

































 **Controller GrahamPgkRob** **Controller Fault Handler** **Power-Up Handler****Tasks** **GrahamPgkRob** **MainRoutines** **MainRoutines** **R01_AlarmWarnMsg** **R02_SystemSts** **R03_SystemStartup** **R10_SystemCtrl** **R11_PnuematicCtrl** **R20_ScannerIO** **R21_SystemIO** **R22_RobotEIO** **R23_CameraEIO** **R30_HMISSts** **R31_HMICtrl** **R32_BaySts** **ProcessRoutines**

Routines that perform actions in a set order every time. ie do this then that then this ...

 **SubRoutines** **r_EvaluateBox** **r_PositionBox** **r_ReadBox** **r_RejectBox** **r_RobotPickBox** **MainTask** **MainProgram** **MainRoutine** **Unscheduled Programs / Phases****Motion Groups** **Ungrouped Axes****Add-On Instructions** **AirCyl_NoExtendFeedback** **Logic** **PulseDO** **Logic****Data Types** **User-Defined** **AirCylinder** **BayStatus** **BoxData** **PLCtoRobot** **ProcessIndicators** **RobotToPLC** **StepData** **Strings** **Add-On-Defined** **AirCyl_NoExtendFeedback** **PulseDO** **Module-Defined** **AB:1734_1SLOT:I:0** **AB:1734_1SLOT:O:0** **AB:1734_3SLOT:I:0** **AB:1734_3SLOT:O:0** **AB:1734_DI8:C:0** **AB:Embedded_DiscreteIO:C:0**

 AB:Embedded_DiscreteIO:I:0
 AB:Embedded_DiscreteIO:O:0
 AB:ETHERNET_MODULE:C:0
 AB:ETHERNET_MODULE_DINT_20Bytes:I:0
 AB:ETHERNET_MODULE_DINT_20Bytes:O:0
 AB:ETHERNET_MODULE_DINT_32Bytes:I:0
 AB:ETHERNET_MODULE_DINT_32Bytes:O:0
 AB:ETHERNET_MODULE_DINT_40Bytes:I:0
 AB:ETHERNET_MODULE_DINT_40Bytes:O:0
 AB:ETHERNET_MODULE_SINT_8Bytes:I:0
 AB:ETHERNET_MODULE_SINT_8Bytes:O:0
 CC:DataMan_Control:O:0
 CC:DataMan_NODATA:O:0
 CC:DataMan_SINT32:I:0
 CC:DataMan_Status:I:0
 _000C:XS26_AAB94180:O:0
 _000C:XS26_E44F4328:I:0

Trends

I/O Configuration

PointIO

 [0] 1769-L16ER-BB1B GrahamPgkRob

 [1] Embedded Discrete_IO

Ethernet

 1769-L16ER-BB1B GrahamPgkRob

 1734-AENTR/B Rack02

Remote Rack 02

PointIO 3 Slot Chassis

 [0] 1734-AENTR/B Rack02


Remote Rack 02

 [1] 1734-IB8/C Slot01

 [2] 1734-IB8/C Slot02

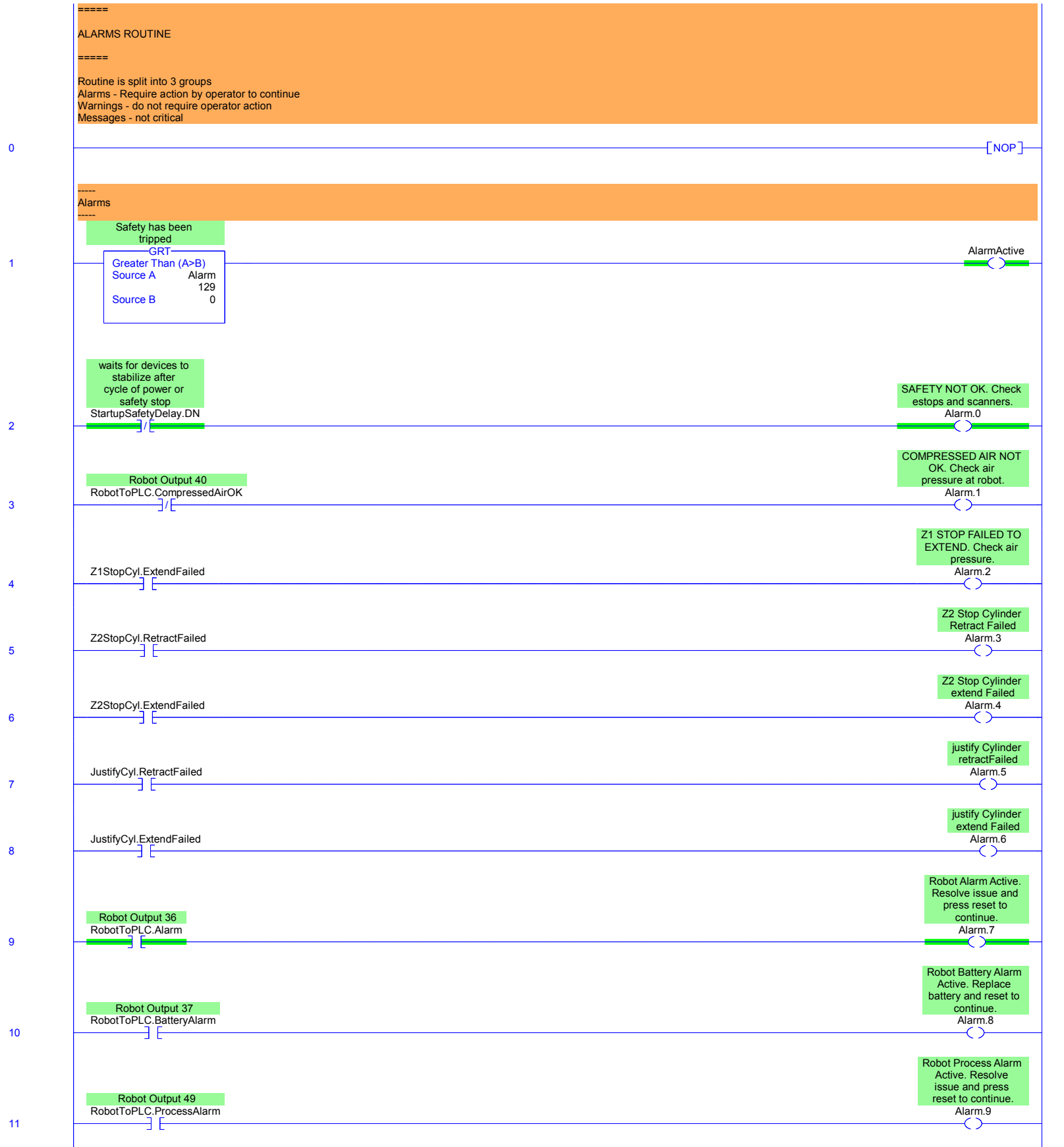
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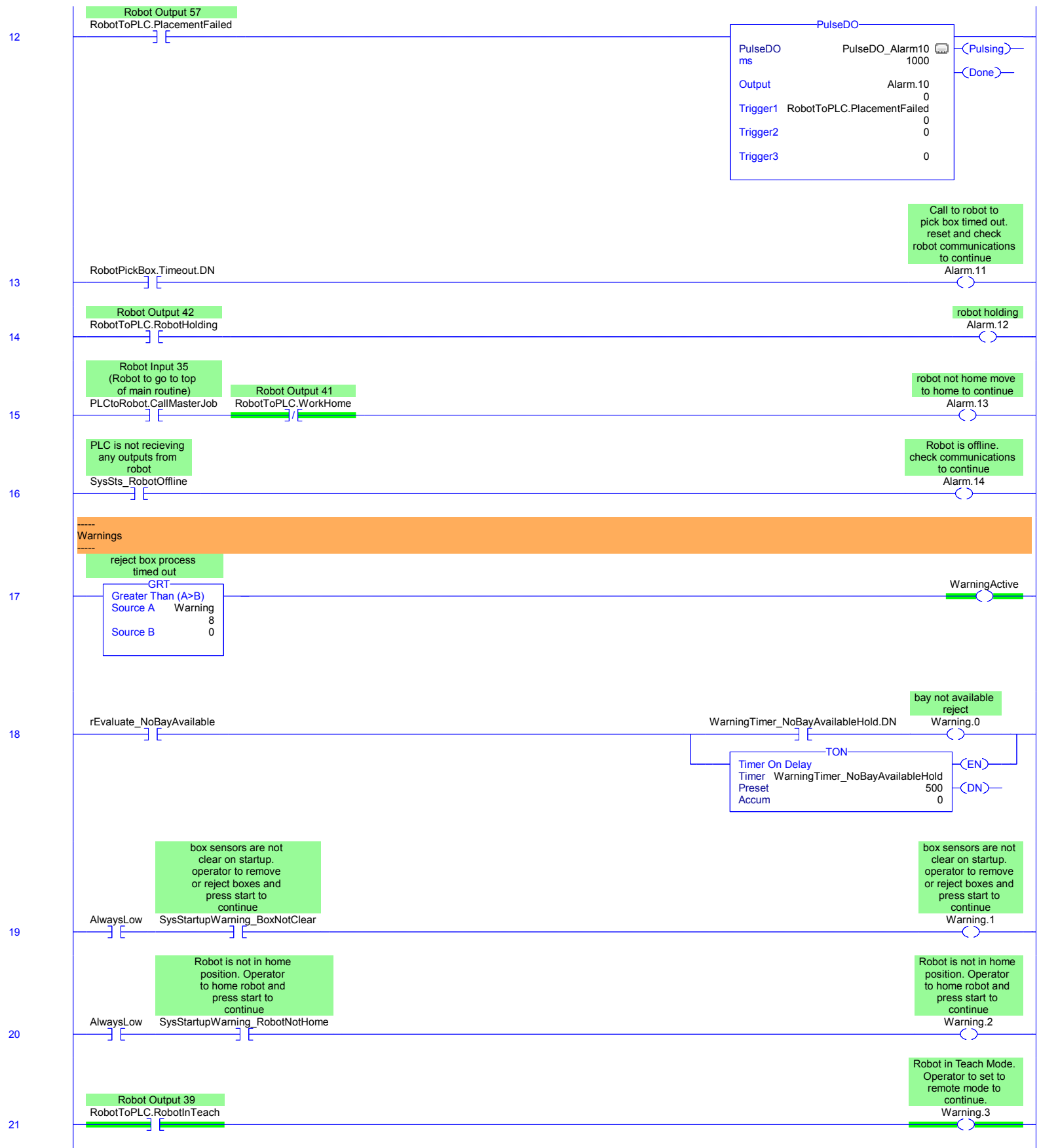
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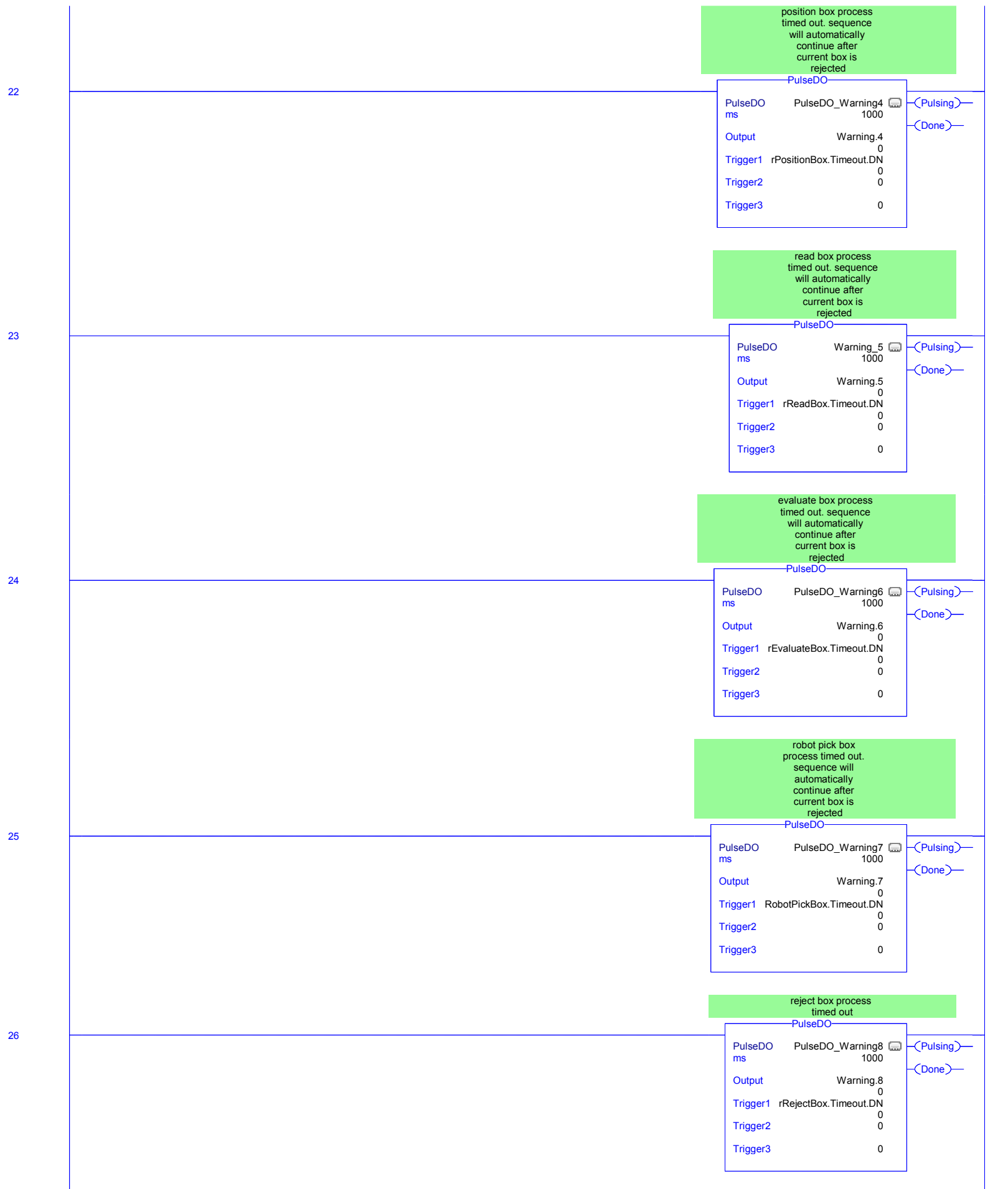
 DataMan 300 Series DM300

