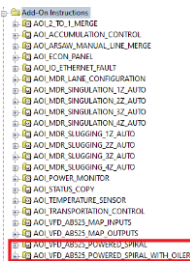
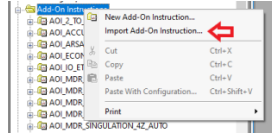
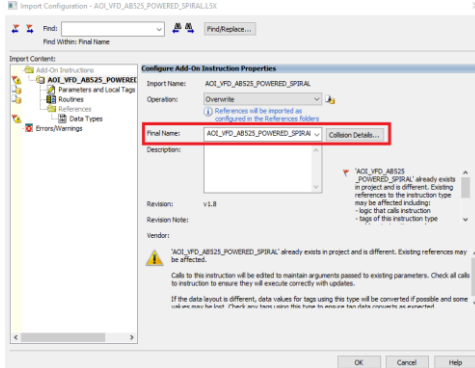
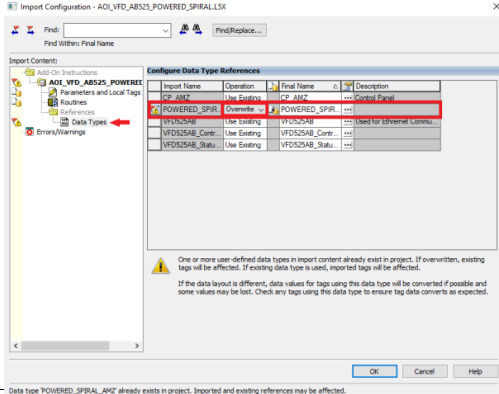
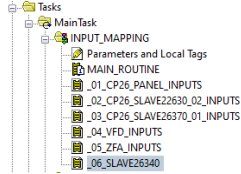

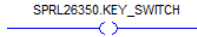

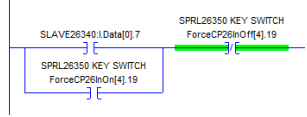
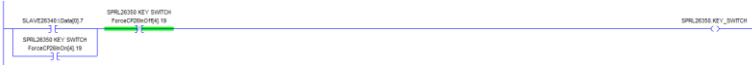
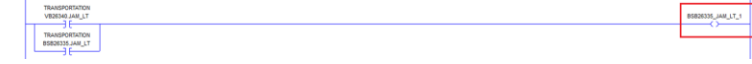
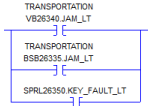


Maintenance Job Planning/Estimating Worksheet					
Planner: X		WO#: X		Date: 09/27/2021	
Job Contact: X		Location: AOx Spiral Infeed		Asset ID#:	
Job Description: Update code to support keyed reset					
Job Scope					
Job Plan Seq.	Task Description	Task Duration	Number of Resources Required	Total Estimated Labour Hours	Reference Pictures
10	Locate and open current project for panel being modified in NACF-AE.  Go online with the project and create a new backup dated today, save within NACF-AE as this will be the rollback copy.	0.50	1	0.50	
20	"Save As" a copy of the above project on your desktop, naming it something to differentiate.  At this point go Offline with the controller.	0.50	1	0.50	
30	Locate and download the two new AOI to be imported from the Parent MCM's Attachments	0.25	1	0.25	
40	Confirm that both Add-On Instructions exist within the project.	0.25	1	0.25	
50	Move to import the new Add-On Instructions.  Navigate to location where new Add-On Instructions were downloaded in previous steps.	0.25	1	0.25	
60	Confirm that final names matches the AOI to be replaced  For example: AOI_VFD_AB525_POWERED_SPIRAL	0.25	1	0.25	
70	Navigate to Data Types, and from the drop down within the operation column chose to overwrite "POWERED_SPIRAL_AM2"	0.25	1	0.25	
80	Repeat steps 6 and 7 with second Add-on Instruction to be imported.				

90	Navigate to Main Task / Input Mapping / The IBX where the key switch input was landed (Example _06_SLAVE26340)	0.25	1	0.25	
100	At the bottom of the routine add a new rung structured as shown				
110	For the OTE use the POWERED_SPIRAL_AMZ UDT's KEY_SWTICH  In this example we are using SPRL26350, this vary dependant on the spiral being modified.				
120	For the first XIC create a new tag.  Naming should be "KS_(Spiral's Bed Number)" Example KS_26350 Type: Alias Alias For: The input identified during the installation of the Key Switch  In this example we are using SPRL26350, this vary dependant on the spiral being modified.				
130	For the Rung XIO and branch XIC:  For the XIC Use the next available increment of the "ForceCPXXInOn[X].XX" This is determined by looking at the rungs above where you are currently working. Use Find-All with the selected tag to confirm it has not been used elsewhere.  Example: ForceCP26InOn[4].19  For the XIO perform the same as above substituting with "ForceCPXXInOff[X].XX"  Add a decsription to make this easy to identify.  In this example we are using SPRL26350, this vary dependant on the spiral being modified.				
140	End result as shown				
150	Navigate to CPxx_MAIN_PROGRAM/_xx_JAM_BEACONS  Locate the OTE for the closest jam beacon to the spiral being modified.				
160	On the above rung add a branch and XIC as shown.  The XIC's tag should be POWERED_SPIRAL_AMZ UDT's KEY_FAULT_LT Example: SPRL26350.KEY_FAULT_LT				
170	If this change is being performed on multiple spirals controlled by the same panel steps 9-16 will need to be completed for each.				
180	At this point be sure save the project.				
190	During an apporiatly scheduled down time window the project is to be downloaded into the appropriate controller.				

					<div>AOI_VFD_AB252_POWERED_SPIRAL_WITH_OILS</div> <div><div>AOI_VFD_AB252_POWERED_SPIRAL...SPRL28350_AOI</div><div>CONTROL_PANELCP28</div><div>USE_PANEL_SUMMARY_RESETYES</div><div>USE_PANEL_ECONYES</div><div>AIR_PRESSURE_FAULT_REQUIREDNO</div><div>CONVEYORSPRL28350</div><div>RUN_DELAY_TIME7000</div><div>ETHERNET_MODULEVFD28350</div><div>VFDACCEL_TIMEDR28350</div><div>DECEL_TIME7000</div><div>VFD_REF_SPEED6000</div><div>VFD_ACT_SPEED0</div><div>PHOTOEYE0</div><div>JAM_ENABLEDNO</div><div>SECONDARY_JAMNO</div><div>JAM_TIME4000</div><div>TOTAL_LENGTH_OF_BELT_IN_FEET76</div><div>NOMINAL_SPEED_IN_FPM224</div><div>ECON_RESETCP28_AOI_ECON_RESET</div><div>MOTOR_FAULT_LTCP28_AOI_MTR_FAULT_LT</div><div>PANEL_JAM_LTCP28_AOI_PANEL_JAM_LT</div><div>JAM_HORNCP28_AOI_JAM_HORN</div><div>ALARM_HORNCP28_AOI_ALARM_HORN</div><div>STATUS_WORDHMI_STATUS_CP28[0]</div><div>ALARM_WORSHMI_ALARM_CP28[0]</div><div>KEY_SWITCH_ENABLEDYES</div></div>
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