



MTR_ArticleBucket_Retard.ActualPosition
0.0
MTR_ArticleBucket_Pusher.ActualPosition
0.0

SUB
Source A MTR_ArticleBucket_Retard.ActualPosition
Source B MTR_ArticleBucket_Pusher.ActualPosition
Dest ArticleBucketDelta

MTR_ArticleBucket_Pusher.ActualPosition
0.0
MTR_ArticleBucket_Retard.ActualPosition
0.0

CPT
Dest ArticleBucketDelta
Expression MTR_ArticleBucket_Retard.ActualPosition+MachinePitch-MTR_ArticleBucket_Pusher.ActualPosition

ArticleBucketDelta
0.0
ArticleBucketDelta
0.0
ArticleBucketDelta
12.0

ArticleBucketDelta
12.0
ArticleBucketDelta
Position

177

LES
Source A ArticleBucketDelta
12.0
Source B CartonLengthMax
11.5

testjr12

MaxPocketSizeFaultEnabled

178

MaxPocketSizeFaultEnabled

GRT
Source A ArticleBucketDelta
12.0
Source B CartonLengthMax
11.5

Fault 89
Article Bucket Max Pocket Size Fault

LES
Source A ArticleBucketDelta
12.0
Source B MachinePitch
12.0

ErrorNum[89] FaultPresent

179

ResetSignal

Fault 89
Reset

ErrorNum[89]

