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 0

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 17

R5Z_Read (L)

R5Z_Read_Start (L)

Rung 1

R5Z_Read_Start

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

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

Rung 2

R5Z_Read_Start

RFID_N056:I.Channel[0].Busy

R5Z_Read_Start (U)

R5Z_Read_InProgress (L)

Rung 3

R5Z_Read_InProgress

RFID_N056:I.Channel[0].Busy

EQU — Equal — Source A RFID_N056:I.Channel[0].Command 0 — 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]
                                        0
Dest   R5Z_Current_Part_NO
                                        2

MOV
Move
Source   RFID_N056:I.Channel[0].Data[4]
                                        0
Dest   R5Z_Current_Process_NO
                                        2

R5Z_Read_Results
—(U)—

R5Z_Read_Finished
—(L)—

Rung 5:

November 1, 2016
This rung executes after the part leaves RFID 1. It resets the tags so that this routine is ready for the next part.

Mode_Start
—] [—

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

Mode_Semi
—] [—

R5Z_Read
—(U)—

R5Z_Read_Finished
—(U)—

(End)