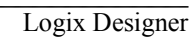
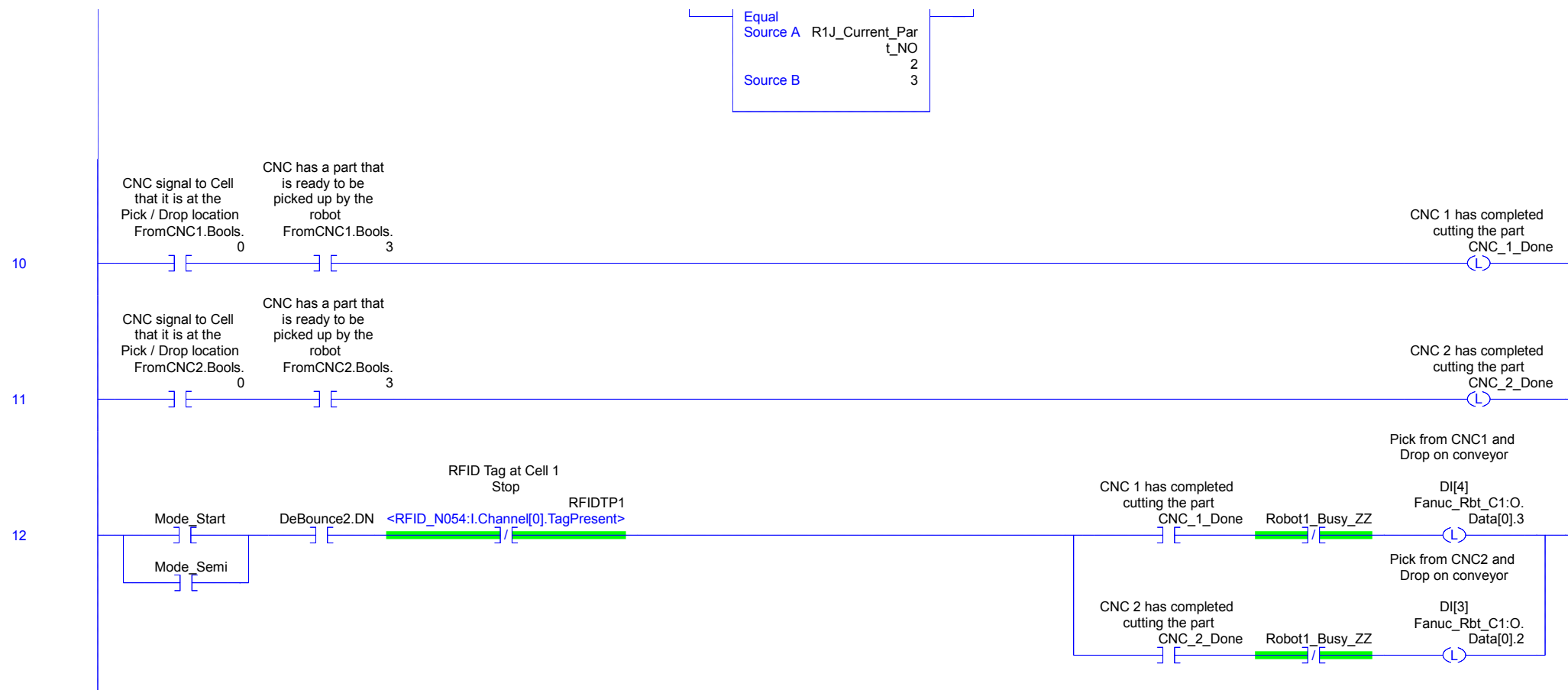




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October 11, 2016

This rung evaluates all possible conditions for retraction of the Cell 1 Robot Stop. The conditions are:
If the part has been dropped to the conveyer (has written process number and checked), or both CNC1 and CNC2 running (both busy now), or the pallet is empty and both CNCs are not done, or the process is not 0, or CNC2 is not idle and Part A is in cell, or CNC1 is not idle and part B or C is in cell.

November 1, 2016

Added DeBounce2 timer done condition to ensure PartEntering tag is unlatched. Changed tags to match RFID_1_JW.