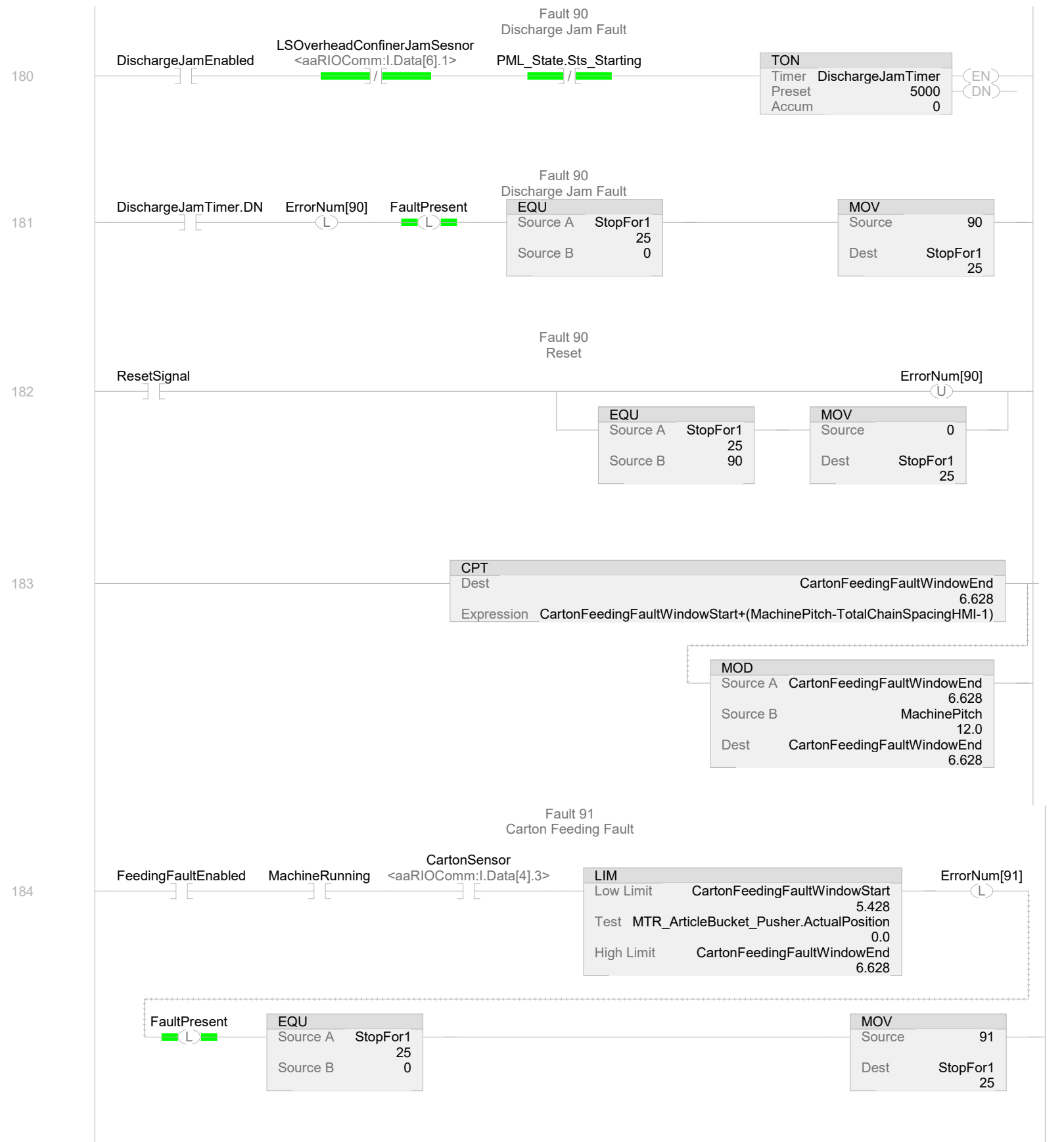
MaxPocketSizeFaultEnabled

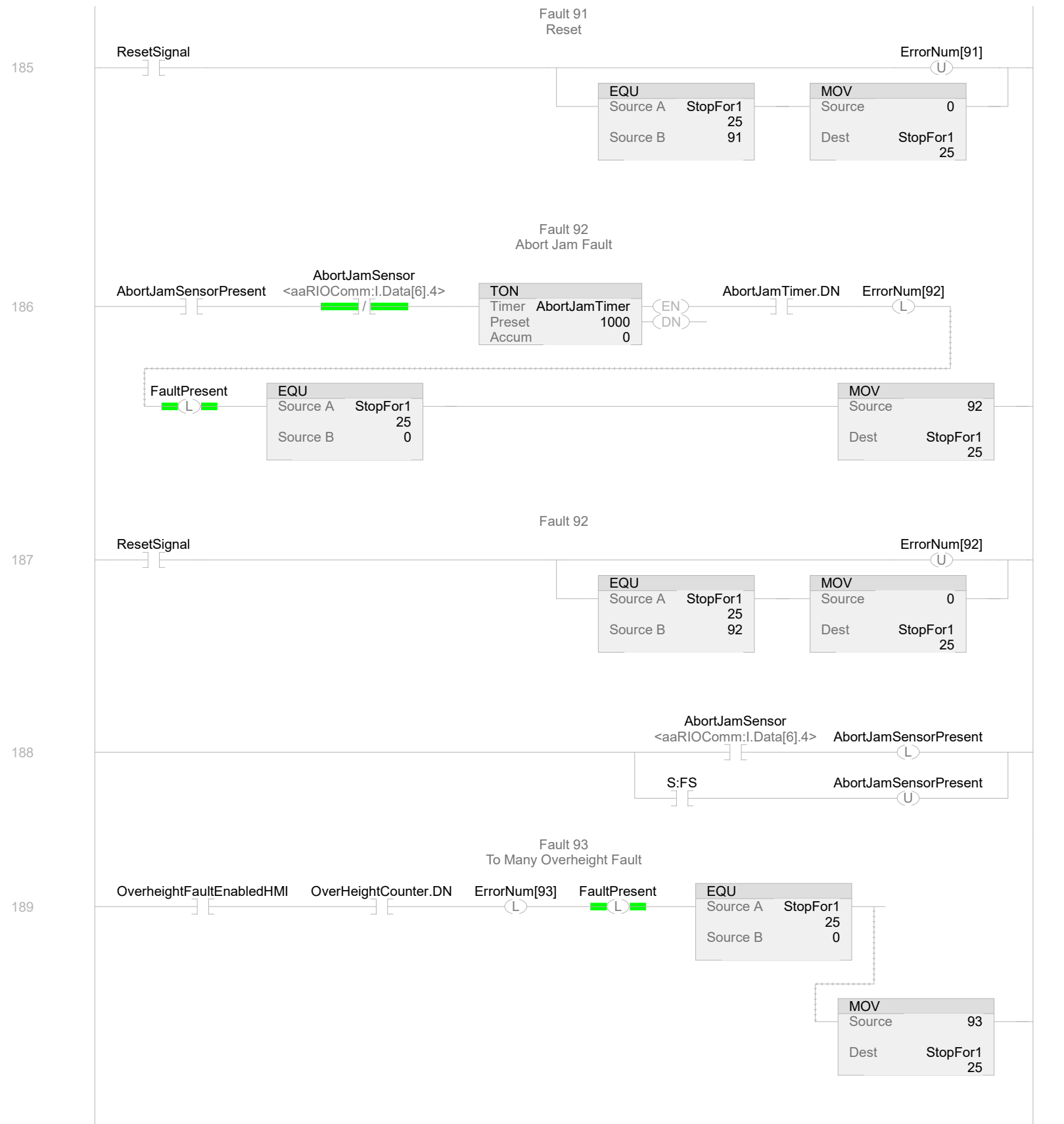
EQU
Source A StopFor1
25
Source B 0

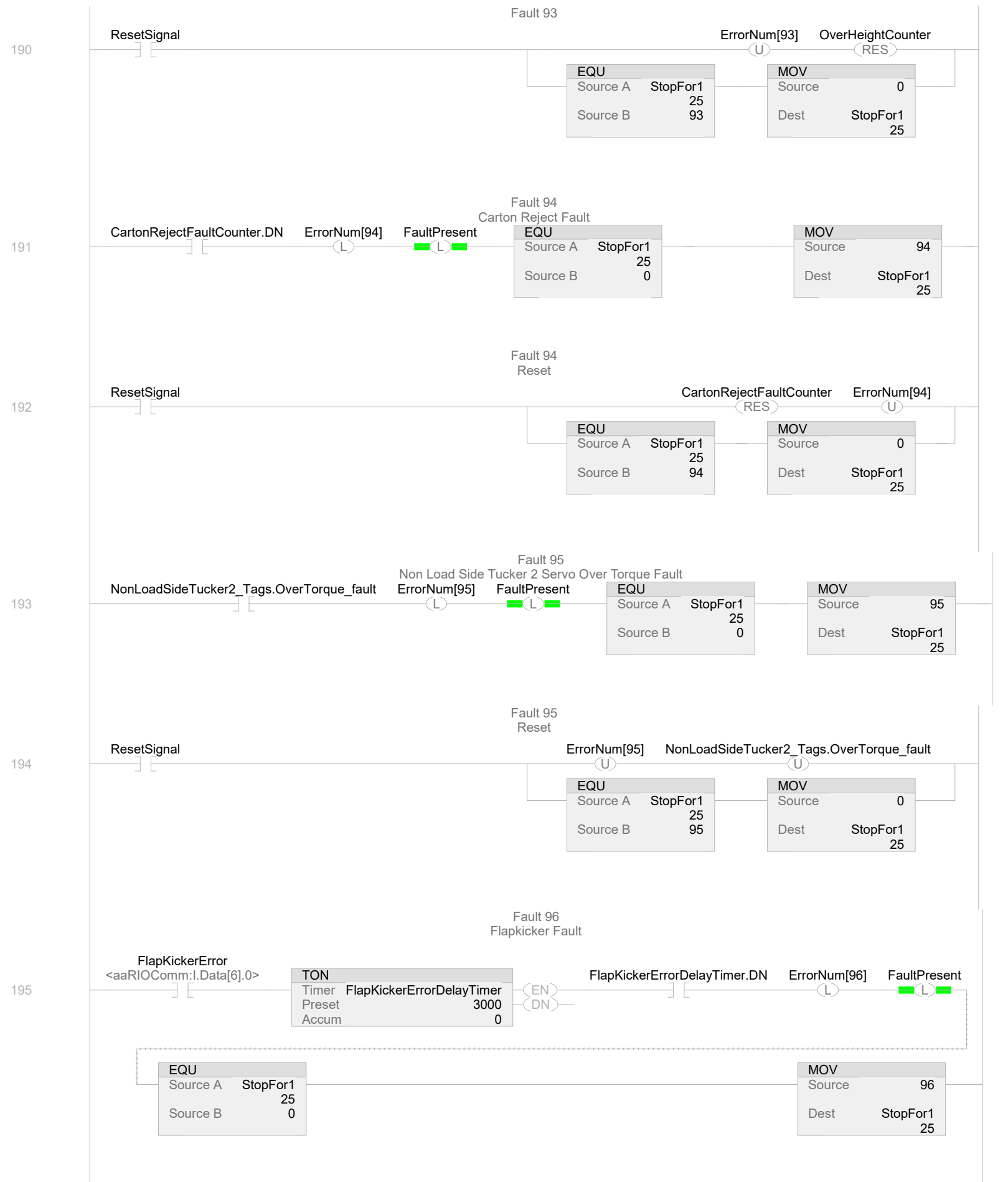
MOV
Source 89
Dest StopFor1
25

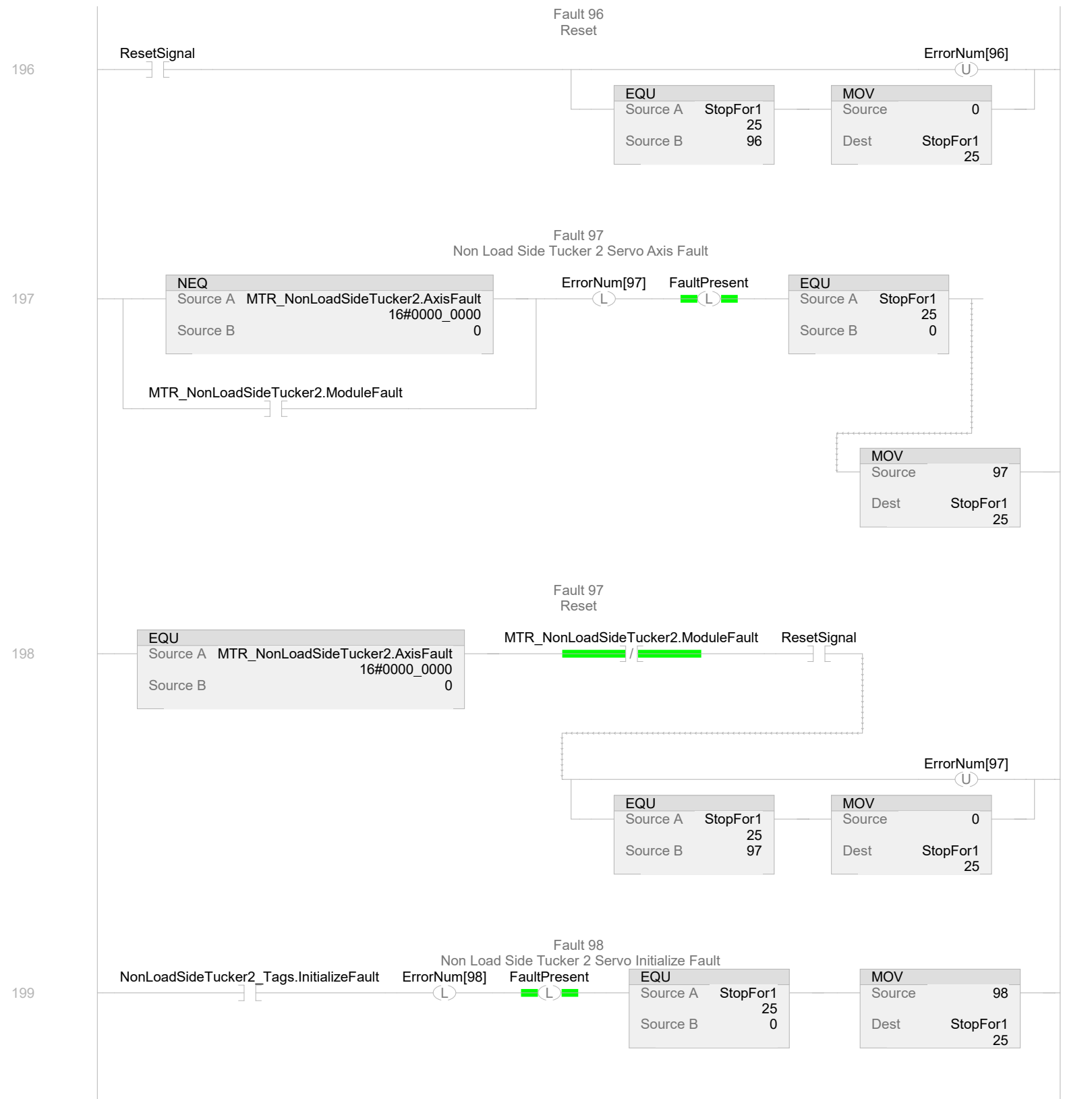
EQU
Source A StopFor1
25
Source B 89

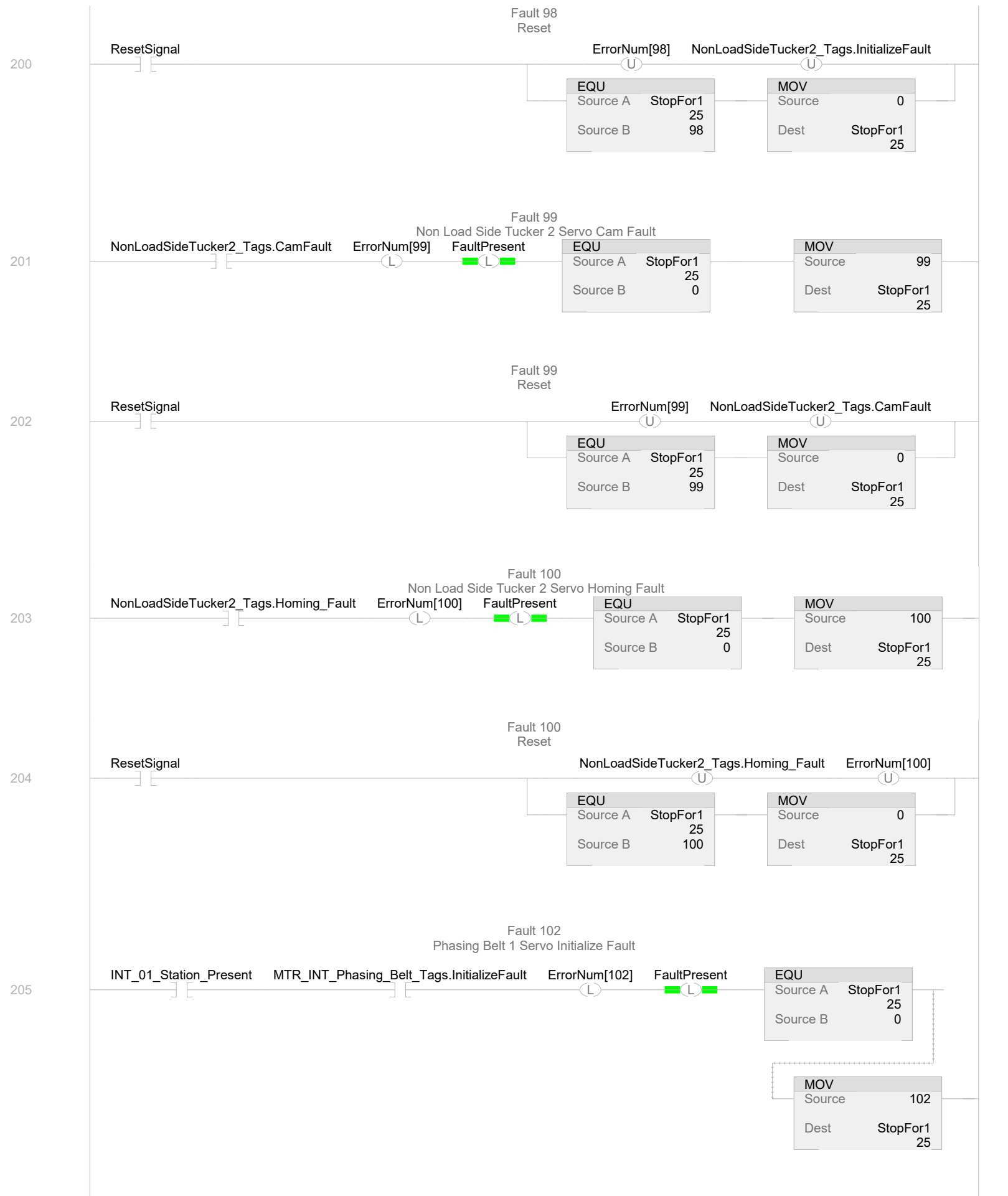
MOV
Source 0
Dest StopFor1
25