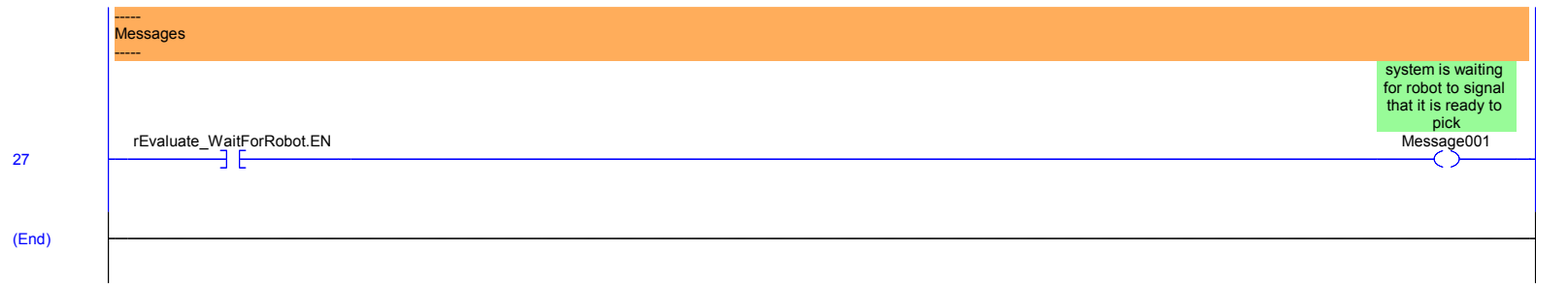
Cognex Dataman 300 Barcode Scanner

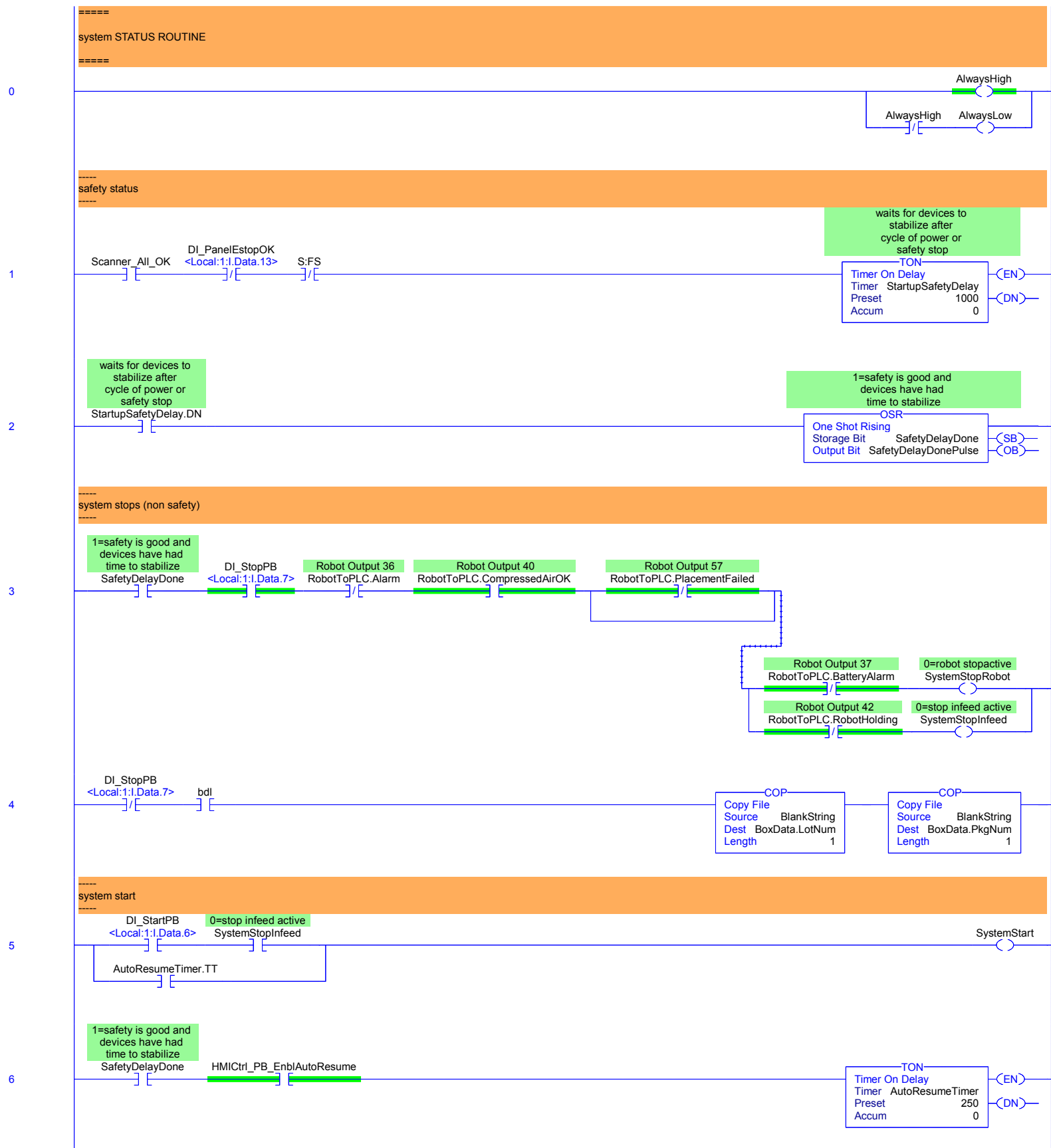


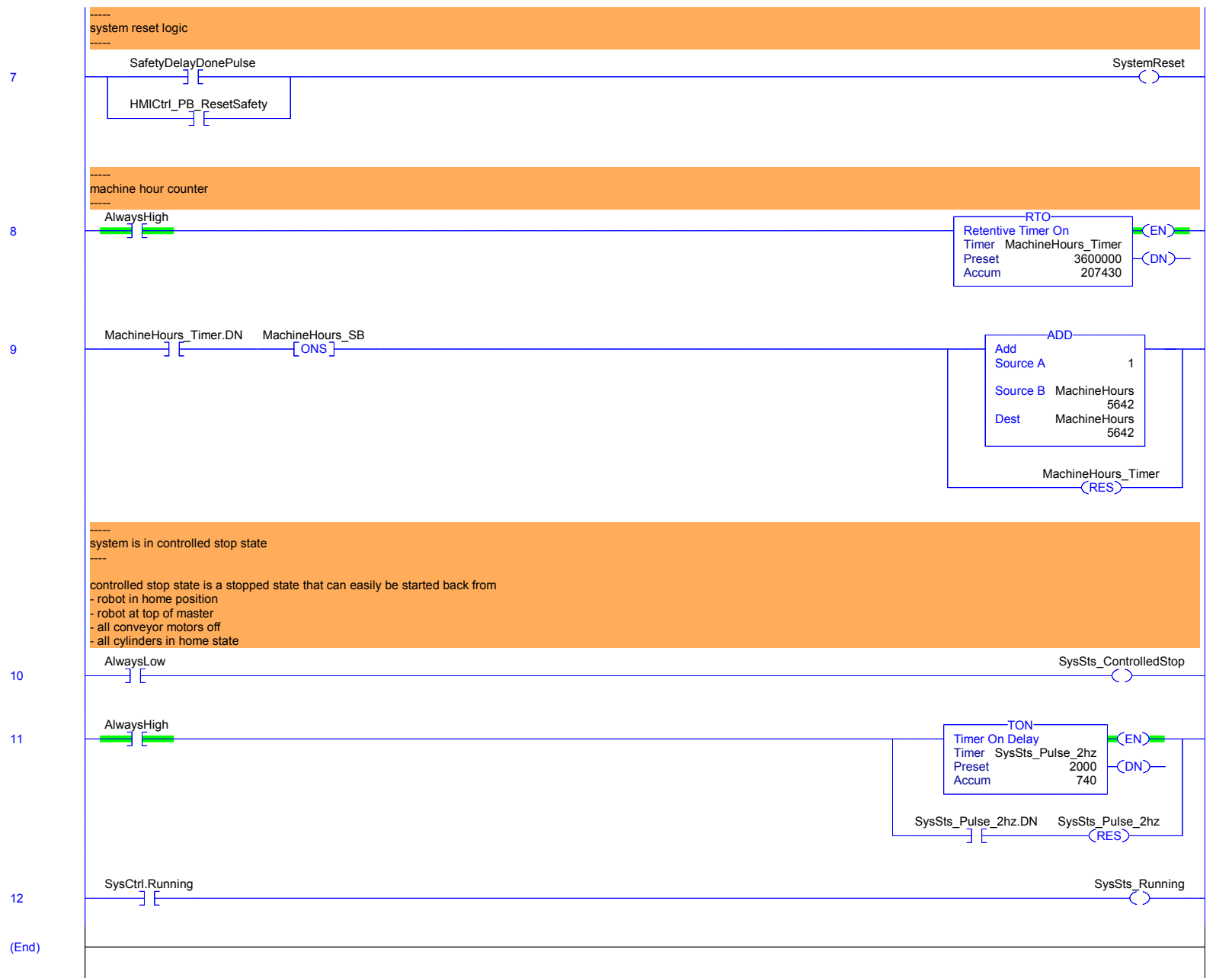


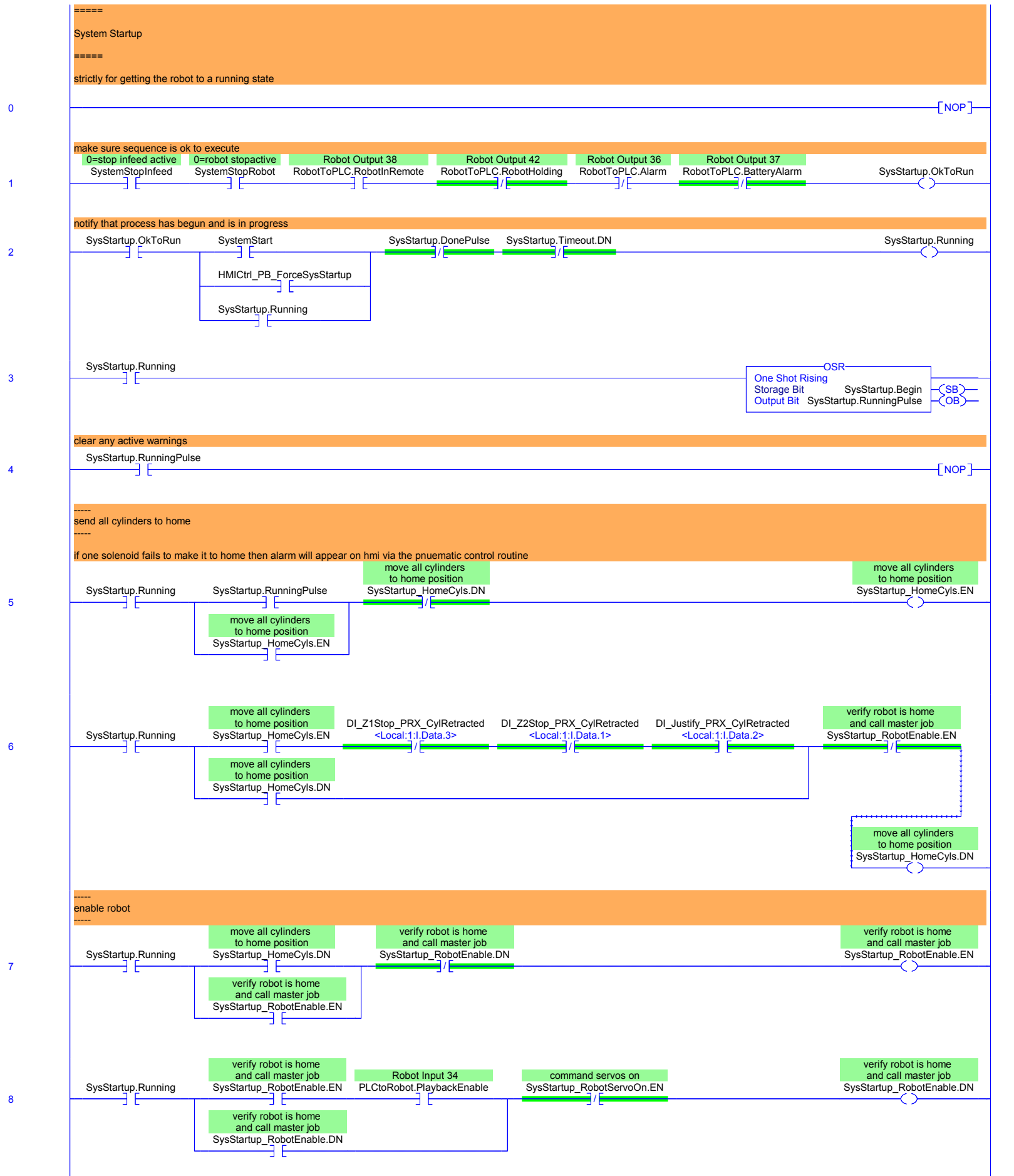


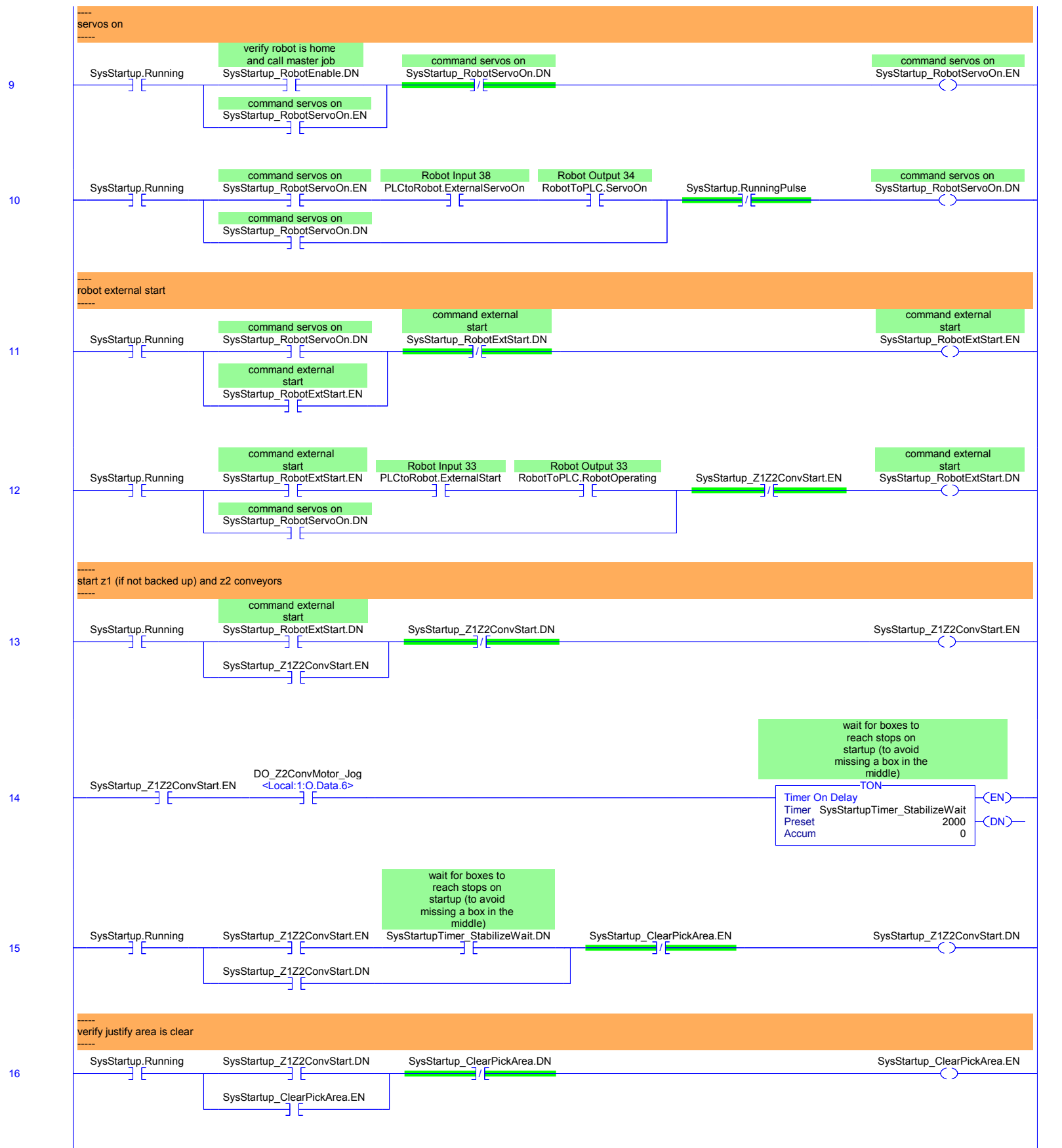


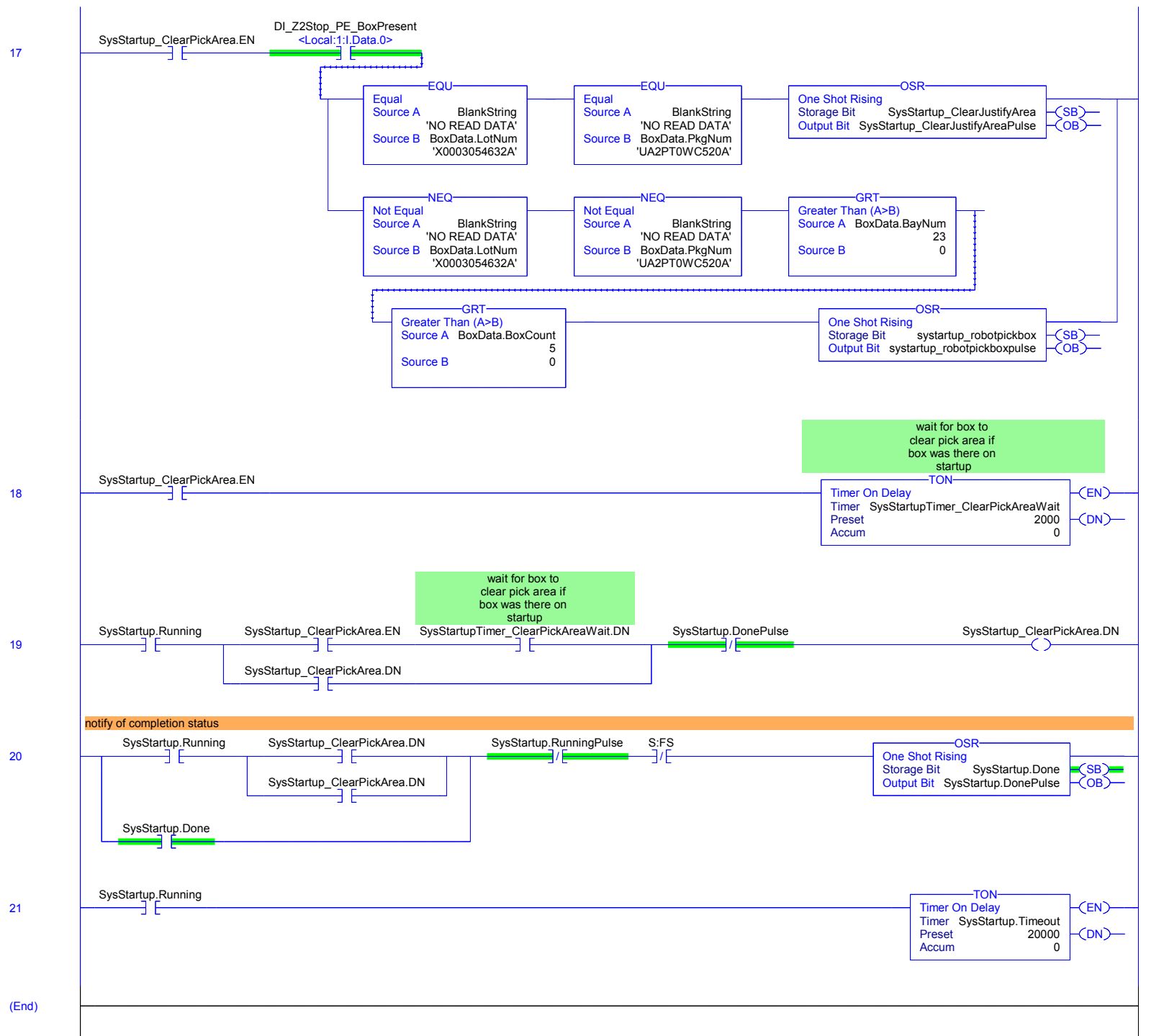


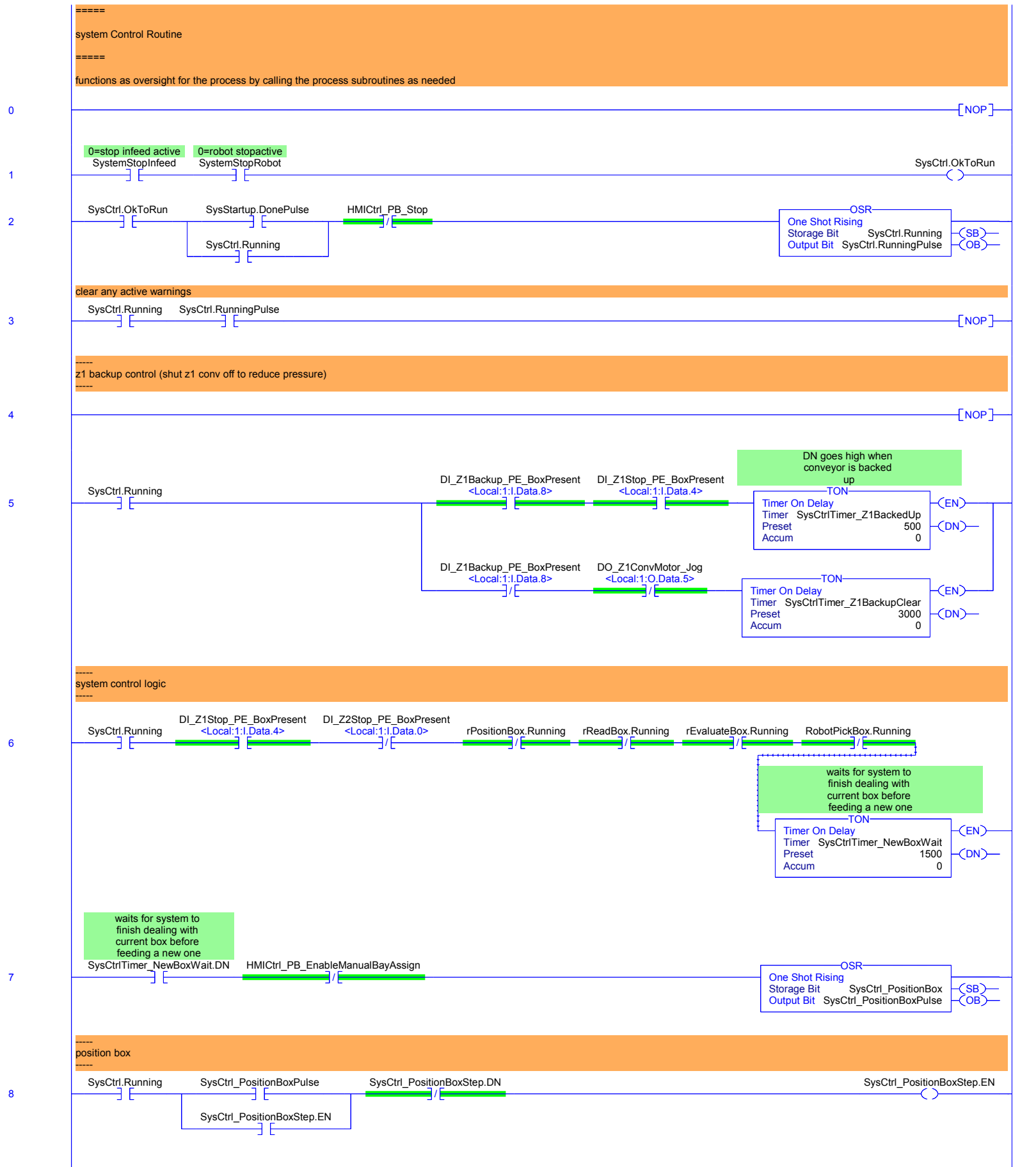


