FLAP
M   81.5 = M  81.5                  LINE : LINE ON
A   71.7 = A 71.7                   SCRAP FLAP DOWN
```

```
Z   26   = Z  26                    SCRAP DETECTED : COUNTER 1
E   83.4 = 204S5                   RESET PRODUCT. REPORT  (MAIN CONTR.PAN.)
M    5.2 = M   5.2                 RESET PRODUCTION DATAS

NETZWERK 12          0051      COUNTER 1 FOR SCRAP = 900 ?
0051       :L   Z   26     -Z  26
0052       :L   KF +900
0054       :>=F
0055       :=   M   64.5   -M  64.5
0056       :U   M   64.5   -M  64.5
0057       :R   Z   26     -Z  26
0058       :***

Z   26   = Z  26                    SCRAP DETECTED : COUNTER 1
M   64.5 = M  64.5                  SCRAP DETECTED : COUNTER 1 = 900

NETZWERK 13          0059      COUNTER 2 FOR SCRAP DETECTED
                       -Z  27
                        +-----+
            -M  64.5 --!ZV    !
                     --!ZR    !
                     --!S     !
                     --!ZW DU!- DW 126
                +---+    !   DE!-
 -204S5    ---!>=1!     !     !
 -M   5.2  ---!   !     !----!R   Q!-
                +---+     +-----+

M   64.5 = M  64.5                  SCRAP DETECTED : COUNTER 1 = 900
Z   27   = Z  27                    SCRAP DETECTED : COUNTER 2
E   83.4 = 204S5                   RESET PRODUCT. REPORT  (MAIN CONTR.PAN.)
M    5.2 = M   5.2                 RESET PRODUCTION DATAS

NETZWERK 14          0066      CALCULATE SUM SCRAP
0066       :L   DW 126
0067       :L   KF +900
0069       :XF
006A       :L   DW 125
006B       :+F
006C       :T   DW 116
006D       :***


NETZWERK 15          006E
006E       :BE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                          LINEAR CHECK WEIGHER                             *
*                                                                           *
*****************************************************************************
0000      :***

NETZWERK 2          0001      BCD-DATA QUEUE UP
0001      :NOP 0                                U M 81.5 EINFUEGEN NACH TEST
0002      :U   E   45.1  -A925.0
0003      :UN  A   40.3  -A925.1
0004      :SPB FB  83    -FB  83
0005 NAME :MGW-ANST
0006      :***

E   45.1 = A925.0                    LINEAR CHECK WEIGHER BCD DATA PENDING
A   40.3 = A925.1                    LINEAR CHECK WEIGHER DEMAND ACTUAL WEIG.

FB  83   = FB  83                    LINEAR CHECK WEIGHER BCD-DATAS

NETZWERK 3          0007      EVALUATION LINEAR CHECK WEIGHER

                                -FB  84
                                 +--------------+
                                 !   M-WAAGE    !
                                 +--------------+

FB  84   = FB  84                    EVALUATION AND PICTURES LINEAR CHECK W.

NETZWERK 4          000A      RESET OUTPUTS LINEAR CHECK WEIG.
             +---+
 -A925.0  ---! & !    +------+
 -A925.1  --O!   !--+-! =    ! -A925.2
             +---+    +------+

E   45.1 = A925.0                    LINEAR CHECK WEIGHER BCD DATA PENDING
A   40.3 = A925.1                    LINEAR CHECK WEIGHER DEMAND ACTUAL WEIG.
A   40.4 = A925.2                    LINEAR CHECK WEIGHER RESET OUTPUTS

NETZWERK 5          000E      DEMAND WEIGHT
             +---+
 -M   0.1 ---! & !    +------+
 -M   0.3 ---!   !--+-! =    ! -A925.1
             +---+    +------+

M    0.1 = M   0.1                   "1"-SIGNAL
M    0.3 = M   0.3                   TACT 0.5 HZ
A   40.3 = A925.1                    LINEAR CHECK WEIGHER DEMAND ACTUAL WEIG.

NETZWERK 6          0012      ACKNOWLEDGING FAULT
          -T 156
           +-----+
 -A925    --!T!-!0!
 KT 500.0 --!TW DU!-
           !   DE!-
         --!R   Q!-
           +-----+

E   45.2 = A925                      LINEAR CHECK WEIGHER FAULT
T  156   = T 156                     ACKNOWLEDGING FAULT LINEAR CHECK WEIGHER

NETZWERK 7          001B      ACKNOWLEDGING FAULT
             +---+
 -A925    ---! & !     +---+
 -205S3.2 ---!   !-----!>=1!
             +---+     !   !    +------+
          -T 156   ---!   !--+-! =    ! -A925.3
                      +---+    +------+
```

```
PB 84    -PB  84                          C:KERM06ST.S5D        BIB=7023     LAE=38

E    45.2 = A925                          LINEAR CHECK WEIGHER FAULT
E    84.3 = 205S3.2                       ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
T   156   = T 156                         ACKNOWLEDGING FAULT LINEAR CHECK WEIGHER
A    40.5 = A925.3                        LINEAR CHECK WEIGHER FAULT ACKNOWLEDGING

NETZWERK 8          0020
0020       :BE
```

KRUPP KUNSTOFFTECHNIK			
ELASTOMERTECHNIK	WERK HARBURG	MASTERPROGRAMM	
PROJECT	: KERMAN TIRE	DATE :	
INSTALLATION	: TREAD-LINE	MODIFICATION:	PGNO
PROJECT POS. NO.	: 84/823804	PROGRAMMER :	2

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                          CONTROL RUNNING CONVEYORS                        *
*                                                                           *
*****************************************************************************
0000      :A   DB  95    -DB  95
0001      :L   DD  46                                  DRAW-OFF-CONVEYOR
0002      :L   KG +2300000+01
0005      :<G
0006      :=   M   95.0  -M  95.0
0007      :L   DD  48                                  CONVEYOR LINEAR CHECK WEIGHER
0008      :L   KG +2300000+01
000B      :<G
000C      :=   M   95.1  -M  95.1
000D      :L   DD  50                                  CONVEYOR CEMENTING 2
000E      :L   KG +2300000+01
0011      :<G
0012      :=   M   95.2  -M  95.2
0013      :L   DD  52                                  COOLING SECTION 1
0014      :L   KG +2300000+01
0017      :<G
0018      :=   M   95.3  -M  95.3
0019      :L   DD  54                                  COOLING SECTION 2
001A      :L   KG +2300000+01
001D      :<G
001E      :=   M   95.4  -M  95.4
001F      :L   DD  56                                  COOLING SECTION 3
0020      :L   KG +2300000+01
0023      :<G
0024      :=   M   95.5  -M  95.5
0025      :L   DD  58                                  COOLING SECTION 4
0026      :L   KG +2300000+01
0029      :<G
002A      :=   M   95.6  -M  95.6
002B      :L   DD  60                                  CONVEYOR CENTERING 2
002C      :L   KG +2300000+01
002F      :<G
0030      :=   M   95.7  -M  95.7
0031      :***

M   95.0 = M  95.0                    FAULT DRAW-OFF CONVEYOR
M   95.1 = M  95.1                    FAULT CONVEYOR LINEAR CHECK WEIGHER
M   95.2 = M  95.2                    FAULT CONVEYOR CEMENTING 2
M   95.3 = M  95.3                    FAULT COOLING SECTION 1
M   95.4 = M  95.4                    FAULT COOLING SECTION 2
M   95.5 = M  95.5                    FAULT COOLING SECTION 3
M   95.6 = M  95.6                    FAULT COOLING SECTION 4
M   95.7 = M  95.7                    FAULT CONVEYOR CENTERING 2

DB  95   = DB  95                     GENERAL DATAS
```

NETZWERK 2 0032 CONTROL DRAW-OFF CONVEYOR

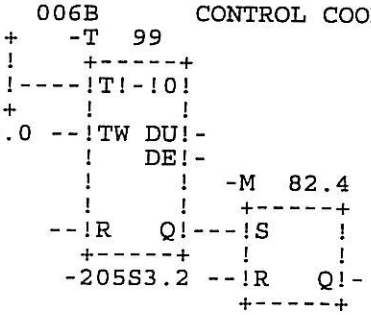
```
             +---+   -T  95
 -73A1    ---! & !    +-----+
 -M  95.0 ---!   !----!T!-!0!
             +---+    !     !
          KT 500.0 --!TW DU!-
                     !   DE!-
                     !     !  -M  82.0
                     !     !   +-----+
                   --!R   Q!---!S    !
                     +-----+   !     !
                    -205S3.2 --!R   Q!-
                              +-----+
```

```
A    3.2 = 73A1                       DRAW-OFF CONVEYOR ON
M   95.0 = M  95.0                    FAULT DRAW-OFF CONVEYOR
T   95   = T  95                      CONTROL DRAW-OFF CONVEYOR
M   82.0 = M  82.0                    FAULT SPEED DRAW-OFF CONVEYOR
```

```
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                     !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                     !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE       !  DATE         :                     !
! INSTALLATION     : TREAD-LINE        !  MODIFICATION:                   PGNO!
! PROJECT POS. NO.: 84/823804          !  PROGRAMMER   :                     1!
+-----------------------------------------------------------------------------+
```

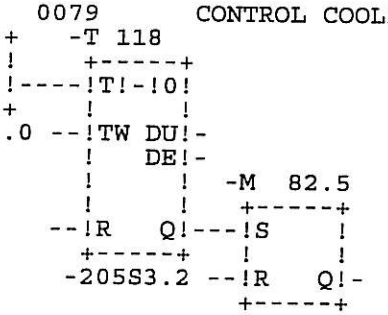
```
E   84.3 = 205S3.2                    ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)

NETZWERK 3          0040      CONTROL CON.LINEAR CHECK WEIGHER
              +---+    -T  96
 -77A1     ---! & !     +-----+
 -M  95.1  ---!   !-----!T!-!0!
              +---+     !     !
           KT 500.0 --!TW DU!-
                      !   DE!-
                      !     !  -M  82.1
                      !     !   +-----+
                    --!R   Q!---!S     !
                      +-----+   !     !
                     -205S3.2 --!R   Q!-
                               +-----+

A    3.4 = 77A1                        CONVEYOR LINEAR CHECKER ON
M   95.1 = M  95.1                     FAULT CONVEYOR LINEAR CHECK WEIGHER
T   96   = T  96                       CONTROL CONVEYOR LINEAR CHECK WEIGHER
M   82.1 = M  82.1                     FAULT SPEED CONT. SCALE CONVEYOR
E   84.3 = 205S3.2                     ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)

NETZWERK 4          004E      CONTROL CONVEYOR CEMENTING 2
              +---+    -T  97
 -100A1    ---! & !     +-----+
 -M  95.2  ---!   !-----!T!-!0!
              +---+     !     !
           KT 500.0 --!TW DU!-
                      !   DE!-
                      !     !  -M  82.2
                      !     !   +-----+
                    --!R   Q!---!S     !
                      +-----+   !     !
                     -205S3.2 --!R   Q!-
                               +-----+

A    7.1 = 100A1                       CONVEYOR CEMENTING 2 ON
M   95.2 = M  95.2                     FAULT CONVEYOR CEMENTING 2
T   97   = T  97                       CONTROL CONVEYOR CEMENTING 2
M   82.2 = M  82.2                     FAULT SPEED CEMENTING 2 CONVEYOR
E   84.3 = 205S3.2                     ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)

NETZWERK 5          005C      CONTROL COOLING SECTION 1
             +---+
 -M   0.0 ---! & !    -T  98
 -103A1   ---!   !     +-----+
 -M  95.3 ---!   !-----!T!-!0!
              +---+     !     !
           KT 500.0 --!TW DU!-
                      !   DE!-
                      !     !  -M  82.3
                      !     !   +-----+
                    --!R   Q!---!S     !
                      +-----+   !     !
                     -205S3.2 --!R   Q!-
                               +-----+

M    0.0 = M   0.0                     "0"-SIGNAL
A    7.4 = 103A1                       COOLING SECT 1 ON
M   95.3 = M  95.3                     FAULT COOLING SECTION 1
T   98   = T  98                       CONTROL COOLING SECTION 1
M   82.3 = M  82.3                     FAULT SPEED COOLING SECTION 1 CONVEYOR
E   84.3 = 205S3.2                     ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
```

NETZWERK 6 006B CONTROL COOLING SECTION 2



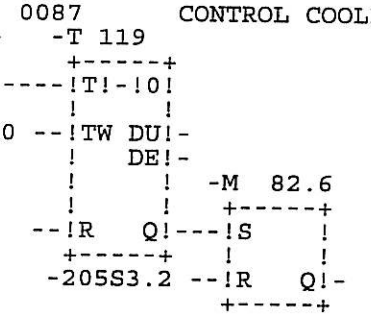

```
A    7.4 = 103A1                    COOLING SECT 1 ON
M   95.4 = M  95.4                  FAULT COOLING SECTION 2
T   99   = T  99                    CONTROL COOLING SECTION 2
M   82.4 = M  82.4                  FAULT SPEED COOLING SECTION 2 CONVEYOR
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
```

NETZWERK 7 0079 CONTROL COOLING SECTION 3



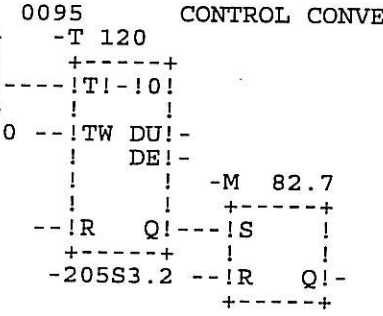

```
A    8.1 = 108A1                    COOLING SECT 3 ON
M   95.5 = M  95.5                  FAULT COOLING SECTION 3
T  118   = T 118                    CONTROL COOLING SECTION 3
M   82.5 = M  82.5                  FAULT SPEED COOLING SECTION 3 CONVEYOR
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
```

NETZWERK 8 0087 CONTROL COOLING SECTION 4




```
A    8.3 = 110A1                    COOLING SECT 4 ON
M   95.6 = M  95.6                  FAULT COOLING SECTION 4
T  119   = T 119                    CONTROL COOLING SECTION 4
M   82.6 = M  82.6                  FAULT SPEED COOLING SECTION 4 CONVEYOR
E   84.3 = 205S3.2                  ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
```

NETZWERK 9 0095 CONTROL CONVEYOR CENTERING 2



```
PB 86   -PB  86                          C:KERM06ST.S5D        BIB=26112   LAE=170

A    9.0 = 115A1                         CONVEYOR CENTERING 2 ON
M   95.7 = M  95.7                       FAULT CONVEYOR CENTERING 2
T  120   = T 120                         CONTROL CONVEYOR CENTERING 2
M   82.7 = M  82.7                       FAULT SPEED CENTERING 2 CONVEYOR
E   84.3 = 205S3.2                       ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)

NETZWERK 10          00A3
00A3       :AWL
00A4       :BE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                        SCRAP MARKING TREAD CHECKER                        *
*                                                                           *
*****************************************************************************

0000       :***

NETZWERK 2          0001      IMPULSE TREAD IS LEAVING WEIGHER
0001       :UN  E   72.2  -E 72.2
0002       :U   E   72.3  -E 72.3
0003       :UN  M   61.3  -M  61.3
0004       :U   M   81.5  -M  81.5
0005       :=   M   61.7  -M  61.7
0006       :UN  E   72.2  -E 72.2
0007       :U   E   72.3  -E 72.3
0008       :U   M   81.5  -M  81.5
0009       :=   M   61.3  -M  61.3
000A       :***

E   72.2 = E 72.2                    TREAD INLET LENGHT MEASURING DEVICE
E   72.3 = E 72.3                    TREAD RETIREMENT LENGHT MEASURING DEVICE
M   61.3 = M  61.3                   TREAD CHECKER : HF TREAD OUTLET
M   81.5 = M  81.5                   LINE : LINE ON
M   61.7 = M  61.7                   TREAD CHECKER : IMPULSE TREAD OUTLET

NETZWERK 3          000B      IMPULSE TREAD UNDER SCRAP MARK.
000B       :U   E   75.5  -E 75.5
000C       :UN  M   62.2  -M  62.2
000D       :U   M   81.5  -M  81.5
000E       :=   M   62.5  -M  62.5
000F       :U   E   75.5  -E 75.5
0010       :U   M   81.5  -M  81.5
0011       :=   M   62.2  -M  62.2
0012       :***

E   75.5 = E 75.5                    PHOTOEYE SCRAP MARKING TREAD WEIGHER
M   62.2 = M  62.2                   TREAD CHECKER : HF TREAD UNDER SCRAP M.
M   81.5 = M  81.5                   LINE : LINE ON
M   62.5 = M  62.5                   TREAD CHECKER : IMP. TREAD UNDER SCRAP M

NETZWERK 4          0013      SV SCRAP MARKING TREAD WEIGHER
0013       :U   M   62.5  -M  62.5
0014       :U   M   62.3  -M  62.3
0015       :S   A   72.7  -A 72.7
0016       :
0017       :U   A   72.7  -A 72.7
0018       :U   M   81.5  -M  81.5
0019       :L   KT 050.0
001B       :SE  T  154    -T 154
001C       :
001D       :U   T  154    -T 154
001E       :ON  M   81.5  -M  81.5
001F       :R   A   72.7  -A 72.7
0020       :***

M   62.5 = M  62.5                   TREAD CHECKER : IMP. TREAD UNDER SCRAP M
M   62.3 = M  62.3                   TREAD CHECKER : SCRAP (FB87)
A   72.7 = A 72.7                    SCRAP MARKING 1
M   81.5 = M  81.5                   LINE : LINE ON
T  154   = T 154                     TREAD CHECKER : SCRAP MARKING ON

NETZWERK 5          0021
0021       :A   DB 170    -DB 170
0022       :***

DB 170   = DB 170                    ACTUAL DATAS
```

```
NETZWERK 6          0023      COUNTER 1 FOR SCRAP
                +---+    -Z  20
 -M  62.3 ---! & !     +-----+
 -M  81.5 ---!   !-----!ZV   !
                +---+    !     !
                         --!ZR   !
                         --!S    !
                         --!ZW DU!- DW 121
                +---+    !   DE!-
 -204S5   ---!>=1!     !     !
 -M   5.2 ---!   !-----!R   Q!-
                +---+    +-----+

M   62.3 = M  62.3                    TREAD CHECKER : SCRAP (FB87)
M   81.5 = M  81.5                    LINE : LINE ON
Z   20   = Z  20                      TREAD CHECKER : SCRAP COUNTER 1
E   83.4 = 204S5                      RESET PRODUCT. REPORT  (MAIN CONTR.PAN.)
M    5.2 = M   5.2                    RESET PRODUCTION DATAS

NETZWERK 7          0031      COUNTER 1 FOR SCRAP = 900 ?
0031       :L   Z   20    -Z  20
0032       :L   KF +900
0034       :>=F
0035       :=   M   64.2  -M  64.2
0036       :U   M   64.2  -M  64.2
0037       :R   Z   20    -Z  20
0038       :***

Z   20   = Z  20                      TREAD CHECKER : SCRAP COUNTER 1
M   64.2 = M  64.2                    TREAD CHECKER : COUNTER 1 SCRAP = 900

NETZWERK 8          0039      COUNTER 2 FOR SCRAP
                      -Z  21
                       +-----+
            -M  64.2 --!ZV   !
                     --!ZR   !
                     --!S    !
                     --!ZW DU!- DW 122
              +---+    !   DE!-
 -204S5   ---!>=1!     !     !
 -M   5.2 ---!   !-----!R   Q!-
              +---+    +-----+

M   64.2 = M  64.2                    TREAD CHECKER : COUNTER 1 SCRAP = 900
Z   21   = Z  21                      TREAD CHECKER : SCRAP COUNTER 2
E   83.4 = 204S5                      RESET PRODUCT. REPORT  (MAIN CONTR.PAN.)
M    5.2 = M   5.2                    RESET PRODUCTION DATAS

NETZWERK 9          0046      CALCULATE SUM TREADS SCRAP
0046       :L   DW 122
0047       :L   KF +900
0049       :XF
004A       :L   DW 121
004B       :+F
004C       :T   DW 111
004D       :***

NETZWERK 10         004E      COUNTER 1 FOR TREADS OK
                +---+    -Z  22
 -M  62.4 ---! & !     +-----+
 -M  81.5 ---!   !-----!ZV   !
                +---+    !     !
                         --!ZR   !
                         --!S    !
                         --!ZW DU!- DW 119
                +---+    !   DE!-
 -204S5   ---!>=1!     !     !
 -M   5.2 ---!   !-----!R   Q!-
                +---+    +-----+
```

```
M   62.4 = M  62.4                    TREAD CHECKER : WEIGHT OK (FB87)
M   81.5 = M  81.5                    LINE : LINE ON
Z   22   = Z  22                      TREAD CHECKER : OK COUNTER 1
E   83.4 = 204S5                      RESET PRODUCT. REPORT  (MAIN CONTR.PAN.)
M    5.2 = M   5.2                    RESET PRODUCTION DATAS

NETZWERK 11          005C       COUNTER 1 FOR TREADS OK = 900 ?
005C       :L   Z   22    -Z  22
005D       :L   KF +900
005F       :>=F
0060       :=   M   64.3  -M  64.3
0061       :U   M   64.3  -M  64.3
0062       :R   Z   22    -Z  22
0063       :***

Z   22   = Z  22                      TREAD CHECKER : OK COUNTER 1
M   64.3 = M  64.3                    TREAD CHECKER : COUNTER 1 OK = 900

NETZWERK 12          0064       COUNTER 2 FOR TREADS OK
                       -Z  23
                        +-----+
            -M  64.3 --!ZV    !
                     --!ZR    !
                     --!S     !
                     --!ZW DU!- DW 120
               +---+     !   DE!-
 -204S5   ---!>=1!     !      !
 -M   5.2 ---!   !     !----!R   Q!-
               +---+     +-----+

M   64.3 = M  64.3                    TREAD CHECKER : COUNTER 1 OK = 900
Z   23   = Z  23                      TREAD CHECKER : OK COUNTER 2
E   83.4 = 204S5                      RESET PRODUCT. REPORT  (MAIN CONTR.PAN.)
M    5.2 = M   5.2                    RESET PRODUCTION DATAS

NETZWERK 13          0071       CALCULATE SUM TREADS OK
0071       :L   DW 120
0072       :L   KF +900
0074       :XF
0075       :L   DW 119
0076       :+F
0077       :T   DW 110
0078       :***


NETZWERK 14          0079       COUNTER 1 FOR TREADS TOTAL
               +---+    -Z  24
 -M  61.7 ---! & !     +-----+
 -M  81.5 ---!   !-----!ZV    !
               +---+     !     !
                     --!ZR    !
                     --!S     !
                     --!ZW DU!- DW 123
               +---+     !   DE!-
 -204S5   ---!>=1!     !      !
 -M   5.2 ---!   !     !----!R   Q!-
               +---+     +-----+

M   61.7 = M  61.7                    TREAD CHECKER : IMPULSE TREAD OUTLET
M   81.5 = M  81.5                    LINE : LINE ON
Z   24   = Z  24                      TREAD CHECKER : TOTAL COUNTER 1
E   83.4 = 204S5                      RESET PRODUCT. REPORT  (MAIN CONTR.PAN.)
M    5.2 = M   5.2                    RESET PRODUCTION DATAS

NETZWERK 15          0087       COUNTER 1 TREADS TOTAL = 900 ?
0087       :L   Z   24    -Z  24
0088       :L   KF +900
008A       :>=F
008B       :=   M   64.4  -M  64.4
008C       :U   M   64.4  -M  64.4
008D       :R   Z   24    -Z  24
008E       :***
```

```
Z   24   = Z  24                    TREAD CHECKER : TOTAL COUNTER 1
M   64.4 = M  64.4                  TREAD CHECKER : COUNTER 1 TOTAL = 900

NETZWERK 16          008F      COUNTER 2 FOR TREADS TOTAL
                       -Z  25
                        +-----+
            -M  64.4 --!ZV    !
                     --!ZR    !
                     --!S     !
                     --!ZW DU!- DW 124
                +---+    !   DE!-
 -204S5    ---!>=1!    !     !
 -M   5.2  ---!   !    !----!R   Q!-
                +---+    +-----+

M   64.4 = M  64.4                  TREAD CHECKER : COUNTER 1 TOTAL = 900
Z   25   = Z  25                    TREAD CHECKER : TOTAL COUNTER 2
E   83.4 = 204S5                    RESET PRODUCT. REPORT  (MAIN CONTR.PAN.)
M    5.2 = M   5.2                  RESET PRODUCTION DATAS

NETZWERK 17          009C      CALCULATE TREADS TOTAL
009C       :L   DW 124
009D       :L   KF +900
009F       :XF
00A0       :L   DW 123
00A1       :+F
00A2       :T   DW 114
00A3       :***


NETZWERK 18          00A4      RESET FLAGS FROM FB87
               +---+
 -M  62.5 ---!>=1!    +------+
 -M  81.5 --O!   !--+-! R    ! -M  62.3
               +---+  ! +------+
                      ! +------+
                      +-! R    ! -M  62.4
                        +------+

M   62.5 = M  62.5                  TREAD CHECKER : IMP. TREAD UNDER SCRAP M
M   81.5 = M  81.5                  LINE : LINE ON
M   62.3 = M  62.3                  TREAD CHECKER : SCRAP (FB87)
M   62.4 = M  62.4                  TREAD CHECKER : WEIGHT OK (FB87)

NETZWERK 19          00A9
00A9       :BE
```

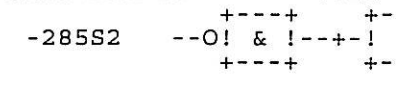
```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                            WIDTH MEASURING DEVICE                         *
*                                                                           *
*****************************************************************************
0000      :***

NETZWERK 2          0001      FAULT : WIDTH MEASURING DEVICE
                  +---+     +------+
 -A925.04 --O! & !--+-! =     ! -M0199
                  +---+     +------+

E   42.4 = A925.04                      WIDTH MEASURING DEVICE FAULT
M  173.2 = M0199                        FAULT              WIDTH MEASURING DEVICE

NETZWERK 3          0004      FAULT : CAMERA DIRTY
                  +---+     +------+
 -A925.01 ---! & !--+-! =     ! -M0200
                  +---+     +------+

E   42.1 = A925.01                      WIDTH MEASURING DEVICE CAMERA DIRTY
M  173.3 = M0200                        CAMERA DIRTY       WIDTH MEASURING DEVICE

NETZWERK 4          0007      FAULT : MEAS.RANGE LIMIT RIGHT
                  +---+
 -A925.02 ---! & !     +------+
 -M  81.5 ---!   !--+-! =     ! -M0201
                  +---+     +------+

E   42.2 = A925.02                      WIDTH MEASURING DEVICE LIMIT RIGHT
M   81.5 = M  81.5                      LINE : LINE ON
M  173.4 = M0201                        MEAS.RANGE LIMIT RIGHT     WIDTH MEAS.DEV

NETZWERK 5          000B      FAULT : MEAS.RANGE LIMIT LEFT
                  +---+
 -A925.03 ---! & !     +------+
 -M  81.5 ---!   !--+-! =     ! -M0202
                  +---+     +------+

E   42.3 = A925.03                      WIDTH MEASURING DEVICE LIMIT LEFT
M   81.5 = M  81.5                      LINE : LINE ON
M  173.5 = M0202                        MEAS.RANGE LIMIT LEFT      WIDTH MEAS.DEV

NETZWERK 6          000F      DEMAND WIDTH
                  +---+
 -A925.04 ---! & !     +------+
 -M   0.4 ---!   !--+-! =     ! -A 40.0
                  +---+     +------+

E   42.4 = A925.04                      WIDTH MEASURING DEVICE FAULT
M    0.4 = M   0.4                      TACT 1 HZ
A   40.0 = A 40.0                       WIDTH MEASURING DEV. REQUIRE WIDTH

NETZWERK 7          0013      WIDTH EVALUATION

                              -FB  88
                               +--------------+
                               !   WIDTH-E    !
                               +--------------+

FB  88   = FB  88                       WIDTH MEASURING DEVICE

NETZWERK 8          0016      PICTURES WIDTH MEASURING

                              -FB  93
                               +--------------+
                               !   WIDTH-P    !
                               +--------------+
```

```
PB 88    -PB  88                        C:KERM06ST.S5D        BIB=9033    LAE=50
FB  93    = FB  93                      EVALUATION + PICTURES WIDTH MEASURING D.
NETZWERK 9          0019       CALCULATE WIDTH FOR DISPLAY

                                  -FB  48
                                   +--------------+
                                   !   DISP-10V   !
                       -DB 170   --!DBNR          !
                       DD 102    --!IN            !
                       DD 44     --!OUT           !
              +8000000+03        --!RANG          !
                       -M   0.1  --!RESE          !
                                   +--------------+

M     0.1 = M   0.1                        "1"-SIGNAL
DB 170    = DB 170                         ACTUAL DATAS
FB  48    = FB  48                         CALCULATION FOR ANALOG DISPLAY
NETZWERK 10         0022       DISPLAY WIDTH

                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                       +186      --!PERE          !
                       DD 44     --!SOLL          !
              +1000000+02        --!EINH          !
                       -M   0.1  --!INVE          !
                       -M   0.1  --!FREI          !
                       -DB 170   --!DBNR          !
                                   +--------------+

M     0.1 = M   0.1                        "1"-SIGNAL
DB 170    = DB 170                         ACTUAL DATAS
FB  44    = FB  44                         ANALOG OUTPUT
NETZWERK 11         002C
002C       :BE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                              FAULTS CALANDER                              *
*                                                                           *
*****************************************************************************
0000      :AWL
0001      :***

NETZWERK 2          0002      RIPCORD CALANDER REAR
              +---+    +------+
 -A800.2  ---! & !--+-! =    ! -M0350
              +---+    +------+

E   64.1 = A800.2                    E-STOP RIPCORD CALENDER REAR
M  190.1 = M0350                     E-STOP RIPCORD REAR              CALENDER

NETZWERK 3          0005      RIPCORD CALANDER FRONT
              +---+    +------+
 -E 64.6  ---! & !--+-! =    ! -M0351
              +---+    +------+

E   64.6 = E 64.6                    E-STOP RIPCORD CALENDER FRONT
M  190.2 = M0351                     E-STOP RIPCORD FRONT             CALENDER

NETZWERK 4          0008      E-STOP CALANDER LEFT SIDE
              +---+    +------+
 -E 64.7  ---! & !--+-! =    ! -M0335
              +---+    +------+

E   64.7 = E 64.7                    E-STOP CALENDER LEFT SIDE
M  188.2 = M0335                     E-STOP LEFT SIDE                 CALENDER

NETZWERK 5          000B      E-STOP OPERATOR PANEL A800
              +---+    +------+
 -A800    ---! & !--+-! =    ! -M0352
              +---+    +------+

E   62.7 = A800                      E-STOP                        (CAL PANEL)
M  190.3 = M0352                     E-STOP OPERATOR PANEL            CALENDER

NETZWERK 6          000E      FAULT : EXTERNAL FAN OUTSIDE
              +---+    +------+
 -96Q4    ---! & !--+-! =    ! -M0220
              +---+    +------+

E    5.1 = 96Q4                      CALENDER FAULT EXTERNAL FAN OUTSIDE
M  175.7 = M0220                     EXTERNAL FAN OUTSIDE MAIN DRIVE CALENDER

NETZWERK 7          0011      FAULT : EXTERNAL FAN INSIDE
              +---+    +------+
 -96Q6    ---! & !--+-! =    ! -M0237
              +---+    +------+

E    5.2 = 96Q6                      CALENDER FAULT EXTERNAL FAN INSIDE
M  176.0 = M0237                     EXTERNAL FAN INSIDE MAIN DRIVE  CALENDER

NETZWERK 8          0014      FAULT : DRIVE MOTOR OIL PUMP
              +---+    +------+
 -96Q1    ---! & !--+-! =    ! -M0240
              +---+    +------+

E    5.0 = 96Q1                      CALENDER FAULT OIL PUMP
M  176.3 = M0240                     MOTOR OIL PUMP FAULT             CALENDER

NETZWERK 9          0017      FAULT : DRIVE MOTOR BRAKE
              +---+    +------+
 -97Q1    ---! & !--+-! =    ! -M0241
              +---+    +------+
```

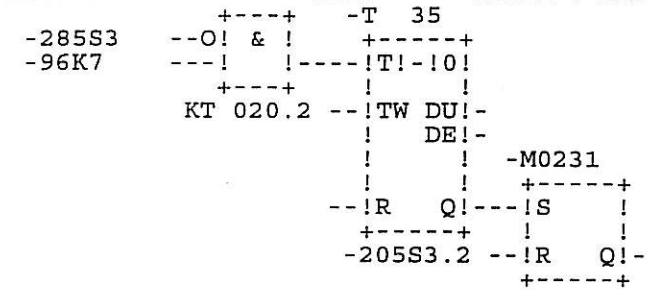
```
E    5.3 = 97Q1                    CALENDER FAULT MOTOR HYDRAULIC BRAKE
M  176.4 = M0241                   HYDRAULICS PUMP FAULT          CALENDER
```

NETZWERK 10 001A FAULT : MAX OIL PRESSURE



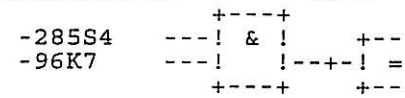

```
E   60.1 = 285S2                   CALENDER MAX OIL PRESSURE
M  177.1 = M0230                   MAX OIL PRESSURE               CALENDER
```

NETZWERK 11 001D FAULT : MIN OIL PRESSURE



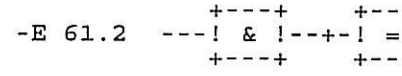

```
E   60.2 = 285S3                   CALENDER MIN OIL PRESSURE
A    5.6 = 96K7                    CALENDER AUX DRIVES ON/OFF
T   35   = T  35                   CALENDER : MIN OIL PRESSURE
M  177.2 = M0231                   MIN OIL PRESSURE               CALENDER
E   84.3 = 205S3.2                 ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
```

NETZWERK 12 002B FAULT : OIL LUBRICATION



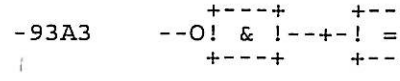

```
E   60.3 = 285S4                   CALENDER FAULT OIL LUBRICATION
A    5.6 = 96K7                    CALENDER AUX DRIVES ON/OFF
M  177.0 = M0229                   FAULT OIL LUBRICATION          CALENDER
```

NETZWERK 13 002F FAULT : MIN OIL LEVEL



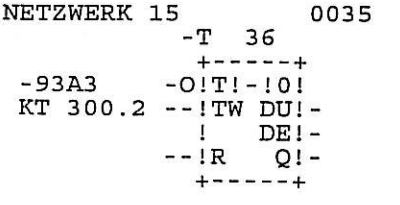

```
E   61.2 = E 61.2                  CALENDER MIN OIL LEVEL
M  177.3 = M0232                   MIN OIL LEVEL                  CALENDER
```

NETZWERK 14 0032 FAULT : MOTOR TEMP. MAIN DRIVE



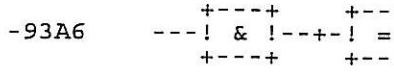

```
E    4.2 = 93A3                    CALENDER FAULT EXCESS TEMP MOT WINDING
M  176.5 = M0242                   DRIVE MOTOR TEMPERATURE        CALENDER
```

NETZWERK 15 0035 FAULT : MOTOR TEMP. CALANDER OFF




```
E    4.2 = 93A3                    CALENDER FAULT EXCESS TEMP MOT WINDING
T   36   = T  36                   CALENDER : FAULT MOTOR TEMP
```

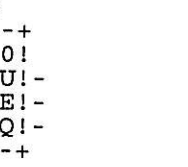
NETZWERK 16 003E FAULT : CARBON BRUSH CONTROL



```
E    4.3 = 93A6                    CALENDER CARBON BRUSH CONTROL
M  175.6 = M0219                   MAIN DRIVE CARBON BRUSH          CALENDER

NETZWERK 17        0041      FAULT : TEMP. DC-CONVERTER CAL.
              +---+    +------+
 -91A1/1  --O! & !--+-! =    ! -M0244
              +---+    +------+

E    4.4 = 91A1/1                  CALENDER FAULT DC-CONVERTER TEMP.
M  176.7 = M0244                   DC-CONVERTER TEMPERATURE FAULT  CALENDER

NETZWERK 18        0044      FAULT : DC-CONVERTER CALENDER
              +---+    +------+
 -91A1/2  --O! & !--+-! =    ! -M0243
              +---+    +------+

E    4.5 = 91A1/2                  CALENDER FAULT DC-CONVERTER
M  176.6 = M0243                   DC-CONVERTER FAULT               CALENDER

NETZWERK 19        0047
0047       :AWL
0048       :BE
```

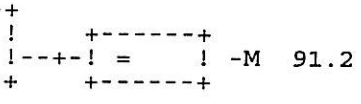
```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  CALANDER                                   *
*                                                                             *
*******************************************************************************
0000      :***

NETZWERK 2          0001      GENERAL FAULT CALANDER
              +---+     +------+
 -M   9.0 ---! & !--+-! =    ! -M  91.0
              +---+     +------+

M    9.0 = M   9.0                    E-STOP TRIGGERED
M   91.0 = M  91.0                    CALENDER : GENERAL FAULTS

NETZWERK 3          0004      START AUXILIARY DRIVES
             +---+
 -286S40.1---! & !
 -287S46.2--O!   !     +---+
 -M   9.1 ---!   !-----!>=1!   -M  91.1
              +---+     !   !    +-----+
           -M  92.1 ---!   !----!S    !
             +---+     +---+    !     !
 -286S40.2--O! & !               !     !
 -287S46.2--O!   !     +---+     !     !
 -91A1.1  --O!   !-----!>=1!     !     !
             +---+     !   !     !     !
           -T  82   ---!   !     !     !   +------+
           -M  91.0 ---!   !----!R   Q!-+-! =    ! -96K7
                       +---+    +-----+   +------+

E   61.6 = 286S40.1                   AUX DRIVES ON                 (CAL PANEL)
E   62.3 = 287S46.2                   CALENDER AUTOMATIC/MANUAL     (CAL PANEL)
M    9.1 = M   9.1                    CONTROL VOLTAGE IS ON
M   92.1 = M  92.1                    CALENDER : START
M   91.1 = M  91.1                    CALENDER : AUX.DRIVES ON
E   61.7 = 286S40.2                   AUX DRIVES OFF                (CAL PANEL)
A    5.2 = 91A1.1                     CALENDER START/STOP
T   82   = T  82                      CALENDER : RUN AFTER TIME AUX.DRIVES
M   91.0 = M  91.0                    CALENDER : GENERAL FAULTS
A    5.6 = 96K7                       CALENDER AUX DRIVES ON/OFF

NETZWERK 4          0012      IMPULSE CALANDER OFF
0012      :UN  A    5.3  -91A1.2
0013      :UN  M   91.3  -M  91.3
0014      :=   M   91.4  -M  91.4
0015      :UN  A    5.3  -91A1.2
0016      :=   M   91.3  -M  91.3
0017      :***

A    5.3 = 91A1.2                     CALENDER CONTROLLER RELEASE
M   91.3 = M  91.3                    CALENDER : HF CALENDER OFF
M   91.4 = M  91.4                    CALENDER : IMPULSE CALENDER OFF

NETZWERK 5          0018      RUNAFTER TIME AUXILIARY DRIVES
                      -M  91.5
                      +-----+
            -M  91.4 --!S    !
              +---+    !     !
 -91A1.2  ---!>=1!     !     !
 -T  82   ---!   !     !     !
 -M  91.1 --O!   !-----!R   Q!-
              +---+    +-----+

M   91.4 = M  91.4                    CALENDER : IMPULSE CALENDER OFF
M   91.5 = M  91.5                    CALENDER : RUN AFTER TIME AUX.DRIVES
A    5.3 = 91A1.2                     CALENDER CONTROLLER RELEASE
T   82   = T  82                      CALENDER : RUN AFTER TIME AUX.DRIVES
M   91.1 = M  91.1                    CALENDER : AUX.DRIVES ON
```

NETZWERK 6 0020 RUN AFTER TIME AUXILIARY DRIVES



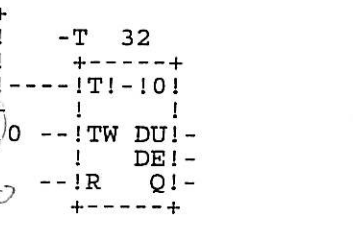

```
M   91.5 = M  91.5                    CALENDER : RUN AFTER TIME AUX.DRIVES
T   82   = T  82                      CALENDER : RUN AFTER TIME AUX.DRIVES
```

NETZWERK 7 0029 AUXILIARY DRIVES READY TO START




```
M   91.0 = M  91.0                    CALENDER : GENERAL FAULTS
A    5.6 = 96K7                       CALENDER AUX DRIVES ON/OFF
M   91.2 = M  91.2                    CALENDER : AUX.DRIVES READY TO START
```

NETZWERK 8 002D START ALARM CALANDER

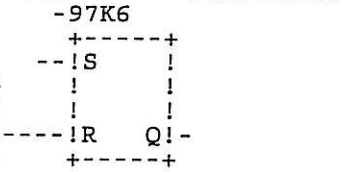



```
M   91.1 = M  91.1                    CALENDER : AUX.DRIVES ON
M   91.2 = M  91.2                    CALENDER : AUX.DRIVES READY TO START
M   92.1 = M  92.1                    CALENDER : START
T   32   = T  32                      CALENDER : START ALARM
```

```
NETZWERK 9          0038      IMPULSE MAINCONTACTOR IS OFF
0038       :UN  E    4.7  -93K1
0039       :UN  M   91.7  -M  91.7
003A       :=   M   92.2  -M  92.2
003B       :UN  E    4.7  -93K1
003C       :=   M   91.7  -M  91.7
003D       :***
```

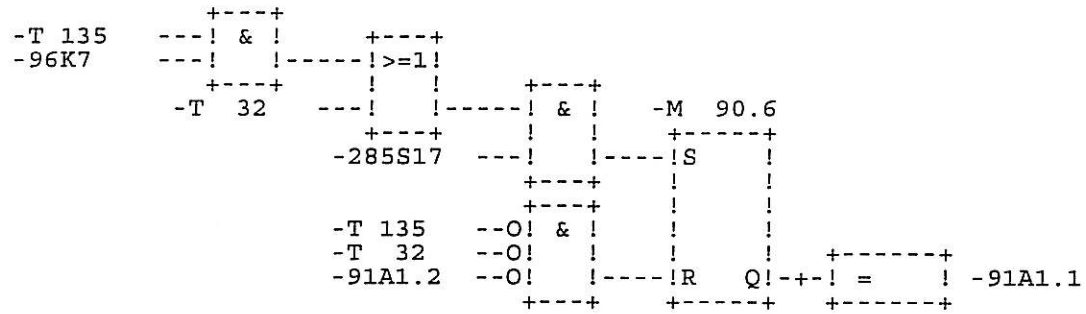
```
E    4.7 = 93K1                       CALENDER MAIN CONTACTOR ATTRACTED
M   91.7 = M  91.7                    CALENDER : HF FOR NEG. FLANC E 4.7
M   92.2 = M  92.2                    CALENDER : IMPULSE FOR NEG. FLANC E 4.7
```

NETZWERK 10 003E VENT BRAKE



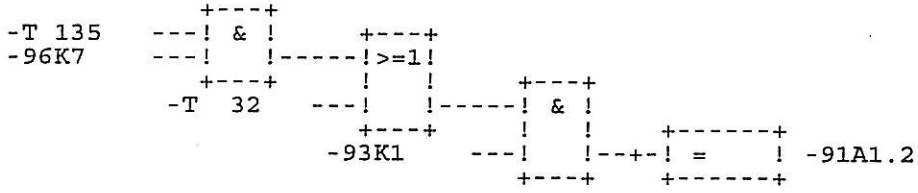

```
T   32   = T  32                      CALENDER : START ALARM
A    0.7 = 97K6                       DRIVE MOTOR BRAKE ON/OFF
M   92.2 = M  92.2                    CALENDER : IMPULSE FOR NEG. FLANC E 4.7
M    9.0 = M   9.0                    E-STOP TRIGGERED
```

NETZWERK 11 0045 MAINCONTACTOR ON



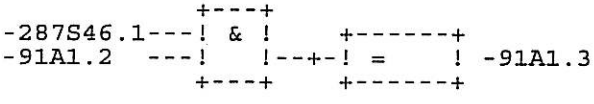

```
T  135   = T 135                    START ALARM FOR AUTOMTIC START
A    5.6 = 96K7                     CALENDER AUX DRIVES ON/OFF
T   32   = T  32                    CALENDER : START ALARM
E   60.0 = 285S17                   CALENDER BRAKE VENTED
M   90.6 = M  90.6                  CALENDER : READY TO START
A    5.3 = 91A1.2                   CALENDER CONTROLLER RELEASE
A    5.2 = 91A1.1                   CALENDER START/STOP
```

NETZWERK 12 0053 CONTROLLER RELEASE



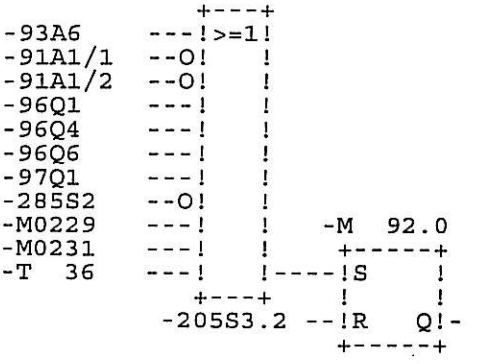

```
T  135   = T 135                    START ALARM FOR AUTOMTIC START
A    5.6 = 96K7                     CALENDER AUX DRIVES ON/OFF
T   32   = T  32                    CALENDER : START ALARM
E    4.7 = 93K1                     CALENDER MAIN CONTACTOR ATTRACTED
A    5.3 = 91A1.2                   CALENDER CONTROLLER RELEASE
```

NETZWERK 13 005B CALANDER CREEP (PREHEATING)




```
E   62.2 = 287S46.1                 CALENDER PREHEATING          (CAL PANEL)
A    5.3 = 91A1.2                   CALENDER CONTROLLER RELEASE
A    5.4 = 91A1.3                   CALENDER CREEP
```

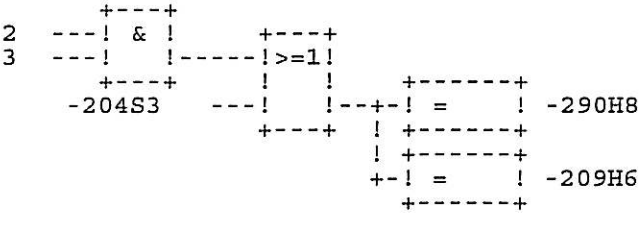
NETZWERK 14 005F FAULT CALANDER OFF




```
E    4.3 = 93A6                     CALENDER CARBON BRUSH CONTROL
E    4.4 = 91A1/1                   CALENDER FAULT DC-CONVERTER TEMP.
E    4.5 = 91A1/2                   CALENDER FAULT DC-CONVERTER
E    5.0 = 96Q1                     CALENDER FAULT OIL PUMP
E    5.1 = 96Q4                     CALENDER FAULT EXTERNAL FAN OUTSIDE
```

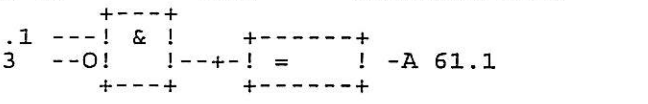
```
E     5.2 = 96Q6                    CALENDER FAULT EXTERNAL FAN INSIDE
E     5.3 = 97Q1                    CALENDER FAULT MOTOR HYDRAULIC BRAKE
E    60.1 = 285S2                   CALENDER MAX OIL PRESSURE
M   177.0 = M0229                   FAULT OIL LUBRICATION          CALENDER
M   177.2 = M0231                   MIN OIL PRESSURE               CALENDER
T    36   = T  36                   CALENDER : FAULT MOTOR TEMP
M    92.0 = M  92.0                 CALENDER : FAULTS CALENDER OFF
E    84.3 = 205S3.2                 ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)

NETZWERK 15          006F      LAMP FAULT CALANDER
              +---+
 -M  92.0 ---!>=1!    +------+
 -204S3   ---!   !--+-! =    ! -290H6
              +---+    +------+

M    92.0 = M  92.0                 CALENDER : FAULTS CALENDER OFF
E    83.2 = 204S3                   LAMP TEST              (MAIN CONTR.PAN.)
A    60.5 = 290H6                   CALENDER FAULT (LAMP)        (CAL PANEL)

NETZWERK 16          0073      IMPULSE LINE OFF
0073       :UN  M   81.5  -M  81.5
0074       :UN  M   81.6  -M  81.6
0075       :UN  A    5.4  -91A1.3
0076       :=   M   81.7  -M  81.7
0077       :UN  M   81.5  -M  81.5
0078       :UN  A    5.4  -91A1.3
0079       :=   M   81.6  -M  81.6
007A       :***

M    81.5 = M  81.5                 LINE : LINE ON
M    81.6 = M  81.6                 LINE : HF LINE OFF
A     5.4 = 91A1.3                  CALENDER CREEP
M    81.7 = M  81.7                 LINE : IMPULSE LINE OFF

NETZWERK 17          007B      CALANDER START
              +---+
 -287S42  ---! & !     +---+
 -287S46.2--O!   !-----!>=1!
              +---+     !   !
              +---+     !   !
 -287S46.1--O! & !     !   !
 -M  81.4 ---!   !-----!   !
              +---+     !   !
              +---+     !   !
 -96K7    ---! & !     !   !     +---+
 -T 135   ---!   !-----!   !-----! & !   -M  92.1
              +---+     +---+     !   !    +-----+
                     -M   9.1 ---!   !----!S    !
                       +---+     +---+    !     !
           -287S46.2--O! & !     +---+    !     !
           -287S43  --O!   !-----!>=1!    !     !
                       +---+     !   !    !     !
                     -M   9.6 ---!   !    !     !
                     -M  81.7 ---!   !    !     !
                     -M  91.0 ---!   !    !     !
                     -M  92.0 ---!   !----!R   Q!-
                                 +---+    +-----+

E    62.0 = 287S42                  CALENDER START                 (CAL PANEL)
E    62.3 = 287S46.2                CALENDER AUTOMATIC/MANUAL      (CAL PANEL)
E    62.2 = 287S46.1                CALENDER PREHEATING            (CAL PANEL)
M    81.4 = M  81.4                 LINE : START ALARM HORN ON
A     5.6 = 96K7                    CALENDER AUX DRIVES ON/OFF
T   135   = T 135                   START ALARM FOR AUTOMTIC START
M     9.1 = M   9.1                 CONTROL VOLTAGE IS ON
M    92.1 = M  92.1                 CALENDER : START
E    62.1 = 287S43                  CALENDER STOP                  (CAL PANEL)
M     9.6 = M   9.6                 PROGRAM STOP
M    81.7 = M  81.7                 LINE : IMPULSE LINE OFF
M    91.0 = M  91.0                 CALENDER : GENERAL FAULTS
M    92.0 = M  92.0                 CALENDER : FAULTS CALENDER OFF
```

NETZWERK 18 0090 LAMP CALANDER PREHEATING



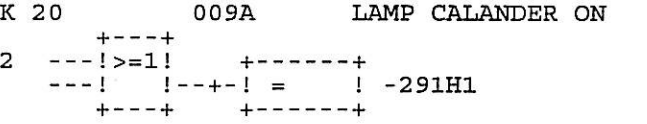
A	5.3 = 91A1.2	CALENDER CONTROLLER RELEASE	
A	5.4 = 91A1.3	CALENDER CREEP	
E	83.2 = 204S3	LAMP TEST	(MAIN CONTR.PAN.)
A	60.7 = 290H8	CALENDER PREHEATING (LAMP)	(CAL PANEL)
A	80.5 = 209H6	CALENDER PREHEATING	(MAIN CONTR.PAN.)

NETZWERK 19 0096 DISKROLL DOWN



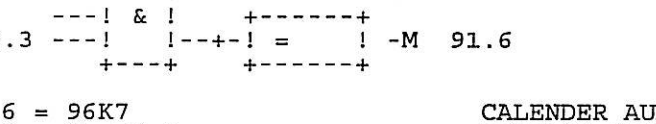
M	91.1 = M 91.1	CALENDER : AUX.DRIVES ON
A	5.4 = 91A1.3	CALENDER CREEP
A	61.1 = A 61.1	DISKROLL DOWN

NETZWERK 20 009A LAMP CALANDER ON



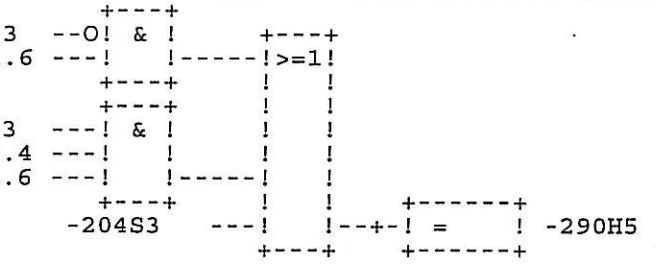
A	5.3 = 91A1.2	CALENDER CONTROLLER RELEASE	
E	83.2 = 204S3	LAMP TEST	(MAIN CONTR.PAN.)
A	61.0 = 291H1	CAL ON (LAMP)	(CAL PANEL)

NETZWERK 21 009E CALANDER READY TO START



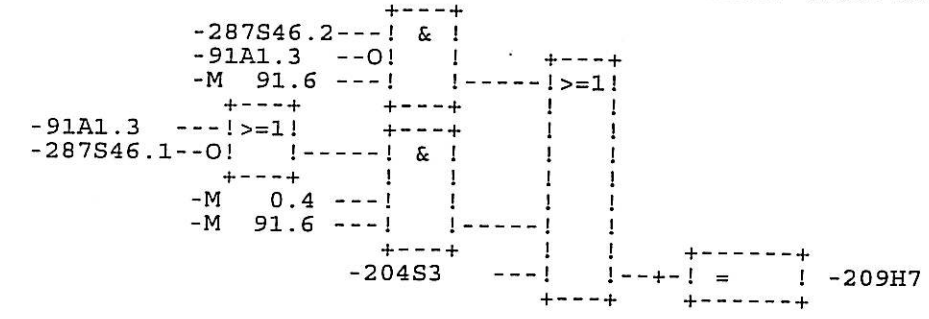
A	5.6 = 96K7	CALENDER AUX DRIVES ON/OFF
M	55.3 = M 55.3	RELEASE CALENDER FROM HEATING DEVICE
M	91.6 = M 91.6	CALENDER : READY TO START

NETZWERK 22 00A2 LAMP CALANDER READY (CAL PANEL)



A	5.4 = 91A1.3	CALENDER CREEP	
M	91.6 = M 91.6	CALENDER : READY TO START	
M	0.4 = M 0.4	TACT 1 HZ	
E	83.2 = 204S3	LAMP TEST	(MAIN CONTR.PAN.)
A	60.4 = 290H5	CAL READY TO START (LAMP)	(CAL PANEL)

NETZWERK 23 00AB LAMP CALANDER READY (MAIN PANEL)

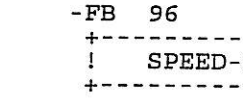



```
E   62.3 = 287S46.2                  CALENDER AUTOMATIC/MANUAL     (CAL PANEL)
A    5.4 = 91A1.3                    CALENDER CREEP
M   91.6 = M  91.6                   CALENDER : READY TO START
E   62.2 = 287S46.1                  CALENDER PREHEATING           (CAL PANEL)
M    0.4 = M   0.4                   TACT 1 HZ
E   83.2 = 204S3                     LAMP TEST                (MAIN CONTR.PAN.)
A   80.6 = 209H7                     CAL. READY TO START      (MAIN CONTR.PAN.)
```

```
NETZWERK 24        00B8      CHANGE CAL SPEED FACT.(0.5-2.0)
00B8       :UN  E   62.3  -287S46.2
00B9       :U   A    5.3  -91A1.2
00BA       :UN  A    5.4  -91A1.3
00BB       :SPB FB  80    -FB  80
00BC NAME  :SLIT +/-
00BD DBNR  :    DB  95    -DB  95
00BE SOLL  :    DD   6
00BF H-DD  :    DD   8
00C0 TAKT  :    M    0.5  -M   0.5
00C1 ZAEH  :    Z   50    -Z  50
00C2 SIG+  :    E   62.5  -287S47.1
00C3 SIG-  :    E   62.6  -287S47.2
00C4 XMAL  :    KZ 005
00C5 SMAX  :    KG +2000000+01
00C7 SMIN  :    KG +5000000+00
00C9 FMAX  :    KG +9999999-01
00CB FMIN  :    KG +1000000-01
00CD MFL1  :    M   92.3  -M  92.3
00CE MIM1  :    M   92.4  -M  92.4
00CF HM2   :    M   92.5  -M  92.5
00D0 MFL2  :    M   92.6  -M  92.6
00D1 MIM2  :    M   92.7  -M  92.7
00D2       :***
```

```
E   62.3 = 287S46.2                  CALENDER AUTOMATIC/MANUAL     (CAL PANEL)
A    5.3 = 91A1.2                    CALENDER CONTROLLER RELEASE
A    5.4 = 91A1.3                    CALENDER CREEP
M    0.5 = M   0.5                   TACT 2 HZ
Z   50   = Z  50                     CALENDER : SPEED +/-
E   62.5 = 287S47.1                  CALENDER FASTER               (CAL PANEL)
E   62.6 = 287S47.2                  CALENDER SLOWLIER             (CAL PANEL)
M   92.3 = M  92.3                   CALENDER : HF FASTER/SLOWLIER
M   92.4 = M  92.4                   CALENDER : HF FASTER/SLOWLIER
M   92.5 = M  92.5                   CALENDER : HF FASTER/SLOWLIER
M   92.6 = M  92.6                   CALENDER : HF FASTER/SLOWLIER
M   92.7 = M  92.7                   CALENDER : HF FASTER/SLOWLIER

DB  95   = DB  95                    GENERAL DATAS

FB  80   = FB  80                    FASTER/SLOWLIER FOR 1 SWITCH
```

NETZWERK 25 00D3 CALCULATE SPEED CALENDER



FB 96 = FB 96 CALCULATE SPEED CALENDER

NETZWERK 26 00D6 SPEED CALANDER

```
                                -FB  44
                                 +--------------+
                                 !   KF-AA      !
                      +142      --!PERE         !
                      DD 10     --!SOLL         !
          +1000000+03           --!EINH         !
                      -M   0.1 --!INVE         !
                      -M   0.1 --!FREI         !
                      -DB  95  --!DBNR         !
                                 +--------------+
```

M 0.1 = M 0.1 "1"-SIGNAL

DB 95 = DB 95 GENERAL DATAS

FB 44 = FB 44 ANALOG OUTPUT

NETZWERK 27 00E0 DISPLAY SPEED CALANDER

```
                                -FB  44
                                 +--------------+
                                 !   KF-AA      !
                      +196      --!PERE         !
                      DD 178    --!SOLL         !
          +4250000+02           --!EINH         !
                      -M   0.0 --!INVE         !
                      -M   0.1 --!FREI         !
                      -DB 170  --!DBNR         !
                                 +--------------+
```

M 0.0 = M 0.0 "0"-SIGNAL
M 0.1 = M 0.1 "1"-SIGNAL

DB 170 = DB 170 ACTUAL DATAS

FB 44 = FB 44 ANALOG OUTPUT

NETZWERK 28 00EA

```
                               -FB  76
                                +--------------+
                                !   CURR-DIS   !
                                +--------------+
```

FB 76 = FB 76 CALCULATE CURRENT CALENDER FOR DISPLAY

NETZWERK 29 00ED DISPLAY CURRENT CALANDER

```
                                -FB  44
                                 +--------------+
                                 !   KF-AA      !
                      +198      --!PERE         !
                      DD 32     --!SOLL         !
          +1000000+02           --!EINH         !
                      -M   0.0 --!INVE         !
                      -M   0.1 --!FREI         !
                      -DB 170  --!DBNR         !
                                 +--------------+
```

M 0.0 = M 0.0 "0"-SIGNAL
M 0.1 = M 0.1 "1"-SIGNAL

DB 170 = DB 170 ACTUAL DATAS

FB 44 = FB 44 ANALOG OUTPUT

```
NETZWERK 30          00F7       MAIN CONTACTOR FEEDING BELT ON
                +---+
 -M  91.1 ---! & !     +------+
 -90K5     --O!    !--+-! =     ! -89K6
                +---+     +------+

M    91.1 = M  91.1                      CALENDER : AUX.DRIVES ON
E     4.1 = 90K5                         FEEDING BELT CALENDER FAULT
A     5.1 = 89K6                         CALENDER FEEDING BELT MAIN CONTACTOR ON

NETZWERK 31          00FB       FEEDING BELT ON
                +---+
 -89K6     ---! & !
 -91A1.2   ---!    !     +------+
 -91A1.3   --O!    !--+-! =     ! -90A1
                +---+     +------+

A     5.1 = 89K6                         CALENDER FEEDING BELT MAIN CONTACTOR ON
A     5.3 = 91A1.2                       CALENDER CONTROLLER RELEASE
A     5.4 = 91A1.3                       CALENDER CREEP
A     5.0 = 90A1                         CALENDER FEEDING BELT ON/OFF

NETZWERK 32          0100       CHANGE FEED.BELT FAC. (0.5-2.0)
0100        :U    A     5.0   -90A1
0101        :SPB FB   78     -FB   78
0102 NAME   :SLIT +/-
0103 DBNR   :     DB   95     -DB   95
0104 SOLL   :     DD   34
0105 H-DD   :     DD   36
0106 TAKT   :     M     0.5   -M    0.5
0107 ZAEH   :     Z    51     -Z   51
0108 SI1+   :     E    63.5   -288S53.1
0109 SI1-   :     E    63.6   -288S53.2
010A XMAL   :     KZ 005
010B SMAX   :     KG +2000000+01
010D SMIN   :     KG +5000000+00
010F FMAX   :     KG +9999999-01
0111 FMIN   :     KG +1000000-01
0113 MFL1   :     M    93.5   -M   93.5
0114 MIM1   :     M    93.6   -M   93.6
0115 HM2    :     M    93.7   -M   93.7
0116 MFL2   :     M    94.0   -M   94.0
0117 MIM2   :     M    94.1   -M   94.1
0118 SI2+   :     E    53.5   -E   53.5
0119 SI2-   :     E    53.6   -E   53.6
011A        :***

A     5.0 = 90A1                         CALENDER FEEDING BELT ON/OFF
M     0.5 = M    0.5                     TACT 2 HZ
Z    51   = Z   51                       CALENDER : CONVEYOR SPEED +/-
E    63.5 = 288S53.1                     FEED.CONV.CAL. FASTER          (CAL PANEL)
E    63.6 = 288S53.2                     FEED.CONV.CAL. SLOWLIER        (CAL PANEL)
M    93.5 = M   93.5                     CALENDER FEEDING BELT : HF FASTER/SLOWER
M    93.6 = M   93.6                     CALENDER FEEDING BELT : HF FASTER/SLOWER
M    93.7 = M   93.7                     CALENDER FEEDING BELT : HF FASTER/SLOWER
M    94.0 = M   94.0                     CALENDER FEEDING BELT : HF FASTER/SLOWER
M    94.1 = M   94.1                     CALENDER FEEDING BELT : HF FASTER/SLOWER
E    53.5 = E   53.5                     FEED.CONV.CAL. FASTER     (EXTR.CAL.PAN.)
E    53.6 = E   53.6                     FEED.CONV.CAL. SLOWLIER   (EXTR.CAL.PAN.)

DB   95   = DB   95                      GENERAL DATAS

FB   78   = FB   78                      FASTER/SLOWLIER FOR 2 SWITCHES

NETZWERK 33          011B       CALCULATE SPEED
011B        :A    DB   95     -DB   95
011C        :L    DD    2
011D        :L    DD   34
011E        :XG
011F        :T    DD   38
0120        :***
```

DB 95 = DB 95 GENERAL DATAS

NETZWERK 34 0121 SPEED FEEDING CONVEYOR CALANDER

```
                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                        +140      --!PERE         !
                        DD 38     --!SOLL         !
                +1000000+03       --!EINH         !
                        -M   0.0  --!INVE         !
                        -M   0.1  --!FREI         !
                        -DB  95   --!DBNR         !
                                   +--------------+
```

M 0.0 = M 0.0 "0"-SIGNAL
M 0.1 = M 0.1 "1"-SIGNAL

DB 95 = DB 95 GENERAL DATAS

FB 44 = FB 44 ANALOG OUTPUT

NETZWERK 35 012B CALANDER FEEDING BELT LEFT

```
              -M  40.7
               +-----+
 -T  64    --!S    !
               !     !
 -T  65    --!R   Q!-
               +-----+
```

T 64 = T 64 CALENDER FEEDING BELT LEFT
M 40.7 = M 40.7 CALENDER FEEDING BELT LEFT
T 65 = T 65 CALENDER FEEDING BELT RIGHT

NETZWERK 36 0131 CALANDER FEEDING BELT LEFT

```
              -T  64
               +-----+
 -M  40.7 -O!T!-!0!
 KT 005.2 --!TW DU!-
               !   DE!-
      005.2 --!R   Q!-
               +-----+
```

M 40.7 = M 40.7 CALENDER FEEDING BELT LEFT
T 64 = T 64 CALENDER FEEDING BELT LEFT

NETZWERK 37 013A CALANDER FEEDING BELT RIGHT

```
              -T  65
               +-----+
 -M  40.7 --!T!-!0!
 KT 005.2 --!TW DU!-
               !   DE!-
    005.2 --!R   Q!-
               +-----+
```

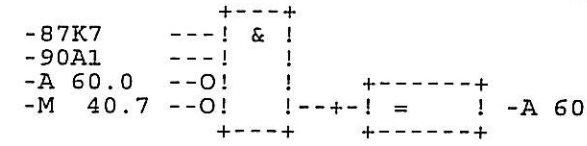
M 40.7 = M 40.7 CALENDER FEEDING BELT LEFT
T 65 = T 65 CALENDER FEEDING BELT RIGHT

NETZWERK 38 0143 CALANDER FEEDING BELT LEFT

```
               +---+
 -87K7     ---! & !
 -90A1     ---!   !
 -A 60.1   --O!   !    +------+
 -M  40.7  ---!   !--+-! =    ! -A 60.0
               +---+    +------+
```

A 4.7 = 87K7 EXTRUDER CALENDER AUX DRIVES ON/OFF
A 5.0 = 90A1 CALENDER FEEDING BELT ON/OFF
A 60.1 = A 60.1 CALENDER FEEDING BELT RIGHT
M 40.7 = M 40.7 CALENDER FEEDING BELT LEFT
A 60.0 = A 60.0 CALENDER FEEDING BELT LEFT

NETZWERK 39 0149 CALANDER FEEDING BELT RIGHT




```
A    4.7 = 87K7                    EXTRUDER CALENDER AUX DRIVES ON/OFF
A    5.0 = 90A1                    CALENDER FEEDING BELT ON/OFF
A   60.0 = A 60.0                  CALENDER FEEDING BELT LEFT
M   40.7 = M  40.7                 CALENDER FEEDING BELT LEFT
A   60.1 = A 60.1                  CALENDER FEEDING BELT RIGHT
```

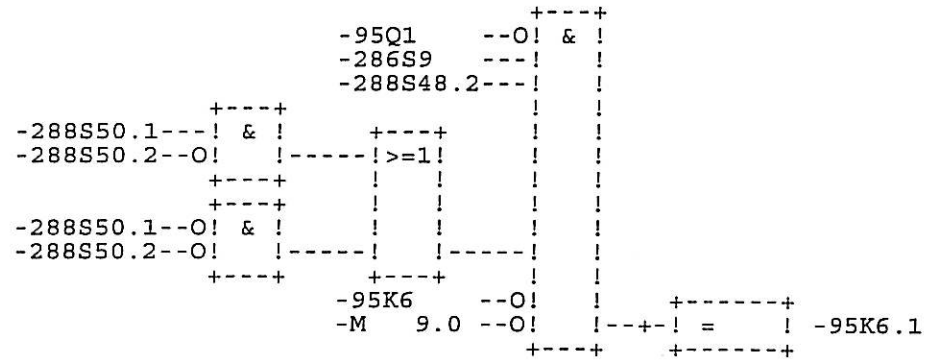
NETZWERK 40 014F

```
014F      :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                          ROLLSLIT AND KNIFE CALANDER                        *
*                                                                             *
*******************************************************************************
0000      :AWL
0001      :***

NETZWERK 2          0002      MAX ROLLSLIT LEFT SIDE
              +---+    +------+
 -286S10   --O! & !--+-! =    ! -M0238
              +---+    +------+

E   61.1 = 286S10                    CALENDER MAX ROLLSLIT LEFT SIDE
M  176.1 = M0238                     MAX ROLLSLIT LEFT SIDE          CALENDER

NETZWERK 3          0005      OPEN ROLLSLIT LEFT SIDE
                                    +---+
                        -94Q1     --O! & !
                        -286S10   ---!   !
                        -288S48.2---!    !
                +---+                    !   !
 -288S50.1--O! & !      +---+             !   !
 -288S50.2---!    !-----!>=1!            !   !
                +---+     !   !          !   !
                +---+     !   !          !   !
 -288S50.1--O! & !        !   !          !   !
 -288S50.2--O!    !-------!   !----------!   !
                +---+     +---+          !   !
                        -94K6     --O!   !    +------+
                        -M   9.0  --O!   !--+-! =    ! -94K6.1
                                    +---+    +------+

E    5.4 = 94Q1                      ROLLSLIT DRIVE 1 FAULT
E   61.1 = 286S10                    CALENDER MAX ROLLSLIT LEFT SIDE
E   63.1 = 288S48.2                  OPEN ROLLSLIT                  (CAL PANEL)
E   63.2 = 288S50.1                  ROLLSLIT RIGHT SIDE            (CAL PANEL)
E   63.3 = 288S50.2                  ROLLSLIT LEFT SIDE             (CAL PANEL)
A    6.0 = 94K6                      CLOSE ROLLSLIT LEFT SIDE
M    9.0 = M   9.0                   E-STOP TRIGGERED
A    6.1 = 94K6.1                    OPEN ROLLSLIT LEFT SIDE

NETZWERK 4          0013      CLOSE ROLLSLIT LEFT SIDE
                                    +---+
                        -94Q1     --O! & !
                        -E 61.3   ---!   !
                        -288S48.1---!    !
                +---+                    !   !
 -288S50.1--O! & !      +---+             !   !
 -288S50.2---!    !-----!>=1!            !   !
                +---+     !   !          !   !
                +---+     !   !          !   !
 -288S50.1--O! & !        !   !          !   !
 -288S50.2--O!    !-------!   !----------!   !
                +---+     +---+          !   !
                        -94K6.1   --O!   !    +------+
                        -M   9.0  --O!   !--+-! =    ! -94K6
                                    +---+    +------+

E    5.4 = 94Q1                      ROLLSLIT DRIVE 1 FAULT
E   61.3 = E 61.3                    CALENDER MIN ROLLSLIT LEFT SIDE
E   63.0 = 288S48.1                  CLOSE ROLLSLIT                 (CAL PANEL)
E   63.2 = 288S50.1                  ROLLSLIT RIGHT SIDE            (CAL PANEL)
E   63.3 = 288S50.2                  ROLLSLIT LEFT SIDE             (CAL PANEL)
A    6.1 = 94K6.1                    OPEN ROLLSLIT LEFT SIDE
M    9.0 = M   9.0                   E-STOP TRIGGERED
A    6.0 = 94K6                      CLOSE ROLLSLIT LEFT SIDE

NETZWERK 5          0021      MAX ROLLSLIT RIGHT SIDE
              +---+    +------+
 -286S9    --O! & !--+-! =    ! -M0239
              +---+    +------+
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                     1!
+-------------------------------------------------------------------------------+
```

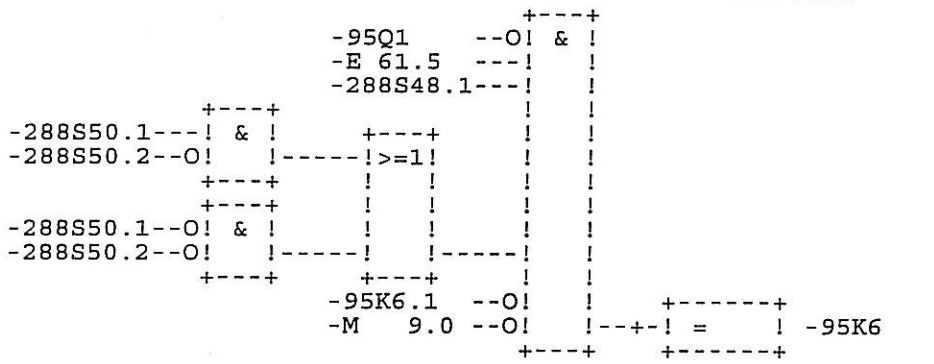
E 61.0 = 286S9 CALENDER MAX ROLLSLIT RIGHT SIDE
M 176.2 = M0239 MAX ROLLSLIT RIGHT SIDE CALENDER

NETZWERK 6 0024 OPEN ROLLSLIT RIGHT SIDE



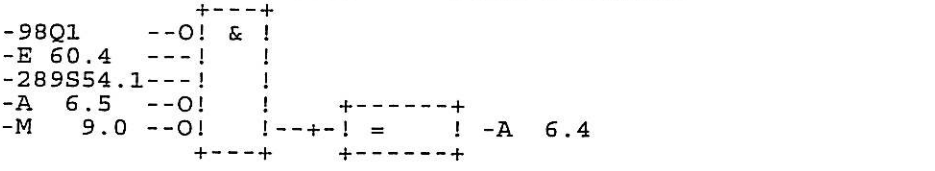
E 5.5 = 95Q1 ROLLSLIT DRIVE 2 FAULT
E 61.0 = 286S9 CALENDER MAX ROLLSLIT RIGHT SIDE
E 63.1 = 288S48.2 OPEN ROLLSLIT (CAL PANEL)
E 63.2 = 288S50.1 ROLLSLIT RIGHT SIDE (CAL PANEL)
E 63.3 = 288S50.2 ROLLSLIT LEFT SIDE (CAL PANEL)
A 6.2 = 95K6 CLOSE ROLLSLIT RIGHT SIDE
M 9.0 = M 9.0 E-STOP TRIGGERED
A 6.3 = 95K6.1 OPEN ROLLSLIT RIGHT SIDE

NETZWERK 7 0032 CLOSE ROLLSLIT RIGHT SIDE



E 5.5 = 95Q1 ROLLSLIT DRIVE 2 FAULT
E 61.5 = E 61.5 CALENDER MIN ROLLSLIT RIGHT SIDE
E 63.0 = 288S48.1 CLOSE ROLLSLIT (CAL PANEL)
E 63.2 = 288S50.1 ROLLSLIT RIGHT SIDE (CAL PANEL)
E 63.3 = 288S50.2 ROLLSLIT LEFT SIDE (CAL PANEL)
A 6.3 = 95K6.1 OPEN ROLLSLIT RIGHT SIDE
M 9.0 = M 9.0 E-STOP TRIGGERED
A 6.2 = 95K6 CLOSE ROLLSLIT RIGHT SIDE

NETZWERK 8 0040 KNIFE 1 FORWARD



E 5.6 = 98Q1 CALENDER KNIFE DRIVE 1 FAULT
E 60.4 = E 60.4 CALENDER KNIFE 1 MAX FORWARD
E 64.2 = 289S54.1 KNIFE 1 FORWARD (CAL PANEL)
A 6.5 = A 6.5 CALENDER KNIFE 1 REVERSE
M 9.0 = M 9.0 E-STOP TRIGGERED
A 6.4 = A 6.4 CALENDER KNIFE 1 FORWARD

```
NETZWERK 9          0047      KNIFE 1 REVERSE
              +---+
 -98Q1     --O! & !
 -E 60.5   ---!   !
 -289S54.2---!    !
 -A  6.4   --O!   !    +------+
 -M   9.0  --O!   !--+-! =    ! -A  6.5
              +---+    +------+

E    5.6 = 98Q1                      CALENDER KNIFE DRIVE 1 FAULT
E   60.5 = E 60.5                    CALENDER KNIFE 1 MAX REVERSE
E   64.3 = 289S54.2                  KNIFE 1 REVERSE              (CAL PANEL)
A    6.4 = A  6.4                    CALENDER KNIFE 1 FORWARD
M    9.0 = M   9.0                   E-STOP TRIGGERED
A    6.5 = A  6.5                    CALENDER KNIFE 1 REVERSE

NETZWERK 10         004E      KNIFE 2 FORWARD
              +---+
 -98Q3     --O! & !
 -E 60.7   ---!   !
 -289S55.1---!    !
 -A  6.7   --O!   !    +------+
 -M   9.0  --O!   !--+-! =    ! -A  6.6
              +---+    +------+

E    5.7 = 98Q3                      CALENDER KNIFE DRIVE 2 FAULT
E   60.7 = E 60.7                    CALENDER KNIFE 2 MAX FORWARD
E   64.4 = 289S55.1                  KNIFE 2 FORWARD              (CAL PANEL)
A    6.7 = A  6.7                    CALENDER KNIFE 2 REVERSE
M    9.0 = M   9.0                   E-STOP TRIGGERED
A    6.6 = A  6.6                    CALENDER KNIFE 2 FORWARD

NETZWERK 11         0055      KNIFE 2 REVERSE
              +---+
 -98Q3     --O! & !
 -E 60.6   ---!   !
 -289S55.2---!    !
 -A  6.6   --O!   !    +------+
 -M   9.0  --O!   !--+-! =    ! -A  6.7
              +---+    +------+

E    5.7 = 98Q3                      CALENDER KNIFE DRIVE 2 FAULT
E   60.6 = E 60.6                    CALENDER KNIFE 2 MAX REVERSE
E   64.5 = 289S55.2                  KNIFE 2 REVERSE              (CAL PANEL)
A    6.6 = A  6.6                    CALENDER KNIFE 2 FORWARD
M    9.0 = M   9.0                   E-STOP TRIGGERED
A    6.7 = A  6.7                    CALENDER KNIFE 2 REVERSE

NETZWERK 12         005C
005C       :AWL
005D       :BE
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                              ANALOG INPUT                                 *
*                                                                           *
*****************************************************************************
```

0000 :***

NETZWERK 2 0001 SPEED TOPMACHINE

```
                                -FB  46
                                 +--------------+
                                 !   AE:0-10V   !
                     +128      --!PERE      DWNR!-- DD 18
           +5071000+02         --!EINH          !
                     -DB 170   --!DBNR          !
                                 +--------------+
```

DB 170 = DB 170 ACTUAL DATAS

FB 46 = FB 46 ANALOG INPUT 0 - 10 V

NETZWERK 3 0009 CURRENT TOPMACHINE

```
                                -FB  46
                                 +--------------+
                                 !   AE:0-10V   !
                     +130      --!PERE      DWNR!-- DD 20
           +6000000+03         --!EINH          !
                     -DB 170   --!DBNR          !
                                 +--------------+
```

DB 170 = DB 170 ACTUAL DATAS

FB 46 = FB 46 ANALOG INPUT 0 - 10 V

NETZWERK 4 0011 SPEED BOTTOMMACHINE

```
                                -FB  46
                                 +--------------+
                                 !   AE:0-10V   !
                     +132      --!PERE      DWNR!-- DD 22
           +5855000+02         --!EINH          !
                     -DB 170   --!DBNR          !
                                 +--------------+
```

1025000+03

DB 170 = DB 170 ACTUAL DATAS

FB 46 = FB 46 ANALOG INPUT 0 - 10 V

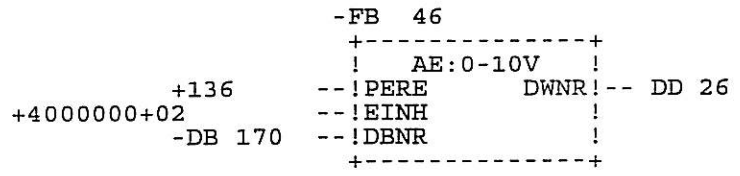
NETZWERK 5 0019 CURRENT BOTTOMMACHINE

```
                                -FB  46
                                 +--------------+
                                 !   AE:0-10V   !
                     +134      --!PERE      DWNR!-- DD 24
           +4000000+03         --!EINH          !
                     -DB 170   --!DBNR          !
                                 +--------------+
```

DB 170 = DB 170 ACTUAL DATAS

FB 46 = FB 46 ANALOG INPUT 0 - 10 V

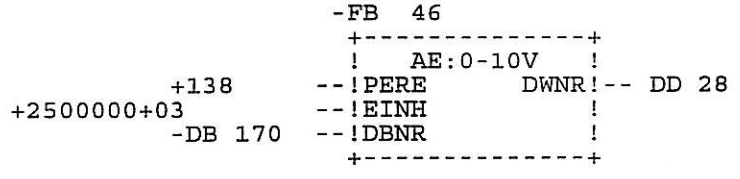
NETZWERK 6 0021 SPEED EXTRUDER 3



DB 170 = DB 170 ACTUAL DATAS

FB 46 = FB 46 ANALOG INPUT 0 - 10 V

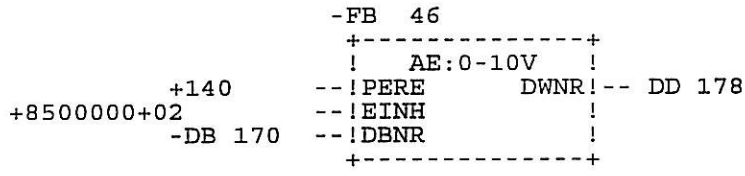
NETZWERK 7 0029 CURRENT EXTRUDER 3



DB 170 = DB 170 ACTUAL DATAS

FB 46 = FB 46 ANALOG INPUT 0 - 10 V

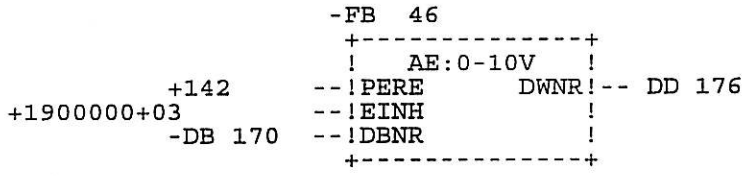
NETZWERK 8 0031 SPEED CALENDER



DB 170 = DB 170 ACTUAL DATAS

FB 46 = FB 46 ANALOG INPUT 0 - 10 V

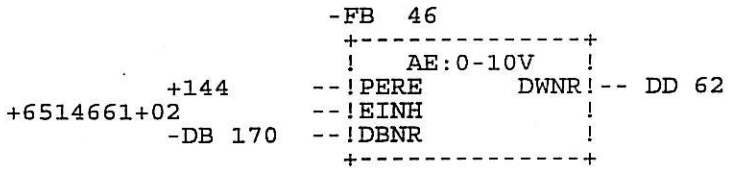
NETZWERK 9 0039 CURRENT CALENDER



DB 170 = DB 170 ACTUAL DATAS

FB 46 = FB 46 ANALOG INPUT 0 - 10 V

NETZWERK 10 0041 LINE SPEED (DRAW-OFF-CONVEYOR)

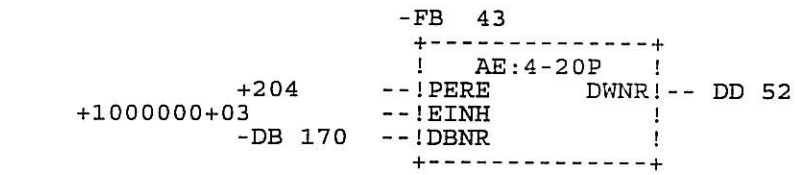


```
DB 170   = DB 170                    ACTUAL DATAS

FB  46   = FB  46                    ANALOG INPUT  0 - 10 V

NETZWERK 11        0049      TRANSFER LINE SPEED TO DB95
0049      :A   DB 170    -DB 170
004A      :L   DD  62
004B      :A   DB  95    -DB  95
004C      :T   DD  46
004D      :***


DB 170   = DB 170                    ACTUAL DATAS
DB  95   = DB  95                    GENERAL DATAS

NETZWERK 12        004E      PRESSURE CHANNEL 1

                                  -FB  46
                                   +--------------+
                                   !   AE:0-10V   !
                     +160        --!PERE      DWNR!-- DD 172
          +4000000+03            --!EINH          !
                     -DB 170     --!DBNR          !
                                   +--------------+

DB 170   = DB 170                    ACTUAL DATAS

FB  46   = FB  46                    ANALOG INPUT  0 - 10 V

NETZWERK 13        0056      PRESSURE CHANNEL 2

                                  -FB  46
                                   +--------------+
                                   !   AE:0-10V   !
                     +162        --!PERE      DWNR!-- DD 174
          +4000000+03            --!EINH          !
                     -DB 170     --!DBNR          !
                                   +--------------+

DB 170   = DB 170                    ACTUAL DATAS

FB  46   = FB  46                    ANALOG INPUT  0 - 10 V

NETZWERK 14        005E      LOOP LINEAR CHECK WEIGHER

                                  -FB  43
                                   +--------------+
                                   !   AE:4-20P   !
                     +192        --!PERE      DWNR!-- DD 48
          +1000000+03            --!EINH          !
                     -DB 170     --!DBNR          !
                                   +--------------+

DB 170   = DB 170                    ACTUAL DATAS

FB  43   = FB  43                    ANALOG INPUT  4 -20 mA

NETZWERK 15        0066      LOOP CALANDER

                                  -FB  43
                                   +--------------+
                                   !   AE:4-20P   !
                     +194        --!PERE      DWNR!-- DD 50
          +1000000+03            --!EINH          !
                     -DB 170     --!DBNR          !
                                   +--------------+
```

DB 170 = DB 170 ACTUAL DATAS

FB 43 = FB 43 ANALOG INPUT 4 -20 mA

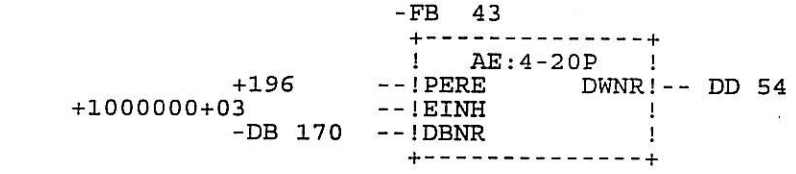
NETZWERK 16 006E LOOP CEMENTING 2



DB 170 = DB 170 ACTUAL DATAS

FB 43 = FB 43 ANALOG INPUT 4 -20 mA

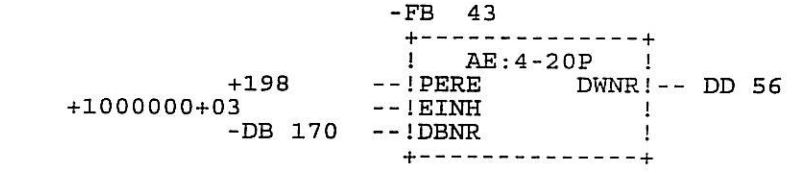
NETZWERK 17 0076 LOOP COOLING SECTION 1



DB 170 = DB 170 ACTUAL DATAS

FB 43 = FB 43 ANALOG INPUT 4 -20 mA

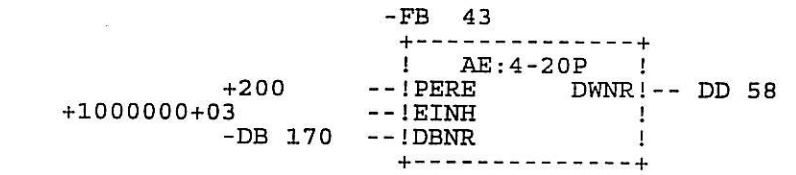
NETZWERK 18 007E LOOP COOLING SECTION 2



DB 170 = DB 170 ACTUAL DATAS

FB 43 = FB 43 ANALOG INPUT 4 -20 mA

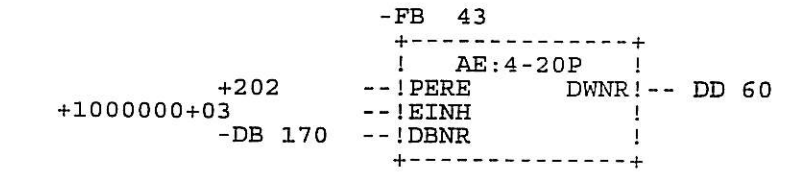
NETZWERK 19 0086 LOOP COOLING SECTION 3



DB 170 = DB 170 ACTUAL DATAS

FB 43 = FB 43 ANALOG INPUT 4 -20 mA

NETZWERK 20 008E LOOP COOLING SECTION 4



```
PB 93    -PB  93                          C:KERM06ST.S5D        BIB=23023    LAE=220

DB 170    = DB 170                        ACTUAL DATAS

FB  43    = FB  43                        ANALOG INPUT  4 -20 mA

NETZWERK 21          0096       LOOP CENTERING DEVICE 2

                                  -FB  43
                                   +--------------+
                                   !   AE:4-20P   !
                       +206      --!PERE      DWNR!-- DD 46
            +1000000+03          --!EINH          !
                       -DB 170   --!DBNR          !
                                   +--------------+

DB 170    = DB 170                        ACTUAL DATAS

FB  43    = FB  43                        ANALOG INPUT  4 -20 mA

NETZWERK 22          009E       SPEED LINEAR CHECK WEIGHER

                                  -FB  46
                                   +--------------+
                                   !   AE:0-10V   !
                       +148      --!PERE      DWNR!-- DD 48
            +7000000+02          --!EINH          !
                       -DB  95   --!DBNR          !
                                   +--------------+

DB  95    = DB  95                        GENERAL DATAS

FB  46    = FB  46                        ANALOG INPUT  0 - 10 V

NETZWERK 23          00A6       SPEED CONVEYOR CEMENTING 2

                                  -FB  46
                                   +--------------+
                                   !   AE:0-10V   !
                       +150      --!PERE      DWNR!-- DD 50
            +6000000+02          --!EINH          !
                       -DB  95   --!DBNR          !
                                   +--------------+

DB  95    = DB  95                        GENERAL DATAS

FB  46    = FB  46                        ANALOG INPUT  0 - 10 V

NETZWERK 24          00AE       SPEED COOLING SECTION 1

                                  -FB  46
                                   +--------------+
                                   !   AE:0-10V   !
                       +152      --!PERE      DWNR!-- DD 52
            +6000000+02          --!EINH          !
                       -DB  95   --!DBNR          !
                                   +--------------+

DB  95    = DB  95                        GENERAL DATAS

FB  46    = FB  46                        ANALOG INPUT  0 - 10 V

NETZWERK 25          00B6       SPEED COOLING SECTION 2

                                  -FB  46
                                   +--------------+
                                   !   AE:0-10V   !
                       +154      --!PERE      DWNR!-- DD 54
            +6000000+02          --!EINH          !
                       -DB  95   --!DBNR          !
                                   +--------------+

+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                      !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                      !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                    PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                      5!
+-------------------------------------------------------------------------------+
```

```
DB  95   = DB  95                    GENERAL DATAS

FB  46   = FB  46                    ANALOG INPUT  0 - 10 V

NETZWERK 26        00BE      SPEED COOLING SECTION 3

                                  -FB  46
                                   +--------------+
                                   !   AE:0-10V   !
                        +156      --!PERE      DWNR!-- DD 56
              +6000000+02         --!EINH          !
                        -DB  95   --!DBNR          !
                                   +--------------+

DB  95   = DB  95                    GENERAL DATAS

FB  46   = FB  46                    ANALOG INPUT  0 - 10 V

NETZWERK 27        00C6      SPEED COOLING SECTION 4

                                  -FB  46
                                   +--------------+
                                   !   AE:0-10V   !
                        +158      --!PERE      DWNR!-- DD 58
              +6000000+02         --!EINH          !
                        -DB  95   --!DBNR          !
                                   +--------------+

DB  95   = DB  95                    GENERAL DATAS

FB  46   = FB  46                    ANALOG INPUT  0 - 10 V

NETZWERK 28        00CE      SPEED CONVEYOR CEMENTING 2

                                  -FB  46
                                   +--------------+
                                   !   AE:0-10V   !
                        +146      --!PERE      DWNR!-- DD 60
              +6000000+02         --!EINH          !
                        -DB  95   --!DBNR          !
                                   +--------------+

DB  95   = DB  95                    GENERAL DATAS

FB  46   = FB  46                    ANALOG INPUT  0 - 10 V

NETZWERK 29        00D6
00D6       :BE
```

```
PB 95   -PB  95                        C:KERM06ST.S5D        BIB=28102   LAE=128

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  ANALOG OUTPUT                              *
*                                                                             *
*******************************************************************************
0000      :***

NETZWERK 2          0001      DRAW-OFF/SHRINKAGE CONVEYOR

                                    -FB  44
                                     +--------------+
                                     !   KF-AA      !
                        +132       --!PERE         !
                        DD 2       --!SOLL         !
              +1000000+03          --!EINH         !
                        -M   0.0 --!INVE           !
                        -M   0.1 --!FREI           !
                        -DB  95  --!DBNR           !
                                     +--------------+

M    0.0 = M   0.0                        "0"-SIGNAL
M    0.1 = M   0.1                        "1"-SIGNAL

DB  95   = DB  95                         GENERAL DATAS

FB  44   = FB  44                         ANALOG OUTPUT

NETZWERK 3          000B      CONVEYOR LINEAR CHECK WEIGHER

                                    -FB  44
                                     +--------------+
                                     !   KF-AA      !
                        +134       --!PERE         !
                        DD 12      --!SOLL         !
              +1000000+03          --!EINH         !
                        -M   0.0 --!INVE           !
                        -M   0.1 --!FREI           !
                        -DB  95  --!DBNR           !
                                     +--------------+

M    0.0 = M   0.0                        "0"-SIGNAL
M    0.1 = M   0.1                        "1"-SIGNAL

DB  95   = DB  95                         GENERAL DATAS

FB  44   = FB  44                         ANALOG OUTPUT

NETZWERK 4          0015      CONVEYOR CEMENTING DEVICE

                                    -FB  44
                                     +--------------+
                                     !   KF-AA      !
                        +144       --!PERE         !
                        DD 14      --!SOLL         !
              +1000000+03          --!EINH         !
                        -M   0.0 --!INVE           !
                        -M   0.1 --!FREI           !
                        -DB  95  --!DBNR           !
                                     +--------------+

M    0.0 = M   0.0                        "0"-SIGNAL
M    0.1 = M   0.1                        "1"-SIGNAL

DB  95   = DB  95                         GENERAL DATAS

FB  44   = FB  44                         ANALOG OUTPUT
```

```
NETZWERK 5          001F      COOLING SECTION 1

                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                       +146      --!PERE          !
                       DD 16     --!SOLL          !
             +1000000+03         --!EINH          !
                       -M   0.0  --!INVE          !
                       -M   0.1  --!FREI          !
                       -DB  95   --!DBNR          !
                                   +--------------+

M    0.0 = M   0.0                      "0"-SIGNAL
M    0.1 = M   0.1                      "1"-SIGNAL

DB  95   = DB  95                       GENERAL DATAS

FB  44   = FB  44                       ANALOG OUTPUT

NETZWERK 6          0029      COOLING SECTION 2

                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                       +148      --!PERE          !
                       DD 18     --!SOLL          !
             +1000000+03         --!EINH          !
                       -M   0.0  --!INVE          !
                       -M   0.1  --!FREI          !
                       -DB  95   --!DBNR          !
                                   +--------------+

M    0.0 = M   0.0                      "0"-SIGNAL
M    0.1 = M   0.1                      "1"-SIGNAL

DB  95   = DB  95                       GENERAL DATAS

FB  44   = FB  44                       ANALOG OUTPUT

NETZWERK 7          0033      COOLING SECTION 3

                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                       +150      --!PERE          !
                       DD 20     --!SOLL          !
             +1000000+03         --!EINH          !
                       -M   0.0  --!INVE          !
                       -M   0.1  --!FREI          !
                       -DB  95   --!DBNR          !
                                   +--------------+

M    0.0 = M   0.0                      "0"-SIGNAL
M    0.1 = M   0.1                      "1"-SIGNAL

DB  95   = DB  95                       GENERAL DATAS

FB  44   = FB  44                       ANALOG OUTPUT

NETZWERK 8          003D      COOLING SECTION 4

                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                       +152      --!PERE          !
                       DD 22     --!SOLL          !
             +1000000+03         --!EINH          !
                       -M   0.0  --!INVE          !
                       -M   0.1  --!FREI          !
                       -DB  95   --!DBNR          !
                                   +--------------+
```

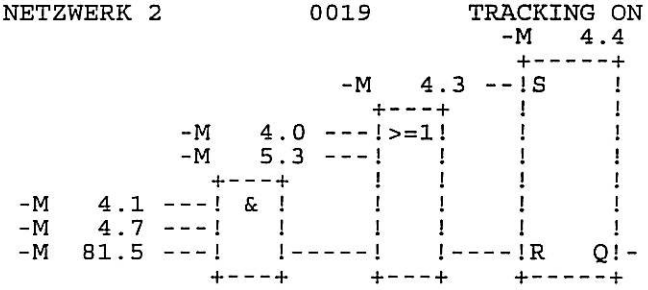
```
M     0.0 = M    0.0                    "0"-SIGNAL
M     0.1 = M    0.1                    "1"-SIGNAL

DB   95   = DB   95                     GENERAL DATAS

FB   44   = FB   44                     ANALOG OUTPUT

NETZWERK 9          0047      KNIFE MIDDLE SEPERATING DEVICE

                                -FB  44
                                 +--------------+
                                 !   KF-AA      !
                      +154      --!PERE         !
                      DD 28     --!SOLL         !
            +1000000+03         --!EINH         !
                      -M   0.0  --!INVE         !
                      -M   0.1  --!FREI         !
                      -DB  95   --!DBNR         !
                                 +--------------+

M     0.0 = M    0.0                    "0"-SIGNAL
M     0.1 = M    0.1                    "1"-SIGNAL

DB   95   = DB   95                     GENERAL DATAS

FB   44   = FB   44                     ANALOG OUTPUT

NETZWERK 10         0051      CONVEYOR CENTERING DEVICE

                                -FB  44
                                 +--------------+
                                 !   KF-AA      !
                      +156      --!PERE         !
                      DD 44     --!SOLL         !
            +1000000+03         --!EINH         !
                      -M   0.0  --!INVE         !
                      -M   0.1  --!FREI         !
                      -DB  95   --!DBNR         !
                                 +--------------+

M     0.0 = M    0.0                    "0"-SIGNAL
M     0.1 = M    0.1                    "1"-SIGNAL

DB   95   = DB   95                     GENERAL DATAS

FB   44   = FB   44                     ANALOG OUTPUT

NETZWERK 11         005B      FREEWHEEL + ACCELERATING CONV.

                                -FB  44
                                 +--------------+
                                 !   KF-AA      !
                      +162      --!PERE         !
                      DD 44     --!SOLL         !
            +1000000+03         --!EINH         !
                      -M   0.0  --!INVE         !
                      -M   0.1  --!FREI         !
                      -DB  95   --!DBNR         !
                                 +--------------+

M     0.0 = M    0.0                    "0"-SIGNAL
M     0.1 = M    0.1                    "1"-SIGNAL

DB   95   = DB   95                     GENERAL DATAS

FB   44   = FB   44                     ANALOG OUTPUT
```

```
NETZWERK 12        0065      CONVEYOR TREAD CHECKER

                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                          +158     --!PERE        !
                          DD 2     --!SOLL        !
                +1000000+03        --!EINH        !
                          -M   0.0 --!INVE        !
                          -M   0.1 --!FREI        !
                          -DB  95  --!DBNR        !
                                   +--------------+

M    0.0 = M   0.0                      "0"-SIGNAL
M    0.1 = M   0.1                      "1"-SIGNAL

DB  95   = DB  95                       GENERAL DATAS

FB  44   = FB  44                       ANALOG OUTPUT

NETZWERK 13        006F

                                  -FB  44
                                   +--------------+
                                   !   KF-AA      !
                          +160     --!PERE        !
                          DD 2     --!SOLL        !
                +1000000+03        --!EINH        !
                          -M   0.0 --!INVE        !
                          -M   0.1 --!FREI        !
                          -DB  95  --!DBNR        !
                                   +--------------+

M    0.0 = M   0.0                      "0"-SIGNAL
M    0.1 = M   0.1                      "1"-SIGNAL

DB  95   = DB  95                       GENERAL DATAS

FB  44   = FB  44                       ANALOG OUTPUT

NETZWERK 14        0079      SOLLWERT TEMPERATUR ZONE 4 OM
0079      :AWL
007A      :BE
```

NETZWERK 1   0000

```
*******************************************************************************
*                                                                             *
*                              PROFILE MANEGEMENT                             *
*                                                                             *
*******************************************************************************
0000       :U   M  160.7                          RESET CP
0001       :SPB FB 182     -FB 182
0002 NAME  :RESET-CP
0003       :SPA FB 186     -FB 186                CONTROL ORDERS TO CP'S
0004 NAME  :CONTR-CP
0005       :SPA FB 170     -FB 170                PROFILE MANAGEMENT
0006 NAME  :RE-HAUPT
0007       :SPA FB 188     -FB 188                OUTPUT ORDERS CP525
0008 NAME  :AUFT-525
0009       :SPA FB 189     -FB 189                OUTPUT ORDERS CP527
000A NAME  :AUFT-527
000B       :SPA FB 187     -FB 187                FLAGS CP527
000C NAME  :KOPPL-M
000D PANF  :    M    0.0   -M   0.0
000E       :SPA FB 199     -FB 199                SYSTEM TIME OUT OF DB6
000F NAME  :UHRZEIT
0010       :SPA PB 101     -PB 101                TRACKING
0011       :SPA FB 195     -FB 195                CHECK PROFILE
0012 NAME  :CHECK-P.
0013       :SPA FB  95     -FB  95                PICTURES LMD
0014 NAME  :CKECKLMD
0015       :BEA
0016       :
0017       :U   M    3.0   -M   3.0              COPY PROFILE PART B TO DB180
0018       :SPB FB 193     -FB 193
0019 NAME  :COPY-B
001A       :U   M    3.1   -M   3.1              COPY PROFILE PART C TO DB180
001B       :SPB FB 194     -FB 194
001C NAME  :COPY-C
001D       :BE

M    0.0 = M   0.0                    "0"-SIGNAL
M    3.0 = M   3.0                    SPARE
M    3.1 = M   3.1                    SPARE

PB 101   = PB 101                     TRACKING

FB 182   = FB 182                     RESET CP
FB 186   = FB 186                     CONTROL CP527/525
FB 170   = FB 170                     PROFILE MANAGEMENT
FB 188   = FB 188                     ORDER TO CP525
FB 189   = FB 189                     ORDER TO CP527
FB 187   = FB 187                     FLAGS CP527
FB 199   = FB 199                     ACTUAL TIME
FB 195   = FB 195                     CHECK ACTUAL PROFILE PARTS
FB  95   = FB  95                     PICTURES LENGTH MEASURING DEVICE
FB 193   = FB 193                     COPY PROFILE PART B
FB 194   = FB 194                     COPY PROFILE PART C
```

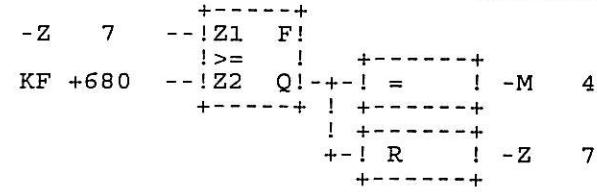
```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                              PROFILE TRACKING                             *
*                                                                           *
*****************************************************************************
0000       :A   DB 170     -DB 170                 DB ACTUAL DATAS
0001       :L   DD  64                             LINEAR WEIGHT
0002       :L   KG +2000000+00
0005       :>=G
0006       :=   M    4.1   -M   4.1                MATERIAL ON WEIGHER
0007       :UN  M    4.1   -M   4.1
0008       :UN  M    4.2   -M   4.2
0009       :=   M    4.3   -M   4.3                IMPULSE NO MATERIAL ON WEIGHER
000A       :UN  M    4.1   -M   4.1
000B       :=   M    4.2   -M   4.2
000C       :A   DB 180     -DB 180
000D       :L   DL   1
000E       :L   DL  30
000F       :!=F
0010       :=   M  200.0
0011       :L   DL   1
0012       :L   DL  31
0013       :!=F
0014       :=   M  200.1
0015       :U   M  200.0
0016       :U   M  200.1
0017       :=   M    4.7   -M   4.7
0018       :***

M    4.1 = M   4.1                  NO MATERIAL ON WEIGHER
M    4.2 = M   4.2                  HF NO MATERIAL ON WEIGHER
M    4.3 = M   4.3                  IMPULSE NO MATERIAL ON WEIGHER
M    4.7 = M   4.7                  PROFILE PART A=B=C

DB 170   = DB 170                  ACTUAL DATAS
DB 180   = DB 180                  PROFILE AG

NETZWERK 2          0019       TRACKING ON
```




```
M    4.3 = M   4.3                  IMPULSE NO MATERIAL ON WEIGHER
M    4.4 = M   4.4                  TRACKING ON
M    4.0 = M   4.0                  MATERIAL AT PART C
M    5.3 = M   5.3                  COPY PROFILE PART C
M    4.1 = M   4.1                  NO MATERIAL ON WEIGHER
M    4.7 = M   4.7                  PROFILE PART A=B=C
M   81.5 = M  81.5                  LINE : LINE ON

NETZWERK 3          0024       TRACKING COUNTER 1
0024       :L   PY  45
0025       :T   EB  45
0026       :U   E   45.3  -E 45.3
0027       :U   M    4.4  -M   4.4
0028       :ZV  Z    7    -Z   7
0029       :UN  M    4.4  -M   4.4
002A       :R   Z    7    -Z   7
002B       :***

E   45.3 = E 45.3                  PULSE GENERATOR TRACKING (CENTERING 2)
```

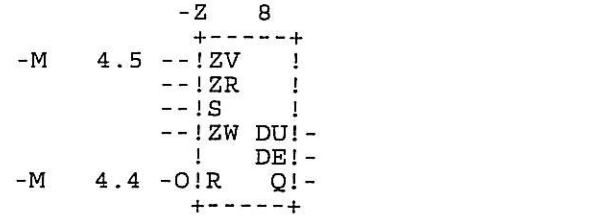
```
M    4.4 = M   4.4                    TRACKING ON
Z    7   = Z   7                      TRACKING COUNTER 1
```

NETZWERK 4 002C TRACKING COUNTER 1 = 600 (30m) ?



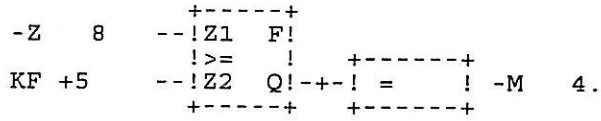

```
Z    7   = Z   7                      TRACKING COUNTER 1
M    4.5 = M   4.5                    TRACKING COUNTER 1 = 900
```

NETZWERK 5 0033



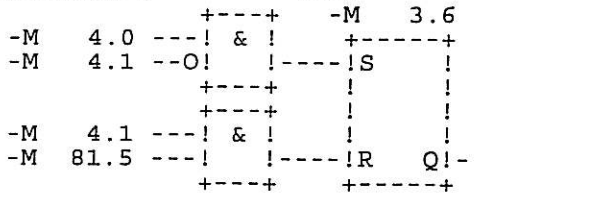

```
M    4.5 = M   4.5                    TRACKING COUNTER 1 = 900
Z    8   = Z   8                      TRACKING COUNTER 2
M    4.4 = M   4.4                    TRACKING ON
```

NETZWERK 6 003E TRACKING COUNTER 2



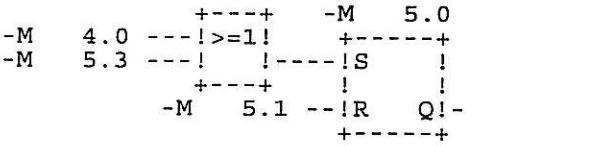

```
Z    8   = Z   8                      TRACKING COUNTER 2
M    4.0 = M   4.0                    MATERIAL AT PART C
```

NETZWERK 7 0044




```
M    4.0 = M   4.0                    MATERIAL AT PART C
M    4.1 = M   4.1                    NO MATERIAL ON WEIGHER
M    3.6 = M   3.6                    NO MATERIAL IN LINE
M   81.5 = M  81.5                    LINE : LINE ON
```

NETZWERK 8 004C




```
M    4.0 = M   4.0                    MATERIAL AT PART C
M    5.3 = M   5.3                    COPY PROFILE PART C
M    5.0 = M   5.0                    TIME FOR PRODUCTION REPORT
M    5.1 = M   5.1                    TIME FOR PRODUCTION REPORT
```

```
NETZWERK 9          0053      MATERIAL END AT SKIVER (150m) ?
            -T 121
             +-----+
 -M   5.0 --!T!-!0!
 KT 200.1 --!TW DU!-
            !   DE!-
            !     !   +------+
          --!R   Q!-+-! =    ! -M   5.1
            +-----+   +------+

M    5.0 = M   5.0                    TIME FOR PRODUCTION REPORT
T  121   = T 121                      TIME FOR PRODUCTION REPORT
M    5.1 = M   5.1                    TIME FOR PRODUCTION REPORT

NETZWERK 10         005D      NO MATERIAL IN LINE
              +---+   -T 122
 -204S5   ---!>=1!    +-----+
 -M   5.1 ---!   !----!1_-_V!
              +---+    !     !
           KT 300.0 --!TW DU!-
                      !   DE!-
                      !     !   +------+
                    --!R   Q!-+-! =    ! -M   5.2
                      +-----+   +------+

E   83.4 = 204S5                      RESET PRODUCT. REPORT  (MAIN CONTR.PAN.)
M    5.1 = M   5.1                    TIME FOR PRODUCTION REPORT
T  122   = T 122                      TIME FOR RESET PRODUCTION DATAS
M    5.2 = M   5.2                    RESET PRODUCTION DATAS

NETZWERK 11         0068      TIME FOR RESET PRODUCTION REPORT
0068       :UN  M    5.2  -M   5.2
0069       :BEB
006A       :A   DB 170    -DB 170
006B       :L   DD 240
006C       :T   DD 210
006D       :L   DD 242
006E       :T   DD 212
006F       :L   DD 244
0070       :T   DD 214
0071       :L   DD 246
0072       :T   DD 216
0073       :L   DD 248
0074       :T   DD 218
0075       :L   KF +0
0077       :T   DW 115
0078       :L   KG +0000000+00
007B       :T   DD 117
007C       :***

M    5.2 = M   5.2                    RESET PRODUCTION DATAS

DB 170   = DB 170                     ACTUAL DATAS

NETZWERK 12         007D      TIME FOR RESET PRODUCTION REPORT
007D       :BE
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                                SET TIME CP525                             *
*                                                                           *
*****************************************************************************
0000      :A   DB 199    -DB 199
0001      :L   KH 0000
0003      :T   DW  16                          KH: SLAVE IDENTIFICATION
0004      :A   DB   6    -DB   6
0005      :L   DW  52
0006      :A   DB 199    -DB 199
0007      :T   DW  17                          KH: 1/10      / SEC
0008      :A   DB   6    -DB   6
0009      :L   DW  53
000A      :T   DW  18                          KH: MINUTEN   / TAG
000B      :A   DB   6    -DB   6
000C      :L   DW  54
000D      :A   DB 199    -DB 199
000E      :T   DW  19                          KH: TAG       / MONAT
000F      :A   DB   6    -DB   6
0010      :L   DW  55
0011      :A   DB 199    -DB 199
0012      :T   DW  20                          KH: JAHR      / ----
0013      :UN  M    2.6  -M   2.6
0014      :R   M    5.4  -M   5.4
0015      :U   M    2.6  -M   2.6
0016      :S   M    5.4  -M   5.4
0017      :SPA FB 120    -FB 120
0018 NAME :SEND
0019 SSNR :    KY 0,10
001A A-NR :    KY 0,218
001B ANZW :    MW 200
001C QTYP :    KC DB
001D DBNR :    KY 0,199
001E QANF :    KF +16
001F QLAE :    KF +5
0020 PAFE :    MB 200
0021      :U   M    2.6  -M   2.6
0022      :R   M    2.6  -M   2.6
0023      :BE

M    2.6 = M   2.6                  HF SET CP525-TIME
M    5.4 = M   5.4                  IMPULSE SET CP525-TIME

DB 199   = DB 199                   TIME
DB   6   = DB   6                   DB FOR CP527

FB 120   = FB 120                   SEND (S)
```

```
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                     !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                     !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE        :                      !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                   PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER  :                      1!
+-----------------------------------------------------------------------------+
```

```
PB 255  -PB 255                          C:KERM06ST.S5D        BIB=18031   LAE=40

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                          START UP PROFILE MANAGEMENT                        *
*                                                                             *
*******************************************************************************
0000      :AWL
0001      :A   DB 185     -DB 185              DELETE FLAG'S
0002      :L   KH 0000
0004      :T   DW   1
0005      :T   DW   2
0006      :T   DW   3
0007      :A   DB 184     -DB 184              DELETE CHOICE
0008      :T   DR  18
0009      :T   DR  28
000A      :T   DR  38
000B      :T   DR  48
000C      :T   DR  58
000D      :T   DR  68
000E      :T   DR  78
000F      :T   DR  88
0010      :T   DR  98
0011      :T   DR 108
0012      :T   DR 118
0013      :T   DR 128
0014      :T   DR 138
0015      :T   DR 148
0016      :T   DR 158
0017      :T   DR 168
0018      :T   DR 178
0019      :T   DR 188
001A      :T   DR 198
001B      :T   DR 208
001C      :T   DR 218
001D      :T   DR 228
001E      :T   DR 238
001F      :T   DR 248
0020      :***


DB 185    = DB 185                       PROFILE MANAGEMENT
DB 184    = DB 184                       PROFILE NAME

NETZWERK 2          0021
0021      :AWL
0022      :BE
```

FB

```
FB 23    -FB  23                    C:KERM06ST.S5D        BIB=4112     LAE=91

NETZWERK 1          0000

**********************************************************************************
*                                                                                *
*                                PRESSURE EVALUATION                             *
*                                                                                *
**********************************************************************************
NAME :PRESSURE

0005       :AWL
0006       :***

NETZWERK 2          0007       RELEASE DEH : PRESSURE <= 5 BAR
0007       :AWL                                ###### TOPMACHINE ###############
0008       :A    DB 170     -DB 170            DB ACTUAL DATA
0009       :L    DD 172                        PRESSURE CHANNEL 1 (TOPMACHINE)
000A       :L    KG +1500000+02                15 BAR
000D       :<=G                                IF PRESSURE TOPM <= 15 BAR
000E       :=    M   27.2   -M  27.2           RELEASE DEH FROM CHANNEL 1
000F       :                                   ###### BOTTOMMACHINE ############
0010       :L    DD 174                        PRESSURE CHANNEL 2 (BOTTOMMACH.)
0011       :L    KG +1500000+02                15 BAR
0014       :<=G                                IF PRESSURE BOTM <= 15 BAR
0015       :=    M   27.3   -M  27.3           RELEASE DEH FROM CHANNEL 2
0016       :***

M   27.2 = M  27.2                  PRESSURE CHANNEL 1 (UP.EXTR.) <= 15 BAR
M   27.3 = M  27.3                  PRESSURE CHANNEL 2 (BOT.EXTR.) <= 15 BAR

DB 170   = DB 170                   ACTUAL DATAS

NETZWERK 3          0017       MAX. PRESSURE
0017       :AWL                                ###### TOPMACHINE ###############
0018       :A    DB 180     -DB 180            DB PROFILE
0019       :L    DD  34                        WARNING PRESSURE CH. 1 (TOPM)
001A       :A    DB 170     -DB 170            DB ACTUAL DATA
001B       :L    DD 172                        ACTUAL VALUE PRESSURE CHANNEL 1
001C       :<=G                                IF ACTUAL VALUE <= WARNING PR.
001D       :=    M  185.6   -M0299             WARNING
001E       :
001F       :A    DB 180     -DB 180            DB PROFILE
0020       :L    DD  36                        MAX PRESSURE CHANNEL 1
0021       :A    DB 170     -DB 170            DB ACTUAL DATA
0022       :L    DD 172                        ACTUAL VALUE PRESSURE CHANNEL 1
0023       :<=G                                IF ACTUAL VALUE >= MAX PRESSURE
0024       :=    M   27.5   -M  27.5           ---> EXTRUDER TOPM OFF
0025       :S    M  185.4   -M0297             MAX. PRESSURE EXCEEDED CHANNEL 1
0026       :U    E   84.3   -205S3.2
0027       :R    M  185.4   -M0297
0028       :
0029       :A    DB 180     -DB 180            ###### BOTTOMMACHINE ##########
002A       :L    DD  42                        DB PROFILE
002B       :A    DB 170     -DB 170            WARNING PRESSURE CH. 2 (BOTM)
002C       :L    DD 174                        DB ACTUAL DATA
002D       :<=G                                ACTUAL VALUE PRESSURE CHANNEL 2
002E       :=    M  185.7   -M0300             IF ACTUAL VALUE >= WARNING PR.
002F       :                                   WARNING
0030       :A    DB 180     -DB 180
0031       :L    DD  44                        DB PROFILE
0032       :A    DB 170     -DB 170            MAX PRESSURE CHANNEL 2
0033       :L    DD 174                        DB ACTUAL DATA
0034       :<=G                                ACTUAL VALUE PRESSURE CHANNEL 2
0035       :=    M   27.7   -M  27.7           IF ACTUAL VALUE >= MAX PRESSURE
0036       :S    M  185.5   -M0298             ---> EXTRUDER BOTM OFF
0037       :U    E   84.3   -205S3.2           MAX. PRESSURE EXCEEDED CHANNEL 2
0038       :R    M  185.5   -M0298
0039       :***

M  185.6 = M0299                    WARNING EXTRUSION PRESSURE CH1        DEH
M   27.5 = M  27.5                  PRESSURE CHANNEL 1 >= MAX PRESSURE
M  185.4 = M0297                    MAX EXTRUSION PRESS. EXCEEDED  CH1    DEH
```

KRUPP KUNSTOFFTECHNIK ELASTOMERTECHNIK	WERK HARBURG	MASTERPROGRAMM	
PROJECT : KERMAN TIRE		DATE :	
INSTALLATION : TREAD-LINE		MODIFICATION:	PGNO
PROJECT POS. NO.: 84/823804		PROGRAMMER :	1

```
FB 23   -FB  23                          C:KERM06ST.S5D        BIB=4112    LAE=91

E   84.3 = 205S3.2                       ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
M  185.7 = M0300                         WARNING EXTRUSION PRESSURE CH2        DEH
M   27.7 = M  27.7                       PRESSURE CHANNEL 2 >= MAX PRESSURE
M  185.5 = M0298                         MAX EXTRUSION PRESS. EXCEEDED  CH2    DEH

DB 180    = DB 180                       PROFILE AG
DB 170    = DB 170                       ACTUAL DATAS

NETZWERK 4          003A      PRESSURE DIFFERENCE
003A       :AWL                                  ###### TOPMACHINE ##############
003B       :A    DB 170     -DB 170              DB ACTUAL DATA
003C       :L    DD 172                          PRESSURE CHANNEL 1 (TOPM)
003D       :L    DD 174                          PRESSURE CHANNEL 2 (BOTM)
003E       :-G                                   DIFFERENCE : TOPM - BOTM
003F       :L    KG +1500000+03                  MAX PRESSURE DIFFERENCE
0042       :>=G                                  IF DIFFERENCE >= MAX PR.DIFF.
0043       :=    M   29.6   -M  29.6             ---> EXTRUDER TOPM OFF
0044       :S    M  179.5   -M0250
0045       :U    E   84.3   -205S3.2
0046       :R    M  179.5   -M0250
0047       :
0048       :A    DB 170     -DB 170              ####### BOTTOMMACHINE ##########
0049       :L    DD 174                          DB ANALOG INPUT
004A       :L    DD 172                          PRESSURE CHANNEL 2 (BOTM)
004B       :-G                                   PRESSURE CHANNEL 1 (TOPM)
004C       :L    KG +1500000+03                  DIFFERENCE : BOTM - TOPM
004F       :>=G                                  MAX PRESSURE DIFFERENCE
0050       :=    M   29.7   -M  29.7             IF DIFFERENCE >= MAX PR.DIFF.
0051       :S    M  179.6   -M0251               ---> EXTRUDER BOTM OFF
0052       :U    E   84.3   -205S3.2
0053       :R    M  179.6   -M0251
0054       :***

M   29.6 = M  29.6                       PRESS.DIFF.EXCEEDED : UPPER EXTR. OFF
M  179.5 = M0250                         PRESSURE DIFFERENCE BOTTOM EXTRUDER OFF
E   84.3 = 205S3.2                       ACKNOWLEDGING FAULT    (MAIN CONTR.PAN.)
M   29.7 = M  29.7                       PRESS.DIFF.EXCEEDED : BOTTOM EXTR. OFF
M  179.6 = M0251                         PRESSURE DIFFERENCE UPPER EXTRUDER OFF

DB 170    = DB 170                       ACTUAL DATAS

NETZWERK 5          0055
0055       :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                              FAULT MATERIAL LOOP                            *
*                                                                             *
*******************************************************************************
NAME :LOOP-FAU
BEZ  :DBAE       E/A/D/B/T/Z: B
BEZ  :IW-L       E/A/D/B/T/Z: E  BI/BY/W/D: D
BEZ  :MAX        E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :MIN        E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :MARK       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :T-NR       E/A/D/B/T/Z: T
BEZ  :ST-M       E/A/D/B/T/Z: A  BI/BY/W/D: BI

001A       :AWL
001B       :B    =DBAE                        CALL DB ANALOG INPUT
001C       :L    =IW-L                        ACTUAL DATA LOOP
001D       :LD   =MAX                         MAX VALUE LOOP
001E       :>=G
001F       :=    =MARK
0020       :SPB  =M001
0021       :
0022       :L    =IW-L                        ACTUAL DATA LOOP
0023       :LD   =MIN                         MIN VALUE LOOP
0024       :<=F
0025       :=    =MARK
0026 M001  :
0027       :U    =MARK
0028       :L    KT 060.2                     TIME 60 S
002A       :SE   =T-NR
002B       :U    =T-NR
002C       :=    =ST-M                        FAULT LOOP
002D       :BE
```

```
FB 39   -FB  39                        C:KERM06ST.S5D        BIB=14013   LAE=88

NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                      TREADS AND SCRAP FOR PRODUCTIONS REPORT              *
*                                                                           *
*****************************************************************************
NAME :P-REPORT

0005       :A   DB 185     -DB 185
0006       :U   D    1.9                          PRINT PRODUCTION REPORT
0008       :BEB
0009       :A   DB 170     -DB 170                DB ACTUAL DATA
000A       :O   E   83.4   -204S5                  SET-UP
000B       :O   M    2.5   -M   2.5                WIND-UP
000C       :SPB =M001
000D       :SPA =M002
000E M001  :L   KF +0
0010       :T   DW 110                            TREAD CHECKER OK
0011       :T   DW 111                            TREAD CHECKER SCRAP
0012       :T   DW 112                            LENGTH MEASURING OK
0013       :T   DW 113                            LENGTH MEASURING SCRAP
0014       :T   DW 114                            NUMBER OF TREADS TOTAL
0015       :T   DW 115                            NUMBER OF TREADS ACCEPTED
0016       :T   DW 116                            NUMBER OF TREADS SCRAP
0017       :L   KG +0000000+00
001A       :T   DD 117                            NUMBER OF TREADS SCRAP %
001B       :U   M    2.5   -M   2.5
001C       :SPB =M003
001D       :BEA
001E M002  :
001F       :L   DW 114                            TREADS TOTAL
0020       :L   KF +0
0022       :<=F
0023       :SPB =M003
0024       :L   DW 114                            TREADS TOTAL
0025       :L   DW 116                            SCRAP TOTAL
0026       :-F
0027       :T   DW 115                            TREADS ACCEPTED
0028       :L   DW 116                            SCRAP TOTAL
0029       :FDG                                   FP ---> GP
002A       :T   MD 200                            SCRAP TOTAL GP
002B       :L   DW 114                            TREADS TOTAL
002C       :FDG                                   FP ---> GP
002D       :T   MD 204                            TREADS TOTAL GP
002E       :L   MD 200                            SCRAP TOTAL
002F       :L   KG +1000000+03                    100%
0032       :XG
0033       :L   MD 204                            TREADS TOTAL GP
0034       ::G                                    = SCRAP * 100% / TREADS TOTAL
0035       :T   DD 117                            SCRAP IN %
0036       :A   DB  21     -DB  21                RECEIVED DATAS FROM 115U
0037       :L   DW  11                            SCRAP LMD COUNTER 2 (900)
0038       :L   KF +900
003A       :XF
003B       :L   DW  10                            SCRAP LMD COUNTER 1 (0 - 899)
003C       :+F
003D       :A   DB 170     -DB 170
003E       :T   DW 127                            SCRAP FROM LENGTH MEAS. DEVICE
003F M003  :A   DB  21     -DB  21                RECEIVED DATAS FROM 115U
0040       :L   DW   7                            COUNTER FOR 5m
0041       :FDG
0042       :L   KG +5000000+01                    5m
0045       :XG                                    = COUNTER * 5m
0046       :T   MD 224
0047       :L   DW   8                            IMPULSE
0048       :FDG
0049       :L   KG +4000000+01                    IMPULSE/mm
004C       ::G                                    = 0.0  - 4.99 m
004D       :L   MD 224                            COUNTER * 5m
004E       :+G                                    = SUM WIND-UP IN METER
004F       :A   DB 170     -DB 170
0050       :T   DD 108
0051       :***
+---------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                   !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                    !
+---------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE         :                   !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER   :                  1!
+---------------------------------------------------------------------------+
```

```
FB 39   -FB  39                          C:KERM06ST.S5D        BIB=14013   LAE=88

E   83.4 = 204S5                         RESET PRODUCT. REPORT  (MAIN CONTR.PAN.)
M    2.5 = M   2.5                       WIND-UP

DB 185   = DB 185                        PROFILE MANAGEMENT
DB 170   = DB 170                        ACTUAL DATAS
DB  21   = DB  21                        RECEIVE DATAS FROM SLAVE-No1 (115U)

NETZWERK 2          0052
0052       :BE
```

```
FB 43    -FB  43                        C:KERM06ST.S5D        BIB=12106    LAE=41

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                              ANALOG INPUT  4 - 20 mA                        *
*                                                                             *
*******************************************************************************


NAME :AE:4-20P
BEZ  :PERE       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :DWNR       E/A/D/B/T/Z: A  BI/BY/W/D: D
BEZ  :EINH       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :DBNR       E/A/D/B/T/Z: B

0011      :***

NETZWERK 2          0012
0012      :LW   =PERE
0013      :T    MW 200
0014      :B    =DBNR
0015      :B    MW 200
0016      :L    PW   0
0017      :SVW       3
0018      :ADD  KF -512
001A      :SPA  OB 220
001B      :FDG
001C      :LD   =EINH
001D      :XG
001E      :L    KG +2048000+04
0021      ::G
0022      :T    =DWNR
0023      :BE
```

```
FB 44    -FB  44                        C:KERM06ST.S5D        BIB=11022    LAE=64

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                   ANALOG OUTPUT                             *
*                                                                             *
*******************************************************************************
NAME :KF-AA
BEZ  :PERE       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :SOLL       E/A/D/B/T/Z: E  BI/BY/W/D: D
BEZ  :EINH       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :INVE       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :FREI       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :DBNR       E/A/D/B/T/Z: B

0017      :***

NETZWERK 2          0018      WERT NORMIEREN UND AUSGEBEN
0018      :LW  =PERE
0019      :T   MW 200
001A      :B   =DBNR
001B      :L   =SOLL
001C      :U   =FREI
001D      :SPB =M001
001E      :L   KF +0
0020 M001 :
0021      :LD  =EINH
0022      ::G
0023      :L   KG +1024000+04
0026      :XG
0027      :T   MD 202
0028      :L   KG +1024000+04
002B      :<=G
002C      :L   MD 202
002D      :SPB =M002
002E      :L   KG +1024000+04
0031 M002 :
0032      :GFD
0033      :UN  =INVE
0034      :SPB =M003
0035      :KZW
0036 M003 :
0037      :SLW      4
0038      :B   MW 200
0039      :T   PW   0
003A      :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                              ANALOG INPUT  0 - 10 V                         *
*                                                                             *
*******************************************************************************


NAME :AE:0-10V
BEZ  :PERE       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :DWNR       E/A/D/B/T/Z: A  BI/BY/W/D: D
BEZ  :EINH       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :DBNR       E/A/D/B/T/Z: B

0011      :***

NETZWERK 2          0012
0012      :LW   =PERE
0013      :T    MW 200
0014      :***


NETZWERK 3          0015
0015      :B    =DBNR
0016      :B    MW 200
0017      :L    PW   0
0018      :SVW       3
0019      :SPA OB 220
001A      :FDG
001B      :LD   =EINH
001C      :XG
001D      :L    KG +2048000+04
0020      ::G
0021      :T    =DWNR
0022      :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  ANALOG OUTPUT                              *
*                                                                             *
*******************************************************************************
NAME :KF-AA(Q)
BEZ  :PERE       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :SOLL       E/A/D/B/T/Z: E  BI/BY/W/D: D
BEZ  :EINH       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :INVE       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :FREI       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :DBNR       E/A/D/B/T/Z: B

0017      :***

NETZWERK 2          0018      WERT NORMIEREN UND AUSGEBEN
0018      :LW   =PERE
0019      :T    MW 200
001A      :B    =DBNR
001B      :L    =SOLL
001C      :U    =FREI
001D      :SPB  =M001
001E      :L    KF +0
0020 M001 :
0021      :LD   =EINH
0022      ::G
0023      :L    KG +1024000+04
0026      :XG
0027      :T    MD 202
0028      :L    KG +1024000+04
002B      :<=G
002C      :L    MD 202
002D      :SPB  =M002
002E      :L    KG +1024000+04
0031 M002 :
0032      :GFD
0033      :UN   =INVE
0034      :SPB  =M003
0035      :KZW
0036 M003 :
0037      :SLW      4
0038      :B    MW 200
0039      :T    QW   0
003A      :BE
```

```
FB 48   -FB  48                    C:KERM06ST.S5D        BIB=18112   LAE=42

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                      CALCULATE VALUE FOR ANALOG DISPLAY                     *
*                                                                             *
*******************************************************************************
NAME :DISP-10V
BEZ  :DBNR       E/A/D/B/T/Z: B
BEZ  :IN         E/A/D/B/T/Z: E  BI/BY/W/D: D
BEZ  :OUT        E/A/D/B/T/Z: E  BI/BY/W/D: D
BEZ  :RANG       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :RESE       E/A/D/B/T/Z: E  BI/BY/W/D: BI

0014       :B   =DBNR
0015       :UN  =RESE
0016       :SPB =M001
0017       :L   =IN
0018       :L   KG +1000000+02
001B       :XG
001C       :LD  =RANG
001D       ::G
001E       :T   =OUT
001F       :BEA
0020 M001  :L   KG +0000000+00
0023       :T   =OUT
0024       :BE
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                          MOVE FLAG-BYTE TO DATA-BYTE                      *
*                                                                           *
*****************************************************************************
NAME :MB--->DB
BEZ  :DBNR      E/A/D/B/T/Z: B
BEZ  :BIT0      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :BIT1      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :BIT2      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :BIT3      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :BIT4      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :BIT5      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :BIT6      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :BIT7      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :DW        E/A/D/B/T/Z: A  BI/BY/W/D: BY

0023      :AWL
0024      :B   =DBNR                          DATENBAUSTEIN-NR.
0025      :U   =BIT0                          MELDETABELLE BIT 0
0026      :=   M  240.0                       HILFSMERKER HM 0
0027      :U   =BIT1                          MELDETABELLE BIT 1
0028      :=   M  240.1                       HM 1
0029      :U   =BIT2                          MELDETABELLE BIT 2
002A      :=   M  240.2                       HM 2
002B      :U   =BIT3                          MELDETABELLE BIT 3
002C      :=   M  240.3                       HM 3
002D      :U   =BIT4                          MELDETABELLE BIT 4
002E      :=   M  240.4                       HM 4
002F      :U   =BIT5                          MELDETABELLE BIT 5
0030      :=   M  240.5                       HM 5
0031      :U   =BIT6                          MELDETABELLE BIT 6
0032      :=   M  240.6                       HM 6
0033      :U   =BIT7                          MELDETABELLE BIT 7
0034      :=   M  240.7                       HM 7
0035      :L   MB 240                         LADE HILFSMERBERBYTE
0036      :T   =DW                            TRANSFERIERE AUF DA-
0037      :BE                                 TENBYTE LINKS/RECHTS
```

NETZWERK 1 0000

```
**********************************************************************************
*                                                                                *
*                          MOVE DATA-BYTE TO FLAG-BYTE                           *
*                                                                                *
**********************************************************************************
NAME :DB--->MB
BEZ  :DB      E/A/D/B/T/Z: B
BEZ  :BIT0    E/A/D/B/T/Z: A  BI/BY/W/D: BI
BEZ  :BIT1    E/A/D/B/T/Z: A  BI/BY/W/D: BI
BEZ  :BIT2    E/A/D/B/T/Z: A  BI/BY/W/D: BI
BEZ  :BIT3    E/A/D/B/T/Z: A  BI/BY/W/D: BI
BEZ  :BIT4    E/A/D/B/T/Z: A  BI/BY/W/D: BI
BEZ  :BIT5    E/A/D/B/T/Z: A  BI/BY/W/D: BI
BEZ  :BIT6    E/A/D/B/T/Z: A  BI/BY/W/D: BI
BEZ  :BIT7    E/A/D/B/T/Z: A  BI/BY/W/D: BI
BEZ  :DW      E/A/D/B/T/Z: E  BI/BY/W/D: BY

0023      :AWL
0024      :B   =DB
0025      :L   =DW
0026      :T   MB 240
0027      :U   M  240.0
0028      :=   =BIT0
0029      :U   M  240.1
002A      :=   =BIT1
002B      :U   M  240.2
002C      :=   =BIT2
002D      :U   M  240.3
002E      :=   =BIT3
002F      :U   M  240.4
0030      :=   =BIT4
0031      :U   M  240.5
0032      :=   =BIT5
0033      :U   M  240.6
0034      :=   =BIT6
0035      :U   M  240.7
0036      :=   =BIT7
0037      :BE
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                CONTROL MIN. TEMPERATURES FROM PROFILE MANAGEMENT          *
*                        AND WRITE TO DB170 (ACTUAL DATAS)                  *
*                                                                           *
*****************************************************************************
NAME :GTR-9000

0005      :A   DB 180    -DB 180          #### EXTRUDER BOTTOMMACHINE ####
0006      :L   DW  78                     PRESET TEMP. SCREW
0007      :A   DB  40    -DB  40
0008      :L   DW  38
0009      :!=F                            YES >> TEMP. IN GTR
000A      :=   M  200.0
000B      :A   DB 180    -DB 180
000C      :L   DW  80                     PRESET TEMP. BARREL
000D      :A   DB  41    -DB  41
000E      :L   DW  38
000F      :!=F                            YES >> TEMP. IN GTR
0010      :=   M  200.1
0011      :A   DB  40    -DB  40
0012      :L   DW  40                     ACTUAL TEMP. SCREW
0013      :A   DB 170    -DB 170
0014      :T   DW  78
0015      :A   DB 180    -DB 180
0016      :L   DW  79                     MIN TEMP. SCREW
0017      :>=F
0018      :=   M  200.2                   YES >> RELEASE MIN TEMP.
0019      :A   DB  41    -DB  41
001A      :L   DW  40                     ACTUAL TEMP. BARREL
001B      :A   DB 170    -DB 170
001C      :T   DW  80
001D      :A   DB 180    -DB 180
001E      :L   DW  81                     MIN TEMP. BARREL
001F      :>=F                            YES >> RELEASE MIN TEMP.
0020      :=   M  200.3
0021      :U   M  200.0
0022      :U   M  200.1
0023      :U   M  200.2
0024      :U   M  200.3
0025      :=   M   55.1  -M  55.1         RELEASE EXTRUDER BM.
0026      :A   DB 180    -DB 180          #### EXTRUDER TOPMACHINE #######
0027      :L   DW  74                     PRESET TEMP. SCREW
0028      :A   DB  42    -DB  42
0029      :L   DW  38
002A      :!=F                            YES >> TEMP. IN GTR-9000
002B      :=   M  200.4
002C      :A   DB 180    -DB 180
002D      :L   DW  76                     PRESET TEMP. BARREL
002E      :A   DB  43    -DB  43
002F      :L   DW  38
0030      :!=F                            YES >> TEMP. IN GTR-9000
0031      :=   M  200.5
0032      :A   DB  42    -DB  42
0033      :L   DW  40                     ACTUAL TEMP. SCREW
0034      :A   DB 170    -DB 170
0035      :T   DW  74
0036      :A   DB 180    -DB 180
0037      :L   DW  75                     MIN TEMP. SCREW
0038      :>=F                            YES >> RELEASE MIN TEMP.
0039      :=   M  200.6
003A      :A   DB  43    -DB  43
003B      :L   DW  40                     ACTUAL TEMP. BARREL
003C      :A   DB 170    -DB 170
003D      :T   DW  76
003E      :A   DB 180    -DB 180
003F      :L   DW  77                     MIN TEMP. BARREL
0040      :>=F                            YES >> RELEASE MIN TEMP.
0041      :=   M  200.7
0042      :U   M  200.4
0043      :U   M  200.5
0044      :U   M  200.6
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                    !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                    !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE        :                     !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER  :                     1!
+-----------------------------------------------------------------------------+
```

```
0045      :U   M  200.7
0046      :=   M   55.0  -M  55.0          RELEASE EXTRUDER TOPMACHINE
0047      :A   DB 180    -DB 180           #### EXTRUDER 3 ################
0048      :L   DW  82                      PRESET TEMP. HEAD
0049      :A   DB  54    -DB  54
004A      :L   DW  38
004B      :!=F                            YES >> TEMP. IN GTR-9000
004C      :=   M  201.0
004D      :A   DB 180    -DB 180
004E      :L   DW  86                      PRESET TEMP. BARREL/PIN
004F      :A   DB  53    -DB  53
0050      :L   DW  38
0051      :!=F                            YES >> TEMP. IN GTR-9000
0052      :=   M  201.1
0053      :A   DB 180    -DB 180
0054      :L   DW  84                      PRESET TEMP. SCREW
0055      :A   DB  52    -DB  52
0056      :L   DW  38
0057      :!=F
0058      :=   M  201.2                   YES >> TEMP. IN GTR-9000
0059      :A   DB  54    -DB  54
005A      :L   DW  40                      ACTUAL TEMP. HEAD
005B      :A   DB 170    -DB 170
005C      :T   DW  82
005D      :A   DB 180    -DB 180
005E      :L   DW  83                      MIN TEMP. HEAD
005F      :>=F                            YES >> RELEASE MIN TEMP.
0060      :=   M  201.3
0061      :A   DB  53    -DB  53
0062      :L   DW  40                      ACTUAL TEMP. BARREL/PIN
0063      :A   DB 170    -DB 170
0064      :T   DW  86
0065      :A   DB 180    -DB 180
0066      :L   DW  87                      MIN TEMP. BARREL/PIN
0067      :>=F                            YES >> RELEASE MIN TEMP.
0068      :=   M  201.4
0069      :A   DB  52    -DB  52
006A      :L   DW  40                      ACTUAL TEMP. SCREW
006B      :A   DB 170    -DB 170
006C      :T   DW  84
006D      :A   DB 180    -DB 180
006E      :L   DW  85                      MIN TEMP. SCREW
006F      :>=F
0070      :=   M  201.5
0071      :U   M  201.0
0072      :U   M  201.1
0073      :U   M  201.2
0074      :U   M  201.3
0075      :U   M  201.4
0076      :U   M  201.5
0077      :=   M   55.2  -M  55.2          RELEASE EXTRUDER 3
0078      :A   DB 180    -DB 180           #### CALANDER ##################
0079      :L   DW  96                      PRESET TEMP. ROLL TOP
007A      :A   DB  50    -DB  50
007B      :L   DW  38
007C      :!=F                            YES >> TEMP. IN GTR-9000
007D      :=   M  202.0
007E      :A   DB 180    -DB 180
007F      :L   DW  98                      PRESET TEMP. ROLL BOTTOM
0080      :A   DB  51    -DB  51
0081      :L   DW  38
0082      :!=F                            YES >> TEMP. IN GTR-9000
0083      :=   M  202.1
0084      :A   DB  50    -DB  50
0085      :L   DW  40                      ACTUAL TEMP. ROLL TOP
0086      :A   DB 170    -DB 170
0087      :T   DW  96
0088      :A   DB 180    -DB 180
0089      :L   DW  97                      MIN TEMP. ROLL TOP
008A      :>=F                            YES >> RELEASE MIN TEMP.
008B      :=   M  202.2
008C      :A   DB  51    -DB  51
008D      :L   DW  40                      ACTUAL TEMP. ROLL BOTTOM
008E      :A   DB 170    -DB 170
```

```
008F      :T   DW  98
0090      :A   DB 180    -DB 180
0091      :L   DW  99                    MIN TEMP. ROLL BOTTOM
0092      :>=F                           YES >> RELEASE MIN TEMP.
0093      :=   M  202.3
0094      :U   M  202.0
0095      :U   M  202.1
0096      :U   M  202.2
0097      :U   M  202.3
0098      :=   M   55.3  -M  55.3        RELEASE CALANDER
0099      :A   DB 180    -DB 180         #### EXTRUSION HEAD ############
009A      :L   DW  90                    PRESET TEMP. MIDDLE PART
009B      :A   DB  48    -DB  48
009C      :L   DW  38
009D      :!=F                           YES >> TEMP. IN GTR-9000
009E      :=   M  202.4
009F      :A   DB 180    -DB 180
00A0      :L   DW  88                    PRESET TEMP. UPPER PART
00A1      :A   DB  49    -DB  49
00A2      :L   DW  38
00A3      :!=F                           YES >> TEMP. IN GTR-9000
00A4      :=   M  202.5
00A5      :A   DB  48    -DB  48
00A6      :L   DW  40                    ACTUAL TEMP. MIDDLE PART
00A7      :A   DB 170    -DB 170
00A8      :T   DW  90
00A9      :A   DB 180    -DB 180
00AA      :L   DW  91                    MIN TEMP. MIDDLE PART
00AB      :>=F                           YES >> RELEASE MIN TEMP.
00AC      :=   M  202.6
00AD      :A   DB  49    -DB  49
00AE      :L   DW  40                    ACTUAL TEMP. UPPER PART
00AF      :A   DB 170    -DB 170
00B0      :T   DW  88
00B1      :A   DB 180    -DB 180
00B2      :L   DW  89                    MIN TEMP. UPPER PART
00B3      :>=F                           YES >> RELEASE MIN TEMP.
00B4      :=   M  202.7
00B5      :U   M  202.4
00B6      :U   M  202.5
00B7      :U   M  202.6
00B8      :U   M  202.7
00B9      :=   M   55.4  -M  55.4        RELEASE EXTRUSION HEAD
00BA      :A   DB  46    -DB  46
00BB      :L   DW  40                    ACTUAL TEMP. PREHEATING TABLE
00BC      :A   DB 170    -DB 170
00BD      :T   DW 104
00BE      :A   DB  44    -DB  44
00BF      :L   DW  40                    ACTUAL TEMP. CASSETTE LEFT
00C0      :A   DB 170    -DB 170
00C1      :T   DW  92
00C2      :A   DB  45    -DB  45
00C3      :L   DW  40                    ACTUAL TEMP. CASSETTE RIGHT
00C4      :A   DB 170    -DB 170
00C5      :T   DW  94
00C6      :***
```

```
M   55.1 = M  55.1      RELEASE BOTTOM EXTR. FROM HEATING DEVICE
M   55.0 = M  55.0      RELEASE UPPER EXTR. FROM HEATING DEVICE
M   55.2 = M  55.2      RELEASE EXTR.CAL. FROM HEATING DEVICE
M   55.3 = M  55.3      RELEASE CALENDER FROM HEATING DEVICE
M   55.4 = M  55.4      RELEASE DEH FROM HEATING EQUIPMENT

DB 180   = DB 180      PROFILE AG
DB  40   = DB  40      RECEIVE FROM GTR-9000 CICLE No. 1
DB  41   = DB  41      RECEIVE FROM GTR-9000 CICLE No. 2
DB 170   = DB 170      ACTUAL DATAS
DB  42   = DB  42      RECEIVE FROM GTR-9000 CICLE No. 3
DB  43   = DB  43      RECEIVE FROM GTR-9000 CICLE No. 4
DB  54   = DB  54      RECEIVE FROM GTR-9000 CICLE No. 15
DB  53   = DB  53      RECEIVE FROM GTR-9000 CICLE No. 14
```

```
DB  52   = DB  52     RECEIVE FROM GTR-9000 CICLE No. 13
DB  50   = DB  50     RECEIVE FROM GTR-9000 CICLE No. 11
DB  51   = DB  51     RECEIVE FROM GTR-9000 CICLE No. 12
DB  48   = DB  48     RECEIVE FROM GTR-9000 CICLE No. 9
DB  49   = DB  49     RECEIVE FROM GTR-9000 CICLE No. 10
DB  46   = DB  46     RECEIVE FROM GTR-9000 CICLE No. 7
DB  44   = DB  44     RECEIVE FROM GTR-9000 CICLE No. 5
DB  45   = DB  45     RECEIVE FROM GTR-9000 CICLE No. 6

NETZWERK 2          00C7
00C7      :BE
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                          TRANSFER TEMPERATURES DATAS                      *
*                                                                           *
*****************************************************************************
```

TRANSFER PERSET TEMPERATURE DATAS FROM DB180 (PROFILE ON AG) TO PARAMETER DB60-75 (SEND BLOCKS TO GTR9000).