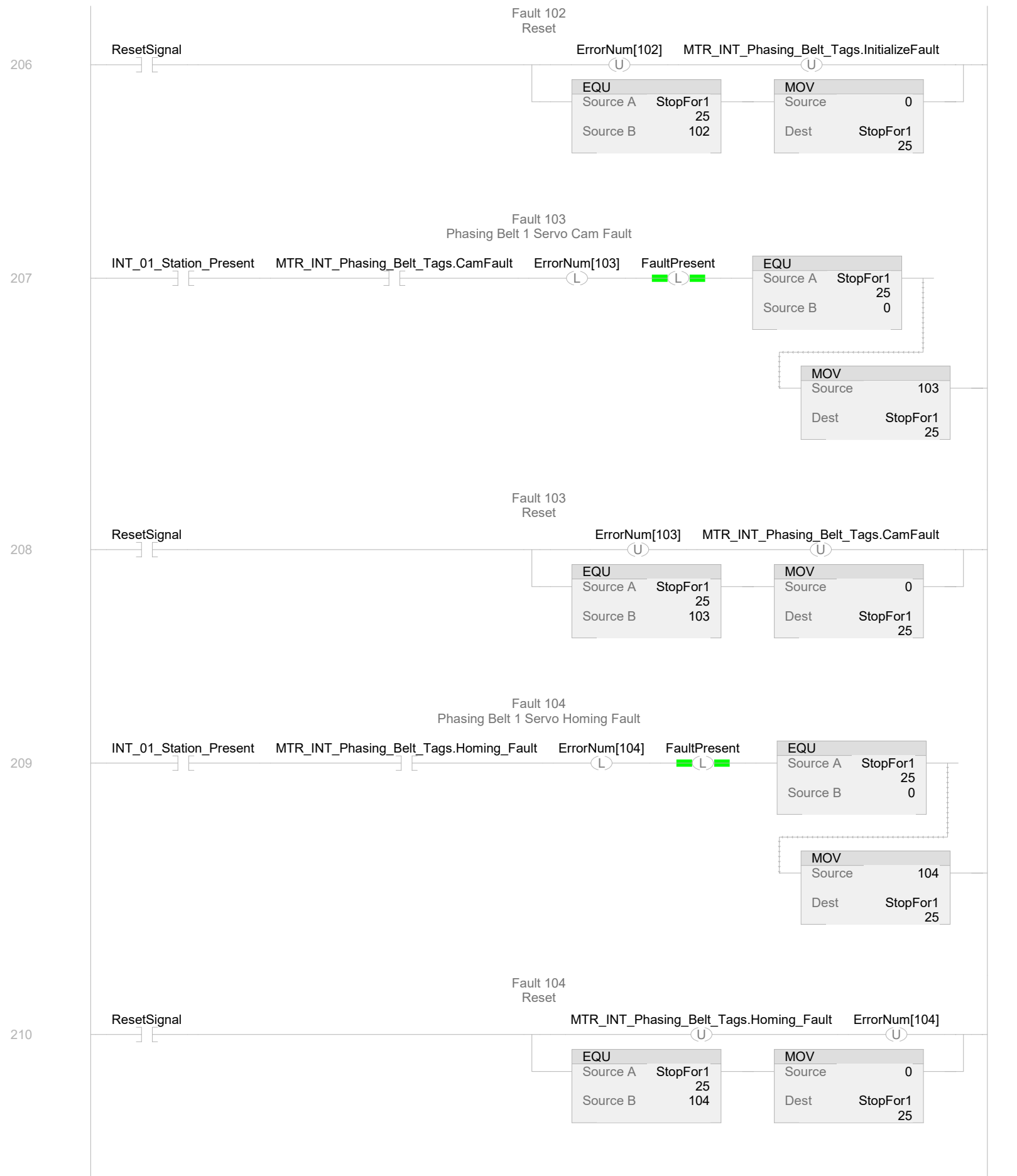


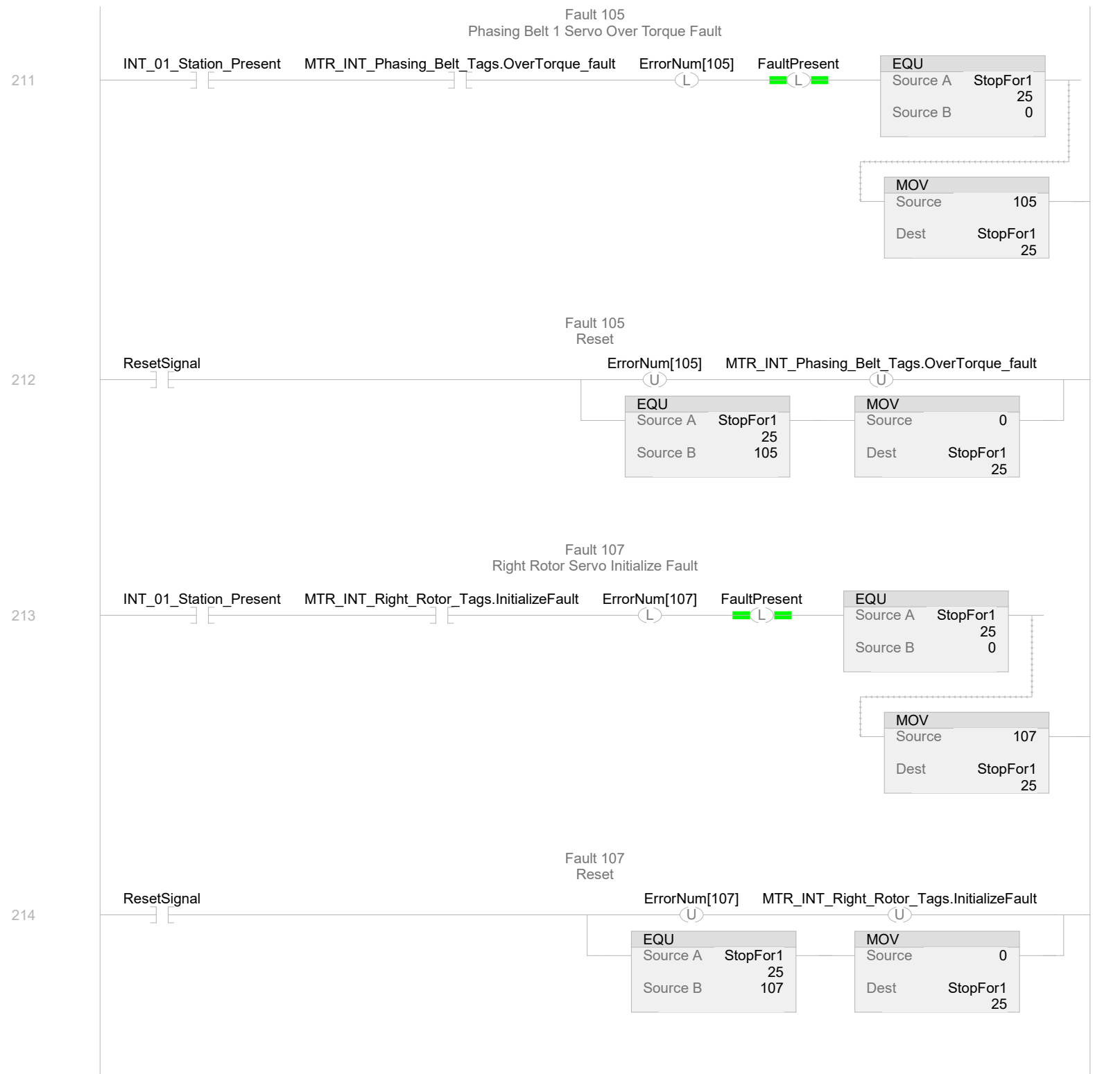


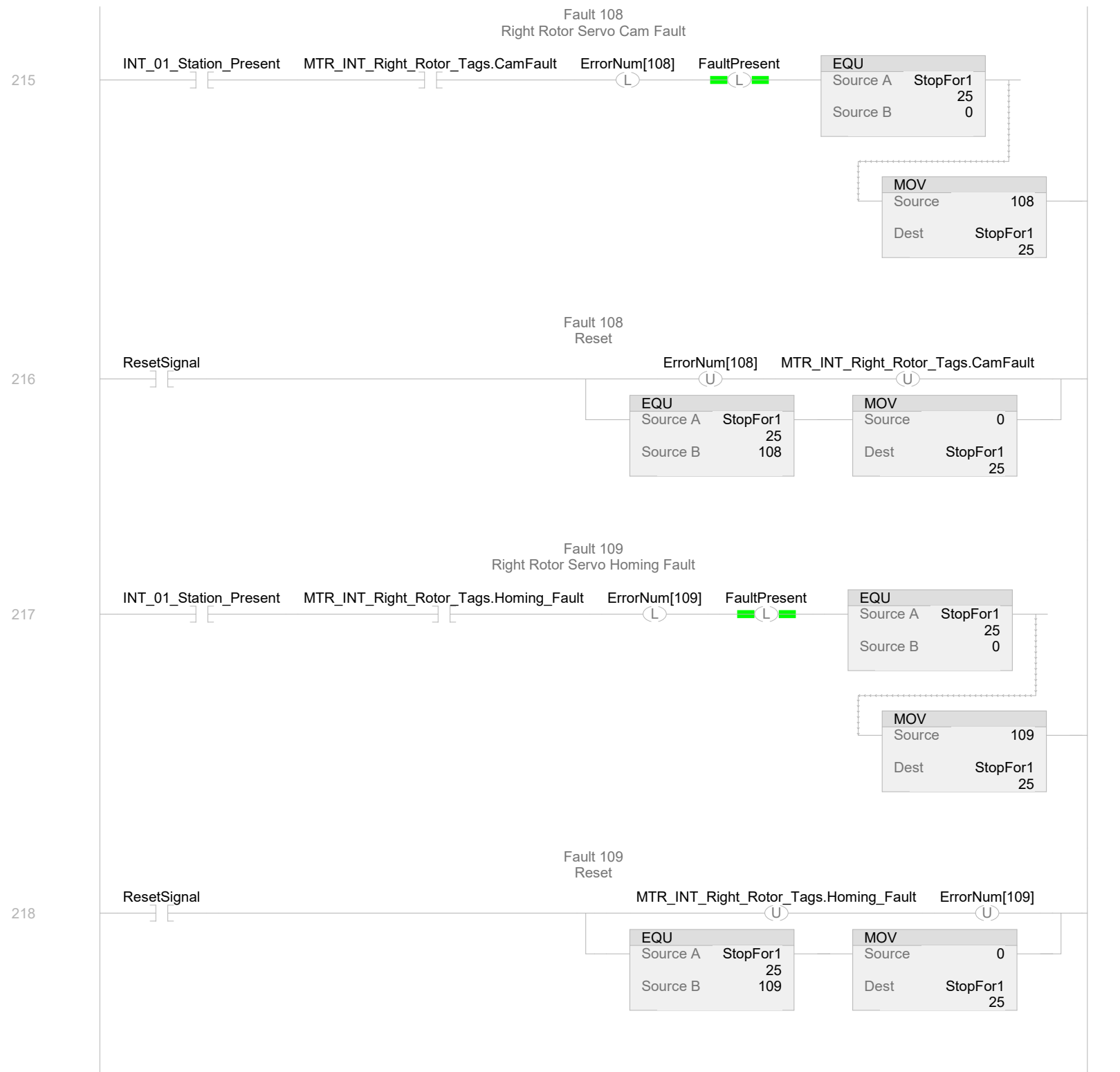






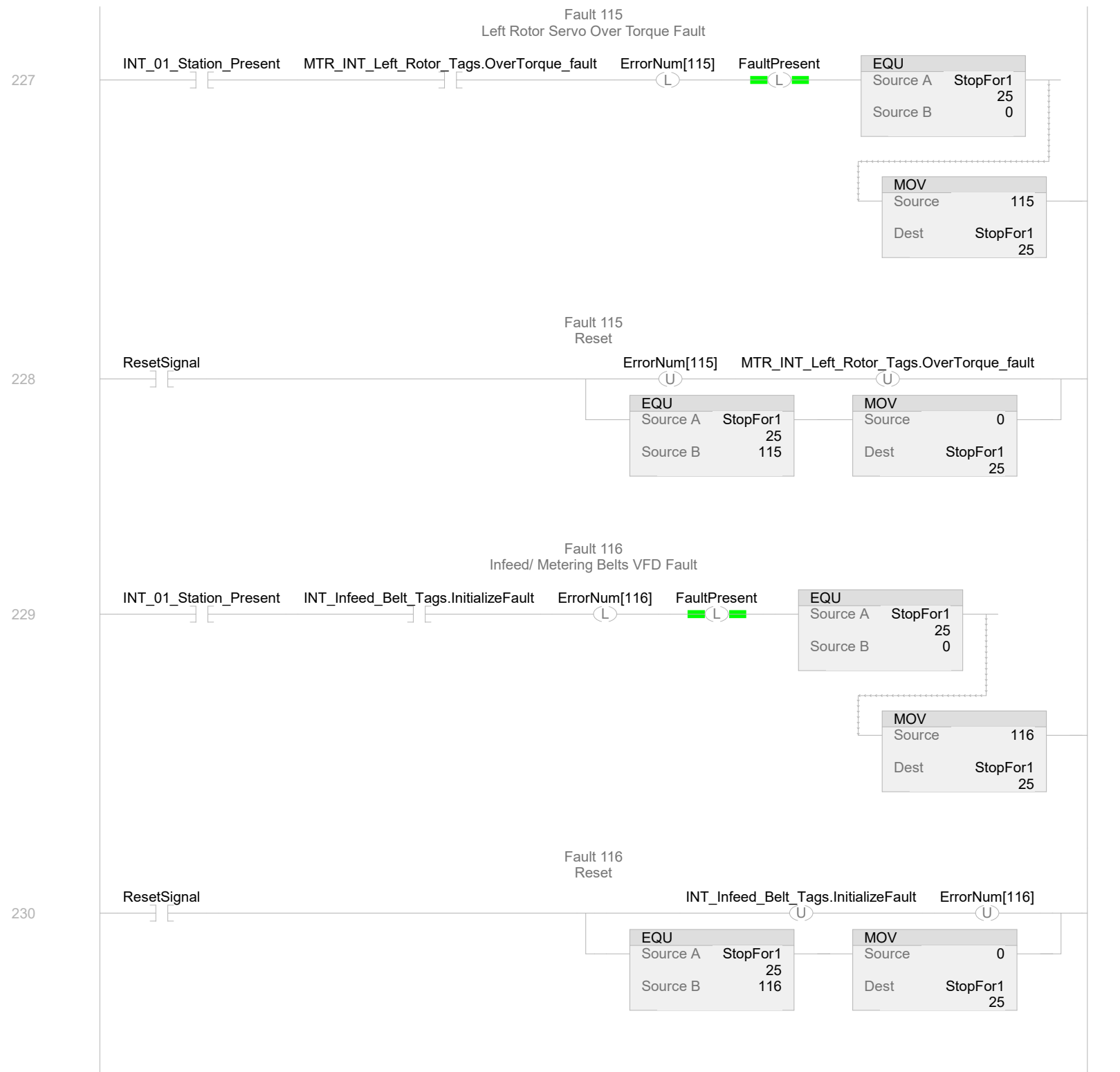


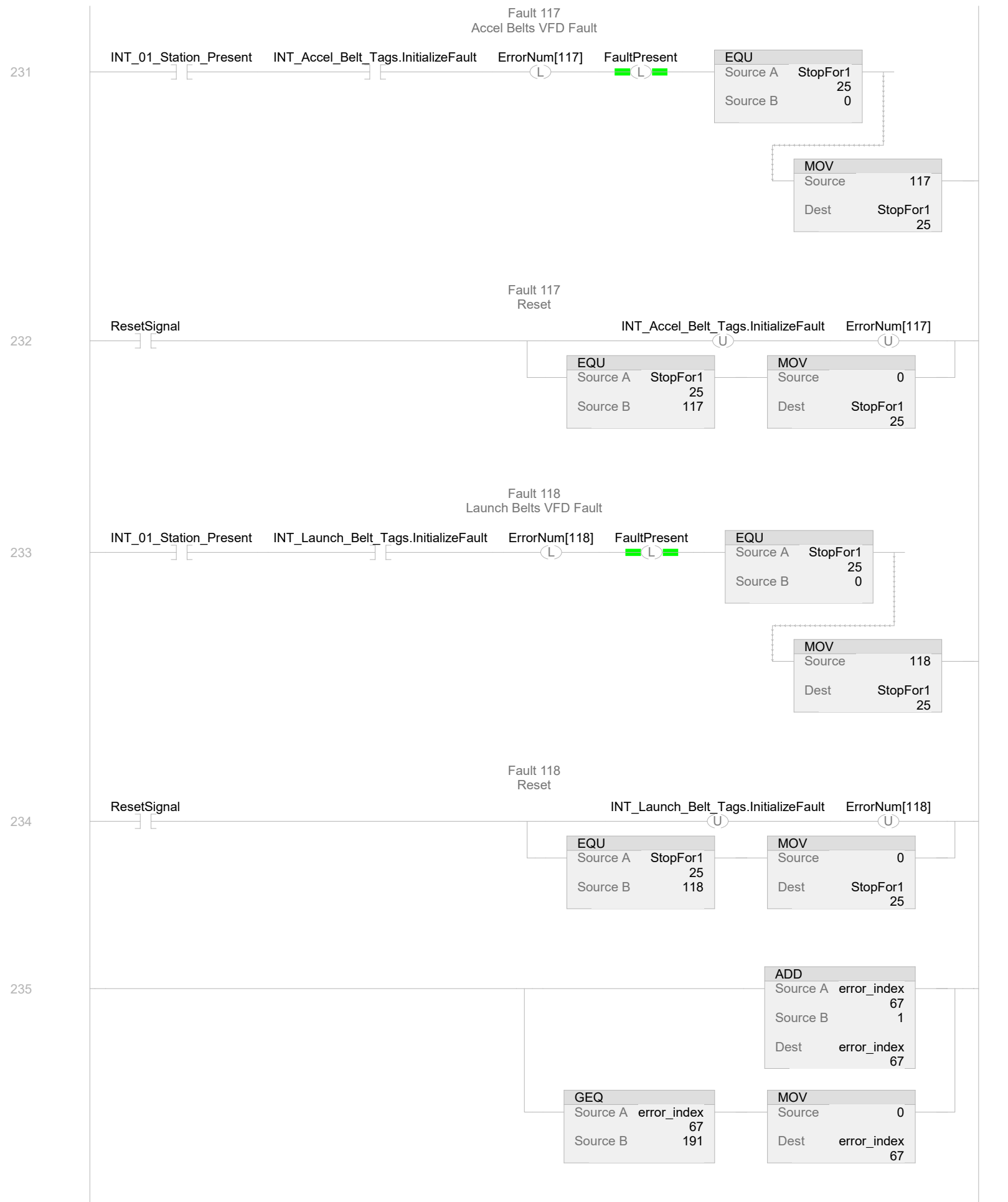


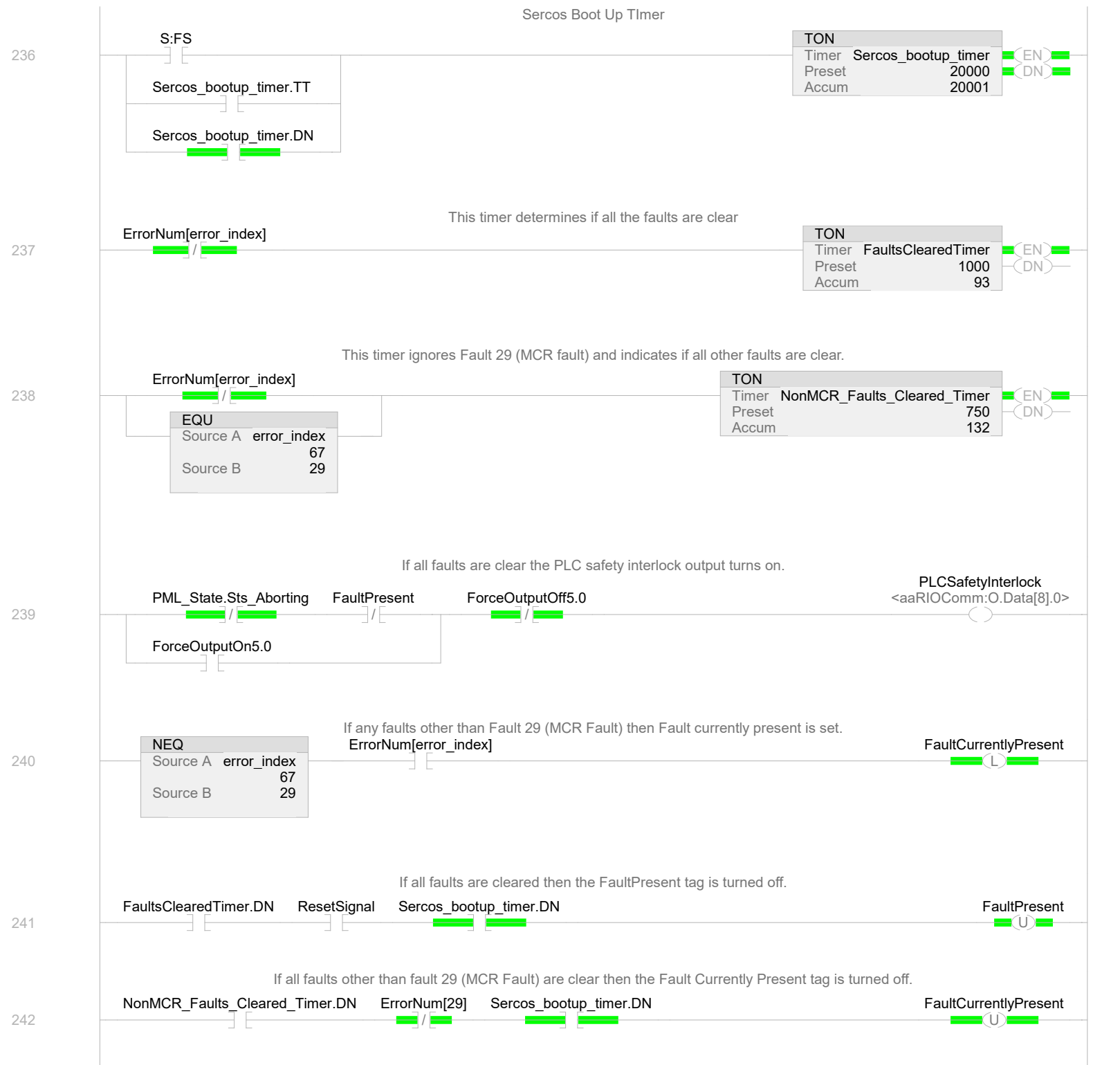


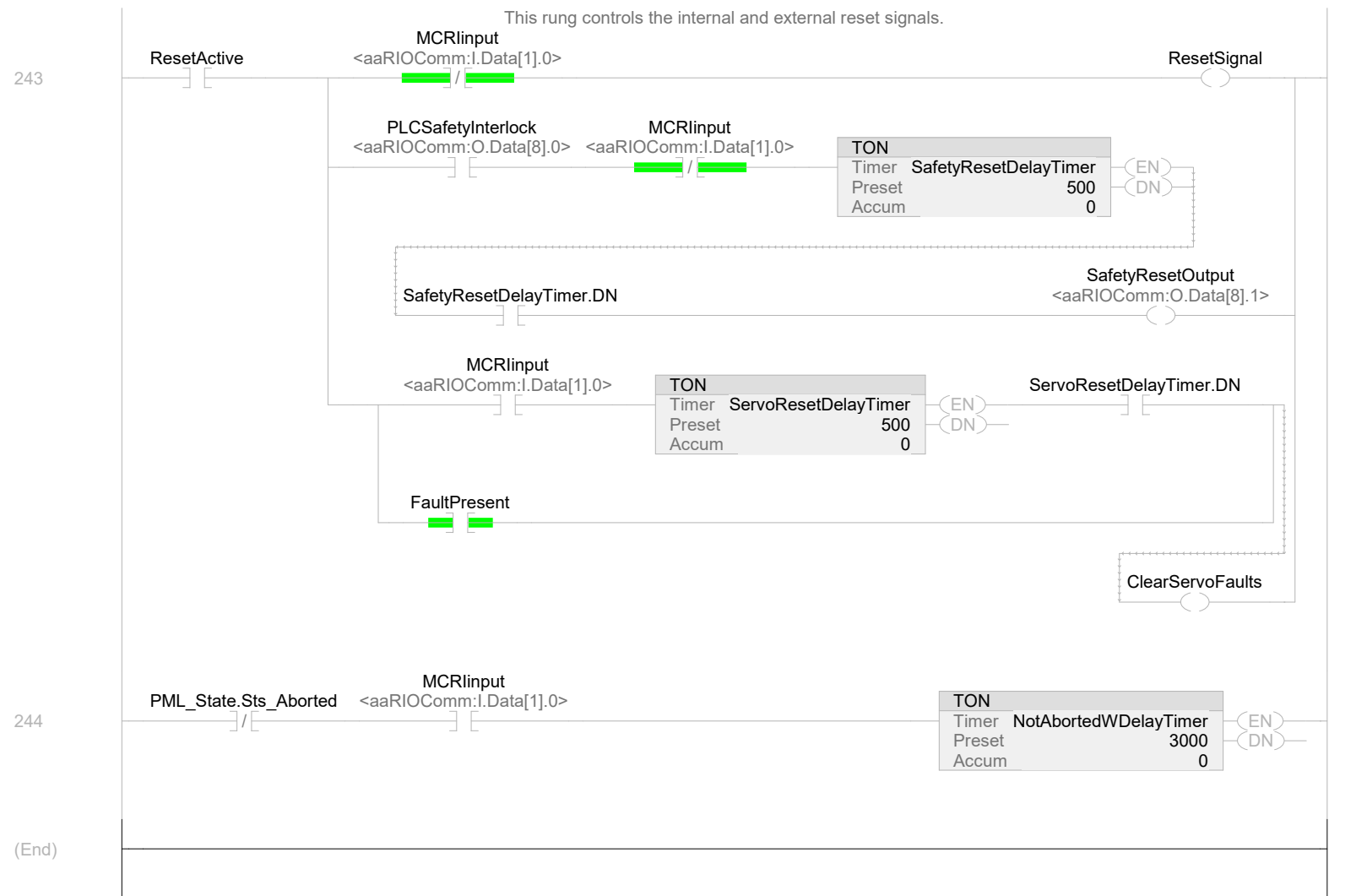


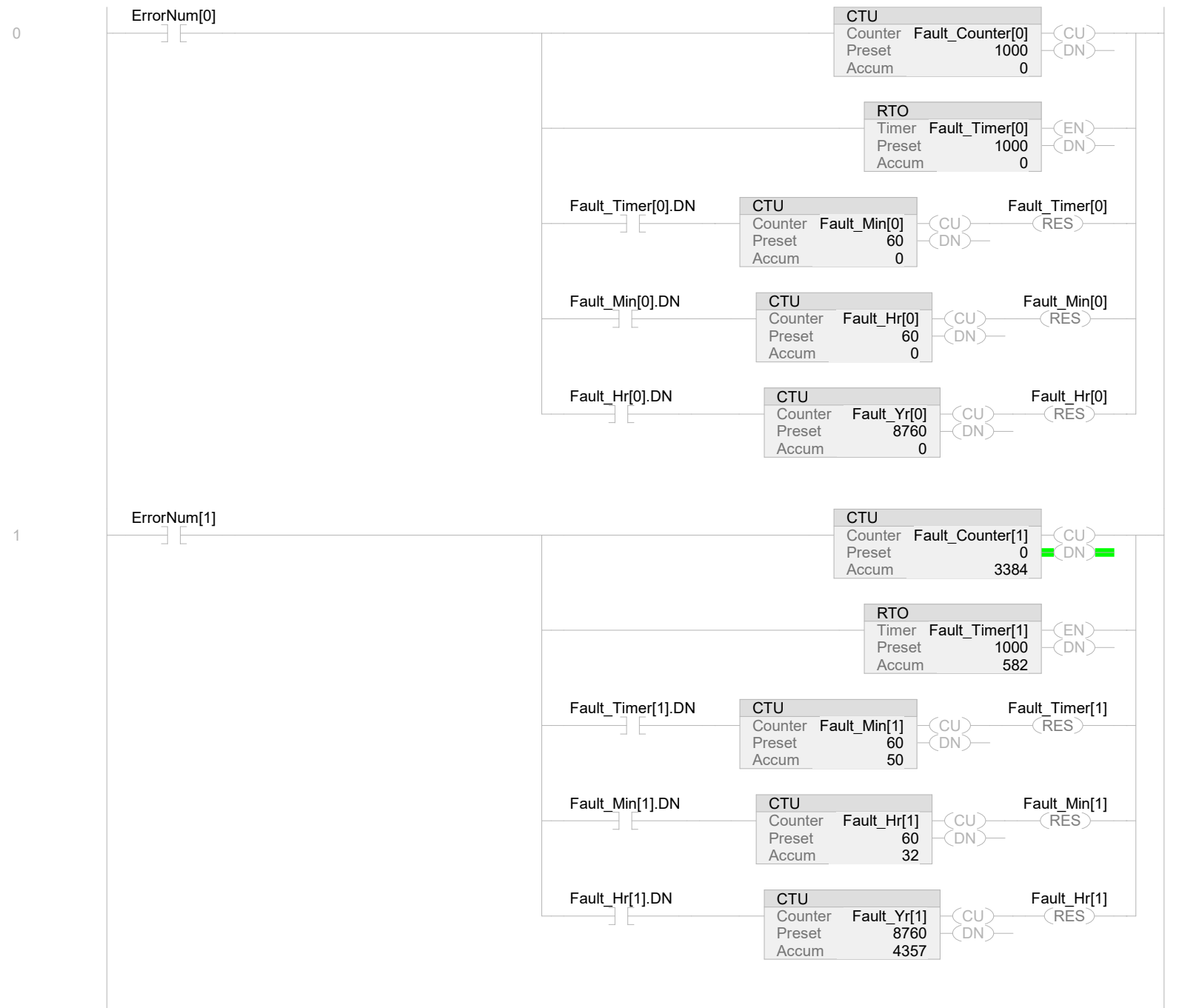


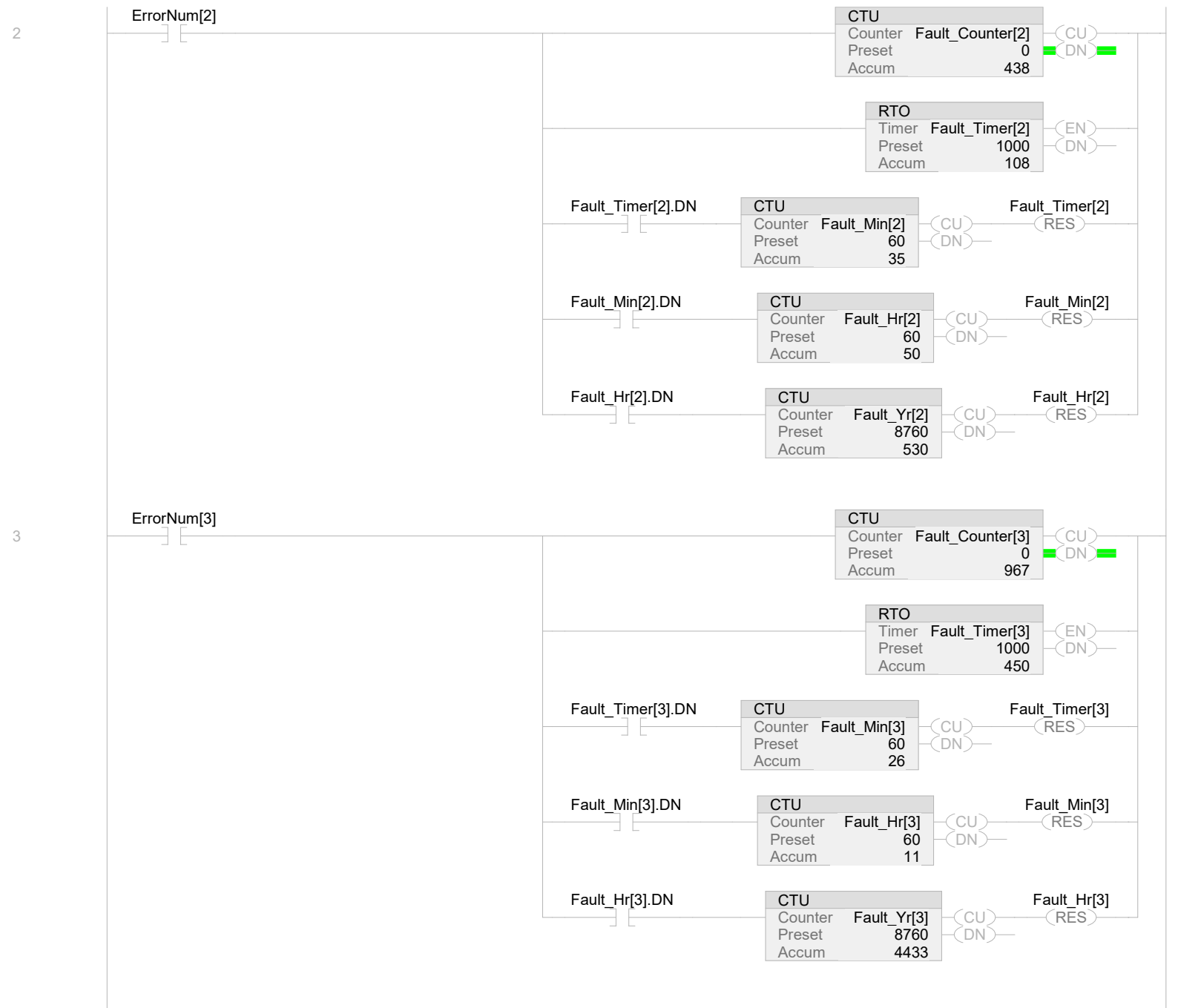


