1/5/2023 Update Current for TENSORVISIONZ_1100_REV01.RSS

Address	Name	PLC Usage	Implemented in GUI	Implemented in PLC	Notes
O:0/0	REJECT_OUTPUT	Output	N/A	Y	Happens after timer if REJECTION_MODE_CMD=1
O:0/1	LINESTOP_OUTPUT	Output	N/A	Y	Commands line to stop running
O:0/2	RED_LIGHT	Output	N/A	Y	Happens on LINESTOP_ACTIVE_CMD if REJECTION_MODE_CMD=1 (or test)
O:0/3	GREEN_LIGHT	Output	N/A	Y	Happens if REDLAMP is off and REJECTION_MODE_CMD=1 (or test)
O:0/4	CYCLE_CAM_POWER	Output	N/A	NO	
I:0/0	ENCODER_INPUT	Input	N/A	Y	Input from optional high-speed encoder
I:0/1	INSPECT_TRIGGER	Input	N/A	Y	Trigger Photoeye
I:0/2	REJECT_TRIGGER	Input	N/A	N	Optional downstream trigger to synchronize reject signal
I:0/3	REJECT_CONFIRM	Input	N/A	N	Optional downstream reject confirmation photoeye
I:0/4	PASS_1	Input	N/A	Y	Goes high momentarily to indicate PASS condition 1
I:0/5	FAIL_1A	Input	N/A	Y	Goes high momentarily on FAIL condition 1A
I:0/6	FAIL_1B	Input	N/A	Y	Goes high momentarily on FAIL condition 1B
I:0/7	PASS_2	Input	N/A	Y	Goes high momentarily to indicate PASS condition 2
I:0/8	FAIL_2A	Input	N/A	Y	Goes high momentarily on FAIL condition 2A
I:0/9	FAIL_2B	Input	N/A	Y	Goes high momentarily on FAIL condition 2B
C5:1	INSPECT_TRIGGER_CTR	Output	Y	Y	Counts INSPECT_TRIGGER inputs, reset by RESET_COUNTERS_CMD
C5:2	REJECT_OUTPUT_CTR	Output	Y	Y	Counts REJECT_OUTPUTS issued, reset by RESET_COUNTERS_CMD
C5:3	REJECT_TRIGGER_CTR	Output	Y	Y	Counts REJECT_TRIGGER inputs, reset by RESET_COUNTERS_CMD
C5:4	REJECT_CONFIRM_CTR	Output	Y	Y	Counts REJECT_CONFIRM inputs, reset by RESET_COUNTERS_CMD
C15:0	PASS_1_CTR	Output	Y	Y	Counts PASS_1 inputs, reset by RESET_COUNTERS_CMD
C15:1	FAIL_1A_CTR	Output	Y	Y	Counts FAIL_1A inputs, reset by RESET_COUNTERS_CMD
C15:2	FAIL_1B_CTR	Output	Y	Y	Counts FAIL_1B inputs, reset by RESET_COUNTERS_CMD
C15:3	PASS_2_CTR	Output	Y	Y	Counts PASS_2 inputs, reset by RESET_COUNTERS_CMD
C15:4	FAIL_2A_CTR	Output	Y	Y	Counts FAIL_2A inputs, reset by RESET_COUNTERS_CMD
C15:5	FAIL_2B_CTR	Output	Y	Y	Counts FAIL_2B inputs, reset by RESET_COUNTERS_CMD
ST19:0	PLC_REVISION	Output	Y	Y	PLC Revision displayed on GUI
ST19:1	CURRENT_JOBFILE	Input	Y	Y	Vision job filename sent from GUI
ST19:2	CURRENT_OPERATOR	Input	Y	Y	Operator name sent from GUI
B13:0/0	HEARTBEAT_FROM_GUI	Input	Y	N	Unused
B13:0/1	HEARTBEAT_TO_GUI	Output	Y	Y	1Hz signal to GUI
B13:0/2	REJECTION_MODE_CMD	Input	Y	Y	Must be 1 to get REJECT_OUTPUT
B13:0/3	REDLAMP_TEST_CMD	Input	Y	Y	Set from GUI, clears itself after timer
B13:0/4	GREENLAMP_TEST_CMD	Input	Y	Y	Set from GUI, clears itself after timer
B13:0/5	PUSHER_TEST_CMD	Input	Y	Y	Set from GUI, clears itself after timer
B13:0/6	LINESTOP_TEST_CMD	Input	Y	Y	Set from GUI, clears itself after timer
B13:0/7	LINESTOP_ACTIVE_CMD	Input	Y	Y	Set from GUI, determines if we issue line stops from PLC
B13:0/10	USE_REJECT_TRIGGER	Input	Y	N	Set from GUI, determines if we wait for REJECT_TRIGGER to reject
B13:0/11	USE_ENCODER	Input	Y	N	Set from GUI, determines if we watch and use encoder pulses
B13:0/12	RESET_COUNTERS_CMD	Input	Y	Y	Set from GUI, clears itself upon reject
B13:0/15	REJECT_NOW_CMD	Input	N	Y	Set from GUI, triggers a reject
T14:0	REJECT_DWELL_TMR	Timer	N		Reject Actuator Dwell
T14:1	TRIG_SUPPRESS_TMR	Timer	N		Input Supression Window
T14:2	COLLECT_INPUTS_TMR	Timer	N		Input Accept Window
T14:5	INSPECT_FAIL_TMR	Timer	N		Inspection Fail Indication
T14:6	GREEN_LAMP_TEST_TMR	Timer	N		Green Lamp Test Active
T14:7	RED_LAMP_TEST_TMR	Timer	N		Red Lamp Test Active
T14:8	LINESTOP_TEST_TMR	Timer	N		Linestop Test Active
T14:9	REJECT_TEST_TMR	Timer	N		Reject Pusher Test Active
N17:0	HISPEED_OFFSET_SP	Input	Y	Y	Setpoint set from GUI
N17:1	LOSPEED_OFFSET_SP	Input	Y	Y	Setpoint set from GUI
N17:2	ACTUAL_OFFSET_CALCD	Output	Y	Y	Reported to GUI for debug
N17:5	REJECTOR_DURATION_SP	Input	Y	Y	Setpoint set from GUI
N17:11	ENCODER_HIPRESET_SP	Input	Y	Y	Setpoint set from GUI
F18:0	TOTAL_INSPECTED_GUI	Handoff	Y	Y	Sent down from GUI
F18:1	TOTAL_PASSED_GUI	Handoff	Y	Y	Sent down from GUI
F18:2	TOTAL_FAILED_GUI	Handoff	Y	Y	Sent down from GUI
F18:3	TOTAL_REJECTED_GUI	Handoff	Y	Y	Sent down from GUI
F18:10	AVE_LINESPEED	Output	N	Y	Available to GUI or other
F18:15	CURR_LINESPEED	Output	N	Y	Available to GUI or other