NAME :PARAM.DB TRANSFER DATAS FROM DB180

```
0005      :A   DB 180    -DB 180          BOTTOMMACHINE SCREW
0006      :L   DW  78
0007      :A   DB  60    -DB  60
0008      :T   DW  38
0009      :A   DB 180    -DB 180          BOTTOMMACHINE BARREL
000A      :L   DW  80
000B      :A   DB  61    -DB  61
000C      :T   DW  38
000D      :A   DB 180    -DB 180          TOPMACHINE SCREW
000E      :L   DW  74
000F      :A   DB  62    -DB  62
0010      :T   DW  38
0011      :A   DB 180    -DB 180          TOPMACHINE BARREL
0012      :L   DW  76
0013      :A   DB  63    -DB  63
0014      :T   DW  38
0015      :A   DB 180    -DB 180          CASSETTE LEFT
0016      :L   DW  92
0017      :A   DB  64    -DB  64
0018      :T   DW  38
0019      :A   DB 180    -DB 180          CASSETTE RIGHT
001A      :L   DW  94
001B      :A   DB  65    -DB  65
001C      :T   DW  38
001D      :A   DB 180    -DB 180          PREHEATING TABLE
001E      :L   DW 104
001F      :A   DB  66    -DB  66
0020      :T   DW  38
0021      :A   DB 180    -DB 180          SPARE
0022      :L   KF +20
0024      :A   DB  67    -DB  67
0025      :T   DW  38
0026      :A   DB 180    -DB 180          HEAD MIDDLE PART
0027      :L   DW  90
0028      :A   DB  68    -DB  68
0029      :T   DW  38
002A      :A   DB 180    -DB 180          HEAD UPPER PART
002B      :L   DW  88
002C      :A   DB  69    -DB  69
002D      :T   DW  38
002E      :A   DB 180    -DB 180          CALANDER ROLL TOP
002F      :L   DW  96
0030      :A   DB  70    -DB  70
0031      :T   DW  38
0032      :A   DB 180    -DB 180          CALANDER ROLL BOTTOM
0033      :L   DW  98
0034      :A   DB  71    -DB  71
0035      :T   DW  38
0036      :A   DB 180    -DB 180          EXTRUDER 3 SCREW
0037      :L   DW  84
0038      :A   DB  72    -DB  72
0039      :T   DW  38
003A      :A   DB 180    -DB 180          EXTRUDER 3 BARREL/PIN
003B      :L   DW  86
003C      :A   DB  73    -DB  73
003D      :T   DW  38
003E      :A   DB 180    -DB 180          EXTRUDER 3 HEAD
003F      :L   DW  82
0040      :A   DB  74    -DB  74
0041      :T   DW  38
0042      :BE
```

DB 180	= DB 180	PROFILE AG
DB 60	= DB 60	SEND BLOCK TO GTR-9000 CICLE No. 1
DB 61	= DB 61	SEND BLOCK TO GTR-9000 CICLE No. 2
DB 62	= DB 62	SEND BLOCK TO GTR-9000 CICLE No. 3
DB 63	= DB 63	SEND BLOCK TO GTR-9000 CICLE No. 4
DB 64	= DB 64	SEND BLOCK TO GTR-9000 CICLE No. 5
DB 65	= DB 65	SEND BLOCK TO GTR-9000 CICLE No. 6
DB 66	= DB 66	SEND BLOCK TO GTR-9000 CICLE No. 7
DB 67	= DB 67	SEND BLOCK TO GTR-9000 CICLE No. 8
DB 68	= DB 68	SEND BLOCK TO GTR-9000 CICLE No. 9
DB 69	= DB 69	SEND BLOCK TO GTR-9000 CICLE No. 10
DB 70	= DB 70	SEND BLOCK TO GTR-9000 CICLE No. 11
DB 71	= DB 71	SEND BLOCK TO GTR-9000 CICLE No. 12
DB 72	= DB 72	SEND BLOCK TO GTR-9000 CICLE No. 13
DB 73	= DB 73	SEND BLOCK TO GTR-9000 CICLE No. 14
DB 74	= DB 74	SEND BLOCK TO GTR-9000 CICLE No. 15

```
FB 54   -FB  54                          C:KERM06ST.S5D        BIB=8033    LAE=469

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                SEND BLOCKS TO GTR-9000                      *
*                                                                             *
*******************************************************************************
NAME :BLOCK-S.

0005      :***

NETZWERK 2          0006      RESET COUNTER FOR GTR-9000
0006      :U   M    0.4  -M   0.4
0007      :ZV  Z    16   -Z  16
0008      :***

M    0.4 = M   0.4                    TACT 1 HZ
Z   16   = Z  16                      SEND/READ PARAMETERS GTR-9000

NETZWERK 3          0009      CICLE No. 1,2,3,4
0009      :L   Z   16    -Z  16
000A      :L   KF +1
000C      :!=F
000D      :=   M   30.0  -M  30.0
000E      :SPB =M001                          >> CICLE No. 1
000F      :SPA =M002
0010 M001 :U   M   30.0  -M  30.0
0011      :UN  M   30.1  -M  30.1
0012      :=   M   30.2  -M  30.2
0013      :U   M   30.0  -M  30.0
0014      :=   M   30.1  -M  30.1
0015      :SPA FB 148    -FB 148
0016 NAME :BLOCKSEN
0017 QUDB :    DB  60    -DB  60              CICLE No.1
0018 RUN  :    M   30.2  -M  30.2
0019 FAIL :    M   30.3  -M  30.3
001A TIME :    T  170    -T 170
001B      :BEA
001C      :
001D M002 :U   M    0.0  -M   0.0
001E      :=   M   30.1  -M  30.1              RESET HF-IMPULSE
001F      :L   Z   16    -Z  16
0020      :L   KF +3
0022      :!=F
0023      :=   M   30.4  -M  30.4
0024      :SPB =M003                          >> CICLE No.2
0025      :SPA =M004
0026 M003 :U   M   30.4  -M  30.4
0027      :UN  M   30.5  -M  30.5
0028      :=   M   30.6  -M  30.6
0029      :U   M   30.4  -M  30.4
002A      :=   M   30.5  -M  30.5
002B      :SPA FB 148    -FB 148
002C NAME :BLOCKSEN
002D QUDB :    DB  61    -DB  61              CICLE No.2
002E RUN  :    M   30.6  -M  30.6
002F FAIL :    M   30.7  -M  30.7
0030 TIME :    T  171    -T 171
0031      :BEA
0032      :
0033 M004 :U   M    0.0  -M   0.0
0034      :=   M   30.5  -M  30.5              RESET HF-IMPULSE
0035      :L   Z   16    -Z  16
0036      :L   KF +5
0038      :!=F
0039      :=   M   31.0  -M  31.0
003A      :SPB =M005                          >> CICLE No.3
003B      :SPA =M006
003C M005 :U   M   31.0  -M  31.0
003D      :UN  M   31.1  -M  31.1
003E      :=   M   31.2  -M  31.2
003F      :U   M   31.0  -M  31.0
0040      :=   M   31.1  -M  31.1
0041      :SPA FB 148    -FB 148
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE         ! DATE         :                      !
! INSTALLATION     : TREAD-LINE          ! MODIFICATION:                  PGNO! 
! PROJECT POS. NO.: 84/823804            ! PROGRAMMER   :                    1!
+-------------------------------------------------------------------------------+
```

```
0042 NAME :BLOCKSEN
0043 QUDB :    DB  62    -DB  62          CICLE No.2
0044 RUN  :    M   31.2  -M  31.2
0045 FAIL :    M   31.3  -M  31.3
0046 TIME :    T  172    -T 172
0047      :BEA
0048      :
0049 M006 :U   M    0.0  -M   0.0
004A      :=   M   31.1  -M  31.1          RESET HF-IMPULSE
004B      :L   Z   16    -Z  16
004C      :L   KF +7
004E      :!=F
004F      :=   M   31.4  -M  31.4
0050      :SPB =M007                       >> CICLE No.4
0051      :SPA =M008
0052 M007 :U   M   31.4  -M  31.4
0053      :UN  M   31.5  -M  31.5
0054      :=   M   31.6  -M  31.6
0055      :U   M   31.4  -M  31.4
0056      :=   M   31.5  -M  31.5
0057      :SPA FB 148    -FB 148
0058 NAME :BLOCKSEN
0059 QUDB :    DB  63    -DB  63          CICLE No.4
005A RUN  :    M   31.6  -M  31.6
005B FAIL :    M   31.7  -M  31.7
005C TIME :    T  173    -T 173
005D      :BEA
005E M008 :
005F      :U   M    0.0  -M   0.0
0060      :=   M   31.5  -M  31.5          RESET HF-IMPULSE
0061      :***

Z   16   = Z  16                    SEND/READ PARAMETERS GTR-9000
M   30.0 = M  30.0                  SEND CICLE No. 1 : COUNTER
M   30.1 = M  30.1                  SEND CICLE No. 1 : HF RUN
M   30.2 = M  30.2                  SEND CICLE No. 1 : RUN
M   30.3 = M  30.3                  SEND CICLE No. 1 : FAIL
T  170   = T 170                    SEND CICLE No. 1 : TIME FAIL
M    0.0 = M   0.0                  "0"-SIGNAL
M   30.4 = M  30.4                  SEND CICLE No. 2 : COUNTER
M   30.5 = M  30.5                  SEND CICLE No. 2 : HF RUN
M   30.6 = M  30.6                  SEND CICLE No. 2 : RUN
M   30.7 = M  30.7                  SEND CICLE No. 2 : FAIL
T  171   = T 171                    SEND CICLE No. 2 : TIME FAIL
M   31.0 = M  31.0                  SEND CICLE No. 3 : COUNTER
M   31.1 = M  31.1                  SEND CICLE No. 3 : HF RUN
M   31.2 = M  31.2                  SEND CICLE No. 3 : RUN
M   31.3 = M  31.3                  SEND CICLE No. 3 : FAIL
T  172   = T 172                    SEND CICLE No. 3 : TIME FAIL
M   31.4 = M  31.4                  SEND CICLE No. 4 : COUNTER
M   31.5 = M  31.5                  SEND CICLE No. 4 : HF RUN
M   31.6 = M  31.6                  SEND CICLE No. 4 : RUN
M   31.7 = M  31.7                  SEND CICLE No. 4 : FAIL
T  173   = T 173                    SEND CICLE No. 4 : TIME FAIL

DB  60   = DB  60                   SEND BLOCK TO GTR-9000 CICLE No. 1
DB  61   = DB  61                   SEND BLOCK TO GTR-9000 CICLE No. 2
DB  62   = DB  62                   SEND BLOCK TO GTR-9000 CICLE No. 3
DB  63   = DB  63                   SEND BLOCK TO GTR-9000 CICLE No. 4

FB 148   = FB 148                   TRANSFER BLOCK TO R-9000

NETZWERK 4          0062      CICLE No. 5,6,7,8
0062      :L   Z   16    -Z  16
0063      :L   KF +9
0065      :!=F
0066      :=   M   32.0  -M  32.0
0067      :SPB =M001                       CICLE No.5
0068      :SPA =M002
0069 M001 :U   M   32.0  -M  32.0
006A      :UN  M   32.1  -M  32.1
006B      :=   M   32.2  -M  32.2
006C      :U   M   32.0  -M  32.0
006D      :=   M   32.1  -M  32.1
```

```
006E       :SPA FB 148     -FB 148
006F NAME  :BLOCKSEN
0070 QUDB  :     DB  64     -DB  64              CICLE No.5
0071 RUN   :     M   32.2   -M  32.2
0072 FAIL  :     M   32.3   -M  32.3
0073 TIME  :     T  174     -T 174
0074       :BEA
0075       :
0076 M002  :U    M    0.0   -M   0.0
0077       :=    M   32.1   -M  32.1              RESET HF-IMPULSE
0078       :L    Z   16     -Z  16
0079       :L    KF +11
007B       :!=F
007C       :=    M   32.4   -M  32.4
007D       :SPB =M003                            >> CICLE No.6
007E       :SPA =M004
007F M003  :U    M   32.4   -M  32.4
0080       :UN   M   32.5   -M  32.5
0081       :=    M   32.6   -M  32.6
0082       :U    M   32.4   -M  32.4
0083       :=    M   32.5   -M  32.5
0084       :SPA FB 148     -FB 148
0085 NAME  :BLOCKSEN
0086 QUDB  :     DB  65     -DB  65              CICLE No.6
0087 RUN   :     M   32.6   -M  32.6
0088 FAIL  :     M   32.7   -M  32.7
0089 TIME  :     T  175     -T 175
008A       :BEA
008B       :
008C M004  :U    M    0.0   -M   0.0
008D       :=    M   32.5   -M  32.5              RESET HF-IMPULSE
008E       :L    Z   16     -Z  16
008F       :L    KF +13
0091       :!=F
0092       :=    M   33.0   -M  33.0
0093       :SPB =M005                            CICLE No.7
0094       :SPA =M006
0095 M005  :U    M   33.0   -M  33.0
0096       :UN   M   33.1   -M  33.1
0097       :=    M   33.2   -M  33.2
0098       :U    M   33.0   -M  33.0
0099       :=    M   33.1   -M  33.1
009A       :SPA FB 148     -FB 148
009B NAME  :BLOCKSEN
009C QUDB  :     DB  66     -DB  66
009D RUN   :     M   33.2   -M  33.2
009E FAIL  :     M   33.3   -M  33.3
009F TIME  :     T  176     -T 176
00A0       :BEA
00A1       :
00A2 M006  :U    M    0.0   -M   0.0
00A3       :=    M   33.1   -M  33.1              RESET HF-IMPULSE
00A4       :L    Z   16     -Z  16
00A5       :L    KF +15
00A7       :!=F
00A8       :=    M   33.4   -M  33.4
00A9       :SPA =M007                            DELETE IF CICLE No.8 IS IN
00AA       :SPB =M008                            >> CICLE No.8
00AB       :SPA =M007
00AC M008  :U    M   33.4   -M  33.4
00AD       :UN   M   33.5   -M  33.5
00AE       :=    M   33.6   -M  33.6
00AF       :U    M   33.4   -M  33.4
00B0       :=    M   33.5   -M  33.5
00B1       :SPA FB 148     -FB 148
00B2 NAME  :BLOCKSEN
00B3 QUDB  :     DB  67     -DB  67              CICLE No.8
00B4 RUN   :     M   33.6   -M  33.6
00B5 FAIL  :     M   33.7   -M  33.7
00B6 TIME  :     T  177     -T 177
00B7       :BEA
00B8 M007  :
00B9       :U    M    0.0   -M   0.0
00BA       :=    M   33.5   -M  33.5              RESET HF-IMPULSE
```

```
FB 54    -FB  54                          C:KERM06ST.S5D        BIB=8033     LAE=469

00BB       :***

Z   16    = Z  16                         SEND/READ PARAMETERS GTR-9000
M   32.0  = M  32.0                       SEND CICLE No. 5 : COUNTER
M   32.1  = M  32.1                       SEND CICLE No. 5 : HF RUN
M   32.2  = M  32.2                       SEND CICLE No. 5 : RUN
M   32.3  = M  32.3                       SEND CICLE No. 5 : FAIL
T  174    = T 174                         SEND CICLE No. 5 : TIME FAIL
M    0.0  = M   0.0                       "0"-SIGNAL
M   32.4  = M  32.4                       SEND CICLE No. 6 : COUNTER
M   32.5  = M  32.5                       SEND CICLE No. 6 : HF RUN
M   32.6  = M  32.6                       SEND CICLE No. 6 : RUN
M   32.7  = M  32.7                       SEND CICLE No. 6 : FAIL
T  175    = T 175                         SEND CICLE No. 6 : TIME FAIL
M   33.0  = M  33.0                       SEND CICLE No. 7 : COUNTER
M   33.1  = M  33.1                       SEND CICLE No. 7 : HF RUN
M   33.2  = M  33.2                       SEND CICLE No. 7 : RUN
M   33.3  = M  33.3                       SEND CICLE No. 7 : FAIL
T  176    = T 176                         SEND CICLE No. 7 : TIME FAIL
M   33.4  = M  33.4                       SEND CICLE No. 8 : COUNTER
M   33.5  = M  33.5                       SEND CICLE No. 8 : HF RUN
M   33.6  = M  33.6                       SEND CICLE No. 8 : RUN
M   33.7  = M  33.7                       SEND CICLE No. 8 : FAIL
T  177    = T 177                         SEND CICLE No. 8 : TIME FAIL

DB  64    = DB  64                        SEND BLOCK TO GTR-9000 CICLE No. 5
DB  65    = DB  65                        SEND BLOCK TO GTR-9000 CICLE No. 6
DB  66    = DB  66                        SEND BLOCK TO GTR-9000 CICLE No. 7
DB  67    = DB  67                        SEND BLOCK TO GTR-9000 CICLE No. 8

FB 148    = FB 148                        TRANSFER BLOCK TO R-9000

NETZWERK 5          00BC      CICLE No. 9,10,11,12
00BC       :L   Z   16    -Z  16
00BD       :L   KF +17
00BF       :!=F
00C0       :=   M   34.0  -M  34.0
00C1       :SPB =M001                              >> CICLE No.9
00C2       :SPA =M002
00C3 M001  :U   M   34.0  -M  34.0
00C4       :UN  M   34.1  -M  34.1
00C5       :=   M   34.2  -M  34.2
00C6       :U   M   34.0  -M  34.0
00C7       :=   M   34.1  -M  34.1
00C8       :SPA FB 148    -FB 148
00C9 NAME  :BLOCKSEN
00CA QUDB  :    DB  68    -DB  68              CICLE No.9
00CB RUN   :    M   34.2  -M  34.2
00CC FAIL  :    M   34.3  -M  34.3
00CD TIME  :    T  178    -T 178
00CE       :BEA
00CF       :
00D0 M002  :U   M    0.0  -M   0.0
00D1       :=   M   34.1  -M  34.1              RESET HF-IMPULSE
00D2       :L   Z   16    -Z  16
00D3       :L   KF +19
00D5       :!=F
00D6       :=   M   34.4  -M  34.4
00D7       :SPB =M003                              >> CICLE No.10
00D8       :SPA =M004
00D9 M003  :U   M   34.4  -M  34.4
00DA       :UN  M   34.5  -M  34.5
00DB       :=   M   34.6  -M  34.6
00DC       :U   M   34.4  -M  34.4
00DD       :=   M   34.5  -M  34.5
00DE       :SPA FB 148    -FB 148
00DF NAME  :BLOCKSEN
00E0 QUDB  :    DB  69    -DB  69              CICLE No.10
00E1 RUN   :    M   34.6  -M  34.6
00E2 FAIL  :    M   34.7  -M  34.7
00E3 TIME  :    T  179    -T 179
00E4       :BEA
00E5       :
00E6 M004  :U   M    0.0  -M   0.0
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE         ! DATE        :                       !
! INSTALLATION     : TREAD-LINE          ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804            ! PROGRAMMER  :                     4!
+-------------------------------------------------------------------------------+
```

```
00E7       :=   M   34.5  -M  34.5          RESET HF-IMPULSE
00E8       :L   Z   16    -Z  16
00E9       :L   KF +21
00EB       :!=F
00EC       :=   M   35.0  -M  35.0
00ED       :SPB =M005                      >> CICLE No.11
00EE       :SPA =M006
00EF M005  :U   M   35.0  -M  35.0
00F0       :UN  M   35.1  -M  35.1
00F1       :=   M   35.2  -M  35.2
00F2       :U   M   35.0  -M  35.0
00F3       :=   M   35.1  -M  35.1
00F4       :SPA FB 148    -FB 148
00F5 NAME  :BLOCKSEN
00F6 QUDB  :    DB  70    -DB  70          CICLE No.11
00F7 RUN   :    M   35.2  -M  35.2
00F8 FAIL  :    M   35.3  -M  35.3
00F9 TIME  :    T  180    -T 180
00FA       :BEA
00FB       :
00FC M006  :U   M    0.0  -M   0.0
00FD       :=   M   35.1  -M  35.1          RESET HF-IMPULSE
00FE       :L   Z   16    -Z  16
00FF       :L   KF +23
0101       :!=F
0102       :=   M   35.4  -M  35.4
0103       :SPB =M007                      >> CICLE No.12
0104       :SPA =M008
0105 M007  :U   M   35.4  -M  35.4
0106       :UN  M   35.5  -M  35.5
0107       :=   M   35.6  -M  35.6
0108       :U   M   35.4  -M  35.4
0109       :=   M   35.5  -M  35.5
010A       :SPA FB 148    -FB 148
010B NAME  :BLOCKSEN
010C QUDB  :    DB  71    -DB  71          CICLE No.12
010D RUN   :    M   35.6  -M  35.6
010E FAIL  :    M   35.7  -M  35.7
010F TIME  :    T  181    -T 181
0110       :BEA
0111 M008  :
0112       :U   M    0.0  -M   0.0
0113       :=   M   35.5  -M  35.5          RESET HF-IMPULSE
0114       :***
```

```
Z   16   = Z  16          SEND/READ PARAMETERS GTR-9000
M   34.0 = M  34.0        SEND CICLE No. 9 : COUNTER
M   34.1 = M  34.1        SEND CICLE No. 9 : HF RUN
M   34.2 = M  34.2        SEND CICLE No. 9 : RUN
M   34.3 = M  34.3        SEND CICLE No. 9 : FAIL
T  178   = T 178          SEND CICLE No. 9 : TIME FAIL
M    0.0 = M   0.0        "0"-SIGNAL
M   34.4 = M  34.4        SEND CICLE No.10 : COUNTER
M   34.5 = M  34.5        SEND CICLE No.10 : HF RUN
M   34.6 = M  34.6        SEND CICLE No.10 : RUN
M   34.7 = M  34.7        SEND CICLE No.10 : FAIL
T  179   = T 179          SEND CICLE No.10 : TIME FAIL
M   35.0 = M  35.0        SEND CICLE No.11 : COUNTER
M   35.1 = M  35.1        SEND CICLE No.11 : HF RUN
M   35.2 = M  35.2        SEND CICLE No.11 : RUN
M   35.3 = M  35.3        SEND CICLE No.11 : FAIL
T  180   = T 180          SEND CICLE No.11 : TIME FAIL
M   35.4 = M  35.4        SEND CICLE No.12 : COUNTER
M   35.5 = M  35.5        SEND CICLE No.12 : HF RUN
M   35.6 = M  35.6        SEND CICLE No.12 : RUN
M   35.7 = M  35.7        SEND CICLE No.12 : FAIL
T  181   = T 181          SEND CICLE No.12 : TIME FAIL

DB  68   = DB  68         SEND BLOCK TO GTR-9000 CICLE No. 9
DB  69   = DB  69         SEND BLOCK TO GTR-9000 CICLE No. 10
DB  70   = DB  70         SEND BLOCK TO GTR-9000 CICLE No. 11
```

```
FB 54    -FB  54                        C:KERM06ST.S5D        BIB=8033    LAE=469

DB  71    = DB  71                      SEND BLOCK TO GTR-9000 CICLE No. 12

FB 148    = FB 148                      TRANSFER BLOCK TO R-9000

NETZWERK 6          0115       CICLE No. 13,14,15
0115       :L    Z   16     -Z  16
0116       :L    KF +25
0118       :!=F
0119       :=    M   36.0   -M  36.0
011A       :SPB =M001
011B       :SPA =M002
011C M001  :U    M   36.0   -M  36.0              >> CICLE No.13
011D       :UN   M   36.1   -M  36.1
011E       :=    M   36.2   -M  36.2
011F       :U    M   36.0   -M  36.0
0120       :=    M   36.1   -M  36.1
0121       :SPA FB 148      -FB 148
0122 NAME  :BLOCKSEN
0123 QUDB  :     DB  72     -DB  72
0124 RUN   :     M   36.2   -M  36.2
0125 FAIL  :     M   36.3   -M  36.3              CICLE No.13
0126 TIME  :     T  182     -T 182
0127       :BEA
0128       :
0129 M002  :U    M    0.0   -M   0.0
012A       :=    M   36.1   -M  36.1
012B       :L    Z   16     -Z  16
012C       :L    KF +27                          RESET HF-IMPULSE
012E       :!=F
012F       :=    M   36.4   -M  36.4
0130       :SPB =M003
0131       :SPA =M004
0132 M003  :U    M   36.4   -M  36.4              >> CICLE No.14
0133       :UN   M   36.5   -M  36.5
0134       :=    M   36.6   -M  36.6
0135       :U    M   36.4   -M  36.4
0136       :=    M   36.5   -M  36.5
0137       :SPA FB 148      -FB 148
0138 NAME  :BLOCKSEN
0139 QUDB  :     DB  73     -DB  73
013A RUN   :     M   36.6   -M  36.6
013B FAIL  :     M   36.7   -M  36.7              CICLE No.14
013C TIME  :     T  183     -T 183
013D       :BEA
013E       :
013F M004  :U    M    0.0   -M   0.0
0140       :=    M   36.5   -M  36.5
0141       :L    Z   16     -Z  16
0142       :L    KF +29                          RESET HF-IMPULSE
0144       :!=F
0145       :=    M   37.0   -M  37.0
0146       :SPB =M005
0147       :SPA =M006
0148 M005  :U    M   37.0   -M  37.0              >> CICLE No.15
0149       :UN   M   37.1   -M  37.1
014A       :=    M   37.2   -M  37.2
014B       :U    M   37.0   -M  37.0
014C       :=    M   37.1   -M  37.1
014D       :SPA FB 148      -FB 148
014E NAME  :BLOCKSEN
014F QUDB  :     DB  74     -DB  74
0150 RUN   :     M   37.2   -M  37.2
0151 FAIL  :     M   37.3   -M  37.3              CICLE No.15
0152 TIME  :     T  184     -T 184
0153       :BEA
0154 M006  :
0155       :U    M    0.0   -M   0.0
0156       :=    M   37.1   -M  37.1
0157       :***

Z   16    = Z  16                       SEND/READ PARAMETERS GTR-9000
```

```
+-------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                 !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                  !
+-------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                   !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                   6!
+-------------------------------------------------------------------------+
```

```
M   36.0 = M  36.0                  SEND CICLE No.13 : COUNTER
M   36.1 = M  36.1                  SEND CICLE No.13 : HF RUN
M   36.2 = M  36.2                  SEND CICLE No.13 : RUN
M   36.3 = M  36.3                  SEND CICLE No.13 : FAIL
T  182   = T 182                    SEND CICLE No.13 : TIME FAIL
M    0.0 = M   0.0                  "0"-SIGNAL
M   36.4 = M  36.4                  SEND CICLE No.14 : COUNTER
M   36.5 = M  36.5                  SEND CICLE No.14 : HF RUN
M   36.6 = M  36.6                  SEND CICLE No.14 : RUN
M   36.7 = M  36.7                  SEND CICLE No.14 : FAIL
T  183   = T 183                    SEND CICLE No.14 : TIME FAIL
M   37.0 = M  37.0                  SEND CICLE No.15 : COUNTER
M   37.1 = M  37.1                  SEND CICLE No.15 : HF RUN
M   37.2 = M  37.2                  SEND CICLE No.15 : RUN
M   37.3 = M  37.3                  SEND CICLE No.15 : FAIL
T  184   = T 184                    SEND CICLE No.15 : TIME FAIL

DB  72   = DB  72                   SEND BLOCK TO GTR-9000 CICLE No. 13
DB  73   = DB  73                   SEND BLOCK TO GTR-9000 CICLE No. 14
DB  74   = DB  74                   SEND BLOCK TO GTR-9000 CICLE No. 15

FB 148   = FB 148                   TRANSFER BLOCK TO R-9000

NETZWERK 7          0158      READ FROM GTR9000 CICLE No. 1-15
0158      :L   Z   16    -Z  16
0159      :L   KF +31
015B      :!=F
015C      :=   M   38.4  -M  38.4
015D      :SPB =M001                          CICLE No. 1
015E      :L   Z   16    -Z  16
015F      :L   KF +33
0161      :!=F
0162      :=   M   38.4  -M  38.4
0163      :SPB =M001                          CICLE NO. 2
0164      :L   Z   16    -Z  16
0165      :L   KF +35
0167      :=   M   38.4  -M  38.4
0168      :!=F
0169      :SPB =M001                          CICLE No. 3
016A      :L   Z   16    -Z  16
016B      :L   KF +37
016D      :=   M   38.4  -M  38.4
016E      :!=F
016F      :SPB =M001                          CICLE No. 4
0170      :L   Z   16    -Z  16
0171      :L   KF +39
0173      :!=F
0174      :=   M   38.4  -M  38.4
0175      :SPB =M001                          CICLE No. 5
0176      :L   Z   16    -Z  16
0177      :L   KF +41
0179      :!=F
017A      :=   M   38.4  -M  38.4
017B      :SPB =M001                          CICLE No. 6
017C      :L   Z   16    -Z  16
017D      :L   KF +43
017F      :=   M   38.4  -M  38.4
0180      :!=F
0181      :=   M   38.4  -M  38.4
0182      :SPB =M001                          CICLE No. 7
0183      :L   Z   16    -Z  16
0184      :L   KF +45
0186      :=   M   38.4  -M  38.4
0187      :!=F
0188      :SPB =M001                          CICLE No. 8
0189      :L   Z   16    -Z  16
018A      :L   KF +47
018C      :=   M   38.4  -M  38.4
018D      :!=F
018E      :SPB =M001                          CICLE No. 9
018F      :L   Z   16    -Z  16
0190      :L   KF +49
0192      :=   M   38.4  -M  38.4
0193      :!=F
```

```
0194        :SPB =M001                          CICLE No.10
0195        :L   Z   16     -Z  16
0196        :L   KF +51
0198        :=   M   38.4   -M  38.4
0199        :!=F
019A        :=   M   38.4   -M  38.4
019B        :SPB =M001                          CICLE No.11
019C        :L   Z   16     -Z  16
019D        :L   KF +53
019F        :=   M   38.4   -M  38.4
01A0        :!=F
01A1        :=   M   38.4   -M  38.4
01A2        :SPB =M001                          CICLE No.12
01A3        :L   Z   16     -Z  16
01A4        :L   KF +55
01A6        :!=F
01A7        :=   M   38.4   -M  38.4
01A8        :SPB =M001                          CICLE No.13
01A9        :L   Z   16     -Z  16
01AA        :L   KF +57
01AC        :!=F
01AD        :=   M   38.4   -M  38.4
01AE        :SPB =M001                          CICLE No.14
01AF        :L   Z   16     -Z  16
01B0        :L   KF +59
01B2        :=   M   38.4   -M  38.4
01B3        :!=F
01B4        :=   M   38.4   -M  38.4
01B5        :SPB =M001                          CICLE No.15
01B6        :U   M    0.0   -M   0.0
01B7        :=   M   38.5   -M  38.5            RESET HF-IMPULSE
01B8        :=   M   38.7   -M  38.7            RESET FAIL
01B9        :L   Z   16     -Z  16
01BA        :L   KF +60
01BC        :!=F
01BD        :R   Z   16     -Z  16
01BE        :BEA
01BF        :
01C0 M001   :U   M   38.4   -M  38.4
01C1        :UN  M   38.5   -M  38.5
01C2        :=   M   38.6   -M  38.6
01C3        :U   M   38.4   -M  38.4
01C4        :=   M   38.5   -M  38.5
01C5        :SPA FB 150     -FB 150
01C6 NAME   :ZYKL
01C7 ANF    :    KF +1
01C8 ENDE   :    KF +15
01C9 RUN    :    M   38.6   -M  38.6
01CA DB1    :    KF +40
01CB TIME   :    T    5     -T   5
01CC FAIL   :    M   38.7   -M  38.7
01CD        :BEA
01CE        :***

Z   16   = Z  16                    SEND/READ PARAMETERS GTR-9000
M   38.4 = M  38.4                  READ CICLE No. 1-16 : COUNTER
M    0.0 = M   0.0                  "0"-SIGNAL
M   38.5 = M  38.5                  READ CICLE No. 1-16 : HF RUN
M   38.7 = M  38.7                  READ CICLE No. 1-16 : FAIL
M   38.6 = M  38.6                  READ CICLE No. 1-16 : RUN
T    5   = T   5                    DATATRANSFER 135U - R-9000

FB 150   = FB 150                   CALL PARAMETER-BLOCK FROM R-9000

NETZWERK 8          01CF
01CF       :BE
```

```
FB 55   -FB  55                          C:KERM06ST.S5D        BIB=1033     LAE=173

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                          DATA TRANSFER BETWEEN 135U AND 115U                *
*                                                                             *
*******************************************************************************
NAME :DATA

0005       :***

NETZWERK 2          0006       BUILT SENDIMPULSE
0006       :UN  M   19.6  -M  19.6
0007       :L   KT 050.0
0009       :SE  T    2    -T   2
000A       :U   T    2    -T   2
000B       :S   M   19.6  -M  19.6
000C       :=   M   19.7  -M  19.7
000D       :U   M   19.6  -M  19.6
000E       :L   KT 050.0
0010       :SE  T    3    -T   3
0011       :U   T    3    -T   3
0012       :R   M   19.6  -M  19.6
0013       :***

M   19.6 = M  19.6                    BUILT SENDIMPULSE
T    2   = T   2                     TIMER 2 SENDIMPULSE
M   19.7 = M  19.7                    BUILT SENDIMPULSE
T    3   = T   3                     TIMER 3 SENDIMPULSE

NETZWERK 3          0014
0014       :SPA FB 100     -FB 100
0015 NAME  :ZYKFLAGS
0016       :***

FB 100   = FB 100                     CICLE MOVE REGISTER

NETZWERK 4          0017       SEND DATAS FROM 135U TO 115U
0017       :O   M  105.2  -M 105.2
0018       :O   M  105.6  -M 105.6
0019       :SPB FB  91    -FB  91
001A NAME  :S-SLAVE1
001B       :***

M  105.2 = M 105.2                    CICLE MOVE REGISTER
M  105.6 = M 105.6                    CICLE MOVE REGISTER

FB  91   = FB  91                     SEND DATAS TO SLAVE-No1

NETZWERK 5          001C       RECIEVE DATAS FROM 115U TO 135U
001C       :O   M  105.4  -M 105.4
001D       :O   M  104.0  -M 104.0
001E       :SPB FB  92    -FB  92
001F NAME  :R-SLAVE1
0020       :***

M  105.4 = M 105.4                    CICLE MOVE REGISTER
M  104.0 = M 104.0                    CICLE MOVE REGISTER

FB  92   = FB  92                     RECEIVE DATAS FROM SLAVE-No1

NETZWERK 6          0021       115U:DB30/82 ---> 135U:DB21/4
0021       :SPA FB  51    -FB  51
0022 NAME  :DB--->MB
0023 DB    :    DB  21    -DB  21
0024 BIT0  :    M  192.0  -M0365
0025 BIT1  :    M    8.4  -M   8.4
0026 BIT2  :    M  192.2  -M0367
0027 BIT3  :    M  192.3  -M0368
0028 BIT4  :    M  192.4  -M0369
0029 BIT5  :    M  192.5  -M0370
002A BIT6  :    M  192.6  -M0371
002B BIT7  :    M  192.7  -M0372
002C DW    :    DR   4
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE         ! DATE        :                       !
! INSTALLATION     : TREAD-LINE          ! MODIFICATION:                 PGNO! !
! PROJECT POS. NO.: 84/823804            ! PROGRAMMER  :                    1! !
+-------------------------------------------------------------------------------+
```

```
FB 55   -FB  55                          C:KERM06ST.S5D        BIB=1033     LAE=173

002D       :***

M  192.0 = M0365                         MOTOR KNIFE TRANSFER FAULT  TREAD SKIVER
M    8.4 = M   8.4                       TREAD SKIVER : KNIFE RETURNED
M  192.2 = M0367                         BALL-UP NO CUTTING          TREAD SKIVER
M  192.3 = M0368                         BALL-UP CONVEYOR STOP       TREAD SKIVER
M  192.4 = M0369                         MATERIAL OUT OF MEAS.RANGE  TREAD SKIVER
M  192.5 = M0370                         TIMER KNIFE FEED CUTTING    TREAD SKIVER
M  192.6 = M0371                         TIMER LIFTING KNIFE         TREAD SKIVER
M  192.7 = M0372                         TIMER KNIFE REVERSE         TREAD SKIVER

DB  21   = DB  21                       RECEIVE DATAS FROM SLAVE-No1 (115U)

FB  51   = FB  51                       DB ---> MB

NETZWERK 7          002E      115U:DB30/82 ---> 135U:DB21/4
002E       :SPA FB  51    -FB  51
002F NAME :DB--->MB
0030 DB    :    DB  21    -DB  21
0031 BIT0  :    M  193.0   -M0357
0032 BIT1  :    M  193.1   -M0358
0033 BIT2  :    M  193.2   -M0359
0034 BIT3  :    M  193.3   -M0360
0035 BIT4  :    M  193.4   -M0361
0036 BIT5  :    M    8.5   -M   8.5
0037 BIT6  :    M  180.0   -M0269
0038 BIT7  :    M  193.7   -M0364
0039 DW    :    DL   4
003A       :***

M  193.0 = M0357                         TIMER KNIFE NORMAL POSITION TREAD SKIVER
M  193.1 = M0358                         CONVEYOR BELT MOTOR FAULT   TREAD SKIVER
M  193.2 = M0359                         EXTERNAL FAN MOTOR FAULT    TREAD SKIVER
M  193.3 = M0360                         KNIFE MOTOR FAULT           TREAD SKIVER
M  193.4 = M0361                         MIN. FIELD CURRENT          TREAD SKIVER
M    8.5 = M   8.5                       TREAD SKIVER : KNIFE NORMAL POSITION
M  180.0 = M0269                         PRESSURE FAULT SOFT WATER
M  193.7 = M0364                         AC-CONTROL VOLTAGE FAULT    TREAD SKIVER

DB  21   = DB  21                       RECEIVE DATAS FROM SLAVE-No1 (115U)

FB  51   = FB  51                       DB ---> MB

NETZWERK 8          003B      115U:DB30/83 ---> 135U:DB21/5
003B       :SPA FB  51    -FB  51
003C NAME :DB--->MB
003D DB    :    DB  21    -DB  21
003E BIT0  :    M    8.6   -M   8.6
003F BIT1  :    M  194.1   -M0382
0040 BIT2  :    M  194.2   -M0383
0041 BIT3  :    M  194.3   -M0384
0042 BIT4  :    M  194.4   -M0385
0043 BIT5  :    M  194.5   -M0386
0044 BIT6  :    M  255.0
0045 BIT7  :    M  255.0
0046 DW    :    DR   5
0047       :***

M    8.6 = M   8.6                       TREAD SKIVER : LENGTH MEASURING ACTIVE
M  194.1 = M0382                         COMPRESSED AIR FAULT        TREAD SKIVER
M  194.2 = M0383                         E-STOP CABINET              TREAD SKIVER
M  194.3 = M0384                         E-STOP OPERATOR PANEL       TREAD SKIVER
M  194.4 = M0385                         START LOOK LIGHT CURTAIN    TREAD SKIVER
M  194.5 = M0386                         MATERIAL OUT OF MEAS.RANGE  TREAD SKIVER

DB  21   = DB  21                       RECEIVE DATAS FROM SLAVE-No1 (115U)

FB  51   = FB  51                       DB ---> MB

NETZWERK 9          0048      115U:DB30/83 ---> 135U:DB21/5
0048       :SPA FB  51    -FB  51
0049 NAME :DB--->MB
004A DB    :    DB  21    -DB  21
004B BIT0  :    M    8.0   -M   8.0
+-------------------------------------------------------------------------------+
!         KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                        !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE         ! DATE        :                       !
! INSTALLATION     : TREAD-LINE          ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804            ! PROGRAMMER  :                     2!
+-------------------------------------------------------------------------------+
```

```
004C BIT1 :    M    8.1  -M   8.1
004D BIT2 :    M    8.2  -M   8.2
004E BIT3 :    M    8.3  -M   8.3
004F BIT4 :    M  255.0
0050 BIT5 :    M  255.0
0051 BIT6 :    M  255.0
0052 BIT7 :    M  255.0
0053 DW   :    DL   5
0054      :***

M    8.0 = M   8.0                    TREAD SKIVER : SWITCH IS IN AUTOMAT
M    8.1 = M   8.1                    TREAD SKIVER : READY FOR START
M    8.2 = M   8.2                    TREAD SKIVER : AUX DRIVES ON
M    8.3 = M   8.3                    TREAD SKIVER : FAULT (MACHINE OFF)

DB  21   = DB  21                     RECEIVE DATAS FROM SLAVE-No1 (115U)

FB  51   = FB  51                     DB ---> MB

NETZWERK 10        0055      TRANSFER DATAS TO SEND DB20
0055      :UN  M   19.7  -M  19.7
0056      :BEB                                YES >> NO TRANSFER
0057      :A   DB 180    -DB 180
0058      :L   DW 100                         PRESET TREAD LENGTH
0059      :A   DB  20    -DB  20
005A      :T   DW   4                         PRESET TREAD LENGTH IN mm
005B      :A   DB  21    -DB  21
005C      :L   DW  12                         CORRECTION
005D      :+F
005E      :L   KF +4                          IMPULSE / mm (IMPULSE SENDER)
0060      :XF
0061      :A   DB  20    -DB  20
0062      :T   DW   3                         So IN IMPULSES
0063      :A   DB 180    -DB 180
0064      :L   DW 100                         PRESET TREAD LENGTH
0065      :A   DB  21    -DB  21
0066      :L   DW  12                         CORRECTION
0067      :+F
0068      :L   KF +100                        BRAKE-WAY 12.5 cm
006A      :-F
006B      :L   KF +4
006D      :XF
006E      :A   DB  20    -DB  20
006F      :T   DW   8                         So - 500
0070      :A   DB 180    -DB 180
0071      :L   DD  62                         PRESET LINE SPEED
0072      :L   KG +1000000+02
0075      :XG
0076      :GFD                                = XX.X m/min
0077      :A   DB  20    -DB  20
0078      :T   DW   5
0079      :A   DB 180    -DB 180
007A      :L   DW  68                         BOOKING
007B      :L   KC Y#
007D      :!=F
007E      :=   M    2.7  -M   2.7             YES >> BOOKING
007F      :L   DW  68
0080      :L   KC N#
0082      :!=F
0083      :=   M    2.5  -M   2.5             YES >> WIND-UP
0084      :O   M    2.7  -M   2.7
0085      :O   M    2.5  -M   2.5
0086      :SPB =M001                          YES >> CORRECT INPUT
0087      :L   KC Y#
0089      :T   DW  68
008A      :U   M    0.1  -M   0.1
008B      :=   M    2.7  -M   2.7
008C M001 :***

M   19.7 = M  19.7                    BUILT SENDIMPULSE
M    2.7 = M   2.7                    BOOKING
```

```
FB 55   -FB  55                          C:KERM06ST.S5D        BIB=1033    LAE=173

M    2.5 = M   2.5                       WIND-UP
M    0.1 = M   0.1                       "1"-SIGNAL

DB 180   = DB 180                        PROFILE AG
DB  20   = DB  20                        SEND DATAS TO SLAVE No1 (115U)
DB  21   = DB  21                        RECEIVE DATAS FROM SLAVE-No1 (115U)

NETZWERK 11          008D       135U:DB20/7 ---> 115U:DB30/46
008D       :SPA FB  50     -FB  50
008E NAME  :MB--->DB
008F DBNR  :     DB  20     -DB  20
0090 BIT0  :     M   81.5   -M  81.5              LINE ON
0091 BIT1  :     M   81.1   -M  81.1              AUX DRIVES LINE ON
0092 BIT2  :     M   81.3   -M  81.3              LINE READY TO START
0093 BIT3  :     M   80.0   -M  80.0              IMPULSE GENERAL FAULT CONVEYOR
0094 BIT4  :     E   84.3   -205S3.2             ACKNOWLEDGING FAULT
0095 BIT5  :     M    2.7   -M   2.7              BOOKING
0096 BIT6  :     M    2.5   -M   2.5              WIND-UP
0097 BIT7  :     M    9.0   -M   9.0              E-STOP
0098 DW    :     DR   7
0099       :***

M   81.5 = M  81.5                       LINE : LINE ON
M   81.1 = M  81.1                       LINE : AUXILIARY DRIVES ON
M   81.3 = M  81.3                       LINE : LINE READY FOR WORK
M   80.0 = M  80.0                       LINE : FAULT
E   84.3 = 205S3.2                       ACKNOWLEDGING FAULT     (MAIN CONTR.PAN.)
M    2.7 = M   2.7                       BOOKING
M    2.5 = M   2.5                       WIND-UP
M    9.0 = M   9.0                       E-STOP TRIGGERED

DB  20   = DB  20                        SEND DATAS TO SLAVE No1 (115U)

FB  50   = FB  50                        MB ---> DB

NETZWERK 12          009A       135U:DB20/7 ---> 115U:DB30/46
009A       :SPA FB  50     -FB  50
009B NAME  :MB--->DB
009C DBNR  :     DB  20     -DB  20
009D BIT0  :     M   80.7   -M  80.7              FAULT LINE (DRIVE MOTORS ETC.)
009E BIT1  :     M    5.2   -M   5.2              RESET PRODUCTION REPORT
009F BIT2  :     M    7.6   -M   7.6              V-LINE PRESET > V-LINE LIMIT
00A0 BIT3  :     M    0.0   -M   0.0
00A1 BIT4  :     M    0.0   -M   0.0
00A2 BIT5  :     M    0.0   -M   0.0
00A3 BIT6  :     M    0.0   -M   0.0
00A4 BIT7  :     M    0.0   -M   0.0
00A5 DW    :     DL   7
00A6       :***

M   80.7 = M  80.7                       LINE : LINE FAULT (DRIVE MOTORS,ETC)
M    5.2 = M   5.2                       RESET PRODUCTION DATAS
M    7.6 = M   7.6                       V-LINE PRESET > V-LINE LIMIT
M    0.0 = M   0.0                       "0"-SIGNAL

DB  20   = DB  20                        SEND DATAS TO SLAVE No1 (115U)

FB  50   = FB  50                        MB ---> DB

NETZWERK 13          00A7
00A7       :BE
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                              CONTROL DISPLAY                              *
*                                                                           *
*****************************************************************************
NAME :CONT-DAT

0005       :A   DB 170    -DB 170
0006       :L   DD  18                          SPEED TOPMACHINE
0007       :L   KG +0000000+00
000A       :>=G
000B       :U   A    0.0  -43A1/1
000C       :SPB =M001
000D       :L   KG +0000000+00
0010       :T   DD  18
0011 M001  :
0012       :L   DD  20                          CURRENT TOPMACHINE
0013       :L   KG +0000000+00
0016       :>=G
0017       :U   A    0.0  -43A1/1
0018       :SPB =M002
0019       :L   KG +0000000+00
001C       :T   DD  20
001D M002  :
001E       :L   DD  22                          SPEED BOTTOMMACHINE
001F       :L   KG +0000000+00
0022       :>=G
0023       :U   A    1.0  -A  1.0
0024       :SPB =M003
0025       :L   KG +0000000+00
0028       :T   DD  22
0029 M003  :
002A       :L   DD  24                          CURRENT BOTTOMMACHINE
002B       :L   KG +0000000+00
002E       :>=G
002F       :U   A    1.0  -A  1.0
0030       :SPB =M004
0031       :L   KG +0000000+00
0034       :T   DD  24
0035 M004  :
0036       :L   DD  26                          SPEED EXTRUDER CALANDER
0037       :L   KG +0000000+00
003A       :>=G
003B       :U   A    4.2  -84A1.1
003C       :SPB =M005
003D       :L   KG +0000000+00
0040       :T   DD  26
0041 M005  :
0042       :L   DD  28                          CURRENT EXTRUDER CALANDER
0043       :L   KG +0000000+00
0046       :>=G
0047       :U   A    4.2  -84A1.1
0048       :SPB =M006
0049       :L   KG +0000000+00
004C       :T   DD  28
004D M006  :
004E       :L   DD 172                          PRESSURE CHANNEL 1
004F       :L   KG +0000000+00
0052       :>=G
0053       :SPB =M007
0054       :L   KG +0000000+00
0057       :T   DD 172
0058 M007  :
0059       :L   DD 174                          PRESSURE CHANNEL 2
005A       :L   KG +0000000+00
005D       :>=G
005E       :SPB =M008
005F       :L   KG +0000000+00
0062       :T   DD 174
0063 M008  :
0064       :L   DD 178                          SPEED CALANDER
0065       :L   KG +0000000+00
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                    !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                    !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                    !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                    1!
+-----------------------------------------------------------------------------+
```

```
0068       :>=G
0069       :U   A    5.2  -91A1.1
006A       :SPB =M009
006B       :L   KG +0000000+00
006E       :T   DD 178
006F M009  :
0070       :L   DD 176                          CURRENT CALANDER
0071       :L   KG +0000000+00
0074       :U   A    5.2  -91A1.1
0075       :>=G
0076       :SPB =M010
0077       :L   KG +0000000+00
007A       :T   DD 176
007B M010  :
007C       :U   M   81.5  -M  81.5               LINE SPEED
007D       :SPB =M011
007E       :L   KG +0000000+00
0081       :T   DD  62
0082 M011  :***

A    0.0 = 43A1/1                               UPPER EXTRUDER ON/OFF
A    1.0 = A  1.0                               BOTTOM EXTRUDER ON/OFF
A    4.2 = 84A1.1                               EXTRUDER CALENDER DC-CONVERTER ON/OFF
A    5.2 = 91A1.1                               CALENDER START/STOP
M   81.5 = M  81.5                              LINE : LINE ON

DB 170   = DB 170                               ACTUAL DATAS

NETZWERK 2          0083
0083       :A   DB 170    -DB 170
0084       :L   DD  48                          REGULATOR LINEAR WEIGHER
0085       :L   KG +1000000+03
0088       :<=G
0089       :SPB =M001
008A       :L   KG +1000000+03
008D       :T   DD  48
008E       :SPA =M002
008F M001  :L   DD  48
0090       :L   KG +0000000+00
0093       :>=G
0094       :SPB =M002
0095       :L   KG +0000000+00
0098       :T   DD  48
0099 M002  :
009A       :L   DD  50                          REGULATOR CALENDER
009B       :L   KG +1000000+03
009E       :<=G
009F       :SPB =M003
00A0       :L   KG +1000000+03
00A3       :T   DD  50
00A4       :SPA =M004
00A5 M003  :L   DD  50
00A6       :L   KG +0000000+00
00A9       :>=G
00AA       :SPB =M004
00AB       :L   KG +0000000+00
00AE       :T   DD  50
00AF M004  :
00B0       :L   DD  52                          REGULATOR CEMENTING 2
00B1       :L   KG +1000000+03
00B4       :<=G
00B5       :SPB =M005
00B6       :L   KG +1000000+03
00B9       :T   DD  52
00BA       :SPA =M006
00BB M005  :L   DD  52
00BC       :L   KG +0000000+00
00BF       :>=G
00C0       :SPB =M006
00C1       :L   KG +0000000+00
00C4       :T   DD  52
00C5 M006  :
00C6       :L   DD  54                          REGULATOR COOLING SECTION 1
00C7       :L   KG +1000000+03
```

```
NETZWERK 3          0135
0135       :A   DB 170    -DB 170
0136       :L   DW  74                    TEMP. UPPER EXTRUDER SCREW
0137       :L   KF +0
0139       :>=F
013A       :SPB =M001                     YES >> TEMP. >= 0
013B       :L   KF +0
013D       :T   DW  74
013E       :SPA =M002
013F M001  :L   DW  74
0140       :L   KF +200
0142       :<=F
0143       :SPB =M002                     YES >> TEMP. <= 200
0144       :L   KF +999
0146       :T   DW  74
0147 M002  :
0148       :L   DW  76                    TEMP. UPPER EXTRUDER BARREL
0149       :L   KF +0
014B       :>=F
014C       :SPB =M003                     YES >> TEMP. >= 0
014D       :L   KF +0
014F       :T   DW  76
0150       :SPA =M004
0151 M003  :L   DW  76
0152       :L   KF +200
0154       :<=F
0155       :SPB =M004                     YES >> TEMP. <= 200
0156       :L   KF +999
0158       :T   DW  76
0159 M004  :
015A       :L   DW  78                    TEMP. BOTTOM EXTRUDER SCREW
015B       :L   KF +0
015D       :>=F
015E       :SPB =M005                     YES >> TEMP. >= 0
015F       :L   KF +0
0161       :T   DW  78
0162       :SPA =M006
0163 M005  :L   DW  78
0164       :L   KF +200
0166       :<=F
0167       :SPB =M006                     YES >> TEMP. <= 200
0168       :L   KF +999
016A       :T   DW  78
016B M006  :
016C       :L   DW  80                    TEMP. BOTTOM EXTRUDER BARREL
016D       :L   KF +0
016F       :>=F
0170       :SPB =M007                     YES >> TEMP. >= 0
0171       :L   KF +0
0173       :T   DW  80
0174       :SPA =M008
0175 M007  :L   DW  80
0176       :L   KF +200
0178       :<=F
0179       :SPB =M008                     YES >> TEMP. <= 200
017A       :L   KF +999
017C       :T   DW  80
017D M008  :
017E       :L   DW  82                    TEMP. EXTRUDER CAL. HEAD
017F       :L   KF +0
0181       :>=F
0182       :SPB =M009                     YES >> TEMP. >= 0
0183       :L   KF +0
0185       :T   DW  82
0186       :SPA =M010
0187 M009  :L   DW  82
0188       :L   KF +200
018A       :<=F
018B       :SPB =M010                     YES >> TEMP. <= 200
018C       :L   KF +999
018E       :T   DW  82
018F M010  :
```

```
0190        :L   DW  84                          TEMP. EXTRUDER CA. SCREW
0191        :L   KF +0
0193        :>=F
0194        :SPB =M011                           YES >> TEMP. >= 0
0195        :L   KF +0
0197        :T   DW  84
0198        :SPA =M012
0199 M011   :L   DW  84
019A        :L   KF +200
019C        :<=F
019D        :SPB =M012                           YES >> TEMP. <= 200
019E        :L   KF +999
01A0        :T   DW  84
01A1 M012   :
01A2        :L   DW  86                          TEMP. EXTRUDER CAL. BARREL/PIN
01A3        :L   KF +0
01A5        :>=F
01A6        :SPB =M013                           YES >> TEMP. >= 0
01A7        :L   KF +0
01A9        :T   DW  86
01AA        :SPA =M014
01AB M013   :L   DW  86
01AC        :L   KF +200
01AE        :<=F
01AF        :SPB =M014                           YES >> TEMP. <= 200
01B0        :L   KF +999
01B2        :T   DW  86
01B3 M014   :
01B4        :L   DW  88                          TEMP. HEAD UPPER PART
01B5        :L   KF +0
01B7        :>=F
01B8        :SPB =M015                           YES >> TEMP. >= 0
01B9        :L   KF +0
01BB        :T   DW  88
01BC        :SPA =M016
01BD M015   :L   DW  88
01BE        :L   KF +200
01C0        :<=F
01C1        :SPB =M016                           YES >> TEMP. <= 200
01C2        :L   KF +999
01C4        :T   DW  88
01C5 M016   :
01C6        :L   DW  90                          TEMP. MIDDLE PART
01C7        :L   KF +0
01C9        :>=F
01CA        :SPB =M017                           YES >> TEMP. >= 0
01CB        :L   KF +0
01CD        :T   DW  90
01CE        :SPA =M018
01CF M017   :L   DW  90
01D0        :L   KF +200
01D2        :<=F
01D3        :SPB =M018                           YES >> TEMP. <= 200
01D4        :L   KF +999
01D6        :T   DW  90
01D7 M018   :
01D8        :L   DW  92                          TEMP. CASSETTE LEFT
01D9        :L   KF +0
01DB        :>=F
01DC        :SPB =M019                           YES >> TEMP. >= 0
01DD        :L   KF +0
01DF        :T   DW  92
01E0        :SPA =M020
01E1 M019   :L   DW  92
01E2        :L   KF +200
01E4        :<=F
01E5        :SPB =M020                           YES >> TEMP. <= 200
01E6        :L   KF +999
01E8        :T   DW  92
01E9 M020   :
01EA        :L   DW  94                          TEMP. CASSETTE RIGHT
01EB        :L   KF +0
01ED        :>=F
01EE        :SPB =M021                           YES >> TEMP. >= 0
```

```
01EF       :L   KF +0
01F1       :T   DW  94
01F2       :SPA =M022
01F3 M021  :L   DW  94
01F4       :L   KF +200
01F6       :<=F
01F7       :SPB =M022                    YES >> TEMP. <= 200
01F8       :L   KF +999
01FA       :T   DW  94
01FB M022  :
01FC       :L   DW  96                   TEMP. CALENDER ROLL TOP
01FD       :L   KF +0
01FF       :>=F
0200       :SPB =M023                    YES >> TEMP. >= 0
0201       :L   KF +0
0203       :T   DW  96
0204       :SPA =M024
0205 M023  :L   DW  96
0206       :L   KF +200
0208       :<=F
0209       :SPB =M024                    YES >> TEMP. <= 200
020A       :L   KF +999
020C       :T   DW  96
020D M024  :
020E       :L   DW  98                   TEMP. CALENDER ROLL BOTTOM
020F       :L   KF +0
0211       :>=F
0212       :SPB =M025                    YES >> TEMP. >= 0
0213       :L   KF +0
0215       :T   DW  98
0216       :SPA =M026
0217 M025  :L   DW  98
0218       :L   KF +200
021A       :<=F
021B       :SPB =M026                    YES >> TEMP. <= 200
021C       :L   KF +999
021E       :T   DW  98
021F M026  :
0220       :L   DW 104                   TEMP. PREHEATING TABLE
0221       :L   KF +0
0223       :>=F
0224       :SPB =M027                    YES >> TEMP. >= 0
0225       :L   KF +0
0227       :T   DW 104
0228       :SPA =M028
0229 M027  :L   DW 104
022A       :L   KF +200
022C       :<=F
022D       :SPB =M028                    YES >> TEMP. <= 200
022E       :L   KF +999
0230       :T   DW 104
0231 M028  :
0232       :***
```

DB 170 = DB 170 ACTUAL DATAS

```
NETZWERK 4          0233
0233       :AWL
0234       :BE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                          TRANSFER DATA-DOUBLEWORD                         *
*                                                                           *
*****************************************************************************
NAME :TRANS-DD
BEZ  :DB-Q       E/A/D/B/T/Z: B
BEZ  :QUEL       E/A/D/B/T/Z: E  BI/BY/W/D: D
BEZ  :DB-Z       E/A/D/B/T/Z: B
BEZ  :ZIEL       E/A/D/B/T/Z: E  BI/BY/W/D: D

0011      :B   =DB-Q                    QUELL-DB
0012      :L   =QUEL                    ZU TRANSFERIERENDES DD-WORT
0013      :B   =DB-Z                    ZIEL-DB
0014      :T   =ZIEL                    ZIEL DES DD-WORT
0015      :BE
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                    SPEED FEEDING DEVICE EXTRUDER CALANDER                 *
*                                                                           *
*****************************************************************************
NAME :FEED-SPE

0005       :U   A    4.0  -81A1.1
0006       :SPB =M001                          >> RELEASE SPEED
0007       :A   DB  95    -DB  95
0008       :L   KG +0000000+00
000B       :T   DD  30
000C       :SPA =M002                          >> ANALOG OUTPUT
000D M001  :U   E   52.5  -275S34
000E       :SPB =M003                          >> MAX. SPEED
000F       :U   M   48.7  -M  48.7
0010       :SPB =M004                          >> REVERSE
0011       :U   A    4.4  -84A1.2
0012       :SPB =M005                          >> EXTRUDER IS ON
0013       :A   DB  95    -DB  95
0014       :L   KG +5000000+02
0017       :T   DD  30
0018       :SPA =M002                          >> ANALOG OUTPUT
0019 M005  :A   DB  95    -DB  95
001A       :L   KG +5000000+02
001D       :T   DD  30
001E       :SPA =M002                          >> ANALOG OUTPUT
001F       :
0020       :
0021 M004  :A   DB  95    -DB  95
0022       :L   KG +2000000+02
0025       :T   DD  30
0026       :SPA =M002                          >> ANALOG OUTPUT
0027 M003  :A   DB  95    -DB  95
0028       :L   KG +1000000+03
002B       :T   DD  30
002C M002  :SPA FB  44    -FB  44
002D NAME  :KF-AA
002E PERE  :    KF +136
002F SOLL  :    DD  30
0030 EINH  :    KG +1000000+03
0032 INVE  :    M    0.0  -M   0.0
0033 FREI  :    M    0.1  -M   0.1
0034 DBNR  :    DB  95    -DB  95
0035       :BE

A    4.0 = 81A1.1                    FEEDER ON
E   52.5 = 275S34                    FEEDER MAX SPEED        (HOPPER STATION)
M   48.7 = M  48.7                   FEEDER : REVERSE
A    4.4 = 84A1.2                    EXTRUDER CALENDER CONTROLLER RELEASE
M    0.0 = M   0.0                   "0"-SIGNAL
M    0.1 = M   0.1                   "1"-SIGNAL

DB  95   = DB  95                    GENERAL DATAS

FB  44   = FB  44                    ANALOG OUTPUT
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                                HYSTERESE                                  *
*                                                                           *
*****************************************************************************
NAME :HYSTER.1
BEZ  :DB-I      E/A/D/B/T/Z: B
BEZ  :ISTW      E/A/D/B/T/Z: E  BI/BY/W/D: D
BEZ  :OGR       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :UGR       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :AUSG      E/A/D/B/T/Z: A  BI/BY/W/D: BI

0014      :B   =DB-I
0015      :L   =ISTW
0016      :LD  =OGR
0017      :>=G
0018      :S   =AUSG
0019      :LD  =UGR
001A      :L   =ISTW
001B      :>=G
001C      :RB  =AUSG
001D      :BE
```

```
FB 74    -FB  74                        C:KERM06ST.S5D        BIB=15102    LAE=85

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                        NOMINAL VALUE DRIVE MOTORS LINE                      *
*                                                                             *
*******************************************************************************


LOOP REGULATOR FULL = 100 AND EMPTY = 0

Vout   =  Vio   +   corr * (IW/2-IW) * RI / 5000      = SW

Vio    =  VE * K


Vout   OUTPUT SPEED
VE     PRESET SPEED
K      MOTOR CONST.
IW/2   EQUAL MIDDLE POSITION REGULATOR
IW     REAL POSITION REGULATOR ( O=MIN/UP UNTIL 100=MAX/DOWN)
RI     REGULATING PROPORTIONAK FACTOR
5000   CONST. FOR MIDDLEPOSITION


NAME  :CONLOOP-                                      CONVEYOR LOOP NEGATIVE
BEZ   :DBVE       E/A/D/B/T/Z: B
BEZ   :VE         E/A/D/B/T/Z: E  BI/BY/W/D: D
BEZ   :KI         E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ   :UNGE       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ   :DBAE       E/A/D/B/T/Z: B
BEZ   :IW         E/A/D/B/T/Z: E  BI/BY/W/D: D
BEZ   :IW/2       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ   :RI/%       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ   :DBAA       E/A/D/B/T/Z: B
BEZ   :SW         E/A/D/B/T/Z: A  BI/BY/W/D: D
BEZ   :STOE       E/A/D/B/T/Z: E  BI/BY/W/D: BI

0026        :B    =DBVE
0027        :L    =VE                          LINE SPEED IN VOLT
0028        :LD   =KI                          MOTOR KONSTANTE
0029        :XG                                Vio = VE * KI
002A        :T    MD 226
002B        :UN   =UNGE
002C        :SPB  =M001
002D        :T    MD 230                       OUTPUT UNCONTROLLED
002E        :SPA  =M999
002F M001   :B    =DBAE
0030        :L    =IW
0031        :LD   =IW/2
0032        :-G
0033        :T    MD 230                       (IW - IW/2)
0034        :LD   =RI/%
0035        :L    KG +5000000+04
0038        ::G                                RI / 5000
0039        :L    MD 230
003A        :XG                                RI * ( IW - IW/2)/5000
003B        :L    KG +2500000+02
003E        :XG                                corr * RI * (IW -IW/2)/5000
003F        :L    MD 226
0040        :+G                                SW=Vio+corr*RI*(IW -IW/2)/5000
0041        :T    MD 230                       OUTPUT CONTROLLED
0042 M999   :***


NETZWERK 2          0043
0043        :B    =DBAA
0044        :L    MD 230
0045        :L    =SW
0046        :>G
0047        :L    KG +9999999-01
004A        :SPB  =M001
004B        :-G
004C        :SPA  =M002
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE         :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER   :                    1!
+-------------------------------------------------------------------------------+
```

```
004D M001 :+G
004E M002 :T   =SW
004F      :BE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                    CALCULATE CURRENT CALANDER FOR DISPLAY                 *
*                                                                           *
*****************************************************************************
NAME :CURR-DIS

0005        :A   DB 170     -DB 170
0006        :L   DD 176
0007        :L   KG +1000000+02
000A        :XG
000B        :L   KG +2870000+03
000E        ::G
000F        :T   DD  32
0010        :ON  A    5.3   -91A1.2
0011        :SPB =M001
0012        :BEA
0013 M001   :L   KG +0000000+00
0016        :T   DD  32
0017        :BE

A    5.3 = 91A1.2                    CALENDER CONTROLLER RELEASE

DB 170   = DB 170                    ACTUAL DATAS
```

```
FB 77   -FB  77                      C:KERM06ST.S5D        BIB=8112     LAE=29

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                    CALCULATE CURRENT EXTRUDER FOR DISPLAY                   *
*                                                                             *
*******************************************************************************
NAME :CURR-DIS

0005       :A   DB 170     -DB 170
0006       :L   DD  28
0007       :L   KG +1000000+02
000A       :XG
000B       :L   KG +9200000+02
000E       ::G
000F       :T   DD  30
0010       :ON  A    4.4   -84A1.2
0011       :SPB =M001
0012       :BEA
0013 M001  :L   KG +0000000+00
0016       :T   DD  30
0017       :BE

A    4.4 = 84A1.2                    EXTRUDER CALENDER CONTROLLER RELEASE

DB 170   = DB 170                    ACTUAL DATAS
```

```
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                      !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE        :                       !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                 PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER  :                    1!
+-------------------------------------------------------------------------------+
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                          FASTER OR SLOWLIER                               *
*                                                                           *
*****************************************************************************

NAME :SLIT +/-
BEZ  :DBNR      E/A/D/B/T/Z: B
BEZ  :SOLL      E/A/D/B/T/Z: A  BI/BY/W/D: D
BEZ  :H-DD      E/A/D/B/T/Z: A  BI/BY/W/D: D
BEZ  :TAKT      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :ZAEH      E/A/D/B/T/Z: Z
BEZ  :SI1+      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :SI1-      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :XMAL      E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KZ
BEZ  :SMAX      E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :SMIN      E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :FMAX      E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :FMIN      E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :MFL1      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :MIM1      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :HM2       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :MFL2      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :MIM2      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :SI2+      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :SI2-      E/A/D/B/T/Z: E  BI/BY/W/D: BI

003E      :B   =DBNR
003F      :U   =TAKT                          ################################
0040      :UN  =MFL1                          #
0041      :=   =MIM1                          # IMPULSE FOR TACT
0042      :U   =MIM1                          #
0043      :S   =MFL1                          #
0044      :UN  =TAKT                          #
0045      :RB  =MFL1                          ################################
0046      :UN  =SI1+                          ################################
0047      :UN  =SI1-                          #
0048      :UN  =SI2+                          #
0049      :UN  =SI2-                          #
004A      :O(                                 # RESET COUNTER IF THERE IS NO
004B      :U   =SI1+                01        #
004C      :U   =SI1-                01        # SIGNAL
004D      :U   =SI2+                01        #
004E      :U   =SI2-                01        #
004F      :)                        01        #
0050      :LW  =XMAL                          #
0051      :L   KF +2                          #
0053      :+F                                 #
0054      :SVZ =ZAEH                          ################################
0055      :O   =SI1+                          ################################
0056      :O   =SI2+                          #
0057      :UN  =SI1-                          #
0058      :UN  =SI2-                          #
0059      :SPB =M001                          # IF CORRECT SIGNAL THEN JUMP
005A      :O   =SI1-                          # INTO MAIN PROGRAMM +/-
005B      :O   =SI2-                          #
005C      :UN  =SI1+                          #
005D      :UN  =SI2+                          #
005E      :SPB =M001                          ################################
005F      :LD  =FMIN                          RESET CHANGING VALUE TO MIN IF
0060      :T   =H-DD                          THERE IS NO CORRECT SIGNAL
0061      :BEA
0062 M001 :UN  =ZAEH                          ################################
0063      :LW  =XMAL                          # SET COUNTER IF COUNTER=0
0064      :SVZ =ZAEH                          # RECOUNT WITH TACT
0065      :U   =MIM1                          #
0066      :SAR =ZAEH                          ################################
0067      :L   =ZAEH                          IF COUNTER = 1
0068      :L   KF +1                          SET HELPFLAG
006A      :!=F
006B      :=   =HM2
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                    !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                    !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE        :                     !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER  :                     1!
+-----------------------------------------------------------------------------+
```

```
006C       :U    =HM2
006D       :UN   =MFL2
006E       :=    =MIM2
006F       :U    =MIM2
0070       :S    =MFL2
0071       :UN   =HM2
0072       :RB   =MFL2
0073       :UN   =MIM2
0074       :SPB  =M002
0075       :L    =H-DD
0076       :L    =H-DD
0077       :+G
0078       :T    =H-DD
0079       :LD   =SMAX
007A       :<=G
007B       :SPB  =M002
007C       :LD   =FMAX
007D       :T    =H-DD
007E M002  :UN   =MIM1
007F       :BEB
0080       :UN   =SI1+
0081       :UN   =SI2+
0082       :SPB  =M003
0083       :L    =SOLL
0084       :L    =H-DD
0085       :+G
0086       :T    =SOLL
0087       :LD   =SMAX
0088       :<=G
0089       :BEB
008A       :LD   =SMAX
008B       :T    =SOLL
008C       :BEA
008D M003  :L    =SOLL
008E       :L    =H-DD
008F       :-G
0090       :T    =SOLL
0091       :LD   =SMIN
0092       :>=G
0093       :BEB
0094       :LD   =SMIN
0095       :T    =SOLL
0096       :BE
```

```
##################################
#
#  IMPULSE IF COUNTER = 1
#
#
#
##################################
IF POSITIVEN FLANC COUNTER = 1
CHANGE CHANGING VALUE
##################################
# CHANGING VALUE DOUBLE IF
# COUNTER = 1
##################################
# CONTROL MAX. VALUE
#
#
# SET MAX. VALUE
##################################
NO TACT --> NO CHANGING

IF NOT + THEN -

YES >> VALUE DOWN
##################################
# ADD CHANGING VALUE TO SLIT
#
# CONTROL IF MAXIMUM REACHED
#
#
#
# SET MAXIMUN
##################################

##################################
# SUB CHANGING VALUE TO SLIT
#
# CONTROL IF MINIMUM SPEED
#
#
#
# SET MINIMUM
##################################
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                FASTER OR SLOWLIER                           *
*                                                                             *
*******************************************************************************


NAME :SLIT +/-
BEZ  :DBNR       E/A/D/B/T/Z: B
BEZ  :SOLL       E/A/D/B/T/Z: A  BI/BY/W/D: D
BEZ  :H-DD       E/A/D/B/T/Z: A  BI/BY/W/D: D
BEZ  :TAKT       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :ZAEH       E/A/D/B/T/Z: Z
BEZ  :SIG+       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :SIG-       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :XMAL       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KZ
BEZ  :SMAX       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :SMIN       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :FMAX       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :FMIN       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KG
BEZ  :MFL1       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :MIM1       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :HM2        E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :MFL2       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :MIM2       E/A/D/B/T/Z: E  BI/BY/W/D: BI

0038       :B    =DBNR
0039       :
003A       :U    =TAKT                        ##################################
003B       :UN   =MFL1                        #
003C       :=    =MIM1                        # IMPULSE FOR TACT
003D       :U    =MIM1                        #
003E       :S    =MFL1                        #
003F       :UN   =TAKT                        #
0040       :RB   =MFL1                        ##################################
0041       :
0042       :UN   =SIG+                        ##################################
0043       :UN   =SIG-                        #
0044       :O(                                # RESET COUNTER IF THERE IS NO
0045       :U    =SIG+              01        #
0046       :U    =SIG-              01        # SIGNAL
0047       :)                       01        #
0048       :LW   =XMAL                        #
0049       :L    KF +2                        #
004B       :+F                                #
004C       :SVZ  =ZAEH                        ##################################
004D       :
004E       :U    =SIG+                        ##################################
004F       :UN   =SIG-                        #
0050       :SPB  =M001                        # IF SIGNAL THEN JUMP INTO
0051       :UN   =SIG+                        # MAIN PROGRAMM +/-
0052       :U    =SIG-                        #
0053       :SPB  =M001                        ##################################
0054       :
0055       :LD   =FMIN                        RESET CHANGING VALUE TO MIN IF
0056       :T    =H-DD                        THERE IS NO SIGNAL
0057       :BEA
0058       :
0059       :
005A M001  :UN   =ZAEH                        ##################################
005B       :LW   =XMAL                        # SET COUNTER IF COUNTER=0
005C       :SVZ  =ZAEH                        # RECOUNT WITH TACT
005D       :U    =MIM1                        #
005E       :SAR  =ZAEH                        ##################################
005F       :
0060       :L    =ZAEH                        IF COUNTER = 1
0061       :L    KF +1                        SET HELPFLAG
0063       :!=F
0064       :=    =HM2
0065       :
0066       :U    =HM2                         ##################################
0067       :UN   =MFL2                        #
```

KRUPP KUNSTOFFTECHNIK ELASTOMERTECHNIK WERK HARBURG	MASTERPROGRAMM
PROJECT : KERMAN TIRE INSTALLATION : TREAD-LINE PROJECT POS. NO.: 84/823804	DATE : MODIFICATION: PROGRAMMER : PGNO 1

```
0068       :=    =MIM2          #  IMPULSE IF COUNTER = 1
0069       :U    =MIM2          #
006A       :S    =MFL2          #
006B       :UN   =HM2           #
006C       :RB   =MFL2          ################################
006D       :
006E       :UN   =MIM2          IF POSITIVEN FLANC COUNTER = 1
006F       :SPB  =M002          CHANGE CHANGING VALUE
0070       :
0071       :
0072       :L    =H-DD          ################################
0073       :L    =H-DD          # CHANGING VALUE DOUBLE IF
0074       :+G                  # COUNTER = 1
0075       :T    =H-DD          ################################
0076       :LD   =SMAX          # CONTROL MAX. VALUE
0077       :<=G                 #
0078       :SPB  =M002          #
0079       :LD   =FMAX          # SET MAX. VALUE
007A       :T    =H-DD          ################################
007B       :
007C       :
007D M002  :UN   =MIM1          NO TACT --> NO CHANGING
007E       :BEB
007F       :
0080       :UN   =SIG+          IF NOT + THEN -
0081       :SPB  =M003
0082       :
0083       :L    =SOLL          ################################
0084       :L    =H-DD          # ADD CHANGING VALUE TO SLIT
0085       :+G                  #
0086       :T    =SOLL          # CONTROL IF MAXIMUM REACHED
0087       :LD   =SMAX          #
0088       :<=G                 #
0089       :BEB                 #
008A       :LD   =SMAX          # SET MAXIMUN
008B       :T    =SOLL          ################################
008C       :BEA
008D       :
008E       :
008F M003  :L    =SOLL          ################################
0090       :L    =H-DD          # SUB CHANGING VALUE TO SLIT
0091       :-G                  #
0092       :T    =SOLL          # CONTROL IF MINIMUM SPEED
0093       :LD   =SMIN          #
0094       :>=G                 #
0095       :BEB                 #
0096       :LD   =SMIN          # SET MINIMUM
0097       :T    =SOLL          ################################
0098       :BE
```

```
FB 82   -FB  82                      C:KERM06ST.S5D        BIB=16023   LAE=27

NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                     CALCULATE LINE SPEED IN % FOR OUTPUT                  *
*                                                                           *
*****************************************************************************
NAME :CALSPEED

0005       :A   DB 180     -DB 180
0006       :L   DD  62                          LINE SPEED IN M/MIN
0007       :L   KG +1000000+02
000A       :XG
000B       :L   KG +3780000+02
000E       ::G
000F       :L   KG +1000000+02
0012       :XG                                  --> Vline IN %
0013       :A   DB  95     -DB  95
0014       :T   DD   2
0015       :BE


DB 180    = DB 180                    PROFILE AG
DB  95    = DB  95                    GENERAL DATAS
```

```
+-------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                 !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                  !
+-------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                   !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                   1!
+-------------------------------------------------------------------------+
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                    BCD-DATAS LINEAR CHECK WEIGHER                         *
*                                                                           *
*****************************************************************************
```

NAME :MGW-ANST

```
0005      :AWL                                  BCD-DATEN
0006      :U   E   44.5  -A925.91               ################################
0007      :=   M   87.0  -M  87.0               #
0008      :U   E   44.6  -A925.92               #
0009      :=   M   87.1  -M  87.1               #   10^-3
000A      :U   E   44.7                         #
000B      :=   M   87.2  -M  87.2               #
000C      :U   E   45.0  -A925.94               #
000D      :=   M   87.3  -M  87.3               ################################
000E      :U   E   44.1  -A925.81               ////////////////////////////////
000F      :=   M   87.4  -M  87.4               /
0010      :U   E   44.2  -A925.82               /
0011      :=   M   87.5  -M  87.5               /   10^-2
0012      :U   E   44.3  -A925.83               /
0013      :=   M   87.6  -M  87.6               /
0014      :U   E   44.4  -A925.84               /
0015      :=   M   87.7  -M  87.7               ////////////////////////////////
0016      :U   E   43.5  -A925.71               ################################
0017      :=   M   86.0  -M  86.0               #
0018      :U   E   43.6  -A925.72               #
0019      :=   M   86.1  -M  86.1               #   10^-1
001A      :U   E   43.7  -A925.73               #
001B      :=   M   86.2  -M  86.2               #
001C      :U   E   44.0  -A925.74               #
001D      :=   M   86.3  -M  86.3               ################################
001E      :U   E   43.1  -A925.61               ////////////////////////////////
001F      :=   M   86.4  -M  86.4               /
0020      :U   E   43.2  -A925.62               /
0021      :=   M   86.5  -M  86.5               /   10^0
0022      :U   E   43.3  -A925.63               /
0023      :=   M   86.6  -M  86.6               /
0024      :U   E   43.4  -A925.64               /
0025      :=   M   86.7  -M  86.7               ////////////////////////////////
0026      :U   E   43.0  -A925.5                ################################
0027      :=   M   85.0  -M  85.0               #   10^1
0028      :                                     ################################
0029      :U   M   40.3  -M  40.3               ////////////////////////////////
002A      :R   M   85.1  -M  85.1               /
002B      :R   M   85.2  -M  85.2               /
002C      :R   M   85.3  -M  85.3               /
002D      :R   M   85.4  -M  85.4               /
002E      :R   M   85.5  -M  85.5               /   RESET OTHER FLAGS
002F      :R   M   85.6  -M  85.6               /
0030      :R   M   85.7  -M  85.7               /
0031      :R   M   84.0  -M  84.0               /
0032      :R   M   84.1  -M  84.1               /
0033      :R   M   84.2  -M  84.2               /
0034      :R   M   84.3  -M  84.3               /
0035      :R   M   84.4  -M  84.4               /
0036      :R   M   84.5  -M  84.5               /
0037      :R   M   84.6  -M  84.6               /
0038      :R   M   84.7  -M  84.7               ////////////////////////////////
0039      :BE
```

```
E   44.5 = A925.91          CONTINUOUS WEIGHER 5 DECADE
M   87.0 = M  87.0          0-SIGNAL BCD 1*10^3
E   44.6 = A925.92          CONTINUOUS WEIGHER 5 DECADE
M   87.1 = M  87.1          0-SIGNAL BCD 2*10^3
M   87.2 = M  87.2          0-SIGNAL BCD 4*10^3
E   45.0 = A925.94          CONTINUOUS WEIGHER 5 DECADE
```


```
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                     !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                     !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE        :                      !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER  :                     1!
+-----------------------------------------------------------------------------+
```

```
M   87.3 = M  87.3          0-SIGNAL BCD 8*10^3
E   44.1 = A925.81          CONTINUOUS WEIGHER 4 DECADE
M   87.4 = M  87.4          0-SIGNAL
E   44.2 = A925.82          CONTINUOUS WEIGHER 4 DECADE
M   87.5 = M  87.5          0-SIGNAL
E   44.3 = A925.83          CONTINUOUS WEIGHER 4 DECADE
M   87.6 = M  87.6          0-SIGNAL
E   44.4 = A925.84          CONTINUOUS WEIGHER 4 DECADE
M   87.7 = M  87.7          0-SIGNAL
E   43.5 = A925.71          CONTINUOUS WEIGHER 3 DECADE
M   86.0 = M  86.0          BCD-INPUT LINEAR CHECK WEIGHER 1*10^1
E   43.6 = A925.72          CONTINUOUS WEIGHER 3 DECADE
M   86.1 = M  86.1          0-SIGNAL BCD 2*10^1
E   43.7 = A925.73          CONTINUOUS WEIGHER 3 DECADE
M   86.2 = M  86.2          0-SIGNAL BCD 4*10^1
E   44.0 = A925.74          CONTINUOUS WEIGHER 3 DECADE
M   86.3 = M  86.3          0-SIGNAL BCD 8*10^1
E   43.1 = A925.61          CONTINUOUS WEIGHER 2 DECADE
M   86.4 = M  86.4          0-SIGNAL BCD 1*10^2
E   43.2 = A925.62          CONTINUOUS WEIGHER 2 DECADE
M   86.5 = M  86.5          0-SIGNAL BCD 2*10^2
E   43.3 = A925.63          CONTINUOUS WEIGHER 2 DECADE
M   86.6 = M  86.6          0-SIGNAL BCD 4*10^2
E   43.4 = A925.64          CONTINUOUS WEIGHER 2 DECADE
M   86.7 = M  86.7          0-SIGNAL BCD 8*10^2
E   43.0 = A925.5           CONTINUOUS WEIGHER 1 DECADE
M   85.0 = M  85.0          BCD-INPUT LINEAR CHECK WEIGHER 1*10^-1
M   40.3 = M  40.3          UP.EXTR. : IMPULSE EXTRUDER OFF
M   85.1 = M  85.1          BCD-INPUT LINEAR CHECK WEIGHER 2*10^-1
M   85.2 = M  85.2          BCD-INPUT LINEAR CHECK WEIGHER 4*10^-1
M   85.3 = M  85.3          BCD-INPUT LINEAR CHECK WEIGHER 8*10^-1
M   85.4 = M  85.4          BCD-INPUT LINEAR CHECK WEIGHER 1*10^0
M   85.5 = M  85.5          BCD-INPUT LINEAR CHECK WEIGHER 2*10^0
M   85.6 = M  85.6          BCD-INPUT LINEAR CHECK WEIGHER 4*10^0
M   85.7 = M  85.7          BCD-INPUT LINEAR CHECK WEIGHER 8*10^0
M   84.0 = M  84.0          BCD-INPUT LINEAR CHECK WEIGHER 1*10^-3
M   84.1 = M  84.1          BCD-INPUT LINEAR CHECK WEIGHER 2*10^-3
M   84.2 = M  84.2          BCD-INPUT LINEAR CHECK WEIGHER 4*10^-3
M   84.3 = M  84.3          BCD-INPUT LINEAR CHECK WEIGHER 8*10^-3
M   84.4 = M  84.4          BCD-INPUT LINEAR CHECK WEIGHER 1*10^-2
M   84.5 = M  84.5          BCD-INPUT LINEAR CHECK WEIGHER 2*10^-2
M   84.6 = M  84.6          BCD-INPUT LINEAR CHECK WEIGHER 4*10^-2
M   84.7 = M  84.7          BCD-INPUT LINEAR CHECK WEIGHER 8*10^-2
```

```
FB 84   -FB  84                          C:KERM06ST.S5D        BIB=21023   LAE=186

NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*              EVALUATION AND PICTURES LINEAR CHECK WEIGHER                 *
*                                                                           *
*****************************************************************************
NAME :M-WAAGE

0005      :***

NETZWERK 2          0006
0006      :U   E   45.1   -A925.0
0007      :UN  A   40.4   -A925.2
0008      :SPB =M001                          YES >> EVALUATION TREADWEIGHT
0009      :UN  M   81.5   -M  81.5
000A      :U   M   81.5   -M  81.5           ENTFERNEN NACH TEST
000B      :SPB =M002                          YES >> RESET OUTPUTS
000C      :BEA
000D M002 :U   M    0.0   -M   0.0
000E      :=   A   40.6   -A925.4
000F      :=   A   40.7   -A  40.7
0010      :=   A   41.0   -A925.6
0011      :BEA
0012 M001 :NOP 0                            ###### ACTUAL WEIGHT IN KG #####
0013      :L   MD  84                       H.FLAG ACTUAL WEIGHT IN BCD
0014      :DED                              BCD IN FPT
0015      :FDG                              FPT IN GPT
0016      :L   KG +1000000+04               CONST.1000
0019      ::G                               ---> LINEAR WEIGHT IN KG
001A      :A   DB 170     -DB 170           DB ACTUAL DATAS
001B      :T   DD  64                       LINEAR WEIGHT IN KG
001C      :T   MD 230                       H.FLAG
001D      :UN  E   45.2   -A925             FAULT LINEAR CHECK WEIGHER
001E      :SPB =M003                        YES >> NO FAULT
001F      :A   DB 188     -DB 188           RESET OK AND SET STATE
0020      :L   KY 0,1
0022      :T   DW  22
0023      :T   DW  65
0024      :L   KY 0,0                       RESET MIN AND MAX
0026      :T   DW  21
0027      :T   DW  23
0028      :T   DW  64
0029      :T   DW  66
002A      :BEA
002B M003 :***

E   45.1 = A925.0                  LINEAR CHECK WEIGHER BCD DATA PENDING
A   40.4 = A925.2                  LINEAR CHECK WEIGHER RESET OUTPUTS
M   81.5 = M  81.5                 LINE : LINE ON
M    0.0 = M   0.0                 "0"-SIGNAL
A   40.6 = A925.4                  LINEAR WEIGHT IS TO LOW
A   40.7 = A  40.7                 CONTINUOUS WEIGHT IS O.K.
A   41.0 = A925.6                  LINEAR WEIGHT IS TO HIGH
E   45.2 = A925                    LINEAR CHECK WEIGHER FAULT

DB 170   = DB 170                  ACTUAL DATAS
DB 188   = DB 188                  PICTURES

NETZWERK 3          002C
002C      :NOP 0                            ####### WEIGHT TO LOW? #########
002D      :A   DB 180     -DB 180
002E      :L   DD  64                       SLIT
002F      :L   DD  66                       TOLERANCE
0030      :-G                               =  MIN-    IN KG
0031      :L   MD 230                       ACTUAL WEIGHT
0032      :>G
0033      :=   A   40.6   -A925.4           OUTPUT WEIGHT TO LOW
0034      :L   DD  64                       SLIT
0035      :L   DD  66                       TOLERANCE
0036      :-G
0037      :L   DD  66                       TOLERANCE
0038      :-G                               =  MIN--     IN KG
0039      :L   MD 230                       ACTUAL WEIGHT
+-------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                 !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                  !
+-------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                   !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                  1!
+-------------------------------------------------------------------------+
```

```
003A       :>G
003B       :=   M  210.1
003C       :UN  A   40.6  -A925.4
003D       :SPB =M001
003E       :U   M    0.0  -M   0.0
003F       :=   A   40.7  -A  40.7
0040       :=   A   41.0  -A925.6
0041       :UN  M  210.1
0042       :SPB =M002
0043       :A   DB 188    -DB 188
0044       :L   KF +1
0046       :T   DL  21
0047       :T   DL  64
0048       :L   KF +0
004A       :T   DR  21
004B       :T   DW  22
004C       :T   DW  23
004D       :T   DR  64
004E       :T   DW  65
004F       :T   DW  66
0050       :BEA
0051 M002  :A   DB 188    -DB 188
0052       :L   KF +1
0054       :T   DR  21
0055       :T   DR  64
0056       :L   KF +0
0058       :T   DL  21
0059       :T   DW  22
005A       :T   DW  23
005B       :T   DL  64
005C       :T   DW  65
005D       :T   DW  66
005E       :BEA
005F M001  :***
```

H.FLAG

WITH "0" RESET OUTPUTS LINEAR
CHECK WEIGHER : WEIGHT 0.K.
WEIGHT TO HIGH

YES >> WEIGHT TO LOW (MIN-)
DB FOR PICTURES

PICTURE MIN-- D01
D03
RESET OTHER PICTURES
D01 : MIN-
OK / STATE
MAX++ / MAX+
D03 : MIN-
OK / STATE
MAX++ / MAX+

DB FOR PICTURES

PICTURE MIN- D01
D03
RESET OTHER PICTURES
D01 : MIN--
OK / STATE
MAX++ / MAX+
D03 : MIN--
OK / STATE
MAX++ / MAX+

```
A   40.6 = A925.4
M    0.0 = M   0.0
A   40.7 = A  40.7
A   41.0 = A925.6

DB 180   = DB 180
DB 188   = DB 188
```

LINEAR WEIGHT IS TO LOW
"0"-SIGNAL
CONTINUOUS WEIGHT IS O.K.
LINEAR WEIGHT IS TO HIGH

PROFILE AG
PICTURES

```
NETZWERK 4          0060
0060       :NOP 0
0061       :L   DD  64
0062       :L   DD  66
0063       :+G
0064       :L   MD 230
0065       :<G
0066       :=   A   41.0  -A925.6
0067       :L   DD  64
0068       :L   DD  66
0069       :+G
006A       :L   DD  66
006B       :+G
006C       :L   MD 230
006D       :<G
006E       :=   M  210.2
006F       :UN  A   41.0  -A925.6
0070       :SPB =M001
0071       :U   M    0.0  -M   0.0
0072       :=   A   40.6  -A925.4
0073       :=   A   40.7  -A  40.7
0074       :UN  M  210.2
0075       :SPB =M002
0076       :A   DB 188    -DB 188
0077       :L   KF +1
0079       :T   DL  23
007A       :T   DL  66
007B       :L   KF +0
007D       :T   DW  21
007E       :T   DW  22
007F       :T   DR  23
```

WEIGHT TO HIGH?
SLIT IN KG
TOLERANCE IN KG
= MAX+
ACTUAL WEIGHT IN KG

OUTPUT WEIGHT TO HIGH
SLIT
TOLERANCE

TOLERANCE
= MAX++
ACTUAL WEIGHT

H.FLAG

YES >> NO OVERWEIGHT
RESET OTHER OUTPUTS LINEAR CHECK
WEIGHER : WEIGHT TO LOW
WEIGHT O.K.

YES >> OVERWEIGHT AND MAX+
DB FOR PICTURES

PICTURE MAX++ D01
D03
RESET OTHER PICTURES
D01 : MIN-- / MIN-
OK / STATE
MAX+

```
0080       :T   DW  64
0081       :T   DW  65
0082       :T   DR  66
0083       :BEA
0084 M002  :A   DB 188     -DB 188
0085       :L   KF +1
0087       :T   DR  23
0088       :T   DR  66
0089       :L   KF +0
008B       :T   DW  21
008C       :T   DW  22
008D       :T   DL  23
008E       :T   DW  64
008F       :T   DW  65
0090       :T   DL  66
0091       :BEA
0092 M001  :***
```

```
A   41.0 = A925.6
M    0.0 = M   0.0
A   40.6 = A925.4
A   40.7 = A  40.7
```

```
DB 188   = DB 188
```

```
NETZWERK 5          0093
0093       :NOP 0
0094       :UN  A   40.6  -A925.4
0095       :UN  A   41.0  -A925.6
0096       :=   A   40.7  -A  40.7
0097       :UN  A   40.7  -A  40.7
0098       :SPB =M001
0099       :A   DB 188    -DB 188
009A       :L   KY 1,0
009C       :T   DW  22
009D       :T   DW  65
009E       :L   KF +0
00A0       :T   DW  21
00A1       :T   DW  23
00A2       :T   DW  64
00A3       :T   DW  66
00A4       :BEA
00A5 M001  :A   DB 188    -DB 188
00A6       :L   KF +0
00A8       :T   DW  21
00A9       :T   DL  22
00AA       :T   DW  23
00AB       :T   DW  64
00AC       :T   DL  65
00AD       :T   DW  66
00AE       :U   M    0.0  -M   0.0
00AF       :=   A   40.6  -A925.4
00B0       :=   A   40.7  -A  40.7
00B1       :=   A   41.0  -A925.6
00B2       :***
```

```
A   40.6 = A925.4
A   41.0 = A925.6
A   40.7 = A  40.7
M    0.0 = M   0.0
```

```
DB 188   = DB 188
```

```
NETZWERK 6          00B3
00B3       :AWL
00B4       :BE
```

```
D03 : MIN-- / MIN-
      OK    / STATE
      MAX+

DB FOR PICTURES

PICTURE MAX+  D01
              D03
RESET OTHER PICTURES
D01 : MIN-- / MIN-
      OK    / STATE
      MAX++
D03 : MIN-- / MIN-
      OK    / STATE
      MAX++
```

```
LINEAR WEIGHT IS TO HIGH
"0"-SIGNAL
LINEAR WEIGHT IS TO LOW
CONTINUOUS WEIGHT IS O.K.
```

```
PICTURES
```

```
###### LINEAR WEIGHT OK? #######
WEIGHT TO LOW
WEIGHT TO HIGH
WEIGHT O.K.

YES >> FAULT
DB FOR PICTURES

PICTURE OK  D01
            D03
RESET OTHER PICTURES
D01 : MIN-- / MIN-
      MAX++ / MAX+
D03 : MIN-- / MIN-
      MAX++ / MAX+

DB FOR PICTURES
RESET ALL PICTURES
D01 : MIN-- / MIN-
      OK
      MAX++ / MAX+
D03 : MIN-- / MIN-
      OK
      MAX++ / MAX+
WITH "0"-SIGNAL
RESET ALL OUTPUTS LINEAR CHECK
                  WEIGHER
```

```
LINEAR WEIGHT IS TO LOW
LINEAR WEIGHT IS TO HIGH
CONTINUOUS WEIGHT IS O.K.
"0"-SIGNAL
```

```
PICTURES
```

```
FB 86   -FB  86                        C:KERM06ST.S5D        BIB=6023     LAE=57

NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                          BCD-DATAS TREAD CHECK WEIGHER                    *
*                                                                           *
*****************************************************************************


NAME :TREAD-W

0005      :***

NETZWERK 2           0006
0006      :U   E   72.1  -A942.44          ////////////////////////////////
0007      :=   M  223.0                    /
0008      :U   E   72.0  -A942.43          /
0009      :=   M  223.1                    /   10^-2
000A      :U   E   71.7  -A942.42          /
000B      :=   M  223.2                    /
000C      :U   E   71.6  -A942.41          /
000D      :=   M  223.3                    ////////////////////////////////
000E      :U   E   71.5  -A942.34          ################################
000F      :=   M  223.4                    #
0010      :U   E   71.4  -A942.33          #
0011      :=   M  223.5                    #
0012      :U   E   71.3  -A942.32          #   10^-1
0013      :=   M  223.6                    #
0014      :U   E   71.2  -A942.31          #
0015      :=   M  223.7                    ################################
0016      :U   E   71.1  -A942.24          ////////////////////////////////
0017      :=   M  222.0                    /
0018      :U   E   71.0  -A942.23          /
0019      :=   M  222.1                    /
001A      :U   E   70.7  -A942.22          /   10^0
001B      :=   M  222.2                    /
001C      :U   E   70.6  -A942.21          /
001D      :=   M  222.3                    ////////////////////////////////
001E      :U   E   70.5  -A942.14          ################################
001F      :=   M  222.4                    #
0020      :U   E   70.4  -A942.13          #
0021      :=   M  222.5                    #
0022      :U   E   70.3  -A942.12          #   10^1
0023      :=   M  222.6                    #
0024      :U   E   70.2  -A942.11          #
0025      :=   M  222.7                    ################################
0026      :L   KB 0
0027      :T   MW 220
0028      :L   MD 220
0029      :DED                             BCD ---> FP
002A      :FDG                             FP ---> GP
002B      :L   KG +1000000+03
002E      ::G
002F      :T   MD 230
0030      :A   DB 170    -DB 170           DB ACTUAL DATAS
0031      :T   DD  70                      TREAD WEIGHT IN ??.?? KG
0032      :***

E   72.1 = A942.44          TREAD CHECKER BCD-CODE 1 * 10^-2
E   72.0 = A942.43          TREAD CHECKER BCD-CODE 2 * 10^-2
E   71.7 = A942.42          TREAD CHECKER BCD-CODE 4 * 10^-2
E   71.6 = A942.41          TREAD CHECKER BCD-CODE 8 * 10^-2
E   71.5 = A942.34          TREAD CHECKER BCD-CODE 1 * 10^-1
E   71.4 = A942.33          TREAD CHECKER BCD-CODE 2 * 10^-1
E   71.3 = A942.32          TREAD CHECKER BCD-CODE 4 * 10^-1
E   71.2 = A942.31          TREAD CHECKER BCD-CODE 8 * 10^-1
E   71.1 = A942.24          TREAD CHECKER BCD-CODE 1 * 10^0
E   71.0 = A942.23          TREAD CHECKER BCD-CODE 2 * 10^0
E   70.7 = A942.22          TREAD CHECKER BCD-CODE 4 * 10^0
E   70.6 = A942.21          TREAD CHECKER BCD-CODE 8 * 10^0
E   70.5 = A942.14          TREAD CHECKER BCD-CODE 1 * 10^1


+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                     !
!ELASTOMERTECHNIK          WERK HARBURG  !  MASTERPROGRAMM                     !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE         !  DATE        :                     !
! INSTALLATION     : TREAD-LINE          !  MODIFICATION:                PGNO!
! PROJECT POS. NO.: 84/823804            !  PROGRAMMER  :                   1!
+-----------------------------------------------------------------------------+
```

```
FB 86   -FB  86                          C:KERM06ST.S5D        BIB=6023    LAE=57

E   70.4 = A942.13                       TREAD CHECKER BCD-CODE 2 * 10^1
E   70.3 = A942.12                       TREAD CKECKER BCD-CODE 4 * 10^1
E   70.2 = A942.11                       TREAD CHECKER BCD-CODE 8 * 10^1

DB 170   = DB 170                        ACTUAL DATAS

NETZWERK 3          0033
0033      :BE
```

KRUPP KUNSTOFFTECHNIK			
ELASTOMERTECHNIK	WERK HARBURG	MASTERPROGRAMM	
PROJECT	: KERMAN TIRE	DATE	:
INSTALLATION	: TREAD-LINE	MODIFICATION:	PGNO
PROJECT POS. NO.	: 84/823804	PROGRAMMER	: 2

```
FB 87    -FB  87                        C:KERM06ST.S5D        BIB=13023    LAE=196

NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*               EVALUATION AND PICTURES TREAD CHECK WEIGHER                 *
*                                                                           *
*****************************************************************************
NAME :S-WAAGE

0005       :***

NETZWERK 2          0006
0006       :U    M   88.4   -M  88.4
0007       :SPB =M001                          YES >> EVALUATION TREADWEIGHT
0008       :UN   M   81.5   -M  81.5
0009       :SPB =M002                          YES >> RESET OUTPUTS
000A       :BEA
000B M002  :U    M    0.0   -M   0.0
000C       :=    A   70.3   -A942.4
000D       :=    A   70.4   -A942.5
000E       :=    A   70.5   -A942.6
000F       :A    DB 170     -DB 170
0010       :L    KG +0000000+00
0013       :T    DD  70
0014       :A    DB 188     -DB 188
0015       :L    KY 1,0
0017       :T    DW  31
0018       :T    DW  98
0019       :L    KY 0,0
001B       :T    DW  32
001C       :T    DW  33
001D       :T    DW  99
001E       :T    DW 100
001F       :BEA
0020 M001  :NOP 0                           ###### ACTUAL WEIGHT IN KG #####
0021       :A    DB 170     -DB 170        DB ACTUAL DATAS
0022       :L    DD  70                    TREAD WEIGHT IN KG
0023       :T    MD 230                    H.FLAG
0024       :UN   E   70.1   -A942.02       FAULT TREAD CHECK WEIGHER
0025       :SPB =M003                      YES >> NO FAULT
0026       :A    DB 188     -DB 188        RESET OK AND SET STATE
0027       :L    KY 0,1
0029       :T    DW  32
002A       :T    DW  99
002B       :L    KY 0,0                    RESET MIN AND MAX
002D       :T    DW  31
002E       :T    DW  33
002F       :T    DW  98
0030       :T    DW 100
0031       :BEA
0032 M003  :***

M   88.4 = M  88.4                          TREAD CHECKER : IMPULSE EVALUATE WEIGHT
M   81.5 = M  81.5                          LINE : LINE ON
M    0.0 = M   0.0                          "0"-SIGNAL
A   70.3 = A942.4                           TREAD CHECKER UNDERWEIGHT
A   70.4 = A942.5                           TREAD CHECKER WEIGHT OK
A   70.5 = A942.6                           TREAD CHECKER OVERWEIGHT
E   70.1 = A942.02                          TREAD CHECKER FAULT

DB 170   = DB 170                          ACTUAL DATAS
DB 188   = DB 188                          PICTURES

NETZWERK 3          0033
0033       :NOP 0                           ####### WEIGHT TO LOW? #########
0034       :A    DB 180     -DB 180
0035       :L    DD  70                    SLIT
0036       :L    DD  72                    TOLERANCE
0037       :-G                             =  MIN-    IN KG
0038       :L    MD 230                    ACTUAL WEIGHT
0039       :>G
003A       :=    A   70.3   -A942.4         OUTPUT WEIGHT TO LOW
003B       :=    M   62.3   -M  62.3
003C       :L    DD  70                    SLIT
+-------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                 !
!ELASTOMERTECHNIK          WERK HARBURG  !  MASTERPROGRAMM                 !
+-------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE         !  DATE        :                 !
! INSTALLATION     : TREAD-LINE          !  MODIFICATION:            PGNO!
! PROJECT POS. NO.: 84/823804            !  PROGRAMMER  :               1!
+-------------------------------------------------------------------------+
```

```
003D       :L   DD  72                          TOLERANCE
003E       :-G
003F       :L   DD  72                          TOLERANCE
0040       :-G                                  = MIN--     IN KG
0041       :L   MD 230                          ACTUAL WEIGHT
0042       :>G
0043       :=   M  210.1                        H.FLAG
0044       :UN  A   70.3  -A942.4
0045       :SPB =M001
0046       :U   M    0.0  -M   0.0              WITH "0" RESET OUTPUTS TREAD
0047       :=   A   70.4  -A942.5               CHECK WEIGHER : WEIGHT 0.K.
0048       :=   A   70.5  -A942.6                               WEIGHT TO HIGH
0049       :UN  M  210.1
004A       :SPB =M002                           YES >> WEIGHT TO LOW (MIN-)
004B       :A   DB 188    -DB 188               DB FOR PICTURES
004C       :L   KF +1
004E       :T   DL  31                          PICTURE MIN--  D01
004F       :T   DL  98                                         D05
0050       :L   KF +0                           RESET OTHER PICTURES
0052       :T   DR  31                          D01 : MIN-
0053       :T   DW  32                                OK     / STATE
0054       :T   DW  33                                MAX++ / MAX+
0055       :T   DR  98                          D05 : MIN-
0056       :T   DW  99                                OK     / STATE
0057       :T   DW 100                                MAX++ / MAX+
0058       :BEA
0059 M002  :A   DB 188    -DB 188               DB FOR PICTURES
005A       :L   KF +1
005C       :T   DR  21                          PICTURE MIN-  D01
005D       :T   DR  98                                        D05
005E       :L   KF +0                           RESET OTHER PICTURES
0060       :T   DL  21                          D01 : MIN--
0061       :T   DW  22                                OK     / STATE
0062       :T   DW  23                                MAX++ / MAX+
0063       :T   DL  98                          D05 : MIN--
0064       :T   DW  99                                OK     / STATE
0065       :T   DW 100                                MAX++ / MAX+
0066       :BEA
0067 M001  :***

A   70.3 = A942.4                               TREAD CHECKER UNDERWEIGHT
M   62.3 = M  62.3                              TREAD CHECKER : SCRAP (FB87)
M    0.0 = M   0.0                              "0"-SIGNAL
A   70.4 = A942.5                               TREAD CHECKER WEIGHT OK
A   70.5 = A942.6                               TREAD CHECKER OVERWEIGHT

DB 180   = DB 180                               PROFILE AG
DB 188   = DB 188                               PICTURES

NETZWERK 4          0068
0068       :NOP 0                                ###### WEIGHT TO HIGH? #########
0069       :L   DD  70                           SLIT       IN KG
006A       :L   DD  72                           TOLERANCE  IN KG
006B       :+G                                   = MAX+
006C       :L   MD 230                           ACTUAL WEIGHT  IN KG
006D       :<G
006E       :=   A   70.5  -A942.6                OUTPUT WEIGHT TO HIGH
006F       :=   M   62.3  -M  62.3
0070       :L   DD  70                           SLIT
0071       :L   DD  72                           TOLERANCE
0072       :+G
0073       :L   DD  72                           TOLERANCE
0074       :+G                                   = MAX++
0075       :L   MD 230                           ACTUAL WEIGHT
0076       :<G
0077       :=   M  210.2                         H.FLAG
0078       :UN  A   70.5  -A942.6
0079       :SPB =M001                            YES >> NO OVERWEIGHT
007A       :U   M    0.0  -M   0.0              RESET OTHER OUTPUTS TREAD CHECK
007B       :=   A   70.3  -A942.4                WEIGHER : WEIGHT TO LOW
007C       :=   A   70.4  -A942.5                          WEIGHT O.K.
007D       :UN  M  210.2
007E       :SPB =M002                            YES >> OVERWEIGHT AND MAX+
007F       :A   DB 188    -DB 188               DB FOR PICTURES
```

```
0080       :L   KF +1
0082       :T   DL  33
0083       :T   DL 100
0084       :L   KF +0
0086       :T   DW  31
0087       :T   DW  32
0088       :T   DR  33
0089       :T   DW  98
008A       :T   DW  99
008B       :T   DR 100
008C       :BEA
008D M002  :A   DB 188     -DB 188
008E       :L   KF +1
0090       :T   DR  33
0091       :T   DR 100
0092       :L   KF +0
0094       :T   DW  31
0095       :T   DW  32
0096       :T   DL  33
0097       :T   DW  98
0098       :T   DW  99
0099       :T   DL 100
009A       :BEA
009B M001  :***
```

```
PICTURE MAX++  D01
               D05
RESET OTHER PICTURES
D01 : MIN-- / MIN-
      OK    / STATE
      MAX+
D05 : MIN-- / MIN-
      OK    / STATE
      MAX+

DB FOR PICTURES

PICTURE MAX+  D01
              D05
RESET OTHER PICTURES
D01 : MIN-- / MIN-
      OK    / STATE
      MAX++
D05 : MIN-- / MIN-
      OK    / STATE
      MAX++
```

```
A   70.5 = A942.6
M   62.3 = M  62.3
M    0.0 = M   0.0
A   70.3 = A942.4
A   70.4 = A942.5
```

TREAD CHECKER OVERWEIGHT
TREAD CHECKER : SCRAP (FB87)
"0"-SIGNAL
TREAD CHECKER UNDERWEIGHT
TREAD CHECKER WEIGHT OK

```
DB 188   = DB 188
```

PICTURES

```
NETZWERK 5          009C
009C       :NOP 0
009D       :UN  A   70.3  -A942.4
009E       :UN  A   70.5  -A942.6
009F       :=   A   70.4  -A942.5
00A0       :=   M   62.4  -M  62.4
00A1       :UN  A   70.4  -A942.5
00A2       :SPB =M001
00A3       :A   DB 188    -DB 188
00A4       :L   KY 1,0
00A6       :T   DW  32
00A7       :T   DW  99
00A8       :L   KF +0
00AA       :T   DW  31
00AB       :T   DW  33
00AC       :T   DW  98
00AD       :T   DW 100
00AE       :BEA
00AF M001  :A   DB 188    -DB 188
00B0       :L   KF +0
00B2       :T   DW  31
00B3       :T   DL  32
00B4       :T   DW  33
00B5       :T   DW  98
00B6       :T   DL  99
00B7       :T   DW 100
00B8       :U   M    0.0  -M   0.0
00B9       :=   A   70.3  -A942.4
00BA       :=   A   70.4  -A942.5
00BB       :=   A   70.5  -A942.6
00BC       :***
```

```
###### TREAD WEIGHT OK? #######
WEIGHT TO LOW
WEIGHT TO HIGH
WEIGHT O.K.


YES >> FAULT
DB FOR PICTURES

PICTURE OK  D01
            D05
RESET OTHER PICTURES
D01 : MIN-- / MIN-
      MAX++ / MAX+
D05 : MIN-- / MIN-
      MAX++ / MAX+

DB FOR PICTURES
RESET ALL PICTURES
D01 : MIN-- / MIN-
      OK
      MAX++ / MAX+
D05 : MIN-- / MIN-
      OK
      MAX++ / MAX+
WITH "0"-SIGNAL
RESET ALL OUTPUTS TREAD CHECK
                  WEIGHER
```

```
A   70.3 = A942.4
A   70.5 = A942.6
A   70.4 = A942.5
M   62.4 = M  62.4
M    0.0 = M   0.0
```

TREAD CHECKER UNDERWEIGHT
TREAD CHECKER OVERWEIGHT
TREAD CHECKER WEIGHT OK
TREAD CHECKER : WEIGHT OK (FB87)
"0"-SIGNAL

```
NETZWERK 6          00BD
00BD       :AWL
00BE       :BE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                        EVALUATION WIDTH MEASURING DEVICE                  *
*                                                                           *
*****************************************************************************


NAME :WIDTH-E

0005       :***

NETZWERK 2          0006
0006       :U   E   42.4  -A925.04
0007       :SPB =M001
0008       :A   DB 170    -DB 170                  ##################################
0009       :L   KG +0000000+00                     #  RESET WIDTH
000C       :T   DD 102                             ##################################
000D       :BEA
000E M001  :U   E   40.1  -A925.11                  ////////////////////////////////
000F       :=   M  223.0                           /
0010       :U   E   40.2  -A925.12                 /
0011       :=   M  223.1                           /   10^0
0012       :U   E   40.3  -A925.13                 /
0013       :=   M  223.2                           /
0014       :U   E   40.4  -A925.14                 /
0015       :=   M  223.3                           ////////////////////////////////
0016       :U   E   40.5  -A925.21                 ##################################
0017       :=   M  223.4                           #
0018       :U   E   40.6  -A925.22                 #
0019       :=   M  223.5                           #   10^1
001A       :U   E   40.7  -A925.23                 #
001B       :=   M  223.6                           #
001C       :U   E   41.0  -A925.24                 #
001D       :=   M  223.7                           ##################################
001E       :U   E   41.1  -A925.31                 ////////////////////////////////
001F       :=   M  222.0                           /
0020       :U   E   41.2  -A925.32                 /
0021       :=   M  222.1                           /   10^3
0022       :U   E   41.3  -A925.33                 /
0023       :=   M  222.2                           /
0024       :U   E   41.4  -A925.34                 /
0025       :=   M  222.3                           ////////////////////////////////
0026       :U   E   41.5  -A925.41                 ##################################
0027       :=   M  222.4                           #
0028       :U   E   41.6  -A925.42                 #
0029       :=   M  222.5                           #   10^4
002A       :U   E   41.7  -A925.43                 #
002B       :=   M  222.6                           #
002C       :U   E   42.0  -A925.44                 #
002D       :=   M  222.7                           ##################################
002E       :L   KB 0                               SET 10^5 - 10^7 TO "0"
002F       :T   MW 220
0030       :L   MD 220
0031       :DED                                    BCD ---> FP
0032       :FDG                                    FP ---> GP
0033       :T   MD 224
0034       :L   KG +8000000+03
0037       :<G
0038       :SPB =M002
0039       :L   KG +0000000+00
003C       :A   DB 170    -DB 170
003D       :T   DD 102
003E       :BEA
003F M002  :A   DB 170    -DB 170
0040       :L   MD 224
0041       :T   DD 102                             XXX.X mm
0042       :***

E   42.4 = A925.04                    WIDTH MEASURING DEVICE FAULT
```

E	40.1 = A925.11	WIDTH MEASURING DEVICE 1 DECADE
E	40.2 = A925.12	WIDTH MEASURING DEVICE 1 DECADE
E	40.3 = A925.13	WIDTH MEASURING DEVICE 1 DECADE
E	40.4 = A925.14	WIDTH MEASURING DEVICE 1 DECADE
E	40.5 = A925.21	WIDTH MEASURING DEVICE 2 DECADE
E	40.6 = A925.22	WIDTH MEASURING DEVICE 2 DECADE
E	40.7 = A925.23	WIDTH MEASURING DEVICE 2 DECADE
E	41.0 = A925.24	WIDTH MEASURING DEVICE 2 DECADE
E	41.1 = A925.31	WIDTH MEASURING DEVICE 3 DECADE
E	41.2 = A925.32	WIDTH MEASURING DEVICE 3 DECADE
E	41.3 = A925.33	WIDTH MEASURING DEVICE 3 DECADE
E	41.4 = A925.34	WIDTH MEASURING DEVICE 3 DECADE
E	41.5 = A925.41	WIDTH MEASURING DEVICE 4 DECADE
E	41.6 = A925.42	WIDTH MEASURING DEVICE 4 DECADE
E	41.7 = A925.43	WIDTH MEASURING DEVICE 4 DECADE
E	42.0 = A925.44	WIDTH MEASURING DEVICE 4 DECADE

DB 170 = DB 170 ACTUAL DATAS

NETZWERK 3 0043
0043 :BE

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                    WIDTH MEASURING DEVICE AND LINE SPEED                  *
*                                                                           *
*****************************************************************************
```

NAME :WIDTH-R.

```
0005      :ON  A    0.1  -43A1/2          TOPM CONTROLLER RELEASE
0006      :ON  A    1.1  -A  1.1          BOTM CONTROLLER RELEASE
0007      :ON  M    9.3  -M   9.3         PROGRAM IS RUNNING
0008      :BEB                            NO SETTLEMENT
0009      :A   DB 180    -DB 180          DB ACTUAL PROFIL
000A      :L   DD 102                     PRESET WIDTH
000B      :A   DB 170    -DB 170          DB ACTUAL DATAS
000C      :L   DD 102                     ACTUAL WIDTH
000D      :-G
000E      :T   MD 200                     MEMORY : PRESET - ACTUAL
000F      :L   KG +1000000+02             = + 10mm
0012      :>=G                            MEMORY >= + 10mm
0013      :BEB                            NO SETTLEMENT
0014      :L   MD 200
0015      :L   KG -9999998+01
0018      :<=G                            MEMORY <= - 10mm
0019      :BEB                            NO SETTLEMENT
001A      :A   DB 170    -DB 170
001B      :L   KG +7000000+01             DISTANCE DEH-WEIGHER IN m
001E      :L   DD  62                     ACTUAL LINE SPEED IN m/min
001F      ::G                             t = s/v IN min
0020      :L   KG +6000000+02
0023      :XG                             t = s/v IN sec
0024      :GFD                            GP-ZAHL IN FP-ZAHL
0025      :DUD                            FP-ZAHL IN BCD-ZAHL
0026      :T   MD 204
0027      :U   M    0.1  -M   0.1         ////////////////////////////////
0028      :S   M  206.5                   / TIMER-SET WITH KT???.2
0029      :R   M  206.4                   ////////////////////////////////
002A      :U   T  151    -T 151
002B      :S   M   83.7  -M  83.7
002C      :L   MW 206
002D      :UN  E   82.6  -203S7.1
002E      :UN  E   82.7  -203S7.2
002F      :UN  T  151    -T 151
0030      :UN  M   83.7  -M  83.7
0031      :BEB
0032      :U   M    0.0  -M   0.0
0033      :ON  M    0.0  -M   0.0
0034      :R   M   83.7  -M  83.7
0035      :A   DB 180    -DB 180
0036      :L   DD 102
0037      :A   DB 170    -DB 170
0038      :L   DD 102
0039      :-G
003A      :T   MD 220                     MEMORY : PRESET - ACTUAL WIDTH
003B      :L   KG +5000000+00             = + 0.5 mm
003E      :<G                             MEMORY < + 0.5 mm
003F      :=   M  210.0                   NO SETTLEMENT
0040      :L   MD 220
0041      :L   KG -5000000+00             = - 0.5 mm
0044      :>G                             MEMORY > - 0.5 mm
0045      :=   M  210.1                   NO SETTLEMENT
0046      :U   M  210.0
0047      :U   M  210.1
0048      :BEB                            NO SETTLEMENT
0049      :A   DB 170    -DB 170
004A      :L   DD 102                     ACTUAL WIDTH
004B      :A   DB 180    -DB 180
004C      :L   DD 102                     PRESET WIDTH
004D      ::G                             A = (ACTUAL WIDTH/PRESET W.)
004E      :A   DB 170    -DB 170
004F      :L   DD  62                     ACTUAL LINE SPEED
```

```
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                    !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                    !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                    !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                    1!
+-----------------------------------------------------------------------------+
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                    RECIEVE DATAS FROM 115U  (DB21)                        *
*                                                                           *
*****************************************************************************
```

NAME :R-SLAVE1

```
0005       :SPA FB 123    -FB 123
0006 NAME  :CONTROL
0007 SSNR  :    KY 0,20
0008 A-NR  :    KY 0,101                          RECIEVE FROM SLAVE 1
0009 ANZW  :    MW  75    -MW  75
000A PAFE  :    MB 200
000B       :
000C       :U   M   76.0  -M  76.0
000D       :SPB FB 121    -FB 121
000E NAME  :RECEIVE
000F SSNR  :    KY 0,20
0010 A-NR  :    KY 0,101
0011 ANZW  :    MW  77
0012 ZTYP  :    KC DB
0013 DBNR  :    KY 0,21                           RECIEVE DB21
0014 ZANF  :    KF +1                             FIRST RECIEVED DW AFTER DW1
0015 ZLAE  :    KF +21                            20 DW TO RECIEVE
0016 PAFE  :    MB 203
0017       :                                      FIRST RECIEVED DW IS IN DB21
0018       :BE                                    ON POSITION DL2
```

```
MW  75    = MW  75                    SEND TO 115U
M   76.0  = M  76.0                   RECEIVE FROM SLAVE 1

FB 123    = FB 123                    CONTROL (S)
FB 121    = FB 121                    RECEIVE (S)
```

```
+-----------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                !
+-----------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE        :                 !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:              PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER  :                 1!
+-----------------------------------------------------------------------+
```

```
003C        :L   DD 102                          SLIT        IN MM
003D        :L   KG +2000000+01                  TOLERANCE   IN MM
0040        :+G                                  = MAX
0041        :L   MD 230                          ACTUAL WIDTH IN MM
0042        :<G
0043        :=   M  210.2                        OUTPUT WIDTH MAX
0044        :UN  M  210.2
0045        :SPB =M001                           YES >> NO WIDTH MAX
0046        :A   DB 188     -DB 188              DB FOR PICTURES
0047        :L   KF +1
0049        :T   DR  24                          PICTURE MAX  D01
004A        :T   DR  67                                      D03
004B        :L   KF +0                           RESET OTHER PICTURES
004D        :T   DL  24                          D01 : MIN
004E        :T   DW  25                                OK     / STATE
004F        :T   DL  67                          D05 : MIN
0050        :T   DW  68                                OK     / STATE
0051        :BEA
0052 M001   :***
```

DB 188 = DB 188 PICTURES

```
NETZWERK 5          0053
0053        :NOP 0                               ###### WIDTH OK ? #############
0054        :UN  M  210.1                        WIDTH MIN
0055        :UN  M  210.2                        WIDTH MAX
0056        :=   M  210.3                        WIDTH O.K.
0057        :UN  M  210.3
0058        :SPB =M001                           YES >> FAULT
0059        :A   DB 188     -DB 188              DB FOR PICTURES
005A        :L   KY 1,0
005C        :T   DW  25                          PICTURE OK  D01
005D        :T   DW  68                                      D03
005E        :L   KF +0                           RESET OTHER PICTURES
0060        :T   DW  24                          D01 : MIN / MAX
0061        :T   DW  67                          D03 : MIN / MAX
0062        :BEA
0063 M001   :A   DB 188     -DB 188              DB FOR PICTURES
0064        :L   KF +0                           RESET ALL PICTURES
0066        :T   DW  24                          D01 : MIN / MAX
0067        :T   DW  25                                OK  / STATE
0068        :T   DW  67                          D05 : MIN / MAX
0069        :T   DW  68                                OK  / STATE
006A        :***
```

DB 188 = DB 188 PICTURES

```
NETZWERK 6          006B
006B        :BE
```

```
FB 95   -FB  95                          C:KERM06ST.S5D        BIB=10033   LAE=69

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                          PICTURES LENGTH MEASURING DEVICE                   *
*                                                                             *
*******************************************************************************
NAME :CKECKLMD

0005       :***

NETZWERK 2          0006
0006       :A    DB 180     -DB 180
0007       :L    DW 100                          PRESET LENGTH
0008       :L    KF +5                           TOLERANCE
000A       :+F
000B       :A    DB  21     -DB  21
000C       :L    DW   9                          LENGTH FROM LMD
000D       :<F
000E       :=    M  200.0                        TREAD IS TO LONG
000F       :A    DB 180     -DB 180
0010       :L    DW 100                          PRESET LENGTH
0011       :L    KF +5                           TOLERANCE
0013       :-F
0014       :A    DB  21     -DB  21
0015       :L    DW   9                          LENGTH FROM LMD
0016       :>F
0017       :=    M  200.1                        TREAD IS TO SHORT
0018       :UN   M  200.0
0019       :SPB =M001                            YES >> TREAD IS NOT TO LONG
001A       :A    DB 188     -DB 188
001B       :L    KF +1
001D       :T    DR  34                          SET +
001E       :L    KF +0
0020       :T    DL  34                          RESET -
0021       :T    DL  35                          RESET OK
0022       :SPA =M002
0023 M001  :UN   M  200.1
0024       :SPB =M003                            YES >> TREAD IS NOT TO SHORT
0025       :A    DB 188     -DB 188
0026       :L    KF +1
0028       :T    DL  34                          SET -
0029       :L    KF +0
002B       :T    DR  34                          RESET +
002C       :T    DL  35                          RESET OK
002D       :SPA =M002
002E M003  :UN   M  200.0
002F       :UN   M  200.1
0030       :SPB =M004                            YES >> TREADLENGTH IS OK
0031       :A    DB 188     -DB 188
0032       :L    KF +0
0034       :T    DW  34                          RESET + / -
0035       :T    DW  35                          RESET OK
0036       :SPA =M002
0037 M004  :A    DB 188     -DB 188
0038       :L    KF +1
003A       :T    DL  35                          SET OK
003B       :L    KF +0
003D       :T    DW  34                          RESET + / -
003E M002  :***


DB 180    = DB 180                    PROFILE AG
DB  21    = DB  21                    RECEIVE DATAS FROM SLAVE-No1 (115U)
DB 188    = DB 188                    PICTURES

NETZWERK 3          003F
003F       :BE
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                          CALCULATE SPEED CALENDER                         *
*                                                                           *
*****************************************************************************
NAME :SPEED-C.

0005       :A   DB  95    -DB  95
0006       :UN  E   62.3  -287S46.2
0007       :SPB =M001
0008       :L   DD   4                    YES >> SPEED CALENDER MANUAL
0009       :T   DD  10                    SPEED WITH REGULATOR
000A       :BEA                           SPEED OUTPUT
000B M001  :L   DD   4
000C       :L   DD   6                    SPEED WITH REGULATOR
000D       :XG                            COUPLE FACTOR
000E       :T   DD  10
000F       :BE                            SPEED OUTPUT

E   62.3 = 287S46.2                       CALENDER AUTOMATIC/MANUAL    (CAL PANEL)

DB  95   = DB  95                         GENERAL DATAS
```

```
FB 98    -FB  98                          C:KERM06ST.S5D        BIB=18031   LAE=27

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                        FLOATING-POINT NUMBER ---> BCD-NUMBER                *
*                                                                             *
*******************************************************************************
NAME :KG = BCD
BEZ  :A-DB       E/A/D/B/T/Z: B
BEZ  :DDKG       E/A/D/B/T/Z: E  BI/BY/W/D: D
BEZ  :BCDW       E/A/D/B/T/Z: A  BI/BY/W/D: W

000E       :B    =A-DB                    CALL DB
000F       :L    =DDKG                    LOAD FLOATING-POINT NUMBER
0010       :GFD                           FLOATING-P. ---> FIXED-P.NUMBER
0011       :DUD                           FIXED-POINT NUMBER ---> BCD-NUM.
0012       :T    MD 220                   SAVE
0013       :L    MW 222                   LOAD LAST 4 DIGITS
0014       :T    =BCDW                    OUTPUT OF THE 4 DIGITS
0015       :BE
```

KRUPP KUNSTOFFTECHNIK ELASTOMERTECHNIK WERK HARBURG		MASTERPROGRAMM	
PROJECT	: KERMAN TIRE	DATE :	
INSTALLATION	: TREAD-LINE	MODIFICATION:	PGNO
PROJECT POS. NO.	: 84/823804	PROGRAMMER :	1

NETZWERK 1 0000

```
*********************************************************************************
*                                                                               *
*                                    CICLETIME                                  *
*                                                                               *
*********************************************************************************
NAME :ZYKLZEIT

0005       :A   DB 170     -DB 170
0006       :UN  T  109     -T 109
0007       :SPB =M001
0008       :L   KF +10000
000A       :L   DW   2
000B       ::F
000C       :T   DW   3
000D       :L   KH 0000
000F       :T   DW   2
0010 M001  :
0011       :L   DW   2
0012       :ADD KF +1
0014       :T   DW   2
0015       :UN  T  109     -T 109
0016       :L   KT 100.1
0018       :SE  T  109     -T 109
0019       :BE
```

T 109 = T 109 CICLETIME

DB 170 = DB 170 ACTUAL DATAS

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                          CICLE MOVE - REGISTER                            *
*                                                                           *
*****************************************************************************
NAME :ZYKFLAGS

0005      :                                  ZYKLUSMERKER SCHIEBEREGISTER
0006      :UN  M  105.1  -M 105.1            1.ZYKLUS
0007      :UN  M  105.2  -M 105.2            2.ZYKLUS
0008      :UN  M  105.3  -M 105.3            3.ZYKLUS
0009      :UN  M  105.4  -M 105.4            4.ZYKLUS
000A      :UN  M  105.5  -M 105.5            5.ZYKLUS
000B      :UN  M  105.6  -M 105.6            6.ZYKLUS
000C      :UN  M  105.7  -M 105.7            7.ZYKLUS
000D      :UN  M  104.0  -M 104.0            8.ZYKLUS
000E      :=   M  105.0  -M 105.0
000F      :R   M  104.1  -M 104.1
0010      :L   MW 104    -MW 104
0011      :SLW      1
0012      :T   MW 104    -MW 104
0013      :BE

M  105.1 = M 105.1                  CICLE MOVE REGISTER
M  105.2 = M 105.2                  CICLE MOVE REGISTER
M  105.3 = M 105.3                  CICLE MOVE REGISTER
M  105.4 = M 105.4                  CICLE MOVE REGISTER
M  105.5 = M 105.5                  CICLE MOVE REGISTER
M  105.6 = M 105.6                  CICLE MOVE REGISTER
M  105.7 = M 105.7                  CICLE MOVE REGISTER
M  104.0 = M 104.0                  CICLE MOVE REGISTER
M  105.0 = M 105.0                  CICLE MOVE REGISTER
M  104.1 = M 104.1                  CICLE MOVE REGISTER
MW 104   = MW 104                   ZYKLUSMERKER
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                          Smax = MAX. BRAKE-WAY                            *
*                                                                           *
*****************************************************************************
NAME :S-MAX

0005        :A   DB 180    -DB 180
0006        :L   DD  62                          LINE SPEED IN m/min
0007        :L   KG +2000000+02                  = 20 m/min
000A        :>G                                  20.0m/min < Vo
000B        :SPB =M001                           YES >> BRAKE WAY 300 IMPULSES
000C        :L   DD  62
000D        :L   KG +1500000+02                  = 15 m/min
0010        :>G                                  15.0m/min < Vo < 20.0m/min
0011        :SPB =M002                           YES >> BRAKE WAY 200 IMPULSES
0012        :L   DD  62
0013        :L   KG +1000000+02                  = 10 m/min
0016        :>G                                  10.0m/min < Vo < 15m/min
0017        :SPB =M003                           YES >> BRAKE WAY 130 IMPULSES
0018        :L   DD  62
0019        :L   KG +7500000+01                  = 7.5 m/min
001C        :>G                                  7.5m/min < Vo < 10.0m/min
001D        :SPB =M004                           YES >> BRAKE WAY 140 IMPULSES
001E        :L   DD  62
001F        :L   KG +5000000+01                  = 5 m/min
0022        :>=G                                 5.0m/min < Vo < 7.5m/min
0023        :SPB =M005                           YES >> BRAKE WAY 100 IMPULSES
0024        :
0025        :
0026 M005   :L   DW 100                          TREAD LENGTH (NOMINAL VALUE)
0027        :L   KF +25                          = 25 mm (100 IMPULSES)
0029        :-F
002A        :L   KF +4                           = IMPULSE/mm
002C        :XF
002D        :A   DB  20    -DB  20
002E        :T   DW   8                          Smax IN IMPULSEN
002F        :BEA
0030 M004   :L   DW 100
0031        :L   KF +35                          = 35 mm (140 IMPULSES)
0033        :-F
0034        :L   KF +4                           = IMPULSE/mm
0036        :XF
0037        :A   DB  20    -DB  20
0038        :T   DW   8                          Smax IN IMPULSEN
0039        :BEA
003A M003   :L   DW 100                          So IN mm
003B        :L   KF +45                          = 45 mm (180 IMPULSES)
003D        :-F
003E        :L   KF +4                           = IMPULSE/mm
0040        :XF
0041        :A   DB  20    -DB  20
0042        :T   DW   8                          Smax IN IMPULSEN
0043        :BEA
0044 M002   :L   DW 100                          So IN mm
0045        :L   KF +50                          = 50 mm (200 IMPULSES)
0047        :-F
0048        :L   KF +4                           = IMPULSE/mm
004A        :XF
004B        :A   DB  20    -DB  20
004C        :T   DW   8
004D        :BEA
004E M001   :L   DW 100                          So IN mm
004F        :L   KF +75                          = 75 mm (300 IMPULSES)
0051        :-F
0052        :L   KF +4                           = IMPULSE/mm
0054        :XF
0055        :A   DB  20    -DB  20
0056        :T   DW   8
0057        :BE
```


```
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK                !                              !
!ELASTOMERTECHNIK          WERK HARBURG      !  MASTERPROGRAMM              !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE             !  DATE          :              !
! INSTALLATION     : TREAD-LINE              !  MODIFICATION:              PGNO!
! PROJECT POS. NO.: 84/823804                !  PROGRAMMER   :              1!
+-----------------------------------------------------------------------------+
```

FB 110 -FB 110

DB 180 = DB 180
DB 20 = DB 20

C:KERM06ST.S5D BIB=16112 LAE=93

PROFILE AG
SEND DATAS TO SLAVE No1 (115U)

```
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK                !                                !
!ELASTOMERTECHNIK          WERK HARBURG      !  MASTERPROGRAMM                 !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE             !  DATE          :                !
! INSTALLATION     : TREAD-LINE              !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804                !  PROGRAMMER    :                  2!
+-----------------------------------------------------------------------------+
```

FB 112 C:KERM06ST.S5D BIB=20023 LAE=103

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                                SAVE PROFILE                               *
*                                                                           *
*****************************************************************************
NAME :RE-SAFE                                                  SAVE PROFILES

0005       :***

NETZWERK 2          0006       SAFETY REQUEST TO CP527
0006       :A    DB 185     -DB 185
0007       :U    D    2.0                                   CHANGE FKT-KEYS
0009       :SPB =M001
000A       :U    M    0.1   -M    0.1
000B       :UN   D   19.7
000D       :S    D   20.7                                   ORDER CHANGE FKT-KEYS
000F       :S    D    2.0
0011       :BEA
0012 M001  :U    D    2.1                                   REQUEST ACTIVE
0014       :SPB =M002
0015       :U    M    0.1   -M    0.1
0016       :UN   D   19.7
0018       :S    D   21.8                                   ORDER SAFETY REQUEST
001A       :S    D    2.1                                   F-REQUEST
001C       :BEA
001D M002  :***

M     0.1 = M    0.1                        "1"-SIGNAL

DB 185    = DB 185                          PROFILE MANAGEMENT

NETZWERK 3          001E       INPUT CANCEL
001E       :UN   M  161.7                                   CANCEL?
001F       :SPB =M001                                       NO ->
0020       :U    M    0.1   -M    0.1                       YES,
0021       :UN   D   19.7
0023       :S    D   20.5                                   CHANGE FKT-KEYS
0025       :R    D    1.2                                   FINISH ORDER
0027       :R    D    1.14                                  F-ORDER
0029       :R    D    2.0
002B       :R    D    2.1
002D       :R    M  161.7
002E       :BEA
002F M001  :***

M     0.1 = M    0.1                        "1"-SIGNAL

NETZWERK 4          0030       INPUT SAVE
0030       :U    M  161.6                                   ACCEPT?
0031       :UN   D   19.7
0033       :SPB =M001                                       YES ->
0034       :BEA
0035 M001  :U    D    1.11                                  F-AGDA?
0037       :SPB =M002                                       YES, ->
0038       :                                                --- SAVE TO DB-RZXX -----
0039       :L    DL   3
003A       :ADD KF +100
003C       :T    DW  13                                     PROFILE NO TO
003D       :                                                PARAMETER FOR COPY
003E       :T    DR 202
003F       :SPA FB 185     -FB 185
0040 NAME  :DB-T>256
0041 PANF  :     KY 185,200
0042       :A    DB 185     -DB 185
0043       :U    M    0.1   -M    0.1                       RESET
0044       :S    D   20.5                                   CHANGE FKT-KEYS
0046       :R    D    1.2                                   F-SAVE
0048       :R    D    1.14                                  F-ORDER
004A       :R    D    2.0                                   F-REQUEST1
004C       :R    D    2.1
004E       :BEA
004F M002  :                                                ---- SAVE TO DB-AGXX ------
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK                 !                              !
!ELASTOMERTECHNIK          WERK HARBURG        !  MASTERPROGRAMM              !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE               !  DATE          :             !
! INSTALLATION     : TREAD-LINE                !  MODIFICATION:              PGNO!
! PROJECT POS. NO.: 84/823804                  !  PROGRAMMER    :             1!
+-----------------------------------------------------------------------------+
```

```
0050       :SPA FB 185     -FB 185
0051 NAME  :DB-T>256
0052 PANF  :     KY 185,150
0053       :A    DB 185     -DB 185
0054       :U    M    0.1   -M   0.1
0055       :S    D   20.5
0057       :R    D    1.2
0059       :R    D    1.14
005B       :R    D    2.0
005D       :R    D    2.1
005F       :BEA
0060       :***
```

RESET
CHANGE FKT-KEYS
F-SAVE
F-ORDER
F-REQUEST1

M 0.1 = M 0.1 "1"-SIGNAL

DB 185 = DB 185 PROFILE MANAGEMENT

FB 185 = FB 185 COPY DATA BLOCK

```
NETZWERK 5          0061      NO INPUT
0061       :BE
```

FB 113 C:KERM06ST.S5D BIB=20023 LAE=184

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                                ORDER TO CP527                             *
*                                                                           *
*****************************************************************************
NAME :AUFT-527

0005      :***

NETZWERK 2          0006      LOAD ORDER NUMBER
0006      :A   DB 185    -DB 185
0007      :L   DW  20
0008      :L   DW  21
0009      :OW
000A      :L   DW  22
000B      :OW
000C      :L   KF +0                          EXIST SEND-ORDER ?
000E      :!=F
000F      :=   M  200.0
0010      :U   M  200.0
0011      :SPB =M001                          NO, ->
0012      :U   M    0.1  -M   0.1             YES, SET SEND-ORDER
0013      :S   D   19.0                            (IMPULSE)
0015      :L   KF +100
0017      :U   D   20.0
0019      :SPB =M002                          BAK, AUSWAHL
001A      :L   KF +101
001C      :U   D   20.1
001E      :SPB =M002                          BAK, REZE
001F      :L   KF +102
0021      :U   D   20.2
0023      :SPB =M002                          FKT, AKTIV
0024      :L   KF +103
0026      :U   D   20.3
0028      :SPB =M002                          BAK, TB01
0029      :L   KF +104
002B      :U   D   20.4
002D      :SPB =M002                          FKT, LEARN
002E      :U   M  200.0
002F M001 :SPB =M002                          GOTO NW3
0030      :L   KF +105
0032      :U   D   20.5
0034      :SPB =M002                          FKT, REAKTIV (MAIN FKT-KEY'S)
0035      :L   KF +106
0037      :U   D   20.6
0039      :SPB =M002                          FKT, COPY
003A      :L   KF +107
003C      :U   D   20.7
003E      :SPB =M002                          FKT, SAVE
003F      :L   KF +108
0041      :U   D   20.8
0043      :SPB =M002                          FKT, RENAME
0044      :L   KF +109
0046      :U   D   20.9
0048      :SPB =M002                          FKT, DELETE
0049      :L   KF +110
004B      :U   D   21.0
004D      :SPB =M002                          WAK, OPERATION NOT ALLOWED
004E      :L   KF +111
0050      :U   D   21.1
0052      :SPB =M002                          WAK, DATAS NOT ALLOWED
0053      :L   KF +112
0055      :U   D   21.2
0057      :SPB =M002                          WAK, NEW NAME
0058      :L   KF +113
005A      :U   D   21.3
005C      :SPB =M002                          WAK, TARGET PROFILE
005D      :L   KF +114
005F      :U   D   21.4
0061      :SPB =M002                          WAK, FUNCTION DONE
0062      :L   KF +115
0064      :U   D   21.5
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK                !                                !
!ELASTOMERTECHNIK          WERK HARBURG      !  MASTERPROGRAMM                !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE             !  DATE          :               !
! INSTALLATION     : TREAD-LINE              !  MODIFICATION:                 PGNO!
! PROJECT POS. NO.: 84/823804                !  PROGRAMMER    :                  1!
+-----------------------------------------------------------------------------+
```

```
0066        :SPB =M002
0067        :L   KF +116
0069        :U   D   21.6
006B        :SPB =M002
006C        :L   KF +120
006E        :U   D   21.8
0070        :SPB =M002
0071        :L   KF +121
0073        :U   D   21.9
0075        :SPB =M002
0076        :L   KF +122
0078        :U   D   21.10
007A        :SPB =M002
007B        :L   KF +123
007D        :U   D   21.11
007F        :SPB =M002
0080        :L   KF +124
0082        :U   D   21.12
0084        :SPB =M002
0085        :L   KF +126
0087        :U   D   21.14
0089        :SPB =M002
008A        :L   KF +130
008C        :U   D   22.0
008E        :SPB =M002
008F M002   :***
```

WAK, FUNCTION EXIT

WAK, PRINTER ACTIVE

WAK, SAVE

WAK, CANCEL FUNCTION

WAK, COPY

WAK, RENAME

WAK, DELETE

WAK, ACTIVATE PROFILE

WAK, LEARN FUNCTION

```
M    0.1 = M    0.1
```

"1"-SIGNAL

```
DB 185    = DB 185
```

PROFILE MANAGEMENT

```
NETZWERK 3              0090
0090        :T   DR  41
0091        :UN  D   19.0
0093        :R   D   19.7
0095        :U   D   19.0
0097        :UN  D   19.7
0099        :S   D   19.7
009B        :SPA FB 120      -FB 120
009C NAME   :SEND
009D SSNR   :    KY 255,40
009E A-NR   :    KY 0,0
009F ANZW   :    MW   0
00A0 QTYP   :    KC NN
00A1 DBNR   :    KY 0,0
00A2 QANF   :    KF +0
00A3 QLAE   :    KF +0
00A4 PAFE   :    MB 200
00A5        :A   DB 185      -DB 185
00A6        :L   MB 200
00A7        :T   DW  46
00A8        :U   D   19.0
00AA        :R   D   19.0
00AC        :L   KH 0000
00AE        :T   DW  20
00AF        :T   DW  21
00B0        :T   DW  22
00B1        :***
```