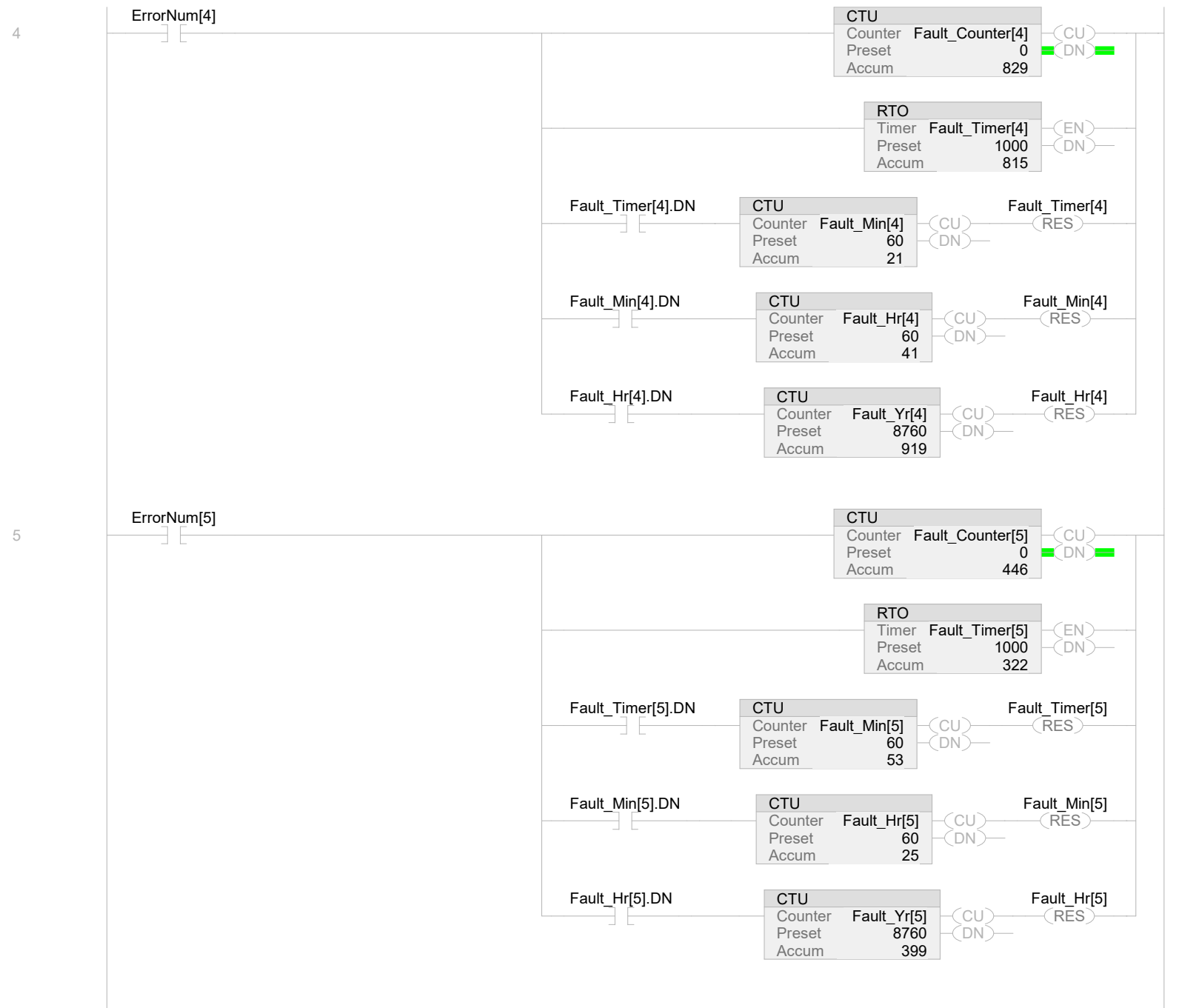


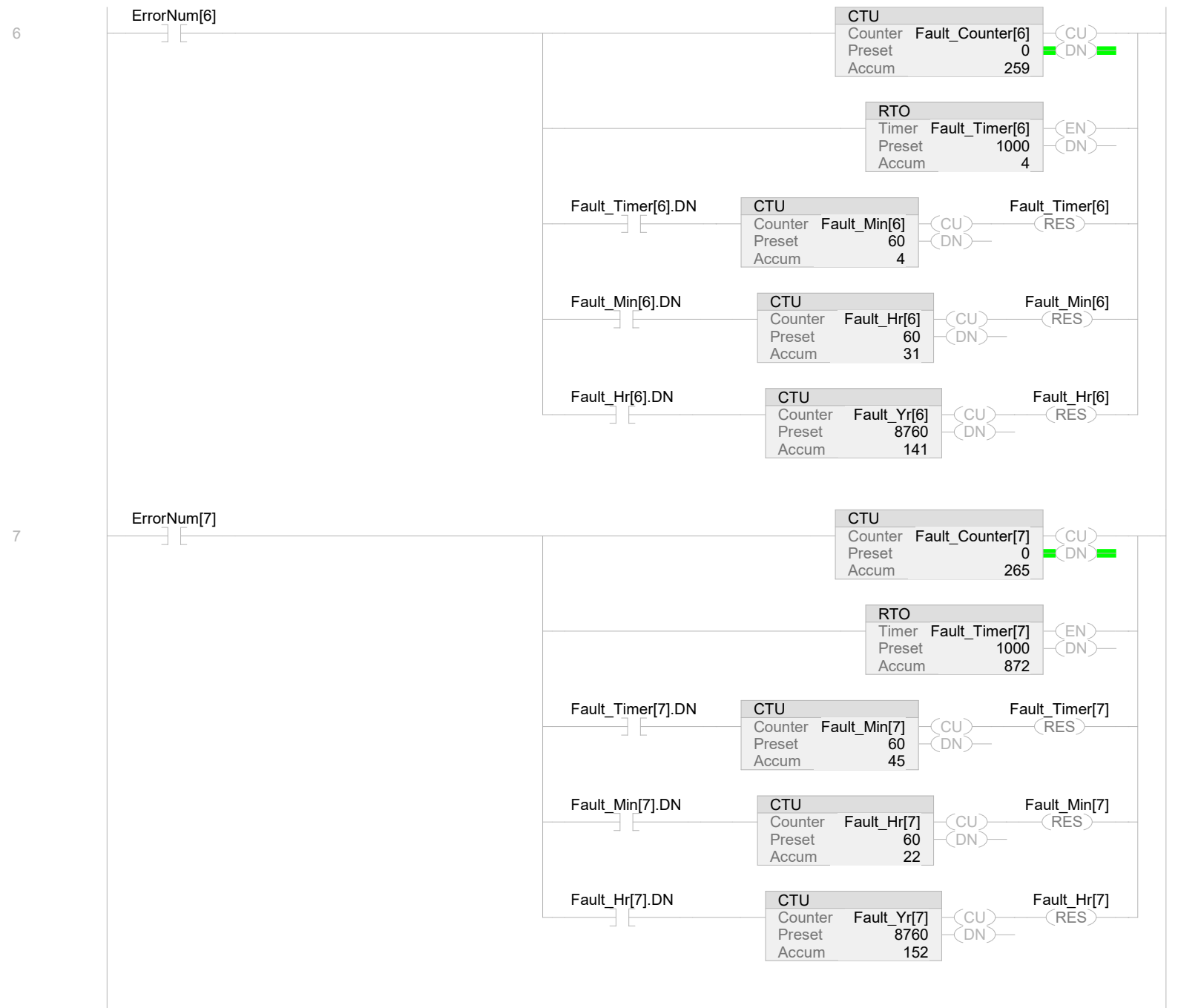


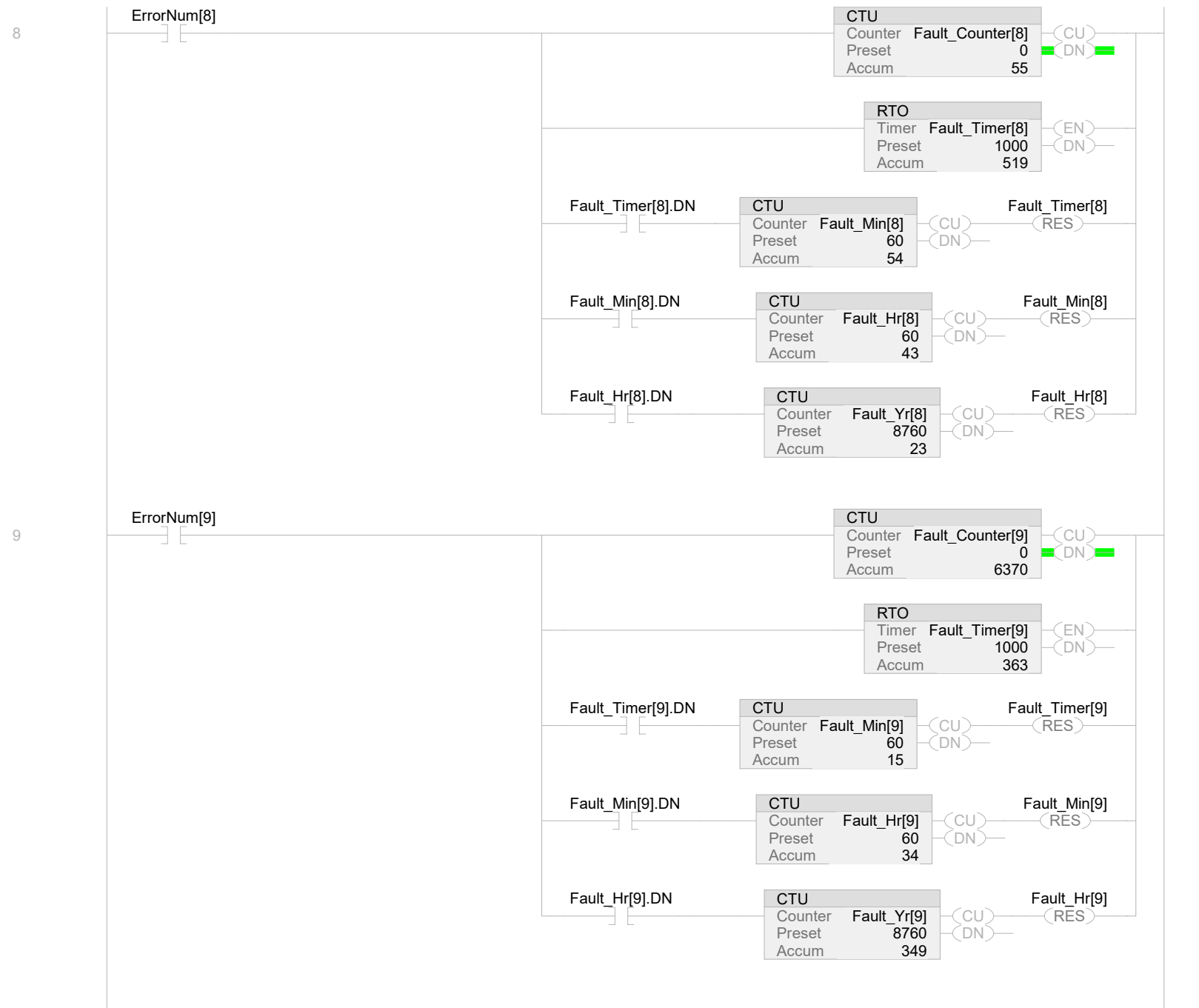


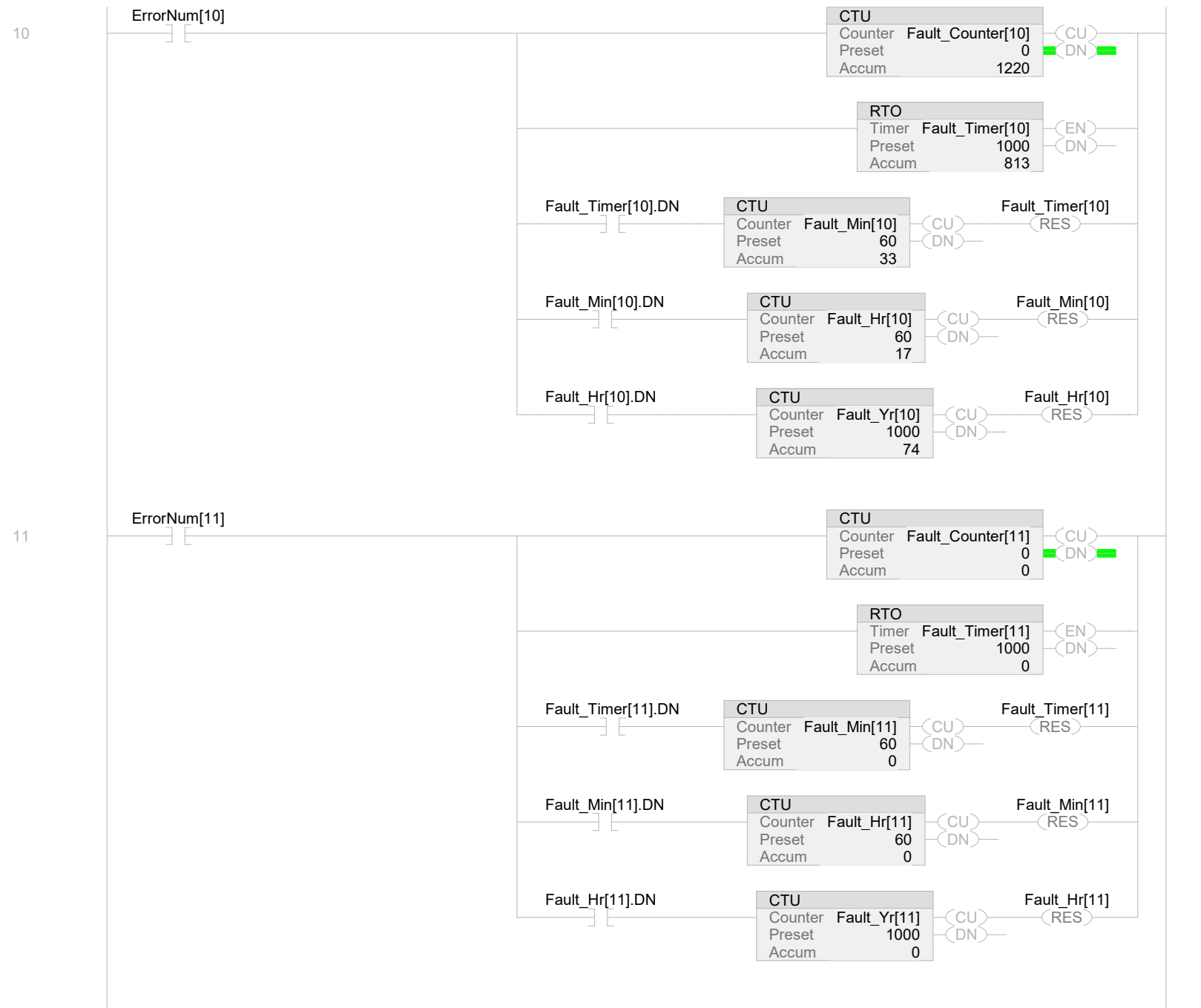


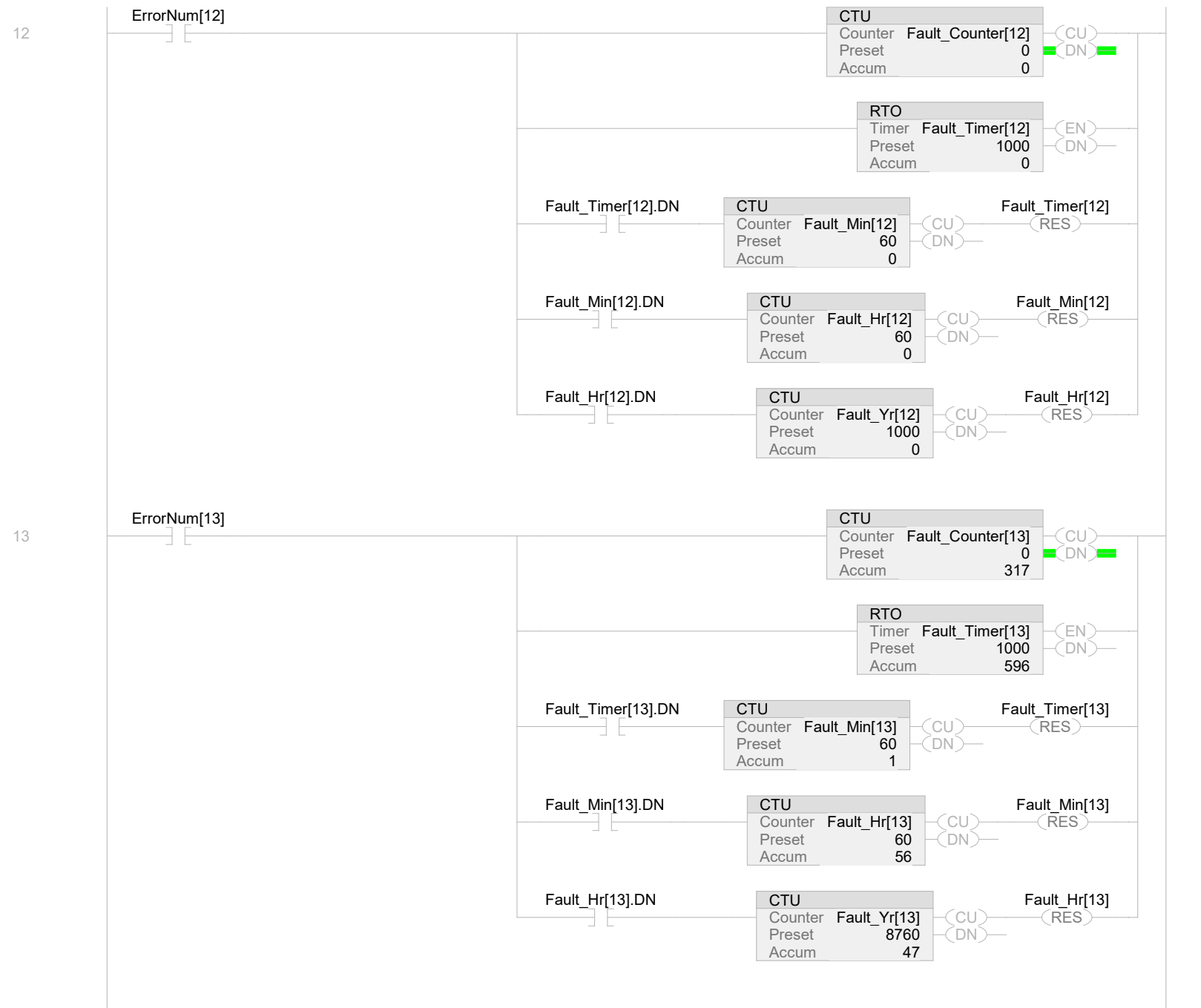






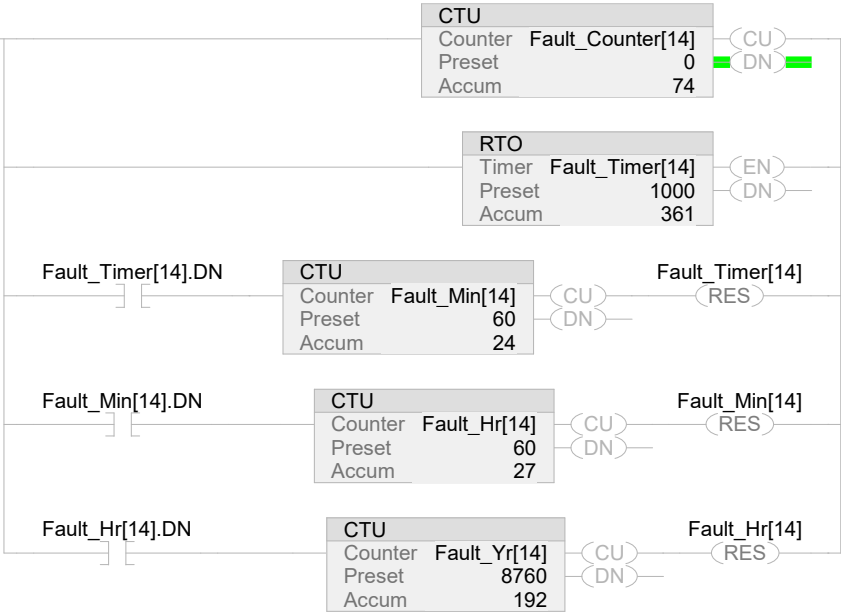






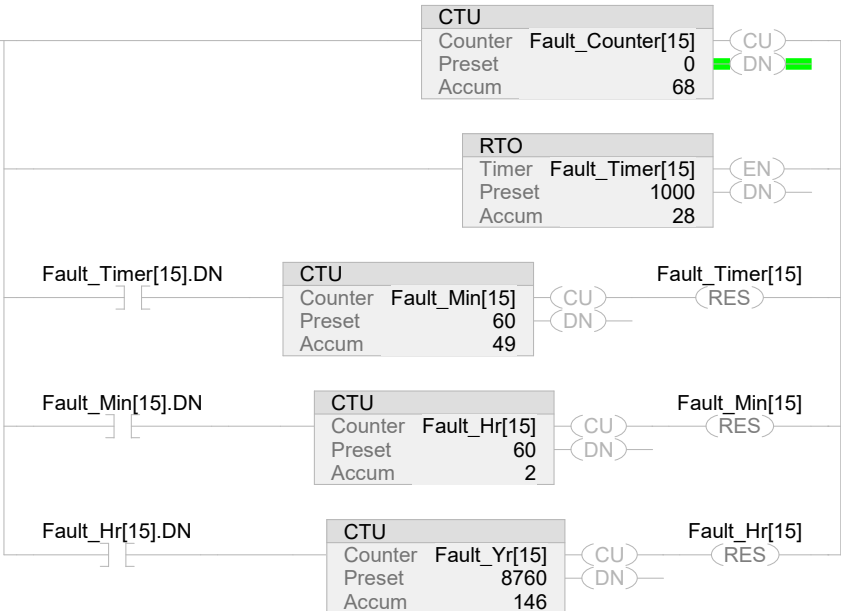
14

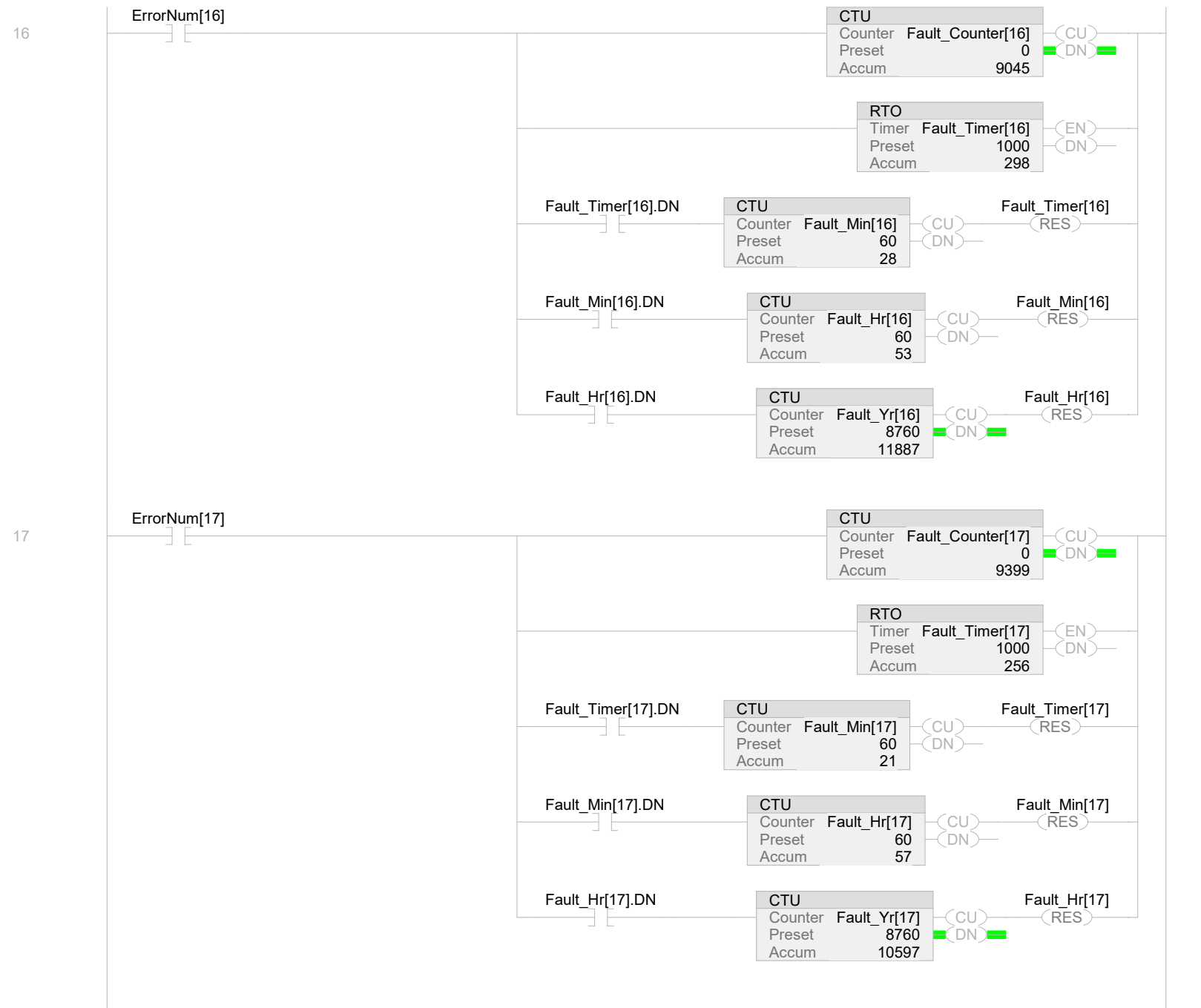
ErrorNum[14]