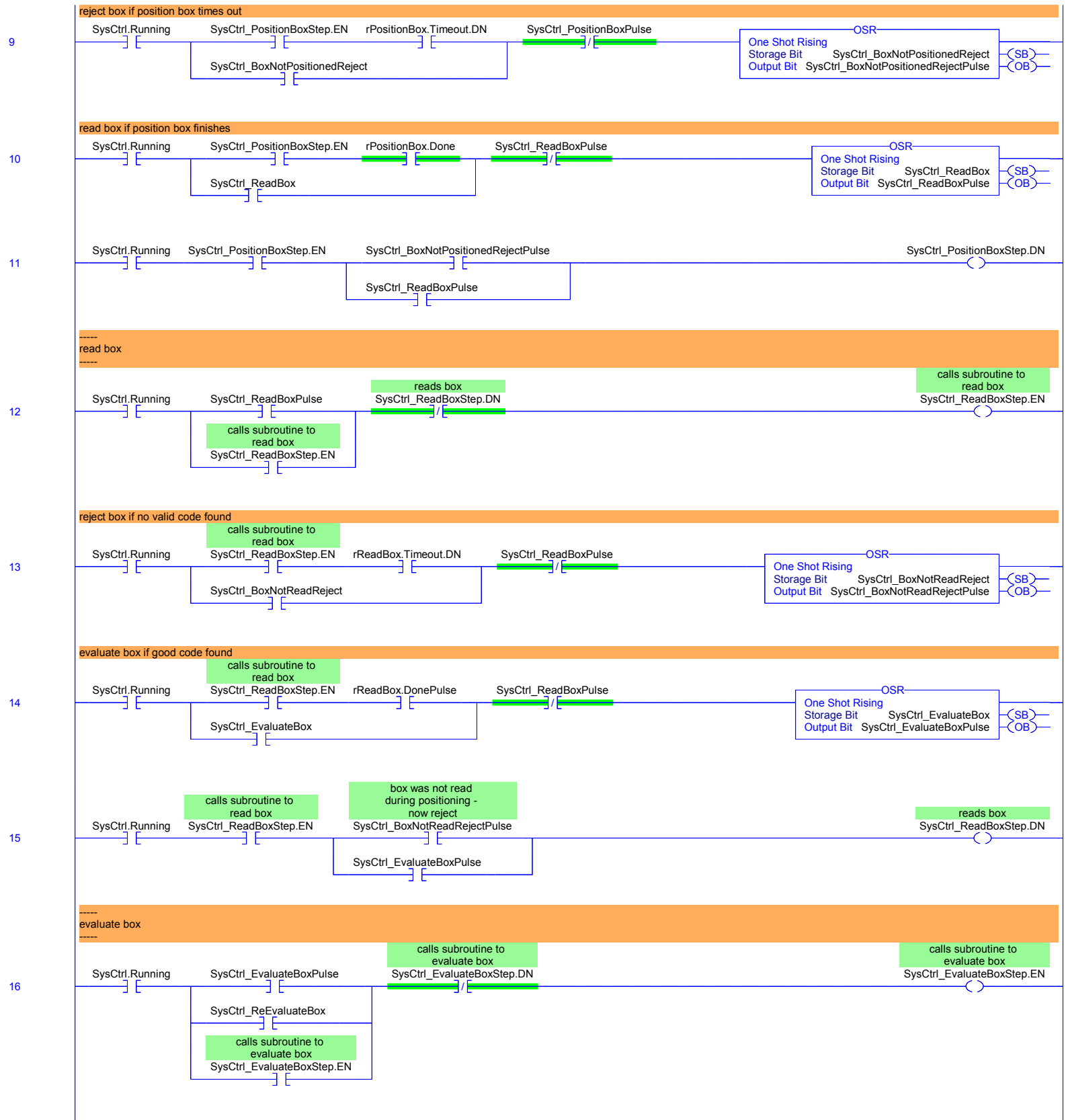


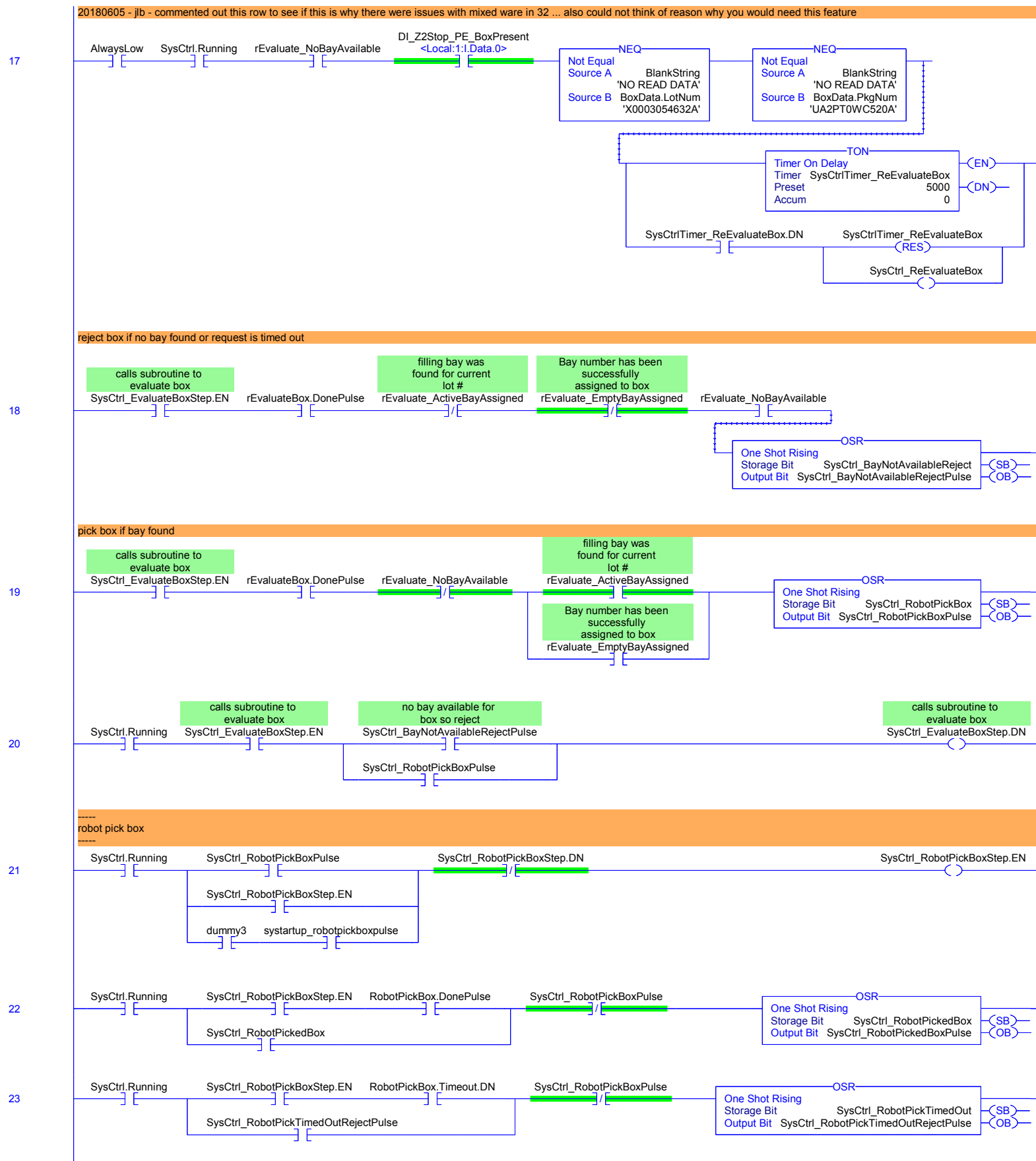


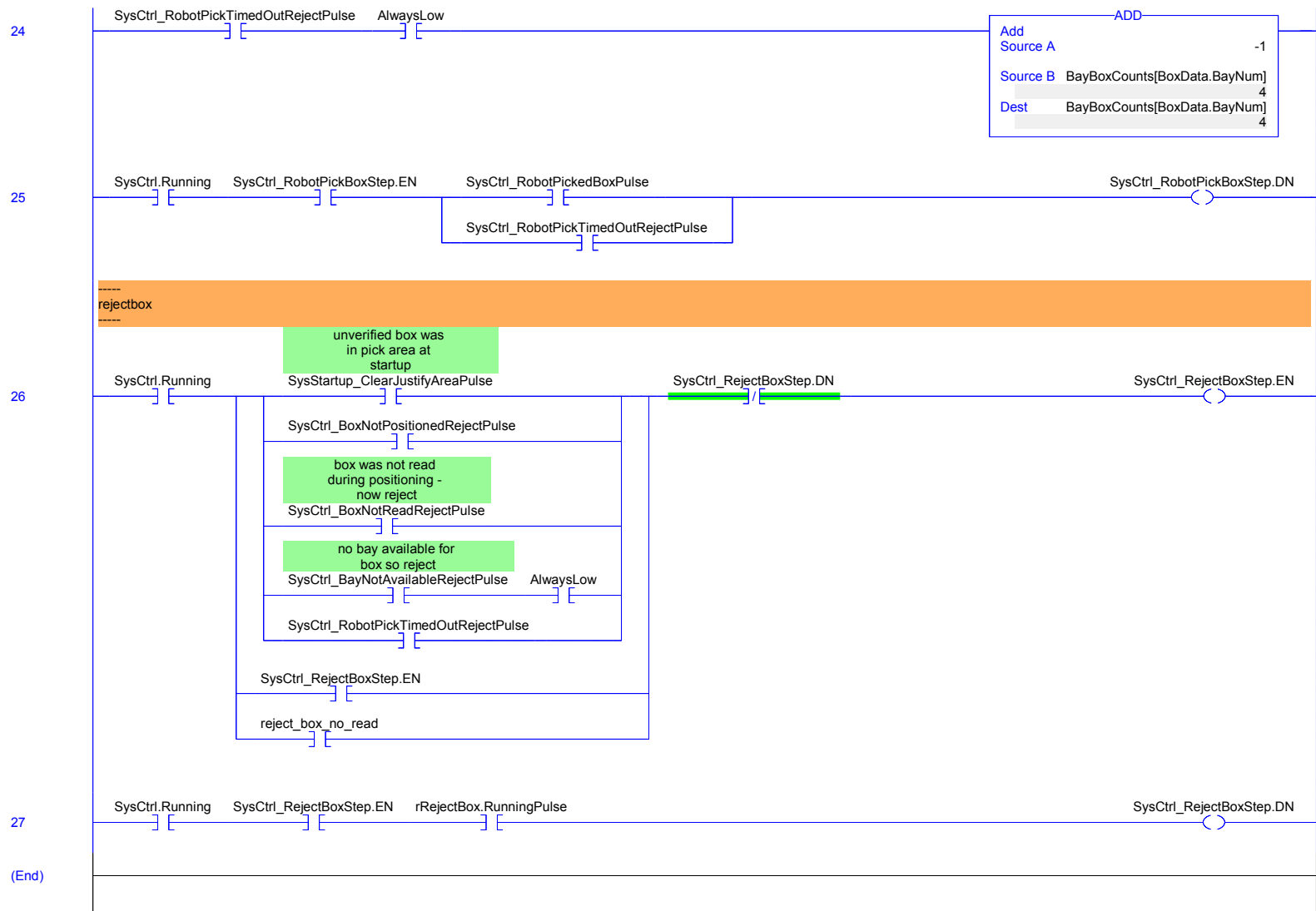


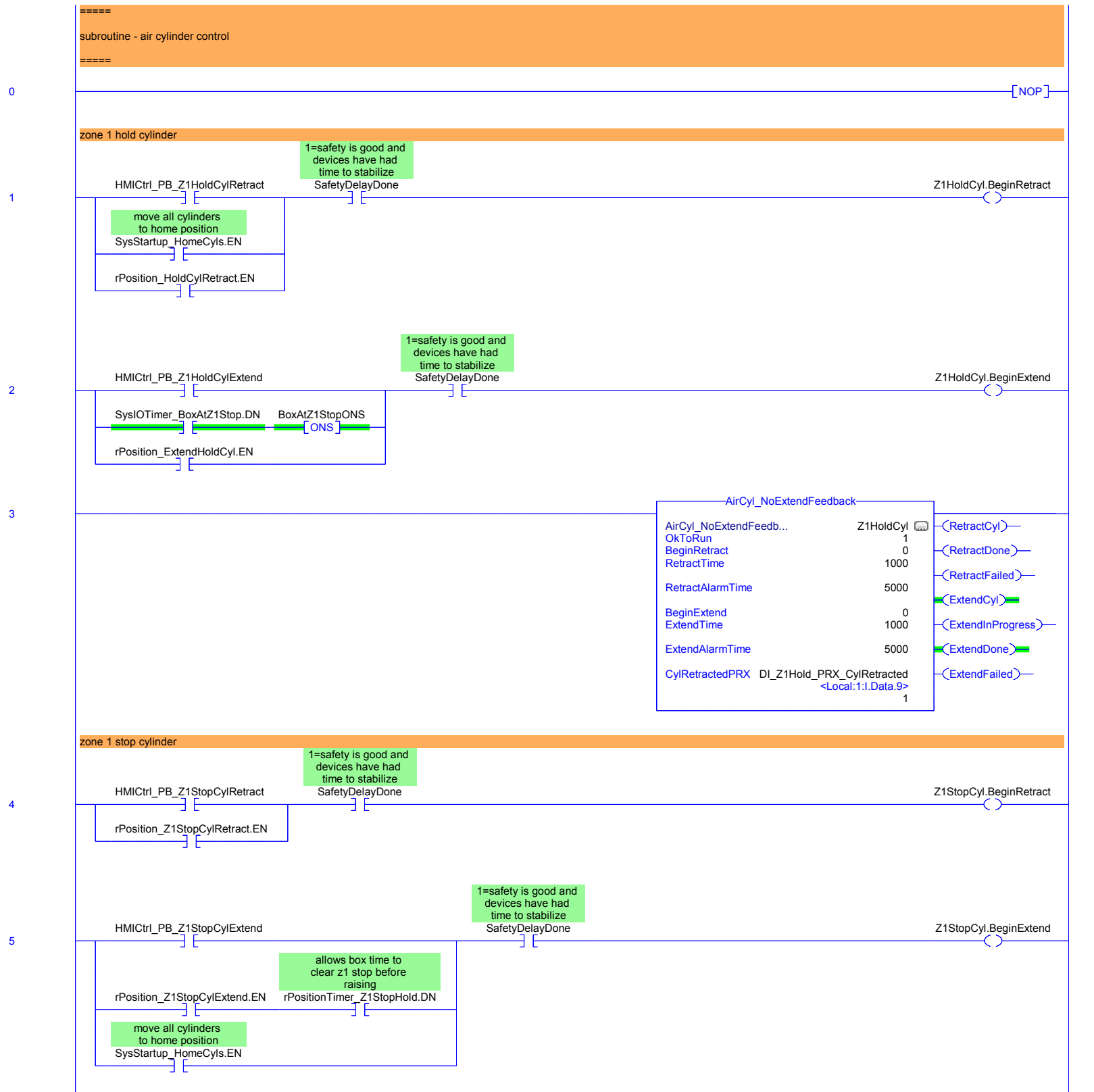




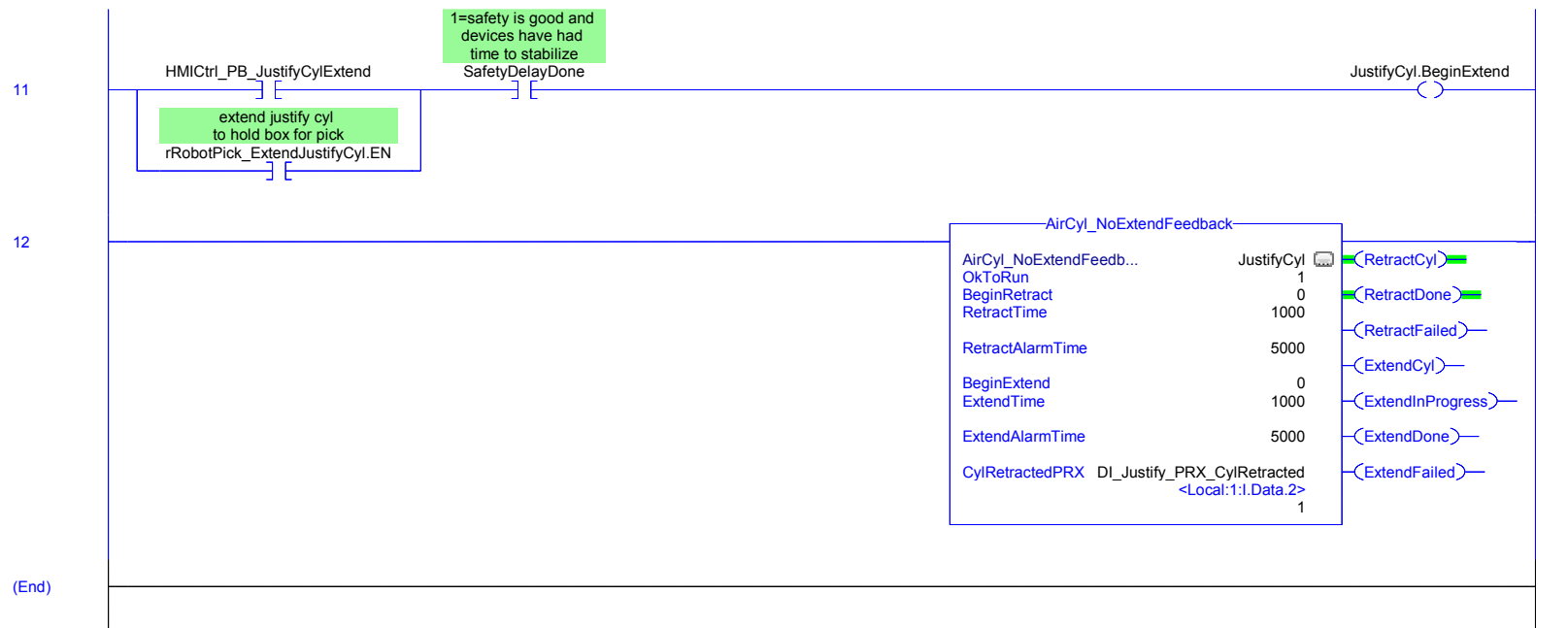


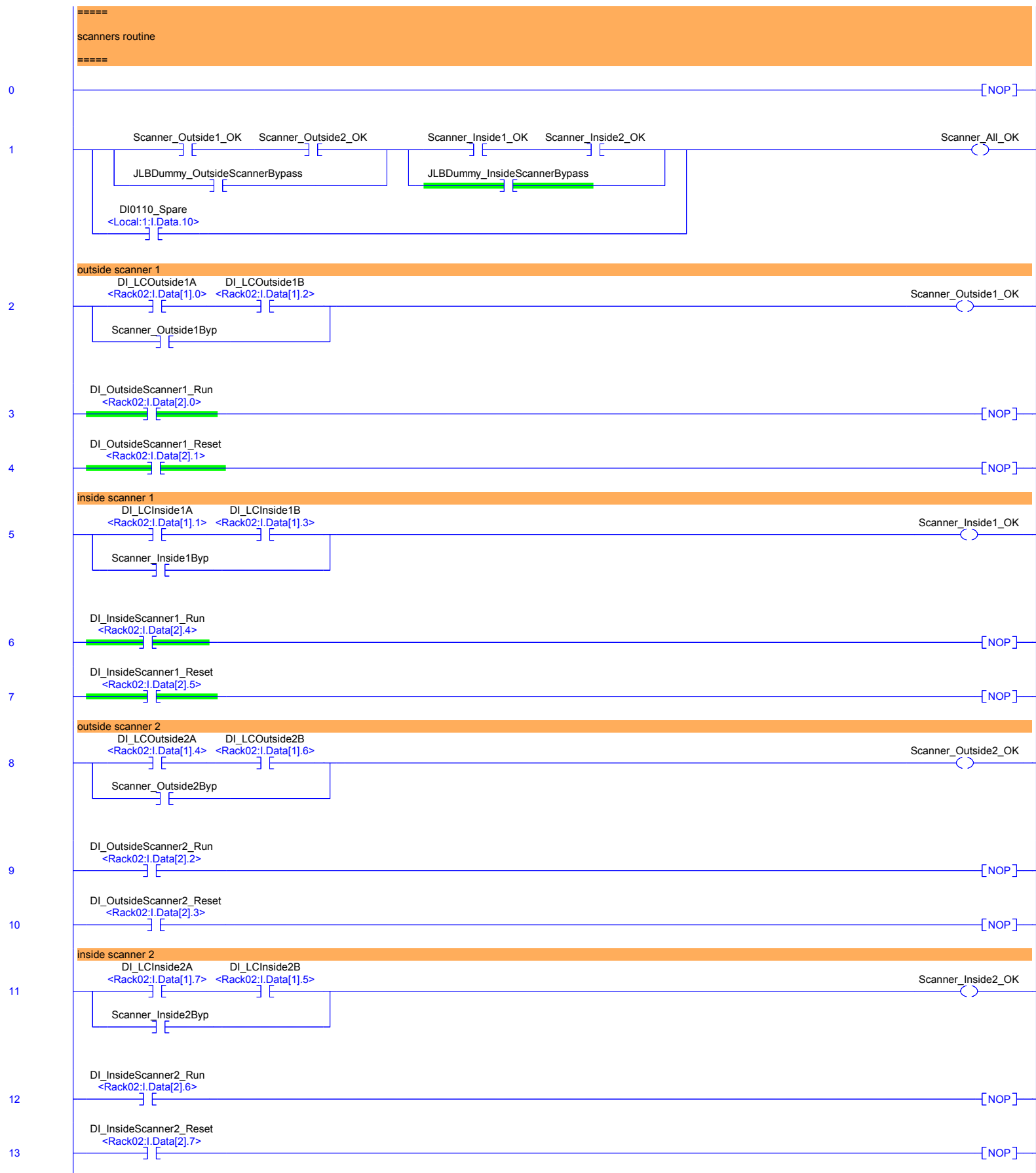


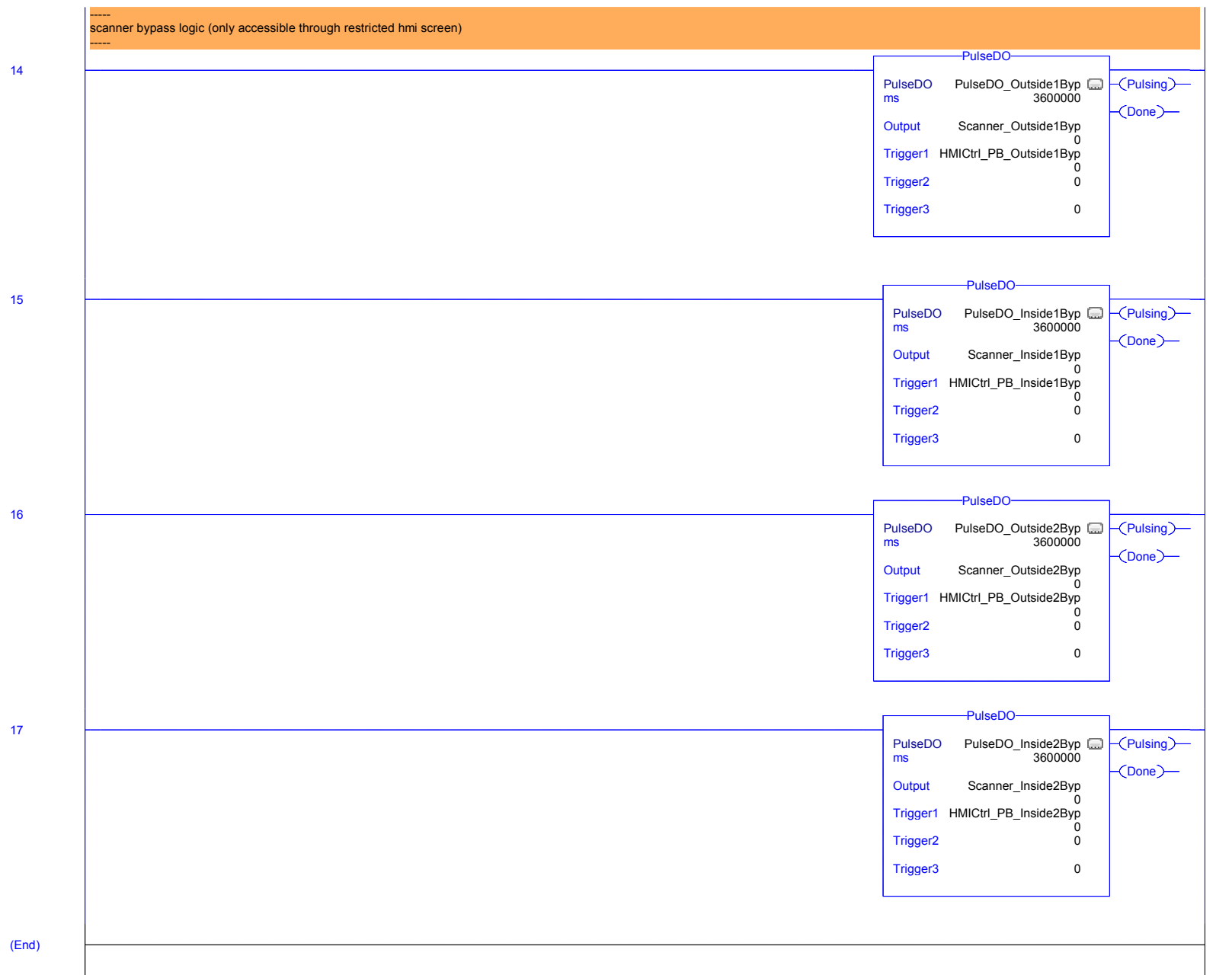