LOAD ORDER NUMBER

BUILD SEND IMPULSE

SAVE FAULT

RESET ORDER
DELETE ORDERS

```
DB 185    = DB 185
```

PROFILE MANAGEMENT

```
FB 120    = FB 120
```

SEND (S)

```
NETZWERK 4              00B2
00B2        :BE
```

```
FB 115                                    C:KERM06ST.S5D        BIB=20023   LAE=163
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                                COPY PROFILE                               *
*                                                                           *
*****************************************************************************
NAME :RE-COPY                                                  COPY PROFILES

0005       :***

NETZWERK 2          0006        REQUEST TERGET
0006       :A    DB 185     -DB 185
0007       :U    D    2.0                                     CHANGE FKT-KEYS
0009       :SPB =M001                                         YES, ->
000A       :L    KF +0                                        DELETE OLD TARGET
000C       :T    DL   4
000D       :U    M    0.1   -M    0.1
000E       :UN   D   19.7
0010       :S    D   20.6                                     ORDER CHANGE FKT-KEYS
0012       :S    D    2.0                                     F-REQUEST1 SET
0014       :BEA
0015 M001  :U    D    2.1
0017       :SPB =M002
0018       :U    M    0.1   -M    0.1
0019       :UN   D   19.7
001B       :S    D   21.3                                     ORDER TARGET REQUEST
001D       :S    D    2.1                                     F-REQUEST2 SET
001F       :BEA
0020 M002  :UN   M  161.7                                     CANCEL PRESSED?
0021       :O    D    2.2                                     OR GO ON
0023       :SPB =M003                                         REQUEST->
0024       :U    M    0.1   -M    0.1
0025       :UN   D   19.7
0027       :S    D   20.5                                     CHANGE FKT-KEYS
0029       :R    D    1.5
002B       :R    D    1.14
002D       :R    D    2.0
002F       :R    D    2.1
0031       :R    D    2.2
0033       :R    M  161.7
0034       :BEA
0035 M003  :L    DL   4                                       INPUT ?
0036       :L    KF +0
0038       :!=F
0039       :BEB                                               NO, ->>
003A       :***

M     0.1 = M    0.1                        "1"-SIGNAL

DB 185    = DB 185                          PROFILE MANAGEMENT

NETZWERK 3          003B        REQUEST COPY YES,NO
003B       :U    D    2.2                                     REQUEST ACTIVE?
003D       :SPB =M001                                         YES, ->
003E       :U    M    0.1   -M    0.1
003F       :UN   D   19.7
0041       :S    D    2.2                                     F-REQUEST2 SET
0043       :S    D   21.10                                    SET ORDER REQUEST
0045       :BEA
0046 M001  :***

M     0.1 = M    0.1                        "1"-SIGNAL

NETZWERK 4          0047        EVALUATE THE INPUTS
0047       :UN   M  161.6                                     COPY ?
0048       :SPB =M001                                         NO, ->
0049       :U    D   19.7
004B       :BEB
004C       :L    DL   4                                       TARGET No.
004D       :L    KF +100
004F       :+F
0050       :T    DR  13
0051       :L    KF +1                                        TYP
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK                 !                              !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                     !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE          !  DATE          :                  !
! INSTALLATION     : TREAD-LINE           !  MODIFICATION:                    PGNO!
! PROJECT POS. NO.: 84/823804             !  PROGRAMMER    :                    1!
+-----------------------------------------------------------------------------+
```

```
0053        :T    DL  13
0054        :L    DW  13                    WRITE TARGET-DB-No.
0055        :T    DW 202
0056        :SPA FB 185     -FB 185
0057 NAME   :DB-T>256
0058 PANF   :     KY 185,200
0059        :A    DB 185     -DB 185
005A        :L    DL   3
005B        :L    KF +10
005D        :XF
005E        :T    MB 220                    FIST DATE WORD FROM
005F        :L    DL   4                    SOURCE-PROFILENAME
0060        :L    KF +10
0062        :XF
0063        :T    MB 221                    FIRST DATE WORD FROM
0064        :                               TARGET-PROFILENAME
0065        :SPA FB 184     -FB 184
0066 NAME   :DW-COPY                        COPY
0067 DB     :     DB 184     -DB 184
0068 DQDZ   :     MW 220
0069 ANZA   :     KF +8
006A        :
006B        :A    DB 185     -DB 185        #########
006C        :L    DL   4
006D        :T    MB 200
006E        :L    KF +100
0070        :+F
0071        :T    MW 204
0072        :B    MW 204
0073        :A    DB   0
0074        :L    MB 200
0075        :T    DL   1                    PROFILE-No. PART A
0076        :T    DL  30                    PROFILE-No. PART B
0077        :T    DL  31                    PROFILE-No. PART C
0078        :
0079        :A    DB 185     -DB 185
007A        :U    M    0.1   -M   0.1
007B        :S    D   20.5
007D        :R    D    1.5                  CHANGE FKT-KEYS
007F        :R    D    1.14                 F-COPY
0081        :R    D    2.0                  F-ORDER
0083        :R    D    2.1                  F-REQUEST1
0085        :R    D    2.2                  F-REQUEST2
0087        :R    M  161.6
0088        :BEA
0089 M001   :UN   M  161.7
008A        :SPB =M002                      CANCEL ?
008B        :U    M    0.1   -M   0.1       NO, NO INPUT, ->
008C        :UN   D   19.7                  YES, EXIT
008E        :S    D   20.5
0090        :R    D    1.5                  CHANGE FKT-KEYS
0092        :R    D    1.14
0094        :R    D    2.0
0096        :R    D    2.1
0098        :R    D    2.2
009A        :R    M  161.7
009B        :BEA
009C M002   :***

M    0.1 = M   0.1                          "1"-SIGNAL

DB 185   = DB 185                          PROFILE MANAGEMENT
DB 184   = DB 184                          PROFILE NAME

FB 185   = FB 185                          COPY DATA BLOCK
FB 184   = FB 184                          COPY < 254 WORDS

NETZWERK 5          009D
009D       :BE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                                RENAME PROFILE                             *
*                                                                           *
*****************************************************************************
NAME :RE-RENAM                                    RENAME PROFILES

0005       :***

NETZWERK 2          0006       REQUEST NEW NAME
0006       :A   DB 185    -DB 185
0007       :U   D    2.0                          REQUEST ACTIVE ?
0009       :SPB =M001                             YES, ->
000A       :L   KC ..                             DELETE OLD TARGET
000C       :T   DW   5
000D       :T   DW   6
000E       :T   DW   7
000F       :T   DW   8
0010       :T   DW   9
0011       :T   DW  10
0012       :T   DW  11
0013       :T   DW  12
0014       :U   M    0.1  -M   0.1
0015       :UN  D   19.7
0017       :S   D   20.8                          ORDER CHANGE FKT-KEYS
0019       :S   D    2.0                          F-REQUEST1 SET
001B       :BEA
001C M001  :U   D    2.1
001E       :SPB =M002
001F       :U   M    0.1  -M   0.1
0020       :UN  D   19.7
0022       :S   D   21.2                          ORDER NEW NAME
0024       :S   D    2.1
0026       :BEA
0027 M002  :UN  M  161.7                          CANCEL
0028       :O   D    2.2                          OR GO ON
002A       :SPB =M003                             -->
002B       :U   M    0.1  -M   0.1                YES, AWAY
002C       :UN  D   19.7
002E       :S   D   20.5                          CHANGE FKT-KEYS
0030       :R   D    1.6
0032       :R   D    1.14
0034       :R   D    2.0
0036       :R   D    2.1
0038       :R   D    2.2
003A       :R   M  161.7
003B       :BEA
003C M003  :L   DW   5                            WAS AN INPUT?
003D       :L   KC ..
003F       :!=F
0040       :BEB                                   NO, ->>
0041       :***

M    0.1 = M   0.1                    "1"-SIGNAL

DB 185   = DB 185                     PROFILE MANAGEMENT

NETZWERK 3          0042       REQUEST RENAME YES,NO
0042       :U   D    2.2                          REQUEST ACTIVE?
0044       :SPB =M001                             YES, ->
0045       :U   M    0.1  -M   0.1
0046       :UN  D   19.7
0048       :S   D   21.11                         ORDER SET REQUEST
004A       :S   D    2.2                          F-REQUEST2
004C       :BEA
004D M001  :***

M    0.1 = M   0.1                    "1"-SIGNAL

NETZWERK 4          004E       EVALUATION OF INPUTS
004E       :UN  M  161.6                          RENAME ?
004F       :SPB =M001                             NO, ->
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK                 !                              !
!ELASTOMERTECHNIK          WERK HARBURG        !  MASTERPROGRAMM              !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE               !  DATE         :              !
! INSTALLATION     : TREAD-LINE                !  MODIFICATION:          PGNO!
! PROJECT POS. NO.: 84/823804                  !  PROGRAMMER   :            1!
+-----------------------------------------------------------------------------+
```

```
0050        :U   D   19.7
0052        :BEB                                YES >> ORDER IS ACTIVE
0053        :L   KY 1,185                       SOURCE-DB
0055        :T   MW 254
0056        :L   KF +5                          FROM DW
0058        :T   MW 252
0059        :L   KY 1,184                       TARGET-DB
005B        :T   MW 250
005C        :L   DL   3
005D        :L   KF +10
005F        :XF
0060        :T   MW 248                         TO DW
0061        :L   KF +8
0063        :T   MW 246                         LENGTH
0064        :SPA FB 185     -FB 185
0065 NAME   :DB-T>256
0066 PANF   :    KY 0,0
0067        :A   DB 185     -DB 185
0068        :L   KY 1,185
006A        :T   MW 254
006B        :L   KF +5
006D        :T   MW 252
006E        :L   KY 1,170
0070        :T   MW 250
0071        :L   KF +230
0073        :T   MW 248
0074        :L   KF +8
0076        :T   MW 246
0077        :SPA FB 185     -FB 185
0078 NAME   :DB-T>256
0079 PANF   :    KY 0,0
007A        :
007B        :A   DB 185     -DB 185
007C        :U   M    0.1   -M   0.1
007D        :S   D   20.5                       ORDER CHANGE FKT-KEYS
007F        :R   D    1.6                       F-RENAME
0081        :R   D    1.14                      F-ORDER
0083        :R   D    2.0                       F-REQUEST1
0085        :R   D    2.1                       F-REQUEST2
0087        :R   D    2.2                       F-REQUEST3
0089        :R   M  161.6
008A        :BEA
008B M001   :UN  M  161.7                       CANCEL?
008C        :SPB =M002                          NO, NO INPUTS, ->
008D        :U   M    0.1   -M   0.1           YES, CANCEL
008E        :UN  D   19.7
0090        :S   D   20.5                       ORDER CHANGE FKT-KEYS
0092        :R   D    1.6                       F-RENAME
0094        :R   D    1.14                      F-ORDER
0096        :R   D    2.0                       F-REQUEST1
0098        :R   D    2.1                       F-REQUEST2
009A        :R   D    2.2                       F-REQUEST3
009C        :R   M  161.7
009D        :BEA
009E M002   :***

M    0.1 = M    0.1                             "1"-SIGNAL

DB 185    = DB 185                              PROFILE MANAGEMENT

FB 185    = FB 185                              COPY DATA BLOCK

NETZWERK 5          009F
009F        :BE
```

```
FB 118                                  C:KERM06ST.S5D        BIB=20023   LAE=140

NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                                DELETE PROFILE                             *
*                                                                           *
*****************************************************************************
NAME :RE-ERASE                                      DELETE PROFILE

0005       :***

NETZWERK 2          0006       SAFETY REQUEST
0006       :A   DB 185    -DB 185
0007       :U   D    2.0                            CHANGE FKT-KEYS
0009       :SPB =M001                               YES, ->
000A       :U   M    0.1  -M   0.1
000B       :UN  D   19.7
000D       :S   D   20.9                            ORDER CHANGE FKT-KEYS
000F       :S   D    2.0                            F-REQUEST1
0011       :BEA
0012 M001  :U   D    2.1
0014       :SPB =M002                               YES, ->
0015       :U   M    0.1  -M   0.1
0016       :UN  D   19.7
0018       :S   D   21.12                           ORDER SAFETY REQUEST
001A       :S   D    2.1                            F-REQUEST2
001C       :BEA
001D M002  :***

M    0.1 = M   0.1                    "1"-SIGNAL

DB 185   = DB 185                     PROFILE MANAGEMENT

NETZWERK 3          001E       INPUT F7 DELETE
001E       :UN  M  161.6                            DELETE?
001F       :SPB =M001                               NO ->
0020       :U   D   19.7
0022       :BEB
0023       :L   DL   3                              *********
0024       :A   DB 100    -DB 100                   PROFILE-No. TO DB 100
0025       :T   DL   1                              PROFILE-No. PART A
0026       :T   DL  30                              PROFILE-No. PART B
0027       :T   DL  31                              PROFILE-No. PART C
0028       :A   DB 185    -DB 185                   *********
0029       :L   KY 1,100                            COPY TO SELECTED
002B       :T   MW 254                              PROFILE
002C       :L   KF +0                               *********
002E       :T   MW 252
002F       :L   KF +1
0031       :T   MB 250
0032       :L   DL   3
0033       :ADD KF +100
0035       :T   MB 251
0036       :T   DW  13
0037       :L   KF +0
0039       :T   MW 248
003A       :L   DW  47
003B       :T   MW 246
003C       :SPA FB 185    -FB 185
003D NAME  :DB-T>256
003E PANF  :    KY 0,0
003F       :                                        LOAD FROM EMPTY PROFILE
0040       :                                        TO DB-CPXX
0041       :                                        ***
0042       :A   DB 185    -DB 185
0043       :L   DR  13                              WRITE PROFILE No.
0044       :T   DR 100
0045       :SPA FB 185    -FB 185
0046 NAME  :DB-T>256
0047 PANF  :    KY 185,100
0048       :
0049       :A   DB 184    -DB 184                   ##################################
004A       :L   KC ..                               DELETE RECIPE-NAME
004C       :T   DW   1
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK                 !                              !
!ELASTOMERTECHNIK          WERK HARBURG        !  MASTERPROGRAMM              !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE               !  DATE        :               !
! INSTALLATION     : TREAD-LINE                !  MODIFICATION:           PGNO!
! PROJECT POS. NO.: 84/823804                  !  PROGRAMMER  :              1!
+-----------------------------------------------------------------------------+
```

```
0092      :>F
0093      :SPB =M001                                NO THEN GO ON
0094      :***

MW 154   = MW 114                          FLAG-W. GTR-9000
MW 150   = MW 110                          FLAG-W. GTR-9000
MW 152   = MW 112                          FLAG-W. GTR-9000

DB 150   = DB 150                          SEND/RECEIVE FOR GTR-9000

NETZWERK 5          0095      CODE H0-H9,G0-G8,L+,L-,W
0095 M001 :
0096      :B   =QUDB                                SOURCE DB
0097      :
0098      :B   MW 154    -MW 114                    POINTER TO DW
0099      :L   DW   0                               VALUE FROM DW
009A      :L   KM 00000000 00111111
009C      :UW
009D      :T   MW 152    -MW 112                    RIGHT BYTE
009E      :L   MW 152    -MW 112
009F      :L   KF +64
00A1      :OW
00A2      :T   MW 152    -MW 112
00A3      :                                         --------------------------------
00A4      :B   MW 154    -MW 114
00A5      :L   DW   0
00A6      :SLW      2
00A7      :L   KM 00111111 00000000
00A9      :UW
00AA      :L   KM 01000000 00000000
00AC      :+F
00AD      :T   MW 150    -MW 110                    LEFT BYTE
00AE      :
00AF      :L   MW 152    -MW 112
00B0      :L   MW 150    -MW 110
00B1      :OW
00B2      :T   MW 152    -MW 112
00B3      :A   DB 150    -DB 150                    TARGET DB
00B4      :L   MW 154    -MW 114                    DW-ADRESS
00B5      :D        6
00B6      :T   MW 154    -MW 114
00B7      :L   MW 152    -MW 112                    VALUE ASCII-CODE
00B8      :B   MW 154    -MW 114                    POINTER TO DW
00B9      :T   DW   0
00BA      :                                         --------------------------------
00BB      :L   MB 152                               SUM
00BC      :L   MB 153
00BD      :+F
00BE      :L   DW  36
00BF      :+F
00C0      :T   DW  36
00C1      :                                         --------------------------------
00C2      :L   MW 154    -MW 114
00C3      :I        7
00C4      :T   MW 154    -MW 114
00C5      :L   KF +39
00C7      :L   MW 154    -MW 114
00C8      :>F
00C9      :SPB =M001
00CA      :***

MW 154   = MW 114                          FLAG-W. GTR-9000
MW 152   = MW 112                          FLAG-W. GTR-9000
MW 150   = MW 110                          FLAG-W. GTR-9000

DB 150   = DB 150                          SEND/RECEIVE FOR GTR-9000

NETZWERK 6          00CB      SUM ASCII-CODE
00CB      :A   DB 150    -DB 150
00CC      :L   DW  36                               LEFT BYTE
00CD      :L   KM 11111111 00000000
00CF      :UW
00D0      :SRW      8
00D1      :T   MW 150    -MW 110                    HF
```

```
00D2        :L   KF +33                          DW ADDRESS
00D4        :T   MW 154     -MW 114
00D5 M004   :
00D6        :L   KH 0030
00D8        :T   MB 152
00D9        :
00DA        :L   MW 150     -MW 110
00DB        :L   KH 000F
00DD        :UW
00DE        :T   MB 153
00DF        :L   KH 0009
00E1        :<=F
00E2        :SPB =M001
00E3        :L   KH 0037
00E5        :T   MB 152
00E6 M001   :
00E7        :L   MB 152
00E8        :L   MB 153
00E9        :+F
00EA        :B   MW 154     -MW 114              POINTER TO DW
00EB        :T   DW   0
00EC        :
00ED        :L   KH 0030
00EF        :T   MB 152
00F0        :L   MW 150     -MW 110
00F1        :SRW      4
00F2        :L   KH 000F
00F4        :UW
00F5        :T   MB 153
00F6        :L   KH 0009
00F8        :<=F
00F9        :SPB =M002
00FA        :L   KH 0037
00FC        :T   MB 152
00FD M002   :
00FE        :L   MB 152
00FF        :L   MB 153
0100        :+F
0101        :SLW      8
0102        :B   MW 154     -MW 114
0103        :L   DW   0
0104        :OW
0105        :B   MW 154     -MW 114
0106        :T   DW   0
0107        :
0108        :L   KF +34
010A        :L   MW 154     -MW 114
010B        :!=F
010C        :SPB =M003
010D        :
010E        :L   DW  36                          RIGHT BYTE
010F        :L   KM 00000000 11111111
0111        :UW
0112        :T   MW 150     -MW 110              HF
0113        :L   KF +34                          DW ADDRESS CORRECTION
0115        :T   MW 154     -MW 114
0116        :SPA =M004
0117 M003   :
0118        :***

MW 150    = MW 110                    FLAG-W. GTR-9000
MW 154    = MW 114                    FLAG-W. GTR-9000

DB 150    = DB 150                    SEND/RECEIVE FOR GTR-9000

NETZWERK 7          0119       SEND ROUTINE
0119        :U   =RUN                            RUN
011A        :SPA FB 120     -FB 120
011B NAME   :SEND
011C SSNR   :    KY 0,4
011D A-NR   :    KY 0,191
011E ANZW   :    MW 150     -MW 110
011F QTYP   :    KC DB
0120 DBNR   :    KY 0,150
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                     !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                     !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                     !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                    4!
+-----------------------------------------------------------------------------+
```

```
0121 QANF :    KF +1
0122 QLAE :    KF +35
0123 PAFE :    MB 152
0124      :
0125      :UN  =RUN
0126      :L   KT 050.1
0128      :SI  =TIME
0129      :U   =RUN                          RUN
012A      :L   KT 050.1
012C      :SI  =TIME                         START CONTROLTIME
012D      :S   M  159.7                      FB149, FB150 LOCK
012E      :S   M  159.2                      TELEGRAM EXPECTED
012F      :***

MW 150   = MW 110                            FLAG-W. GTR-9000

FB 120   = FB 120                            SEND (S)

NETZWERK 8          0130
0130      :
0131      :BE
```

```
FB 149  -FB 149                    C:KERM06ST.S5D                    LAE=245

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                              SEND SET TO GTR-9000                           *
*                                                                             *
*******************************************************************************
NAME  :SATZ
BEZ   :RKNR       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ   :PARA       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KC
BEZ   :WERT       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ   :RUN        E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ   :TIME       E/A/D/B/T/Z: T
BEZ   :FAIL       E/A/D/B/T/Z: A  BI/BY/W/D: BI

0017       :***

NETZWERK 2          0018       RECEIVE ROUTINE
0018       :UN  M  159.1                        NO TELEGRAM EXPECTED
0019       :SPB =M001
001A       :U   M  159.1                        TELEGRAM EXPECTED
001B       :SPA FB 127     -FB 127              RECEIVE ALL
001C NAME  :REC-A
001D SSNR  :    KY 0,4
001E A-NR  :    KY 0,0
001F ANZW  :    MW 150     -MW 110
0020 PAFE  :    MB 152
0021       :
0022       :ON  =TIME                           CONTROLTIME TERMINATED
0023       :O   M  151.0                        TELEGRAM RECEIVED
0024       :R   M  159.1
0025       :R   M  159.7                        FB150, FB152 RELEASE
0026       :
0027       :UN  =TIME                           CONTROLTIME TERMINATED
0028       :SPB =M002                           FAULTMESSAGE
0029       :
002A       :UN  M  151.0                        NO TELEGRAM RECEIVED
002B       :BEB
002C       :
002D       :LW  =PARA
002E       :L   KC P9
0030       :!=F                                 STANDARD ?
0031       :BEB                                 YES => NO ANSWER FROM GTR
0032       :
0033       :LW  =WERT
0034       :L   KF +999
0036       :>F
0037       :SPB =M003
0038       :A   DB 150     -DB 150              SEND DB
0039       :L   DR   4
003A       :A   DB 151     -DB 151
003B       :L   DR   2
003C       :><F
003D       :SPB =M002
003E       :SPA =M004
003F M003  :A   DB 150     -DB 150
0040       :L   DW   4
0041       :A   DB 151     -DB 151              RECEIVE DB
0042       :L   DW   2
0043       :><F                                 SEND VALUE UNEQUAL RECEIVE VALUE
0044       :SPB =M002                           FAULTMESSAGE
0045 M004  :L   DW   3
0046       :A   DB 150     -DB 150
0047       :L   DW   5
0048       :><F                                 UNEQUAL
0049 M002  :S   =FAIL                           FAULTMESSAGE
004A       :BEA
004B M001  :***

MW 150    = MW 110                  FLAG-W. GTR-9000
```

```
DB 150   = DB 150
DB 151   = DB 151

FB 127   = FB 127

NETZWERK 3          004C
004C       :O   M  159.7
004D       :ON  =RUN
004E       :BEB
004F       :
0050       :U   =RUN
0051       :RB  =FAIL
0052       :RD  =TIME
0053       :
0054       :A   DB 150     -DB 150
0055       :LW  =PARA
0056       :T   DW   3
0057       :T   DW   9
0058       :L   KH 0D20
005A       :T   DW   6
005B       :L   KH 3F0D
005D       :T   DW  10
005E       :
005F       :L   KF +10
0061       :LW  =RKNR
0062       :<=F
0063       :SPB =M001
0064       :T   DW 100
0065       :L   KC R0
0067       :SPA =M002
0068 M001  :L   KF +20
006A       :>=F
006B       :SPB =M003
006C       :LW  =RKNR
006D       :L   KF +10
006F       :-F
0070       :T   DW 100
0071       :L   KC R1
0073       :SPA =M002
0074 M003  :L   KF +30
0076       :LW  =RKNR
0077       :<=F
0078       :SPB =M004
0079       :L   KF +20
007B       :-F
007C       :T   DW 100
007D       :L   KC R2
007F       :SPA =M002
0080 M004  :L   KF +30
0082       :-F
0083       :T   DW 100
0084       :L   KC R3
0086 M002  :
0087       :T   DW   1
0088       :T   DW   7
0089       :L   KH 0020
008B       :T   DR   2
008C       :T   DR   8
008D       :L   DW 100
008E       :L   KF +48
0090       :+F
0091       :T   DW 100
0092       :L   DR 100
0093       :T   DL   2
0094       :T   DL   8
0095       :
0096       :LW  =WERT
0097       :L   KF +1000
0099       ::F
009A       :T   DD 100
009B       :L   DW 101
009C       :L   KF +48
009E       :OW
009F       :T   DW 101
```

SEND/RECEIVE FOR GTR-9000
SEND/RECEIVE FOR GTR-9000

RECEIVE-ALL (S)

FB150, FB152 LOCKED
NO RUN

RUN
RESET FAULTMESSAGE
RESET CONTROLTIME

SEND DB
PARAMETER TAKE-OVER

ASCII "CR" AND "BLANK"

ASCII "?" AND "CR"

CICLE No. TO SENDE DB

VALUE PARAMETER TO SEND DB

THOUSAND

```
00A0       :
00A1       :L    DW 100
00A2       :L    KF +100
00A4       ::F
00A5       :T    DD 102
00A6       :L    DW 103
00A7       :L    KF +48
00A9       :OW
00AA       :T    DW 103                          HUNDERT
00AB       :
00AC       :L    DW 102
00AD       :L    KF +10
00AF       ::F
00B0       :T    DD 104
00B1       :
00B2       :L    DW 105
00B3       :L    KF +48
00B5       :OW
00B6       :T    DW 102                          TEN
00B7       :
00B8       :L    DW 104
00B9       :L    KF +48
00BB       :OW
00BC       :T    DW 104                          ONE
00BD       :
00BE       :L    DR 101
00BF       :T    DL   4                          THOUSAND
00C0       :L    DR 103
00C1       :T    DR   4                          HUNDERT
00C2       :L    DR 102
00C3       :T    DL   5                          TEN
00C4       :L    DR 104
00C5       :T    DR   5                          ONE
00C6       :L    KF +11
00C8       :T    DW 102
00C9 M006  :L    KF +0                           DW 11-35 WITH ZERO
00CB       :B    DW 102
00CC       :T    DW   0
00CD       :L    DW 102
00CE       :I      1
00CF       :T    DW 102
00D0       :L    DW 102
00D1       :L    KF +36
00D3       :>=F
00D4       :SPB  =M005
00D5       :SPA  =M006
00D6 M005  :***
```

DB 150 = DB 150 SEND/RECEIVE FOR GTR-9000

```
NETZWERK 4          00D7      SEND ROUTINE
00D7       :U    =RUN                            RUN
00D8       :SPA FB 120     -FB 120
00D9 NAME  :SEND
00DA SSNR  :     KY 0,4
00DB A-NR  :     KY 0,191
00DC ANZW  :     MW 150     -MW 110
00DD QTYP  :     KC DB
00DE DBNR  :     KY 0,150
00DF QANF  :     KF +1
00E0 QLAE  :     KF +10
00E1 PAFE  :     MB 152
00E2       :
00E3       :UN   =RUN
00E4       :L    KT 050.1
00E6       :SI   =TIME
00E7       :
00E8       :U    =RUN                            RUN
00E9       :L    KT 050.1
00EB       :SI   =TIME                           START CONTROLTIME
00EC       :S    M  159.1                        TELEGRAM EXPECTED
00ED       :S    M  159.7                        FB150, FB148 LOCK
00EE       :***
```

```
FB 149  -FB 149                          C:KERM06ST.S5D                    LAE=245

MW 150   = MW 110                        FLAG-W. GTR-9000

FB 120   = FB 120                        SEND (S)

NETZWERK 5          00EF
00EF      :BE
```

```
FB 150  -FB 150                         C:KERM06ST.S5D                      LAE=528

MW 150   = MW 110                       FLAG-W. GTR-9000

FB 120   = FB 120                       SEND (S)

NETZWERK 4          00AA      RECEIVE ROUTINE
00AA       :UN  M  159.0
00AB       :BEB                                    NO TELEGRAM EXPECTED
00AC       :U   M  159.0
00AD       :SPA FB 127     -FB 127                 TELEGRAM EXPECTED
00AE NAME  :REC-A                                  RECEIVE ALL AUFRUFEN
00AF SSNR  :    KY 0,4
00B0 A-NR  :    KY 0,0
00B1 ANZW  :    MW 150     -MW 110
00B2 PAFE  :    MB 152
00B3       :
00B4       :ON  =TIME
00B5       :O   M  151.0                           CONTROLTIME TERMINATED
00B6       :R   M  159.0                           TELEGRAM RECEIVED
00B7       :R   M  159.7                           RESET RECEIVE TELEGRAM
00B8       :
00B9       :UN  =TIME                              CONTROLTIME TERMINATED
00BA       :S   =FAIL                              SET FAULTMESSAGE
00BB       :
00BC       :UN  M  151.0                           NO TELEGRAM RECEIVED
00BD       :BEB
00BE       :
00BF       :A   DB 151     -DB 151                 RECEIVE DB
00C0       :L   DW   1
00C1       :L   KF +95
00C3       :><F                                    LENGTH TELEGRAM
00C4       :BEB                                    NO STANDARD LENGTH -> END
00C5       :
00C6       :L   KF +6                              /1.DATA
00C8       :T   DW 110                             /LOADPOINTER
00C9       :T   MW 150     -MW 110                 /TRANSFERPOINTER
00CA       :UN  M  159.0                           ?TELEGRAM FROM GTR RECEIVED
00CB       :=   M  158.0                           /HF EVALUATION CICLE No.
00CC       :=   M  158.2                           /HF K-PARAMETER
00CD       :R   M  158.1                           /HF DL/DR
00CE M006  :
00CF       :A   DB 151     -DB 151                 RECEIVE DB
00D0       :B   DW 110                             /DL K-PARAMETER
00D1       :L   DW   0
00D2       :SRW      8
00D3       :SPA =M001
00D4 M004  :
00D5       :A   DB 151     -DB 151
00D6       :U   M  158.1
00D7       :R   M  158.1
00D8       :B   DW 110
00D9       :L   DW   0
00DA       :L   KM 00000000 11111111
00DC       :UW
00DD       :SPA =M001
00DE M005  :
00DF       :A   DB 151     -DB 151
00E0       :B   DW 110                             /H-/G-/W-PARAMETER
00E1       :L   DW   0
00E2 M001  :
00E3       :L   KM 10111111 10111111
00E5       :UW                                     CHANGE KC -> KF
00E6       :T   MW 156     -MW 116
00E7       :U   M  156.0
00E8       :=   M  157.6
00E9       :U   M  156.1
00EA       :=   M  157.7
00EB       :U   M  156.2
00EC       :=   M  156.0
00ED       :U   M  156.3
00EE       :=   M  156.1
00EF       :U   M  156.4
00F0       :=   M  156.2
00F1       :U   M  156.5
00F2       :=   M  156.3
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                     3!
+-------------------------------------------------------------------------------+
```

```
00F3        :U   M  156.6
00F4        :=   M  156.4
00F5        :U   M  156.7
00F6        :=   M  156.5
00F7        :
00F8        :UN  M  158.0
00F9        :SPB =M002
00FA        :LW  =ANF
00FB        :L   MW 156     -MW 116
00FC        :>F
00FD        :BEB
00FE        :LW  =ENDE
00FF        :>F
0100        :BEB
0101        :L   MW 156     -MW 116
0102        :LW  =DB1                          TARGET DB No.
0103        :+F
0104        :L   KF +1
0106        :-F
0107        :T   MW 154     -MW 114
0108 M002   :
0109        :B   MW 154     -MW 114
010A        :A   DB   0
010B        :L   MW 156     -MW 116
010C        :B   MW 150     -MW 110
010D        :T   DW   0
010E        :L   MW 150     -MW 110
010F        :I        1
0110        :T   MW 150     -MW 110
0111        :
0112        :UN  M  158.2
0113        :SPB =M003
0114        :U   M  158.1
0115        :SPB =M004
0116        :A   DB 151     -DB 151
0117        :L   DW 110
0118        :I        1
0119        :T   DW 110
011A        :UN  M  158.1
011B        :=   M  158.1
011C        :R   M  158.0
011D        :L   DW 110
011E        :L   KF +12
0120        :!=F                               ?ALL K-PARAMETER WRITEN
0121        :R   M  158.2
0122        :SPB =M005                         /YES -> GO ON WITH H-PARAMETER
0123        :SPB =M006                         /NO
0124        :
0125 M003   :A   DB 151     -DB 151
0126        :L   DW 110
0127        :I        1
0128        :T   DW 110
0129        :L   DW 110
012A        :L   KF +34
012C        :<F                                ?LAST PARAMETER
012D        :SPB =M005                         /NO
012E        :***

MW 150    = MW 110                    FLAG-W. GTR-9000
MW 156    = MW 116                    FLAG-W. GTR-9000
MW 154    = MW 114                    FLAG-W. GTR-9000

DB 151    = DB 151                    SEND/RECEIVE FOR GTR-9000

FB 127    = FB 127                    RECEIVE-ALL (S)

NETZWERK 5          012F
012F        :A   DB 151     -DB 151
0130        :L   KF +38
0132        :T   DW 110
0133        :L   KF +39
0135        :T   MW 150     -MW 110
0136 M002   :
0137        :B   DW 110
```

```
0138        :L    DW   0
0139        :T    DW 111
013A        :                                  ---------------------------------
013B        :L    DL 111                       HUNDERT
013C        :L    KF +48
013E        :-F
013F        :T    DW 112
0140        :L    DW 112
0141        :SLW       6
0142        :T    DW 113
0143        :L    DW 112
0144        :SLW       5
0145        :T    DW 114
0146        :L    DW 112
0147        :SLW       2
0148        :L    DW 113
0149        :+F
014A        :L    DW 114
014B        :+F
014C        :T    DW 114
014D        :                                  ---------------------------------
014E        :L    DR 111                       TEN
014F        :L    KF +48
0151        :-F
0152        :T    DW 112
0153        :L    DW 112
0154        :SLW       3
0155        :T    DW 113
0156        :L    DW 112
0157        :SLW       1
0158        :L    DW 113
0159        :+F
015A        :T    DW 113
015B        :
015C        :L    DW 110
015D        :I         1
015E        :T    DW 110
015F        :B    DW 110
0160        :L    DW   0
0161        :T    DW 111
0162        :                                  ---------------------------------
0163        :L    DL 111                       ONE
0164        :L    KF +48
0166        :-F
0167        :L    DW 114
0168        :+F
0169        :L    DW 113
016A        :+F
016B        :T    MW 152     -MW 112           SUM
016C        :
016D        :B    MW 154     -MW 114
016E        :A    DB   0
016F        :L    MW 152     -MW 112
0170        :B    MW 150     -MW 110
0171        :T    DW   0
0172        :
0173        :L    MW 150     -MW 110
0174        :I         1
0175        :T    MW 150     -MW 110
0176        :A    DB 151     -DB 151
0177        :L    DW 110
0178        :I         2
0179        :T    DW 110
017A        :L    DW 110
017B        :L    KF +50
017D        :!=F
017E        :SPB =M001
017F        :SPA =M002
0180 M001   :
0181        :***
```

```
FB 150  -FB 150                          C:KERM06ST.S5D                    LAE=528

MW 150    = MW 110                       FLAG-W. GTR-9000
MW 152    = MW 112                       FLAG-W. GTR-9000
MW 154    = MW 114                       FLAG-W. GTR-9000

DB 151    = DB 151                       SEND/RECEIVE FOR GTR-9000

NETZWERK 6          0182
0182        :                                  ---------------------------------
0183        :A    DB 151     -DB 151           SUM
0184        :L    KH 0000
0186        :T    DW 111
0187        :L    KF +6
0189        :T    DW 112
018A M001   :B    DW 112
018B        :L    DW   0
018C        :T    DW 113
018D        :L    DR 113
018E        :L    DL 113
018F        :+F
0190        :L    DW 111
0191        :+F
0192        :T    DW 111
0193        :
0194        :L    DW 112
0195        :I         1
0196        :T    DW 112
0197        :L    DW 112
0198        :L    KF +33
019A        :<=F
019B        :SPB =M001
019C        :                                  ---------------------------------
019D        :L    KH 0030
019F        :T    DL 114
01A0        :L    DL 111
01A1        :L    KH 000F
01A3        :UW
01A4        :T    DR 114
01A5        :L    KH 0009
01A7        :<=F
01A8        :SPB =M002
01A9        :L    KH 0037
01AB        :T    DL 114
01AC M002   :
01AD        :L    DL 114
01AE        :L    DR 114
01AF        :+F
01B0        :T    DW 112
01B1        :
01B2        :L    KH 0030
01B4        :T    DL 114
01B5        :L    DL 111
01B6        :SRW       4
01B7        :L    KH 000F
01B9        :UW
01BA        :T    DR 114
01BB        :L    KH 0009
01BD        :<=F
01BE        :SPB =M003
01BF        :L    KH 0037
01C1        :T    DL 114
01C2 M003   :
01C3        :L    DL 114
01C4        :L    DR 114
01C5        :+F
01C6        :SLW       8
01C7        :L    DW 112
01C8        :OW
01C9        :T    DW 112
01CA        :
01CB        :
01CC        :L    KH 0030
01CE        :T    DL 114
01CF        :L    DR 111
01D0        :L    KH 000F
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                    !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                    !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                    !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                    6!
+-----------------------------------------------------------------------------+
```

```
01D2       :UW
01D3       :T    DR 114
01D4       :L    KH 0009
01D6       :<=F
01D7       :SPB  =M004
01D8       :L    KH 0037
01DA       :T    DL 114
01DB M004  :
01DC       :L    DL 114
01DD       :L    DR 114
01DE       :+F
01DF       :T    DW 115
01E0       :
01E1       :L    KH 0030
01E3       :T    DL 114
01E4       :L    DR 111
01E5       :SRW        4
01E6       :L    KH 000F
01E8       :UW
01E9       :T    DR 114
01EA       :L    KH 0009
01EC       :<=F
01ED       :SPB  =M005
01EE       :L    KH 0037
01F0       :T    DL 114
01F1 M005  :
01F2       :L    DL 114
01F3       :L    DR 114
01F4       :+F
01F5       :SLW        8
01F6       :L    DW 115
01F7       :OW
01F8       :T    DW 115
01F9       :
01FA       :L    DW 112
01FB       :T    MW 150     -MW 110
01FC       :L    DW 115
01FD       :T    MW 152     -MW 112
01FE       :                                  ---------------------------------
01FF       :A    DB 151     -DB 151           CHECK SUM
0200       :L    DW  34
0201       :L    MW 150     -MW 110
0202       :><F                               UNEQUAL ?
0203       :SPB  =M006
0204       :L    DW  35
0205       :L    MW 152     -MW 112
0206       :><F                               UNEQUAL ?
0207 M006  :S    =FAIL                        YES => FAULTMESSAGE
0208       :                                  ---------------------------------
0209       :***

MW 150    = MW 110                  FLAG-W. GTR-9000
MW 152    = MW 112                  FLAG-W. GTR-9000

DB 151    = DB 151                  SEND/RECEIVE FOR GTR-9000

NETZWERK 7          020A
020A       :BE
```

```
FB 170  -FB 170                          C:KERM06ST.S5D        BIB=29092   LAE=216

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  PROFILE MANAGEMENT                         *
*                                                                             *
*******************************************************************************
NAME :RE-HAUPT                                        PROFILE MANAGEMENT

0005       :AWL
0006       :***

NETZWERK 2          0007       ORDER PROFILE ?
0007       :AWL
0008       :A    DB 185     -DB 185
0009       :U    M  160.0                          IF CALL PROFILE
000A       :S    D   20.1                          ORDER REZE
000C       :S    D    1.15                         SET   F-REZE
000E       :UN   D    1.15
0010       :BEB
0011       :***


DB 185    = DB 185                        PROFILE MANAGEMENT

NETZWERK 3          0012       LOAD PROFILE
0012       :AWL
0013       :U    M  162.2                          F2 LOAD
0014       :U    D    1.10                         F-REDA
0016       :UN   D    1.14                         F-ORDER
0018       :S    D    1.1                          F_LOAD
001A       :S    D    1.14                         F_ORDER
001C       :                                       -_LOAD  ----------------------
001D       :U    D    1.1
001F       :SPB FB 171     -FB 171
0020 NAME  :RE-LOAD
0021       :***


FB 171    = FB 171                        LOAD PROFILE

NETZWERK 4          0022       SAVE PROFILE
0022       :AWL
0023       :U    M  160.3                          FUNCTION KEY SAVE (ALLG-F10)
0024       :U(
0025       :O    D    1.10             01          F-REDA
0027       :O    D    1.11             01          F-AGDA
0029       :)                          01
002A       :UN   D    1.14
002C       :S    D    1.2                           F-SAFE
002E       :S    D    1.14                          F-ORDER
0030       :U    D    1.2
0032       :SPB FB 172     -FB 172
0033 NAME  :RE-SAFE
0034       :***


FB 172    = FB 172                        SAVE PROFILE

NETZWERK 5          0035       EDIT PROFILE
0035       :AWL
0036       :U    M  162.4                          FUNCTION KEY EDIT
0037       :U    D    1.10                         F-REDA
0039       :UN   D    1.14
003B       :S    D    1.3                           F-EDIT
003D       :S    D    1.14                          F-ORDER
003F       :U    D    1.3
0041       :SPB FB 173     -FB 173
0042 NAME  :RE-EDIT
0043       :***
```

FB 170 -FB 170 C:KERM06ST.S5D BIB=29092 LAE=216

```
FB 173    = FB 173                          EDIT PROFILE

NETZWERK 6          0044       EDIT ACTUAL PROFILE
0044        :AWL
0045        :U    M  163.4                          FUNCTION KEY EDITA
0046        :UN   D    1.14
0048        :S    D    1.4                          F-EDITA
004A        :S    D    1.14                         F-ORDER
004C        :R    D    1.10                         F-REDA
004E        :U    D    1.4
0050        :SPB FB 174     -FB 174
0051 NAME   :RE-EDITA
0052        :***


FB 174    = FB 174                          EDIT ACTUAL PROFILE

NETZWERK 7          0053       TEACHING FUNCTION
0053        :AWL
0054        :A    DB 180     -DB 180
0055        :L    DL   1
0056        :L    DL  30
0057        :!=F
0058        :=    M  200.0
0059        :L    DL   1
005A        :L    DL  31
005B        :!=F
005C        :=    M  200.1
005D        :A    DB 185     -DB 185
005E        :U    M  200.0
005F        :U    M  200.1
0060        :U    M  163.5                          FUNCTION KEY TEACHING FUNCTION
0061        :UN   D    1.14
0063        :S    D    2.5                          F-TEACH
0065        :S    D    1.14                         F-ORDER
0067        :U    D    2.5
0069        :SPB FB 190     -FB 190
006A NAME   :LERNFKT.
006B        :***


DB 180    = DB 180                          PROFILE AG
DB 185    = DB 185                          PROFILE MANAGEMENT

FB 190    = FB 190                          LEARNFUNCTION

NETZWERK 8          006C       COPY PROFILE
006C        :AWL
006D        :U    M  162.5                          FUNCTION KEY COPY
006E        :U    D    1.10                         F-REDA
0070        :UN   D    1.14
0072        :S    D    1.5                          F-COPY
0074        :S    D    1.14                         F-ORDER
0076        :U    D    1.5
0078        :SPB FB 175     -FB 175
0079 NAME   :RE-COPY
007A        :***


FB 175    = FB 175                          COPY PROFILE

NETZWERK 9          007B       RENAME PROFILE
007B        :AWL
007C        :U    M  162.6                          FUNCTION KEY RENAME
007D        :U    D    1.10                         F-REDA
007F        :UN   D    1.14
0081        :S    D    1.6                          F-RENAM
0083        :S    D    1.14                         F-ORDER
0085        :U    D    1.6
0087        :SPB FB 176     -FB 176
0088 NAME   :RE-RENAM
0089        :***
```

```
FB 170   -FB 170                          C:KERM06ST.S5D        BIB=29092    LAE=216

FB 176    = FB 176                        RENEAME PROFILE

NETZWERK 10          008A       PRINT PROFILE
008A       :AWL
008B       :U    M  163.6                          FUNCTION KEY REPORT
008C       :UN   D    2.12                         AND PRINTER READY
008E       :U(
008F       :O    D    1.10              01         F-REDA
0091       :O    D    1.11              01         F-AGDA
0093       :)                           01
0094       :UN   D    1.14
0096       :S    D    1.7                          F-PRINT
0098       :S    D    1.14                         F-ORDER
009A       :U    D    1.7
009C       :SPB FB 177     -FB 177
009D NAME  :RE-PRINT
009E       :***


FB 177    = FB 177                        PRINT PROFILE

NETZWERK 11          009F       DELETE PROFILE
009F       :AWL
00A0       :U    M  162.7                          FUNCTION KEY ERASE
00A1       :U    D    1.10                         F-REDA
00A3       :UN   D    1.14
00A5       :S    D    1.8                          F-ERASE
00A7       :S    D    1.14                         F-ORDER
00A9       :U    D    1.8
00AB       :SPB FB 178     -FB 178
00AC NAME  :RE-ERASE
00AD       :***


FB 178    = FB 178                        DELETE PROFILE

NETZWERK 12          00AE       PRODUCTION DATAS
00AE       :AWL
00AF       :U    M  162.3                          FUNCTION KEY PROD.REPORT
00B0       :UN   D    1.12                         PRINTER ACTIVE?
00B2       :UN   D    1.14
00B4       :S    D    1.9                          F-PROD.REP
00B6       :S    D    1.14                         F-ORDER
00B8       :U    D    1.9
00BA       :SPB FB 179     -FB 179
00BB NAME  :RE-SCHI
00BC       :***


FB 179    = FB 179                        PRODUCTION REPORT

NETZWERK 13          00BD       CHOICE PROFILE
00BD       :AWL
00BE       :UN   D    1.14                         F-ORDER ?
00C0       :SPB =M001                              NO, TEST PROFILE SELECTION
00C1       :L    DL   3                            YES, DELETE CHANGE
00C2       :T    DR   3
00C3       :SPA =M002                              -> END
00C4 M001  :                                       --------------------------------
00C5       :SPA FB 180     -FB 180
00C6 NAME  :SELECT
00C7 M002  :***


FB 180    = FB 180                        CHOICE PROFILE

NETZWERK 14          00C8       EXIT
00C8       :AWL
00C9       :U    M  160.2                          AND F16 EXIT
00CA       :UN   D    1.14                         AND NO ORDER IS ON
00CC       :R    D    1.15                         E N D   PROFILE MANAGEMENT
00CE       :S    D   20.0
00D0       :***

+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                     !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                     !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                     !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                    3!
+-----------------------------------------------------------------------------+
```

```
NETZWERK 15          00D1
00D1       :AWL
00D2       :BE
```

```
FB 171  -FB 171                    C:KERM06ST.S5D        BIB=23023   LAE=140

NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                                LOAD PROFILE                               *
*                                                                           *
*****************************************************************************
NAME :RE-LOAD                                          LOAD PROFILES

0005      :***

NETZWERK 2          0006       ORDER TO CP527:  CHANGE FKT-KEYS
0006      :A   DB 185     -DB 185
0007      :U   D    2.0                          ORDER ACTIVE?
0009      :SPB =M001                             YES, ->
000A      :U   M    0.1   -M   0.1               SET
000B      :UN  D   19.7
000D      :S   D    2.0                          FKT-CHANGED
000F      :S   D   20.2                          FKT,AKTIV
0011      :BEA
0012 M001 :***

M    0.1 = M   0.1                    "1"-SIGNAL

DB 185   = DB 185                    PROFILE MANAGEMENT

NETZWERK 3          0013       INPUT:  LOAD
0013      :A   DB 185     -DB 185
0014      :U   D    2.1                          ORDER ACTIVE?
0016      :SPB =M001                             YES, ->
0017      :U   M    0.1   -M   0.1               YES,
0018      :UN  D   19.7
001A      :S   D   21.14                         SAFETY REQUEST
001C      :S   D    2.1                          F-REQUEST2
001E      :BEA
001F M001 :UN  M  160.5                          EXIT?
0020      :SPB =M002                             NO, ->
0021      :U   M    0.1   -M   0.1
0022      :UN  D   19.7
0024      :S   D   20.5                          FKT, REAKTIV (MAIN FKT-KEY'S)
0026      :R   D    1.1
0028      :R   D    1.14
002A      :R   D    2.0
002C      :R   D    2.1
002E      :BEA
002F M002 :UN  M  161.0                          FUNCTION KEY ACTIVATE PROFILE?
0030      :BEB                                   NO, END
0031      :U   D   19.7
0033      :BEB
0034      :NOP 0                                 ** DB-CPXX TO DB-AGXX ***
0035      :U   M    0.1   -M   0.1
0036      :S   M    4.6   -M   4.6               LOAD PROFILE
0037      :A   DB 180     -DB 180                OLD PROFILE
0038      :L   DD  62                            LINE SPEED
0039      :L   KG +1000000+01                    = 110%
003C      :XG
003D      :A   DB 160     -DB 160                NEW PROFILE
003E      :L   DD  62                            LINE SPEED
003F      :>=G                                   V(new) <= 1,1 * V(old)
0040      :S   M    3.4   -M   3.4               RELEASE COPY PART B
0041      :A   DB 160     -DB 160
0042      :L   DL   1                            SELECTED PROFILE
0043      :A   DB 180     -DB 180
0044      :L   DL   1                            ACTUAL PROFILE
0045      :!=F                                   SELECTED PROFILE = ACTUAL PROF.
0046      :S   M    3.5   -M   3.5               RELEASE COPY PART B AND C
0047      :SPA FB 192     -FB 192                COPY PART AG TO DB 180
0048 NAME :COPY-A
0049      :
004A      :L   KF +1                             WRITE ACTUAL
004C      :A   DB 180     -DB 180
004D      :T   DR   1
004E      :A   DB 185     -DB 185                WRITE ACTUAL PROFILE NO.
004F      :L   DL   3
+---------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                   !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                   !
+-----------------------------------------+---------------------------------+
! PROJECT          : KERMAN TIRE         !  DATE        :                   !
! INSTALLATION     : TREAD-LINE          !  MODIFICATION:              PGNO!
! PROJECT POS. NO.: 84/823804            !  PROGRAMMER  :                 1!
+-----------------------------------------+---------------------------------+
```

```
0050       :A   DB 184     -DB 184
0051       :T   DR 249
0052       :L   KF +10                          WRITE ACTUAL PROFILE NAME
0054       :XF
0055       :T   MB 220
0056       :L   KF +240
0058       :T   MB 221
0059       :SPA FB 184     -FB 184
005A NAME  :DW-COPY
005B DB    :    DB 184     -DB 184
005C DQDZ  :    MW 220
005D ANZA  :    KF +8
005E       :A   DB 185     -DB 185
005F       :U   M    0.1   -M   0.1
0060       :S   D   20.5                        FKT, REAKTIV (MAIN FKT-KEY'S)
0062       :R   D    1.1                        F-LOAD
0064       :R   D    1.14                       F-ORDER
0066       :R   D    2.0                        F-REQUEST1
0068       :R   D    2.1                        F-REQUEST2
006A       :SPA FB 185     -FB 185              ACTUAL PROFILE NAME
006B NAME  :DB-T>256
006C PANF  :    KY 185,120
006D       :A   DB 199     -DB 199              ACTUAL TIME FOR START PROFILE
006E       :L   DW   1                          HOUR
006F       :T   MW 200
0070       :L   DW   2                          MINUTE
0071       :A   DB 170     -DB 170
0072       :T   DW 249                          MINUTE
0073       :L   MW 200
0074       :T   DW 248                          HOUR
0075       :U   M    3.6   -M   3.6
0076       :UN  T  121     -T 121
0077       :UN  T  122     -T 122
0078       :SPB =M003                           TRANSFER TIME + NAME OF PROFILE
0079       :SPA =M004
007A M003  :A   DB 170     -DB 170
007B       :L   DD 240
007C       :T   DD 210
007D       :L   DD 242
007E       :T   DD 212
007F       :L   DD 244
0080       :T   DD 214
0081       :L   DD 246
0082       :T   DD 216
0083       :L   DD 248
0084       :T   DD 218
0085 M004  :***

M    0.1 = M   0.1                  "1"-SIGNAL
M    4.6 = M   4.6                  LOAD PROFILE
M    3.4 = M   3.4                  COPY PART B  V(new) <= 1.1 V(old)
M    3.5 = M   3.5                  LOAD AND SELECTED PROF. = ACTUAL PROF.
M    3.6 = M   3.6                  NO MATERIAL IN LINE
T  121   = T 121                    TIME FOR PRODUCTION REPORT
T  122   = T 122                    TIME FOR RESET PRODUCTION DATAS

DB 185   = DB 185                   PROFILE MANAGEMENT
DB 180   = DB 180                   PROFILE AG
DB 160   = DB 160                   PROFILE CP
DB 184   = DB 184                   PROFILE NAME
DB 199   = DB 199                   TIME
DB 170   = DB 170                   ACTUAL DATAS

FB 192   = FB 192                   COPY PROFILE PART A
FB 184   = FB 184                   COPY < 254 WORDS
FB 185   = FB 185                   COPY DATA BLOCK

NETZWERK 4          0086
0086       :BE
```

```
NETZWERK 1          0000

********************************************************************************
*                                                                              *
*                                  SAVE PROFILE                                *
*                                                                              *
********************************************************************************
NAME :RE-SAFE                                        SAVE PROFILES

0005       :***

NETZWERK 2          0006       SAFETY REQUEST TO CP527
0006       :A   DB 185     -DB 185
0007       :U   D    2.0                            REQUEST ALREADY ACTIVE
0009       :SPB =M001
000A       :U   M    0.1   -M   0.1
000B       :UN  D   19.7
000D       :S   D   21.8                            ORDER SAFETY REQUEST
000F       :S   D    2.0                            F-REQUEST
0011       :BEA
0012 M001  :***

M    0.1 = M   0.1                    "1"-SIGNAL

DB 185   = DB 185                    PROFILE MANAGEMENT

NETZWERK 3          0013       INPUT F16 CANCEL
0013       :UN  M  160.2                            EXIT?
0014       :SPB =M001                               NO ->
0015       :U   M    0.1   -M   0.1                  YES,
0016       :R   D    1.2                            FINISH ORDER
0018       :R   D    1.14                           F-ORDER
001A       :R   D    2.0                            F-REQUEST1
001C       :R   M  160.2
001D       :BEA
001E M001  :***

M    0.1 = M   0.1                    "1"-SIGNAL

NETZWERK 4          001F       INPUT F10 SAVE
001F       :UN  M  160.3                            SAVE?
0020       :SPB =M001                               NO, ->
0021       :U   D    1.11                           F-AGDA?
0023       :SPB =M002                               YES, ->
0024       :                                        --- SAVE TO DB-RZXX -----
0025       :L   DL   3
0026       :ADD KF +100
0028       :T   DW  13                              PROFILE NO TO
0029       :                                        PARAMETER FOR COPY
002A       :T   DR 202
002B       :SPA FB 185     -FB 185
002C NAME  :DB-T>256
002D PANF  :    KY 185,200
002E       :A   DB 185     -DB 185
002F       :U   M    0.1   -M   0.1                  RESET
0030       :R   D    1.2                            F-SAVE
0032       :R   D    1.14                           F-ORDER
0034       :R   D    2.0                            F-REQUEST1
0036       :BEA
0037 M002  :                                        ---- SAVE TO DB-AGXX ------
0038       :SPA FB 185     -FB 185
0039 NAME  :DB-T>256
003A PANF  :    KY 185,150
003B       :U   M    0.1   -M   0.1                  RESET
003C       :R   D    1.2                            F-SAVE
003E       :R   D    1.14                           F-ORDER
0040       :R   D    2.0                            F-REQUEST1
0042       :BEA
0043 M001  :***

M    0.1 = M   0.1                    "1"-SIGNAL
```

NETZWERK 5 0044 NO INPUT
0044 :BE

```
FB 173  -FB 173                          C:KERM06ST.S5D        BIB=29092   LAE=66

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                    EDIT PROFILE                             *
*                                                                             *
*******************************************************************************
NAME :RE-EDIT                                          EDIT PROFILES

0005       :AWL
0006       :***

NETZWERK 2          0007       SHOW TABLE 02
0007       :AWL
0008       :A   DB 185     -DB 185
0009       :U   D    1.13                          TABLE ARLEADY ACTIVE
000B       :SPB =M001                              YES, -->
000C       :U   M    0.1   -M   0.1                SET  F-TAB
000D       :UN  D   19.7
000F       :S   D   20.3                           ORDER TB02
0011       :S   D    1.13                          F-TAB
0013       :BEA
0014 M001  :***

M    0.1 = M   0.1                    "1"-SIGNAL

DB 185   = DB 185                     PROFILE MANAGEMENT

NETZWERK 3          0015       WAIT FOR INPUTS
0015       :AWL
0016       :***

NETZWERK 4          0017       F15  SELECTION
0017       :AWL
0018       :UN  M  160.1                           SELECT?
0019       :SPB =M001                              NO, ->
001A       :U   M    0.1   -M   0.1                ORDER SELECTION
001B       :UN  D   19.7                           TO CP527
001D       :S   D   20.0
001F       :R   D    1.3                           F-EDIT
0021       :R   D    1.14                          F-ORDER
0023       :R   D    1.13                          F-TAB
0025       :R   D    1.15                          F-REZE
0027       :R   M  160.1
0028       :BEA
0029 M001  :***

M    0.1 = M   0.1                    "1"-SIGNAL

NETZWERK 5          002A       F16 EXIT
002A       :AWL
002B       :UN  M  160.2                           EXIT?
002C       :SPB =M001                              NO, ->
002D       :U   M    0.1   -M   0.1                YES,
002E       :UN  D   19.7
0030       :S   D   20.1                           ORDER PROFILE MANAGEMENT
0032       :R   D    1.3                           F-EDIT
0034       :R   D    1.14                          F-ORDER
0036       :R   D    1.13                          F-TAB
0038       :R   M  160.2
0039       :BEA
003A M001  :***

M    0.1 = M   0.1                    "1"-SIGNAL

NETZWERK 6          003B
003B       :AWL
003C       :BE
```

```
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                     !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                      !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE         :                     !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER   :                    1!
+-----------------------------------------------------------------------------+
```

```
FB 174  -FB 174                    C:KERM06ST.S5D        BIB=29092   LAE=114

NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                              EDIT ACTUAL PROFILE                          *
*                                                                           *
*****************************************************************************
NAME :RE-EDITA                                        EDIT ACTUAL PROFILE

0005       :AWL
0006       :***

NETZWERK 2          0007      DB-AGXX TO DB-CPXX
0007       :AWL
0008       :A   DB 185     -DB 185
0009       :U   D    1.11                            ACTUAL PROFILE ACTIVE?
000B       :SPB =M001                                YES, ->
000C       :                                         NO, LOAD!
000D       :SPA FB 185     -FB 185
000E NAME  :DB-T>256
000F PANF  :    KY 185,50
0010       :                                         --- SWITCH STATE  ---
0011       :A   DB 185     -DB 185                   DELETE OLD STATE!
0012       :L   DL  3
0013       :L   KF +10
0015       :XF
0016       :ADD KF +8
0018       :T   MW 200
0019       :A   DB 184     -DB 184
001A       :L   KF +0
001C       :B   MW 200
001D       :T   DW   0
001E       :SPA =M002
001F       :A   DB 160     -DB 160                   WRITE No. FROM AG-REZEPT
0020       :L   DL   1
0021       :A   DB 185     -DB 185
0022       :T   DL   3
0023       :T   DR   3
0024 M002  :
0025       :A   DB 184     -DB 184                   SELECT ACTUAL
0026       :L   KF +1
0028       :T   DR 248
0029       :A   DB 185     -DB 185
002A       :U   M    0.1   -M   0.1
002B       :S   D    1.11                            F-AGDA SET
002D       :A   DB 170     -DB 170
002E       :L   DD 240                               ACTUAL PROFILE = EDIT PROFILE
002F       :T   DD 230
0030       :L   DD 242
0031       :T   DD 232
0032       :L   DD 244
0033       :T   DD 234
0034       :L   DD 246
0035       :T   DD 236
0036 M001  :***

M    0.1 = M   0.1                        "1"-SIGNAL

DB 185    = DB 185                       PROFILE MANAGEMENT
DB 184    = DB 184                       PROFILE NAME
DB 160    = DB 160                       PROFILE CP
DB 170    = DB 170                       ACTUAL DATAS

FB 185    = FB 185                       COPY DATA BLOCK

NETZWERK 3          0037      SHOW TABLE 02
0037       :AWL
0038       :A   DB 185     -DB 185
0039       :U   D    1.13                            TABLE ALREADY ACTIVE?
003B       :SPB =M001
003C       :U   M    0.1   -M   0.1
003D       :UN  D   19.7
003F       :S   D   20.3                             ORDER TB02
0041       :S   D    1.13                           SET F-TAB
+---------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                  !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                   !
+---------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                    !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                   1!
+---------------------------------------------------------------------------+
```

```
0043       :BEA
0044 M001  :***

M    0.1 = M   0.1                    "1"-SIGNAL

DB 185   = DB 185                     PROFILE MANAGEMENT

NETZWERK 4          0045       WAIT FOR INPUTS
0045       :AWL
0046       :***

NETZWERK 5          0047       F15 SELECTION
0047       :AWL
0048       :UN  M  160.1                          SELCTION?
0049       :SPB =M001                             NO, ->
004A       :U   M    0.1  -M   0.1                ORDER SELECTION
004B       :UN  D   19.7                          TO CP527
004D       :S   D   20.0
004F       :R   D    1.4                          F-EDITA
0051       :R   D    1.14                         F-ORDER
0053       :R   D    1.13                         F-TAB
0055       :R   D    1.15                         F-REZE
0057       :R   M  160.1
0058       :BEA
0059 M001  :***

M    0.1 = M   0.1                    "1"-SIGNAL

NETZWERK 6          005A       F16  EXIT
005A       :AWL
005B       :UN  M  160.2                          EXIT?
005C       :SPB =M001                             NO, ->
005D       :U   M    0.1  -M   0.1                YES, ORDER
005E       :UN  D   19.7                               PROFILE MANAGEMENT
0060       :S   D   20.1
0062       :R   D    1.4                          F-EDITA
0064       :R   D    1.14                         F-ORDER
0066       :R   D    1.13                         F-TAB
0068       :R   M  160.2
0069       :BEA
006A M001  :***

M    0.1 = M   0.1                    "1"-SIGNAL

NETZWERK 7          006B
006B       :AWL
006C       :BE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                                RENAME PROFILE                             *
*                                                                           *
*****************************************************************************
NAME :RE-RENAM                                  RENAME PROFILES

0005       :***

NETZWERK 2          0006       REQUEST NEW NAME
0006       :A   DB 185    -DB 185
0007       :U   D    2.0                        REQUEST ACTIVE ?
0009       :SPB =M001                           YES, ->
000A       :L   KC ..                           DELETE OLD TARGET
000C       :T   DW   5
000D       :T   DW   6
000E       :T   DW   7
000F       :T   DW   8
0010       :T   DW   9
0011       :T   DW  10
0012       :T   DW  11
0013       :T   DW  12
0014       :U   M    0.1  -M   0.1
0015       :UN  D   19.7
0017       :S   D   21.2                        ORDER NEW NAME
0019       :S   D    2.0                        F-REQUEST1 SET
001B       :BEA
001C M001  :UN  M  160.2                        EXIT ?
001D       :O   D    2.1                        OR GO ON
001F       :SPB =M002                           -->
0020       :U   M    0.1  -M   0.1              YES, AWAY
0021       :S   D   21.5                        FUNCTION CANCELED
0023       :R   D    1.6
0025       :R   D    1.14
0027       :R   D    2.0
0029       :R   M  160.2
002A       :BEA
002B M002  :L   DW   5                          WAS AN INPUT?
002C       :L   KC ..
002E       :!=F
002F       :BEB                                 NO, ->>
0030       :***

M    0.1 = M   0.1                    "1"-SIGNAL

DB 185   = DB 185                     PROFILE MANAGEMENT

NETZWERK 3          0031       REQUEST RENAME YES,NO
0031       :U   D    2.1                        REQUEST ACTIVE?
0033       :SPB =M001                           YES, ->
0034       :U   M    0.1  -M   0.1
0035       :UN  D   19.7
0037       :S   D   21.11                       ORDER SET REQUEST
0039       :S   D    2.1                        F-REQUEST2
003B       :BEA
003C M001  :***

M    0.1 = M   0.1                    "1"-SIGNAL

NETZWERK 4          003D       EVALUATION OF INPUTS
003D       :UN  M  162.6                        F6 RENAME ?
003E       :SPB =M001                           NO, ->
003F       :                                    RENAME
0040       :L   KY 1,185                        SOURCE-DB
0042       :T   MW 254
0043       :L   KF +5                           FROM DW
0045       :T   MW 252
0046       :L   KY 1,184                        TARGET-DB
0048       :T   MW 250
0049       :L   DL   3
004A       :L   KF +10
004C       :XF
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                    !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                    !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE          :                   !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER    :                   1!
+-----------------------------------------------------------------------------+
```

```
004D       :T    MW 248                          TO DW
004E       :L    KF +8
0050       :T    MW 246                          LENGTH
0051       :SPA FB 185     -FB 185
0052 NAME  :DB-T>256
0053 PANF  :     KY 0,0
0054       :A    DB 185     -DB 185
0055       :L    KY 1,185
0057       :T    MW 254
0058       :L    KF +5
005A       :T    MW 252
005B       :L    KY 1,170
005D       :T    MW 250
005E       :L    KF +230
0060       :T    MW 248
0061       :L    KF +8
0063       :T    MW 246
0064       :SPA FB 185     -FB 185
0065 NAME  :DB-T>256
0066 PANF  :     KY 0,0
0067       :
0068       :A    DB 185     -DB 185
0069       :U    M    0.1   -M   0.1
006A       :R    D    1.6                        F-RENAME
006C       :R    D    1.14                       F-ORDER
006E       :R    D    2.0                        F-REQUEST1
0070       :R    D    2.1                        F-REQUEST2
0072       :R    M  162.6
0073       :BEA
0074 M001  :UN   M  160.2                        F16 EXIT?
0075       :SPB =M002                            NO, NO INPUTS, ->
0076       :U    M    0.1   -M   0.1             YES, CANCEL
0077       :R    D    1.6                        F-RENAME
0079       :R    D    1.14                       F-ORDER
007B       :R    D    2.0                        F-REQUEST1
007D       :R    D    2.1                        F-REQUEST2
007F       :R    M  160.2
0080       :BEA
0081 M002  :***

M    0.1 = M    0.1                  "1"-SIGNAL

DB 185   = DB 185                    PROFILE MANAGEMENT

FB 185   = FB 185                    COPY DATA BLOCK

NETZWERK 5          0082
0082       :BE
```

```
FB 177  -FB 177                    C:KERM06ST.S5D        BIB=18031   LAE=38

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  PRINT PROFILE                              *
*                                                                             *
*******************************************************************************
NAME :RE-PRINT                                        PRINT PROFILES

0005       :AWL
0006       :***

NETZWERK 2          0007       ORDER TO CP525
0007       :AWL
0008       :A   DB 185     -DB 185
0009       :U   D    1.12                          ORDER ALREADY ACTIVE?
000B       :SPB =M001                              YES, ->
000C       :U   M    0.1   -M   0.1
000D       :S   D   23.0
000F       :S   D    1.12                          ORDER TO CP525
0011       :BEA
0012 M001  :L   DW  16
0013       :L   KF +7
0015       :!=F                                    ORDER READY?
0016       :BEB                                    NO, ->>
0017       :U   M    0.1   -M   0.1                YES, END
0018       :R   D    1.12                          F-CP525
001A       :R   D    1.7                           F-PRINT
001C       :R   D    1.14                          F-ORDER
001E       :***

M    0.1 = M    0.1                    "1"-SIGNAL

DB 185    = DB 185                    PROFILE MANAGEMENT

NETZWERK 3          001F
001F       :AWL
0020       :BE
```

```
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE         :                      !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO! 
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER   :                    1! 
+-------------------------------------------------------------------------------+
```

```
FB 178  -FB 178                          C:KERM06ST.S5D        BIB=18031   LAE=121

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                    DELETE PROFILE                           *
*                                                                             *
*******************************************************************************
NAME :RE-ERASE                                          DELETE PROFILE

0005       :AWL
0006       :***

NETZWERK 2          0007       SAFETY REQUEST
0007       :AWL
0008       :A   DB 185     -DB 185
0009       :U   D    2.0                               REQUEST ACTIVE?
000B       :SPB =M001                                  YES, ->
000C       :U   M    0.1  -M   0.1
000D       :UN  D   19.7
000F       :S   D   21.12                              ORDER SAFETY REQUEST
0011       :S   D    2.0                               F-REQUEST1
0013       :BEA
0014 M001  :***

M    0.1 = M   0.1                      "1"-SIGNAL

DB 185   = DB 185                      PROFILE MANAGEMENT

NETZWERK 3          0015       WAIT FOR INPUT
0015       :AWL
0016       :***

NETZWERK 4          0017       INPUT F7 DELETE
0017       :AWL
0018       :UN  M  162.7                               DELETE?
0019       :SPB =M001                                  NO ->
001A       :L   DL   3                                 *********
001B       :A   DB 100     -DB 100                     PROFILE-No. TO DB 100
001C       :T   DL   1                                 PROFILE-No. PART A
001D       :T   DL  30                                 PROFILE-No. PART B
001E       :T   DL  31                                 PROFILE-No. PART C
001F       :A   DB 185     -DB 185                     *********
0020       :L   KY 1,100                               COPY TO SELECTED
0022       :T   MW 254                                 PROFILE
0023       :L   KF +0                                  *********
0025       :T   MW 252
0026       :L   KF +1
0028       :T   MB 250
0029       :L   DL   3
002A       :ADD KF +100
002C       :T   MB 251
002D       :T   DW  13
002E       :L   KF +0
0030       :T   MW 248
0031       :L   DW  47
0032       :T   MW 246
0033       :SPA FB 185     -FB 185
0034 NAME  :DB-T>256
0035 PANF  :    KY 0,0
0036       :                                           LOAD FROM EMPTY PROFILE
0037       :                                           TO DB-CPXX
0038       :                                           ***
0039       :A   DB 185     -DB 185
003A       :L   DR  13                                 WRITE PROFILE No.
003B       :T   DR 100
003C       :SPA FB 185     -FB 185
003D NAME  :DB-T>256
003E PANF  :    KY 185,100
003F       :
0040       :A   DB 184     -DB 184                     ################################
0041       :L   KC ..                                  DELETE RECIPE-NAME
0043       :T   DW   1
0044       :T   DW   2
0045       :T   DW   3
+-------------------------------------------------------------------------------+
!       KRUPP KUNSTOFFTECHNIK          !                                       !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                        !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE         :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER   :                     1!
+-------------------------------------------------------------------------------+
```

```
0046        :T   DW   4
0047        :T   DW   5
0048        :T   DW   6
0049        :T   DW   7
004A        :T   DW   8
004B        :
004C        :
004D        :A   DB 185    -DB 185                DELETE RECIPE-NAME
004E        :L   KF +1                            SOURCE-DW
0050        :T   MB 220
0051        :L   DL   3                           TARGET-DW
0052        :L   KF +10
0054        :XF
0055        :T   MB 221
0056        :SPA FB 184    -FB 184                DELETE
0057 NAME   :DW-COPY
0058 DB     :    DB 184    -DB 184
0059 DQDZ   :    MW 220
005A ANZA   :    KF +8
005B        :A   DB 185    -DB 185
005C        :U   M    0.1  -M   0.1
005D        :R   D    2.0                         F-REQUEST1
005F        :R   D    1.8                         F-ERASE
0061        :R   D    1.14                        F-ORDER
0063        :BEA
0064 M001   :***

M    0.1 = M   0.1                    "1"-SIGNAL

DB 100    = DB 100                   ORIGINAL PROFILE !!!!!!
DB 185    = DB 185                   PROFILE MANAGEMENT
DB 184    = DB 184                   PROFILE NAME

FB 185    = FB 185                   COPY DATA BLOCK
FB 184    = FB 184                   COPY < 254 WORDS

NETZWERK 5          0065      CANCEL?
0065        :AWL
0066        :UN  M  160.2                         CANCEL?
0067        :SPB =M001                            NO, NO INPUT, ->>
0068        :U   M    0.1  -M   0.1
0069        :R   D    1.8                         F-ERASE
006B        :R   D    2.0                         F-REQUEST1
006D        :R   D    1.14                        F-ORDER
006F        :R   M  160.2
0070        :BEA
0071 M001   :***

M    0.1 = M   0.1                    "1"-SIGNAL

NETZWERK 6          0072
0072        :AWL
0073        :BE
```

```
FB 179  -FB 179                          C:KERM06ST.S5D        BIB=18031   LAE=40

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  PRODUCTION REPORT                          *
*                                                                             *
*******************************************************************************
NAME :RE-SCHI                                          PRODUCTION REPORT

0005       :AWL
0006       :***

NETZWERK 2          0007
0007       :AWL
0008       :A   DB 185     -DB 185
0009       :U   D    1.12                          ORDER ALREADY ACTIVE?
000B       :SPB =M001                              YES, ->
000C       :U   M    0.1   -M   0.1
000D       :UN  D   19.7
000F       :S   D    1.12
0011       :S   D   24.0
0013       :BEA
0014 M001  :L   DW  16
0015       :L   KF +11
0017       :!=F                                    ORDER READY?
0018       :BEB
0019       :U   M    0.1   -M   0.1
001A       :R   D    1.9
001C       :R   D    1.12
001E       :R   D    1.14
0020       :***

M    0.1 = M   0.1                    "1"-SIGNAL

DB 185   = DB 185                     PROFILE MANAGEMENT

NETZWERK 3          0021
0021       :AWL
0022       :BE
```

```
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                     1!
+-------------------------------------------------------------------------------+
```

```
FB 180  -FB 180                          C:KERM06ST.S5D        BIB=23092   LAE=102

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  CHOICE PROFILE                             *
*                                                                             *
*******************************************************************************
NAME :SELECT                                          CHOICE PROFILE

0005       :AWL
0006       :***

NETZWERK 2          0007
0007       :AWL
0008       :A    DB 185     -DB 185
0009       :L    DL   3                               OLD PROFILE-No.
000A       :L    DR   3                               NEW PROFILE-No.
000B       :!=F                                       EQUAL?
000C       :BEB                                       YES, >> OUT
000D       :                                          --- NEW CHOICE ----------------
000E       :U    M     0.1  -M   0.1
000F       :S    D     1.0                            SET              F_SELECT
0011       :S    D     1.14                           SET              F-ORDER
0013       :R    D     1.11                           RESET            F_AGDA
0015       :***

M    0.1 = M    0.1                    "1"-SIGNAL

DB 185    = DB 185                     PROFILE MANAGEMENT

NETZWERK 3          0016       COPY -> DB-CPXX
0016       :AWL
0017       :A    DB 185     -DB 185
0018       :L    DR   3
0019       :ADD KF +100
001B       :T    DW  13                               IN DW13 IS TGE NO. DB-REXX
001C       :T    DR 100                               SOURCE-DB No. TO
001D       :                                          *** COPY *******
001E       :SPA FB 185     -FB 185
001F NAME  :DB-T>256
0020 PANF  :     KY 185,100
0021       :***


DB 185    = DB 185                     PROFILE MANAGEMENT

FB 185    = FB 185                     COPY DATA BLOCK

NETZWERK 4          0022
0022       :AWL
0023       :A    DB 185     -DB 185
0024       :L    DR   3                               ADDRESS FOR NEW
0025       :L    KF +10                               PROFILE NAME
0027       :XF
0028       :T    DW 111
0029       :SPA FB 185     -FB 185
002A NAME  :DB-T>256
002B PANF  :     KY 185,110                           PROFILE NAME COPY TO DB170
002C       :***


DB 185    = DB 185                     PROFILE MANAGEMENT

FB 185    = FB 185                     COPY DATA BLOCK

NETZWERK 5          002D       CHOICE-VISU
002D       :AWL
002E       :A    DB 185     -DB 185                   DELETE OLD CHOICE
002F       :L    KF +0
0031       :L    DL   3
0032       :!=F
0033       :SPB =M001
0034       :L    KF +10
0036       :XF
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                    !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                     !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                      !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                PGNO! 
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                  1!
+-----------------------------------------------------------------------------+
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                   RESET CP                                  *
*                                                                             *
*******************************************************************************
NAME :RESET-CP                                    RESET DW1 AND DW2

0005       :AWL
0006       :***

NETZWERK 2          0007       PRINTER READY
0007       :AWL
0008       :A    DB 185     -DB 185
0009       :L    KH 0000
000B       :T    DW   2
000C       :L    KH 0000
000E       :T    DR   1
000F       :U    M    0.1   -M    0.1
0010       :R    D    1.9
0012       :R    D    1.11
0014       :R    D    1.12
0016       :R    D    1.13
0018       :R    D    1.14
001A       :R    D    1.15
001C       :***

M    0.1 = M   0.1                    "1"-SIGNAL

DB 185   = DB 185                    PROFILE MANAGEMENT

NETZWERK 3          001D
001D       :AWL
001E       :BE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                    COPY < 256 WORDS IN THE SAME DB                        *
*                                                                           *
*****************************************************************************
NAME :DW-COPY                                          COPY DATA WORDS
BEZ  :DB        E/A/D/B/T/Z: B
BEZ  :DQDZ      E/A/D/B/T/Z: E  BI/BY/W/D: W
BEZ  :ANZA      E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF

000E      :AWL
000F      :***

NETZWERK 2          0010      FROM DB-REZE TO XX
0010      :AWL
0011      :LW   =ANZA                          LOAD NUMBER OF DATA WORDS
0012      :T    MB 230
0013      :L    =DQDZ                          LOAD SOURCE-DW AND TARGET-DW
0014      :T    MW 240
0015      :B    =DB                            CALL DB
0016 M001 :B    MW 239                         COPY
0017      :L    DW   0
0018      :B    MW 240
0019      :T    DW   0
001A      :L    MB 240                         SOURCE-DW INKREMENT
001B      :I         1
001C      :T    MB 240
001D      :L    MB 241                         TARGET-DW INKREMENT
001E      :I         1
001F      :T    MB 241
0020      :L    MB 230                         COUNTER DEKREMENT
0021      :D         1
0022      :T    MB 230
0023      :L    MB 230
0024      :L    KF +0
0026      :<=F                                 READY?
0027      :BEB                                 YES, ->>
0028      :SPA =M001
0029      :***

NETZWERK 3          002A
002A      :AWL
002B      :BE
```


```
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK                !                                !
!ELASTOMERTECHNIK          WERK HARBURG      !  MASTERPROGRAMM                !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE             !  DATE          :               !
! INSTALLATION     : TREAD-LINE              !  MODIFICATION:                 PGNO!
! PROJECT POS. NO.: 84/823804                !  PROGRAMMER    :                 1!
+-----------------------------------------------------------------------------+
```

```
0049       :
004A       :L   MW 250
004B       :SPA OB 181
004C       :SPB =M006
004D       :SPM =M007
004E       :TAK
004F       :ENT
0050       :L   MW 248
0051       :ENT
0052       :L   MW 246
0053       :+F
0054       :<F
0055       :SPB =M008
0056       :L   KB 1
0057       :-F
0058       :+F
0059       :T   MW 242
005A       :
005B       :
005C       :L   KB 0
005D       :L   MB 246
005E       :!=F
005F       :SLW      1
0060       :T   BS  60
0061       :L   MW 244
0062       :L   MW 242
0063       :SPB =M009
0064 M010  :TNW    128
0065       :ADD KF -128
0067       :TAK
0068       :ADD KF -128
006A       :TAK
006B       :SPA OB 160
006C       :SPB =M010
006D       :
006E M009  :B   MW 246
006F       :TNW      0
0070       :
0071       :L   KB 0
0072 M011  :T   MB 241
0073       :BEA
0074 M002  :L   KB 129
0075       :SPA =M011
0076 M003  :L   KB 130
0077       :SPA =M011
0078 M004  :L   KB 131
0079       :SPA =M011
007A M005  :L   KB 132
007B       :SPA =M011
007C M006  :L   KB 133
007D       :SPA =M011
007E M007  :L   KB 134
007F       :SPA =M011
0080 M008  :L   KB 135
0081       :SPA =M011
0082       :BE
```

```
###### TARGET-DB ###############
TYP AND NUMBER TARGET DB
DB TEST
YES >> FAULT MESSAGE
YES >> FAULT
A1: NUMBER DW , A2: ADDRESS
A3: ADDRESS
WRITE BEGIN TARGET-DB
A3: NUMBER DW , A4: ADDRESS
BLOCK LENGTH
WRITE BEGIN + BLOCK LENGTH
NUM.DW < WRITE BEGIN  + BLOCK L.
YES >> FAULT MESSAGE
A2: WRITE BEGIN + BLOCKL. A3: AD
WRITE BEGIN + BLOCK L. - 1
WRITE BEGIN + BLOCK L. - 1 + ADD
ENDADDRESS TARGET DB AND
END TARGET-DB
###### TRANSFER ################

BLOCK LENGTH, HIGH-BYTE
BLOCK LENGTH >= 256 WORDS
MULTIPL. WITH 2, NUMBER PART-
  BLOCKS WITH 128 WORDS
END ADDRESS DB-SOURCE
END ADDRESS DB-TARGET
YES >> BLOCKL. LESS THAN 256 W.
TRANSFER PART BLOCK
SOURCE-END ADDRESS - LENGTH FROM
  PART BLOCK
TARGET-END ADDRESS - LENGTH FROM
  PART BLOCK
COUNTER LOOP
YES >> NOT ALL PART BLOCKS
       TRANSFERED
BLOCK LENGTH, LOW-BYTE
REST-BLOCK TRANSFER
###### FAULT MESSAGES ##########
00 (HEX.): NO FAULT
DISPLAY : STATE/FAULT

81 (HEX.):
  SOURCE-DB = TARGET-DB
82 (HEX.):
  BEGIN OR LENGTH >= 4096
83 (HEX.):
  SOURCE-DB NOT ALLOWED
84 (HEX.):
  SOURCE-DB TO SHORT
85 (HEX.):
  TARGET-DB NOT ALLOWED
86 (HEX.):
  TARGET-DB ONLY READ-MEMORY
87 (HEX.):
  TARGET-DB TO SHORT
```

```
NETZWERK 1          0000

**************************************************************************
*                                                                        *
*                                  CONTROL CP'S                          *
*                                                                        *
**************************************************************************
NAME :CONTR-CP

0005       :AWL
0006       :***

NETZWERK 2          0007       ACTIVE ORDERS ON CP'S
0007       :A   DB 185     -DB 185
0008       :                                    -- CP 525 ---
0009       :SPA FB 123     -FB 123
000A NAME  :CONTROL
000B SSNR  :     KY 0,10
000C A-NR  :     KY 0,0
000D ANZW  :     DW  16
000E PAFE  :     MB 200
000F       :L    MB 200
0010       :T    DW  17
0011       :                                    -- CP 527 ----
0012       :SPA FB 123     -FB 123
0013 NAME  :CONTROL
0014 SSNR  :     KY 0,7
0015 A-NR  :     KY 0,0
0016 ANZW  :     DW  14
0017 PAFE  :     MB 200
0018       :L    MB 200
0019       :T    DW  15
001A       :***


DB 185    = DB 185                    PROFILE MANAGEMENT

FB 123    = FB 123                    CONTROL (S)

NETZWERK 3          001B
001B       :AWL
001C       :BE
```

```
FB 187  -FB 187                          C:KERM06ST.S5D        BIB=18031   LAE=141

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                          FLAGS FOR CP527 <---> 135U                         *
*                                                                             *
*******************************************************************************
NAME :KOPPL-M
BEZ  :PANF       E/A/D/B/T/Z: E  BI/BY/W/D: BI

0008       :AWL
0009       :L    KF +0                              DELETE FLAGS
000B       :T    MW 160     -MW 160
000C       :T    MW 162     -MW 162
000D       :T    MW 164     -MW 164
000E       :T    MW 166     -MW 166
000F       :T    MB 168     -MB 168
0010       :U    =PANF                              IF 1 THAN
0011       :SPB  =M001                              WITH DB1 --> DELETE
0012       :L    KH F2A0
0014       :LIR        1
0015       :L    KH 00FF
0017       :UW
0018       :SPZ  =M002
0019       :TAK
001A       :T    MB 160     -MB 160
001B M002  :L    KH F2A1
001D       :LIR        1
001E       :L    KH 00FF
0020       :UW
0021       :SPZ  =M003
0022       :TAK
0023       :T    MB 161     -MB 161
0024 M003  :L    KH F2A2
0026       :LIR        1
0027       :L    KH 00FF
0029       :UW
002A       :SPZ  =M004
002B       :TAK
002C       :T    MB 162     -MB 162
002D M004  :L    KH F2A3
002F       :LIR        1
0030       :L    KH 00FF
0032       :UW
0033       :SPZ  =M005
0034       :TAK
0035       :T    MB 163     -MB 163
0036 M005  :L    KH F2A4
0038       :LIR        1
0039       :L    KH 00FF
003B       :UW
003C       :SPZ  =M006
003D       :TAK
003E       :T    MB 164     -MB 164
003F M006  :L    KH F2A5
0041       :LIR        1
0042       :L    KH 00FF
0044       :UW
0045       :SPZ  =M007
0046       :TAK
0047       :T    MB 165     -MB 165
0048 M007  :L    KH F2A6
004A       :LIR        1
004B       :L    KH 00FF
004D       :UW
004E       :SPZ  =M008
004F       :TAK
0050       :T    MB 166     -MB 166
0051 M008  :L    KH F2A7
0053       :LIR        1
0054       :L    KH 00FF
0056       :UW
0057       :SPZ  =M009
0058       :TAK
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                        !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO! !
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                    1! !
+-------------------------------------------------------------------------------+
```

```
0059        :T   MB 167    -MB 167
005A M009   :L   KH F2A8
005C        :LIR      1
005D        :L   KH 00FF
005F        :UW
0060        :SPZ =M001
0061        :TAK
0062        :T   MB 168    -MB 168
0063 M001   :L   KB 0                          DELETE FLAGS
0064        :L   KH F2A0
0066        :TIR      3
0067        :L   KB 0
0068        :L   KH F2A1
006A        :TIR      3
006B        :L   KB 0
006C        :L   KH F2A2
006E        :TIR      3
006F        :L   KB 0
0070        :L   KH F2A3
0072        :TIR      3
0073        :L   KB 0
0074        :L   KH F2A4
0076        :TIR      3
0077        :L   KB 0
0078        :L   KH F2A5
007A        :TIR      3
007B        :L   KB 0
007C        :L   KH F2A6
007E        :TIR      3
007F        :L   KB 0
0080        :L   KH F2A7
0082        :TIR      3
0083        :L   KB 0
0084        :L   KH F2A8
0086        :TIR      3
0087        :BE

MW 160    = MW 160                    PROFILE MANAGEMENT
MW 162    = MW 162                    PROFILE MANAGEMENT
MW 164    = MW 164                    PROFILE MANAGEMENT
MW 166    = MW 166                    PROFILE MANAGEMENT
MB 168    = MB 168                    PROFILE MANAGEMENT
MB 160    = MB 160                    PROFILE MANAGEMENT
MB 161    = MB 161                    PROFILE MANAGEMENT
MB 162    = MB 162                    PROFILE MANAGEMENT
MB 163    = MB 163                    PROFILE MANAGEMENT
MB 164    = MB 164                    PROFILE MANAGEMENT
MB 165    = MB 165                    PROFILE MANAGEMENT
MB 166    = MB 166                    PROFILE MANAGEMENT
MB 167    = MB 167                    PROFILE MANAGEMENT
```

```
FB 188  -FB 188                        C:KERM06ST.S5D        BIB=18031   LAE=77

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  ORDER TO CP525                             *
*                                                                             *
*******************************************************************************
NAME :AUFT-525

0005       :AWL
0006       :***

NETZWERK 2          0007       LOAD ORDER NUMBER
0007       :AWL
0008       :A    DB 185     -DB 185
0009       :L    DW  23
000A       :L    DW  24
000B       :OW
000C       :L    DW  25
000D       :OW
000E       :L    KF +0                          EXIST SEND-ORDER ?
0010       :!=F
0011       :SPB  =M001                          NO >> EXIT
0012       :U    M    0.1   -M    0.1           YES, SET SEND-ORDER
0013       :S    D   19.8                           (IMPULSE)
0015       :
0016       :                                    LOAD ORDER-NUMBER
0017       :L    KF +7
0019       :U    D   23.0                       PRINT PROFILE
001B       :SPB  =M001
001C       :L    KF +11
001E       :U    D   24.0                       PRODUCTION REPORT
0020       :SPB  =M001
0021 M001  :***

M    0.1 = M    0.1                  "1"-SIGNAL

DB 185    = DB 185                  PROFILE MANAGEMENT

NETZWERK 3          0022
0022       :AWL
0023       :T    DR  31                         LOAD ORDER NUMBER
0024       :UN   D   19.8
0026       :R    D   19.15
0028       :U    D   19.8
002A       :UN   D   19.15
002C       :S    D   19.15
002E       :                                    SEND-ORDER
002F       :SPA FB 120     -FB 120
0030 NAME  :SEND
0031 SSNR  :     KY 255,30
0032 A-NR  :     KY 0,0
0033 ANZW  :     MW   0
0034 QTYP  :     KC NN
0035 DBNR  :     KY 0,0
0036 QANF  :     KF +0
0037 QLAE  :     KF +0
0038 PAFE  :     MB 200
0039       :A    DB 185     -DB 185
003A       :L    MB 200                         SAVE FAULT
003B       :T    DW  36
003C       :U    D   19.8                       RESET ORDER
003E       :R    D   19.8
0040       :L    KH 0000                        RESET ORDERS
0042       :T    DW  23
0043       :T    DW  24
0044       :T    DW  25
0045       :***

DB 185    = DB 185                  PROFILE MANAGEMENT

+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                      !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE         !  DATE        :                      !
! INSTALLATION     : TREAD-LINE          !  MODIFICATION:                 PGNO!
! PROJECT POS. NO.: 84/823804            !  PROGRAMMER  :                    1!
+-------------------------------------------------------------------------------+
```

FB 120 = FB 120 SEND (S)

```
NETZWERK 4          0046
0046       :AWL
0047       :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                ORDER TO CP527                               *
*                                                                             *
*******************************************************************************
NAME :AUFT-527

0005       :AWL
0006       :***

NETZWERK 2          0007      LOAD ORDER NUMBER
0007       :AWL
0008       :A   DB 185    -DB 185
0009       :L   DW  20
000A       :L   DW  21
000B       :OW
000C       :L   DW  22
000D       :OW
000E       :L   KF +0                          EXIST SEND-ORDER ?
0010       :!=F
0011       :=   M  200.0
0012       :U   M  200.0
0013       :SPB =M001                          NO, ->
0014       :U   M    0.1  -M   0.1             YES, SET SEND-ORDER
0015       :S   D   19.0                            (IMPULSE)
0017       :L   KF +100
0019       :U   D   20.0
001B       :SPB =M002                          BAK, AUSWAHL
001C       :L   KF +101
001E       :U   D   20.1
0020       :SPB =M002                          BAK, REZE
0021       :L   KF +102
0023       :U   D   20.2
0025       :SPB =M002                          BAK, TB01
0026       :L   KF +103
0028       :U   D   20.3
002A       :SPB =M002                          BAK, TB02
002B       :L   KF +104
002D       :U   D   20.4
002F       :SPB =M002                          BAK, PD01
0030       :
0031       :U   M  200.0                       GOTO NW3
0032 M001  :SPB =M002
0033       :L   KF +105
0035       :U   D   20.5
0037       :SPB =M002
0038       :L   KF +110
003A       :U   D   21.0
003C       :SPB =M002                          WAK, OPERATION NOT ALLOWED
003D       :L   KF +111
003F       :U   D   21.1
0041       :SPB =M002                          WAK, DATAS NOT ALLOWED
0042       :L   KF +112
0044       :U   D   21.2
0046       :SPB =M002                          WAK, NEW NAME
0047       :L   KF +113
0049       :U   D   21.3
004B       :SPB =M002                          WAK, TARGET PROFILE
004C       :L   KF +114
004E       :U   D   21.4
0050       :SPB =M002                          WAK, FUNCTION DONE
0051       :L   KF +115
0053       :U   D   21.5
0055       :SPB =M002                          WAK, FUNCTION EXIT
0056       :L   KF +116
0058       :U   D   21.6
005A       :SPB =M002                          WAK, PRINTER ACTIVE
005B       :L   KF +120
005D       :U   D   21.8
005F       :SPB =M002                          WAK, SAVE
0060       :L   KF +121
0062       :U   D   21.9
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                    !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                    !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE        :                     !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER  :                     1!
+-----------------------------------------------------------------------------+
```

```
0064       :SPB =M002                    WAK, CANCEL FUNCTION
0065       :L   KF +122
0067       :U   D   21.10
0069       :SPB =M002                    WAK, COPY
006A       :L   KF +123
006C       :U   D   21.11
006E       :SPB =M002                    WAK, RENAME
006F       :L   KF +124
0071       :U   D   21.12
0073       :SPB =M002                    WAK, DELETE
0074       :L   KF +126
0076       :U   D   21.14
0078       :SPB =M002                    WAK, ACTIVATE PROFILE ?
0079       :L   KF +130
007B       :U   D   22.0                 WAK, LEARN FUNCTION ?
007D       :SPB =M002
007E M002  :***

M    0.1 = M   0.1                       "1"-SIGNAL

DB 185   = DB 185                        PROFILE MANAGEMENT

NETZWERK 3          007F
007F       :AWL
0080       :T   DR  41                   LOAD ORDER NUMBER
0081       :UN  D   19.0
0083       :R   D   19.7
0085       :U   D   19.0
0087       :UN  D   19.7
0089       :S   D   19.7
008B       :                             BUILD SEND IMPULSE
008C       :SPA FB 120     -FB 120
008D NAME  :SEND
008E SSNR  :     KY 255,40
008F A-NR  :     KY 0,0
0090 ANZW  :     MW   0
0091 QTYP  :     KC NN
0092 DBNR  :     KY 0,0
0093 QANF  :     KF +0
0094 QLAE  :     KF +0
0095 PAFE  :     MB 200
0096       :A    DB 185     -DB 185
0097       :L    MB 200                 SAVE FAULT
0098       :T    DW  46
0099       :U    D   19.0
009B       :R    D   19.0               RESET ORDER
009D       :L    KH 0000                DELETE ORDERS
009F       :T    DW  20
00A0       :T    DW  21
00A1       :T    DW  22
00A2       :***

DB 185   = DB 185                        PROFILE MANAGEMENT

FB 120   = FB 120                        SEND (S)

NETZWERK 4          00A3
00A3       :AWL
00A4       :BE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                              TEACHING FUNCTION                            *
*                                                                           *
*****************************************************************************
NAME :LERNFKT.

0005       :AWL
0006       :***

NETZWERK 2          0007       SAFETY REQUEST TO CP527
0007       :A    DB 185     -DB 185
0008       :U    D    2.0                        REQUEST1 ACTIVE?
000A       :SPB  =M001
000B       :U    M    0.1   -M   0.1
000C       :UN   D   19.7
000E       :S    D    2.0                        F_REQUEST1 SET
0010       :S    D   22.0                        SET ORDER REQUEST
0012       :BEA
0013 M001  :***

M    0.1 = M    0.1                    "1"-SIGNAL

DB 185    = DB 185                    PROFILE MANAGEMENT

NETZWERK 3          0014       INPUT LEARN FUNCTION
0014       :AWL
0015       :UN   M  163.5                        F13 : SAVE ACT.PROFILE
0016       :O    D   19.7
0018       :SPB  =M001
0019       :A    DB 184     -DB 184
001A       :L    DR 249                         NUMBER ACTUAL PROFILE IN AG
001B       :L    KF +100
001D       :+F
001E       :A    DB 185     -DB 185
001F       :T    DR  72                         WRITE TARGET-No.
0020       :SPA  FB 185     -FB 185              *** DB-AGXX TO DB-RZXX ***
0021 NAME  :DB-T>256
0022 PANF  :     KY 185,70
0023       :
0024       :A    DB 184     -DB 184              PROFILE No. ACTUAL PROFILE
0025       :L    KF +240                         COPY BACK
0027       :T    MB 224                          SOURCE-ADDRESS
0028       :L    DR 249                          PROFILE No.
0029       :L    KF +10
002B       :XF
002C       :T    MB 225                          TARGET-ADDRESS
002D       :SPA  FB 184     -FB 184
002E NAME  :DW-COPY
002F DB    :     DB 184     -DB 184
0030 DQDZ  :     MW 224
0031 ANZA  :     KF +8
0032       :A    DB 185     -DB 185
0033       :L    DL   3                          SELECTED PROFILE
0034       :A    DB 184     -DB 184
0035       :L    DR 249                          ACTUAL PROFILE
0036       :><F
0037       :SPB  =M002                           YES >> NO COPY DBAGXX -> DBCPXX
0038       :SPA  FB 185     -FB 185
0039 NAME  :DB-T>256
003A PANF  :     KY 185,50
003B       :L    KF +0
003D       :A    DB 160     -DB 160              RESET ACTUAL STATE
003E       :T    DR   1
003F M002  :A    DB 185     -DB 185
0040       :U    M    0.1   -M   0.1
0041       :R    D    2.0                        F_REQUEST1
0043       :R    D    2.5                        F_LEARN
0045       :R    D    1.14                       F_ORDER
0047       :BEA
0048 M001  :***
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                    PICTURES                                 *
*                                                                             *
*******************************************************************************
NAME :PICTURES

0005       :A   DB 188     -DB 188
0006       :O   M   40.0   -M  40.0            UPPER EXTRUDER
0007       :O   M   42.5   -M  42.5
0008       :SPB =M001                         YES >> FAULT
0009       :L   KF +0
000B       :T   DL   1                        D01
000C       :T   DL  46                        D02
000D       :T   DL 106                        D06
000E       :T   DR 106                        D06
000F       :A   DB 170     -DB 170
0010       :T   DL 130                        D01
0011       :A   DB 188     -DB 188
0012       :SPA =M002
0013 M001  :L   KF +1
0015       :T   DL   1                        D01
0016       :T   DL  46                        D02
0017       :T   DL 106                        D06
0018       :T   DR 106                        D06
0019       :A   DB 170     -DB 170
001A       :T   DL 130                        D01
001B       :A   DB 188     -DB 188
001C M002  :
001D       :O   M   43.0   -M  43.0            EXTRUDER BOTTOMMACHINE
001E       :O   M   45.7   -M  45.7
001F       :SPB =M003                         YES >> FAULT
0020       :L   KF +0
0022       :T   DL   2                        D01
0023       :T   DL  47                        D02
0024       :T   DL 107                        D06
0025       :T   DR 107                        D06
0026       :A   DB 170     -DB 170
0027       :T   DR 130                        D01
0028       :A   DB 188     -DB 188
0029       :SPA =M004
002A M003  :L   KF +1
002C       :T   DL   2                        D01
002D       :T   DL  47                        D02
002E       :T   DL 107                        D06
002F       :T   DR 107                        D06
0030       :A   DB 170     -DB 170
0031       :T   DR 130                        D01
0032       :A   DB 188     -DB 188
0033 M004  :
0034       :O   M   57.0   -M  57.0            EXTRUDER CALANDER
0035       :O   M   57.7   -M  57.7
0036       :SPB =M005                         YES >> FAULT
0037       :L   KF +0
0039       :T   DL   3                        D01
003A       :T   DL  70                        D03
003B       :T   DL 108                        D06
003C       :T   DR 108                        D06
003D       :T   DL 109                        D06
003E       :A   DB 170     -DB 170
003F       :T   DL 131                        D01
0040       :A   DB 188     -DB 188
0041       :SPA =M006
0042 M005  :L   KF +1
0044       :T   DL   3                        D01
0045       :T   DL  70                        D03
0046       :T   DL 108                        D06
0047       :T   DR 108                        D06
0048       :T   DL 109                        D06
0049       :A   DB 170     -DB 170
004A       :T   DL 131                        D01
004B       :A   DB 188     -DB 188
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                     1!
+-------------------------------------------------------------------------------+
```

```
004C M006 :
004D      :***

M   40.0 = M  40.0                    UP.EXTR. : GENERAL FAULTS
M   42.5 = M  42.5                    UP.EXTR. : FAULT EXTRUDER OFF
M   43.0 = M  43.0                    BOT.EXTR. : GENERAL FAULTS
M   45.7 = M  45.7                    BOT.EXTR. : FAULT EXTRUDER OFF
M   57.0 = M  57.0                    EX.CAL. : GENERAL FAULT EXTRUDER 3
M   57.7 = M  57.7                    EX.CAL. : FAULT EXTRUDER OFF

DB 188   = DB 188                     PICTURES
DB 170   = DB 170                     ACTUAL DATAS

NETZWERK 2          004E
004E      :O   M  182.5  -M0290                AUX. DRIVES TOPMACHINE
004F      :O   M  180.5  -M0274
0050      :O   M  182.3  -M0288
0051      :O   M  181.5  -M0266
0052      :O   M  181.2  -M0263
0053      :SPB =M001                           YES >> FAULT
0054      :L   KF +0
0056      :T   DR   1                          D01
0057      :T   DR  46                          D03
0058      :SPA =M002
0059 M001 :L   KF +1
005B      :T   DR   1                          D01
005C      :T   DR  46                          D02
005D M002 :
005E      :O   M  182.6  -M0291                AUX. DRIVES BOTTOMMACHINE
005F      :O   M  180.6  -M0275
0060      :O   M  182.4  -M0289
0061      :O   M  181.6  -M0267
0062      :O   M  181.3  -M0264
0063      :SPB =M003                           YES >> FAULT
0064      :L   KF +0
0066      :T   DR   2                          D01
0067      :T   DR  47                          D02
0068      :SPA =M004
0069 M003 :L   KF +1
006B      :T   DR   2                          D01
006C      :T   DR  47                          D02
006D M004 :
006E      :O   M  181.1  -M0262                AUX. DRIVES EXTR. CALANDER
006F      :O   M  180.7  -M0276
0070      :O   M  181.0  -M0261
0071      :O   M  181.7  -M0268
0072      :O   M  181.4  -M0265
0073      :O   M  182.2  -M0287
0074      :SPB =M005                           YES >> FAULT
0075      :L   KF +0
0077      :T   DR   3                          D01
0078      :T   DR  70                          D03
0079      :SPA =M006
007A M005 :L   KF +1
007C      :T   DR   3                          D01
007D      :T   DR  70                          D03
007E M006 :
007F      :***

M  182.5 = M0290                      MOTOR OIL PUMP FAULT      UPPER EXTRUDER
M  180.5 = M0274                      DRIVE MOTOR EXTERNAL FAN  UPPER EXTRUDER
M  182.3 = M0288                      PRESSURE WATER-COOLING    UPPER EXTRUDER
M  181.5 = M0266                      OIL FLOW OIL LUBRICATION  UPPER EXTRUDER
M  181.2 = M0263                      PRESSURE OIL LUBRICATION  UPPER EXTRUDER
M  182.6 = M0291                      MOTOR OIL PUMP FAULT     BOTTOM EXTRUDER
M  180.6 = M0275                      DRIVE MOTOR EXTERNAL FAN BOTTOM EXTRUDER
M  182.4 = M0289                      PRESSURE WATER-COOLING   BOTTOM EXTRUDER
M  181.6 = M0267                      OIL FLOW OIL LUBRICATION BOTTOM EXTRUDER
M  181.3 = M0264                      PRESSURE OIL LUBRICATION BOTTOM EXTRUDER
M  181.1 = M0262                      DRIVE MOTOR OIL PUMP   EXTRUDER CALENDER
M  180.7 = M0276                      DRIVE MOTOR EXTERNAL FAN OUT. EXTR. CAL.
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M  181.0 = M0261                DRIVE MOTOR EXTERNAL FAN INS. EXTR. CAL.
M  181.7 = M0268                OIL FLOW OIL LUBRICATION  EXTR. CALENDER
M  181.4 = M0265                PRESSURE OIL LUBRICATION  EXTR. CALENDER
M  182.2 = M0287                TEMP. OIL LUBRICATION  EXTRUDER CALENDER

NETZWERK 3          0080
0080       :O   E    2.3  -74K5          DRAW-OFF CONVEYOR
0081       :SPB =M001                     YES >> FAULT
0082       :L   KF +0
0084       :T   DL   6                    D01
0085       :T   DL   7                    D01
0086       :T   DL  57                    D03
0087       :SPA =M002
0088 M001  :L   KF +1
008A       :T   DL   6                    D01
008B       :T   DL   7                    D01
008C       :T   DL  57                    D03
008D M002  :
008E       :O   E    2.4  -78K5          CONVEYOR LINEAR SCALE
008F       :SPB =M003                     YES >> FAULT
0090       :L   KF +0
0092       :T   DR   7                    D01
0093       :                              DL8 D01
0094       :T   DL  58                    D03
0095       :                              DR58 D03
0096       :SPA =M004
0097 M003  :L   KF +1
0099       :T   DR   7                    D01
009A       :T   DL  58                    D03
009B M004  :
009C       :                              CONVEYOR CALANDER MIT CALANDER
009D       :
009E       :O   E    6.0  -101K5         CONVEYOR CEMENTING 2
009F       :SPB =M005                     YES >> FAULT
00A0       :L   KF +0
00A2       :T   DR   9                    D01
00A3       :T   DL  59                    D03
00A4       :SPA =M006
00A5 M005  :L   KF +1
00A7       :T   DL   9                    D01
00A8       :T   DL  59                    D03
00A9 M006  :
00AA       :O   E    4.1  -90K5          CONVEYOR CALANDER
00AB       :SPB =M007                     YES >> FAULT
00AC       :L   KF +0
00AE       :T   DL   9                    D01
00AF       :T   DR  59                    D03
00B0       :SPA =M008
00B1 M007  :L   KF +1
00B3       :T   DL   9                    D01
00B4       :T   DR  59                    D03
00B5 M008  :
00B6       :O   E    6.3  -104K5         COOLING SECTION 1
00B7       :SPB =M009                     YES >> FAULT
00B8       :L   KF +0
00BA       :T   DL  10                    D01
00BB       :T   DR  10                    D01
00BC       :T   DR  79                    D04
00BD       :SPA =M010
00BE M009  :L   KF +1
00C0       :T   DL  10                    D01
00C1       :T   DR  10                    D01
00C2       :T   DR  79                    D04
00C3 M010  :
00C4       :O   E    6.4  -106K5         COOLING SECTION 2
00C5       :SPB =M011                     YES >> FAULT
00C6       :L   KF +0
00C8       :T   DL  11                    D01
00C9       :T   DL  80                    D04
00CA       :SPA =M012
00CB M011  :L   KF +1
00CD       :T   DL  11                    D01
00CE       :T   DL  80                    D04
00CF M012  :
```

```
00D0       :O   E    6.5  -109K5          COOLING SECTION 3
00D1       :SPB =M013                     YES >> FAULT
00D2       :L   KF +0
00D4       :T   DR  11                    D01
00D5       :T   DR  80                    D04
00D6       :SPA =M014
00D7 M013  :L   KF +1
00D9       :T   DR  11                    D01
00DA       :T   DR  80                    D04
00DB M014  :
00DC       :O   E    6.6  -111K5          COOLING SECTION 4
00DD       :SPB =M015                     YES >> FAULT
00DE       :L   KF +0
00E0       :T   DL  12                    D01
00E1       :T   DR  12                    D01
00E2       :T   DL  81                    D04
00E3       :SPA =M016
00E4 M015  :L   KF +1
00E6       :T   DL  12                    D01
00E7       :T   DR  12                    D01
00E8       :T   DL  81                    D04
00E9 M016  :
00EA       :O   E    7.5  -116K5          CONVEYOR CENTERING 2
00EB       :SPB =M017                     YES >> FAULT
00EC       :L   KF +0
00EE       :T   DL  13                    D01
00EF       :T   DL  82                    D04
00F0       :SPA =M018
00F1 M017  :L   KF +1
00F3       :T   DL  13                    D01
00F4       :T   DR  82                    D04
00F5 M018  :
00F6       :O   E    7.4  -114K5          KNIFE MIDDLE SEP.DEVICE
00F7       :SPB =M019                     YES >> FAULT
00F8       :L   KF +0
00FA       :T   DL  28                    D01
00FB       :T   DR  84                    D04
00FC       :SPA =M020
00FD M019  :L   KF +1
00FF       :T   DL  28                    D01
0100       :T   DR  84                    D04
0101 M020  :
0102       :O   M  193.1 -M0358           CONVEYOR SKIVER
0103       :SPB =M021                     YES FAULT
0104       :L   KF +0
0106       :T   DR  13                    D01
0107       :T   DR  82                    D04
0108       :SPA =M022
0109 M021  :L   KF +1
010B       :T   DR  13                    D01
010C       :T   DR  82                    D04
010D M022  :
010E       :O   E    7.6  -121K5          FREEWHEEL + ACCALERATING CONV.
010F       :SPB =M023                     YES >> FAULT
0110       :L   KF +0
0112       :T   DL  14                    D01
0113       :T   DL  91                    D05
0114       :SPA =M024
0115 M023  :L   KF +1
0117       :T   DL  14                    D01
0118       :T   DL  91                    D05
0119 M024  :
011A       :O   E    7.7  -129K5          CONVEYOR TREAD CHECKER
011B       :SPB =M025                     YES >> FAULT
011C       :L   KF +0
011E       :T   DR  14                    D01
011F       :T   DR  91                    D05
0120       :SPA =M026
0121 M025  :L   KF +1
0123       :T   DR  14                    D01
0124       :T   DR  91                    D05
0125 M026  :
0126       :O   E    8.0  -131Q1          SLOW-DOWN CONVEYOR
0127       :SPB =M027                     YES >> FAULT
```

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0128       :L   KF +0
012A       :T   DL  91                          D05
012B       :SPA =M028
012C M027  :L   KF +1
012E       :T   DL  91                          D05
012F M028  :
0130       :O   E    8.1  -132Q1/Q3             CONVEYOR END CEMENTING
0131       :SPB =M029                           YES >> FAULT
0132       :L   KF +0
0134       :T   DR  15                          D01
0135       :T   DR  92                          D05
0136       :SPA =M030
0137 M029  :L   KF +1
0139       :T   DR  15                          D01
013A       :T   DR  92                          D05
013B M030  :
013C       :O   E    8.4  -136Q1/Q3             TAKE-AWAY CONVEYOR
013D       :SPB =M031                           YES >> FAULT
013E       :L   KF +0
0140       :T   DL  16                          D01
0141       :SPA =M032
0142 M031  :L   KF +1
0144       :T   DL  16                          D01
0145 M032  :***

E    2.3 = 74K5                    DRAW-OFF + SHRINKAGE CONVEYOR FAULT
E    2.4 = 78K5                    CONVEYOR LINEAR CHECK WEIGHER FAULT
E    6.0 = 101K5                   CONVEYOR CEMENTING 2 FAULT
E    4.1 = 90K5                    FEEDING BELT CALENDER FAULT
E    6.3 = 104K5                   COOLING LINE PART 1 FAULT
E    6.4 = 106K5                   COOLING LINE PART 2 FAULT
E    6.5 = 109K5                   COOLING LINE PART 3 FAULT
E    6.6 = 111K5                   COOLING LINE PART 4 FAULT
E    7.5 = 116K5                   CENTERING CONVEYOR FAULT
E    7.4 = 114K5                   KNIFE MIDDLE SEP.DEVICE FAULT
M  193.1 = M0358                   CONVEYOR BELT MOTOR FAULT   TREAD SKIVER
E    7.6 = 121K5                   ACCELERATING CONVEYOR FAULT
E    7.7 = 129K5                   TREAD CHECK WEIGHER CONVEYOR FAULT
E    8.0 = 131Q1                   SLOW-DOWN CONVEYOR FAULT
E    8.1 = 132Q1/Q3                END CEM. FAULT
E    8.4 = 136Q1/Q3                TAKE-AWAY CONVEYOR FAULT

NETZWERK 4          0146
0146       :O   M   17.0  -M  17.0              LOOP LINEAR WEIGHER
0147       :SPB =M001                           YES >> FAULT
0148       :L   KF +0
014A       :T   DL  62                          D03
014B       :SPA =M002
014C M001  :L   KF +1
014E       :T   DL  62                          D03
014F M002  :
0150       :O   M   17.6  -M  17.6              LOOP CALANDER
0151       :SPB =M003                           YES >> FAULT
0152       :L   KF +0
0154       :T   DR  62                          D03
0155       :SPA =M004
0156 M003  :L   KF +1
0158       :T   DR  62                          D03
0159 M004  :
015A       :O   M   17.1  -M  17.1              LOOP CEMENTING 2
015B       :SPB =M005                           YES >> FAULT
015C       :L   KF +1
015E       :T   DL  63                          D03
015F       :SPA =M006
0160 M005  :L   KF +1
0162       :T   DL  63                          D03
0163 M006  :
0164       :O   M   17.2  -M  17.2              LOOP COOLING SECTION 1
0165       :SPB =M007                           YES >> FAULT
0166       :L   KF +0
0168       :T   DL  76                          D04
0169       :SPA =M008
016A M007  :L   KF +1
016C       :T   DL  76                          D04
```

```
016D M008 :
016E      :O   M   17.3  -M  17.3          LOOP COOLING SECTION 2
016F      :SPB =M009                       YES >> FAULT
0170      :L   KF +0
0172      :T   DR  76                      D04
0173      :SPA =M010
0174 M009 :L   KF +1
0176      :T   DR  76                      D04
0177 M010 :
0178      :O   M   17.4  -M  17.4          LOOP COOLING SECTION 3
0179      :SPB =M011                       YES >> FAULT
017A      :L   KF +0
017C      :T   DL  77                      D04
017D      :SPA =M012
017E M011 :L   KF +1
0180      :T   DL  77                      D04
0181 M012 :
0182      :O   M   17.5  -M  17.5          LOOP COOLING SECTION 4
0183      :SPB =M013                       YES >> FAULT
0184      :L   KF +0
0186      :T   DR  77                      D04
0187      :SPA =M014
0188 M013 :L   KF +1
018A      :T   DR  77                      D04
018B M014 :
018C      :O   M  192.4  -M0369            LIGHT BARRIER SKIVER
018D      :SPB =M015                       YES >> FAULT
018E      :L   KF +0
0190      :T   DL  78                      D04
0191      :SPA =M016
0192 M015 :L   KF +1
0194      :T   DL  78                      D04
0195 M016 :***

M   17.0 = M  17.0              EXTR. POSITION LOOP LINEAR CHECK WEIGHER
M   17.6 = M  17.6              EXTR. POSITION LOOP CALENDER
M   17.1 = M  17.1              EXTR. POSITION LOOP CONVEYOR CEMENTING 2
M   17.2 = M  17.2              EXTR. POSITION LOOP COOLING SECTION 1
M   17.3 = M  17.3              EXTR. POSITION LOOP COOLING SECTION 2
M   17.4 = M  17.4              EXTR. POSITION LOOP COOLING SECTION 3
M   17.5 = M  17.5              EXTR. POSITION LOOP COOLING SECTION 4
M  192.4 = M0369                MATERIAL OUT OF MEAS.RANGE  TREAD SKIVER

NETZWERK 5          0196
0196      :O   E    2.1  -72Q1           EXHAUSTER 1
0197      :O   E    2.2  -72A7
0198      :SPB =M001                      YES >> FAULT
0199      :L   KF +0
019B      :T   DL  18                     D01
019C      :T   DL  60                     D03
019D      :SPA =M002
019E M001 :L   KF +1
01A0      :T   DL  18                     D01
01A1      :T   DL  60                     D03
01A2 M002 :
01A3      :O   E    2.5  -79Q2           EXHAUSTER CEMENTING 1
01A4      :O   E    2.6  -79A7
01A5      :SPB =M003
01A6      :L   KF +0
01A8      :T   DR  18                     D01
01A9      :T   DR  60                     D03
01AA      :SPA =M004
01AB M003 :L   KF +1
01AD      :T   DR  18                     D01
01AE      :T   DR  60                     D03
01AF M004 :
01B0      :O   E    6.1  -102Q2          EXHAUSTER CEMENTING 2
01B1      :O   E    6.2  -102A6
01B2      :SPB =M005
01B3      :L   KF +0
01B5      :T   DL  19                     D01
01B6      :T   DL  61                     D03
01B7      :SPA =M006
01B8 M005 :L   KF +1
```

```
01BA       :T   DL  19                          D01
01BB       :T   DL  61                          D03
01BC M006  :
01BD       :O   E    8.2  -133Q1                EXHAUSTER END CEMENTING
01BE       :O   E    8.3  -133A7
01BF       :SPB =M007                           YES >> FAULT
01C0       :L   KF +0
01C2       :T   DR  19                          D01
01C3       :T   DL 102                          D05
01C4       :SPA =M008
01C5 M007  :L   KF +1
01C7       :T   DR  19                          D01
01C8       :T   DL 102                          D05
01C9 M008  :***

E    2.1 = 72Q1                     EXHAUST FRONT PLANT SECTION FAULT
E    2.2 = 72A7                     EXHAUST FRONT PL. EXCESS TEM MOT WINDING
E    2.5 = 79Q2                     EXHAUST CEMENTING 1 FAULT
E    2.6 = 79A7                     EXHAUST CEM1 FAULT EXCESS TEMP MOT WIND
E    6.1 = 102Q2                    EXHAUST CEMENTING 2 FAULT
E    6.2 = 102A6                    EXHAUST CEMENTING 2 EXCESS TEMP.MOT WIND
E    8.2 = 133Q1                    END CEM. EXHAUST FAULT
E    8.3 = 133A7                    END CEM. EXHAUST EXCESS TEMP MOT WINDING

NETZWERK 6          01CA
01CA       :O   M  192.0  -M0365                SKIVER
01CB       :O   M  192.2  -M0367
01CC       :O   M  192.3  -M0368
01CD       :O   M  192.4  -M0369
01CE       :O   M  192.5  -M0370
01CF       :O   M  192.6  -M0371
01D0       :O   M  192.7  -M0372
01D1       :O   M  193.0  -M0357
01D2       :O   M  193.2  -M0359
01D3       :O   M  193.3  -M0360
01D4       :O   M  193.7  -M0364
01D5       :O   M  194.1  -M0382
01D6       :O   M  194.2  -M0383
01D7       :O   M  194.3  -M0384
01D8       :O   M  194.4  -M0385
01D9       :SPB =M001                           YES >> FAULT
01DA       :L   KF +0
01DC       :T   DR  28                          D01
01DD       :T   DL  85                          D04
01DE       :SPA =M002
01DF M001  :L   KF +1
01E1       :T   DR  28                          D01
01E2       :T   DL  85                          D04
01E3 M002  :
01E4       :O   E    4.3  -93A6                CALANDER
01E5       :O   E    4.4  -91A1/1
01E6       :O   E    4.5  -91A1/2
01E7       :O   E   60.1  -285S2
01E8       :O   T   36    -T  36
01E9       :SPB =M003                           YES >> FAULT
01EA       :L   KF +0
01EC       :T   DL  27                          D01
01ED       :T   DL  71                          D03
01EE       :T   DL 111                          D06
01EF       :SPA =M004
01F0 M003  :L   KF +1
01F2       :T   DL  27                          D01
01F3       :T   DL  71                          D03
01F4       :T   DL 111                          D06
01F5 M004  :
01F6       :O   E    5.0  -96Q1                AUX.DRIVES CALANDER
01F7       :O   E    5.1  -96Q4
01F8       :O   E    5.2  -96Q6
01F9       :O   E    5.3  -97Q1
01FA       :O   M  177.0  -M0229
01FB       :O   M  177.2  -M0231
01FC       :SPB =M005                           YES >> FAULT
01FD       :L   KF +0
01FF       :T   DR  71                          D03
```

```
0200       :SPA =M006
0201 M005  :L   KF +1
0203       :T   DR  71                          D03
0204 M006  :***

M  192.0 = M0365                  MOTOR KNIFE TRANSFER FAULT  TREAD SKIVER
M  192.2 = M0367                  BALL-UP NO CUTTING          TREAD SKIVER
M  192.3 = M0368                  BALL-UP CONVEYOR STOP       TREAD SKIVER
M  192.4 = M0369                  MATERIAL OUT OF MEAS.RANGE  TREAD SKIVER
M  192.5 = M0370                  TIMER KNIFE FEED CUTTING    TREAD SKIVER
M  192.6 = M0371                  TIMER LIFTING KNIFE         TREAD SKIVER
M  192.7 = M0372                  TIMER KNIFE REVERSE         TREAD SKIVER
M  193.0 = M0357                  TIMER KNIFE NORMAL POSITION TREAD SKIVER
M  193.2 = M0359                  EXTERNAL FAN MOTOR FAULT    TREAD SKIVER
M  193.3 = M0360                  KNIFE MOTOR FAULT           TREAD SKIVER
M  193.7 = M0364                  AC-CONTROL VOLTAGE FAULT    TREAD SKIVER
M  194.1 = M0382                  COMPRESSED AIR FAULT        TREAD SKIVER
M  194.2 = M0383                  E-STOP CABINET              TREAD SKIVER
M  194.3 = M0384                  E-STOP OPERATOR PANEL       TREAD SKIVER
M  194.4 = M0385                  START LOOK LIGHT CURTAIN    TREAD SKIVER
E    4.3 = 93A6                   CALENDER CARBON BRUSH CONTROL
E    4.4 = 91A1/1                 CALENDER FAULT DC-CONVERTER TEMP.
E    4.5 = 91A1/2                 CALENDER FAULT DC-CONVERTER
E   60.1 = 285S2                  CALENDER MAX OIL PRESSURE
T   36   = T  36                  CALENDER : FAULT MOTOR TEMP
E    5.0 = 96Q1                   CALENDER FAULT OIL PUMP
E    5.1 = 96Q4                   CALENDER FAULT EXTERNAL FAN OUTSIDE
E    5.2 = 96Q6                   CALENDER FAULT EXTERNAL FAN INSIDE
E    5.3 = 97Q1                   CALENDER FAULT MOTOR HYDRAULIC BRAKE
M  177.0 = M0229                  FAULT OIL LUBRICATION           CALENDER
M  177.2 = M0231                  MIN OIL PRESSURE                CALENDER

NETZWERK 7          0205
0205       :AWL
0206       :BE
```

NETZWERK 1 0000

```
**********************************************************************************
*                                                                                *
*                          COPY PROFILE PART A TO DB180                          *
*                                                                                *
**********************************************************************************
NAME :COPY-A

0005       :L    KY 1,160                        COPY DW0-DW25
0007       :T    MW 254
0008       :L    KF +0
000A       :T    MW 252
000B       :L    KY 1,180
000D       :T    MW 250
000E       :L    KF +0
0010       :T    MW 248
0011       :L    KF +26
0013       :T    MW 246
0014       :SPA FB 185     -FB 185
0015 NAME :DB-T>256
0016 PANF :      KY 0,0
0017       :A    DB 160     -DB 160
0018       :L    DD  34                          UP.EXTR. MAX FLOW PR.(WARNING)
0019       :A    DB 180     -DB 180
001A       :T    DD  34
001B       :A    DB 160     -DB 160
001C       :L    DD  36                          UP.EXTR. MAX FLOW PR.(TURN OFF)
001D       :A    DB 180     -DB 180
001E       :T    DD  36
001F       :A    DB 160     -DB 160
0020       :L    DD  42                          BOT.EXTR. MAX FLOW PR.(WARNING)
0021       :A    DB 180     -DB 180
0022       :T    DD  42
0023       :A    DB 160     -DB 160
0024       :L    DD  44                          BOT.EXTR. MAX FLOW PR.(TURN OFF)
0025       :A    DB 180     -DB 180
0026       :T    DD  44
0027       :A    DB 160     -DB 160
0028       :L    DW  74                          PRESET TEMP. UPPER EXTR. SCREW
0029       :A    DB 180     -DB 180
002A       :T    DW  74
002B       :A    DB 160     -DB 160
002C       :L    DW  75                          MIN TEMP. UPPER EXTRUDER SCREW
002D       :A    DB 180     -DB 180
002E       :T    DW  75
002F       :A    DB 160     -DB 160
0030       :L    DW  76                          PRESET TEMP. UPPER EXTR. BARREL
0031       :A    DB 180     -DB 180
0032       :T    DW  76
0033       :A    DB 160     -DB 160
0034       :L    DW  77                          MIN TEMP. UPPER EXTRUDER BARREL
0035       :A    DB 180     -DB 180
0036       :T    DW  77
0037       :A    DB 160     -DB 160
0038       :L    DW  78                          PRESET TEMP. BOTTOM EXTR. SCREW
0039       :A    DB 180     -DB 180
003A       :T    DW  78
003B       :A    DB 160     -DB 160
003C       :L    DW  79                          MIN TEMP. BOTTOM EXTRUDER SCREW
003D       :A    DB 180     -DB 180
003E       :T    DW  79
003F       :A    DB 160     -DB 160
0040       :L    DW  80                          PRESET TEMP. BOTTOM EXTR. BARREL
0041       :A    DB 180     -DB 180
0042       :T    DW  80
0043       :A    DB 160     -DB 160
0044       :L    DW  81                          MIN TEMP. BOTTOM EXTRUDER BARREL
0045       :A    DB 180     -DB 180
0046       :T    DW  81
0047       :A    DB 160     -DB 160
0048       :L    DW  88                          PRESET TEMP. HEAD UPPER PART
0049       :A    DB 180     -DB 180
004A       :T    DW  88
```

```
004B      :A   DB 160    -DB 160
004C      :L   DW  89                MIN TEMP. HEAD UPPER PART
004D      :A   DB 180    -DB 180
004E      :T   DW  89
004F      :A   DB 160    -DB 160
0050      :L   DW  90                PRESET TEMP. HEAD MIDDLE PART
0051      :A   DB 180    -DB 180
0052      :T   DW  90
0053      :A   DB 160    -DB 160
0054      :L   DW  91                MIN. TEMP. HEAD MIDDLE PART
0055      :A   DB 180    -DB 180
0056      :T   DW  91
0057      :A   DB 160    -DB 160
0058      :L   DW  92                PRESET TEMP. CASSETTE LEFT
0059      :A   DB 180    -DB 180
005A      :T   DW  92
005B      :A   DB 160    -DB 160
005C      :L   DW  93                MIN TEMP. CASSETTE LEFT
005D      :A   DB 180    -DB 180
005E      :T   DW  93
005F      :A   DB 160    -DB 160
0060      :L   DW  94                PRESET TEMP. CASSETTE RIGHT
0061      :A   DB 180    -DB 180
0062      :T   DW  94
0063      :A   DB 160    -DB 160
0064      :L   DW  95                MIN TEMP. CASSETTE RIGHT
0065      :A   DB 180    -DB 180
0066      :T   DW  95
0067      :A   DB 160    -DB 160
0068      :L   DW 101                MIN TEMP. PREHEATING TABLE
0069      :A   DB 180    -DB 180
006A      :T   DW 101
006B      :A   DB 160    -DB 160
006C      :L   DW 104                PRESET TEMP. PREHEATING TABLE
006D      :A   DB 180    -DB 180
006E      :T   DW 104
006F      :BE
```

```
DB 160   = DB 160          PROFILE CP
DB 180   = DB 180          PROFILE AG

FB 185   = FB 185          COPY DATA BLOCK
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                          COPY PROFILE PART B TO DB180                     *
*                                                                           *
*****************************************************************************
NAME :COPY-B

0005      :A   DB 180     -DB 180              PROFILE ON AG
0006      :L   DL   1                          PROFILE No. ACTUAL PROFILE
0007      :L   KF +100
0009      :+F
000A      :T   MW 200
000B      :B   MW 200
000C      :A   DB   0                          *** PROFILE from DB101-121
000D      :L   DD  26                          EXTRUDER CALANDER SPEED
000E      :T   MD 206
000F      :L   DD  28                          EXTRUDER CALANDER CURRENT
0010      :T   MD 210
0011      :L   DW  30                          PROFILE-No. PART B
0012      :T   MW 214
0013      :L   DD  62                          LINE SPEED
0014      :T   MD 216
0015      :L   DD  64                          LINEAR WEIGHT
0016      :T   MD 220
0017      :L   DD  66                          LINEAR WEIGHT (TOLERANCE)
0018      :T   MD 224
0019      :L   DW  82                          PRESET TEMP. EXTR. CALANDER HEAD
001A      :T   MW 228
001B      :L   DW  83                          MIN TEMP. EXTR. CALANDER HEAD
001C      :T   MW 230
001D      :L   DW  84                          PRESET TEMP. EXTR. CAL. SCREW
001E      :T   MW 232
001F      :L   DW  85                          MIN TEMP. EXTR. CALANDER SCREW
0020      :T   MW 234
0021      :L   DW  86                          PRESET TEMP. EXTR. CAL. PIN/BAR.
0022      :T   MW 236
0023      :L   DW  87                          MIN TEMP. EXTR. CAL. PIN/BARREL
0024      :T   MW 238
0025      :L   DW  96                          PRESET TEMP. CALANDER ROLL TOP
0026      :T   MW 240
0027      :L   DW  97                          MIN TEMP. CALANDER ROLL TOP
0028      :T   MW 242
0029      :L   DW  98                          PRESET TEMP. CALANDER ROLL BOTT.
002A      :T   MW 244
002B      :L   DW  99                          MIN. TEMP. CALANDER ROLL BOTTOM
002C      :T   MW 246
002D      :L   DD 102                          TREAD WIDTH
002E      :T   MD 248
002F      :A   DB 180     -DB 180              DB ON AG
0030      :L   MD 206                          EXTRUDER CALANDER SPEED
0031      :
0032      :L   MD 210                          EXTRUDER CALANDER CURRENT
0033      :T   DD  28
0034      :L   MW 214                          PROFILE-No. PART B
0035      :T   DW  30
0036      :L   MD 216                          LINE SPEED
0037      :
0038      :L   MD 220                          LINEAR WEIGHT
0039      :T   DD  64
003A      :L   MD 224                          LINEAR WEIGHT (TOLERANCE)
003B      :T   DD  66
003C      :L   MW 228                          PRESET TEMP. EXTR. CALANDER HEAD
003D      :T   DW  82
003E      :L   MW 230                          MIN TEMP. EXTR. CALANDER HEAD
003F      :T   DW  83
0040      :L   MW 232                          PRESET TEMP. EXTR. CAL. SCREW
0041      :T   DW  84
0042      :L   MW 234                          MIN TEMP. EXTR. CALANDER SCREW
0043      :T   DW  85
0044      :L   MW 236                          PRESET TEMP. EXTR. CAL. PIN/BAR.
0045      :T   DW  86
0046      :L   MW 238                          MIN TEMP. EXTR. CAL. PIN/BARREL
+-------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                 !
+-------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                  !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:            PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :              1!
+-------------------------------------------------------------------------+
```

```
0047      :T   DW  87
0048      :L   MW 240
0049      :T   DW  96
004A      :L   MW 242
004B      :T   DW  97
004C      :L   MW 244
004D      :T   DW  98
004E      :L   MW 246
004F      :T   DW  99
0050      :L   MD 248
0051      :T   DD 102
0052      :BE
```

PRESET TEMP. CALANDER ROLL TOP

MIN TEMP. CALANDER ROLL TOP

PRESET TEMP. CALANDER ROLL BOTT.

MIN TEMP. CALANDER ROLL BOTTOM

TREAD WIDTH

DB 180 = DB 180 PROFILE AG

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                          CHECK ACTUAL PROFILE PARTS                       *
*                                                                           *
*****************************************************************************
NAME :CHECK-P.

0005       :A   DB 180     -DB 180                PROFILE AG
0006       :L   DL   1                            PROFILE No. PART A
0007       :L   DL  30                            PROFILE No. PART B
0008       :><F
0009       :=   M    3.2   -M   3.2               DIFFERENT PROFILES A/B
000A       :O(
000B       :O   E   87.6   -E 87.6     01        TAKE OVER PROFILE PART B
000C       :O   M    3.4   -M   3.4    01        V(new)   <=   1,1 * V(old)
000D       :O   M    4.0   -M   4.0    01        END OF MATERIAL AT SKIVER
000E       :U   M    3.2   -M   3.2    01        DIFFERENT PROFILES A/B
000F       :)                           01
0010       :O(
0011       :U   M    3.6   -M   3.6    01        NO MATERIAL IN LINE
0012       :U   M    4.6   -M   4.6    01        LOAD PROFILE
0013       :)                           01
0014       :O(
0015       :U   M    3.5   -M   3.5    01        LOAD ORIGINAL PROFILE
0016       :UN  M    3.2   -M   3.2    01        EQUAL PROFILES A/B
0017       :)                           01
0018       :SPB FB 193     -FB 193                COPY PROFILE PART B
0019 NAME  :COPY-B
001A       :U   E   87.6   -E 87.6                TAKE OVER PROFILE PART
001B       :L   KT 300.0                          3 SECONDS
001D       :SE  T  115     -T 115                 TAKE OVER PROFILE PART C
001E       :A   DB 180     -DB 180                PROFILE AG
001F       :L   DL   1                            PROFILE No. PART A
0020       :L   DL  31                            PROFILE No. PART C
0021       :><F
0022       :=   M    3.3   -M   3.3               DIFFERENT PROFILES A/C
0023       :O(
0024       :O   M    4.0   -M   4.0    01        END OF MATERIAL AT SKIVER
0025       :O   T  115     -T 115     01        TAKE OVER PART C (3 SEK.)
0026       :U   M    3.3   -M   3.3    01        DIFFERENT PROFILES A/C
0027       :)                           01
0028       :O(
0029       :U   M    3.6   -M   3.6    01        NO MATERIAL IN LINE
002A       :U   M    4.6   -M   4.6    01        LOAD PROFILE
002B       :)                           01
002C       :O(
002D       :U   M    3.5   -M   3.5    01        LOAD ORIGINAL PROFILE
002E       :UN  M    3.3   -M   3.3    01        EQUAL PROFILES A/C
002F       :)                           01
0030       :=   M    5.3   -M   5.3
0031       :U   M    5.3   -M   5.3
0032       :SPB FB 194     -FB 194
0033 NAME  :COPY-C
0034       :U   M    0.1   -M   0.1               RESET FLAGS FROM FB171
0035       :R   M    3.4   -M   3.4               V(new) <= 1.1 * V(old)
0036       :R   M    3.5   -M   3.5               SELECTED = ACTUAL PROFILE
0037       :R   M    4.6   -M   4.6               LOAD PROFILE
0038       :
0039       :U   M    0.4   -M   0.4               TAKT
003A       :U   M    3.3   -M   3.3               DIFFERENT PROFILES A/C
003B       :O   M    3.2   -M   3.2               DIFFERENT PROFILES A/B
003C       :O   E   83.2   -204S3                 LAMP TEST
003D       :=   A   81.6   -A 81.6                LAMP DIFFERENT PROFILES A/B
003E       :BE

M    3.2 = M   3.2                  DIFFERENT PROFILE PARTS A/B
E   87.6 = E 87.6                   ACCEPT PROFILE PART B OR/AND C
M    3.4 = M   3.4                  COPY PART B  V(new) <= 1.1 V(old)
M    4.0 = M   4.0                  MATERIAL AT PART C
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                          COPY PROFILE PART C TO DB180                       *
*                                                                             *
*******************************************************************************
NAME :COPY-C

0005      :A   DB 180     -DB 180              PROFILE ON AG
0006      :L   DL   1                          PROFILE No. ACTUAL PROFILE
0007      :L   KF +100
0009      :+F
000A      :T   MW 200
000B      :B   MW 200
000C      :A   DB   0                          *** PROFILE from DB101-121
000D      :L   DW  31                          PROFILE-No. PART C
000E      :T   MW 204
000F      :L   DW  68                          BOOKING (Y:BOOKING N:WIND UP)
0010      :T   MW 206
0011      :L   DD  70                          TREAD WEIGHT
0012      :T   MD 208
0013      :L   DD  72                          TREAD WEIGHT (TOLERANCE)
0014      :T   MD 212
0015      :L   DW 100                          TREAD LENGTH
0016      :T   MW 216
0017      :A   DB 180     -DB 180              DB ON AG
0018      :L   MW 204                          PROFILE-No. PART C
0019      :T   DW  31
001A      :L   MW 206                          BOOKING (Y:BOOKING N:WIND UP)
001B      :T   DW  68
001C      :L   MD 208                          TREAD WEIGHT
001D      :T   DD  70
001E      :L   MD 212                          TREAD WEIGHT (TOLERANCE)
001F      :T   DD  72
0020      :L   MW 216                          TREAD LENGTH
0021      :T   DW 100
0022      :A   DB 170     -DB 170
0023      :L   DD 240                          ACTUAL PROFILE NAME
0024      :T   DD 210                          PRODUCTION REPORT PROFILE NAME
0025      :L   DD 242
0026      :T   DD 212
0027      :L   DD 244
0028      :T   DD 214
0029      :L   DD 246
002A      :T   DD 216
002B      :L   DW 248                          START-TIME HOURS
002C      :T   DW 218
002D      :L   DW 249                          START-TIME MINUTES
002E      :T   DW 219
002F      :BE                                  LINEAR WEIGHT

DB 180    = DB 180                  PROFILE AG
DB 170    = DB 170                  ACTUAL DATAS
```

FB 195 -FB 195 C:KERM06ST.S5D BIB=3033 LAE=68

M 3.6	= M 3.6	NO MATERIAL IN LINE
M 4.6	= M 4.6	LOAD PROFILE
M 3.5	= M 3.5	LOAD AND SELECTED PROF. = ACTUAL PROF.
T 115	= T 115	TAKE OVER PROFILE PART C
M 3.3	= M 3.3	DIFFERENT PROFILE PARTS A/C
M 5.3	= M 5.3	COPY PROFILE PART C
M 0.1	= M 0.1	"1"-SIGNAL
M 0.4	= M 0.4	TACT 1 HZ
E 83.2	= 204S3	LAMP TEST (MAIN CONTR.PAN.)
A 81.6	= A 81.6	LAMP DIFFERENT PROFILE PART A/B
DB 180	= DB 180	PROFILE AG
FB 193	= FB 193	COPY PROFILE PART B
FB 194	= FB 194	COPY PROFILE PART C

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                          ACTUAL TIME FROM DB6 (COM PMC)                     *
*                                                                             *
*******************************************************************************
NAME :UHRZEIT

0005      :A   DB   6     -DB   6              ##################################
0006      :L   DR  53                          #   HOUR
0007      :SRW      4                          #
0008      :SLW      8                          #
0009      :T   MW 200                          #
000A      :L   DR  53                          #
000B      :SLW     12                          #
000C      :SRW     12                          #
000D      :L   MW 200                          #
000E      :OW                                  #
000F      :L   KH 3030                         #
0011      :OW                                  #
0012      :A   DB 199     -DB 199              #
0013      :T   DW   1                          ##################################
0014      :T   MW 210
0015      :
0016      :A   DB   6     -DB   6              ////////////////////////////////
0017      :L   DL  53                          /   MINUTE
0018      :SRW      4                          /
0019      :SLW      8                          /
001A      :T   MW 200                          /
001B      :L   DL  53                          /
001C      :SLW     12                          /
001D      :SRW     12                          /
001E      :L   MW 200                          /
001F      :OW                                  /
0020      :L   KH 3030                         /
0022      :OW                                  /
0023      :A   DB 199     -DB 199              /
0024      :T   DW   2                          ////////////////////////////////
0025      :T   MW 212
0026      :
0027      :A   DB   6     -DB   6              ##################################
0028      :L   DR  52                          #   SECOND
0029      :SRW      4                          #
002A      :SLW      8                          #
002B      :T   MW 200                          #
002C      :L   DR  52                          #
002D      :SLW     12                          #
002E      :SRW     12                          #
002F      :L   MW 200                          #
0030      :OW                                  #
0031      :L   KH 3030                         #
0033      :OW                                  #
0034      :A   DB 199     -DB 199              #
0035      :T   DW   3                          ##################################
0036      :T   MW 214
0037      :
0038      :A   DB   6     -DB   6              ////////////////////////////////
0039      :L   DL  54                          /   DAY
003A      :SRW      4                          /
003B      :SLW      8                          /
003C      :T   MW 200                          /
003D      :L   DL  54                          /
003E      :SLW     12                          /
003F      :SRW     12                          /
0040      :L   MW 200                          /
0041      :OW                                  /
0042      :L   KH 3030                         /
0044      :OW                                  /
0045      :A   DB 199     -DB 199              /
0046      :T   DW   4                          ////////////////////////////////
0047      :T   MW 216
0048      :
0049      :A   DB   6     -DB   6              ##################################
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG  !  MASTERPROGRAMM                      !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE         !  DATE         :                      !
! INSTALLATION     : TREAD-LINE          !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804            !  PROGRAMMER   :                    1!
+-------------------------------------------------------------------------------+
```

```
NETZWERK 1          0000

**************************************************************************
*                                                                        *
*                              POSITIVE FLANK                            *
*                                                                        *
**************************************************************************
NAME :P.FLANKE
BEZ  :SIGN       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :MFL        E/A/D/B/T/Z: A  BI/BY/W/D: BI
BEZ  :MIM        E/A/D/B/T/Z: A  BI/BY/W/D: BI

000E       :U    =SIGN
000F       :UN   =MFL
0010       :=    =MIM
0011       :U    =MIM
0012       :S    =MFL
0013       :UN   =SIGN
0014       :RB   =MFL
0015       :BE
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                                NEGATIVE FLANK                             *
*                                                                           *
*****************************************************************************
NAME :N.FLANKE
BEZ  :SIGN      E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :M FL      E/A/D/B/T/Z: A  BI/BY/W/D: BI
BEZ  :M IM      E/A/D/B/T/Z: A  BI/BY/W/D: BI

000E      :UN  =SIGN
000F      :U   =M FL
0010      :=   =M IM
0011      :RB  =M FL
0012      :U   =SIGN
0013      :S   =M FL
0014      :BE
```

```
NETZWERK 1          0000

**************************************************************************
*                                                                        *
*                          RESET FLAGS BEFORE START                      *
*                                                                        *
**************************************************************************
NAME :STARTRES

0005      :AWL
0006      :***

NETZWERK 2          0007
0007      :AWL
0008      :UN  M    3.7  -M   3.7
0009      :S   M    3.7  -M   3.7            FLAG FOR FIRST SCAN
000A      :
000B      :U   M    2.6  -M   2.6            FOR SET TIME CP525
000C      :S   M    2.6  -M   2.6
000D      :U   M    5.4  -M   5.4
000E      :R   M    5.4  -M   5.4
000F      :
0010      :L   KH 0000
0012      :T   MW   0
0013      :T   MW   9
0014      :
0015      :T   MW  30
0016      :T   MW  32
0017      :T   MW  34
0018      :T   MW  36
0019      :T   MW  38
001A      :
001B      :T   MW  40
001C      :T   MW  42
001D      :T   MW  44
001E      :T   MW  46
001F      :T   MW  48
0020      :
0021      :T   MW  50
0022      :T   MW  52
0023      :T   MW  54
0024      :T   MW  56
0025      :T   MW  58
0026      :
0027      :T   MW  60
0028      :T   MW  62
0029      :T   MW  64
002A      :T   MW  66
002B      :T   MW  68
002C      :
002D      :T   MW  70
002E      :T   MW  72
002F      :T   MW  74
0030      :T   MW  76
0031      :T   MW  78
0032      :
0033      :T   MW  80
0034      :T   MW  82
0035      :T   MW  84
0036      :T   MW  86
0037      :T   MW  88
0038      :
0039      :T   MW  90
003A      :T   MW  92
003B      :T   MW  94
003C      :T   MW  96
003D      :T   MW  98
003E      :***

M    3.7 = M   3.7                  FLAG FOR FIRST SCAN
M    2.6 = M   2.6                  HF SET CP525-TIME
```

M 5.4 = M 5.4 IMPULSE SET CP525-TIME

```
NETZWERK 3          003F
003F       :AWL
0040       :BE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                  RESET FLAGS PROGRAMPART EXTRUSION HEAD                   *
*                          (HEAD COMPLETE OPEN)                             *
*                                                                           *
*****************************************************************************
NAME :RES-HEAD

0005       :AWL
0006       :U   M    3.7  -M   3.7
0007       :R   M    3.7  -M   3.7
0008       :
0009       :U   E   30.4  -244S5              ! CLAMP OPEN
000A       :U   E   30.5  -244S6              !
000B       :U   E   30.6  -244S7              !
000C       :U   E   30.7  -244S8              !
000D       :U   E   32.6  -246S23             # EJECTING DEVICE OPEN
000E       :U   E   32.7  -246S24             #
000F       :U   E   32.2  -246S19             ! LOCKING CYLINDER HOME POSITION
0010       :U   E   32.3  -246S20             !
0011       :U   E   31.2  -245S11             # MIDDLE PART OPEN
0012       :U   E   31.5  -245S14             ! UPPER PART OPEN
0013       :SPB =M001
0014       :BEA
0015 M001  :
0016       :L   KF +0
0018       :T   MB  10
0019       :T   MB  11
001A       :T   MB  12
001B       :T   MB  13
001C       :T   MB  14
001D       :T   MB  15
001E       :T   MB  16
001F       :T   MB  17
0020       :T   MB  18
0021       :T   MB  19
0022       :T   MB  20
0023       :T   MB  21
0024       :T   MB  22
0025       :T   MB  23
0026       :T   MB  24
0027       :T   MB  25
0028       :T   MB  26
0029       :T   MB  27
002A       :T   MB  28
002B       :T   MB  29
002C       :***

M    3.7 = M   3.7                 FLAG FOR FIRST SCAN
E   30.4 = 244S5                   CLAMPING RIGHT SIDE DOWN OPEN
E   30.5 = 244S6                   CLAMPING LEFT  SIDE DOWN OPEN
E   30.6 = 244S7                   CLAMPING RIGHT SIDE UP   OPEN
E   30.7 = 244S8                   CLAMPING LEFT  SIDE UP   OPEN
E   32.6 = 246S23                  EJECTING DEVICE RIGHT SIDE OPEN
E   32.7 = 246S24                  EJECTING DEVICE LEFT  SIDE OPEN
E   32.2 = 246S19                  RIGHT LOCKING CYLINDER HOME POSITION
E   32.3 = 246S20                  LEFT  LOCKING CYLINDER HOME POSITION
E   31.2 = 245S11                  PROX.SWITCH MEDIUM PART OPEN
E   31.5 = 245S14                  PROX.SWITCH UPPER PART OPEN

NETZWERK 2          002D
002D       :
002E       :BE
```

D B

```
    0:      KH = 4D41;
    1:      KH = 534B;
    2:      KH = 3031;
    3:      KH = DE00;
    4:      KH = 0014;
    5:      KH = 0019;
    6:      KH = 001E;
    7:      KH = 001F;
    8:      KH = 0020;
    9:      KH = 0021;
   10:      KH = 0022;
   11:      KH = 0023;
   12:      KH = 0024;
   13:      KH = 0025;
   14:      KH = 0028;
   15:      KH = 0029;
   16:      KH = 002A;
   17:      KH = 002B;
   18:      KH = 002C;
   19:      KH = 002D;
   20:      KH = 002E;
   21:      KH = 002F;
   22:      KH = 0032;
   23:      KH = 0033;
   24:      KH = 0034;
   25:      KH = 0035;
   26:      KH = 0036;
   27:      KH = 0037;
   28:      KH = 003C;
   29:      KH = 003D;
   30:      KH = 003E;
   31:      KH = 003F;
   32:      KH = 0040;
   33:      KH = 0046;
   34:      KH = 0047;
   35:      KH = 0048;
   36:      KH = 0049;
   37:      KH = 004A;
   38:      KH = 004B;
   39:      KH = 0000;
   40:      KH = 0001;
   41:      KH = 0002;
   42:      KH = 0003;
   43:      KH = 0004;
   44:      KH = 0005;
   45:      KH = 0006;
   46:      KH = 0007;
   47:      KH = 0008;
   48:      KH = 0009;
   49:      KH = 000A;
   50:      KH = 000B;
   51:      KH = 0050;
   52:      KH = 0051;
   53:      KH = 0052;
   54:      KH = 0053;
   55:      KH = 0054;
   56:      KH = 0055;
   57:      KH = 0056;
   58:      KH = 0057;
   59:      KH = 005C;
   60:      KH = 005D;
   61:      KH = 005E;
   62:      KH = 005F;
   63:      KH = 0060;
   64:      KH = 0061;
   65:      KH = 0062;
   66:      KH = 0063;
   67:      KH = 0064;
   68:      KH = DA00;
   69:      KH = 0014;
   70:      KH = 0019;
   71:      KH = 001E;
   72:      KH = 001F;
   73:      KH = 0020;
```

ANFANGSKENNUNG
FUER DB1

INDEX KOPPELMERKEREINGAENGE
KOPPELMERKERBYTE 166
" 167
" 168
" 169
INDEX KOPPELMERKERAUSGAENGE
KOPPELMERKERBYTE 140
" 141
" 142
" 143

" 144
" 145
" 146
" 147
" 148
" 149
" 150
" 151
" 152
" 153
" 154
" 155
" 156
" 157
" 158
" 159
" 160
" 161
" 162
" 163
" 164
" 165
INDEX ENDKENNUNG

```
 74:      KH = 005E;
 75:      KH = 0028;
 76:      KH = 0029;
 77:      KH = 005C;
 78:      KH = 0032;
 79:      KH = 0033;
 80:      KH = 003C;
 81:      KH = 003D;
 82:      KH = 005D;
 83:      KH = 0046;
 84:      KH = 0047;
 85:      KH = 0048;
 86:      KH = 0001;
 87:      KH = 0002;
 88:      KH = 0003;
 89:      KH = 0004;
 90:      KH = 0005;
 91:      KH = 0006;
 92:      KH = 0007;
 93:      KH = 0008;
 94:      KH = 0009;
 95:      KH = 000A;
 96:      KH = 000B;
 97:      KH = 0000;
 98:      KH = 0050;
 99:      KH = 0051;
100:      KH = 0052;
101:      KH = 0053;
102:      KH = 002A;
103:      KH = EEEE;
104:
```

```
  0:    KH = 0004;
  1:    KH = 0005;
  2:    KH = 0101;
  3:    KH = 0000;
  4:    KH = 0002;
  5:    KH = 0101;
  6:    KH = 0101;
  7:    KH = 0000;
  8:    KH = 0000;
  9:    KH = 0000;
 10:    KH = 0000;
 11:    KH = 0000;
 12:    KH = 0000;
 13:    KH = 0000;
 14:    KH = 0000;
 15:    KH = 0000;
 16:    KH = 0000;
 17:    KH = 0100;
 18:    KH = 0007;
 19:    KH = 0000;
 20:    KH = 4442;
 21:    KH = 0673;
 22:    KH = 4442;
 23:    KH = 0006;
 24:    KH = 0033;
 25:    KH = 0005;
 26:    KH = A983;
 27:    KH = 0075;
 28:    KH = 0006;
 29:    KH = 0000;
 30:    KH = 0002;
 31:    KH = 0001;
 32:    KH = 0000;
 33:    KH = 00D0;
 34:    KH = 0001;
 35:    KH = 00B4;
 36:    KH = 0000;
 37:    KH = 0000;
 38:    KH = 00C9;
 39:    KH = 00CA;
 40:    KH = 00CB;
 41:    KH = 00CC;
 42:    KH = 00CD;
 43:    KH = 00CE;
 44:    KH = 0000;
 45:    KH = 000E;
 46:    KH = 000F;
 47:    KH = 00B5;
 48:    KH = 0195;
 49:    KH = 0000;
 50:    KH = 0000;
 51:    KH = 0100;
 52:    KH = 4004;
 53:    KH = 0515;
 54:    KH = 0404;
 55:    KH = 9500;
 56:    KH = 0013;
 57:    KH = 0215;
 58:    KH = 0404;
 59:    KH = 9500;
 60:    KH = 0000;
 61:    KH = 0000;
 62:    KH = 0000;
 63:    KH = 0000;
 64:    KH = 0000;
 65:    KH = 0000;
 66:    KH = 0000;
 67:    KH = 0000;
 68:    KH = 0000;
 69:    KH = 0000;
 70:    KH = 0000;
 71:    KH = 0000;
 72:    KH = 0000;
 73:    KH = 0000;
```