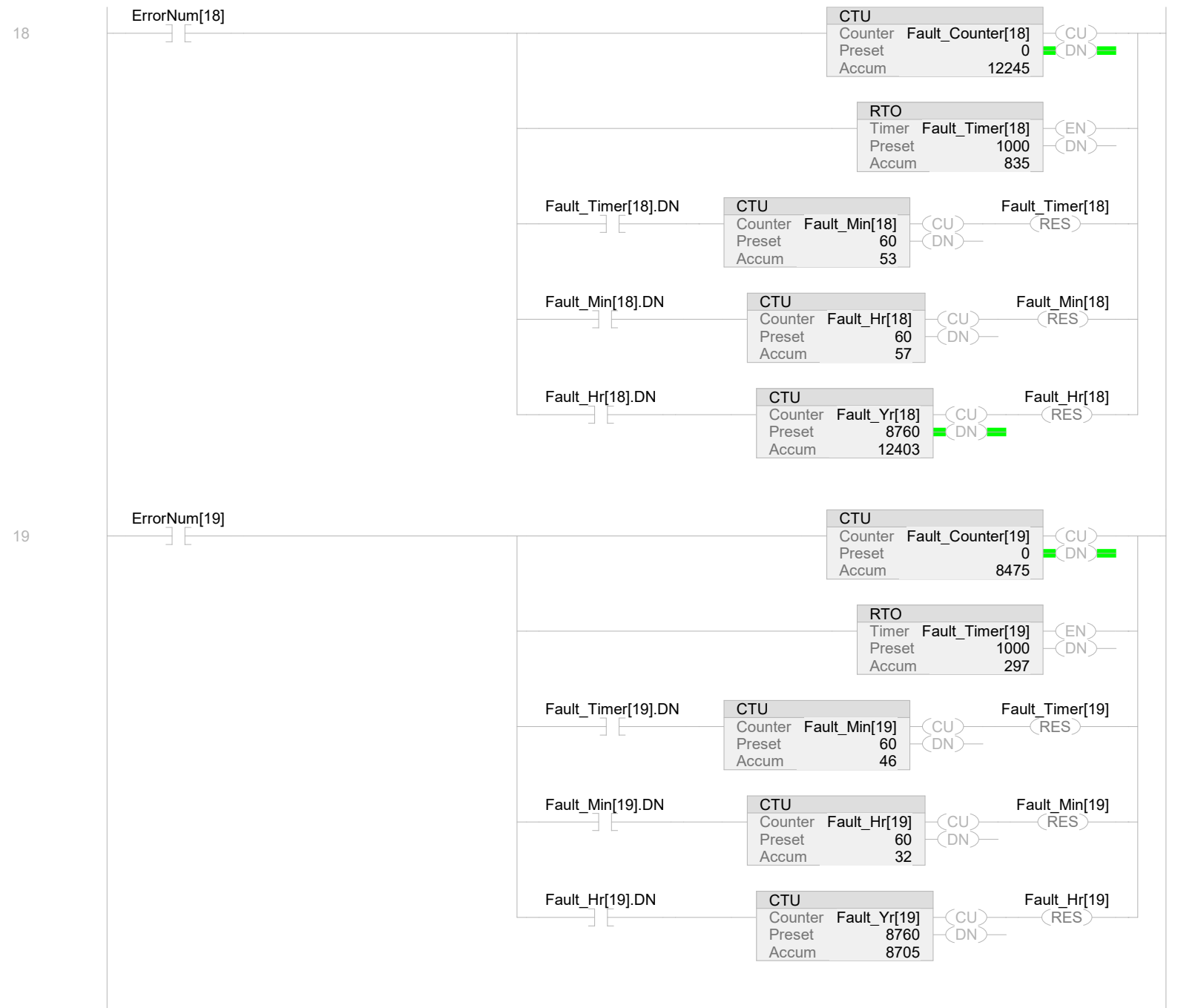


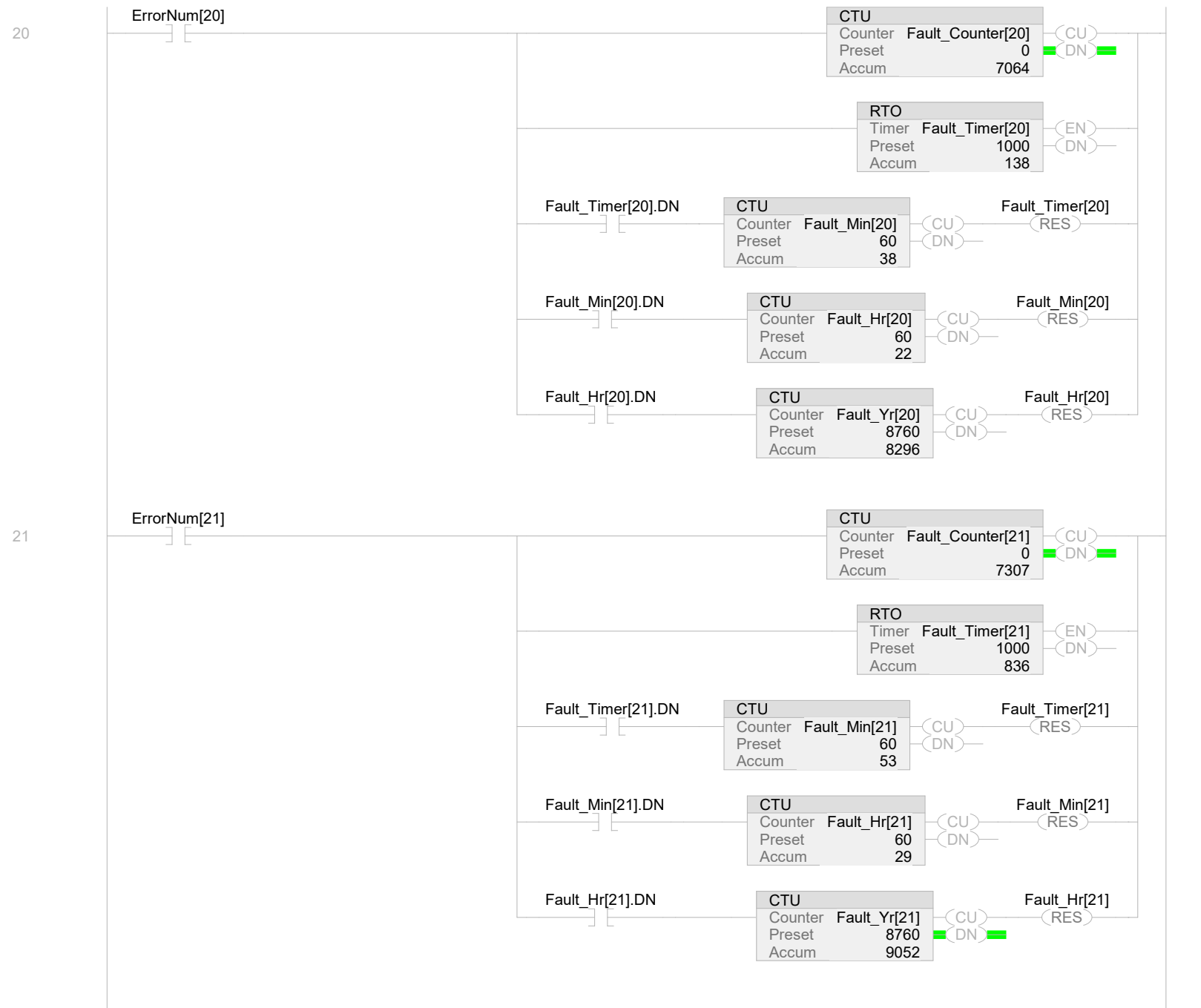
15

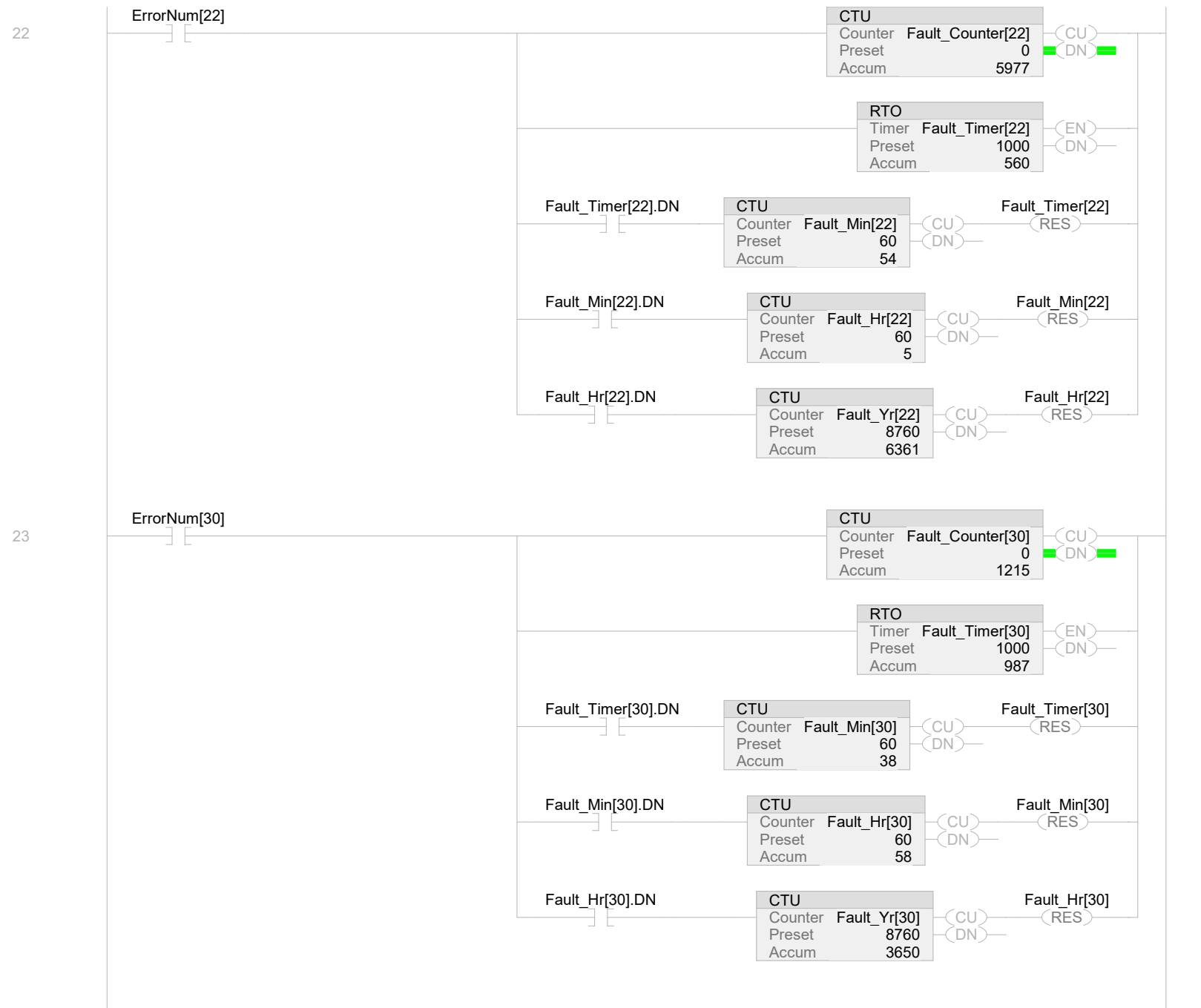
ErrorNum[15]