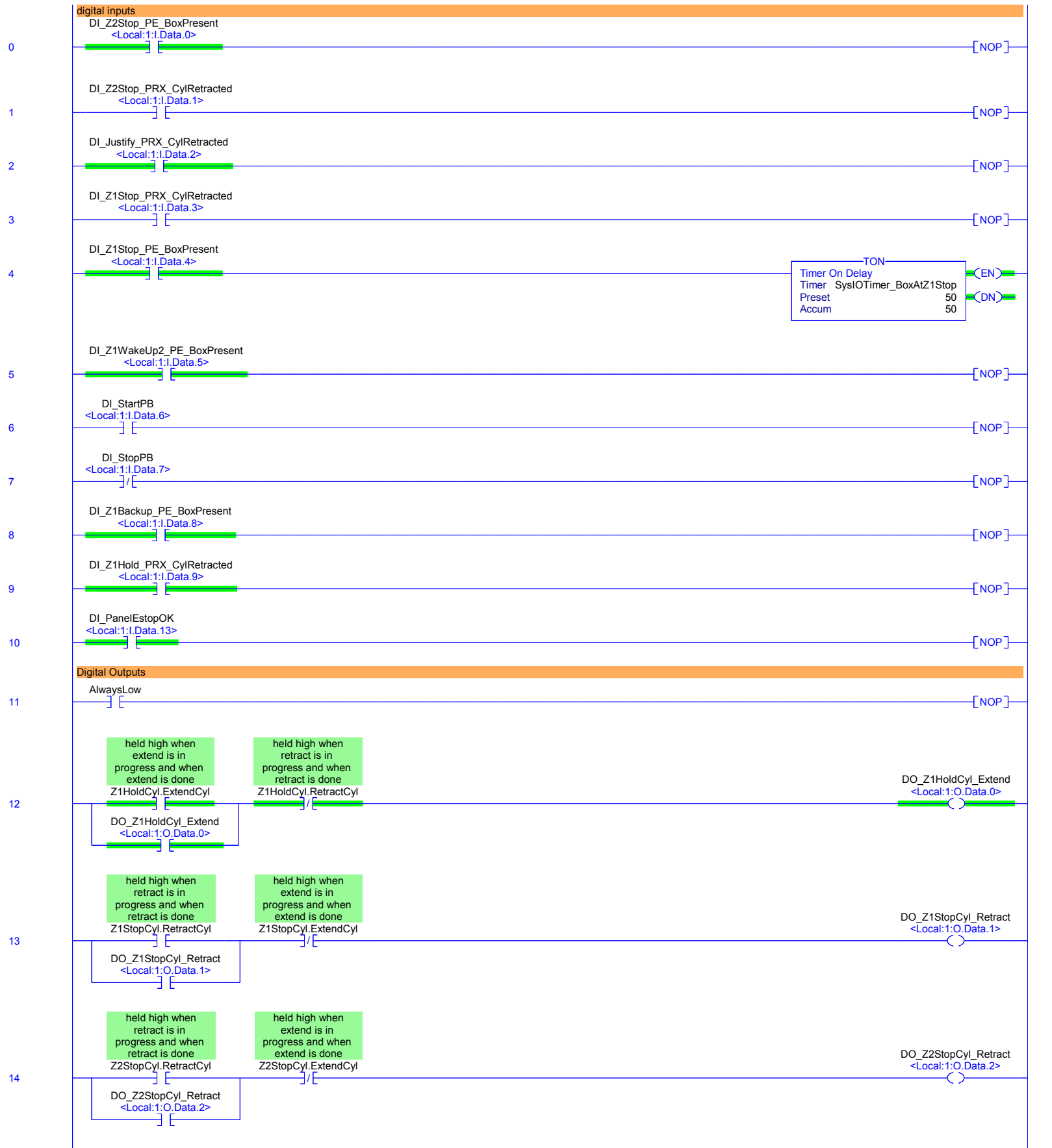


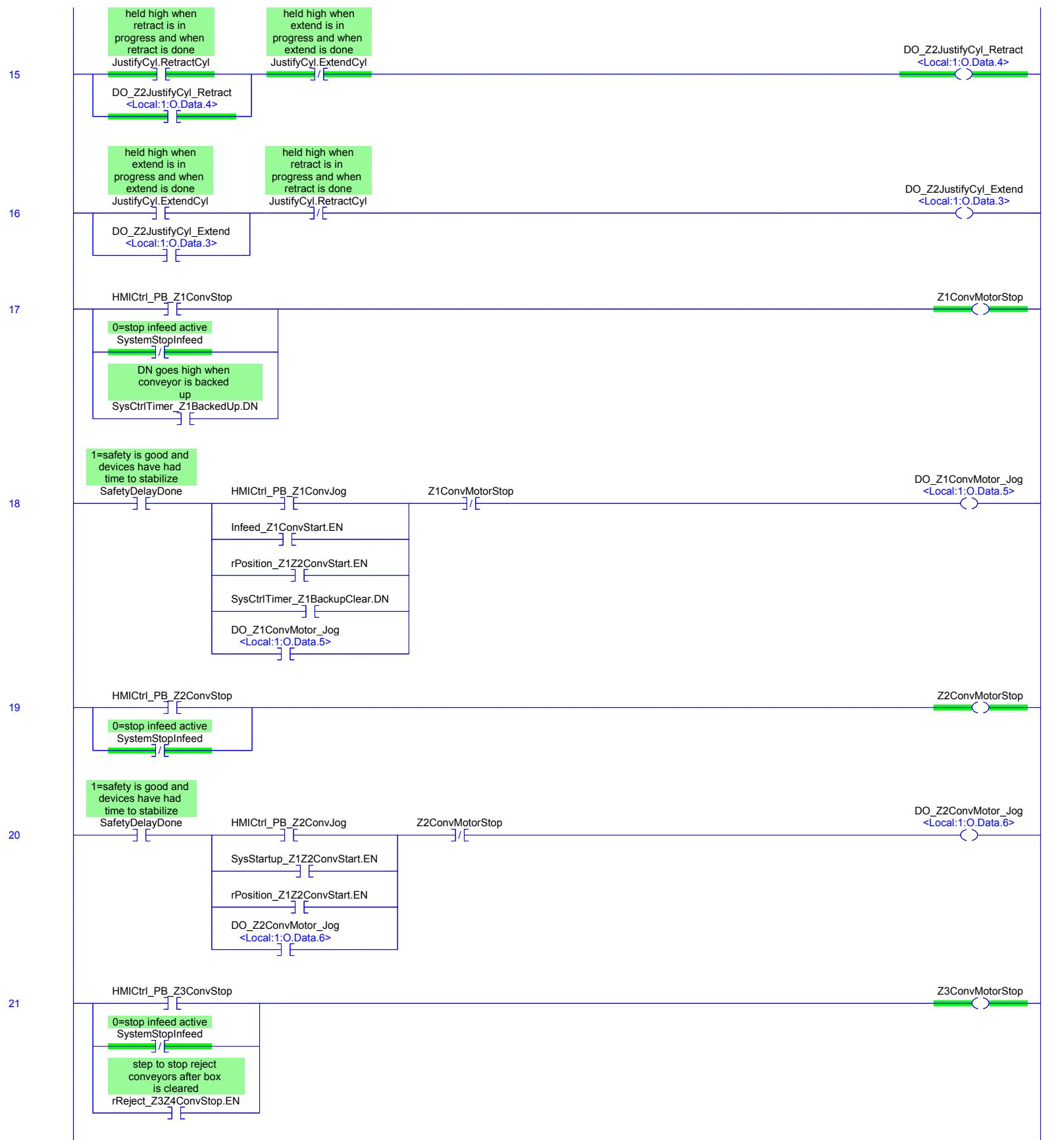


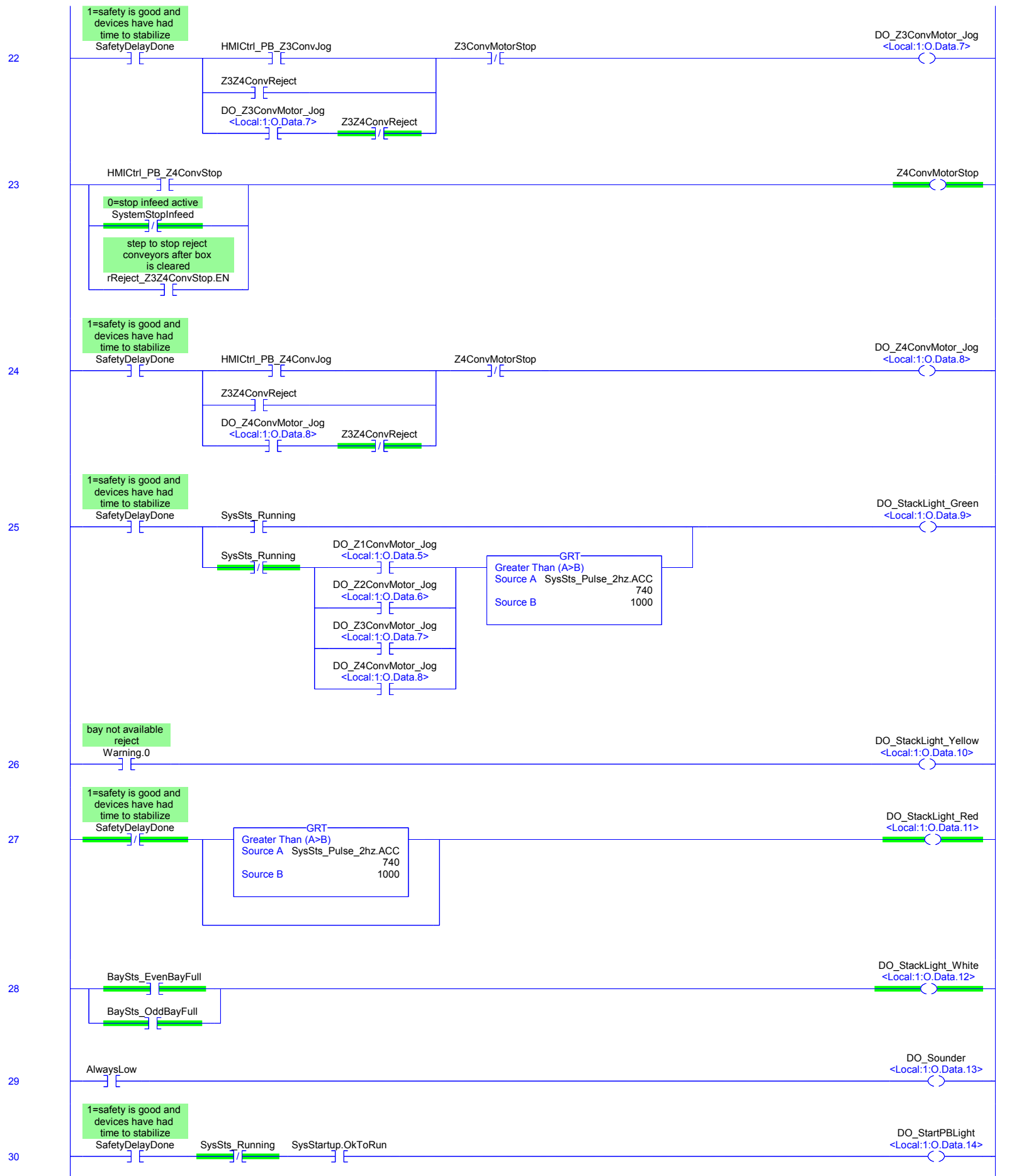


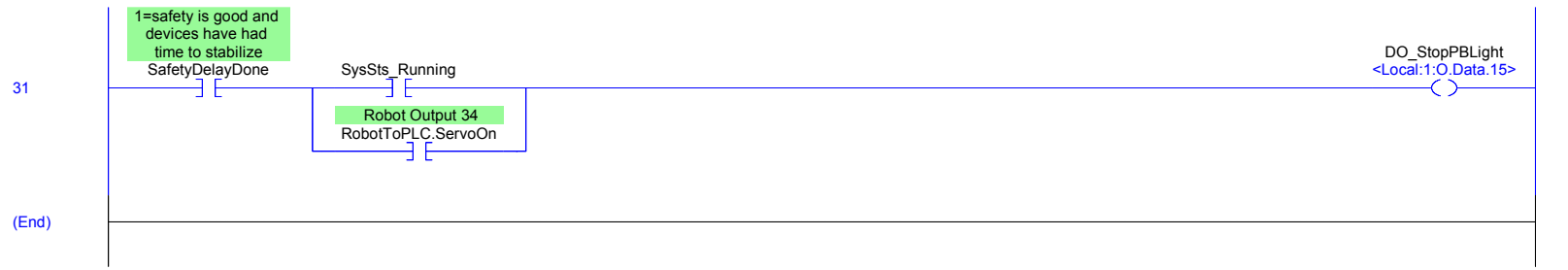


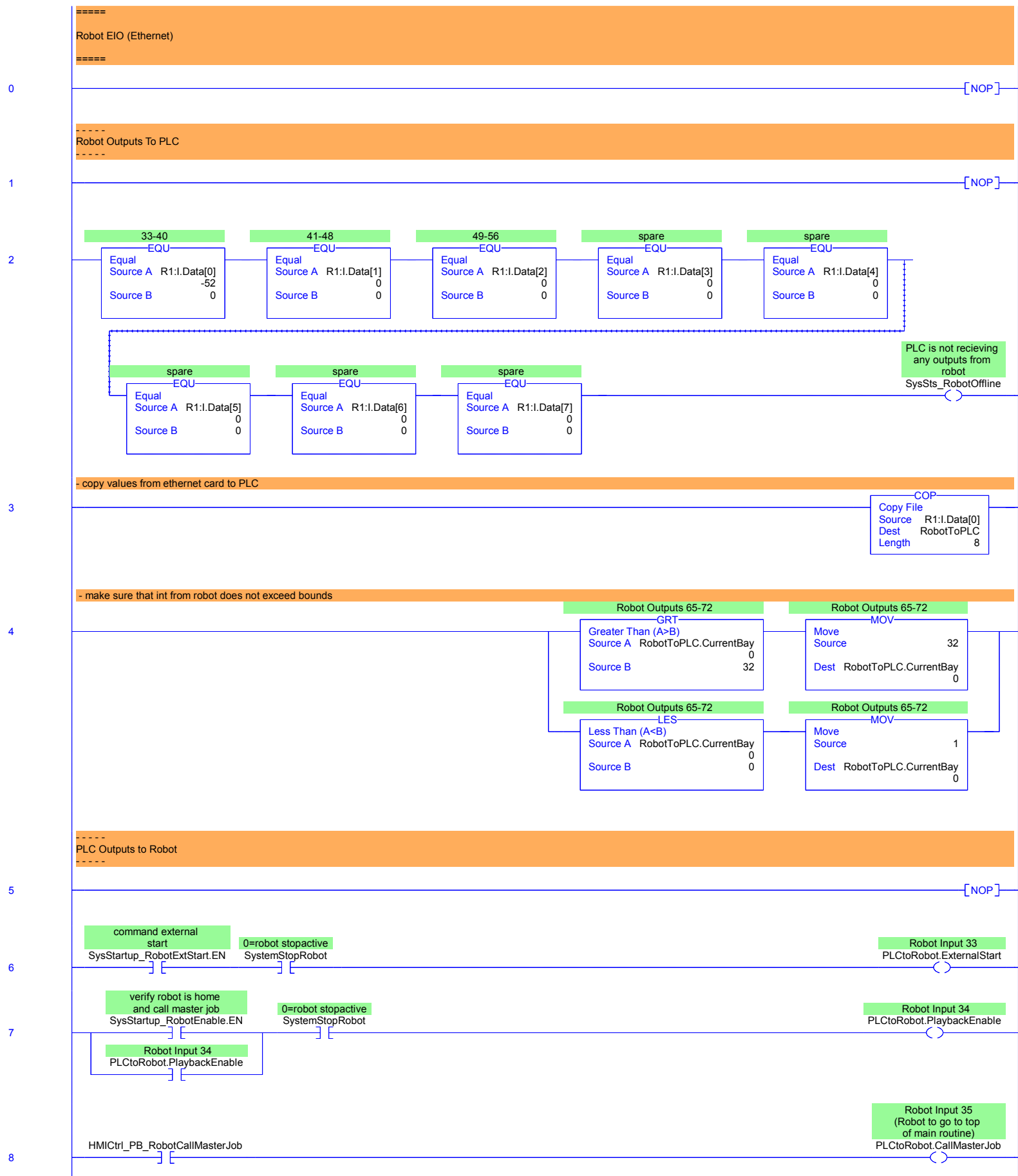


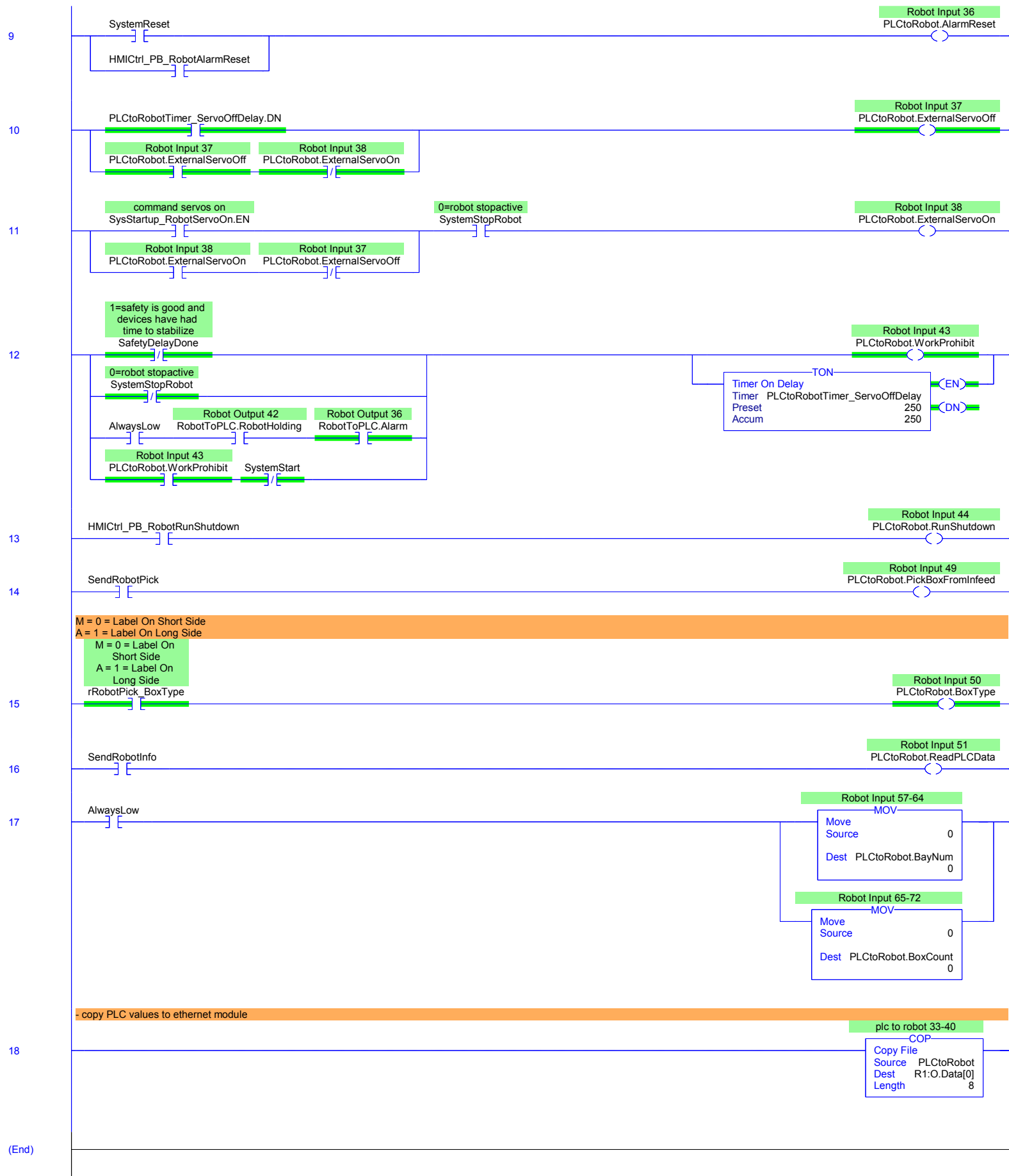


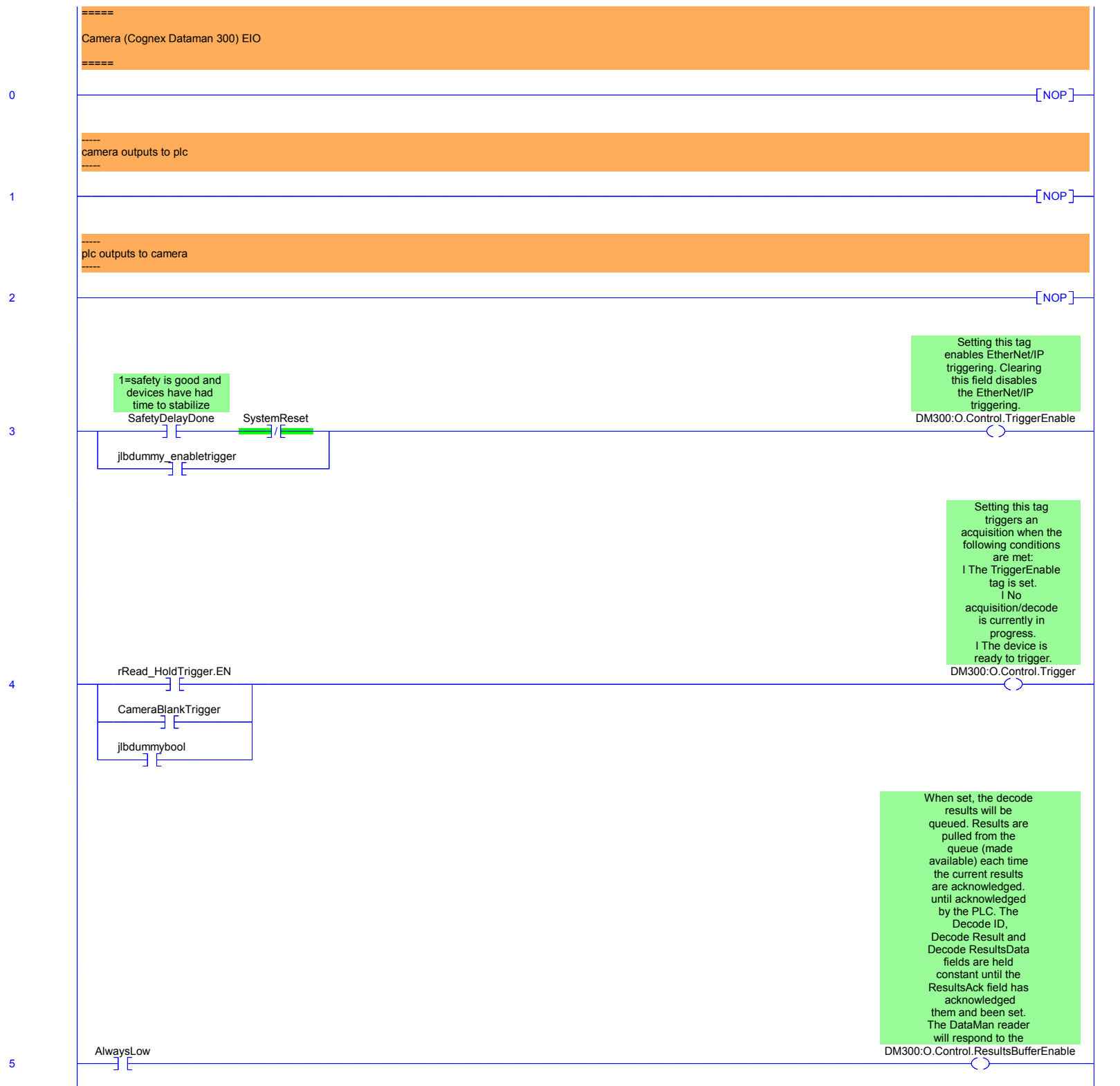


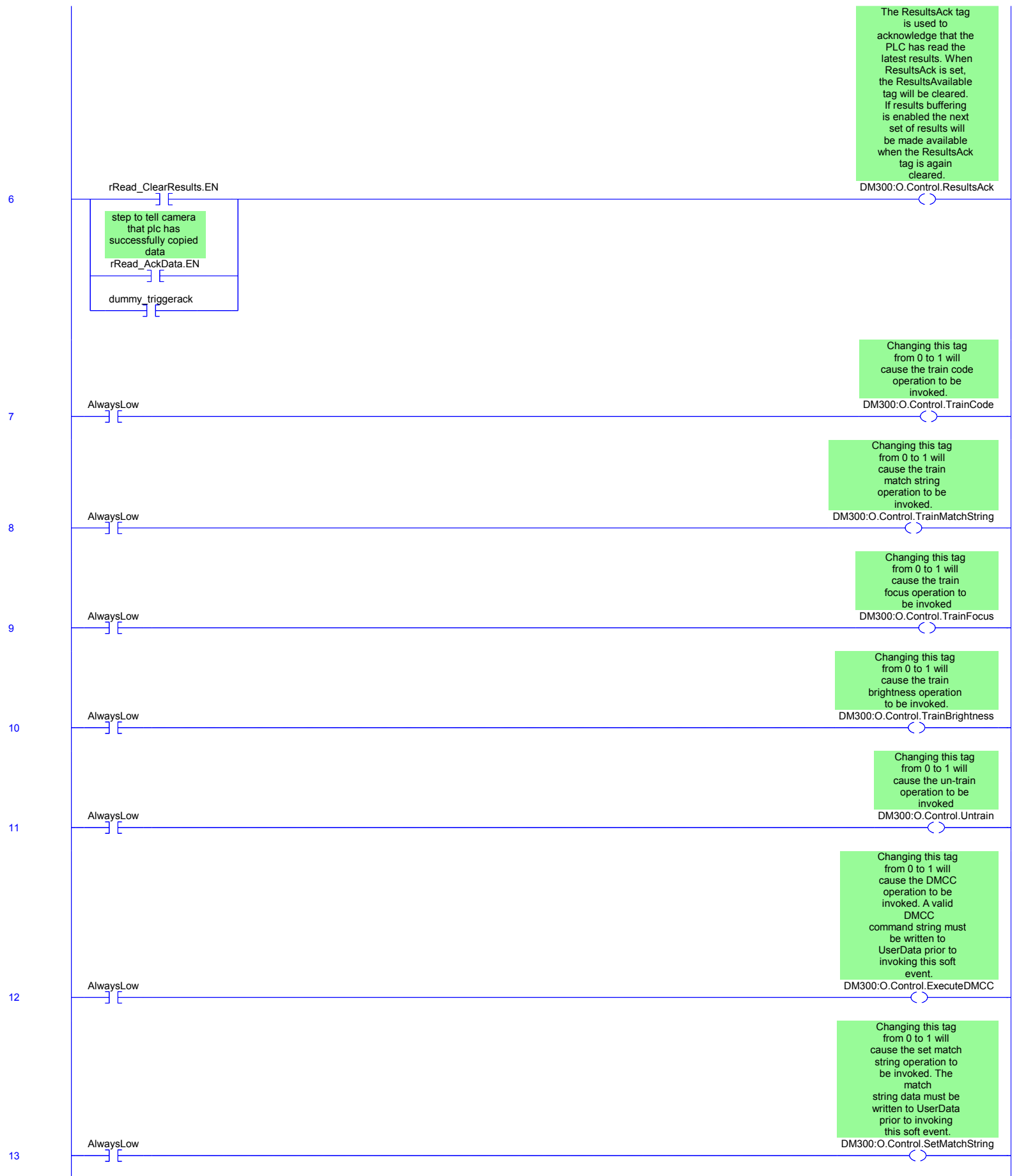


