**Sequence Title**: Bag Stacker Offgoing

**Doc Version:** 1.00.2

**Published By:** Tim Reamsbottom

**Publish Date**: 21/07/2015

# Version History

*The version number corresponds with the program version number set in Automation Studio.*

|  |  |  |  |
| --- | --- | --- | --- |
| Publish Date | Version Number | Comments | Engineer Initials |
| 21/07/2015 | 1.00.1 | First Release | TR |
| 07/02/2018 | 1.00.2 | Modify local vars to use Dynamic var | TR |
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# Sequence Description

## Basic Sequence Description

|  |
| --- |
| Standard bag stacke offgoing.  Options include   1. Rotary point 2. Tracking |

## Sequence Steps

|  |  |
| --- | --- |
| Step | Description |
| 0 | Disabled |
| 1 | Check level position is clear |
| 2 | Open separators |
| 3 | Bag settles in level position |
| 4 | Move level cylinder down |
| 5 | Move level cylinder up |
| 6 | Check for buffer space |
| 7 | Open stop line on A |
| 8 | Open stop line on B |
| 9 | Wait for bag to be released |
| 10 | Click here to enter text. |
| 11 | Click here to enter text. |
| 12 | Click here to enter text. |
| 13 | Click here to enter text. |
| 14 | Click here to enter text. |
| 15 | Click here to enter text. |
| 16 | Click here to enter text. |
| 17 | Click here to enter text. |
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| 19 | Click here to enter text. |
| 20 | Click here to enter text. |

# IO Description

## Standard IO Descriptions

|  |  |  |  |
| --- | --- | --- | --- |
| Standard Block number | Block Port | Input  Output | Description |
| 233 | 1 | X | SBSF1 - Bag in rocker line A |
| 233 | 2 | X | SBSF1 - Bag in rocker line B |
| 233 | 3 | X | SBSF1 - PR Line full |
| 233 | 4 | X | SBSF1 - PR Long trip |
| 233 | 5 | Y | SBSF1 - Open rocker line A |
| 233 | 6 | Y | SBSF1 - Open rocker line B |
| 233 | 7 | Y | SBSF1 - PR Open stop |
| 233 | 8 | Y | Spare |
| 234 | 1 | X | SBSF1 - Bag at tilt line A |
| 234 | 2 | X | SBSF1 - Bag at tilt line B |
| 234 | 3 | X | SBSF1 - Bag released line A |
| 234 | 4 | X | Spare |
| 234 | 5 | Y | SBSF1 - Open stop line A |
| 234 | 6 | Y | SBSF1 - Open stop line B |
| 234 | 7 | Y | SBSF1 - Tilt cylinder |
| 234 | 8 | Y | Spare |
| 235 | 1 | X | SBSF1 - Bag released line B |
| 235 | 2 | X | SBSF1 - Bag released |
| 235 | 3 | X | SBSF1 - Bag on rotary point |
| 235 | 4 | X | Spare |
| 235 | 5 | Y | SBSF1 - Select line A |
| 235 | 6 | Y | SBSF1 - Select line B/Open rotary stop |
| 235 | 7 | Y | Spare |
| 235 | 8 | Y | Spare |

*Description must contain “–“after sequence identifier (i.e.SPN1 – ).*

# Manual Description

|  |
| --- |
| 1. Disabled   All controls functions are disabled.   1. Check level position is clear.   The emergency stop and switch conditions are checked, both “bag at tilt” proximity switches must not be made. Then sequence will then change to step 2.   1. Open separators.   The rocking separators will open allowing a bag to gravitate in, once both “bag in rocker” proximity switches are made for 2 seconds the sequence will change to step 3.   1. Bag settles in level position.   The rocking separators will return to closed position, this will allow the bag to gravitate into the tilt position. When both “bag at tilt” proximity switches are made, the sequence will then change to step 4.   1. Move level cylinder down.   The level cylinder is given 3 seconds to move down and tilt the bag, before the sequence will change to step 5.   1. Move level cylinder up.   The level cylinder is given 3 seconds to retract, before the sequence will change to step 6.   1. Check for buffer space   An assessment is made to determine if releasing the bag is allowed, once release is allowed the sequence will change to step 7.  If tracking is being used then a data integrity check place.  If there is outgoing buffer, the line full trip is checked. The “bag at buffer” proximity and state of the going buffer stop is also checked if this is a single bag buffer to ensure a bag is not released with the buffer stop being in a close position.  If there is no outgoing buffer, a request release signal is sent to the outgoing sequence, valid release is when an enable release signal is received.   1. Open stop on line A.   The point change over to select A. The stop on line A is then opened. The bag will start to gravitate out of the bag stacker, once the “bag released line A” switch is made, the sequence will change to step 8.   1. Open stop on line B.   The stop on line B is opened. The bag will continue to gravitate out of the bag stacker, once the “bag released line B” switch is made, the sequence will change to step 9.   1. Wait for bag to be released.   If this is a rotary point bag stacker, when the bag trolley on line A arrives at the rotary buffer stop and makes the “bag on rotary point” switch the rotary point will then change into line B position and the bag will continue to gravitate out of the bag stacker.  If this is not a rotary point bag stacker, the point will select line and the bag will continue to gravitate out of the bag stacker.  If there is an outgoing buffer then arrival in the buffer is detected by the line trip proximity switch. If there is no outgoing buffer arrival is detected by the enable release signal changing to false. |