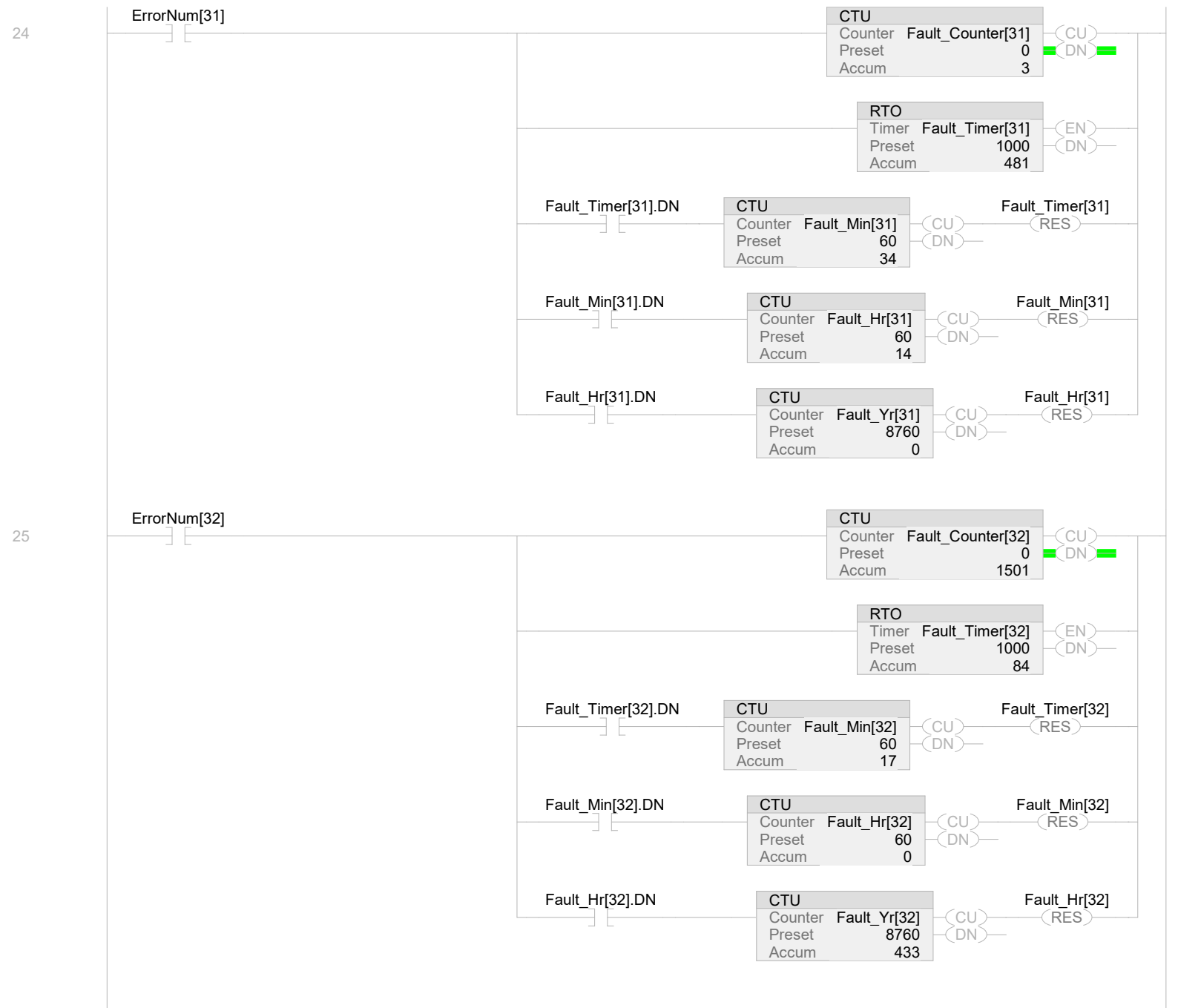


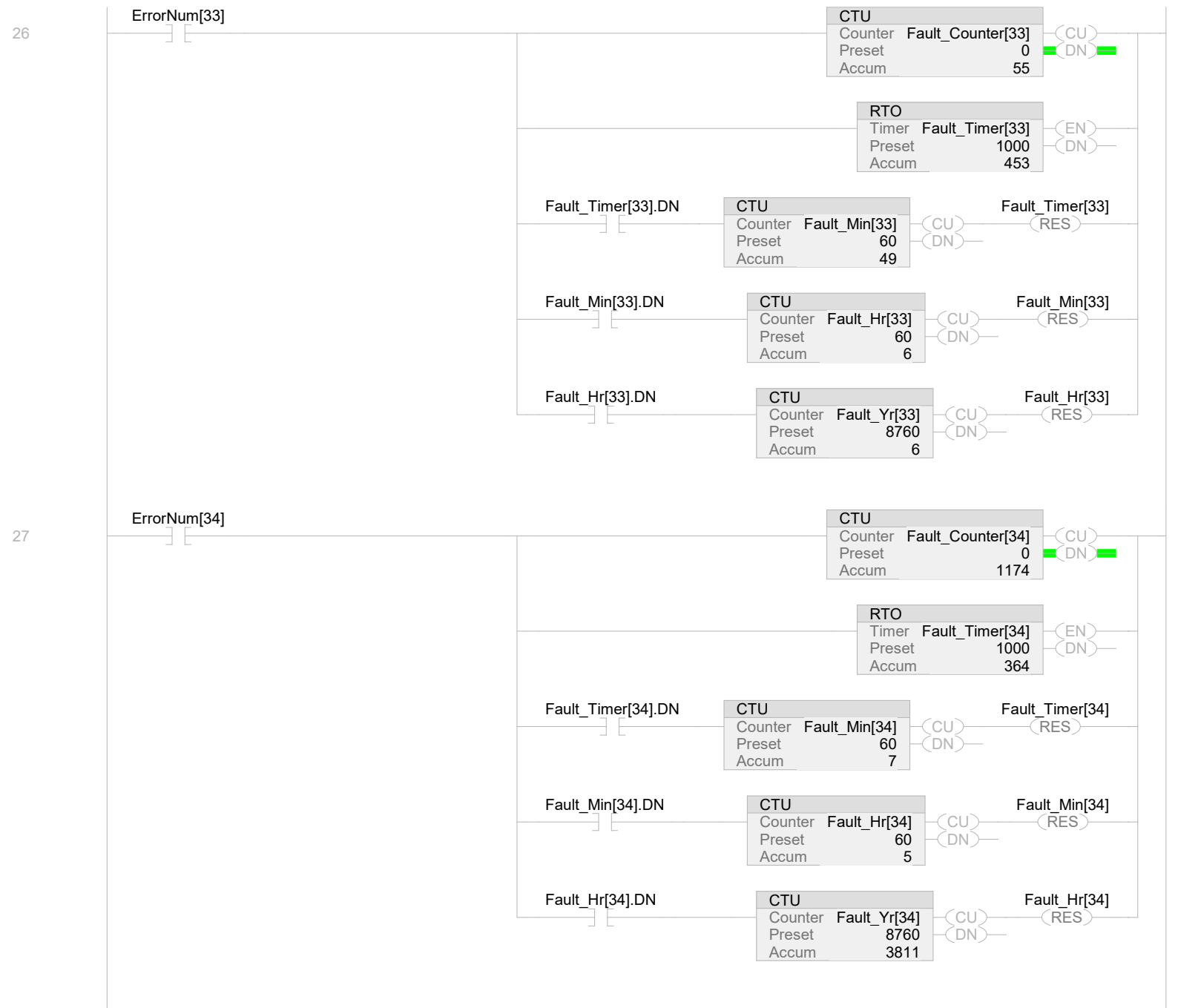


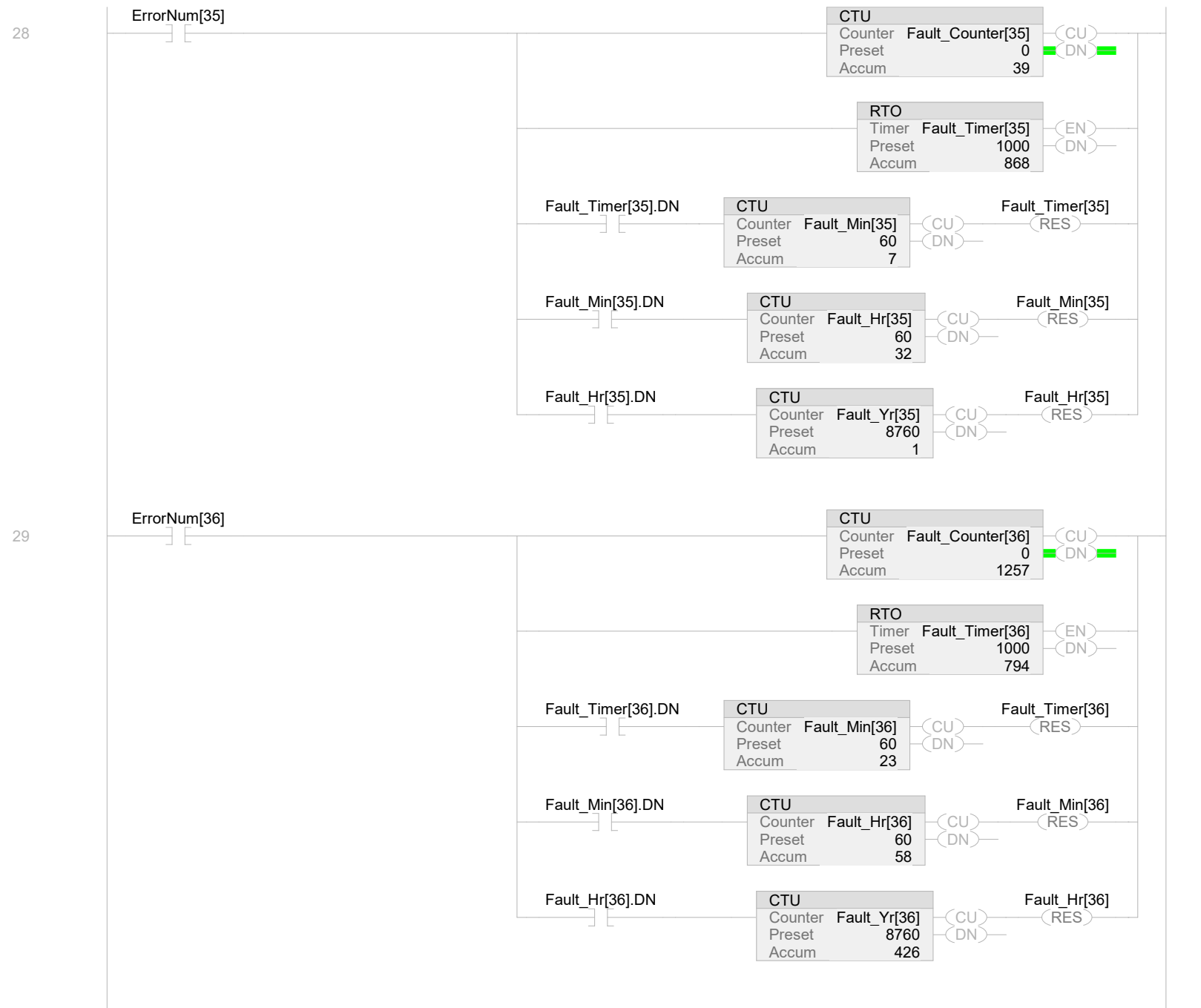


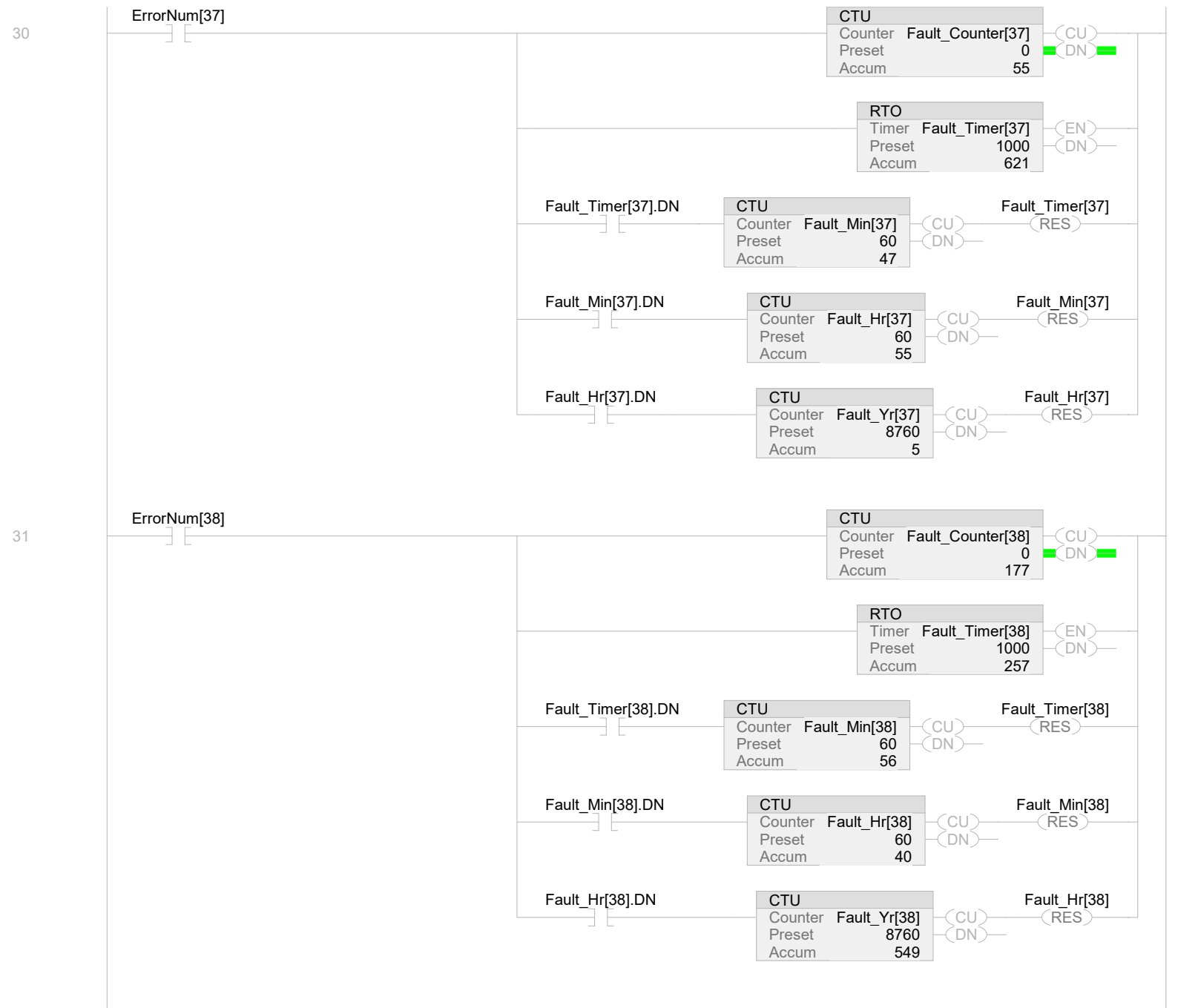


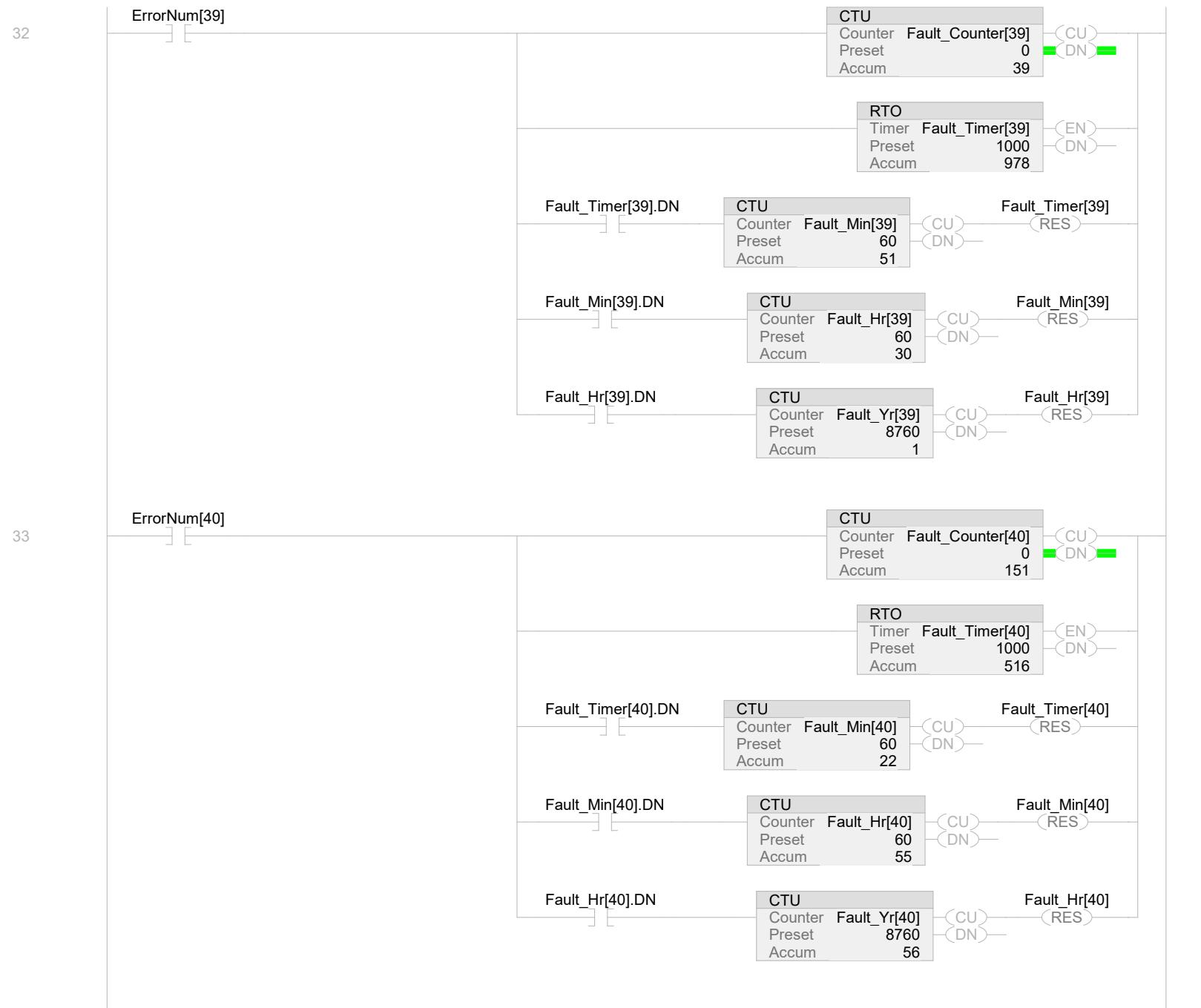






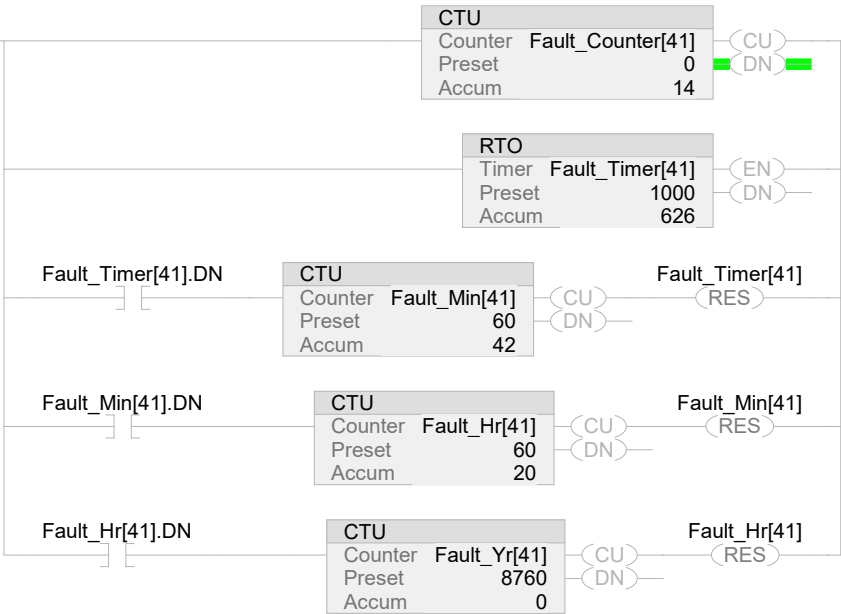






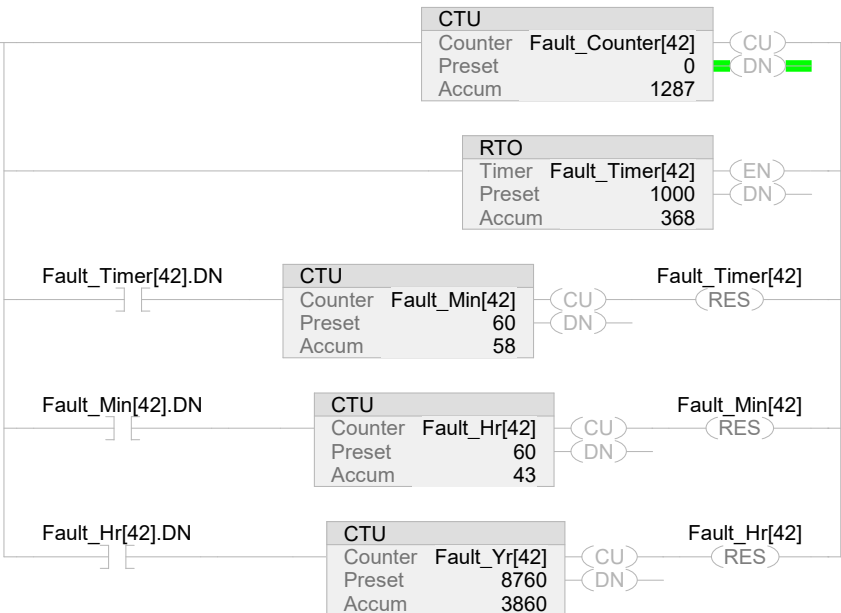
34

ErrorNum[41]