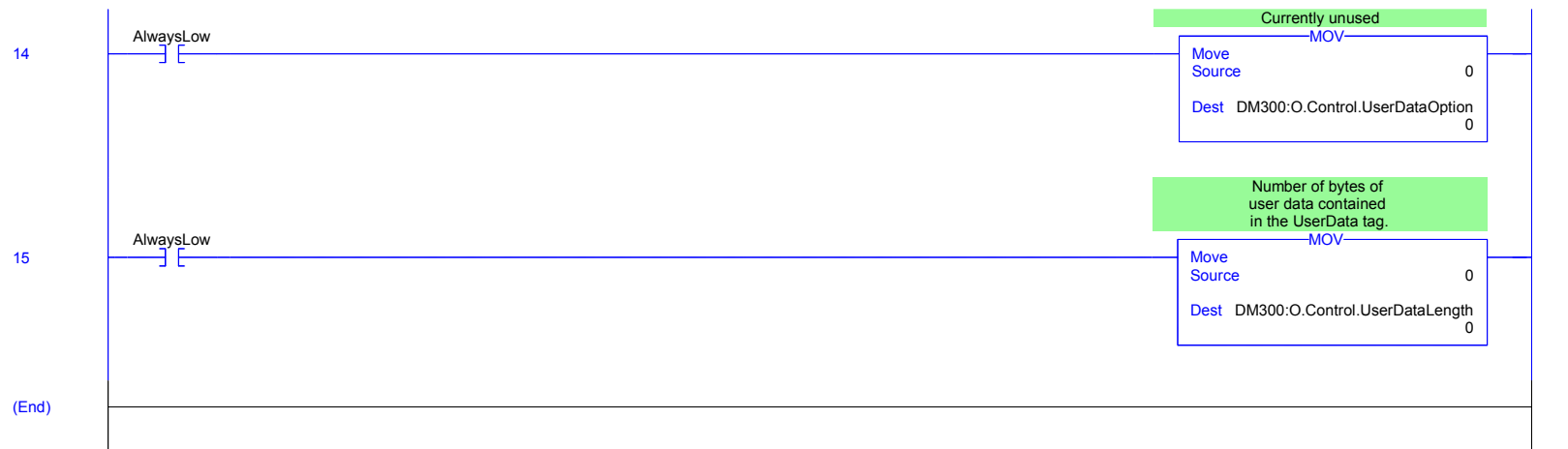


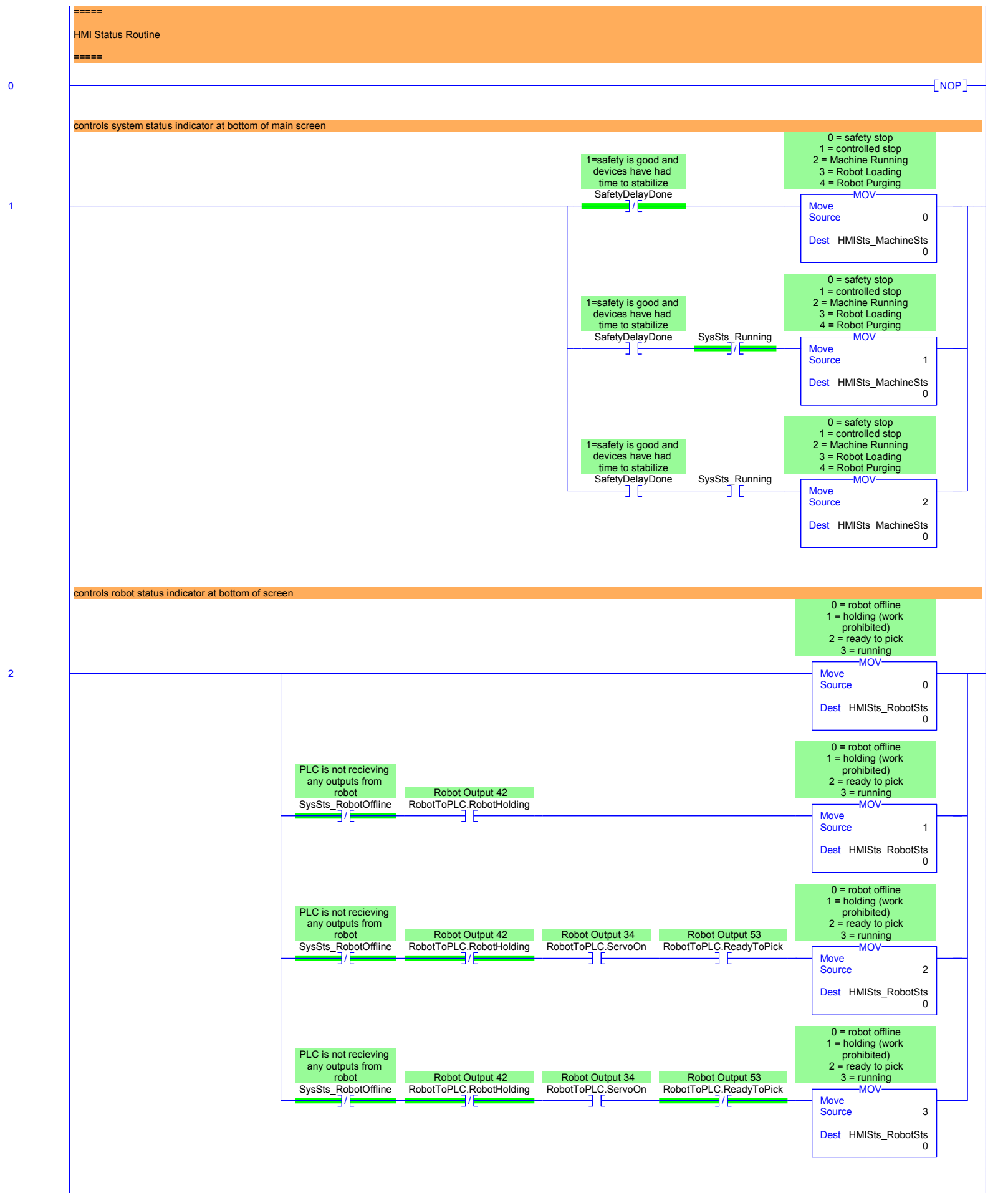


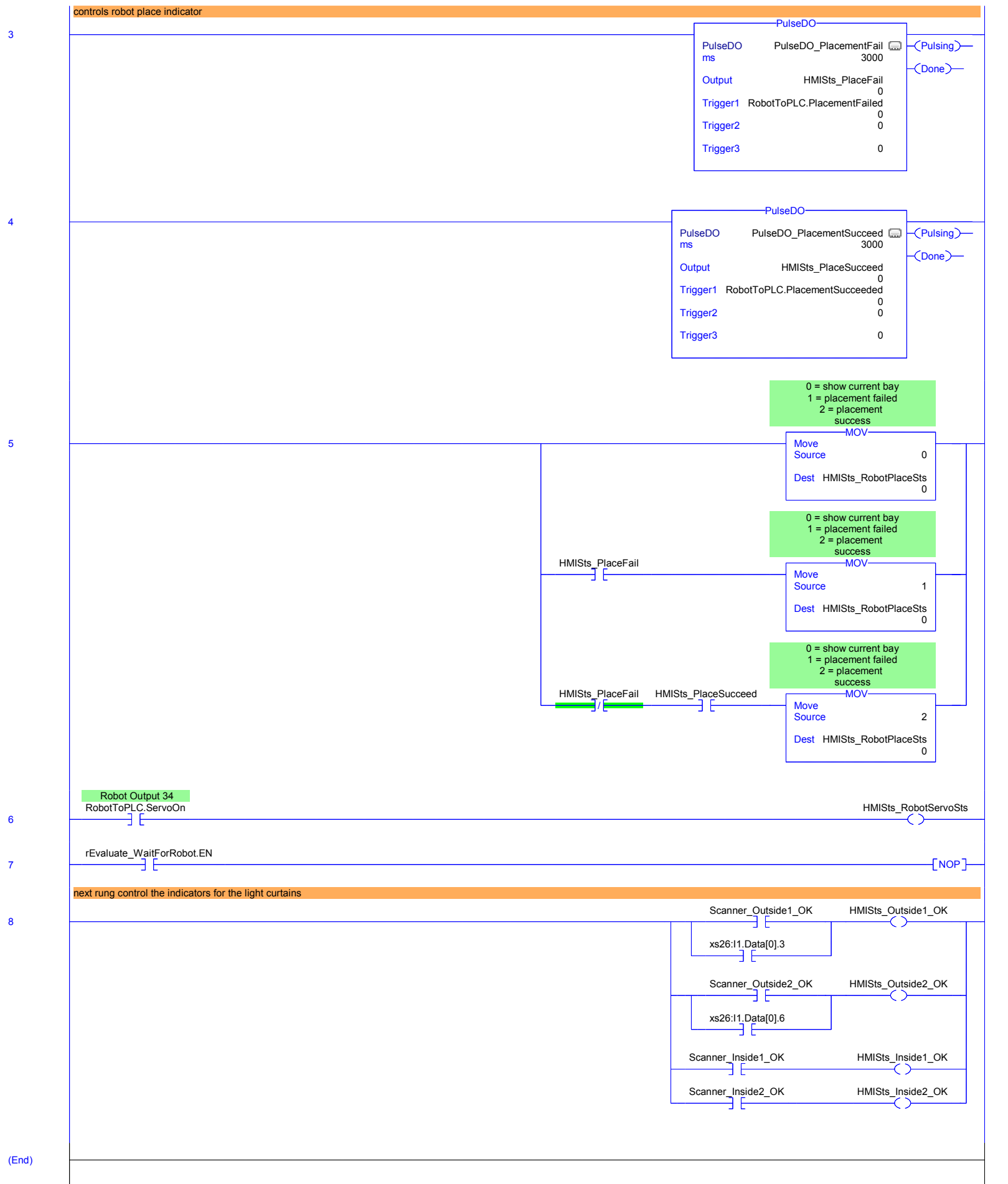


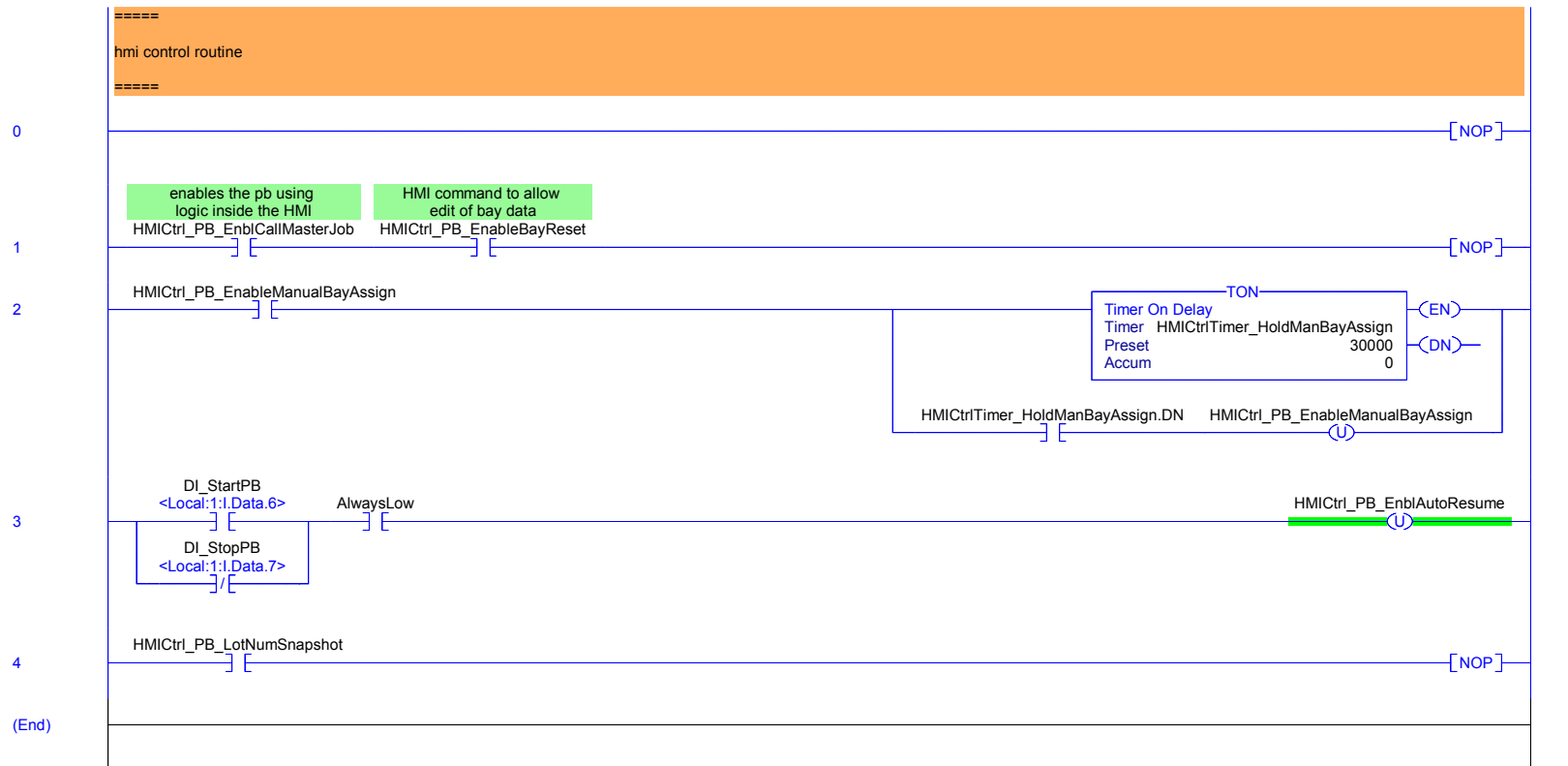


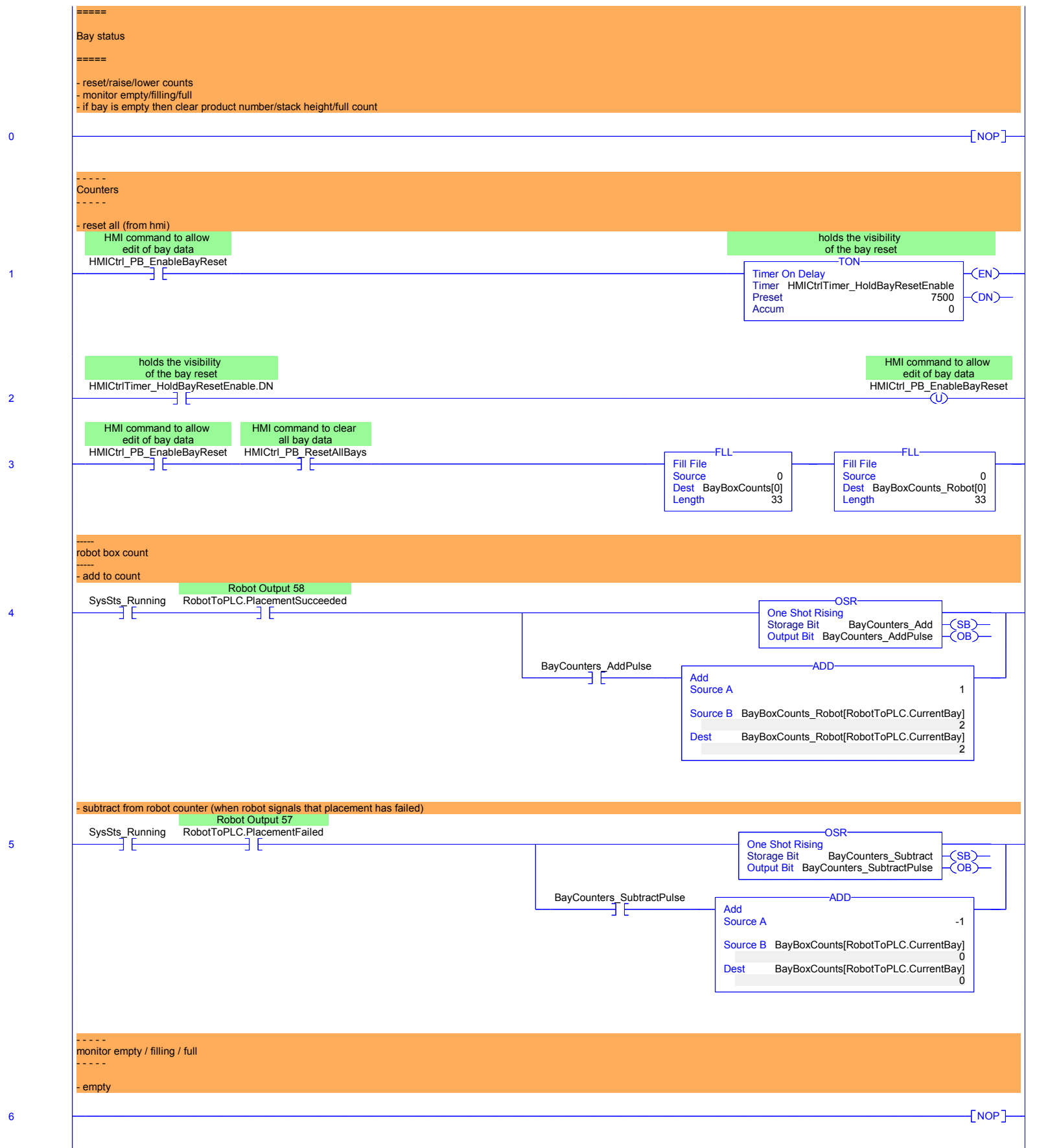


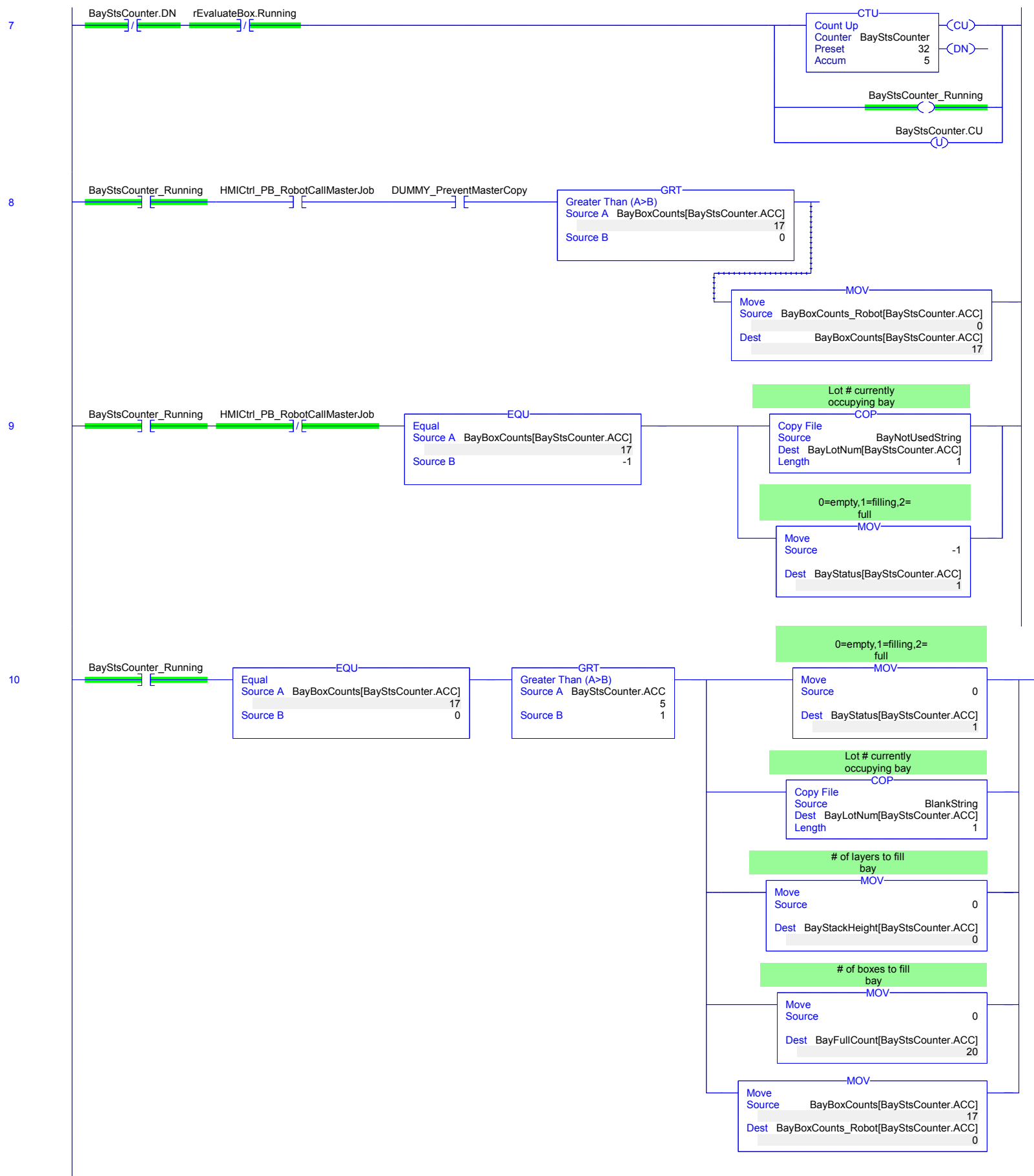






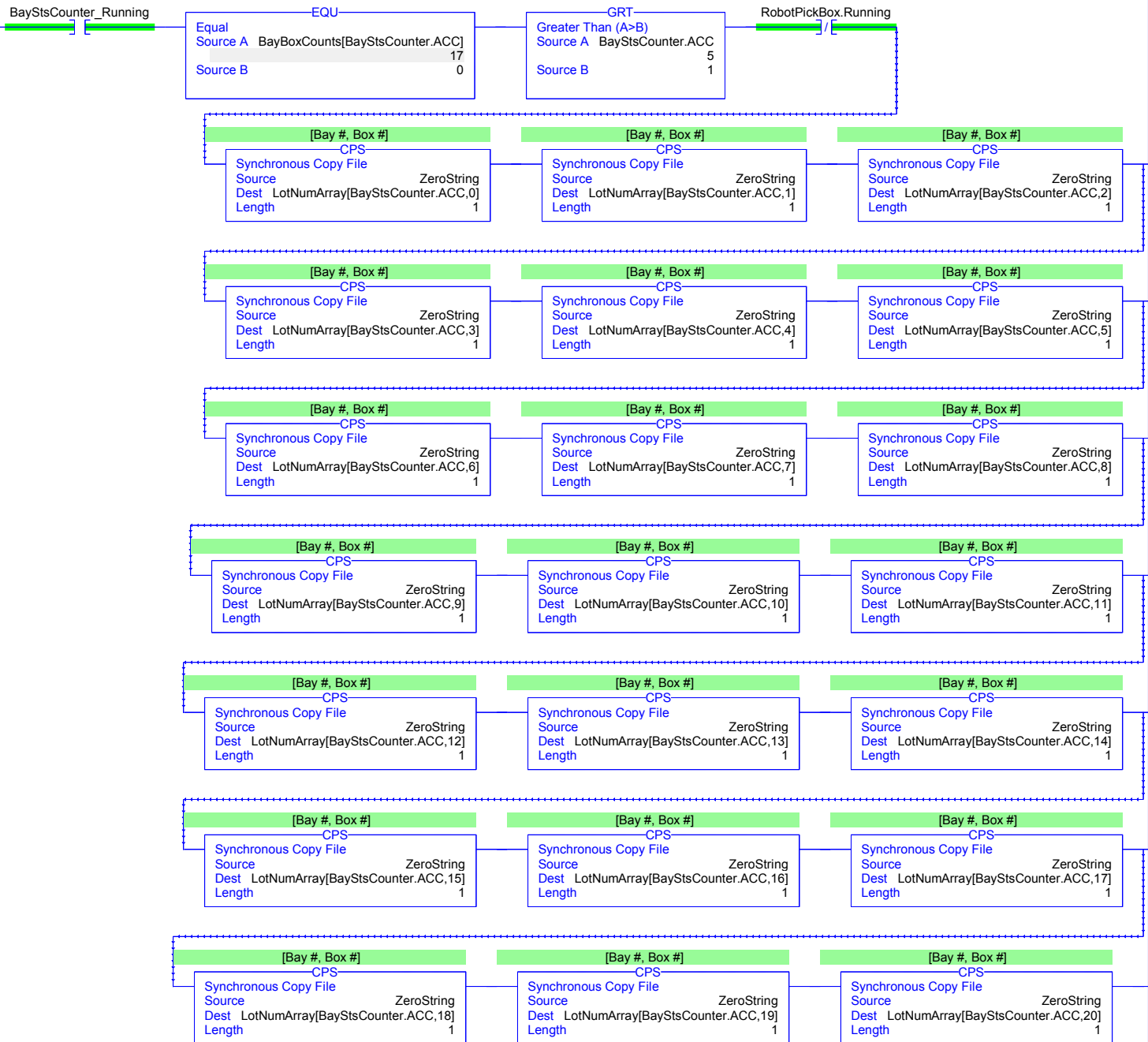


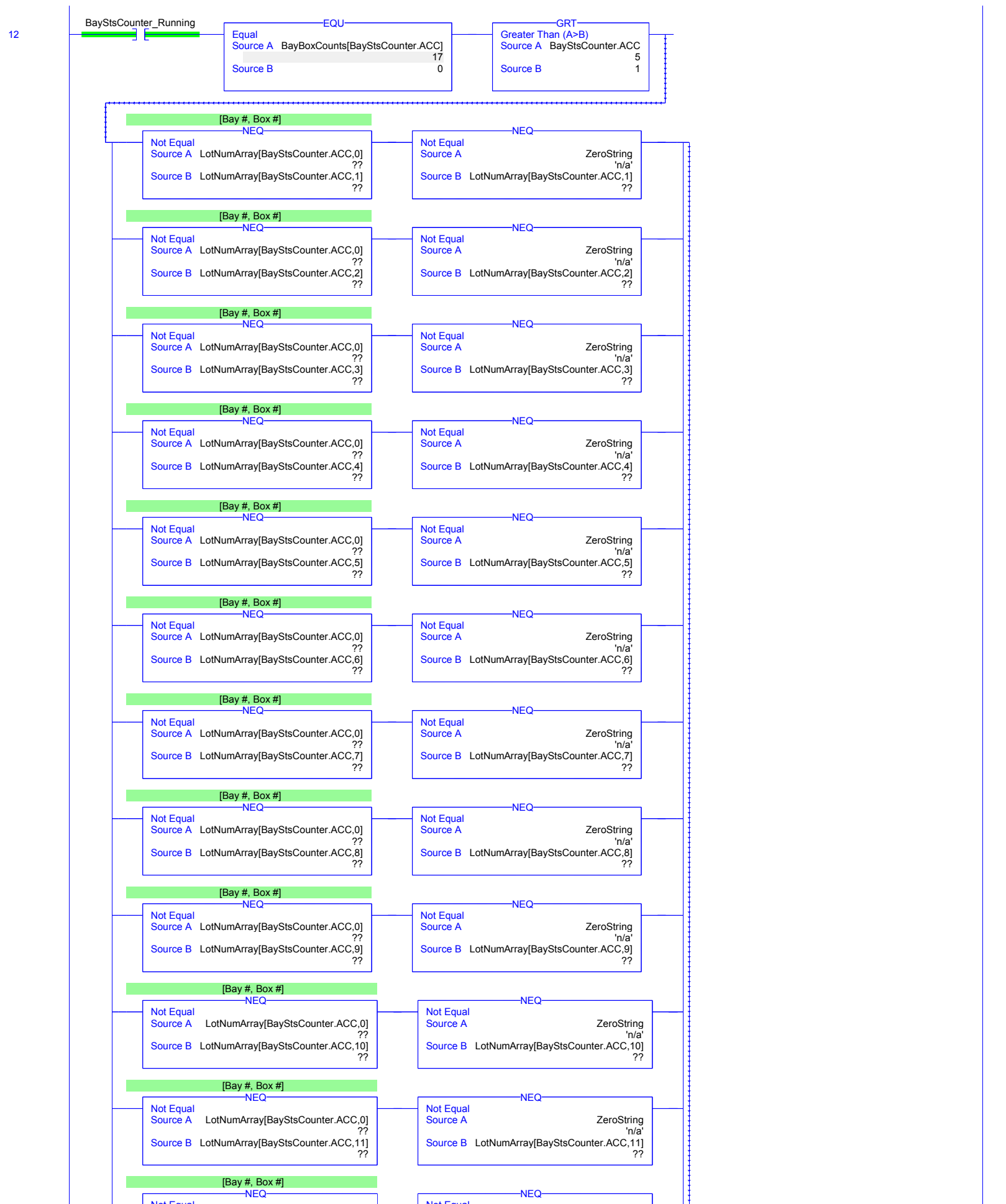