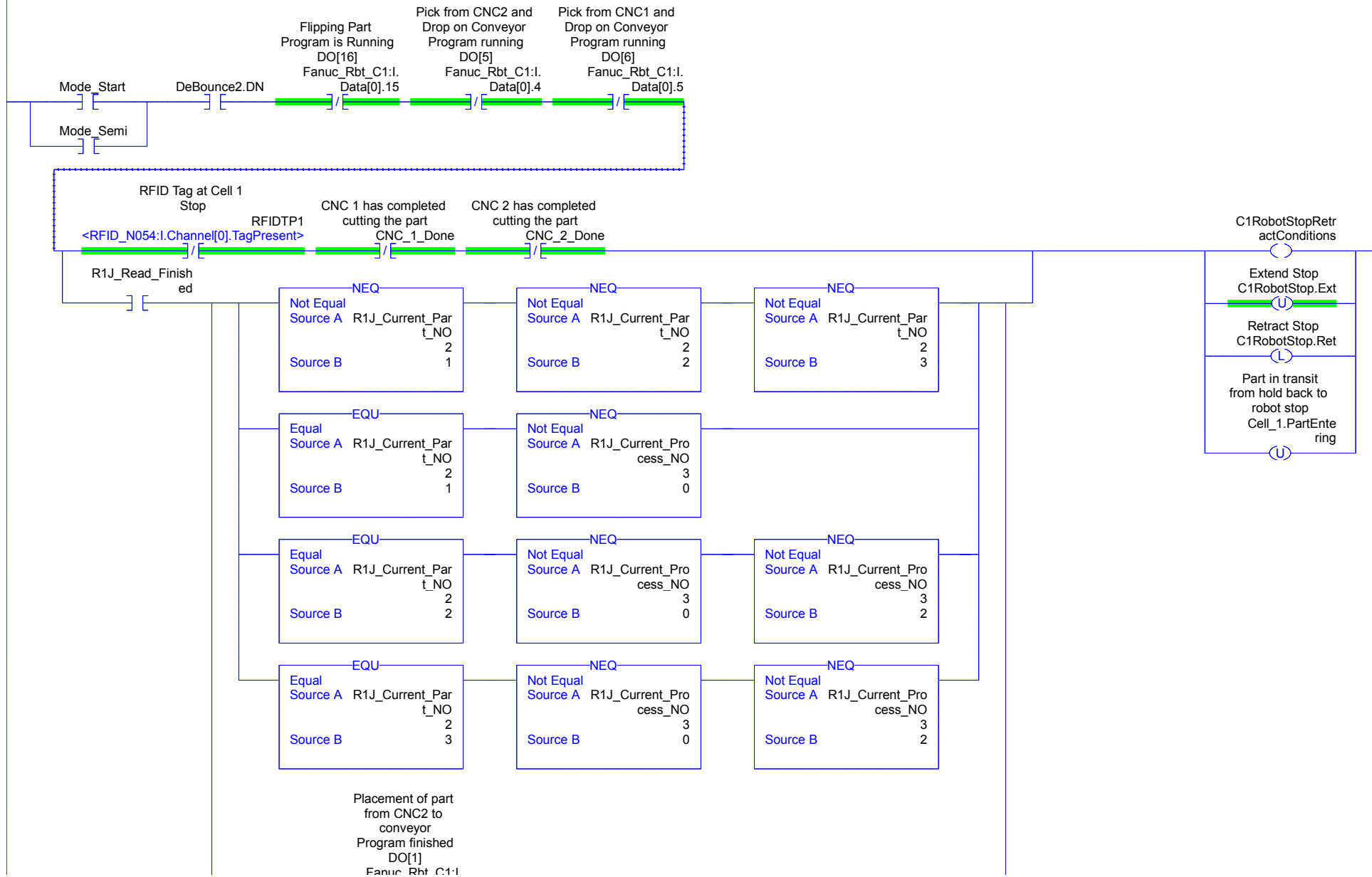
November 5, 2016

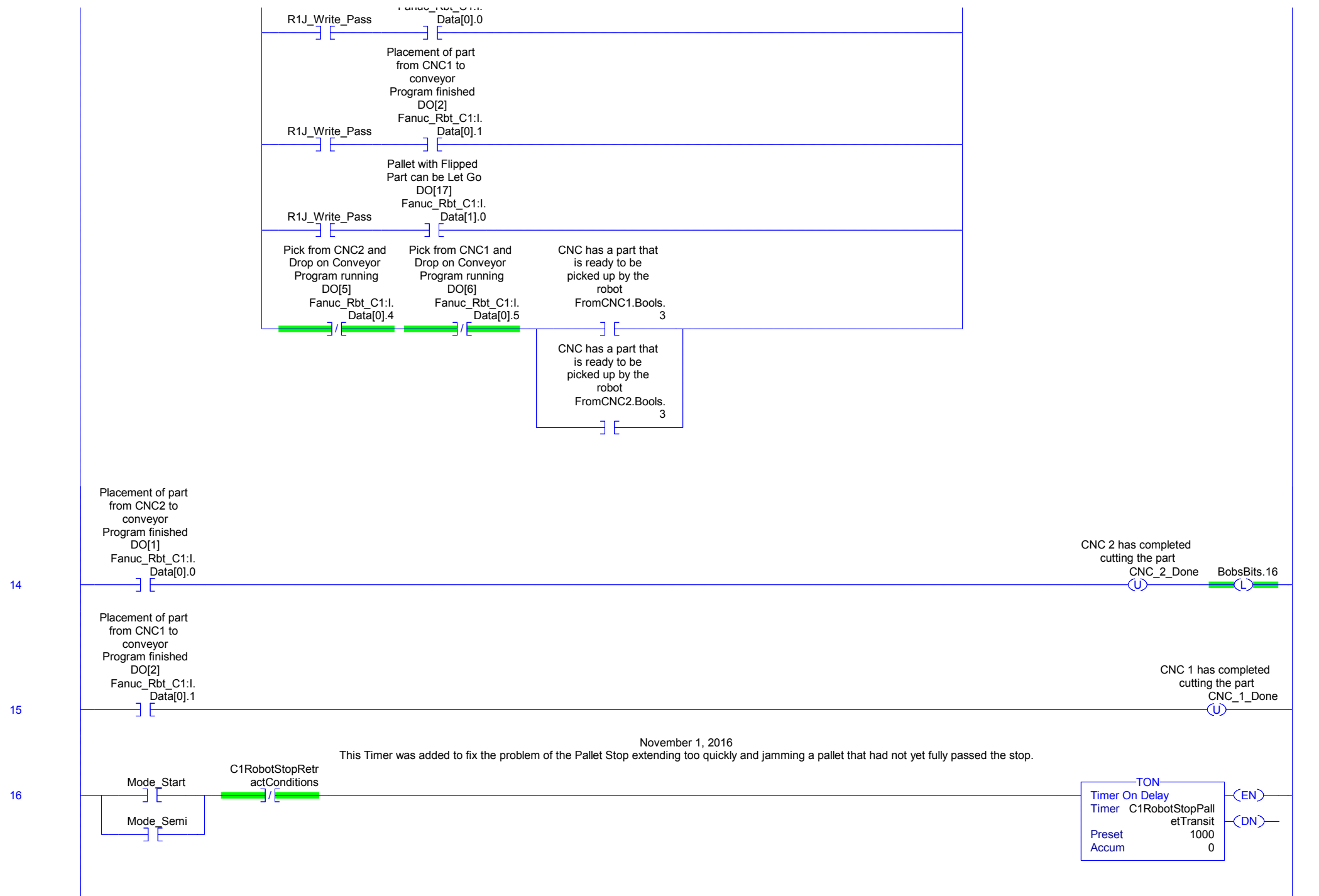
Fixed Error: RFID 3 tags were being used instead of RFID 1

November 9, 2016

Added Robot2_DroppedP1 and P2 FALSE conditions in front of some rungs to avoid releasing a pallet early while the robot is dropping a part from a CNC to the conveyor.

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Robot1_Busy_ZZ

Pick from Conveyor
and Drop on CNC2
Program running
DO[3]
Fanuc_Rbt_C1:I.
Data[0].2

Pick from Conveyor
and Drop on CNC1
Program running
DO[4]
Fanuc_Rbt_C1:I.
Data[0].3

Pick from CNC2 and
Drop on Conveyor
Program running
DO[5]
Fanuc_Rbt_C1:I.
Data[0].4

Pick from CNC1 and
Drop on Conveyor
Program running
DO[6]
Fanuc_Rbt_C1:I.
Data[0].5

Flip Part
Program running
DO[15]
Fanuc_Rbt_C1:I.
Data[0].14

(End)