```
  74:     KH = 0000;
  75:     KH = 0000;
  76:     KH = 0000;
  77:     KH = 0000;
  78:     KH = 0000;
  79:     KH = 0000;
  80:     KH = 0000;
  81:     KH = 0000;
  82:     KH = 0000;
  83:     KH = 0000;
  84:     KH = 0000;
  85:     KH = 0001;
  86:     KH = 9C5D;
  87:     KH = 0000;
  88:     KH = 0000;
  89:     KH = 0000;
  90:     KH = 0006;
  91:     KH = 0007;
  92:     KH = 0000;
  93:     KH = 0088;
  94:     KH = 0001;
  95:     KH = 0003;
  96:     KH = 0000;
  97:     KH = 000A;
  98:     KH = 0000;
  99:     KH = 0000;
 100:     KH = 0000;
 101:     KH = 0000;
 102:     KH = 0000;
 103:     KH = 0000;
 104:     KH = 0000;
 105:     KH = 0000;
 106:     KH = 0000;
 107:     KH = 0000;
 108:     KH = 0000;
 109:     KH = 0000;
 110:     KH = 0000;
 111:     KH = 0000;
 112:     KH = 0007;
 113:     KH = 00FF;
 114:     KH = 0000;
 115:     KH = 0000;
 116:     KH = 0000;
 117:     KH = 0000;
 118:     KH = 00FF;
 119:     KH = 0000;
 120:     KH = 0000;
 121:     KH = 00CA;
 122:     KH = 0000;
 123:     KH = 0002;
 124:     KH = 0005;
 125:     KH = 00FF;
 126:     KH = 0000;
 127:     KH = 0000;
 128:     KH = 0000;
 129:     KH = 0000;
 130:     KH = 0000;
 131:     KH = 0000;
 132:     KH = 0000;
 133:     KH = 0000;
 134:     KH = 0000;
 135:     KH = 0000;
 136:     KH = 000A;
 137:     KH = 00FF;
 138:     KH = 0000;
 139:     KH = 0000;
 140:     KH = 0000;
 141:     KH = 0000;
 142:     KH = 0000;
 143:     KH = 0000;
 144:     KH = 0000;
 145:     KH = 0000;
 146:     KH = 0000;
 147:     KH = 0000;
```

```
148:      KH = 0000;
149:      KH = 00FF;
150:      KH = 0000;
151:      KH = 0000;
152:      KH = 0000;
153:      KH = 0000;
154:      KH = 0000;
155:      KH = 0000;
156:      KH = 0000;
157:      KH = 0000;
158:      KH = 0000;
159:      KH = 0000;
160:      KH = 0008;
161:      KH = 00FF;
162:      KH = 0000;
163:      KH = 0000;
164:      KH = 0000;
165:      KH = 0000;
166:      KH = 0000;
167:      KH = 0000;
168:      KH = 0000;
169:      KH = 0000;
170:      KH = 0000;
171:      KH = 0000;
172:      KH = 0009;
173:      KH = 00FF;
174:      KH = 0000;
175:      KH = 0000;
176:      KH = 0000;
177:      KH = 0000;
178:      KH = 0000;
179:      KH = 0000;
180:      KH = 0000;
181:      KH = 0000;
182:      KH = 0000;
183:      KH = 0000;
184:      KH = 000A;
185:      KH = 00FF;
186:      KH = 0000;
187:      KH = 0000;
188:      KH = 0000;
189:      KH = 0000;
190:      KH = 0000;
191:      KH = 0000;
192:      KH = 0000;
193:      KH = 0000;
194:      KH = 0000;
195:      KH = 0000;
196:      KH = 000B;
197:      KH = 00FF;
198:      KH = 0000;
199:      KH = 0000;
200:      KH = 0000;
201:      KH = 0000;
202:      KH = 0000;
203:      KH = 0000;
204:      KH = 0000;
205:      KH = 0000;
206:      KH = 0000;
207:      KH = 0000;
208:      KH = 000C;
209:      KH = 00FF;
210:      KH = 0000;
211:      KH = 0000;
212:      KH = 0000;
213:      KH = 0000;
214:      KH = 0000;
215:      KH = 0000;
216:      KH = 0000;
217:      KH = 0000;
218:      KH = 0000;
219:      KH = 0000;
220:      KH = 000D;
221:      KH = 00FF;
```

```
222:      KH = 0000;
223:      KH = 0000;
224:      KH = 0000;
225:      KH = 0000;
226:      KH = 0000;
227:      KH = 0000;
228:      KH = 0000;
229:      KH = 0000;
230:      KH = 0000;
231:      KH = 0000;
232:      KH = 000E;
233:      KH = 00FF;
234:      KH = 0000;
235:      KH = 0000;
236:      KH = 0000;
237:      KH = 0000;
238:      KH = 0000;
239:      KH = 0000;
240:      KH = 0000;
241:      KH = 0000;
242:      KH = 0000;
243:      KH = 0000;
244:      KH = 000F;
245:      KH = 00FF;
246:      KH = 0000;
247:      KH = 0000;
248:      KH = 0000;
249:      KH = 0000;
250:      KH = 0000;
251:      KH = 0000;
252:      KH = 0000;
253:      KH = 0000;
254:      KH = 0000;
255:      KH = 0000;
256:
```

```
  0:      KH = 0000;
  1:      KH = 0007;
  2:      KH = 00DA;
  3:      KH = 4442;
  4:      KH = 0006;
  5:      KH = 0033;
  6:      KH = 0005;
  7:      KH = 0043;
  8:      KH = 000A;
  9:      KH = 0000;
 10:      KH = 0000;
 11:      KH = 0000;
 12:      KH = 0000;
 13:      KH = 0000;
 14:      KH = 0000;
 15:      KH = 0000;
 16:      KH = 0000;
 17:      KH = 0000;
 18:      KH = 0000;
 19:      KH = 0000;
 20:      KH = 0000;
 21:      KH = 0000;
 22:      KH = 0000;
 23:      KH = 0000;
 24:      KH = 0000;
 25:      KH = 0000;
 26:      KH = 0000;
 27:      KH = 0000;
 28:      KH = 0000;
 29:      KH = 0000;
 30:      KH = 0000;
 31:      KH = 0000;
 32:      KH = 0000;
 33:      KH = 0000;
 34:      KH = 0000;
 35:      KH = 0000;
 36:      KH = 0000;
 37:      KH = 0000;
 38:      KH = 0000;
 39:      KH = 0000;
 40:      KH = 0000;
 41:      KH = 0000;
 42:      KH = 0000;
 43:      KH = 0000;
 44:      KH = 0000;
 45:      KH = 0000;
 46:      KH = 0000;
 47:      KH = 0000;
 48:      KH = 0000;
 49:      KH = 0000;
 50:
```

```
  0:    KH = 0010;
  1:    KH = 0000;
  2:    KH = 0000;
  3:    KH = 2020;
  4:    KH = 0000;
  5:    KH = 0000;
  6:    KH = 0000;
  7:    KH = 0000;
  8:    KH = 0000;
  9:    KH = 0000;
 10:    KH = 0010;
 11:    KH = 0007;
 12:    KH = 00DA;
 13:    KH = 4442;
 14:    KH = 0006;
 15:    KH = 0033;
 16:    KH = 0001;
 17:    KH = 0025;
 18:    KH = 0002;
 19:    KH = 0000;
 20:    KH = 0000;
 21:    KH = 0007;
 22:    KH = 00DA;
 23:    KH = 4442;
 24:    KH = 0006;
 25:    KH = 0033;
 26:    KH = 0005;
 27:    KH = 0000;
 28:    KH = 000A;
 29:    KH = 0000;
 30:    KH = 0000;
 31:    KH = 0004;
 32:    KH = 00DA;
 33:    KH = 4442;
 34:    KH = 0006;
 35:    KH = 0033;
 36:    KH = 0005;
 37:    KH = 0000;
 38:    KH = 0000;
 39:    KH = 0000;
 40:    KH = 0010;
 41:    KH = 0007;
 42:    KH = 00C7;
 43:    KH = 4442;
 44:    KH = 00CE;
 45:    KH = 0000;
 46:    KH = 0007;
 47:    KH = 0024;
 48:    KH = 000E;
 49:    KH = 0000;
 50:    KH = 0000;
 51:    KH = 0007;
 52:    KH = 00C7;
 53:    KH = 4442;
 54:    KH = 00CE;
 55:    KH = 0000;
 56:    KH = 0007;
 57:    KH = 0000;
 58:    KH = 0000;
 59:    KH = 0000;
 60:    KH = 0000;
 61:    KH = 0004;
 62:    KH = 00C7;
 63:    KH = 4442;
 64:    KH = 00CE;
 65:    KH = 0000;
 66:    KH = 0007;
 67:    KH = 0000;
 68:    KH = 0000;
 69:    KH = 0000;
 70:    KH = 0000;
 71:    KH = 0004;
 72:    KH = 00C7;
 73:    KH = 4442;
```

KRUPP KUNSTOFFTECHNIK		
ELASTOMERTECHNIK WERK HARBURG	MASTERPROGRAMM	
PROJECT : KERMAN TIRE	DATE :	
INSTALLATION : TREAD-LINE	MODIFICATION:	PGNO
PROJECT POS. NO.: 84/823804	PROGRAMMER :	1

```
   74:      KH = 00CE;
   75:      KH = 0000;
   76:      KH = 0007;
   77:      KH = 0000;
   78:      KH = 0000;
   79:      KH = 0000;
   80:      KH = 0000;
   81:      KH = 0000;
   82:      KH = 0000;
   83:      KH = 4442;
   84:      KH = 0000;
   85:      KH = 0000;
   86:      KH = 0000;
   87:      KH = 0000;
   88:      KH = 0000;
   89:      KH = 0000;
   90:      KH = 0000;
   91:      KH = 0000;
   92:      KH = 0000;
   93:      KH = 0000;
   94:      KH = 0000;
   95:      KH = 0000;
   96:      KH = 0000;
   97:      KH = 0000;
   98:      KH = 0000;
   99:      KH = 0000;
  100:      KH = 0000;
  101:      KH = 0000;
  102:      KH = 0000;
  103:      KH = 0000;
  104:      KH = 0000;
  105:      KH = 0000;
  106:      KH = 0000;
  107:      KH = 0000;
  108:      KH = 0000;
  109:      KH = 0000;
  110:      KH = 0000;
  111:      KH = 0000;
  112:      KH = 0000;
  113:      KH = 0000;
  114:      KH = 0000;
  115:      KH = 0000;
  116:      KH = 0000;
  117:      KH = 0000;
  118:      KH = 0000;
  119:      KH = 0000;
  120:      KH = 0000;
  121:      KH = 0000;
  122:      KH = 0000;
  123:      KH = 0000;
  124:      KH = 0000;
  125:      KH = 0000;
  126:      KH = 0000;
  127:      KH = 0000;
  128:      KH = 0000;
  129:      KH = 0000;
  130:
```

DATAS SEND TO 115U

```
 0:    KH = 0000;
 1:    KH = 0000;
 2:    KH = 0000;
 3:    KH = 20C8;
 4:    KH = 0834;
 5:    KH = 005F;
 6:    KH = 0000;
 7:    KH = 0027;
 8:    KH = 1F38;
 9:    KH = 0000;
10:    KH = 0000;
11:    KH = 0000;
12:    KH = 0000;
13:    KH = 0000;
14:    KH = 0000;
15:    KH = 0000;
16:    KH = 0000;
17:    KH = 0000;
18:    KH = 0000;
19:    KH = 0000;
20:    KH = 0000;
21:    KH = 0000;
22:    KH = 0000;
23:    KH = 0000;
24:    KH = 0000;
25:    KH = 0000;
26:    KH = 0000;
27:    KH = 0000;
28:    KH = 0000;
29:    KH = 0000;
30:    KH = 0000;
31:    KH = 0000;
32:    KH = 0000;
33:    KH = 0000;
34:    KH = 0000;
35:    KH = 0000;
36:    KH = 0000;
37:    KH = 0000;
38:    KH = 0000;
39:    KH = 0000;
40:
```

So IN IMPULSES... ---> DB30/DW42
So IN mm ..... ---> DB30/DW43
Vline..... ---> DB30/DW44
Vline..... ---> DB30/DW45
FLAG-BITS..... ---> DB30/DW46
Smax IN IMPULSEN. ---> DB30/DW47

RECEIVED DATAS FROM 115U

```
 0:    KH = 0000;
 1:    KH = 4026;
 2:    KH = 0100;
 3:    KH = 0000;
 4:    KH = 400A;
 5:    KH = 0431;
 6:    KH = 0000;
 7:    KH = 0000;
 8:    KH = 0000;
 9:    KH = 0000;
10:    KH = 0000;
11:    KH = 0000;
12:    KH = FFFE;
13:    KH = 0000;
14:    KH = 0000;
15:    KH = 0000;
16:    KH = 0000;
17:    KH = 0000;
18:    KH = 0000;
19:    KH = 0000;
20:    KH = 0000;
21:    KH = 0000;
22:    KH = 0000;
23:    KH = 0000;
24:    KH = 0000;
25:    KH = 0000;
26:    KH = 0000;
27:    KH = 0000;
28:    KH = 0000;
29:    KH = 0000;
30:    KH = 0000;
31:    KH = 0000;
32:    KH = 0000;
33:    KH = 0000;
34:    KH = 0000;
35:    KH = 0000;
36:    KH = 0000;
37:    KH = 0000;
38:    KH = 0000;
39:    KH = 0000;
40:    KH = 0000;
41:
```

```
FLAG-BITS..... <--- DB30/DW82
FLAG-BITS..... <--- DB30/DW83
FLAG-BITS..... <--- DB30/DW84
COUNTER WIND-UP <--- DB30/DW85
IMPULSE WIND-UP <--- DB30/DW86
TREAD LENGTH... <--- DB30/DW87
SCRAP 0-899.LMD <--- DB30/DW88
SCRAP 900...LMD <--- DB30/DW89
CORRECT. LENGTH <--- DB30/DW90
Vskiver........ <--- DB30/DW91
```

```
RECEIVE BLOCK FROM GTR-9000
DW  6    : CICLE No.
DW  7-16 : PARAMETER K0-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G9
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : SLIT W
DW 39    : P4
DW 40    : ACTUAL VALUE X
DW 41    : P3
DW 42    : E4
     0:     KH = 0000;                    GTR-9000
     1:     KH = 0000;                    BOTTOM EXTRUDER SCREW
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0000;                    CICLE No.
     7:     KH = 0000;                    K0
     8:     KH = 0000;                    K1
     9:     KH = 0000;                    K2
    10:     KH = 0000;                    K3
    11:     KH = 0000;                    K4
    12:     KH = 0000;                    K5
    13:     KH = 0000;                    K6
    14:     KH = 0000;                    K7
    15:     KH = 0000;                    K8
    16:     KH = 0000;                    K9
    17:     KH = 0000;                    H0
    18:     KH = 0000;                    H1
    19:     KH = 0000;                    H2
    20:     KH = 0000;                    H3
    21:     KH = 0000;                    H4
    22:     KH = 0000;                    H5
    23:     KH = 0000;                    H6
    24:     KH = 0000;                    H7
    25:     KH = 0000;                    H8
    26:     KH = 0000;                    H9
    27:     KH = 0000;                    G0
    28:     KH = 0000;                    G1
    29:     KH = 0000;                    G2
    30:     KH = 0000;                    G3
    31:     KH = 0000;                    G4
    32:     KH = 0000;                    G5
    33:     KH = 0000;                    G6
    34:     KH = 0000;                    G7
    35:     KH = 0000;                    G8
    36:     KH = 0000;                    L- BOTTOM LIMIT
    37:     KH = 0000;                    L+ TOP LIMIT
    38:     KH = 0000;                    W  SLIT
    39:     KH = 0000;                    P4
    40:     KH = 0000;                    X  ACTUAL VALUE
    41:     KH = 0000;                    P3
    42:     KH = 0000;                    E4 SWITCH STAND
    43:     KH = 0000;
    44:     KH = 0000;
    45:
```

```
RECEIVE BLOCK FROM GTR-9000
DW  6    : CICLE No.
DW  7-16 : PARAMETER K0-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G9
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : SLIT W
DW 39    : P4
DW 40    : ACTUAL VALUE X
DW 41    : P3
DW 42    : E4
     0:     KH = 0000;
     1:     KH = 0000;
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0000;
     7:     KH = 0000;
     8:     KH = 0000;
     9:     KH = 0000;
    10:     KH = 0000;
    11:     KH = 0000;
    12:     KH = 0000;
    13:     KH = 0000;
    14:     KH = 0000;
    15:     KH = 0000;
    16:     KH = 0000;
    17:     KH = 0000;
    18:     KH = 0000;
    19:     KH = 0000;
    20:     KH = 0000;
    21:     KH = 0000;
    22:     KH = 0000;
    23:     KH = 0000;
    24:     KH = 0000;
    25:     KH = 0000;
    26:     KH = 0000;
    27:     KH = 0000;
    28:     KH = 0000;
    29:     KH = 0000;
    30:     KH = 0000;
    31:     KH = 0000;
    32:     KH = 0000;
    33:     KH = 0000;
    34:     KH = 0000;
    35:     KH = 0000;
    36:     KH = 0000;
    37:     KH = 0000;
    38:     KH = 0000;
    39:     KH = 0000;
    40:     KH = 0000;
    41:     KH = 0000;
    42:     KH = 0000;
    43:     KH = 0000;
    44:     KH = 0000;
    45:
```

GTR-9000
BOTTOM EXTRUDER BARREL

CICLE No.
K0
K1
K2
K3
K4
K5
K6
K7
K8
K9
H0
H1
H2
H3
H4
H5
H6
H7
H8
H9
G0
G1
G2
G3
G4
G5
G6
G7
G8
L- BOTTOM LIMIT
L+ TOP LIMIT
W SLIT
P4
X ACTUAL VALUE
P3
E4 SWITCH STAND

```
RECEIVE BLOCK FROM GTR-9000
DW  6    : CICLE No.
DW  7-16 : PARAMETER K0-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G9
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : SLIT W
DW 39    : P4
DW 40    : ACTUAL VALUE X
DW 41    : P3
DW 42    : E4
     0:     KH = 0000;                    GTR-9000
     1:     KH = 0000;                    UPPER EXTRUDER SCREW
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0000;                    CICLE No.
     7:     KH = 0000;                    K0
     8:     KH = 0000;                    K1
     9:     KH = 0000;                    K2
    10:     KH = 0000;                    K3
    11:     KH = 0000;                    K4
    12:     KH = 0000;                    K5
    13:     KH = 0000;                    K6
    14:     KH = 0000;                    K7
    15:     KH = 0000;                    K8
    16:     KH = 0000;                    K9
    17:     KH = 0000;                    H0
    18:     KH = 0000;                    H1
    19:     KH = 0000;                    H2
    20:     KH = 0000;                    H3
    21:     KH = 0000;                    H4
    22:     KH = 0000;                    H5
    23:     KH = 0000;                    H6
    24:     KH = 0000;                    H7
    25:     KH = 0000;                    H8
    26:     KH = 0000;                    H9
    27:     KH = 0000;                    G0
    28:     KH = 0000;                    G1
    29:     KH = 0000;                    G2
    30:     KH = 0000;                    G3
    31:     KH = 0000;                    G4
    32:     KH = 0000;                    G5
    33:     KH = 0000;                    G6
    34:     KH = 0000;                    G7
    35:     KH = 0000;                    G8
    36:     KH = 0000;                    L- BOTTOM LIMIT
    37:     KH = 0000;                    L+ TOP LIMIT
    38:     KH = 0000;                    W  SLIT
    39:     KH = 0000;                    P4
    40:     KH = 0000;                    X  ACTUAL VALUE
    41:     KH = 0000;                    P3
    42:     KH = 0000;                    E4 SWITCH STAND
    43:     KH = 0000;
    44:     KH = 0000;
    45:
```

```
RECEIVE BLOCK FROM GTR-9000
DW  6     : CICLE No.
DW  7-16  : PARAMETER K0-K9
DW 17-26  : PARAMETER H0-H9
DW 27-35  : PARAMETER G0-G9
DW 36     : BOTTOM LIMIT L-
DW 37     : TOP    LIMIT L+
DW 38     : SLIT W
DW 39     : P4
DW 40     : ACTUAL VALUE X
DW 41     : P3
DW 42     : E4
     0:     KH = 0000;                    GTR-9000
     1:     KH = 0000;                    UPPER EXTRUDER BARREL
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0000;                    CICLE No.
     7:     KH = 0000;                    K0
     8:     KH = 0000;                    K1
     9:     KH = 0000;                    K2
    10:     KH = 0000;                    K3
    11:     KH = 0000;                    K4
    12:     KH = 0000;                    K5
    13:     KH = 0000;                    K6
    14:     KH = 0000;                    K7
    15:     KH = 0000;                    K8
    16:     KH = 0000;                    K9
    17:     KH = 0000;                    H0
    18:     KH = 0000;                    H1
    19:     KH = 0000;                    H2
    20:     KH = 0000;                    H3
    21:     KH = 0000;                    H4
    22:     KH = 0000;                    H5
    23:     KH = 0000;                    H6
    24:     KH = 0000;                    H7
    25:     KH = 0000;                    H8
    26:     KH = 0000;                    H9
    27:     KH = 0000;                    G0
    28:     KH = 0000;                    G1
    29:     KH = 0000;                    G2
    30:     KH = 0000;                    G3
    31:     KH = 0000;                    G4
    32:     KH = 0000;                    G5
    33:     KH = 0000;                    G6
    34:     KH = 0000;                    G7
    35:     KH = 0000;                    G8
    36:     KH = 0000;                    L- BOTTOM LIMIT
    37:     KH = 0000;                    L+ TOP LIMIT
    38:     KH = 0000;                    W  SLIT
    39:     KH = 0000;                    P4
    40:     KH = 0000;                    X  ACTUAL VALUE
    41:     KH = 0000;                    P3
    42:     KH = 0000;                    E4 SWITCH STAND
    43:     KH = 0000;
    44:     KH = 0000;
    45:
```

```
RECEIVE BLOCK FROM GTR-9000
DW  6    : CICLE No.
DW  7-16 : PARAMETER K0-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G9
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : SLIT W
DW 39    : P4
DW 40    : ACTUAL VALUE X
DW 41    : P3
DW 42    : E4
     0:      KH = 0000;                    GTR-9000
     1:      KH = 0000;                    CASSETTE LEFT
     2:      KH = 0000;
     3:      KH = 0000;
     4:      KH = 0000;
     5:      KH = 0000;
     6:      KH = 0000;                    CICLE No.
     7:      KH = 0000;                    K0
     8:      KH = 0000;                    K1
     9:      KH = 0000;                    K2
    10:      KH = 0000;                    K3
    11:      KH = 0000;                    K4
    12:      KH = 0000;                    K5
    13:      KH = 0000;                    K6
    14:      KH = 0000;                    K7
    15:      KH = 0000;                    K8
    16:      KH = 0000;                    K9
    17:      KH = 0000;                    H0
    18:      KH = 0000;                    H1
    19:      KH = 0000;                    H2
    20:      KH = 0000;                    H3
    21:      KH = 0000;                    H4
    22:      KH = 0000;                    H5
    23:      KH = 0000;                    H6
    24:      KH = 0000;                    H7
    25:      KH = 0000;                    H8
    26:      KH = 0000;                    H9
    27:      KH = 0000;                    G0
    28:      KH = 0000;                    G1
    29:      KH = 0000;                    G2
    30:      KH = 0000;                    G3
    31:      KH = 0000;                    G4
    32:      KH = 0000;                    G5
    33:      KH = 0000;                    G6
    34:      KH = 0000;                    G7
    35:      KH = 0000;                    G8
    36:      KH = 0000;                    L- BOTTOM LIMIT
    37:      KH = 0000;                    L+ TOP LIMIT
    38:      KH = 0000;                    W  SLIT
    39:      KH = 0000;                    P4
    40:      KH = 0000;                    X  ACTUAL VALUE
    41:      KH = 0000;                    P3
    42:      KH = 0000;                    E4 SWITCH STAND
    43:      KH = 0000;
    44:      KH = 0000;
    45:
```

```
RECEIVE BLOCK FROM GTR-9000
DW  6    : CICLE No.
DW  7-16 : PARAMETER K0-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G9
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : SLIT W
DW 39    : P4
DW 40    : ACTUAL VALUE X
DW 41    : P3
DW 42    : E4
     0:     KH = 0000;                    GTR-9000
     1:     KH = 0000;                    CASSETTE RIGHT
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0000;                    CICLE No.
     7:     KH = 0000;                    K0
     8:     KH = 0000;                    K1
     9:     KH = 0000;                    K2
    10:     KH = 0000;                    K3
    11:     KH = 0000;                    K4
    12:     KH = 0000;                    K5
    13:     KH = 0000;                    K6
    14:     KH = 0000;                    K7
    15:     KH = 0000;                    K8
    16:     KH = 0000;                    K9
    17:     KH = 0000;                    H0
    18:     KH = 0000;                    H1
    19:     KH = 0000;                    H2
    20:     KH = 0000;                    H3
    21:     KH = 0000;                    H4
    22:     KH = 0000;                    H5
    23:     KH = 0000;                    H6
    24:     KH = 0000;                    H7
    25:     KH = 0000;                    H8
    26:     KH = 0000;                    H9
    27:     KH = 0000;                    G0
    28:     KH = 0000;                    G1
    29:     KH = 0000;                    G2
    30:     KH = 0000;                    G3
    31:     KH = 0000;                    G4
    32:     KH = 0000;                    G5
    33:     KH = 0000;                    G6
    34:     KH = 0000;                    G7
    35:     KH = 0000;                    G8
    36:     KH = 0000;                    L- BOTTOM LIMIT
    37:     KH = 0000;                    L+ TOP LIMIT
    38:     KH = 0000;                    W  SLIT
    39:     KH = 0000;                    P4
    40:     KH = 0000;                    X  ACTUAL VALUE
    41:     KH = 0000;                    P3
    42:     KH = 0000;                    E4 SWITCH STAND
    43:     KH = 0000;
    44:     KH = 0000;
    45:
```

```
RECEIVE BLOCK FROM GTR-9000
DW  6    : CICLE No.
DW  7-16 : PARAMETER K0-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G9
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : SLIT W
DW 39    : P4
DW 40    : ACTUAL VALUE X
DW 41    : P3
DW 42    : E4
     0:     KH = 0000;                    GTR-9000
     1:     KH = 0000;                    PREHEATING TABLE
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0000;                    CICLE No.
     7:     KH = 0000;                    K0
     8:     KH = 0000;                    K1
     9:     KH = 0000;                    K2
    10:     KH = 0000;                    K3
    11:     KH = 0000;                    K4
    12:     KH = 0000;                    K5
    13:     KH = 0000;                    K6
    14:     KH = 0000;                    K7
    15:     KH = 0000;                    K8
    16:     KH = 0000;                    K9
    17:     KH = 0000;                    H0
    18:     KH = 0000;                    H1
    19:     KH = 0000;                    H2
    20:     KH = 0000;                    H3
    21:     KH = 0000;                    H4
    22:     KH = 0000;                    H5
    23:     KH = 0000;                    H6
    24:     KH = 0000;                    H7
    25:     KH = 0000;                    H8
    26:     KH = 0000;                    H9
    27:     KH = 0000;                    G0
    28:     KH = 0000;                    G1
    29:     KH = 0000;                    G2
    30:     KH = 0000;                    G3
    31:     KH = 0000;                    G4
    32:     KH = 0000;                    G5
    33:     KH = 0000;                    G6
    34:     KH = 0000;                    G7
    35:     KH = 0000;                    G8
    36:     KH = 0000;                    L- BOTTOM LIMIT
    37:     KH = 0000;                    L+ TOP LIMIT
    38:     KH = 0000;                    W  SLIT
    39:     KH = 0000;                    P4
    40:     KH = 0000;                    X  ACTUAL VALUE
    41:     KH = 0000;                    P3
    42:     KH = 0000;                    E4 SWITCH STAND
    43:     KH = 0000;
    44:     KH = 0000;
    45:
```

```
RECEIVE BLOCK FROM GTR-9000
DW  6     : CICLE No.
DW  7-16  : PARAMETER K0-K9
DW 17-26  : PARAMETER H0-H9
DW 27-35  : PARAMETER G0-G9
DW 36     : BOTTOM LIMIT L-
DW 37     : TOP    LIMIT L+
DW 38     : SLIT W
DW 39     : P4
DW 40     : ACTUAL VALUE X
DW 41     : P3
DW 42     : E4
     0:     KH = 0000;                    GTR-9000
     1:     KH = 0000;                    SPARE
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0000;                    CICLE No.
     7:     KH = 0000;                    K0
     8:     KH = 0000;                    K1
     9:     KH = 0000;                    K2
    10:     KH = 0000;                    K3
    11:     KH = 0000;                    K4
    12:     KH = 0000;                    K5
    13:     KH = 0000;                    K6
    14:     KH = 0000;                    K7
    15:     KH = 0000;                    K8
    16:     KH = 0000;                    K9
    17:     KH = 0000;                    H0
    18:     KH = 0000;                    H1
    19:     KH = 0000;                    H2
    20:     KH = 0000;                    H3
    21:     KH = 0000;                    H4
    22:     KH = 0000;                    H5
    23:     KH = 0000;                    H6
    24:     KH = 0000;                    H7
    25:     KH = 0000;                    H8
    26:     KH = 0000;                    H9
    27:     KH = 0000;                    G0
    28:     KH = 0000;                    G1
    29:     KH = 0000;                    G2
    30:     KH = 0000;                    G3
    31:     KH = 0000;                    G4
    32:     KH = 0000;                    G5
    33:     KH = 0000;                    G6
    34:     KH = 0000;                    G7
    35:     KH = 0000;                    G8
    36:     KH = 0000;                    L- BOTTOM LIMIT
    37:     KH = 0000;                    L+ TOP LIMIT
    38:     KH = 0000;                    W  SLIT
    39:     KH = 0000;                    P4
    40:     KH = 0000;                    X  ACTUAL VALUE
    41:     KH = 0000;                    P3
    42:     KH = 0000;                    E4 SWITCH STAND
    43:     KH = 0000;
    44:     KH = 0000;
    45:
```

```
RECEIVE BLOCK FROM GTR-9000
DW  6    : CICLE No.
DW  7-16 : PARAMETER K0-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G9
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : SLIT W
DW 39    : P4
DW 40    : ACTUAL VALUE X
DW 41    : P3
DW 42    : E4
     0:     KH = 0000;                    GTR-9000
     1:     KH = 0000;                    EXTR. HEAD MIDDLE PART
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0000;                    CICLE No.
     7:     KH = 0000;                    K0
     8:     KH = 0000;                    K1
     9:     KH = 0000;                    K2
    10:     KH = 0000;                    K3
    11:     KH = 0000;                    K4
    12:     KH = 0000;                    K5
    13:     KH = 0000;                    K6
    14:     KH = 0000;                    K7
    15:     KH = 0000;                    K8
    16:     KH = 0000;                    K9
    17:     KH = 0000;                    H0
    18:     KH = 0000;                    H1
    19:     KH = 0000;                    H2
    20:     KH = 0000;                    H3
    21:     KH = 0000;                    H4
    22:     KH = 0000;                    H5
    23:     KH = 0000;                    H6
    24:     KH = 0000;                    H7
    25:     KH = 0000;                    H8
    26:     KH = 0000;                    H9
    27:     KH = 0000;                    G0
    28:     KH = 0000;                    G1
    29:     KH = 0000;                    G2
    30:     KH = 0000;                    G3
    31:     KH = 0000;                    G4
    32:     KH = 0000;                    G5
    33:     KH = 0000;                    G6
    34:     KH = 0000;                    G7
    35:     KH = 0000;                    G8
    36:     KH = 0000;                    L- BOTTOM LIMIT
    37:     KH = 0000;                    L+ TOP LIMIT
    38:     KH = 0000;                    W  SLIT
    39:     KH = 0000;                    P4
    40:     KH = 0000;                    X  ACTUAL VALUE
    41:     KH = 0000;                    P3
    42:     KH = 0000;                    E4 SWITCH STAND
    43:     KH = 0000;
    44:     KH = 0000;
    45:
```

```
RECEIVE BLOCK FROM GTR-9000
DW  6     : CICLE No.
DW  7-16  : PARAMETER K0-K9
DW 17-26  : PARAMETER H0-H9
DW 27-35  : PARAMETER G0-G9
DW 36     : BOTTOM LIMIT L-
DW 37     : TOP    LIMIT L+
DW 38     : SLIT W
DW 39     : P4
DW 40     : ACTUAL VALUE X
DW 41     : P3
DW 42     : E4
     0:     KH = 0000;                    GTR-9000
     1:     KH = 0000;                    EXTR. HEAD UPPER PART
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0000;                    CICLE No.
     7:     KH = 0000;                    K0
     8:     KH = 0000;                    K1
     9:     KH = 0000;                    K2
    10:     KH = 0000;                    K3
    11:     KH = 0000;                    K4
    12:     KH = 0000;                    K5
    13:     KH = 0000;                    K6
    14:     KH = 0000;                    K7
    15:     KH = 0000;                    K8
    16:     KH = 0000;                    K9
    17:     KH = 0000;                    H0
    18:     KH = 0000;                    H1
    19:     KH = 0000;                    H2
    20:     KH = 0000;                    H3
    21:     KH = 0000;                    H4
    22:     KH = 0000;                    H5
    23:     KH = 0000;                    H6
    24:     KH = 0000;                    H7
    25:     KH = 0000;                    H8
    26:     KH = 0000;                    H9
    27:     KH = 0000;                    G0
    28:     KH = 0000;                    G1
    29:     KH = 0000;                    G2
    30:     KH = 0000;                    G3
    31:     KH = 0000;                    G4
    32:     KH = 0000;                    G5
    33:     KH = 0000;                    G6
    34:     KH = 0000;                    G7
    35:     KH = 0000;                    G8
    36:     KH = 0000;                    L- BOTTOM LIMIT
    37:     KH = 0000;                    L+ TOP LIMIT
    38:     KH = 0000;                    W  SLIT
    39:     KH = 0000;                    P4
    40:     KH = 0000;                    X  ACTUAL VALUE
    41:     KH = 0000;                    P3
    42:     KH = 0000;                    E4 SWITCH STAND
    43:     KH = 0000;
    44:     KH = 0000;
    45:
```

```
RECEIVE BLOCK FROM GTR-9000
DW  6    : CICLE No.
DW  7-16 : PARAMETER K0-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G9
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : SLIT W
DW 39    : P4
DW 40    : ACTUAL VALUE X
DW 41    : P3
DW 42    : E4
     0:     KH = 0000;                    GTR-9000
     1:     KH = 0000;                    CALANDER ROLL TOP
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0000;                    CICLE No.
     7:     KH = 0000;                    K0
     8:     KH = 0000;                    K1
     9:     KH = 0000;                    K2
    10:     KH = 0000;                    K3
    11:     KH = 0000;                    K4
    12:     KH = 0000;                    K5
    13:     KH = 0000;                    K6
    14:     KH = 0000;                    K7
    15:     KH = 0000;                    K8
    16:     KH = 0000;                    K9
    17:     KH = 0000;                    H0
    18:     KH = 0000;                    H1
    19:     KH = 0000;                    H2
    20:     KH = 0000;                    H3
    21:     KH = 0000;                    H4
    22:     KH = 0000;                    H5
    23:     KH = 0000;                    H6
    24:     KH = 0000;                    H7
    25:     KH = 0000;                    H8
    26:     KH = 0000;                    H9
    27:     KH = 0000;                    G0
    28:     KH = 0000;                    G1
    29:     KH = 0000;                    G2
    30:     KH = 0000;                    G3
    31:     KH = 0000;                    G4
    32:     KH = 0000;                    G5
    33:     KH = 0000;                    G6
    34:     KH = 0000;                    G7
    35:     KH = 0000;                    G8
    36:     KH = 0000;                    L- BOTTOM LIMIT
    37:     KH = 0000;                    L+ TOP LIMIT
    38:     KH = 0000;                    W  SLIT
    39:     KH = 0000;                    P4
    40:     KH = 0000;                    X  ACTUAL VALUE
    41:     KH = 0000;                    P3
    42:     KH = 0000;                    E4 SWITCH STAND
    43:     KH = 0000;
    44:     KH = 0000;
    45:
```

```
RECEIVE BLOCK FROM GTR-9000
DW  6     : CICLE No.
DW  7-16  : PARAMETER K0-K9
DW 17-26  : PARAMETER H0-H9
DW 27-35  : PARAMETER G0-G9
DW 36     : BOTTOM LIMIT L-
DW 37     : TOP    LIMIT L+
DW 38     : SLIT W
DW 39     : P4
DW 40     : ACTUAL VALUE X
DW 41     : P3
DW 42     : E4
     0:     KH = 0000;                    GTR-9000
     1:     KH = 0000;                    CALANDER ROLL BOTTOM
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0000;                    CICLE No.
     7:     KH = 0000;                    K0
     8:     KH = 0000;                    K1
     9:     KH = 0000;                    K2
    10:     KH = 0000;                    K3
    11:     KH = 0000;                    K4
    12:     KH = 0000;                    K5
    13:     KH = 0000;                    K6
    14:     KH = 0000;                    K7
    15:     KH = 0000;                    K8
    16:     KH = 0000;                    K9
    17:     KH = 0000;                    H0
    18:     KH = 0000;                    H1
    19:     KH = 0000;                    H2
    20:     KH = 0000;                    H3
    21:     KH = 0000;                    H4
    22:     KH = 0000;                    H5
    23:     KH = 0000;                    H6
    24:     KH = 0000;                    H7
    25:     KH = 0000;                    H8
    26:     KH = 0000;                    H9
    27:     KH = 0000;                    G0
    28:     KH = 0000;                    G1
    29:     KH = 0000;                    G2
    30:     KH = 0000;                    G3
    31:     KH = 0000;                    G4
    32:     KH = 0000;                    G5
    33:     KH = 0000;                    G6
    34:     KH = 0000;                    G7
    35:     KH = 0000;                    G8
    36:     KH = 0000;                    L- BOTTOM LIMIT
    37:     KH = 0000;                    L+ TOP LIMIT
    38:     KH = 0000;                    W  SLIT
    39:     KH = 0000;                    P4
    40:     KH = 0000;                    X  ACTUAL VALUE
    41:     KH = 0000;                    P3
    42:     KH = 0000;                    E4 SWITCH STAND
    43:     KH = 0000;
    44:     KH = 0000;
    45:
```

```
RECEIVE BLOCK FROM GTR-9000
DW  6    : CICLE No.
DW  7-16 : PARAMETER K0-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G9
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : SLIT W
DW 39    : P4
DW 40    : ACTUAL VALUE X
DW 41    : P3
DW 42    : E4
     0:     KH = 0000;                    GTR-9000
     1:     KH = 0000;                    EXTRUDER CALANDER SCREW
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0000;                    CICLE No.
     7:     KH = 0000;                    K0
     8:     KH = 0000;                    K1
     9:     KH = 0000;                    K2
    10:     KH = 0000;                    K3
    11:     KH = 0000;                    K4
    12:     KH = 0000;                    K5
    13:     KH = 0000;                    K6
    14:     KH = 0000;                    K7
    15:     KH = 0000;                    K8
    16:     KH = 0000;                    K9
    17:     KH = 0000;                    H0
    18:     KH = 0000;                    H1
    19:     KH = 0000;                    H2
    20:     KH = 0000;                    H3
    21:     KH = 0000;                    H4
    22:     KH = 0000;                    H5
    23:     KH = 0000;                    H6
    24:     KH = 0000;                    H7
    25:     KH = 0000;                    H8
    26:     KH = 0000;                    H9
    27:     KH = 0000;                    G0
    28:     KH = 0000;                    G1
    29:     KH = 0000;                    G2
    30:     KH = 0000;                    G3
    31:     KH = 0000;                    G4
    32:     KH = 0000;                    G5
    33:     KH = 0000;                    G6
    34:     KH = 0000;                    G7
    35:     KH = 0000;                    G8
    36:     KH = 0000;                    L- BOTTOM LIMIT
    37:     KH = 0000;                    L+ TOP LIMIT
    38:     KH = 0000;                    W  SLIT
    39:     KH = 0000;                    P4
    40:     KH = 0000;                    X  ACTUAL VALUE
    41:     KH = 0000;                    P3
    42:     KH = 0000;                    E4 SWITCH STAND
    43:     KH = 0000;
    44:     KH = 0000;
    45:
```

```
RECEIVE BLOCK FROM GTR-9000
DW  6     : CICLE No.
DW  7-16  : PARAMETER K0-K9
DW 17-26  : PARAMETER H0-H9
DW 27-35  : PARAMETER G0-G9
DW 36     : BOTTOM LIMIT L-
DW 37     : TOP    LIMIT L+
DW 38     : SLIT W
DW 39     : P4
DW 40     : ACTUAL VALUE X
DW 41     : P3
DW 42     : E4
     0:     KH = 0000;                    GTR-9000
     1:     KH = 0000;                    EXTRUDER CALANDER PIN/BARREL
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0000;                    CICLE No.
     7:     KH = 0000;                    K0
     8:     KH = 0000;                    K1
     9:     KH = 0000;                    K2
    10:     KH = 0000;                    K3
    11:     KH = 0000;                    K4
    12:     KH = 0000;                    K5
    13:     KH = 0000;                    K6
    14:     KH = 0000;                    K7
    15:     KH = 0000;                    K8
    16:     KH = 0000;                    K9
    17:     KH = 0000;                    H0
    18:     KH = 0000;                    H1
    19:     KH = 0000;                    H2
    20:     KH = 0000;                    H3
    21:     KH = 0000;                    H4
    22:     KH = 0000;                    H5
    23:     KH = 0000;                    H6
    24:     KH = 0000;                    H7
    25:     KH = 0000;                    H8
    26:     KH = 0000;                    H9
    27:     KH = 0000;                    G0
    28:     KH = 0000;                    G1
    29:     KH = 0000;                    G2
    30:     KH = 0000;                    G3
    31:     KH = 0000;                    G4
    32:     KH = 0000;                    G5
    33:     KH = 0000;                    G6
    34:     KH = 0000;                    G7
    35:     KH = 0000;                    G8
    36:     KH = 0000;                    L- BOTTOM LIMIT
    37:     KH = 0000;                    L+ TOP LIMIT
    38:     KH = 0000;                    W  SLIT
    39:     KH = 0000;                    P4
    40:     KH = 0000;                    X  ACTUAL VALUE
    41:     KH = 0000;                    P3
    42:     KH = 0000;                    E4 SWITCH STAND
    43:     KH = 0000;
    44:     KH = 0000;
    45:
```

```
RECEIVE BLOCK FROM GTR-9000
DW  6    : CICLE No.
DW  7-16 : PARAMETER K0-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G9
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : SLIT W
DW 39    : P4
DW 40    : ACTUAL VALUE X
DW 41    : P3
DW 42    : E4
     0:     KH = 0000;                    GTR-9000
     1:     KH = 0000;                    EXTRUDER CALANDER HEAD
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0000;                    CICLE No.
     7:     KH = 0000;                    K0
     8:     KH = 0000;                    K1
     9:     KH = 0000;                    K2
    10:     KH = 0000;                    K3
    11:     KH = 0000;                    K4
    12:     KH = 0000;                    K5
    13:     KH = 0000;                    K6
    14:     KH = 0000;                    K7
    15:     KH = 0000;                    K8
    16:     KH = 0000;                    K9
    17:     KH = 0000;                    H0
    18:     KH = 0000;                    H1
    19:     KH = 0000;                    H2
    20:     KH = 0000;                    H3
    21:     KH = 0000;                    H4
    22:     KH = 0000;                    H5
    23:     KH = 0000;                    H6
    24:     KH = 0000;                    H7
    25:     KH = 0000;                    H8
    26:     KH = 0000;                    H9
    27:     KH = 0000;                    G0
    28:     KH = 0000;                    G1
    29:     KH = 0000;                    G2
    30:     KH = 0000;                    G3
    31:     KH = 0000;                    G4
    32:     KH = 0000;                    G5
    33:     KH = 0000;                    G6
    34:     KH = 0000;                    G7
    35:     KH = 0000;                    G8
    36:     KH = 0000;                    L- BOTTOM LIMIT
    37:     KH = 0000;                    L+ TOP LIMIT
    38:     KH = 0000;                    W  SLIT
    39:     KH = 0000;                    P4
    40:     KH = 0000;                    X  ACTUAL VALUE
    41:     KH = 0000;                    P3
    42:     KH = 0000;                    E4 SWITCH STAND
    43:     KH = 0000;
    44:     KH = 0000;
    45:
```

```
     0:      KH = 0000;          GTR-9000
     1:      KH = 0000;          SPARE
     2:      KH = 0000;
     3:      KH = 0000;
     4:      KH = 0000;
     5:      KH = 0000;
     6:      KH = 0000;          CICLE No.16
     7:      KH = 0000;          K0
     8:      KH = 0000;          K1
     9:      KH = 0000;          K2
    10:      KH = 0000;          K3
    11:      KH = 0000;          K4
    12:      KH = 0000;          K5
    13:      KH = 0000;          K6
    14:      KH = 0000;          K7
    15:      KH = 0000;          K8
    16:      KH = 0000;          K9
    17:      KH = 0000;          H0
    18:      KH = 0000;          H1
    19:      KH = 0000;          H2
    20:      KH = 0000;          H3
    21:      KH = 0000;          H4
    22:      KH = 0000;          H5
    23:      KH = 0000;          H6
    24:      KH = 0000;          H7
    25:      KH = 0000;          H8
    26:      KH = 0000;          H9
    27:      KH = 0000;          G0
    28:      KH = 0000;          G1
    29:      KH = 0000;          G2
    30:      KH = 0000;          G3
    31:      KH = 0000;          G4
    32:      KH = 0000;          G5
    33:      KH = 0000;          G6
    34:      KH = 0000;          G7
    35:      KH = 0000;          G8
    36:      KH = 0000;          L- BOTTOM LIMIT
    37:      KH = 0000;          L+ TOP LIMIT
    38:      KH = 0000;          W  SLIT
    39:      KH = 0000;          P4
    40:      KH = 0000;          X  ACTUAL VALUE
    41:      KH = 0000;          P3
    42:      KH = 0000;          E4 SWITCH STAND
    43:      KH = 0000;
    44:      KH = 0000;
    45:
```

```
SEND BLOCK TO GTR-9000:
DW  6    : CICLE No
DW  7-16 : PARAMETER KO-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G8
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : PRESET W
MIN LENGHT 50DW !!!
     0:     KH = 0000;                    GTR-9000
     1:     KH = 0000;                    BOTTOM EXTRUDER SCREW
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0001;                    No.
     7:     KH = 0000;                    K0
     8:     KH = 0000;                    K1
     9:     KH = 0000;                    K2
    10:     KH = 0004;                    K3
    11:     KH = 0000;                    K4
    12:     KH = 0000;                    K5
    13:     KH = 0008;                    K6
    14:     KH = 0000;                    K7
    15:     KH = 0002;                    K8
    16:     KH = 0008;                    K9
    17:     KH = 0384;                    H0
    18:     KH = 000A;                    H1
    19:     KH = 000A;                    H2
    20:     KH = 0032;                    H3
    21:     KH = 002D;                    H4
    22:     KH = 0000;                    H5
    23:     KH = 03E7;                    H6
    24:     KH = 0064;                    H7
    25:     KH = 0064;                    H8
    26:     KH = 0064;                    H9
    27:     KH = 0000;                    G0
    28:     KH = 0000;                    G1
    29:     KH = 03E7;                    G2
    30:     KH = 0000;                    G3
    31:     KH = 0014;                    G4
    32:     KH = 0038;                    G5
    33:     KH = 0100;                    G6
    34:     KH = 01F4;                    G7
    35:     KH = 0062;                    G8
    36:     KH = 0002;                    L-
    37:     KH = 0002;                    L+
    38:     KH = 0061;                    W
    39:     KH = 0000;
    40:     KH = 0000;
    41:     KH = 0000;
    42:     KH = 0000;
    43:     KH = 0000;
    44:     KH = 0000;
    45:     KH = 0000;
    46:     KH = 0000;
    47:     KH = 0000;
    48:     KH = 0000;
    49:     KH = 0000;
    50:     KH = 0000;
    51:     KH = 0000;
    52:
```

```
SEND BLOCK TO GTR-9000:
DW  6    : CICLE No
DW  7-16 : PARAMETER KO-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G8
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : PRESET W
MIN LENGHT 50DW !!!
     0:     KH = 0000;
     1:     KH = 0000;
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0002;
     7:     KH = 0000;
     8:     KH = 0000;
     9:     KH = 0000;
    10:     KH = 0004;
    11:     KH = 0000;
    12:     KH = 0000;
    13:     KH = 0008;
    14:     KH = 0000;
    15:     KH = 0002;
    16:     KH = 0008;
    17:     KH = 0384;
    18:     KH = 000A;
    19:     KH = 0064;
    20:     KH = 0032;
    21:     KH = 002D;
    22:     KH = 0000;
    23:     KH = 03E7;
    24:     KH = 0064;
    25:     KH = 0064;
    26:     KH = 0064;
    27:     KH = 0000;
    28:     KH = 0000;
    29:     KH = 03E7;
    30:     KH = 0000;
    31:     KH = 0014;
    32:     KH = 0038;
    33:     KH = 0100;
    34:     KH = 01F4;
    35:     KH = 0062;
    36:     KH = 0002;
    37:     KH = 0002;
    38:     KH = 0050;
    39:     KH = 0000;
    40:     KH = 0000;
    41:     KH = 0000;
    42:     KH = 0000;
    43:     KH = 0000;
    44:     KH = 0000;
    45:     KH = 0000;
    46:     KH = 0000;
    47:     KH = 0000;
    48:     KH = 0000;
    49:     KH = 0000;
    50:     KH = 0000;
    51:     KH = 0000;
    52:
```

GTR-9000
BOTTOM EXTRUDER BARREL

No.
K0
K1
K2
K3
K4
K5
K6
K7
K8
K9
H0
H1
H2
H3
H4
H5
H6
H7
H8
H9
G0
G1
G2
G3
G4
G5
G6
G7
G8
L-
L+
W

```
SEND BLOCK TO GTR-9000:
DW  6     : CICLE No
DW  7-16  : PARAMETER KO-K9
DW 17-26  : PARAMETER H0-H9
DW 27-35  : PARAMETER G0-G8
DW 36     : BOTTOM LIMIT L-
DW 37     : TOP    LIMIT L+
DW 38     : PRESET W
MIN LENGHT 50DW !!!
     0:      KH = 0000;
     1:      KH = 0000;
     2:      KH = 0000;
     3:      KH = 0000;
     4:      KH = 0000;
     5:      KH = 0000;
     6:      KH = 0003;
     7:      KH = 0000;
     8:      KH = 0000;
     9:      KH = 0000;
    10:      KH = 0004;
    11:      KH = 0000;
    12:      KH = 0000;
    13:      KH = 0008;
    14:      KH = 0000;
    15:      KH = 0002;
    16:      KH = 0008;
    17:      KH = 0384;
    18:      KH = 000A;
    19:      KH = 000A;
    20:      KH = 0032;
    21:      KH = 002D;
    22:      KH = 0000;
    23:      KH = 03E7;
    24:      KH = 0064;
    25:      KH = 0064;
    26:      KH = 0064;
    27:      KH = 0000;
    28:      KH = 0000;
    29:      KH = 03E7;
    30:      KH = 0000;
    31:      KH = 0014;
    32:      KH = 0038;
    33:      KH = 0100;
    34:      KH = 01F4;
    35:      KH = 0062;
    36:      KH = 0002;
    37:      KH = 0002;
    38:      KH = 0028;
    39:      KH = 0000;
    40:      KH = 0000;
    41:      KH = 0000;
    42:      KH = 0000;
    43:      KH = 0000;
    44:      KH = 0000;
    45:      KH = 0000;
    46:      KH = 0000;
    47:      KH = 0000;
    48:      KH = 0000;
    49:      KH = 0000;
    50:      KH = 0000;
    51:      KH = 0000;
    52:
```

GTR-9000
UPPER EXTRUDER SCREW

No.
K0
K1
K2
K3
K4
K5
K6
K7
K8
K9
H0
H1
H2
H3
H4
H5
H6
H7
H8
H9
G0
G1
G2
G3
G4
G5
G6
G7
G8
L-
L+
W

```
SEND BLOCK TO GTR-9000:
DW  6    : CICLE No
DW  7-16 : PARAMETER KO-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G8
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : PRESET W
MIN LENGHT 50DW !!!
     0:     KH = 0000;                    GTR-9000
     1:     KH = 0000;                    UPPER EXTRUDER BARREL
     2:     KH = 0000;
     3:     KH = 0000;
     4:     KH = 0000;
     5:     KH = 0000;
     6:     KH = 0004;                    No.
     7:     KH = 0000;                    K0
     8:     KH = 0000;                    K1
     9:     KH = 0000;                    K2
    10:     KH = 0004;                    K3
    11:     KH = 0000;                    K4
    12:     KH = 0000;                    K5
    13:     KH = 0008;                    K6
    14:     KH = 0000;                    K7
    15:     KH = 0002;                    K8
    16:     KH = 0008;                    K9
    17:     KH = 0384;                    H0
    18:     KH = 000A;                    H1
    19:     KH = 0064;                    H2
    20:     KH = 0032;                    H3
    21:     KH = 002D;                    H4
    22:     KH = 0000;                    H5
    23:     KH = 03E7;                    H6
    24:     KH = 0064;                    H7
    25:     KH = 0064;                    H8
    26:     KH = 0064;                    H9
    27:     KH = 0000;                    G0
    28:     KH = 0000;                    G1
    29:     KH = 03E7;                    G2
    30:     KH = 0000;                    G3
    31:     KH = 0014;                    G4
    32:     KH = 0038;                    G5
    33:     KH = 0100;                    G6
    34:     KH = 01F4;                    G7
    35:     KH = 0062;                    G8
    36:     KH = 0002;                    L-
    37:     KH = 0002;                    L+
    38:     KH = 0050;                    W
    39:     KH = 0000;
    40:     KH = 0000;
    41:     KH = 0000;
    42:     KH = 0000;
    43:     KH = 0000;
    44:     KH = 0000;
    45:     KH = 0000;
    46:     KH = 0000;
    47:     KH = 0000;
    48:     KH = 0000;
    49:     KH = 0000;
    50:     KH = 0000;
    51:     KH = 0000;
    52:
```

```
SEND BLOCK TO GTR-9000:
DW  6    : CICLE No
DW  7-16 : PARAMETER KO-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G8
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : PRESET W
MIN LENGHT 50DW !!!
     0:      KH = 0000;
     1:      KH = 0000;
     2:      KH = 0000;
     3:      KH = 0000;
     4:      KH = 0000;
     5:      KH = 0000;
     6:      KH = 0005;
     7:      KH = 0000;
     8:      KH = 0000;
     9:      KH = 0001;
    10:      KH = 0001;
    11:      KH = 0000;
    12:      KH = 0000;
    13:      KH = 0008;
    14:      KH = 0000;
    15:      KH = 0002;
    16:      KH = 0008;
    17:      KH = 0384;
    18:      KH = 000A;
    19:      KH = 0064;
    20:      KH = 0032;
    21:      KH = 002D;
    22:      KH = 0000;
    23:      KH = 03E7;
    24:      KH = 0064;
    25:      KH = 0064;
    26:      KH = 0064;
    27:      KH = 0000;
    28:      KH = 0000;
    29:      KH = 03E7;
    30:      KH = 0000;
    31:      KH = 0001;
    32:      KH = 0038;
    33:      KH = 0100;
    34:      KH = 01F4;
    35:      KH = 0062;
    36:      KH = 0028;
    37:      KH = 0028;
    38:      KH = 003C;
    39:      KH = 0000;
    40:      KH = 0000;
    41:      KH = 0000;
    42:      KH = 0000;
    43:      KH = 0000;
    44:      KH = 0000;
    45:      KH = 0000;
    46:      KH = 0000;
    47:      KH = 0000;
    48:      KH = 0000;
    49:      KH = 0000;
    50:      KH = 0000;
    51:      KH = 0000;
    52:
```

GTR-9000
CASSETTE LEFT

No.
K0
K1
K2
K3
K4
K5
K6
K7
K8
K9
H0
H1
H2
H3
H4
H5
H6
H7
H8
H9
G0
G1
G2
G3
G4
G5
G6
G7
G8
L-
L+
W

```
SEND BLOCK TO GTR-9000:
DW  6     : CICLE No
DW  7-16  : PARAMETER KO-K9
DW 17-26  : PARAMETER H0-H9
DW 27-35  : PARAMETER G0-G8
DW 36     : BOTTOM LIMIT L-
DW 37     : TOP    LIMIT L+
DW 38     : PRESET W
MIN LENGHT 50DW !!!
     0:      KH = 0000;                    GTR-9000
     1:      KH = 0000;                    CASSETTE RIGHT
     2:      KH = 0000;
     3:      KH = 0000;
     4:      KH = 0000;
     5:      KH = 0000;
     6:      KH = 0006;                    No.
     7:      KH = 0000;                    K0
     8:      KH = 0000;                    K1
     9:      KH = 0001;                    K2
    10:      KH = 0002;                    K3
    11:      KH = 0000;                    K4
    12:      KH = 0000;                    K5
    13:      KH = 0008;                    K6
    14:      KH = 0000;                    K7
    15:      KH = 0002;                    K8
    16:      KH = 0008;                    K9
    17:      KH = 0384;                    H0
    18:      KH = 000A;                    H1
    19:      KH = 0064;                    H2
    20:      KH = 0032;                    H3
    21:      KH = 002D;                    H4
    22:      KH = 0000;                    H5
    23:      KH = 03E7;                    H6
    24:      KH = 0064;                    H7
    25:      KH = 0064;                    H8
    26:      KH = 0064;                    H9
    27:      KH = 0000;                    G0
    28:      KH = 0000;                    G1
    29:      KH = 03E7;                    G2
    30:      KH = 0000;                    G3
    31:      KH = 0001;                    G4
    32:      KH = 0038;                    G5
    33:      KH = 0100;                    G6
    34:      KH = 01F4;                    G7
    35:      KH = 0062;                    G8
    36:      KH = 0028;                    L-
    37:      KH = 0028;                    L+
    38:      KH = 003C;                    W
    39:      KH = 0000;
    40:      KH = 0000;
    41:      KH = 0000;
    42:      KH = 0000;
    43:      KH = 0000;
    44:      KH = 0000;
    45:      KH = 0000;
    46:      KH = 0000;
    47:      KH = 0000;
    48:      KH = 0000;
    49:      KH = 0000;
    50:      KH = 0000;
    51:      KH = 0000;
    52:
```

```
SEND BLOCK TO GTR-9000:
DW  6     : CICLE No
DW  7-16  : PARAMETER KO-K9
DW 17-26  : PARAMETER H0-H9
DW 27-35  : PARAMETER G0-G8
DW 36     : BOTTOM LIMIT L-
DW 37     : TOP    LIMIT L+
DW 38     : PRESET W
MIN LENGHT 50DW !!!
     0:      KH = 0000;
     1:      KH = 0000;
     2:      KH = 0000;
     3:      KH = 0000;
     4:      KH = 0000;
     5:      KH = 0000;
     6:      KH = 0007;
     7:      KH = 0000;
     8:      KH = 0000;
     9:      KH = 0001;
    10:      KH = 0005;
    11:      KH = 0000;
    12:      KH = 0000;
    13:      KH = 0008;
    14:      KH = 0000;
    15:      KH = 0002;
    16:      KH = 0008;
    17:      KH = 0384;
    18:      KH = 000A;
    19:      KH = 0064;
    20:      KH = 0032;
    21:      KH = 002D;
    22:      KH = 0000;
    23:      KH = 03E7;
    24:      KH = 0064;
    25:      KH = 0064;
    26:      KH = 0064;
    27:      KH = 0000;
    28:      KH = 0000;
    29:      KH = 03E7;
    30:      KH = 0000;
    31:      KH = 0001;
    32:      KH = 0038;
    33:      KH = 0100;
    34:      KH = 01F4;
    35:      KH = 0062;
    36:      KH = 03E7;
    37:      KH = 03E7;
    38:      KH = 003C;
    39:      KH = 0000;
    40:      KH = 0000;
    41:      KH = 0000;
    42:      KH = 0000;
    43:      KH = 0000;
    44:      KH = 0000;
    45:      KH = 0000;
    46:      KH = 0000;
    47:      KH = 0000;
    48:      KH = 0000;
    49:      KH = 0000;
    50:      KH = 0000;
    51:      KH = 0000;
    52:
```

GTR-9000
PREHEATING TABLE

No.
K0
K1
K2
K3
K4
K5
K6
K7
K8
K9
H0
H1
H2
H3
H4
H5
H6
H7
H8
H9
G0
G1
G2
G3
G4
G5
G6
G7
G8
L-
L+
W

```
SEND BLOCK TO GTR-9000:
DW  6     : CICLE No
DW  7-16  : PARAMETER KO-K9
DW 17-26  : PARAMETER H0-H9
DW 27-35  : PARAMETER G0-G8
DW 36     : BOTTOM LIMIT L-
DW 37     : TOP    LIMIT L+
DW 38     : PRESET W
MIN LENGHT 50DW !!!
     0:      KF = +00000;                GTR-9000
     1:      KF = +00000;                SPARE
     2:      KF = +00000;
     3:      KF = +00000;
     4:      KF = +00000;
     5:      KF = +00000;
     6:      KF = +00008;                No.
     7:      KF = +00000;                K0
     8:      KF = +00000;                K1
     9:      KF = +00001;                K2
    10:      KF = +00005;                K3
    11:      KF = +00000;                K4
    12:      KF = +00000;                K5
    13:      KF = +00008;                K6
    14:      KF = +00000;                K7
    15:      KF = +00002;                K8
    16:      KF = +00008;                K9
    17:      KF = +00900;                H0
    18:      KF = +00010;                H1
    19:      KF = +00100;                H2
    20:      KF = +00050;                H3
    21:      KF = +00045;                H4
    22:      KF = +00000;                H5
    23:      KF = +00999;                H6
    24:      KF = +00100;                H7
    25:      KF = +00100;                H8
    26:      KF = +00100;                H9
    27:      KF = +00000;                G0
    28:      KF = +00000;                G1
    29:      KF = +00999;                G2
    30:      KF = +00000;                G3
    31:      KF = +00001;                G4
    32:      KF = +00056;                G5
    33:      KF = +00256;                G6
    34:      KF = +00500;                G7
    35:      KF = +00098;                G8
    36:      KF = +00999;                L-
    37:      KF = +00999;                L+
    38:      KF = +00035;                W
    39:      KF = +00000;
    40:      KF = +00000;
    41:      KF = +00000;
    42:      KF = +00000;
    43:      KF = +00000;
    44:      KF = +00000;
    45:      KF = +00000;
    46:      KF = +00000;
    47:      KF = +00000;
    48:      KF = +00000;
    49:      KF = +00000;
    50:      KF = +00000;
    51:      KF = +00000;
    52:
```

```
SEND BLOCK TO GTR-9000:
DW  6    : CICLE No
DW  7-16 : PARAMETER KO-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G8
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : PRESET W
MIN LENGHT 50DW !!!
     0:     KF = +00000;                    GTR-9000
     1:     KF = +00000;                    ETRUSION HEAD MIDDLE PART
     2:     KF = +00000;
     3:     KF = +00000;
     4:     KF = +00000;
     5:     KF = +00000;
     6:     KF = +00009;                    No.
     7:     KF = +00000;                    K0
     8:     KF = +00000;                    K1
     9:     KF = +00000;                    K2
    10:     KF = +00004;                    K3
    11:     KF = +00000;                    K4
    12:     KF = +00000;                    K5
    13:     KF = +00008;                    K6
    14:     KF = +00000;                    K7
    15:     KF = +00002;                    K8
    16:     KF = +00008;                    K9
    17:     KF = +00900;                    H0
    18:     KF = +00010;                    H1
    19:     KF = +00100;                    H2
    20:     KF = +00050;                    H3
    21:     KF = +00045;                    H4
    22:     KF = +00000;                    H5
    23:     KF = +00999;                    H6
    24:     KF = +00100;                    H7
    25:     KF = +00100;                    H8
    26:     KF = +00100;                    H9
    27:     KF = +00000;                    G0
    28:     KF = +00000;                    G1
    29:     KF = +00999;                    G2
    30:     KF = +00000;                    G3
    31:     KF = +00001;                    G4
    32:     KF = +00056;                    G5
    33:     KF = +00256;                    G6
    34:     KF = +00500;                    G7
    35:     KF = +00098;                    G8
    36:     KF = +00002;                    L-
    37:     KF = +00002;                    L+
    38:     KF = +00085;                    W
    39:     KF = +00000;
    40:     KF = +00000;
    41:     KF = +00000;
    42:     KF = +00000;
    43:     KF = +00000;
    44:     KF = +00000;
    45:     KF = +00000;
    46:     KF = +00000;
    47:     KF = +00000;
    48:     KF = +00000;
    49:     KF = +00000;
    50:     KF = +00000;
    51:     KF = +00000;
    52:
```

```
SEND BLOCK TO GTR-9000:
DW  6    : CICLE No
DW  7-16 : PARAMETER KO-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G8
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : PRESET W
MIN LENGHT 50DW !!!
     0:     KF = +00000;
     1:     KF = +00000;
     2:     KF = +00000;
     3:     KF = +00000;
     4:     KF = +00000;
     5:     KF = +00000;
     6:     KF = +00010;
     7:     KF = +00000;
     8:     KF = +00000;
     9:     KF = +00000;
    10:     KF = +00004;
    11:     KF = +00000;
    12:     KF = +00000;
    13:     KF = +00008;
    14:     KF = +00000;
    15:     KF = +00002;
    16:     KF = +00008;
    17:     KF = +00900;
    18:     KF = +00010;
    19:     KF = +00100;
    20:     KF = +00050;
    21:     KF = +00045;
    22:     KF = +00000;
    23:     KF = +00999;
    24:     KF = +00100;
    25:     KF = +00100;
    26:     KF = +00100;
    27:     KF = +00000;
    28:     KF = +00000;
    29:     KF = +00999;
    30:     KF = +00000;
    31:     KF = +00001;
    32:     KF = +00056;
    33:     KF = +00256;
    34:     KF = +00500;
    35:     KF = +00098;
    36:     KF = +00002;
    37:     KF = +00002;
    38:     KF = +00090;
    39:     KF = +00000;
    40:     KF = +00000;
    41:     KF = +00000;
    42:     KF = +00000;
    43:     KF = +00000;
    44:     KF = +00000;
    45:     KF = +00000;
    46:     KF = +00000;
    47:     KF = +00000;
    48:     KF = +00000;
    49:     KF = +00000;
    50:     KF = +00000;
    51:     KF = +00000;
    52:
```

GTR-9000
EXTRUSION HEAD UPPER PART

No.
K0
K1
K2
K3
K4
K5
K6
K7
K8
K9
H0
H1
H2
H3
H4
H5
H6
H7
H8
H9
G0
G1
G2
G3
G4
G5
G6
G7
G8
L-
L+
W

```
SEND BLOCK TO GTR-9000:
DW  6    : CICLE No
DW  7-16 : PARAMETER KO-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G8
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : PRESET W
MIN LENGHT 50DW !!!
     0:     KF = +00000;                    GTR-9000
     1:     KF = +00000;                    CALANDER ROLL TOP
     2:     KF = +00000;
     3:     KF = +00000;
     4:     KF = +00000;
     5:     KF = +00000;
     6:     KF = +00011;                    No.
     7:     KF = +00000;                    K0
     8:     KF = +00000;                    K1
     9:     KF = +00000;                    K2
    10:     KF = +00004;                    K3
    11:     KF = +00000;                    K4
    12:     KF = +00000;                    K5
    13:     KF = +00008;                    K6
    14:     KF = +00000;                    K7
    15:     KF = +00002;                    K8
    16:     KF = +00008;                    K9
    17:     KF = +00900;                    H0
    18:     KF = +00010;                    H1
    19:     KF = +00100;                    H2
    20:     KF = +00050;                    H3
    21:     KF = +00045;                    H4
    22:     KF = +00000;                    H5
    23:     KF = +00999;                    H6
    24:     KF = +00100;                    H7
    25:     KF = +00100;                    H8
    26:     KF = +00100;                    H9
    27:     KF = +00000;                    G0
    28:     KF = +00000;                    G1
    29:     KF = +00999;                    G2
    30:     KF = +00000;                    G3
    31:     KF = +00001;                    G4
    32:     KF = +00056;                    G5
    33:     KF = +00256;                    G6
    34:     KF = +00500;                    G7
    35:     KF = +00098;                    G8
    36:     KF = +00002;                    L-
    37:     KF = +00002;                    L+
    38:     KF = +00075;                    W
    39:     KF = +00000;
    40:     KF = +00000;
    41:     KF = +00000;
    42:     KF = +00000;
    43:     KF = +00000;
    44:     KF = +00000;
    45:     KF = +00000;
    46:     KF = +00000;
    47:     KF = +00000;
    48:     KF = +00000;
    49:     KF = +00000;
    50:
```

```
SEND BLOCK TO GTR-9000:
DW  6    : CICLE No
DW  7-16 : PARAMETER KO-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G8
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : PRESET W
MIN LENGHT 50DW !!!
     0:     KF = +00000;
     1:     KF = +00000;
     2:     KF = +00000;
     3:     KF = +00000;
     4:     KF = +00000;
     5:     KF = +00000;
     6:     KF = +00012;
     7:     KF = +00000;
     8:     KF = +00000;
     9:     KF = +00000;
    10:     KF = +00004;
    11:     KF = +00000;
    12:     KF = +00000;
    13:     KF = +00008;
    14:     KF = +00000;
    15:     KF = +00002;
    16:     KF = +00008;
    17:     KF = +00900;
    18:     KF = +00010;
    19:     KF = +00100;
    20:     KF = +00050;
    21:     KF = +00045;
    22:     KF = +00000;
    23:     KF = +00999;
    24:     KF = +00100;
    25:     KF = +00100;
    26:     KF = +00100;
    27:     KF = +00000;
    28:     KF = +00000;
    29:     KF = +00999;
    30:     KF = +00000;
    31:     KF = +00001;
    32:     KF = +00056;
    33:     KF = +00256;
    34:     KF = +00500;
    35:     KF = +00098;
    36:     KF = +00002;
    37:     KF = +00002;
    38:     KF = +00075;
    39:     KF = +00000;
    40:     KF = +00000;
    41:     KF = +00000;
    42:     KF = +00000;
    43:     KF = +00000;
    44:     KF = +00000;
    45:     KF = +00000;
    46:     KF = +00000;
    47:     KF = +00000;
    48:     KF = +00000;
    49:     KF = +00000;
    50:
```

GTR-9000
CALANDER ROLL BOTTOM

No.
K0
K1
K2
K3
K4
K5
K6
K7
K8
K9
H0
H1
H2
H3
H4
H5
H6
H7
H8
H9
G0
G1
G2
G3
G4
G5
G6
G7
G8
L-
L+
W

```
SEND BLOCK TO GTR-9000:
DW  6     : CICLE No
DW  7-16  : PARAMETER KO-K9
DW 17-26  : PARAMETER H0-H9
DW 27-35  : PARAMETER G0-G8
DW 36     : BOTTOM LIMIT L-
DW 37     : TOP    LIMIT L+
DW 38     : PRESET W
MIN LENGHT 50DW !!!
     0:      KF = +00000;                    GTR-9000
     1:      KF = +00000;                    EXTRUDER CALANDER SCREW
     2:      KF = +00000;
     3:      KF = +00000;
     4:      KF = +00000;
     5:      KF = +00000;
     6:      KF = +00013;                    No.
     7:      KF = +00000;                    K0
     8:      KF = +00000;                    K1
     9:      KF = +00000;                    K2
    10:      KF = +00004;                    K3
    11:      KF = +00000;                    K4
    12:      KF = +00000;                    K5
    13:      KF = +00008;                    K6
    14:      KF = +00000;                    K7
    15:      KF = +00002;                    K8
    16:      KF = +00008;                    K9
    17:      KF = +00900;                    H0
    18:      KF = +00010;                    H1
    19:      KF = +00100;                    H2
    20:      KF = +00050;                    H3
    21:      KF = +00045;                    H4
    22:      KF = +00000;                    H5
    23:      KF = +00999;                    H6
    24:      KF = +00100;                    H7
    25:      KF = +00100;                    H8
    26:      KF = +00100;                    H9
    27:      KF = +00000;                    G0
    28:      KF = +00000;                    G1
    29:      KF = +00999;                    G2
    30:      KF = +00000;                    G3
    31:      KF = +00001;                    G4
    32:      KF = +00056;                    G5
    33:      KF = +00256;                    G6
    34:      KF = +00500;                    G7
    35:      KF = +00098;                    G8
    36:      KF = +00002;                    L-
    37:      KF = +00002;                    L+
    38:      KF = +00071;                    W
    39:      KF = +00000;
    40:      KF = +00000;
    41:      KF = +00000;
    42:      KF = +00000;
    43:      KF = +00000;
    44:      KF = +00000;
    45:      KF = +00000;
    46:      KF = +00000;
    47:      KF = +00000;
    48:      KF = +00000;
    49:      KF = +00000;
    50:
```

```
SEND BLOCK TO GTR-9000:
DW  6    : CICLE No
DW  7-16 : PARAMETER KO-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G8
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : PRESET W
MIN LENGHT 50DW !!!
     0:      KF = +00000;                    GTR-9000
     1:      KF = +00000;                    EXTRUDER CALANDER PIN/BARREL
     2:      KF = +00000;
     3:      KF = +00000;
     4:      KF = +00000;
     5:      KF = +00000;
     6:      KF = +00014;                    No.
     7:      KF = +00000;                    K0
     8:      KF = +00000;                    K1
     9:      KF = +00000;                    K2
    10:      KF = +00004;                    K3
    11:      KF = +00000;                    K4
    12:      KF = +00000;                    K5
    13:      KF = +00008;                    K6
    14:      KF = +00000;                    K7
    15:      KF = +00002;                    K8
    16:      KF = +00008;                    K9
    17:      KF = +00900;                    H0
    18:      KF = +00010;                    H1
    19:      KF = +00100;                    H2
    20:      KF = +00050;                    H3
    21:      KF = +00045;                    H4
    22:      KF = +00000;                    H5
    23:      KF = +00999;                    H6
    24:      KF = +00100;                    H7
    25:      KF = +00100;                    H8
    26:      KF = +00100;                    H9
    27:      KF = +00000;                    G0
    28:      KF = +00000;                    G1
    29:      KF = +00999;                    G2
    30:      KF = +00000;                    G3
    31:      KF = +00001;                    G4
    32:      KF = +00056;                    G5
    33:      KF = +00256;                    G6
    34:      KF = +00500;                    G7
    35:      KF = +00098;                    G8
    36:      KF = +00002;                    L-
    37:      KF = +00002;                    L+
    38:      KF = +00080;                    W
    39:      KF = +00000;
    40:      KF = +00000;
    41:      KF = +00000;
    42:      KF = +00000;
    43:      KF = +00000;
    44:      KF = +00000;
    45:      KF = +00000;
    46:      KF = +00000;
    47:      KF = +00000;
    48:      KF = +00000;
    49:      KF = +00000;
    50:
```

```
SEND BLOCK TO GTR-9000:
DW  6     : CICLE No
DW  7-16  : PARAMETER KO-K9
DW 17-26  : PARAMETER H0-H9
DW 27-35  : PARAMETER G0-G8
DW 36     : BOTTOM LIMIT L-
DW 37     : TOP    LIMIT L+
DW 38     : PRESET W
MIN LENGHT 50DW !!!
     0:     KF = +00000;                    GTR-9000
     1:     KF = +00000;                    EXTRUDER CALANDER HEAD
     2:     KF = +00000;
     3:     KF = +00000;
     4:     KF = +00000;
     5:     KF = +00000;
     6:     KF = +00015;                    No.
     7:     KF = +00000;                    K0
     8:     KF = +00000;                    K1
     9:     KF = +00000;                    K2
    10:     KF = +00004;                    K3
    11:     KF = +00000;                    K4
    12:     KF = +00000;                    K5
    13:     KF = +00008;                    K6
    14:     KF = +00000;                    K7
    15:     KF = +00002;                    K8
    16:     KF = +00008;                    K9
    17:     KF = +00900;                    H0
    18:     KF = +00010;                    H1
    19:     KF = +00100;                    H2
    20:     KF = +00050;                    H3
    21:     KF = +00045;                    H4
    22:     KF = +00000;                    H5
    23:     KF = +00999;                    H6
    24:     KF = +00100;                    H7
    25:     KF = +00100;                    H8
    26:     KF = +00100;                    H9
    27:     KF = +00000;                    G0
    28:     KF = +00000;                    G1
    29:     KF = +00999;                    G2
    30:     KF = +00000;                    G3
    31:     KF = +00001;                    G4
    32:     KF = +00056;                    G5
    33:     KF = +00256;                    G6
    34:     KF = +00500;                    G7
    35:     KF = +00098;                    G8
    36:     KF = +00002;                    L-
    37:     KF = +00002;                    L+
    38:     KF = +00085;                    W
    39:     KF = +00000;
    40:     KF = +00000;
    41:     KF = +00000;
    42:     KF = +00000;
    43:     KF = +00000;
    44:     KF = +00000;
    45:     KF = +00000;
    46:     KF = +00000;
    47:     KF = +00000;
    48:     KF = +00000;
    49:     KF = +00000;
    50:
```

```
SEND BLOCK TO GTR-9000:
DW  6    : CICLE No
DW  7-16 : PARAMETER KO-K9
DW 17-26 : PARAMETER H0-H9
DW 27-35 : PARAMETER G0-G8
DW 36    : BOTTOM LIMIT L-
DW 37    : TOP    LIMIT L+
DW 38    : PRESET W
MIN LENGHT 50DW !!!
     0:     KF = +00000;          GTR-9000
     1:     KF = +00000;          SPARE
     2:     KF = +00000;
     3:     KF = +00000;
     4:     KF = +00000;
     5:     KF = +00000;
     6:     KF = +00016;          No.
     7:     KF = +00000;          K0
     8:     KF = +00000;          K1
     9:     KF = +00000;          K2
    10:     KF = +00000;          K3
    11:     KF = +00000;          K4
    12:     KF = +00000;          K5
    13:     KF = +00000;          K6
    14:     KF = +00000;          K7
    15:     KF = +00000;          K8
    16:     KF = +00000;          K9
    17:     KF = +00000;          H0
    18:     KF = +00000;          H1
    19:     KF = +00000;          H2
    20:     KF = +00000;          H3
    21:     KF = +00000;          H4
    22:     KF = +00000;          H5
    23:     KF = +00000;          H6
    24:     KF = +00000;          H7
    25:     KF = +00000;          H8
    26:     KF = +00000;          H9
    27:     KF = +00000;          G0
    28:     KF = +00000;          G1
    29:     KF = +00000;          G2
    30:     KF = +00000;          G3
    31:     KF = +00000;          G4
    32:     KF = +00000;          G5
    33:     KF = +00000;          G6
    34:     KF = +00000;          G7
    35:     KF = +00000;          G8
    36:     KF = +00000;          L-
    37:     KF = +00000;          L+
    38:     KF = +00000;          W
    39:     KF = +00000;
    40:     KF = +00000;
    41:     KF = +00000;
    42:     KF = +00000;
    43:     KF = +00000;
    44:     KF = +00000;
    45:     KF = +00000;
    46:     KF = +00000;
    47:     KF = +00000;
    48:     KF = +00000;
    49:     KF = +00000;
    50:
```

```
  0:    KH = 0020;
  1:    KH = 0020;
  2:    KH = 0020;
  3:    KH = 0020;
  4:    KH = 0020;
  5:    KH = 0020;
  6:    KH = 0020;
  7:    KH = 0020;
  8:    KH = 0020;
  9:    KH = 0020;
 10:    KH = 0020;
 11:    KH = 0020;
 12:    KH = 0020;
 13:    KH = 0020;
 14:    KH = 0020;
 15:    KH = 0020;
 16:    KH = 0020;
 17:    KH = 0020;
 18:    KH = 0020;
 19:    KH = 0020;
 20:    KH = 0020;
 21:    KH = 0020;
 22:    KH = 0020;
 23:    KH = 0020;
 24:    KH = 0020;
 25:    KH = 0020;
 26:    KH = 0020;
 27:    KH = 0020;
 28:    KH = 0020;
 29:    KH = 0020;
 30:    KH = 0020;
 31:    KH = 0020;
 32:    KH = 0020;
 33:    KH = 0020;
 34:    KH = 0020;
 35:    KH = 0020;
 36:    KH = 0020;
 37:    KH = 0020;
 38:    KH = 0020;
 39:    KH = 0020;
 40:    KH = 0020;
 41:    KH = 0020;
 42:    KH = 0020;
 43:    KH = 0020;
 44:    KH = 0020;
 45:    KH = 0020;
 46:    KH = 0020;
 47:    KH = 0020;
 48:    KH = 0000;
 49:    KH = 0000;
 50:    KH = 0000;
 51:    KH = 0000;
 52:    KH = 0000;
 53:    KH = 0000;
 54:    KH = 0000;
 55:    KH = 0000;
 56:    KH = 0000;
 57:    KH = 0000;
 58:    KH = 0000;
 59:    KH = 0000;
 60:    KH = 0000;
 61:    KH = 0000;
 62:    KH = 0000;
 63:    KH = 0000;
 64:    KH = 0000;
 65:    KH = 0000;
 66:    KH = 0000;
 67:    KH = 0000;
 68:    KH = 0000;
 69:    KH = 0000;
 70:    KH = 0000;
 71:    KH = 0000;
 72:    KH = 0000;
 73:    KH = 0000;
```

```
   74:      KH = 0000;
   75:      KH = 0000;
   76:      KH = 0000;
   77:      KH = 0000;
   78:      KH = 0000;
   79:      KH = 0000;
   80:      KH = 0000;
   81:      KH = 0000;
   82:      KH = 0000;
   83:      KH = 0000;
   84:      KH = 0000;
   85:      KH = 0000;
   86:      KH = 0000;
   87:      KH = 0000;
   88:      KH = 0000;
   89:      KH = 0000;
   90:      KH = 0000;
   91:      KH = 0000;
   92:      KH = 0000;
   93:      KH = 0000;
   94:      KH = 0000;
   95:      KH = 0000;
   96:      KH = 0000;
   97:      KH = 0000;
   98:      KH = 0000;
   99:      KH = 0000;
  100:      KH = 0000;
  101:      KH = 0000;
  102:      KH = 0000;
  103:      KH = 0000;
  104:      KH = 0000;
  105:      KH = 0000;
  106:      KH = 0000;
  107:      KH = 0000;
  108:      KH = 0000;
  109:      KH = 0000;
  110:      KH = 0000;
  111:      KH = 0000;
  112:      KH = 0000;
  113:      KH = 0000;
  114:      KH = 0000;
  115:      KH = 0000;
  116:      KH = 0000;
  117:      KH = 0000;
  118:      KH = 0000;
  119:      KH = 0000;
  120:      KH = 0000;
  121:      KH = 0000;
  122:      KH = 0000;
  123:      KH = 0000;
  124:      KH = 0000;
  125:      KH = 0000;
  126:      KH = 0000;
  127:      KH = 0000;
  128:      KH = 0000;
  129:      KH = 0000;
  130:      KH = 0000;
  131:      KH = 0000;
  132:      KH = 0000;
  133:      KH = 0000;
  134:      KH = 0000;
  135:      KH = 0000;
  136:      KH = 0000;
  137:      KH = 0000;
  138:      KH = 0000;
  139:      KH = 0000;
  140:      KH = 0000;
  141:      KH = 0000;
  142:      KH = 0000;
  143:      KH = 0000;
  144:      KH = D800;
  145:      KH = 1500;
  146:      KH = 0100;
  147:      KH = C564;
```

```
148:      KH = 9C3C;
149:      KH = 1720;
150:      KH = 4442;
151:      KH = 2053;
152:      KH = 5452;
153:      KH = 554B;
154:      KH = 5455;
155:      KH = 522C;
156:      KH = 2044;
157:      KH = 422D;
158:      KH = 4E72;
159:      KH = 3D31;
160:      KH = 3536;
161:      KH = A3FC;
162:      KH = FAFC;
163:      KH = 966E;
164:      KH = 1720;
165:      KH = 4442;
166:      KH = 2053;
167:      KH = 5452;
168:      KH = 554B;
169:      KH = 5455;
170:      KH = 522C;
171:      KH = 2044;
172:      KH = 422D;
173:      KH = 4E72;
174:      KH = 3D31;
175:      KH = 3536;
176:      KH = 0000;
177:      KH = 0000;
178:      KH = 0000;
179:      KH = C564;
180:      KH = E3FC;
181:      KH = 0B55;
182:      KH = 1720;
183:      KH = 4442;
184:      KH = 2053;
185:      KH = 5452;
186:      KH = 554B;
187:      KH = 5455;
188:      KH = 522C;
189:      KH = 2044;
190:      KH = 422D;
191:      KH = 4E93;
192:      KH = 6E17;
193:      KH = 2044;
194:      KH = 4220;
195:      KH = 5354;
196:      KH = 5255;
197:      KH = 4B54;
198:      KH = 5552;
199:      KH = 2C20;
200:      KH = 4442;
201:      KH = 2D4E;
202:      KH = 723D;
203:      KH = 3135;
204:      KH = 36FA;
205:      KH = FC63;
206:      KH = FDA3;
207:      KH = 8814;
208:      KH = 2044;
209:      KH = 4220;
210:      KH = 5354;
211:      KH = 5255;
212:      KH = 4B54;
213:      KH = 5552;
214:      KH = 2C20;
215:      KH = 4442;
216:      KH = 2D4E;
217:      KH = 723D;
218:      KH = 5241;
219:      KH = 2D53;
220:      KH = 2C20;
221:      KH = 4442;
```

```
222:      KH = 2D4E;
223:      KH = 723D;
224:      KH = 322C;
225:      KH = 2044;
226:      KH = 422D;
227:      KH = 4E72;
228:      KH = 3D3D;
229:      KH = 0000;
230:      KH = 0000;
231:      KH = 0000;
232:      KH = 0000;
233:      KH = 0000;
234:      KH = 0000;
235:      KH = 00C5;
236:      KH = 64A0;
237:      KH = 8814;
238:      KH = 2044;
239:      KH = 4220;
240:      KH = 5354;
241:      KH = 5255;
242:      KH = 4B54;
243:      KH = 5552;
244:      KH = 2C20;
245:      KH = 4442;
246:      KH = 2D4E;
247:      KH = 723D;
248:      KH = D31C;
249:      KH = 0B55;
250:      KH = 0001;
251:      KH = 9C00;
252:      KH = 5FFD;
253:      KH = C564;
254:      KH = D32C;
255:      KH = 0B55;
256:
```

ANALOG OUTPUT

```
  0:    KH = 0000;
  1:    KH = 0000;
  2:    KG = +1000000+02;                OUTPUT LINE SPEED
  4:    KG = +0000000+00;                LOOP CALANDER
  6:    KG = +1000000+01;                CALANDER COUPL.FACTOR 0.5-2.0
  8:    KG = +0000000+00;                CALANDER +/- COUPL.FACTOR
 10:    KG = +0000000+00;                OUTPUT CALANDER SPEED
 12:    KG = +0000000+00;                OUTPUT CONV. LINEAR CHECK WEIGHT
 14:    KG = +0000000+00;                OUTPUT CONV. CEMENTING DEVICE
 16:    KG = +0000000+00;                OUTPUT COOLING SECTION 1
 18:    KG = +0000000+00;                OUTPUT COOLING SECTION 2
 20:    KG = +0000000+00;                OUTPUT COOLING SECTION 3
 22:    KG = +0000000+00;                OUTPUT COOLING SECTION 4
 24:    KG = +1000000+01;                KNIFE MID.SEP. CO.FACTOR 0.5-2.0
 26:    KG = +0000000+00;                KNIFE MID.SEP. +/- COUPL.FACTOR
 28:    KG = +0000000+00;                OUTPUT KNIFE MIDDLE SEP. DEVICE
 30:    KG = +0000000+00;                OUTPUT FEEDER
 32:    KG = +0000000+00;                OUTPUT KNIFE FEEDER
 34:    KG = +1000000+01;                CAL. FEED.BELT CO.FACTOR 0.5-2.0
 36:    KG = +0000000+00;                CAL. FEED.BELT +/- COUPL.FACTOR
 38:    KG = +0000000+00;                OUTPUT CALANDER FEEDING BELT
 40:    KG = +1000000+01;
 42:    KG = +0000000+00;
 44:    KG = +0000000+00;                OUTPUT CONVEYOR CENTERING 2
 46:    KG = +0000000+00;                SPEED DRAW-OFF-CONVEYOR
 48:    KG = +0000000+00;                SPEED CONV. LINEAR CHECK WEIGHER
 50:    KG = +0000000+00;                SPEED CONVEYOR CEMENTING 2
 52:    KG = +0000000+00;                SPEED COOLING SECTION 1
 54:    KG = +0000000+00;                SPEED COOLING SECTION 2
 56:    KG = +0000000+00;                SPEED COOLING SECTION 3
 58:    KG = +0000000+00;                SPEED COOLING SECTION 4
 60:    KG = +0000000+00;
 62:    KG = +0000000+00;
 64:    KG = +0000000+00;
 66:    KG = +0000000+00;
 68:    KG = +0000000+00;
 70:    KG = +0000000+00;
 72:    KG = +0000000+00;
 74:    KG = +0000000+00;
 76:    KG = +0000000+00;
 78:    KG = +0000000+00;
 80:    KG = +0000000+00;
 82:    KG = +0000000+00;
 84:    KG = +0000000+00;
 86:    KG = +0000000+00;
 88:    KG = +0000000+00;
 90:    KG = +0000000+00;
 92:    KG = +0000000+00;
 94:    KG = +0000000+00;
 96:    KG = +0000000+00;
 98:    KG = +0000000+00;
100:    KG = +0000000+00;
102:    KG = +0000000+00;
104:    KG = +0000000+00;
106:    KG = +0000000+00;
108:    KG = +0000000+00;
110:    KG = +0000000+00;
112:    KG = +0000000+00;
114:    KG = +0000000+00;
116:    KG = +0000000+00;
118:    KG = +0000000+00;
120:    KG = +0000000+00;
122:    KG = +0000000+00;
124:    KG = +0000000+00;
126:    KG = +0000000+00;
128:    KG = +0000000+00;
130:    KG = +0000000+00;
132:    KG = +0000000+00;
134:    KG = +0000000+00;
136:    KG = +0000000+00;
138:    KG = +0000000+00;
140:    KG = +0000000+00;
142:    KG = +0000000+00;
144:    KG = +0000000+00;
```

ANALOG OUTPUT

```
146:     KG = +0000000+00;
148:     KG = +0000000+00;
150:     KG = +0000000+00;
152:     KG = +0000000+00;
154:     KG = +0000000+00;
156:     KG = +0000000+00;
158:     KG = +0000000+00;
160:     KG = +0000000+00;
162:     KG = +0000000+00;
164:     KG = +0000000+00;
166:     KG = +0000000+00;
168:     KG = +0000000+00;
170:     KG = +0000000+00;
172:     KG = +0000000+00;
174:     KG = +0000000+00;
176:     KG = +0000000+00;
178:     KG = +0000000+00;
180:     KG = +0000000+00;
182:     KG = +0000000+00;
184:     KG = +0000000+00;
186:     KG = +0000000+00;
188:     KG = +0000000+00;
190:     KG = +0000000+00;
192:     KG = +0000000+00;
194:     KG = +0000000+00;
196:     KG = +0000000+00;
198:     KG = +0000000+00;
200:     KG = +0000000+00;
202:     KG = +0000000+00;
204:     KG = +0000000+00;
206:     KG = +0000000+00;
208:
```

ORIGINAL PROFILE !!!!!

```
  74:     KH = 0000;    PRESET TEMP. UPPER EXTR. SCREW
  75:     KH = 0000;    MIN TEMP. UPPER EXTR. SCREW
  76:     KH = 0000;    PRESET TEMP. UPPER EXTR. BARREL
  77:     KH = 0000;    MIN TEMP. UPPER EXTR. BARREL
  78:     KH = 0000;    PRESET TEMP. BOTTOM EXTR. SCREW
  79:     KH = 0000;    MIN TEMP. BOTTOM EXTR. SCREW
  80:     KH = 0000;    PRESET TEMP. BOTTOM EXTR. BARREL
  81:     KH = 0000;    MIN TEMP. BOTTOM EXTR. BARREL
  82:     KH = 0000;    PRESET TEMP. EXTR. CALANDER HEAD
  83:     KH = 0000;    MIN TEMP. EXTR. CALANDER HEAD
  84:     KH = 0000;    PRESET TEMP. EXTR. CAL. SCREW
  85:     KH = 0000;    MIN TEMP. EXTR. CALANDER SCREW
  86:     KH = 0000;    PRESET TEMP. EXTR. CAL. PIN/BAR.
  87:     KH = 0000;    MIN TEMP. EXTR. CAL. PIN/BARREL
  88:     KH = 0000;    PRESET TEMP. HEAD UPPER PART
  89:     KH = 0000;    MIN TEMP. HEAD UPPER PART
  90:     KH = 0000;    PRESET TEMP. HEAD MIDDLE PART
  91:     KH = 0000;    MIN TEMP. HEAD MIDDLE PART
  92:     KH = 0000;    PRESET TEMP. CASSETTE LEFT
  93:     KH = 0000;    MIN TEMP. CASSETTE LEFT
  94:     KH = 0000;    PRESET TEMP. CASSETTE RIGHT
  95:     KH = 0000;    MIN TEMP. CASSETTE RIGHT
  96:     KH = 0000;    PRESET TEMP. CALENDER ROLL TOP
  97:     KH = 0000;    MIN TEMP CALANDER ROLL TOP
  98:     KH = 0000;    PRESET TEMP. CALENDER ROLL BOTT.
  99:     KH = 0000;    MIN TEMP. CALANDER ROLL BOTTOM
 100:     KH = 0000;    TREAD LENGTH
 101:     KH = 0000;    MIN TEMP. PREHEATING TABLE
 102:     KH = 8000;    TREAD WIDTH
 103:     KH = 0000;
 104:     KH = 0000;    PRESET TEMP. PREHEATING TABLE
 105:     KH = 0000;
 106:
```

PROFILE No.1

```
 0:    KH = 0000;
 1:    KH = 0100;                    PROFILE-No. A /ACTUAL(YES,NO)
 2:    KH = 4D2E;                    PRODUCER
 3:    KH = 482E;
 4:    KH = 5A41;
 5:    KH = 5245;
 6:    KH = 492E;
 7:    KH = 2E2E;
 8:    KH = 2E2E;
 9:    KH = 2E2E;
10:    KH = 0000;
11:    KH = 0000;
12:    KH = 0000;
13:    KH = 0000;
14:    KH = 3138;                    DATE
15:    KH = 3033;                    MONTH
16:    KH = 3732;                    YEAR
17:    KH = 0000;                    SPARE
18:    KH = 0478;                    UPPER EXTRUDER SPEED
19:    KH = 0000;
20:    KH = 0864;                    UPPER EXTRUDER CURRENT
21:    KH = 0000;
22:    KH = 0568;                    BOTTOM EXTRUDER SPEED
23:    KH = 0000;
24:    KH = 0864;                    BOTTOM EXTRUDER CURRENT
25:    KH = 0000;
26:    KH = 0340;                    EXTRUDER CALENDER SPEED
27:    KH = 0000;
28:    KH = 0550;                    EXTRUDER CALENDER CURRENT
29:    KH = 0000;
30:    KH = 0100;                    PROFILE-No. PART B /
31:    KH = 0100;                    PROFILE-No. PART C /
32:    KH = 8000;
33:    KH = 0000;
34:    KH = 087D;                    UP.EXTR. MAX FLOW PR.(WARNING
35:    KH = 0000;
36:    KH = 0955;                    UP.EXTR. MAX FLOW PR.(TURN OFF)
37:    KH = 0000;
38:    KH = 8000;
39:    KH = 0000;
40:    KH = 8000;
41:    KH = 0000;
42:    KH = 087D;                    BOT.EXTR. MAX FLOW PR.(WARNING)
43:    KH = 0000;
44:    KH = 0955;                    BOT.EXTR. MAX FLOW PR.(TURN OFF)
45:    KH = 0000;
46:    KH = 8000;
47:    KH = 0000;
48:    KH = 8000;
49:    KH = 0000;
50:    KH = 8000;
51:    KH = 0000;
52:    KH = 8000;
53:    KH = 0000;
54:    KH = 8000;
55:    KH = 0000;
56:    KH = 8000;
57:    KH = 0000;
58:    KH = 8000;
59:    KH = 0000;
60:    KH = 8000;
61:    KH = 0000;
62:    KH = 0450;                    LINE SPEED
63:    KH = 0000;
64:    KH = 0248;                    LINEAR WEIGHT
65:    KH = 0000;
66:    KH = FE47;                    LINEAR WEIGHT (TOLERANCE)
67:    KH = AE14;
68:    KH = 5923;                    BOOKING (Y:BOOKING N:WIND UP)
69:    KH = 0000;                    SPARE
70:    KH = 034D;                    TREAD WEIGHT
71:    KH = C28F;
72:    KH = FE70;                    TREAD WEIGHT (TOLERANCE)
73:    KH = A3D7;
```

PROFILE No.1

```
 74:     KH = 0028;                    PRESET TEMP. UPPER EXTR. SCREW
 75:     KH = 001E;                    MIN TEMP. UPPER EXTR. SCREW
 76:     KH = 0050;                    PRESET TEMP. UPPER EXTR. BARREL
 77:     KH = 0046;                    MIN TEMP. UPPER EXTR. BARREL
 78:     KH = 0061;                    PRESET TEMP. BOTTOM EXTR. SCREW
 79:     KH = 005A;                    MIN TEMP. BOTTOM EXTR. SCREW
 80:     KH = 0050;                    PRESET TEMP. BOTTOM EXTR. BARREL
 81:     KH = 0046;                    MIN TEMP. BOTTOM EXTR. BARREL
 82:     KH = 005F;                    PRESET TEMP. EXTR. CALANDER HEAD
 83:     KH = 005A;                    MIN TEMP. EXTR. CALANDER HEAD
 84:     KH = 0061;                    PRESET TEMP. EXTR. CAL. SCREW
 85:     KH = 005A;                    MIN TEMP. EXTR. CALANDER SCREW
 86:     KH = 0062;                    PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:     KH = 005A;                    MIN TEMP. EXTR. CAL. PIN/BARREL
 88:     KH = 005F;                    PRESET TEMP. HEAD UPPER PART
 89:     KH = 005A;                    MIN TEMP. HEAD UPPER PART
 90:     KH = 005F;                    PRESET TEMP. HEAD MIDDLE PART
 91:     KH = 005A;                    MIN TEMP. HEAD MIDDLE PART
 92:     KH = 003C;                    PRESET TEMP. CASSETTE LEFT
 93:     KH = 0028;                    MIN TEMP. CASSETTE LEFT
 94:     KH = 003C;                    PRESET TEMP. CASSETTE RIGHT
 95:     KH = 0028;                    MIN TEMP. CASSETTE RIGHT
 96:     KH = 005F;                    PRESET TEMP. CALENDER ROLL TOP
 97:     KH = 005A;                    MIN TEMP CALANDER ROLL TOP
 98:     KH = 0050;                    PRESET TEMP. CALENDER ROLL BOTT.
 99:     KH = 004B;                    MIN TEMP. CALANDER ROLL BOTTOM
100:     KH = 0834;                    TREAD LENGTH
101:     KH = 0028;                    MIN TEMP. PREHEATING TABLE
102:     KH = 0000;                    STRIP WIDTH
103:     KH = 0000;
104:     KH = 003C;                    PRESET TEMP. PREHEATING TABLE
105:     KH = 0000;
106:
```

DB102 C:KERM06ST.S5D BIB=11022 LAE=111 /4

PROFILE No.2

```
 0:    KH = 0000;
 1:    KH = 0200;                    PROFILE-No. A /ACTUAL(YES,NO)
 2:    KH = 4D2E;                    PRODUCER
 3:    KH = 482E;
 4:    KH = 5A41;
 5:    KH = 5245;
 6:    KH = 492E;
 7:    KH = 2E2E;
 8:    KH = 2E2E;
 9:    KH = 2E2E;
10:    KH = 0000;
11:    KH = 0000;
12:    KH = 0000;
13:    KH = 0000;
14:    KH = 3139;                    DATE
15:    KH = 3033;                    MONTH
16:    KH = 3732;                    YEAR
17:    KH = 0000;                    SPARE
18:    KH = 0478;                    UPPER EXTRUDER SPEED
19:    KH = 0000;
20:    KH = 0864;                    UPPER EXTRUDER CURRENT
21:    KH = 0000;
22:    KH = 0558;                    BOTTOM EXTRUDER SPEED
23:    KH = 0000;
24:    KH = 0864;                    BOTTOM EXTRUDER CURRENT
25:    KH = 0000;
26:    KH = 064E;                    EXTRUDER CALENDER SPEED
27:    KH = 0000;
28:    KH = 0550;                    EXTRUDER CALENDER CURRENT
29:    KH = 0000;
30:    KH = 0200;                    PROFILE-No. PART B /
31:    KH = 0200;                    PROFILE-No. PART C /
32:    KH = 8000;
33:    KH = 0000;
34:    KH = 087D;                    UP.EXTR. MAX FLOW PR.(WARNING)
35:    KH = 0000;
36:    KH = 0955;                    UP.EXTR. MAX FLOW PR.(TURN OFF)
37:    KH = 0000;
38:    KH = 8000;
39:    KH = 0000;
40:    KH = 8000;
41:    KH = 0000;
42:    KH = 087D;                    BOT.EXTR. MAX FLOW PR.(WARNING)
43:    KH = 0000;
44:    KH = 0955;                    BOT.EXTR. MAX FLOW PR.(TURN OFF)
45:    KH = 0000;
46:    KH = 8000;
47:    KH = 0000;
48:    KH = 8000;
49:    KH = 0000;
50:    KH = 8000;
51:    KH = 0000;
52:    KH = 8000;
53:    KH = 0000;
54:    KH = 8000;
55:    KH = 0000;
56:    KH = 8000;
57:    KH = 0000;
58:    KH = 8000;
59:    KH = 0000;
60:    KH = 8000;
61:    KH = 0000;
62:    KH = 0444;                    LINE SPEED
63:    KH = CCCD;
64:    KH = 0244;                    LINEAR WEIGHT
65:    KH = CCCD;
66:    KH = FE42;                    LINEAR WEIGHT (TOLERANCE)
67:    KH = 8F5C;
68:    KH = 5923;                    BOOKING (Y:BOOKING N:WIND UP)
69:    KH = 0000;                    SPARE
70:    KH = 0356;                    TREAD WEIGHT
71:    KH = B852;
72:    KH = FF4C;                    TREAD WEIGHT (TOLERANCE)
73:    KH = CCCD;
```

KRUPP KUNSTOFFTECHNIK ELASTOMERTECHNIK WERK HARBURG	MASTERPROGRAMM	
PROJECT : KERMAN TIRE	DATE :	
INSTALLATION : TREAD-LINE	MODIFICATION:	PGNO
PROJECT POS. NO.: 84/823804	PROGRAMMER :	1

PROFILE No.2

```
 74:     KH = 0028;                    PRESET TEMP. UPPER EXTR. SCREW
 75:     KH = 001E;                    MIN TEMP. UPPER EXTR. SCREW
 76:     KH = 0050;                    PRESET TEMP. UPPER EXTR. BARREL
 77:     KH = 0046;                    MIN TEMP. UPPER EXTR. BARREL
 78:     KH = 0028;                    PRESET TEMP. BOTTOM EXTR. SCREW
 79:     KH = 001E;                    MIN TEMP. BOTTOM EXTR. SCREW
 80:     KH = 0050;                    PRESET TEMP. BOTTOM EXTR. BARREL
 81:     KH = 0046;                    MIN TEMP. BOTTOM EXTR. BARREL
 82:     KH = 005F;                    PRESET TEMP. EXTR. CALANDER HEAD
 83:     KH = 005A;                    MIN TEMP. EXTR. CALANDER HEAD
 84:     KH = 0061;                    PRESET TEMP. EXTR. CAL. SCREW
 85:     KH = 005A;                    MIN TEMP. EXTR. CALANDER SCREW
 86:     KH = 0062;                    PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:     KH = 005A;                    MIN TEMP. EXTR. CAL. PIN/BARREL
 88:     KH = 005F;                    PRESET TEMP. HEAD UPPER PART
 89:     KH = 005A;                    MIN TEMP. HEAD UPPER PART
 90:     KH = 005F;                    PRESET TEMP. HEAD MIDDLE PART
 91:     KH = 005A;                    MIN TEMP. HEAD MIDDLE PART
 92:     KH = 003C;                    PRESET TEMP. CASSETTE LEFT
 93:     KH = 0028;                    MIN TEMP. CASSETTE LEFT
 94:     KH = 003C;                    PRESET TEMP. CASSETTE RIGHT
 95:     KH = 0028;                    MIN TEMP. CASSETTE RIGHT
 96:     KH = 005F;                    PRESET TEMP. CALENDER ROLL TOP
 97:     KH = 005A;                    MIN TEMP CALANDER ROLL TOP
 98:     KH = 0050;                    PRESET TEMP. CALENDER ROLL BOTT.
 99:     KH = 004B;                    MIN TEMP. CALANDER ROLL BOTTOM
100:     KH = 09B0;                    TREAD LENGTH
101:     KH = 0028;                    MIN TEMP. PREHEATING TABLE
102:     KH = 0A41;                    STRIP WIDTH
103:     KH = 0000;
104:     KH = 003C;                    PRESET TEMP. PREHEATING TABLE
105:     KH = 0000;
106:
```

PROFILE No.3

```
 0:    KH = 0000;
 1:    KH = 0300;                    PROFILE-No. A /ACTUAL(YES,NO)
 2:    KH = 4D2E;                    PRODUCER
 3:    KH = 482E;
 4:    KH = 5A41;
 5:    KH = 5245;
 6:    KH = 492E;
 7:    KH = 2E2E;
 8:    KH = 2E2E;
 9:    KH = 2E2E;
10:    KH = 0000;
11:    KH = 0000;
12:    KH = 0000;
13:    KH = 0000;
14:    KH = 3138;                    DATE
15:    KH = 3033;                    MONTH
16:    KH = 3732;                    YEAR
17:    KH = 0000;                    SPARE
18:    KH = 0650;                    UPPER EXTRUDER SPEED
19:    KH = 0000;
20:    KH = 087D;                    UPPER EXTRUDER CURRENT
21:    KH = 0000;
22:    KH = 0654;                    BOTTOM EXTRUDER SPEED
23:    KH = 0000;
24:    KH = 087D;                    BOTTOM EXTRUDER CURRENT
25:    KH = 0000;
26:    KH = 0650;                    EXTRUDER CALENDER SPEED
27:    KH = 0000;
28:    KH = 076E;                    EXTRUDER CALENDER CURRENT
29:    KH = 0000;
30:    KH = 0300;                    PROFILE-No. PART B /
31:    KH = 0300;                    PROFILE-No. PART C /
32:    KH = 8000;
33:    KH = 0000;
34:    KH = 087D;                    UP.EXTR. MAX FLOW PR.(WARNING)
35:    KH = 0000;
36:    KH = 0955;                    UP.EXTR. MAX FLOW PR.(TURN OFF)
37:    KH = 0000;
38:    KH = 8000;
39:    KH = 0000;
40:    KH = 8000;
41:    KH = 0000;
42:    KH = 087D;                    BOT.EXTR. MAX FLOW PR.(WARNING)
43:    KH = 0000;
44:    KH = 0955;                    BOT.EXTR. MAX FLOW PR.(TURN OFF)
45:    KH = 0000;
46:    KH = 8000;
47:    KH = 0000;
48:    KH = 8000;
49:    KH = 0000;
50:    KH = 8000;
51:    KH = 0000;
52:    KH = 8000;
53:    KH = 0000;
54:    KH = 8000;
55:    KH = 0000;
56:    KH = 8000;
57:    KH = 0000;
58:    KH = 8000;
59:    KH = 0000;
60:    KH = 8000;
61:    KH = 0000;
62:    KH = 044E;                    LINE SPEED
63:    KH = 6666;
64:    KH = 0451;                    LINEAR WEIGHT
65:    KH = 999A;
66:    KH = FF70;                    LINEAR WEIGHT (TOLERANCE)
67:    KH = A3D7;
68:    KH = 5923;                    BOOKING (Y:BOOKING N:WIND UP)
69:    KH = 0000;                    SPARE
70:    KH = 0572;                    TREAD WEIGHT
71:    KH = E148;
72:    KH = 0057;                    TREAD WEIGHT (TOLERANCE)
73:    KH = 0A3D;
```

PROFILE No.3

```
 74:     KH = 0028;                    PRESET TEMP. UPPER EXTR. SCREW
 75:     KH = 001E;                    MIN TEMP. UPPER EXTR. SCREW
 76:     KH = 0050;                    PRESET TEMP. UPPER EXTR. BARREL
 77:     KH = 0046;                    MIN TEMP. UPPER EXTR. BARREL
 78:     KH = 0028;                    PRESET TEMP. BOTTOM EXTR. SCREW
 79:     KH = 001E;                    MIN TEMP. BOTTOM EXTR. SCREW
 80:     KH = 0050;                    PRESET TEMP. BOTTOM EXTR. BARREL
 81:     KH = 0046;                    MIN TEMP. BOTTOM EXTR. BARREL
 82:     KH = 0062;                    PRESET TEMP. EXTR. CALANDER HEAD
 83:     KH = 005A;                    MIN TEMP. EXTR. CALANDER HEAD
 84:     KH = 0061;                    PRESET TEMP. EXTR. CAL. SCREW
 85:     KH = 005A;                    MIN TEMP. EXTR. CALANDER SCREW
 86:     KH = 0062;                    PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:     KH = 005A;                    MIN TEMP. EXTR. CAL. PIN/BARREL
 88:     KH = 005F;                    PRESET TEMP. HEAD UPPER PART
 89:     KH = 005A;                    MIN TEMP. HEAD UPPER PART
 90:     KH = 005F;                    PRESET TEMP. HEAD MIDDLE PART
 91:     KH = 005A;                    MIN TEMP. HEAD MIDDLE PART
 92:     KH = 003C;                    PRESET TEMP. CASSETTE LEFT
 93:     KH = 0028;                    MIN TEMP. CASSETTE LEFT
 94:     KH = 003C;                    PRESET TEMP. CASSETTE RIGHT
 95:     KH = 0028;                    MIN TEMP. CASSETTE RIGHT
 96:     KH = 005F;                    PRESET TEMP. CALENDER ROLL TOP
 97:     KH = 005A;                    MIN TEMP CALANDER ROLL TOP
 98:     KH = 0055;                    PRESET TEMP. CALENDER ROLL BOTT.
 99:     KH = 004B;                    MIN TEMP. CALANDER ROLL BOTTOM
100:     KH = 0A55;                    TREAD LENGTH
101:     KH = 0028;                    MIN TEMP. PREHEATING TABLE
102:     KH = 0978;                    STRIP WIDTH
103:     KH = 8000;
104:     KH = 0032;                    PRESET TEMP. PREHEATING TABLE
105:     KH = 0000;
106:
```

DB104 C:KERM06ST.S5D BIB=11022 LAE=111 /4

PROFILE No.4

```
 0:    KH = 0000;
 1:    KH = 0400;   PROFILE-No. A /ACTUAL(YES,NO)
 2:    KH = 4D2E;   PRODUCER
 3:    KH = 482E;
 4:    KH = 5A41;
 5:    KH = 5245;
 6:    KH = 492E;
 7:    KH = 2E2E;
 8:    KH = 2E2E;
 9:    KH = 2E2E;
10:    KH = 0000;
11:    KH = 0000;
12:    KH = 0000;
13:    KH = 0000;
14:    KH = 3138;   DATE
15:    KH = 3033;   MONTH
16:    KH = 3732;   YEAR
17:    KH = 0000;   SPARE
18:    KH = 0650;   UPPER EXTRUDER SPEED
19:    KH = 0000;
20:    KH = 087D;   UPPER EXTRUDER CURRENT
21:    KH = 0000;
22:    KH = 0658;   BOTTOM EXTRUDER SPEED
23:    KH = 0000;
24:    KH = 087D;   BOTTOM EXTRUDER CURRENT
25:    KH = 0000;
26:    KH = 0646;   EXTRUDER CALENDER SPEED
27:    KH = 0000;
28:    KH = 076E;   EXTRUDER CALENDER CURRENT
29:    KH = 0000;
30:    KH = 0400;   PROFILE-No. PART B /
31:    KH = 0400;   PROFILE-No. PART C /
32:    KH = 8000;
33:    KH = 0000;
34:    KH = 087D;   UP.EXTR. MAX FLOW PR.(WARNING)
35:    KH = 0000;
36:    KH = 0955;   UP.EXTR. MAX FLOW PR.(TURN OFF)
37:    KH = 0000;
38:    KH = 8000;
39:    KH = 0000;
40:    KH = 8000;
41:    KH = 0000;
42:    KH = 087D;   BOT.EXTR. MAX FLOW PR.(WARNING)
43:    KH = 0000;
44:    KH = 0955;   BOT.EXTR. MAX FLOW PR.(TURN OFF)
45:    KH = 0000;
46:    KH = 8000;
47:    KH = 0000;
48:    KH = 8000;
49:    KH = 0000;
50:    KH = 8000;
51:    KH = 0000;
52:    KH = 8000;
53:    KH = 0000;
54:    KH = 8000;
55:    KH = 0000;
56:    KH = 8000;
57:    KH = 0000;
58:    KH = 8000;
59:    KH = 0000;
60:    KH = 8000;
61:    KH = 0000;
62:    KH = 0442;   LINE SPEED
63:    KH = 6666;
64:    KH = 0457;   LINEAR WEIGHT
65:    KH = 5C29;
66:    KH = FF70;   LINEAR WEIGHT (TOLERANCE)
67:    KH = A3D7;
68:    KH = 5923;   BOOKING (Y:BOOKING N:WIND UP)
69:    KH = 0000;   SPARE
70:    KH = 057A;   TREAD WEIGHT
71:    KH = 147B;
72:    KH = 0059;   TREAD WEIGHT (TOLERANCE)
73:    KH = 999A;
```

PROFILE No.4

```
 74:     KH = 0028;                    PRESET TEMP. UPPER EXTR. SCREW
 75:     KH = 001E;                    MIN TEMP. UPPER EXTR. SCREW
 76:     KH = 0050;                    PRESET TEMP. UPPER EXTR. BARREL
 77:     KH = 0046;                    MIN TEMP. UPPER EXTR. BARREL
 78:     KH = 0028;                    PRESET TEMP. BOTTOM EXTR. SCREW
 79:     KH = 001E;                    MIN TEMP. BOTTOM EXTR. SCREW
 80:     KH = 0050;                    PRESET TEMP. BOTTOM EXTR. BARREL
 81:     KH = 0046;                    MIN TEMP. BOTTOM EXTR. BARREL
 82:     KH = 0062;                    PRESET TEMP. EXTR. CALANDER HEAD
 83:     KH = 005A;                    MIN TEMP. EXTR. CALANDER HEAD
 84:     KH = 0061;                    PRESET TEMP. EXTR. CAL. SCREW
 85:     KH = 005A;                    MIN TEMP. EXTR. CALANDER SCREW
 86:     KH = 0062;                    PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:     KH = 005A;                    MIN TEMP. EXTR. CAL. PIN/BARREL
 88:     KH = 005F;                    PRESET TEMP. HEAD UPPER PART
 89:     KH = 005A;                    MIN TEMP. HEAD UPPER PART
 90:     KH = 005F;                    PRESET TEMP. HEAD MIDDLE PART
 91:     KH = 005A;                    MIN TEMP. HEAD MIDDLE PART
 92:     KH = 003C;                    PRESET TEMP. CASSETTE LEFT
 93:     KH = 0032;                    MIN TEMP. CASSETTE LEFT
 94:     KH = 003C;                    PRESET TEMP. CASSETTE RIGHT
 95:     KH = 0032;                    MIN TEMP. CASSETTE RIGHT
 96:     KH = 005F;                    PRESET TEMP. CALENDER ROLL TOP
 97:     KH = 005A;                    MIN TEMP CALANDER ROLL TOP
 98:     KH = 0055;                    PRESET TEMP. CALENDER ROLL BOTT.
 99:     KH = 004B;                    MIN TEMP. CALANDER ROLL BOTTOM
100:     KH = 0A55;                    TREAD LENGTH
101:     KH = 0028;                    MIN TEMP. PREHEATING TABLE
102:     KH = 097B;                    STRIP WIDTH
103:     KH = 0000;
104:     KH = 0032;                    PRESET TEMP. PREHEATING TABLE
105:     KH = 0000;
106:
```

PROFILE No.5

```
 0:    KH = 0000;
 1:    KH = 0500;                    PROFILE-No. A /ACTUAL(YES,NO)
 2:    KH = 4D2E;                    PRODUCER
 3:    KH = 482E;
 4:    KH = 5A41;
 5:    KH = 5245;
 6:    KH = 492E;
 7:    KH = 2E2E;
 8:    KH = 2E2E;
 9:    KH = 2E2E;
10:    KH = 0000;
11:    KH = 0000;
12:    KH = 0000;
13:    KH = 0000;
14:    KH = 3139;                    DATE
15:    KH = 3033;                    MONTH
16:    KH = 3732;                    YEAR
17:    KH = 0000;                    SPARE
18:    KH = 0646;                    UPPER EXTRUDER SPEED
19:    KH = 0000;
20:    KH = 087D;                    UPPER EXTRUDER CURRENT
21:    KH = 0000;
22:    KH = 0574;                    BOTTOM EXTRUDER SPEED
23:    KH = 0000;
24:    KH = 087D;                    BOTTOM EXTRUDER CURRENT
25:    KH = 0000;
26:    KH = 0646;                    EXTRUDER CALENDER SPEED
27:    KH = 0000;
28:    KH = 076E;                    EXTRUDER CALENDER CURRENT
29:    KH = 0000;
30:    KH = 0500;                    PROFILE-No. PART B /
31:    KH = 0500;                    PROFILE-No. PART C /
32:    KH = 8000;
33:    KH = 0000;
34:    KH = 084B;                    UP.EXTR. MAX FLOW PR.(WARNING)
35:    KH = 0000;
36:    KH = 0864;                    UP.EXTR. MAX FLOW PR.(TURN OFF)
37:    KH = 0000;
38:    KH = 8000;
39:    KH = 0000;
40:    KH = 8000;
41:    KH = 0000;
42:    KH = 084B;                    BOT.EXTR. MAX FLOW PR.(WARNING)
43:    KH = 0000;
44:    KH = 0864;                    BOT.EXTR. MAX FLOW PR.(TURN OFF)
45:    KH = 0000;
46:    KH = 8000;
47:    KH = 0000;
48:    KH = 8000;
49:    KH = 0000;
50:    KH = 8000;
51:    KH = 0000;
52:    KH = 8000;
53:    KH = 0000;
54:    KH = 8000;
55:    KH = 0000;
56:    KH = 8000;
57:    KH = 0000;
58:    KH = 8000;
59:    KH = 0000;
60:    KH = 8000;
61:    KH = 0000;
62:    KH = 0449;                    LINE SPEED
63:    KH = 999A;
64:    KH = 037E;                    LINEAR WEIGHT
65:    KH = 6666;
66:    KH = FF57;                    LINEAR WEIGHT (TOLERANCE)
67:    KH = 0A3D;
68:    KH = 5923;                    BOOKING (Y:BOOKING N:WIND UP)
69:    KH = 0000;                    SPARE
70:    KH = 054A;                    TREAD WEIGHT
71:    KH = CCCD;
72:    KH = 004C;                    TREAD WEIGHT (TOLERANCE)
73:    KH = CCCD;
```

PROFILE No.5

```
 74:     KH = 0028;                    PRESET TEMP. UPPER EXTR. SCREW
 75:     KH = 001E;                    MIN TEMP. UPPER EXTR. SCREW
 76:     KH = 0050;                    PRESET TEMP. UPPER EXTR. BARREL
 77:     KH = 0046;                    MIN TEMP. UPPER EXTR. BARREL
 78:     KH = 0028;                    PRESET TEMP. BOTTOM EXTR. SCREW
 79:     KH = 001E;                    MIN TEMP. BOTTOM EXTR. SCREW
 80:     KH = 0050;                    PRESET TEMP. BOTTOM EXTR. BARREL
 81:     KH = 0046;                    MIN TEMP. BOTTOM EXTR. BARREL
 82:     KH = 0062;                    PRESET TEMP. EXTR. CALANDER HEAD
 83:     KH = 005A;                    MIN TEMP. EXTR. CALANDER HEAD
 84:     KH = 0061;                    PRESET TEMP. EXTR. CAL. SCREW
 85:     KH = 005A;                    MIN TEMP. EXTR. CALANDER SCREW
 86:     KH = 0062;                    PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:     KH = 005A;                    MIN TEMP. EXTR. CAL. PIN/BARREL
 88:     KH = 005F;                    PRESET TEMP. HEAD UPPER PART
 89:     KH = 005A;                    MIN TEMP. HEAD UPPER PART
 90:     KH = 005F;                    PRESET TEMP. HEAD MIDDLE PART
 91:     KH = 005A;                    MIN TEMP. HEAD MIDDLE PART
 92:     KH = 003C;                    PRESET TEMP. CASSETTE LEFT
 93:     KH = 0032;                    MIN TEMP. CASSETTE LEFT
 94:     KH = 003C;                    PRESET TEMP. CASSETTE RIGHT
 95:     KH = 0032;                    MIN TEMP. CASSETTE RIGHT
 96:     KH = 005F;                    PRESET TEMP. CALENDER ROLL TOP
 97:     KH = 005A;                    MIN TEMP CALANDER ROLL TOP
 98:     KH = 0055;                    PRESET TEMP. CALENDER ROLL BOTT.
 99:     KH = 004B;                    MIN TEMP. CALANDER ROLL BOTTOM
100:     KH = 0893;                    TREAD LENGTH
101:     KH = 0028;                    MIN TEMP. PREHEATING TABLE
102:     KH = 0971;                    STRIP WIDTH
103:     KH = 0000;
104:     KH = 0032;                    PRESET TEMP. PREHEATING TABLE
105:     KH = 0000;
106:
```

PROFILE No.6

```
 0:   KH = 0000;
 1:   KH = 0600;                    PROFILE-No. A /ACTUAL(YES,NO)
 2:   KH = 4D2E;                    PRODUCER
 3:   KH = 482E;
 4:   KH = 5A41;
 5:   KH = 5245;
 6:   KH = 492E;
 7:   KH = 2E2E;
 8:   KH = 2E2E;
 9:   KH = 2E2E;
10:   KH = 0000;
11:   KH = 0000;
12:   KH = 0000;
13:   KH = 0000;
14:   KH = 3139;                    DATE
15:   KH = 3320;                    MONTH
16:   KH = 3732;                    YEAR
17:   KH = 0000;                    SPARE
18:   KH = 0652;                    UPPER EXTRUDER SPEED
19:   KH = 0000;
20:   KH = 087D;                    UPPER EXTRUDER CURRENT
21:   KH = 0000;
22:   KH = 0564;                    BOTTOM EXTRUDER SPEED
23:   KH = 0000;
24:   KH = 087D;                    BOTTOM EXTRUDER CURRENT
25:   KH = 0000;
26:   KH = 0646;                    EXTRUDER CALENDER SPEED
27:   KH = 0000;
28:   KH = 076E;                    EXTRUDER CALENDER CURRENT
29:   KH = 0000;
30:   KH = 0600;                    PROFILE-No. PART B /
31:   KH = 0600;                    PROFILE-No. PART C /
32:   KH = 8000;
33:   KH = 0000;
34:   KH = 087D;                    UP.EXTR. MAX FLOW PR.(WARNING)
35:   KH = 0000;
36:   KH = 0955;                    UP.EXTR. MAX FLOW PR.(TURN OFF)
37:   KH = 0000;
38:   KH = 8000;
39:   KH = 0000;
40:   KH = 8000;
41:   KH = 0000;
42:   KH = 087D;                    BOT.EXTR. MAX FLOW PR.(WARNING)
43:   KH = 0000;
44:   KH = 0955;                    BOT.EXTR. MAX FLOW PR.(TURN OFF)
45:   KH = 0000;
46:   KH = 8000;
47:   KH = 0000;
48:   KH = 8000;
49:   KH = 0000;
50:   KH = 8000;
51:   KH = 0000;
52:   KH = 8000;
53:   KH = 0000;
54:   KH = 8000;
55:   KH = 0000;
56:   KH = 8000;
57:   KH = 0000;
58:   KH = 8000;
59:   KH = 0000;
60:   KH = 8000;
61:   KH = 0000;
62:   KH = 0452;                    LINE SPEED
63:   KH = 6666;
64:   KH = 0376;                    LINEAR WEIGHT
65:   KH = 6666;
66:   KH = FF51;                    LINEAR WEIGHT (TOLERANCE)
67:   KH = EB85;
68:   KH = 5923;                    BOOKING (Y:BOOKING N:WIND UP)
69:   KH = 0000;                    SPARE
70:   KH = 0546;                    TREAD WEIGHT
71:   KH = 3333;
72:   KH = 004E;                    TREAD WEIGHT (TOLERANCE)
73:   KH = 147B;
```

PROFILE No.6

```
 74:     KH = 0028;                    PRESET TEMP. UPPER EXTR. SCREW
 75:     KH = 001E;                    MIN TEMP. UPPER EXTR. SCREW
 76:     KH = 0050;                    PRESET TEMP. UPPER EXTR. BARREL
 77:     KH = 0046;                    MIN TEMP. UPPER EXTR. BARREL
 78:     KH = 0028;                    PRESET TEMP. BOTTOM EXTR. SCREW
 79:     KH = 001E;                    MIN TEMP. BOTTOM EXTR. SCREW
 80:     KH = 0050;                    PRESET TEMP. BOTTOM EXTR. BARREL
 81:     KH = 0046;                    MIN TEMP. BOTTOM EXTR. BARREL
 82:     KH = 0062;                    PRESET TEMP. EXTR. CALANDER HEAD
 83:     KH = 005A;                    MIN TEMP. EXTR. CALANDER HEAD
 84:     KH = 0061;                    PRESET TEMP. EXTR. CAL. SCREW
 85:     KH = 005A;                    MIN TEMP. EXTR. CALANDER SCREW
 86:     KH = 0062;                    PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:     KH = 005A;                    MIN TEMP. EXTR. CAL. PIN/BARREL
 88:     KH = 005F;                    PRESET TEMP. HEAD UPPER PART
 89:     KH = 005A;                    MIN TEMP. HEAD UPPER PART
 90:     KH = 005F;                    PRESET TEMP. HEAD MIDDLE PART
 91:     KH = 005A;                    MIN TEMP. HEAD MIDDLE PART
 92:     KH = 003C;                    PRESET TEMP. CASSETTE LEFT
 93:     KH = 0032;                    MIN TEMP. CASSETTE LEFT
 94:     KH = 003C;                    PRESET TEMP. CASSETTE RIGHT
 95:     KH = 0032;                    MIN TEMP. CASSETTE RIGHT
 96:     KH = 005F;                    PRESET TEMP. CALENDER ROLL TOP
 97:     KH = 005A;                    MIN TEMP CALANDER ROLL TOP
 98:     KH = 0055;                    PRESET TEMP. CALENDER ROLL BOTT.
 99:     KH = 004B;                    MIN TEMP. CALANDER ROLL BOTTOM
100:     KH = 08A2;                    TREAD LENGTH
101:     KH = 0028;                    MIN TEMP. PREHEATING TABLE
102:     KH = 0000;                    STRIP WIDTH
103:     KH = 0000;
104:     KH = 0032;                    PRESET TEMP. PREHEATING TABLE
105:     KH = 0000;
106:
```

PROFILE No.7

```
 0:    KH = 0000;
 1:    KH = 0700;                    PROFILE-No. A /ACTUAL(YES,NO)
 2:    KH = 2E2E;                    PRODUCER
 3:    KH = 2E2E;
 4:    KH = 2E2E;
 5:    KH = 2E2E;
 6:    KH = 2E2E;
 7:    KH = 2E2E;
 8:    KH = 2E2E;
 9:    KH = 2E2E;
10:    KH = 0000;
11:    KH = 0000;
12:    KH = 0000;
13:    KH = 0000;
14:    KH = 2E2E;                    DATE
15:    KH = 2E2E;                    MONTH
16:    KH = 2E2E;                    YEAR
17:    KH = 0000;                    SPARE
18:    KH = 8000;                    UPPER EXTRUDER SPEED
19:    KH = 0000;
20:    KH = 8000;                    UPPER EXTRUDER CURRENT
21:    KH = 0000;
22:    KH = 8000;                    BOTTOM EXTRUDER SPEED
23:    KH = 0000;
24:    KH = 8000;                    BOTTOM EXTRUDER CURRENT
25:    KH = 0000;
26:    KH = 8000;                    EXTRUDER CALENDER SPEED
27:    KH = 0000;
28:    KH = 8000;                    EXTRUDER CALENDER CURRENT
29:    KH = 0000;
30:    KH = 0700;                    PROFILE-No. PART B /
31:    KH = 0700;                    PROFILE-No. PART C /
32:    KH = 8000;
33:    KH = 0000;
34:    KH = 8000;                    UP.EXTR. MAX FLOW PR.(WARNING)
35:    KH = 0000;
36:    KH = 8000;                    UP.EXTR. MAX FLOW PR.(TURN OFF)
37:    KH = 0000;
38:    KH = 8000;
39:    KH = 0000;
40:    KH = 8000;
41:    KH = 0000;
42:    KH = 8000;                    BOT.EXTR. MAX FLOW PR.(WARNING)
43:    KH = 0000;
44:    KH = 8000;                    BOT.EXTR. MAX FLOW PR.(TURN OFF)
45:    KH = 0000;
46:    KH = 8000;
47:    KH = 0000;
48:    KH = 8000;
49:    KH = 0000;
50:    KH = 8000;
51:    KH = 0000;
52:    KH = 8000;
53:    KH = 0000;
54:    KH = 8000;
55:    KH = 0000;
56:    KH = 8000;
57:    KH = 0000;
58:    KH = 8000;
59:    KH = 0000;
60:    KH = 8000;
61:    KH = 0000;
62:    KH = 8000;                    LINE SPEED
63:    KH = 0000;
64:    KH = 8000;                    LINEAR WEIGHT
65:    KH = 0000;
66:    KH = 8000;                    LINEAR WEIGHT (TOLERANCE)
67:    KH = 0000;
68:    KH = 5923;                    BOOKING (Y:BOOKING N:WIND UP)
69:    KH = 0000;                    SPARE
70:    KH = 8000;                    TREAD WEIGHT
71:    KH = 0000;
72:    KH = 8000;                    TREAD WEIGHT (TOLERANCE)
73:    KH = 0000;
```

```
KH = 0000;                    PRESET TEMP. UPPER EXTR. SCREW
KH = 0000;                    MIN TEMP. UPPER EXTR. SCREW
KH = 0000;                    PRESET TEMP. UPPER EXTR. BARREL
KH = 0000;                    MIN TEMP. UPPER EXTR. BARREL
KH = 0000;                    PRESET TEMP. BOTTOM EXTR. SCREW
KH = 0000;                    MIN TEMP. BOTTOM EXTR. SCREW
KH = 0000;                    PRESET TEMP. BOTTOM EXTR. BARREL
KH = 0000;                    MIN TEMP. BOTTOM EXTR. BARREL
KH = 0000;                    PRESET TEMP. EXTR. CALANDER HEAD
KH = 0000;                    MIN TEMP. EXTR. CALANDER HEAD
KH = 0000;                    PRESET TEMP. EXTR. CAL. SCREW
KH = 0000;                    MIN TEMP. EXTR. CALANDER SCREW
KH = 0000;                    PRESET TEMP. EXTR. CAL. PIN/BAR.
KH = 0000;                    MIN TEMP. EXTR. CAL. PIN/BARREL
KH = 0000;                    PRESET TEMP. HEAD UPPER PART
KH = 0000;                    MIN TEMP. HEAD UPPER PART
KH = 0000;                    PRESET TEMP. HEAD MIDDLE PART
KH = 0000;                    MIN TEMP. HEAD MIDDLE PART
KH = 0000;                    PRESET TEMP. CASSETTE LEFT
KH = 0000;                    MIN TEMP. CASSETTE LEFT
KH = 0000;                    PRESET TEMP. CASSETTE RIGHT
KH = 0000;                    MIN TEMP. CASSETTE RIGHT
KH = 0000;                    PRESET TEMP. CALENDER ROLL TOP
KH = 0000;                    MIN TEMP CALANDER ROLL TOP
KH = 0000;                    PRESET TEMP. CALENDER ROLL BOTT.
KH = 0000;                    MIN TEMP. CALANDER ROLL BOTTOM
KH = 0000;                    TREAD LENGTH
KH = 0000;                    MIN TEMP. PREHEATING TABLE
KH = 8000;                    STRIP WIDTH
KH = 0000;
KH = 0000;                    PRESET TEMP. PREHEATING TABLE
KH = 0000;
```

PROFILE No.8

```
 0:    KH = 0000;
 1:    KH = 0800;   PROFILE-No. A /ACTUAL(YES,NO)
 2:    KH = 2E2E;   PRODUCER
 3:    KH = 2E2E;
 4:    KH = 2E2E;
 5:    KH = 2E2E;
 6:    KH = 2E2E;
 7:    KH = 2E2E;
 8:    KH = 2E2E;
 9:    KH = 2E2E;
10:    KH = 0000;
11:    KH = 0000;
12:    KH = 0000;
13:    KH = 0000;
14:    KH = 2E2E;   DATE
15:    KH = 2E2E;   MONTH
16:    KH = 2E2E;   YEAR
17:    KH = 0000;   SPARE
18:    KH = 8000;   UPPER EXTRUDER SPEED
19:    KH = 0000;
20:    KH = 8000;   UPPER EXTRUDER CURRENT
21:    KH = 0000;
22:    KH = 8000;   BOTTOM EXTRUDER SPEED
23:    KH = 0000;
24:    KH = 8000;   BOTTOM EXTRUDER CURRENT
25:    KH = 0000;
26:    KH = 8000;   EXTRUDER CALENDER SPEED
27:    KH = 0000;
28:    KH = 8000;   EXTRUDER CALENDER CURRENT
29:    KH = 0000;
30:    KH = 0800;   PROFILE-No. PART B /
31:    KH = 0800;   PROFILE-No. PART C /
32:    KH = 8000;
33:    KH = 0000;
34:    KH = 8000;   UP.EXTR. MAX FLOW PR.(WARNING)
35:    KH = 0000;
36:    KH = 8000;   UP.EXTR. MAX FLOW PR.(TURN OFF)
37:    KH = 0000;
38:    KH = 8000;
39:    KH = 0000;
40:    KH = 8000;
41:    KH = 0000;
42:    KH = 8000;   BOT.EXTR. MAX FLOW PR.(WARNING)
43:    KH = 0000;
44:    KH = 8000;   BOT.EXTR. MAX FLOW PR.(TURN OFF)
45:    KH = 0000;
46:    KH = 8000;
47:    KH = 0000;
48:    KH = 8000;
49:    KH = 0000;
50:    KH = 8000;
51:    KH = 0000;
52:    KH = 8000;
53:    KH = 0000;
54:    KH = 8000;
55:    KH = 0000;
56:    KH = 8000;
57:    KH = 0000;
58:    KH = 8000;
59:    KH = 0000;
60:    KH = 8000;
61:    KH = 0000;
62:    KH = 8000;   LINE SPEED
63:    KH = 0000;
64:    KH = 8000;   LINEAR WEIGHT
65:    KH = 0000;
66:    KH = 8000;   LINEAR WEIGHT (TOLERANCE)
67:    KH = 0000;
68:    KH = 5923;   BOOKING (Y:BOOKING N:WIND UP)
69:    KH = 0000;   SPARE
70:    KH = 8000;   TREAD WEIGHT
71:    KH = 0000;
72:    KH = 8000;   TREAD WEIGHT (TOLERANCE)
73:    KH = 0000;
```

PROFILE No.8

```
 74:     KH = 0000;                    PRESET TEMP. UPPER EXTR. SCREW
 75:     KH = 0000;                    MIN TEMP. UPPER EXTR. SCREW
 76:     KH = 0000;                    PRESET TEMP. UPPER EXTR. BARREL
 77:     KH = 0000;                    MIN TEMP. UPPER EXTR. BARREL
 78:     KH = 0000;                    PRESET TEMP. BOTTOM EXTR. SCREW
 79:     KH = 0000;                    MIN TEMP. BOTTOM EXTR. SCREW
 80:     KH = 0000;                    PRESET TEMP. BOTTOM EXTR. BARREL
 81:     KH = 0000;                    MIN TEMP. BOTTOM EXTR. BARREL
 82:     KH = 0000;                    PRESET TEMP. EXTR. CALANDER HEAD
 83:     KH = 0000;                    MIN TEMP. EXTR. CALANDER HEAD
 84:     KH = 0000;                    PRESET TEMP. EXTR. CAL. SCREW
 85:     KH = 0000;                    MIN TEMP. EXTR. CALANDER SCREW
 86:     KH = 0000;                    PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:     KH = 0000;                    MIN TEMP. EXTR. CAL. PIN/BARREL
 88:     KH = 0000;                    PRESET TEMP. HEAD UPPER PART
 89:     KH = 0000;                    MIN TEMP. HEAD UPPER PART
 90:     KH = 0000;                    PRESET TEMP. HEAD MIDDLE PART
 91:     KH = 0000;                    MIN TEMP. HEAD MIDDLE PART
 92:     KH = 0000;                    PRESET TEMP. CASSETTE LEFT
 93:     KH = 0000;                    MIN TEMP. CASSETTE LEFT
 94:     KH = 0000;                    PRESET TEMP. CASSETTE RIGHT
 95:     KH = 0000;                    MIN TEMP. CASSETTE RIGHT
 96:     KH = 0000;                    PRESET TEMP. CALENDER ROLL TOP
 97:     KH = 0000;                    MIN TEMP CALANDER ROLL TOP
 98:     KH = 0000;                    PRESET TEMP. CALENDER ROLL BOTT.
 99:     KH = 0000;                    MIN TEMP. CALANDER ROLL BOTTOM
100:     KH = 0000;                    TREAD LENGTH
101:     KH = 0000;                    MIN TEMP. PREHEATING TABLE
102:     KH = 8000;                    STRIP WIDTH
103:     KH = 0000;
104:     KH = 0000;                    PRESET TEMP. PREHEATING TABLE
105:     KH = 0000;
106:
```

PROFILE No.9

```
 0:   KH = 0000;
 1:   KH = 0900;                    PROFILE-No. A /ACTUAL(YES,NO)
 2:   KH = 2E2E;                    PRODUCER
 3:   KH = 2E2E;
 4:   KH = 2E2E;
 5:   KH = 2E2E;
 6:   KH = 2E2E;
 7:   KH = 2E2E;
 8:   KH = 2E2E;
 9:   KH = 2E2E;
10:   KH = 0000;
11:   KH = 0000;
12:   KH = 0000;
13:   KH = 0000;
14:   KH = 2E2E;                    DATE
15:   KH = 2E2E;                    MONTH
16:   KH = 2E2E;                    YEAR
17:   KH = 0000;                    SPARE
18:   KH = 8000;                    UPPER EXTRUDER SPEED
19:   KH = 0000;
20:   KH = 8000;                    UPPER EXTRUDER CURRENT
21:   KH = 0000;
22:   KH = 8000;                    BOTTOM EXTRUDER SPEED
23:   KH = 0000;
24:   KH = 8000;                    BOTTOM EXTRUDER CURRENT
25:   KH = 0000;
26:   KH = 8000;                    EXTRUDER CALENDER SPEED
27:   KH = 0000;
28:   KH = 8000;                    EXTRUDER CALENDER CURRENT
29:   KH = 0000;
30:   KH = 0900;                    PROFILE-No. PART B /
31:   KH = 0900;                    PROFILE-No. PART C /
32:   KH = 8000;
33:   KH = 0000;
34:   KH = 8000;                    UP.EXTR. MAX FLOW PR.(WARNING)
35:   KH = 0000;
36:   KH = 8000;                    UP.EXTR. MAX FLOW PR.(TURN OFF)
37:   KH = 0000;
38:   KH = 8000;
39:   KH = 0000;
40:   KH = 8000;
41:   KH = 0000;
42:   KH = 8000;                    BOT.EXTR. MAX FLOW PR.(WARNING)
43:   KH = 0000;
44:   KH = 8000;                    BOT.EXTR. MAX FLOW PR.(TURN OFF)
45:   KH = 0000;
46:   KH = 8000;
47:   KH = 0000;
48:   KH = 8000;
49:   KH = 0000;
50:   KH = 8000;
51:   KH = 0000;
52:   KH = 8000;
53:   KH = 0000;
54:   KH = 8000;
55:   KH = 0000;
56:   KH = 8000;
57:   KH = 0000;
58:   KH = 8000;
59:   KH = 0000;
60:   KH = 8000;
61:   KH = 0000;
62:   KH = 8000;                    LINE SPEED
63:   KH = 0000;
64:   KH = 8000;                    LINEAR WEIGHT
65:   KH = 0000;
66:   KH = 8000;                    LINEAR WEIGHT (TOLERANCE)
67:   KH = 0000;
68:   KH = 5923;                    BOOKING (Y:BOOKING N:WIND UP)
69:   KH = 0000;                    SPARE
70:   KH = 8000;                    TREAD WEIGHT
71:   KH = 0000;
72:   KH = 8000;                    TREAD WEIGHT (TOLERANCE)
73:   KH = 0000;
```

PROFILE No.9

```
 74:     KH = 0000;                    PRESET TEMP. UPPER EXTR. SCREW
 75:     KH = 0000;                    MIN TEMP. UPPER EXTR. SCREW
 76:     KH = 0000;                    PRESET TEMP. UPPER EXTR. BARREL
 77:     KH = 0000;                    MIN TEMP. UPPER EXTR. BARREL
 78:     KH = 0000;                    PRESET TEMP. BOTTOM EXTR. SCREW
 79:     KH = 0000;                    MIN TEMP. BOTTOM EXTR. SCREW
 80:     KH = 0000;                    PRESET TEMP. BOTTOM EXTR. BARREL
 81:     KH = 0000;                    MIN TEMP. BOTTOM EXTR. BARREL
 82:     KH = 0000;                    PRESET TEMP. EXTR. CALANDER HEAD
 83:     KH = 0000;                    MIN TEMP. EXTR. CALANDER HEAD
 84:     KH = 0000;                    PRESET TEMP. EXTR. CAL. SCREW
 85:     KH = 0000;                    MIN TEMP. EXTR. CALANDER SCREW
 86:     KH = 0000;                    PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:     KH = 0000;                    MIN TEMP. EXTR. CAL. PIN/BARREL
 88:     KH = 0000;                    PRESET TEMP. HEAD UPPER PART
 89:     KH = 0000;                    MIN TEMP. HEAD UPPER PART
 90:     KH = 0000;                    PRESET TEMP. HEAD MIDDLE PART
 91:     KH = 0000;                    MIN TEMP. HEAD MIDDLE PART
 92:     KH = 0000;                    PRESET TEMP. CASSETTE LEFT
 93:     KH = 0000;                    MIN TEMP. CASSETTE LEFT
 94:     KH = 0000;                    PRESET TEMP. CASSETTE RIGHT
 95:     KH = 0000;                    MIN TEMP. CASSETTE RIGHT
 96:     KH = 0000;                    PRESET TEMP. CALENDER ROLL TOP
 97:     KH = 0000;                    MIN TEMP CALANDER ROLL TOP
 98:     KH = 0000;                    PRESET TEMP. CALENDER ROLL BOTT.
 99:     KH = 0000;                    MIN TEMP. CALANDER ROLL BOTTOM
100:     KH = 0000;                    TREAD LENGTH
101:     KH = 0000;                    MIN TEMP. PREHEATING TABLE
102:     KH = 8000;                    STRIP WIDTH
103:     KH = 0000;
104:     KH = 0000;                    PRESET TEMP. PREHEATING TABLE
105:     KH = 0000;
106:
```

PROFILE No.10

0:	KH = 0000;	
1:	KH = 0A00;	PROFILE-No. A /ACTUAL(YES,NO)
2:	KH = 2E2E;	PRODUCER
3:	KH = 2E2E;	
4:	KH = 2E2E;	
5:	KH = 2E2E;	
6:	KH = 2E2E;	
7:	KH = 2E2E;	
8:	KH = 2E2E;	
9:	KH = 2E2E;	
10:	KH = 0000;	
11:	KH = 0000;	
12:	KH = 0000;	
13:	KH = 0000;	
14:	KH = 2E2E;	DATE
15:	KH = 2E2E;	MONTH
16:	KH = 2E2E;	YEAR
17:	KH = 0000;	SPARE
18:	KH = 8000;	UPPER EXTRUDER SPEED
19:	KH = 0000;	
20:	KH = 8000;	UPPER EXTRUDER CURRENT
21:	KH = 0000;	
22:	KH = 8000;	BOTTOM EXTRUDER SPEED
23:	KH = 0000;	
24:	KH = 8000;	BOTTOM EXTRUDER CURRENT
25:	KH = 0000;	
26:	KH = 8000;	EXTRUDER CALENDER SPEED
27:	KH = 0000;	
28:	KH = 8000;	EXTRUDER CALENDER CURRENT
29:	KH = 0000;	
30:	KH = 0A00;	PROFILE-No. PART B /
31:	KH = 0A00;	PROFILE-No. PART C /
32:	KH = 8000;	
33:	KH = 0000;	
34:	KH = 8000;	UP.EXTR. MAX FLOW PR.(WARNING)
35:	KH = 0000;	
36:	KH = 8000;	UP.EXTR. MAX FLOW PR.(TURN OFF)
37:	KH = 0000;	
38:	KH = 8000;	
39:	KH = 0000;	
40:	KH = 8000;	
41:	KH = 0000;	
42:	KH = 8000;	BOT.EXTR. MAX FLOW PR.(WARNING)
43:	KH = 0000;	
44:	KH = 8000;	BOT.EXTR. MAX FLOW PR.(TURN OFF)
45:	KH = 0000;	
46:	KH = 8000;	
47:	KH = 0000;	
48:	KH = 8000;	
49:	KH = 0000;	
50:	KH = 8000;	
51:	KH = 0000;	
52:	KH = 8000;	
53:	KH = 0000;	
54:	KH = 8000;	
55:	KH = 0000;	
56:	KH = 8000;	
57:	KH = 0000;	
58:	KH = 8000;	
59:	KH = 0000;	
60:	KH = 8000;	
61:	KH = 0000;	
62:	KH = 8000;	LINE SPEED
63:	KH = 0000;	
64:	KH = 8000;	LINEAR WEIGHT
65:	KH = 0000;	
66:	KH = 8000;	LINEAR WEIGHT (TOLERANCE)
67:	KH = 0000;	
68:	KH = 5923;	BOOKING (Y:BOOKING N:WIND UP)
69:	KH = 0000;	SPARE
70:	KH = 8000;	TREAD WEIGHT
71:	KH = 0000;	
72:	KH = 8000;	TREAD WEIGHT (TOLERANCE)
73:	KH = 0000;	


