Cell 2 ZZ - Ladder Diagram

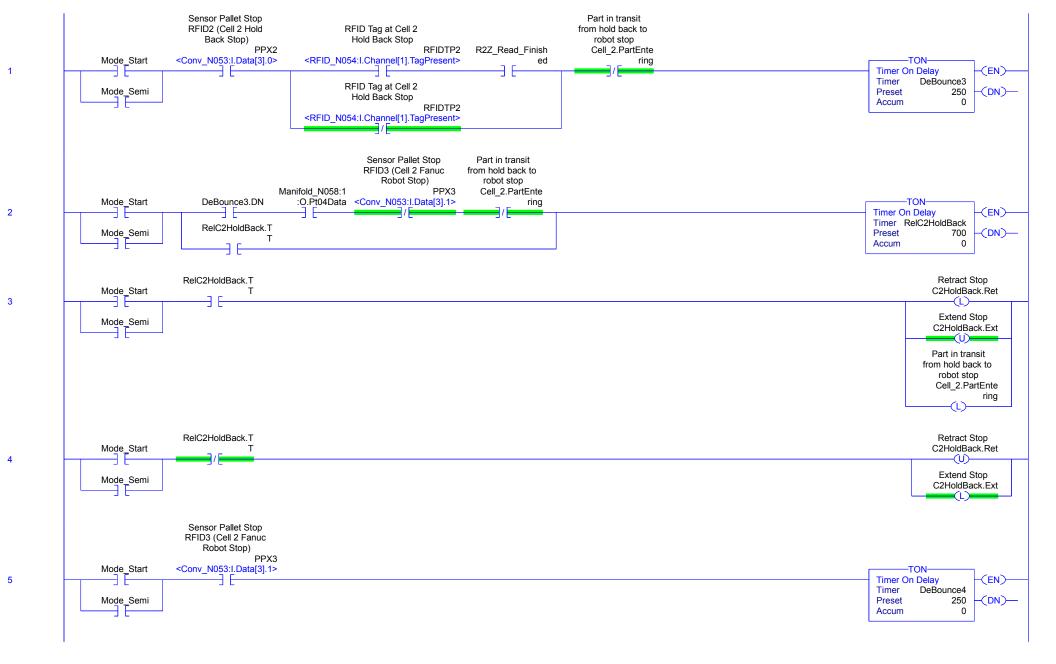
AdvManLab:MainTask:MainProgram Total number of rungs in routine: 17

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Total number of rungs in routine: 17

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RFID Tag at Cell 2 Bit is ON when CNC is NOT in cycle. Stop RFIDTP3 FromCNC3.Bools. DeBounce4.DN <RFID_N055:I.Channel[0].TagPresent> 5 Robot2_Busy_ZZ Mode_Start 6 Egual Equal Source A R3J_Current_Pro Source A R3J_Current_Par t_NO 2 2 Mode_Semi cess NO 3 3 Source B Source B Pick from Conveyor and drop on CNC 3 Fanuc Rbt C2:O. Data[0].0 Bit is ON when CNC is NOT in cycle. FromCNC4.Bools. 5 Robot2_Busy_ZZ Equal Equal Source A R3J_Current_Pro Source A R3J_Current_Par cess_NO t_NO 2 3 Source B Source B Pick from Conveyor and drop on CNC 4 DI[2] Fanuc_Rbt_C2:O. Data[0].1 CNC has a part that CNC signal to Cell is ready to be that it is at the picked up by the CNC 3 has completed Pick / Drop location robot cutting the part FromCNC3.Bools. FromCNC3.Bools. CNC_3_Done 7 CNC has a part that CNC signal to Cell is ready to be that it is at the picked up by the Pick / Drop location robot (M73) CNC 4 has completed FromCNC4.Bools. FromCNC4.Bools. cutting the part CNC_4_Done 8

