0

This Rung is continuation of b_Production
This Routine will Accept and Reject boxed based on the Barcode Label
As the Box is placed in the convayour belt and the Barcode scanner has a good read Latch Step 0

Prod_Step.9 | BCR_Scanned | I_Vacuum_Sensor_On <Local:3:I.Data.8> | AR_Step.0 (L)
Prod_Step.10

1

If Barcode Reader is able to scan the Box Latch BCR_Scanned

BCR_Good_Read | BCR_Scanned (L)

2

Turn on the convayour Belt when the machine is in Production

O_Conveyor_On <Local:5:O.Data.5>

3

Step 0. Have a delay after the box is placed on the convayour belt

AR_Test_Bit.0 | AR_Step.0 | TON Timer AR_Timer[0] Preset 1500 Accum 0 (EN) (DN)

4

After AR_Timer is done latch Step 1

AR_Test_Bit.0 | AR_Step.0 | AR_Timer[0].DN | AR_Step.1 (L)

5

Step 1. Raise the Barcode Stop

AR_Test_Bit.1 | AR_Step.1 | TON Timer AR_Timer[1] Preset 1000 Accum 0 (EN) (DN)
O_Barcode_Stop_Raise <Local:4:O.Data.14>

6

When the Barcode Stop is Raised enter Step 2 and unlatch Step 0

AR_Test_Bit.1 | AR_Step.1 | AR_Timer[1].DN | AR_Step.0 (U)
AR_Step.2 (L)

7

Step 2. as the machine enters this step Lower the Barcode Stop by unlatching Step 1 and start a timer

AR_Test_Bit.2 | AR_Step.2 | TON Timer AR_Timer[2] Preset 6000 Accum 0 (EN) (DN)
AR_Step.1 (U)

If the box is confirmed to be ejected or the box clear timer runs out, then latch step 4 to end the program.

8

AR_Test_Bit.2 AR_Step.2 AR_Timer[2].DN
AR_Test_Bit.3 AR_Step.3 AR_Timer[4].DN
AR_Step.4 (L)

If the barcode reads a multi-colored box enter Step 3 to reject the box

9

AR_Test_Bit.2 AR_Step.2
GRT
Source A Color_Code
3
Source B 3
BCR_Scanned (/)
AR_Step.3 (L)

Step 3. If the box is multi-colored Lower the Reject cylinder and start timer

10

AR_Test_Bit.3 AR_Step.3
O_Reject_Cyl_Lower
<Local:4:O.Data.15>
TON
Timer AR_Timer[3]
Preset 3000
Accum 0
EN
DN

When the Reject Cylincer is lowered LAUNCH the box

11

AR_Test_Bit.3 AR_Step.3 AR_Timer[3].DN
O_Reject_Cyl_Extend
<Local:5:O.Data.0>
TON
Timer AR_Timer[4]
Preset 1000
Accum 0
EN
DN

Step 4. Clear all the timers, Steps

12

AR_Test_Bit.4 AR_Step.4
CLR
Dest AR_Step
0
AR_Timer[0] (RES)
AR_Timer[1] (RES)
AR_Timer[2] (RES)
AR_Timer[3] (RES)
AR_Timer[4] (RES)
BCR_Scanned (U)

(End)