```
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                      !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                      !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                   PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                     1!
+-------------------------------------------------------------------------------+
```

```
KH = 0000;                    PRESET TEMP. UPPER EXTR. SCREW
KH = 0000;                    MIN TEMP. UPPER EXTR. SCREW
KH = 0000;                    PRESET TEMP. UPPER EXTR. BARREL
KH = 0000;                    MIN TEMP. UPPER EXTR. BARREL
KH = 0000;                    PRESET TEMP. BOTTOM EXTR. SCREW
KH = 0000;                    MIN TEMP. BOTTOM EXTR. SCREW
KH = 0000;                    PRESET TEMP. BOTTOM EXTR. BARREL
KH = 0000;                    MIN TEMP. BOTTOM EXTR. BARREL
KH = 0000;                    PRESET TEMP. EXTR. CALANDER HEAD
KH = 0000;                    MIN TEMP. EXTR. CALANDER HEAD
KH = 0000;                    PRESET TEMP. EXTR. CAL. SCREW
KH = 0000;                    MIN TEMP. EXTR. CALANDER SCREW
KH = 0000;                    PRESET TEMP. EXTR. CAL. PIN/BAR.
KH = 0000;                    MIN TEMP. EXTR. CAL. PIN/BARREL
KH = 0000;                    PRESET TEMP. HEAD UPPER PART
KH = 0000;                    MIN TEMP. HEAD UPPER PART
KH = 0000;                    PRESET TEMP. HEAD MIDDLE PART
KH = 0000;                    MIN TEMP. HEAD MIDDLE PART
KH = 0000;                    PRESET TEMP. CASSETTE LEFT
KH = 0000;                    MIN TEMP. CASSETTE LEFT
KH = 0000;                    PRESET TEMP. CASSETTE RIGHT
KH = 0000;                    MIN TEMP. CASSETTE RIGHT
KH = 0000;                    PRESET TEMP. CALENDER ROLL TOP
KH = 0000;                    MIN TEMP CALANDER ROLL TOP
KH = 0000;                    PRESET TEMP. CALENDER ROLL BOTT.
KH = 0000;                    MIN TEMP. CALANDER ROLL BOTTOM
KH = 0000;                    TREAD LENGTH
KH = 0000;                    MIN TEMP. PREHEATING TABLE
KH = 8000;                    STRIP WIDTH
KH = 0000;
KH = 0000;                    PRESET TEMP. PREHEATING TABLE
KH = 0000;
```

PROFILE No.11

0:	KH = 0000;	
1:	KH = 0B00;	PROFILE-No. A /ACTUAL(YES,NO)
2:	KH = 2E2E;	PRODUCER
3:	KH = 2E2E;	
4:	KH = 2E2E;	
5:	KH = 2E2E;	
6:	KH = 2E2E;	
7:	KH = 2E2E;	
8:	KH = 2E2E;	
9:	KH = 2E2E;	
10:	KH = 0000;	
11:	KH = 0000;	
12:	KH = 0000;	
13:	KH = 0000;	
14:	KH = 2E2E;	DATE
15:	KH = 2E2E;	MONTH
16:	KH = 2E2E;	YEAR
17:	KH = 0000;	SPARE
18:	KH = 8000;	UPPER EXTRUDER SPEED
19:	KH = 0000;	
20:	KH = 8000;	UPPER EXTRUDER CURRENT
21:	KH = 0000;	
22:	KH = 8000;	BOTTOM EXTRUDER SPEED
23:	KH = 0000;	
24:	KH = 8000;	BOTTOM EXTRUDER CURRENT
25:	KH = 0000;	
26:	KH = 8000;	EXTRUDER CALENDER SPEED
27:	KH = 0000;	
28:	KH = 8000;	EXTRUDER CALENDER CURRENT
29:	KH = 0000;	
30:	KH = 0B00;	PROFILE-No. PART B /
31:	KH = 0B00;	PROFILE-No. PART C /
32:	KH = 8000;	
33:	KH = 0000;	
34:	KH = 8000;	UP.EXTR. MAX FLOW PR.(WARNING)
35:	KH = 0000;	
36:	KH = 8000;	UP.EXTR. MAX FLOW PR.(TURN OFF)
37:	KH = 0000;	
38:	KH = 8000;	
39:	KH = 0000;	
40:	KH = 8000;	
41:	KH = 0000;	
42:	KH = 8000;	BOT.EXTR. MAX FLOW PR.(WARNING)
43:	KH = 0000;	
44:	KH = 8000;	BOT.EXTR. MAX FLOW PR.(TURN OFF)
45:	KH = 0000;	
46:	KH = 8000;	
47:	KH = 0000;	
48:	KH = 8000;	
49:	KH = 0000;	
50:	KH = 8000;	
51:	KH = 0000;	
52:	KH = 8000;	
53:	KH = 0000;	
54:	KH = 8000;	
55:	KH = 0000;	
56:	KH = 8000;	
57:	KH = 0000;	
58:	KH = 8000;	
59:	KH = 0000;	
60:	KH = 8000;	
61:	KH = 0000;	
62:	KH = 8000;	LINE SPEED
63:	KH = 0000;	
64:	KH = 8000;	LINEAR WEIGHT
65:	KH = 0000;	
66:	KH = 8000;	LINEAR WEIGHT (TOLERANCE)
67:	KH = 0000;	
68:	KH = 5923;	BOOKING (Y:BOOKING N:WIND UP)
69:	KH = 0000;	SPARE
70:	KH = 8000;	TREAD WEIGHT
71:	KH = 0000;	
72:	KH = 8000;	TREAD WEIGHT (TOLERANCE)
73:	KH = 0000;	

```
KH = 0000;                    PRESET TEMP. UPPER EXTR. SCREW
KH = 0000;                    MIN TEMP. UPPER EXTR. SCREW
KH = 0000;                    PRESET TEMP. UPPER EXTR. BARREL
KH = 0000;                    MIN TEMP. UPPER EXTR. BARREL
KH = 0000;                    PRESET TEMP. BOTTOM EXTR. SCREW
KH = 0000;                    MIN TEMP. BOTTOM EXTR. SCREW
KH = 0000;                    PRESET TEMP. BOTTOM EXTR. BARREL
KH = 0000;                    MIN TEMP. BOTTOM EXTR. BARREL
KH = 0000;                    PRESET TEMP. EXTR. CALANDER HEAD
KH = 0000;                    MIN TEMP. EXTR. CALANDER HEAD
KH = 0000;                    PRESET TEMP. EXTR. CAL. SCREW
KH = 0000;                    MIN TEMP. EXTR. CALANDER SCREW
KH = 0000;                    PRESET TEMP. EXTR. CAL. PIN/BAR.
KH = 0000;                    MIN TEMP. EXTR. CAL. PIN/BARREL
KH = 0000;                    PRESET TEMP. HEAD UPPER PART
KH = 0000;                    MIN TEMP. HEAD UPPER PART
KH = 0000;                    PRESET TEMP. HEAD MIDDLE PART
KH = 0000;                    MIN TEMP. HEAD MIDDLE PART
KH = 0000;                    PRESET TEMP. CASSETTE LEFT
KH = 0000;                    MIN TEMP. CASSETTE LEFT
KH = 0000;                    PRESET TEMP. CASSETTE RIGHT
KH = 0000;                    MIN TEMP. CASSETTE RIGHT
KH = 0000;                    PRESET TEMP. CALENDER ROLL TOP
KH = 0000;                    MIN TEMP CALANDER ROLL TOP
KH = 0000;                    PRESET TEMP. CALENDER ROLL BOTT.
KH = 0000;                    MIN TEMP. CALANDER ROLL BOTTOM
KH = 0000;                    TREAD LENGTH
KH = 0000;                    MIN TEMP. PREHEATING TABLE
KH = 8000;                    STRIP WIDTH
KH = 0000;
KH = 0000;                    PRESET TEMP. PREHEATING TABLE
KH = 0000;
```

PROFILE No.12

0:	KH = 0000;	
1:	KH = 0C00;	PROFILE-No. A /ACTUAL(YES,NO)
2:	KH = 2E2E;	PRODUCER
3:	KH = 2E2E;	
4:	KH = 2E2E;	
5:	KH = 2E2E;	
6:	KH = 2E2E;	
7:	KH = 2E2E;	
8:	KH = 2E2E;	
9:	KH = 2E2E;	
10:	KH = 0000;	
11:	KH = 0000;	
12:	KH = 0000;	
13:	KH = 0000;	
14:	KH = 2E2E;	DATE
15:	KH = 2E2E;	MONTH
16:	KH = 2E2E;	YEAR
17:	KH = 0000;	SPARE
18:	KH = 8000;	UPPER EXTRUDER SPEED
19:	KH = 0000;	
20:	KH = 8000;	UPPER EXTRUDER CURRENT
21:	KH = 0000;	
22:	KH = 8000;	BOTTOM EXTRUDER SPEED
23:	KH = 0000;	
24:	KH = 8000;	BOTTOM EXTRUDER CURRENT
25:	KH = 0000;	
26:	KH = 8000;	EXTRUDER CALENDER SPEED
27:	KH = 0000;	
28:	KH = 8000;	EXTRUDER CALENDER CURRENT
29:	KH = 0000;	
30:	KH = 0C00;	PROFILE-No. PART B /
31:	KH = 0C00;	PROFILE-No. PART C /
32:	KH = 8000;	
33:	KH = 0000;	
34:	KH = 8000;	UP.EXTR. MAX FLOW PR.(WARNING)
35:	KH = 0000;	
36:	KH = 8000;	UP.EXTR. MAX FLOW PR.(TURN OFF)
37:	KH = 0000;	
38:	KH = 8000;	
39:	KH = 0000;	
40:	KH = 8000;	
41:	KH = 0000;	
42:	KH = 8000;	BOT.EXTR. MAX FLOW PR.(WARNING)
43:	KH = 0000;	
44:	KH = 8000;	BOT.EXTR. MAX FLOW PR.(TURN OFF)
45:	KH = 0000;	
46:	KH = 8000;	
47:	KH = 0000;	
48:	KH = 8000;	
49:	KH = 0000;	
50:	KH = 8000;	
51:	KH = 0000;	
52:	KH = 8000;	
53:	KH = 0000;	
54:	KH = 8000;	
55:	KH = 0000;	
56:	KH = 8000;	
57:	KH = 0000;	
58:	KH = 8000;	
59:	KH = 0000;	
60:	KH = 8000;	
61:	KH = 0000;	
62:	KH = 8000;	LINE SPEED
63:	KH = 0000;	
64:	KH = 8000;	LINEAR WEIGHT
65:	KH = 0000;	
66:	KH = 8000;	LINEAR WEIGHT (TOLERANCE)
67:	KH = 0000;	
68:	KH = 5923;	BOOKING (Y:BOOKING N:WIND UP)
69:	KH = 0000;	SPARE
70:	KH = 8000;	TREAD WEIGHT
71:	KH = 0000;	
72:	KH = 8000;	TREAD WEIGHT (TOLERANCE)
73:	KH = 0000;	

PROFILE No.12

```
 74:     KH = 0000;                    PRESET TEMP. UPPER EXTR. SCREW
 75:     KH = 0000;                    MIN TEMP. UPPER EXTR. SCREW
 76:     KH = 0000;                    PRESET TEMP. UPPER EXTR. BARREL
 77:     KH = 0000;                    MIN TEMP. UPPER EXTR. BARREL
 78:     KH = 0000;                    PRESET TEMP. BOTTOM EXTR. SCREW
 79:     KH = 0000;                    MIN TEMP. BOTTOM EXTR. SCREW
 80:     KH = 0000;                    PRESET TEMP. BOTTOM EXTR. BARREL
 81:     KH = 0000;                    MIN TEMP. BOTTOM EXTR. BARREL
 82:     KH = 0000;                    PRESET TEMP. EXTR. CALANDER HEAD
 83:     KH = 0000;                    MIN TEMP. EXTR. CALANDER HEAD
 84:     KH = 0000;                    PRESET TEMP. EXTR. CAL. SCREW
 85:     KH = 0000;                    MIN TEMP. EXTR. CALANDER SCREW
 86:     KH = 0000;                    PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:     KH = 0000;                    MIN TEMP. EXTR. CAL. PIN/BARREL
 88:     KH = 0000;                    PRESET TEMP. HEAD UPPER PART
 89:     KH = 0000;                    MIN TEMP. HEAD UPPER PART
 90:     KH = 0000;                    PRESET TEMP. HEAD MIDDLE PART
 91:     KH = 0000;                    MIN TEMP. HEAD MIDDLE PART
 92:     KH = 0000;                    PRESET TEMP. CASSETTE LEFT
 93:     KH = 0000;                    MIN TEMP. CASSETTE LEFT
 94:     KH = 0000;                    PRESET TEMP. CASSETTE RIGHT
 95:     KH = 0000;                    MIN TEMP. CASSETTE RIGHT
 96:     KH = 0000;                    PRESET TEMP. CALENDER ROLL TOP
 97:     KH = 0000;                    MIN TEMP CALANDER ROLL TOP
 98:     KH = 0000;                    PRESET TEMP. CALENDER ROLL BOTT.
 99:     KH = 0000;                    MIN TEMP. CALANDER ROLL BOTTOM
100:     KH = 0000;                    TREAD LENGTH
101:     KH = 0000;                    MIN TEMP. PREHEATING TABLE
102:     KH = 8000;                    STRIP WIDTH
103:     KH = 0000;
104:     KH = 0000;                    PRESET TEMP. PREHEATING TABLE
105:     KH = 0000;
106:
```

PROFILE No.13

```
  0:    KH = 0000;
  1:    KY = 013,000;                    PROFILE-No. A /ACTUAL(YES,NO)
  2:    KC ='................';          PRODUCER
 10:    KH = 0000;
 11:    KH = 0000;
 12:    KH = 0000;
 13:    KH = 0000;
 14:    KC ='..';                        DATE
 15:    C  ='..';                        MONTH
 16:    KC ='..';                        YEAR
 17:    KF = +00000;                     SPARE
 18:    KG = +0000000+00;                UPPER EXTRUDER SPEED
 20:    KG = +0000000+00;                UPPER EXTRUDER CURRENT
 22:    KG = +0000000+00;                BOTTOM EXTRUDER SPEED
 24:    KG = +0000000+00;                BOTTOM EXTRUDER CURRENT
 26:    KG = +0000000+00;                EXTRUDER CALENDER SPEED
 28:    KG = +0000000+00;                EXTRUDER CALENDER CURRENT
 30:    KY = 013,000;                    PROFILE-No. PART B /
 31:    KY = 013,000;                    PROFILE-No. PART C /
 32:    KG = +0000000+00;
 34:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(WARNING)
 36:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(TURN OFF)
 38:    KG = +0000000+00;
 40:    KG = +0000000+00;
 42:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(WARNING)
 44:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(TURN OFF)
 46:    KG = +0000000+00;
 48:    KG = +0000000+00;
 50:    KG = +0000000+00;
 52:    KG = +0000000+00;
 54:    KG = +0000000+00;
 56:    KG = +0000000+00;
 58:    KG = +0000000+00;
 60:    KG = +0000000+00;
 62:    KG = +0000000+00;                LINE SPEED
 64:    KG = +0000000+00;                LINEAR WEIGHT
 66:    KG = +0000000+00;                LINEAR WEIGHT (TOLERANCE)
 68:    KC ='Y#';                        BOOKING (Y:BOOKING N:WIND UP)
 69:    KF = +00000;                     SPARE
 70:    KG = +0000000+00;                TREAD WEIGHT
 72:    KG = +0000000+00;                TREAD WEIGHT (TOLERANCE)
 74:    KF = +00000;                     PRESET dEMP. UPPER EXTR. SCREW
 75:    KF = +00000;                     MIN TEMP. UPPER EXTR. SCREW
 76:    KF = +00000;                     PRESET TEMP. UPPER EXTR. BARREL
 77:    KF = +00000;                     MIN TEMP. UPPER EXTR. BARREL
 78:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. SCREW
 79:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. SCREW
 80:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. BARREL
 81:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. BARREL
 82:    KF = +00000;                     PRESET TEMP. EXTR. CALANDER HEAD
 83:    KF = +00000;                     MIN TEMP. EXTR. CALANDER HEAD
 84:    KF = +00000;                     PRESET TEMP. EXTR. CAL. SCREW
 85:    KF = +00000;                     MIN TEMP. EXTR. CALANDER SCREW
 86:    KF = +00000;                     PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:    KF = +00000;                     MIN TEMP. EXTR. CAL. PIN/BARREL
 88:    KF = +00000;                     PRESET TEMP. HEAD UPPER PART
 89:    KF = +00000;                     MIN TEMP. HEAD UPPER PART
 90:    KF = +00000;                     PRESET TEMP. HEAD MIDDLE PART
 91:    KF = +00000;                     MIN TEMP. HEAD MIDDLE PART
 92:    KF = +00000;                     PRESET TEMP. CASSETTE LEFT
 93:    KF = +00000;                     MIN TEMP. CASSETTE LEFT
 94:    KF = +00000;                     PRESET TEMP. CASSETTE RIGHT
 95:    KF = +00000;                     MIN TEMP. CASSETTE RIGHT
 96:    KF = +00000;                     PRESET TEMP. CALENDER ROLL TOP
 97:    KF = +00000;                     MIN TEMP CALANDER ROLL TOP
 98:    KF = +00000;                     PRESET TEMP. CALENDER ROLL BOTT.
 99:    KF = +00000;                     MIN TEMP. CALANDER ROLL BOTTOM
100:    KF = +00000;                     TREAD LENGTH
101:    KF = +00000;                     MIN TEMP. PREHEATING TABLE
102:    KG = +0000000+00;                STRIP WIDTH
104:    KF = +00000;                     PRESET TEMP. PREHEATING TABLE
105:    KF = +00000;
106:
```

```
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                     !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                     !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                     !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                    1!
+-----------------------------------------------------------------------------+
```

```
DB114   C:KERM06ST.S5D              BIB=11022          LAE=111 /122
                        PROFILE No.14
     0:      KH = 0000;
     1:      KY = 014,000;                          PROFILE-No. A /ACTUAL(YES,NO)
     2:      KC ='................';                 PRODUCER
    10:      KH = 0000;
    11:      KH = 0000;
    12:      KH = 0000;
    13:      KH = 0000;
    14:      KC ='..';                              DATE
    15:      C  ='..';                              MONTH
    16:      KC ='..';                              YEAR
    17:      KF = +00000;                           SPARE
    18:      KG = +0000000+00;                      UPPER EXTRUDER SPEED
    20:      KG = +0000000+00;                      UPPER EXTRUDER CURRENT
    22:      KG = +0000000+00;                      BOTTOM EXTRUDER SPEED
    24:      KG = +0000000+00;                      BOTTOM EXTRUDER CURRENT
    26:      KG = +0000000+00;                      EXTRUDER CALENDER SPEED
    28:      KG = +0000000+00;                      EXTRUDER CALENDER CURRENT
    30:      KY = 014,000;                          PROFILE-No. PART B /
    31:      KY = 014,000;                          PROFILE-No. PART C /
    32:      KG = +0000000+00;
    34:      KG = +0000000+00;                      UP.EXTR. MAX FLOW PR.(WARNING)
    36:      KG = +0000000+00;                      UP.EXTR. MAX FLOW PR.(TURN OFF)
    38:      KG = +0000000+00;
    40:      KG = +0000000+00;
    42:      KG = +0000000+00;                      BOT.EXTR. MAX FLOW PR.(WARNING)
    44:      KG = +0000000+00;                      BOT.EXTR. MAX FLOW PR.(TURN OFF)
    46:      KG = +0000000+00;
    48:      KG = +0000000+00;
    50:      KG = +0000000+00;
    52:      KG = +0000000+00;
    54:      KG = +0000000+00;
    56:      KG = +0000000+00;
    58:      KG = +0000000+00;
    60:      KG = +0000000+00;
    62:      KG = +0000000+00;                      LINE SPEED
    64:      KG = +0000000+00;                      LINEAR WEIGHT
    66:      KG = +0000000+00;                      LINEAR WEIGHT (TOLERANCE)
    68:      KC ='Y#';                              BOOKING (Y:BOOKING N:WIND UP)
    69:      KF = +00000;                           SPARE
    70:      KG = +0000000+00;                      TREAD WEIGHT
    72:      KG = +0000000+00;                      TREAD WEIGHT (TOLERANCE)
    74:      KF = +00000;                           PRESET TEMP. UPPER EXTR. SCREW
    75:      KF = +00000;                           MIN TEMP. UPPER EXTR. SCREW
    76:      KF = +00000;                           PRESET TEMP. UPPER EXTR. BARREL
    77:      KF = +00000;                           MIN TEMP. UPPER EXTR. BARREL
    78:      KF = +00000;                           PRESET TEMP. BOTTOM EXTR. SCREW
    79:      KF = +00000;                           MIN TEMP. BOTTOM EXTR. SCREW
    80:      KF = +00000;                           PRESET TEMP. BOTTOM EXTR. BARREL
    81:      KF = +00000;                           MIN TEMP. BOTTOM EXTR. BARREL
    82:      KF = +00000;                           PRESET TEMP. EXTR. CALANDER HEAD
    83:      KF = +00000;                           MIN TEMP. EXTR. CALANDER HEAD
    84:      KF = +00000;                           PRESET TEMP. EXTR. CAL. SCREW
    85:      KF = +00000;                           MIN TEMP. EXTR. CALANDER SCREW
    86:      KF = +00000;                           PRESET TEMP. EXTR. CAL. PIN/BAR.
    87:      KF = +00000;                           MIN TEMP. EXTR. CAL. PIN/BARREL
    88:      KF = +00000;                           PRESET TEMP. HEAD UPPER PART
    89:      KF = +00000;                           MIN TEMP. HEAD UPPER PART
    90:      KF = +00000;                           PRESET TEMP. HEAD MIDDLE PART
    91:      KF = +00000;                           MIN TEMP. HEAD MIDDLE PART
    92:      KF = +00000;                           PRESET TEMP. CASSETTE LEFT
    93:      KF = +00000;                           MIN TEMP. CASSETTE LEFT
    94:      KF = +00000;                           PRESET TEMP. CASSETTE RIGHT
    95:      KF = +00000;                           MIN TEMP. CASSETTE RIGHT
    96:      KF = +00000;                           PRESET TEMP. CALENDER ROLL TOP
    97:      KF = +00000;                           MIN TEMP CALANDER ROLL TOP
    98:      KF = +00000;                           PRESET TEMP. CALENDER ROLL BOTT.
    99:      KF = +00000;                           MIN TEMP. CALANDER ROLL BOTTOM
   100:      KF = +00000;                           TREAD LENGTH
   101:      KF = +00000;                           MIN TEMP. PREHEATING TABLE
   102:      KG = +0000000+00;                      STRIP WIDTH
   104:      KF = +00000;                           PRESET TEMP. PREHEATING TABLE
   105:      KF = +00000;
   106:

+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                     1!
+-------------------------------------------------------------------------------+
```

DB115 C:KERM06ST.S5D BIB=11022 LAE=111 /122

PROFILE No.15

```
  0:    KH = 0000;
  1:    KY = 015,000;                    PROFILE-No. A /ACTUAL(YES,NO)
  2:    KC ='................';          PRODUCER
 10:    KH = 0000;
 11:    KH = 0000;
 12:    KH = 0000;
 13:    KH = 0000;
 14:    KC ='..';                        DATE
 15:    C  ='..';                        MONTH
 16:    KC ='..';                        YEAR
 17:    KF = +00000;                     SPARE
 18:    KG = +0000000+00;                UPPER EXTRUDER SPEED
 20:    KG = +0000000+00;                UPPER EXTRUDER CURRENT
 22:    KG = +0000000+00;                BOTTOM EXTRUDER SPEED
 24:    KG = +0000000+00;                BOTTOM EXTRUDER CURRENT
 26:    KG = +0000000+00;                EXTRUDER CALENDER SPEED
 28:    KG = +0000000+00;                EXTRUDER CALENDER CURRENT
 30:    KY = 015,000;                    PROFILE-No. PART B /
 31:    KY = 015,000;                    PROFILE-No. PART C /
 32:    KG = +0000000+00;
 34:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(WARNING)
 36:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(TURN OFF)
 38:    KG = +0000000+00;
 40:    KG = +0000000+00;
 42:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(WARNING)
 44:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(TURN OFF)
 46:    KG = +0000000+00;
 48:    KG = +0000000+00;
 50:    KG = +0000000+00;
 52:    KG = +0000000+00;
 54:    KG = +0000000+00;
 56:    KG = +0000000+00;
 58:    KG = +0000000+00;
 60:    KG = +0000000+00;
 62:    KG = +0000000+00;                LINE SPEED
 64:    KG = +0000000+00;                LINEAR WEIGHT
 66:    KG = +0000000+00;                LINEAR WEIGHT (TOLERANCE)
 68:    KC ='Y#';                        BOOKING (Y:BOOKING N:WIND UP)
 69:    KF = +00000;                     SPARE
 70:    KG = +0000000+00;                TREAD WEIGHT
 72:    KG = +0000000+00;                TREAD WEIGHT (TOLERANCE)
 74:    KF = +00000;                     PRESET TEMP. UPPER EXTR. SCREW
 75:    KF = +00000;                     MIN TEMP. UPPER EXTR. SCREW
 76:    KF = +00000;                     PRESET TEMP. UPPER EXTR. BARREL
 77:    KF = +00000;                     MIN TEMP. UPPER EXTR. BARREL
 78:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. SCREW
 79:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. SCREW
 80:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. BARREL
 81:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. BARREL
 82:    KF = +00000;                     PRESET TEMP. EXTR. CALANDER HEAD
 83:    KF = +00000;                     MIN TEMP. EXTR. CALANDER HEAD
 84:    KF = +00000;                     PRESET TEMP. EXTR. CAL. SCREW
 85:    KF = +00000;                     MIN TEMP. EXTR. CALANDER SCREW
 86:    KF = +00000;                     PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:    KF = +00000;                     MIN TEMP. EXTR. CAL. PIN/BARREL
 88:    KF = +00000;                     PRESET TEMP. HEAD UPPER PART
 89:    KF = +00000;                     MIN TEMP. HEAD UPPER PART
 90:    KF = +00000;                     PRESET TEMP. HEAD MIDDLE PART
 91:    KF = +00000;                     MIN TEMP. HEAD MIDDLE PART
 92:    KF = +00000;                     PRESET TEMP. CASSETTE LEFT
 93:    KF = +00000;                     MIN TEMP. CASSETTE LEFT
 94:    KF = +00000;                     PRESET TEMP. CASSETTE RIGHT
 95:    KF = +00000;                     MIN TEMP. CASSETTE RIGHT
 96:    KF = +00000;                     PRESET TEMP. CALENDER ROLL TOP
 97:    KF = +00000;                     MIN TEMP CALANDER ROLL TOP
 98:    KF = +00000;                     PRESET TEMP. CALENDER ROLL BOTT.
 99:    KF = +00000;                     MIN TEMP. CALANDER ROLL BOTTOM
100:    KF = +00000;                     TREAD LENGTH
101:    KF = +00000;                     MIN TEMP. PREHEATING TABLE
102:    KG = +0000000+00;                STRIP WIDTH
104:    KF = +00000;                     PRESET TEMP. PREHEATING TABLE
105:    KF = +00000;
106:
```

PROFILE No.16

```
  0:    KH = 0000;
  1:    KY = 016,000;                    PROFILE-No. A /ACTUAL(YES,NO)
  2:    KC ='................';          PRODUCER
 10:    KH = 0000;
 11:    KH = 0000;
 12:    KH = 0000;
 13:    KH = 0000;
 14:    KC ='..';                        DATE
 15:    C  ='..';                        MONTH
 16:    KC ='..';                        YEAR
 17:    KF = +00000;                     SPARE
 18:    KG = +0000000+00;                UPPER EXTRUDER SPEED
 20:    KG = +0000000+00;                UPPER EXTRUDER CURRENT
 22:    KG = +0000000+00;                BOTTOM EXTRUDER SPEED
 24:    KG = +0000000+00;                BOTTOM EXTRUDER CURRENT
 26:    KG = +0000000+00;                EXTRUDER CALENDER SPEED
 28:    KG = +0000000+00;                EXTRUDER CALENDER CURRENT
 30:    KY = 016,000;                    PROFILE-No. PART B /
 31:    KY = 016,000;                    PROFILE-No. PART C /
 32:    KG = +0000000+00;
 34:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(WARNING)
 36:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(TURN OFF)
 38:    KG = +0000000+00;
 40:    KG = +0000000+00;
 42:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(WARNING)
 44:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(TURN OFF)
 46:    KG = +0000000+00;
 48:    KG = +0000000+00;
 50:    KG = +0000000+00;
 52:    KG = +0000000+00;
 54:    KG = +0000000+00;
 56:    KG = +0000000+00;
 58:    KG = +0000000+00;
 60:    KG = +0000000+00;
 62:    KG = +0000000+00;                LINE SPEED
 64:    KG = +0000000+00;                LINEAR WEIGHT
 66:    KG = +0000000+00;                LINEAR WEIGHT (TOLERANCE)
 68:    KC ='Y#';                        BOOKING (Y:BOOKING N:WIND UP)
 69:    KF = +00000;                     SPARE
 70:    KG = +0000000+00;                TREAD WEIGHT
 72:    KG = +0000000+00;                TREAD WEIGHT (TOLERANCE)
 74:    KF = +00000;                     PRESET TEMP. UPPER EXTR. SCREW
 75:    KF = +00000;                     MIN TEMP. UPPER EXTR. SCREW
 76:    KF = +00000;                     PRESET TEMP. UPPER EXTR. BARREL
 77:    KF = +00000;                     MIN TEMP. UPPER EXTR. BARREL
 78:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. SCREW
 79:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. SCREW
 80:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. BARREL
 81:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. BARREL
 82:    KF = +00000;                     PRESET TEMP. EXTR. CALANDER HEAD
 83:    KF = +00000;                     MIN TEMP. EXTR. CALANDER HEAD
 84:    KF = +00000;                     PRESET TEMP. EXTR. CAL. SCREW
 85:    KF = +00000;                     MIN TEMP. EXTR. CALANDER SCREW
 86:    KF = +00000;                     PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:    KF = +00000;                     MIN TEMP. EXTR. CAL. PIN/BARREL
 88:    KF = +00000;                     PRESET TEMP. HEAD UPPER PART
 89:    KF = +00000;                     MIN TEMP. HEAD UPPER PART
 90:    KF = +00000;                     PRESET TEMP. HEAD MIDDLE PART
 91:    KF = +00000;                     MIN TEMP. HEAD MIDDLE PART
 92:    KF = +00000;                     PRESET TEMP. CASSETTE LEFT
 93:    KF = +00000;                     MIN TEMP. CASSETTE LEFT
 94:    KF = +00000;                     PRESET TEMP. CASSETTE RIGHT
 95:    KF = +00000;                     MIN TEMP. CASSETTE RIGHT
 96:    KF = +00000;                     PRESET TEMP. CALENDER ROLL TOP
 97:    KF = +00000;                     MIN TEMP CALANDER ROLL TOP
 98:    KF = +00000;                     PRESET TEMP. CALENDER ROLL BOTT.
 99:    KF = +00000;                     MIN TEMP. CALANDER ROLL BOTTOM
100:    KF = +00000;                     TREAD LENGTH
101:    KF = +00000;                     MIN TEMP. PREHEATING TABLE
102:    KG = +0000000+00;                STRIP WIDTH
104:    KF = +00000;                     PRESET TEMP. PREHEATING TABLE
105:    KF = +00000;
106:
```


```
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                     !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                     !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                     !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                     1!
+-----------------------------------------------------------------------------+
```

DB117 C:KERM06ST.S5D BIB=11022 LAE=111 /122

PROFILE No.17

```
  0:    KH = 0000;
  1:    KY = 017,000;                    PROFILE-No. A /ACTUAL(YES,NO)
  2:    KC ='................';           PRODUCER
 10:    KH = 0000;
 11:    KH = 0000;
 12:    KH = 0000;
 13:    KH = 0000;
 14:    KC ='..';                        DATE
 15:    C  ='..';                        MONTH
 16:    KC ='..';                        YEAR
 17:    KF = +00000;                     SPARE
 18:    KG = +0000000+00;                UPPER EXTRUDER SPEED
 20:    KG = +0000000+00;                UPPER EXTRUDER CURRENT
 22:    KG = +0000000+00;                BOTTOM EXTRUDER SPEED
 24:    KG = +0000000+00;                BOTTOM EXTRUDER CURRENT
 26:    KG = +0000000+00;                EXTRUDER CALENDER SPEED
 28:    KG = +0000000+00;                EXTRUDER CALENDER CURRENT
 30:    KY = 017,000;                    PROFILE-No. PART B /
 31:    KY = 017,000;                    PROFILE-No. PART C /
 32:    KG = +0000000+00;
 34:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(WARNING)
 36:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(TURN OFF)
 38:    KG = +0000000+00;
 40:    KG = +0000000+00;
 42:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(WARNING)
 44:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(TURN OFF)
 46:    KG = +0000000+00;
 48:    KG = +0000000+00;
 50:    KG = +0000000+00;
 52:    KG = +0000000+00;
 54:    KG = +0000000+00;
 56:    KG = +0000000+00;
 58:    KG = +0000000+00;
 60:    KG = +0000000+00;
 62:    KG = +0000000+00;                LINE SPEED
 64:    KG = +0000000+00;                LINEAR WEIGHT
 66:    KG = +0000000+00;                LINEAR WEIGHT (TOLERANCE)
 68:    KC ='Y#';                        BOOKING (Y:BOOKING N:WIND UP)
 69:    KF = +00000;                     SPARE
 70:    KG = +0000000+00;                TREAD WEIGHT
 72:    KG = +0000000+00;                TREAD WEIGHT (TOLERANCE)
 74:    KF = +00000;                     PRESET TEMP. UPPER EXTR. SCREW
 75:    KF = +00000;                     MIN TEMP. UPPER EXTR. SCREW
 76:    KF = +00000;                     PRESET TEMP. UPPER EXTR. BARREL
 77:    KF = +00000;                     MIN TEMP. UPPER EXTR. BARREL
 78:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. SCREW
 79:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. SCREW
 80:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. BARREL
 81:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. BARREL
 82:    KF = +00000;                     PRESET TEMP. EXTR. CALANDER HEAD
 83:    KF = +00000;                     MIN TEMP. EXTR. CALANDER HEAD
 84:    KF = +00000;                     PRESET TEMP. EXTR. CAL. SCREW
 85:    KF = +00000;                     MIN TEMP. EXTR. CALANDER SCREW
 86:    KF = +00000;                     PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:    KF = +00000;                     MIN TEMP. EXTR. CAL. PIN/BARREL
 88:    KF = +00000;                     PRESET TEMP. HEAD UPPER PART
 89:    KF = +00000;                     MIN TEMP. HEAD UPPER PART
 90:    KF = +00000;                     PRESET TEMP. HEAD MIDDLE PART
 91:    KF = +00000;                     MIN TEMP. HEAD MIDDLE PART
 92:    KF = +00000;                     PRESET TEMP. CASSETTE LEFT
 93:    KF = +00000;                     MIN TEMP. CASSETTE LEFT
 94:    KF = +00000;                     PRESET TEMP. CASSETTE RIGHT
 95:    KF = +00000;                     MIN TEMP. CASSETTE RIGHT
 96:    KF = +00000;                     PRESET TEMP. CALENDER ROLL TOP
 97:    KF = +00000;                     MIN TEMP CALANDER ROLL TOP
 98:    KF = +00000;                     PRESET TEMP. CALENDER ROLL BOTT.
 99:    KF = +00000;                     MIN TEMP. CALANDER ROLL BOTTOM
100:    KF = +00000;                     TREAD LENGTH
101:    KF = +00000;                     MIN TEMP. PREHEATING TABLE
102:    KG = +0000000+00;                STRIP WIDTH
104:    KF = +00000;                     PRESET TEMP. PREHEATING TABLE
105:    KF = +00000;
106:
```

KRUPP KUNSTOFFTECHNIK ELASTOMERTECHNIK WERK HARBURG		MASTERPROGRAMM	
PROJECT	: KERMAN TIRE	DATE :	
INSTALLATION	: TREAD-LINE	MODIFICATION:	PGNO
PROJECT POS. NO.	: 84/823804	PROGRAMMER :	1

DB118 C:KERM06ST.S5D BIB=11022 LAE=111 /122

PROFILE No.18

```
  0:    KH = 0000;
  1:    KY = 018,000;                    PROFILE-No. A /ACTUAL(YES,NO)
  2:    KC ='................';           PRODUCER
 10:    KH = 0000;
 11:    KH = 0000;
 12:    KH = 0000;
 13:    KH = 0000;
 14:    KC ='..';                        DATE
 15:    C  ='..';                        MONTH
 16:    KC ='..';                        YEAR
 17:    KF = +00000;                     SPARE
 18:    KG = +0000000+00;                UPPER EXTRUDER SPEED
 20:    KG = +0000000+00;                UPPER EXTRUDER CURRENT
 22:    KG = +0000000+00;                BOTTOM EXTRUDER SPEED
 24:    KG = +0000000+00;                BOTTOM EXTRUDER CURRENT
 26:    KG = +0000000+00;                EXTRUDER CALENDER SPEED
 28:    KG = +0000000+00;                EXTRUDER CALENDER CURRENT
 30:    KY = 018,000;                    PROFILE-No. PART B /
 31:    KY = 018,000;                    PROFILE-No. PART C /
 32:    KG = +0000000+00;
 34:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(WARNING)
 36:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(TURN OFF)
 38:    KG = +0000000+00;
 40:    KG = +0000000+00;
 42:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(WARNING)
 44:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(TURN OFF)
 46:    KG = +0000000+00;
 48:    KG = +0000000+00;
 50:    KG = +0000000+00;
 52:    KG = +0000000+00;
 54:    KG = +0000000+00;
 56:    KG = +0000000+00;
 58:    KG = +0000000+00;
 60:    KG = +0000000+00;
 62:    KG = +0000000+00;                LINE SPEED
 64:    KG = +0000000+00;                LINEAR WEIGHT
 66:    KG = +0000000+00;                LINEAR WEIGHT (TOLERANCE)
 68:    KC ='Y#';                        BOOKING (Y:BOOKING N:WIND UP)
 69:    KF = +00000;                     SPARE
 70:    KG = +0000000+00;                TREAD WEIGHT
 72:    KG = +0000000+00;                TREAD WEIGHT (TOLERANCE)
 74:    KF = +00000;                     PRESET TEMP. UPPER EXTR. SCREW
 75:    KF = +00000;                     MIN TEMP. UPPER EXTR. SCREW
 76:    KF = +00000;                     PRESET TEMP. UPPER EXTR. BARREL
 77:    KF = +00000;                     MIN TEMP. UPPER EXTR. BARREL
 78:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. SCREW
 79:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. SCREW
 80:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. BARREL
 81:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. BARREL
 82:    KF = +00000;                     PRESET TEMP. EXTR. CALANDER HEAD
 83:    KF = +00000;                     MIN TEMP. EXTR. CALANDER HEAD
 84:    KF = +00000;                     PRESET TEMP. EXTR. CAL. SCREW
 85:    KF = +00000;                     MIN TEMP. EXTR. CALANDER SCREW
 86:    KF = +00000;                     PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:    KF = +00000;                     MIN TEMP. EXTR. CAL. PIN/BARREL
 88:    KF = +00000;                     PRESET TEMP. HEAD UPPER PART
 89:    KF = +00000;                     MIN TEMP. HEAD UPPER PART
 90:    KF = +00000;                     PRESET TEMP. HEAD MIDDLE PART
 91:    KF = +00000;                     MIN TEMP. HEAD MIDDLE PART
 92:    KF = +00000;                     PRESET TEMP. CASSETTE LEFT
 93:    KF = +00000;                     MIN TEMP. CASSETTE LEFT
 94:    KF = +00000;                     PRESET TEMP. CASSETTE RIGHT
 95:    KF = +00000;                     MIN TEMP. CASSETTE RIGHT
 96:    KF = +00000;                     PRESET TEMP. CALENDER ROLL TOP
 97:    KF = +00000;                     MIN TEMP CALANDER ROLL TOP
 98:    KF = +00000;                     PRESET TEMP. CALENDER ROLL BOTT.
 99:    KF = +00000;                     MIN TEMP. CALANDER ROLL BOTTOM
100:    KF = +00000;                     TREAD LENGTH
101:    KF = +00000;                     MIN TEMP. PREHEATING TABLE
102:    KG = +0000000+00;                STRIP WIDTH
104:    KF = +00000;                     PRESET TEMP. PREHEATING TABLE
105:    KF = +00000;
106:
```

DB119 C:KERM06ST.S5D BIB=11022 LAE=111 /122

PROFILE No.19

```
  0:    KH = 0000;
  1:    KY = 019,000;                    PROFILE-No. A /ACTUAL(YES,NO)
  2:    KC ='................';           PRODUCER
 10:    KH = 0000;
 11:    KH = 0000;
 12:    KH = 0000;
 13:    KH = 0000;
 14:    KC ='..';                        DATE
 15:    C  ='..';                        MONTH
 16:    KC ='..';                        YEAR
 17:    KF = +00000;                     SPARE
 18:    KG = +0000000+00;                UPPER EXTRUDER SPEED
 20:    KG = +0000000+00;                UPPER EXTRUDER CURRENT
 22:    KG = +0000000+00;                BOTTOM EXTRUDER SPEED
 24:    KG = +0000000+00;                BOTTOM EXTRUDER CURRENT
 26:    KG = +0000000+00;                EXTRUDER CALENDER SPEED
 28:    KG = +0000000+00;                EXTRUDER CALENDER CURRENT
 30:    KY = 019,000;                    PROFILE-No. PART B /
 31:    KY = 019,000;                    PROFILE-No. PART C /
 32:    KG = +0000000+00;
 34:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(WARNING)
 36:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(TURN OFF)
 38:    KG = +0000000+00;
 40:    KG = +0000000+00;
 42:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(WARNING)
 44:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(TURN OFF)
 46:    KG = +0000000+00;
 48:    KG = +0000000+00;
 50:    KG = +0000000+00;
 52:    KG = +0000000+00;
 54:    KG = +0000000+00;
 56:    KG = +0000000+00;
 58:    KG = +0000000+00;
 60:    KG = +0000000+00;
 62:    KG = +0000000+00;                LINE SPEED
 64:    KG = +0000000+00;                LINEAR WEIGHT
 66:    KG = +0000000+00;                LINEAR WEIGHT (TOLERANCE)
 68:    KC ='Y#';                        BOOKING (Y:BOOKING N:WIND UP)
 69:    KF = +00000;                     SPARE
 70:    KG = +0000000+00;                TREAD WEIGHT
 72:    KG = +0000000+00;                TREAD WEIGHT (TOLERANCE)
 74:    KF = +00000;                     PRESET TEMP. UPPER EXTR. SCREW
 75:    KF = +00000;                     MIN TEMP. UPPER EXTR. SCREW
 76:    KF = +00000;                     PRESET TEMP. UPPER EXTR. BARREL
 77:    KF = +00000;                     MIN TEMP. UPPER EXTR. BARREL
 78:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. SCREW
 79:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. SCREW
 80:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. BARREL
 81:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. BARREL
 82:    KF = +00000;                     PRESET TEMP. EXTR. CALANDER HEAD
 83:    KF = +00000;                     MIN TEMP. EXTR. CALANDER HEAD
 84:    KF = +00000;                     PRESET TEMP. EXTR. CAL. SCREW
 85:    KF = +00000;                     MIN TEMP. EXTR. CALANDER SCREW
 86:    KF = +00000;                     PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:    KF = +00000;                     MIN TEMP. EXTR. CAL. PIN/BARREL
 88:    KF = +00000;                     PRESET TEMP. HEAD UPPER PART
 89:    KF = +00000;                     MIN TEMP. HEAD UPPER PART
 90:    KF = +00000;                     PRESET TEMP. HEAD MIDDLE PART
 91:    KF = +00000;                     MIN TEMP. HEAD MIDDLE PART
 92:    KF = +00000;                     PRESET TEMP. CASSETTE LEFT
 93:    KF = +00000;                     MIN TEMP. CASSETTE LEFT
 94:    KF = +00000;                     PRESET TEMP. CASSETTE RIGHT
 95:    KF = +00000;                     MIN TEMP. CASSETTE RIGHT
 96:    KF = +00000;                     PRESET TEMP. CALENDER ROLL TOP
 97:    KF = +00000;                     MIN TEMP CALANDER ROLL TOP
 98:    KF = +00000;                     PRESET TEMP. CALENDER ROLL BOTT.
 99:    KF = +00000;                     MIN TEMP. CALANDER ROLL BOTTOM
100:    KF = +00000;                     TREAD LENGTH
101:    KF = +00000;                     MIN TEMP. PREHEATING TABLE
102:    KG = +0000000+00;                STRIP WIDTH
104:    KF = +00000;                     PRESET TEMP. PREHEATING TABLE
105:    KF = +00000;
106:
```

KRUPP KUNSTOFFTECHNIK		
ELASTOMERTECHNIK WERK HARBURG	MASTERPROGRAMM	
PROJECT : KERMAN TIRE	DATE :	
INSTALLATION : TREAD-LINE	MODIFICATION:	PGNO
PROJECT POS. NO.: 84/823804	PROGRAMMER :	1

DB120 C:KERM06ST.S5D BIB=11022 LAE=111 /122

PROFILE No.20

```
  0:    KH = 0000;
  1:    KY = 020,000;                    PROFILE-No. A /ACTUAL(YES,NO)
  2:    KC ='................';           PRODUCER
 10:    KH = 0000;
 11:    KH = 0000;
 12:    KH = 0000;
 13:    KH = 0000;
 14:    KC ='..';                        DATE
 15:    C  ='..';                        MONTH
 16:    KC ='..';                        YEAR
 17:    KF = +00000;                     SPARE
 18:    KG = +0000000+00;                UPPER EXTRUDER SPEED
 20:    KG = +0000000+00;                UPPER EXTRUDER CURRENT
 22:    KG = +0000000+00;                BOTTOM EXTRUDER SPEED
 24:    KG = +0000000+00;                BOTTOM EXTRUDER CURRENT
 26:    KG = +0000000+00;                EXTRUDER CALENDER SPEED
 28:    KG = +0000000+00;                EXTRUDER CALENDER CURRENT
 30:    KY = 020,000;                    PROFILE-No. PART B /
 31:    KY = 020,000;                    PROFILE-No. PART C /
 32:    KG = +0000000+00;
 34:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(WARNING)
 36:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(TURN OFF)
 38:    KG = +0000000+00;
 40:    KG = +0000000+00;
 42:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(WARNING)
 44:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(TURN OFF)
 46:    KG = +0000000+00;
 48:    KG = +0000000+00;
 50:    KG = +0000000+00;
 52:    KG = +0000000+00;
 54:    KG = +0000000+00;
 56:    KG = +0000000+00;
 58:    KG = +0000000+00;
 60:    KG = +0000000+00;
 62:    KG = +0000000+00;                LINE SPEED
 64:    KG = +0000000+00;                LINEAR WEIGHT
 66:    KG = +0000000+00;                LINEAR WEIGHT (TOLERANCE)
 68:    KC ='Y#';                        BOOKING (Y:BOOKING N:WIND UP)
 69:    KF = +00000;                     SPARE
 70:    KG = +0000000+00;                TREAD WEIGHT
 72:    KG = +0000000+00;                TREAD WEIGHT (TOLERANCE)
 74:    KF = +00000;                     PRESET TEMP. UPPER EXTR. SCREW
 75:    KF = +00000;                     MIN TEMP. UPPER EXTR. SCREW
 76:    KF = +00000;                     PRESET TEMP. UPPER EXTR. BARREL
 77:    KF = +00000;                     MIN TEMP. UPPER EXTR. BARREL
 78:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. SCREW
 79:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. SCREW
 80:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. BARREL
 81:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. BARREL
 82:    KF = +00000;                     PRESET TEMP. EXTR. CALANDER HEAD
 83:    KF = +00000;                     MIN TEMP. EXTR. CALANDER HEAD
 84:    KF = +00000;                     PRESET TEMP. EXTR. CAL. SCREW
 85:    KF = +00000;                     MIN TEMP. EXTR. CALANDER SCREW
 86:    KF = +00000;                     PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:    KF = +00000;                     MIN TEMP. EXTR. CAL. PIN/BARREL
 88:    KF = +00000;                     PRESET TEMP. HEAD UPPER PART
 89:    KF = +00000;                     MIN TEMP. HEAD UPPER PART
 90:    KF = +00000;                     PRESET TEMP. HEAD MIDDLE PART
 91:    KF = +00000;                     MIN TEMP. HEAD MIDDLE PART
 92:    KF = +00000;                     PRESET TEMP. CASSETTE LEFT
 93:    KF = +00000;                     MIN TEMP. CASSETTE LEFT
 94:    KF = +00000;                     PRESET TEMP. CASSETTE RIGHT
 95:    KF = +00000;                     MIN TEMP. CASSETTE RIGHT
 96:    KF = +00000;                     PRESET TEMP. CALENDER ROLL TOP
 97:    KF = +00000;                     MIN TEMP CALANDER ROLL TOP
 98:    KF = +00000;                     PRESET TEMP. CALENDER ROLL BOTT.
 99:    KF = +00000;                     MIN TEMP. CALANDER ROLL BOTTOM
100:    KF = +00000;                     TREAD LENGTH
101:    KF = +00000;                     MIN TEMP. PREHEATING TABLE
102:    KG = +0000000+00;                STRIP WIDTH
104:    KF = +00000;                     PRESET TEMP. PREHEATING TABLE
105:    KF = +00000;
106:
```

DB121 C:KERM06ST.S5D BIB=11022 LAE=111 /122

PROFILE No.21

```
  0:    KH = 0000;
  1:    KY = 021,000;                    PROFILE-No. A /ACTUAL(YES,NO)
  2:    KC ='................';           PRODUCER
 10:    KH = 0000;
 11:    KH = 0000;
 12:    KH = 0000;
 13:    KH = 0000;
 14:    KC ='..';                        DATE
 15:    C  ='..';                        MONTH
 16:    KC ='..';                        YEAR
 17:    KF = +00000;                     SPARE
 18:    KG = +0000000+00;                UPPER EXTRUDER SPEED
 20:    KG = +0000000+00;                UPPER EXTRUDER CURRENT
 22:    KG = +0000000+00;                BOTTOM EXTRUDER SPEED
 24:    KG = +0000000+00;                BOTTOM EXTRUDER CURRENT
 26:    KG = +0000000+00;                EXTRUDER CALENDER SPEED
 28:    KG = +0000000+00;                EXTRUDER CALENDER CURRENT
 30:    KY = 021,000;                    PROFILE-No. PART B /
 31:    KY = 021,000;                    PROFILE-No. PART C /
 32:    KG = +0000000+00;
 34:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(WARNING)
 36:    KG = +0000000+00;                UP.EXTR. MAX FLOW PR.(TURN OFF)
 38:    KG = +0000000+00;
 40:    KG = +0000000+00;
 42:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(WARNING)
 44:    KG = +0000000+00;                BOT.EXTR. MAX FLOW PR.(TURN OFF)
 46:    KG = +0000000+00;
 48:    KG = +0000000+00;
 50:    KG = +0000000+00;
 52:    KG = +0000000+00;
 54:    KG = +0000000+00;
 56:    KG = +0000000+00;
 58:    KG = +0000000+00;
 60:    KG = +0000000+00;
 62:    KG = +0000000+00;                LINE SPEED
 64:    KG = +0000000+00;                LINEAR WEIGHT
 66:    KG = +0000000+00;                LINEAR WEIGHT (TOLERANCE)
 68:    KC ='Y#';                        BOOKING (Y:BOOKING N:WIND UP)
 69:    KF = +00000;                     SPARE
 70:    KG = +0000000+00;                TREAD WEIGHT
 72:    KG = +0000000+00;                TREAD WEIGHT (TOLERANCE)
 74:    KF = +00000;                     PRESET TEMP. UPPER EXTR. SCREW
 75:    KF = +00000;                     MIN TEMP. UPPER EXTR. SCREW
 76:    KF = +00000;                     PRESET TEMP. UPPER EXTR. BARREL
 77:    KF = +00000;                     MIN TEMP. UPPER EXTR. BARREL
 78:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. SCREW
 79:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. SCREW
 80:    KF = +00000;                     PRESET TEMP. BOTTOM EXTR. BARREL
 81:    KF = +00000;                     MIN TEMP. BOTTOM EXTR. BARREL
 82:    KF = +00000;                     PRESET TEMP. EXTR. CALANDER HEAD
 83:    KF = +00000;                     MIN TEMP. EXTR. CALANDER HEAD
 84:    KF = +00000;                     PRESET TEMP. EXTR. CAL. SCREW
 85:    KF = +00000;                     MIN TEMP. EXTR. CALANDER SCREW
 86:    KF = +00000;                     PRESET TEMP. EXTR. CAL. PIN/BAR.
 87:    KF = +00000;                     MIN TEMP. EXTR. CAL. PIN/BARREL
 88:    KF = +00000;                     PRESET TEMP. HEAD UPPER PART
 89:    KF = +00000;                     MIN TEMP. HEAD UPPER PART
 90:    KF = +00000;                     PRESET TEMP. HEAD MIDDLE PART
 91:    KF = +00000;                     MIN TEMP. HEAD MIDDLE PART
 92:    KF = +00000;                     PRESET TEMP. CASSETTE LEFT
 93:    KF = +00000;                     MIN TEMP. CASSETTE LEFT
 94:    KF = +00000;                     PRESET TEMP. CASSETTE RIGHT
 95:    KF = +00000;                     MIN TEMP. CASSETTE RIGHT
 96:    KF = +00000;                     PRESET TEMP. CALENDER ROLL TOP
 97:    KF = +00000;                     MIN TEMP CALANDER ROLL TOP
 98:    KF = +00000;                     PRESET TEMP. CALENDER ROLL BOTT.
 99:    KF = +00000;                     MIN TEMP. CALANDER ROLL BOTTOM
100:    KF = +00000;                     TREAD LENGTH
101:    KF = +00000;                     MIN TEMP. PREHEATING TABLE
102:    KG = +0000000+00;                STRIP WIDTH
104:    KF = +00000;                     PRESET TEMP. PREHEATING TABLE
105:    KF = +00000;
106:
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KRUPP KUNSTOFFTECHNIK ELASTOMERTECHNIK WERK HARBURG	MASTERPROGRAMM
PROJECT : KERMAN TIRE INSTALLATION : TREAD-LINE PROJECT POS. NO.: 84/823804	DATE : MODIFICATION: PROGRAMMER : PGNO 1

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  0:    KF = +00000;
  1:    KF = +00000;
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255:
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     0:      KH = 0000;
     1:      KH = 0000;
     2:      KH = 2020;
     3:      KH = 2020;
     4:      KH = 2020;
     5:      KH = 2020;
     6:      KH = 2020;
     7:      KH = 2020;
     8:      KH = 0000;
     9:      KH = 0000;
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    30:      KH = 0000;
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    32:      KH = 0000;
    33:      KH = 0000;
    34:      KH = 2020;
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    36:      KH = 2020;
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    38:      KH = 2020;
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    61:      KH = 0000;
    62:      KH = 0000;
    63:      KH = 0000;
    64:      KH = 0000;
    65:      KH = 0000;
    66:      KH = 2020;
    67:      KH = 2020;
    68:      KH = 2020;
    69:      KH = 2020;
    70:      KH = 2020;
    71:      KH = 2020;
    72:      KH = 0000;
    73:      KH = 0000;
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK                !                                !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                     !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE         !  DATE         :                    !
! INSTALLATION     : TREAD-LINE          !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804            !  PROGRAMMER   :                    1!
+-----------------------------------------------------------------------------+
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   74:      KH = 0000;
   75:      KH = 0000;
   76:      KH = 0000;
   77:      KH = 0000;
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   95:      KH = 0000;
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   98:      KH = 2020;
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  103:      KH = 2020;
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!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                      !
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! PROJECT          : KERMAN TIRE        !  DATE        :                       !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                 PGNO! 
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER  :                    2! 
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148:      KH = 0000;
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160:      KH = 0000;
161:      KH = 0000;
162:      KH = 2020;
163:      KH = 2020;
164:      KH = 2020;
165:      KH = 2020;
166:      KH = 2020;
167:      KH = 2020;
168:      KH = 0000;
169:      KH = 0000;
170:      KH = 0000;
171:      KH = 0000;
172:      KH = 0000;
173:      KH = 0000;
174:      KH = 0000;
175:      KH = 0000;
176:      KH = 0000;
177:      KH = 0000;
178:      KH = 0000;
179:      KH = 0000;
180:      KH = 0000;
181:      KH = 0000;
182:      KH = 0000;
183:      KH = 0000;
184:      KH = 0000;
185:      KH = 0000;
186:      KH = 0000;
187:      KH = 0000;
188:      KH = 0000;
189:      KH = 0000;
190:      KH = 0000;
191:      KH = 0000;
192:      KH = 0000;
193:      KH = 0000;
194:      KH = 2020;
195:      KH = 2020;
196:      KH = 2020;
197:      KH = 2020;
198:      KH = 2020;
199:      KH = 2020;
200:      KH = 0000;
201:      KH = 0000;
202:      KH = 0000;
203:      KH = 0000;
204:      KH = 0000;
205:      KH = 0000;
206:      KH = 0000;
207:      KH = 0000;
208:      KH = 0000;
209:      KH = 0000;
210:      KH = 0000;
211:      KH = 0000;
212:      KH = 0000;
213:      KH = 0000;
214:      KH = 0000;
215:      KH = 0000;
216:      KH = 0000;
217:      KH = 0000;
218:      KH = 0000;
219:      KH = 0000;
220:      KH = 0000;
221:      KH = 0000;
```

```
222:      KH = 0000;
223:      KH = 0000;
224:      KH = 0000;
225:      KH = 0000;
226:      KH = 2020;
227:      KH = 2020;
228:      KH = 2020;
229:      KH = 2020;
230:      KH = 2020;
231:      KH = 2020;
232:      KH = 0000;
233:      KH = 0000;
234:      KH = 0000;
235:      KH = 0000;
236:      KH = 0000;
237:      KH = 0000;
238:      KH = 0000;
239:      KH = 0000;
240:      KH = 0000;
241:      KH = 0000;
242:      KH = 0000;
243:      KH = 0000;
244:      KH = 0000;
245:      KH = 0000;
246:      KH = 0000;
247:      KH = 0000;
248:      KH = 0000;
249:      KH = 0000;
250:      KH = 0000;
251:      KH = 0000;
252:      KH = 0000;
253:      KH = 0000;
254:      KH = 0000;
255:      KH = 0000;
256:
```

```
DB160   C:KERM06ST.S5D              BIB=14022          LAE=111 /122
                        PROFILE FOR CP527
     0:      KH = 0000;
     1:      KY = 000,000;                          PROFILE-No. A /ACTUAL(YES,NO)
     2:      KC ='................';                 PRODUCER
    10:      KH = 0000;
    11:      KH = 0000;
    12:      KH = 0000;
    13:      KH = 0000;
    14:      KC ='..';                              DATE
    15:      C  ='..';                              MONTH
    16:      KC ='..';                              YEAR
    17:      KF = +00000;                           SPARE
    18:      KG = +0000000+00;                      UPPER EXTRUDER SPEED
    20:      KG = +0000000+00;                      UPPER EXTRUDER CURRENT
    22:      KG = +0000000+00;                      BOTTOM EXTRUDER SPEED
    24:      KG = +0000000+00;                      BOTTOM EXTRUDER CURRENT
    26:      KG = +0000000+00;                      EXTRUDER CALENDER SPEED
    28:      KG = +0000000+00;                      EXTRUDER CALENDER CURRENT
    30:      KY = 000,000;                          PROFILE-No. PART B /
    31:      KY = 000,000;                          PROFILE-No. PART C /
    32:      KG = +0000000+00;
    34:      KG = +0000000+00;                      UP.EXTR. MAX FLOW PR.(WARNING)
    36:      KG = +0000000+00;                      UP.EXTR. MAX FLOW PR.(TURN OFF)
    38:      KG = +0000000+00;
    40:      KG = +0000000+00;
    42:      KG = +0000000+00;                      BOT.EXTR. MAX FLOW PR.(WARNING)
    44:      KG = +0000000+00;                      BOT.EXTR. MAX FLOW PR.(TURN OFF)
    46:      KG = +0000000+00;
    48:      KG = +0000000+00;
    50:      KG = +0000000+00;
    52:      KG = +0000000+00;
    54:      KG = +0000000+00;
    56:      KG = +0000000+00;
    58:      KG = +0000000+00;
    60:      KG = +0000000+00;
    62:      KG = +0000000+00;                      LINE SPEED
    64:      KG = +0000000+00;                      LINEAR WEIGHT
    66:      KG = +0000000+00;                      LINEAR WEIGHT (TOLERANCE)
    68:      KC ='Y#';                              BOOKING (Y:BOOKING N:WIND UP)
    69:      KF = +00000;                           SPARE
    70:      KG = +0000000+00;                      TREAD WEIGHT
    72:      KG = +0000000+00;                      TREAD WEIGHT (TOLERANCE)
    74:      KF = +00000;                           PRESET TEMP. UPPER EXTR. SCREW
    75:      KF = +00000;                           MIN TEMP. UPPER EXTR. SCREW
    76:      KF = +00000;                           PRESET TEMP. UPPER EXTR. BARREL
    77:      KF = +00000;                           MIN TEMP. UPPER EXTR. BARREL
    78:      KF = +00000;                           PRESET TEMP. BOTTOM EXTR. SCREW
    79:      KF = +00000;                           MIN TEMP. BOTTOM EXTR. SCREW
    80:      KF = +00000;                           PRESET TEMP. BOTTOM EXTR. BARREL
    81:      KF = +00000;                           MIN TEMP. BOTTOM EXTR. BARREL
    82:      KF = +00000;                           PRESET TEMP. EXTR. CALANDER HEAD
    83:      KF = +00000;                           MIN TEMP. EXTR. CALANDER HEAD
    84:      KF = +00000;                           PRESET TEMP. EXTR. CAL. SCREW
    85:      KF = +00000;                           MIN TEMP. EXTR. CALANDER SCREW
    86:      KF = +00000;                           PRESET TEMP. EXTR. CAL. PIN/BAR.
    87:      KF = +00000;                           MIN TEMP. EXTR. CAL. PIN/BARREL
    88:      KF = +00000;                           PRESET TEMP. HEAD UPPER PART
    89:      KF = +00000;                           MIN TEMP. HEAD UPPER PART
    90:      KF = +00000;                           PRESET TEMP. HEAD MIDDLE PART
    91:      KF = +00000;                           MIN TEMP. HEAD MIDDLE PART
    92:      KF = +00000;                           PRESET TEMP. CASSETTE LEFT
    93:      KF = +00000;                           MIN TEMP. CASSETTE LEFT
    94:      KF = +00000;                           PRESET TEMP. CASSETTE RIGHT
    95:      KF = +00000;                           MIN TEMP. CASSETTE RIGHT
    96:      KF = +00000;                           PRESET TEMP. CALENDER ROLL TOP
    97:      KF = +00000;                           MIN TEMP CALANDER ROLL TOP
    98:      KF = +00000;                           PRESET TEMP. CALENDER ROLL BOTT.
    99:      KF = +00000;                           MIN TEMP. CALANDER ROLL BOTTOM
   100:      KF = +00000;                           TREAD LENGTH
   101:      KF = +00000;                           MIN TEMP. PREHEATING TABLE
   102:      KG = +0000000+00;                      STRIP WIDTH
   104:      KF = +00000;                           PRESET TEMP. PREHEATING TABLE
   105:      KF = +00000;
   106:

+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                    1!
+-------------------------------------------------------------------------------+
```

DB WITH ACTUAL DATAS

```
  0:    KG = +0000000+00;
  2:    KF = +00000;                          HELP CICLETIME
  3:    KF = +00000;                          CICLETIME
  4:    KG = +0000000+00;
  6:    KG = +0000000+00;
  8:    KG = +0000000+00;
 10:    KG = +0000000+00;
 12:    KC ='..';                             ACTUAL TIME  : YEAR
 13:    C  ='..';                                           SECONDS
 14:    KC ='..';                                           HOURS
 15:    C  ='..';                                           MINUTE
 16:    KC ='..';                                           DATE
 17:    C  ='..';                                           MONTH
 18:    KG = +0000000+00;                     UPPER EXTRUDER SPEED
 20:    KG = +0000000+00;                     UPPER EXTRUDER CURRENT
 22:    KG = +0000000+00;                     BOTTOM EXTRUDER SPEED
 24:    KG = +0000000+00;                     BOTTOM EXTRUDER CURRENT
 26:    KG = +0000000+00;                     EXTRUDER CALENDER SPEED
 28:    KG = +0000000+00;                     EXTRUDER CALENDER CURRENT
 30:    KG = +0000000+00;                     HELP DISPLAY CURRENT EX.CALENDER
 32:    KG = +0000000+00;                     HELP DISPLAY CURRENT CALENDER
 34:    KG = +0000000+00;                     HELP DISPLAY SPEED LINE
 36:    KG = +0000000+00;                     HELP DISPLAY CURRENT UPPER EXTR.
 38:    KG = +0000000+00;                     HELP DISPLAY CURRENT BOTTOM EXT.
 40:    KG = +0000000+00;                     HELP DISPLAY SPEED UPPER EXTR.
 42:    KG = +0000000+00;                     HELP DISPLAY SPEED BOTTOM EXTR.
 44:    KG = +0000000+00;                     HELP DISPLAY WIDTH MEASURING
 46:    KG = +0000000+00;                     LOOP CENTERING DEVICE 2
 48:    KG = +0000000+00;                     LOOP LINEAR WEIGHT CHECKER
 50:    KG = +0000000+00;                     LOOP CALENDER
 52:    KG = +0000000+00;                     LOOP CEMENTING DEVICE 2
 54:    KG = +0000000+00;                     LOOP COOLING CONVEYOR 1
 56:    KG = +0000000+00;                     LOOP COOLING CONVEYOR 2
 58:    KG = +0000000+00;                     LOOP COOLING CONVEYOR 3
 60:    KG = +0000000+00;                     LOOP COOLING CONVEYOR 4
 62:    KG = +0000000+00;                     LINE SPEED
 64:    KG = +0000000+00;                     LINEAR WEIGHT
 66:    KG = +0000000+00;
 68:    KC ='Y#';                             BOOKING (Y:BOOKING N:WIND UP)
 69:    KF = +00000;                          SPARE
 70:    KG = +0000000+00;                     TREAD WEIGHT
 72:    KG = +0000000+00;
 74:    KF = +00000;                          TEMP. UPPER EXTRUDER SCREW
 75:    KF = +00000;                          SPARE
 76:    KF = +00000;                          TEMP. UPPER EXTRUDER BARREL
 77:    KF = +00000;                          SPARE
 78:    KF = +00000;                          TEMP. BOTTOM EXTRUDER SCREW
 79:    KF = +00000;                          SPARE
 80:    KF = +00000;                          TEMP. BOTTOM EXTRUDER BARREL
 81:    KF = +00000;                          SPARE
 82:    KF = +00000;                          TEMP. EXTRUDER CAL. HEAD
 83:    KF = +00000;                          SPARE
 84:    KF = +00000;                          TEMP. EXTRUDER CAL. SCREW
 85:    KF = +00000;                          SPARE
 86:    KF = +00000;                          TEMP. EXTRUDER CAL. BARREL/PIN
 87:    KF = +00000;                          SPARE
 88:    KF = +00000;                          TEMP. HEAD UPPER PART
 89:    KF = +00000;                          SPARE
 90:    KF = +00000;                          TEMP. HEAD MIDDLE PART
 91:    KF = +00000;                          SPARE
 92:    KF = +00000;                          TEMP. CASSETTE LEFT
 93:    KF = +00000;                          SPARE
 94:    KF = +00000;                          TEMP. CASSETTE RIGHT
 95:    KF = +00000;                          SPARE
 96:    KF = +00000;                          TEMP. CALENDER ROLL TOP
 97:    KF = +00000;                          SPARE
 98:    KF = +00000;                          TEMP. CALENDER ROLL BOTTOM
 99:    KF = +00000;                          SPARE
100:    KF = +00000;                          TREAD LENGTH
101:    KF = +00000;                          SPARE
102:    KG = +0000000+00;                     STRIP WIDTH
104:    KF = +00000;                          TEMP. PREHEATING TABLE
105:    KF = +00000;
106:    KG = +0000000+00;
```

DB WITH ACTUAL DATAS

```
108:    KG = +0000000+00;                    WIND-UP LENGTH
110:    KF = +00000;                         TREAD CHECKER NUMBER O.K.
111:    KF = +00000;                         TREAD CHECKER NUMBER SCRAP
112:    KF = +00000;                         LENGTH MEAS. NUMBER O.K.
113:    KF = +00000;                         LENGTH MEAS. NUMBER SCRAP
114:    KF = +00000;                         NUMBER OF TREADS TOTAL
115:    KF = +00000;                         NUMBER OF TREADS ACCEPTED
116:    KF = +00000;                         NUMBER OF SCRAP TOTAL
117:    KG = +0000000+00;                    NUMBER OF SCRAP %
119:    KF = +00000;                         TREAD CHECKER COUNTER 1 OK
120:    KF = +00000;                         TREAD CHECKER COUNTER 2 OK
121:    KF = +00000;                         TREAD CHECKER COUNTER 1 SCRAP
122:    KF = +00000;                         TREAD CHECKER COUNTER 2 SCRAP
123:    KF = +00000;                         TREAD CHECKER COUNTER 1 TOTAL
124:    KF = +00000;                         TREAD CHECKER COUNTER 2 TOTAL
125:    KF = +00000;                         SCRAP DETECTED COUNTER 1
126:    KF = +00000;                         SCRAP DETECTED COUNTER 2
127:    KF = +00000;                         LENGTH MEASURING DEVICE SCRAP
128:    KG = +0000000+00;                    #### PICTURES
130:    KY = 000,000;                        UPPER EXTRUDER / BOTTOM EXTRUDER
131:    KY = 000,000;                        EXTR. CALENDER /
132:    KG = +0000000+00;
134:    KG = +0000000+00;
136:    KG = +0000000+00;
138:    KG = +0000000+00;
140:    KG = +0000000+00;
142:    KG = +0000000+00;
144:    KG = +0000000+00;
146:    KG = +0000000+00;
148:    KG = +0000000+00;
150:    KG = +0000000+00;
152:    KG = +0000000+00;
154:    KG = +0000000+00;
156:    KG = +0000000+00;
158:    KG = +0000000+00;
160:    KG = +0000000+00;
162:    KG = +0000000+00;
164:    KG = +0000000+00;
166:    KG = +0000000+00;
168:    KG = +0000000+00;
170:    KG = +0000000+00;
172:    KG = +0000000+00;                    PRESSURE CHANNEL 1
174:    KG = +0000000+00;                    PRESSURE CHANNEL 2
176:    KG = +0000000+00;                    CALENDER ARMATURE CURRENT
178:    KG = +0000000+00;                    CALENDER SPEED
180:    KG = +0000000+00;
182:    KG = +0000000+00;
184:    KG = +0000000+00;
186:    KG = +0000000+00;
188:    KG = +0000000+00;
190:    KG = +0000000+00;
192:    KG = +0000000+00;
194:    KG = +0000000+00;
196:    KG = +0000000+00;
198:    KG = +0000000+00;
200:    KG = +0000000+00;
202:    KG = +0000000+00;
204:    KG = +0000000+00;
206:    KG = +0000000+00;
208:    KG = +0000000+00;
210:    C  ='................';              PRODUCTION REPORT PROFILE NAME
218:    KC ='??';                            PROD.REPORT START-TIME HOURS
219:    C  ='??';                            PROD.REPORT START-TIME MINUTES
220:    KC ='................';              OPERATOR-NAME
228:    KG = +0000000+00;
230:    KC ='................';              CHOICE PROFILE
238:    KG = +0000000+00;
240:    KC ='................';              ACTUAL PROFILE
248:    C  ='??';                            START-TIME PROFILE HOURS
249:    KC ='??';                            START-TIME PROFILE MINUTES
250:
```

PROFILE FOR AG-135U

0:	KG = +0000000+00;	K
2:	KG = +2538794+14;	PRODUCER
4:	KG = +2538794+14;	
6:	KG = +2538794+14;	
8:	KG = +2538794+14;	
10:	KG = +0000000+00;	
12:	KG = +0000000+00;	
14:	KG = +2538794+14;	K DATE
16:	KG = +1077953+10;	K YEAR
18:	KG = +3100000+02;	UPPER EXTRUDER SPEED
20:	KG = +1073742+10;	UPPER EXTRUDER CURRENT
22:	KG = +2600000+02;	BOTTOM EXTRUDER SPEED
24:	KG = +3000000+03;	BOTTOM EXTRUDER CURRENT
26:	KG = +0000000+00;	EXTRUDER CALENDER SPEED
28:	KG = +0000000+00;	EXTRUDER CALENDER CURRENT
30:	KG = +0000000+00;	K PROFILE-No. PART B /
32:	KG = +3000000+03;	
34:	KG = +0000000+00;	UP.EXTR. MAX FLOW PR.(WARNING)
36:	KG = +3500000+03;	UP.EXTR. MAX FLOW PR.(TURN OFF)
38:	KG = +2500000+03;	
40:	KG = +3400000+03;	
42:	KG = +2500000+03;	BOT.EXTR. MAX FLOW PR.(WARNING)
44:	KG = +3400000+03;	BOT.EXTR. MAX FLOW PR.(TURN OFF)
46:	KG = +2500000+03;	
48:	KG = +3400000+03;	
50:	KG = +0000000+00;	
52:	KG = +0000000+00;	
54:	KG = +0000000+00;	
56:	KG = +0000000+00;	
58:	KG = +0000000+00;	
60:	KG = +0000000+00;	
62:	KG = +7895752+01;	LINE SPEED
64:	KG = +0000000+00;	LINEAR WEIGHT
66:	KG = +0000000+00;	LINEAR WEIGHT (TOLERANCE)
68:	KG = +1692496+27;	K BOOKING (Y:BOOKING N:WIND UP)
70:	KG = +5000000+00;	TREAD WEIGHT
72:	KG = +1692496+27;	TREAD WEIGHT (TOLERANCE)
74:	KG = +5000000+01;	K PRESET TEMP. UPPER EXTR. SCREW
76:	KG = +5000000+00;	K PRESET TEMP. UPPER EXTR. BARREL
78:	KG = +6250083+00;	K PRESET TEMP. BOTTOM EXTR. SCREW
80:	KG = +6250083+00;	K PRESET TEMP. BOTTOM EXTR. BARREL
82:	KG = +0000000+00;	K PRESET TEMP. EXTR. CAL. HEAD
84:	KG = +0000000+00;	K PRESET TEMP. EXTR. CAL. SCREW
86:	KG = +0000000+00;	K PRESET TEMP. EXTR. CAL. BARREL/P
88:	KG = +6250083+00;	K PRESET TEMP. HEAD UPPER PART
90:	KG = +6250083+00;	K PRESET TEMP. HEAD MEDIUM PART
92:	KG = +6250083+00;	K PRESET TEMP. CASSETTE LEFT
94:	KG = +6250083+00;	K PRESET TEMP. CASSETTE RIGHT
96:	KG = +0000000+00;	K PRESET TEMP. CALENDER ROLL TOP
98:	KG = +0000000+00;	K PRESET TEMP. CALENDER ROLL BOT.
100:	KG = +6250083+00;	K TREAD LENGTH
102:	KG = +0000000+00;	STRIP WIDTH
104:	KG = -2399957+03;	PRESET TEMP. PREHEATING TABLE
106:	KG = +2000000+03;	
108:	KG = +6250000+00;	
110:	KG = +0000000+00;	
112:	KG = +0000000+00;	
114:	KG = +0000000+00;	
116:	KG = +0000000+00;	
118:	KG = +0000000+00;	
120:	KG = +0000000+00;	
122:	KG = +0000000+00;	
124:	KG = +0000000+00;	
126:	KG = +0000000+00;	
128:	KG = +1000000+01;	SPEED +/- UPPER EXTRUDER
130:	KG = +1000000+01;	SPEED +/- BOTTOM EXTRUDER
132:	KG = +9999999-01;	SPEED +/- EXTRUDER CALENDER
134:	KG = +0000000+00;	
136:	KG = +9999999-01;	SPEED +/- LINE
138:	KG = +0000000+00;	HELP DISPLAY LINE SPEED
140:	KG = +0000000+00;	
142:	KG = +0000000+00;	
144:	KG = +0000000+00;	
146:	KG = +0000000+00;	

PROFILE FOR AG-135U

```
148:     KG = +0000000+00;
150:     KG = +0000000+00;
152:     KG = +0000000+00;
154:     KG = +0000000+00;
156:     KG = +0000000+00;
158:     KG = +0000000+00;
160:     KG = +0000000+00;
162:     KG = +0000000+00;
164:     KG = +0000000+00;
166:     KG = +0000000+00;
168:     KG = +0000000+00;
170:     KG = +0000000+00;
172:     KG = +0000000+00;
174:     KG = +0000000+00;
176:     KG = +0000000+00;
178:     KG = +0000000+00;
180:     KG = +0000000+00;
182:     KG = +0000000+00;
184:     KG = +0000000+00;
186:     KG = +0000000+00;
188:     KG = +0000000+00;
190:     KG = +0000000+00;
192:     KG = +0000000+00;
194:     KG = +0000000+00;
196:     KG = +0000000+00;
198:     KG = +0000000+00;
200:     KG = +0000000+00;
202:     KG = +0000000+00;
204:     KG = +0000000+00;
206:     KG = +0000000+00;
208:     KG = +0000000+00;
210:
```

PROFILE NAME AND STATE

```
 0:      KH = 0000;
 1:      KH = 2E2E;
 2:      KH = 2E2E;
 3:      KH = 2E2E;
 4:      KH = 2E2E;
 5:      KH = 2E2E;
 6:      KH = 2E2E;
 7:      KH = 2E2E;
 8:      KH = 2E2E;
 9:      KH = 0000;
10:      KH = 5442;
11:      KH = 2E31;
12:      KH = 3030;
13:      KH = 302E;
14:      KH = 3230;
15:      KH = 2E53;
16:      KH = 4944;
17:      KH = 452E;
18:      KH = 0000;
19:      KH = 0000;
20:      KH = 5442;
21:      KH = 2E31;
22:      KH = 322E;
23:      KH = 3234;
24:      KH = 2E53;
25:      KH = 4944;
26:      KH = 4520;
27:      KH = 2020;
28:      KH = 0000;
29:      KH = 0000;
30:      KH = 5442;
31:      KH = 2E31;
32:      KH = 322E;
33:      KH = 3234;
34:      KH = 2E55;
35:      KH = 4C4E;
36:      KH = 2E2E;
37:      KH = 2E2E;
38:      KH = 0000;
39:      KH = 0000;
40:      KH = 5442;
41:      KH = 2E31;
42:      KH = 322E;
43:      KH = 3234;
44:      KH = 2E55;
45:      KH = 544E;
46:      KH = 2E2E;
47:      KH = 2E2E;
48:      KH = 0000;
49:      KH = 0000;
50:      KH = 5442;
51:      KH = 2E31;
52:      KH = 3030;
53:      KH = 302E;
54:      KH = 3230;
55:      KH = 2E55;
56:      KH = 544E;
57:      KH = 2020;
58:      KH = 0000;
59:      KH = 0000;
60:      KH = 5442;
61:      KH = 2E31;
62:      KH = 3030;
63:      KH = 302E;
64:      KH = 3230;
65:      KH = 2E55;
66:      KH = 4C4E;
67:      KH = 2020;
68:      KH = 0000;
69:      KH = 0000;
70:      KH = 4C54;
71:      KH = 2E37;
72:      KH = 3530;
```

PROFILE NAME FOR DELETE

NAME PROFILE 1

DR: STATE 1=SELECTED

NAME PROFILE 2

DR: STATE 1=SELECTED

NAME PROFILE 3

DR: STATE 1=SELECTED

NAME PROFILE 4

DR: STATE 1=SELECTED

NAME PROFILE 5

DR: STATE 1=SELECTED

NAME PROFILE 6

DR: STATE 1=SELECTED

NAME PROFILE 7

PROFILE NAME AND STATE

```
   73:      KH = 2E31;
   74:      KH = 362E;
   75:      KH = 5554;
   76:      KH = 4E20;
   77:      KH = 2020;
   78:      KH = 0000;                    DR: STATE 1=SELECTED
   79:      KH = 0000;                    ---------------------------------
   80:      KH = 4C54;                    NAME PROFILE 8
   81:      KH = 2E37;
   82:      KH = 3530;
   83:      KH = 2E31;
   84:      KH = 362E;
   85:      KH = 554C;
   86:      KH = 4E20;
   87:      KH = 2020;
   88:      KH = 0000;                    DR: STATE 1=SELECTED
   89:      KH = 0000;                    ---------------------------------
   90:      KH = 4C54;                    NAME PROFILE 9
   91:      KH = 2E37;
   92:      KH = 3530;
   93:      KH = 2E31;
   94:      KH = 362E;
   95:      KH = 4D52;
   96:      KH = 4E20;
   97:      KH = 2020;
   98:      KH = 0000;                    DR: STATE 1=SELECTED
   99:      KH = 0000;                    ---------------------------------
  100:      KH = 4C54;                    NAME PROFILE 10
  101:      KH = 2E37;
  102:      KH = 3030;
  103:      KH = 2E31;
  104:      KH = 362E;
  105:      KH = 4D52;
  106:      KH = 4E20;
  107:      KH = 2020;
  108:      KH = 0000;                    DR: STATE 1=SELECTED
  109:      KH = 0000;                    ---------------------------------
  110:      KH = 5442;                    NAME PROFILE 11
  111:      KH = 2E31;
  112:      KH = 3030;
  113:      KH = 302E;
  114:      KH = 3230;
  115:      KH = 2E48;
  116:      KH = 2E53;
  117:      KH = 4944;
  118:      KH = 0000;                    DR: STATE 1=SELECTED
  119:      KH = 0000;                    ---------------------------------
  120:      KH = 5442;                    NAME PROFILE 12
  121:      KH = 2E31;
  122:      KH = 3030;
  123:      KH = 302E;
  124:      KH = 3230;
  125:      KH = 2E48;
  126:      KH = 2E38;
  127:      KH = 3639;
  128:      KH = 0000;                    DR: STATE 1=SELECTED
  129:      KH = 0000;                    ---------------------------------
  130:      KH = 4147;                    NAME PROFILE 13
  131:      KH = 2E31;
  132:      KH = 3430;
  133:      KH = 302E;
  134:      KH = 3338;
  135:      KH = 2E46;
  136:      KH = 534C;
  137:      KH = 4420;
  138:      KH = 0000;                    DR: STATE 1=SELECTED
  139:      KH = 0000;                    ---------------------------------
  140:      KH = 4147;                    NAME PROFILE 14
  141:      KH = 2E31;
  142:      KH = 382E;
  143:      KH = 342E;
  144:      KH = 3135;
  145:      KH = 2E46;
  146:      KH = 534C;
```

PROFILE NAME AND STATE

```
147:     KH = 2020;
148:     KH = 0000;                          DR: STATE 1=SELECTED
149:     KH = 0000;                          ---------------------------------
150:     KH = 4C54;                          NAME PROFILE 15
151:     KH = 2E38;
152:     KH = 3235;
153:     KH = 2E31;
154:     KH = 362E;
155:     KH = 4D52;
156:     KH = 4E20;
157:     KH = 2020;
158:     KH = 0000;                          DR: STATE 1=SELECTED
159:     KH = 0000;                          ---------------------------------
160:     KH = 2E2E;                          NAME PROFILE 16
161:     KH = 2E2E;
162:     KH = 2E2E;
163:     KH = 2E2E;
164:     KH = 2E2E;
165:     KH = 2E2E;
166:     KH = 2E2E;
167:     KH = 2E2E;
168:     KH = 0000;                          DR: STATE 1=SELECTED
169:     KH = 0000;                          ---------------------------------
170:     KH = 2E2E;                          NAME PROFILE 17
171:     KH = 2E2E;
172:     KH = 2E2E;
173:     KH = 2E2E;
174:     KH = 2E2E;
175:     KH = 2E2E;
176:     KH = 2E2E;
177:     KH = 2E2E;
178:     KH = 0000;                          DR: STATE 1=SELECTED
179:     KH = 0000;                          ---------------------------------
180:     KH = 2E2E;                          NAME PROFILE 18
181:     KH = 2E2E;
182:     KH = 2E2E;
183:     KH = 2E2E;
184:     KH = 2E2E;
185:     KH = 2E2E;
186:     KH = 2E2E;
187:     KH = 2E2E;
188:     KH = 0000;                          DR: STATE 1=SELECTED
189:     KH = 0000;                          ---------------------------------
190:     KH = 2E2E;                          NAME PROFILE 19
191:     KH = 2E2E;
192:     KH = 2E2E;
193:     KH = 2E2E;
194:     KH = 2E2E;
195:     KH = 2E2E;
196:     KH = 2E2E;
197:     KH = 2E2E;
198:     KH = 0000;                          DR: STATE 1=SELECTED
199:     KH = 0000;                          ---------------------------------
200:     KH = 2E2E;                          NAME PROFILE 20
201:     KH = 2E2E;
202:     KH = 2E2E;
203:     KH = 2E2E;
204:     KH = 2E2E;
205:     KH = 2E2E;
206:     KH = 2E2E;
207:     KH = 2E2E;
208:     KH = 0000;                          DR: STATE 1=SELECTED
209:     KH = 0000;                          ---------------------------------
210:     KH = 2E2E;                          NAME PROFILE 21
211:     KH = 2E2E;
212:     KH = 2E2E;
213:     KH = 2E2E;
214:     KH = 2E2E;
215:     KH = 2E2E;
216:     KH = 2E2E;
217:     KH = 2E2E;
218:     KH = 0000;                          DR: STATE 1=SELECTED
219:     KH = 0000;                          ---------------------------------
220:     KH = 2E2E;                          NAME PROFILE 22
```

PROFILE NAME AND STATE

```
221:     KH = 2E2E;
222:     KH = 2E2E;
223:     KH = 2E2E;
224:     KH = 2E2E;
225:     KH = 2E2E;
226:     KH = 2E2E;
227:     KH = 2E2E;
228:     KH = 0000;                    DR: STATE 1=SELECTED
229:     KH = 0000;                    --------------------
230:     KH = 0000;
231:     KH = 0000;
232:     KH = 0000;
233:     KH = 0000;
234:     KH = 0000;
235:     KH = 0000;
236:     KH = 0000;
237:     KH = 0000;
238:     KH = 0000;
239:     KH = 0000;                    --------------------
240:     KH = 5442;                    ACTUAL PROFILE
241:     KH = 2E31;
242:     KH = 322E;
243:     KH = 3234;
244:     KH = 2E53;
245:     KH = 4944;
246:     KH = 4520;
247:     KH = 2020;
248:     KH = 0000;                    DR: STATE 1=SELECTED
249:     KH = 0002;                    DR: PROFILE-No.
250:     KH = 0000;
251:     KH = 0000;
252:     KH = 0000;
253:     KH = 0000;
254:     KH = 0000;
255:     KH = 0000;
256:
```

DB-STAT REZEPTURVERWALTUNG

FLAG'S:

DW 1.0: F-SELECT
DW 1.1: F-LOAD
DW 1.2: F-SAVE
DW 1.3: F-EDIT
DW 1.4: F-EDITA
DW 1.5: F-COPY
DW 1.6: F-RENAME
DW 1.7: F-PRINT
DW 1.8: F-ERASE
DW 1.9: F-SHIFT
DW 1.10:F-REDA
DW 1.11:F-AGDA
DW 1.12:F-CP525

DW 2.0: SAFETY REQUEST 1
DW 2.1: SAFETY REQUEST 2
DW 2.2: SAFETY REQUEST 3

```
  0:    KH = 0000;
  1:    KH = 0000;                    FLAG'S
  2:    KH = 0000;                    FLAG'S
  3:    KH = 0000;                    FOR SELECT: OLD / NEW PROFILE No
  4:    KH = 0000;                    FOR COPY  : FIELD INPUT / SPARE
  5:    KH = 4C54;                    FOR RENAME: NEW NAME
  6:    KH = 2E38;
  7:    KH = 3235;
  8:    KH = 2E31;
  9:    KH = 362E;
 10:    KH = 4D52;
 11:    KH = 4E20;
 12:    KH = 2020;
 13:    KH = 0066;                    MEMORY
 14:    KH = 0000;                    ACTUAL ORDER ON CP527
 15:    KH = 0000;                    PAFE
 16:    KH = 0000;                    ACTUAL ORDER ON CP525
 17:    KH = 0000;                    PAFE
 18:    KH = 2020;                    OUTPUT VALUE FOR WAK'S ON CP527
 19:    KH = 0000;                    GENERAL ORDER FLAGS
 20:    KH = 0000;                    ORDER FOR CP527
 21:    KH = 0000;                      "
 22:    KH = 0000;                      "
 23:    KH = 0000;                    ORDER FOR CP525
 24:    KH = 0000;                      "
 25:    KH = 0000;                      "
 26:    KH = 0000;
 27:    KH = 0000;
 28:    KH = 0000;
 29:    KH = 0000;
 30:    KH = 000A;                    *** PARAMETER FOR CP525 *****
 31:    KH = 0000;                    *
 32:    KH = 4442;                    *
 33:    KH = B922;                    *
 34:    KH = 0000;                    *
 35:    KH = 0000;                    *
 36:    KH = 0000;                    SPARE
 37:    KH = 0000;                    SPARE
 38:    KH = 0000;                    SPARE
 39:    KH = 0000;                    SPARE
 40:    KH = 0007;                    *** PARAMETER FOR CP527 *****
 41:    KH = 0000;                    *
 42:    KH = 4442;                    *
 43:    KH = B92C;                    *
 44:    KH = 0000;                    *
 45:    KH = 0000;                    *
 46:    KH = 0000;                    SPARE
 47:    KH = 0069;                    LENGTH WHOLE PROFILE
 48:    KH = 0000;                    *** PARAMETER FOR
 49:    KH = 0000;                           DB-AGXX TO DB CPXX ***
 50:    KH = 01B4;                    SOURCE: TYPE / NUMBER
```

DB-STAT REZEPTURVERWALTUNG

```
  51:    KH = 0000;
  52:    KH = 01A0;
  53:    KH = 0000;
  54:    KH = 0069;
  55:    KH = 01B5;
  56:    KH = 0000;
  57:    KH = 01A1;
  58:    KH = 0000;
  59:    KH = 0064;
  60:    KH = 0100;
  61:    KH = 0000;
  62:    KH = 0100;
  63:    KH = 0000;
  64:    KH = 0000;
  65:    KH = 0100;
  66:    KH = 0000;
  67:    KH = 0100;
  68:    KH = 0000;
  69:    KH = 0000;
  70:    KH = 01B4;
  71:    KH = 0000;
  72:    KH = 0179;
  73:    KH = 0000;
  74:    KH = 0069;
  75:    KH = 0100;
  76:    KH = 0000;
  77:    KH = 0100;
  78:    KH = 0000;
  79:    KH = 0064;
  80:    KH = 0100;
  81:    KH = 0000;
  82:    KH = 0100;
  83:    KH = 0000;
  84:    KH = 0000;
  85:    KH = 0100;
  86:    KH = 0000;
  87:    KH = 0100;
  88:    KH = 0000;
  89:    KH = 0000;
  90:    KH = 0100;
  91:    KH = 0000;
  92:    KH = 0100;
  93:    KH = 0000;
  94:    KH = 0000;
  95:    KH = 0000;
  96:    KH = 0000;
  97:    KH = 0000;
  98:    KH = 0000;
  99:    KH = 0000;
 100:    KH = 0166;
 101:    KH = 0000;
 102:    KH = 01A0;
 103:    KH = 0000;
 104:    KH = 0069;
 105:    KH = 0000;
 106:    KH = 0000;
 107:    KH = 0000;
 108:    KH = 0000;
 109:    KH = 0000;
 110:    KH = 01B8;
 111:    KH = 0014;
 112:    KH = 01AA;
 113:    KH = 00E6;
 114:    KH = 0008;
 115:    KH = 0000;
 116:    KH = 0000;
 117:    KH = 0000;
 118:    KH = 0000;
 119:    KH = 0000;
 120:    KH = 01B8;
 121:    KH = 00F0;
 122:    KH = 01AA;
 123:    KH = 00F0;
 124:    KH = 0008;
```

OFFSET: SOURCE
TARGET: TYPE / NUMBER
OFFSET: TARGET
LENGTH ----------

*** PARAMETER FOR
DB-AGXX TO DB-RZXX ***

*** PARAMETER COPY
DB-RZXX TO DB-CPXX ***
SOURCE: TYPE / NUMBER
OFFSET: SOURCE
TARGET: TYPE / NUMBER
OFFSET: TARGET
LENGTH ----------

*** PROFILE NAME FOR EDIT
WRITE TO DB170 ***
SOURCE: TYPE / NUMBER
OFFSET: SOURCE
TARGET: TYPE / NUMBER
OFFSET: TARGET
LENGTH ----------

*** ACTUAL PROFILE NAME FROM
DB184 TO DB 170 ***
SOURCE: TYP / NUMBER
OFFSET: SOURCE
TARGET: TYP / NUMBER
OFFSET: TARGET
LENGTH ----------

```
125:      KH = 0000;
126:      KH = 0000;
127:      KH = 0000;
128:      KH = 0000;
129:      KH = 0000;
130:      KH = 0000;
131:      KH = 0000;
132:      KH = 01A6;
133:      KH = 0000;
134:      KH = 003C;
135:      KH = 0100;
136:      KH = 024E;
137:      KH = 01A7;
138:      KH = 0000;
139:      KH = 005A;
140:      KH = 0100;
141:      KH = 02A8;
142:      KH = 01A8;
143:      KH = 0000;
144:      KH = 000A;
145:      KH = 0000;
146:      KH = 0000;
147:      KH = 0000;
148:      KH = 0000;                    *** PARAMETER COPY
149:      KH = 0000;                        DB-CPXX TO DB-AGXX     ***
150:      KH = 01A0;                    SOURCE: TYPE / NUMBER
151:      KH = 0000;                    OFFSET: SOURCE
152:      KH = 01B4;                    TARGET: TYPE / NUMBER
153:      KH = 0000;                    OFFSET: TARGET
154:      KH = 0069;                    LENGTH   ----------------------1
155:      KH = 01A1;
156:      KH = 0000;
157:      KH = 01B5;
158:      KH = 0000;
159:      KH = 0064;
160:      KH = 01A2;
161:      KH = 0000;
162:      KH = 01B6;
163:      KH = 0000;
164:      KH = 0028;
165:      KH = 01A3;
166:      KH = 0000;
167:      KH = 01B7;
168:      KH = 0000;
169:      KH = 0046;
170:      KH = 01A4;
171:      KH = 0000;
172:      KH = 01B8;
173:      KH = 0000;
174:      KH = 0032;
175:      KH = 01A5;
176:      KH = 0000;
177:      KH = 01B9;
178:      KH = 0000;
179:      KH = 0064;
180:      KH = 01A6;
181:      KH = 0000;
182:      KH = 01BA;
183:      KH = 0000;
184:      KH = 003C;
185:      KH = 01A7;
186:      KH = 0000;
187:      KH = 01BB;
188:      KH = 0000;
189:      KH = 005A;
190:      KH = 01A8;
191:      KH = 0000;
192:      KH = 01BC;
193:      KH = 0000;
194:      KH = 000A;
195:      KH = 0000;
196:      KH = 0000;
197:      KH = 0000;
198:      KH = 0000;                    *** PARAMETER COPY
```

DB-STAT REZEPTURVERWALTUNG

```
199:     KH = 0000;
200:     KH = 01A0;
201:     KH = 0000;
202:     KH = 0166;
203:     KH = 0000;
204:     KH = 0069;
205:     KH = 01A1;
206:     KH = 0000;
207:     KH = 0100;
208:     KH = 00AA;
209:     KH = 0064;
210:     KH = 01A2;
211:     KH = 0000;
212:     KH = 0100;
213:     KH = 010E;
214:     KH = 0028;
215:     KH = 01A3;
216:     KH = 0000;
217:     KH = 0100;
218:     KH = 0136;
219:     KH = 0046;
220:     KH = 01A4;
221:     KH = 0000;
222:     KH = 0100;
223:     KH = 017C;
224:     KH = 0032;
225:     KH = 01A5;
226:     KH = 0000;
227:     KH = 0100;
228:     KH = 01AE;
229:     KH = 0064;
230:     KH = 01A6;
231:     KH = 0000;
232:     KH = 0100;
233:     KH = 0212;
234:     KH = 003C;
235:     KH = 01A7;
236:     KH = 0000;
237:     KH = 0100;
238:     KH = 024E;
239:     KH = 005A;
240:     KH = 01A8;
241:     KH = 0000;
242:     KH = 0100;
243:     KH = 02A8;
244:     KH = 000A;
245:     KH = 0000;
246:     KH = 0000;
247:     KH = 0000;
248:
```

DB-CPXX TO DB-RZXX ***
SOURCE: TYPE / NUMBER
OFFSET: SOURCE
TARGET: TYPE / NUMBER
OFFSET: TARGET
LENGTH ----------1

BILDUMSCHALTUNGEN

```
 0:    KH = 0000;                    ######### DISPLAY 01 ###########
 1:    KY = 000,000;                 UPPER EXTRUDER / AUX.DR. UP.EX.
 2:    KY = 000,000;                 BOTTOM EXTRUDER/ AUX.DR. BOT.EX.
 3:    KY = 000,000;                 EXTRUDER CAL.  / AUX.DR. EX.CAL.
 4:    KY = 000,000;                 EXTRUSION HEAD /
 5:    KY = 000,000;
 6:    KY = 000,000;
 7:    KY = 000,000;                 CON.TAKE+SHRINK/ CON.SCALE1
 8:    KY = 000,000;                 CON.CALANDER   / CON.CEMENTING 2
 9:    KY = 000,000;                 FEED.CONV.CAL. /
10:    KY = 000,000;                 CON.COOL 1.1   / CON.COOL 1.2
11:    KY = 000,000;                 CON.COOL 2     / CON.COOL 3
12:    KY = 000,000;                 CON.COOL 4.1   / CON.COOL 4.2
13:    KY = 000,000;                 CON.SEPAR.DEV. / CON.SKIVER
14:    KY = 000,000;                 CON.WIND UP    / CON.SCALE2
15:    KY = 000,000;                 CON.LENGTH     / CON.CEM
16:    KY = 000,000;                 CON.BOOKING    / CON.REJECTS
17:    KY = 000,000;
18:    KY = 000,000;                 EXHA.SHRINKAGE / EXHA.CEM.DEV.1
19:    KY = 000,000;                 EXHA.CEM.DEV.2 / EXHA.TREAD END
20:    KY = 000,000;
21:    KY = 000,000;                 SCALE1 --      / SCALE1 -
22:    KY = 000,000;                 SCALE1 OK      / SCALE1 FAULT
23:    KY = 000,000;                 SCALE1 ++      / SCALE1 +
24:    KY = 000,000;                 WIDTH -        / WIDTH +
25:    KY = 000,000;                 WIDTH OK       / WIDTH FAULT
26:    KY = 000,000;                 CEM.DEV.1      / CEM.DEV.2
27:    KY = 000,000;                 CALENDER       / COOLING UNIT
28:    KY = 000,000;                 SEPARATING DEV./ TREAD SKIVER
29:    KY = 000,000;                 WIND UP 1      / WIND UP 2
30:    KY = 000,000;                 WIND UP 3      / WIND UP 4
31:    KY = 000,000;                 SCALE2 --      / SCALE2 -
32:    KY = 000,000;                 SCALE2 OK      / SCALE2 FAULT
33:    KY = 000,000;                 SCALE2 ++      / SCALE2 +
34:    KY = 000,000;                 LENGTH -       / LENGTH +
35:    KY = 000,000;                 LENGTH OK      / LENGTH FAULT
36:    KY = 000,000;                 CUT END CEM.   /
37:    KY = 000,000;
38:    KY = 000,000;
39:    KY = 000,000;
40:    KY = 000,000;
41:    KY = 000,000;
42:    KY = 000,000;
43:    KY = 000,000;
44:    KY = 000,000;
45:    KH = 0000;                    ######### DISPLAY 02 ###########
46:    KY = 000,000;                 UPPER EXTRUDER / AUX.DR. UP.EX.
47:    KY = 000,000;                 BOTTOM EXTRUDER/ AUX.DR. BOT.EX.
48:    KY = 000,000;                 CLAMPS TOP     / CLAMPS BOTTOM
49:    KY = 000,000;                 LOCK.CYLINDER  / CASSETTE
50:    KY = 000,000;                 EXTRUSION HEAD
51:    KY = 000,000;
52:    KY = 000,000;
53:    KY = 000,000;
54:    KY = 000,000;
55:    KY = 000,000;
56:    KH = 0000;                    ######### DISPLAY 03 ###########
57:    KY = 000,000;                 CON.TAKE AWAY + SHRINKAGE
58:    KY = 000,000;                 CON.SCALE1     / CON.CALENDER
59:    KY = 000,000;                 CON.CEMENTING 2/ FEED.CONV.CAL.
60:    KY = 000,000;                 EXH.SHRINKAGE  / EXH.CEM.1
61:    KY = 000,000;                 EXH.CEM.2      /
62:    KY = 000,000;                 LOOP SCALE1    / LOOP CEM.1
63:    KY = 000,000;                 LOOP CEM.2
64:    KY = 000,000;                 SCALE1 --      / SCALE1 -
65:    KY = 000,000;                 SCALE1 OK      / SCALE1 FAULT
66:    KY = 000,000;                 SCALE1 ++      / SCALE1 +
67:    KY = 000,000;                 WIDTH -        / WIDTH +
68:    KY = 000,000;                 WIDTH OK       / WIDTH FAULT
69:    KY = 000,000;                 CEM.DEV.1      / CEM.DEV.2
70:    KY = 000,000;                 EXTRUDER CAL.  / AUX.DR. EX.CAL.
71:    KY = 000,000;                 CALENDER       / AUX.DRIVES CAL.
72:    KY = 000,000;
73:    KY = 000,000;
```

BILDUMSCHALTUNGEN

```
   74:      KY = 000,000;
   75:      KH = 0000;
   76:      KY = 000,000;
   77:      KY = 000,000;
   78:      KY = 000,000;
   79:      KY = 000,000;
   80:      KY = 000,000;
   81:      KY = 000,000;
   82:      KY = 000,000;
   83:      KY = 000,000;
   84:      KY = 000,000;
   85:      KY = 000,000;
   86:      KY = 000,000;
   87:      KY = 000,000;
   88:      KY = 000,000;
   89:      KY = 000,000;
   90:      KH = 0000;
   91:      KY = 000,000;
   92:      KY = 000,000;
   93:      KY = 000,000;
   94:      KY = 000,000;
   95:      KY = 000,000;
   96:      KY = 000,000;
   97:      KY = 000,000;
   98:      KY = 000,000;
   99:      KY = 000,000;
  100:      KY = 000,000;
  101:      KY = 000,000;
  102:      KY = 000,000;
  103:      KY = 000,000;
  104:      KY = 000,000;
  105:      KH = 0000;
  106:      KY = 000,000;
  107:      KY = 000,000;
  108:      KY = 000,000;
  109:      KY = 000,000;
  110:      KY = 000,000;
  111:      KY = 000,000;
  112:      KY = 000,000;
  113:      KY = 000,000;
  114:      KY = 000,000;
  115:      KH = 0000;
  116:      KY = 000,000;
  117:      KY = 000,000;
  118:      KY = 000,000;
  119:      KY = 000,000;
  120:      KY = 000,000;
  121:      KY = 000,000;
  122:      KY = 000,000;
  123:      KY = 000,000;
  124:      KY = 000,000;
  125:
```

```
########## DISPLAY 04 ##########
LOOP COOL.1      / LOOP COOL.1-2
LOOP COOL.2-3    / LOOP COOL.3-4
LOOP SKIVER
CON.COOL.1
CON.COOL.2       / CON.COOL.3
CON.COOL.4
CON.SEPAR.DEV.   / CON.SKIVER

COOLING UNIT     / SEPAR.DEV.
TREAD SKIVER



########## DISPLAY 05 ##########
CON.WIND UP      / CON.SCALE2
CON.SLOW.DOWN    / CON.TRAD END C.
CON.BOOKING      / CON.TREAD SLIT.

WIND-UP 1        / WIND-UP 2
WIND-UP 3        / WIND-UP 4

SCALE2 --        / SCALE2 -
SCALE2 OK        / SCALE2 FAULT
SCALE2 ++        / SCALE2 +

EXH.TREAD END    / TREAD END CEM.

########## DISPLAY 06 ##########
UPPER EX.SCREW /UPPER EX.BARREL
BOTTOM EX.SCREW/BOTTOM EX.BARREL
EX.CAL.SCREW    /EX.CAL.BARREL 1
EX.CAL.BARREL 2
EXTRUSION HEAD / CASSETTE
CALENDER



################################
```

```
KH = 0000;                    #### TIME ASCII ################
KH = 0000;                    HOUR
KH = 0000;                    MINUTE
KH = 0000;                    SECOND
KH = 0000;                    DAY
KH = 0000;                    MONTH
KH = 0000;                    YEAR
KH = 0000;
KH = 0000;
KH = 0000;
KH = 0000;
KH = 0000;
KH = 0000;
KH = 0000;
KH = 0000;
KH = 0000;
KH = 0000;                    #### TIME CP525 ################
KH = 0000;                    SLAVE IDENTIFICATION
KH = 0000;                    1/10   / SECOND
KH = 0000;                    MINUTE / HOUR
KH = 0000;                    DAY    / MONTH
KH = 0000;                    YEAR   / ---
```

```
  0:    KY = 000,000;
  1:    KH = 0000;
  2:    KH = 0000;
  3:    KH = 0000;
  4:    KH = 0000;
  5:    KH = 0000;
  6:    KH = 0000;
  7:    KH = 0000;
  8:    KH = 0000;
  9:    KH = 0000;
 10:    KH = 0000;
 11:    KH = 0000;
 12:    KH = 0000;
 13:    KH = 0000;
 14:    KH = 0000;
 15:    KH = 0000;
 16:    KH = 0000;
 17:    KH = 0000;
 18:    KH = 0000;
 19:    KH = 0000;
 20:    KH = 0000;
 21:    KH = 0000;
 22:    KH = 0000;
 23:    KH = 0000;
 24:    KH = 0000;
 25:    KH = 0000;
 26:    KH = 0000;
 27:    KH = 0000;
 28:    KH = 0000;
 29:    KH = 0000;
 30:    KH = 0000;
 31:    KH = 0000;
 32:    KH = 0000;
 33:    KH = 0000;
 34:    KH = 0000;
 35:    KH = 0000;
 36:    KH = 0000;
 37:    KH = 0000;
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251:      KH = 0000;
252:      KH = 0000;
253:      KH = 00B5;
254:      KH = 000E;
255:      KH = 0000;
256:
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  0:    KY = 000,000;
  1:    KH = 0000;
  2:    KH = 0000;
  3:    KH = 0000;
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    0:      KM = 00000000 00000000;
    1:      KF = +00000;
    2:      KF = +00000;
    3:      KH = 0000;
    4:      KH = 0000;
    5:      KH = 0000;
    6:      KH = 0000;
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     0:      KY = 000,000;
     1:      KH = 0000;
     2:      KH = 0000;
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    43:      KH = 0000;
    44:      KH = 0000;
    45:      KH = 0000;
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    70:      KH = 0000;
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    73:      KH = 0000;
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222:      KH = 0000;
223:      KH = 0000;
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229:      KH = 0000;
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249:      KH = 0000;
250:      KH = 0000;
251:      KH = 0000;
252:      KH = 0000;
253:      KH = 0000;
254:      KH = 0000;
255:      KH = 0000;
256:
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  0:     KY = 003,000;
  1:     KY = 170,001;
  2:     KY = 003,000;
  3:     KY = 172,001;
  4:     KY = 003,000;
  5:     KY = 174,001;
  6:     KY = 003,000;
  7:     KY = 176,001;
  8:     KY = 003,000;
  9:     KY = 178,001;
 10:     KY = 003,000;
 11:     KY = 180,001;
 12:     KY = 003,000;
 13:     KY = 182,001;
 14:     KY = 003,000;
 15:     KY = 184,001;
 16:     KY = 003,000;
 17:     KY = 186,001;
 18:     KY = 003,000;
 19:     KY = 188,001;
 20:     KH = 0300;
 21:     KH = BE01;
 22:     KH = 0300;
 23:     KH = C001;
 24:     KH = 0300;
 25:     KH = C201;
 26:     KH = 0300;
 27:     KH = C401;
 28:     KH = FFFF;
 29:     KH = FFFF;
 30:
```

QUERVERWEISLISTE: EINGAENGE

```
   PB     1 : BEARBEITET
   PB     3 : BEARBEITET
   PB     6 : BEARBEITET
   PB     7 : BEARBEITET
   PB     8 : BEARBEITET
   PB     9 : BEARBEITET
   PB    10 : BEARBEITET
   PB    11 : BEARBEITET
   PB    12 : BEARBEITET
   PB    13 : BEARBEITET
   PB    14 : BEARBEITET
   PB    15 : BEARBEITET
   PB    16 : BEARBEITET
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   PB    20 : BEARBEITET
   PB    21 : BEARBEITET
   PB    30 : BEARBEITET
   PB    31 : BEARBEITET
   PB    40 : BEARBEITET
   PB    41 : BEARBEITET
   PB    42 : BEARBEITET
   PB    55 : BEARBEITET
   PB    60 : BEARBEITET
   PB    61 : BEARBEITET
   PB    79 : BEARBEITET
   PB    80 : BEARBEITET
   PB    81 : BEARBEITET
   PB    82 : BEARBEITET
   PB    83 : BEARBEITET
   PB    84 : BEARBEITET
   PB    85 : BEARBEITET
   PB    86 : BEARBEITET
   PB    87 : BEARBEITET
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   PB    91 : BEARBEITET
   PB    92 : BEARBEITET
   PB    93 : BEARBEITET
   PB    95 : BEARBEITET
   PB   100 : BEARBEITET
   PB   101 : BEARBEITET
   PB   253 : BEARBEITET
   PB   255 : BEARBEITET
   FB    1S: BEARBEITET
   FB    2S: BEARBEITET
   FB    3S: BEARBEITET
   FB    4S: BEARBEITET
   FB    5S: BEARBEITET
   FB    6S: BEARBEITET
   FB   10S: BEARBEITET
   FB   11S: BEARBEITET
   FB   12S: BEARBEITET
   FB   13S: BEARBEITET
   FB.  23 : BEARBEITET
   FB'  33 : BEARBEITET
   FB,  39 : BEARBEITET
   FB   40S: BEARBEITET
   FB   41S: BEARBEITET
   FB   43 : BEARBEITET
   FB   44 : BEARBEITET
   FB   46 : BEARBEITET
   FB   47 : BEARBEITET
   FB   48 : BEARBEITET
   FB.  50 : BEARBEITET
   FB'  51 : BEARBEITET
   FB'  52 : BEARBEITET
   FB   53 : BEARBEITET
   FB   54 : BEARBEITET
   FB   55 : BEARBEITET
   FB   57 : BEARBEITET
   FB   58 : BEARBEITET
   FB   72 : BEARBEITET
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK                !                                !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE          !  DATE        :                     !
! INSTALLATION     : TREAD-LINE           !  MODIFICATION:                PGNO!
! PROJECT POS. NO.: 84/823804             !  PROGRAMMER  :                   1!
+-------------------------------------------------------------------------------+
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QUERVERWEISLISTE: EINGAENGE

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    FB   73 : BEARBEITET
    FB   74 : BEARBEITET
    FB   75 : BEARBEITET
    FB   76 : BEARBEITET
    FB   77 : BEARBEITET
    FB   78 : BEARBEITET
    FB   80 : BEARBEITET
    FB   82 : BEARBEITET
    FB   83*: BEARBEITET
    FB   84*: BEARBEITET
    FB   86 : BEARBEITET
    FB   87 : BEARBEITET
    FB   88 : BEARBEITET
    FB   89 : BEARBEITET
    FB   90 : BEARBEITET
    FB   91*: BEARBEITET
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    FB   93 : BEARBEITET
    FB   95 : BEARBEITET
    FB   96 : BEARBEITET
    FB   98 : BEARBEITET
    FB   99 : BEARBEITET
    FB  100 : BEARBEITET
    FB  110 : BEARBEITET
    FB  112 : BEARBEITET
    FB  113 : BEARBEITET
    FB  115 : BEARBEITET
    FB  116 : BEARBEITET
    FB  118 : BEARBEITET
    FB  120S: BEARBEITET
    FB  121S: BEARBEITET
    FB  122S: BEARBEITET
    FB  123S: BEARBEITET
    FB  124S: BEARBEITET
    FB  125S: BEARBEITET
    FB  126S: BEARBEITET
    FB  127S: BEARBEITET
    FB  130S: BEARBEITET
    FB  141S: BEARBEITET
    FB  142S: BEARBEITET
    FB  143S: BEARBEITET
    FB  144S: BEARBEITET
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    FB  152S: BEARBEITET
    FB  153S: BEARBEITET
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    FB  173 : BEARBEITET
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    FB  187 : BEARBEITET
    FB  188 : BEARBEITET
    FB  189 : BEARBEITET
    FB  190*: BEARBEITET
    FB  191 : BEARBEITET
    FB  192 : BEARBEITET
    FB  193 : BEARBEITET
    FB  194 : BEARBEITET
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QUERVERWEISLISTE: EINGAENGE

```
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   FB  196S: BEARBEITET
   FB  199 : BEARBEITET
   FB  202 : BEARBEITET
   FB  203 : BEARBEITET
   FB  254 : BEARBEITET
   FB  255 : BEARBEITET
   OB    1 : BEARBEITET
   OB   13 : BEARBEITET
   OB   20 : BEARBEITET
   OB   21 : BEARBEITET
   OB   22 : BEARBEITET
```

QUERVERWEISLISTE: EINGAENGE

E	0.0 -45A3	PB 20	6 , 7
E	0.1 -45A6	PB 20	4
E	0.2 -43A1.1	PB 20	8 , 24
E	0.3 -43A1.2	PB 20	9 , 24
E	0.5 -45K1	PB 20	29
E	0.6 -46Q1	PB 20	2 , 24
E	0.7 -46Q3	PB 20	3 , 24
E	1.0 -50A3.1	PB 30	6 , 7
E	1.1 -50A3.2	PB 30	4
E	1.2 -48A1.1	PB 30	8 , 24
E	1.3 -48A1.2	PB 30	9 , 24
E	1.5 -50K1	PB 30	29
E	1.6 -51Q1	PB 30	2 , 24
E	1.7 -51Q3	PB 30	3 , 24
E	2.0 -64Q2	PB 11	2 , 5
E	2.1 -72Q1	PB 82	10
		FB191	5
E	2.2 -72A7	PB 82	11
		FB191	5
E	2.3 -74K5	PB 79	1
		FB191	3
E	2.4 -78K5	PB 79	4
		FB191	3
E	2.5 -79Q2	PB 82	30
		FB191	5
E	2.6 -79A7	PB 82	31
		FB191	5
E	2.7 -80Q2	PB 42	9 , 11 , 31 , 32
E	3.0 -82K5	PB 42	8 , 11 , 16
E	3.1 -86A3	PB 40	5 , 6
E	3.2 -84A1/1	PB 40	8 , 27
E	3.3 -84A1/2	PB 40	9 , 27
E	3.5 -86K1	PB 40	32
E	3.6 -87Q1	PB 40	2 , 27
E	3.7 -87Q3	PB 40	3 , 27
E	4.0 -87Q5	PB 40	4
E	4.1 -90K5	PB 91	30
		FB191	3
E	4.2 -93A3	PB 90	14 , 15
E	4.3 -93A6	PB 90	16
		PB 91	14

QUERVERWEISLISTE: EINGAENGE

		FB191	6
E	4.4 -91A1/1	PB 90	17
		PB 91	14
		FB191	6
E	4.5 -91A1/2	PB 90	18
		PB 91	14
		FB191	6
E	4.7 -93K1	PB 91	9 , 12
E	5.0 -96Q1	PB 90	8
		PB 91	14
		FB191	6
E	5.1 -96Q4	PB 90	6
		PB 91	14
		FB191	6
E	5.2 -96Q6	PB 90	7
		PB 91	14
		FB191	6
E	5.3 -97Q1	PB 90	9
		PB 91	14
		FB191	6
E	5.4 -94Q1	PB 92	3 , 4
E	5.5 -95Q1	PB 92	6 , 7
E	5.6 -98Q1	PB 92	8 , 9
E	5.7 -98Q3	PB 92	10 , 11
E	6.0 -101K5	PB 79	7
		FB191	3
E	6.1 -102Q2	PB 82	32
		FB191	5
E	6.2 -102A6	PB 82	33
		FB191	5
E	6.3 -104K5	PB 79	10
		FB191	3
E	6.4 -106K5	PB 79	11
		FB191	3
E	6.5 -109K5	PB 79	12
		FB191	3
E	6.6 -111K5	PB 79	13
		FB191	3
E	7.0 -107F1	PB 80	5 , 10
		PB 82	40
E	7.1 -102A8	PB 82	41
E	7.3 -E 7.3	PB 82	39
E	7.4 -114K5	PB 79	17
		FB191	3
E	7.5 -116K5	PB 79	14
		FB191	3
E	7.6 -121K5	PB 79	18
		FB191	3
E	7.7 -129K5	PB 79	19

QUERVERWEISLISTE: EINGAENGE

			FB191	3
E	8.0	-131Q1	PB 79	22
			FB191	3
E	8.1	-132Q1/Q3	PB 79	23
			FB191	3
E	8.2	-133Q1	PB 82	42
			FB191	5
E	8.3	-133A7	PB 82	43
			FB191	5
E	8.4	-136Q1/Q3	PB 79	24
			FB191	3
E	8.6	-27F2	PB 9	5
E	8.7	-28SP0	PB 9	6
E	9.0	-86A6	PB 40	7
E	10.0	-E 10.0	PB 79	2
E	10.1	-E 10.1	PB 79	5
E	10.2	-E 10.2	PB 79	8
E	10.3	-E 10.3	PB 79	3
E	10.4	-E 10.4	PB 79	6
E	10.5	-E 10.5	PB 79	9
E	10.6	-E 10.6	PB 79	15
E	10.7	-E 10.7	PB 79	16
E	11.0	-E 11.0	PB 79	20
E	11.1	-E 11.1	PB 79	21
E	20.0	-A320	PB 9	6
			PB 20	10
E	20.1	-234S2	PB 20	5
E	20.2	-234S3	PB 20	11
E	20.3	-234S4	PB 20	12 , 22
E	20.4	-234S5	PB 20	20 , 21
E	20.5	-234S6	PB 20	13 , 22
E	25.0	-A420	PB 9	6
			PB 30	10
E	25.1	-239S2	PB 30	5
E	25.2	-239S3	PB 30	11
E	25.3	-239S4	PB 30	12 , 22
E	25.4	-239S5	PB 30	20 , 21
E	25.5	-239S6	PB 30	13 , 22
E	25.6	-E 25.6	PB 82	34
E	30.0	-244S1	PB 10	3 , 4
			PB 19	2

QUERVERWEISLISTE: EINGAENGE

E	30.1 -244S2	PB 10	3 , 4
		PB 19	2
E	30.2 -244S3	PB 10	3 , 4
		PB 19	4
E	30.3 -244S4	PB 10	3 , 4
		PB 19	4
E	30.4 -244S5	PB 10	5 , 6
		PB 19	6
		FB255	1
E	30.5 -244S6	PB 10	5 , 6
		PB 19	6
		FB255	1
E	30.6 -244S7	PB 10	5 , 6
		PB 19	8
		FB255	1
E	30.7 -244S8	PB 10	5 , 6
		PB 19	8
		FB255	1
E	31.0 -245S9	PB 10	7 , 8
		PB 19	10
E	31.1 -245S10	PB 10	7 , 8
		PB 19	10
E	31.2 -245S11	PB 12	2 , 3 , 4 , 7 , 8 , 14
		PB 17	2
		FB255	1
E	31.3 -245S12	PB 10	9 , 10
		PB 19	12
E	31.4 -245S13	PB 10	9 , 10
		PB 19	12
E	31.5 -245S14	PB 12	2 , 4 , 14
		PB 13	2 , 3 , 4 , 7 , 14
		PB 14	29
		PB 17	2
		FB255	1
E	31.6 -245S15	PB 10	11 , 12
		PB 19	14
E	31.7 -245S16	PB 10	11 , 12
		PB 19	14
E	32.0 -246S17	PB 10	13 , 14
E	32.1 -246S18	PB 10	13 , 14
E	32.2 -246S19	PB 10	15 , 16
		PB 19	16
		FB255	1
E	32.3 -246S20	PB 10	15 , 16
		PB 19	16
		FB255	1
E	32.4 -246S21	PB 10	17 , 18
		PB 19	18
E	32.5 -246S22	PB 10	17 , 18
		PB 19	18
E	32.6 -246S23	PB 10	19 , 20
		PB 19	20
		FB255	1

QUERVERWEISLISTE: EINGAENGE

E	32.7 -246S24	PB 10	19 , 20
		PB 19	20
		FB255	1
E	33.0 -247S25	PB 12	4 , 8
E	33.1 -247S26	PB 13	8
E	33.2 -247S27	PB 10	21 , 22
		PB 19	22
E	33.3 -247S28	PB 10	21 , 22
		PB 19	22
E	33.4 -247S29	PB 14	39 , 41
E	33.5 -247S30	PB 15	18
		PB 17	5 , 6
E	33.6 -247S31	PB 15	18
E	33.7 -247S32	PB 17	6
E	34.0 -248S33	PB 11	23
E	34.1 -248S34	PB 10	24
		PB 14	44
		PB 15	4
		PB 17	3 , 4 , 6
E	34.2 -248S35	PB 14	11 , 44
E	34.4 -248S37	PB 11	23
		PB 14	41
E	34.6 -248S46	PB 12	2 , 4
		PB 13	2 , 4
		PB 14	17
		PB 15	2
		PB 16	2 , 4 , 6 , 8
E	34.7 -248S47	PB 16	4 , 6 , 8
E	35.0 -249S1	PB 16	2 , 8
E	35.1 -249S2.1	PB 16	2
E	35.2 -249S2.2	PB 16	4
E	35.3 -249S4.1	PB 16	6
E	35.4 -249S4.2	PB 16	8
E	35.5 -E 35.5	PB 11	4 , 23
		PB 15	19
		PB 17	7 , 8
E	35.6 -E 35.6	PB 11	3
E	35.7 -E 35.7	PB 9	6
		PB 10	2
E	36.0 -250S41.1	PB 15	3 , 6 , 11
E	36.1 -250S41.2	PB 15	3 , 4 , 9
		PB 21	4
		PB 31	4
		PB 41	4
E	36.2 -250S42.1	PB 15	3 , 6
E	36.3 -250S42.2	PB 15	4
		PB 21	4

QUERVERWEISLISTE: EINGAENGE

			PB 31	4
			PB 41	4
E	36.4	-250S43.1	PB 13	4 , 14
			PB 14	2 , 3
E	36.5	-250S43.2	PB 13	2
			PB 14	3 , 17
E	36.6	-250S44.1	PB 12	4 , 14
E	36.7	-250S44.2	PB 12	2
			PB 14	45
E	37.0	-E37.0	PB 14	20 , 39
E	40.1	-A925.11	FB 88	2
E	40.2	-A925.12	FB 88	2
E	40.3	-A925.13	FB 88	2
E	40.4	-A925.14	FB 88	2
E	40.5	-A925.21	FB 88	2
E	40.6	-A925.22	FB 88	2
E	40.7	-A925.23	FB 88	2
E	41.0	-A925.24	FB 88	2
E	41.1	-A925.31	FB 88	2
E	41.2	-A925.32	FB 88	2
E	41.3	-A925.33	FB 88	2
E	41.4	-A925.34	FB 88	2
E	41.5	-A925.41	FB 88	2
E	41.6	-A925.42	FB 88	2
E	41.7	-A925.43	FB 88	2
E	42.0	-A925.44	FB 88	2
E	42.1	-A925.01	PB 88	3
			FB 93	2
E	42.2	-A925.02	PB 88	4
E	42.3	-A925.03	PB 88	5
E	42.4	-A925.04	PB 88	2 , 6
			FB 88	2
E	42.6	-E 42.6	PB 80	8
			PB 82	35
E	42.7	-E 42.7	PB 82	36
E	43.0	-A925.5	FB 83	1
E	43.1	-A925.61	FB 83	1
E	43.2	-A925.62	FB 83	1
E	43.3	-A925.63	FB 83	1
E	43.4	-A925.64	FB 83	1
E	43.5	-A925.71	FB 83	1

QUERVERWEISLISTE: EINGAENGE

E	43.6 -A925.72	FB 83	1
E	43.7 -A925.73	FB 83	1
E	44.0 -A925.74	FB 83	1
E	44.1 -A925.81	FB 83	1
E	44.2 -A925.82	FB 83	1
E	44.3 -A925.83	FB 83	1
E	44.4 -A925.84	FB 83	1
E	44.5 -A925.91	FB 83	1
E	44.6 -A925.92	FB 83	1
E	44.7 -	FB 83	1
E	45.0 -A925.94	FB 83	1
E	45.1 -A925.0	PB 84	2 , 4
		FB 84	2
E	45.2 -A925	PB 84	6 , 7
		FB 84	2
E	45.3 -E 45.3	PB101	3
E	45.5 -E 45.5	PB 81	17?
E	45.6 -E 45.6	PB 81	17?
E	45.7 -E 45.7	PB 81	5
E	46.0 -264S1	PB 82	38
E	46.1 -264S2	PB 80	8
		PB 82	37
E	46.2 -A900.0	PB 9	6
		PB 82	8
E	46.3 -A900.1	PB 9	6
		PB 82	6
E	46.4 -A900.2	PB 9	6
		PB 82	2
E	46.5 -E 46.5	PB 80	8
		PB 82	46
E	46.7 -E 46.7	PB 81	4
E	50.0 -273S2	PB 42	18
E	50.1 -273S3.	PB 42	18
E	50.3 -83A3	PB 42	33 , 40 , 41 , 42
E	50.4 -273B8	PB 42	25 , 35 , 42
E	50.5 -273S5	PB 42	18 , 29 , 30 , 31 , 38 , 45
E	50.6 -273S6	PB 42	28
E	50.7 -273S7	PB 42	23
E	51.0 -274S8	PB 42	24
E	51.2 -274S10	PB 42	22

QUERVERWEISLISTE: EINGAENGE

E	51.5 -274S13	PB 42	10 , 11
E	51.6 -A700.1	PB 9 PB 42	6 2 , 3
E	51.7 -A700.2	PB 9 PB 42	6 4 , 5
E	52.0 -A700.3	PB 9 PB 42	6 6
E	52.1 -275S33.1	PB 42	14 , 15 , 28
E	52.2 -275S30.1	PB 42	14 , 17 , 22 , 28
E	52.3 -275S30.2	PB 42	14
E	52.4 -A700.4	PB 9 PB 42	6 7
E	52.5 -275S34	PB 42 FB 72	17 1
E	52.6 -275S32	PB 40	29
E	52.7 -275S33.2	PB 40 PB 42	29 14
E	53.0 -276S31.1	PB 42	14
E	53.1 -276S31.2	PB 42	14
E	53.2 -276S36	PB 42	31
E	53.3 -E 53.3	PB 80	62
E	53.4 -E 53.4	PB 80	62
E	53.5 -E 53.5	PB 91	32?
E	53.6 -E 53.6	PB 91	32?
E	54.1 -A700.6	PB 9 PB 40	6 11
E	54.2 -277S2	PB 40	12 , 25
E	54.3 -277S3	PB 40	13 , 25
E	54.4 -277S4	PB 40	23 , 24
E	54.5 -277S5	PB 40	14 , 25
E	54.7 -277B1	PB 40	16
E	55.0 -278S10	PB 40	29
E	55.1 -278S11	PB 40	29
E	55.2 -278S12	PB 40	19
E	55.3 -278S13	PB 40	19
E	55.4 -278S14.1	PB 40	38?, 39
E	55.5 -278S14.2	PB 40	38?, 39
E	55.6 -A700.8	PB 9 PB 40	6 10
E	55.7 -278S8	PB 40 PB 42	17 , 34 14
E	60.0 -285S17	PB 91	11

QUERVERWEISLISTE: EINGAENGE

E	60.1 -285S2	PB 90	10
		PB 91	14
		FB191	6
E	60.2 -285S3	PB 90	11
E	60.3 -285S4	PB 90	12
E	60.4 -E 60.4	PB 92	8
E	60.5 -E 60.5	PB 92	9
E	60.6 -E 60.6	PB 92	11
E	60.7 -E 60.7	PB 92	10
E	61.0 -286S9	PB 92	5 , 6
E	61.1 -286S10	PB 92	2 , 3
E	61.2 -E 61.2	PB 90	13
E	61.3 -E 61.3	PB 92	4
E	61.5 -E 61.5	PB 92	7
E	61.6 -286S40.1	PB 91	3
E	61.7 -286S40.2	PB 91	3
E	62.0 -287S42	PB 91	17
E	62.1 -287S43	PB 91	17
E	62.2 -287S46.1	PB 91	13 , 17 , 23
E	62.3 -287S46.2	PB 9	11
		PB 91	3 , 17 , 23 , 24
		FB 96	1
E	62.4 -E 62.4	PB 80	60
E	62.5 -287S47.1	PB 91	24?
E	62.6 -287S47.2	PB 91	24?
E	62.7 -A800	PB 9	6
		PB 90	5
E	63.0 -288S48.1	PB 92	4 , 7
E	63.1 -288S48.2	PB 92	3 , 6
E	63.2 -288S50.1	PB 92	3 , 4 , 6 , 7
E	63.3 -288S50.2	PB 92	3 , 4 , 6 , 7
E	63.4 -E 63.4	PB 80	56
E	63.5 -288S53.1	PB 91	32?
E	63.6 -288S53.2	PB 91	32?
E	63.7 -E 63.7	PB 80	56
E	64.0 -E 64.0	PB 80	60
E	64.1 -A800.2	PB 9	6
		PB 90	2
E	64.2 -289S54.1	PB 92	8
E	64.3 -289S54.2	PB 92	9

QUERVERWEISLISTE: EINGAENGE

E	64.4 -289S55.1	PB 92	10
E	64.5 -289S55.2	PB 92	11
E	64.6 -E 64.6	PB 9	6
		PB 90	3
E	64.7 -E 64.7	PB 9	6
		PB 90	4
E	70.0 -A942.01	PB 85	5 , 6 , 8
E	70.1 -A942.02	PB 85	2 , 3 , 4
		FB 87	2
E	70.2 -A942.11	FB 86	2
E	70.3 -A942.12	FB 86	2
E	70.4 -A942.13	FB 86	2
E	70.5 -A942.14	FB 86	2
E	70.6 -A942.21	FB 86	2
E	70.7 -A942.22	FB 86	2
E	71.0 -A942.23	FB 86	2
E	71.1 -A942.24	FB 86	2
E	71.2 -A942.31	FB 86	2
E	71.3 -A942.32	FB 86	2
E	71.4 -A942.33	FB 86	2
E	71.5 -A942.34	FB 86	2
E	71.6 -A942.41	FB 86	2
E	71.7 -A942.42	FB 86	2
E	72.0 -A942.43	FB 86	2
E	72.1 -A942.44	FB 86	2
E	72.2 -E 72.2	PB 85	9
		PB 87	2
E	72.3 -E 72.3	PB 85	9
		PB 87	2
E	72.4 -298S5	PB 61	2 , 11
E	72.6 -298S7	PB 82	45
E	73.1 -299S3	PB 83	2
E	73.2 -299S4	PB 83	7
E	73.3 -A950.1	PB 9	6
		PB 82	5
E	73.4 -A950.2	PB 9	6
		PB 82	4
E	73.5 -A950.3	PB 9	6
		PB 82	7
E	73.6 -A950.4	PB 9	6
		PB 82	9

QUERVERWEISLISTE: EINGAENGE

E	73.7 -E 73.7	PB 80	8
		PB 82	44
E	74.0 -300S1.1	PB 60	6
E	74.1 -300S1.2	PB 60	6
E	74.2 -300S3.1	PB 60	7
E	74.3 -300S3.2	PB 60	7
E	74.4 -300S5.1	PB 60	8
E	74.5 -300S5.2	PB 60	8
E	74.6 -300S7.1	PB 60	9
E	74.7 -300S7.2	PB 60	9
E	75.0 -E 75.0	PB 9	6
E	75.1 -E 75.1	PB 9	6
E	75.2 -E 75.2	PB 9	6
E	75.3 -E 75.3	PB 9	6
E	75.4 -E 75.4	PB 9	6
		PB 82	3
E	75.5 -E 75.5	PB 87	3
E	80.0 -201S1	PB 20	16 , 18
E	80.1 -201S2	PB 20	16
E	80.2 -201S3	PB 20	25 , 26
E	80.3 -201S4	PB 20	26
		PB 40	29
E	80.4 -201S5.1	PB 20	35?, 36
E	80.5 -201S5.2	PB 20	35?, 36
E	81.0 -202S1	PB 30	16 , 18
E	81.1 -202S2	PB 30	16
E	81.2 -202S3	PB 30	25 , 26
E	81.3 -202S4	PB 30	26
E	81.4 -202S5.1	PB 30	35?, 36
E	81.5 -202S5.2	PB 30	35?, 36
E	82.1 -203S2	PB 81	3
E	82.2 -203S3	PB 80	5
E	82.3 -203S4	PB 80	5
E	82.4 -203S5	PB 80	10
E	82.5 -203S6	PB 80	18
E	82.6 -203S7.1	PB 81	6?, 7
		FB 89	1
E	82.7 -203S7.2	PB 81	6?, 7
		FB 89	1
E	83.0 -204S1	PB 9	7

QUERVERWEISLISTE: EINGAENGE

E	83.1 -204S2	PB 9	7
E	83.2 -204S3	PB 9	8 , 9 , 10 , 15 , 22
		PB 20	23 , 30
		PB 30	23 , 30
		PB 40	26 , 28 , 33
		PB 80	7 , 9 , 13
		PB 91	15 , 18 , 20 , 22 , 23
		FB195	1
E	83.3 -204S4	PB 14	47
E	83.4 -204S5	PB 83	11 , 13
		PB 87	6 , 8 , 10 , 12 , 14 , 16
		PB101	10
		FB 39	1
E	83.5 -204S6.1	PB 9	9 , 10 , 15
		PB 20	16 , 26 , 31
		PB 30	16 , 26 , 31
		PB 40	34
		PB 80	5 , 10 , 18
E	83.6 -204S6.2	PB 9	9 , 10 , 12 , 13 , 14
		PB 20	16 , 26 , 31
		PB 30	16 , 26 , 31
		PB 40	34
		PB 80	5 , 10
E	83.7 -E 83.7	PB 9	4 , 6
E	84.0 -205S1.1	PB 9	15
E	84.1 -205S1.2	PB 9	17
E	84.2 -205S3.1	PB 9	20
E	84.3 -205S3.2	PB 9	19 , 20
		PB 14	46
		PB 15	20
		PB 17	9
		PB 19	1 , 3 , 5 , 7 , 9 , 11 , 13 , 15 , 17 , 19 , 21
		PB 20	11 , 12 , 13 , 14 , 24 , 25
		PB 30	11 , 12 , 13 , 14 , 24 , 25
		PB 40	13 , 14 , 15 , 27 , 37
		PB 42	22 , 28
		PB 79	1 , 2 , 3 , 4 , 5 , 6 , 7 , 8 , 9 , 10 , 11 , 12 , 13 , 14 , 15 , 16 , 17 , 18 , 19 , 20 , 21 , 22 , 23 , 24
		PB 84	7
		PB 85	4
		PB 86	2 , 3 , 4 , 5 , 6 , 7 , 8 , 9
		PB 90	11
		PB 91	14
		FB 23	3 , 4
		FB 55	11?
E	84.4 -205S5.1	PB 55	2
E	84.5 -205S6.2	PB 20	31
		PB 30	31
E	84.6 -E 84.6	PB 82	48
E	84.7 -E 84.7	PB 9	6
		PB 82	47
E	87.6 -E 87.6	FB195	1
E	92.1 -E 92.1	PB 55	11
E	92.2 -E 92.2	PB 55	11

QUERVERWEISLISTE: EINGAENGE

E	92.4 -E 92.4	PB 55	13
E	92.5 -E 92.5	PB 55	11
E	92.6 -E 92.6	PB 55	11
E	93.0 -E 93.0	PB 55	12
E	93.1 -E 93.1	PB 55	12
E	93.3 -E 93.3	PB 55	11
E	93.4 -E 93.4	PB 55	12
E	93.5 -E 93.5	PB 55	12
E	93.7 -E 93.7	PB 55	12
E	94.0 -E 94.0	PB 55	13
E	94.1 -E 94.1	PB 55	13
E	94.2 -E 94.2	PB 55	13
E	95.0 -E 95.0	PB 55	7
E	95.1 -E 95.1	PB 55	7
E	95.2 -E 95.2	PB 55	7
E	95.3 -E 95.3	PB 55	7
E	95.4 -E 95.4	PB 55	7
E	95.5 -E 95.5	PB 55	7
E	95.6 -E 95.6	PB 55	7
E	95.7 -E 95.7	PB 55	7
E	96.0 -E 96.0	PB 55	8
E	96.1 -E 96.1	PB 55	8
E	96.2 -E 96.2	PB 55	8
E	96.3 -E 96.3	PB 55	8
E	96.4 -E 96.4	PB 55	9
E	96.5 -E 96.5	PB 55	9
E	96.6 -E 96.6	PB 55	9
E	96.7 -E 96.7	PB 55	9
E	97.0 -E 97.0	PB 55	9
E	97.1 -E 97.1	PB 55	9
E	97.2 -E 97.2	PB 55	9
E	97.3 -E 97.3	PB 55	9
E	98.0 -E 98.0	PB 55	3
E	98.1 -E 98.1	PB 55	3
E	98.2 -E 98.2	PB 55	3
E	98.3 -E 98.3	PB 55	3
E	98.4 -E 98.4	PB 55	3

QUERVERWEISLISTE: EINGAENGE

E	98.5	-E 98.5	PB 55	3
E	98.6	-E 98.6	PB 55	3
E	98.7	-E 98.7	PB 55	3
E	99.0	-E 99.0	PB 55	4
E	99.1	-E 99.1	PB 55	4
E	99.2	-E 99.2	PB 55	4
E	99.3	-E 99.3	PB 55	4
E	99.4	-E 99.4	PB 55	4
E	99.5	-E 99.5	PB 55	4
E	99.6	-E 99.6	PB 55	4
E	99.7	-E 99.7	PB 55	4
E	100.0	-E100.0	PB 55	5
E	100.1	-E100.1	PB 55	5
E	100.2	-E100.2	PB 55	5
E	100.3	-E100.3	PB 55	5
E	100.4	-E100.4	PB 55	5
E	100.5	-E100.5	PB 55	5
E	100.6	-E100.6	PB 55	5
E	100.7	-E100.7	PB 55	5
EB	45	-	PB101	3*
EB	72	-	PB 61	2*

QUERVERWEISLISTE: AUSGAENGE

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    PB     1 : BEARBEITET
    PB     3 : BEARBEITET
    PB     6 : BEARBEITET
    PB     7 : BEARBEITET
    PB     8 : BEARBEITET
    PB     9 : BEARBEITET
    PB    10 : BEARBEITET
    PB    11 : BEARBEITET
    PB    12 : BEARBEITET
    PB    13 : BEARBEITET
    PB    14 : BEARBEITET
    PB    15 : BEARBEITET
    PB    16 : BEARBEITET
    PB    17 : BEARBEITET
    PB    18 : BEARBEITET
    PB    19 : BEARBEITET
    PB    20 : BEARBEITET
    PB    21 : BEARBEITET
    PB    30 : BEARBEITET
    PB    31 : BEARBEITET
    PB    40 : BEARBEITET
    PB    41 : BEARBEITET
    PB    42 : BEARBEITET
    PB    55 : BEARBEITET
    PB    60 : BEARBEITET
    PB    61 : BEARBEITET
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    PB    84 : BEARBEITET
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    PB    91 : BEARBEITET
    PB    92 : BEARBEITET
    PB    93 : BEARBEITET
    PB    95 : BEARBEITET
    PB   100 : BEARBEITET
    PB   101 : BEARBEITET
    PB   253 : BEARBEITET
    PB   255 : BEARBEITET
    FB     1S: BEARBEITET
    FB     2S: BEARBEITET
    FB     3S: BEARBEITET
    FB     4S: BEARBEITET
    FB     5S: BEARBEITET
    FB     6S: BEARBEITET
    FB    10S: BEARBEITET
    FB    11S: BEARBEITET
    FB    12S: BEARBEITET
    FB    13S: BEARBEITET
    FB    23 : BEARBEITET
    FB    33 : BEARBEITET
    FB    39 : BEARBEITET
    FB    40S: BEARBEITET
    FB    41S: BEARBEITET
    FB    43 : BEARBEITET
    FB    44 : BEARBEITET
    FB    46 : BEARBEITET
    FB    47 : BEARBEITET
    FB    48 : BEARBEITET
    FB    50 : BEARBEITET
    FB    51 : BEARBEITET
    FB    52 : BEARBEITET
    FB    53 : BEARBEITET
    FB    54 : BEARBEITET
    FB    55 : BEARBEITET
    FB    57 : BEARBEITET
    FB    58 : BEARBEITET
    FB    72 : BEARBEITET
+-------------------------------------------------------------------------------+
!         KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG  !  MASTERPROGRAMM                      !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE         !  DATE        :                       !
! INSTALLATION     : TREAD-LINE          !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804            !  PROGRAMMER  :                     1!
+-------------------------------------------------------------------------------+
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QUERVERWEISLISTE: AUSGAENGE

A	0.0 -43A1/1	PB 11	6
		PB 17	9
		PB 20	28*
		FB 57	1
A	0.1 -43A1/2	PB 20	5 , 14 , 17 , 18 , 28 , 29*, 30 , 32 , 34 , 38?, 40?
		PB 21	3 , 8
		FB 89	1
A	0.2 -43A1/3	PB 20	32*
A	0.3 -45K3/1	PB 20	32
		PB 21	3 , 12*, 13
A	0.4 -45K3/2	PB 21	3 , 13*
A	0.5 -46K5	PB 9	11 , 27
		PB 20	11 , 12 , 13 , 16*, 26 , 28 , 29
A	0.6 -A 0.6	PB 20	16*
A	0.7 -97K6	PB 91	10*
A	1.0 -A 1.0	PB 11	6
		PB 17	9
		PB 30	28*
		FB 57	1
A	1.1 -A 1.1	PB 30	5 , 14 , 17 , 18 , 28 , 29*, 30 , 32 , 34 , 38?, 40?
		PB 31	3 , 8
		FB 89	1
A	1.2 -A 1.2	PB 30	32*
A	1.3 -50K3.1	PB 30	32
		PB 31	3 , 12*, 13
A	1.4 -50K3.2	PB 31	3 , 13*
A	1.5 -A 1.5	PB 9	11 , 27
		PB 30	11 , 12 , 13 , 16*, 26 , 28 , 29
A	1.6 -A 1.6	PB 30	16*
A	1.7 -A 1.7	PB 42	14 , 15*, 25 , 29 , 32
A	2.0 -A 2.0	PB 11	23*
A	2.1 -64A1.1	PB 11	25*, 30
A	2.2 -64A1.2	PB 11	26*, 31
A	2.3 -64A1.3	PB 11	27*, 32
A	2.4 -64A1.4	PB 11	28*, 33
A	2.7 -87K8	PB 40	19*
A	3.0 -72K5	PB 80	6*
A	3.1 -73K6	PB 80	19*
A	3.2 -73A1	PB 80	15?, 20*
		PB 81	2
		PB 86	2
A	3.3 -77K6	PB 80	21*
A	3.4 -77A1	PB 80	22*
		PB 81	2
		PB 86	3

QUERVERWEISLISTE: AUSGAENGE

A	3.5 -79K5	PB 80	6*
A	3.6 -80K5	PB 42	32*, 38 , 45
A	3.7 -81K5	PB 42	16*, 17 , 23 , 24 , 42
A	4.0 -81A1.1	PB 42	17*, 23 , 24 , 25 , 29 , 42
		FB 72	1
A	4.2 -84A1.1	PB 40	31*
		FB 57	1
A	4.3 -A 4.3	PB 40	35
		PB 41	12*
A	4.4 -84A1.2	PB 40	15 , 17 , 20 , 21 , 31 , 32*, 33 , 35 , 37 , 38
		PB 41	3 , 8
		PB 42	12 , 13 , 17
		FB 72	1
		FB 77	1
A	4.5 -84A1.3	PB 40	35*, 38
A	4.6 -86K3	PB 41	3 , 13*
A	4.7 -87K7	PB 9	11 , 27
		PB 40	12 , 13 , 14 , 19*, 29 , 31 , 32
		PB 91	38 , 39
A	5.0 -90A1	PB 91	31*, 32 , 38 , 39
A	5.1 -89K6	PB 91	30*, 31
A	5.2 -91A1.1	PB 91	3 , 11*
		FB 57	1
A	5.3 -91A1.2	PB 81	17?
		PB 91	4 , 5 , 11 , 12*, 13 , 18 , 20 , 24 , 31 , 32?
		FB 76	1
A	5.4 -91A1.3	PB 91	13*, 16 , 18 , 19 , 22 , 23 , 24 , 31
A	5.5 -86K3.1	PB 41	3 , 13
A	5.6 -96K7	PB 9	11
		PB 90	11 , 12
		PB 91	3*, 7 , 11 , 12 , 17 , 21
A	6.0 -94K6	PB 92	3 , 4*
A	6.1 -94K6.1	PB 92	3*, 4
A	6.2 -95K6	PB 92	6 , 7*
A	6.3 -95K6.1	PB 92	6*, 7
A	6.4 -A 6.4	PB 92	8*, 9
A	6.5 -A 6.5	PB 92	8 , 9*
A	6.6 -A 6.6	PB 92	10*, 11
A	6.7 -A 6.7	PB 92	10 , 11*
A	7.0 -100K6	PB 80	23*
A	7.1 -100A1	PB 80	24*
		PB 81	2
		PB 86	4
A	7.2 -102K5	PB 80	6*
A	7.3 -103K6	PB 80	25*

QUERVERWEISLISTE: AUSGAENGE

A	7.4 -103A1	PB 80	26*
		PB 81	2
		PB 86	5 , 6
A	7.5 -105K5	PB 80	27*
A	7.6 -105A1	PB 80	28*
		PB 81	2
A	8.0 -108K6	PB 80	29*
A	8.1 -108A1	PB 80	30*
		PB 81	2
		PB 86	7
A	8.2 -110K6	PB 80	31*
A	8.3 -110A1	PB 80	32*
		PB 81	2
		PB 86	8
A	8.5 -113K6	PB 80	35*
A	8.6 -113A1	PB 80	36*
		PB 81	2
A	8.7 -115K6	PB 80	33*
A	9.0 -115A1	PB 80	34*
		PB 81	2
		PB 86	9
A	9.1 -120K6	PB 80	37*
A	9.2 -120A1	PB 80	38*
		PB 81	2
A	9.3 -128K6	PB 80	39*
A	9.4 -128A1	PB 80	40*
A	9.5 -131K5	PB 80	43 , 44*
A	9.6 -131K6	PB 80	42 , 45*
A	9.7 -132K5	PB 61	3 , 5 , 12 , 14 , 23
		PB 80	47 , 48*
A	10.0 -132K6	PB 61	3 , 5 , 12 , 14 , 23
		PB 80	46 , 49*
A	10.1 -133K5	PB 80	6*
A	10.2 -136K5	PB 80	51 , 52*
A	10.3 -136K6	PB 80	50 , 53*
A	10.4 -137K5	PB 80	54*
A	10.5 -A 10.5	PB 80	6*, 14
A	10.7 -33K7	PB 9	7*, 8
A	11.0 -122K7	PB 60	4*, 6
A	11.1 -123K7	PB 60	4*, 7
A	11.2 -124K7	PB 60	4*, 8
A	11.3 -125K7	PB 60	4*, 9
A	20.0 -235B1	PB 20	20*, 21

QUERVERWEISLISTE: AUSGAENGE

A	20.1 -235B2	PB 20	29*
A	20.2 -235B3	PB 20	16*
A	25.0 -240B1	PB 30	20*, 21
A	25.1 -240B2	PB 30	29*
A	25.2 -240B3	PB 30	16*
A	30.0 -252B1	PB 11	34
		PB 15	7*, 12
A	30.1 -252B2	PB 11	34
		PB 15	5*, 12
A	30.2 -252B3	PB 11	34
		PB 15	12*
A	30.3 -252B4	PB 11	34
		PB 15	5 , 10*
A	30.4 -252B5	PB 11	34
		PB 12	17*
A	30.5 -252B6	PB 11	34
		PB 12	16*
A	30.6 -252B7	PB 11	34
		PB 13	17*
A	30.7 -252B8	PB 11	34
		PB 13	16*
A	31.0 -253B1	PB 11	34
		PB 14	37*
A	31.1 -253B2	PB 11	34
		PB 14	36*
A	31.2 -253B3	PB 11	34
		PB 14	9 , 27 , 38*
A	31.3 -253B4	PB 11	34
		PB 14	41*
A	31.4 -253B5	PB 11	34
		PB 14	40*
A	31.5 -253B6	PB 11	34
		PB 14	42*
A	31.6 -253K7	PB 12	15*
A	31.7 -253K8	PB 13	15*
A	32.0 -254B1	PB 11	34
		PB 16	5*
A	32.1 -254B2	PB 11	34
		PB 16	3*
A	32.2 -254B3	PB 11	34
		PB 16	7*
A	32.3 -254B4	PB 11	34
		PB 16	9*
A	32.4 -254H5	PB 9	25*
A	32.5 -254K6	PB 9	24*
A	40.0 -A 40.0	PB 88	6*

QUERVERWEISLISTE: AUSGAENGE

A	40.1 -A 40.1	PB 80	14*
A	40.2 -A 40.2	PB 80	60*
A	40.3 -A925.1	PB 84	2 , 4 , 5*
A	40.4 -A925.2	PB 84 FB 84	4* 2
A	40.5 -A925.3	PB 84	7*
A	40.6 -A925.4	FB 84	2*, 3*, 4*, 5*
A	40.7 -A 40.7	FB 84	2*, 3*, 4*, 5*
A	41.0 -A925.6	FB 84	2*, 3*, 4*, 5*
A	41.1 -267B2	PB 80	55*
A	41.2 -267B3	PB 80	59*
A	41.3 -267B4	PB 80	59*
A	41.4 -267K5	PB 60	3*
A	41.5 -267K6	PB 60	2*
A	41.6 -A 41.6	PB 80	59*
A	41.7 -A 41.7	PB 80	59*
A	42.0 -A 42.0	PB 80	65*
A	42.1 -A 42.1	PB 80	65*
A	42.2 -A 42.2	PB 80	65*
A	42.3 -A 42.3	PB 80	65*
A	50.0 -279B1	PB 42	50*
A	50.2 -279B3	PB 42	23*
A	50.3 -279B4	PB 42	24*
A	50.4 -279B5	PB 42	26*, 27
A	50.5 -279B6	PB 42	20*, 21
A	50.6 -279B7	PB 40	23*, 24
A	50.7 -279B8	PB 40	32*
A	51.0 -280H1	PB 40	26*
A	51.1 -280H2	PB 40	28*
A	51.2 -280H3	PB 40	33*
A	51.3 -30H5	PB 42	3*
A	51.4 -30H7	PB 42	5*
A	51.5 -30H8	PB 80	66*
A	51.6 -A 51.6	PB 42	47*
A	51.7 -A 51.7	PB 42	49*
A	60.0 -A 60.0	PB 91	38*, 39
A	60.1 -A 60.1	PB 91	38 , 39*
A	60.4 -290H5	PB 91	22*

QUERVERWEISLISTE: MERKER

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+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                     !
!ELASTOMERTECHNIK          WERK HARBURG ! MASTERPROGRAMM                      !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                 PGNO! 
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                    1! 
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QUERVERWEISLISTE: MERKER

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QUERVERWEISLISTE: MERKER

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   FB  199 : BEARBEITET
   FB  202 : BEARBEITET
   FB  203 : BEARBEITET
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   OB   20 : BEARBEITET
   OB   21 : BEARBEITET
   OB   22 : BEARBEITET
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QUERVERWEISLISTE: MERKER

M 0.0 -M 0.0	PB 9	2*, 23
	PB 20	15 , 22 , 24 , 39?, 41?
	PB 30	15 , 22 , 24 , 38?, 39?, 41?
	PB 40	41?, 43?
	PB 41	3 , 4
	PB 42	22
	PB 79	8 , 15 , 16 , 20 , 21
	PB 80	16?
	PB 81	9?, 10?, 11?, 12?, 13?, 14?, 15?, 16?
	PB 86	5
	PB 91	27?, 29?, 34?
	PB 95	2?, 3?, 4?, 5?, 6?, 7?, 8?, 9?, 10?, 11?, 12?, 13?
	PB100	1?
	FB 54	3 , 4 , 5 , 6 , 7
	FB 55	12?
	FB 72	1?
	FB 84	2 , 3 , 4 , 5
	FB 87	2 , 3 , 4 , 5
	FB 89	1
M 0.1 -M 0.1	PB 9	2*
	PB 20	37?, 39?, 41?
	PB 30	37?, 39?, 41?
	PB 40	40?, 41?, 43?
	PB 80	16?
	PB 84	5
	PB 88	9?, 10?
	PB 91	26?, 27?, 29?, 34?
	PB 95	2?, 3?, 4?, 5?, 6?, 7?, 8?, 9?, 10?, 11?, 12?, 13?
	FB 55	10
	FB 72	1?
	FB 89	1
	FB112	2 , 3 , 4
	FB113	2
	FB115	2 , 3 , 4
	FB116	2 , 3 , 4
	FB118	2 , 3 , 4
	FB171	2 , 3
	FB172	2 , 3 , 4
	FB173	2 , 4 , 5
	FB174	2 , 3 , 5 , 6
	FB175	2 , 3 , 4
	FB176	2 , 3 , 4
	FB177	2
	FB178	2 , 4 , 5
	FB179	2
	FB180	2 , 6
	FB182	2
	FB188	2
	FB189	2
	FB190	2 , 3 , 4
	FB195	1
M 0.3 -M 0.3	PB 1	2*
	PB 84	5
M 0.4 -M 0.4	PB 1	3*
	PB 9	3?, 22 , 24
	PB 20	35?
	PB 30	35?
	PB 42	47
	PB 88	6
	PB 91	22 , 23
	FB 54	2
	FB195	1
M 0.5 -M 0.5	PB 1	4*
	PB 9	24
	PB 40	38?
	PB 81	6?, 17?
	PB 91	24?, 32?