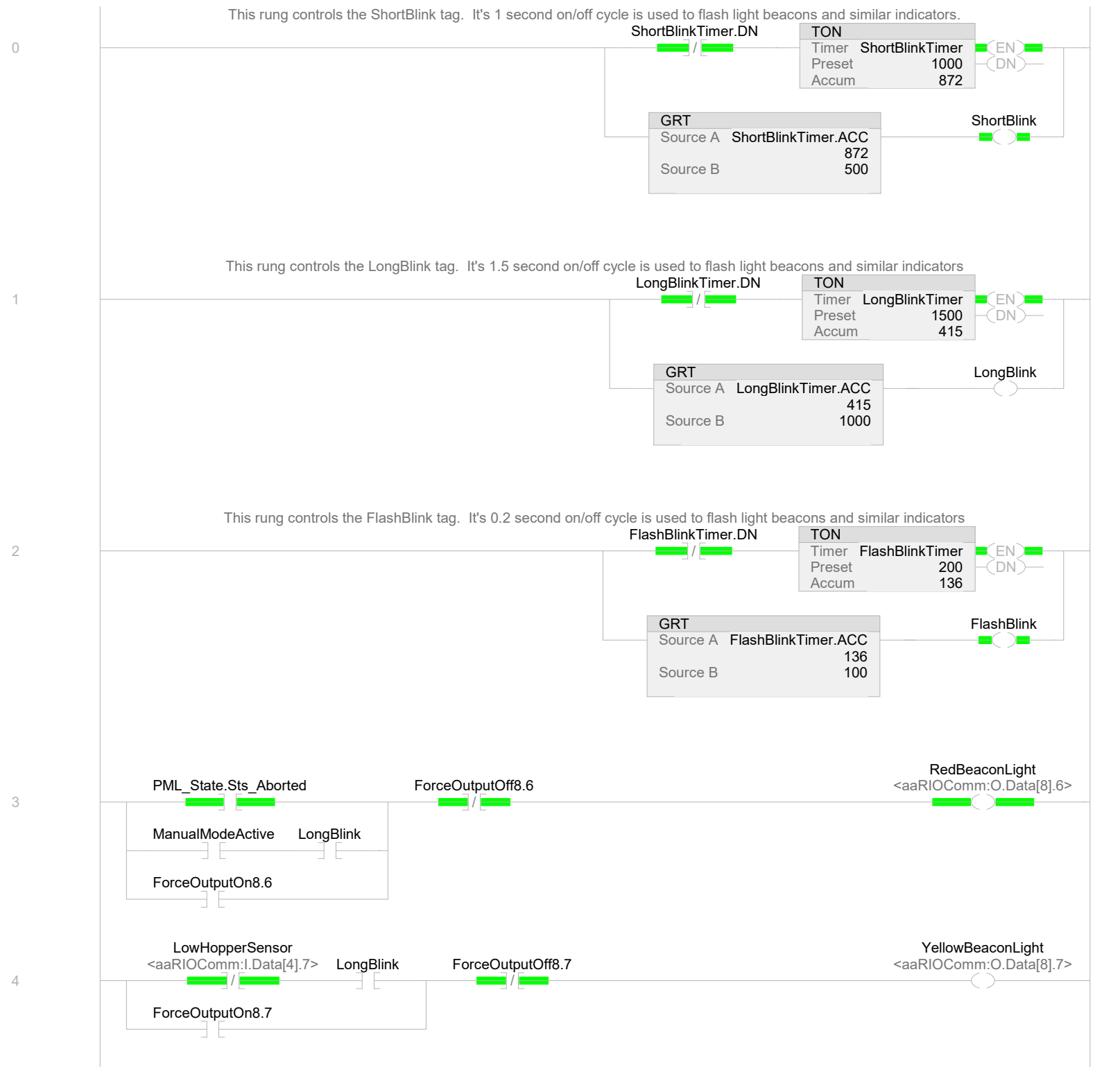


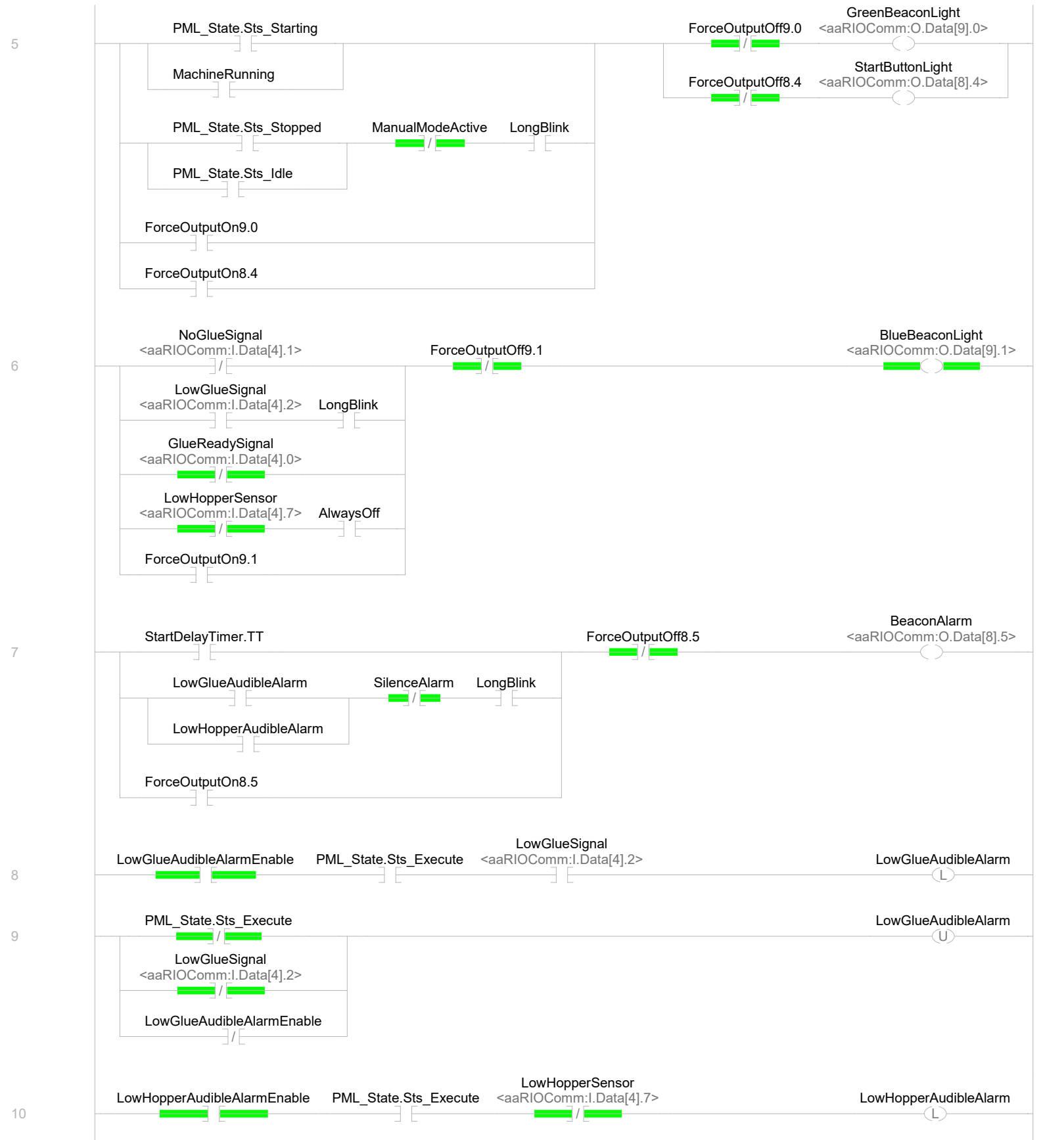
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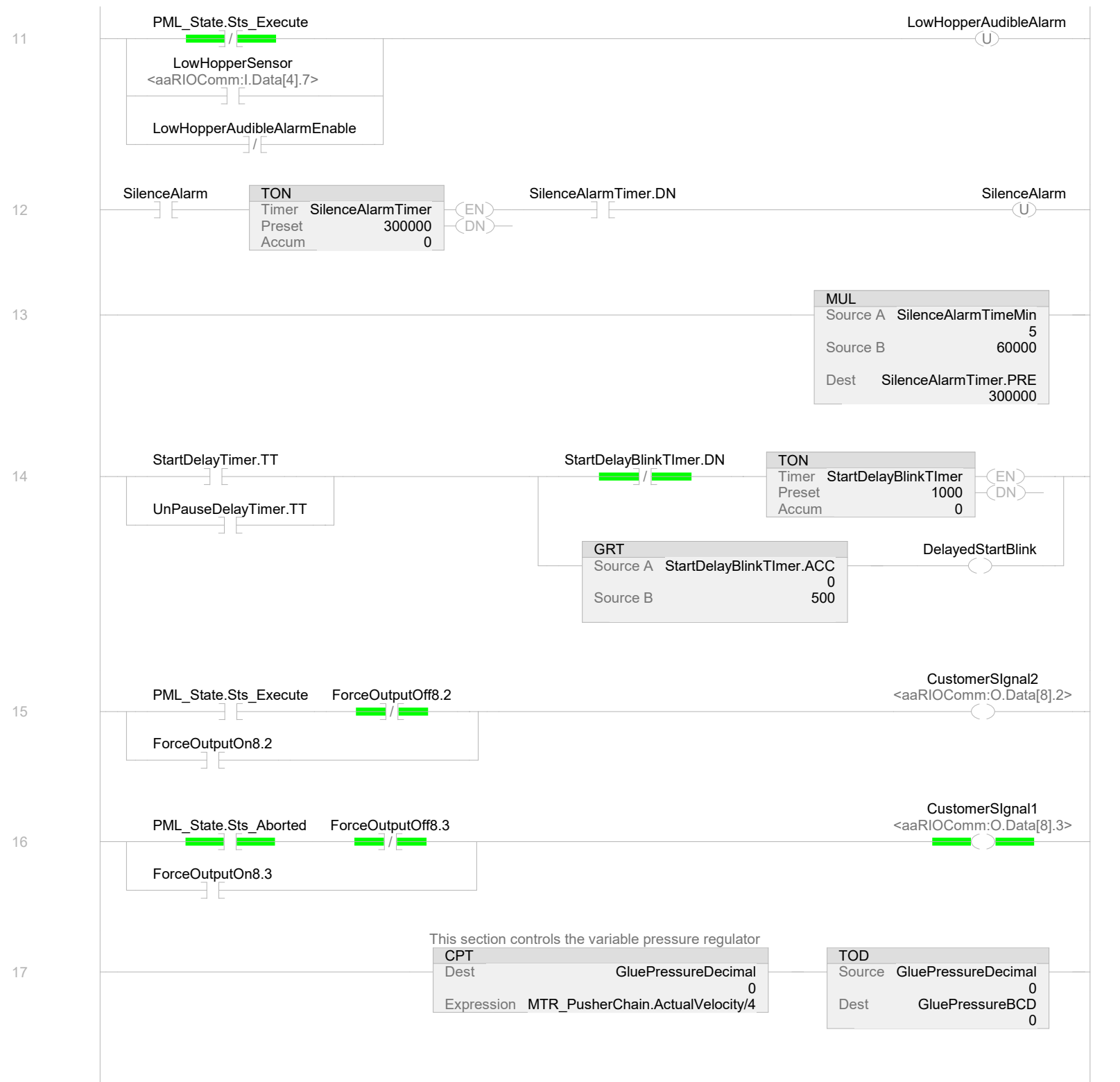
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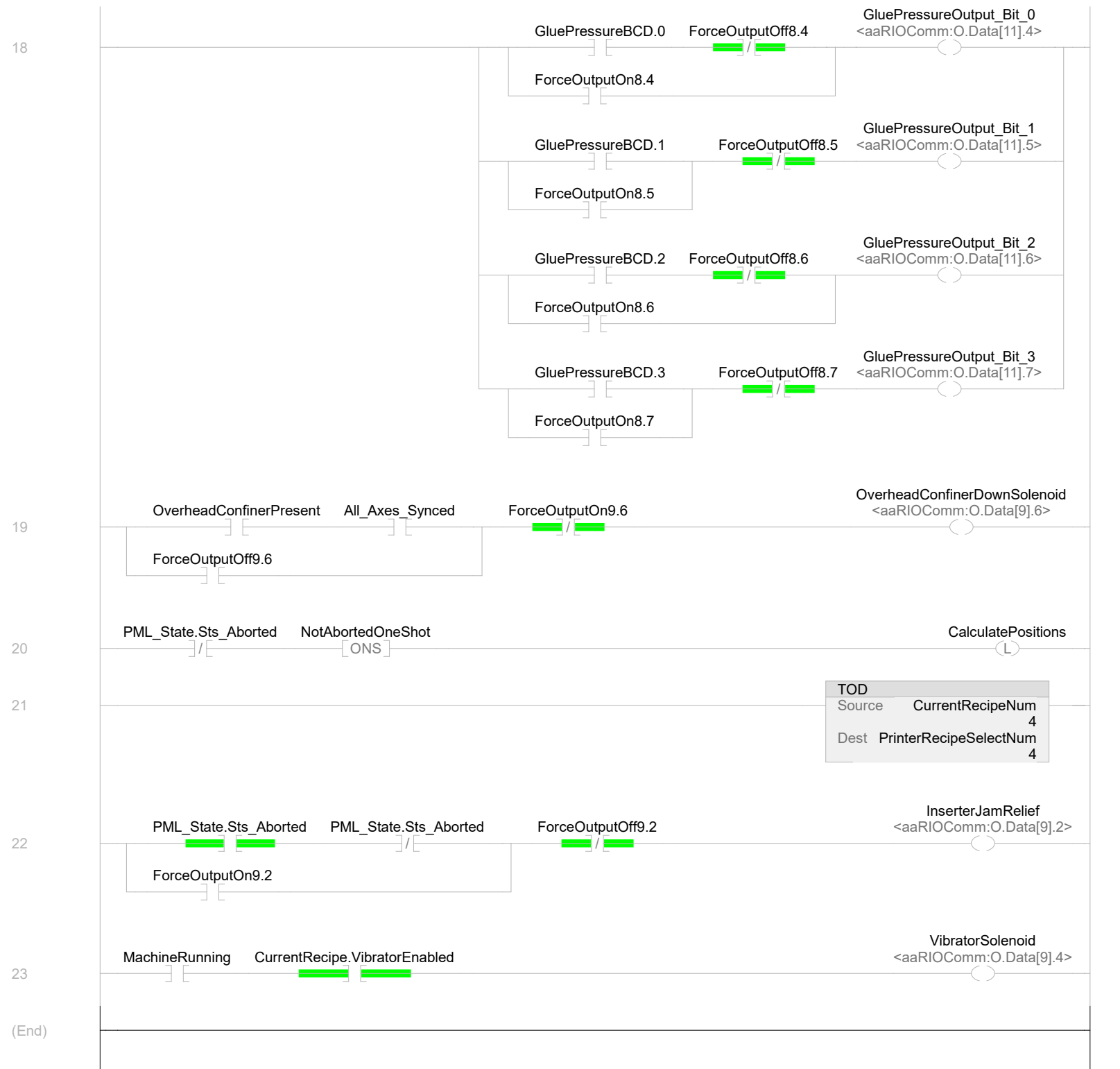


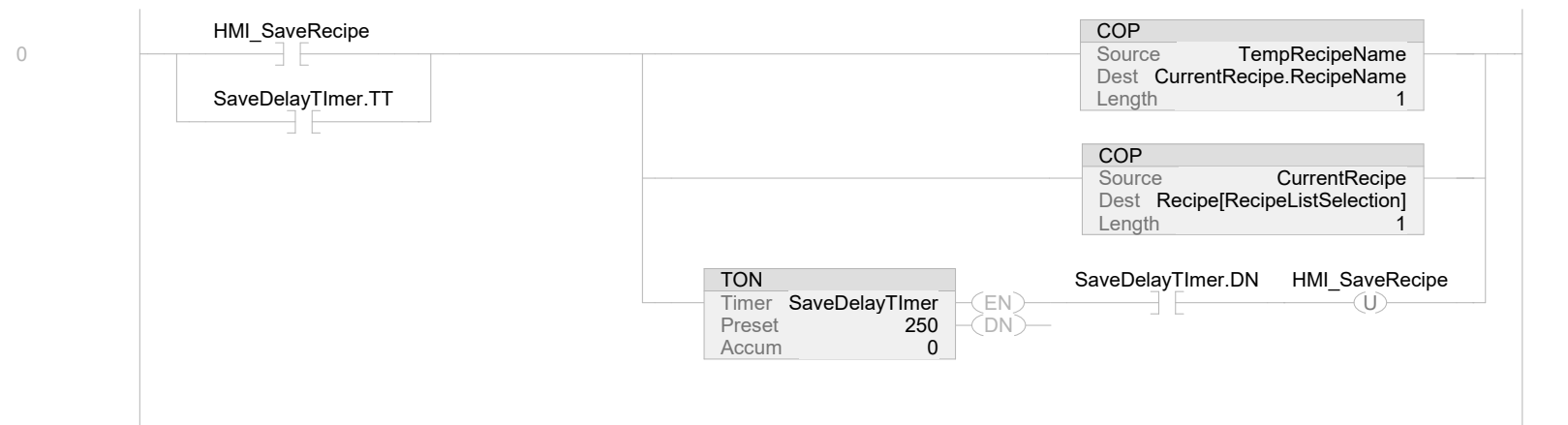
(End)

