**VBAI Read (PLC output)**

**Booleans:**

|  |  |
| --- | --- |
| **VBAI** | **Studio 5000 I/O** |
| Bool 0: Camera Trigger | NI\_1752:O.Data[0].0 |

**SINTs:**

|  |  |
| --- | --- |
| **Studio 5000** | **RFID Address** |
| Part\_Type\_Counter | Address 3 |
| RFID\_ReadData#process | Address 4 |

**VBAI Write (PLC input)**

**Booleans:**

|  |  |  |  |
| --- | --- | --- | --- |
| **VBAI** | **Studio 5000 I/O** | **Studio 5000 Storage Tags** | **RFID Address\*** |
| Bool 8: Reset Camera Trigger | NI\_1752:I.Data[0].8 | N/A | N/A |
| Bool 9: Geometry 1 Pass/Fail | NI\_1752:I.Data[0].9 | VBAI\_Geometry1 | Address 11 – bit 0 |

**REALs:**

|  |  |  |  |
| --- | --- | --- | --- |
| **VBAI** | **Studio 5000 I/O** | **Studio 5000 Storage Tags** | **RFID Address\*** |
| REAL 0: Geometry 1 dimension | NI\_1752:I.Data[22] | VBAI\_Geometry1\_Dim | Address 12-15 (4 bytes) |

**\*Note: 112 bytes (address locations) appear to be available on each RFID tag.** Some Address locations are in use for measuring process times and for test values (# indicates different tags are used in different routines and on different branches):

* Address 2: RFID\_WriteData#
* Address 3: RFID\_ReadData#p or HMI\_WritePart (RFID\_6) - now in use for part numbers
* Address 4: RFID\_ReadData#process or RFID\_WriteProcess# (RFID\_1 and 3) or 0 (RFID\_6) - now in use for process numbers
* Address 7: RFID#timer[0] or CNC#timer[0] (RFID\_1 and 3)
* Address 8: RFID#timer[1] or CNC#timer[1] (RFID\_1 and 3)
* Address 9: RFID#timer[2] or CNC#timer[2] (RFID\_1 and 3)
* Address 10: RFID#timer[3] or CNC#timer[3] (RFID\_1 and 3)

**RFID INFO:**

**2 RFID tags for one member:**

**RFID\_N054:I.Channel[0] - RFID 1**

**RFID\_N054:I.Channel[1] - RFID 2**

**-RFID\_N054:I.Channel[1].TagPresent**

**Command = 14, write**

**Command = 4, read**

**Command = 0, before action is called, reset?**

**RFID tag size: 112 bytes**