QUERVERWEISLISTE: MERKER

M	0.6 -M	0.6	PB 9	3?
M	0.7 -M	0.7	PB 9	3?
M	1.0 -M	1.0	PB 1	5*
M	1.1 -M	1.1	PB 1	3*
M	1.2 -M	1.2	PB 1	4*
M	1.3 -M	1.3	PB 1	5*
M	1.4 -M	1.4	PB 1	2*
M	1.5 -M	1.5	PB 1	2*
M	1.6 -M	1.6	PB 1	3*
M	1.7 -M	1.7	PB 1	4*
M	2.0 -M	2.0	PB 1	5*
M	2.4 -M	2.4	PB 9	23*, 24 , 25 , 26
M	2.5 -M	2.5	PB 9	11
			PB 60	6 , 7 , 8 , 9
			PB 80	7
			FB 39	1
			FB 55	10*, 11?
M	2.6 -M	2.6	PB253	1*
			FB254	2*
M	2.7 -M	2.7	PB 9	11
			PB 80	7
			FB 55	10*, 11?
M	3.0 -M	3.0	PB100	1
M	3.1 -M	3.1	PB100	1
M	3.2 -M	3.2	FB195	1*
M	3.3 -M	3.3	FB195	1*
M	3.4 -M	3.4	FB171	3*
			FB195	1*
M	3.5 -M	3.5	FB171	3*
			FB195	1*
M	3.6 -M	3.6	PB101	7*
			FB171	3
			FB195	1
M	3.7 -M	3.7	FB254	2*
			FB255	1*
			OB 1	2
M	4.0 -M	4.0	PB101	2 , 6*, 7 , 8
			FB195	1
M	4.1 -M	4.1	PB101	1*, 2 , 7
M	4.2 -M	4.2	PB101	1*
M	4.3 -M	4.3	PB101	1*, 2
M	4.4 -M	4.4	PB101	2*, 3 , 5
M	4.5 -M	4.5	PB101	4*, 5
M	4.6 -M	4.6	FB171	3*

QUERVERWEISLISTE: MERKER

			FB195	1*
M	4.7	-M 4.7	PB101	1*, 2
M	5.0	-M 5.0	PB101	8*, 9
M	5.1	-M 5.1	PB101	8 , 9*, 10
M	5.2	-M 5.2	PB 83	11 , 13
			PB 87	6 , 8 , 10 , 12 , 14 , 16
			PB101	10*, 11
			FB 55	12?
M	5.3	-M 5.3	PB101	2 , 8
			FB195	1*
M	5.4	-M 5.4	PB253	1*
			FB254	2*
M	7.5	-M 7.5	PB 9	21*, 22 , 25 , 26
M	7.6	-M 7.6	PB 80	41?, 44 , 45 , 48 , 49 , 52 , 53
			FB 55	12?
M	7.7	-M 7.7	PB 9	18*, 19
M	8.0	-M 8.0	PB 9	11
			PB 80	7
			FB 55	9?
M	8.1	-M 8.1	PB 9	11
			PB 80	7
			FB 55	9?
M	8.2	-M 8.2	PB 80	7
			FB 55	9?
M	8.3	-M 8.3	PB 9	18
			PB 80	17
			FB 55	9?
M	8.4	-M 8.4	PB 80	7
			FB 55	6?
M	8.5	-M 8.5	PB 80	7
			FB 55	7?
M	8.6	-M 8.6	FB 55	8?
M	9.0	-M 9.0	PB 9	6*, 7 , 15 , 18
			PB 11	5
			PB 20	15
			PB 30	15
			PB 40	18
			PB 42	11 , 16 , 31
			PB 60	6 , 7 , 8 , 9
			PB 61	3 , 5 , 7 , 12 , 14 , 16 , 23
			PB 80	5 , 10 , 56 , 60 , 62
			PB 83	5 , 8
			PB 91	2 , 10
			PB 92	3 , 4 , 6 , 7 , 8 , 9 , 10 , 11
			FB 55	11?
M	9.1	-M 9.1	PB 9	7*
			PB 11	5
			PB 14	44 , 47
			PB 15	18
			PB 20	16 , 26
			PB 30	16 , 26
			PB 40	19 , 29
			PB 42	14 , 16
			PB 55	2
			PB 80	5 , 10 , 54 , 56 , 60 , 62
			PB 91	3 , 17

QUERVERWEISLISTE: MERKER

M	9.2 -M	9.2	PB 9	11*, 12 , 13 , 14 , 15
M	9.3 -M	9.3	PB 9	14 , 15*, 16 , 17 , 23
			PB 80	12
			FB 89	1
M	9.4 -M	9.4	PB 9	19*, 20 , 22 , 23 , 24
M	9.5 -M	9.5	PB 9	20*, 22 , 23 , 24
M	9.6 -M	9.6	PB 9	15 , 17*
			PB 20	26
			PB 30	26
			PB 40	29
			PB 80	18
			PB 91	17
M	9.7 -M	9.7	PB 9	27*
M	10.0 -M	10.0	PB 10	3*, 4
			PB 15	6 , 13 , 14 , 15 , 16
			PB 17	6
			PB 21	4
			PB 31	4
			PB 41	4
M	10.1 -M	10.1	PB 10	5*, 6 , 23
			PB 14	17
			PB 15	3 , 4 , 8 , 12
			PB 16	6 , 8
			PB 17	2 , 4
M	10.2 -M	10.2	PB 10	7*, 8 , 24
			PB 12	14
			PB 13	2 , 4 , 14
			PB 14	2 , 17 , 47
			PB 15	4
			PB 17	4 , 6
M	10.3 -M	10.3	PB 10	9*, 10 , 24
			PB 13	14
			PB 14	2 , 17 , 47
			PB 15	4 , 8
			PB 16	2 , 4 , 6 , 8
			PB 17	4 , 6
M	10.4 -M	10.4	PB 10	11*, 12 , 24
			PB 14	8 , 9 , 17
			PB 15	4
			PB 16	2 , 4 , 6 , 8
			PB 17	4 , 6
M	10.5 -M	10.5	PB 10	13*, 14
			PB 14	6 , 24
M	10.6 -M	10.6	PB 10	15*, 16 , 23
			PB 14	26 , 27
			PB 17	2
M	10.7 -M	10.7	PB 10	17*, 18
			PB 15	2 , 11
			PB 17	6
M	11.0 -M	11.0	PB 10	19*, 20 , 23
			PB 14	17
			PB 15	9
			PB 17	2 , 4
M	11.1 -M	11.1	PB 10	21*, 22 , 23 , 24
			PB 14	17
			PB 15	2 , 3
			PB 17	2 , 4 , 6

QUERVERWEISLISTE: MERKER

M	11.3 -M	11.3	PB 10	23*
			PB 12	2 , 4 , 14
			PB 13	2 , 4 , 14
			PB 14	2
M	11.4 -M	11.4	PB 10	24*
			PB 15	2
M	11.6 -M	11.6	PB 11	5*, 6 , 19 , 20 , 21 , 22 , 23
			PB 14	3 , 40 , 41 , 45
			PB 15	19
M	11.7 -M	11.7	PB 10	4 , 6 , 8 , 10 , 12 , 14 , 16 , 18 , 20 , 22
			PB 11	6*
			PB 12	2 , 3 , 4 , 5 , 6 , 7 , 8 , 9 , 10 , 11 , 14 , 15 , 16
			PB 13	2 , 3 , 4 , 5 , 6 , 7 , 8 , 9 , 10 , 11 , 15 , 16
			PB 14	2 , 4 , 5 , 6 , 7 , 8 , 9 , 10 , 11 , 16 , 17 , 18 , 19 , 20 , 22 , 23 , 24 , 25 , 26 , 27 , 28 , 29 , 35
			PB 15	2 , 3 , 4 , 8
			PB 16	2 , 4 , 6 , 8
M	12.0 -M	12.0	PB 11	7*, 8 , 9
M	12.1 -M	12.1	PB 11	8*, 19 , 20 , 21 , 22 , 23
M	12.2 -M	12.2	PB 11	8 , 9*
M	12.3 -M	12.3	PB 11	10*, 11 , 12
M	12.4 -M	12.4	PB 11	11*, 19 , 20 , 21 , 22 , 23
M	12.5 -M	12.5	PB 11	11 , 12*
M	12.6 -M	12.6	PB 11	13*, 14 , 15
M	12.7 -M	12.7	PB 11	14*, 19 , 20 , 21 , 22 , 23
M	13.0 -M	13.0	PB 11	14 , 15*
M	13.1 -M	13.1	PB 11	16*, 17 , 18
M	13.2 -M	13.2	PB 11	17*, 19 , 20 , 21 , 22 , 23
M	13.3 -M	13.3	PB 11	17 , 18*
M	13.4 -M	13.4	PB 11	19*, 25
M	13.5 -M	13.5	PB 11	20*, 26
M	13.6 -M	13.6	PB 11	21*, 27
M	13.7 -M	13.7	PB 11	22*, 28
M	14.0 -M	14.0	PB 11	23*, 24 , 34
M	14.1 -M	14.1	PB 11	30*
			PB 12	9 , 17
			PB 13	9 , 17
			PB 14	5 , 7 , 23 , 25
			PB 16	7 , 9
M	14.2 -M	14.2	PB 11	31*
			PB 15	7
			PB 16	3 , 5
M	14.3 -M	14.3	PB 11	32*
			PB 14	10 , 19 , 20 , 39 , 41 , 42 , 48 , 49 , 50
			PB 15	7
M	14.4 -M	14.4	PB 11	33*
			PB 12	3 , 6

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			PB 13	3 , 6
			PB 14	28
			PB 15	5 , 10 , 12
M	15.0 -M	15.0	PB 11	16
			PB 12	2*, 3
M	15.1 -M	15.1	PB 12	3*, 4 , 14 , 16
			PB 13	4
M	15.2 -M	15.2	PB 12	4*, 5
M	15.3 -M	15.3	PB 11	16
			PB 12	5*, 6 , 11
M	15.4 -M	15.4	PB 12	5 , 6*, 7 , 12 , 16
M	15.5 -M	15.5	PB 12	6 , 7*, 8 , 15
M	15.6 -M	15.6	PB 11	7
			PB 12	7 , 8*, 9
M	15.7 -M	15.7	PB 12	8 , 9*, 10 , 13 , 16 , 17
M	16.0 -M	16.0	PB 12	9 , 10*, 11 , 15
M	16.1 -M	16.1	PB 12	2 , 4 , 11*, 14
M	16.3 -M	16.3	PB 11	7
			PB 12	14*, 17
M	16.4 -M	16.4	PB 12	15*
M	16.5 -M	16.5	PB 12	16*
M	17.0 -M	17.0	PB 82	49?
			FB191	4
M	17.1 -M	17.1	PB 82	51?
			FB191	4
M	17.2 -M	17.2	PB 82	52?
			FB191	4
M	17.3 -M	17.3	PB 82	53?
			FB191	4
M	17.4 -M	17.4	PB 82	54?
			FB191	4
M	17.5 -M	17.5	PB 82	55?
			FB191	4
M	17.6 -M	17.6	PB 82	50?
			FB191	4
M	18.0 -M	18.0	PB 11	16
			PB 13	2*, 3
			PB 14	2
M	18.1 -M	18.1	PB 13	3*, 14 , 16
M	18.2 -M	18.2	PB 13	4*, 5
M	18.3 -M	18.3	PB 11	16
			PB 13	5*, 6 , 11
M	18.4 -M	18.4	PB 13	5 , 6*, 7 , 12 , 16
M	18.5 -M	18.5	PB 13	6 , 7*, 8 , 15
M	18.6 -M	18.6	PB 11	7
			PB 13	7 , 8*, 9 , 16

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M	18.7 -M	18.7	PB 13	8 , 9*, 10 , 13 , 17
M	19.0 -M	19.0	PB 13	9 , 10*, 11 , 15
M	19.1 -M	19.1	PB 12	2
			PB 13	2 , 4 , 11*, 14
M	19.3 -M	19.3	PB 11	7
			PB 12	17
			PB 13	14*, 17
M	19.4 -M	19.4	PB 13	15*
M	19.5 -M	19.5	PB 13	16*
M	19.6 -M	19.6	FB 55	2*
			FB 91	1
M	19.7 -M	19.7	FB 55	2*, 10
M	20.0 -M	20.0	PB 14	2*, 4
M	20.1 -M	20.1	PB 11	7
			PB 14	4*, 5 , 12 , 13
M	20.2 -M	20.2	PB 12	17
			PB 13	17
			PB 14	4 , 5*, 6 , 16 , 36 , 38
M	20.3 -M	20.3	PB 11	7
			PB 12	17
			PB 13	17
			PB 14	5 , 6*, 7 , 13 , 14
M	20.4 -M	20.4	PB 12	17
			PB 13	17
			PB 14	6 , 7*, 8 , 37 , 38
M	20.5 -M	20.5	PB 11	13
			PB 14	8 , 9*, 10
M	20.6 -M	20.6	PB 14	9 , 10*, 11 , 39 , 41
M	20.7 -M	20.7	PB 14	10 , 11*, 12 , 15 , 39 , 43
M	21.0 -M	21.0	PB 13	3 , 14
			PB 14	2 , 3 , 12*, 17
			PB 15	9 , 11
M	21.1 -M	21.1	PB 14	4 , 13*
M	21.2 -M	21.2	PB 14	6 , 14*
M	21.3 -M	21.3	PB 14	9 , 15*
M	21.4 -M	21.4	PB 14	7 , 8*, 9 , 14 , 15 , 16 , 38
M	21.5 -M	21.5	PB 14	16*
M	21.6 -M	21.6	PB 14	3*
M	21.7 -M	21.7	PB 14	3*, 4 , 6 , 9 , 18 , 22 , 24 , 27
M	22.0 -M	22.0	PB 14	17*, 18 , 45
M	22.1 -M	22.1	PB 11	13
			PB 14	18*, 19 , 30 , 31 , 43 , 44
M	22.2 -M	22.2	PB 14	18 , 19*, 20 , 40
M	22.3 -M	22.3	PB 14	19 , 20*, 21 , 22 , 42
M	22.4 -M	22.4	PB 11	7
			PB 14	20 , 22*, 23 , 31 , 32

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M	22.5 -M	22.5	PB 14	22 , 23*, 24 , 35 , 36 , 38
M	22.6 -M	22.6	PB 11	7
			PB 14	23 , 24*, 25 , 32 , 33
M	22.7 -M	22.7	PB 14	24 , 25*, 26 , 37 , 38
M	23.0 -M	23.0	PB 11	16
			PB 14	26 , 27*, 28
M	23.1 -M	23.1	PB 13	16
			PB 14	27 , 28*, 29
M	23.2 -M	23.2	PB 14	28 , 29*, 30 , 34
M	23.3 -M	23.3	PB 13	2 , 14
			PB 14	2 , 3 , 17 , 30*
			PB 15	9 , 11
M	23.4 -M	23.4	PB 14	18 , 31*
M	23.5 -M	23.5	PB 14	22 , 32*
M	23.6 -M	23.6	PB 14	24 , 33*
M	23.7 -M	23.7	PB 14	27 , 34*
M	24.0 -M	24.0	PB 14	25 , 26*, 27 , 33 , 34 , 35 , 38
M	24.1 -M	24.1	PB 12	17
			PB 13	17
			PB 14	35*, 38
M	24.2 -M	24.2	PB 14	43*, 44 , 47
			PB 17	4 , 6
M	24.3 -M	24.3	PB 14	44*, 45
			PB 15	19
M	24.4 -M	24.4	PB 11	13
			PB 14	39 , 41 , 45*, 46 , 47
			PB 15	4 , 6 , 9 , 11 , 18
			PB 16	2 , 4 , 6 , 8
M	24.5 -M	24.5	PB 14	41
M	24.6 -M	24.6	PB 14	39*, 40
M	25.0 -M	25.0	PB 15	2*, 4 , 6
M	25.1 -M	25.1	PB 11	16
			PB 14	44 , 47
			PB 15	4*, 5 , 9 , 19
M	25.2 -M	25.2	PB 11	10
			PB 14	44 , 47
			PB 15	6*, 7 , 9
M	25.3 -M	25.3	PB 15	8*, 9 , 11
M	25.4 -M	25.4	PB 11	16
			PB 14	44 , 47
			PB 15	6 , 9*, 10 , 12
M	25.5 -M	25.5	PB 11	16
			PB 14	44
			PB 15	11*, 12
M	25.6 -M	25.6	PB 15	13*, 17
M	25.7 -M	25.7	PB 15	13 , 14*
M	26.0 -M	26.0	PB 15	15*, 17 , 18

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M	26.1 -M	26.1	PB 15	15 , 16*
M	26.2 -M	26.2	PB 15	17*, 18
			PB 17	6
M	26.3 -M	26.3	PB 15	18*, 19
M	26.4 -M	26.4	PB 11	13
			PB 14	44 , 47
			PB 15	7 , 19*, 20
			PB 16	2 , 4 , 6 , 8
M	26.6 -M	26.6	PB 15	3*
M	26.7 -M	26.7	PB 17	2*, 7 , 8
M	27.0 -M	27.0	PB 17	4*, 7 , 8
M	27.1 -M	27.1	PB 17	6*, 7 , 8
M	27.2 -M	27.2	PB 21	3
			FB 23	2*
M	27.3 -M	27.3	PB 31	3
			FB 23	2*
M	27.5 -M	27.5	PB 9	18
			FB 23	3*
M	27.7 -M	27.7	PB 9	18
			FB 23	3*
M	28.0 -M	28.0	PB 11	10
			PB 14	44 , 47
			PB 15	18
			PB 16	2*, 3
M	28.1 -M	28.1	PB 11	10
			PB 14	44 , 47
			PB 15	18
			PB 16	4*, 5
M	28.2 -M	28.2	PB 11	7
			PB 14	44 , 47
			PB 15	18
			PB 16	6*, 7
M	28.3 -M	28.3	PB 11	7
			PB 14	44 , 47
			PB 15	18
			PB 16	8*, 9
M	28.4 -M	28.4	PB 11	13
			PB 14	2 , 3 , 17 , 42 , 44 , 47*, 48 , 49 , 50
			PB 15	2 , 4 , 9 , 11 , 18
			PB 17	4 , 6
M	28.5 -M	28.5	PB 14	40 , 49*
M	29.6 -M	29.6	PB 9	18
			FB 23	4*
M	29.7 -M	29.7	PB 9	18
			FB 23	4*
M	30.0 -M	30.0	FB 54	3*
M	30.1 -M	30.1	FB 54	3*
M	30.2 -M	30.2	FB 54	3*
M	30.3 -M	30.3	FB 54	3?

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M	30.4	-M	30.4	FB 54	3*
M	30.5	-M	30.5	FB 54	3*
M	30.6	-M	30.6	FB 54	3*
M	30.7	-M	30.7	FB 54	3?
M	31.0	-M	31.0	FB 54	3*
M	31.1	-M	31.1	FB 54	3*
M	31.2	-M	31.2	FB 54	3*
M	31.3	-M	31.3	FB 54	3?
M	31.4	-M	31.4	FB 54	3*
M	31.5	-M	31.5	FB 54	3*
M	31.6	-M	31.6	FB 54	3*
M	31.7	-M	31.7	FB 54	3?
M	32.0	-M	32.0	FB 54	4*
M	32.1	-M	32.1	FB 54	4*
M	32.2	-M	32.2	FB 54	4*
M	32.3	-M	32.3	FB 54	4?
M	32.4	-M	32.4	FB 54	4*
M	32.5	-M	32.5	FB 54	4*
M	32.6	-M	32.6	FB 54	4*
M	32.7	-M	32.7	FB 54	4?
M	33.0	-M	33.0	FB 54	4*
M	33.1	-M	33.1	FB 54	4*
M	33.2	-M	33.2	FB 54	4*
M	33.3	-M	33.3	FB 54	4?
M	33.4	-M	33.4	FB 54	4*
M	33.5	-M	33.5	FB 54	4*
M	33.6	-M	33.6	FB 54	4*
M	33.7	-M	33.7	FB 54	4?
M	34.0	-M	34.0	FB 54	5*
M	34.1	-M	34.1	FB 54	5*
M	34.2	-M	34.2	FB 54	5*
M	34.3	-M	34.3	FB 54	5?
M	34.4	-M	34.4	FB 54	5*
M	34.5	-M	34.5	FB 54	5*
M	34.6	-M	34.6	FB 54	5*
M	34.7	-M	34.7	FB 54	5?
M	35.0	-M	35.0	FB 54	5*

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M	35.1	-M	35.1	FB 54	5*
M	35.2	-M	35.2	FB 54	5*
M	35.3	-M	35.3	FB 54	5?
M	35.4	-M	35.4	FB 54	5*
M	35.5	-M	35.5	FB 54	5*
M	35.6	-M	35.6	FB 54	5*
M	35.7	-M	35.7	FB 54	5?
M	36.0	-M	36.0	FB 54	6*
M	36.1	-M	36.1	FB 54	6*
M	36.2	-M	36.2	FB 54	6*
M	36.3	-M	36.3	FB 54	6?
M	36.4	-M	36.4	FB 54	6*
M	36.5	-M	36.5	FB 54	6*
M	36.6	-M	36.6	FB 54	6*
M	36.7	-M	36.7	FB 54	6?
M	37.0	-M	37.0	FB 54	6*
M	37.1	-M	37.1	FB 54	6*
M	37.2	-M	37.2	FB 54	6*
M	37.3	-M	37.3	FB 54	6?
M	38.4	-M	38.4	FB 54	7*
M	38.5	-M	38.5	FB 54	7*
M	38.6	-M	38.6	FB 54	7*
M	38.7	-M	38.7	FB 54	7*
M	40.0	-M	40.0	PB 20	15*, 16 , 26
				PB 21	4
				FB191	1
M	40.1	-M	40.1	PB 9	7 , 23
				PB 20	16*, 18 , 20 , 21 , 22 , 27
				PB 21	4 , 9
M	40.2	-M	40.2	PB 20	17*
M	40.3	-M	40.3	PB 20	17*, 18
				FB 83	1
M	40.4	-M	40.4	PB 20	18*, 19
M	40.5	-M	40.5	PB 9	23
				PB 11	6
				PB 20	14 , 16 , 26*, 27 , 31
M	40.6	-M	40.6	PB 9	23
				PB 20	22*, 23 , 27
M	40.7	-M	40.7	PB 91	35*, 36 , 37 , 38 , 39
M	41.0	-M	41.0	PB 20	26
				PB 21	7*
M	41.1	-M	41.1	PB 20	26 , 32

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			PB 21	4*, 5 , 6 , 8 , 9 , 10 , 11
M	41.2	-M 41.2	PB 17	7*, 9
			PB 20	26
M	41.3	-M 41.3	PB 20	31*, 32
M	41.4	-M 41.4	PB 20	33*, 34
M	41.5	-M 41.5	PB 20	35?
M	41.6	-M 41.6	PB 20	35?
M	41.7	-M 41.7	PB 20	35?
M	42.0	-M 42.0	PB 20	35?
M	42.1	-M 42.1	PB 20	35?
M	42.2	-M 42.2	PB 21	2*, 3
M	42.3	-M 42.3	PB 15	2 , 4
			PB 21	3*, 4
M	42.4	-M 42.4	PB 21	7*
M	42.5	-M 42.5	PB 9	18
			PB 20	24*, 26
			FB191	1
M	42.6	-M 42.6	PB 20	28*
M	43.0	-M 43.0	PB 30	15*, 16 , 26
			PB 31	4
			FB191	1
M	43.1	-M 43.1	PB 9	7 , 23
			PB 30	16*, 18 , 20 , 21 , 22 , 27
			PB 31	4 , 9
M	43.2	-M 43.2	PB 30	17*
M	43.3	-M 43.3	PB 30	17*, 18
M	43.4	-M 43.4	PB 30	18*, 19
M	43.5	-M 43.5	PB 9	23
			PB 11	6
			PB 30	14 , 16 , 26*, 27 , 31
M	43.6	-M 43.6	PB 9	23
			PB 30	22*, 23 , 27
M	44.0	-M 44.0	PB 30	26
			PB 31	7*
M	44.1	-M 44.1	PB 30	26 , 32
			PB 31	4*, 5 , 6 , 8 , 9 , 10 , 11
M	44.2	-M 44.2	PB 17	8*, 9
			PB 30	26
M	44.3	-M 44.3	PB 30	31*, 32
M	44.4	-M 44.4	PB 30	33*, 34
M	44.5	-M 44.5	PB 30	35?
M	44.6	-M 44.6	PB 30	35?
M	44.7	-M 44.7	PB 30	35?
M	45.0	-M 45.0	PB 30	35?

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M	45.1 -M	45.1	PB 30	35?
M	45.2 -M	45.2	PB 31	2*, 3
M	45.3 -M	45.3	PB 15	2 , 4
			PB 31	3*, 4
M	45.5 -M	45.5	PB 30	28*
M	45.6 -M	45.6	PB 31	7*
M	45.7 -M	45.7	PB 9	18
			PB 30	24*, 26
			FB191	1
M	46.0 -M	46.0	PB 55	3*, 6
M	46.1 -M	46.1	PB 55	4*, 6
M	46.2 -M	46.2	PB 55	5*, 6
M	46.3 -M	46.3	PB 55	11*, 14
M	46.4 -M	46.4	PB 55	12*, 14
M	46.5 -M	46.5	PB 55	13*, 14
M	46.6 -M	46.6	PB 55	7*, 10
M	46.7 -M	46.7	PB 55	8*, 10
M	47.0 -M	47.0	PB 55	9*, 10
M	48.0 -M	48.0	PB 42	11*, 14 , 18 , 29 , 30
M	48.1 -M	48.1	PB 42	14*, 15 , 17 , 20
M	48.2 -M	48.2	PB 42	17 , 18*
M	48.3 -M	48.3	PB 42	12*
M	48.4 -M	48.4	PB 42	12*, 14
M	48.5 -M	48.5	PB 42	13*
M	48.6 -M	48.6	PB 42	13*, 14
M	48.7 -M	48.7	PB 42	15*, 17 , 28
			FB 72	1
M	49.0 -M	49.0	PB 42	29*, 30
M	49.1 -M	49.1	PB 42	31*, 32
M	49.2 -M	49.2	PB 42	34*, 35
M	49.3 -M	49.3	PB 42	17 , 32 , 36*, 38
M	49.4 -M	49.4	PB 42	32 , 37*, 38 , 50
M	49.5 -M	49.5	PB 42	30*, 32
M	49.6 -M	49.6	PB 42	40*
M	49.7 -M	49.7	PB 42	40*, 41 , 46
M	50.0 -M	50.0	PB 42	41*, 42
M	50.1 -M	50.1	PB 42	17 , 32 , 43*, 45
M	50.2 -M	50.2	PB 42	41 , 42 , 44*, 45 , 49 , 50
M	50.3 -M	50.3	PB 42	32 , 50*

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M	50.4 -M	50.4	PB 42	46*, 47 , 48
M	50.5 -M	50.5	PB 42	34 , 39*
M	50.6 -M	50.6	PB 42	33*
M	50.7 -M	50.7	PB 42	33*, 34 , 46 , 49
M	51.0 -M	51.0	PB 42	49*
M	55.0 -M	55.0	PB 9	11
			PB 20	25
			FB 52	1*
M	55.1 -M	55.1	PB 9	11
			PB 30	25
			FB 52	1*
M	55.2 -M	55.2	PB 9	11
			FB 52	1*
M	55.3 -M	55.3	PB 9	11
			PB 91	21
			FB 52	1*
M	55.4 -M	55.4	FB 52	1*
M	56.5 -M	56.5	PB 40	31*
M	56.6 -M	56.6	PB 40	38?
M	56.7 -M	56.7	PB 40	38?
M	57.0 -M	57.0	PB 40	18*, 19 , 28 , 29
			PB 41	4
			FB191	1
M	57.1 -M	57.1	PB 9	7 , 23
			PB 40	19*, 21 , 23 , 24 , 25 , 30
			PB 41	4 , 9
			PB 42	47
M	57.2 -M	57.2	PB 40	20*
M	57.3 -M	57.3	PB 40	20*, 21
M	57.4 -M	57.4	PB 40	21*, 22
M	57.5 -M	57.5	PB 9	23
			PB 40	15 , 19 , 29*, 30 , 34
			PB 42	47
M	57.6 -M	57.6	PB 9	23
			PB 40	25*, 26 , 30
			PB 42	47
M	57.7 -M	57.7	PB 9	18
			PB 40	27*, 28 , 29
			FB191	1
M	58.0 -M	58.0	PB 40	29
			PB 41	7*
M	58.1 -M	58.1	PB 40	29 , 35
			PB 41	4*, 5 , 6 , 8 , 9 , 10 , 11
M	58.3 -M	58.3	PB 40	34*, 35
M	58.4 -M	58.4	PB 40	36*, 37
M	58.5 -M	58.5	PB 40	38?
M	58.6 -M	58.6	PB 40	38?

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M	58.7 -M	58.7	PB 40	38?
M	61.0 -M	61.0	PB 41	3
M	61.1 -M	61.1	PB 41	3*, 4
M	61.2 -M	61.2	PB 41	3
M	61.3 -M	61.3	PB 87	2*
M	61.4 -M	61.4	PB 41	7*
M	61.5 -M	61.5	PB 40	16*
M	61.6 -M	61.6	PB 40	16*, 17
M	61.7 -M	61.7	PB 87	2*, 14
M	62.0 -M	62.0	PB 85	9*, 10
M	62.1 -M	62.1	PB 85	9*
M	62.2 -M	62.2	PB 87	3*
M	62.3 -M	62.3	PB 87	4 , 6 , 18*
			FB 87	3*, 4*
M	62.4 -M	62.4	PB 87	10 , 18*
			FB 87	5*
M	62.5 -M	62.5	PB 87	3*, 4 , 18
M	63.3 -M	63.3	PB 83	2*
M	63.4 -M	63.4	PB 83	2*, 3 , 5 , 11
M	63.5 -M	63.5	PB 61	3 , 5 , 12 , 14
			PB 83	5*, 6
M	63.6 -M	63.6	PB 61	3 , 5 , 12 , 14
			PB 83	5 , 6*
M	63.7 -M	63.7	PB 83	7*
M	64.0 -M	64.0	PB 83	7*, 8
M	64.1 -M	64.1	PB 83	2 , 3*, 4
M	64.2 -M	64.2	PB 87	7*, 8
M	64.3 -M	64.3	PB 87	11*, 12
M	64.4 -M	64.4	PB 87	15*, 16
M	64.5 -M	64.5	PB 83	12*, 13
M	64.6 -M	64.6	PB 83	3 , 4*
M	70.0 -M	70.0	PB 79	1*, 25
			PB 80	19
			PB 82	12 , 26
M	70.1 -M	70.1	PB 79	2*, 25
			PB 82	12 , 27
M	70.2 -M	70.2	PB 79	3*, 25
			PB 82	12 , 28
M	70.3 -M	70.3	PB 79	4*, 25
			PB 80	21
			PB 82	13 , 26
M	70.4 -M	70.4	PB 79	5*, 26
			PB 82	13 , 27

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M	70.5 -M	70.5	PB 79	6*, 26
			PB 82	13 , 28
M	70.6 -M	70.6	PB 79	7*, 26
			PB 80	23
			PB 82	14 , 26
M	70.7 -M	70.7	PB 79	8*, 26
			PB 82	14 , 27
M	71.0 -M	71.0	PB 79	9*, 27
			PB 82	14 , 28
M	71.1 -M	71.1	PB 79	10*, 27
			PB 80	25
			PB 82	15 , 26
M	71.2 -M	71.2	PB 79	11*, 27
			PB 80	27
			PB 82	16 , 26
M	71.3 -M	71.3	PB 79	12*, 27
			PB 80	29
			PB 82	17 , 26
M	71.4 -M	71.4	PB 79	13*, 28
			PB 80	31
			PB 82	18 , 26
M	71.5 -M	71.5	PB 79	14*, 28
			PB 80	33
			PB 82	19 , 26
M	71.6 -M	71.6	PB 79	15*, 28
			PB 82	19 , 27
M	71.7 -M	71.7	PB 79	16*, 28
			PB 82	19 , 28
M	72.0 -M	72.0	PB 79	17*, 29
			PB 80	35
			PB 82	20 , 26
M	72.1 -M	72.1	PB 79	18*, 29
			PB 80	37
			PB 82	21 , 26
M	72.2 -M	72.2	PB 79	19*, 29
			PB 80	39
			PB 82	22 , 26
M	72.3 -M	72.3	PB 79	20*, 29
			PB 82	22 , 27
M	72.4 -M	72.4	PB 79	21*, 30
			PB 82	22 , 28
M	72.5 -M	72.5	PB 79	22*, 30
			PB 82	23 , 26
M	72.6 -M	72.6	PB 79	23*, 30
			PB 82	24 , 26
M	72.7 -M	72.7	PB 79	24*, 30
			PB 82	25 , 26
M	76.0 -M	76.0	FB 92	1
M	79.0 -M	79.0	PB 81	4*
M	79.1 -M	79.1	PB 81	5*
M	80.0 -M	80.0	PB 9	18

QUERVERWEISLISTE: MERKER

			PB 79	25*, 26*, 27*, 28*, 29*, 30*, 31*, 32*
			PB 80	2 , 18 , 20 , 22 , 24 , 26 , 28 , 30 , 32 , 34 , 36 , 38 , 40 , 44 , 45 , 48 , 49 , 52 , 53
			FB 55	11?
M	80.1	-M 80.1	PB 81	2*, 3
M	80.2	-M 80.2	PB 81	3*, 4 , 5 , 9?, 10?, 11?, 12?, 13?, 14?, 15?, 16?
M	80.3	-M 80.3	PB 80	17*
M	80.4	-M 80.4	PB 80	17*, 18
M	80.6	-M 80.6	PB 9	27
			PB 80	10 , 18*
M	80.7	-M 80.7	FB 55	12?
M	81.1	-M 81.1	PB 9	7
			PB 60	2 , 4 , 6 , 7 , 8 , 9
			PB 80	3 , 5*, 6 , 8 , 19 , 21 , 23 , 25 , 27 , 29 , 31 , 33 , 35 , 37 , 39
			FB 55	11?
M	81.3	-M 81.3	PB 9	11
			PB 80	8*, 9 , 10
			FB 55	11?
M	81.4	-M 81.4	PB 9	23
			PB 80	4 , 5 , 10*, 11 , 12
			PB 81	17
			PB 91	17
M	81.5	-M 81.5	PB 60	2 , 3
			PB 80	12*, 13 , 14 , 20 , 22 , 24 , 26 , 28 , 30 , 32 , 34 , 36 , 38 , 40 , 42 , 43 , 44 , 45 , 46 , 47 , 48 , 49 , 50 , 51 , 52 , 53 , 55
			PB 81	2
			PB 82	35 , 37 , 44 , 46 , 49 , 50 , 51 , 52 , 53 , 54 , 55
			PB 83	5
			PB 85	10
			PB 87	2 , 3 , 4 , 6 , 10 , 14 , 18
			PB 88	4 , 5
			PB 91	16
			PB101	2 , 7
			FB 55	11?
			FB 57	1
			FB 84	2
			FB 87	2
			FB 93	2
M	81.6	-M 81.6	PB 91	16*
M	81.7	-M 81.7	PB 91	16*, 17
M	82.0	-M 82.0	PB 79	31
			PB 82	12 , 29
			PB 86	2*
M	82.1	-M 82.1	PB 79	31
			PB 82	13 , 29
			PB 86	3*
M	82.2	-M 82.2	PB 79	31
			PB 82	14 , 29
			PB 86	4*
M	82.3	-M 82.3	PB 79	31
			PB 82	15 , 29
			PB 86	5*
M	82.4	-M 82.4	PB 79	32

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				PB 82	16 , 29
				PB 86	6*
M	82.5	-M	82.5	PB 79	32
				PB 82	17 , 29
				PB 86	7*
M	82.6	-M	82.6	PB 79	32
				PB 82	18 , 29
				PB 86	8*
M	82.7	-M	82.7	PB 79	32
				PB 82	19 , 29
				PB 86	9*
M	83.1	-M	83.1	PB 81	6?
M	83.2	-M	83.2	PB 81	6?
M	83.3	-M	83.3	PB 81	6?
M	83.4	-M	83.4	PB 81	6?
M	83.5	-M	83.5	PB 81	6?
M	83.7	-M	83.7	FB 89	1*
M	84.0	-M	84.0	FB 83	1*
M	84.1	-M	84.1	FB 83	1*
M	84.2	-M	84.2	FB 83	1*
M	84.3	-M	84.3	FB 83	1*
M	84.4	-M	84.4	FB 83	1*
M	84.5	-M	84.5	FB 83	1*
M	84.6	-M	84.6	FB 83	1*
M	84.7	-M	84.7	FB 83	1*
M	85.0	-M	85.0	FB 83	1*
M	85.1	-M	85.1	FB 83	1*
M	85.2	-M	85.2	FB 83	1*
M	85.3	-M	85.3	FB 83	1*
M	85.4	-M	85.4	FB 83	1*
M	85.5	-M	85.5	FB 83	1*
M	85.6	-M	85.6	FB 83	1*
M	85.7	-M	85.7	FB 83	1*
M	86.0	-M	86.0	FB 83	1*
M	86.1	-M	86.1	FB 83	1*
M	86.2	-M	86.2	FB 83	1*
M	86.3	-M	86.3	FB 83	1*
M	86.4	-M	86.4	FB 83	1*
M	86.5	-M	86.5	FB 83	1*
M	86.6	-M	86.6	FB 83	1*
M	86.7	-M	86.7	FB 83	1*

QUERVERWEISLISTE: MERKER

M	87.0 -M	87.0	FB 83	1*
M	87.1 -M	87.1	FB 83	1*
M	87.2 -M	87.2	FB 83	1*
M	87.3 -M	87.3	FB 83	1*
M	87.4 -M	87.4	FB 83	1*
M	87.5 -M	87.5	FB 83	1*
M	87.6 -M	87.6	FB 83	1*
M	87.7 -M	87.7	FB 83	1*
M	88.0 -M	88.0	PB 80	56*, 57 , 58 , 61
M	88.1 -M	88.1	PB 80	60*, 61
M	88.2 -M	88.2	PB 80	62*, 63 , 64 , 66
M	88.3 -M	88.3	PB 85	6*
M	88.4 -M	88.4	PB 85	6*
			FB 87	2
M	89.0 -M	89.0	PB 61	2*
M	89.1 -M	89.1	PB 61	2*, 3 , 5
M	89.2 -M	89.2	PB 61	3*, 4 , 8 , 10 , 21
M	89.3 -M	89.3	PB 61	5*, 6 , 9 , 10 , 22
M	89.4 -M	89.4	PB 61	11*
M	89.5 -M	89.5	PB 61	11*, 12 , 14
M	89.6 -M	89.6	PB 61	7*, 8 , 9 , 10
M	89.7 -M	89.7	PB 61	16*, 17 , 18 , 19
M	90.0 -M	90.0	PB 61	12*, 13 , 17 , 19
M	90.1 -M	90.1	PB 61	14*, 15 , 18 , 19
M	90.2 -M	90.2	PB 61	23*
M	90.3 -M	90.3	PB 61	20*
M	90.4 -M	90.4	PB 61	20*, 23
M	90.6 -M	90.6	PB 91	11*
M	91.0 -M	91.0	PB 91	2*, 3 , 7 , 17
M	91.1 -M	91.1	PB 9	7 , 23
			PB 91	3*, 5 , 8 , 19 , 30
M	91.2 -M	91.2	PB 9	23
			PB 91	7*, 8
M	91.3 -M	91.3	PB 91	4*
M	91.4 -M	91.4	PB 91	4*, 5
M	91.5 -M	91.5	PB 91	5*, 6
M	91.6 -M	91.6	PB 91	21*, 22 , 23
M	91.7 -M	91.7	PB 91	9*

QUERVERWEISLISTE: MERKER

M	92.0	-M	92.0	PB 9	18
				PB 80	10
				PB 91	14*, 15 , 17
M	92.1	-M	92.1	PB 9	23
				PB 91	3 , 8 , 17*
M	92.2	-M	92.2	PB 91	9*, 10
M	92.3	-M	92.3	PB 91	24?
M	92.4	-M	92.4	PB 91	24?
M	92.5	-M	92.5	PB 91	24?
M	92.6	-M	92.6	PB 91	24?
M	92.7	-M	92.7	PB 91	24?
M	93.0	-M	93.0	PB 81	17?
M	93.1	-M	93.1	PB 81	17?
M	93.2	-M	93.2	PB 81	17?
M	93.3	-M	93.3	PB 81	17?
M	93.4	-M	93.4	PB 81	17?
M	93.5	-M	93.5	PB 91	32?
M	93.6	-M	93.6	PB 91	32?
M	93.7	-M	93.7	PB 91	32?
M	94.0	-M	94.0	PB 91	32?
M	94.1	-M	94.1	PB 91	32?
M	95.0	-M	95.0	PB 86	1*, 2
M	95.1	-M	95.1	PB 86	1*, 3
M	95.2	-M	95.2	PB 86	1*, 4
M	95.3	-M	95.3	PB 86	1*, 5
M	95.4	-M	95.4	PB 86	1*, 6
M	95.5	-M	95.5	PB 86	1*, 7
M	95.6	-M	95.6	PB 86	1*, 8
M	95.7	-M	95.7	PB 86	1*, 9
M	104.0	-M	104.0	FB 55	5
				FB100	1
M	104.1	-M	104.1	FB100	1*
M	105.0	-M	105.0	FB100	1*
M	105.1	-M	105.1	FB100	1
M	105.2	-M	105.2	FB 55	4
				FB100	1
M	105.3	-M	105.3	FB100	1
M	105.4	-M	105.4	FB 55	5
				FB100	1
M	105.5	-M	105.5	FB100	1

QUERVERWEISLISTE: MERKER

M	105.6	-M 105.6	FB 55	4
			FB100	1
M	105.7	-M 105.7	FB100	1
M	128.0	-M 128.0	FB 91	1*
M	128.1	-M 128.1	FB 91	1*
M	128.2	-M 128.2	FB 91	1*
M	132.0	-M 132.0	FB 91	1
M	136.1	-M 136.1	FB 91	1
M	136.2	-M 136.2	FB 91	1
M	151.0	-	FB148	1
			FB149	2
			FB150	4
M	156.0	-	FB150	4*
M	156.1	-	FB150	4*
M	156.2	-	FB150	4*
M	156.3	-	FB150	4*
M	156.4	-	FB150	4*
M	156.5	-	FB150	4*
M	156.6	-	FB150	4
M	156.7	-	FB150	4
M	157.6	-	FB150	4*
M	157.7	-	FB150	4*
M	158.0	-	FB150	4*
M	158.1	-	FB150	4*
M	158.2	-	FB150	4*
M	158.5	-	FB150	2*
M	159.0	-	FB150	2 , 3*, 4*
M	159.1	-	FB149	2*, 4*
M	159.2	-	FB148	1*, 7*
M	159.7	-	FB148	1*, 7*
			FB149	2*, 3 , 4*
			FB150	2 , 3*, 4*
M	160.0	-	FB170	2
M	160.1	-	FB173	4*
			FB174	5*
M	160.2	-	FB170	14
			FB172	3*
			FB173	5*
			FB174	6*
			FB175	2*, 4*
			FB176	2*, 4*
			FB178	5*
			FB190	4
M	160.3	-	FB170	4

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M	177.2 -M0231	PB 90	11*
		PB 91	14
		FB191	6
M	177.3 -M0232	PB 90	13*
M	177.4 -M0233	PB 40	17*, 28
		PB 42	47
M	177.5 -M0234	PB 82	39*
M	177.6 -M0235	PB 82	40*
M	177.7 -M0236	PB 82	41*
M	178.0 -M0253	PB 82	46*
M	178.1 -M0254	PB 85	2*
M	178.2 -M0255	PB 82	42*
M	178.3 -M0256	PB 82	43*
M	178.4 -M0257	PB 82	44*
M	178.5 -M0258	PB 82	50?
M	178.6 -M0259	PB 55	6*
M	178.7 -M0260	PB 55	10*
M	179.0 -M0245	PB 55	14*
M	179.1 -M0246	PB 30	21*
M	179.2 -M0247	PB 20	21*
M	179.3 -M0248	PB 17	9*
		PB 20	24
		PB 30	24
M	179.4 -M0249	PB 9	18
		PB 82	34*
M	179.5 -M0250	PB 20	24
		FB 23	4*
M	179.6 -M0251	PB 30	24
		FB 23	4*
M	179.7 -M0252	PB 40	24*, 27
M	180.0 -M0269	FB 55	7?
M	180.1 -M0270	PB 20	10*
M	180.2 -M0271	PB 30	10*
M	180.3 -M0272	PB 40	11*
M	180.4 -M0273	PB 40	10*
M	180.5 -M0274	PB 20	3*
		FB191	2
M	180.6 -M0275	PB 30	3*
		FB191	2
M	180.7 -M0276	PB 40	3*
		FB191	2
M	181.0 -M0261	PB 40	4*
		FB191	2

QUERVERWEISLISTE: MERKER

M	181.1	-M0262	PB 40	2*
			FB191	2
M	181.2	-M0263	PB 20	12*, 24
			FB191	2
M	181.3	-M0264	PB 30	12*, 24
			FB191	2
M	181.4	-M0265	PB 40	13*, 27
			FB191	2
M	181.5	-M0266	PB 9	21
			PB 20	11*
			FB191	2
M	181.6	-M0267	PB 9	21
			PB 30	11*
			FB191	2
M	181.7	-M0268	PB 40	12*, 18
			FB191	2
M	182.0	-M0285	PB 20	13*, 24
M	182.1	-M0286	PB 30	13*, 24
M	182.2	-M0287	PB 40	14*, 27
			FB191	2
M	182.3	-M0288	PB 20	5*, 24
			FB191	2
M	182.4	-M0289	PB 30	5*, 24
			FB191	2
M	182.5	-M0290	PB 20	2*
			FB191	2
M	182.6	-M0291	PB 30	2*
			FB191	2
M	182.7	-M0292	PB 20	6*
M	183.0	-M0277	PB 30	6*
M	183.1	-M0278	PB 40	7*
M	183.2	-M0279	PB 20	4*
M	183.3	-M0280	PB 30	4*
M	183.4	-M0281	PB 40	5*
M	183.5	-M0282	PB 20	8*
M	183.6	-M0283	PB 30	8*
M	183.7	-M0284	PB 40	8*
M	184.0	-M0301	PB 20	9*
M	184.1	-M0302	PB 30	9*
M	184.2	-M0303	PB 40	9*
M	184.3	-M0304	PB 20	24 , 34*
M	184.4	-M0305	PB 30	24 , 34*
M	184.5	-M0306	PB 40	27 , 37*
M	185.4	-M0297	PB 20	24
			FB 23	3*

QUERVERWEISLISTE: MERKER

M	185.5	-M0298	PB 30	24
			FB 23	3*
M	185.6	-M0299	FB 23	3*
M	185.7	-M0300	FB 23	3*
M	186.0	-M0317	PB 82	36*
M	186.1	-M0318	PB 82	38*
M	186.2	-M0319	PB 82	45*
M	186.3	-M0320	PB 82	26*
M	186.4	-M0321	PB 82	27*
M	186.5	-M0322	PB 82	28*
M	186.6	-M0323	PB 82	29*
M	186.7	-M0324	PB 11	2*
M	187.5	-M0314	PB 9	18
			PB 15	20*
M	187.6	-M0315	PB 9	18
			PB 14	44 , 46*
M	187.7	-M0316	PB 9	18
			PB 11	4*
M	188.0	-M0333	PB 9	21
			PB 20	25*
M	188.1	-M0334	PB 9	21
			PB 30	25*
M	188.2	-M0335	PB 90	4*
M	188.3	-M0336	PB 10	2*
M	188.4	-M0337	PB 11	3*
M	189.0	-M0325	PB 82	2*
M	189.1	-M0326	PB 82	3*
M	189.2	-M0327	PB 82	4*
M	189.3	-M0328	PB 82	5*
M	189.4	-M0329	PB 82	8*
M	189.5	-M0330	PB 82	6*
M	189.6	-M0331	PB 82	9*
M	189.7	-M0332	PB 82	7*
M	190.1	-M0350	PB 90	2*
M	190.2	-M0351	PB 90	3*
M	190.3	-M0352	PB 90	5*
M	190.4	-M0353	PB 9	4*
M	190.6	-M0355	PB 9	12*
M	190.7	-M0356	PB 42	7*
M	191.0	-M0341	PB 9	14*

QUERVERWEISLISTE: MERKER

M	191.2 -M0343	PB 42	2*
M	191.3 -M0344	PB 42	4*
M	191.4 -M0345	PB 42	6*
M	191.5 -M0346	PB 20	14*, 24
M	191.6 -M0347	PB 30	14*, 24
M	191.7 -M0348	PB 40	15*, 27
M	192.0 -M0365	FB 55	6?
		FB191	6
M	192.2 -M0367	FB 55	6?
		FB191	6
M	192.3 -M0368	FB 55	6?
		FB191	6
M	192.4 -M0369	FB 55	6?
		FB191	4 , 6
M	192.5 -M0370	FB 55	6?
		FB191	6
M	192.6 -M0371	FB 55	6?
		FB191	6
M	192.7 -M0372	FB 55	6?
		FB191	6
M	193.0 -M0357	FB 55	7?
		FB191	6
M	193.1 -M0358	FB 55	7?
		FB191	3
M	193.2 -M0359	FB 55	7?
		FB191	6
M	193.3 -M0360	FB 55	7?
		FB191	6
M	193.4 -M0361	FB 55	7?
M	193.7 -M0364	FB 55	7?
		FB191	6
M	194.1 -M0382	FB 55	8?
		FB191	6
M	194.2 -M0383	PB 9	6
		FB 55	8?
		FB191	6
M	194.3 -M0384	PB 9	6
		FB 55	8?
		FB191	6
M	194.4 -M0385	FB 55	8?
		FB191	6
M	194.5 -M0386	FB 55	8?
M	195.2 -M0375	PB 19	1*, 2*
M	195.3 -M0376	PB 19	3*, 4*
M	195.4 -M0377	PB 19	5*, 6*
M	195.5 -M0378	PB 19	7*, 8*

QUERVERWEISLISTE: MERKER

M	195.6 -M0379	PB 10	22*
M	195.7 -M0380	PB 10	20*
M	196.0 -M0397	PB 10	4*
M	196.1 -M0398	PB 10	6*
M	196.2 -M0399	PB 10	8*
M	196.3 -M0400	PB 10	10*
M	196.4 -M0401	PB 10	12*
M	196.5 -M0402	PB 10	14*
M	196.6 -M0403	PB 10	16*
M	196.7 -M0404	PB 10	18*
M	197.0 -M0389	PB 19	9*, 10*
M	197.1 -M0390	PB 19	11*, 12*
M	197.2 -M0391	PB 19	13*, 14*
M	197.3 -M0392	PB 19	15*, 16*
M	197.4 -M0393	PB 19	17*, 18*
M	197.5 -M0394	PB 19	19*, 20*
M	197.6 -M0395	PB 19	21*, 22*
M	200.0 -	PB101	1*
		FB 52	1*
		FB 95	2*
		FB113	2*
		FB170	7*
		FB189	2*
M	200.1 -	PB101	1*
		FB 52	1*
		FB 95	2*
		FB170	7*
M	200.2 -	FB 52	1*
M	200.3 -	FB 52	1*
M	200.4 -	FB 52	1*
M	200.5 -	FB 52	1*
M	200.6 -	FB 52	1*
M	200.7 -	FB 52	1*
M	201.0 -	FB 52	1*
M	201.1 -	FB 52	1*
M	201.2 -	FB 52	1*
M	201.3 -	FB 52	1*
M	201.4 -	FB 52	1*
M	201.5 -	FB 52	1*
M	202.0 -	FB 52	1*
M	202.1 -	FB 52	1*

QUERVERWEISLISTE: MERKER

M 202.2 -	FB 52	1*	
M 202.3 -	FB 52	1*	
M 202.4 -	FB 52	1*	
M 202.5 -	FB 52	1*	
M 202.6 -	FB 52	1*	
M 202.7 -	FB 52	1*	
M 206.4 -	FB 89	1*	
M 206.5 -	FB 89	1*	
M 210.0 -	FB 89	1*	
M 210.1 -	FB 84	3*	
	FB 87	3*	
	FB 89	1*	
	FB 93	3*,	5
M 210.2 -	FB 84	4*	
	FB 87	4*	
	FB 93	4*,	5
M 210.3 -	FB 93	5*	
M 222.0 -	FB 86	2*	
	FB 88	2*	
M 222.1 -	FB 86	2*	
	FB 88	2*	
M 222.2 -	FB 86	2*	
	FB 88	2*	
M 222.3 -	FB 86	2*	
	FB 88	2*	
M 222.4 -	FB 86	2*	
	FB 88	2*	
M 222.5 -	FB 86	2*	
	FB 88	2*	
M 222.6 -	FB 86	2*	
	FB 88	2*	
M 222.7 -	FB 86	2*	
	FB 88	2*	
M 223.0 -	FB 86	2*	
	FB 88	2*	
M 223.1 -	FB 86	2*	
	FB 88	2*	
M 223.2 -	FB 86	2*	
	FB 88	2*	
M 223.3 -	FB 86	2*	
	FB 88	2*	
M 223.4 -	FB 86	2*	
	FB 88	2*	
M 223.5 -	FB 86	2*	
	FB 88	2*	
M 223.6 -	FB 86	2*	
	FB 88	2*	

QUERVERWEISLISTE: MERKER

M	223.7 -	FB 86	2*
		FB 88	2*
M	235.0 -	FB152	1*
M	237.0 -	FB152	1*
M	237.1 -	FB152	1*
M	237.2 -	FB152	1*
M	237.3 -	FB152	1
M	237.4 -	FB152	1*
M	240.0 -	FB 50	1*
		FB 51	1
M	240.1 -	FB 50	1*
		FB 51	1
M	240.2 -	FB 50	1*
		FB 51	1
M	240.3 -	FB 50	1*
		FB 51	1
M	240.4 -	FB 50	1*
		FB 51	1
M	240.5 -	FB 50	1*
		FB 51	1
M	240.6 -	FB 50	1*
		FB 51	1
M	240.7 -	FB 50	1*
		FB 51	1
M	242.5 -	FB143	2
M	245.0 -	FB144	3*, 4*
M	245.1 -	FB144	3*, 4*
M	246.5 -	FB144	3
M	247.2 -	FB151	1
M	247.3 -	FB151	1
M	247.4 -	FB151	1
M	248.4 -	FB152	1*
M	248.7 -	FB 40	7
M	249.0 -	FB196	3
M	250.2 -	FB 40	3
M	250.3 -	FB 40	3
		FB163	3*, 4*
M	250.4 -	FB 40	3
		FB163	3*, 4*
M	250.5 -	FB 40	3
		FB163	3*, 4*
M	250.6 -	FB 40	3
		FB163	3*, 4*

QUERVERWEISLISTE: MERKER

M	250.7 -	FB 40	5 , 6
M	251.0 -	FB 40	6
		FB143	2
M	251.1 -	FB 40	3
M	251.2 -	FB 40	4
M	252.0 -	FB 40	2*, 4
M	253.0 -	FB144	3
M	254.7 -	FB163	2*, 3 , 4
M	255.0 -	FB 55	8?, 9?
		FB144	3
		FB163	2*
		FB196	2*
M	255.1 -	FB163	2*
		FB196	2*
M	255.2 -	FB196	2*
M	255.3 -	FB196	2*
M	255.7 -	FB 90	1
		OB 20	1*
		OB 21	1*
		OB 22	1*
MB	10 -	FB255	1*
MB	11 -	FB255	1*
MB	12 -	FB255	1*
MB	13 -	FB255	1*
MB	14 -	FB255	1*
MB	15 -	FB255	1*
MB	16 -	FB255	1*
MB	17 -	FB255	1*
MB	18 -	FB255	1*
MB	19 -	FB255	1*
MB	20 -	FB255	1*
MB	21 -	FB255	1*
MB	22 -	FB255	1*
MB	23 -	FB255	1*
MB	24 -	FB255	1*
MB	25 -	FB255	1*
MB	26 -	FB255	1*
MB	27 -	FB255	1*
MB	28 -	FB255	1*
MB	29 -	FB255	1*
MB	75 -	PB 93	3?

QUERVERWEISLISTE: MERKER

MB 100	-	PB 88	9?
MB 132	-MB 132	FB 91	1?
MB 152	-	FB148	1?, 4*, 5 , 6*, 7?
		FB149	2?, 4?
		FB150	4?
MB 153	-	FB148	4*, 5 , 6*
MB 154	-	FB150	3?
MB 160	-MB 160	FB187	1*
MB 161	-MB 161	FB187	1*
MB 162	-MB 162	FB187	1*
MB 163	-MB 163	FB187	1*
MB 164	-MB 164	FB187	1*
MB 165	-MB 165	FB187	1*
MB 166	-MB 166	FB187	1*
MB 167	-MB 167	FB187	1*
MB 168	-MB 168	FB187	1*
MB 199	-MB 199	PB 7	2
MB 200	-	PB253	1?
		FB 90	1?
		FB 91	1?
		FB 92	1?
		FB113	3
		FB115	4*
		FB175	4*
		FB186	2
		FB188	3
		FB189	3
MB 201	-	OB 22	1?
MB 202	-	OB 20	1?
		OB 21	1?
MB 203	-	FB 92	1?
MB 220	-	PB 18	3?
		FB115	4*
		FB118	3*
		FB153	1
		FB171	3*
		FB175	4*
		FB178	4*
MB 221	-	FB115	4*
		FB118	3*
		FB171	3*
		FB175	4*
		FB178	4*
MB 224	-	FB190	3*
MB 225	-	FB190	3*
MB 230	-	FB184	2*
MB 233	-	FB144	4*
MB 236	-	FB152	1*

QUERVERWEISLISTE: MERKER

MB 237	-	FB152	1*
MB 238	-	FB151	1
MB 239	-	FB151	1
		FB185	1*
		FB196	2*, 3
MB 240	-	FB 50	1
		FB 51	1*
		FB151	1
		FB184	2*
MB 241	-	FB184	2*
		FB185	1*
MB 242	-	FB151	1*
		FB152	1
		FB153	1
MB 243	-	FB144	3*
		FB153	1*
MB 244	-	FB144	3*
MB 245	-	FB144	4*
		FB196	3*
MB 246	-	FB144	3*
		FB185	1
MB 247	-	FB144	3*
		FB151	1*
MB 248	-	FB151	1*
		FB196	2 , 3
MB 249	-	FB151	1*
		FB196	2 , 3
MB 250	-	FB118	3*
		FB152	1*
		FB178	4*
		FB196	2
MB 251	-	FB118	3*
		FB151	1
		FB152	1*
		FB178	4*
		FB196	2
MB 253	-	FB 40	2*
		FB 41	3*
		FB152	1*
		FB163	2 , 4*
MB 254	-	FB 40	2*, 3 , 5 , 6 , 7
		FB 41	3*, 4
		FB163	2
MB 255	-	FB 90	1*
		FB151	1
		FB152	1*
		FB196	2*
MW 0	-	PB 7	2?
		FB113	3?
		FB188	3?
		FB189	3?
		FB254	2*
MW 9	-	FB254	2*
MW 30	-	FB254	2*

QUERVERWEISLISTE: MERKER

MW 32	-	FB254	2*
MW 34	-	FB254	2*
MW 36	-	FB254	2*
MW 38	-	FB254	2*
MW 40	-	FB254	2*
MW 42	-	FB254	2*
MW 44	-	FB254	2*
MW 46	-	FB254	2*
MW 48	-	FB254	2*
MW 50	-	FB254	2*
MW 52	-	FB254	2*
MW 54	-	FB254	2*
MW 56	-	FB254	2*
MW 58	-	FB254	2*
MW 60	-	FB254	2*
MW 62	-	FB254	2*
MW 64	-	FB254	2*
MW 66	-	FB254	2*
MW 68	-	FB254	2*
MW 70	-	FB254	2*
MW 72	-	FB254	2*
MW 74	-	FB254	2*
MW 75	-MW 75	FB 92	1?
MW 76	-	FB254	2*
MW 77	-	FB 92	1?
MW 78	-	PB 7	2?
		FB113	3?
		FB188	3?
		FB189	3?
		FB254	2*
MW 80	-	FB254	2*
MW 82	-	FB254	2*
MW 84	-	FB254	2*
MW 86	-	FB254	2*
MW 88	-	FB254	2*
MW 90	-	FB254	2*
MW 92	-	FB254	2*
MW 94	-	FB254	2*
MW 96	-	FB254	2*

QUERVERWEISLISTE: MERKER

MW 98	-	FB254	2*
MW 104	-MW 104	FB100	1*
MW 135	-MW 135	FB 91	1?
MW 137	-MW 137	FB 91	1?
MW 150	-MW 110	FB148	1?, 4*, 5*, 6*, 7?
		FB149	2?, 4?
		FB150	3?, 4*, 5*, 6*
MW 152	-MW 112	FB148	4 , 5*
		FB150	5*, 6*
MW 154	-MW 114	FB148	4*, 5*, 6*
		FB150	4*, 5
MW 156	-MW 116	FB150	4*
MW 160	-MW 160	FB187	1*
MW 162	-MW 162	FB187	1*
MW 164	-MW 164	FB187	1*
MW 166	-MW 166	FB187	1*
MW 200	-	PB253	1?
		FB 43	2*
		FB 44	2*
		FB 46	2*, 3
		FB 47	2*
		FB171	3*
		FB174	2*
		FB180	5*
		FB193	1*
		FB194	1*
		FB199	1*
MW 204	-	FB115	4*
		FB175	4*
		FB194	1*
MW 206	-	FB 89	1
		FB194	1*
MW 210	-	FB199	1*
MW 212	-	FB199	1*
MW 214	-	FB193	1*
		FB199	1*
MW 215	-	FB153	1*
MW 216	-	FB194	1*
		FB199	1*
MW 217	-	FB153	1*
MW 218	-	FB199	1*
MW 219	-	FB153	1*
MW 220	-	FB 86	2*
		FB 88	2*
		FB115	4?
		FB118	3?
		FB171	3?
		FB175	4?
		FB178	4?

QUERVERWEISLISTE: MERKER

MW 222	-	FB 98	1
MW 224	-	FB190	3?
MW 226	-	FB153	1*
MW 228	-	FB153	1*
		FB193	1*
MW 230	-	PB 18	3?
		FB193	1*
MW 231	-	FB144	3*, 4*
		FB153	1*
MW 232	-	FB193	1*
MW 233	-	FB152	1*
		FB153	1*
MW 234	-	FB193	1*
MW 235	-	FB153	1*
MW 236	-	FB193	1*
MW 237	-	FB144	4
		FB151	1*
		FB153	1*
		FB185	1
MW 238	-	FB152	1*
		FB185	1*
		FB193	1*
		FB196	3
MW 239	-	FB144	4
		FB151	1*
		FB153	1*
		FB184	2
MW 240	-	FB152	1*
		FB184	2*
		FB193	1*
		FB196	3*
MW 241	-	FB151	1*
		FB153	1*
MW 242	-	FB143	2*
		FB185	1*
		FB193	1*
		FB196	3*
MW 243	-	FB151	1*
MW 244	-	FB143	2*
		FB153	1*
		FB185	1*
		FB193	1*
		FB196	3
MW 245	-	FB144	2*
		FB151	1*
MW 246	-	FB 40	7*
		FB 41	4*, 5
		FB116	4*
		FB118	3*
		FB143	2*
		FB152	1*
		FB153	1*
		FB176	4*
		FB178	4*

QUERVERWEISLISTE: MERKER

		FB185	1*
		FB192	1*
		FB193	1*
		FB196	2*, 3
MW 248	-	FB 40	5*, 6*
		FB116	4*
		FB118	3*
		FB143	2*
		FB144	4*
		FB152	1*
		FB153	1*
		FB176	4*
		FB178	4*
		FB185	1*
		FB192	1*
		FB196	2*
MW 250	-	FB 40	2*, 5
		FB116	4*
		FB143	2*
		FB144	2*, 3*, 4*
		FB151	1*
		FB152	1
		FB153	1*
		FB163	3*, 4*
		FB176	4*
		FB185	1*
		FB192	1*
		FB196	2*, 3
MW 252	-	FB 40	2 , 4
		FB 41	5
		FB116	4*
		FB118	3*
		FB143	2*
		FB144	2*, 3*
		FB151	1*
		FB152	1*
		FB153	1*
		FB163	2*, 3 , 4
		FB176	4*
		FB178	4*
		FB185	1*
		FB192	1*
		FB196	2*, 3
MW 254	-	FB116	4*
		FB118	3*
		FB144	3*
		FB151	1*
		FB152	1*
		FB163	2*
		FB176	4*
		FB178	4*
		FB185	1*
		FB192	1*
MD 84	-	FB 84	2
MD 200	-	FB 39	1*
		FB 89	1*
MD 202	-	FB 44	2*
		FB 47	2*
MD 204	-	FB 39	1*
		FB 89	1*
MD 206	-	FB193	1*
MD 208	-	FB194	1*
MD 210	-	FB193	1*

QUERVERWEISLISTE: MERKER

MD 212	-	FB194	1*
MD 216	-	FB193	1*
MD 220	-	FB 86	2
		FB 88	2
		FB 89	1*
		FB 98	1*
		FB193	1*
MD 224	-	FB 39	1*
		FB 88	2*
		FB193	1*
MD 226	-	FB 74	1*
		FB 75	1*
MD 230	-	FB 74	1*, 2
		FB 75	1*, 2
		FB 84	2*, 3 , 4
		FB 86	2*
		FB 87	2*, 3 , 4
		FB 93	2*, 3 , 4
MD 237	-	FB144	4*
MD 238	-	FB 40	7*
MD 242	-	FB 40	7*
		FB143	2*
		FB152	1*
MD 246	-	FB 40	7*
MD 248	-	FB 41	2*, 4*
		FB144	4*
		FB193	1*

QUERVERWEISLISTE: BAUSTEINE

```
   PB     1 : BEARBEITET
   PB     3 : BEARBEITET
   PB     6 : BEARBEITET
   PB     7 : BEARBEITET
   PB     8 : BEARBEITET
   PB     9 : BEARBEITET
   PB    10 : BEARBEITET
   PB    11 : BEARBEITET
   PB    12 : BEARBEITET
   PB    13 : BEARBEITET
   PB    14 : BEARBEITET
   PB    15 : BEARBEITET
   PB    16 : BEARBEITET
   PB    17 : BEARBEITET
   PB    18 : BEARBEITET
   PB    19 : BEARBEITET
   PB    20 : BEARBEITET
   PB    21 : BEARBEITET
   PB    30 : BEARBEITET
   PB    31 : BEARBEITET
   PB    40 : BEARBEITET
   PB    41 : BEARBEITET
   PB    42 : BEARBEITET
   PB    55 : BEARBEITET
   PB    60 : BEARBEITET
   PB    61 : BEARBEITET
   PB    79 : BEARBEITET
   PB    80 : BEARBEITET
   PB    81 : BEARBEITET
   PB    82 : BEARBEITET
   PB    83 : BEARBEITET
   PB    84 : BEARBEITET
   PB    85 : BEARBEITET
   PB    86 : BEARBEITET
   PB    87 : BEARBEITET
   PB    88 : BEARBEITET
   PB    90 : BEARBEITET
   PB    91 : BEARBEITET
   PB    92 : BEARBEITET
   PB    93 : BEARBEITET
   PB    95 : BEARBEITET
   PB   100 : BEARBEITET
   PB   101 : BEARBEITET
   PB   253 : BEARBEITET
   PB   255 : BEARBEITET
   FB    1S: BEARBEITET
   FB    2S: BEARBEITET
   FB    3S: BEARBEITET
   FB    4S: BEARBEITET
   FB    5S: BEARBEITET
   FB    6S: BEARBEITET
   FB   10S: BEARBEITET
   FB   11S: BEARBEITET
   FB   12S: BEARBEITET
   FB   13S: BEARBEITET
   FB   23 : BEARBEITET
   FB   33 : BEARBEITET
   FB   39 : BEARBEITET
   FB   40S: BEARBEITET
   FB   41S: BEARBEITET
   FB   43 : BEARBEITET
   FB   44 : BEARBEITET
   FB   46 : BEARBEITET
   FB   47 : BEARBEITET
   FB   48 : BEARBEITET
   FB   50 : BEARBEITET
   FB   51 : BEARBEITET
   FB   52 : BEARBEITET
   FB   53 : BEARBEITET
   FB   54 : BEARBEITET
   FB   55 : BEARBEITET
   FB   57 : BEARBEITET
   FB   58 : BEARBEITET
   FB   72 : BEARBEITET
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QUERVERWEISLISTE: BAUSTEINE

```
   FB   73 : BEARBEITET
   FB   74 : BEARBEITET
   FB   75 : BEARBEITET
   FB   76 : BEARBEITET
   FB   77 : BEARBEITET
   FB   78 : BEARBEITET
   FB   80 : BEARBEITET
   FB   82 : BEARBEITET
   FB   83 : BEARBEITET
   FB   84 : BEARBEITET
   FB   86 : BEARBEITET
   FB   87 : BEARBEITET
   FB   88 : BEARBEITET
   FB   89 : BEARBEITET
   FB   90 : BEARBEITET
   FB   91 : BEARBEITET
   FB   92 : BEARBEITET
   FB   93 : BEARBEITET
   FB   95 : BEARBEITET
   FB   96 : BEARBEITET
   FB   98 : BEARBEITET
   FB   99 : BEARBEITET
   FB  100 : BEARBEITET
   FB  110 : BEARBEITET
   FB  112 : BEARBEITET
   FB  113 : BEARBEITET
   FB  115 : BEARBEITET
   FB  116 : BEARBEITET
   FB  118 : BEARBEITET
   FB  120S: BEARBEITET
   FB  121S: BEARBEITET
   FB  122S: BEARBEITET
   FB  123S: BEARBEITET
   FB  124S: BEARBEITET
   FB  125S: BEARBEITET
   FB  126S: BEARBEITET
   FB  127S: BEARBEITET
   FB  130S: BEARBEITET
   FB  141S: BEARBEITET
   FB  142S: BEARBEITET
   FB  143S: BEARBEITET
   FB  144S: BEARBEITET
   FB  148 : BEARBEITET
   FB  149 : BEARBEITET
   FB  150 : BEARBEITET
   FB  151S: BEARBEITET
   FB  152S: BEARBEITET
   FB  153S: BEARBEITET
   FB  154S: BEARBEITET
   FB  155S: BEARBEITET
   FB  163S: BEARBEITET
   FB  170 : BEARBEITET
   FB  171 : BEARBEITET
   FB  172 : BEARBEITET
   FB  173 : BEARBEITET
   FB  174 : BEARBEITET
   FB  175 : BEARBEITET
   FB  176 : BEARBEITET
   FB  177 : BEARBEITET
   FB  178 : BEARBEITET
   FB  179 : BEARBEITET
   FB  180 : BEARBEITET
   FB  182 : BEARBEITET
   FB  184 : BEARBEITET
   FB  185 : BEARBEITET
   FB  186 : BEARBEITET
   FB  187 : BEARBEITET
   FB  188 : BEARBEITET
   FB  189 : BEARBEITET
   FB  190 : BEARBEITET
   FB  191 : BEARBEITET
   FB  192 : BEARBEITET
   FB  193 : BEARBEITET
   FB  194 : BEARBEITET
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK                !                                !
!ELASTOMERTECHNIK          WERK HARBURG !  MASTERPROGRAMM                       !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE          !  DATE        :                      !
! INSTALLATION     : TREAD-LINE           !  MODIFICATION:                PGNO!
! PROJECT POS. NO.: 84/823804             !  PROGRAMMER  :                   2!
+-------------------------------------------------------------------------------+
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QUERVERWEISLISTE: BAUSTEINE

```
   FB  195 : BEARBEITET
   FB  196S: BEARBEITET
   FB  199 : BEARBEITET
   FB  202 : BEARBEITET
   FB  203 : BEARBEITET
   FB  254 : BEARBEITET
   FB  255 : BEARBEITET
   OB    1 : BEARBEITET
   OB   13 : BEARBEITET
   OB   20 : BEARBEITET
   OB   21 : BEARBEITET
   OB   22 : BEARBEITET
```

QUERVERWEISLISTE: BAUSTEINE

PB	0	-		FB143	2#
				FB144	4#
PB	1	-PB 1		OB 1	1
PB	3	-PB 3		OB 1	1
PB	6	-PB 6		OB 20	1
PB	8	-PB 8		OB 21	1
				OB 22	1
PB	9	-PB 9		OB 1	1
PB	10	-PB 10		OB 1	2
PB	11	-PB 11		OB 1	2
PB	12	-PB 12		OB 1	2
PB	13	-PB 13		OB 1	2
PB	14	-PB 14		OB 1	2
PB	15	-PB 15		OB 1	2
PB	16	-PB 16		OB 1	2
PB	17	-PB 17		OB 1	2
PB	18	-PB 18		OB 1	1
PB	19	-PB 19		OB 1	2
PB	20	-PB 20		OB 1	3
PB	21	-PB 21		OB 1	3
PB	30	-PB 30		OB 1	3
PB	31	-PB 31		OB 1	3
PB	40	-PB 40		OB 1	3
PB	41	-PB 41		OB 1	3
PB	42	-PB 42		OB 1	3
PB	55	-PB 55		OB 1	4
PB	60	-PB 60		OB 1	4
PB	61	-PB 61		OB 1	4
PB	79	-PB 79		OB 1	4
PB	80	-PB 80		OB 1	4
PB	81	-PB 81		OB 1	4
PB	82	-PB 82		OB 1	4
PB	83	-PB 83		OB 1	4
PB	84	-PB 84		OB 1	4
PB	85	-PB 85		OB 1	4
PB	86	-PB 86		OB 1	4
PB	87	-PB 87		OB 1	4
PB	88	-PB 88		OB 1	4

QUERVERWEISLISTE: BAUSTEINE

PB 90	-PB 90	OB 1	4
PB 91	-PB 91	OB 1	4
PB 92	-PB 92	OB 1	4
PB 93	-PB 93	OB 1	1
PB 95	-PB 95	OB 1	4
PB 100	-PB 100	OB 1	1
PB 101	-PB 101	PB100	1
PB 255	-PB 255	OB 20	1
		OB 21	1
		OB 22	1
FB 23	-FB 23	OB 1	2
FB 33	-FB 33	PB 82	49 , 50 , 51 , 52 , 53 , 54 , 55
FB 39	-FB 39	OB 1	4
FB 43	-FB 43	PB 93	14 , 15 , 16 , 17 , 18 , 19 , 20 , 21
FB 44	-FB 44	PB 20	37 , 39 , 41
		PB 30	37 , 39 , 41
		PB 40	40 , 41 , 43
		PB 80	16
		PB 88	10
		PB 91	26 , 27 , 29 , 34
		PB 95	2 , 3 , 4 , 5 , 6 , 7 , 8 , 9 , 10 , 11 , 12 , 13
		FB 72	1
FB 46	-FB 46	PB 93	2 , 3 , 4 , 5 , 6 , 7 , 8 , 9 , 10 , 12 , 13 , 22 , 23 , 24 , 25 , 26 , 27 , 28
FB 48	-FB 48	PB 20	38 , 40
		PB 30	38 , 40
		PB 80	15
		PB 88	9
FB 50	-FB 50	FB 55	11 , 12
FB 51	-FB 51	FB 55	6 , 7 , 8 , 9
FB 52	-FB 52	PB 18	4
FB 53	-FB 53	PB 18	1
FB 54	-FB 54	PB 18	2
FB 55	-FB 55	OB 1	1
FB 57	-FB 57	OB 1	1
FB 58	-FB 58	PB 20	36
		PB 30	36
		PB 40	39
		PB 81	7
FB 72	-FB 72	PB 42	19
FB 73	-FB 73	PB 80	41
FB 74	-FB 74	PB 81	9 , 10 , 14 , 16
FB 75	-FB 75	PB 81	11 , 12 , 13 , 15
FB 76	-FB 76	PB 91	28

QUERVERWEISLISTE: BAUSTEINE

FB 77	-FB 77	PB 40	42
FB 78	-FB 78	PB 91	32
FB 80	-FB 80	PB 20	35
		PB 30	35
		PB 40	38
		PB 81	6 , 17
		PB 91	24
FB 82	-FB 82	PB 81	8
FB 83	-FB 83	PB 84	2
FB 84	-FB 84	PB 84	3
FB 86	-FB 86	PB 85	5
FB 87	-FB 87	PB 85	7
FB 88	-FB 88	PB 88	7
FB 90	-FB 90	OB 20	1
		OB 21	1
		OB 22	1
FB 91	-FB 91	FB 55	4
FB 92	-FB 92	FB 55	5
FB 93	-FB 93	PB 88	8
FB 95	-FB 95	PB100	1
FB 96	-FB 96	PB 91	25
FB 99	-FB 99	OB 1	4
FB 100	-FB 100	FB 55	3
FB 120	-FB 120	PB 7	2
		PB253	1
		FB 91	1
		FB113	3
		FB148	7
		FB149	4
		FB150	3
		FB188	3
		FB189	3
FB 121	-FB 121	PB 7	2
		FB 92	1
FB 123	-FB 123	PB 7	2
		FB 91	1
		FB 92	1
		FB186	2
FB 125	-FB 125	PB 7	2
		FB 90	1
		OB 20	1
		OB 21	1
		OB 22	1
FB 126	-FB 126	PB 7	2
		PB 18	3
FB 127	-FB 127	PB 7	2
		FB148	1
		FB149	2
		FB150	4
FB 130	-FB 130	PB 6	2
		PB 8	2

QUERVERWEISLISTE: BAUSTEINE

		OB 1	1
FB 141	-	PB 3	9 , 10 , 11 , 12
FB 143	-	PB 3	13
FB 144	-	PB 3	2
FB 148	-FB 148	FB 54	3 , 4 , 5 , 6
FB 150	-FB 150	FB 54	7
FB 151	-	PB 3	5
FB 152	-	PB 3	6
FB 153	-	PB 3	3 , 4
FB 154	-	PB 3	7
FB 155	-	PB 3	8
FB 170	-FB 170	PB100	1
FB 171	-FB 171	FB170	3
FB 172	-FB 172	FB170	4
FB 173	-FB 173	FB170	5
FB 174	-FB 174	FB170	6
FB 175	-FB 175	FB170	8
FB 176	-FB 176	FB170	9
FB 177	-FB 177	FB170	10
FB 178	-FB 178	FB170	11
FB 179	-FB 179	FB170	12
FB 180	-FB 180	FB170	13
FB 182	-FB 182	PB100	1
FB 184	-FB 184	FB115	4
		FB118	3
		FB171	3
		FB175	4
		FB178	4
		FB190	3
FB 185	-FB 185	FB112	4
		FB115	4
		FB116	4
		FB118	3
		FB171	3
		FB172	4
		FB174	2
		FB175	4
		FB176	4
		FB178	4
		FB180	3 , 4
		FB190	3
		FB192	1
FB 186	-FB 186	PB100	1
FB 187	-FB 187	PB100	1
FB 188	-FB 188	PB100	1
FB 189	-FB 189	PB100	1

QUERVERWEISLISTE: BAUSTEINE

FB 190	-FB 190	FB170	7
FB 192	-FB 192	FB171	3
FB 193	-FB 193	PB100	1
		FB195	1
FB 194	-FB 194	PB100	1
		FB195	1
FB 195	-FB 195	PB100	1
FB 199	-FB 199	PB100	1
FB 202	-FB 202	PB 9	3
FB 254	-FB 254	OB 20	1
		OB 21	1
		OB 22	1
FB 255	-FB 255	OB 1	2
OB 160	-	FB185	1
OB 181	-	FB185	1
OB 217	-	FB144	3 , 4
OB 220	-	FB 43	2
		FB 46	3
OB 230	-	FB120	1
OB 231	-	FB121	1
OB 232	-	FB122	1
OB 233	-	FB123	1
OB 234	-	FB124	1
OB 235	-	FB125	1
OB 236	-	FB126	1
OB 237	-	FB127	1
DB 0	-	FB115	4#
		FB150	4#, 5#
		FB151	1#
		FB153	1#
		FB175	4#
		FB185	1#
		FB193	1#
		FB194	1#
		FB196	3#
DB 6	-DB 6	PB 3	1
		PB 6	2
		PB 7	2
		PB 8	2
		PB253	1
		FB199	1
		OB 1	1
		OB 13	1
DB 20	-DB 20	FB 55	10 , 11?, 12?
		FB110	1
DB 21	-DB 21	FB 39	1
		FB 55	6?, 7?, 8?, 9?, 10
		FB 95	2

QUERVERWEISLISTE: BAUSTEINE

DB	40	-DB	40	FB 52 1
DB	41	-DB	41	FB 52 1
DB	42	-DB	42	FB 52 1
DB	43	-DB	43	FB 52 1
DB	44	-DB	44	FB 52 1
DB	45	-DB	45	FB 52 1
DB	46	-DB	46	FB 52 1
DB	48	-DB	48	FB 52 1
DB	49	-DB	49	FB 52 1
DB	50	-DB	50	FB 52 1
DB	51	-DB	51	FB 52 1
DB	52	-DB	52	FB 52 1
DB	53	-DB	53	FB 52 1
DB	54	-DB	54	FB 52 1
DB	60	-DB	60	FB 53 1 FB 54 3?
DB	61	-DB	61	FB 53 1 FB 54 3?
DB	62	-DB	62	FB 53 1 FB 54 3?
DB	63	-DB	63	FB 53 1 FB 54 3?
DB	64	-DB	64	FB 53 1 FB 54 4?
DB	65	-DB	65	FB 53 1 FB 54 4?
DB	66	-DB	66	FB 53 1 FB 54 4?
DB	67	-DB	67	FB 53 1 FB 54 4?
DB	68	-DB	68	FB 53 1 FB 54 5?
DB	69	-DB	69	FB 53 1 FB 54 5?
DB	70	-DB	70	FB 53 1 FB 54 5?
DB	71	-DB	71	FB 53 1 FB 54 5?
DB	72	-DB	72	FB 53 1 FB 54 6?
DB	73	-DB	73	FB 53 1 FB 54 6?
DB	74	-DB	74	FB 53 1 FB 54 6?
DB	95	-DB	95	PB 81 9?, 10?, 11?, 12?, 13?, 14?, 15?, 16?, 17?, 18

QUERVERWEISLISTE: BAUSTEINE

		PB 86	1
		PB 91	24?, 26?, 32?, 33 , 34?
		PB 93	11 , 22?, 23?, 24?, 25?, 26?, 27?, 28?
		PB 95	2?, 3?, 4?, 5?, 6?, 7?, 8?, 9?, 10?, 11?, 12?, 13?
		FB 72	1
		FB 82	1
		FB 96	1
DB 100	-DB 100	FB118	3
		FB178	4
DB 150	-DB 150	FB148	1 , 2 , 3 , 4 , 5 , 6
		FB149	2 , 3
		FB150	2
DB 151	-DB 151	FB148	1
		FB149	2
		FB150	4 , 5 , 6
DB 160	-DB 160	PB 20	36?
		PB 30	36?
		PB 40	39?
		PB 81	7?
		FB171	3
		FB174	2
		FB180	5
		FB190	3
		FB192	1
DB 170	-DB 170	PB 20	33 , 38?, 39?, 40?, 41?
		PB 21	2
		PB 30	33 , 38?, 39?, 40?, 41?
		PB 31	2
		PB 40	36 , 41?, 43?
		PB 80	15?, 16?
		PB 81	9?, 10?, 11?, 12?, 13?, 14?, 15?, 16?
		PB 82	49?, 50?, 51?, 52?, 53?, 54?, 55?
		PB 83	10
		PB 87	5
		PB 88	9?, 10?
		PB 91	27?, 29?
		PB 93	2?, 3?, 4?, 5?, 6?, 7?, 8?, 9?, 10?, 11 , 12?, 13?, 14?, 15?, 16?, 17?, 18?, 19?, 20?, 21?
		PB101	1 , 11
		FB 23	2 , 3 , 4
		FB 39	1
		FB 52	1
		FB 57	1 , 2 , 3
		FB 76	1
		FB 77	1
		FB 84	2
		FB 86	2
		FB 87	2
		FB 88	2
		FB 89	1
		FB 93	2
		FB 99	1
		FB171	3
		FB174	2
		FB191	1
		FB194	1
		FB199	1
DB 180	-DB 180	PB 20	35?, 36?, 37?
		PB 30	35?, 36?, 37?
		PB 40	38?, 39?, 40?
		PB 80	41?
		PB 81	6?, 7?
		PB101	1
		FB 23	3
		FB 52	1
		FB 53	1
		FB 55	10

QUERVERWEISLISTE: BAUSTEINE

		FB 82	1
		FB 84	3
		FB 87	3
		FB 89	1
		FB 93	3
		FB 95	2
		FB110	1
		FB170	7
		FB171	3
		FB192	1
		FB193	1
		FB194	1
		FB195	1
DB 184	-DB 184	PB255	1
		FB115	4?
		FB118	3
		FB171	3
		FB174	2
		FB175	4?
		FB178	4
		FB180	5
		FB190	3
DB 185	-DB 185	PB 20	36
		PB 30	36
		PB 81	7
		PB255	1
		FB 39	1
		FB112	2 , 4
		FB113	2 , 3
		FB115	2 , 4
		FB116	2 , 4
		FB118	2 , 3
		FB170	2 , 7
		FB171	2 , 3
		FB172	2 , 4
		FB173	2
		FB174	2 , 3
		FB175	2 , 4
		FB176	2 , 4
		FB177	2
		FB178	2 , 4
		FB179	2
		FB180	2 , 3 , 4 , 5 , 6
		FB182	2
		FB186	2
		FB188	2 , 3
		FB189	2 , 3
		FB190	2 , 3
DB 188	-DB 188	FB 84	2 , 3 , 4 , 5
		FB 87	2 , 3 , 4 , 5
		FB 93	2 , 3 , 4 , 5
		FB 95	2
		FB191	1
DB 199	-DB 199	PB253	1
		FB171	3
		FB199	1

QUERVERWEISLISTE: DATEN

PB 1 : BEARBEITET
PB 3 : BEARBEITET
PB 6 : BEARBEITET
PB 7 : BEARBEITET
PB 8 : BEARBEITET
PB 9 : BEARBEITET
PB 10 : BEARBEITET
PB 11 : BEARBEITET
PB 12 : BEARBEITET
PB 13 : BEARBEITET
PB 14 : BEARBEITET
PB 15 : BEARBEITET
PB 16 : BEARBEITET
PB 17 : BEARBEITET
PB 18 : BEARBEITET
PB 19 : BEARBEITET
PB 20 : BEARBEITET
PB 21 : BEARBEITET
PB 30 : BEARBEITET
PB 31 : BEARBEITET
PB 40 : BEARBEITET
PB 41 : BEARBEITET
PB 42 : BEARBEITET
PB 55 : BEARBEITET
PB 60 : BEARBEITET
PB 61 : BEARBEITET
PB 79 : BEARBEITET
PB 80 : BEARBEITET
PB 81 : BEARBEITET
PB 82 : BEARBEITET
PB 83 : BEARBEITET
PB 84 : BEARBEITET
PB 85 : BEARBEITET
PB 86 : BEARBEITET
PB 87 : BEARBEITET
PB 88 : BEARBEITET
PB 90 : BEARBEITET
PB 91 : BEARBEITET
PB 92 : BEARBEITET
PB 93 : BEARBEITET
PB 95 : BEARBEITET
PB 100 : BEARBEITET
PB 101 : BEARBEITET
PB 253 : BEARBEITET
PB 255 : BEARBEITET
FB 1S: BEARBEITET
FB 2S: BEARBEITET
FB 3S: BEARBEITET
FB 4S: BEARBEITET
FB 5S: BEARBEITET
FB 6S: BEARBEITET
FB 10S: BEARBEITET
FB 11S: BEARBEITET
FB 12S: BEARBEITET
FB 13S: BEARBEITET
FB 23 : BEARBEITET
FB 33 : BEARBEITET
FB 39 : BEARBEITET
FB 40S: BEARBEITET
FB 41S: BEARBEITET
FB 43 : BEARBEITET
FB 44 : BEARBEITET
FB 46 : BEARBEITET
FB 47 : BEARBEITET
FB 48 : BEARBEITET
FB 50 : BEARBEITET
FB 51 : BEARBEITET
FB 52 : BEARBEITET
FB 53 : BEARBEITET
FB 54 : BEARBEITET
FB 55 : BEARBEITET
FB 57 : BEARBEITET
FB 58 : BEARBEITET
FB 72 : BEARBEITET

QUERVERWEISLISTE: DATEN

```
   FB  195 : BEARBEITET
   FB  196S: BEARBEITET
   FB  199 : BEARBEITET
   FB  202 : BEARBEITET
   FB  203 : BEARBEITET
   FB  254 : BEARBEITET
   FB  255 : BEARBEITET
   OB    1 : BEARBEITET
   OB   13 : BEARBEITET
   OB   20 : BEARBEITET
   OB   21 : BEARBEITET
   OB   22 : BEARBEITET
```

QUERVERWEISLISTE: DATEN

D	0.0 -	FB151	1
		FB152	1*
		FB153	1*
D	0.1 -	FB153	1*
D	0.2 -	FB153	1*
D	0.3 -	FB153	1
D	1.0 -	FB143	2
		FB180	2*, 6*
D	1.1 -	FB143	2
		FB170	3*
		FB171	3*
D	1.2 -	FB112	3*, 4*
		FB170	4*
		FB172	3*, 4*
D	1.3 -	FB170	5*
		FB173	4*, 5*
D	1.4 -	FB170	6*
		FB174	5*, 6*
D	1.5 -	FB115	2*, 4*
		FB170	8*
		FB175	2*, 4*
D	1.6 -	FB116	2*, 4*
		FB170	9*
		FB176	2*, 4*
D	1.7 -	FB170	10*
		FB177	2*
D	2.0 -	FB112	2*, 3*, 4*
		FB115	2*, 4*
		FB116	2*, 4*
		FB118	2*, 3*, 4*
		FB171	2*, 3*
		FB172	2*, 3*, 4*
		FB175	2*, 4*
		FB176	2*, 4*
		FB178	2*, 4*, 5*
		FB190	2*, 3*, 4*
D	2.1 -	FB112	2*, 3*, 4*
		FB115	2*, 4*
		FB116	2*, 4*
		FB118	2*, 3*, 4*
		FB171	3*
		FB175	2 , 3*, 4*
		FB176	2 , 3*, 4*
D	2.2 -	FB115	2*, 3*, 4*
		FB116	2*, 3*, 4*
D	2.5 -	FB170	7*
		FB190	3*, 4*
D	17.0 -	FB143	2*
		FB144	2*, 3*, 4*
D	17.1 -	FB143	2
D	17.2 -	FB143	2
D	17.3 -	FB144	3*
		FB153	1*

QUERVERWEISLISTE: DATEN

D	17.4 -	FB144	3*
		FB153	1*
D	19.0 -	FB113	2*, 3*
		FB189	2*, 3*
D	19.7 -	FB112	2 , 3 , 4
		FB113	3*
		FB115	2 , 3 , 4
		FB116	2 , 3 , 4
		FB118	2 , 3 , 4
		FB171	2 , 3
		FB172	2
		FB173	2 , 4 , 5
		FB174	3 , 5 , 6
		FB175	2 , 3
		FB176	2 , 3
		FB178	2
		FB179	2
		FB189	3*
		FB190	2 , 3 , 4
D	20.0 -	FB113	2
		FB170	14*
		FB173	4*
		FB174	5*
		FB189	2
D	20.1 -	FB113	2
		FB170	2*
		FB173	5*
		FB174	6*
		FB189	2
D	20.2 -	FB113	2
		FB171	2*
		FB189	2
D	20.3 -	FB113	2
		FB173	2*
		FB174	3*
		FB189	2
D	20.4 -	FB113	2
		FB189	2
D	20.5 -	FB112	3*, 4*
		FB113	2
		FB115	2*, 4*
		FB116	2*, 4*
		FB118	3*, 4*
		FB171	3*
		FB189	2
D	20.6 -	FB113	2
		FB115	2*
D	20.7 -	FB112	2*
		FB113	2
D	21.0 -	FB113	2
		FB189	2
D	21.1 -	FB113	2
		FB189	2
D	21.2 -	FB113	2
		FB116	2*
		FB176	2*
		FB189	2
D	21.3 -	FB113	2
		FB115	2*
		FB175	2*

QUERVERWEISLISTE: DATEN

		FB189	2
D	21.4 -	FB113	2
		FB189	2
D	21.5 -	FB113	2
		FB175	2*
		FB176	2*
		FB189	2
D	21.6 -	FB113	2
		FB189	2
D	22.0 -	FB113	2
		FB189	2
		FB190	2*
D	23.0 -	FB177	2*
		FB188	2
D	24.0 -	FB179	2*
		FB188	2
D@	1.8 -	FB118	3*, 4*
		FB170	11*
		FB178	4*, 5*
D@	1.9 -	FB 39	1
		FB170	12*
		FB179	2*
		FB182	2*
D@	1.A -	FB170	3 , 4 , 5 , 6*, 8 , 9 , 10 , 11
		FB180	6*
D@	1.B -	PB 20	36
		PB 30	36
		PB 81	7
		FB112	4
		FB170	4 , 10
		FB172	4
		FB174	2*
		FB180	2*
		FB182	2*
D@	1.C -	FB170	12
		FB177	2*
		FB179	2*
		FB182	2*
D@	1.D -	FB173	2*, 4*, 5*
		FB174	3*, 5*, 6*
		FB182	2*
D@	1.E -	FB112	3*, 4*
		FB115	2*, 4*
		FB116	2*, 4*
		FB118	3*, 4*
		FB170	3*, 4*, 5*, 6*, 7*, 8*, 9*, 10*, 11*, 12*, 13 , 14
		FB171	3*
		FB172	3*, 4*
		FB173	4*, 5*
		FB174	5*, 6*
		FB175	2*, 4*
		FB176	2*, 4*
		FB177	2*
		FB178	4*, 5*
		FB179	2*
		FB180	2*, 6*
		FB182	2*
		FB190	3*, 4*
D@	1.F -	FB170	2*, 14*

QUERVERWEISLISTE: DATEN

		FB173	4*
		FB174	5*
		FB182	2*
D@	2.C -	FB170	10
D@	5.8 -	PB 3	9
D@	5.9 -	PB 3	10
D@	5.A -	PB 3	11
D@	5.B -	PB 3	12
D@	8.8 -	OB 13	1*
D@	8.D -	PB 6	2*
		PB 8	2*
D@	8.E -	PB 8	2*
D@	8.F -	PB 6	2*
D@	19.8 -	FB188	2*, 3*
D@	19.F -	FB188	3*
D@	20.8 -	FB113	2
		FB116	2*
D@	20.9 -	FB113	2
		FB118	2*
D@	21.8 -	FB112	2*
		FB113	2
		FB172	2*
		FB189	2
D@	21.9 -	FB113	2
		FB189	2
D@	21.A -	FB113	2
		FB115	3*
		FB175	3*
		FB189	2
D@	21.B -	FB113	2
		FB116	3*
		FB176	3*
		FB189	2
D@	21.C -	FB113	2
		FB118	2*
		FB178	2*
		FB189	2
D@	21.E -	FB113	2
		FB171	3*
		FB189	2
D@	92.8 -	PB 7	2
		FB143	2*
D@	92.9 -	PB 7	2
		FB144	4*
D@	92.A -	PB 7	2
D@	92.B -	PB 7	2
D@	92.C -	PB 7	2
D@	92.D -	PB 7	2

QUERVERWEISLISTE: DATEN

D@	92.E	-	PB 7	2
DL	0	-	FB151	1#
			FB153	1*
			FB196	3#
DL	1	-	PB101	1
			FB115	4*
			FB118	3*
			FB170	7
			FB171	3
			FB174	2
			FB175	4*
			FB178	4*
			FB180	5*
			FB191	1*
			FB193	1
			FB194	1
			FB195	1
DL	2	-	FB143	2*
			FB149	3*
			FB191	1*
DL	3	-	FB112	4
			FB115	4
			FB116	4
			FB118	3
			FB170	13
			FB171	3
			FB172	4
			FB174	2*
			FB175	4
			FB176	4
			FB178	4
			FB180	2 , 5*
			FB190	3
			FB191	1*
DL	4	-	FB 55	7?
			FB115	2*, 4
			FB149	3*
			FB175	2*, 4
DL	5	-	FB 55	9?
			FB148	3
			FB149	3*
DL	6	-	FB191	3*
DL	7	-	FB 55	12?
			FB191	3*
DL	8	-	PB 6	2*
			PB 8	2*
			FB149	3*
DL	9	-	FB191	3*
DL	10	-	FB191	3*
DL	11	-	FB191	3*
DL	12	-	FB191	3*
DL	13	-	FB115	4*
			FB175	4*
			FB191	3*
DL	14	-	FB191	3*
DL	16	-	FB191	3*
DL	18	-	FB191	5*

QUERVERWEISLISTE: DATEN

DL 19	-	FB191	5*
DL 21	-	FB 84	3*
		FB 87	3*
		FB143	2*
		FB144	4*
DL 22	-	FB 84	5*
DL 23	-	FB 84	4*
DL 24	-	FB 93	3*, 4*
DL 27	-	FB191	6*
DL 28	-	FB191	3*
DL 30	-	PB101	1
		FB115	4*
		FB118	3*
		FB170	7
		FB175	4*
		FB178	4*
		FB195	1
DL 31	-	PB101	1
		FB 87	3*
		FB115	4*
		FB118	3*
		FB170	7
		FB175	4*
		FB178	4*
		FB195	1
DL 32	-	FB 87	5*
DL 33	-	FB 87	4*
DL 34	-	FB 95	2*
DL 35	-	FB 95	2*
DL 46	-	FB191	1*
DL 47	-	FB191	1*
DL 53	-	FB199	1
DL 54	-	FB199	1
DL 55	-	FB199	1
DL 57	-	FB191	3*
DL 58	-	FB191	3*
DL 59	-	FB191	3*
DL 60	-	FB191	5*
DL 61	-	FB191	5*
DL 62	-	FB191	4*
DL 63	-	FB191	4*
DL 64	-	FB 84	3*
DL 65	-	FB 84	5*
DL 66	-	FB 84	4*
DL 67	-	FB 93	3*, 4*

QUERVERWEISLISTE: DATEN

DL 70	-	FB191	1*
DL 71	-	FB191	6*
DL 76	-	FB191	4*
DL 77	-	FB191	4*
DL 78	-	FB191	4*
DL 80	-	FB191	3*
DL 81	-	FB191	3*
DL 82	-	FB191	3*
DL 85	-	FB191	6*
DL 91	-	FB191	3*
DL 92	-	PB 7	2*
DL 98	-	FB 87	3*
DL 99	-	FB 87	5*
DL 100	-	FB 87	4*
DL 102	-	FB191	5*
DL 104	-	FB150	2*
DL 106	-	FB191	1*
DL 107	-	FB191	1*
DL 108	-	FB191	1*
DL 109	-	FB191	1*
DL 111	-	FB150	5 , 6
		FB191	6*
DL 113	-	FB150	6
DL 114	-	FB150	6*
DL 130	-	FB191	1*
DL 131	-	FB191	1*
DR 0	-	FB151	1
		FB152	1*
		FB153	1
DR 1	-	FB151	1*
		FB152	1*
		FB153	1
		FB171	3*
		FB182	2*
		FB190	3*
		FB191	2*
DR 2	-	FB144	2 , 3*, 4*
		FB149	2 , 3*
		FB152	1*
		FB191	2*
DR 3	-	FB170	13*
		FB174	2*
		FB180	2 , 3 , 4 , 5
		FB191	2*

QUERVERWEISLISTE: DATEN

DR	4	-	FB 55	6?
			FB149	2 , 3*
DR	5	-	FB 55	8?
			FB148	3
			FB149	3*
DR	7	-	FB 55	11?
			FB191	3*
DR	8	-	FB149	3*
DR	9	-	FB191	3*
DR	10	-	FB191	3*
DR	11	-	FB191	3*
DR	12	-	FB191	3*
DR	13	-	FB115	4*
			FB118	3
			FB175	4*
			FB178	4
			FB191	3*
DR	14	-	FB191	3*
DR	15	-	FB191	3*
DR	18	-	PB255	1*
			FB191	5*
DR	19	-	FB191	5*
DR	21	-	FB 84	3*
			FB 87	3*
			FB143	2*
			FB144	4*
DR	23	-	FB 84	4*
DR	24	-	FB 93	3*, 4*
DR	28	-	PB255	1*
			FB191	6*
DR	31	-	FB 87	3*
			FB144	4*
			FB188	3*
DR	33	-	FB 87	4*
			FB151	1
DR	34	-	FB 95	2*
DR	38	-	PB255	1*
			FB151	1
			FB152	1
DR	41	-	FB113	3*
			FB152	1
			FB153	1
			FB189	3*
DR	46	-	FB191	2*
DR	47	-	FB191	2*
DR	48	-	PB255	1*
DR	52	-	FB199	1
DR	53	-	FB199	1

QUERVERWEISLISTE: DATEN

DR 54	-	FB199	1
DR 58	-	PB255	1*
DR 59	-	FB191	3*
DR 60	-	FB191	5*
DR 62	-	FB191	4*
DR 64	-	FB 84	3*
DR 66	-	FB 84	4*
DR 67	-	FB 93	3*, 4*
DR 68	-	PB255	1*
DR 70	-	FB191	2*
DR 71	-	FB191	6*
DR 72	-	FB190	3*
DR 76	-	FB191	4*
DR 77	-	FB191	4*
DR 78	-	PB255	1*
DR 79	-	FB191	3*
DR 80	-	FB191	3*
DR 82	-	FB191	3*
DR 84	-	FB191	3*
DR 86	-	FB153	1
DR 88	-	PB255	1*
DR 90	-	FB151	1
		FB153	1
DR 91	-	FB191	3*
DR 92	-	PB 7	2*
		FB143	2
		FB144	4
		FB191	3*
DR 98	-	PB255	1*
		FB 87	3*
DR 100	-	FB 87	4*
		FB118	3*
		FB149	3
		FB178	4*
		FB180	3*
DR 101	-	FB149	3
DR 102	-	FB149	3
DR 103	-	FB149	3
		FB150	2
DR 104	-	FB149	3
DR 106	-	FB191	1*
DR 107	-	FB191	1*

QUERVERWEISLISTE: DATEN

DR 108	-	PB255	1*
		FB191	1*
DR 111	-	FB150	5 , 6
DR 113	-	FB150	6
DR 114	-	FB150	6*
DR 118	-	PB255	1*
DR 128	-	PB255	1*
DR 130	-	FB191	1*
DR 138	-	PB255	1*
DR 148	-	PB255	1*
DR 158	-	PB255	1*
DR 168	-	PB255	1*
DR 178	-	PB255	1*
DR 188	-	PB255	1*
DR 198	-	PB255	1*
DR 202	-	FB112	4*
		FB172	4*
DR 208	-	PB255	1*
DR 218	-	PB255	1*
DR 228	-	PB255	1*
DR 238	-	PB255	1*
DR 248	-	PB255	1*
		FB174	2*
		FB180	5*
DR 249	-	FB171	3*
		FB190	3
DW 0	-	FB143	2#
		FB144	3#, 4#
		FB148	4#, 5#, 6#
		FB149	3#
		FB150	4#, 5#, 6#
		FB151	1#
		FB152	1#
		FB153	1#
		FB174	2#
		FB180	5#
		FB184	2#
		FB185	1#
DW 1	-	PB255	1*
		FB118	3*
		FB143	2
		FB144	2 , 3 , 4
		FB148	2*
		FB149	3*
		FB150	2*, 4
		FB152	1*
		FB153	1*
		FB171	3
		FB178	4*
		FB199	1*

QUERVERWEISLISTE: DATEN

DW	2	-	PB255	1*
			FB 99	1*
			FB118	3*
			FB148	1*, 2*
			FB149	2
			FB150	2*
			FB171	3
			FB178	4*
			FB182	2*
			FB199	1*
DW	3	-	PB255	1*
			FB 55	10*
			FB 99	1*
			FB118	3*
			FB148	1*, 2*
			FB149	2 , 3*
			FB150	2*
			FB178	4*
			FB199	1*
DW	4	-	FB 55	10*
			FB118	3*
			FB148	2*
			FB149	2
			FB150	2*
			FB178	4*
			FB199	1*
DW	5	-	FB 55	10*
			FB116	2*
			FB118	3*
			FB148	3*
			FB149	2
			FB150	2*
			FB176	2*
			FB178	4*
			FB199	1*
DW	6	-	FB116	2*
			FB118	3*
			FB148	3
			FB149	3*
			FB150	2*
			FB176	2*
			FB178	4*
			FB199	1*
DW	7	-	FB 39	1
			FB116	2*
			FB118	3*
			FB149	3*
			FB150	2*
			FB176	2*
			FB178	4*
DW	8	-	FB 39	1
			FB 55	10*
			FB110	1*
			FB116	2*
			FB118	3*
			FB150	2*
			FB176	2*
			FB178	4*
DW	9	-	FB 95	2
			FB116	2*
			FB149	3*
			FB150	2*
			FB176	2*
DW	10	-	FB 39	1
			FB116	2*
			FB149	3*

QUERVERWEISLISTE: DATEN

			FB150	2*
			FB176	2*
DW	11	-	FB 39	1
			FB116	2*
			FB150	2*
			FB176	2*
DW	12	-	FB 55	10
			FB116	2*
			FB150	2*
			FB176	2*
			FB199	1*
DW	13	-	FB112	4*
			FB115	4
			FB118	3*
			FB150	2*
			FB172	4*
			FB175	4
			FB178	4*
			FB180	3*
			FB199	1*
DW	14	-	FB150	2*
			FB186	2?
			FB199	1*
DW	15	-	FB150	2*
			FB186	2*
			FB199	1*
DW	16	-	PB253	1*
			FB150	2*
			FB177	2
			FB179	2
			FB186	2?
			FB199	1*
DW	17	-	PB253	1*
			FB150	2*
			FB186	2*
			FB199	1*
DW	18	-	PB253	1*
			FB143	2*
			FB144	4*
			FB150	2*
DW	19	-	PB253	1*
			FB143	2*
			FB144	4*
			FB150	2*
DW	20	-	PB253	1*
			FB113	2 , 3*
			FB150	2*
			FB189	2 , 3*
DW	21	-	FB 84	2*, 4*, 5*
			FB113	2 , 3*
			FB189	2 , 3*
DW	22	-	FB 84	2*, 3*, 4*, 5*
			FB 87	3*
			FB113	2 , 3*
			FB189	2 , 3*
DW	23	-	FB 84	2*, 3*, 5*
			FB 87	3*
			FB188	2 , 3*
DW	24	-	FB 93	2*, 5*
			FB188	2 , 3*

QUERVERWEISLISTE: DATEN

DW	25	-	FB 93	2*,	3*,	4*,	5*
			FB188	2 ,	3*		
DW	27	-	FB144	3*,	4*		
DW	28	-	FB144	3*,	4*		
DW	30	-	FB193	1*			
DW	31	-	FB 87	2*,	4*,	5*	
			FB194	1*			
DW	32	-	FB 87	2*,	3*,	4*,	5*
DW	33	-	FB 87	2*,	3*,	5*	
			FB148	1			
DW	34	-	FB 95	2*			
			FB148	1			
			FB150	6			
			FB153	1			
DW	35	-	FB 95	2*			
			FB148	2*			
			FB150	6			
			FB153	1			
DW	36	-	FB148	3*,	4*,	5*,	6
			FB188	3*			
DW	38	-	FB 52	1			
			FB 53	1*			
DW	40	-	FB 52	1			
DW	41	-	FB151	1			
DW	46	-	FB113	3*			
			FB189	3*			
DW	47	-	FB118	3			
			FB152	1			
			FB178	4			
DW	52	-	PB253	1			
DW	53	-	PB253	1			
DW	54	-	PB253	1			
DW	55	-	PB253	1			
DW	64	-	FB 84	2*,	4*,	5*	
DW	65	-	FB 84	2*,	3*,	4*,	5*
DW	66	-	FB 84	2*,	3*,	5*	
DW	67	-	FB 93	2*,	5*		
DW	68	-	FB 55	10*			
			FB 93	2*,	3*,	4*,	5*
			FB194	1*			
DW	74	-	FB 52	1*			
			FB 53	1			
			FB 57	3*			
			FB192	1*			
DW	75	-	FB 52	1			
			FB192	1*			
DW	76	-	FB 52	1*			

QUERVERWEISLISTE: DATEN

			FB 53	1
			FB 57	3*
			FB192	1*
DW	77	-	FB 52	1
			FB192	1*
DW	78	-	FB 52	1*
			FB 53	1
			FB 57	3*
			FB192	1*
DW	79	-	FB 52	1
			FB192	1*
DW	80	-	FB 52	1*
			FB 53	1
			FB 57	3*
			FB192	1*
DW	81	-	FB 52	1
			FB192	1*
DW	82	-	FB 52	1*
			FB 53	1
			FB 57	3*
			FB193	1*
DW	83	-	FB 52	1
			FB153	1
			FB193	1*
DW	84	-	FB 52	1*
			FB 53	1
			FB 57	3*
			FB153	1
			FB193	1*
DW	85	-	FB 52	1
			FB193	1*
DW	86	-	FB 52	1*
			FB 53	1
			FB 57	3*
			FB193	1*
DW	87	-	FB 52	1
			FB193	1*
DW	88	-	FB 52	1*
			FB 53	1
			FB 57	3*
			FB192	1*
DW	89	-	FB 52	1
			FB192	1*
DW	90	-	FB 52	1*
			FB 53	1
			FB 57	3*
			FB143	2
			FB144	4
			FB192	1*
DW	91	-	FB 52	1
			FB143	2
			FB144	4
			FB192	1*
DW	92	-	FB 52	1*
			FB 53	1
			FB 57	3*
			FB192	1*

QUERVERWEISLISTE: DATEN

DW	93	-	FB192	1*		
DW	94	-	FB 52	1*		
			FB 53	1		
			FB 57	3*		
			FB192	1*		
DW	95	-	FB192	1*		
DW	96	-	FB 52	1*		
			FB 53	1		
			FB 57	3*		
			FB193	1*		
DW	97	-	FB 52	1		
			FB193	1*		
DW	98	-	FB 52	1*		
			FB 53	1		
			FB 57	3*		
			FB 87	2*,	4*,	5*
			FB193	1*		
DW	99	-	FB 52	1		
			FB 87	2*,	3*,	4*, 5*
			FB150	2*		
			FB193	1*		
DW	100	-	FB 55	10		
			FB 87	2*,	3*,	5*
			FB 95	2		
			FB110	1		
			FB149	3*		
			FB194	1*		
DW	101	-	FB149	3*		
			FB192	1*		
DW	102	-	FB149	3*		
DW	103	-	FB149	3*		
			FB150	2*		
DW	104	-	FB 52	1*		
			FB 53	1		
			FB 57	3*		
			FB149	3*		
			FB150	2*		
			FB192	1*		
DW	105	-	FB149	3		
DW	110	-	PB 87	13*		
			FB 39	1*		
			FB150	4*,	5*	
DW	111	-	PB 87	9*		
			FB 39	1*		
			FB150	5*,	6*	
			FB180	4*		
DW	112	-	FB 39	1*		
			FB150	5*,	6*	
DW	113	-	FB 39	1*		
			FB150	5*,	6*	
DW	114	-	PB 87	17*		
			FB 39	1*		
			FB150	5*		
DW	115	-	PB101	11*		
			FB 39	1*		
			FB150	6*		

QUERVERWEISLISTE: DATEN

DW 116	-	PB 83	14*
		FB 39	1*
DW 119	-	PB 87	10*, 13
DW 120	-	PB 87	12*, 13
DW 121	-	PB 87	6*, 9
DW 122	-	PB 87	8*, 9
DW 123	-	PB 87	14*, 17
DW 124	-	PB 87	16*, 17
DW 125	-	PB 83	11*, 14
DW 126	-	PB 83	13*, 14
DW 127	-	FB 39	1*
DW 202	-	FB115	4*
		FB175	4*
DW 218	-	FB194	1*
DW 219	-	FB194	1*
DW 248	-	FB171	3*
		FB194	1
DW 249	-	FB171	3*
		FB194	1
DD 2	-	PB 81	9?, 10?, 11?, 12?
		PB 91	33
		PB 95	2?, 12?, 13?
		FB 82	1*
DD 4	-	PB 81	10?
		FB 96	1
DD 6	-	PB 91	24?
		FB 96	1
DD 8	-	PB 91	24?
DD 10	-	PB 91	26?
		FB 96	1*
DD 12	-	PB 81	9?
		PB 95	3?
DD 14	-	PB 81	11?
		PB 95	4?
DD 16	-	PB 81	12?, 13?
		PB 95	5?
DD 18	-	PB 20	35?, 36?, 37?, 38?
		PB 81	13?, 14?
		PB 93	2?
		PB 95	6?
		FB 57	1*
DD 20	-	PB 20	33 , 40?
		PB 81	14?, 15?
		PB 93	3?
		PB 95	7?
		FB 57	1*
DD 22	-	PB 30	35?, 36?, 37?, 38?
		PB 81	15?, 16?, 18

QUERVERWEISLISTE: DATEN

			PB 93	4?
			PB 95	8?
			FB 57	1*
DD	24	-	PB 30	33 , 40?
			PB 81	17?, 18
			PB 93	5?
			FB 57	1*
DD	26	-	PB 40	38?, 39?, 40?, 41?
			PB 81	17?
			PB 93	6?
			FB 57	1*
			FB143	2*
			FB144	4*
			FB193	1
DD	28	-	PB 40	36
			PB 81	18*
			PB 93	7?
			PB 95	9?
			FB 57	1*
			FB 77	1
			FB193	1*
DD	29	-	FB144	4*
DD	30	-	PB 40	43?
			FB 72	1*
			FB 77	1*
DD	32	-	PB 91	29?
			FB 76	1*
DD	34	-	PB 80	15?, 16?
			PB 91	32?, 33
			FB 23	3
			FB192	1*
DD	36	-	PB 20	40?, 41?
			PB 91	32?
			FB 23	3
			FB192	1*
DD	38	-	PB 30	40?, 41?
			PB 91	33*, 34?
DD	40	-	PB 20	38?, 39?
DD	42	-	PB 30	38?, 39?
			FB 23	3
			FB192	1*
DD	44	-	PB 81	16?
			PB 88	9?, 10?
			PB 95	10?, 11?
			FB 23	3
			FB192	1*
DD	46	-	PB 81	16?
			PB 86	1
			PB 93	11*, 21?
			FB 57	2*
DD	48	-	PB 81	9?
			PB 82	49?
			PB 86	1
			PB 93	14?, 22?
			FB 57	2*
DD	50	-	PB 81	10?
			PB 82	50?
			PB 86	1
			PB 93	15?, 23?

QUERVERWEISLISTE: DATEN

		FB 57	2*
DD 52	-	PB 81	11?
		PB 82	51?
		PB 86	1
		PB 93	16?, 24?
		FB 57	2*
DD 54	-	PB 81	12?
		PB 82	52?
		PB 86	1
		PB 93	17?, 25?
		FB 57	2*
DD 56	-	PB 81	13?
		PB 82	53?
		PB 86	1
		PB 93	18?, 26?
		FB 57	2*
DD 58	-	PB 81	14?
		PB 82	54?
		PB 86	1
		PB 93	19?, 27?
		FB 57	2*
DD 60	-	PB 81	15?
		PB 82	55?
		PB 86	1
		PB 93	20?, 28?
		FB 57	2*
DD 62	-	PB 80	15?, 41?
		PB 81	6?, 7?
		PB 93	10?, 11
		FB 55	10
		FB 57	1*
		FB 82	1
		FB 89	1*
		FB110	1
		FB171	3
		FB193	1
DD 64	-	PB101	1
		FB 84	2*, 3 , 4
		FB193	1*
DD 66	-	FB 84	3 , 4
		FB193	1*
DD 70	-	FB 86	2*
		FB 87	2*, 3 , 4
		FB194	1*
DD 72	-	FB 87	3 , 4
		FB194	1*
DD 100	-	FB149	3*
DD 102	-	PB 88	9?
		FB 88	2*
		FB 89	1
		FB 93	2 , 3 , 4
		FB149	3*
		FB193	1*
DD 104	-	FB149	3*
DD 108	-	FB 39	1*
DD 117	-	PB101	11*
		FB 39	1*
DD 128	-	PB 20	35?