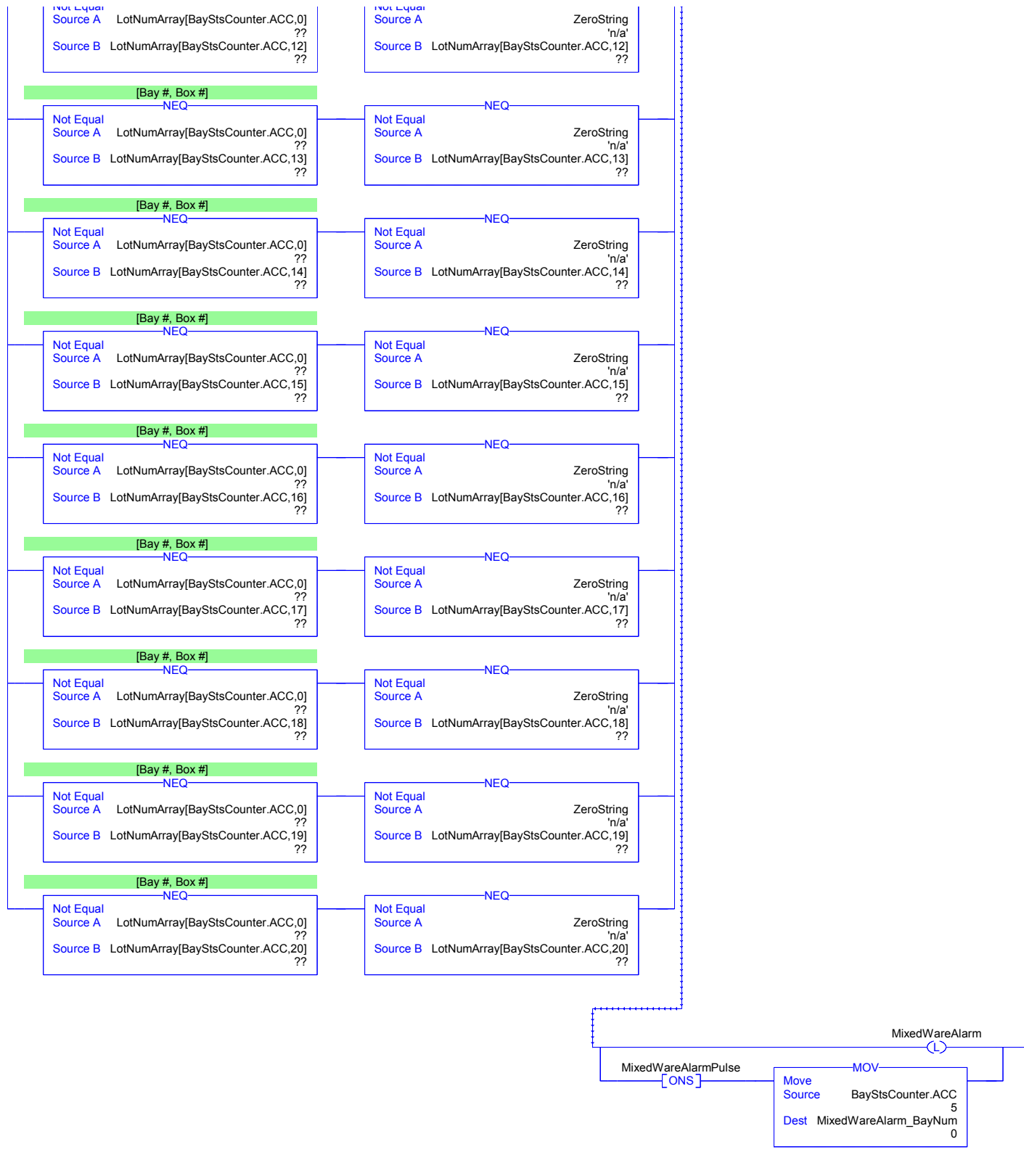


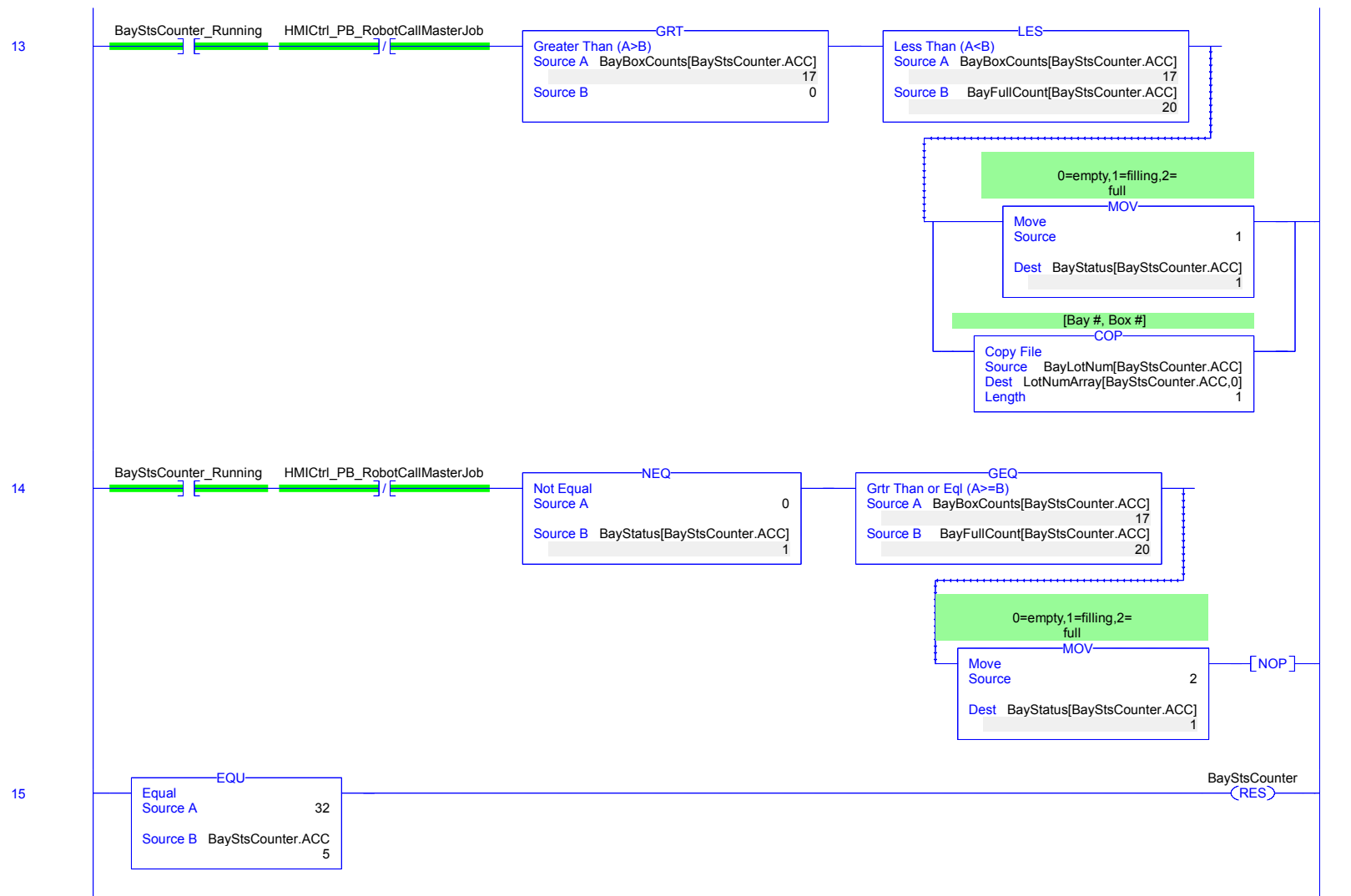
20180605 - jlb - added line to copy blank strings into BayLotNumArray for all cleared bays

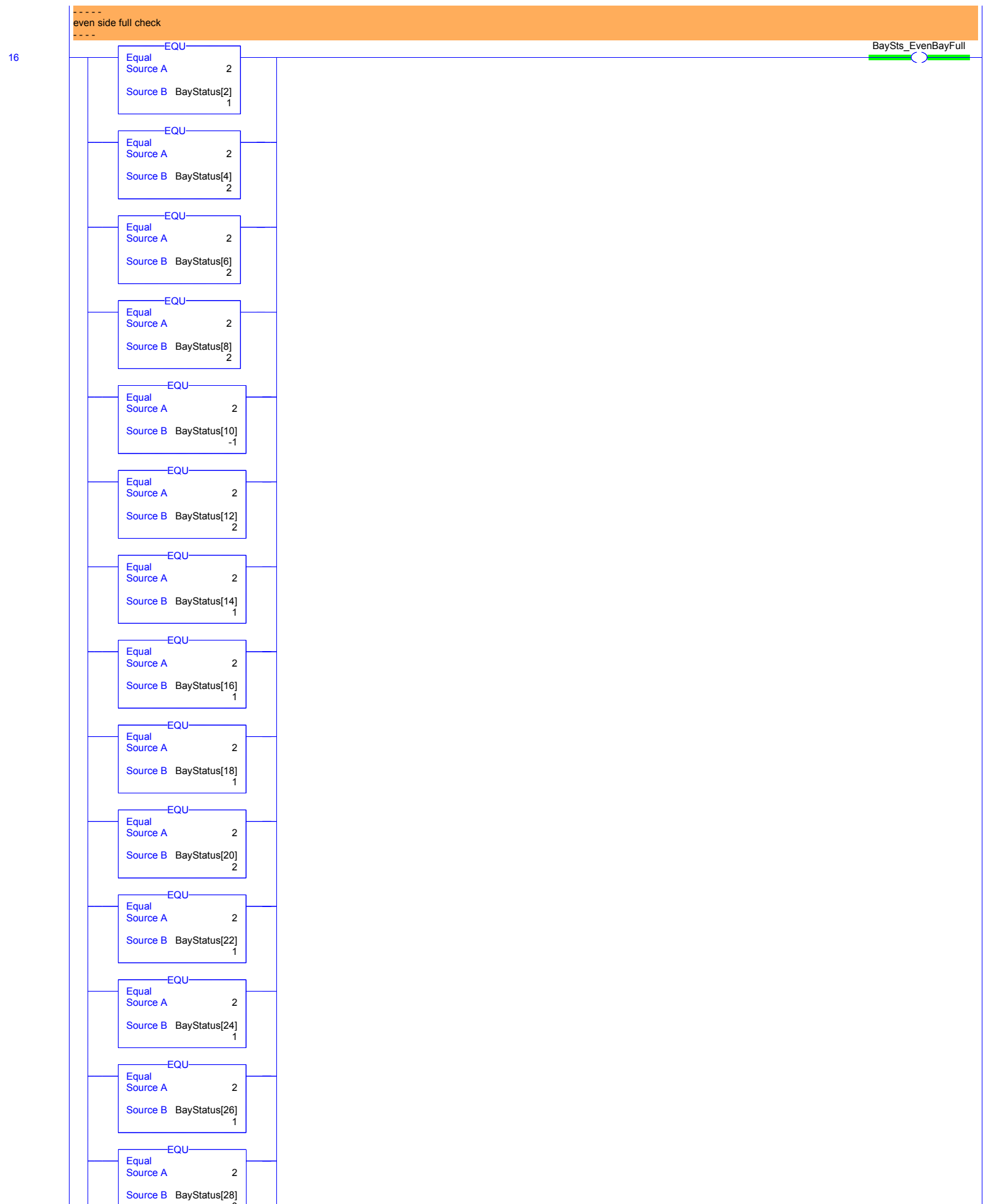
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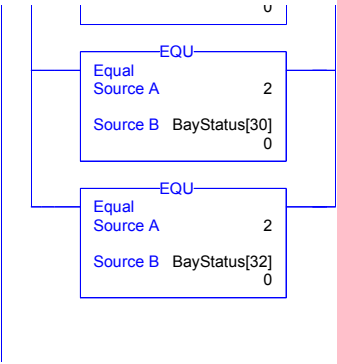




