**Sequence Title**: bsn – Bag Stacker Ongoing

**Doc Version:** 1.00.1

**Published By: Tim Reamsbottom**

**Publish Date**: 17/07/2015

# Version History

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

|  |  |  |  |
| --- | --- | --- | --- |
| Publish Date | Version Number | Comments | Engineer Initials |
| 17/07/2015 | 1.00.1 | First Release | TR |
| 24/08/2016 | 1.00.2 | Bug fix with release switch.. | TR |
| 07/02/2018 | 1.00.3 | Change to dynamic Variable standard | TR |
| 21/09/2018 | 1.00.4 | Bug Fix. Bag data wasn’t deleted when tracking | TR |
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# Sequence Description

## Basic Sequence Description

|  |
| --- |
| Standard bag stacker ongoing.  Options include   1. rotary point 2. Tracking |

## Sequence Steps

|  |  |
| --- | --- |
| Step | Description |
| 0 | Disabled |
| 1 | Checks status |
| 2 | Wait for bag at buffer |
| 3 | Wait for bag to arrive on line A |
| 4 | Select line B |
| 5 | Move tilt cylinder down |
| 6 | Move tilt cylinder up |
| 7 | Check for space |
| 8 | Release bag |
| 9 | Click here to enter text. |
| 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. |
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# IO Description

## Standard IO Descriptions

|  |  |  |  |
| --- | --- | --- | --- |
| Standard Block number | Block Port | Input  Output | Description |
| 231 | 1 | X | SBSN1 – Bag at buffer |
| 231 | 2 | X | SBSN1 – Bag on line A |
| 231 | 3 | X | SBSN1 – Bag on rotary point |
| 231 | 4 | X | Spare |
| 231 | 5 | Y | SBSN1 – Open buffer |
| 231 | 6 | Y | SBSN1 – Select line |
| 231 | 7 | Y | SBSN1 – Select line or open rotary stop |
| 231 | 8 | Y | SBSN1 – Tilt cylinder |
| 232 | 1 | X | SBSN1 - Bag in separator line A |
| 232 | 2 | X | SBSN1 - Bag in separator line B |
| 232 | 3 | X | SBSN1 – Bag released |
| 232 | 4 | X | Spare |
| 232 | 5 | Y | SBSN1 – Open separator line A |
| 232 | 6 | Y | SBSN1 – Open separator line B |
| 232 | 7 | Y | SBSN1 – Operate pusher |
| 232 | 8 | Y | Spare |
| No. | - | - | Click here to enter text. |
| No. | - | - | Click here to enter text. |
| No. | - | - | Click here to enter text. |
| No. | - | - | Click here to enter text. |
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*Description must contain “–“after sequence identifier (i.e.SPN1 – ).*

# Manual Description

|  |
| --- |
| 1. Disabled   All controls functions are disabled.   1. Check Status   The point returns to its reset position, the emergency stop and switch conditions are checked.  Both bag at separator switches and the bag on rotary point switch (If applicable) must not be made. The sequence will then change to step 2.   1. Wait for bag at buffer   A logical assessment is made of the input buffer condition, by checking the “bag at buffer” proximity switch and data for validity (if applicable), or the request release state of the incoming buffer sequence.  When the assessment is true the sequence will change to step 3.   1. Wait for bag to arrive on line A   The incoming buffer will open, or the incoming buffer sequence will release a bag. The bag will then gravitate into the bag stacker. When the first trolley is detected via a proximity switch on line A the sequence will change to step 4.  If this is a rotary point bag stacker the rotary stop will be open during this step.   1. Select line B   The point will change over the line B selection; the bag will then continue to gravitate into the bag stacker.  If this is a rotary point bag stacker before the point changes to the line B selection the bag on rotary point switch must be made.  When both “bag in separator” proximity switches are made the sequence will change to step 5.   1. Move tilt cylinder down   The tilt cylinder is given 3 seconds to move down and tilt the bag before the sequence will change to step 6.   1. Move tilt cylinder up   The tilt cylinder is allowed 3 seconds to retract before the sequence will change to step 7.   1. Check for space   The space is in the bag stacker is checked, by ensuring the bag released switch has not been made for 3 seconds. Then the sequence will change to step 8.   1. Release Bag   The separators are both opened and the bag will gravitate into the bag stacker.  Once the bag released switch is made, the sequence will return to step 1. |