QUERVERWEISLISTE: DATEN

DD 130	-	PB 30	35?
DD 132	-	PB 40	38?
DD 136	-	PB 81	6?
DD 172	-	PB 21	2
		PB 93	12?
		FB 23	2 , 3 , 4
		FB 57	1*
DD 174	-	PB 31	2
		PB 93	13?
		FB 23	2 , 3 , 4
		FB 57	1*
DD 176	-	PB 93	9?
		FB 57	1*
		FB 76	1
DD 178	-	PB 91	27?
		PB 93	8?
		FB 57	1*
DD 210	-	PB101	11*
		FB171	3*
		FB194	1*
DD 212	-	PB101	11*
		FB171	3*
		FB194	1*
DD 214	-	PB101	11*
		FB171	3*
		FB194	1*
DD 216	-	PB101	11*
		FB171	3*
		FB194	1*
DD 218	-	PB101	11*
		FB171	3*
DD 230	-	FB174	2*
DD 232	-	FB174	2*
DD 234	-	FB174	2*
DD 236	-	FB174	2*
DD 240	-	PB101	11
		FB171	3
		FB174	2
		FB194	1
DD 242	-	PB101	11
		FB171	3
		FB174	2
		FB194	1
DD 244	-	PB101	11
		FB171	3
		FB174	2
		FB194	1
DD 246	-	PB101	11
		FB171	3
		FB174	2
		FB194	1
DD 248	-	PB101	11
		FB171	3

QUERVERWEISLISTE: ZEITEN

```
   PB     1 : BEARBEITET
   PB     3 : BEARBEITET
   PB     6 : BEARBEITET
   PB     7 : BEARBEITET
   PB     8 : BEARBEITET
   PB     9 : BEARBEITET
   PB    10 : BEARBEITET
   PB    11 : BEARBEITET
   PB    12 : BEARBEITET
   PB    13 : BEARBEITET
   PB    14 : BEARBEITET
   PB    15 : BEARBEITET
   PB    16 : BEARBEITET
   PB    17 : BEARBEITET
   PB    18 : BEARBEITET
   PB    19 : BEARBEITET
   PB    20 : BEARBEITET
   PB    21 : BEARBEITET
   PB    30 : BEARBEITET
   PB    31 : BEARBEITET
   PB    40 : BEARBEITET
   PB    41 : BEARBEITET
   PB    42 : BEARBEITET
   PB    55 : BEARBEITET
   PB    60 : BEARBEITET
   PB    61 : BEARBEITET
   PB    79 : BEARBEITET
   PB    80 : BEARBEITET
   PB    81 : BEARBEITET
   PB    82 : BEARBEITET
   PB    83 : BEARBEITET
   PB    84 : BEARBEITET
   PB    85 : BEARBEITET
   PB    86 : BEARBEITET
   PB    87 : BEARBEITET
   PB    88 : BEARBEITET
   PB    90 : BEARBEITET
   PB    91 : BEARBEITET
   PB    92 : BEARBEITET
   PB    93 : BEARBEITET
   PB    95 : BEARBEITET
   PB   100 : BEARBEITET
   PB   101 : BEARBEITET
   PB   253 : BEARBEITET
   PB   255 : BEARBEITET
   FB     1S: BEARBEITET
   FB     2S: BEARBEITET
   FB     3S: BEARBEITET
   FB     4S: BEARBEITET
   FB     5S: BEARBEITET
   FB     6S: BEARBEITET
   FB    10S: BEARBEITET
   FB    11S: BEARBEITET
   FB    12S: BEARBEITET
   FB    13S: BEARBEITET
   FB    23 : BEARBEITET
   FB    33 : BEARBEITET
   FB    39 : BEARBEITET
   FB    40S: BEARBEITET
   FB    41S: BEARBEITET
   FB    43 : BEARBEITET
   FB    44 : BEARBEITET
   FB    46 : BEARBEITET
   FB    47 : BEARBEITET
   FB    48 : BEARBEITET
   FB    50 : BEARBEITET
   FB    51 : BEARBEITET
   FB    52 : BEARBEITET
   FB    53 : BEARBEITET
   FB    54 : BEARBEITET
   FB    55 : BEARBEITET
   FB    57 : BEARBEITET
   FB    58 : BEARBEITET
   FB    72 : BEARBEITET
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK                !                              !
!ELASTOMERTECHNIK          WERK HARBURG       !  MASTERPROGRAMM              !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE              !  DATE         :              !
! INSTALLATION     : TREAD-LINE               !  MODIFICATION:          PGNO!
! PROJECT POS. NO.: 84/823804                 !  PROGRAMMER   :             1!
+-----------------------------------------------------------------------------+
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Datei C:SKIV06Z0.SEQ

OPERAND	SYMBOL	KOMMENTAR
E 0.0	12A5	MIN FIELD CURRENT
E 0.1	15Q1	DRIVE MOTOR FAULT KNIFE
E 0.2	E 0.2	SPARE
E 0.3	15Q5	DRIVE MOTOR FAULT KNIFE TRANSFER
E 0.4	E 0.4	SPARE
E 0.5	16Q5	DRIVE MOTOR FAULT EXTERNAL FAN
E 0.6	E 0.6	SPARE
E 0.7	E 0.7	SPARE
E 1.0	21A1.1	LENGTH MEASURING DEVICE VERTICAL
E 1.1	E 1.1	SPARE
E 1.2	E 1.2	SPARE
E 1.3	26S4	COMPRESSED AIR SUPPLY
E 1.4	E 1.4	SPARE
E 1.5	26S6	HIGH-CONTROL 60 MM (NO CUT)
E 1.6	26S7	HIGH-CONTROL 100 MM (TREAD SKIVER OFF)
E 1.7	E 1.7	SPARE
E 2.0	27S1	KNIFE HOME POSITION
E 2.1	27S2	KNIFE ON HIGH
E 2.2	27S3	WATER OFF
E 2.3	27S4	CUT END
E 2.4	27S5	KNIFE RETURNED
E 2.5	E 2.5	LOOP LIGHT BARRIER FILLED
E 2.6	E 2.6	SPARE
E 2.7	E 2.7	PRESSURE FAULT SOFT WATER
E 3.0	17A1.1	LIGHT BARRIER READY FOR START
E 3.1	17A1.2	MATERIAL OUTSIDE MEASURING SECTION
E 3.2	10F3	CONTROL FUSE TRIGGERED
E 3.3	9S1	E-STOP SWITCH CABINET
E 3.4	28S5.1	MANUAL (CONTROL PANEL)
E 3.5	28S5.2	AUTOMATIC (CONTROL PANEL)
E 3.6	28S7.1	KNIFE DRIVE OFF (CONTROL PANEL)
E 3.7	28S7.2	KNIFE DRIVE ON (CONTROL PANEL)
E 4.0	29S1.1	KNIFE ON (CONTROL PANEL)
E 4.1	29S1.2	KNIFE OFF (CONTROL PANEL)
E 4.2	29S3	KNIFE HOME POSITION (CONTROL PANEL)
E 4.3	29S4	CUTTING START (CONTROL PANEL)
E 4.4	29S5	CUTTING STOP (CONTROL PANEL)
E 4.5	29S6	ADVANCE ON (CONTROL PANEL)
E 4.6	E 4.6	FAULT ACKNOWLEDGED (MAIN CABINET)
E 4.7	A220	E-STOP (CONTROL PANEL)
E 5.0	30S1.1	TREAD SHORTER (CONTROL PANEL)
E 5.1	30S1.2	TREAD LONGER (CONTROL PANEL)
E 5.2	E 5.2	RESET LENGTH PULSE FROM MARTENS
E 5.3	E 5.3	CONVEYOR REVERSE (CONTROL PANEL)
E 5.4	E 5.4	SPARE
E 5.5	E 5.5	SPARE
E 5.6	E 5.6	SPARE
E 5.7	E 5.7	SPARE
E 6.0	E 6.0	SPARE
E 6.1	E 6.1	SPARE
E 6.2	E 6.2	SPARE
E 6.3	E 6.3	SPARE
E 6.4	E 6.4	SPARE
E 6.5	E 6.5	SPARE
E 6.6	E 6.6	LENGTH CORRECTION +
E 6.7	E 6.7	LENGTH CORRECTION -
E 7.0	E 7.0	LENGTH CORRECTION 1 * 10^1
E 7.1	E 7.1	LENGTH CORRECTION 2 * 10^1
E 7.2	E 7.2	LENGTH CORRECTION 4 * 10^1
E 7.3	E 7.3	LENGTH CORRECTION 8 * 10^1
E 7.4	E 7.4	LENGTH CORRECTION 1 * 10^0
E 7.5	E 7.5	LENGTH CORRECTION 2 * 10^0
E 7.6	E 7.6	LENGTH CORRECTION 4 * 10^0
E 7.7	E 7.7	LENGTH CORRECTION 8 * 10^0
A 0.0	SWL 1.1	PRESET TREAD LENGTH 4.1 DECADE
A 0.1	SWL 1.2	PRESET TREAD LENGTH 4.2 DECADE
A 0.2	SWL 1.3	PRESET TREAD LENGTH 4.3 DECADE
A 0.3	SWL 1.4	PRESET TREAD LENGTH 4.4 DECADE
A 0.4	SWL 2.1	PRESET TREAD LENGTH 3.1 DECADE
A 0.5	SWL 2.2	PRESET TREAD LENGTH 3.2 DECADE
A 0.6	SWL 2.3	PRESET TREAD LENGTH 3.3 DECADE
A 0.7	SWL 2.4	PRESET TREAD LENGTH 3.4 DECADE

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OPERAND	SYMBOL	KOMMENTAR
A 1.0	SWL 3.1	PRESET TREAD LENGTH 2.1 DECADE
A 1.1	SWL 3.2	PRESET TREAD LENGTH 2.2 DECADE
A 1.2	SWL 3.3	PRESET TREAD LENGTH 2.3 DECADE
A 1.3	SWL 3.4	PRESET TREAD LENGTH 2.4 DECADE
A 1.4	SWL 4.1	PRESET TREAD LENGTH 1.1 DECADE
A 1.5	SWL 4.2	PRESET TREAD LENGTH 1.2 DECADE
A 1.6	SWL 4.3	PRESET TREAD LENGTH 1.3 DECADE
A 1.7	SWL 4.4	PRESET TREAD LENGTH 1.4 DECADE
A 2.0	IWL 1.1	ACTUAL TREAD LENGTH 4.1 DECADE
A 2.1	IWL 1.2	ACTUAL TREAD LENGTH 4.2 DECADE
A 2.2	IWL 1.3	ACTUAL TREAD LENGTH 4.3 DECADE
A 2.3	IWL 1.4	ACTUAL TREAD LENGTH 4.4 DECADE
A 2.4	IWL 2.1	ACTUAL TREAD LENGTH 3.1 DECADE
A 2.5	IWL 2.2	ACTUAL TREAD LENGTH 3.2 DECADE
A 2.6	IWL 2.3	ACTUAL TREAD LENGTH 3.3 DECADE
A 2.7	IWL 2.4	ACTUAL TREAD LENGTH 3.4 DECADE
A 3.0	IWL 3.1	ACTUAL TREAD LENGTH 2.1 DECADE
A 3.1	IWL 3.2	ACTUAL TREAD LENGTH 2.2 DECADE
A 3.2	IWL 3.3	ACTUAL TREAD LENGTH 2.3 DECADE
A 3.3	IWL 3.4	ACTUAL TREAD LENGTH 2.4 DECADE
A 3.4	IWL 4.1	ACTUAL TREAD LENGTH 1.1 DECADE
A 3.5	IWL 4.2	ACTUAL TREAD LENGTH 1.2 DECADE
A 3.6	IWL 4.3	ACTUAL TREAD LENGTH 1.3 DECADE
A 3.7	IWL 4.4	ACTUAL TREAD LENGTH 1.4 DECADE
A 4.0	A 4.0	SCRAP MARKING 2
A 4.1	37K2	CONVEYOR BELT : FIELD CONTACTOR
A 4.2	A 4.2	DC-CONVERTER CREEP
A 4.3	A 4.3	SPARE
A 4.4	37K5	DRIVE MOTOR KNIFE
A 4.5	37K6	DRIVE MOTOR KNIFE CARRIAGE
A 4.6	A 4.6	SPARE
A 4.7	37K8	EXTERNAL FAN
A 5.0	38K1	KNIFE CARRIAGE FORWARD (SV)
A 5.1	38K2	KNIFE CARRIAGE REVERSE (SV)
A 5.2	38K3	KNIFE CARRIAGE KNIFE UP (SV)
A 5.3	38K4	KNIFE CARRIAGE TERMINAL DEVICE UP (SV)
A 5.4	38K5	SPARE
A 5.5	38K6	KNIFE CARRIAGE WATER SRAYING START (SV)
A 5.6	A 5.6	SPARE
A 5.7	A 5.7	SPARE
A 6.0	A 6.0	SPARE
A 6.1	39H2	LAMP FAULT SKIVER
A 6.2	39H3	LAMP FAULT LINE
A 6.3	39H4	LAMP KNIFE READY TO START
A 6.4	39H5	LAMP KNIFE IS OPERATING
A 6.5	A 6.5	RELAIS LIGHT BARRIER TO DC-CONVERTER
A 6.6	A 6.6	SPARE
A 6.7	A 6.7	SPARE
A 7.0	A 7.0	CONVEYOR BELT : RELEASE
A 7.1	A 7.1	CONVEYOR BELT : BRAKE OFF
A 7.2	A 7.2	SPARE
A 7.3	A 7.3	SPARE
A 7.4	A 7.4	SPARE
A 7.5	A 7.5	SPARE
A 7.6	A 7.6	SPARE
A 7.7	A 7.7	SPARE
M 0.0	M 0.0	"0"-SIGNAL
M 0.1	M 0.1	CUTTING CICLE MANUAL
M 0.2	M 0.2	CUTTING CICLE SEMI AUTOMATIC
M 0.3	M 0.3	CUTTING CICLE AUTOMATIC
M 0.4	M 0.4	SKIVER READY TO START
M 0.5	M 0.5	CUTTING CICLE START MARK
M 0.6	M 0.6	HOME POSITION START MARK
M 0.7	M 0.7	CUTTING CARRIAGE OUT OF HOME POSITION
M 1.0	M 1.0	SKIVER IS IN OPERATION
M 1.1	M 1.1	CUTTING CICLE STEP 1
M 1.2	M 1.2	CUTTING CICLE STEP 2
M 1.3	M 1.3	CUTTING CICLE STEP 3
M 1.4	M 1.4	CUTTING CICLE STEP 4
M 1.5	M 1.5	CUTTING CICLE STEP 5
M 1.6	M 1.6	CUTTING CICLE STEP 6
M 1.7	M 1.7	CUTTING CICLE END

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OPERAND	SYMBOL	KOMMENTAR
M 2.0	M 2.0	FAULT DRIVE MOTOR CONVEYOR BELT
M 2.1	M 2.1	CONVEYOR BELT MANUAL
M 2.2	M 2.2	CONVEYOR SEMI-AUTOMATIC
M 2.3	M 2.3	CONVEYOR AUTOMATIC
M 2.4	M 2.4	SPARE
M 2.5	M 2.5	KNIFE READY TO START FOR AUTOMATIC
M 2.6	M 2.6	AUXILIARY DRIVES ON MESSAGE
M 2.7	M 2.7	V-LINE PRESET > V-LINE LIMIT
M 3.0	M 3.0	TREAD LENGTH OK
M 3.1	M 3.1	START CUTTING
M 3.2	M 3.2	FAULT COMPRESSED AIR SUPPLY
M 3.3	M 3.3	TIMER KNIFE CUTTING
M 3.4	M 3.4	SOLENOID VALVE KNIFE RETURN
M 3.5	M 3.5	SOLENOID VALVE KNIFE CUTTING
M 3.6	M 3.6	SOLENOID VALVE KNIFE LUBRICATION ON/OFF
M 3.7	M 3.7	SOLENOID VALVE KNIFE UP/DOWN
M 4.0	M 4.0	LINE ON (135U)
M 4.1	M 4.1	AUXILIARY DRIVES LINE (135U)
M 4.2	M 4.2	START CUTTING CICLE SEMI-AUTOMATIC
M 4.3	M 4.3	START CUTTING CICLE AUTOMATIC
M 4.4	M 4.4	SOLENOID VALVE CLAMPING DEVICE DOWN
M 4.5	M 4.5	CUTTING CICLE AUTOMATIC OFF
M 4.6	M 4.6	START HOME POSITION
M 4.7	M 4.7	SWITCH IN AUTOMATIC POSITION
M 5.0	M 5.0	OB2 DONE (TEST)
M 5.1	M 5.1	CICLE HOME POSITION STEP 1
M 5.2	M 5.2	CICLE HOME POSITION STEP 2
M 5.3	M 5.3	RESET INTERRUPT DONE (TEST)
M 5.4	M 5.4	FAULT AC-CONTROL VOLTAGE
M 5.5	M 5.5	HIGH-CONTROL TRIGGERED
M 5.6	M 5.6	CONVEYOR OFF
M 5.7	M 5.7	UNUSABLE STRIP AND NO HIGH-CONTROL
M 6.0	M 6.0	AUTOMATIC KNIFE ON
M 6.1	M 6.1	MANUAL AND SEMI-AUTOMATIC KNIFE ON
M 6.2	M 6.2	AUTOMATIC KNIFE OFF
M 6.3	M 6.3	MANUAL AND SEMI-AUTOMATIC KNIFE OFF
M 6.4	M 6.4	KNIFE ON
M 6.5	M 6.5	FAULT LINE (SINEC-L1)
M 6.6	M 6.6	IMPULSE FAULT MESSAGE FROM 135U
M 6.7	M 6.7	FAULT : TREAD SKIVER OFF
M 7.0	M 7.0	SPARE
M 7.1	M 7.1	SPARE
M 7.2	M 7.2	SPARE
M 7.3	M 7.3	HF FAULT LINE
M 7.4	M 7.4	WIND-UP (135U)
M 7.5	M 7.5	FAULT : LAMP AND HORN ON
M 7.6	M 7.6	FAULT : ONLY LAMP ON
M 7.7	M 7.7	BOOKING (135U)
M 8.0	M 8.0	E-STOP (135U)
M 8.1	M 8.1	ACKNOWLEDGING FAULT (135U)
M 8.2	M 8.2	FAULT LINE (135U)
M 8.3	M 8.3	HF LINE ON
M 8.4	M 8.4	IMPULSE LINE ON
M 8.5	M 8.5	CONVEYOR AUTOMATIC ON
M 8.6	M 8.6	HF LINE OFF
M 8.7	M 8.7	IMPULSE LINE OFF
M 9.0	M 9.0	TIMER CLAMPING DEVICE LOWERING/LIFTUNG
M 9.1	M 9.1	TIMER KNIFE IS CUTTING
M 9.2	M 9.2	TIMER KNIFE IS CUTTING
M 9.3	M 9.3	TIMER KNIFE LIFTING
M 9.4	M 9.4	TIMER KNIFE MOVE HOME
M 9.5	M 9.5	TIMER KNIFE HOME POSITION
M 9.6	M 9.6	MATERIAL OUT OF LIGHT BARRIER
M 9.7	M 9.7	CREEP WAY REACHED
M 10.0	M 10.0	COUNTER TREAD SHORTER
M 10.1	M 10.1	COUNTER TREAD LONGER
M 10.2	M 10.2	COUNTER TREAD SHORTER
M 10.3	M 10.3	COUNTER TREAD SHORTER (IMPULSE)
M 10.4	M 10.4	RELAIS LIGHT BARRIER ON
M 10.5	M 10.5	HF WIND-UP OFF
M 10.6	M 10.6	TREAD LENGTH REACHED
M 10.7	M 10.7	LINE READY TO START (135)

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OPERAND	SYMBOL	KOMMENTAR
M 11.0	M 11.0	SPARE
M 11.1	M 11.1	SPARE
M 11.2	M 11.2	IMPULSE CONVEYOR AUTOMATIC
M 11.3	M 11.3	HF CONVEYOR AUTOMATIC
M 11.4	M 11.4	IMPULS SEMI-AUTOMATIC ON
M 11.5	M 11.5	WIND-UP START
M 11.6	M 11.6	HF WIND-UP ON
M 11.7	M 11.7	IMPULSE WIND-UP ON
M 12.0	M 12.0	LINE STOP
M 12.1	M 12.1	USABLE TREAD
M 12.2	M 12.2	CONVEYOR ON WIND-UP
M 12.3	M 12.3	COUNTER WIND-UP PLUS 1
M 12.4	M 12.4	USABLE STRIP
M 12.5	M 12.5	UNUSABLE TREAD
M 12.6	M 12.6	SCRAP LENGTH MEAS.DEVICE COUNTER 1 = 900
M 12.7	M 12.7	SPARE
M 13.0	M 13.0	SPARE
M 13.1	M 13.1	SPARE
M 13.2	M 13.2	SPARE
M 13.3	M 13.3	SPARE
M 13.4	M 13.4	SPARE
M 13.5	M 13.5	IMPULSE WIND-UP OFF
M 13.6	M 13.6	MATERIAL IN LIGHT BARRIER
M 13.7	M 13.7	FAULT SKIVER
M 14.0	M 14.0	HF WIND-UP
M 14.1	M 14.1	IMPULSE WIND-UP
M 14.2	M 14.2	HF READ COUNTER 2
M 14.3	M 14.3	IMPULSE READ COUNTER 2
M 14.4	M 14.4	HF KNIFE HOMEPOSITION
M 14.5	M 14.5	IMPULSE KNIFE HOMEPOSITION
M 14.6	M 14.6	RESET COUNTER 1
M 14.7	M 14.7	RESET PRODUCTION REPORT
M 15.0	M 15.0	FAULT MATERIAL OUT OF MEASURING SECTION
M 15.1	M 15.1	SET DEMEND LENGTH
M 15.2	M 15.2	HF DEMEND LENGTH
M 15.3	M 15.3	IMPULSE DEMAND LENGTH
M 15.4	M 15.4	TIME DEMAND LENGTH
M 15.5	M 15.5	SCRAP DETECTED
M 15.6	M 15.6	TREAD IS PASSING LENGTH MEASURING DEVICE
M 15.7	M 15.7	SPARE
M 16.0	M 16.0	STRIP IN TOP SECTION
M 16.1	M 16.1	STRIP IN BOTTOM SECTION
M 16.2	M 16.2	STRIP IN BOT.SECTION (LINE creep-speed)
M 16.3	M 16.3	LIGHT BARRIER OUT OF SECTION
M 16.4	M 16.4	STRIP 60s IN BOTTOM SECTION (LINE off)
M 16.5	M 16.5	HF E-STOP LINE (135U)
M 16.6	M 16.6	LIGHT BARRIER NOT O.K.
M 16.7	M 16.7	LIGHT BARRIER O.K.
M 17.0	M 17.0	IMPULSE HIGH-CONTROL TRIGGERED
M 17.1	M 17.1	IMPULSE UNUSABLE TREAD LENGTH
M 17.2	M 17.2	CUT UNUSABLE TREAD
M 17.3	M 17.3	HF UNUSABLE TREAD LENGTH
M 17.4	M 17.4	HF HIGH-CONTROL TRIGGERED
M 17.5	M 17.5	HF SEMI-AUTOMATIC ON
M 17.6	M 17.6	HF TREAD SHORTER
M 17.7	M 17.7	HF TACT M 25.3
M 18.0	M 18.0	IMPULSE M 25.3
M 18.1	M 18.1	HF TREAD LONGER
M 18.2	M 18.2	HF TACT M 25.3
M 18.3	M 18.3	IMPULSE M 25.3
M 18.4	M 18.4	PRESSURE FAULT SOFT WATER
M 18.5	M 18.5	IMPULSE E-STOP LINE (135U)
M 18.6	M 18.6	SPARE
M 18.7	M 18.7	SPARE
M 19.0	M 19.0	LENGTH MEASURING MAX. SLIT
M 19.1	M 19.1	LENGTH MEASURING MIN. SLIT
M 19.2	M 19.2	LENGTH MEASURING TREAD LENGTH O.K.
M 19.3	M 19.3	10 TREADS COUNTED
M 19.4	M 19.4	SPARE
M 19.5	M 19.5	TREAD > MAX
M 19.6	M 19.6	TREAD < MIN
M 19.7	M 19.7	SPARE

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OPERAND	SYMBOL	KOMMENTAR
E 0.0	12A5	MIN FIELD CURRENT
E 0.1	15Q1	DRIVE MOTOR FAULT KNIFE
E 0.2	E 0.2	SPARE
E 0.3	15Q5	DRIVE MOTOR FAULT KNIFE TRANSFER
E 0.4	E 0.4	SPARE
E 0.5	16Q5	DRIVE MOTOR FAULT EXTERNAL FAN
E 0.6	E 0.6	SPARE
E 0.7	E 0.7	SPARE
E 1.0	21A1.1	LENGTH MEASURING DEVICE VERTICAL
E 1.1	E 1.1	SPARE
E 1.2	E 1.2	SPARE
E 1.3	26S4	COMPRESSED AIR SUPPLY
E 1.4	E 1.4	SPARE
E 1.5	26S6	HIGH-CONTROL 60 MM (NO CUT)
E 1.6	26S7	HIGH-CONTROL 100 MM (TREAD SKIVER OFF)
E 1.7	E 1.7	SPARE
E 2.0	27S1	KNIFE HOME POSITION
E 2.1	27S2	KNIFE ON HIGH
E 2.2	27S3	WATER OFF
E 2.3	27S4	CUT END
E 2.4	27S5	KNIFE RETURNED
E 2.5	E 2.5	LOOP LIGHT BARRIER FILLED
E 2.6	E 2.6	SPARE
E 2.7	E 2.7	PRESSURE FAULT SOFT WATER
E 3.0	17A1.1	LIGHT BARRIER READY FOR START
E 3.1	17A1.2	MATERIAL OUTSIDE MEASURING SECTION
E 3.2	10F3	CONTROL FUSE TRIGGERED
E 3.3	9S1	E-STOP SWITCH CABINET
E 3.4	28S5.1	MANUAL (CONTROL PANEL)
E 3.5	28S5.2	AUTOMATIC (CONTROL PANEL)
E 3.6	28S7.1	KNIFE DRIVE OFF (CONTROL PANEL)
E 3.7	28S7.2	KNIFE DRIVE ON (CONTROL PANEL)
E 4.0	29S1.1	KNIFE ON (CONTROL PANEL)
E 4.1	29S1.2	KNIFE OFF (CONTROL PANEL)
E 4.2	29S3	KNIFE HOME POSITION (CONTROL PANEL)
E 4.3	29S4	CUTTING START (CONTROL PANEL)
E 4.4	29S5	CUTTING STOP (CONTROL PANEL)
E 4.5	29S6	ADVANCE ON (CONTROL PANEL)
E 4.6	E 4.6	FAULT ACKNOWLEDGED (MAIN CABINET)
E 4.7	A220	E-STOP (CONTROL PANEL)
E 5.0	30S1.1	TREAD SHORTER (CONTROL PANEL)
E 5.1	30S1.2	TREAD LONGER (CONTROL PANEL)
E 5.2	E 5.2	RESET LENGTH PULSE FROM MARTENS
E 5.3	E 5.3	CONVEYOR REVERSE (CONTROL PANEL)
E 5.4	E 5.4	SPARE
E 5.5	E 5.5	SPARE
E 5.6	E 5.6	SPARE
E 5.7	E 5.7	SPARE
E 6.0	E 6.0	SPARE
E 6.1	E 6.1	SPARE
E 6.2	E 6.2	SPARE
E 6.3	E 6.3	SPARE
E 6.4	E 6.4	SPARE
E 6.5	E 6.5	SPARE
E 6.6	E 6.6	LENGTH CORRECTION +
E 6.7	E 6.7	LENGTH CORRECTION -
E 7.0	E 7.0	LENGTH CORRECTION 1 * 10^1
E 7.1	E 7.1	LENGTH CORRECTION 2 * 10^1
E 7.2	E 7.2	LENGTH CORRECTION 4 * 10^1
E 7.3	E 7.3	LENGTH CORRECTION 8 * 10^1
E 7.4	E 7.4	LENGTH CORRECTION 1 * 10^0
E 7.5	E 7.5	LENGTH CORRECTION 2 * 10^0
E 7.6	E 7.6	LENGTH CORRECTION 4 * 10^0
E 7.7	E 7.7	LENGTH CORRECTION 8 * 10^0
A 0.0	SWL 1.1	PRESET TREAD LENGTH 4.1 DECADE
A 0.1	SWL 1.2	PRESET TREAD LENGTH 4.2 DECADE
A 0.2	SWL 1.3	PRESET TREAD LENGTH 4.3 DECADE
A 0.3	SWL 1.4	PRESET TREAD LENGTH 4.4 DECADE
A 0.4	SWL 2.1	PRESET TREAD LENGTH 3.1 DECADE
A 0.5	SWL 2.2	PRESET TREAD LENGTH 3.2 DECADE
A 0.6	SWL 2.3	PRESET TREAD LENGTH 3.3 DECADE
A 0.7	SWL 2.4	PRESET TREAD LENGTH 3.4 DECADE

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OPERAND	SYMBOL	KOMMENTAR
A 1.0	SWL 3.1	PRESET TREAD LENGTH 2.1 DECADE
A 1.1	SWL 3.2	PRESET TREAD LENGTH 2.2 DECADE
A 1.2	SWL 3.3	PRESET TREAD LENGTH 2.3 DECADE
A 1.3	SWL 3.4	PRESET TREAD LENGTH 2.4 DECADE
A 1.4	SWL 4.1	PRESET TREAD LENGTH 1.1 DECADE
A 1.5	SWL 4.2	PRESET TREAD LENGTH 1.2 DECADE
A 1.6	SWL 4.3	PRESET TREAD LENGTH 1.3 DECADE
A 1.7	SWL 4.4	PRESET TREAD LENGTH 1.4 DECADE
A 2.0	IWL 1.1	ACTUAL TREAD LENGTH 4.1 DECADE
A 2.1	IWL 1.2	ACTUAL TREAD LENGTH 4.2 DECADE
A 2.2	IWL 1.3	ACTUAL TREAD LENGTH 4.3 DECADE
A 2.3	IWL 1.4	ACTUAL TREAD LENGTH 4.4 DECADE
A 2.4	IWL 2.1	ACTUAL TREAD LENGTH 3.1 DECADE
A 2.5	IWL 2.2	ACTUAL TREAD LENGTH 3.2 DECADE
A 2.6	IWL 2.3	ACTUAL TREAD LENGTH 3.3 DECADE
A 2.7	IWL 2.4	ACTUAL TREAD LENGTH 3.4 DECADE
A 3.0	IWL 3.1	ACTUAL TREAD LENGTH 2.1 DECADE
A 3.1	IWL 3.2	ACTUAL TREAD LENGTH 2.2 DECADE
A 3.2	IWL 3.3	ACTUAL TREAD LENGTH 2.3 DECADE
A 3.3	IWL 3.4	ACTUAL TREAD LENGTH 2.4 DECADE
A 3.4	IWL 4.1	ACTUAL TREAD LENGTH 1.1 DECADE
A 3.5	IWL 4.2	ACTUAL TREAD LENGTH 1.2 DECADE
A 3.6	IWL 4.3	ACTUAL TREAD LENGTH 1.3 DECADE
A 3.7	IWL 4.4	ACTUAL TREAD LENGTH 1.4 DECADE
A 4.0	A 4.0	SCRAP MARKING 2
A 4.1	37K2	CONVEYOR BELT : FIELD CONTACTOR
A 4.2	A 4.2	DC-CONVERTER CREEP
A 4.3	A 4.3	SPARE
A 4.4	37K5	DRIVE MOTOR KNIFE
A 4.5	37K6	DRIVE MOTOR KNIFE CARRIAGE
A 4.6	A 4.6	SPARE
A 4.7	37K8	EXTERNAL FAN
A 5.0	38K1	KNIFE CARRIAGE FORWARD (SV)
A 5.1	38K2	KNIFE CARRIAGE REVERSE (SV)
A 5.2	38K3	KNIFE CARRIAGE KNIFE UP (SV)
A 5.3	38K4	KNIFE CARRIAGE TERMINAL DEVICE UP (SV)
A 5.4	38K5	SPARE
A 5.5	38K6	KNIFE CARRIAGE WATER SRAYING START (SV)
A 5.6	A 5.6	SPARE
A 5.7	A 5.7	SPARE
A 6.0	A 6.0	SPARE
A 6.1	39H2	LAMP FAULT SKIVER
A 6.2	39H3	LAMP FAULT LINE
A 6.3	39H4	LAMP KNIFE READY TO START
A 6.4	39H5	LAMP KNIFE IS OPERATING
A 6.5	A 6.5	RELAIS LIGHT BARRIER TO DC-CONVERTER
A 6.6	A 6.6	SPARE
A 6.7	A 6.7	SPARE
A 7.0	A 7.0	CONVEYOR BELT : RELEASE
A 7.1	A 7.1	CONVEYOR BELT : BRAKE OFF
A 7.2	A 7.2	SPARE
A 7.3	A 7.3	SPARE
A 7.4	A 7.4	SPARE
A 7.5	A 7.5	SPARE
A 7.6	A 7.6	SPARE
A 7.7	A 7.7	SPARE
M 0.0	M 0.0	"O"-SIGNAL
M 0.1	M 0.1	CUTTING CICLE MANUAL
M 0.2	M 0.2	CUTTING CICLE SEMI AUTOMATIC
M 0.3	M 0.3	CUTTING CICLE AUTOMATIC
M 0.4	M 0.4	SKIVER READY TO START
M 0.5	M 0.5	CUTTING CICLE START MARK
M 0.6	M 0.6	HOME POSITION START MARK
M 0.7	M 0.7	CUTTING CARRIAGE OUT OF HOME POSITION
M 1.0	M 1.0	SKIVER IS IN OPERATION
M 1.1	M 1.1	CUTTING CICLE STEP 1
M 1.2	M 1.2	CUTTING CICLE STEP 2
M 1.3	M 1.3	CUTTING CICLE STEP 3
M 1.4	M 1.4	CUTTING CICLE STEP 4
M 1.5	M 1.5	CUTTING CICLE STEP 5
M 1.6	M 1.6	CUTTING CICLE STEP 6
M 1.7	M 1.7	CUTTING CICLE END

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OPERAND	SYMBOL	KOMMENTAR
M 2.0	M 2.0	FAULT DRIVE MOTOR CONVEYOR BELT
M 2.1	M 2.1	CONVEYOR BELT MANUAL
M 2.2	M 2.2	CONVEYOR SEMI-AUTOMATIC
M 2.3	M 2.3	CONVEYOR AUTOMATIC
M 2.4	M 2.4	SPARE
M 2.5	M 2.5	KNIFE READY TO START FOR AUTOMATIC
M 2.6	M 2.6	AUXILIARY DRIVES ON MESSAGE
M 2.7	M 2.7	V-LINE PRESET > V-LINE LIMIT
M 3.0	M 3.0	TREAD LENGTH OK
M 3.1	M 3.1	START CUTTING
M 3.2	M 3.2	FAULT COMPRESSED AIR SUPPLY
M 3.3	M 3.3	TIMER KNIFE CUTTING
M 3.4	M 3.4	SOLENOID VALVE KNIFE RETURN
M 3.5	M 3.5	SOLENOID VALVE KNIFE CUTTING
M 3.6	M 3.6	SOLENOID VALVE KNIFE LUBRICATION ON/OFF
M 3.7	M 3.7	SOLENOID VALVE KNIFE UP/DOWN
M 4.0	M 4.0	LINE ON (135U)
M 4.1	M 4.1	AUXILIARY DRIVES LINE (135U)
M 4.2	M 4.2	START CUTTING CICLE SEMI-AUTOMATIC
M 4.3	M 4.3	START CUTTING CICLE AUTOMATIC
M 4.4	M 4.4	SOLENOID VALVE CLAMPING DEVICE DOWN
M 4.5	M 4.5	CUTTING CICLE AUTOMATIC OFF
M 4.6	M 4.6	START HOME POSITION
M 4.7	M 4.7	SWITCH IN AUTOMATIC POSITION
M 5.0	M 5.0	OB2 DONE (TEST)
M 5.1	M 5.1	CICLE HOME POSITION STEP 1
M 5.2	M 5.2	CICLE HOME POSITION STEP 2
M 5.3	M 5.3	RESET INTERRUPT DONE (TEST)
M 5.4	M 5.4	FAULT AC-CONTROL VOLTAGE
M 5.5	M 5.5	HIGH-CONTROL TRIGGERED
M 5.6	M 5.6	CONVEYOR OFF
M 5.7	M 5.7	UNUSABLE STRIP AND NO HIGH-CONTROL
M 6.0	M 6.0	AUTOMATIC KNIFE ON
M 6.1	M 6.1	MANUAL AND SEMI-AUTOMATIC KNIFE ON
M 6.2	M 6.2	AUTOMATIC KNIFE OFF
M 6.3	M 6.3	MANUAL AND SEMI-AUTOMATIC KNIFE OFF
M 6.4	M 6.4	KNIFE ON
M 6.5	M 6.5	FAULT LINE (SINEC-L1)
M 6.6	M 6.6	IMPULSE FAULT MESSAGE FROM 135U
M 6.7	M 6.7	FAULT : TREAD SKIVER OFF
M 7.0	M 7.0	SPARE
M 7.1	M 7.1	SPARE
M 7.2	M 7.2	SPARE
M 7.3	M 7.3	HF FAULT LINE
M 7.4	M 7.4	WIND-UP (135U)
M 7.5	M 7.5	FAULT : LAMP AND HORN ON
M 7.6	M 7.6	FAULT : ONLY LAMP ON
M 7.7	M 7.7	BOOKING (135U)
M 8.0	M 8.0	E-STOP (135U)
M 8.1	M 8.1	ACKNOWLEDGING FAULT (135U)
M 8.2	M 8.2	FAULT LINE (135U)
M 8.3	M 8.3	HF LINE ON
M 8.4	M 8.4	IMPULSE LINE ON
M 8.5	M 8.5	CONVEYOR AUTOMATIC ON
M 8.6	M 8.6	HF LINE OFF
M 8.7	M 8.7	IMPULSE LINE OFF
M 9.0	M 9.0	TIMER CLAMPING DEVICE LOWERING/LIFTUNG
M 9.1	M 9.1	TIMER KNIFE IS CUTTING
M 9.2	M 9.2	TIMER KNIFE IS CUTTING
M 9.3	M 9.3	TIMER KNIFE LIFTING
M 9.4	M 9.4	TIMER KNIFE MOVE HOME
M 9.5	M 9.5	TIMER KNIFE HOME POSITION
M 9.6	M 9.6	MATERIAL OUT OF LIGHT BARRIER
M 9.7	M 9.7	CREEP WAY REACHED
M 10.0	M 10.0	COUNTER TREAD SHORTER
M 10.1	M 10.1	COUNTER TREAD LONGER
M 10.2	M 10.2	COUNTER TREAD SHORTER
M 10.3	M 10.3	COUNTER TREAD SHORTER (IMPULSE)
M 10.4	M 10.4	RELAIS LIGHT BARRIER ON
M 10.5	M 10.5	HF WIND-UP OFF
M 10.6	M 10.6	TREAD LENGTH REACHED
M 10.7	M 10.7	LINE READY TO START (135)

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OPERAND	SYMBOL	KOMMENTAR
M 11.0	M 11.0	SPARE
M 11.1	M 11.1	SPARE
M 11.2	M 11.2	IMPULSE CONVEYOR AUTOMATIC
M 11.3	M 11.3	HF CONVEYOR AUTOMATIC
M 11.4	M 11.4	IMPULS SEMI-AUTOMATIC ON
M 11.5	M 11.5	WIND-UP START
M 11.6	M 11.6	HF WIND-UP ON
M 11.7	M 11.7	IMPULSE WIND-UP ON
M 12.0	M 12.0	LINE STOP
M 12.1	M 12.1	USABLE TREAD
M 12.2	M 12.2	CONVEYOR ON WIND-UP
M 12.3	M 12.3	COUNTER WIND-UP PLUS 1
M 12.4	M 12.4	USABLE STRIP
M 12.5	M 12.5	UNUSABLE TREAD
M 12.6	M 12.6	SCRAP LENGTH MEAS.DEVICE COUNTER 1 = 900
M 12.7	M 12.7	SPARE
M 13.0	M 13.0	SPARE
M 13.1	M 13.1	SPARE
M 13.2	M 13.2	SPARE
M 13.3	M 13.3	SPARE
M 13.4	M 13.4	SPARE
M 13.5	M 13.5	IMPULSE WIND-UP OFF
M 13.6	M 13.6	MATERIAL IN LIGHT BARRIER
M 13.7	M 13.7	FAULT SKIVER
M 14.0	M 14.0	HF WIND-UP
M 14.1	M 14.1	IMPULSE WIND-UP
M 14.2	M 14.2	HF READ COUNTER 2
M 14.3	M 14.3	IMPULSE READ COUNTER 2
M 14.4	M 14.4	HF KNIFE HOMEPOSITION
M 14.5	M 14.5	IMPULSE KNIFE HOMEPOSITION
M 14.6	M 14.6	RESET COUNTER 1
M 14.7	M 14.7	RESET PRODUCTION REPORT
M 15.0	M 15.0	FAULT MATERIAL OUT OF MEASURING SECTION
M 15.1	M 15.1	SET DEMEND LENGTH
M 15.2	M 15.2	HF DEMEND LENGTH
M 15.3	M 15.3	IMPULSE DEMAND LENGTH
M 15.4	M 15.4	TIME DEMAND LENGTH
M 15.5	M 15.5	SCRAP DETECTED
M 15.6	M 15.6	TREAD IS PASSING LENGTH MEASURING DEVICE
M 15.7	M 15.7	SPARE
M 16.0	M 16.0	STRIP IN TOP SECTION
M 16.1	M 16.1	STRIP IN BOTTOM SECTION
M 16.2	M 16.2	STRIP IN BOT.SECTION (LINE creep-speed)
M 16.3	M 16.3	LIGHT BARRIER OUT OF SECTION
M 16.4	M 16.4	STRIP 60s IN BOTTOM SECTION (LINE off)
M 16.5	M 16.5	HF E-STOP LINE (135U)
M 16.6	M 16.6	LIGHT BARRIER NOT O.K.
M 16.7	M 16.7	LIGHT BARRIER O.K.
M 17.0	M 17.0	IMPULSE HIGH-CONTROL TRIGGERED
M 17.1	M 17.1	IMPULSE UNUSABLE TREAD LENGTH
M 17.2	M 17.2	CUT UNUSABLE TREAD
M 17.3	M 17.3	HF UNUSABLE TREAD LENGTH
M 17.4	M 17.4	HF HIGH-CONTROL TRIGGERED
M 17.5	M 17.5	HF SEMI-AUTOMATIC ON
M 17.6	M 17.6	HF TREAD SHORTER
M 17.7	M 17.7	HF TACT M 25.3
M 18.0	M 18.0	IMPULSE M 25.3
M 18.1	M 18.1	HF TREAD LONGER
M 18.2	M 18.2	HF TACT M 25.3
M 18.3	M 18.3	IMPULSE M 25.3
M 18.4	M 18.4	PRESSURE FAULT SOFT WATER
M 18.5	M 18.5	IMPULSE E-STOP LINE (135U)
M 18.6	M 18.6	SPARE
M 18.7	M 18.7	SPARE
M 19.0	M 19.0	LENGTH MEASURING MAX. SLIT
M 19.1	M 19.1	LENGTH MEASURING MIN. SLIT
M 19.2	M 19.2	LENGTH MEASURING TREAD LENGTH O.K.
M 19.3	M 19.3	10 TREADS COUNTED
M 19.4	M 19.4	SPARE
M 19.5	M 19.5	TREAD > MAX
M 19.6	M 19.6	TREAD < MIN
M 19.7	M 19.7	SPARE

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OPERAND	SYMBOL	KOMMENTAR
M 20.0	M 20.0	INTERRUPT FB123 CREEP (TEST)
M 20.1	M 20.1	INTERRUPT FB123 STOP (TEST)
M 20.2	M 20.2	TREAD UNDER SCRAP MARKING FAST
M 20.3	M 20.3	TREAD UNDER SCRAP MARKING SLOW
M 20.4	M 20.4	SPARE
M 20.5	M 20.5	HF RESET DISPLAY LENGTH MEASURING DEVICE
M 20.6	M 20.6	IMPULSE RESET DISPLAY LENGTH MEAS.DEVICE
M 20.7	M 20.7	SPARE
M 21.0	M 21.0	SPARE
M 21.1	M 21.1	SPARE
M 21.2	M 21.2	SPARE
M 21.3	M 21.3	SPARE
M 21.4	M 21.4	SPARE
M 21.5	M 21.5	SPARE
M 21.6	M 21.6	SPARE
M 21.7	M 21.7	SPARE
M 22.0	M 22.0	SPARE
M 22.1	M 22.1	SPARE
M 22.2	M 22.2	SPARE
M 22.3	M 22.3	SPARE
M 22.4	M 22.4	SPARE
M 22.5	M 22.5	SPARE
M 22.6	M 22.6	SPARE
M 22.7	M 22.7	SPARE
M 23.0	M 23.0	SPARE
M 23.1	M 23.1	SPARE
M 23.2	M 23.2	SPARE
M 23.3	M 23.3	SPARE
M 23.4	M 23.4	SPARE
M 23.5	M 23.5	SPARE
M 23.6	M 23.6	SPARE
M 23.7	M 23.7	SPARE
M 24.0	M 24.0	HF TACT 1 Hz
M 24.1	M 24.1	HF TACT 1 Hz
M 24.2	M 24.2	TACT 1 Hz
M 24.3	M 24.3	TACT 2 Hz
M 24.4	M 24.4	HF TACT 2 Hz
M 24.5	M 24.5	HF TACT 2 Hz
M 24.6	M 24.6	SPARE
M 24.7	M 24.7	SPARE
M 60.0	M 60.0	SINEC L1-BUS
M 60.1	M 60.1	SINEC L1-BUS
M 60.2	M 60.2	SINEC L1-BUS
M 60.3	M 60.3	SINEC L1-BUS
M 60.4	M 60.4	SINEC L1-BUS
M 60.5	M 60.5	SINEC L1-BUS
M 60.6	M 60.6	SINEC L1-BUS
M 60.7	M 60.7	SINEC L1-BUS
M 61.0	M 61.0	SINEC L1-BUS
M 61.1	M 61.1	SINEC L1-BUS
M 61.2	M 61.2	SINEC L1-BUS
M 61.3	M 61.3	SINEC L1-BUS
M 61.4	M 61.4	SINEC L1-BUS
M 61.5	M 61.5	SINEC L1-BUS
M 61.6	M 61.6	SINEC L1-BUS
M 61.7	M 61.7	SINEC L1-BUS : FLAG RECIEVE DATAS
M 62.0	M 62.0	SINEC L1-BUS
M 62.1	M 62.1	SINEC L1-BUS : SEND FAULT
M 62.2	M 62.2	SINEC L1-BUS
M 62.3	M 62.3	SINEC L1-BUS
M 62.4	M 62.4	SINEC L1-BUS
M 62.5	M 62.5	SINEC L1-BUS
M 62.6	M 62.6	SINEC L1-BUS
M 62.7	M 62.7	SINEC L1-BUS : FLAG SEND DATAS
M 99.0	M 99.0	"0"-SIGNAL
M 99.1	M 99.1	"1"-SIGNAL
M 135.0	M 135.0	SINEC L1-BUS : RECEIVED DATA COPIED
M 135.1	M 135.1	SINEC L1-BUS
M 135.2	M 135.2	SINEC L1-BUS
M 135.3	M 135.3	SINEC L1-BUS
M 160.0	M 160.0	IP242
M 160.1	M 160.1	IP242

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OPERAND	SYMBOL	KOMMENTAR
M 160.2	M 160.2	IP242
M 160.3	M 160.3	IP242
M 160.4	M 160.4	IP242
M 160.5	M 160.5	IP242
M 160.6	M 160.6	IP242
M 160.7	M 160.7	IP242 READY BIT
M 190.0	M 190.0	BCD-DISPLAY PRESET TREAD LENGTH
M 190.1	M 190.1	BCD-DISPLAY PRESET TREAD LENGTH
M 190.2	M 190.2	BCD-DISPLAY PRESET TREAD LENGTH
M 190.3	M 190.3	BCD-DISPLAY PRESET TREAD LENGTH
M 190.4	M 190.4	BCD-DISPLAY PRESET TREAD LENGTH
M 190.5	M 190.5	BCD-DISPLAY PRESET TREAD LENGTH
M 190.6	M 190.6	BCD-DISPLAY PRESET TREAD LENGTH
M 190.7	M 190.7	BCD-DISPLAY PRESET TREAD LENGTH
M 191.0	M 191.0	BCD-DISPLAY PRESET TREAD LENGTH
M 191.1	M 191.1	BCD-DISPLAY PRESET TREAD LENGTH
M 191.2	M 191.2	BCD-DISPLAY PRESET TREAD LENGTH
M 191.3	M 191.3	BCD-DISPLAY PRESET TREAD LENGTH
M 191.4	M 191.4	BCD-DISPLAY PRESET TREAD LENGTH
M 191.5	M 191.5	BCD-DISPLAY PRESET TREAD LENGTH
M 191.6	M 191.6	BCD-DISPLAY PRESET TREAD LENGTH
M 191.7	M 191.7	BCD-DISPLAY PRESET TREAD LENGTH
M 194.0	M 194.0	BCD-DISPLAY LENGTH MEAS.DEVICE
M 194.1	M 194.1	BCD-DISPLAY LENGTH MEAS.DEVICE
M 194.2	M 194.2	BCD-DISPLAY LENGTH MEAS.DEVICE
M 194.3	M 194.3	BCD-DISPLAY LENGTH MEAS.DEVICE
M 194.4	M 194.4	BCD-DISPLAY LENGTH MEAS.DEVICE
M 194.5	M 194.5	BCD-DISPLAY LENGTH MEAS.DEVICE
M 194.6	M 194.6	BCD-DISPLAY LENGTH MEAS.DEVICE
M 194.7	M 194.7	BCD-DISPLAY LENGTH MEAS.DEVICE
M 195.0	M 195.0	BCD-DISPLAY LENGTH MEAS.DEVICE
M 195.1	M 195.1	BCD-DISPLAY LENGTH MEAS.DEVICE
M 195.2	M 195.2	BCD-DISPLAY LENGTH MEAS.DEVICE
M 195.3	M 195.3	BCD-DISPLAY LENGTH MEAS.DEVICE
M 195.4	M 195.4	BCD-DISPLAY LENGTH MEAS.DEVICE
M 195.5	M 195.5	BCD-DISPLAY LENGTH MEAS.DEVICE
M 195.6	M 195.6	BCD-DISPLAY LENGTH MEAS.DEVICE
M 195.7	M 195.7	BCD-DISPLAY LENGTH MEAS.DEVICE
MB 60	MB 60	SINEC L1-BUS
MB 61	MB 61	SINEC L1-BUS
MB 62	MB 62	SINEC L1-BUS
MB 160	MB 160	IP242 : MB
MW 26	MW 226	BCD-VALUE FOR TREAD CORRECTION
MW 190	MW 190	BCD-DISPALY PRESET TREAD LENGTH
MW 194	MW 194	BCD-DISPLAY LENGTH MEASURING DEVICE
PY 160	PY 160	IP242
PW 128	12A1.1	CONVEYOR BELT SLIT
PW 130	17A1	LIGHT CURTAIN
PW 132	E:PW 132	SPARE
PW 134	E:PW 134	SPARE
PW 136	E:PW 136	SPARE
PW 138	E:PW 138	SPARE
PW 140	E:PW 140	SPARE
PW 142	E:PW 142	SPARE
PW 144	E:PW 144	SPARE
PW 146	E:PW 146	SPARE
PW 148	E:PW 148	SPARE
PW 150	E:PW 150	SPARE
PW 160	PW 160	IP242
PW 162	PW 162	IP242
PW 164	PW 164	IP242 : INTM-REGISTER
PW 166	PW 166	IP242 : MM-REGISTER
PW 168	PW 168	IP242 : CM-REGISTER
PW 170	PW 170	IP242 : CTRL-REGISTER
T 1	T 1	WAIT FOR DEMAND LENGTH
T 2	T 2	CLAMPING DEVICE DOWN
T 3	T 3	CLAMPING DEVICE UP/DOWN
T 4	T 4	KNIFE IS CUTTING
T 5	T 5	KNIFE DRIVE MOTOR
T 6	T 6	KNIFE IS CUTTING
T 7	T 7	STRIP IS 60s IN BOTTOM SECTION LIGHT-B.
T 8	T 8	LIFTING KNIFE

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OPERAND	SYMBOL		KOMMENTAR
T 9	T 9		MOVE KNIFE HOME
T 10	T 10		TIMER FOR TACT 1 Hz
T 11	T 11		TIMER FOR TACT 2 Hz
T 12	T 12		RELEASE CONVEYOR MANUAL FORWARD
T 13	T 13		RELEASE CONVEYOR MANUAL REVERSE
T 14	T 14		CICLETIME
T 15	T 15		SPARE
T 16	T 16		SPARE
T 17	T 17		SPARE
T 18	T 18		TREAD UNDER SCRAP MARKING FAST
T 19	T 19		TREAD UNDER SCRAP MARKING SLOW
T 20	T 20		RESET SCRAP MARKING
T 21	T 21		BY-PASS MIN FIELD CURRENT
T 22	T 22		SPARE
T 23	T 23		SPARE
T 24	T 24		SPARE
T 25	T 25		SPARE
T 26	T 26		SPARE
T 27	T 27		SPARE
T 28	T 28		SPARE
T 29	T 29		SPARE
Z 1	Z 1		SPARE
Z 2	Z 2		COUNTER TREAD LONGER
Z 3	Z 3		COUNTER TREAD SHORTER
Z 4	Z 4		COUNTER FOR WIND-UP
Z 5	Z 5		LENGTH MEASURING DEVICE SCRAP 0-899
Z 6	Z 6		LENGTH MEASURING DEVICE SCRAP 900
Z 7	Z 7		SPARE
Z 8	Z 8		SPARE
Z 9	Z 9		SPARE
FB 1	FB 1		SPARE
FB 2	FB 2		SPARE
FB 3	FB 3		SPARE
FB 4	FB 4		SPARE
FB 5	FB 5	S	RAD
FB 6	FB 6		SPARE
FB 7	FB 7		PRESET TREAD LENGTH
FB 8	FB 8		BCD-DISPLAY LENGTH MEASURING DEVICE
FB 9	FB 9		VALUE FOR TREAD LENGTH CORRECTION
FB 10	FB 10		ADD
FB 11	FB 11		SUB
FB 12	FB 12		TRANSFER 1 WORD
FB 13	FB 13		TRANSFER 2 WORDS
FB 14	FB 14		CICLETIME
FB 15	FB 15	S	FIXED-POINT NUMBER --> FLOATING-POINT N.
FB 16	FB 16	S	FLOATING-POINT NUMBER --> FIXED-POINT N.
FB 17	FB 17	S	ADD TWO FLOATING-POINT NUMBERS
FB 18	FB 18	S	SUBTRACT TWO FLOATING-POINT NUMBERS
FB 19	FB 19	S	MULTIPLY TWO FLOATING-POINT NUMBERS
FB 20	FB 20	S	DIVIDE TWO FLOATING-POINT NUMBERS
FB 21	FB 21	S	COMPARE TWO FLOATING-POINT NUMBERS
FB 22	FB 22		SPARE
FB 23	FB 23		SPARE
FB 24	FB 24		SPARE
FB 25	FB 25		SPARE
FB 26	FB 26		SPARE
FB 27	FB 27		SPARE
FB 28	FB 28		SPARE
FB 29	FB 29		SPARE
FB 30	FB 30		CALCULATION : TREAD IN TOLERANCE
FB 31	FB 31		SPARE
FB 32	FB 32		SPARE
FB 33	FB 33		SPARE
FB 34	FB 34		SPARE
FB 35	FB 35		SPARE
FB 36	FB 36		SPARE
FB 37	FB 37		SPARE
FB 38	FB 38		SPARE
FB 39	FB 39		CALCULATION USABLE TREAD (HIGH-CONTROL)
FB 50	FB 50		MOVE MB ==> DB
FB 51	FB 51		MOVE DB ==> MB
FB 60	FB 60		SPEED CONVEYOR SEMI-AUTOMATIC

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OPERAND	SYMBOL	KOMMENTAR
FB 70	FB 70	TREADS SHORTER
FB 71	FB 71	TREADS LONGER
FB 109	FB 109	TEST PERIPHERIE
FB 110	FB 110	RESET FLAGS
FB 113	FB 113	DATA TRANSFER SINEC-L1
FB 114	FB 114	DATA TRANSFER SINEC-L1
FB 120	FB 120	COUNTER 1 : READ
FB 121	FB 121	COUNTER 1 : RESET INTERRUPT
FB 123	FB 123	COUNTER 1 : INTERRUPT PROGRAM
FB 125	FB 125	DEMAND TREAD LENGTH
FB 134	FB 134	500 ns FOR IP242
FB 140	FB 140	COUNTER 2 : LOAD + START
FB 141	FB 141	COUNTER 2 : INSTALL
FB 142	FB 142	COUNTER 2 : READ
FB 149	FB 149	COUNTER 1 : INSTALL NEW INTERRUPT
FB 150	FB 150	COUNTER 1 : INSTALL
FB 151	FB 151	COUNTER 1 : INSTALL FOR WIND-UP
FB 152	FB 152	COUNTER 1 : READ FOR WIND-UP
FB 153	FB 153	RESET FLAGS BOOKING + INSTALL COUNTER
FB 154	FB 154	COUNTER 1 : LOAD + STAR FOR WIND-UP
FB 155	FB 155	COUNTER 1 : RESET WIND-UP SET BOOKING
FB 202	FB 202	POSITIVE FLANK
FB 240	FB 240 S	BCD NUMBER ---> FIXED-POINT NUMBER
FB 241	FB 241 S	FIXED-POINT NUMBER ---> BCD NUMBER
FB 242	FB 242 S	MUL 16-BIT
FB 243	FB 243 S	DIV 16-BIT
FB 244	FB 244 S	SEND
FB 245	FB 245 S	RECEIVE
FB 246	FB 246 S	FETCH
FB 247	FB 247 S	CONTROL
FB 248	FB 248 S	RESET
FB 249	FB 249 S	SYNCHRON
FB 250	FB 250 S	ANALOG-INPUT
FB 251	FB 251 S	ANALOG-OUTPUT
FB 255	FB 255	S5-115U AS SLAVE
PB 1	PB 1	TACT
PB 2	PB 2	SPARE
PB 3	PB 3	GENERAL SIGNALS
PB 4	PB 4	CICLE NORMAL POSITION
PB 5	PB 5	CUTTING CICLE
PB 6	PB 6	LIGHT BARRIER
PB 7	PB 7	SPARE
PB 8	PB 8	SPEED CONVEYOR BELT
PB 9	PB 9	HIGH-CONTROL 60MM
PB 10	PB 10	HIGH CONTROL : CALCULATION USABLE STRIP
PB 11	PB 11	SPARE
PB 12	PB 12	LENGTH MEASURING DEVICE + SCRAP MARKING
PB 13	PB 13	WIND-UP
PB 14	PB 14	SPARE
PB 15	PB 15	SPARE
PB 16	PB 16	SPARE
PB 17	PB 17	SPARE
PB 18	PB 18	SPARE
PB 19	PB 19	SPARE
PB 20	PB 20	SPARE
PB 21	PB 21	SPARE
PB 22	PB 22	SPARE
PB 23	PB 23	SPARE
PB 24	PB 24	SPARE
PB 25	PB 25	MB ---> DB (SEND DW40-79)
PB 26	PB 26	DB ---> MB (RECIEVE DW80-119)
PB 255	PB 255	START PB
DB 30	DB 30	CALCULATION DATA

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NETZWERK 1          0000
0000       :SPA PB   1     -PB  1              TACT
0001       :SPA FB 114     -FB 114             SINEC L1-BUS
0002 NAME  :SINEC
0003       :SPA PB   3     -PB  3              GENERAL SIGNALS
0004       :SPA PB   4     -PB  4              NORMAL POSITION
0005       :SPA PB   5     -PB  5              CUTTING CICLE
0006       :SPA FB   7     -FB   7             PRESET VALUE LENGTH
0007 NAME  :VALUE-SO
0008       :SPA PB   8     -PB  8              CONVEYOR
0009       :SPA PB  10     -PB 10              HIGH CONTROL
000A       :SPA PB  12     -PB 12              LENGTH MEASURING DEVICE
000B       :SPA PB  13     -PB 13              WIND-UP
000C       :SPA FB   8     -FB   8             DISPLAY LENGTH MEASURING DEVICE
000D NAME  :LMD-DISP
000E       :SPA PB  25     -PB 25              SEND TO 135U
000F       :SPA PB   6     -PB  6              LIGHT BARRIER
0010       :UN  M   11.5   -M  11.5
0011       :SPB FB 120     -FB 120             READ COUNTER 1
0012 NAME  :READ-ZAE
0013       :SPA PB  26     -PB 26              RECEIVE FROM 135U
0014       :U   M    3.0   -M   3.0            RESET TEST INTERRUPT
0015       :R   M    5.0   -M   5.0
0016       :R   M    5.3   -M   5.3
0017       :R   M   20.0   -M  20.0
0018       :U   M    1.7   -M   1.7
0019       :R   M   20.1   -M  20.1
001A       :SPA FB  14     -FB  14             CICLETIME
001B NAME  :ZYKLZEIT
001C       :***

M   11.5 = M  11.5                  WIND-UP START
M    3.0 = M   3.0                  TREAD LENGTH OK
M    5.0 = M   5.0                  OB2 DONE (TEST)
M    5.3 = M   5.3                  RESET INTERRUPT DONE (TEST)
M   20.0 = M  20.0                  INTERRUPT FB123 CREEP (TEST)
M    1.7 = M   1.7                  CUTTING CICLE END
M   20.1 = M  20.1                  INTERRUPT FB123 STOP (TEST)

PB   1   = PB  1                    TACT
PB   3   = PB  3                    GENERAL SIGNALS
PB   4   = PB  4                    CICLE NORMAL POSITION
PB   5   = PB  5                    CUTTING CICLE
PB   8   = PB  8                    SPEED CONVEYOR BELT
PB  10   = PB 10                    HIGH CONTROL : CALCULATION USABLE STRIP
PB  12   = PB 12                    LENGTH MEASURING DEVICE + SCRAP MARKING
PB  13   = PB 13                    WIND-UP
PB  25   = PB 25                    MB ---> DB (SEND DW40-79)
PB   6   = PB  6                    LIGHT BARRIER
PB  26   = PB 26                    DB ---> MB (RECIEVE DW80-119)

FB 114   = FB 114                   DATA TRANSFER SINEC-L1
FB   7   = FB   7                   PRESET TREAD LENGTH
FB   8   = FB   8                   BCD-DISPLAY LENGTH MEASURING DEVICE
FB 120   = FB 120                   COUNTER 1 : READ
FB  14   = FB  14                   CICLETIME

NETZWERK 2          001D
001D       :BE
```

```
OB 2                                    C:SKIV06ST.S5D        BIB=11112   LAE=13

NETZWERK 1          0000
0000       :AWL
0001       :SPA FB 121     -FB 121              RESET INTERRUPT
0002 NAME  :RESET-I
0003       :SPA FB 123     -FB 123              EVALUATION INTERRUPT
0004 NAME  :INTER-2
0005       :UN  M     5.0  -M   5.0
0006       :S   M     5.0  -M   5.0
0007       :BE

M    5.0 = M   5.0                          OB2 DONE (TEST)

FB 121    = FB 121                          COUNTER 1 : RESET INTERRUPT
FB 123    = FB 123                          COUNTER 1 : INTERRUPT PROGRAM
```

```
OB 20                                   C:SKIV06ST.S5D        BIB=7022    LAE=10

NETZWERK 1          0000
0000       :AWL
0001       :
0002       :SPA PB 255     -PB 255                START
0003       :
0004       :BE

PB 255     = PB 255                     START PB
```

```
OB 21                                C:SKIV06ST.S5D        BIB=7022     LAE=10

NETZWERK 1          0000
0000       :AWL
0001       :
0002       :SPA PB 255     -PB 255              START
0003       :
0004       :BE

PB 255     = PB 255                  START PB
```

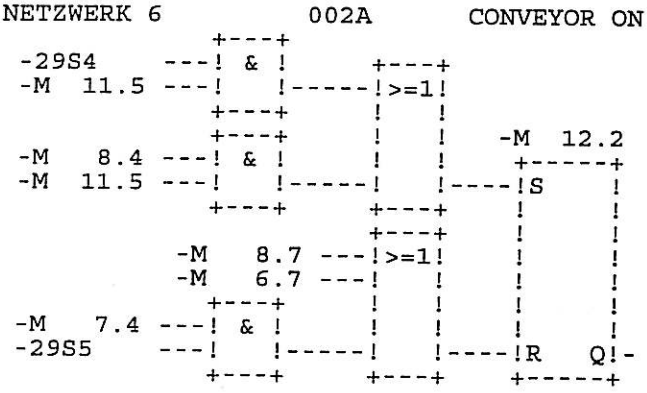
```
NETZWERK 1          0000
0000       :AWL
0001       :
0002       :SPA PB 255     -PB 255
0003       :
0004       :BE

PB 255    = PB 255                    START PB
```

```
NETZWERK 1          0000
0000      :NOP 1
0002      :BE
```

```
0078      :L   Z    5    -Z   5
0079      :L   KF +900
007B      :>=F
007C      :=   M   12.6  -M  12.6
007D      :U   M   12.6  -M  12.6
007E      :R   Z    5    -Z   5
007F      :***

Z    5   = Z   5                    LENGTH MEASURING DEVICE SCRAP 0-899
M   12.6 = M  12.6                  SCRAP LENGTH MEAS.DEVICE COUNTER 1 = 900

DB  30   = DB  30                   CALCULATION DATA

NETZWERK 14        0080      COUNTER 2 FOR SCRAP
            -Z   6
             +-----+
 -M  12.6 --!ZV   !
          --!ZR   !
          --!S    !
          --!ZW DU!- DW 89
            !   DE!-
 -M  14.7 --!R   Q!-
             +-----+

M   12.6 = M  12.6                  SCRAP LENGTH MEAS.DEVICE COUNTER 1 = 900
Z    6   = Z   6                    LENGTH MEASURING DEVICE SCRAP 900
M   14.7 = M  14.7                  RESET PRODUCTION REPORT

NETZWERK 15        008C      RESET FLAGS FROM FB30
             +---+
 -M   4.0 --O!>=1!
 -M  20.2 ---!   !    +------+
 -M  20.3 ---!   !--+-! R    ! -M  15.5
             +---+  ! +------+
                    ! +------+
                    +-! R    ! -M  19.0
                    ! +------+
                    ! +------+
                    +-! R    ! -M  19.1
                      +------+

M    4.0 = M   4.0                  LINE ON (135U)
M   20.2 = M  20.2                  TREAD UNDER SCRAP MARKING FAST
M   20.3 = M  20.3                  TREAD UNDER SCRAP MARKING SLOW
M   15.5 = M  15.5                  SCRAP DETECTED
M   19.0 = M  19.0                  LENGTH MEASURING MAX. SLIT
M   19.1 = M  19.1                  LENGTH MEASURING MIN. SLIT

NETZWERK 16        0093
0093      :BE
```

```
NETZWERK 1          0000      WIND-UP IN

*****************************************************************************
*                                                                           *
*                                   WIND-UP                                 *
*                                                                           *
*****************************************************************************
                        +---+
           -M   7.4 ---! & !
           -M   4.0 --O!   !
           -M   0.5 --O!   !
           -M   1.0 --O!   !
           -M   1.1 --O!   !
           -M   1.2 --O!   !
           -M   2.1 --O!   !
           -M   2.2 --O!   !
           -M   4.2 --O!   !
           -M   4.3 --O!   !
             +---+     !   !   -M  11.5
 -27S1    ---!>=1!     !   !    +-----+
 -27S2    ---!   !-----!   !----!S    !
             +---+     +---+    !     !
                       +---+    !     !
           -M   7.4 --O! & !    !     !
           -M   7.7 ---!   !----!R   Q!-
                       +---+    +-----+

M    7.4 = M   7.4                    WIND-UP (135U)
M    4.0 = M   4.0                    LINE ON (135U)
M    0.5 = M   0.5                    CUTTING CICLE START MARK
M    1.0 = M   1.0                    SKIVER IS IN OPERATION
M    1.1 = M   1.1                    CUTTING CICLE STEP 1
M    1.2 = M   1.2                    CUTTING CICLE STEP 2
M    2.1 = M   2.1                    CONVEYOR BELT MANUAL
M    2.2 = M   2.2                    CONVEYOR SEMI-AUTOMATIC
M    4.2 = M   4.2                    START CUTTING CICLE SEMI-AUTOMATIC
M    4.3 = M   4.3                    START CUTTING CICLE AUTOMATIC
E    2.0 = 27S1                       KNIFE HOME POSITION
E    2.1 = 27S2                       KNIFE ON HIGH
M   11.5 = M  11.5                    WIND-UP START
M    7.7 = M   7.7                    BOOKING (135U)

NETZWERK 2          0014      IMPULSE WIND-UP ON
0014      :U   M   11.5  -M  11.5
0015      :UN  M   11.6  -M  11.6
0016      :=   M   11.7  -M  11.7
0017      :U   M   11.5  -M  11.5
0018      :=   M   11.6  -M  11.6
0019      :***

M   11.5 = M  11.5                    WIND-UP START
M   11.6 = M  11.6                    HF WIND-UP ON
M   11.7 = M  11.7                    IMPULSE WIND-UP ON

NETZWERK 3          001A      RES.COUNTER BOOK. + SET WIND-UP
001A      :U   M   11.7  -M  11.7
001B      :SPB FB 153    -FB 153
001C NAME :RES-WIND
001D      :***

M   11.7 = M  11.7                    IMPULSE WIND-UP ON

FB 153   = FB 153                     RESET FLAGS BOOKING + INSTALL COUNTER

NETZWERK 4          001E      IMPULSE WIND-UP OFF
001E      :UN  M    7.4  -M   7.4
001F      :UN  M    4.0  -M   4.0
0020      :UN  M   10.5  -M  10.5
0021      :=   M   13.5  -M  13.5
0022      :UN  M    7.4  -M   7.4
0023      :UN  M    4.0  -M   4.0
0024      :=   M   10.5  -M  10.5
0025      :***

+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                     !
!ELASTOMERTECHNIK          WERK HARBURG !  SKIVER                             !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                     !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                   PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                     1!
+-----------------------------------------------------------------------------+
```

```
M    7.4 = M   7.4                    WIND-UP (135U)
M    4.0 = M   4.0                    LINE ON (135U)
M   10.5 = M  10.5                    HF WIND-UP OFF
M   13.5 = M  13.5                    IMPULSE WIND-UP OFF

NETZWERK 5          0026       RES.COUNTER WIND-UP + SET BOOK.
0026       :U   M   13.5  -M  13.5
0027       :SPB FB 155    -FB 155
0028 NAME  :OFF-WIND
0029       :***

M   13.5 = M  13.5                    IMPULSE WIND-UP OFF

FB 155   = FB 155                     COUNTER 1 : RESET WIND-UP SET BOOKING

NETZWERK 6          002A       CONVEYOR ON
```




```
E    4.3 = 29S4                       CUTTING START        (CONTROL PANEL)
M   11.5 = M  11.5                    WIND-UP START
M    8.4 = M   8.4                    IMPULSE LINE ON
M   12.2 = M  12.2                    CONVEYOR ON WIND-UP
M    8.7 = M   8.7                    IMPULSE LINE OFF
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
M    7.4 = M   7.4                    WIND-UP (135U)
E    4.4 = 29S5                       CUTTING STOP         (CONTROL PANEL)

NETZWERK 7          0038       COUNTER FOR WIND-UP
0038       :A   DB  30    -DB  30
0039       :U   M   12.3  -M  12.3
003A       :ZV  Z    4    -Z   4
003B       :ON  M    7.4  -M   7.4
003C       :O   M   14.7  -M  14.7
003D       :R   Z    4    -Z   4
003E       :L   Z    4    -Z   4
003F       :T   DW  85
0040       :U   M   99.1  -M  99.1
0041       :R   M   12.3  -M  12.3
0042       :U   M   11.5  -M  11.5
0043       :SPB FB 152    -FB 152
0044 NAME  :R-WIND
0045       :***

M   12.3 = M  12.3                    COUNTER WIND-UP PLUS 1
Z    4   = Z   4                     COUNTER FOR WIND-UP
M    7.4 = M   7.4                    WIND-UP (135U)
M   14.7 = M  14.7                    RESET PRODUCTION REPORT
M   99.1 = M  99.1                    "1"-SIGNAL
M   11.5 = M  11.5                    WIND-UP START

DB  30   = DB  30                     CALCULATION DATA

FB 152   = FB 152                     COUNTER 1 : READ FOR WIND-UP

NETZWERK 8          0046
0046       :BE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                              115U ---> 135U                               *
*                                                                           *
*****************************************************************************
0000      :***

NETZWERK 2          0001      115U:DB30/82 ---> 135U:DB21/4

                                -FB  50
                                 +--------------+
                                 !   MB--->DB   !
                     -DB  30  --!DBNR      DW  !-- DR 82
                     -15Q5    --!BIT0          !
                     -27S2    --!BIT1          !
                     -M   5.5 --!BIT2          !
                     -26S7    --!BIT3          !
                     -M  16.4 --!BIT4          !
                     -M   9.2 --!BIT5          !
                     -M   9.3 --!BIT6          !
                     -M   9.4 --!BIT7          !
                                 +--------------+

E    0.3 = 15Q5                      DRIVE MOTOR FAULT KNIFE TRANSFER
E    2.1 = 27S2                      KNIFE ON HIGH
M    5.5 = M   5.5                   HIGH-CONTROL TRIGGERED
E    1.6 = 26S7                      HIGH-CONTROL 100 MM (TREAD SKIVER OFF)
M   16.4 = M  16.4                   STRIP 60s IN BOTTOM SECTION (LINE off)
M    9.2 = M   9.2                   TIMER KNIFE IS CUTTING
M    9.3 = M   9.3                   TIMER KNIFE LIFTING
M    9.4 = M   9.4                   TIMER KNIFE MOVE HOME

DB  30   = DB  30                    CALCULATION DATA

FB  50   = FB  50                    MOVE  MB ==> DB

NETZWERK 3          000E      115U:DB30/82 ---> 135U:DB21/4

                                -FB  50
                                 +--------------+
                                 !   MB--->DB   !
                     -DB  30  --!DBNR      DW  !-- DL 82
                     -M   9.5 --!BIT0          !
                     -M  99.0 --!BIT1          !
                     -16Q5    --!BIT2          !
                     -15Q1    --!BIT3          !
                     -M   2.0 --!BIT4          !
                     -27S1    --!BIT5          !
                     -M  18.4 --!BIT6          !
                     -M   5.4 --!BIT7          !
                                 +--------------+

M    9.5 = M   9.5                   TIMER KNIFE HOME POSITION
M   99.0 = M  99.0                   "0"-SIGNAL
E    0.5 = 16Q5                      DRIVE MOTOR FAULT EXTERNAL FAN
E    0.1 = 15Q1                      DRIVE MOTOR FAULT KNIFE
M    2.0 = M   2.0                   FAULT DRIVE MOTOR CONVEYOR BELT
E    2.0 = 27S1                      KNIFE HOME POSITION
M   18.4 = M  18.4                   PRESSURE FAULT SOFT WATER
M    5.4 = M   5.4                   FAULT AC-CONTROL VOLTAGE

DB  30   = DB  30                    CALCULATION DATA

FB  50   = FB  50                    MOVE  MB ==> DB
```

NETZWERK 4 001B 115U:DB30/83 ---> 135U:DB21/5

```
                          -FB  50
                           +--------------+
                           !   MB--->DB   !
-DB  30   --!DBNR      DW  !-- DR 83
-21A1.1   --!BIT0          !
-M   3.2  --!BIT1          !
-9S1      --!BIT2          !
-A220     --!BIT3          !
-17A1.1   --!BIT4          !
-M   9.6  --!BIT5          !
-M  99.0  --!BIT6          !
-M  99.0  --!BIT7          !
                           +--------------+
```

```
E    1.0 = 21A1.1                  LENGTH MEASURING DEVICE VERTICAL
M    3.2 = M   3.2                 FAULT COMPRESSED AIR SUPPLY
E    3.3 = 9S1                     E-STOP SWITCH CABINET
E    4.7 = A220                    E-STOP                (CONTROL PANEL)
E    3.0 = 17A1.1                  LIGHT BARRIER READY FOR START
M    9.6 = M   9.6                 MATERIAL OUT OF LIGHT BARRIER
M   99.0 = M  99.0                 "0"-SIGNAL

DB  30   = DB  30                  CALCULATION DATA

FB  50   = FB  50                  MOVE  MB ==> DB
```

NETZWERK 5 0028 115U:DB30/83 ---> 135U:DB21/5

```
                          -FB  50
                           +--------------+
                           !   MB--->DB   !
-DB  30   --!DBNR      DW  !-- DL 83
-M   4.7  --!BIT0          !
-M   2.5  --!BIT1          !
-M   2.6  --!BIT2          !
-M   6.7  --!BIT3          !
-M  99.0  --!BIT4          !
-M  99.0  --!BIT5          !
-M  99.0  --!BIT6          !
-M  99.0  --!BIT7          !
                           +--------------+
```

```
M    4.7 = M   4.7                 SWITCH IN AUTOMATIC POSITION
M    2.5 = M   2.5                 KNIFE READY TO START FOR AUTOMATIC
M    2.6 = M   2.6                 AUXILIARY DRIVES ON MESSAGE
M    6.7 = M   6.7                 FAULT : TREAD SKIVER OFF
M   99.0 = M  99.0                 "0"-SIGNAL

DB  30   = DB  30                  CALCULATION DATA

FB  50   = FB  50                  MOVE  MB ==> DB
```

```
NETZWERK 6          0035
0035       :A   DB  30    -DB  30
0036       :L   DW   4                    Vconveyor
0037       :T   DW  91
0038       :***


DB  30   = DB  30                  CALCULATION DATA

NETZWERK 7          0039
0039       :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  135U ---> 115U                             *
*                                                                             *
*******************************************************************************
0000      :AWL
0001      :***

NETZWERK 2          0002      135U:DB20/7 ---> 115U:DB30/46

                                -FB  51
                                 +--------------+
                                 !   DB--->MB   !
                      -DB  30  --!DB         BIT0!-- -M   4.0
                      DR 46    --!DW         BIT1!-- -M   4.1
                                 !           BIT2!-- -M  10.7
                                 !           BIT3!-- -M   6.5
                                 !           BIT4!-- -M   8.1
                                 !           BIT5!-- -M   7.7
                                 !           BIT6!-- -M   7.4
                                 !           BIT7!-- -M   8.0
                                 +--------------+

M    4.0 = M   4.0                    LINE ON (135U)
M    4.1 = M   4.1                    AUXILIARY DRIVES LINE (135U)
M   10.7 = M  10.7                    LINE READY TO START (135)
M    6.5 = M   6.5                    FAULT LINE (SINEC-L1)
M    8.1 = M   8.1                    ACKNOWLEDGING FAULT (135U)
M    7.7 = M   7.7                    BOOKING (135U)
M    7.4 = M   7.4                    WIND-UP (135U)
M    8.0 = M   8.0                    E-STOP (135U)

DB  30   = DB  30                     CALCULATION DATA

FB  51   = FB  51                     MOVE  DB ==> MB

NETZWERK 3          000F      135U:DB20/7 ---> 115U:DB30/46

                                -FB  51
                                 +--------------+
                                 !   DB--->MB   !
                      -DB  30  --!DB         BIT0!-- -M   8.2
                      DL 46    --!DW         BIT1!-- -M  14.7
                                 !           BIT2!-- -M   2.7
                                 !           BIT3!-- M 222.2
                                 !           BIT4!-- M 222.2
                                 !           BIT5!-- M 222.2
                                 !           BIT6!-- M 222.2
                                 !           BIT7!-- M 222.2
                                 +--------------+

M    8.2 = M   8.2                    FAULT LINE (135U)
M   14.7 = M  14.7                    RESET PRODUCTION REPORT
M    2.7 = M   2.7                    V-LINE PRESET > V-LINE LIMIT

DB  30   = DB  30                     CALCULATION DATA

FB  51   = FB  51                     MOVE  DB ==> MB

NETZWERK 4          001C
001C      :AWL
001D      :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  PB FOR START                               *
*                                                                             *
*******************************************************************************

0000       :AWL
0001       :***

NETZWERK 2          0002
0002       :AWL
0003       :SPA FB 113     -FB 113              SINEC L1-BUS
0004 NAME  :SINEC-L1
0005       :SPA FB 110     -FB 110              RESET FLAGS
0006 NAME  :RESET M
0007       :SPA FB 109     -FB 109              TEST INPUT/OUTPUT
0008 NAME  :PERIPHE.
0009       :SPA FB 150     -FB 150              INSTALL COUNTER 1
000A NAME  :PARA.Z1
000B       :SPA FB 121     -FB 121              RESET INTERRUPT
000C NAME  :RESET-I
000D       :SPA FB 144                          INSTALL COUNTER 2
000E NAME  :PARA.Z2
000F       :
0010       :BEA
0011       :
0012       :SPA FB 144                          FB141 INSTALL COUNTER 2
0013 NAME  :PARA.Z2
0014       :***

FB 113    = FB 113                  DATA TRANSFER SINEC-L1
FB 110    = FB 110                  RESET FLAGS
FB 109    = FB 109                  TEST PERIPHERIE
FB 150    = FB 150                  COUNTER 1 : INSTALL
FB 121    = FB 121                  COUNTER 1 : RESET INTERRUPT

NETZWERK 3          0015
0015       :AWL
0016       :BE
```

```
M   14.3 = M  14.3                    IMPULSE READ COUNTER 2
M   15.1 = M  15.1                    SET DEMEND LENGTH
M   15.4 = M  15.4                    TIME DEMAND LENGTH
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF

NETZWERK 6          0025      WAIT FOR DEMAND LENGTH
            -T   1
             +-----+
 -M  15.1 --!T!-!0!
 KT 010.0 --!TW DU!-
            !   DE!-
            !     !   +------+
          --!R   Q!-+-! =    ! -M  15.4
            +-----+   +------+

M   15.1 = M  15.1                    SET DEMEND LENGTH
T    1   = T   1                      WAIT FOR DEMAND LENGTH
M   15.4 = M  15.4                    TIME DEMAND LENGTH

NETZWERK 7          002F      IMPULSE DEMAND LENGTH
002F       :U   M   15.4  -M  15.4
0030       :UN  M   15.2  -M  15.2
0031       :=   M   15.3  -M  15.3
0032       :U   M   15.4  -M  15.4
0033       :=   M   15.2  -M  15.2
0034       :
0035       :U   M   15.3  -M  15.3
0036       :SPA FB 142    -FB 142          READ COUNTER 2
0037 NAME  :READ-Z2
0038       :U   M   15.3  -M  15.3
0039       :SPB FB 125    -FB 125          DETERMINE TREAD LENGTH
003A NAME  :T.LENGTH
003B       :U   M   15.3  -M  15.3
003C       :SPB FB 140    -FB 140          RESET, LOAD AND START COUNTER 2
003D NAME  :RESET Z2
003E       :U   M   15.3  -M  15.3
003F       :SPB FB  30    -FB  30          TREAD IN TOLERANCE
0040 NAME  :TOLERANZ
0041       :***

M   15.4 = M  15.4                    TIME DEMAND LENGTH
M   15.2 = M  15.2                    HF DEMEND LENGTH
M   15.3 = M  15.3                    IMPULSE DEMAND LENGTH

FB 142   = FB 142                     COUNTER 2 : READ
FB 125   = FB 125                     DEMAND TREAD LENGTH
FB 140   = FB 140                     COUNTER 2 : LOAD + START
FB  30   = FB  30                     CALCULATION : TREAD IN TOLERANCE

NETZWERK 8          0042      TREAD IS PASSING LMD
                      -M  15.6
                       +-----+
            -M  20.6 --!S    !
              +---+    !     !
 -M   4.0 --O!>=1!     !     !
 -M  20.2 ---!   !     !     !
 -M  20.3 ---!   !-----!R   Q!-
             +---+     +-----+

M   20.6 = M  20.6                    IMPULSE RESET DISPLAY LENGTH MEAS.DEVICE
M   15.6 = M  15.6                    TREAD IS PASSING LENGTH MEASURING DEVICE
M    4.0 = M   4.0                    LINE ON (135U)
M   20.2 = M  20.2                    TREAD UNDER SCRAP MARKING FAST
M   20.3 = M  20.3                    TREAD UNDER SCRAP MARKING SLOW
```

```
NETZWERK 9          004A      TREAD UNDER SCRAP MARKING FAST
              +---+   -T  18
 -M   2.7 ---! & !    +-----+
 -M  15.6 ---!   !----!T!-!0!
              +---+    !     !
           KT 200.0 --!TW DU!-
                      !   DE!-
                      !     !   +------+
                    --!R   Q!-+-! =    ! -M  20.2
                      +-----+   +------+

M    2.7 = M   2.7                    V-LINE PRESET > V-LINE LIMIT
M   15.6 = M  15.6                    TREAD IS PASSING LENGTH MEASURING DEVICE
T   18   = T  18                      TREAD UNDER SCRAP MARKING FAST
M   20.2 = M  20.2                    TREAD UNDER SCRAP MARKING FAST

NETZWERK 10         0055      TREAD UNDER SCRAP MARKING SLOW
              +---+   -T  19
 -M   2.7 --O! & !    +-----+
 -M  15.6 ---!   !----!T!-!0!
              +---+    !     !
           KT 400.0 --!TW DU!-
                      !   DE!-
                      !     !   +------+
                    --!R   Q!-+-! =    ! -M  20.3
                      +-----+   +------+

M    2.7 = M   2.7                    V-LINE PRESET > V-LINE LIMIT
M   15.6 = M  15.6                    TREAD IS PASSING LENGTH MEASURING DEVICE
T   19   = T  19                      TREAD UNDER SCRAP MARKING SLOW
M   20.3 = M  20.3                    TREAD UNDER SCRAP MARKING SLOW

NETZWERK 11         0060      SV SCRAP MARKING
0060      :O   M   20.2  -M  20.2
0061      :O   M   20.3  -M  20.3
0062      :U   M   15.5  -M  15.5
0063      :S   A    4.0  -A  4.0                SV SCRAP MARKING
0064      :
0065      :U   A    4.0  -A  4.0
0066      :L   KT 100.0
0068      :SE  T   20    -T  20
0069      :
006A      :O   T   20    -T  20
006B      :ON  M    4.0  -M   4.0
006C      :R   A    4.0  -A  4.0
006D      :***

M   20.2 = M  20.2                    TREAD UNDER SCRAP MARKING FAST
M   20.3 = M  20.3                    TREAD UNDER SCRAP MARKING SLOW
M   15.5 = M  15.5                    SCRAP DETECTED
A    4.0 = A  4.0                     SCRAP MARKING 2
T   20   = T  20                      RESET SCRAP MARKING
M    4.0 = M   4.0                    LINE ON (135U)

NETZWERK 12         006E      COUNTER 1 FOR SCRAP
006E      :A   DB  30    -DB  30
006F      :U   M    4.0  -M   4.0
0070      :U   M   15.5  -M  15.5
0071      :ZV  Z    5    -Z   5
0072      :U   M   14.7  -M  14.7
0073      :R   Z    5    -Z   5
0074      :L   Z    5    -Z   5
0075      :T   DW  88
0076      :***

M    4.0 = M   4.0                    LINE ON (135U)
M   15.5 = M  15.5                    SCRAP DETECTED
Z    5   = Z   5                      LENGTH MEASURING DEVICE SCRAP 0-899
M   14.7 = M  14.7                    RESET PRODUCTION REPORT

DB  30   = DB  30                     CALCULATION DATA

NETZWERK 13         0077      COUNTER 1 FOR SCRAP = 900 ?
0077      :A   DB  30    -DB  30
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                     !
!ELASTOMERTECHNIK          WERK HARBURG !  SKIVER                             !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                     !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                   PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                     3!
+-----------------------------------------------------------------------------+
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                              HIGH-CONTROL TRIGGERED ?                       *
*                                                                             *
*******************************************************************************
0000       :U   M   11.5  -M  11.5              WIND-UP ON
0001       :BEB
0002       :***

M   11.5 = M  11.5                        WIND-UP START

NETZWERK 2          0003       HIGH-CONTROL TRIGGERED ?
                      -M   5.5
                       +------+
            -26S6     --!S     !
              +---+     !      !
 -M  17.2 ---!>=1!     !      !
 -M   6.7 ---!   !-----!R    Q!-
              +---+     +------+

E    1.5 = 26S6                           HIGH-CONTROL  60 MM (NO CUT)
M    5.5 = M   5.5                        HIGH-CONTROL TRIGGERED
M   17.2 = M  17.2                        CUT UNUSABLE TREAD
M    6.7 = M   6.7                        FAULT : TREAD SKIVER OFF

NETZWERK 3          000A       IMPULSE HIGH-CONTROL TRIGGERED

                                  -FB 202
                                   +--------------+
                                   !   P.FLANKE   !
                        -M   5.5 --!SIGN      MFL !-- -M  17.4
                                   !           MIM !-- -M  17.0
                                   +--------------+

M    5.5 = M   5.5                        HIGH-CONTROL TRIGGERED
M   17.4 = M  17.4                        HF HIGH-CONTROL TRIGGERED
M   17.0 = M  17.0                        IMPULSE HIGH-CONTROL TRIGGERED

FB 202   = FB 202                         POSITIVE FLANK

NETZWERK 4          0010       CALCULATION HIGH-CONTROL
              +---+    +------+
 -M   5.5 ---! & !--+-! SPB  ! -PB  9
              +---+    +------+

M    5.5 = M   5.5                        HIGH-CONTROL TRIGGERED

PB   9   = PB  9                          HIGH-CONTROL 60MM

NETZWERK 5          0013
              +---+    +------+
 -M   5.5 --O! & !--+-! R    ! -M  17.2
              +---+  ! +------+
                     ! +------+
                     +-! R    ! -M  12.5
                     ! +------+
                     ! +------+
                     +-! R    ! -M   5.7
                       +------+

M    5.5 = M   5.5                        HIGH-CONTROL TRIGGERED
M   17.2 = M  17.2                        CUT UNUSABLE TREAD
M   12.5 = M  12.5                        UNUSABLE TREAD
M    5.7 = M   5.7                        UNUSABLE STRIP AND NO HIGH-CONTROL

NETZWERK 6          0018
0018       :AWL
0019       :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                    LENGHT MEASURING DEVICE AND SCRAP MARKING                *
*                                                                             *
*******************************************************************************
0000      :***

NETZWERK 2          0001      CHOICE WIND-UP
0001      :U   M    7.4  -M   7.4
0002      :UN  M   14.0  -M  14.0
0003      :=   M   14.1  -M  14.1
0004      :U   M    7.4  -M   7.4
0005      :=   M   14.0  -M  14.0
0006      :U   M   14.1  -M  14.1
0007      :SPB FB 140    -FB 140
0008 NAME :RESET Z2
0009      :U   M    7.4  -M   7.4
000A      :BEB
000B      :***

M    7.4 = M   7.4                  WIND-UP (135U)
M   14.0 = M  14.0                  HF WIND-UP
M   14.1 = M  14.1                  IMPULSE WIND-UP

FB 140   = FB 140                   COUNTER 2 : LOAD + START

NETZWERK 3          000C      RESET DISPLAY LENGTH MEAS.DEVICE
000C      :U   E    1.0  -21A1.1
000D      :UN  M   20.5  -M  20.5
000E      :=   M   20.6  -M  20.6
000F      :U   E    1.0  -21A1.1
0010      :=   M   20.5  -M  20.5
0011      :U   M   20.6  -M  20.6
0012      :SPB FB  12    -FB  12
0013 NAME :TRANSFER
0014 EING :    DW  18
0015 AUSG :    DW 128
0016 DB   :    DB  30    -DB  30
0017      :***

E    1.0 = 21A1.1                   LENGTH MEASURING DEVICE VERTICAL
M   20.5 = M  20.5                  HF RESET DISPLAY LENGTH MEASURING DEVICE
M   20.6 = M  20.6                  IMPULSE RESET DISPLAY LENGTH MEAS.DEVICE

DB  30   = DB  30                   CALCULATION DATA

FB  12   = FB  12                   TRANSFER 1 WORD

NETZWERK 4          0018      IMPULSE READ COUNTER 2
0018      :UN  E    1.0  -21A1.1
0019      :UN  M   14.2  -M  14.2
001A      :=   M   14.3  -M  14.3
001B      :UN  E    1.0  -21A1.1
001C      :=   M   14.2  -M  14.2
001D      :***

E    1.0 = 21A1.1                   LENGTH MEASURING DEVICE VERTICAL
M   14.2 = M  14.2                  HF READ COUNTER 2
M   14.3 = M  14.3                  IMPULSE READ COUNTER 2

NETZWERK 5          001E      DEMAND LENGTH
                      -M  15.1
                       +-----+
            -M  14.3 --!S    !
              +---+    !     !
 -M  15.4 ---!>=1!     !     !
 -M   6.7 ---!   !-----!R   Q!-
              +---+    +-----+
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                HIGH-CONTROL 60mm                            *
*                                                                             *
*******************************************************************************
0000       :U   M   11.5  -M  11.5              WIND-UP ON
0001       :BEB
0002       :***

M   11.5 = M  11.5                    WIND-UP START

NETZWERK 2          0003       CALCULATION USABLE TREAD
0003       :U   M   17.0  -M  17.0
0004       :SPB FB  39    -FB  39
0005 NAME :USABLE S
0006       :***

M   17.0 = M  17.0                    IMPULSE HIGH-CONTROL TRIGGERED

FB  39   = FB  39                     CALCULATION USABLE TREAD (HIGH-CONTROL)

NETZWERK 3          0007       USABLE TREAD LENGHT
            -M  12.1
             +-----+
 -M  12.4 --!S     !
            !      !   +------+
 -M   1.7 --!R    Q!-+-! R    ! -M  12.4
            +-----+   +------+

M   12.4 = M  12.4                    USABLE STRIP
M   12.1 = M  12.1                    USABLE TREAD
M    1.7 = M   1.7                    CUTTING CICLE END

NETZWERK 4          000E       UNUSABLE TREAD LENGHT
            -M  12.5
             +-----+
 -M  12.1 -O!S     !
            !      !
 -M  17.2 --!R    Q!-
            +-----+

M   12.1 = M  12.1                    USABLE TREAD
M   12.5 = M  12.5                    UNUSABLE TREAD
M   17.2 = M  17.2                    CUT UNUSABLE TREAD

NETZWERK 5          0014       HIGH-CONTROL OFF
              +---+
 -M  12.5 ---! & !    +------+
 -26S6     --O!   !--+-! =    ! -M   5.7
              +---+   +------+

M   12.5 = M  12.5                    UNUSABLE TREAD
E    1.5 = 26S6                       HIGH-CONTROL  60 MM (NO CUT)
M    5.7 = M   5.7                    UNUSABLE STRIP AND NO HIGH-CONTROL

NETZWERK 6          0018       IMPULSE UNUSABLE TREAD LENGTH

                             -FB 202
                              +--------------+
                              !   P.FLANKE   !
                    -M   5.7 --!SIGN      MFL !-- -M  17.3
                              !           MIM !-- -M  17.1
                              +--------------+

M    5.7 = M   5.7                    UNUSABLE STRIP AND NO HIGH-CONTROL
M   17.3 = M  17.3                    HF UNUSABLE TREAD LENGTH
M   17.1 = M  17.1                    IMPULSE UNUSABLE TREAD LENGTH

FB 202   = FB 202                     POSITIVE FLANK

NETZWERK 7          001E       UNUSABLE TREAD LENGHT
001E       :U   M   17.1  -M  17.1
```

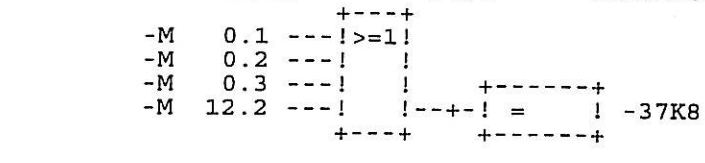
```
001F       :SPB FB  10     -FB  10
0020 NAME  :ADD
0021 ADD1  :     DW  39                          MH + SZ
0022 ADD2  :     DW  22                          Si
0023 ADD3  :     DW  34                          MH + SZ + Si
0024 DB    :     DB  30     -DB  30
0025       :***

M   17.1 = M  17.1                    IMPULSE UNUSABLE TREAD LENGTH

DB  30   = DB  30                     CALCULATION DATA

FB  10   = FB  10                     ADD

NETZWERK 8           0026        TRANSFER TREAD LENGHT
0026       :U   M    5.7   -M   5.7
0027       :SPB FB  12     -FB  12
0028 NAME  :TRANSFER
0029 EING  :     DW  34                          MH + SZ + Si
002A AUSG  :     DW  10                          So (AUTOMATIC)
002B DB    :     DB  30     -DB  30
002C       :***

M    5.7 = M   5.7                    UNUSABLE STRIP AND NO HIGH-CONTROL

DB  30   = DB  30                     CALCULATION DATA

FB  12   = FB  12                     TRANSFER 1 WORD

NETZWERK 9           002D        UNUSABLE TREAD CUTTING
                +---+
 -M  12.5 ---! & !    +------+
 -M   1.5 ---!   !--+-! S    ! -M  17.2
                +---+  +------+

M   12.5 = M  12.5                    UNUSABLE TREAD
M    1.5 = M   1.5                    CUTTING CICLE STEP 5
M   17.2 = M  17.2                    CUT UNUSABLE TREAD

NETZWERK 10          0031        UNUSABLE TREAD CUTTING
0031       :U   E    1.5   -26S6
0032       :U   M   12.5   -M  12.5
0033       :SPB FB  11     -FB  11
0034 NAME  :SUBTRA
0035 SUB1  :     DW  30                          So (PROFILE MANAGEMENT)
0036 SUB2  :     DW  19                          KONSTANT = 10 IMPULSE
0037 SUB3  :     DW  10                          So
0038 DB    :     DB  30     -DB  30
0039       :***

E    1.5 = 26S6                       HIGH-CONTROL  60 MM (NO CUT)
M   12.5 = M  12.5                    UNUSABLE TREAD

DB  30   = DB  30                     CALCULATION DATA

FB  11   = FB  11                     SUB

NETZWERK 11          003A
003A       :BE
```

```
M    2.3 = M   2.3                    CONVEYOR AUTOMATIC
M   11.3 = M  11.3                    HF CONVEYOR AUTOMATIC
M   11.2 = M  11.2                    IMPULSE CONVEYOR AUTOMATIC

FB 202   = FB 202                     POSITIVE FLANK

NETZWERK 21          00BC
00BC       :U   M   12.2  -M  12.2
00BD       :U   M   16.1  -M  16.1
00BE       :SPB FB  12    -FB  12
00BF NAME  :TRANSFER
00C0 EING  :    DW   7
00C1 AUSG  :    DW   3
00C2 DB    :    DB  30    -DB  30
00C3       :***

M   12.2 = M  12.2                    CONVEYOR ON WIND-UP
M   16.1 = M  16.1                    STRIP IN BOTTOM SECTION

DB  30   = DB  30                     CALCULATION DATA

FB  12   = FB  12                     TRANSFER 1 WORD

NETZWERK 22          00C4
00C4       :A   DB  30    -DB  30
00C5       :UN  M    2.1  -M   2.1
00C6       :UN  M    2.2  -M   2.2
00C7       :UN  M    2.3  -M   2.3
00C8       :UN  M   12.2  -M  12.2
00C9       :
00CA       :SPB FB  12    -FB  12
00CB NAME  :TRANSFER
00CC EING  :    DW  18
00CD AUSG  :    DW   3
00CE DB    :    DB  30    -DB  30
00CF       :***

M    2.1 = M   2.1                    CONVEYOR BELT MANUAL
M    2.2 = M   2.2                    CONVEYOR SEMI-AUTOMATIC
M    2.3 = M   2.3                    CONVEYOR AUTOMATIC
M   12.2 = M  12.2                    CONVEYOR ON WIND-UP

DB  30   = DB  30                     CALCULATION DATA

FB  12   = FB  12                     TRANSFER 1 WORD

NETZWERK 23          00D0

                                 -FB 250 S
                                  +--------------+
                                  !   RLG:AE     !
                     +128      --!BG        XA  !-- DW 4
                     0,5       --!KNKT      FB  !-- M 200.0
                     +850      --!OGR       BU  !-- M 200.1
                     -850      --!UGR       TBIT!-- M 200.2
                     -M  99.0  --!EINZ          !
                                  +--------------+

M   99.0 = M  99.0                    "0"-SIGNAL

FB 250   = FB 250 S                   ANALOG-INPUT

NETZWERK 24          00DC
00DC       :U   M    2.3  -M   2.3
00DD       :BEB
00DE       :SPA FB 251    -FB 251 S
00DF NAME  :RLG:AA
00E0 XE    :    DW   3
00E1 BG    :    KF +128
00E2 KNKT  :    KY 0,1
00E3 OGR   :    KF +10000
00E4 UGR   :    KF -10000
00E5 FEH   :    M  200.0
00E6 BU    :    M  200.0
+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                    !
!ELASTOMERTECHNIK          WERK HARBURG !  SKIVER                            !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                    !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                    6!
+-----------------------------------------------------------------------------+
```

```
PB 8     -PB  8                          C:SKIV06ST.S5D        BIB=28023   LAE=238

00E7       :***

M     2.3 = M   2.3                      CONVEYOR AUTOMATIC

FB 251    = FB 251 S                     ANALOG-OUTPUT

NETZWERK 25          00E8
00E8       :BE
```

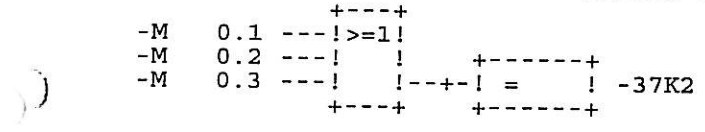
```
M     8.5 = M    8.5                    CONVEYOR AUTOMATIC ON
M     2.3 = M    2.3                    CONVEYOR AUTOMATIC
E     3.5 = 28S5.2                      AUTOMATIC            (CONTROL PANEL)
M     3.0 = M    3.0                    TREAD LENGTH OK
M     6.7 = M    6.7                    FAULT : TREAD SKIVER OFF
M     4.7 = M    4.7                    SWITCH IN AUTOMATIC POSITION
M     8.7 = M    8.7                    IMPULSE LINE OFF
M    11.5 = M   11.5                    WIND-UP START
```

NETZWERK 13 0079 CONVEYOR CREEP



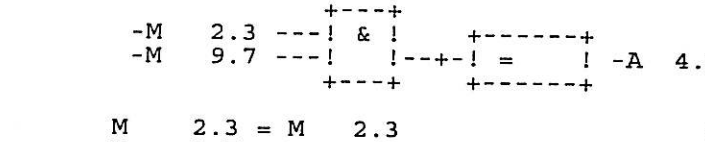

```
M     0.1 = M    0.1                    CUTTING CICLE MANUAL
M     0.2 = M    0.2                    CUTTING CICLE SEMI AUTOMATIC
M     0.3 = M    0.3                    CUTTING CICLE AUTOMATIC
M    12.2 = M   12.2                    CONVEYOR ON WIND-UP
A     4.7 = 37K8                        EXTERNAL FAN
```

NETZWERK 14 0080 RELAIS LIGHT BARRIER ON



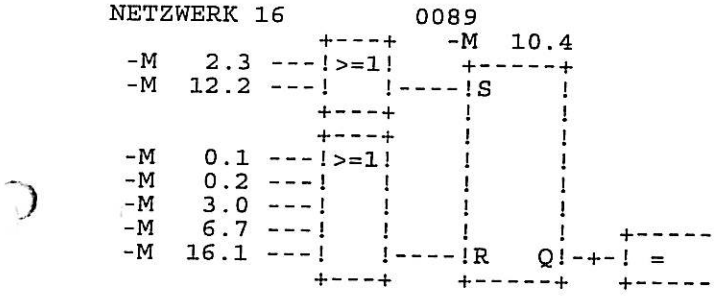

```
M     0.1 = M    0.1                    CUTTING CICLE MANUAL
M     0.2 = M    0.2                    CUTTING CICLE SEMI AUTOMATIC
M     0.3 = M    0.3                    CUTTING CICLE AUTOMATIC
A     4.1 = 37K2                        CONVEYOR BELT : FIELD CONTACTOR
```

NETZWERK 15 0085 CONTROLLER RELEASE



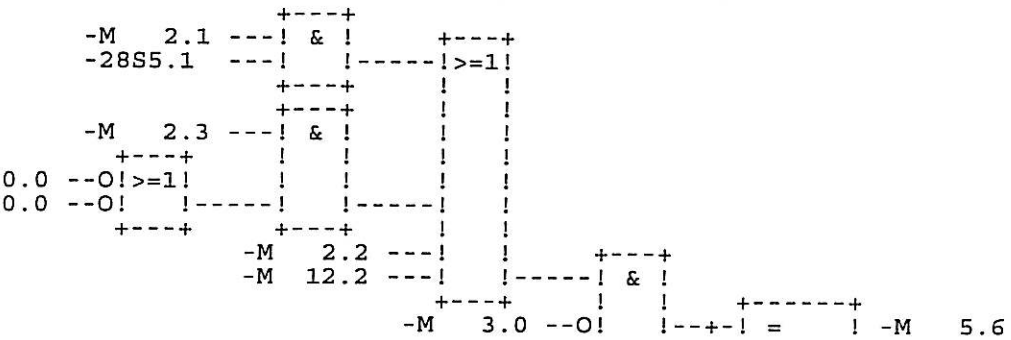

```
M     2.3 = M    2.3                    CONVEYOR AUTOMATIC
M     9.7 = M    9.7                    CREEP WAY REACHED
A     4.2 = A    4.2                    DC-CONVERTER CREEP
```

NETZWERK 16 0089



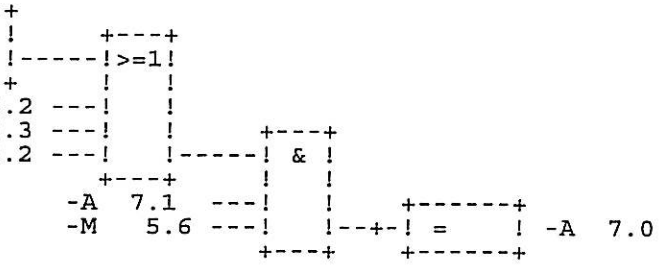

```
M     2.3 = M    2.3                    CONVEYOR AUTOMATIC
M    12.2 = M   12.2                    CONVEYOR ON WIND-UP
M    10.4 = M   10.4                    RELAIS LIGHT BARRIER ON
M     0.1 = M    0.1                    CUTTING CICLE MANUAL
M     0.2 = M    0.2                    CUTTING CICLE SEMI AUTOMATIC
M     3.0 = M    3.0                    TREAD LENGTH OK
M     6.7 = M    6.7                    FAULT : TREAD SKIVER OFF
M    16.1 = M   16.1                    STRIP IN BOTTOM SECTION
A     6.5 = A    6.5                    RELAIS LIGHT BARRIER TO DC-CONVERTER
```

NETZWERK 17 0095 MAX SPEED CONVEYOR WIND-UP



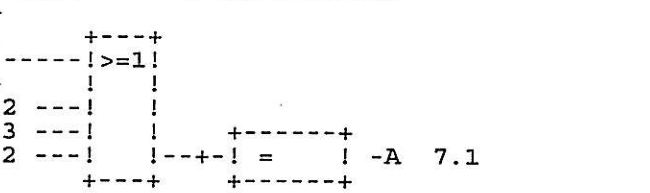
M	2.1 = M	2.1	CONVEYOR BELT MANUAL
E	3.4 = 28S5.1		MANUAL (CONTROL PANEL)
M	2.3 = M	2.3	CONVEYOR AUTOMATIC
M	0.0 = M	0.0	"O"-SIGNAL
M	2.2 = M	2.2	CONVEYOR SEMI-AUTOMATIC
M	12.2 = M	12.2	CONVEYOR ON WIND-UP
M	3.0 = M	3.0	TREAD LENGTH OK
M	5.6 = M	5.6	CONVEYOR OFF

NETZWERK 18 00A4 CONVEYOR SPEED "0"



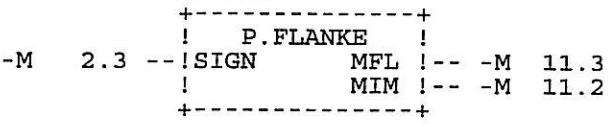
M	2.1 = M	2.1	CONVEYOR BELT MANUAL
E	4.5 = 29S6		ADVANCE ON (CONTROL PANEL)
M	2.2 = M	2.2	CONVEYOR SEMI-AUTOMATIC
M	2.3 = M	2.3	CONVEYOR AUTOMATIC
M	12.2 = M	12.2	CONVEYOR ON WIND-UP
A	7.1 = A	7.1	CONVEYOR BELT : BRAKE OFF
M	5.6 = M	5.6	CONVEYOR OFF
A	7.0 = A	7.0	CONVEYOR BELT : RELEASE

NETZWERK 19 00AF Vreal CONVEYOR



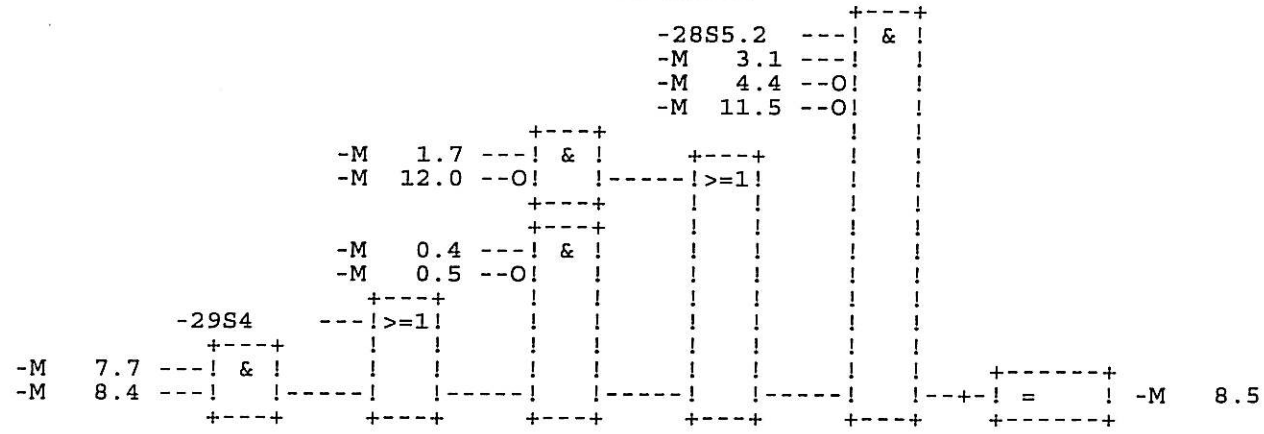
E	4.5 = 29S6		ADVANCE ON (CONTROL PANEL)
M	2.1 = M	2.1	CONVEYOR BELT MANUAL
M	2.2 = M	2.2	CONVEYOR SEMI-AUTOMATIC
M	2.3 = M	2.3	CONVEYOR AUTOMATIC
M	12.2 = M	12.2	CONVEYOR ON WIND-UP
A	7.1 = A	7.1	CONVEYOR BELT : BRAKE OFF

NETZWERK 20 00B6 OUTPUT CONVEYOR SPEED

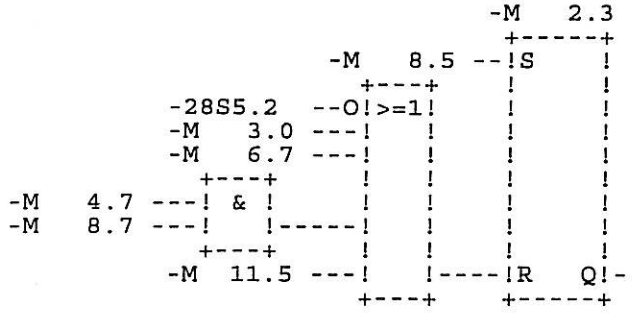


```
M    7.4 = M   7.4                    WIND-UP (135U)
M    0.5 = M   0.5                    CUTTING CICLE START MARK
M    0.6 = M   0.6                    HOME POSITION START MARK
M    4.4 = M   4.4                    SOLENOID VALVE CLAMPING DEVICE DOWN
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
M   11.5 = M  11.5                    WIND-UP START
T   12   = T  12                      RELEASE CONVEYOR MANUAL FORWARD
T   13   = T  13                      RELEASE CONVEYOR MANUAL REVERSE
M    2.1 = M   2.1                    CONVEYOR BELT MANUAL

NETZWERK 6          002E       CONVEYOR MANUAL FORWARD
002E       :U   M    2.1   -M   2.1
002F       :U   T   12     -T  12
0030       :SPB FB  12     -FB  12
0031 NAME  :TRANSFER
0032 EING  :    DW   5                          FP : 3000
0033 AUSG  :    DW   3                          Vconveyor
0034 DB    :    DB  30     -DB  30
0035       :***

M    2.1 = M   2.1                    CONVEYOR BELT MANUAL
T   12   = T  12                      RELEASE CONVEYOR MANUAL FORWARD

DB  30   = DB  30                     CALCULATION DATA

FB  12   = FB  12                     TRANSFER 1 WORD

NETZWERK 7          0036       CONVEYOR MANUAL REVERSE
0036       :U   M    2.1   -M   2.1
0037       :U   T   13     -T  13
0038       :SPB FB  12     -FB  12
0039 NAME  :TRANSFER
003A EING  :    DW   1
003B AUSG  :    DW   3
003C DB    :    DB  30     -DB  30
003D       :***

M    2.1 = M   2.1                    CONVEYOR BELT MANUAL
T   13   = T  13                      RELEASE CONVEYOR MANUAL REVERSE

DB  30   = DB  30                     CALCULATION DATA

FB  12   = FB  12                     TRANSFER 1 WORD

NETZWERK 8          003E       CONVEYOR SEMI-AUTOMATIC
              +---+
 -M   2.1 ---! & !    +------+
 -T  13   ---!   !--+-! =    ! -A  7.2
              +---+    +------+

M    2.1 = M   2.1                    CONVEYOR BELT MANUAL
T   13   = T  13                      RELEASE CONVEYOR MANUAL REVERSE
A    7.2 = A  7.2                     SPARE

NETZWERK 9          0042       CONVEYOR SEMI-AUTOMATIC
              +---+
 -27S1    ---! & !
 -28S5.1  --O!   !
 -28S5.2  --O!   !
 -29S4    ---!   !
 -M   0.4 ---!   !
 -M   0.5 --O!   !
 -M   0.6 --O!   !   -M   2.2
 -M   4.4 --O!   !    +-----+
 -M  11.5 --O!   !----!S    !
             +---+    !     !
             +---+    !     !
 -28S5.1  ---!>=1!    !     !
 -28S5.2  ---!   !    !     !
 -M   3.0 ---!   !    !     !
 -M   6.7 ---!   !----!R   Q!-
             +---+    +-----+
```

```
E    2.0 = 27S1                    KNIFE HOME POSITION
E    3.4 = 28S5.1                  MANUAL              (CONTROL PANEL)
E    3.5 = 28S5.2                  AUTOMATIC           (CONTROL PANEL)
E    4.3 = 29S4                    CUTTING START       (CONTROL PANEL)
M    0.4 = M   0.4                 SKIVER READY TO START
M    0.5 = M   0.5                 CUTTING CICLE START MARK
M    0.6 = M   0.6                 HOME POSITION START MARK
M    4.4 = M   4.4                 SOLENOID VALVE CLAMPING DEVICE DOWN
M   11.5 = M  11.5                 WIND-UP START
M    2.2 = M   2.2                 CONVEYOR SEMI-AUTOMATIC
M    3.0 = M   3.0                 TREAD LENGTH OK
M    6.7 = M   6.7                 FAULT : TREAD SKIVER OFF

NETZWERK 10         0053      CONVEYOR AUTOMATIC ON
0053       :U   M    2.2  -M   2.2
0054       :
0055       :
0056       :
0057       :SPB FB  60    -FB  60
0058 NAME  :V-SEMI
0059       :***

M    2.2 = M   2.2                 CONVEYOR SEMI-AUTOMATIC

FB  60   = FB  60                  SPEED CONVEYOR SEMI-AUTOMATIC

NETZWERK 11         005A      CONVEYOR AUTOMATIC
```




```
E    3.5 = 28S5.2                  AUTOMATIC           (CONTROL PANEL)
M    3.1 = M   3.1                 START CUTTING
M    4.4 = M   4.4                 SOLENOID VALVE CLAMPING DEVICE DOWN
M   11.5 = M  11.5                 WIND-UP START
M    1.7 = M   1.7                 CUTTING CICLE END
M   12.0 = M  12.0                 LINE STOP
M    0.4 = M   0.4                 SKIVER READY TO START
M    0.5 = M   0.5                 CUTTING CICLE START MARK
E    4.3 = 29S4                    CUTTING START       (CONTROL PANEL)
M    7.7 = M   7.7                 BOOKING (135U)
M    8.4 = M   8.4                 IMPULSE LINE ON
M    8.5 = M   8.5                 CONVEYOR AUTOMATIC ON

NETZWERK 12         006D      MAINCONTACTOR DC-CONVERTER ON
```



```
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF

NETZWERK 5          002E      TIMER LIGHT BARRIER
            -T   7
             +-----+
 -E  2.5  --!T!-!0!
 KT 060.2 --!TW DU!-
            !   DE!-
            !     !   +------+
          --!R   Q!-+-! =    ! -M  16.4
            +-----+   +------+

E    2.5 = E  2.5                     LOOP LIGHT BARRIER FILLED
T    7   = T   7                      STRIP IS 60s IN BOTTOM SECTION LIGHT-B.
M   16.4 = M  16.4                    STRIP 60s IN BOTTOM SECTION (LINE off)

NETZWERK 6          0038      LIGHT BARRIER MEASURING SECTION
0038       :L   DW  25                          ANALOG INPUT LIGHT BARRIER
0039       :L   KF +595                         LIGHT BARRIER BOTTOM SECTION
003B       :>=F
003C       :=   M   16.3  -M  16.3
003D       :L   DW  25                          ANALOG INPUT LIGHT BARRIER
003E       :L   KF +5                           LIGHT CURTAIN TOP SECTION
0040       :<=F
0041       :=   M   15.0  -M  15.0
0042       :***

M   16.3 = M  16.3                    LIGHT BARRIER OUT OF SECTION
M   15.0 = M  15.0                    FAULT MATERIAL OUT OF MEASURING SECTION

NETZWERK 7          0043      LIGHT CURTAIN O.K.
            +---+
 -M  16.0 --O! & !    +------+
 -M  16.1 --O!   !--+-! =    ! -M  16.7
            +---+    +------+

M   16.0 = M  16.0                    STRIP IN TOP SECTION
M   16.1 = M  16.1                    STRIP IN BOTTOM SECTION
M   16.7 = M  16.7                    LIGHT BARRIER O.K.

NETZWERK 8          0047      LIGHT CURTAIN NOT O.K.
            +---+
 -M  16.0 ---!>=1!    +------+
 -M  16.1 ---!   !--+-! =    ! -M  16.6
            +---+    +------+

M   16.0 = M  16.0                    STRIP IN TOP SECTION
M   16.1 = M  16.1                    STRIP IN BOTTOM SECTION
M   16.6 = M  16.6                    LIGHT BARRIER NOT O.K.

NETZWERK 9          004B
004B       :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  CONVEYOR BELT                              *
*                                                                             *
*******************************************************************************
0000       :***

NETZWERK 2          0001       IMPULSE KNIFE HOME POSITION
0001       :U   E    2.0   -27S1
0002       :UN  M   14.4   -M  14.4
0003       :=   M   14.5   -M  14.5
0004       :U   E    2.0   -27S1
0005       :=   M   14.4   -M  14.4
0006       :***

E    2.0 = 27S1                     KNIFE HOME POSITION
M   14.4 = M  14.4                  HF KNIFE HOMEPOSITION
M   14.5 = M  14.5                  IMPULSE KNIFE HOMEPOSITION

NETZWERK 3          0007       RELEASE CONVEYOR MANUAL FORWARD
             -T  12
              +-----+
 -E  5.3   -O!T!-!0!
 KT 100.0 --!TW DU!-
              !   DE!-
            --!R   Q!-
              +-----+

E    5.3 = E  5.3                   CONVEYOR REVERSE     (CONTROL PANEL)
T   12   = T  12                   RELEASE CONVEYOR MANUAL FORWARD

NETZWERK 4          0010       RELEASE CONVEYOR MANUAL REVERSE
             -T  13
              +-----+
 -E  5.3   --!T!-!0!
 KT 100.0 --!TW DU!-
              !   DE!-
            --!R   Q!-
              +-----+

E    5.3 = E  5.3                   CONVEYOR REVERSE     (CONTROL PANEL)
T   13   = T  13                   RELEASE CONVEYOR MANUAL REVERSE

NETZWERK 5          0019       CONVEYOR MANUAL MARK
               +---+
 -27S1     ---!>=1!      +---+
 -27S2     ---!   !-----! & !
               +---+     !   !
            -28S5.1  ---!   !
            -29S6    ---!   !
              +---+     !   !
 -M   0.4 ---!>=1!      !   !
 -M   7.4 ---!   !-----!   !
               +---+     !   !
            -M   0.5 --O!   !
            -M   0.6 --O!   !
            -M   4.4 --O!   !
            -M   6.7 --O!   !
            -M  11.5 --O!   !
              +---+     !   !
 -T  12    ---!>=1!     !   !    +------+
 -T  13    ---!   !-----!   !--+-! =    ! -M   2.1
               +---+     +---+    +------+

E    2.0 = 27S1                     KNIFE HOME POSITION
E    2.1 = 27S2                     KNIFE ON HIGH
E    3.4 = 28S5.1                   MANUAL               (CONTROL PANEL)
E    4.5 = 29S6                     ADVANCE ON           (CONTROL PANEL)
M    0.4 = M   0.4                  SKIVER READY TO START
```

```
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
A    5.2 = 38K3                       KNIFE CARRIAGE KNIFE UP  (SV)

NETZWERK 20          0081      WATERSPRAYING ON
                  +---+    +------+
 -M   3.6 ---! & !--+-! =    ! -38K6
                  +---+    +------+

M    3.6 = M   3.6                    SOLENOID VALVE KNIFE LUBRICATION ON/OFF
A    5.5 = 38K6                       KNIFE CARRIAGE WATER SRAYING START (SV)

NETZWERK 21          0084
0084       :BE
```

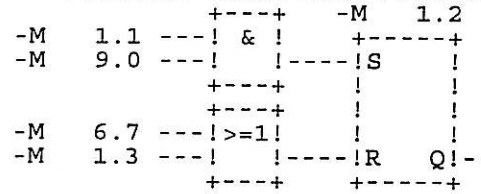
PB 6 -PB 6 C:SKIV06ST.S5D BIB=3122 LAE=81

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                              LIGHT BARRIER                                *
*                                                                           *
*****************************************************************************
0000       :***

NETZWERK 2          0001       ANALOG INPUT LIGHT BARRIER
0001       :A   DB  30     -DB  30
0002       :SPA FB 250     -FB 250 S
0003 NAME  :RLG:AE
0004 BG    :    KF +130
0005 KNKT  :    KY 0,5
0006 OGR   :    KF +12000
0007 UGR   :    KF -12000
0008 EINZ  :    M   99.0   -M  99.0
0009 XA    :    DW  25
000A FB    :    M  200.0
000B BU    :    M  200.0
000C TBIT  :    M  200.0
000D       :***

M   99.0 = M  99.0                    "0"-SIGNAL

DB  30   = DB  30                     CALCULATION DATA

FB 250   = FB 250 S                   ANALOG-INPUT

NETZWERK 3          000E       HYSTERESE
000E       :L   PY   3
000F       :T   EB   3
0010       :L   DW  25                          LIGHT BARRIER
0011       :L   KF +2                           LIGHT BARRIER TOP SECTION
0013       :<=F
0014       :U   E    3.1  -17A1.2               MATERIAL IN LIGHT BARRIER
0015       :S   M   16.0  -M  16.0              STRIP IN TOP SECTION
0016       :L   DW  25                          LIGHT BARRIER
0017       :L   KF +6                           HYSTERESE
0019       :>F
001A       :U   E    3.1  -17A1.2               MATERIAL IN LIGHT BARRIER
001B       :R   M   16.0  -M  16.0              STRIP IS LEAVING TOP SECTION
001C       :L   DW  25                          LIGHT BARRIER
001D       :L   KF +6                           HYSTERESE
001F       :>F
0020       :U   E    3.1  -17A1.2               MATERIAL IN LIGHT BARRIER
0021       :=   M   13.6  -M  13.6
0022       :U   E    2.5  -E  2.5               FOTOEYE LIGHT BARRIER BOTTOM S.
0023       :S   M   16.1  -M  16.1              STRIP IN BOTTOM SECTION
0024       :UN  E    2.5  -E  2.5               FOTOEYE LIGHT BARRIER BOOTOM S.
0025       :R   M   16.1  -M  16.1              STRIP IS LEAVING BOTTOM SECTION
0026       :***

E    3.1 = 17A1.2                     MATERIAL OUTSIDE MEASURING SECTION
M   16.0 = M  16.0                    STRIP IN TOP SECTION
M   13.6 = M  13.6                    MATERIAL IN LIGHT BARRIER
E    2.5 = E  2.5                     LOOP LIGHT BARRIER FILLED
M   16.1 = M  16.1                    STRIP IN BOTTOM SECTION

NETZWERK 4          0027       BOTTOM LIMIT
                      -M  16.2
                       +-----+
           -M  16.1 --!S    !
             +---+    !     !
 -M   6.7 ---!>=1!    !     !
 -M  16.1 --O!   !----!R   Q!-
             +---+    +-----+

M   16.1 = M  16.1                    STRIP IN BOTTOM SECTION
M   16.2 = M  16.2                    STRIP IN BOT.SECTION (LINE creep-speed)
```

```
M    1.0 = M   1.0                    SKIVER IS IN OPERATION
M    4.2 = M   4.2                    START CUTTING CICLE SEMI-AUTOMATIC
M    4.3 = M   4.3                    START CUTTING CICLE AUTOMATIC
M    1.1 = M   1.1                    CUTTING CICLE STEP 1
M    1.2 = M   1.2                    CUTTING CICLE STEP 2
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
```

NETZWERK 6 0020 CUTTING CICLE STEP 2

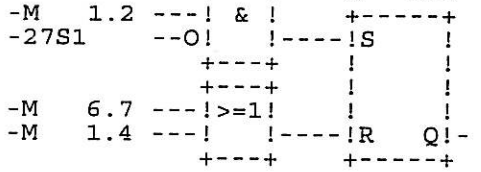
>>> SOLENOID VALVE KNIFE CARRIAGE FORWARD




```
M    1.1 = M   1.1                    CUTTING CICLE STEP 1
M    9.0 = M   9.0                    TIMER CLAMPING DEVICE LOWERING/LIFTUNG
M    1.2 = M   1.2                    CUTTING CICLE STEP 2
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
M    1.3 = M   1.3                    CUTTING CICLE STEP 3
```

NETZWERK 7 0028 CUTTING CICLE STEP 3

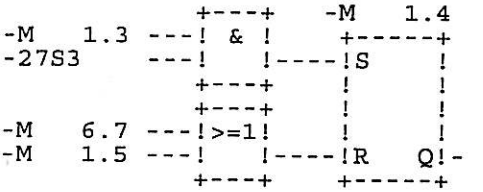
>>> SOLENOID VALVE WATER-SPRAYING ON




```
M    1.2 = M   1.2                    CUTTING CICLE STEP 2
E    2.0 = 27S1                       KNIFE HOME POSITION
M    1.3 = M   1.3                    CUTTING CICLE STEP 3
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
M    1.4 = M   1.4                    CUTTING CICLE STEP 4
```

NETZWERK 8 0030 CUTTING CICLE STEP 4

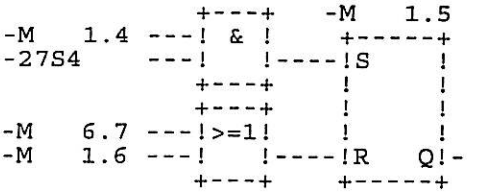
>>> RESET SOLENOID VALVE WATER-SPRAYING ON
>>> RESET SOLENOID VALVE KNIFE CARRIAGE FORWARD




```
M    1.3 = M   1.3                    CUTTING CICLE STEP 3
E    2.2 = 27S3                       WATER OFF
M    1.4 = M   1.4                    CUTTING CICLE STEP 4
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
M    1.5 = M   1.5                    CUTTING CICLE STEP 5
```

NETZWERK 9 0038 CUTTING CICLE STEP 5

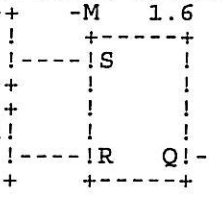
>>> RESET SOLENOID VALVE CLAMPING DEVICE



```
M    1.4 = M   1.4                    CUTTING CICLE STEP 4
E    2.3 = 27S4                       CUT END
M    1.5 = M   1.5                    CUTTING CICLE STEP 5
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
M    1.6 = M   1.6                    CUTTING CICLE STEP 6
```

NETZWERK 10 0040 CUTTING CICLE STEP 6

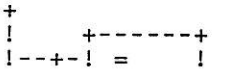
>>> SOLENOID VALVE KNIFE CARRIAGE REVERSE




```
M    1.5 = M   1.5                    CUTTING CICLE STEP 5
E    2.4 = 27S5                       KNIFE RETURNED
M    1.6 = M   1.6                    CUTTING CICLE STEP 6
M    1.7 = M   1.7                    CUTTING CICLE END
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
```

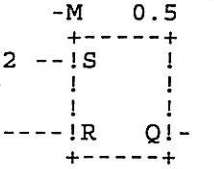
NETZWERK 11 0048 CUTTING CICLE STEP 7

>>> RESET SOLENOID VALVE KNIFE CARRIAGE REVERSE



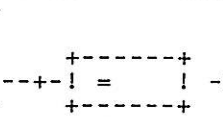

```
M    1.6 = M   1.6                    CUTTING CICLE STEP 6
E    2.1 = 27S2                       KNIFE ON HIGH
M    1.7 = M   1.7                    CUTTING CICLE END
```

NETZWERK 12 004C CUTTING CICLE START MARK



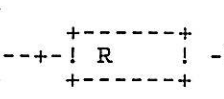

```
M    1.2 = M   1.2                    CUTTING CICLE STEP 2
M    0.5 = M   0.5                    CUTTING CICLE START MARK
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
M    1.7 = M   1.7                    CUTTING CICLE END
```

NETZWERK 13 0053 CUTTING CAR NOT IN NORMAL POS




```
M    0.5 = M   0.5                    CUTTING CICLE START MARK
M    0.6 = M   0.6                    HOME POSITION START MARK
E    2.0 = 27S1                       KNIFE HOME POSITION
M    0.7 = M   0.7                    CUTTING CARRIAGE OUT OF HOME POSITION
```

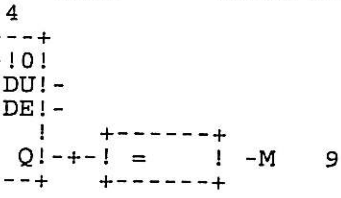
NETZWERK 14 0058 RESET CUT




```
M    1.3 = M   1.3                    CUTTING CICLE STEP 3
M    1.4 = M   1.4                    CUTTING CICLE STEP 4
M    3.0 = M   3.0                    TREAD LENGTH OK
```

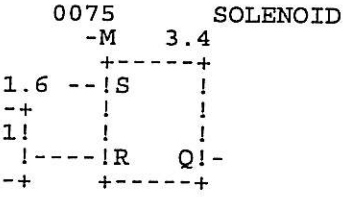
```
M    1.2 = M   1.2                    CUTTING CICLE STEP 2
M    3.3 = M   3.3                    TIMER KNIFE CUTTING
M    1.5 = M   1.5                    CUTTING CICLE STEP 5
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
```

NETZWERK 14 006B TIMER KNIFE IS CUTTING



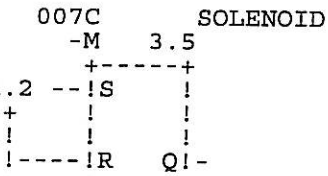

```
M    3.3 = M   3.3                    TIMER KNIFE CUTTING
T    4   = T   4                      KNIFE IS CUTTING
M    9.1 = M   9.1                    TIMER KNIFE IS CUTTING
```

NETZWERK 15 0075 SOLENOID VALVE KNIFE MOVE HOME



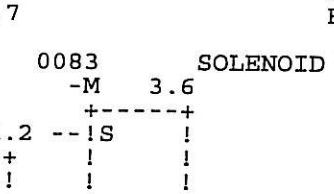

```
M    1.6 = M   1.6                    CUTTING CICLE STEP 6
M    3.4 = M   3.4                    SOLENOID VALVE KNIFE RETURN
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
M    1.7 = M   1.7                    CUTTING CICLE END
```

NETZWERK 16 007C SOLENOID VALVE KNIFE FORWARD



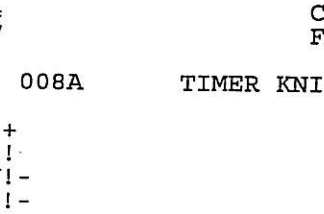

```
M    1.2 = M   1.2                    CUTTING CICLE STEP 2
M    3.5 = M   3.5                    SOLENOID VALVE KNIFE CUTTING
M    1.5 = M   1.5                    CUTTING CICLE STEP 5
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
```

NETZWERK 17 0083 SOLENOID VALVE KNIFE LUBRICATION



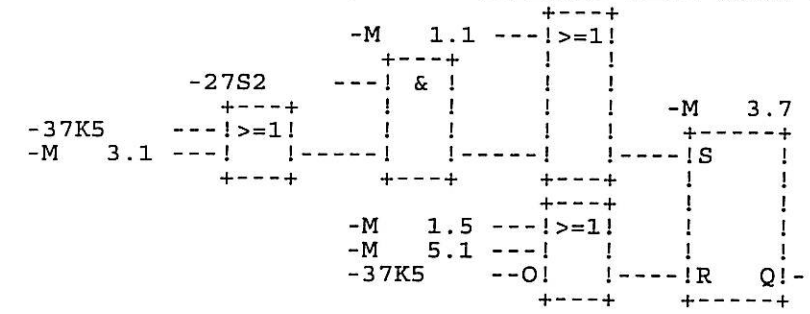

```
M    1.2 = M   1.2                    CUTTING CICLE STEP 2
M    3.6 = M   3.6                    SOLENOID VALVE KNIFE LUBRICATION ON/OFF
M    1.4 = M   1.4                    CUTTING CICLE STEP 4
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
```

NETZWERK 18 008A TIMER KNIFE IS CUTTING



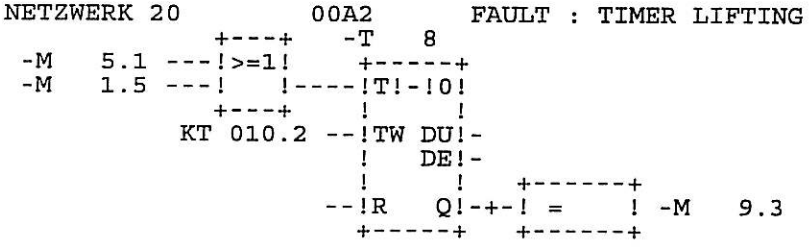
```
M    1.2 = M   1.2                    CUTTING CICLE STEP 2
T    6   = T   6                      KNIFE IS CUTTING
M    9.2 = M   9.2                    TIMER KNIFE IS CUTTING
```

NETZWERK 19 0094 SOLENOID VALVE KNIFE DOWN



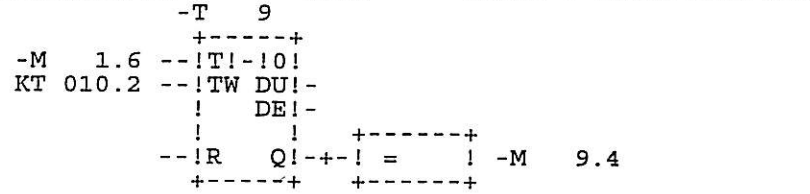

```
M    1.1 = M   1.1                    CUTTING CICLE STEP 1
E    2.1 = 27S2                       KNIFE ON HIGH
A    4.4 = 37K5                       DRIVE MOTOR KNIFE
M    3.1 = M   3.1                    START CUTTING
M    3.7 = M   3.7                    SOLENOID VALVE KNIFE UP/DOWN
M    1.5 = M   1.5                    CUTTING CICLE STEP 5
M    5.1 = M   5.1                    CICLE HOME POSITION STEP 1
```

NETZWERK 20 00A2 FAULT : TIMER LIFTING KNIFE




```
M    5.1 = M   5.1                    CICLE HOME POSITION STEP 1
M    1.5 = M   1.5                    CUTTING CICLE STEP 5
T    8   = T   8                      LIFTING KNIFE
M    9.3 = M   9.3                    TIMER KNIFE LIFTING
```

NETZWERK 21 00AD FAULT : TIMER MOVE KNIFE HOME

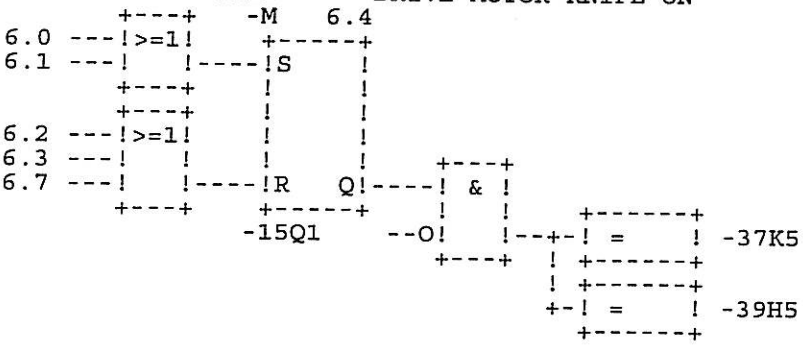



```
M    1.6 = M   1.6                    CUTTING CICLE STEP 6
T    9   = T   9                      MOVE KNIFE HOME
M    9.4 = M   9.4                    TIMER KNIFE MOVE HOME
```

NETZWERK 22 00B7

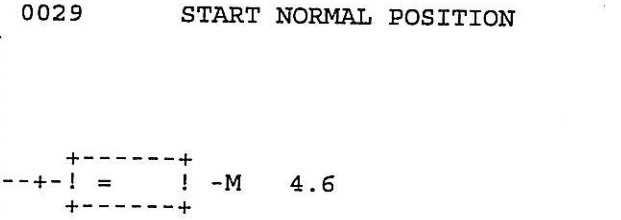
```
00B7      :BE
```

NETZWERK 5 001B DRIVE MOTOR KNIFE ON



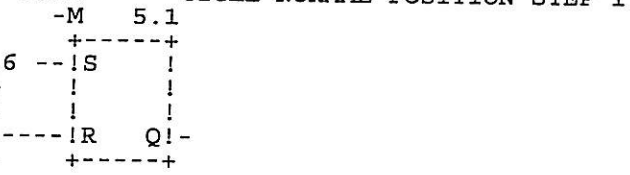
M 6.0 = M 6.0		AUTOMATIC KNIFE ON
M 6.1 = M 6.1		MANUAL AND SEMI-AUTOMATIC KNIFE ON
M 6.4 = M 6.4		KNIFE ON
M 6.2 = M 6.2		AUTOMATIC KNIFE OFF
M 6.3 = M 6.3		MANUAL AND SEMI-AUTOMATIC KNIFE OFF
M 6.7 = M 6.7		FAULT : TREAD SKIVER OFF
E 0.1 = 15Q1		DRIVE MOTOR FAULT KNIFE
A 4.4 = 37K5		DRIVE MOTOR KNIFE
A 6.4 = 39H5		LAMP KNIFE IS OPERATING

NETZWERK 6 0029 START NORMAL POSITION



E 4.2 = 29S3		KNIFE HOME POSITION (CONTROL PANEL)
E 2.0 = 27S1		KNIFE HOME POSITION
A 4.4 = 37K5		DRIVE MOTOR KNIFE
M 0.1 = M 0.1		CUTTING CICLE MANUAL
M 2.6 = M 2.6		AUXILIARY DRIVES ON MESSAGE
M 11.5 = M 11.5		WIND-UP START
M 4.6 = M 4.6		START HOME POSITION

NETZWERK 7 0031 CICLE NORMAL POSITION STEP 1

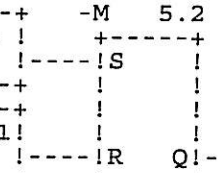


M 4.6 = M 4.6		START HOME POSITION
M 5.1 = M 5.1		CICLE HOME POSITION STEP 1
M 6.7 = M 6.7		FAULT : TREAD SKIVER OFF
E 2.1 = 27S2		KNIFE ON HIGH

NETZWERK 8 0038 CLAMPING DEVICE DOWN

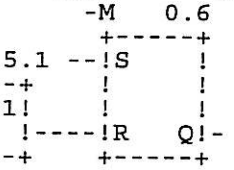
M 5.1 = M 5.1		CICLE HOME POSITION STEP 1
A 5.3 = 38K4		KNIFE CARRIAGE TERMINAL DEVICE UP (SV)
T 2 = T 2		CLAMPING DEVICE DOWN

NETZWERK 9 0042 CICLE NORMAL POSITION STEP 2



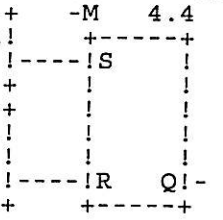
M	5.1 = M	5.1	CICLE HOME POSITION STEP 1
T	2 = T	2	CLAMPING DEVICE DOWN
M	5.2 = M	5.2	CICLE HOME POSITION STEP 2
M	6.7 = M	6.7	FAULT : TREAD SKIVER OFF
E	2.0 = 27S1		KNIFE HOME POSITION

NETZWERK 10 004A START MARK NORMAL POSITION



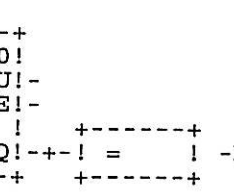
M	5.1 = M	5.1	CICLE HOME POSITION STEP 1
M	0.6 = M	0.6	HOME POSITION START MARK
E	2.1 = 27S2		KNIFE ON HIGH
M	6.7 = M	6.7	FAULT : TREAD SKIVER OFF

NETZWERK 11 0051 SOLENOID VALVE CLAMPING DEVICE



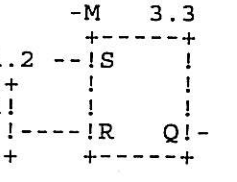
M	1.1 = M	1.1	CUTTING CICLE STEP 1
M	5.1 = M	5.1	CICLE HOME POSITION STEP 1
M	4.4 = M	4.4	SOLENOID VALVE CLAMPING DEVICE DOWN
E	2.1 = 27S2		KNIFE ON HIGH
M	1.5 = M	1.5	CUTTING CICLE STEP 5
M	6.7 = M	6.7	FAULT : TREAD SKIVER OFF

NETZWERK 12 005A TIMER CLAMPING DEVICE UP/DOWN



M	1.1 = M	1.1	CUTTING CICLE STEP 1
T	3 = T	3	CLAMPING DEVICE UP/DOWN
M	9.0 = M	9.0	TIMER CLAMPING DEVICE LOWERING/LIFTUNG

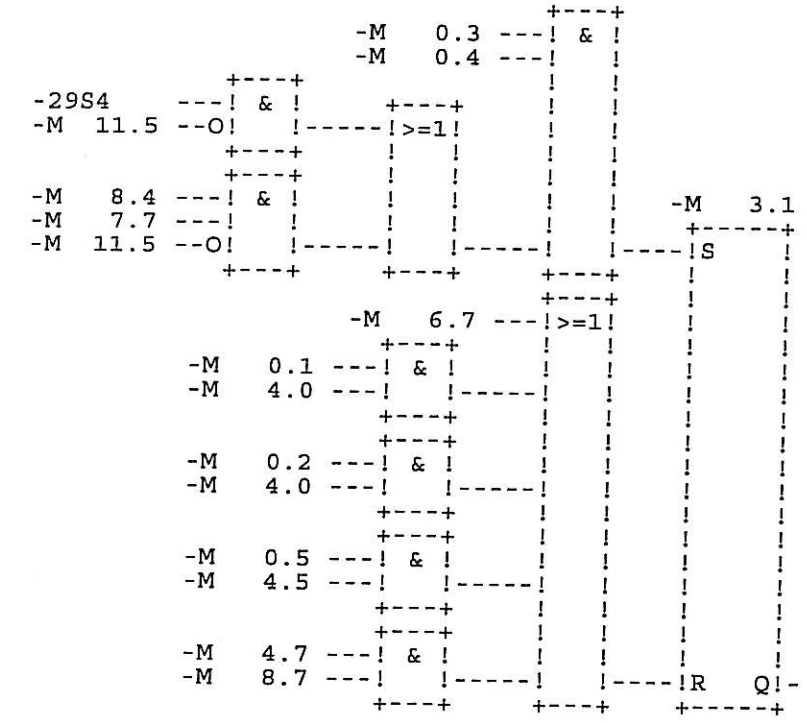
NETZWERK 13 0064 TIMER KNIFE IS CUTTING MARK



```
M    3.1 = M   3.1
M    6.7 = M   6.7
```

START CUTTING
FAULT : TREAD SKIVER OFF

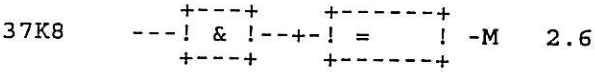
NETZWERK 31 00BE




```
M    0.3 = M   0.3
M    0.4 = M   0.4
E    4.3 = 29S4
M   11.5 = M  11.5
M    8.4 = M   8.4
M    7.7 = M   7.7
M    3.1 = M   3.1
M    6.7 = M   6.7
M    0.1 = M   0.1
M    4.0 = M   4.0
M    0.2 = M   0.2
M    0.5 = M   0.5
M    4.5 = M   4.5
M    4.7 = M   4.7
M    8.7 = M   8.7
```

CUTTING CICLE AUTOMATIC
SKIVER READY TO START
CUTTING START (CONTROL PANEL)
WIND-UP START
IMPULSE LINE ON
BOOKING (135U)
START CUTTING
FAULT : TREAD SKIVER OFF
CUTTING CICLE MANUAL
LINE ON (135U)
CUTTING CICLE SEMI AUTOMATIC
CUTTING CICLE START MARK
CUTTING CICLE AUTOMATIC OFF
SWITCH IN AUTOMATIC POSITION
IMPULSE LINE OFF

NETZWERK 32 00D9



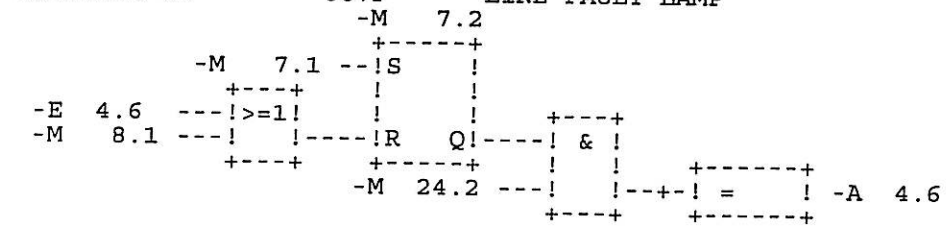

```
A    4.7 = 37K8
M    2.6 = M   2.6
```

EXTERNAL FAN
AUXILIARY DRIVES ON MESSAGE

NETZWERK 33 00DC
00DC :BE

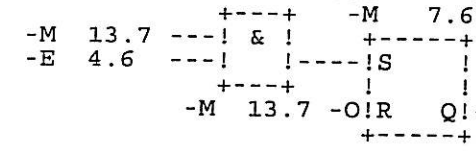
```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                  CICLE NORMAL POSITION AND SOLENOID VALVES                *
*                                                                           *
*****************************************************************************
0000      :***

NETZWERK 2          0001      AUTOMATIC KNIFE ON
                +---+
 -26S4     ---! & !
 -29S1.1   ---!   !
 -M   0.3  ---!   !
 -M   6.7  --O!   !     +------+
 -M  11.5  --O!   !--+-! =    ! -M   6.0
                +---+     +------+

E    1.3 = 26S4                          COMPRESSED AIR SUPPLY
E    4.0 = 29S1.1                        KNIFE ON              (CONTROL PANEL)
M    0.3 = M   0.3                       CUTTING CICLE AUTOMATIC
M    6.7 = M   6.7                       FAULT : TREAD SKIVER OFF
M   11.5 = M  11.5                       WIND-UP START
M    6.0 = M   6.0                       AUTOMATIC KNIFE ON

NETZWERK 3          0008      MANUAL AND SEMI-AUTOM. KNIFE ON
              +---+
 -M   0.1 ---!>=1!      +---+
 -M   0.2 ---!   !------! & !
              +---+      !   !
           -26S4     ---!   !
           -29S1.1   ---!   !     +------+
           -M  11.5  --O!   !--+-! =    ! -M   6.1
                        +---+     +------+

M    0.1 = M   0.1                       CUTTING CICLE MANUAL
M    0.2 = M   0.2                       CUTTING CICLE SEMI AUTOMATIC
E    1.3 = 26S4                          COMPRESSED AIR SUPPLY
E    4.0 = 29S1.1                        KNIFE ON              (CONTROL PANEL)
M   11.5 = M  11.5                       WIND-UP START
M    6.1 = M   6.1                       MANUAL AND SEMI-AUTOMATIC KNIFE ON

NETZWERK 4          0011      MANUAL AND SEMI-AUTOM. KNIFE OFF
              +---+
 -M   0.1 ---!>=1!      +---+
 -M   0.2 ---!   !------! & !
              +---+      !   !
           -27S1     ---!   !
           -29S1.2   --O!   !
           -M   0.5  --O!   !     +------+
           -M  11.5  --O!   !--+-! =    ! -M   6.3
                        +---+     +------+

M    0.1 = M   0.1                       CUTTING CICLE MANUAL
M    0.2 = M   0.2                       CUTTING CICLE SEMI AUTOMATIC
E    2.0 = 27S1                          KNIFE HOME POSITION
E    4.1 = 29S1.2                        KNIFE OFF             (CONTROL PANEL)
M    0.5 = M   0.5                       CUTTING CICLE START MARK
M   11.5 = M  11.5                       WIND-UP START
M    6.3 = M   6.3                       MANUAL AND SEMI-AUTOMATIC KNIFE OFF
```

NETZWERK 24 007F LINE FAULT LAMP



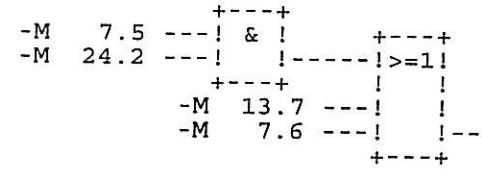
M	7.1 = M 7.1	SPARE
M	7.2 = M 7.2	SPARE
E	4.6 = E 4.6	FAULT ACKNOWLEDGED (MAIN CABINET)
M	8.1 = M 8.1	ACKNOWLEDGING FAULT (135U)
M	24.2 = M 24.2	TACT 1 Hz
A	4.6 = A 4.6	SPARE

NETZWERK 25 0088 KNIFE READY TO START FOR AUTO.



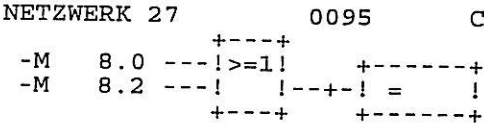
M	13.7 = M 13.7	FAULT SKIVER
E	4.6 = E 4.6	FAULT ACKNOWLEDGED (MAIN CABINET)
M	7.6 = M 7.6	FAULT : ONLY LAMP ON

NETZWERK 26 008F CUTTING MACHINE READY FOR START



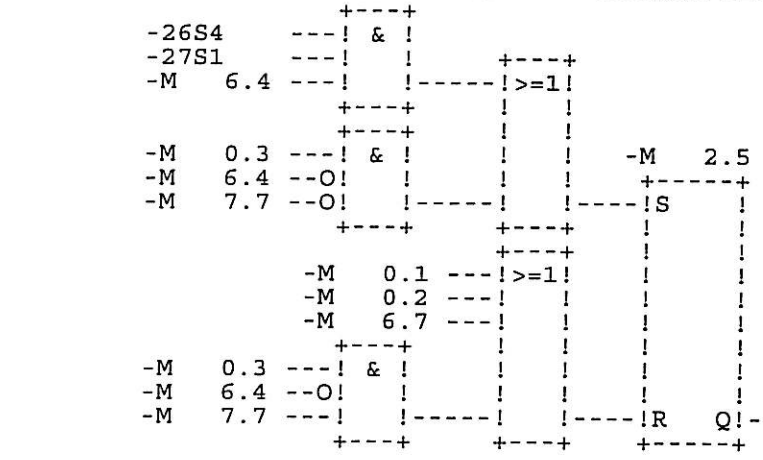
M	7.5 = M 7.5	FAULT : LAMP AND HORN ON
M	24.2 = M 24.2	TACT 1 Hz
M	13.7 = M 13.7	FAULT SKIVER
M	7.6 = M 7.6	FAULT : ONLY LAMP ON
A	6.1 = 39H2	LAMP FAULT SKIVER

NETZWERK 27 0095 CUTTING CICLE AUTOMATIC OFF



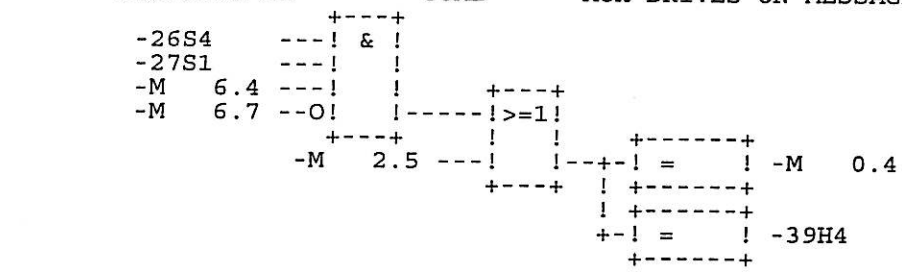
M	8.0 = M 8.0	E-STOP (135U)
M	8.2 = M 8.2	FAULT LINE (135U)
A	6.2 = 39H3	LAMP FAULT LINE

NETZWERK 28 0099 CUTTING CICLE AUTOM. START MARK



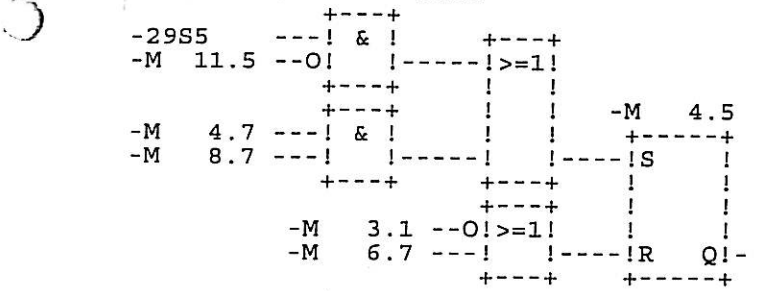
E	1.3 = 26S4		COMPRESSED AIR SUPPLY
E	2.0 = 27S1		KNIFE HOME POSITION
M	6.4 = M	6.4	KNIFE ON
M	0.3 = M	0.3	CUTTING CICLE AUTOMATIC
M	7.7 = M	7.7	BOOKING (135U)
M	2.5 = M	2.5	KNIFE READY TO START FOR AUTOMATIC
M	0.1 = M	0.1	CUTTING CICLE MANUAL
M	0.2 = M	0.2	CUTTING CICLE SEMI AUTOMATIC
M	6.7 = M	6.7	FAULT : TREAD SKIVER OFF

NETZWERK 29 00AB AUX DRIVES ON MESSAGE



E	1.3 = 26S4		COMPRESSED AIR SUPPLY
E	2.0 = 27S1		KNIFE HOME POSITION
M	6.4 = M	6.4	KNIFE ON
M	6.7 = M	6.7	FAULT : TREAD SKIVER OFF
M	2.5 = M	2.5	KNIFE READY TO START FOR AUTOMATIC
M	0.4 = M	0.4	SKIVER READY TO START
A	6.3 = 39H4		LAMP KNIFE READY TO START

NETZWERK 30 00B3



E	4.4 = 29S5		CUTTING STOP (CONTROL PANEL)
M	11.5 = M	11.5	WIND-UP START
M	4.7 = M	4.7	SWITCH IN AUTOMATIC POSITION
M	8.7 = M	8.7	IMPULSE LINE OFF
M	4.5 = M	4.5	CUTTING CICLE AUTOMATIC OFF

```
NETZWERK 13          0042       MIN. FIELD CURRENT
                  +---+
 -12A5     --O! & !
 -37K2     ---!   !     +------+
 -T  21    ---!   !--+-! =    ! -M   2.0
                  +---+     +------+

E     0.0 = 12A5                          MIN FIELD CURRENT
A     4.1 = 37K2                          CONVEYOR BELT : FIELD CONTACTOR
T    21   = T  21                         BY-PASS MIN FIELD CURRENT
M     2.0 = M   2.0                       FAULT DRIVE MOTOR CONVEYOR BELT

NETZWERK 14          0047       COMPRESSED AIR FAULT
                  +---+     +------+
 -26S4     --O! & !--+-! =    ! -M   3.2
                  +---+     +------+

E     1.3 = 26S4                          COMPRESSED AIR SUPPLY
M     3.2 = M   3.2                       FAULT COMPRESSED AIR SUPPLY

NETZWERK 15          004A       FAULT PRESSURE SOFT WATER
                  +---+     +------+
 -E  2.7   --O! & !--+-! =    ! -M  18.4
                  +---+     +------+

E     2.7 = E  2.7                        PRESSURE FAULT SOFT WATER
M    18.4 = M  18.4                       PRESSURE FAULT SOFT WATER

NETZWERK 16          004D       MATERIAL OUT OF MEASURING SECT.
                  +---+     +------+
 -17A1.2   --O! & !--+-! =    ! -M   9.6
                  +---+     +------+

E     3.1 = 17A1.2                        MATERIAL OUTSIDE MEASURING SECTION
M     9.6 = M   9.6                       MATERIAL OUT OF LIGHT BARRIER

NETZWERK 17          0050       FAULT AC-CONTROL VOLTAGE
                  +---+     +------+
 -10F3     --O! & !--+-! =    ! -M   5.4
                  +---+     +------+

E     3.2 = 10F3                          CONTROL FUSE TRIGGERED
M     5.4 = M   5.4                       FAULT AC-CONTROL VOLTAGE

NETZWERK 18          0053       FAULT : TREAD SKIVER OFF
0053        :O   E     0.1   -15Q1
0054        :O   E     0.3   -15Q5
0055        :O   E     0.5   -16Q5
0056        :ON  E     1.3   -26S4
0057        :ON  E     1.6   -26S7
0058        :
0059        :O   E     3.3   -9S1
005A        :O   E     4.7   -A220
005B        :NOP 0
005C        :O   M     9.2   -M    9.2
005D        :O   M     9.3   -M    9.3
005E        :O   M     9.4   -M    9.4
005F        :O   M     6.6   -M    6.6
0060        :=   M    11.0   -M   11.0
0061        :***

E     0.1 = 15Q1                          DRIVE MOTOR FAULT KNIFE
E     0.3 = 15Q5                          DRIVE MOTOR FAULT KNIFE TRANSFER
E     0.5 = 16Q5                          DRIVE MOTOR FAULT EXTERNAL FAN
E     1.3 = 26S4                          COMPRESSED AIR SUPPLY
E     1.6 = 26S7                          HIGH-CONTROL 100 MM (TREAD SKIVER OFF)
E     3.3 = 9S1                           E-STOP SWITCH CABINET
E     4.7 = A220                          E-STOP                (CONTROL PANEL)
M     9.2 = M   9.2                       TIMER KNIFE IS CUTTING
M     9.3 = M   9.3                       TIMER KNIFE LIFTING
M     9.4 = M   9.4                       TIMER KNIFE MOVE HOME
```

```
M    6.6 = M   6.6                    IMPULSE FAULT MESSAGE FROM 135U
M   11.0 = M  11.0                    SPARE
```

```
NETZWERK 19          0062       FAULT TREAD SKIVER OFF
                       -M  13.7
                        +-----+
             -M  11.0 --!S    !
               +---+    !     !
 -E  4.6   ---!>=1!    !     !
 -M   8.1  ---!   !----!R   Q!-
               +---+    +-----+
```

```
M   11.0 = M  11.0                    SPARE
M   13.7 = M  13.7                    FAULT SKIVER
E    4.6 = E  4.6                     FAULT ACKNOWLEDGED  (MAIN CABINET)
M    8.1 = M   8.1                    ACKNOWLEDGING FAULT (135U)
```

```
NETZWERK 20          0069       FAULT : LAMP AND HORN
               +---+
 -M  13.7  ---!>=1!    +------+
 -M  18.5  ---!   !--+-! =    ! -M   6.7
               +---+  ! +------+
                      ! +------+
                      +-! R    ! -M   9.7
                        +------+
```

```
M   13.7 = M  13.7                    FAULT SKIVER
M   18.5 = M  18.5                    IMPULSE E-STOP LINE (135U)
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
M    9.7 = M   9.7                    CREEP WAY REACHED
```

```
NETZWERK 21          006E       FAULT : HORN ON
                       -M   7.5
                        +-----+
             -M  13.7 --!S    !
               +---+    !     !
 -E  4.6   ---!>=1!    !     !
 -M   8.1  ---!   !----!R   Q!-
               +---+    +-----+
```

```
M   13.7 = M  13.7                    FAULT SKIVER
M    7.5 = M   7.5                    FAULT : LAMP AND HORN ON
E    4.6 = E  4.6                     FAULT ACKNOWLEDGED  (MAIN CABINET)
M    8.1 = M   8.1                    ACKNOWLEDGING FAULT (135U)
```

```
NETZWERK 22          0075       FAULT : LAMP
               +---+
 -M   7.2  ---! & !    +------+
 -M  24.2  ---!   !--+-! =    ! M 200.0
               +---+    +------+
```

```
M    7.2 = M   7.2                    SPARE
M   24.2 = M  24.2                    TACT 1 Hz
```

```
NETZWERK 23          0079       FAULT : LAMP ON
0079       :U   M   11.0  -M  11.0
007A       :UN  M    7.0  -M   7.0
007B       :=   M    7.1  -M   7.1
007C       :U   M   11.0  -M  11.0
007D       :=   M    7.0  -M   7.0
007E       :***
```

```
M   11.0 = M  11.0                    SPARE
M    7.0 = M   7.0                    SPARE
M    7.1 = M   7.1                    SPARE
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                              GENERAL SIGNALS                              *
*                                                                           *
*****************************************************************************

0000      :***

NETZWERK 2          0001      "0" AND "1" SIGNAL
             +---+
 -M  99.0 ---!>=1!    +------+
 -M  99.0 --O!   !--+-! S    ! -M  99.1
            +---+  ! +------+
                   ! +------+
                   +-! R    ! -M  99.0
                     +------+

M   99.0 = M  99.0                    "0"-SIGNAL
M   99.1 = M  99.1                    "1"-SIGNAL

NETZWERK 3          0006      MANUAL
            +---+
 -28S5.1  ---! & !
 -28S5.2  --O!  !    +------+
 -M   6.7 --O!  !--+-! =    ! -M   0.1
            +---+    +------+

E    3.4 = 28S5.1                     MANUAL              (CONTROL PANEL)
E    3.5 = 28S5.2                     AUTOMATIC           (CONTROL PANEL)
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
M    0.1 = M   0.1                    CUTTING CICLE MANUAL

NETZWERK 4          000B      SEMI-AUTOMATIC
            +---+
 -28S5.1  --O! & !
 -28S5.2  --O!  !    +------+
 -M   6.7 --O!  !--+-! =    ! -M   0.2
            +---+    +------+

E    3.4 = 28S5.1                     MANUAL              (CONTROL PANEL)
E    3.5 = 28S5.2                     AUTOMATIC           (CONTROL PANEL)
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
M    0.2 = M   0.2                    CUTTING CICLE SEMI AUTOMATIC

NETZWERK 5          0010      AUTOMATIC
            +---+
 -28S5.1  --O! & !
 -28S5.2  ---!  !    +------+
 -M   6.7 --O!  !--+-! =    ! -M   0.3
            +---+    +------+

E    3.4 = 28S5.1                     MANUAL              (CONTROL PANEL)
E    3.5 = 28S5.2                     AUTOMATIC           (CONTROL PANEL)
M    6.7 = M   6.7                    FAULT : TREAD SKIVER OFF
M    0.3 = M   0.3                    CUTTING CICLE AUTOMATIC

NETZWERK 6          0015      SWITCH IN AUTOMATIC
            +---+
 -28S5.1  --O! & !    +------+
 -28S5.2  ---!  !--+-! =    ! -M   4.7
            +---+    +------+