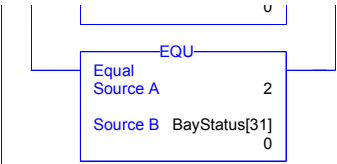




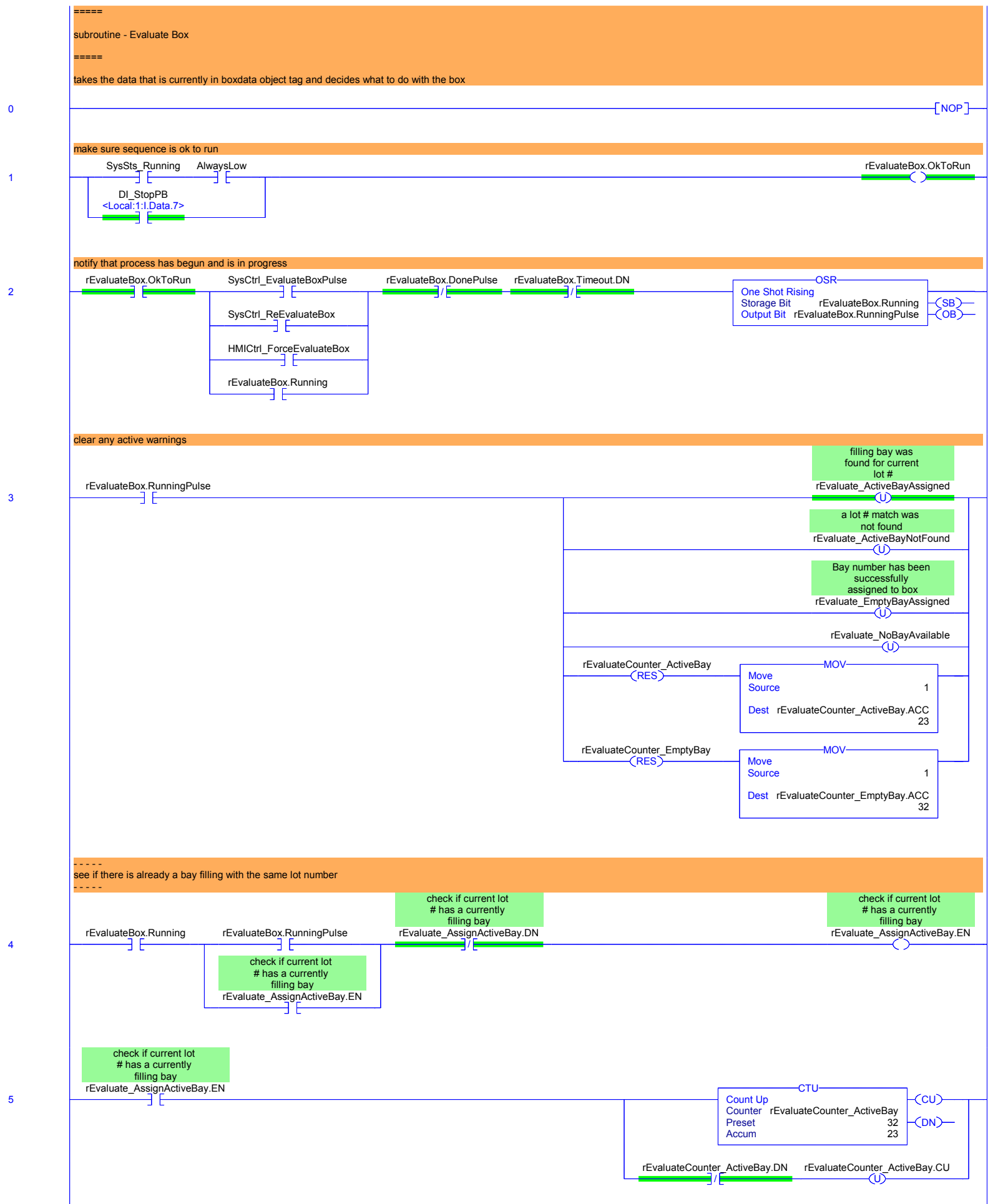


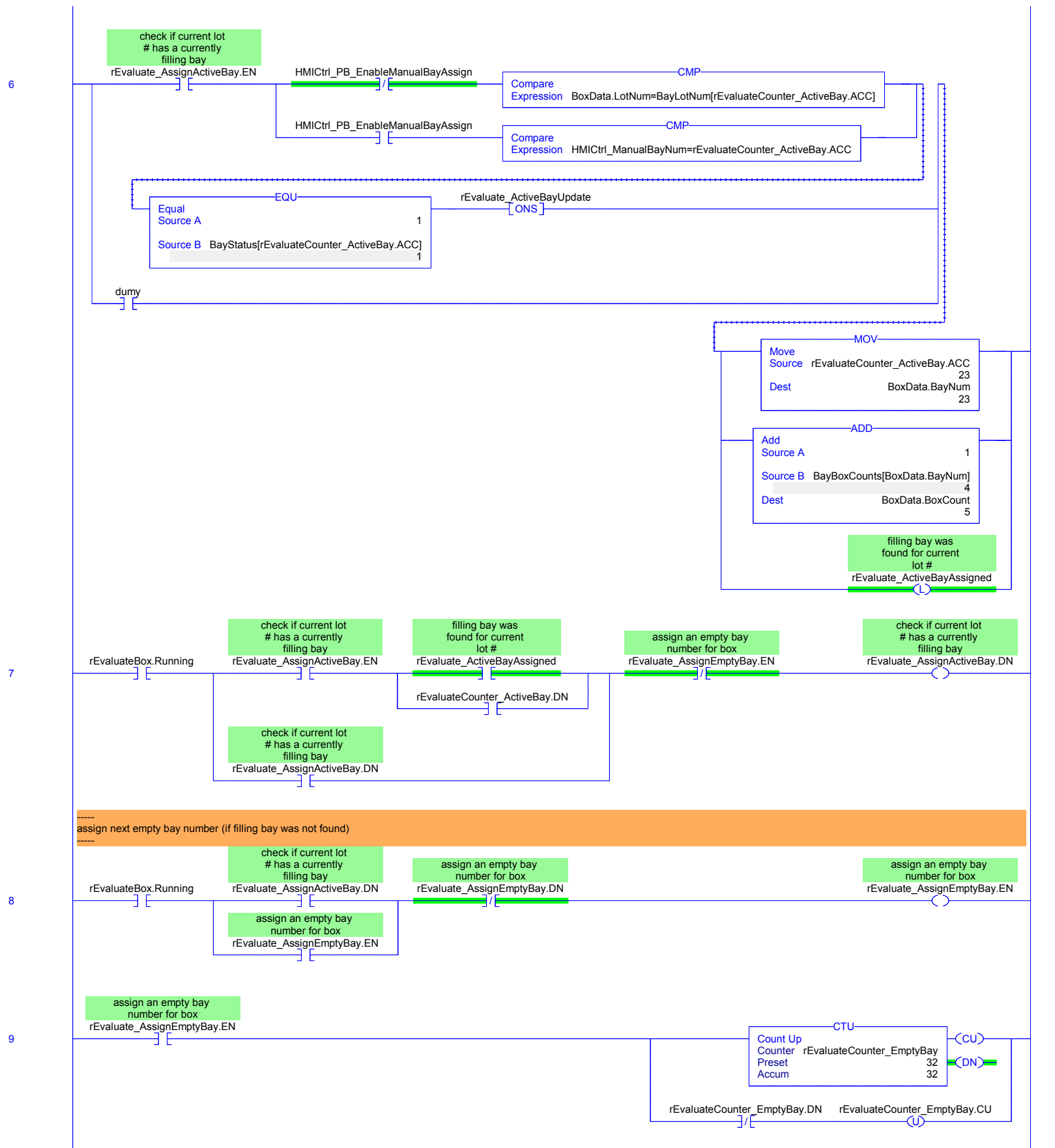


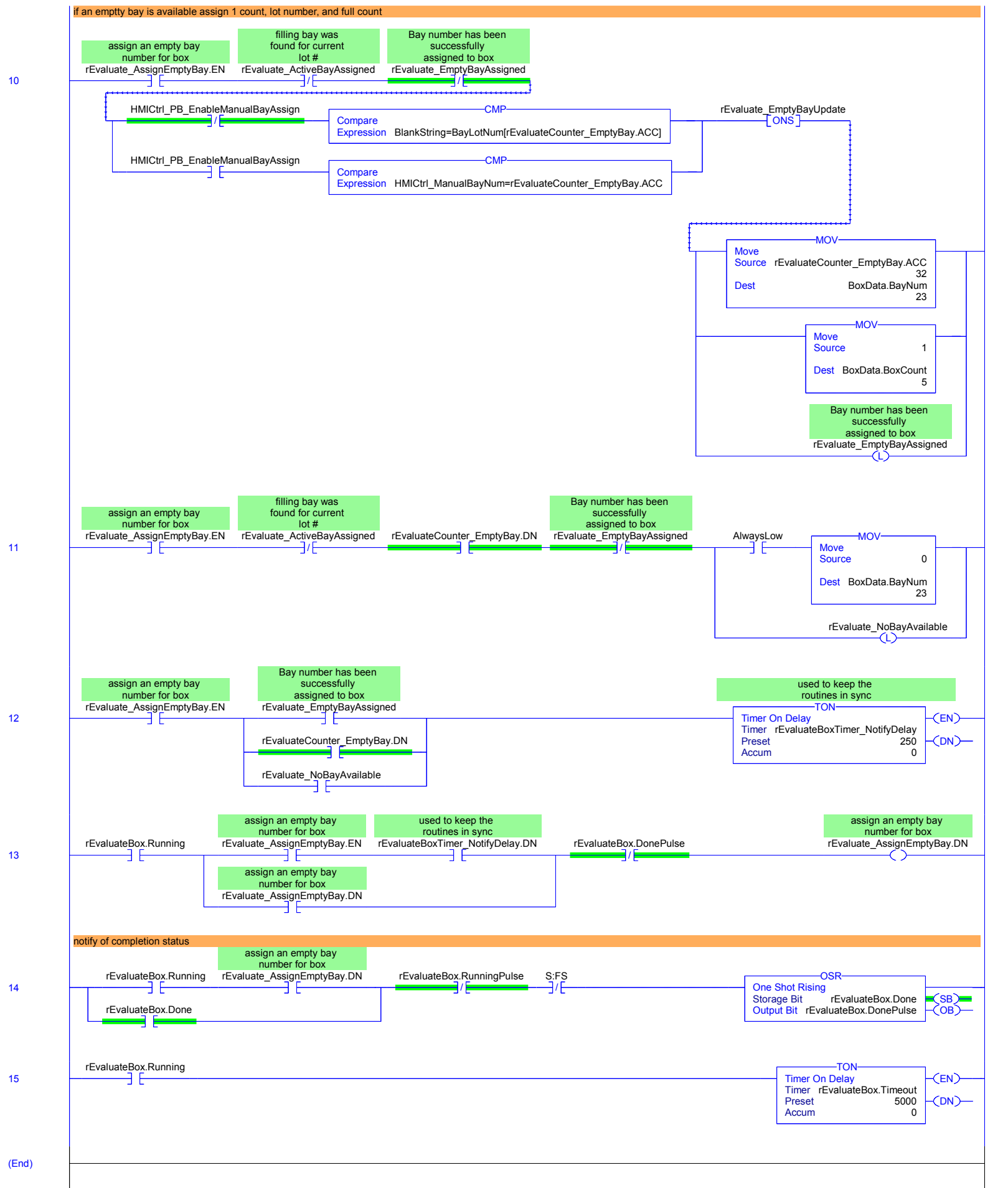


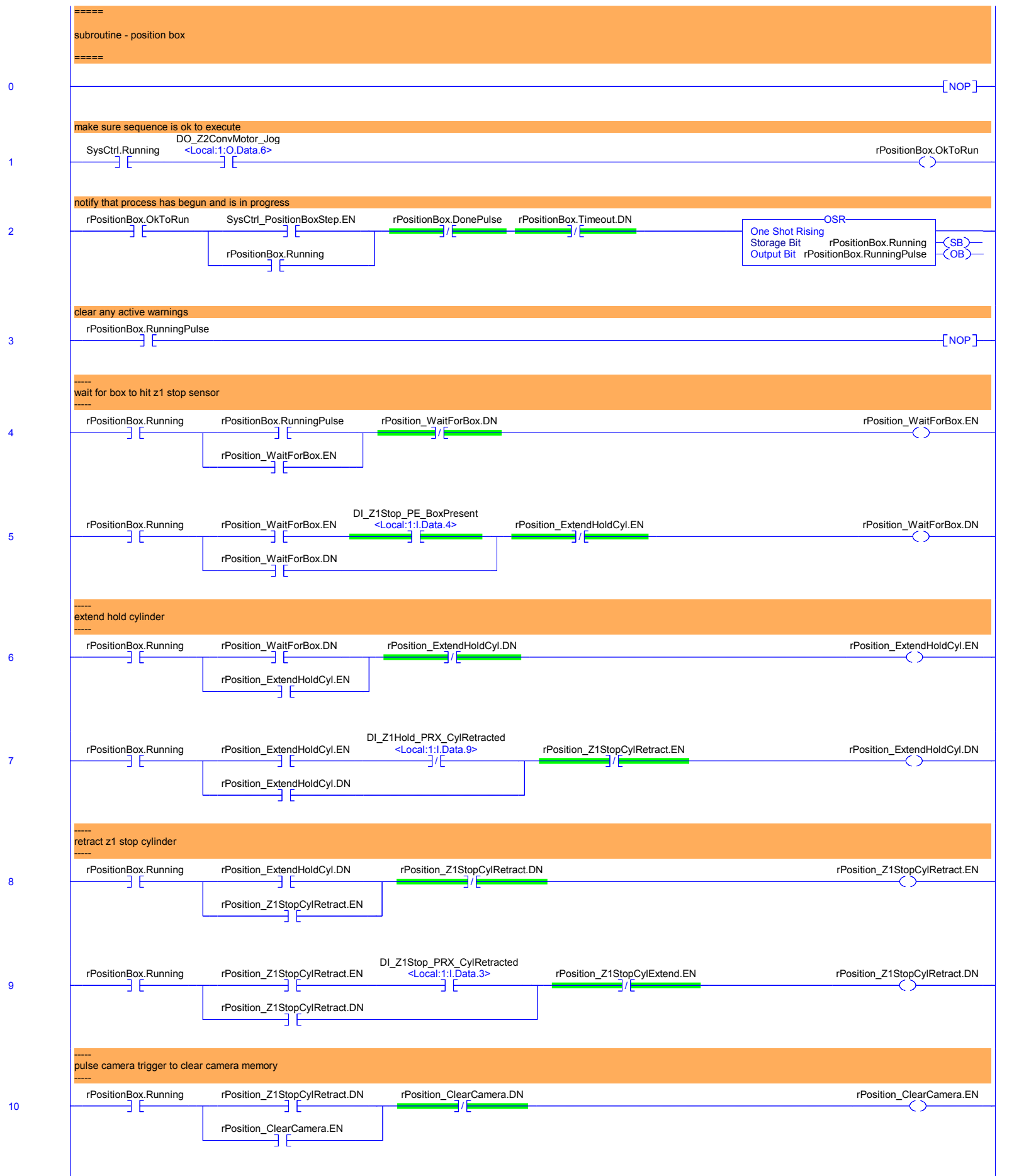


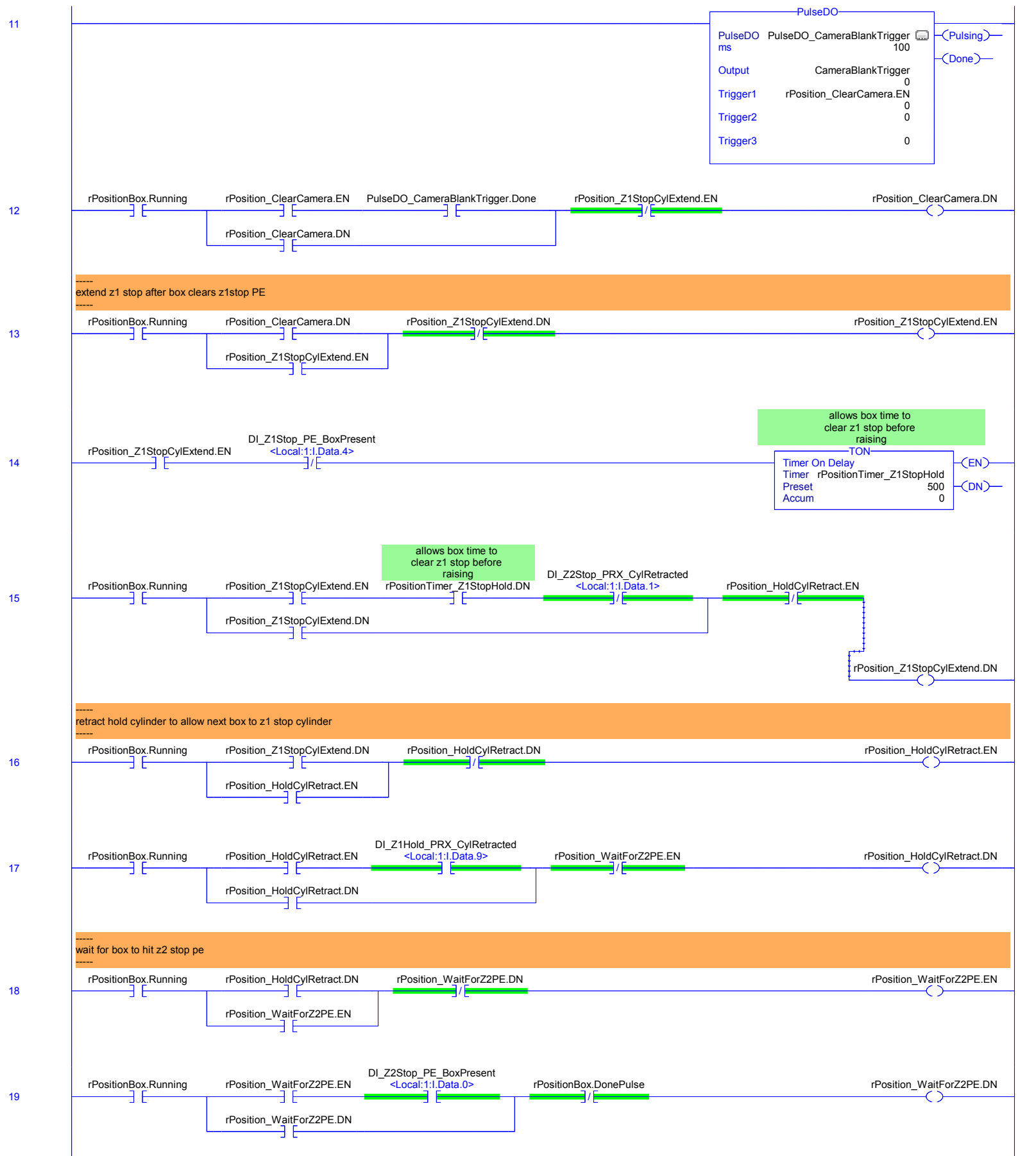
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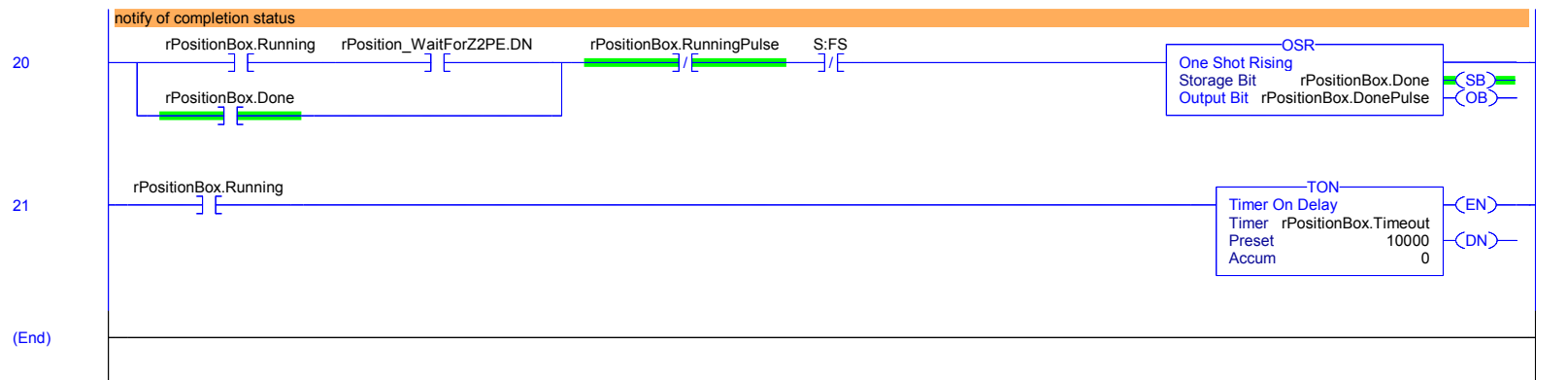


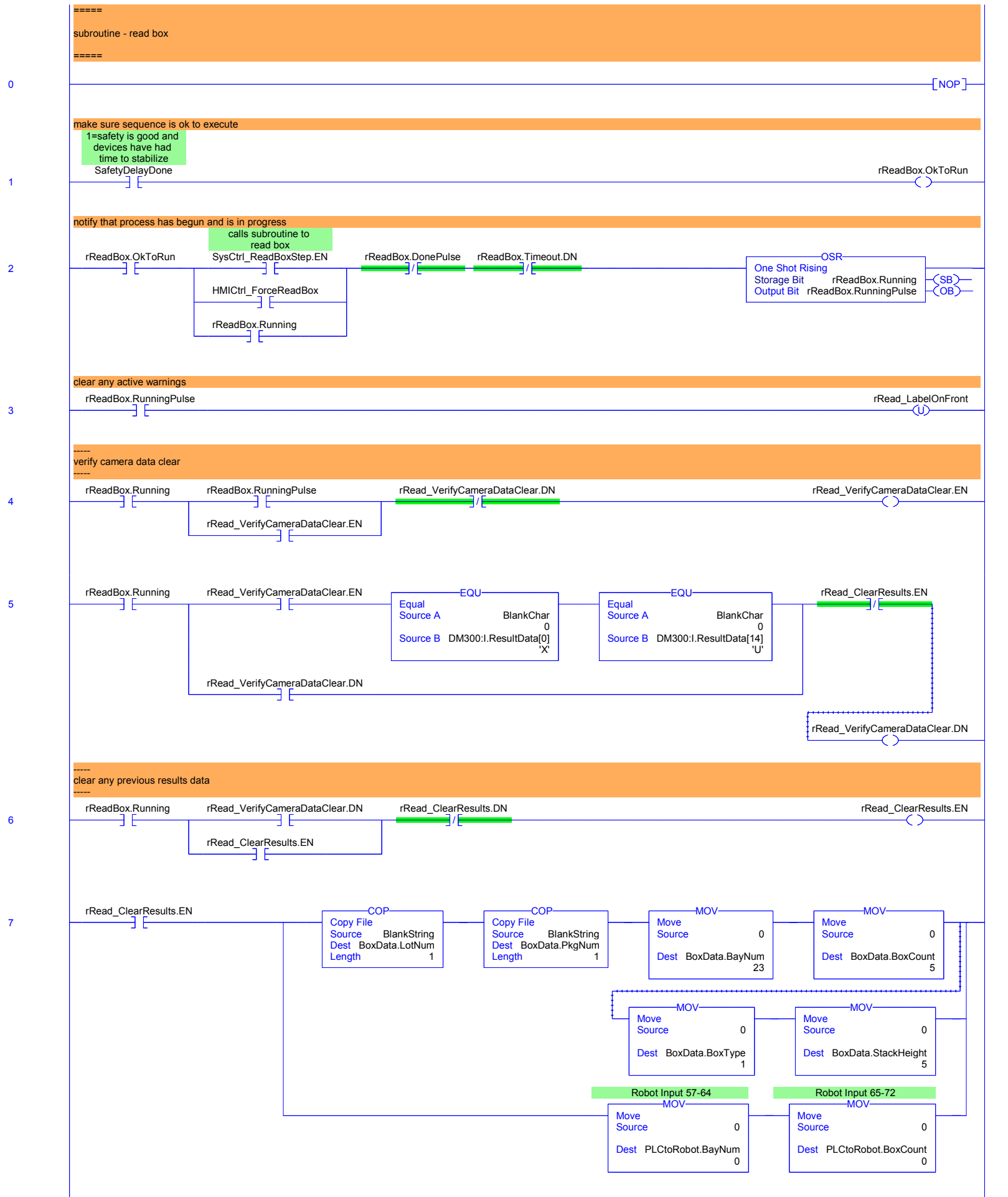


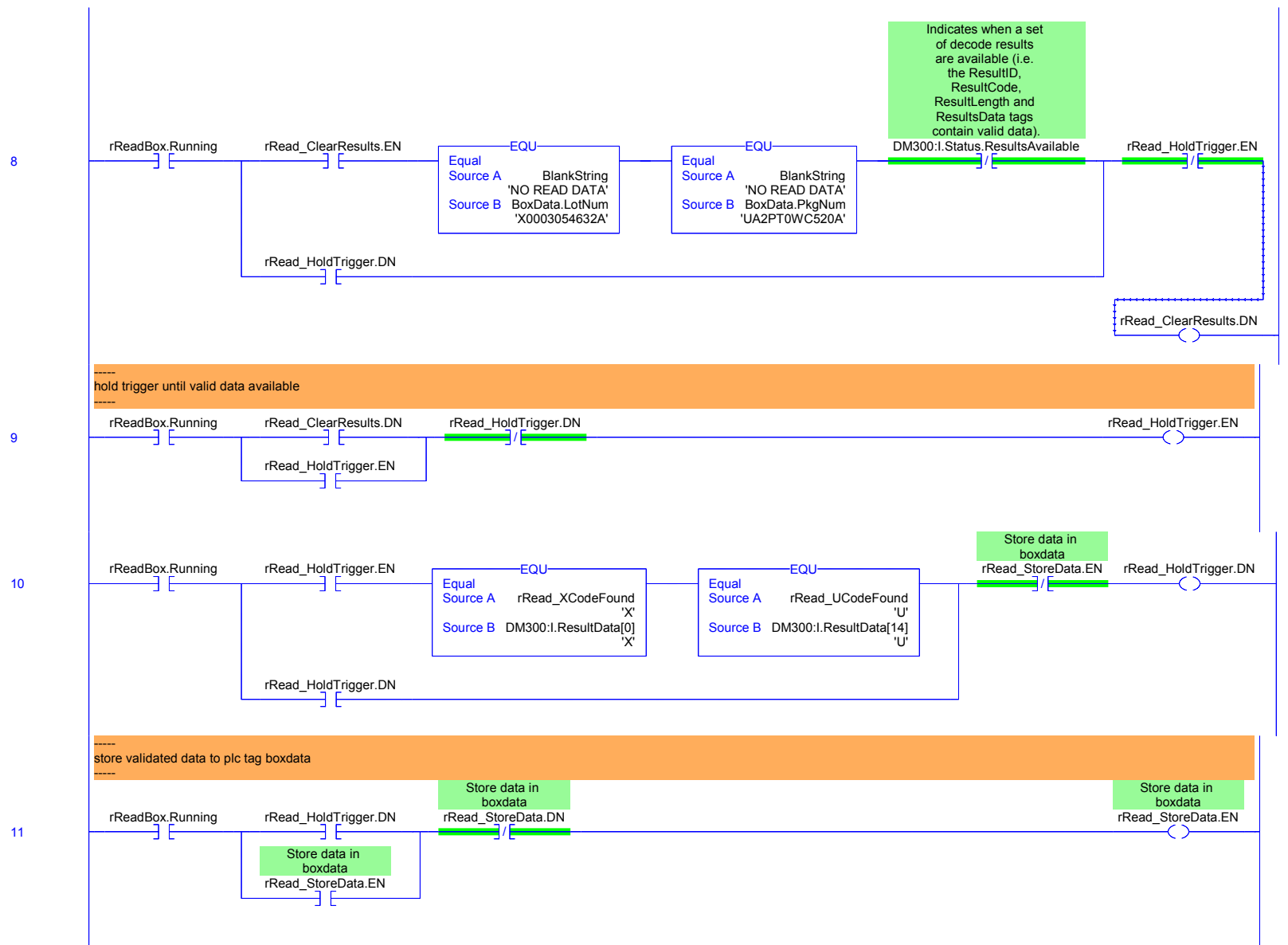












20180605 - jlb - added logic that prevents boxdata.stackheight from exceeding 5 (to keep stacks to max of 20)

Store data in
boxdata
rRead_StoreData.EN

COP

Copy File

Source DM300:I.ResultData[0]

Dest BoxData.LotNum.DATA[0]

Length 12

COP

Copy File

Source DM300:I.ResultData[14]

Dest BoxData.PkgNum.DATA[0]

Length 11

EQU

Equal

Source A DM300:I.ResultData[15]

Source B rRead_BoxType1

65

MOV

Move

Source 1

Dest BoxData.BoxType

1

EQU

Equal

Source A DM300:I.ResultData[15]

Source B rRead_BoxType2

'A'

'M'

MOV

Move

Source 0

Dest BoxData.BoxType

1

EQU

Equal

Source A DM300:I.ResultData[22]

Source B rRead_StackHeight0

'5'

48

MOV

Move

Source 0

Dest BoxData.StackHeight

5

EQU

Equal

Source A DM300:I.ResultData[22]

Source B rRead_StackHeight1

'5'

49

MOV

Move

Source 4

Dest BoxData.StackHeight

5

EQU

Equal

Source A DM300:I.ResultData[22]

Source B rRead_StackHeight2

'5'

50

MOV

Move

Source 4

Dest BoxData.StackHeight

5

EQU

Equal

Source A DM300:I.ResultData[22]

Source B rRead_StackHeight3

'5'

51

MOV

Move

Source 4

Dest BoxData.StackHeight

5

EQU

Equal

Source A DM300:I.ResultData[22]

Source B rRead_StackHeight4

'5'

'4'

MOV

Move

Source 4

Dest BoxData.StackHeight

5

EQU

Equal

Source A DM300:I.ResultData[22]

Source B rRead_StackHeight5

'5'

'5'

MOV

Move

Source 5

Dest BoxData.StackHeight

5

EQU

Equal

Source A DM300:I.ResultData[22]

Source B rRead_StackHeight6

'5'

'6'

MOV

Move

Source 6

Dest BoxData.StackHeight

5

EQU

Equal

Source A DM300:I.ResultData[22]

Source B rRead_StackHeight7

'5'

'7'

MOV

Move

Source 7

Dest BoxData.StackHeight

5

EQU

Equal

Source A DM300:I.ResultData[22]

Source B rRead_StackHeight8

'5'

'8'

MOV

Move

Source 8

Dest BoxData.StackHeight

5

EQU

Equal

Source A DM300:I.ResultData[22]

Source B rRead_StackHeight9

'5'

57

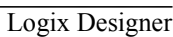
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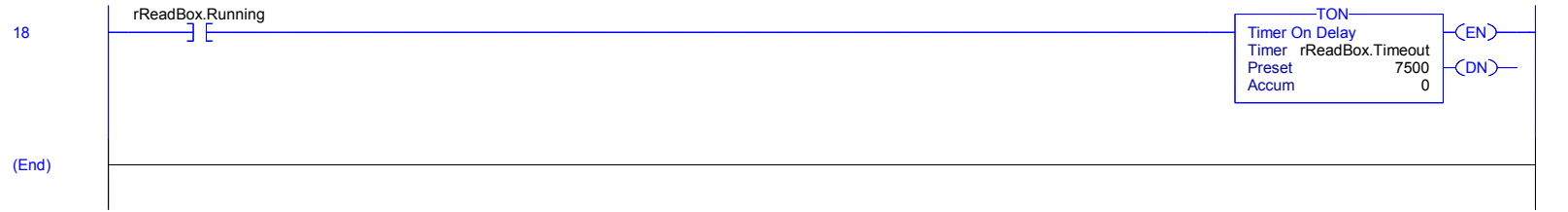
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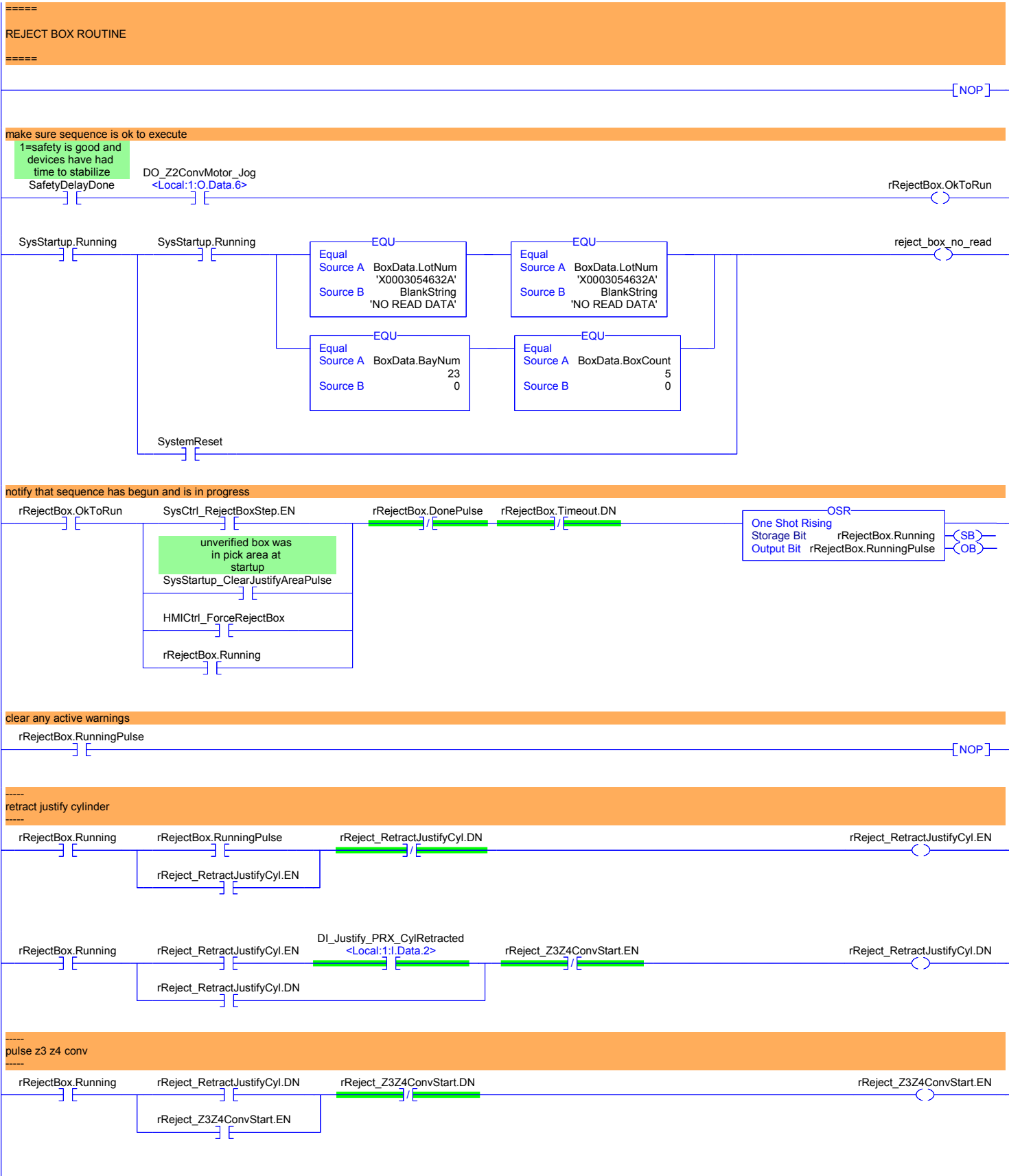
Source 9

