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C:\Users\SIM190Lab\Desktop\PLC HAS S2030A.ACD

Total number of rungs in routine: 5 MOV S:FS 0 Source 0 Dest BCR_Value.LEN MOV Source Local:1:I.Ch0RxID -72 Old_Rx_ID Dest -72 Unconditioned move of the newest transfer ID to a working register MOV Source Local:1:I.Ch0RxID -72 Dest New_Rx_ID -72 Verify the number of characters read during the latest barcode scan is correct before transferring the character length to the working register **GEQ** MOV Source A Local:1:I.RxDataLength Source Local:1:I.RxDataLength 9 9 Source B 9 Dest BCR Value.LEN 9 Verify the new transfer ID is greater than the previous transfer ID to validate new barcode data has been recieved **GRT** Source A New Rx ID Source Local:1:I.RxData[0] Dest BCR Value.DATA[0] -72 Source B Old_Rx_ID Length -72 BCR_Good_Read Upon verification of barcode read, the new transfer ID is moved to the old transfer ID register BCR Test Bit.0 BCR Good Read MOV New_Rx_ID Source -72 Dest Old_Rx_ID MID BCR Value Source '33330464\$r' Qty 1 Start Color_Value Dest '3' STOD Source Color Value '3' Dest Color_Code 3