

	Address	Symbol	Display format	Status value	Modify value
1	// Gross value channel X				
2	MD 50		DEC	L#-154	
3	// Gross value channel Y				
4	MD 60		DEC	L#36	
5	// Controlword 1				
6	MW 70		BIN	2#0000_0000_0000_0001	2#0000_0000_0000_0001
7	MW 70		BIN	2#0000_0000_0000_0001	2#0000_0000_0000_0000
8	// "Zeroing"				
9	M 71.0		BOOL	true	
10	M 71.1		BOOL	false	
11	// Controlword 2				
12	MW 72		BIN	2#0000_0000_0000_0000	2#0000_0000_0010_0000
13	MW 72		BIN	2#0000_0000_0000_0000	2#0000_0000_0000_0000
14	// Process Start/Stop				
15	M 73.5		BOOL	false	
16	// activate the DPV1 functions (SFB52 and SFB53)				
17	M 15.1		BOOL	true	true
18	M 15.2		BOOL	true	true
19	// Read the Workpiece_ID via DPV1 59 Character				
20	MB 80		CHARACTER	'm'	
21	MB 81		CHARACTER	'p'	
22	MB 82		CHARACTER	'8'	
23	MB 83		CHARACTER	'5'	
24	MB 84		CHARACTER	'd'	
25	MB 85		CHARACTER	'p'	
26	MB 86		CHARACTER	B#16#00	
27	MB 87		CHARACTER	B#16#00	
28	MB 88		CHARACTER	B#16#00	
29	MB 89		CHARACTER	B#16#00	
30	MB 90		CHARACTER	B#16#00	
31	MB 91		CHARACTER		

	Address	Symbol	Display format	Status value	Modify value
32	MB 92		CHARACTER		
33	MB 93		CHARACTER		
34	MB 94		CHARACTER		
35	MB 95		CHARACTER		
36	MB 96		CHARACTER		
37	MB 97		CHARACTER		
38	MB 98		CHARACTER		
39	MB 99		CHARACTER		
40	MB 100		CHARACTER		
41	MB 101		CHARACTER		
42	MB 102		CHARACTER		
43	MB 103		CHARACTER		
44	MB 104		CHARACTER		
45	MB 105		CHARACTER		
46	MB 106		CHARACTER		
47	MB 107		CHARACTER		
48	MB 108		CHARACTER		
49	MB 109		CHARACTER		
50	MB 110		CHARACTER		
51	MB 111		CHARACTER		
52	MB 112		CHARACTER		
53	MB 113		CHARACTER		
54	MB 114		CHARACTER		
55	MB 115		CHARACTER		
56	MB 116		CHARACTER		
57	MB 117		CHARACTER		
58	MB 118		CHARACTER		
59	MB 119		CHARACTER		
60	MB 120		CHARACTER		
61	MB 121		CHARACTER		
62	MB 122		CHARACTER		
63	MB 123		CHARACTER		
64	MB 124		CHARACTER		
65	MB 125		CHARACTER		
66	MB 126		CHARACTER		

	Address	Symbol	Display format	Status value	Modify value
67	MB 127		CHARACTER		
68	MB 128		CHARACTER		
69	MB 129		CHARACTER		
70	MB 130		CHARACTER		
71	MB 131		CHARACTER		
72	MB 132		CHARACTER		
73	MB 133		CHARACTER		
74	MB 134		CHARACTER		
75	MB 135		CHARACTER		
76	MB 136		CHARACTER		
77	MB 137		CHARACTER		
78	MB 138		CHARACTER		
79	MB 139		CHARACTER		
80	// Write the Workpiece_ID via DPV1 59 Character -> M15.2 activates the function				
81	MB 140		CHARACTER		'm'
82	MB 141		CHARACTER		'p'
83	MB 142		CHARACTER		'8'
84	MB 143		CHARACTER		'5'
85	MB 144		CHARACTER		'd'
86	MB 145		CHARACTER		'p'
87	MB 146		CHARACTER		
88	MB 147		CHARACTER		
89	MB 148		CHARACTER		
90	MB 149		CHARACTER		
91	MB 150		CHARACTER		
92	MB 151		CHARACTER		
93	MB 152		CHARACTER		
94	MB 153		CHARACTER		
95	MB 154		CHARACTER		
96	MB 155		CHARACTER		
97	MB 156		CHARACTER		
98	MB 157		CHARACTER		
99	MB 158		CHARACTER		
100	MB 159		CHARACTER		

	Address	Symbol	Display format	Status value	Modify value
101	MB 160		CHARACTER		
102	MB 161		CHARACTER		
103	MB 162		CHARACTER		
104	MB 163		CHARACTER		
105	MB 164		CHARACTER		
106	MB 165		CHARACTER		
107	MB 166		CHARACTER		
108	MB 167		CHARACTER		
109	MB 168		CHARACTER		
110	MB 169		CHARACTER		
111	MB 170		CHARACTER		
112	MB 171		CHARACTER		
113	MB 172		CHARACTER		
114	MB 173		CHARACTER		
115	MB 174		CHARACTER		
116	MB 175		CHARACTER		
117	MB 176		CHARACTER		
118	MB 177		CHARACTER		
119	MB 178		CHARACTER		
120	MB 179		CHARACTER		
121	MB 180		CHARACTER		
122	MB 181		CHARACTER		
123	MB 182		CHARACTER		
124	MB 183		CHARACTER		
125	MB 184		CHARACTER		
126	MB 185		CHARACTER		
127	MB 186		CHARACTER		
128	MB 187		CHARACTER		
129	MB 188		CHARACTER		
130	MB 189		CHARACTER		
131	MB 190		CHARACTER		
132	MB 191		CHARACTER		
133	MB 192		CHARACTER		
134	MB 193		CHARACTER		
135	MB 194		CHARACTER		

	Address	Symbol	Display format	Status value	Modify value
136	MB 195		CHARACTER		
137	MB 196		CHARACTER		
138	MB 197		CHARACTER		
139	MB 198		CHARACTER		
140					