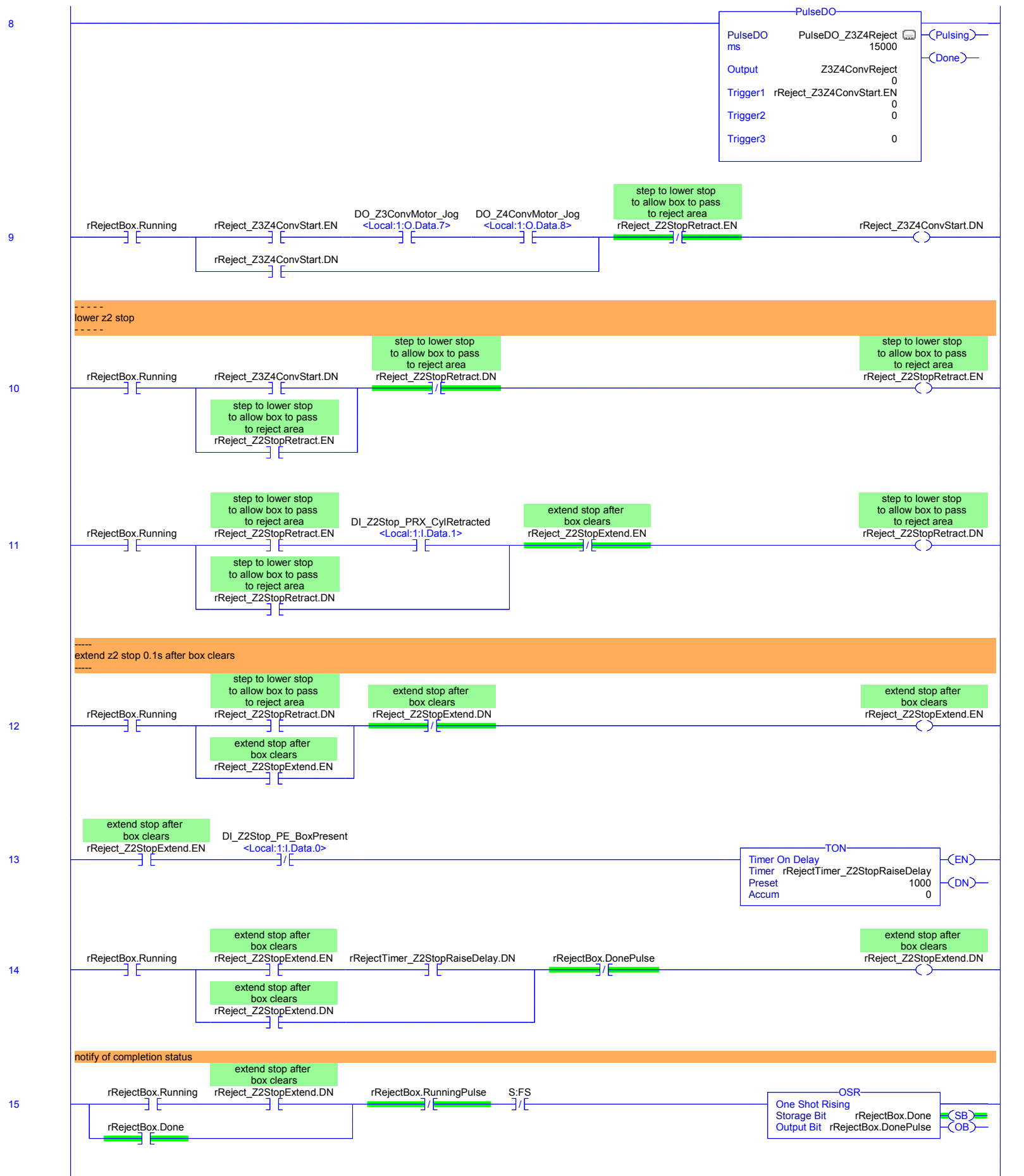
Dest BoxData.StackHeight

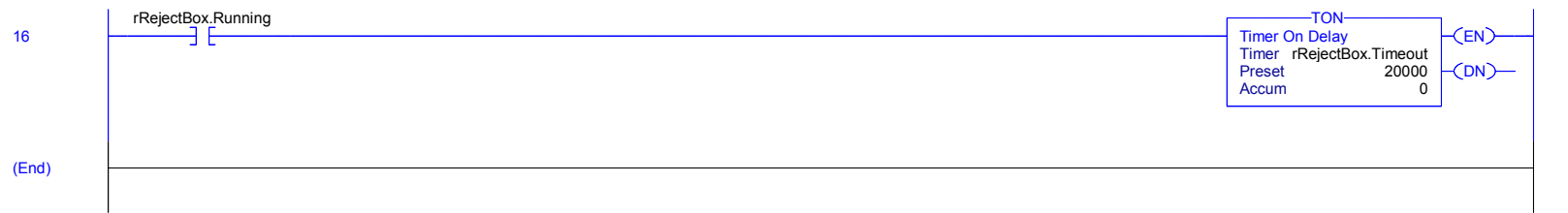
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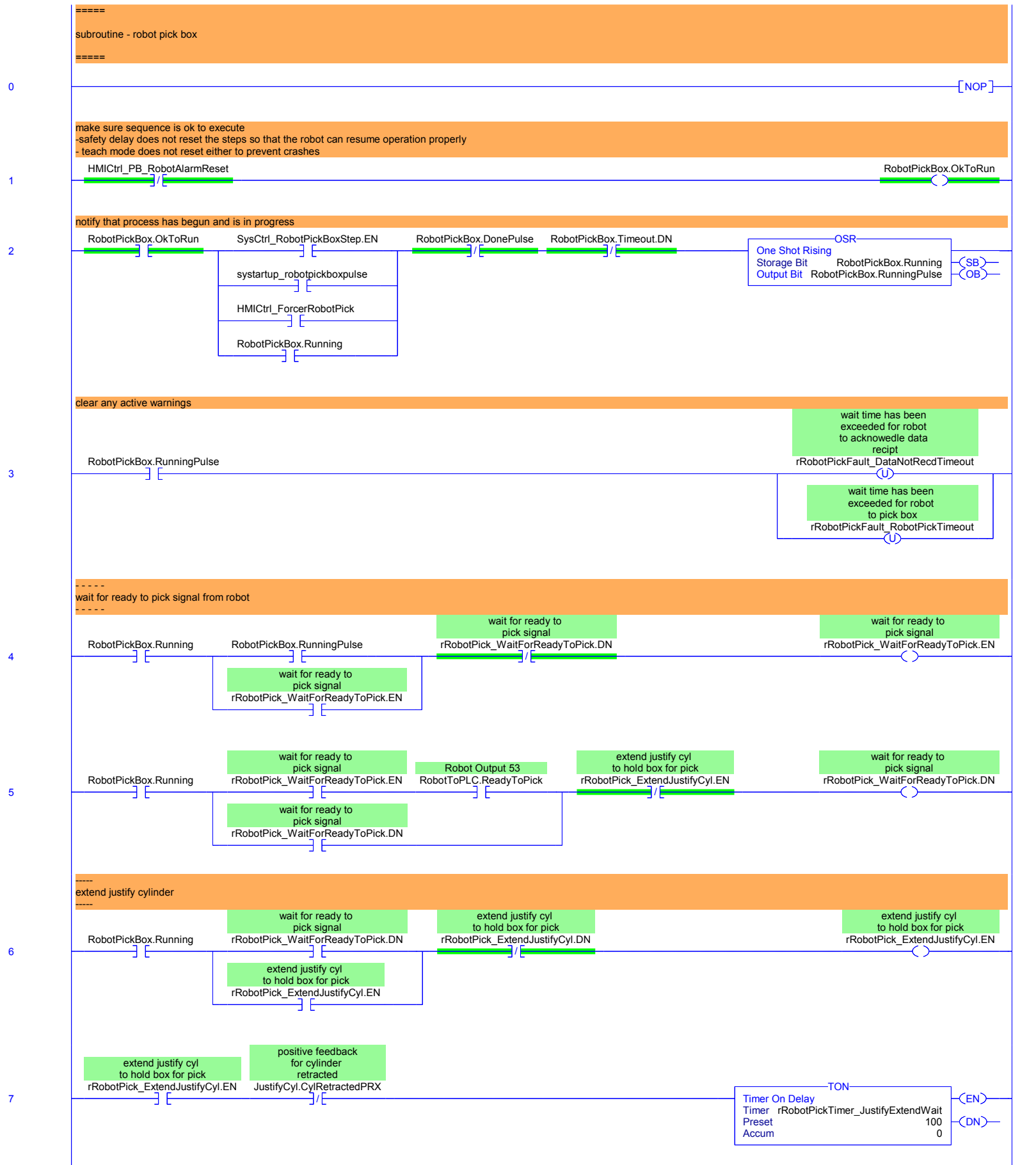


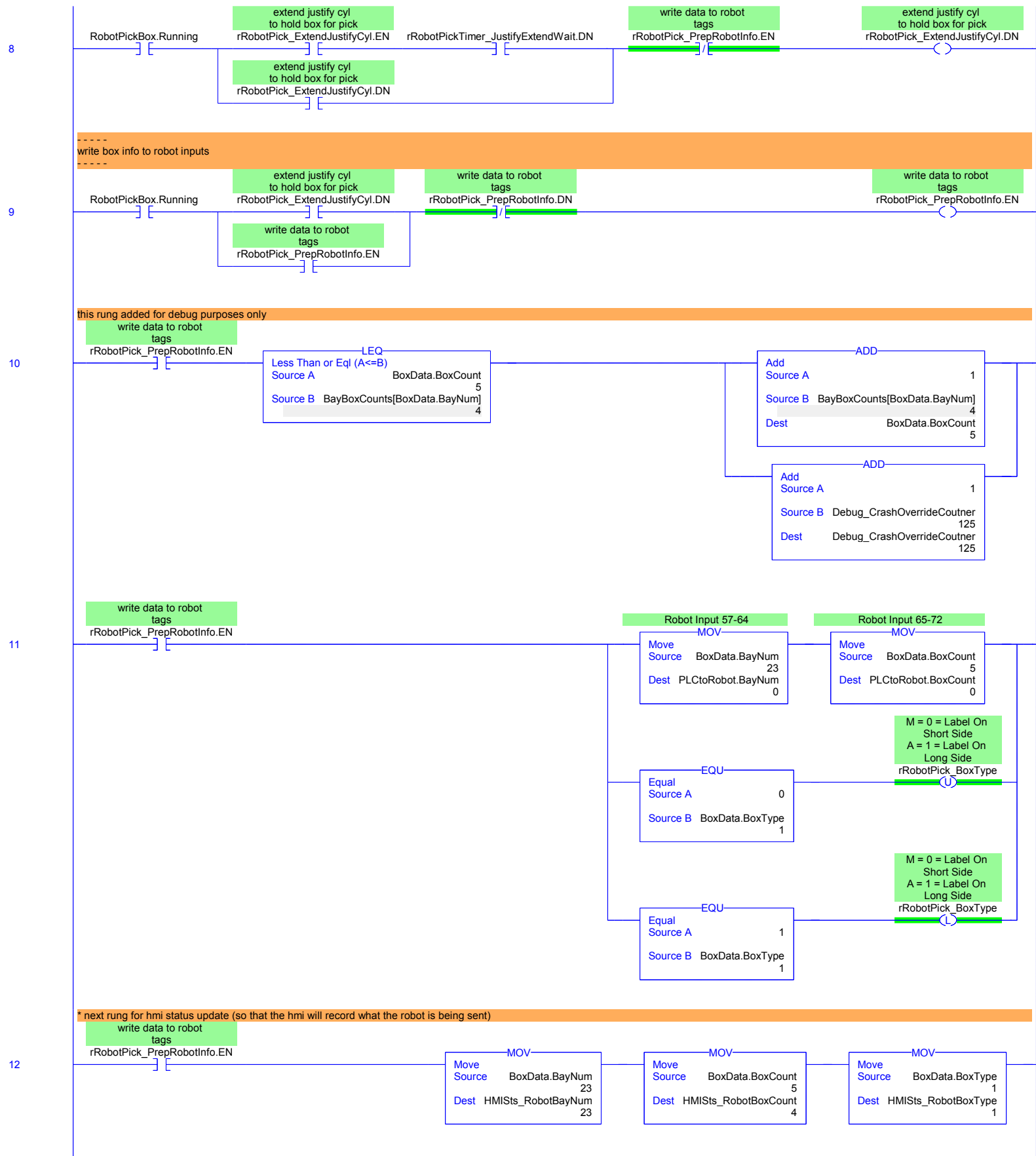


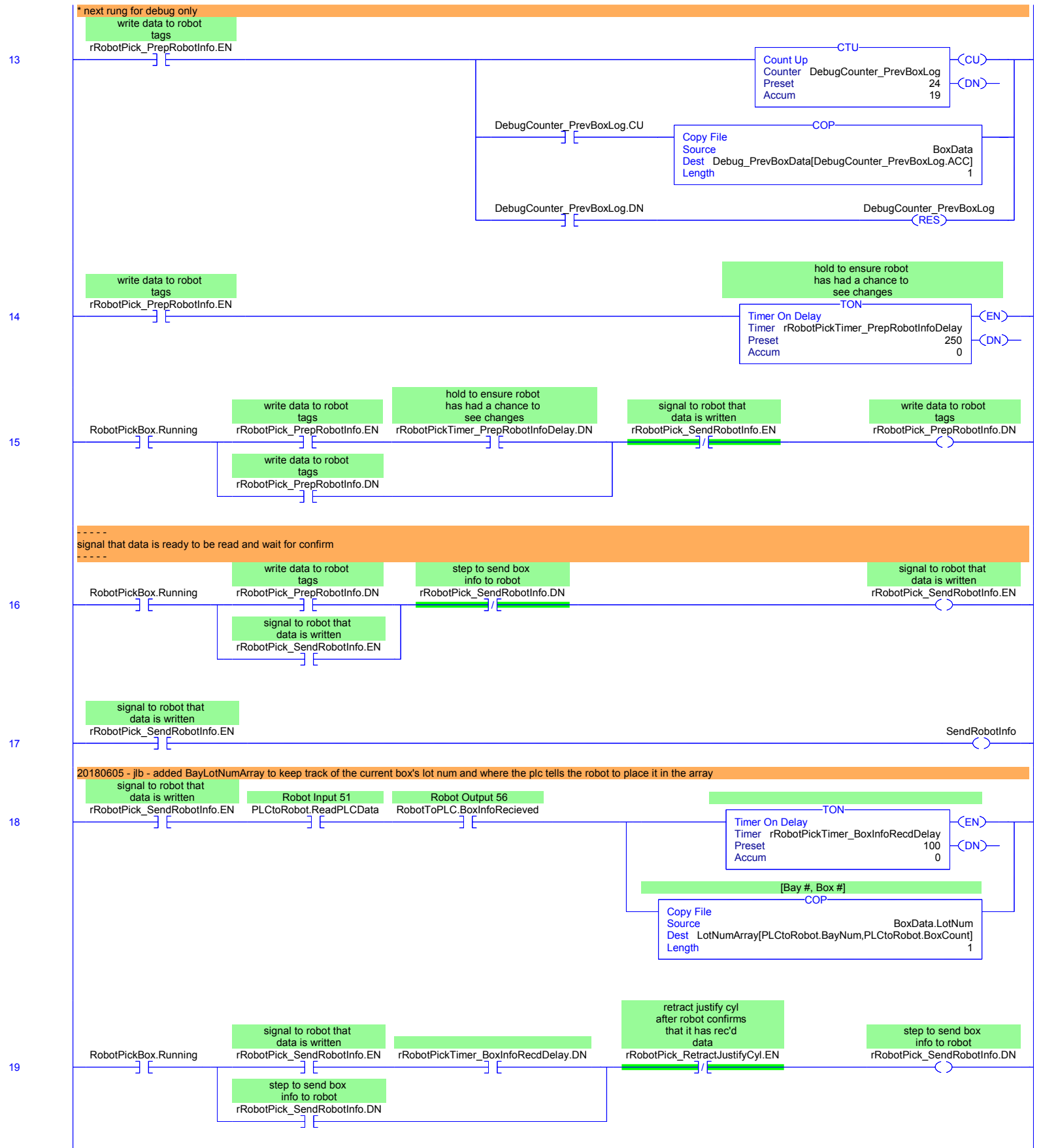


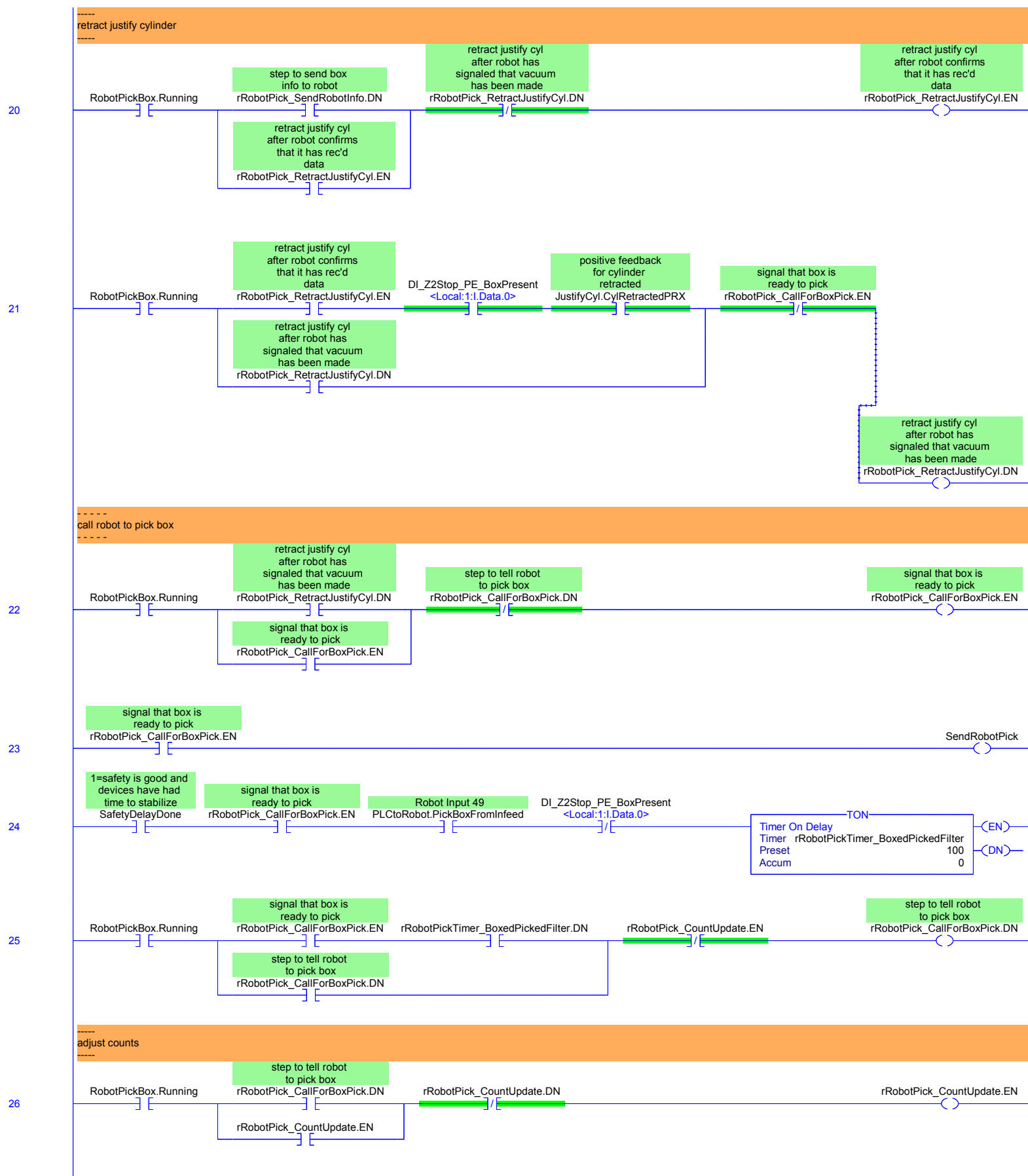


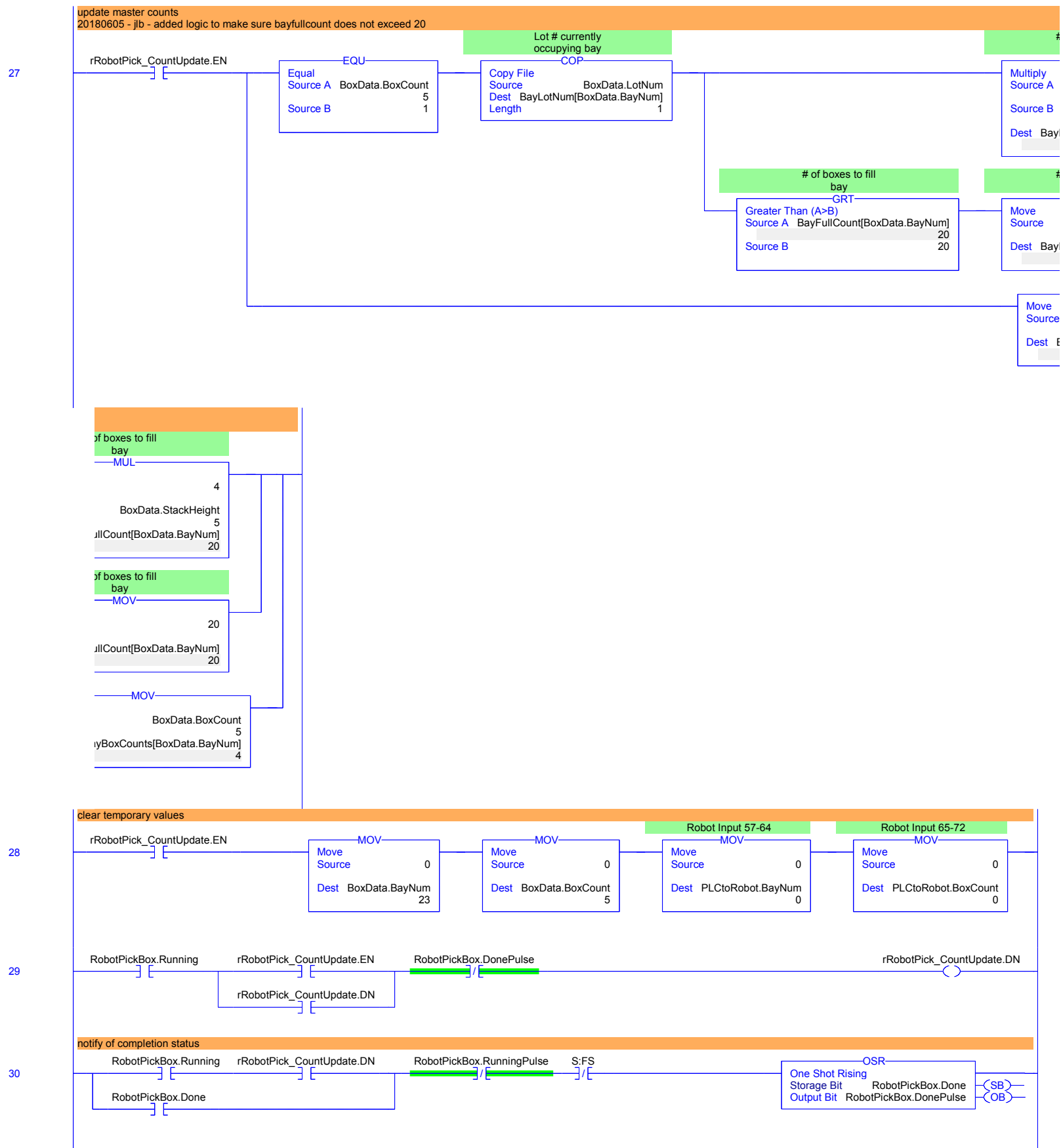


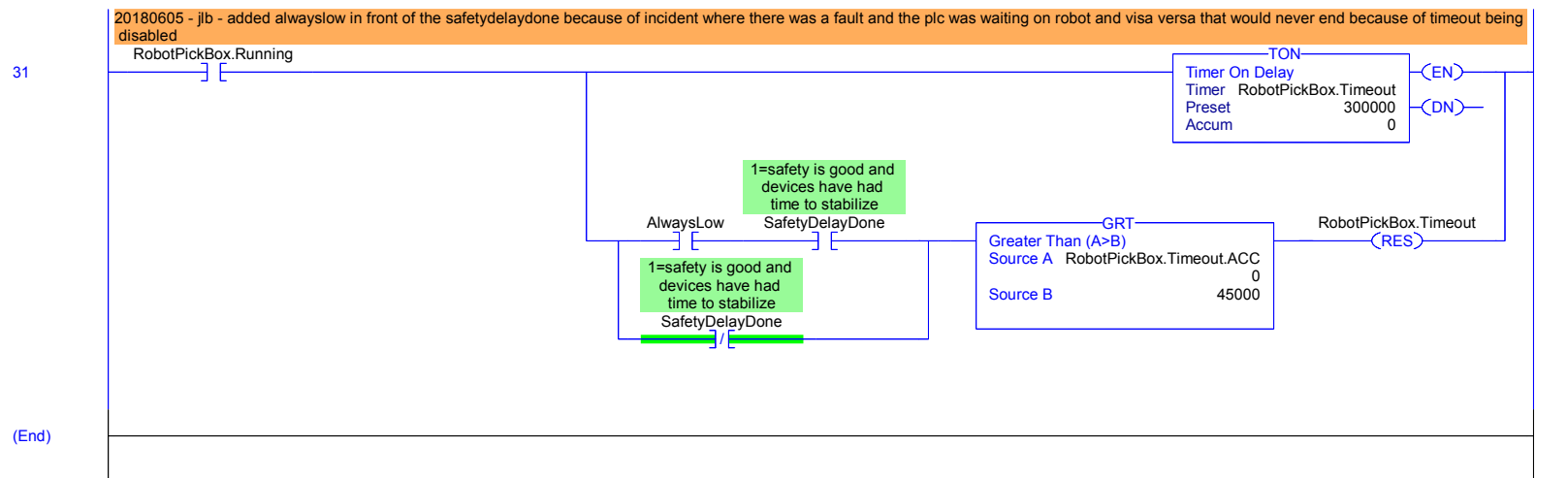




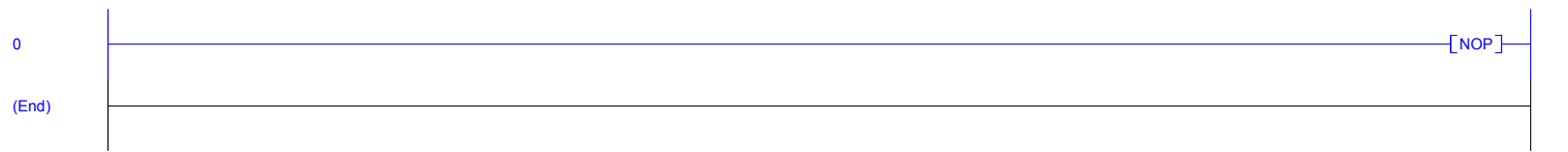












GrahamPgkRob	
Controller Organizer Listing	1
GrahamPkgRob	
MainRoutines	
MainRoutines	
Ladder Diagram	3
R01_AlarmWarnMsg	
Ladder Diagram	4
R02_SystemSts	
Ladder Diagram	8
R03_SystemStartup	
Ladder Diagram	10
R10_SystemCtrl	
Ladder Diagram	13
R11_PnuematicCtrl	
Ladder Diagram	17
R20_ScannerIO	
Ladder Diagram	20
R21_SystemIO	
Ladder Diagram	22
R22_RobotEIO	
Ladder Diagram	26
R23_CameraEIO	
Ladder Diagram	28
R30_HMISTs	
Ladder Diagram	31
R31_HMICtrl	
Ladder Diagram	33
R32_BaySts	
Ladder Diagram	34
ProcessRoutines	
r_EvaluateBox	
Ladder Diagram	44
r_PositionBox	
Ladder Diagram	47
r_ReadBox	
Ladder Diagram	50
r_RejectBox	
Ladder Diagram	55
r_RobotPickBox	
Ladder Diagram	58
SubRoutines	
Ladder Diagram	64
MainTask	
MainProgram	
MainRoutine	
Ladder Diagram	65