**Sequence Title**: 1\_x\_Point

**Doc Version:** 2.00.3

**Published By:** Tim Reamsbottom

**Publish Date**: 31/03/2016

# Version History

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

|  |  |  |  |
| --- | --- | --- | --- |
| Publish Date | Version Number | Comments | Engineer Initials |
| 15/07/2015 | 2.00.1 | First standard release | TR |
| 31/03/2016 | 2.00.2 | Make transit bag optional | TR |
| 02/10/2018 | 2.00.3 | Fix issue build with wrong syntax | TR |
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# Sequence Description

## Basic Sequence Description

|  |
| --- |
| This sequence is designed to integrate with other sequences when handling a single buffers/sequence in, to multiple buffers/sequences out.  Buffer bag data is copied into a transit position from the incoming buffer before the outgoing data position, When using request release the data must be copied from the transit position by the enabling sequence.  This sequence cannot support a request interface to a incoming sequence, request release must be used by the incoming sequence in place of i\_bagAtBuffer. |

## Sequence Steps

|  |  |
| --- | --- |
| Step | Description |
| 0 | Disabled |
| 1 | Reset points |
| 2 | Wait for bag at buffer |
| 3 | Release bag into buffer 1 |
| 4 | Release bag into buffer 2 |
| 5 | Release bag into buffer 3 |
| 6 | Release bag into buffer 4 |
| 7 | Release bag into buffer 5 |
| 8 | Release bag into buffer 6 |
| 9 | Release bag into buffer 7 |
| 10 | Release bag into buffer 8 |
| 11 | Etc……………. |
| 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. |
| 18 | Click here to enter text. |
| 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 |
| 101 | 1 | X | SP1 – Bag at buffer |
| 101 | 2 | X | Spare |
| 101 | 3 | X | SP1 – Bag released to buffer 1 |
| 101 | 4 | X | SP1 – Bag released to buffer 2 |
| 101 | 5 | Y | SP1 – Open buffer |
| 101 | 6 | Y | Spare |
| 101 | 7 | Y | SP1 – Select buffer 1 |
| 101 | 8 | Y | SP1 – Select buffer 2 |
| 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. Reset Points   All points change over to the reset position. The emergency stop condition is checked and then the sequence changes 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.  If data is being tracked with destinations, the destination code is read from the incoming buffer position to determine where the bag should be sent to. If data is not being tracked then out going buffers are scanned alternately to find a space to release the bag.  Once a valid release line has been found, If data is being tracked it is now copied into the “transit” position before the sequence step changes to 2 + the selected out going buffer number.( i.e buffer 3 is selected go to step 2 + 3 = 5).    3>) Release bag into buffer x  This applies to all steps from 3 and above based on the selected buffer number.  The points are changed into the correct position for the selected buffer, the incoming buffer stop is then opened, and the bag gravitates into its selected position. The sequence then returns to step 1.  The bag arriving into its selected position is detected in 2 ways depending on the type of the position:  If releasing into a buffer line, the line trip proximity switch is used to detect arrival, If releasing into another sequence the enable release signal changing to a false condition is used. |