E    3.4 = 28S5.1                     MANUAL              (CONTROL PANEL)
E    3.5 = 28S5.2                     AUTOMATIC           (CONTROL PANEL)
M    4.7 = M   4.7                    SWITCH IN AUTOMATIC POSITION

NETZWERK 7          0019      IMPULSE FAULT LINE (M6.6)
0019      :U   M    8.2  -M   8.2
001A      :UN  M    7.3  -M   7.3
001B      :=   M    6.6  -M   6.6
001C      :U   M    8.2  -M   8.2
001D      :=   M    7.3  -M   7.3
```

```
001E      :***

M    8.2 = M   8.2                    FAULT LINE (135U)
M    7.3 = M   7.3                    HF FAULT LINE
M    6.6 = M   6.6                    IMPULSE FAULT MESSAGE FROM 135U

NETZWERK 8          001F       IMPULSE LINE ON
001F       :U   M    4.0  -M   4.0
0020       :UN  M    8.3  -M   8.3
0021       :=   M    8.4  -M   8.4
0022       :U   M    4.0  -M   4.0
0023       :=   M    8.3  -M   8.3
0024       :***

M    4.0 = M   4.0                    LINE ON (135U)
M    8.3 = M   8.3                    HF LINE ON
M    8.4 = M   8.4                    IMPULSE LINE ON

NETZWERK 9          0025       IMPULSE LINE OFF
0025       :UN  M    4.0  -M   4.0
0026       :UN  M    8.6  -M   8.6
0027       :=   M    8.7  -M   8.7
0028       :UN  M    4.0  -M   4.0
0029       :=   M    8.6  -M   8.6
002A       :***

M    4.0 = M   4.0                    LINE ON (135U)
M    8.6 = M   8.6                    HF LINE OFF
M    8.7 = M   8.7                    IMPULSE LINE OFF

NETZWERK 10         002B       LINE STOP
                +---+    -M  12.0
 -M   4.7 ---! & !    +-----+
 -M   8.7 ---!   !----!S    !
                +---+    !    !
                +---+    !    !
 -M   8.4 ---!>=1!    !    !
 -29S4    ---!   !----!R   Q!-
                +---+    +-----+

M    4.7 = M   4.7                    SWITCH IN AUTOMATIC POSITION
M    8.7 = M   8.7                    IMPULSE LINE OFF
M   12.0 = M  12.0                    LINE STOP
M    8.4 = M   8.4                    IMPULSE LINE ON
E    4.3 = 29S4                       CUTTING START        (CONTROL PANEL)

NETZWERK 11         0033       IMPULSE E-STOP (135U)
0033       :U   M    8.0  -M   8.0
0034       :UN  M   16.5  -M  16.5
0035       :=   M   18.5  -M  18.5
0036       :U   M    8.0  -M   8.0
0037       :=   M   16.5  -M  16.5
0038       :***

M    8.0 = M   8.0                    E-STOP (135U)
M   16.5 = M  16.5                    HF E-STOP LINE (135U)
M   18.5 = M  18.5                    IMPULSE E-STOP LINE (135U)

NETZWERK 12         0039       BY-PASS MIN FIELD CURRENT
           -T  21
            +-----+
 -37K2    --!T!-!0!
 KT 050.0 --!TW DU!-
           !   DE!-
          --!R   Q!-
            +-----+

A    4.1 = 37K2                       CONVEYOR BELT : FIELD CONTACTOR
T   21   = T  21                      BY-PASS MIN FIELD CURRENT
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                    TACT                                     *
*                                                                             *
*******************************************************************************
0000      :***

NETZWERK 2          0001      TACT 1 HZ
0001      :UN  M   24.0  -M  24.0
0002      :L   KT 050.0
0004      :SE  T   10    -T  10
0005      :U   T   10    -T  10
0006      :=   M   24.0  -M  24.0
0007      :U   M   24.0  -M  24.0
0008      :UN  M   24.1  -M  24.1
0009      :S   M   24.2  -M  24.2
000A      :U   M   24.0  -M  24.0
000B      :U   M   24.1  -M  24.1
000C      :R   M   24.2  -M  24.2
000D      :UN  M   24.0  -M  24.0
000E      :U   M   24.2  -M  24.2
000F      :S   M   24.1  -M  24.1
0010      :UN  M   24.0  -M  24.0
0011      :UN  M   24.2  -M  24.2
0012      :R   M   24.1  -M  24.1
0013      :***

M   24.0 = M  24.0                  HF TACT 1 Hz
T   10   = T  10                    TIMER FOR TACT 1 Hz
M   24.1 = M  24.1                  HF TACT 1 Hz
M   24.2 = M  24.2                  TACT 1 Hz

NETZWERK 3          0014      TACT 2 HZ
0014      :UN  M   24.4  -M  24.4
0015      :L   KT 025.0
0017      :SE  T   11    -T  11
0018      :U   T   11    -T  11
0019      :=   M   24.4  -M  24.4
001A      :U   M   24.4  -M  24.4
001B      :UN  M   24.5  -M  24.5
001C      :S   M   24.3  -M  24.3
001D      :U   M   24.4  -M  24.4
001E      :U   M   24.5  -M  24.5
001F      :R   M   24.3  -M  24.3
0020      :UN  M   24.4  -M  24.4
0021      :U   M   24.3  -M  24.3
0022      :S   M   24.5  -M  24.5
0023      :UN  M   24.4  -M  24.4
0024      :UN  M   24.3  -M  24.3
0025      :R   M   24.5  -M  24.5
0026      :***

M   24.4 = M  24.4                  HF TACT 2 Hz
T   11   = T  11                    TIMER FOR TACT 2 Hz
M   24.5 = M  24.5                  HF TACT 2 Hz
M   24.3 = M  24.3                  TACT 2 Hz

NETZWERK 4          0027
0027      :BE
```

```
NETZWERK 1          0000
0000       :AWL
0001       :A    DB  12
0002       :SPA FB  15     -FB  15 S
0003 NAME  :GP:FPGP
0004 Z12   :     DW   3
0005 Z11   :     DW   4
0006 Z22   :     DW   6
0007 Z21   :     DW   7
0008       :SPA FB  15     -FB  15 S
0009 NAME  :GP:FPGP
000A Z12   :     DW   3
000B Z11   :     DW   5
000C Z22   :     DW   8
000D Z21   :     DW  22
000E       :SPA FB  20     -FB  20 S
000F NAME  :GP:DIV
0010 Z12   :     DW   6
0011 Z11   :     DW   7
0012 Z22   :     DW   8
0013 Z21   :     DW  22
0014 OV    :     M  200.0
0015 FEH   :     M  200.1
0016 Z3=0  :     M  200.2
0017 Z32   :     DW  20
0018 Z31   :     DW  21
0019       :L    DW  20
001A       :A    DB  30     -DB  30
001B       :T    DW 123
001C       :A    DB  12
001D       :L    DW  21
001E       :A    DB  30     -DB  30
001F       :T    DW 124
0020       :***


DB  30   = DB  30                    CALCULATION DATA

FB  15   = FB  15 S                  FIXED-POINT NUMBER --> FLOATING-POINT N.
FB  20   = FB  20 S                  DIVIDE TWO FLOATING-POINT NUMBERS

NETZWERK 2          0021
0021       :BE
```

```
NETZWERK 1          0000
NAME :RLG:AA
BEZ  :XE          E/A/D/B/T/Z: E  BI/BY/W/D: W
BEZ  :BG          E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :KNKT        E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :OGR         E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :UGR         E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :FEH         E/A/D/B/T/Z: A  BI/BY/W/D: BI
BEZ  :BU          E/A/D/B/T/Z: A  BI/BY/W/D: BI

001A       :ASM KH 0000
001C       :BE
```

NETZWERK 1 0000

```
*******************************************************************************
*                                                                             *
*                        SINEC-L1 : 115-U AS SLAVE No.1                       *
*                                                                             *
*******************************************************************************
NAME :L1-PG/DA
BEZ  :PGDA      E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :TKBE      E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KC
BEZ  :NKBE      E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :TKBS      E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KC
BEZ  :NKBS      E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :TSF       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KC
BEZ  :NSF       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :TEF       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KC
BEZ  :NEF       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY

0020      :LW  =PGDA                          L1-PG-BUS-/L1-DATABUS-SLAVE-No.
0021      :T   MW 200
0022      :LW  =TKBE
0023      :T   MW 202
0024      :LW  =NKBE
0025      :T   MW 203
0026      :LW  =TKBS
0027      :T   MW 205
0028      :LW  =NKBS
0029      :T   MW 206
002A      :LW  =TSF
002B      :T   MW 208
002C      :LW  =NSF
002D      :T   MW 209
002E      :LW  =TEF
002F      :T   MW 211
0030      :LW  =NEF
0031      :T   MW 212
0032      :L   KH EED5
0034      :L   KH EA7F
0036      :TNB     14
0037      :L   KH 0000
0039      :T   MW 200
003A      :T   MW 202
003B      :T   MW 204
003C      :T   MW 206
003D      :T   MW 208
003E      :T   MW 210
003F      :T   MW 212
0040      :BE
```

```
NETZWERK 1          0000
NAME :SYNCHRON
BEZ  :SSNR       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :BLGR       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :PAFE       E/A/D/B/T/Z: A  BI/BY/W/D: BY

000E       :ASM KH 0000
0010       :BE
```

```
NETZWERK 1          0000
NAME :RLG:AE
BEZ  :BG          E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :KNKT        E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :OGR         E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :UGR         E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :EINZ        E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :XA          E/A/D/B/T/Z: A  BI/BY/W/D: W
BEZ  :FB          E/A/D/B/T/Z: A  BI/BY/W/D: BI
BEZ  :BU          E/A/D/B/T/Z: A  BI/BY/W/D: BI
BEZ  :TBIT        E/A/D/B/T/Z: A  BI/BY/W/D: BI

0020       :ASM KH 0000
0022       :BE
```

```
NETZWERK 1          0000
NAME :RECEIVE
BEZ  :SSNR       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :A-NR       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :ANZW       E/A/D/B/T/Z: E  BI/BY/W/D: W
BEZ  :ZTYP       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KC
BEZ  :DBNR       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :ZANF       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :ZLAE       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :PAFE       E/A/D/B/T/Z: A  BI/BY/W/D: BY

001D       :ASM KH 0000
001F       :BE
```

```
NETZWERK 1          0000
NAME :FETCH
BEZ  :SSNR       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :A-NR       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :ANZW       E/A/D/B/T/Z: E  BI/BY/W/D: W
BEZ  :ZTYP       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KC
BEZ  :DBNR       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :ZANF       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :ZLAE       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :PAFE       E/A/D/B/T/Z: A  BI/BY/W/D: BY

001D       :ASM KH 0000
001F       :BE
```

```
NETZWERK 1          0000
NAME :DELETE
BEZ  :TYPE       E/A/D/B/T/Z: E  BI/BY/W/D: W
BEZ  :NUM        E/A/D/B/T/Z: E  BI/BY/W/D: BY
BEZ  :ERR        E/A/D/B/T/Z: A  BI/BY/W/D: BY

000E       :ASM KH 0000
0010       :BE
```

```
NETZWERK 1          0000
NAME :SEND
BEZ  :SSNR       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :A-NR       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :ANZW       E/A/D/B/T/Z: E  BI/BY/W/D: W
BEZ  :QTYP       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KC
BEZ  :DBNR       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KY
BEZ  :QANF       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :QLAE       E/A/D/B/T/Z: D  KM/KH/KY/KC/KF/KT/KZ/KG: KF
BEZ  :PAFE       E/A/D/B/T/Z: A  BI/BY/W/D: BY

001D      :ASM KH 0000
001F      :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                  POSITIVE FLANC                             *
*                                                                             *
*******************************************************************************
NAME :P.FLANKE
BEZ  :SIGN       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :MFL        E/A/D/B/T/Z: A  BI/BY/W/D: BI
BEZ  :MIM        E/A/D/B/T/Z: A  BI/BY/W/D: BI

000E       :U   =SIGN
000F       :UN  =MFL
0010       :=   =MIM
0011       :U   =MIM
0012       :S   =MFL
0013       :UN  =SIGN
0014       :RB  =MFL
0015       :BE
```

```
NETZWERK 1          0000
NAME :COMPR
BEZ  :AKT       E/A/D/B/T/Z: A  BI/BY/W/D: BI
BEZ  :ERR       E/A/D/B/T/Z: A  BI/BY/W/D: BI

000B       :ASM KH 0000
000D       :BE
```

```
NETZWERK 1          0000

**********************************************************************************
*                                                                                *
*                      LOAD AND START COUNTER 1 FOR WIND-UP                      *
*                                                                                *
**********************************************************************************
NAME :L+S-WIND

0005 M001 :SPA FB 134     -FB 134
0006 NAME :TIME-500
0007      :L   PY 160     -PY 160
0008      :T   MB 160     -MB 160
0009      :UN  M  160.7   -M 160.7
000A      :SPB =M001
000B      :L   KH 0061
000D      :T   PY 160     -PY 160
000E      :BE

PY 160   = PY 160                    IP242
MB 160   = MB 160                    IP242 : MB
M  160.7 = M 160.7                   IP242 READY BIT

FB 134   = FB 134                    500 ns FOR IP242
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*          RESET COUNTER FOR WIND-UP AND INSTALL COUNTER FOR BOOKING         *
*                                                                           *
*****************************************************************************
NAME :OFF-WIND

0005       :A   DB  30     -DB  30
0006       :L   KF +0
0008       :T   DW  86
0009       :SPA FB 150     -FB 150
000A NAME  :PARA.Z1
000B M001  :SPA FB 134     -FB 134
000C NAME  :TIME-500
000D       :L   PY 160     -PY 160
000E       :T   MB 160     -MB 160
000F       :UN  M  160.7   -M 160.7
0010       :SPB =M001
0011       :L   KH 0061
0013       :T   PY 160     -PY 160
0014       :BE

PY 160   = PY 160                    IP242
MB 160   = MB 160                    IP242 : MB
M  160.7 = M 160.7                   IP242 READY BIT

DB  30   = DB  30                    CALCULATION DATA

FB 150   = FB 150                    COUNTER 1 : INSTALL
FB 134   = FB 134                    500 ns FOR IP242
```

NETZWERK 1 0000

```
**********************************************************************
*                                                                    *
*              RESET FLAGS AND START COUNTER 1 FOR WIND-UP           *
*                                                                    *
**********************************************************************
NAME :RES-WIND

0005       :U   M   99.1  -M  99.1
0006       :R   M    0.6  -M   0.6
0007       :R   M    1.1  -M   1.1
0008       :R   M    1.2  -M   1.2
0009       :R   M    1.3  -M   1.3
000A       :R   M    1.4  -M   1.4
000B       :R   M    1.5  -M   1.5
000C       :R   M    1.6  -M   1.6
000D       :R   M    2.2  -M   2.2
000E       :R   M    2.3  -M   2.3
000F       :R   M    3.0  -M   3.0
0010       :R   M    3.1  -M   3.1
0011       :R   M    3.3  -M   3.3
0012       :R   M    3.4  -M   3.4
0013       :R   M    3.5  -M   3.5
0014       :R   M    3.6  -M   3.6
0015       :R   M    3.7  -M   3.7
0016       :R   M    4.4  -M   4.4
0017       :R   M    4.5  -M   4.5
0018       :R   M    5.1  -M   5.1
0019       :R   M    5.2  -M   5.2
001A       :R   M    5.5  -M   5.5
001B       :R   M    6.0  -M   6.0
001C       :R   M    6.1  -M   6.1
001D       :R   M    6.4  -M   6.4
001E       :R   M    9.7  -M   9.7
001F       :R   M   12.1  -M  12.1
0020       :R   M   12.4  -M  12.4
0021       :R   M   12.5  -M  12.5
0022       :R   M   17.2  -M  17.2
0023       :SPA FB 151    -FB 151
0024 NAME  :P-WIND
0025       :SPA FB 154    -FB 154
0026 NAME  :L+S-WIND
0027       :BE

M   99.1 = M  99.1                  "1"-SIGNAL
M    0.6 = M   0.6                  HOME POSITION START MARK
M    1.1 = M   1.1                  CUTTING CICLE STEP 1
M    1.2 = M   1.2                  CUTTING CICLE STEP 2
M    1.3 = M   1.3                  CUTTING CICLE STEP 3
M    1.4 = M   1.4                  CUTTING CICLE STEP 4
M    1.5 = M   1.5                  CUTTING CICLE STEP 5
M    1.6 = M   1.6                  CUTTING CICLE STEP 6
M    2.2 = M   2.2                  CONVEYOR SEMI-AUTOMATIC
M    2.3 = M   2.3                  CONVEYOR AUTOMATIC
M    3.0 = M   3.0                  TREAD LENGTH OK
M    3.1 = M   3.1                  START CUTTING
M    3.3 = M   3.3                  TIMER KNIFE CUTTING
M    3.4 = M   3.4                  SOLENOID VALVE KNIFE RETURN
M    3.5 = M   3.5                  SOLENOID VALVE KNIFE CUTTING
M    3.6 = M   3.6                  SOLENOID VALVE KNIFE LUBRICATION ON/OFF
M    3.7 = M   3.7                  SOLENOID VALVE KNIFE UP/DOWN
M    4.4 = M   4.4                  SOLENOID VALVE CLAMPING DEVICE DOWN
M    4.5 = M   4.5                  CUTTING CICLE AUTOMATIC OFF
M    5.1 = M   5.1                  CICLE HOME POSITION STEP 1
M    5.2 = M   5.2                  CICLE HOME POSITION STEP 2
M    5.5 = M   5.5                  HIGH-CONTROL TRIGGERED
M    6.0 = M   6.0                  AUTOMATIC KNIFE ON
M    6.1 = M   6.1                  MANUAL AND SEMI-AUTOMATIC KNIFE ON
M    6.4 = M   6.4                  KNIFE ON
M    9.7 = M   9.7                  CREEP WAY REACHED
```

```
M   12.1 = M  12.1      USABLE TREAD
M   12.4 = M  12.4      USABLE STRIP
M   12.5 = M  12.5      UNUSABLE TREAD
M   17.2 = M  17.2      CUT UNUSABLE TREAD

FB 151   = FB 151       COUNTER 1 : INSTALL FOR WIND-UP
FB 154   = FB 154       COUNTER 1 : LOAD + STAR FOR WIND-UP
```

NETZWERK 1 0000

```
*******************************************************************************
*                                                                             *
*                          INSTALL COUNTER 1 FOR WIND-UP                      *
*                                                                             *
*******************************************************************************
NAME :P-WIND

0005      :A   DB  30     -DB  30
0006 M001 :SPA FB 134     -FB 134
0007 NAME :TIME-500
0008      :L   PY 160     -PY 160
0009      :T   MB 160     -MB 160
000A      :UN  M  160.7   -M 160.7
000B      :SPB =M001
000C      :L   KH 0080                    RELEASE INTERRUPT COUNTER 1
000E      :T   PW 164     -PW 164         INTM-REGISTER
000F      :L   KH 1004                    RELEASE COMPERATOR 1
0011      :T   PW 166     -PW 166         MM-REGISTER
0012      :L   KH 010A                    COUNTER FORWARD
0014      :T   PW 168     -PW 168         CM-REGISTER
0015      :L   KH 0000                    0
0017      :T   PW 170     -PW 170         L-REGISTER
0018      :L   KF +20000                  IMPULSE FOR 5m
001A      :T   PW 174                     ALARM-REGISTER
001B      :L   KH 0001
001D      :T   PY 160     -PY 160
001E      :BE

PY 160    = PY 160                      IP242
MB 160    = MB 160                      IP242 : MB
M  160.7  = M 160.7                     IP242 READY BIT
PW 164    = PW 164                      IP242 : INTM-REGISTER
PW 166    = PW 166                      IP242 : MM-REGISTER
PW 168    = PW 168                      IP242 : CM-REGISTER
PW 170    = PW 170                      IP242 : CTRL-REGISTER

DB  30    = DB  30                      CALCULATION DATA

FB 134    = FB 134                      500 ns FOR IP242
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                          READ COUNTER 1 FOR WIND-UP                         *
*                                                                             *
*******************************************************************************
NAME :R-WIND

0005      :***

NETZWERK 2          0006
0006      :AWL
0007 M001 :SPA FB 134     -FB 134
0008 NAME :TIME-500
0009      :L   PY 160     -PY 160          READ INTIH-REGISTER
000A      :T   MB 160     -MB 160          H-MARK
000B      :UN  M  160.7   -M 160.7         READY-BIT = 1 ?
000C      :SPB =M001
000D      :L   KH 00A1                     SAVE COUNTER 1 TO H-REGISTER
000F      :T   PY 160     -PY 160
0010 M002 :SPA FB 134     -FB 134
0011 NAME :TIME-500
0012      :L   PY 160     -PY 160          READ INTIH-REGISTER
0013      :T   MB 160     -MB 160          H-MARK
0014      :UN  M  160.7   -M 160.7         READY BIT = 1 ?
0015      :SPB =M002
0016      :L   KH 0081                     COPY H-REGISTER TO E-REGISTER
0018      :T   PY 160     -PY 160          COUNTER 1
0019      :L   PW 166     -PW 166          E-REGISTER COUNTER 1
001A      :A   DB  30     -DB  30
001B      :T   DW  86                      Si = IMPULSE E-REGISTER
001C      :BE

PY 160    = PY 160                       IP242
MB 160    = MB 160                       IP242 : MB
M  160.7  = M 160.7                      IP242 READY BIT
PW 166    = PW 166                       IP242 : MM-REGISTER

DB  30    = DB  30                       CALCULATION DATA

FB 134    = FB 134                       500 ns FOR IP242
```

NETZWERK 1 0000

```
**********************************************************************
*                                                                    *
*                          INSTALL COUNTER 1                         *
*                                                                    *
**********************************************************************
NAME :PARA.Z1

0005      :A   DB  30    -DB  30
0006 M001 :SPA FB 134    -FB 134
0007 NAME :TIME-500
0008      :L   PY 160    -PY 160
0009      :T   MB 160    -MB 160
000A      :UN  M  160.7  -M 160.7
000B      :SPB =M001
000C      :L   KH 0080                  RELEASE INTERRUPT COUNTER 1
000E      :T   PW 164    -PW 164        INTM-REGISTER
000F      :L   KH 1004                  RELEASE COMPERATOR 1
0011      :T   PW 166    -PW 166        MM-REGISTER
0012      :L   KH 010A                  COUNTER FORWARD
0014      :T   PW 168    -PW 168        CM-REGISTER
0015      :L   KH 0000                  0
0017      :T   PW 170    -PW 170        L-REGISTER
0018      :L   DW  10                   TREAD LENGTH
0019      :T   PW 174                   ALARM-REGISTER
001A      :L   KH 0001
001C      :T   PY 160    -PY 160
001D      :BE

PY 160   = PY 160                     IP242
MB 160   = MB 160                     IP242 : MB
M  160.7 = M 160.7                    IP242 READY BIT
PW 164   = PW 164                     IP242 : INTM-REGISTER
PW 166   = PW 166                     IP242 : MM-REGISTER
PW 168   = PW 168                     IP242 : CM-REGISTER
PW 170   = PW 170                     IP242 : CTRL-REGISTER

DB  30   = DB  30                     CALCULATION DATA

FB 134   = FB 134                     500 ns FOR IP242
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                              INSTALL COUNTER 1                            *
*                                                                           *
*****************************************************************************
NAME :PARA.Z1

0005       :A   DB  30     -DB  30
0006 M001  :SPA FB 134     -FB 134
0007 NAME  :TIME-500
0008       :L   PY 160     -PY 160
0009       :T   MB 160     -MB 160
000A       :UN  M  160.7   -M 160.7
000B       :SPB =M001
000C       :L   KH 0080                          RELEASE INTERRUPT COUNTER 1
000E       :T   PW 164     -PW 164               INTM-REGISTER
000F       :L   KH 1004                          RELEASE COMPERATOR 1
0011       :T   PW 166     -PW 166               MM-REGISTER
0012       :L   KH 010A                          COUNTER FORWARD
0014       :T   PW 168     -PW 168               CM-REGISTER
0015       :L   KH 0000                          0
0017       :T   PW 170     -PW 170               L-REGISTER
0018       :L   DW  47                           BRAKE-WAY
0019       :T   PW 174                           ALARM-REGISTER
001A       :L   KH 0001
001C       :T   PY 160     -PY 160
001D       :BE

PY 160    = PY 160                    IP242
MB 160    = MB 160                    IP242 : MB
M  160.7  = M 160.7                   IP242 READY BIT
PW 164    = PW 164                    IP242 : INTM-REGISTER
PW 166    = PW 166                    IP242 : MM-REGISTER
PW 168    = PW 168                    IP242 : CM-REGISTER
PW 170    = PW 170                    IP242 : CTRL-REGISTER

DB  30    = DB  30                    CALCULATION DATA

FB 134    = FB 134                    500 ns FOR IP242
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                              READ COUNTER 2                               *
*                                                                           *
*****************************************************************************
```

NAME :READ-Z2

```
0005       :AS
0006 M001  :SPA FB 134     -FB 134
0007 NAME  :TIME-500
0008       :L   PY 160     -PY 160
0009       :T   MB 160     -MB 160
000A       :UN  M  160.7   -M 160.7          READY-BIT = 1 ?
000B       :SPB =M001
000C       :L   KH 00A2                      SAVE COUNTER 2 TO H-REGISTER
000E       :T   PY 160     -PY 160
000F M002  :SPA FB 134     -FB 134
0010 NAME  :TIME-500
0011       :L   PY 160     -PY 160
0012       :T   MB 160     -MB 160
0013       :UN  M  160.7   -M 160.7          READY-BIT = 1?
0014       :SPB =M002
0015       :L   KH 0082                      COPY H-REGISTER TO E-REGISTER
0017       :T   PY 160     -PY 160
0018       :L   PW 168     -PW 168           LOAD E-REGISTER AND COPY TO
0019       :A   DB  30     -DB  30
001A       :T   DW 120                       IMPULSE LENGTH MEASURING DEVICE
001B       :AF
001C       :BE
```

```
PY 160    = PY 160                  IP242
MB 160    = MB 160                  IP242 : MB
M  160.7  = M 160.7                 IP242 READY BIT
PW 168    = PW 168                  IP242 : CM-REGISTER

DB  30    = DB  30                  CALCULATION DATA

FB 134    = FB 134                  500 ns FOR IP242
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                INSTALL COUNTER 2                            *
*                                                                             *
*******************************************************************************
NAME :PARA.Z2

0005      :***

NETZWERK 2          0006
0006      :AS
0007 M001 :SPA FB 134     -FB 134
0008 NAME :TIME-500
0009      :L   PY 160     -PY 160
000A      :T   MB 160     -MB 160
000B      :UN  M  160.7   -M 160.7            READY-BIT = 1 ?
000C      :SPB =M001
000D      :L   KH 0080                       INTM-REGISTER
000F      :T   PW 164     -PW 164
0010      :L   KH 1004                       010A  1004  MM-REGISTER
0012      :T   PW 166     -PW 166
0013      :L   KH 020A                       CM-REGISTER
0015      :T   PW 168     -PW 168
0016      :L   KH 0000                       L-REGISTER
0018      :T   PW 170     -PW 170
0019      :L   KH 0002                       CTRL-REGISTER
001B      :T   PY 160     -PY 160            (PARAMETRIERE ZAEHLER 2)
001C      :AF
001D      :BE

PY 160   = PY 160                    IP242
MB 160   = MB 160                    IP242 : MB
M  160.7 = M 160.7                   IP242 READY BIT
PW 164   = PW 164                    IP242 : INTM-REGISTER
PW 166   = PW 166                    IP242 : MM-REGISTER
PW 168   = PW 168                    IP242 : CM-REGISTER
PW 170   = PW 170                    IP242 : CTRL-REGISTER

FB 134   = FB 134                    500 ns FOR IP242
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                              INSTALL COUNTER 2                            *
*                                                                           *
*****************************************************************************
NAME :PARA.Z2

0005       :***

NETZWERK 2          0006
0006       :AS
0007 M001  :SPA FB 134     -FB 134
0008 NAME  :TIME-500
0009       :L   PY 160     -PY 160
000A       :T   MB 160     -MB 160
000B       :UN  M  160.7   -M 160.7          READY-BIT = 1 ?
000C       :SPB =M001
000D       :L   KH 0080                      INTM-REGISTER
000F       :T   PW 164     -PW 164
0010       :L   KH 0104                      010A  1004  MM-REGISTER
0012       :T   PW 166     -PW 166
0013       :L   KH 020A                      CM-REGISTER
0015       :T   PW 168     -PW 168
0016       :L   KH 0000                      L-REGISTER
0018       :T   PW 170     -PW 170
0019       :L   KH 0002                      CTRL-REGISTER
001B       :T   PY 160     -PY 160           (PARAMETRIERE ZAEHLER 2)
001C       :AF
001D       :BE

PY 160    = PY 160                  IP242
MB 160    = MB 160                  IP242 : MB
M  160.7  = M 160.7                 IP242 READY BIT
PW 164    = PW 164                  IP242 : INTM-REGISTER
PW 166    = PW 166                  IP242 : MM-REGISTER
PW 168    = PW 168                  IP242 : CM-REGISTER
PW 170    = PW 170                  IP242 : CTRL-REGISTER

FB 134    = FB 134                  500 ns FOR IP242
```

NETZWERK 1 0000

```
*******************************************************************************
*                                                                             *
*                              TIME 500ns FOR IP242                           *
*                                                                             *
*******************************************************************************
NAME :TIME-500

0005      :AWL
0006      :AS
0007      :L   PW 160    -PW 160              99 * 10^-6 SEC.
0008      :L   PW 160    -PW 160
0009      :L   PW 160    -PW 160
000A      :L   PW 160    -PW 160
000B      :L   PW 160    -PW 160
000C      :L   KF +0                          1,6 * 10^-6 SEC.
000E      :L   KF +0
0010      :L   KF +0                          =499,8 * 10^-6 SEC.
0012      :AF
0013      :BE

PW 160    = PW 160                  IP242
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                          LOAD AND START COUNTER 2                         *
*                                                                           *
*****************************************************************************
```

NAME :RESET Z2

```
0005       :AS
0006       :SPA FB 144
0007 NAME  :PARA.Z2
0008 M001  :SPA FB 134     -FB 134
0009 NAME  :TIME-500
000A       :L   PY 160     -PY 160
000B       :T   MB 160     -MB 160
000C       :UN  M  160.7   -M 160.7          READY BIT = 1 ?
000D       :SPB =M001
000E       :L   KH 0062                      LOAD + START COUNTER 2
0010       :T   PY 160     -PY 160
0011       :AF
0012       :BE
```

```
PY 160   = PY 160                  IP242
MB 160   = MB 160                  IP242 : MB
M  160.7 = M 160.7                 IP242 READY BIT

FB 134   = FB 134                  500 ns FOR IP242
```

```
NETZWERK 1          0000
NAME :INTER-2

0005       :U   M   11.5  -M  11.5
0006       :SPB =M001                          YES >> WIND-UP
0007       :U   M    0.2  -M   0.2
0008       :BEB                                YES >> SEMIAUTOMATIC
0009       :U   M    9.7  -M   9.7
000A       :SPB =M002                          YES >> BRAKE-WAY REACHED -> STOP
000B       :A   DB  30    -DB  30
000C       :L   DW   6
000D       :SPA =M998
000E       :T   PW 128    -12A1.1
000F M998  :
0010       :U   M   99.1  -M  99.1
0011       :S   M    9.7  -M   9.7              SET BRAKE-WAY REACHED
0012       :SPA FB 149    -FB 149               SET NEW ALARM ON CUT
0013 NAME  :PARA.Z1
0014 M003  :SPA FB 134    -FB 134
0015 NAME  :TIME-500
0016       :L   PY 160    -PY 160
0017       :T   MB 160    -MB 160
0018       :UN  M  160.7  -M 160.7
0019       :SPB =M003
001A       :UN  M   20.0  -M  20.0
001B       :S   M   20.0  -M  20.0
001C       :BEA
001D M002  :L   KF +0
001F       :SPA =M999
0020       :T   PW 128    -12A1.1
0021 M999  :
0022       :L   KB 0
0023       :T   PY   7
0024       :U   M   99.1  -M  99.1
0025       :S   M    3.0  -M   3.0
0026       :UN  M   20.1  -M  20.1
0027       :S   M   20.1  -M  20.1
0028       :BEA
0029 M001  :SPA FB 151    -FB 151
002A NAME  :P-WIND
002B       :SPA FB 154    -FB 154
002C NAME  :L+S-WIND
002D       :U   M   99.1  -M  99.1
002E       :S   M   12.3  -M  12.3
002F       :BE
```

```
M   11.5 = M  11.5          WIND-UP START
M    0.2 = M   0.2          CUTTING CICLE SEMI AUTOMATIC
M    9.7 = M   9.7          CREEP WAY REACHED
PW 128   = 12A1.1           CONVEYOR BELT SLIT
M   99.1 = M  99.1          "1"-SIGNAL
PY 160   = PY 160           IP242
MB 160   = MB 160           IP242 : MB
M  160.7 = M 160.7          IP242 READY BIT
M   20.0 = M  20.0          INTERRUPT FB123 CREEP (TEST)
M    3.0 = M   3.0          TREAD LENGTH OK
M   20.1 = M  20.1          INTERRUPT FB123 STOP (TEST)
M   12.3 = M  12.3          COUNTER WIND-UP PLUS 1

DB  30   = DB  30           CALCULATION DATA

FB 149   = FB 149           COUNTER 1 : INSTALL NEW INTERRUPT
FB 134   = FB 134           500 ns FOR IP242
FB 151   = FB 151           COUNTER 1 : INSTALL FOR WIND-UP
FB 154   = FB 154           COUNTER 1 : LOAD + STAR FOR WIND-UP
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                              DETERMINE TREAD LENGTH                       *
*                                                                           *
*****************************************************************************
NAME :T.LENGTH

0005       :A   DB  30     -DB  30
0006       :SPA FB  15     -FB  15 S
0007 NAME  :GP:FPGP
0008 Z12   :    DW  18                          "0"
0009 Z11   :    DW 120                          Li IN I
000A Z22   :    DW 121                          Li GP : H-WORD
000B Z21   :    DW 122                                : L-WORD
000C       :SPA FB  20     -FB  20 S
000D NAME  :GP:DIV
000E Z12   :    DW 121                          Li GP : H-WORD
000F Z11   :    DW 122                                : L-WORD
0010 Z22   :    DW 123                          IMPULSE/mm  GP : H-WORD
0011 Z21   :    DW 124                                       : L-WORD
0012 OV    :    M  200.0
0013 FEH   :    M  200.1
0014 Z3=0  :    M  200.2
0015 Z32   :    DW 125                          L IN mm GP : H-WORD
0016 Z31   :    DW 126                                     : L-WORD
0017       :SPA FB  16     -FB  16 S
0018 NAME  :GP:GPFP
0019 Z12   :    DW 125                          L IN mm GP : H-WORD
001A Z11   :    DW 126                                     : LWORD
001B OV    :    M  200.0
001C Z2=0  :    M  200.1
001D Z22   :    DW 127                          LENGTH L IN mm FP : H-WORD = 0 !
001E Z21   :    DW 128                          LENGTH L IN mm FP : L-WORD
001F       :A   DB  30     -DB  30
0020       :L   DW 128
0021       :T   DW  87
0022       :BE


DB  30   = DB  30                  CALCULATION DATA

FB  15   = FB  15 S                FIXED-POINT NUMBER --> FLOATING-POINT N.
FB  20   = FB  20 S                DIVIDE TWO FLOATING-POINT NUMBERS
FB  16   = FB  16 S                FLOATING-POINT NUMBER --> FIXED-POINT N.
```

```
M    6.7 = M   6.7    FAULT : TREAD SKIVER OFF
A    7.2 = A   7.2    SPARE
M   14.6 = M  14.6    RESET COUNTER 1
PY 160   = PY 160     IP242
MB 160   = MB 160     IP242 : MB
M  160.7 = M 160.7    IP242 READY BIT
PW 166   = PW 166     IP242 : MM-REGISTER
M    2.3 = M   2.3    CONVEYOR AUTOMATIC
E    6.3 = E   6.3    SPARE
M   10.6 = M  10.6    TREAD LENGTH REACHED
M   12.5 = M  12.5    UNUSABLE TREAD
E    1.5 = 26S6       HIGH-CONTROL  60 MM (NO CUT)
M    1.5 = M   1.5    CUTTING CICLE STEP 5
PW 128   = 12A1.1     CONVEYOR BELT SLIT
M   16.1 = M  16.1    STRIP IN BOTTOM SECTION

DB  30   = DB  30     CALCULATION DATA

FB 150   = FB 150     COUNTER 1 : INSTALL
FB 134   = FB 134     500 ns FOR IP242
```

```
NETZWERK 1          0000

**************************************************************************
*                                                                        *
*                          RESET INTERRUPT COUNTER 1                     *
*                                                                        *
**************************************************************************
NAME :RESET-I

0005 M001 :SPA FB 134     -FB 134
0006 NAME :TIME-500
0007      :L   PY 160     -PY 160
0008      :T   MB 160     -MB 160
0009      :UN  M  160.7   -M 160.7
000A      :SPB =M001
000B      :L   KH 00E3                          RESET INTERRUPT
000D      :T   PY 160     -PY 160
000E M002 :SPA FB 134     -FB 134
000F NAME :TIME-500
0010      :L   PY 160     -PY 160
0011      :T   MB 160     -MB 160
0012      :UN  M  160.7   -M 160.7
0013      :SPB =M002
0014      :UN  M    5.3   -M   5.3
0015      :S   M    5.3   -M   5.3
0016      :BE

PY 160   = PY 160                    IP242
MB 160   = MB 160                    IP242 : MB
M  160.7 = M 160.7                   IP242 READY BIT
M    5.3 = M   5.3                   RESET INTERRUPT DONE (TEST)

FB 134   = FB 134                    500 ns FOR IP242
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                                READ COUNTER 1                             *
*                                                                           *
*****************************************************************************
NAME :READ-ZAE

0005      :***

NETZWERK 2          0006
0006      :U   M   11.5  -M  11.5
0007      :BEB
0008      :
0009      :U   M    3.0  -M   3.0
000A      :O   M    0.1  -M   0.1
000B      :R   M    9.7  -M   9.7
000C      :
000D      :U   M    0.2  -M   0.2          SEMI-AUTOMATIC
000E      :U   M   14.5  -M  14.5          KNIFE REVERSE
000F      :O   M    0.1  -M   0.1          MANUAL
0010      :O   M    1.1  -M   1.1          CUTTING CICLE STEP 1
0011      :O   M    1.64 -M   1.64         CUTTING CICLE STEP 4
0012      :O   M    3.3  -M   3.3          TIMER KNIFE CUTTING
0013      :O   M   11.4  -M  11.4          IMPULSE AUTO.-->SEMIAUTO.
0014      :O   M    6.7  -M   6.7          FAULT SKIVER
0015      :=   A    7.2  -A   7.2
0016      :=   M   14.6  -M  14.6
0017      :UN  M   14.6  -M  14.6          RESET COUNTER 1 ?
0018      :SPB =M001
0019      :SPA FB 150    -FB 150
001A NAME :PARA.Z1                        PARAMETRIERE COUNTER 1
001B M002 :SPA FB 134    -FB 134
001C NAME :TIME-500
001D      :L   PY 160    -PY 160
001E      :T   MB 160    -MB 160          READ INTIH-REGISTER
001F      :UN  M  160.7  -M 160.7          H-MARK
0020      :SPB =M002                      READY-BIT = 1 ?
0021      :L   KH 0061
0023      :T   PY 160    -PY 160          LOAD + START COUNTER 1
0024      :BEA
0025 M001 :SPA FB 134    -FB 134
0026 NAME :TIME-500
0027      :L   PY 160    -PY 160
0028      :T   MB 160    -MB 160          READ INTIH-REGISTER
0029      :UN  M  160.7  -M 160.7          H-MARK
002A      :SPB =M001                      READY-BIT = 1 ?
002B      :L   KH 00A1
002D      :T   PY 160    -PY 160          SAVE COUNTER 1 TO H-REGISTER
002E M003 :SPA FB 134    -FB 134
002F NAME :TIME-500
0030      :L   PY 160    -PY 160
0031      :T   MB 160    -MB 160          READ INTIH-REGISTER
0032      :UN  M  160.7  -M 160.7          H-MARK
0033      :SPB =M003                      READY BIT = 1 ?
0034      :L   KH 0081
0036      :T   PY 160    -PY 160          COPY H-REGISTER TO E-REGISTER
0037      :L   PW 166    -PW 166          COUNTER 1
0038      :A   DB  30    -DB  30          E-REGISTER COUNTER 1
0039      :T   DW  22
003A      :T   DW  23                     Si = IMPULSE E-REGISTER
003B      :
003C      :
003D      :
003E      :
003F      :
0040      :
0041      :                               #  Si = IMPULSE E-REGISTER
0042      :UN  M    2.3  -M   2.3         #  So * IMPULSE
0043      :BEB                            #
0044      :L   DW  22                     #  TREAD LENGTH REACHED
0045      :L   DW  10
0046      :U   E   6.3  E  6.3  >=F       TREAD LENGTH REACHED
```

KRUPP KUNSTOFFTECHNIK ELASTOMERTECHNIK WERK HARBURG		
PROJECT : KERMAN TIRE	DATE :	
INSTALLATION : TREAD-LINE	MODIFICATION:	PGNO
PROJECT POS. NO.: 84/823804	PROGRAMMER :	1

```
0047       :=    M   10.6   -M  10.6          CUT UNUSABLE TREAD
0048       :                                  HIGH CONTROL
0049       :U    M   10.6   -M  10.6          RESET COUNTER
004A       :U    M   12.5   -M  12.5
004B       :U    E    1.5   -26S6
004C       :SPB =M004
004D       :SPA =M005
004E M004  :SPA FB 150      -FB 150
004F NAME  :PARA.Z1
0050 M006  :SPA FB 134      -FB 134
0051 NAME  :TIME-500
0052       :L    PY 160     -PY 160
0053       :T    MB 160     -MB 160
0054       :UN   M  160.7   -M 160.7
0055       :SPB =M006
0056       :L    KH 0061
0058       :T    PY 160     -PY 160
0059 M007  :SPA FB 134      -FB 134
005A NAME  :TIME-500
005B       :L    PY 160     -PY 160
005C       :T    MB 160     -MB 160
005D       :UN   M  160.7   -M 160.7
005E       :SPB =M007
005F       :R    M   10.6   -M  10.6
0060       :L    KF +0
0062       :T    DW  22                       TREAD LENGTH REACHED
0063 M005  :
0064       :U    M   10.6   -M  10.6
0065       :S    M    3.0   -M   3.0
0066       :O    M    1.5   -M   1.5          TREAD LENGTH REACHED
0067       :O    M    6.7   -M   6.7
0068       :R    M    3.0   -M   3.0
0069       :ON   M    3.0   -M   3.0          OUTPUT CONVEYOR BELT
006A       :SPB =M008                         for Creep Speed
006B       :L    KF +0
006D       :T    DW   3                       #  Si (IMPULSE)
006E       :BEA                               L DW 10
006F       :T    PW 128     -12A1.1           #  Smax (IMPULSE)   L KF +400
0070       :BEA                               #                   - F
0071 M008  :L    DW  22                       #  CREEP WAY REACHED L DW 22
0072       :L    DW  47                       HIGH CONTROL        <= F
0073       :>=F                               CUT UNUSABLE TREAD
0074       :=    M  200.0                     REST CREEP
0075       :U    E    1.5   -26S6
0076       :U    M   12.5   -M  12.5
0077       :R    M    9.7   -M   9.7          = A
0078       :U    M    2.3   -M   2.3          NO CREEP WAY OR SEMI-AUTO
0079       :U    M    9.7   -M   9.7
007A       :SPB =M009
007B       :SPA =M010
007C M009  :L    DW   6                       AUTOMATIC
007D       :BEA
007E       :T    PW 128     -12A1.1
007F       :BEA                               LIGHT BARRIER BOTTOM SECTION
0080 M010  :UN   M    2.3   -M   2.3
0081       :BEB                               MAX. SPEED CONVEYOR
0082       :UN   M   16.1   -M  16.1
0083       :BEB
0084       :L    KF +16000
0086       :BEA
0087       :T    PW 128     -12A1.1
0088       :BE
```

```
M   11.5 = M  11.5          WIND-UP START
M    3.0 = M   3.0          TREAD LENGTH OK
M    0.1 = M   0.1          CUTTING CICLE MANUAL
M    9.7 = M   9.7          CREEP WAY REACHED
M    0.2 = M   0.2          CUTTING CICLE SEMI AUTOMATIC
M   14.5 = M  14.5          IMPULSE KNIFE HOMEPOSITION
M    1.6 = M   1.6          CUTTING CICLE STEP 6
M   11.4 = M  11.4          IMPULS SEMI-AUTOMATIC ON
```

```
FB 113  -FB 113                          C:SKIV06ST.S5D        BIB=7022     LAE=22

NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                          SINEC-L1 : 115-U AS SLAVE No.1                     *
*                                                                             *
*******************************************************************************
NAME :SINEC-L1

0005       :SPA FB 255     -FB 255
0006 NAME :L1-PG/DA
0007 PGDA :     KY 0,1
0008 TKBE :     KC MB
0009 NKBE :     KY 61,0
000A TKBS :     KC MB
000B NKBS :     KY 62,0
000C TSF  :     KC DB
000D NSF  :     KY 30,80                        SENDBOX IN DB30 FROM DW80
000E TEF  :     KC DB
000F NEF  :     KY 30,40                        RECEIVEBOX IN DB30 FROM DW40
0010       :BE


FB 255    = FB 255                    S5-115U AS SLAVE
```

KRUPP KUNSTOFFTECHNIK ELASTOMERTECHNIK	WERK HARBURG	SKIVER	
PROJECT : KERMAN TIRE		DATE :	
INSTALLATION : TREAD-LINE		MODIFICATION:	PGNO
PROJECT POS. NO.: 84/823804		PROGRAMMER :	1

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                      SINEC-L1 : DATA TRANSFER 135U - 115U                   *
*                                                                             *
*******************************************************************************
NAME :SINEC

0005       :A   DB  30     -DB  30
0006       :O   M  135.0   -M 135.0
0007       :O   M   61.7   -M  61.7
0008       :SPB =M001
0009       :UN  M  135.0   -M 135.0
000A       :S   M  135.0   -M 135.0
000B       :L   DW  40
000C       :T   DW  80
000D       :L   DW  41
000E       :T   DW  81
000F       :UN  M   61.7   -M  61.7
0010       :S   M   61.7   -M  61.7
0011 M001  :
0012       :UN  M  135.0   -M 135.0
0013       :BEB
0014       :O   M  135.1   -M 135.1
0015       :O   M   62.7   -M  62.7
0016       :SPB =M002
0017       :UN  M  135.1   -M 135.1
0018       :S   M  135.1   -M 135.1
0019       :UN  M   62.7   -M  62.7
001A       :S   M   62.7   -M  62.7
001B       :R   M  135.2   -M 135.2
001C       :
001D M002  :
001E       :
001F       :
0020       :UN  M   62.7   -M  62.7
0021       :UN  M  135.2   -M 135.2
0022       :=   M  135.3   -M 135.3
0023       :U   M  135.3   -M 135.3
0024       :S   M  135.2   -M 135.2
0025       :U   M  135.3   -M 135.3
0026       :UN  M   62.0   -M  62.0
0027       :R   M  135.0   -M 135.0
0028       :R   M  135.1   -M 135.1
0029       :U   M  135.3   -M 135.3
002A       :U   M   62.0   -M  62.0
002B       :R   M  135.1   -M 135.1
002C       :BE

M  135.0 = M 135.0                  SINEC L1-BUS : RECEIVED DATA COPIED
M   61.7 = M  61.7                  SINEC L1-BUS : FLAG RECIEVE DATAS
M  135.1 = M 135.1                  SINEC L1-BUS
M   62.7 = M  62.7                  SINEC L1-BUS : FLAG SEND DATAS
M  135.2 = M 135.2                  SINEC L1-BUS
M  135.3 = M 135.3                  SINEC L1-BUS
M   62.0 = M  62.0                  SINEC L1-BUS

DB  30   = DB  30                   CALCULATION DATA
```

NETZWERK 1 0000

```
**************************************************************************
*                                                                        *
*                          TEST PERIPHERIE                               *
*                                                                        *
**************************************************************************
NAME :PERIPHE.

0005      :L   KF +0
0007      :T   PW   0                    SET OUTPUT = 0
0008      :T   PW   2
0009      :T   PW   4
000A      :T   PW   6
000B      :L   PW   0                    READ INPUT
000C      :L   PW   2
000D      :L   PW   4
000E      :L   PW   6
000F      :BE
```

NETZWERK 1 0000

```
**********************************************************************************
*                                                                                *
*                                  RESET FLAGS                                   *
*                                                                                *
**********************************************************************************
NAME :RESET M

0005      :L   KF +0
0007      :T   MW   0
0008      :T   MW   2
0009      :T   MW   4
000A      :T   MW   6
000B      :T   MW   8
000C      :T   MW  10
000D      :T   MW  12
000E      :T   MW  14
000F      :T   MW  16
0010      :T   MW  18
0011      :T   MW  20
0012      :T   MW  22
0013      :T   MW  24
0014      :T   MW  26     -MW 226
0015      :T   MW  28
0016      :T   MW  30
0017      :T   MW 120
0018      :T   MW 122
0019      :T   MW 124
001A      :T   MW 126
001B      :T   MW 128
001C      :T   MW 130
001D      :T   MW 132
001E      :T   MW 134
001F      :T   MW 136
0020      :T   MW 140
0021      :BE

MW  26   = MW 226                    BCD-VALUE FOR TREAD CORRECTION
```

```
NETZWERK 1          0000      STRIP SHORTER

*****************************************************************************
*                                                                           *
*                                TREAD SHORTER                              *
*                                                                           *
*****************************************************************************
NAME :SLIT -

0005       :***

NETZWERK 2          0006
0006       :U   E    5.0  -30S1.1                SWITCH STRIP SHORTER
0007       :SPB =M001
0008       :A   DB  30    -DB  30
0009       :L   DW  31
000A       :T   DW  10
000B       :L   KF +4                            # RESET TO MIN (IMPULSE/mm)
000D       :T   DW  24                           #
000E       :BEA                                  #
000F M001  :
0010       :UN  Z    3    -Z   3
0011       :O   M   10.2  -M  10.2
0012       :L   KZ 010
0014       :S   Z    3    -Z   3
0015       :U   M   24.3  -M  24.3
0016       :ZR  Z    3    -Z   3
0017       :L   Z    3    -Z   3
0018       :L   KF +1
001A       :!=F
001B       :=   M   10.2  -M  10.2
001C       :SPA FB 202    -FB 202
001D NAME  :P.FLANKE
001E SIGN  :    M   10.2  -M  10.2
001F MFL   :    M   18.1  -M  18.1
0020 MIM   :    M   10.3  -M  10.3
0021       :UN  M   10.3  -M  10.3
0022       :SPB =M002
0023       :A   DB  30    -DB  30
0024       :L   DW  24
0025       :L   DW  24
0026       :+F
0027       :T   DW  24
0028       :L   KF +65
002A       :<=F
002B       :SPB =M002
002C       :A   DB  30    -DB  30
002D       :L   KF +400
002F       :T   DW  24
0030 M002  :
0031       :SPA FB 202    -FB 202
0032 NAME  :P.FLANKE
0033 SIGN  :    M   24.3  -M  24.3
0034 MFL   :    M   18.2  -M  18.2
0035 MIM   :    M   18.3  -M  18.3
0036       :UN  M   18.3  -M  18.3
0037       :SPB =M003
0038       :A   DB  30    -DB  30
0039       :L   DW  31
003A       :L   DW  24
003B       :-F
003C       :T   DW  31
003D       :L   KF +4000
003F       :>=F
0040       :SPB =M003
0041       :L   KF +4000
0043       :T   DW  31
0044 M003  :
0045       :A   DB  30    -DB  30
0046       :L   DW  31
0047       :T   DW  10
0048       :BE

+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                     !
!ELASTOMERTECHNIK          WERK HARBURG !  SKIVER                             !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                     !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                   PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                     1!
+-----------------------------------------------------------------------------+
```

```
FB 71   -FB  71                    C:SKIV06ST.S5D        BIB=28102   LAE=78

E     5.0 = 30S1.1                 TREAD SHORTER        (CONTROL PANEL)
Z     3   = Z    3                 COUNTER TREAD SHORTER
M    10.2 = M   10.2                COUNTER TREAD SHORTER
M    24.3 = M   24.3                TACT 2 Hz
M    18.1 = M   18.1                HF TREAD LONGER
M    10.3 = M   10.3                COUNTER TREAD SHORTER (IMPULSE)
M    18.2 = M   18.2                HF TACT M 25.3
M    18.3 = M   18.3                IMPULSE M 25.3

DB   30   = DB   30                 CALCULATION DATA

FB 202    = FB 202                 POSITIVE FLANK
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                                TREAD LONGER                               *
*                                                                           *
*****************************************************************************
NAME :SLIT +

0005       :***

NETZWERK 2          0006
0006       :A   DB  30    -DB  30
0007       :U   E    5.1  -30S1.2
0008       :SPB =M001                          SWITCH STRIP LONGER
0009       :A   DB  30    -DB  30
000A       :L   DW  31
000B       :T   DW  10
000C       :L   KF +4                          # RESET TO MIN.
000E       :T   DW  33                         #
000F       :BEA                                #
0010 M001  :
0011       :UN  Z    2    -Z   2
0012       :O   M   10.0  -M  10.0
0013       :L   KZ 010
0015       :S   Z    2    -Z   2
0016       :U   M   24.3  -M  24.3
0017       :ZR  Z    2    -Z   2
0018       :
0019       :L   Z    2    -Z   2               # IF CONUTER = 1
001A       :L   KF +1                          # THEN M 10.0
001C       :!=F                                #
001D       :=   M   10.0  -M  10.0             #
001E       :SPA FB 202    -FB 202
001F NAME  :P.FLANKE
0020 SIGN  :    M   10.0  -M  10.0
0021 MFL   :    M   17.6  -M  17.6
0022 MIM   :    M   10.1  -M  10.1
0023       :UN  M   10.1  -M  10.1
0024       :SPB =M002
0025       :A   DB  30    -DB  30              # ADD FAKTOR TO FAKTOR
0026       :L   DW  33                         #
0027       :L   DW  33                         #
0028       :+F                                 #
0029       :T   DW  33                         #
002A       :L   KF +65
002C       :<=F
002D       :SPB =M002
002E       :L   KF +400                        # MAX. CHANGING FACTOR
0030       :T   DW  33
0031 M002  :
0032       :SPA FB 202    -FB 202
0033 NAME  :P.FLANKE
0034 SIGN  :    M   24.3  -M  24.3
0035 MFL   :    M   17.7  -M  17.7
0036 MIM   :    M   18.0  -M  18.0
0037       :UN  M   18.0  -M  18.0
0038       :SPB =M003
0039       :A   DB  30    -DB  30
003A       :L   DW  31
003B       :L   DW  33
003C       :+F
003D       :T   DW  31
003E       :L   KF +14000
0040       :<=F
0041       :SPB =M003
0042       :L   KF +14000
0044       :T   DW  31
0045 M003  :
0046       :A   DB  30    -DB  30
0047       :L   DW  31
0048       :T   DW  10
0049       :BE

+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                    !
!ELASTOMERTECHNIK          WERK HARBURG !  SKIVER                            !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE         :                    !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER   :                    1!
+-----------------------------------------------------------------------------+
```

```
FB 70   -FB  70                    C:SKIV06ST.S5D        BIB=28102   LAE=79

E    5.1 = 30S1.2                  TREAD LONGER          (CONTROL PANEL)
Z    2   = Z   2                   COUNTER TREAD LONGER
M   10.0 = M  10.0                 COUNTER TREAD SHORTER
M   24.3 = M  24.3                 TACT 2 Hz
M   17.6 = M  17.6                 HF TREAD SHORTER
M   10.1 = M  10.1                 COUNTER TREAD LONGER
M   17.7 = M  17.7                 HF TACT M 25.3
M   18.0 = M  18.0                 IMPULSE M 25.3

DB  30   = DB  30                  CALCULATION DATA

FB 202   = FB 202                  POSITIVE FLANK
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                              FLAG-BYTE ---> DATA-BYTE                       *
*                                                                             *
*******************************************************************************
NAME :MB--->DB                                        BYTE TO DB MOVE
BEZ  :DBNR       E/A/D/B/T/Z: B
BEZ  :BIT0       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :BIT1       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :BIT2       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :BIT3       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :BIT4       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :BIT5       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :BIT6       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :BIT7       E/A/D/B/T/Z: E  BI/BY/W/D: BI
BEZ  :DW         E/A/D/B/T/Z: A  BI/BY/W/D: BY

0023      :B   =DBNR                    DATENBAUSTEIN-NR.
0024      :U   =BIT0                    MELDETABELLE BIT 0
0025      :=   M  240.0                 HILFSMERKER HM 0
0026      :U   =BIT1                    MELDETABELLE BIT 1
0027      :=   M  240.1                 HM 1
0028      :U   =BIT2                    MELDETABELLE BIT 2
0029      :=   M  240.2                 HM 2
002A      :U   =BIT3                    MELDETABELLE BIT 3
002B      :=   M  240.3                 HM 3
002C      :U   =BIT4                    MELDETABELLE BIT 4
002D      :=   M  240.4                 HM 4
002E      :U   =BIT5                    MELDETABELLE BIT 5
002F      :=   M  240.5                 HM 5
0030      :U   =BIT6                    MELDETABELLE BIT 6
0031      :=   M  240.6                 HM 6
0032      :U   =BIT7                    MELDETABELLE BIT 7
0033      :=   M  240.7                 HM 7
0034      :L   MB 240                   LADE HILFSMERBERBYTE
0035      :T   =DW                      TRANSFERIERE AUF DA-
0036      :BE                           TENBYTE LINKS/RECHTS
```

```
FB 60    -FB  60                    C:SKIV06ST.S5D        BIB=21102    LAE=64

NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                                V-SEMI-AUTOMATIC                           *
*                                                                           *
*****************************************************************************
NAME :V-SEMI

0005       :***

NETZWERK 2          0006
0006       :UN  M    3.0   -M   3.0
0007       :SPB =M001
0008       :A   DB  30     -DB  30              ################################
0009       :L   KF +0                           #  TREAD LENGTH REACHED
000B       :T   DW   3                          #  STOP CONVEYOR
000C       :BEA
000D       :T   PW 128     -12A1.1              #
000E       :BEA                                 ################################
000F M001  :
0010       :A   DB  30     -DB  30
0011       :L   DW  22                          Si
0012       :L   DW  10                          So (SEMI-AUTOMATIC)
0013       :>=F
0014       :=   M   10.6   -M  10.6
0015       :U   M   10.6   -M  10.6
0016       :S   M    3.0   -M   3.0             TREAD LENGTH REACHED
0017       :O   M    1.5   -M   1.5
0018       :O   M    6.7   -M   6.7
0019       :R   M    3.0   -M   3.0
001A       :UN  M    3.0   -M   3.0
001B       :SPB =M002
001C       :L   KF +0                           ################################
001E       :T   DW   3                          #  TREAD LENGTH REACHED
001F       :SPA =M002
0020       :T   PW 128     -12A1.1
0021 M999  :
0022       :L   KB 0                            #  OUTPUT "0"
0023       :T   PY   7                          #
0024       :BEA                                 #
0025 M002  :L   DW  10                          ################################
0026       :L   KF +400                         So (SEMI-AUTOMATIC)
0028       :-F                                  K  (CONSTANT STOPPING DISTANCE)
0029       :L   DW  22
002A       :<=F                                 Si
002B       :SPB =M003                           So - K  <  Si
002C       :NOP 0                               ################################
002D       :                                    #  CONSTANT SPEED UNTIL STOPPING
002E       :                                    #               DISTANCE REACHED
002F       :L   KF +3000                        ################################
0031       :T   DW   3                          ////////////////////////////////
0032       :BEA                                 /  CONSTANT SPEED UNTIL TREAD
0033       :                                    /                LENGTH REACHED
0034       :                                    ////////////////////////////////
0035       :
0036 M003  :L   KF +3000
0038       :T   DW   3
0039       :NOP 0
003A       :BE

M    3.0 = M   3.0                  TREAD LENGTH OK
PW 128   = 12A1.1                   CONVEYOR BELT SLIT
M   10.6 = M  10.6                  TREAD LENGTH REACHED
M    1.5 = M   1.5                  CUTTING CICLE STEP 5
M    6.7 = M   6.7                  FAULT : TREAD SKIVER OFF

DB  30   = DB  30                   CALCULATION DATA

+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                     !
!ELASTOMERTECHNIK          WERK HARBURG ! SKIVER                              !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                     1!
+-----------------------------------------------------------------------------+
```

NETZWERK 1 0000

```
*****************************************************************************
*                                                                           *
*                              TREAD IN TOLERANCE                           *
*                                                                           *
*****************************************************************************
```

NAME :TOLERANZ

```
0005      :A   DB  30    -DB  30
0006      :L   DW  42                    TREAD LENGHT FROM 135
0007      :L   KF +5                     TOLERANCE 5 mm
0009      :+F                            = MAX. LENGTH
000A      :L   DW 128                    TREAD LENGHT MEAS.DEVICE
000B      :>=F
000C      :=   M   19.0  -M  19.0        LENGTH UNDER MAX.
000D      :L   DW  42                    TREAD LENGTH FROM 135U
000E      :L   KF +5                     TOLERANCE
0010      :-F                            = MIN. LENGTH
0011      :L   DW 128                    TREAD LENGTH MEAS.DEVICE
0012      :<=F
0013      :=   M   19.1  -M  19.1        LENGTH OVER MIN.
0014      :ON  M   19.0  -M  19.0
0015      :ON  M   19.1  -M  19.1
0016      :=   M   15.5  -M  15.5        SCRAP DETECTED
0017      :BE
```

```
M   19.0 = M  19.0          LENGTH MEASURING MAX. SLIT
M   19.1 = M  19.1          LENGTH MEASURING MIN. SLIT
M   15.5 = M  15.5          SCRAP DETECTED

DB  30   = DB  30           CALCULATION DATA
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                              USABLE STRIP LENGTH                            *
*                                                                             *
*******************************************************************************
NAME :USABLE S

0005      :AWL
0006      :***

NETZWERK 2          0007      USABLE STRIP LENGHT (M 12.4)
0007      :AWL
0008      :A   DB  30    -DB  30
0009      :L   DW  10                          So (NOMINAL VALUE)
000A      :L   DW  22                          Si (ACTUAL LENGTH)
000B      :-F
000C      :L   KF +5000                        SZ (SECURITY ADDITION)
000E      :<F                                  So - Si  <  SZ
000F      :=   M   12.4  -M  12.4              M 12.4 ---> USABLE TREAD
0010      :BE

M   12.4 = M  12.4                  USABLE STRIP

DB  30   = DB  30                   CALCULATION DATA
```

```
FB 13   -FB  13                    C:SKIV06ST.S5D        BIB=7022     LAE=31

NETZWERK 1          0000

**************************************************************************
*                                                                        *
*                              MOVE TWO DATAWORDS                        *
*                                                                        *
**************************************************************************
NAME :TRANS-2
BEZ  :EIN1       E/A/D/B/T/Z: E  BI/BY/W/D: W
BEZ  :EIN2       E/A/D/B/T/Z: E  BI/BY/W/D: W
BEZ  :AUS1       E/A/D/B/T/Z: A  BI/BY/W/D: W
BEZ  :AUS2       E/A/D/B/T/Z: A  BI/BY/W/D: W
BEZ  :DB         E/A/D/B/T/Z: B

0014      :B   =DB
0015      :LW  =EIN1
0016      :T   =AUS1
0017      :LW  =EIN2
0018      :T   =AUS2
0019      :BE
```

KRUPP KUNSTOFFTECHNIK			
ELASTOMERTECHNIK	WERK HARBURG	SKIVER	
PROJECT	: KERMAN TIRE	DATE :	
INSTALLATION	: TREAD-LINE	MODIFICATION:	PGNO
PROJECT POS. NO.	: 84/823804	PROGRAMMER :	1

NETZWERK 1 0000

```
**********************************************************************
*                                                                    *
*                          CICLETIME                                 *
*                                                                    *
**********************************************************************
NAME :ZYKLZEIT

0005       :A   DB  30     -DB  30
0006       :UN  T   14     -T  14
0007       :SPB =M001
0008       :L   DW  20
0009       :T   DW  21
000A       :L   KH 0000
000C       :T   DW  20
000D M001  :
000E       :L   DW  20
000F       :L   KF +1
0011       :+F
0012       :T   DW  20
0013       :UN  T   14     -T  14
0014       :L   KT 100.1
0016       :SE  T   14     -T  14
0017       :BE

T   14   = T  14                    CICLETIME

DB  30   = DB  30                   CALCULATION DATA
```

NETZWERK 1 0000

```
**************************************************************************
*                                                                        *
*                          SUB DATAWORD FROM DATAWORD                    *
*                                                                        *
**************************************************************************
NAME :SUBTRA
BEZ  :SUB1      E/A/D/B/T/Z: E  BI/BY/W/D: W
BEZ  :SUB2      E/A/D/B/T/Z: E  BI/BY/W/D: W
BEZ  :SUB3      E/A/D/B/T/Z: A  BI/BY/W/D: W
BEZ  :DB        E/A/D/B/T/Z: B

0011      :B   =DB
0012      :L   =SUB1
0013      :L   =SUB2
0014      :-F
0015      :T   =SUB3
0016      :BE
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                                   MOVE DATAWORD                             *
*                                                                             *
*******************************************************************************
NAME :TRANSFER
BEZ  :EING       E/A/D/B/T/Z: E  BI/BY/W/D: W
BEZ  :AUSG       E/A/D/B/T/Z: A  BI/BY/W/D: W
BEZ  :DB         E/A/D/B/T/Z: B

000E      :B   =DB
000F      :L   =EING
0010      :T   =AUSG
0011      :BE
```

```
FB 9    -FB   9                    C:SKIV06ST.S5D        BIB=8023     LAE=70

E    7.7 = E  7.7                  LENGTH CORRECTION 8 * 10^0
E    7.0 = E  7.0                  LENGTH CORRECTION 1 * 10^1
E    7.1 = E  7.1                  LENGTH CORRECTION 2 * 10^1
E    7.2 = E  7.2                  LENGTH CORRECTION 4 * 10^1
E    7.3 = E  7.3                  LENGTH CORRECTION 8 * 10^1
M   99.0 = M  99.0                 "0"-SIGNAL
MW  26   = MW 226                  BCD-VALUE FOR TREAD CORRECTION
E    6.7 = E  6.7                  LENGTH CORRECTION -

DB  30   = DB  30                  CALCULATION DATA

FB 240   = FB 240 S                BCD NUMBER ---> FIXED-POINT NUMBER
```

```
NETZWERK 1          0000

*******************************************************************************
*                                                                             *
*                              ADD DATAWORD TO DATAWORD                       *
*                                                                             *
*******************************************************************************
NAME :ADD
BEZ  :ADD1       E/A/D/B/T/Z: E  BI/BY/W/D: W
BEZ  :ADD2       E/A/D/B/T/Z: E  BI/BY/W/D: W
BEZ  :ADD3       E/A/D/B/T/Z: A  BI/BY/W/D: W
BEZ  :DB         E/A/D/B/T/Z: B

0011      :B    =DB
0012      :L    =ADD1
0013      :L    =ADD2
0014      :+F
0015      :T    =ADD3
0016      :BE
```

```
M  195.4 = M 195.4    BCD-DISPLAY LENGTH MEAS.DEVICE
A    3.0 = IWL 3.1    ACTUAL TREAD LENGTH 2.1 DECADE
M  195.5 = M 195.5    BCD-DISPLAY LENGTH MEAS.DEVICE
A    3.1 = IWL 3.2    ACTUAL TREAD LENGTH 2.2 DECADE
M  195.6 = M 195.6    BCD-DISPLAY LENGTH MEAS.DEVICE
A    3.2 = IWL 3.3    ACTUAL TREAD LENGTH 2.3 DECADE
M  195.7 = M 195.7    BCD-DISPLAY LENGTH MEAS.DEVICE
A    3.3 = IWL 3.4    ACTUAL TREAD LENGTH 2.4 DECADE
M  195.0 = M 195.0    BCD-DISPLAY LENGTH MEAS.DEVICE
A    3.4 = IWL 4.1    ACTUAL TREAD LENGTH 1.1 DECADE
M  195.1 = M 195.1    BCD-DISPLAY LENGTH MEAS.DEVICE
A    3.5 = IWL 4.2    ACTUAL TREAD LENGTH 1.2 DECADE
M  195.2 = M 195.2    BCD-DISPLAY LENGTH MEAS.DEVICE
A    3.6 = IWL 4.3    ACTUAL TREAD LENGTH 1.3 DECADE
M  195.3 = M 195.3    BCD-DISPLAY LENGTH MEAS.DEVICE
A    3.7 = IWL 4.4    ACTUAL TREAD LENGTH 1.4 DECADE

DB  30   = DB  30     CALCULATION DATA

FB 241   = FB 241 S   FIXED-POINT NUMBER ---> BCD NUMBER
```

```
NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                        VALUE FOR TREAD LENGTH CORRECTION                  *
*                                                                           *
*****************************************************************************
NAME :CORRECT

0005       :U   E    7.4  -E  7.4              10^0
0006       :=   M   27.0
0007       :U   E    7.5  -E  7.5
0008       :=   M   27.1
0009       :U   E    7.6  -E  7.6
000A       :=   M   27.2
000B       :U   E    7.7  -E  7.7
000C       :=   M   27.3
000D       :
000E       :U   E    7.0  -E  7.0              10^1
000F       :=   M   27.4
0010       :U   E    7.1  -E  7.1
0011       :=   M   27.5
0012       :U   E    7.2  -E  7.2
0013       :=   M   27.6
0014       :U   E    7.3  -E  7.3
0015       :=   M   27.7
0016       :
0017       :U   M   99.0  -M  99.0              10^2
0018       :=   M   26.0
0019       :U   M   99.0  -M  99.0
001A       :=   M   26.1
001B       :U   M   99.0  -M  99.0
001C       :=   M   26.2
001D       :U   M   99.0  -M  99.0
001E       :=   M   26.3
001F       :
0020       :U   M   99.0  -M  99.0              10^3
0021       :=   M   26.4
0022       :U   M   99.0  -M  99.0
0023       :=   M   26.5
0024       :U   M   99.0  -M  99.0
0025       :=   M   26.6
0026       :U   M   99.0  -M  99.0
0027       :=   M   26.7
0028       :
0029       :A   DB  30    -DB  30
002A       :SPA FB 240    -FB 240 S
002B NAME  :COD:B4
002C BCD   :    MW  26    -MW 226
002D SBCD  :    E    6.7  -E  6.7
002E DUAL  :    DW   8
002F       :                                  ##### CHECK MIN/MAX #############
0030       :L   DW   8                        CORRECTION
0031       :L   KF +99                        MAXIMUM
0033       :<=F
0034       :SPB =M001                         YES >> CORRECTION < MAXIMUM
0035       :T   DW   8
0036       :SPA =M002
0037 M001  :L   DW   8
0038       :L   KF -99                        MINIMUM
003A       :>=F
003B       :SPB =M002                         YES >> CORRECTION > MINIMUM
003C       :T   DW   8
003D M002  :
003E       :L   DW   8
003F       :T   DW  90
0040       :BE

E    7.4 = E  7.4                  LENGTH CORRECTION 1 * 10^0
E    7.5 = E  7.5                  LENGTH CORRECTION 2 * 10^0
E    7.6 = E  7.6                  LENGTH CORRECTION 4 * 10^0
```

```
006F      :=   A    0.3  -SWL 1.4
0070      :U   M  190.0  -M 190.0
0071      :=   A    0.4  -SWL 2.1
0072      :U   M  190.1  -M 190.1
0073      :=   A    0.5  -SWL 2.2
0074      :U   M  190.2  -M 190.2
0075      :=   A    0.6  -SWL 2.3
0076      :U   M  190.3  -M 190.3
0077      :=   A    0.7  -SWL 2.4
0078      :U   M  191.4  -M 191.4
0079      :=   A    1.0  -SWL 3.1
007A      :U   M  191.5  -M 191.5
007B      :=   A    1.1  -SWL 3.2
007C      :U   M  191.6  -M 191.6
007D      :=   A    1.2  -SWL 3.3
007E      :U   M  191.7  -M 191.7
007F      :=   A    1.3  -SWL 3.4
0080      :U   M  191.0  -M 191.0
0081      :=   A    1.4  -SWL 4.1
0082      :U   M  191.1  -M 191.1
0083      :=   A    1.5  -SWL 4.2
0084      :U   M  191.2  -M 191.2
0085      :=   A    1.6  -SWL 4.3
0086      :U   M  191.3  -M 191.3
0087      :=   A    1.7  -SWL 4.4
0088      :***
```

```
M    0.3 = M   0.3          CUTTING CICLE AUTOMATIC
M    0.1 = M   0.1          CUTTING CICLE MANUAL
M    0.2 = M   0.2          CUTTING CICLE SEMI AUTOMATIC
M   11.5 = M  11.5          WIND-UP START
MW 190   = MW 190           BCD-DISPALY PRESET TREAD LENGTH
M  190.4 = M 190.4          BCD-DISPLAY PRESET TREAD LENGTH
A    0.0 = SWL 1.1          PRESET TREAD LENGTH 4.1 DECADE
M  190.5 = M 190.5          BCD-DISPLAY PRESET TREAD LENGTH
A    0.1 = SWL 1.2          PRESET TREAD LENGTH 4.2 DECADE
M  190.6 = M 190.6          BCD-DISPLAY PRESET TREAD LENGTH
A    0.2 = SWL 1.3          PRESET TREAD LENGTH 4.3 DECADE
M  190.7 = M 190.7          BCD-DISPLAY PRESET TREAD LENGTH
A    0.3 = SWL 1.4          PRESET TREAD LENGTH 4.4 DECADE
M  190.0 = M 190.0          BCD-DISPLAY PRESET TREAD LENGTH
A    0.4 = SWL 2.1          PRESET TREAD LENGTH 3.1 DECADE
M  190.1 = M 190.1          BCD-DISPLAY PRESET TREAD LENGTH
A    0.5 = SWL 2.2          PRESET TREAD LENGTH 3.2 DECADE
M  190.2 = M 190.2          BCD-DISPLAY PRESET TREAD LENGTH
A    0.6 = SWL 2.3          PRESET TREAD LENGTH 3.3 DECADE
M  190.3 = M 190.3          BCD-DISPLAY PRESET TREAD LENGTH
A    0.7 = SWL 2.4          PRESET TREAD LENGTH 3.4 DECADE
M  191.4 = M 191.4          BCD-DISPLAY PRESET TREAD LENGTH
A    1.0 = SWL 3.1          PRESET TREAD LENGTH 2.1 DECADE
M  191.5 = M 191.5          BCD-DISPLAY PRESET TREAD LENGTH
A    1.1 = SWL 3.2          PRESET TREAD LENGTH 2.2 DECADE
M  191.6 = M 191.6          BCD-DISPLAY PRESET TREAD LENGTH
A    1.2 = SWL 3.3          PRESET TREAD LENGTH 2.3 DECADE
M  191.7 = M 191.7          BCD-DISPLAY PRESET TREAD LENGTH
A    1.3 = SWL 3.4          PRESET TREAD LENGTH 2.4 DECADE
M  191.0 = M 191.0          BCD-DISPLAY PRESET TREAD LENGTH
A    1.4 = SWL 4.1          PRESET TREAD LENGTH 1.1 DECADE
M  191.1 = M 191.1          BCD-DISPLAY PRESET TREAD LENGTH
A    1.5 = SWL 4.2          PRESET TREAD LENGTH 1.2 DECADE
M  191.2 = M 191.2          BCD-DISPLAY PRESET TREAD LENGTH
A    1.6 = SWL 4.3          PRESET TREAD LENGTH 1.3 DECADE
M  191.3 = M 191.3          BCD-DISPLAY PRESET TREAD LENGTH
A    1.7 = SWL 4.4          PRESET TREAD LENGTH 1.4 DECADE

FB 241   = FB 241 S         FIXED-POINT NUMBER ---> BCD NUMBER

NETZWERK 6          0089
0089      :BE
```

```
FB 8    -FB   8                    C:SKIV06ST.S5D        BIB=25102   LAE=54

NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                          LENGTH MEASURING DEVICE                          *
*                                                                           *
*****************************************************************************
NAME :LMD-DISP

0005      :A   DB  30     -DB  30
0006      :SPA FB 241     -FB 241 S
0007 NAME :COD:16
0008 DUAL :    DW 128
0009 SBCD :    M  200.0
000A BCD2 :    MB 200
000B BCD1 :    MW 194     -MW 194
000C      :
000D      :U   M  194.4   -M 194.4
000E      :=   A    2.0   -IWL 1.1
000F      :U   M  194.5   -M 194.5
0010      :=   A    2.1   -IWL 1.2
0011      :U   M  194.6   -M 194.6
0012      :=   A    2.2   -IWL 1.3
0013      :U   M  194.7   -M 194.7
0014      :=   A    2.3   -IWL 1.4
0015      :
0016      :U   M  194.0   -M 194.0
0017      :=   A    2.4   -IWL 2.1
0018      :U   M  194.1   -M 194.1
0019      :=   A    2.5   -IWL 2.2
001A      :U   M  194.2   -M 194.2
001B      :=   A    2.6   -IWL 2.3
001C      :U   M  194.3   -M 194.3
001D      :=   A    2.7   -IWL 2.4
001E      :
001F      :U   M  195.4   -M 195.4
0020      :=   A    3.0   -IWL 3.1
0021      :U   M  195.5   -M 195.5
0022      :=   A    3.1   -IWL 3.2
0023      :U   M  195.6   -M 195.6
0024      :=   A    3.2   -IWL 3.3
0025      :U   M  195.7   -M 195.7
0026      :=   A    3.3   -IWL 3.4
0027      :
0028      :U   M  195.0   -M 195.0
0029      :=   A    3.4   -IWL 4.1
002A      :U   M  195.1   -M 195.1
002B      :=   A    3.5   -IWL 4.2
002C      :U   M  195.2   -M 195.2
002D      :=   A    3.6   -IWL 4.3
002E      :U   M  195.3   -M 195.3
002F      :=   A    3.7   -IWL 4.4
0030      :BE

MW 194    = MW 194                  BCD-DISPLAY LENGTH MEASURING DEVICE
M  194.4  = M 194.4                 BCD-DISPLAY LENGTH MEAS.DEVICE
A    2.0  = IWL 1.1                 ACTUAL TREAD LENGTH 4.1 DECADE
M  194.5  = M 194.5                 BCD-DISPLAY LENGTH MEAS.DEVICE
A    2.1  = IWL 1.2                 ACTUAL TREAD LENGTH 4.2 DECADE
M  194.6  = M 194.6                 BCD-DISPLAY LENGTH MEAS.DEVICE
A    2.2  = IWL 1.3                 ACTUAL TREAD LENGTH 4.3 DECADE
M  194.7  = M 194.7                 BCD-DISPLAY LENGTH MEAS.DEVICE
A    2.3  = IWL 1.4                 ACTUAL TREAD LENGTH 4.4 DECADE
M  194.0  = M 194.0                 BCD-DISPLAY LENGTH MEAS.DEVICE
A    2.4  = IWL 2.1                 ACTUAL TREAD LENGTH 3.1 DECADE
M  194.1  = M 194.1                 BCD-DISPLAY LENGTH MEAS.DEVICE
A    2.5  = IWL 2.2                 ACTUAL TREAD LENGTH 3.2 DECADE
M  194.2  = M 194.2                 BCD-DISPLAY LENGTH MEAS.DEVICE
A    2.6  = IWL 2.3                 ACTUAL TREAD LENGTH 3.3 DECADE
M  194.3  = M 194.3                 BCD-DISPLAY LENGTH MEAS.DEVICE
A    2.7  = IWL 2.4                 ACTUAL TREAD LENGTH 3.4 DECADE

+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                    !
!ELASTOMERTECHNIK          WERK HARBURG ! SKIVER                             !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                      !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                   1!
+-----------------------------------------------------------------------------+
```

```
FB 7     -FB    7                          C:SKIV06ST.S5D        BIB=21013    LAE=143

NETZWERK 1          0000

*****************************************************************************
*                                                                           *
*                          NOMINAL VALUE TREAD LENGTH                       *
*                                                                           *
*****************************************************************************
NAME :VALUE-SO

0005       :SPA FB    9     -FB    9                 CORRECTION TREAD LENGTH
0006 NAME  :CORRECT
0007       :***

FB    9    = FB    9                        VALUE FOR TREAD LENGTH CORRECTION

NETZWERK 2          0008
0008       :A    DB   30     -DB   30
0009       :L    DW    8                              So FROM L1-BUS
000A       :T    DW   11                              So IN IMPULSE
000B       :L    DW   11
000C       :L    DW   11
000D       :+F                                        So IN IMPULSE
000E       :T    DW   11                              C  CORRECTION
000F       :L    DW   11
0010       :L    DW   11                              So FOR IP242
0011       :+F
0012       :T    DW   11
0013       :
0014       :
0015       :L    DW   31
0016       :T    DW   30
0017       :UN   M     0.3   -M    0.3
0018       :SPB =M001                                 YES >> NO FLANC SEMI-AUTOMATIC
0019       :L    DW   30                              So AUTOMATIC
001A       :L    DW   11                              So SEMI-AUTOMATIC
001B       :+F
001C       :T    DW   10
001D       :SPA =M002
001E M001  :U    M     0.2   -M    0.2
001F       :UN   M    17.5   -M   17.5
0020       :=    M    11.4   -M   11.4
0021       :U    M     0.2   -M    0.2
0022       :=    M    17.5   -M   17.5
0023       :UN   M    11.4   -M   11.4
0024       :SPB =M002
0025       :L    DW   30
0026       :T    DW   31
0027 M002  :***

M     0.3 = M    0.3                       CUTTING CICLE AUTOMATIC
M     0.2 = M    0.2                       CUTTING CICLE SEMI AUTOMATIC
M    17.5 = M   17.5                       HF SEMI-AUTOMATIC ON
M    11.4 = M   11.4                       IMPULS SEMI-AUTOMATIC ON

DB   30    = DB   30                       CALCULATION DATA

NETZWERK 3          0028       TREADS LONGER / SHORTER
0028       :O    M     0.2   -M    0.2
0029       :SPB FB   70     -FB   70                 TREADS LONGER
002A NAME  :SLIT +
002B       :UN   E     5.1   -30S1.2
002C       :L    KZ 010
002E       :S    Z     2     -Z    2
002F       :O    M     0.2   -M    0.2
0030       :SPB FB   71     -FB   71                 TREADS SHORTER
0031 NAME  :SLIT -
0032       :UN   E     5.0   -30S1.1
0033       :L    KZ 010
0035       :S    Z     3     -Z    3
0036       :***


+-----------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK                !                                !
!ELASTOMERTECHNIK          WERK HARBURG      !  SKIVER                        !
+-----------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE             !  DATE         :                !
! INSTALLATION     : TREAD-LINE              !  MODIFICATION:              PGNO!
! PROJECT POS. NO.: 84/823804                !  PROGRAMMER   :                1!
+-----------------------------------------------------------------------------+
```

```
FB 7    -FB   7                          C:SKIV06ST.S5D        BIB=21013   LAE=143

M    0.2 = M   0.2                       CUTTING CICLE SEMI AUTOMATIC
E    5.1 = 30S1.2                        TREAD LONGER        (CONTROL PANEL)
Z    2   = Z   2                         COUNTER TREAD LONGER
E    5.0 = 30S1.1                        TREAD SHORTER       (CONTROL PANEL)
Z    3   = Z   3                         COUNTER TREAD SHORTER

FB  70   = FB  70                        TREADS SHORTER
FB  71   = FB  71                        TREADS LONGER

NETZWERK 4          0037
0037      :A   DB  30     -DB  30
0038      :SPA FB  15     -FB  15 S
0039 NAME :GP:FPGP
003A Z12  :    DW  18                                  So IN I : FP H-WORD = 0 !!!
003B Z11  :    DW  10                                          : FP L-WORD
003C Z22  :    DW  12                                  So IN I : GP H-WORD
003D Z21  :    DW  13                                          : GP L-WORD
003E      :SPA FB  20     -FB  20 S
003F NAME :GP:DIV
0040 Z12  :    DW  12                                  So IN I : GP H-WORD
0041 Z11  :    DW  13                                          : GP L-WORD
0042 Z22  :    DW  14                                  I=IMPULSE/mm : GP H-WORD
0043 Z21  :    DW  15                                               : GP L-WORD
0044 OV   :    M  200.0
0045 FEH  :    M  200.1
0046 Z3=0 :    M  200.2
0047 Z32  :    DW  16                                  So IN mm : GP H-WORD
0048 Z31  :    DW  17                                           : GP L-WORD
0049      :SPA FB  16     -FB  16 S
004A NAME :GP:GPFP
004B Z12  :    DW  16                                  So IN mm : GP H-WORD
004C Z11  :    DW  17                                           : GP L-WORD
004D OV   :    M  200.0
004E Z2=0 :    M  200.1
004F Z22  :    DW  16                                  So IN mm : FP H-WORD
0050 Z21  :    DW  17                                           : FP L-WORD
0051      :***


DB  30   = DB  30                        CALCULATION DATA

FB  15   = FB  15 S                      FIXED-POINT NUMBER --> FLOATING-POINT N.
FB  20   = FB  20 S                      DIVIDE TWO FLOATING-POINT NUMBERS
FB  16   = FB  16 S                      FLOATING-POINT NUMBER --> FIXED-POINT N.

NETZWERK 5          0052
0052      :UN  M    0.3  -M   0.3
0053      :SPA =M001
0054      :L   DW  17
0055      :T   DW  37
0056      :SPA =M002
0057 M001 :O   M    0.1  -M   0.1
0058      :O   M    0.2  -M   0.2
0059      :SPB =M003
005A      :SPA =M002
005B M003 :L   DW  17
005C      :T   DW  37
005D M002 :UN  M   11.5  -M  11.5
005E      :SPB =M004
005F      :L   KF +0
0061      :T   DW  37
0062 M004 :SPA FB 241    -FB 241 S
0063 NAME :COD:16
0064 DUAL :    DW  37
0065 SBCD :    M  200.0
0066 BCD2 :    MB 200
0067 BCD1 :    MW 190    -MW 190
0068      :U   M  190.4  -M 190.4
0069      :=   A    0.0  -SWL 1.1
006A      :U   M  190.5  -M 190.5
006B      :=   A    0.1  -SWL 1.2
006C      :U   M  190.6  -M 190.6
006D      :=   A    0.2  -SWL 1.3
006E      :U   M  190.7  -M 190.7
+-------------------------------------------------------------------------------+
!       KRUPP KUNSTOFFTECHNIK          !                                       !
!ELASTOMERTECHNIK          WERK HARBURG ! SKIVER                                !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                        !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                     2!
+-------------------------------------------------------------------------------+
```

```
   63:      KH = 0000;                    #
   64:      KH = 0000;                    #
   65:      KH = 0000;                    #
   66:      KH = 0000;                    #
   67:      KH = 0000;                    #
   68:      KH = 0000;                    #
   69:      KH = 0000;                    #
   70:      KH = 0000;                    #
   71:      KH = 0000;                    #
   72:      KH = 0000;                    #
   73:      KH = 0000;                    #
   74:      KH = 0000;                    #
   75:      KH = 0000;                    ##################################
   76:      KH = 0000;                    %%%%%%%%%%%%%%%%%%%%%%%%%%%%%%%%%
   77:      KH = 0000;                    %
   78:      KH = 0000;                    % SEND DATAS TO 135-U
   79:      KH = 0000;                    %
   80:      KH = 2600;                    %%
   81:      KH = 0000;                    %
   82:      KH = 6008;                    % FLAG-BITS...... ---> DB21/DW4
   83:      KH = 0701;                    % FLAG-BITS...... ---> DB21/DW5
   84:      KH = 0000;                    % FLAG-BITS...... ---> DB21/DW6
   85:      KH = 0000;                    % COUNTER WIND-UP ---> DB21/DW7
   86:      KH = 0000;                    % IMPULSE WIND-UP ---> DB21/DW8
   87:      KH = 0000;                    % TREAD LENGTH... ---> DB21/DW9
   88:      KH = 0000;                    % SCRAP 0-899.LMD ---> DB21/DW10
   89:      KH = 0000;                    % SCRAP 900...LMD ---> DB21/DW11
   90:      KH = FFE5;                    % CORRECTION..... ---> DB21/DW12
   91:      KH = 0000;                    % Vconveyor...... ---> DB21/DW13
   92:      KH = 0000;                    %
   93:      KH = 0000;                    %%
   94:      KH = 0000;                    %%
   95:      KH = 0000;                    %%
   96:      KH = 0000;                    %%
   97:      KH = 0000;                    %%
   98:      KH = 0000;                    %%
   99:      KH = 0000;                    %%
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  113:      KH = 0000;                    %%
  114:      KH = 0000;                    %
  115:      KH = 0000;                    %%%%%%%%%%%%%%%%%%%%%%%%%%%%%%%%%
  116:      KH = 0000;
  117:      KH = 0000;
  118:      KH = 0000;
  119:      KH = 0000;
  120:      KH = 0000;                    Li (I) (LENGHT MEAS.DEV.)
  121:      KH = 0000;                    Li (I) GP : H-WORD
  122:      KH = 0000;                    Li (I) GP : L-WORD
  123:      KH = 0072;                    * IMPULSE/mm GP : H-WORD
  124:      KH = B41C;                    * IMPULSE/mm GP : L-WORD
  125:      KH = 0000;                    L (mm) GP : H-WORD
  126:      KH = 0000;                    L (mm) GP : L-WORD
  127:      KH = 0000;                    L (mm) FP : H-WORD = 0 !!!
  128:      KH = 0000;                    L (mm) FP : L-WORD
  129:      KH = 0000;
  130:      KH = 0000;
  131:      KH = 0000;
  132:      KH = 0000;
  133:      KH = 0000;
  134:      KH = 0000;
  135:      KH = 0000;
  136:      KH = 0000;
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137:      KH = 0000;
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200:      KH = 0000;
201:
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 67:      KH = 0000;
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 89:      KH = 0000;
 90:      KH = 0000;
 91:      KH = 0000;
 92:      KH = 0000;
 93:      KH = 0000;
 94:      KH = 0000;
 95:      KH = 0000;
 96:      KH = 0000;
 97:      KH = 0000;
 98:      KH = 0000;
 99:      KH = 0000;
100:
```

```
V  = SPEED CONVEYOR
So = PRESET TREAD LENGTH
L  = MEASURED LENGTH
Li = IMPULSES MEASURED TREAD LENGTH
I  = IMPULSE
*  = CONSTANT
FP = FIXED-POINT NUMBER
GP = FLOATING-POINT NUMBER

*******************************************************************************
     0:     KH = 0000;
     1:     KH = 07D0;                    * Vmanual (REVERSE)
     2:     KH = 0000;                    V - LINE
     3:     KH = 0000;                    V - CONVEYOR BELT(OUTPUT)
     4:     KH = 0000;                    V - CONVEYOR BELT(REAL)
     5:     KH = 1194;                    * Vmanual (FORWARD)
     6:     KH = 0384;                    * Vcreep AUTOMATIC (ca.4,4m/min)
     7:     KH = 03E8;                    * MAX SPEED FOR WIND-UP
     8:     KH = FFE5;                    CORRECTION (I) LENGTH MEAS.DEV.
     9:     KH = 0000;                    Si  (ACTUAL LENGHTH IMPULSE 242)
    10:     KH = 26CC;                    So  (IMPULSE)
    11:     KH = FF94;
    12:     KH = 0E4D;                    So : GP H-WORD
    13:     KH = 9800;                    So : GP L-WORD
    14:     KH = 0340;                    * IMPULSE/mm : GP H-WORD
    15:     KH = 0000;                    * IMPULSE/mm : GP L-WORD
    16:     KH = 0000;                    So FOR DISPLAY : FP H-WORD
    17:     KH = 09B3;                    So FOR DISPLAY : FP L-WORD
    18:     KH = 0000;                    * 0
    19:     KH = 000A;                    * 10
    20:     KH = 00A8;                    HELP CICLETIME
    21:     KH = 0120;                    10000/DW21 = CICLETIME IN ms
    22:     KH = 2108;
    23:     KH = 0825;
    24:     KH = 0004;                    FACTOR CHANGING TREAD LENGHT -
    25:     KH = 04B1;                    ANALOG INPUT LIGHT BARRIER
    26:     KH = 0000;
    27:     KH = 0000;
    28:     KH = 0000;
    29:     KH = 0000;
    30:     KH = 2738;                    So FROM 135-U (I)
    31:     KH = 2738;                    So FROM AUTO ---> SEMI-AUTOM.(I)
    32:     KH = 0000;
    33:     KH = 0004;                    FACTOR CHANGING TREAD LENGHT +
    34:     KH = 1390;                    LENGHT UNUSABLE STRIP
    35:     KH = 0000;
    36:     KH = 0000;
    37:     KH = 09CE;                    DISPLAY LENGTH
    38:     KH = 0000;
    39:     KH = 1388;                    * MH + SZ (I)
    40:     KH = 2600;                    ### RECEIVED DATAS FROM 135-U ##
    41:     KH = 0000;                    #
    42:     KH = 017C;                    # So (TREAD LENGHT;I) (DB20/DW3)
    43:     KH = 0050;                    # So IN mm .......<--- DB20/DW4
    44:     KH = 0036;                    # LINE SPEED......<--- DB20/DW5
    45:     KH = 0000;                    #                  <--- DB20/DW6
    46:     KH = 0026;                    # FLAG-BITS        <--- DB20/DW7
    47:     KH = FFEC;                    # Smax (I).........<--- DB20/DW8
    48:     KH = 0000;                    #
    49:     KH = 0000;                    #
    50:     KH = 0000;                    #
    51:     KH = 0000;                    #
    52:     KH = 0000;                    #
    53:     KH = 0000;                    #
    54:     KH = 0000;                    #
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    57:     KH = 0000;                    #
    58:     KH = 0000;                    #
    59:     KH = 0000;                    #
    60:     KH = 0000;                    #
    61:     KH = 0000;                    #
    62:     KH = 0000;                    #
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! SKIVER                               !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                     1!
+-------------------------------------------------------------------------------+
```

```
  0:     KH = 4442;
  1:     KH = 3120;
  2:     KH = 5446;
  3:     KH = 423A;
  4:     KH = 204F;
  5:     KH = 4231;
  6:     KH = 3320;
  7:     KH = 3130;
  8:     KH = 3020;
  9:     KH = 3B20;
 10:     KH = 5344;
 11:     KH = 503A;
 12:     KH = 2057;
 13:     KH = 4420;
 14:     KH = 3530;
 15:     KH = 3020;
 16:     KH = 3B20;
 17:     KH = 454E;
 18:     KH = 4420;
 19:
```

```
                    I  = IMPULSE
                    *  = CONSTANT
                    FP = FIXED-POINT NUMBER
                    GP = FLOATING-POINT NUMBER

*******************************************************************************
     0:      KH = 0000;
     1:      KH = 0000;
     2:      KH = 0000;
     3:      KH = 0000;
     4:      KH = 0000;
     5:      KH = 0000;
     6:      KH = 0000;
     7:      KH = 0000;
     8:      KH = 0000;
     9:      KH = 0000;
    10:      KH = 0000;
    11:      KH = 0000;
    12:      KH = 0000;
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    14:      KH = 0000;
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    16:      KH = 0000;
    17:      KH = 0000;
    18:      KH = 0000;
    19:      KH = 0000;
    20:      KH = 0000;
    21:      KH = 0000;
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    30:      KH = 0000;
    31:      KH = 0000;
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    61:      KH = 0000;
    62:      KH = 0000;
    63:      KH = 0000;
    64:      KH = 0000;
    65:      KH = 0000;
    66:      KH = 0000;
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG !  SKIVER                              !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        !  DATE        :                       !
! INSTALLATION     : TREAD-LINE         !  MODIFICATION:                 PGNO!
! PROJECT POS. NO.: 84/823804           !  PROGRAMMER  :                    1!
+-------------------------------------------------------------------------------+
```

QUERVERWEISLISTE: EINGAENGE

PB	1	:	BEARBEITET
PB	2	:	BEARBEITET
PB	3	:	BEARBEITET
PB	4	:	BEARBEITET
PB	5	:	BEARBEITET
PB	6	:	BEARBEITET
PB	8	:	BEARBEITET
PB	9	:	BEARBEITET
PB	10	:	BEARBEITET
PB	12	:	BEARBEITET
PB	13	:	BEARBEITET
PB	25	:	BEARBEITET
PB	26	:	BEARBEITET
PB	255	:	BEARBEITET
FB	7	:	BEARBEITET
FB	8	:	BEARBEITET
FB	9	:	BEARBEITET
FB	10	:	BEARBEITET
FB	11	:	BEARBEITET
FB	12	:	BEARBEITET
FB	13	:	BEARBEITET
FB	14	:	BEARBEITET
FB	15S	:	BEARBEITET
FB	16S	:	BEARBEITET
FB	17S	:	BEARBEITET
FB	18S	:	BEARBEITET
FB	19S	:	BEARBEITET
FB	20S	:	BEARBEITET
FB	21S	:	BEARBEITET
FB	30	:	BEARBEITET
FB	39	:	BEARBEITET
FB	50	:	BEARBEITET
FB	51	:	BEARBEITET
FB	60	:	BEARBEITET
FB	70	:	BEARBEITET
FB	71	:	BEARBEITET
FB	109	:	BEARBEITET
FB	110	:	BEARBEITET
FB	113	:	BEARBEITET
FB	114	:	BEARBEITET
FB	120	:	BEARBEITET
FB	121	:	BEARBEITET
FB	123	:	BEARBEITET
FB	125	:	BEARBEITET
FB	134	:	BEARBEITET
FB	140	:	BEARBEITET
FB	141	:	BEARBEITET
FB	142	:	BEARBEITET
FB	144	:	BEARBEITET
FB	149	:	BEARBEITET
FB	150	:	BEARBEITET
FB	151	:	BEARBEITET
FB	152	:	BEARBEITET
FB	153	:	BEARBEITET
FB	154	:	BEARBEITET
FB	155	:	BEARBEITET
FB	202	:	BEARBEITET
FB	238	:	BEARBEITET
FB	239	:	BEARBEITET
FB	240S	:	BEARBEITET
FB	241S	:	BEARBEITET
FB	242S	:	BEARBEITET
FB	243S	:	BEARBEITET
FB	244	:	BEARBEITET
FB	245	:	BEARBEITET
FB	246	:	BEARBEITET
FB	247	:	BEARBEITET
FB	248	:	BEARBEITET
FB	249	:	BEARBEITET
FB	250	:	BEARBEITET
FB	251	:	BEARBEITET
FB	255	:	BEARBEITET
OB	1	:	BEARBEITET
OB	2	:	BEARBEITET

QUERVERWEISLISTE: EINGAENGE

OB 20 : BEARBEITET
OB 21 : BEARBEITET
OB 22 : BEARBEITET
OB 31 : BEARBEITET

QUERVERWEISLISTE: EINGAENGE

E	0.0 -12A5	PB 3	13
E	0.1 -15Q1	PB 3	18
		PB 4	5
		PB 25	3?
E	0.3 -15Q5	PB 3	18
		PB 25	2?
E	0.5 -16Q5	PB 3	18
		PB 25	3?
E	1.0 -21A1.1	PB 12	3 , 4
		PB 25	4?
E	1.3 -26S4	PB 3	14 , 18 , 28 , 29
		PB 4	2 , 3
E	1.5 -26S6	PB 9	5 , 10
		PB 10	2
		FB120	2
E	1.6 -26S7	PB 3	18
		PB 25	2?
E	2.0 -27S1	PB 3	28 , 29
		PB 4	4 , 6 , 9
		PB 5	7 , 13
		PB 8	2 , 5 , 9
		PB 13	1
		PB 25	3?
E	2.1 -27S2	PB 4	7 , 10 , 11 , 19
		PB 5	11
		PB 8	5
		PB 13	1
		PB 25	2?
E	2.2 -27S3	PB 5	8
E	2.3 -27S4	PB 5	9
E	2.4 -27S5	PB 5	10 , 18
E	2.5 -E 2.5	PB 6	3 , 5
E	2.7 -E 2.7	PB 3	15
E	3.0 -17A1.1	PB 25	4?
E	3.1 -17A1.2	PB 3	16
		PB 6	3
E	3.2 -10F3	PB 3	17
E	3.3 -9S1	PB 3	18
		PB 25	4?
E	3.4 -28S5.1	PB 3	3 , 4 , 5 , 6
		PB 8	5 , 9 , 17
E	3.5 -28S5.2	PB 3	3 , 4 , 5 , 6
		PB 8	9 , 11 , 12
E	4.0 -29S1.1	PB 4	2 , 3
E	4.1 -29S1.2	PB 4	4
E	4.2 -29S3	PB 4	6
E	4.3 -29S4	PB 3	10 , 31
		PB 5	2
		PB 8	9 , 11

QUERVERWEISLISTE: EINGAENGE

			PB 13	6
E	4.4 -29S5		PB 3	30
			PB 13	6
E	4.5 -29S6		PB 8	5 , 18 , 19
E	4.6 -E	4.6	PB 3	19 , 21 , 24 , 25
E	4.7 -A220		PB 3	18
			PB 25	4?
E	5.0 -30S1.1		FB 7	3
			FB 71	2
E	5.1 -30S1.2		FB 7	3
			FB 70	2
E	5.3 -E	5.3	PB 8	3 , 4
E	6.3 -E	6.3	FB120	2
E	6.7 -E	6.7	FB 9	1?
E	7.0 -E	7.0	FB 9	1
E	7.1 -E	7.1	FB 9	1
E	7.2 -E	7.2	FB 9	1
E	7.3 -E	7.3	FB 9	1
E	7.4 -E	7.4	FB 9	1
E	7.5 -E	7.5	FB 9	1
E	7.6 -E	7.6	FB 9	1
E	7.7 -E	7.7	FB 9	1
E	32.1 -		PB 6	2?
EB	3 -		PB 6	3*

QUERVERWEISLISTE: AUSGAENGE

PB	1	: BEARBEITET
PB	2	: BEARBEITET
PB	3	: BEARBEITET
PB	4	: BEARBEITET
PB	5	: BEARBEITET
PB	6	: BEARBEITET
PB	8	: BEARBEITET
PB	9	: BEARBEITET
PB	10	: BEARBEITET
PB	12	: BEARBEITET
PB	13	: BEARBEITET
PB	25	: BEARBEITET
PB	26	: BEARBEITET
PB	255	: BEARBEITET
FB	7	: BEARBEITET
FB	8	: BEARBEITET
FB	9	: BEARBEITET
FB	10	: BEARBEITET
FB	11	: BEARBEITET
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FB	13	: BEARBEITET
FB	14	: BEARBEITET
FB	15S	: BEARBEITET
FB	16S	: BEARBEITET
FB	17S	: BEARBEITET
FB	18S	: BEARBEITET
FB	19S	: BEARBEITET
FB	20S	: BEARBEITET
FB	21S	: BEARBEITET
FB	30	: BEARBEITET
FB	39	: BEARBEITET
FB	50	: BEARBEITET
FB	51	: BEARBEITET
FB	60	: BEARBEITET
FB	70	: BEARBEITET
FB	71	: BEARBEITET
FB	109	: BEARBEITET
FB	110	: BEARBEITET
FB	113	: BEARBEITET
FB	114	: BEARBEITET
FB	120	: BEARBEITET
FB	121	: BEARBEITET
FB	123	: BEARBEITET
FB	125	: BEARBEITET
FB	134	: BEARBEITET
FB	140	: BEARBEITET
FB	141	: BEARBEITET
FB	142	: BEARBEITET
FB	144	: BEARBEITET
FB	149	: BEARBEITET
FB	150	: BEARBEITET
FB	151	: BEARBEITET
FB	152	: BEARBEITET
FB	153	: BEARBEITET
FB	154	: BEARBEITET
FB	155	: BEARBEITET
FB	202	: BEARBEITET
FB	238	: BEARBEITET
FB	239	: BEARBEITET
FB	240S	: BEARBEITET
FB	241S	: BEARBEITET
FB	242S	: BEARBEITET
FB	243S	: BEARBEITET
FB	244	: BEARBEITET
FB	245	: BEARBEITET
FB	246	: BEARBEITET
FB	247	: BEARBEITET
FB	248	: BEARBEITET
FB	249	: BEARBEITET
FB	250	: BEARBEITET
FB	251	: BEARBEITET
FB	255	: BEARBEITET
OB	1	: BEARBEITET
OB	2	: BEARBEITET

QUERVERWEISLISTE: AUSGAENGE

OB 20 : BEARBEITET
OB 21 : BEARBEITET
OB 22 : BEARBEITET
OB 31 : BEARBEITET

QUERVERWEISLISTE: AUSGAENGE

A	0.0 -SWL 1.1	FB	7	5*
A	0.1 -SWL 1.2	FB	7	5*
A	0.2 -SWL 1.3	FB	7	5*
A	0.3 -SWL 1.4	FB	7	5*
A	0.4 -SWL 2.1	FB	7	5*
A	0.5 -SWL 2.2	FB	7	5*
A	0.6 -SWL 2.3	FB	7	5*
A	0.7 -SWL 2.4	FB	7	5*
A	1.0 -SWL 3.1	FB	7	5*
A	1.1 -SWL 3.2	FB	7	5*
A	1.2 -SWL 3.3	FB	7	5*
A	1.3 -SWL 3.4	FB	7	5*
A	1.4 -SWL 4.1	FB	7	5*
A	1.5 -SWL 4.2	FB	7	5*
A	1.6 -SWL 4.3	FB	7	5*
A	1.7 -SWL 4.4	FB	7	5*
A	2.0 -IWL 1.1	FB	8	1*
A	2.1 -IWL 1.2	FB	8	1*
A	2.2 -IWL 1.3	FB	8	1*
A	2.3 -IWL 1.4	FB	8	1*
A	2.4 -IWL 2.1	FB	8	1*
A	2.5 -IWL 2.2	FB	8	1*
A	2.6 -IWL 2.3	FB	8	1*
A	2.7 -IWL 2.4	FB	8	1*
A	3.0 -IWL 3.1	FB	8	1*
A	3.1 -IWL 3.2	FB	8	1*
A	3.2 -IWL 3.3	FB	8	1*
A	3.3 -IWL 3.4	FB	8	1*
A	3.4 -IWL 4.1	FB	8	1*
A	3.5 -IWL 4.2	FB	8	1*
A	3.6 -IWL 4.3	FB	8	1*
A	3.7 -IWL 4.4	FB	8	1*
A	4.0 -A 4.0	PB	12	11*
A	4.1 -37K2	PB	3	12 , 13
		PB	8	14*
A	4.2 -A 4.2	PB	8	15*
A	4.4 -37K5	PB	4	5*, 6 , 19

QUERVERWEISLISTE: AUSGAENGE

A	4.5 -37K6	PB	5	16*
A	4.6 -A 4.6	PB	3	24*
A	4.7 -37K8	PB	3	32
		PB	8	13*
A	5.0 -38K1	PB	5	17*
A	5.1 -38K2	PB	5	18*
A	5.2 -38K3	PB	5	19*
A	5.3 -38K4	PB	4	8
		PB	5	15*
A	5.5 -38K6	PB	5	20*
A	6.1 -39H2	PB	3	26*
A	6.2 -39H3	PB	3	27*
A	6.3 -39H4	PB	3	29*
A	6.4 -39H5	PB	4	5*
A	6.5 -A 6.5	PB	8	16*
A	7.0 -A 7.0	PB	8	18*
A	7.1 -A 7.1	PB	8	18 , 19*
A	7.2 -A 7.2	PB	8	8*
		FB120		2*
A	112.0 -	PB	8	24?

QUERVERWEISLISTE: MERKER

```
    PB     1 : BEARBEITET
    PB     2 : BEARBEITET
    PB     3 : BEARBEITET
    PB     4 : BEARBEITET
    PB     5 : BEARBEITET
    PB     6 : BEARBEITET
    PB     8 : BEARBEITET
    PB     9 : BEARBEITET
    PB    10 : BEARBEITET
    PB    12 : BEARBEITET
    PB    13 : BEARBEITET
    PB    25 : BEARBEITET
    PB    26 : BEARBEITET
    PB   255 : BEARBEITET
    FB     7 : BEARBEITET
    FB     8 : BEARBEITET
    FB     9 : BEARBEITET
    FB    10 : BEARBEITET
    FB    11 : BEARBEITET
    FB    12 : BEARBEITET
    FB    13 : BEARBEITET
    FB    14 : BEARBEITET
    FB   15S: BEARBEITET
    FB   16S: BEARBEITET
    FB   17S: BEARBEITET
    FB   18S: BEARBEITET
    FB   19S: BEARBEITET
    FB   20S: BEARBEITET
    FB   21S: BEARBEITET
    FB    30 : BEARBEITET
    FB    39 : BEARBEITET
    FB    50 : BEARBEITET
    FB    51 : BEARBEITET
    FB    60 : BEARBEITET
    FB    70 : BEARBEITET
    FB    71 : BEARBEITET
    FB   109 : BEARBEITET
    FB   110 : BEARBEITET
    FB   113 : BEARBEITET
    FB   114 : BEARBEITET
    FB   120 : BEARBEITET
    FB   121 : BEARBEITET
    FB   123 : BEARBEITET
    FB   125 : BEARBEITET
    FB   134 : BEARBEITET
    FB   140 : BEARBEITET
    FB   141 : BEARBEITET
    FB   142 : BEARBEITET
    FB   144 : BEARBEITET
    FB   149 : BEARBEITET
    FB   150 : BEARBEITET
    FB   151 : BEARBEITET
    FB   152 : BEARBEITET
    FB   153 : BEARBEITET
    FB   154 : BEARBEITET
    FB   155 : BEARBEITET
    FB   202 : BEARBEITET
    FB   238 : BEARBEITET
    FB   239 : BEARBEITET
    FB   240S: BEARBEITET
    FB   241S: BEARBEITET
    FB   242S: BEARBEITET
    FB   243S: BEARBEITET
    FB   244 : BEARBEITET
    FB   245 : BEARBEITET
    FB   246 : BEARBEITET
    FB   247 : BEARBEITET
    FB   248 : BEARBEITET
    FB   249 : BEARBEITET
    FB   250 : BEARBEITET
    FB   251 : BEARBEITET
    FB   255 : BEARBEITET
    OB     1 : BEARBEITET
    OB     2 : BEARBEITET
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! SKIVER                               !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                     1!
+-------------------------------------------------------------------------------+
```

QUERVERWEISLISTE: MERKER

```
   OB    20 : BEARBEITET
   OB    21 : BEARBEITET
   OB    22 : BEARBEITET
   OB    31 : BEARBEITET
```

QUERVERWEISLISTE: MERKER

M	0.0 -M	0.0	PB 8	17
M	0.1 -M	0.1	PB 3	3*, 28 , 31
			PB 4	3 , 4 , 6
			PB 5	2
			PB 8	13 , 14 , 16
			FB 7	5
			FB120	2
M	0.2 -M	0.2	PB 3	4*, 28 , 31
			PB 4	3 , 4
			PB 5	3
			PB 8	13 , 14 , 16
			FB 7	2 , 3 , 5
			FB120	2
			FB123	1
M	0.3 -M	0.3	PB 3	5*, 28 , 31
			PB 4	2
			PB 5	4
			PB 8	13 , 14
			FB 7	2 , 5
M	0.4 -M	0.4	PB 3	29*, 31
			PB 5	2 , 3 , 4
			PB 8	5 , 9 , 11
M	0.5 -M	0.5	PB 3	31
			PB 4	4
			PB 5	2 , 3 , 4 , 12*, 13
			PB 8	5 , 9 , 11
			PB 13	1
M	0.6 -M	0.6	PB 4	10*
			PB 5	13 , 18
			PB 8	5 , 9
			FB153	1*
M	0.7 -M	0.7	PB 5	13*
M	1.0 -M	1.0	PB 5	2*, 5
			PB 13	1
M	1.1 -M	1.1	PB 4	11 , 12 , 19
			PB 5	5*, 6 , 16
			PB 13	1
			FB153	1*
M	1.2 -M	1.2	PB 4	13 , 16 , 17 , 18
			PB 5	5 , 6*, 7 , 12 , 16
			PB 13	1
			FB153	1*
M	1.3 -M	1.3	PB 5	6 , 7*, 8 , 14 , 16
			FB153	1*
M	1.4 -M	1.4	PB 4	17
			PB 5	7 , 8*, 9 , 14 , 16
			FB153	1*
M	1.5 -M	1.5	PB 4	11 , 13 , 16 , 19 , 20
			PB 5	8 , 9*, 10 , 16
			PB 9	9
			FB 60	2
			FB120	2
			FB153	1*
M	1.6 -M	1.6	PB 4	15 , 21
			PB 5	9 , 10*, 11 , 16
			FB120	2
			FB153	1*
M	1.7 -M	1.7	PB 4	15

QUERVERWEISLISTE: MERKER

			PB 5	10 , 11*, 12
			PB 8	11
			PB 9	3
			OB 1	1
M	2.0 -M	2.0	PB 3	13*
			PB 25	3?
M	2.1 -M	2.1	PB 8	5*, 6 , 7 , 8 , 17 , 18 , 19 , 22
			PB 13	1
M	2.2 -M	2.2	PB 8	9*, 10 , 17 , 18 , 19 , 22
			PB 13	1
			FB153	1*
M	2.3 -M	2.3	PB 8	12*, 15 , 16 , 17 , 18 , 19 , 20?, 22 , 24
			FB120	2
			FB153	1*
M	2.5 -M	2.5	PB 3	28*, 29
			PB 25	5?
M	2.6 -M	2.6	PB 3	32*
			PB 4	6
			PB 25	5?
M	2.7 -M	2.7	PB 12	9 , 10
			PB 26	3?
M	3.0 -M	3.0	PB 5	3 , 4 , 14*
			PB 8	9 , 12 , 16 , 17
			FB 60	2*
			FB120	2*
			FB123	1*
			FB153	1*
			OB 1	1
M	3.1 -M	3.1	PB 3	30 , 31*
			PB 4	19
			PB 5	4
			PB 8	11
			FB153	1*
M	3.2 -M	3.2	PB 3	14*
			PB 25	4?
M	3.3 -M	3.3	PB 4	13*, 14
			FB153	1*
M	3.4 -M	3.4	PB 4	15*
			PB 5	18
			FB153	1*
M	3.5 -M	3.5	PB 4	16*
			PB 5	17
			FB153	1*
M	3.6 -M	3.6	PB 4	17*
			PB 5	20
			FB153	1*
M	3.7 -M	3.7	PB 4	19*
			PB 5	19
			FB153	1*
M	4.0 -M	4.0	PB 3	8 , 9 , 31
			PB 12	8 , 11 , 12 , 15
			PB 13	1 , 4
			PB 26	2?
M	4.1 -M	4.1	PB 26	2?
M	4.2 -M	4.2	PB 5	3*, 5
			PB 13	1

QUERVERWEISLISTE: MERKER

M	4.3 -M	4.3	PB 5	4*, 5
			PB 13	1
M	4.4 -M	4.4	PB 4	11*
			PB 5	15
			PB 8	5 , 9 , 11
			FB153	1*
M	4.5 -M	4.5	PB 3	30*, 31
			FB153	1*
M	4.6 -M	4.6	PB 4	6*, 7
			PB 5	16
M	4.7 -M	4.7	PB 3	6*, 10 , 30 , 31
			PB 8	12
			PB 25	5?
M	5.0 -M	5.0	OB 1	1*
			OB 2	1*
M	5.1 -M	5.1	PB 4	7*, 8 , 9 , 10 , 11 , 19 , 20
			PB 5	15 , 16
			FB153	1*
M	5.2 -M	5.2	PB 4	9*
			PB 5	16 , 18
			FB153	1*
M	5.3 -M	5.3	FB121	1*
			OB 1	1*
M	5.4 -M	5.4	PB 3	17*
			PB 25	3?
M	5.5 -M	5.5	PB 10	2*, 3?, 4 , 5
			PB 25	2?
			FB153	1*
M	5.6 -M	5.6	PB 8	17*, 18
M	5.7 -M	5.7	PB 9	5*, 6?, 8
			PB 10	5*
M	6.0 -M	6.0	PB 4	2*, 5
			FB153	1*
M	6.1 -M	6.1	PB 4	3*, 5
			FB153	1*
M	6.2 -M	6.2	PB 4	5
M	6.3 -M	6.3	PB 4	4*, 5
M	6.4 -M	6.4	PB 3	28 , 29
			PB 4	5*
			FB153	1*
M	6.5 -M	6.5	PB 26	2?
M	6.6 -M	6.6	PB 3	7*, 18
M	6.7 -M	6.7	PB 3	3 , 4 , 5 , 20*, 28 , 29 , 30 , 31
			PB 4	2 , 5 , 7 , 9 , 10 , 11 , 13 , 15 , 16 , 17
			PB 5	2 , 5 , 6 , 7 , 8 , 9 , 10 , 12 , 16 , 19
			PB 6	4
			PB 8	5 , 9 , 12 , 16
			PB 10	2
			PB 12	5
			PB 13	6
			PB 25	5?
			FB 60	2
			FB120	2

QUERVERWEISLISTE: MERKER

M	7.0 -M	7.0	PB 3	23*
M	7.1 -M	7.1	PB 3	23*, 24
M	7.2 -M	7.2	PB 3	22 , 24*
M	7.3 -M	7.3	PB 3	7*
M	7.4 -M	7.4	PB 8	5
			PB 12	2
			PB 13	1 , 4 , 6 , 7
			PB 26	2?
M	7.5 -M	7.5	PB 3	21*, 26
M	7.6 -M	7.6	PB 3	25*, 26
M	7.7 -M	7.7	PB 3	28 , 31
			PB 8	11
			PB 13	1
			PB 26	2?
M	8.0 -M	8.0	PB 3	11 , 27
			PB 26	2?
M	8.1 -M	8.1	PB 3	19 , 21 , 24
			PB 26	2?
M	8.2 -M	8.2	PB 3	7 , 27
			PB 26	3?
M	8.3 -M	8.3	PB 3	8*
M	8.4 -M	8.4	PB 3	8*, 10 , 31
			PB 8	11
			PB 13	6
M	8.5 -M	8.5	PB 8	11*, 12
M	8.6 -M	8.6	PB 3	9*
M	8.7 -M	8.7	PB 3	9*, 10 , 30 , 31
			PB 8	12
			PB 13	6
M	9.0 -M	9.0	PB 4	12*
			PB 5	6
M	9.1 -M	9.1	PB 4	14*
M	9.2 -M	9.2	PB 3	18
			PB 4	18*
			PB 25	2?
M	9.3 -M	9.3	PB 3	18
			PB 4	20*
			PB 25	2?
M	9.4 -M	9.4	PB 3	18
			PB 4	21*
			PB 25	2?
M	9.5 -M	9.5	PB 25	3?
M	9.6 -M	9.6	PB 3	16*
			PB 25	4?
M	9.7 -M	9.7	PB 3	20*
			PB 8	15
			FB120	2*
			FB123	1*
			FB153	1*

QUERVERWEISLISTE: MERKER

M	10.0	-M 10.0	FB 70	2*
M	10.1	-M 10.1	FB 70	2
M	10.2	-M 10.2	FB 71	2*
M	10.3	-M 10.3	FB 71	2
M	10.4	-M 10.4	PB 8	16*
M	10.5	-M 10.5	PB 13	4*
M	10.6	-M 10.6	FB 60	2*
			FB120	2*
M	10.7	-M 10.7	PB 26	2?
M	11.0	-M 11.0	PB 3	18*, 19 , 23
M	11.2	-M 11.2	PB 8	20?
M	11.3	-M 11.3	PB 8	20?
M	11.4	-M 11.4	FB 7	2*
			FB120	2
M	11.5	-M 11.5	PB 3	30 , 31
			PB 4	2 , 3 , 4 , 6
			PB 5	1
			PB 8	5 , 9 , 11 , 12
			PB 9	1
			PB 10	1
			PB 13	1*, 2 , 6 , 7
			FB 7	5
			FB120	2
			FB123	1
			OB 1	1
M	11.6	-M 11.6	PB 13	2*
M	11.7	-M 11.7	PB 13	2*, 3
M	12.0	-M 12.0	PB 3	10*
			PB 8	11
M	12.1	-M 12.1	PB 9	3*, 4
			FB153	1*
M	12.2	-M 12.2	PB 8	13 , 16 , 17 , 18 , 19 , 21 , 22
			PB 13	6*
M	12.3	-M 12.3	PB 13	7*
			FB123	1*
M	12.4	-M 12.4	PB 9	3*
			FB 39	2*
			FB153	1*
M	12.5	-M 12.5	PB 9	4*, 5 , 9 , 10
			PB 10	5*
			FB120	2
			FB153	1*
M	12.6	-M 12.6	PB 12	13*, 14
M	13.5	-M 13.5	PB 13	4*, 5
M	13.6	-M 13.6	PB 6	3*
M	13.7	-M 13.7	PB 3	19*, 20 , 21 , 25 , 26
M	14.0	-M 14.0	PB 12	2*
M	14.1	-M 14.1	PB 12	2*

QUERVERWEISLISTE: MERKER

M	14.2	-M	14.2	PB 12	4*
M	14.3	-M	14.3	PB 12	4*, 5
M	14.4	-M	14.4	PB 8	2*
M	14.5	-M	14.5	PB 8	2*
				FB120	2
M	14.6	-M	14.6	FB120	2*
M	14.7	-M	14.7	PB 12	12 , 14
				PB 13	7
				PB 26	3?
M	15.0	-M	15.0	PB 6	6*
M	15.1	-M	15.1	PB 12	5*, 6
M	15.2	-M	15.2	PB 12	7*
M	15.3	-M	15.3	PB 12	7*
M	15.4	-M	15.4	PB 12	5 , 6*, 7
M	15.5	-M	15.5	PB 12	11 , 12 , 15*
				FB 30	1*
M	15.6	-M	15.6	PB 12	8*, 9 , 10
M	16.0	-M	16.0	PB 6	3*, 7 , 8
M	16.1	-M	16.1	PB 6	3*, 4 , 7 , 8
				PB 8	16 , 21
				FB120	2
M	16.2	-M	16.2	PB 6	4*
M	16.3	-M	16.3	PB 6	6*
M	16.4	-M	16.4	PB 6	5*
				PB 25	2?
M	16.5	-M	16.5	PB 3	11*
M	16.6	-M	16.6	PB 6	8*
M	16.7	-M	16.7	PB 6	7*
M	17.0	-M	17.0	PB 9	2
				PB 10	3?
M	17.1	-M	17.1	PB 9	6?, 7
M	17.2	-M	17.2	PB 9	4 , 9*
				PB 10	2 , 5*
				FB153	1*
M	17.3	-M	17.3	PB 9	6?
M	17.4	-M	17.4	PB 10	3?
M	17.5	-M	17.5	FB 7	2*
M	17.6	-M	17.6	FB 70	2?
M	17.7	-M	17.7	FB 70	2?
M	18.0	-M	18.0	FB 70	2
M	18.1	-M	18.1	FB 71	2?
M	18.2	-M	18.2	FB 71	2?

QUERVERWEISLISTE: MERKER

M	18.3 -M	18.3	FB 71	2
M	18.4 -M	18.4	PB 3	15*
			PB 25	3?
M	18.5 -M	18.5	PB 3	11*, 20
M	19.0 -M	19.0	PB 12	15*
			FB 30	1*
M	19.1 -M	19.1	PB 12	15*
			FB 30	1*
M	20.0 -M	20.0	FB123	1*
			OB 1	1*
M	20.1 -M	20.1	FB123	1*
			OB 1	1*
M	20.2 -M	20.2	PB 12	8 , 9*, 11 , 15
M	20.3 -M	20.3	PB 12	8 , 10*, 11 , 15
M	20.5 -M	20.5	PB 12	3*
M	20.6 -M	20.6	PB 12	3*, 8
M	24.0 -M	24.0	PB 1	2*
M	24.1 -M	24.1	PB 1	2*
M	24.2 -M	24.2	PB 1	2*
			PB 3	22 , 24 , 26
M	24.3 -M	24.3	PB 1	3*
			FB 70	2
			FB 71	2
M	24.4 -M	24.4	PB 1	3*
M	24.5 -M	24.5	PB 1	3*
M	26.0 -		FB 9	1*
M	26.1 -		FB 9	1*
M	26.2 -		FB 9	1*
M	26.3 -		FB 9	1*
M	26.4 -		FB 9	1*
M	26.5 -		FB 9	1*
M	26.6 -		FB 9	1*
M	26.7 -		FB 9	1*
M	27.0 -		FB 9	1*
M	27.1 -		FB 9	1*
M	27.2 -		FB 9	1*
M	27.3 -		FB 9	1*
M	27.4 -		FB 9	1*
M	27.5 -		FB 9	1*
M	27.6 -		FB 9	1*
M	27.7 -		FB 9	1*

QUERVERWEISLISTE: MERKER

M	61.7	-M 61.7	FB114	1*	
M	62.0	-M 62.0	FB114	1	
M	62.7	-M 62.7	FB114	1*	
M	99.0	-M 99.0	PB 3	2*	
			PB 6	2?	
			PB 8	23?	
			PB 25	3?, 4?, 5?	
			FB 9	1	
M	99.1	-M 99.1	PB 3	2*	
			PB 13	7	
			FB123	1	
			FB153	1	
M	135.0	-M 135.0	FB114	1*	
M	135.1	-M 135.1	FB114	1*	
M	135.2	-M 135.2	FB114	1*	
M	135.3	-M 135.3	FB114	1*	
M	160.7	-M 160.7	FB120	2	
			FB121	1	
			FB123	1	
			FB140	1	
			FB141	2	
			FB142	1	
			FB144	2	
			FB149	1	
			FB150	1	
			FB151	1	
			FB152	2	
			FB154	1	
			FB155	1	
M	190.0	-M 190.0	FB 7	5	
M	190.1	-M 190.1	FB 7	5	
M	190.2	-M 190.2	FB 7	5	
M	190.3	-M 190.3	FB 7	5	
M	190.4	-M 190.4	FB 7	5	
M	190.5	-M 190.5	FB 7	5	
M	190.6	-M 190.6	FB 7	5	
M	190.7	-M 190.7	FB 7	5	
M	191.0	-M 191.0	FB 7	5	
M	191.1	-M 191.1	FB 7	5	
M	191.2	-M 191.2	FB 7	5	
M	191.3	-M 191.3	FB 7	5	
M	191.4	-M 191.4	FB 7	5	
M	191.5	-M 191.5	FB 7	5	
M	191.6	-M 191.6	FB 7	5	
M	191.7	-M 191.7	FB 7	5	
M	194.0	-M 194.0	FB 8	1	

QUERVERWEISLISTE: MERKER

M	194.1	-M 194.1	FB	8	1
M	194.2	-M 194.2	FB	8	1
M	194.3	-M 194.3	FB	8	1
M	194.4	-M 194.4	FB	8	1
M	194.5	-M 194.5	FB	8	1
M	194.6	-M 194.6	FB	8	1
M	194.7	-M 194.7	FB	8	1
M	195.0	-M 195.0	FB	8	1
M	195.1	-M 195.1	FB	8	1
M	195.2	-M 195.2	FB	8	1
M	195.3	-M 195.3	FB	8	1
M	195.4	-M 195.4	FB	8	1
M	195.5	-M 195.5	FB	8	1
M	195.6	-M 195.6	FB	8	1
M	195.7	-M 195.7	FB	8	1
M	200.0	-	PB	2	1?
			PB	3	22*
			PB	6	2?
			PB	8	23?, 24?
			FB	7	4?, 5?
			FB	8	1?
			FB120		2*
			FB125		1?
M	200.1	-	PB	2	1?
			PB	8	23?
			FB	7	4?
			FB125		1?
M	200.2	-	PB	2	1?
			PB	8	23?
			FB	7	4?
			FB125		1?
M	222.2	-	PB	26	3?
M	240.0	-	FB	50	1*
			FB	51	1
M	240.1	-	FB	50	1*
			FB	51	1
M	240.2	-	FB	50	1*
			FB	51	1
M	240.3	-	FB	50	1*
			FB	51	1
M	240.4	-	FB	50	1*
			FB	51	1
M	240.5	-	FB	50	1*
			FB	51	1
M	240.6	-	FB	50	1*
			FB	51	1
M	240.7	-	FB	50	1*
			FB	51	1

QUERVERWEISLISTE: MERKER

MB 160	-MB 160	FB120	2*
		FB121	1*
		FB123	1*
		FB140	1*
		FB141	2*
		FB142	1*
		FB144	2*
		FB149	1*
		FB150	1*
		FB151	1*
		FB152	2*
		FB154	1*
		FB155	1*
MB 200	-	FB 7	5?
		FB 8	1?
MB 240	-	FB 50	1
		FB 51	1*
MW 0	-	FB110	1*
MW 2	-	FB110	1*
MW 4	-	FB110	1*
MW 6	-	FB110	1*
MW 8	-	FB110	1*
MW 10	-	FB110	1*
MW 12	-	FB110	1*
MW 14	-	FB110	1*
MW 16	-	FB110	1*
MW 18	-	FB110	1*
MW 20	-	FB110	1*
MW 22	-	FB110	1*
MW 24	-	FB110	1*
MW 26	-MW 226	FB 9	1?
		FB110	1*
MW 28	-	FB110	1*
MW 30	-	FB110	1*
MW 120	-	FB110	1*
MW 122	-	FB110	1*
MW 124	-	FB110	1*
MW 126	-	FB110	1*
MW 128	-	FB110	1*
MW 130	-	FB110	1*
MW 132	-	FB110	1*
MW 134	-	FB110	1*
MW 136	-	FB110	1*
MW 140	-	FB110	1*

QUERVERWEISLISTE: MERKER

MW 190	-MW 190	FB 7	5?
MW 194	-MW 194	FB 8	1?
MW 200	-	FB255	1*
MW 202	-	FB255	1*
MW 203	-	FB255	1*
MW 204	-	FB255	1*
MW 205	-	FB255	1*
MW 206	-	FB255	1*
MW 208	-	FB255	1*
MW 209	-	FB255	1*
MW 210	-	FB255	1*
MW 211	-	FB255	1*
MW 212	-	FB255	1*

QUERVERWEISLISTE: DATEN

```
   PB     1 : BEARBEITET
   PB     2 : BEARBEITET
   PB     3 : BEARBEITET
   PB     4 : BEARBEITET
   PB     5 : BEARBEITET
   PB     6 : BEARBEITET
   PB     8 : BEARBEITET
   PB     9 : BEARBEITET
   PB    10 : BEARBEITET
   PB    12 : BEARBEITET
   PB    13 : BEARBEITET
   PB    25 : BEARBEITET
   PB    26 : BEARBEITET
   PB   255 : BEARBEITET
   FB     7 : BEARBEITET
   FB     8 : BEARBEITET
   FB     9 : BEARBEITET
   FB    10 : BEARBEITET
   FB    11 : BEARBEITET
   FB    12 : BEARBEITET
   FB    13 : BEARBEITET
   FB    14 : BEARBEITET
   FB   15S: BEARBEITET
   FB   16S: BEARBEITET
   FB   17S: BEARBEITET
   FB   18S: BEARBEITET
   FB   19S: BEARBEITET
   FB   20S: BEARBEITET
   FB   21S: BEARBEITET
   FB    30 : BEARBEITET
   FB    39 : BEARBEITET
   FB    50 : BEARBEITET
   FB    51 : BEARBEITET
   FB    60 : BEARBEITET
   FB    70 : BEARBEITET
   FB    71 : BEARBEITET
   FB   109 : BEARBEITET
   FB   110 : BEARBEITET
   FB   113 : BEARBEITET
   FB   114 : BEARBEITET
   FB   120 : BEARBEITET
   FB   121 : BEARBEITET
   FB   123 : BEARBEITET
   FB   125 : BEARBEITET
   FB   134 : BEARBEITET
   FB   140 : BEARBEITET
   FB   141 : BEARBEITET
   FB   142 : BEARBEITET
   FB   144 : BEARBEITET
   FB   149 : BEARBEITET
   FB   150 : BEARBEITET
   FB   151 : BEARBEITET
   FB   152 : BEARBEITET
   FB   153 : BEARBEITET
   FB   154 : BEARBEITET
   FB   155 : BEARBEITET
   FB   202 : BEARBEITET
   FB   238 : BEARBEITET
   FB   239 : BEARBEITET
   FB   240S: BEARBEITET
   FB   241S: BEARBEITET
   FB   242S: BEARBEITET
   FB   243S: BEARBEITET
   FB   244 : BEARBEITET
   FB   245 : BEARBEITET
   FB   246 : BEARBEITET
   FB   247 : BEARBEITET
   FB   248 : BEARBEITET
   FB   249 : BEARBEITET
   FB   250 : BEARBEITET
   FB   251 : BEARBEITET
   FB   255 : BEARBEITET
   OB     1 : BEARBEITET
   OB     2 : BEARBEITET
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK                !                                !
!ELASTOMERTECHNIK          WERK HARBURG       !  SKIVER                        !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE              !  DATE         :                !
! INSTALLATION     : TREAD-LINE               !  MODIFICATION:          PGNO!   !
! PROJECT POS. NO.: 84/823804                 !  PROGRAMMER   :            1!   !
+-------------------------------------------------------------------------------+
```

QUERVERWEISLISTE: DATEN

```
   OB    20 : BEARBEITET
   OB    21 : BEARBEITET
   OB    22 : BEARBEITET
   OB    31 : BEARBEITET
```

QUERVERWEISLISTE: DATEN

DL	46	-	PB 26	3?
DL	82	-	PB 25	3?
DL	83	-	PB 25	5?
DR	46	-	PB 26	2?
DR	82	-	PB 25	2?
DR	83	-	PB 25	4?
DW	1	-	PB 8	7?
DW	3	-	PB 2	1?
			PB 8	6?, 7?, 21?, 22?, 24?
			FB 60	2*
			FB120	2*
DW	4	-	PB 2	1?
			PB 8	23?
			PB 25	6
DW	5	-	PB 2	1?
			PB 8	6?
DW	6	-	PB 2	1?
			FB120	2
			FB123	1
DW	7	-	PB 2	1?
			PB 8	21?
DW	8	-	PB 2	1?
			FB 7	2
			FB 9	1*
DW	10	-	PB 9	8?, 10?
			FB 7	2*, 4?
			FB 39	2
			FB 60	2
			FB 70	2*
			FB 71	2*
			FB120	2
			FB149	1
DW	11	-	FB 7	2*
DW	12	-	FB 7	4?
DW	13	-	FB 7	4?
DW	14	-	FB 7	4?
DW	15	-	FB 7	4?
DW	16	-	FB 7	4?
DW	17	-	FB 7	4?, 5
DW	18	-	PB 8	22?
			PB 12	3?
			FB 7	4?
			FB125	1?
DW	19	-	PB 9	10?
DW	20	-	PB 2	1
			FB 14	1*
DW	21	-	PB 2	1
			FB 14	1*

QUERVERWEISLISTE: BAUSTEINE

PB	1	BEARBEITET
PB	2	BEARBEITET
PB	3	BEARBEITET
PB	4	BEARBEITET
PB	5	BEARBEITET
PB	6	BEARBEITET
PB	8	BEARBEITET
PB	9	BEARBEITET
PB	10	BEARBEITET
PB	12	BEARBEITET
PB	13	BEARBEITET
PB	25	BEARBEITET
PB	26	BEARBEITET
PB	255	BEARBEITET
FB	7	BEARBEITET
FB	8	BEARBEITET
FB	9	BEARBEITET
FB	10	BEARBEITET
FB	11	BEARBEITET
FB	12	BEARBEITET
FB	13	BEARBEITET
FB	14	BEARBEITET
FB	15S	BEARBEITET
FB	16S	BEARBEITET
FB	17S	BEARBEITET
FB	18S	BEARBEITET
FB	19S	BEARBEITET
FB	20S	BEARBEITET
FB	21S	BEARBEITET
FB	30	BEARBEITET
FB	39	BEARBEITET
FB	50	BEARBEITET
FB	51	BEARBEITET
FB	60	BEARBEITET
FB	70	BEARBEITET
FB	71	BEARBEITET
FB	109	BEARBEITET
FB	110	BEARBEITET
FB	113	BEARBEITET
FB	114	BEARBEITET
FB	120	BEARBEITET
FB	121	BEARBEITET
FB	123	BEARBEITET
FB	125	BEARBEITET
FB	134	BEARBEITET
FB	140	BEARBEITET
FB	141	BEARBEITET
FB	142	BEARBEITET
FB	144	BEARBEITET
FB	149	BEARBEITET
FB	150	BEARBEITET
FB	151	BEARBEITET
FB	152	BEARBEITET
FB	153	BEARBEITET
FB	154	BEARBEITET
FB	155	BEARBEITET
FB	202	BEARBEITET
FB	238	BEARBEITET
FB	239	BEARBEITET
FB	240S	BEARBEITET
FB	241S	BEARBEITET
FB	242S	BEARBEITET
FB	243S	BEARBEITET
FB	244	BEARBEITET
FB	245	BEARBEITET
FB	246	BEARBEITET
FB	247	BEARBEITET
FB	248	BEARBEITET
FB	249	BEARBEITET
FB	250	BEARBEITET
FB	251	BEARBEITET
FB	255	BEARBEITET
OB	1	BEARBEITET
OB	2	BEARBEITET

QUERVERWEISLISTE: BAUSTEINE

OB 20 : BEARBEITET
OB 21 : BEARBEITET
OB 22 : BEARBEITET
OB 31 : BEARBEITET

QUERVERWEISLISTE: BAUSTEINE

PB 1	-PB 1	OB 1	1
PB 3	-PB 3	OB 1	1
PB 4	-PB 4	OB 1	1
PB 5	-PB 5	OB 1	1
PB 6	-PB 6	OB 1	1
PB 8	-PB 8	OB 1	1
PB 9	-PB 9	PB 10	4
PB 10	-PB 10	OB 1	1
PB 12	-PB 12	OB 1	1
PB 13	-PB 13	OB 1	1
PB 25	-PB 25	OB 1	1
PB 26	-PB 26	OB 1	1
PB 255	-PB 255	OB 20	1
		OB 21	1
		OB 22	1
FB 0	-	FB113	1?
FB 7	-FB 7	OB 1	1
FB 8	-FB 8	OB 1	1
FB 9	-FB 9	FB 7	1
FB 10	-FB 10	PB 9	7
FB 11	-FB 11	PB 9	10
FB 12	-FB 12	PB 8	6 , 7 , 21 , 22
		PB 9	8
		PB 12	3
FB 14	-FB 14	OB 1	1
FB 15	-FB 15 S	PB 2	1
		FB 7	4
		FB125	1
FB 16	-FB 16 S	FB 7	4
		FB125	1
FB 20	-FB 20 S	PB 2	1
		FB 7	4
		FB125	1
FB 30	-FB 30	PB 12	7
FB 39	-FB 39	PB 9	2
FB 50	-FB 50	PB 25	2 , 3 , 4 , 5
FB 51	-FB 51	PB 26	2 , 3
FB 60	-FB 60	PB 8	10
FB 70	-FB 70	FB 7	3
FB 71	-FB 71	FB 7	3
FB 109	-FB 109	PB255	2

QUERVERWEISLISTE: BAUSTEINE

FB 110	-FB 110	PB255	2
FB 113	-FB 113	PB255	2
FB 114	-FB 114	OB 1	1
FB 120	-FB 120	OB 1	1
FB 121	-FB 121	PB255	2
		OB 2	1
FB 123	-FB 123	OB 2	1
FB 125	-FB 125	PB 12	7
FB 134	-FB 134	FB120	2
		FB121	1
		FB123	1
		FB140	1
		FB141	2
		FB142	1
		FB144	2
		FB149	1
		FB150	1
		FB151	1
		FB152	2
		FB154	1
		FB155	1
FB 140	-FB 140	PB 12	2 , 7
FB 142	-FB 142	PB 12	7
FB 144	-	PB255	2
		FB140	1
FB 149	-FB 149	FB123	1
FB 150	-FB 150	PB255	2
		FB120	2
		FB155	1
FB 151	-FB 151	FB123	1
		FB153	1
FB 152	-FB 152	PB 13	7
FB 153	-FB 153	PB 13	3
FB 154	-FB 154	FB123	1
		FB153	1
FB 155	-FB 155	PB 13	5
FB 202	-FB 202	PB 8	20
		PB 9	6
		PB 10	3
		FB 70	2
		FB 71	2
FB 240	-FB 240 S	FB 9	1
FB 241	-FB 241 S	FB 7	5
		FB 8	1
FB 250	-FB 250 S	PB 6	2
		PB 8	23
FB 251	-FB 251 S	PB 8	24
FB 255	-FB 255	FB113	1
OB 66	-	FB113	1?

QUERVERWEISLISTE: BAUSTEINE

DB	12	-		PB 2	1
DB	30	-DB	30	PB 2	1
				PB 6	2
				PB 8	6?, 7?, 21?, 22
				PB 9	7?, 8?, 10?
				PB 12	3?, 12 , 13
				PB 13	7
				PB 25	2?, 3?, 4?, 5?, 6
				PB 26	2?, 3?
				FB 7	2 , 4
				FB 8	1
				FB 9	1
				FB 14	1
				FB 30	1
				FB 39	2
				FB 60	2
				FB 70	2
				FB 71	2
				FB114	1
				FB120	2
				FB123	1
				FB125	1
				FB142	1
				FB149	1
				FB150	1
				FB151	1
				FB152	2
				FB155	1

QUERVERWEISLISTE: ZEITEN

```
    PB     1 : BEARBEITET
    PB     2 : BEARBEITET
    PB     3 : BEARBEITET
    PB     4 : BEARBEITET
    PB     5 : BEARBEITET
    PB     6 : BEARBEITET
    PB     8 : BEARBEITET
    PB     9 : BEARBEITET
    PB    10 : BEARBEITET
    PB    12 : BEARBEITET
    PB    13 : BEARBEITET
    PB    25 : BEARBEITET
    PB    26 : BEARBEITET
    PB   255 : BEARBEITET
    FB     7 : BEARBEITET
    FB     8 : BEARBEITET
    FB     9 : BEARBEITET
    FB    10 : BEARBEITET
    FB    11 : BEARBEITET
    FB    12 : BEARBEITET
    FB    13 : BEARBEITET
    FB    14 : BEARBEITET
    FB   15S: BEARBEITET
    FB   16S: BEARBEITET
    FB   17S: BEARBEITET
    FB   18S: BEARBEITET
    FB   19S: BEARBEITET
    FB   20S: BEARBEITET
    FB   21S: BEARBEITET
    FB    30 : BEARBEITET
    FB    39 : BEARBEITET
    FB    50 : BEARBEITET
    FB    51 : BEARBEITET
    FB    60 : BEARBEITET
    FB    70 : BEARBEITET
    FB    71 : BEARBEITET
    FB   109 : BEARBEITET
    FB   110 : BEARBEITET
    FB   113 : BEARBEITET
    FB   114 : BEARBEITET
    FB   120 : BEARBEITET
    FB   121 : BEARBEITET
    FB   123 : BEARBEITET
    FB   125 : BEARBEITET
    FB   134 : BEARBEITET
    FB   140 : BEARBEITET
    FB   141 : BEARBEITET
    FB   142 : BEARBEITET
    FB   144 : BEARBEITET
    FB   149 : BEARBEITET
    FB   150 : BEARBEITET
    FB   151 : BEARBEITET
    FB   152 : BEARBEITET
    FB   153 : BEARBEITET
    FB   154 : BEARBEITET
    FB   155 : BEARBEITET
    FB   202 : BEARBEITET
    FB   238 : BEARBEITET
    FB   239 : BEARBEITET
    FB   240S: BEARBEITET
    FB   241S: BEARBEITET
    FB   242S: BEARBEITET
    FB   243S: BEARBEITET
    FB   244 : BEARBEITET
    FB   245 : BEARBEITET
    FB   246 : BEARBEITET
    FB   247 : BEARBEITET
    FB   248 : BEARBEITET
    FB   249 : BEARBEITET
    FB   250 : BEARBEITET
    FB   251 : BEARBEITET
    FB   255 : BEARBEITET
    OB     1 : BEARBEITET
    OB     2 : BEARBEITET
+-------------------------------------------------------------------------------+
!        KRUPP KUNSTOFFTECHNIK          !                                      !
!ELASTOMERTECHNIK          WERK HARBURG ! SKIVER                               !
+-------------------------------------------------------------------------------+
! PROJECT          : KERMAN TIRE        ! DATE        :                       !
! INSTALLATION     : TREAD-LINE         ! MODIFICATION:                  PGNO!
! PROJECT POS. NO.: 84/823804           ! PROGRAMMER  :                     1!
+-------------------------------------------------------------------------------+
```

QUERVERWEISLISTE: ZEITEN

```
OB   20 : BEARBEITET
OB   21 : BEARBEITET
OB   22 : BEARBEITET
OB   31 : BEARBEITET
```

QUERVERWEISLISTE: ZEITEN

T	1	-T	1	PB	12	6*
T	2	-T	2	PB	4	8*, 9
T	3	-T	3	PB	4	12*
T	4	-T	4	PB	4	14*
T	5	-T	5	PB	5	16*
T	6	-T	6	PB	4	18*
T	7	-T	7	PB	6	5*
T	8	-T	8	PB	4	20*
T	9	-T	9	PB	4	21*
T	10	-T	10	PB	1	2*
T	11	-T	11	PB	1	3*
T	12	-T	12	PB	8	3*, 5 , 6
T	13	-T	13	PB	8	4*, 5 , 7 , 8
T	14	-T	14	FB	14	1*
T	18	-T	18	PB	12	9*
T	19	-T	19	PB	12	10*
T	20	-T	20	PB	12	11*
T	21	-T	21	PB	3	12*, 13
T	174	-		PB	8	23?