Cell 2 ZZ - Ladder Diagram

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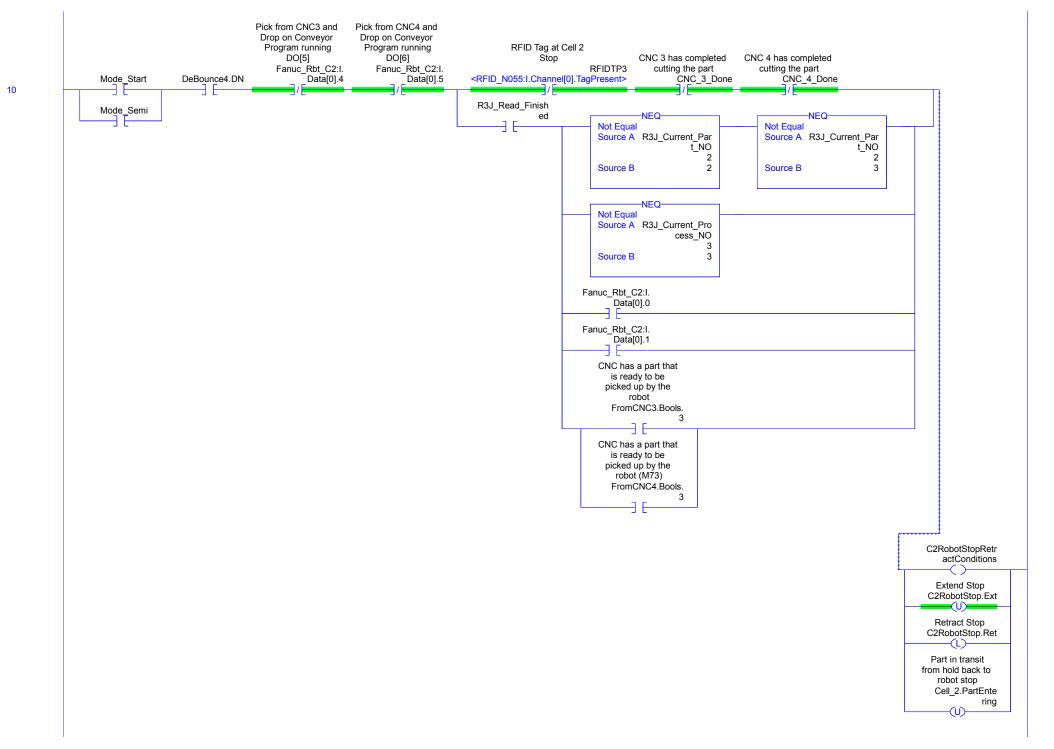
AdvManLab:MainTask:MainProgram Total number of rungs in routine: 17

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Total number of rungs in routine: 17 C:\Users\VRMILLING\Documents\control_team_manuals\Logic W2017\Separate branches\Chris_20171206_1_AdvManLabCurrent.ACD

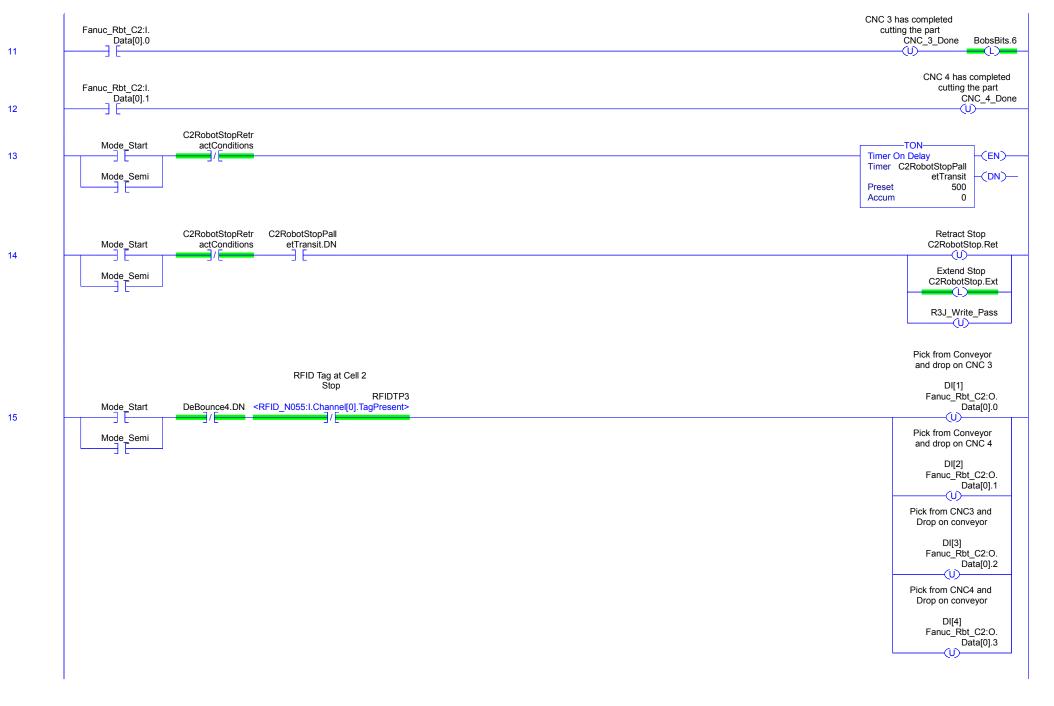


Cell 2 ZZ - Ladder Diagram

AdvManLab:MainTask:MainProgram Total number of rungs in routine: 17

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Total number of rungs in routine: 17

