RFID_5_ZZ

Rung 0

Mode_Start / Mode_Semi — RFID Tag at Cell 3 Stop RFIDTP5 `<RFID_N056:I.Channel[0].TagPresent>` — RFID_N056:I.Channel[0].Busy — R5Z_Read

MOV
Move
Source 0
Dest RFID_N056:O.Channel[0].Command
4

MOV
Move
Source 0
Dest RFID_N056:O.Channel[0].Data[0]
0

MOV
Move
Source 0
Dest RFID_N056:O.Channel[0].Address
0

MOV
Move
Source 10
Dest RFID_N056:O.Channel[0].Length
10

R5Z_Read (L)
R5Z_Read_Start (L)

Rung 1

R5Z_Read_Start —

EQU
Equal
Source A RFID_N056:I.Channel[0].Command
4
Source B 0

MOV
Move
Source 4
Dest RFID_N056:O.Channel[0].Command
4

Rung 2

R5Z_Read_Start — RFID_N056:I.Channel[0].Busy

R5Z_Read_Start (U)
R5Z_Read_InProgress (L)

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Rung 3:

R5Z_Read_InProgress ─┤ ├─ RFID_N056:I.Channel[0].Busy ─┤/├─

EQU
Equal
Source A   RFID_N056:I.Channel[0].Command
                                          4
Source B   4

R5Z_Read_InProgress ─(U)─
R5Z_Read_Results ─(L)─

Rung 4:

R5Z_Read_Results ─┤ ├─

MOV
Move
Source   RFID_N056:I.Channel[0].Data[3]
                                       2
Dest   R5Z_Current_Part_NO
                                       2

MOV
Move
Source   RFID_N056:I.Channel[0].Data[4]
                                       0
Dest   R5Z_Current_Process_NO
                                       0

R5Z_Read_Results ─(U)─
R5Z_Read_Finished ─(L)─

Rung 5:

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This rung executes after the part leaves RFID 1. It resets the tags so that this routine is ready for the next part.

RFID Tag at Cell 3
Stop

RFIDTP5

Mode_Start ─┤ ├─ <RFID_N056:I.Channel[0].TagPresent> ─┤/├─
Mode_Semi ─┤ ├─

R5Z_Read ─(U)─
R5Z_Read_Finished ─(U)─

(End)