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;OPERATION
;CLAMPING PROGRAM FOR FIXTURE
;MAXIMUM 3 M-FUNCTIONS IN ONE SENTENCE
cs_wp_refresh ;(PPROGRAM CALL)
;-----
$a_dbb[890]=2 ;(WRITING TO PLC)
if(((gd_wp_typ1>=1)and(gd_wp_typ1<=20))or(gd_wp_typ1==32));(CHECKING FOR
PART TYPE)
;-----
;RELIEVE ALL LINES
if((i_wp_clamped==true)and(i_wp_released==false)and(i_wp_location_check_i
o==true)and(i_wp_location_check_nio==false))gotof clamp_ok ;(CHECKING IF
PART IS CLAMPED AND MAKES LOCATION CHECK)
  m4=331 m4=332 m4=333 m4=334 ;(RELIEVING LINES 1,2,3,4)
  m4=336 m4=337 m4=338 ;(RELIEVING LINES 6,7,8)
step0:

if((i_wp_clamp1_rel==false)or(i_wp_clamp2_rel==false)or(i_wp_clamp3_rel==
false)or(i_wp_clamp4_rel==false)or(i_wp_clamp6_rel==false)or(i_wp_clamp7_
rel==false)or(i_wp_clamp8_rel==false)) gotob step0 ;(CHECKING IF ALL
LINES ARE RELIEVED)
;-----
;MAIN CLAMPS
m1=335 M1=332 h91=10 h92=2 ;(ACTIVATING HYDRAULIC LINES 5 AND 2
H91=RUNTIME MONITORING, H92=ADDITIONAL WAITING TIME)
step1:
  if ((i_wp_clamp5_act==false) OR (i_wp_clamp2_act==false)) gotob step1
; (CHECKING LINES 5 & 2)
;-----
M1=334 h92=5 ;(ACTIVATING HYDRAULIC LINE 4 H92=ADDITIONAL WAITING TIME)
STEP11:
if(i_wp_clamp4_act==false)GOTOB STEP11 ;(CHECKING LINE 4)
;-----
;ADVANCE WORK SUPPORTS
M2=332 M1=337 M1=333 ;(RELIEVING LINE 2 ACTIVATING LINES 7 & 3)
step2:
  if((i_wp_clamp7_act==false) or (i_wp_clamp3_act==false) OR
(i_wp_clamp2_REL==false))gotob step2 ;(CHECKING LINES 7,3 & 2)
;-----
;LOCK WORK SUPPORTS
M1=338 ;(ACTIVATING HYDRAULIC LINE 8)
step3:
  if(i_wp_clamp8_act==false)gotob step3 ;(CHECKING LINE 8)
;-----
;SECONDARY CLAMPS
m1=332 M0=336 ;(ACTIVATING HYDRAULIC LINE 2-CENTER POSITION FOR LINE 6)
step4:
  if (i_wp_clamp2_act==false) gotob step4 ;(CHECKING LINE 2)
;-----
syg_b8[0]=true ;(NC PROGRESS MARKER)
;-----
;LOCATION CHECK
  if(gd_wp_present1==1) ;(CHECK IF WORKPIECE PRESENT)

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        if((gd_gstf==1)and(i_wp_location_check_nio==true))gotof clamp_ok
;SKIP LOCATIONCHECK AFTER REPEAT LOADING AND SETTING WP-STATUS WITH HMI
        if(i_wp_location_hmi_quit==true) gotof clamp_ok ;(CHECKING STATUS IN
HMI)
        if(loc_chk) ;(IF LOC_CHK=1 (ACTIVE)
            m1=359 m4=354 h91=15 ;(RECLAMPING/LOCATION CHECK/SET WAIT TIME TO
15 SECS)
        else
            m4=354 h91=15 ;(LOCATION CHECK/SET WAIT TIME TO 15 SECS)
        endif

        check11:

if(i_wp_location_check_io==false)and(i_wp_location_check_nio==false)gotob
check11 ;(CHECKING LOCATION STATUS)
    else
        m358 ;(SETTING LOCATION CHECK TO "OK" WITHOUT PART)
    endif

;-----
gotof clamp_ok
endif

;WP-TYPE UNKNOWN ;(SETTING ALARM IF PART TYPE IS UNKNOWN)
SETAL (66025,SUBSTR($P_PROG[$P_STACK],,RINDEX($P_PROG[$P_STACK],"_"))
m0
gotof LBL_END
clamp_ok:
m1=330 ;(WORKPIECE CLAMPED)
m0=350 ;(MANUAL CONTROL FOR SETTING TO CENTER POSITION)
$AC_MARKER[0]=FALSE ;(SYNCHRONIZATION MARKER - PLC)
LBL_END:
ret

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