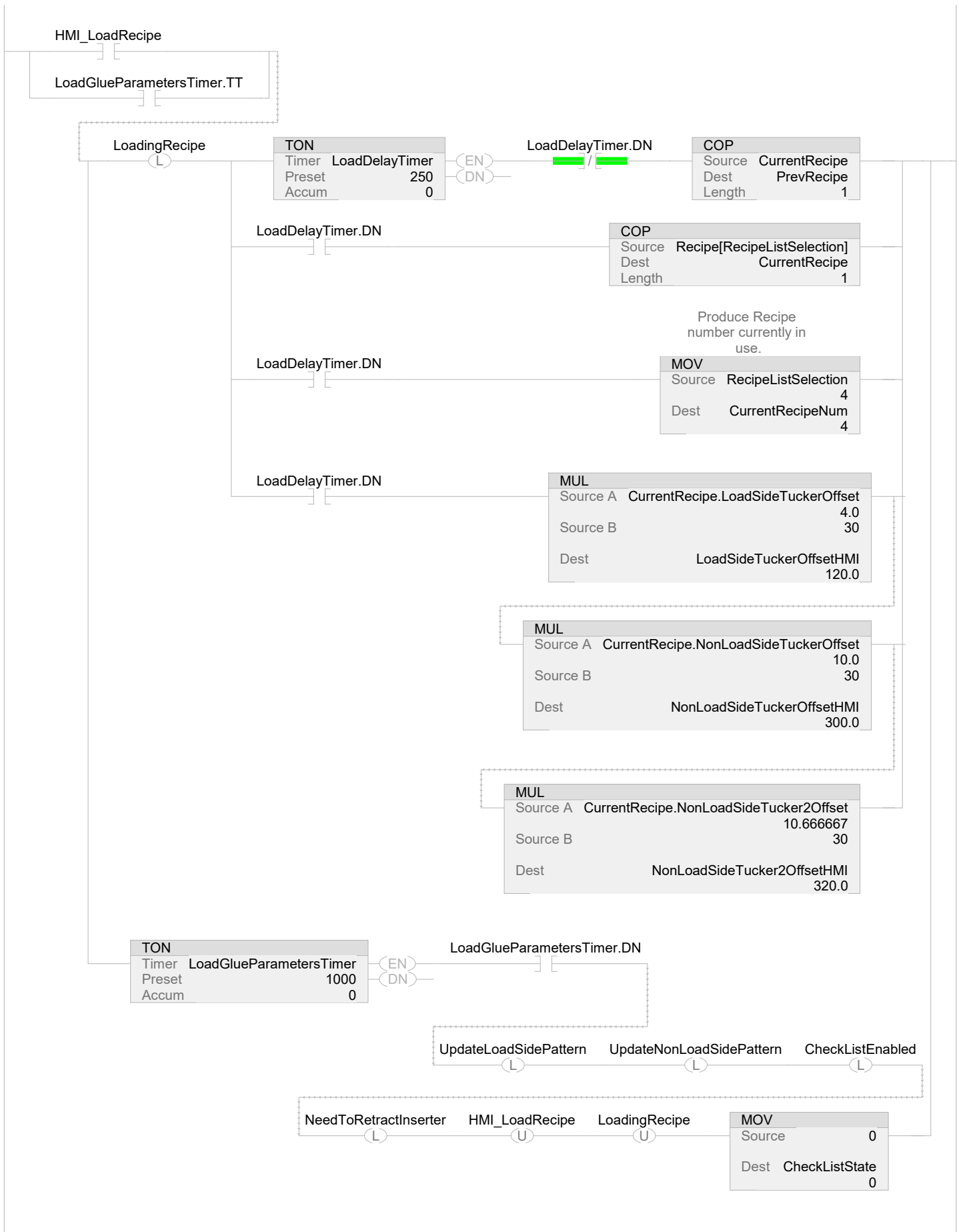


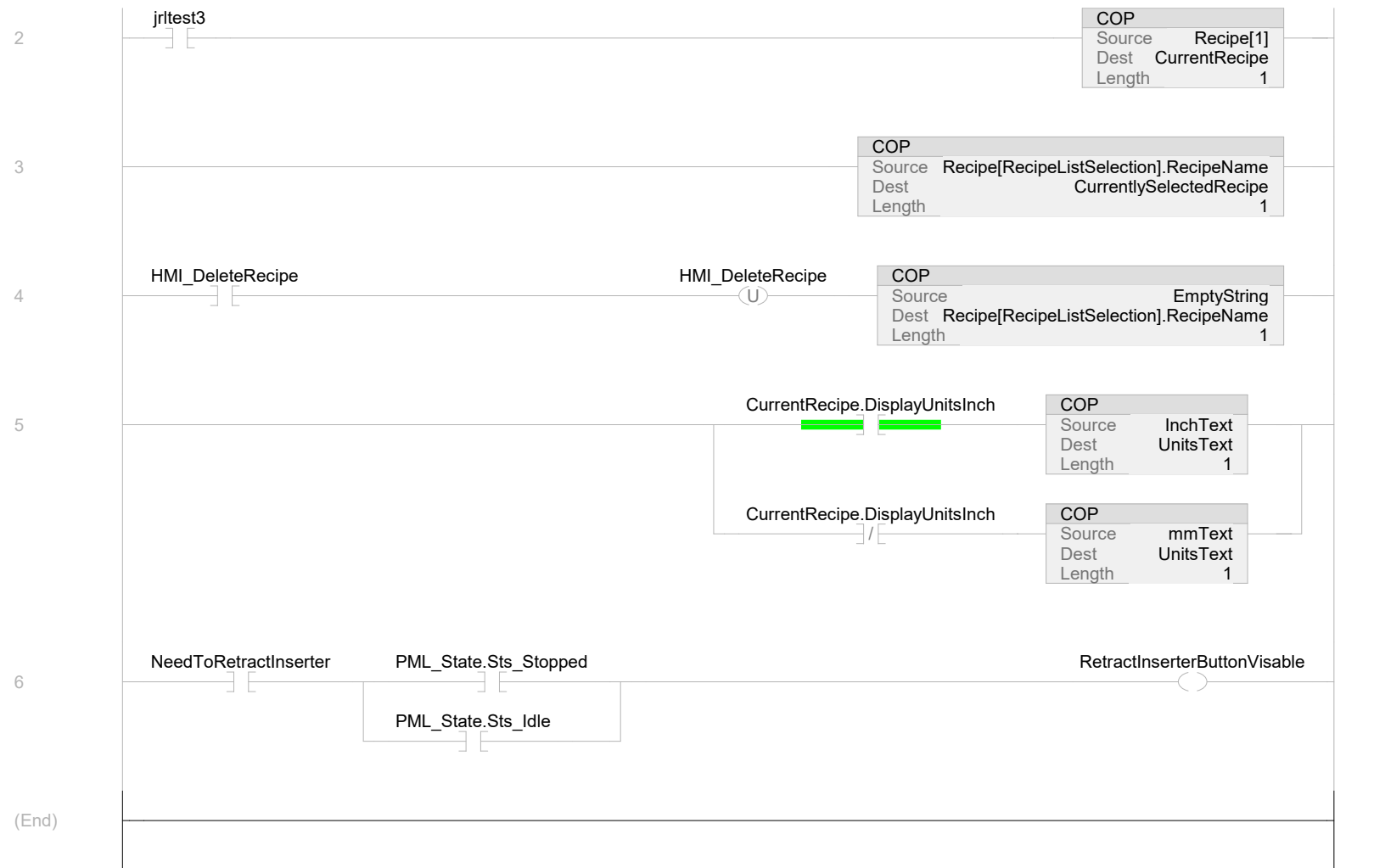


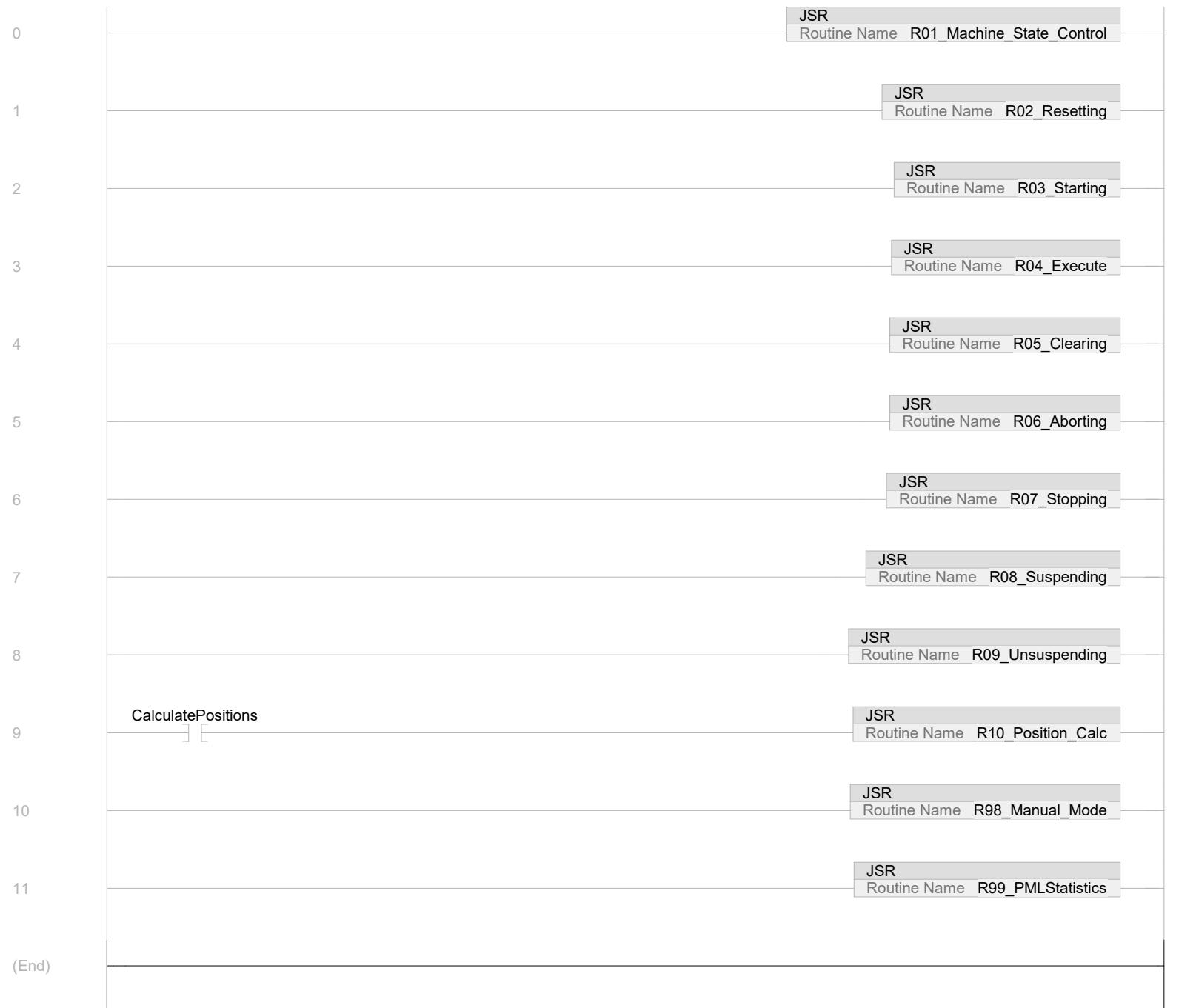




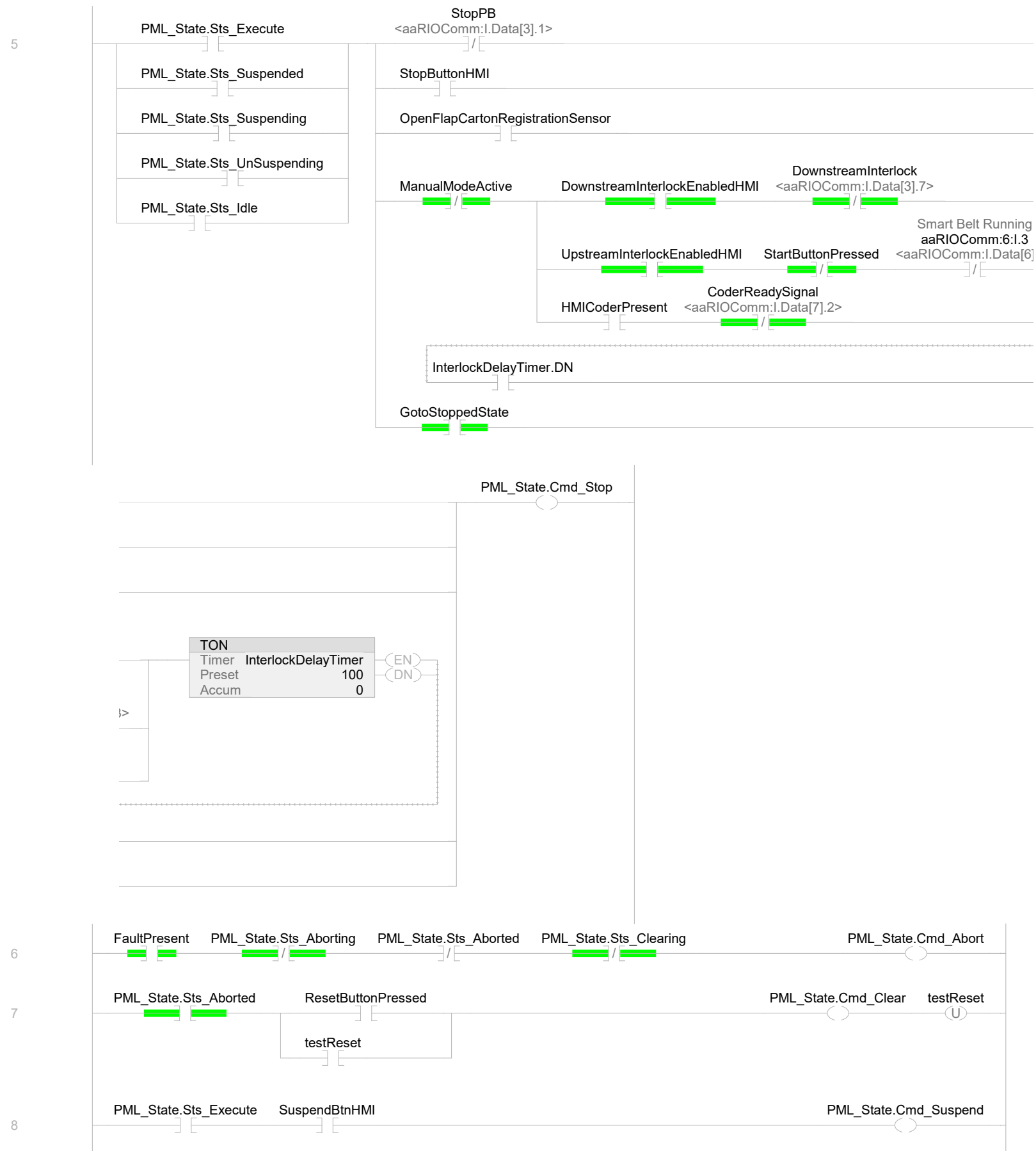




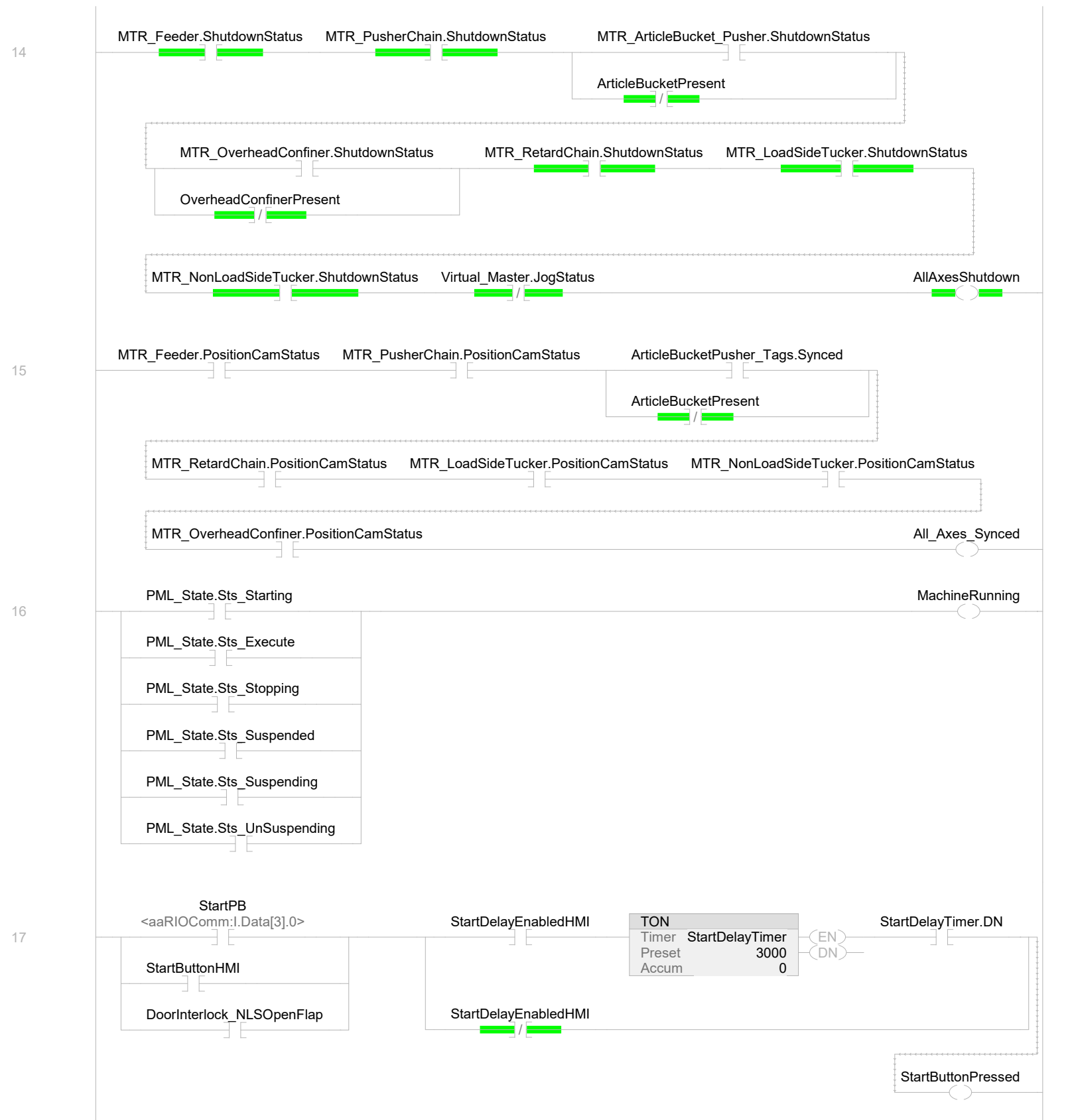




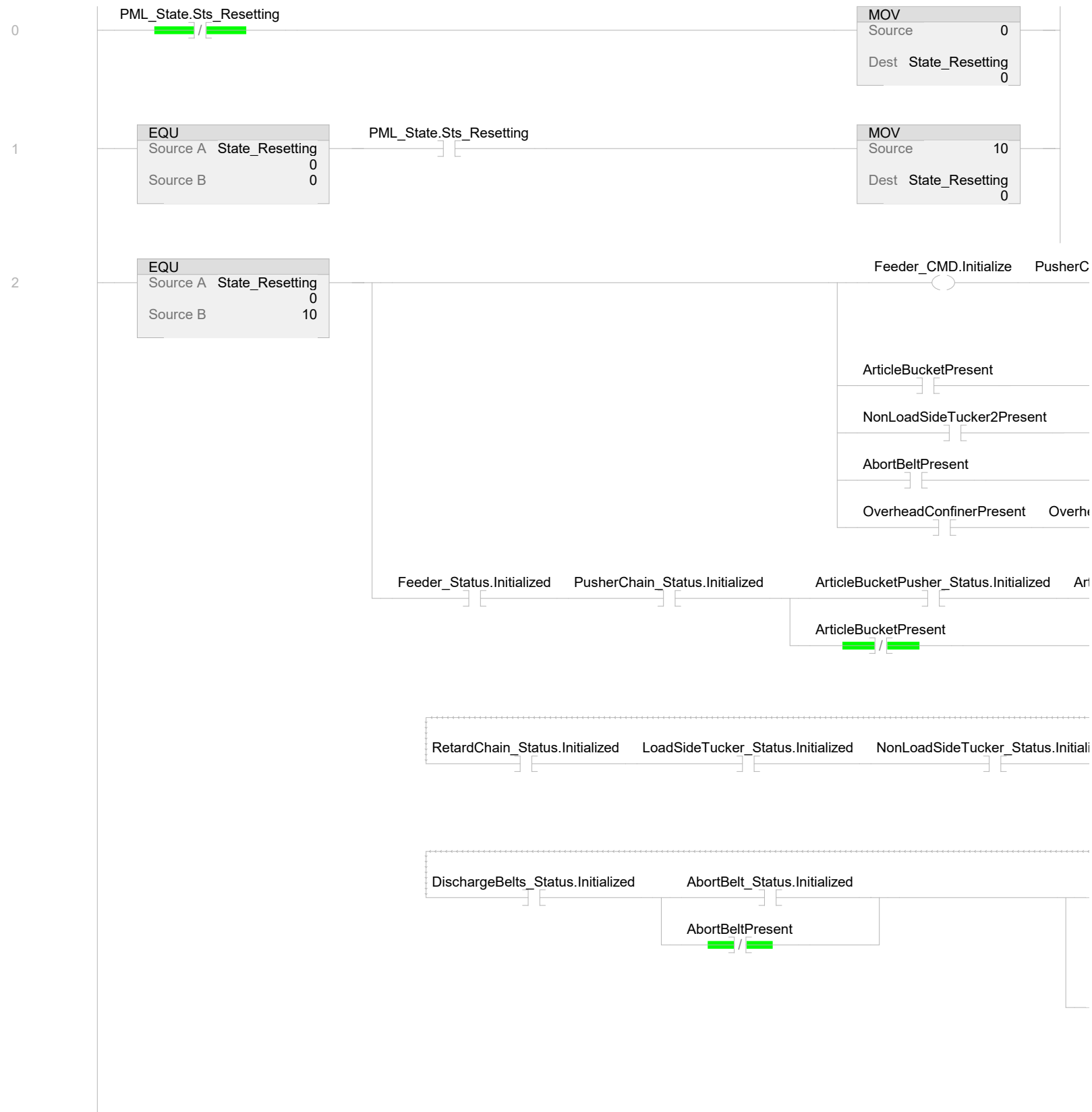


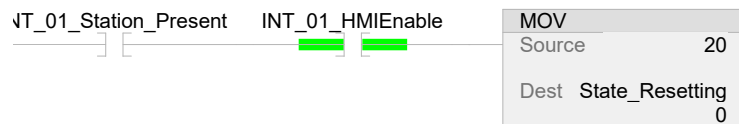
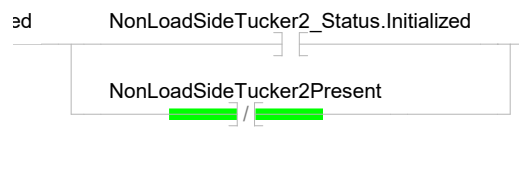
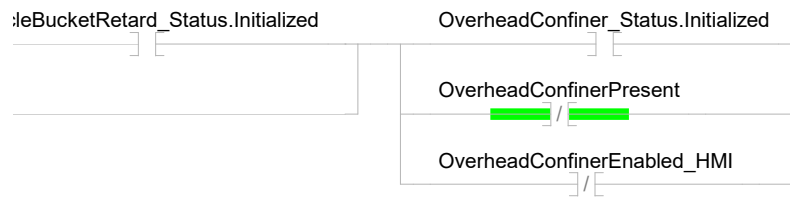
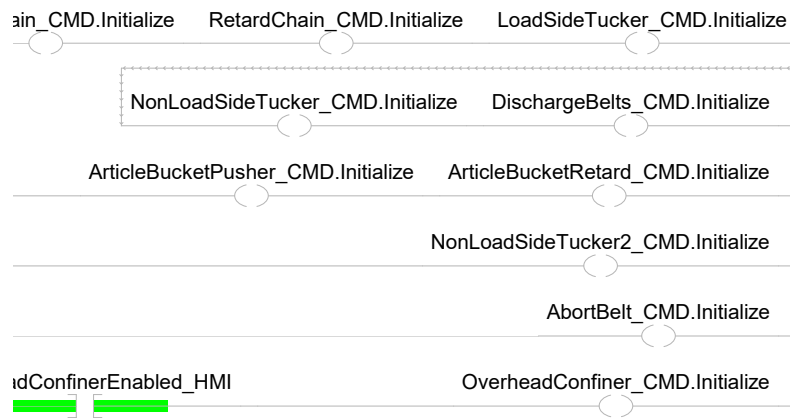




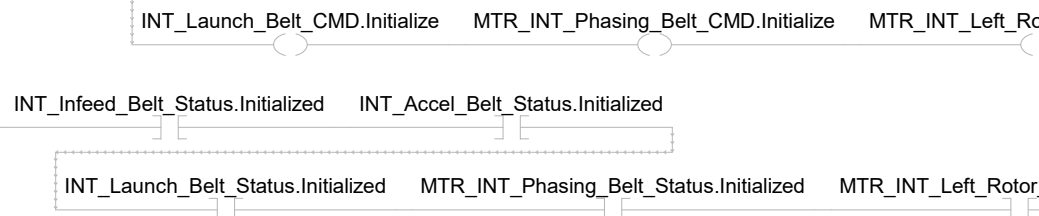




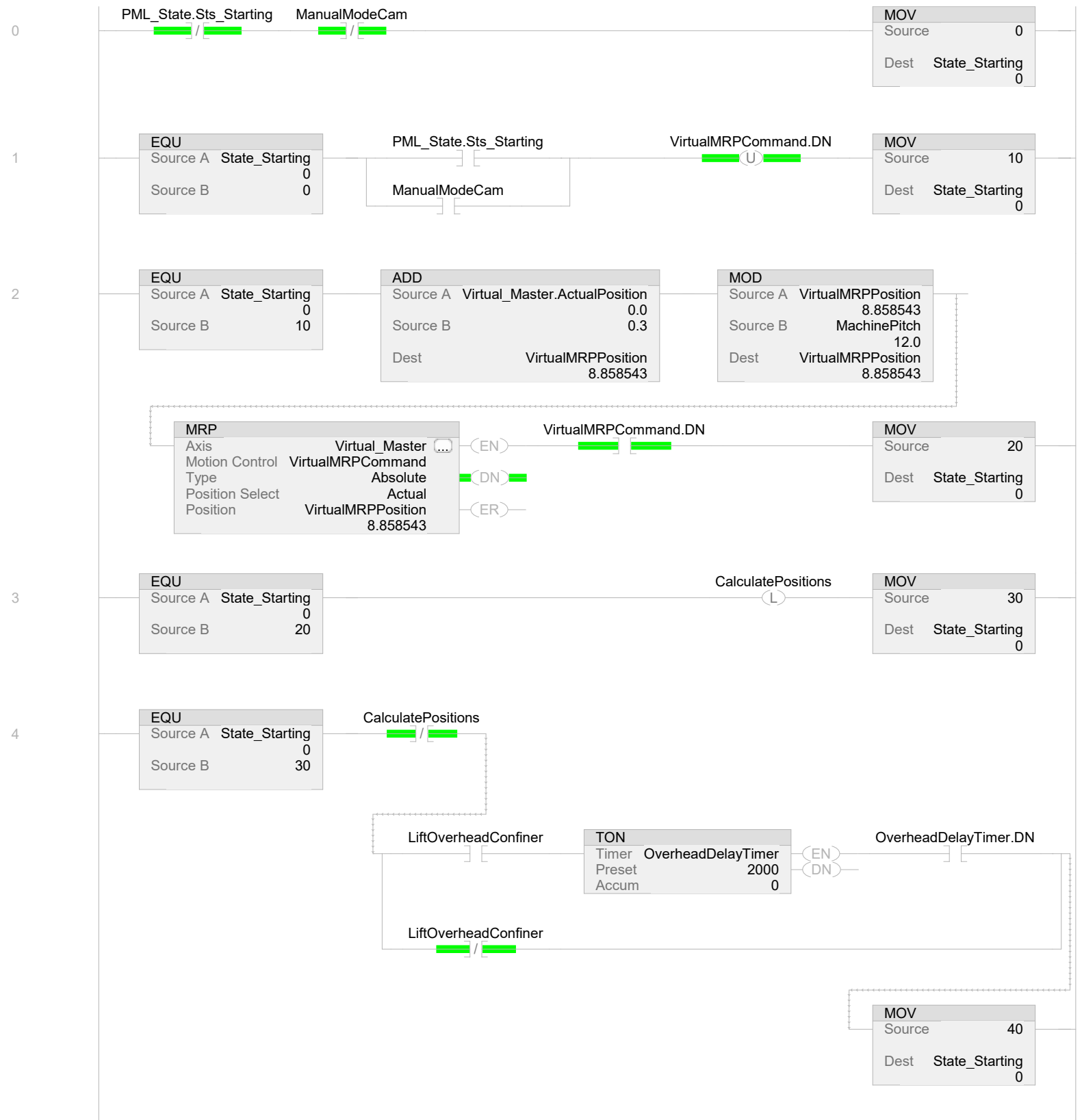


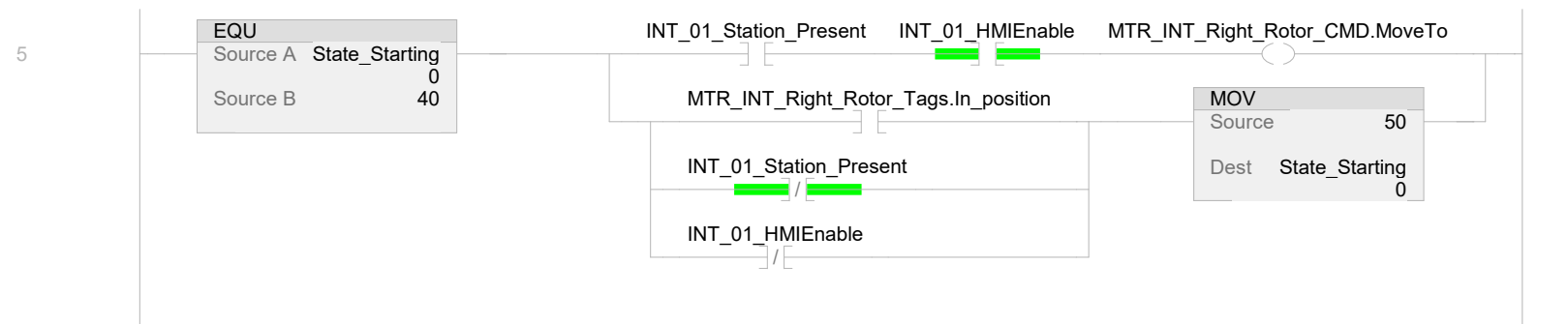


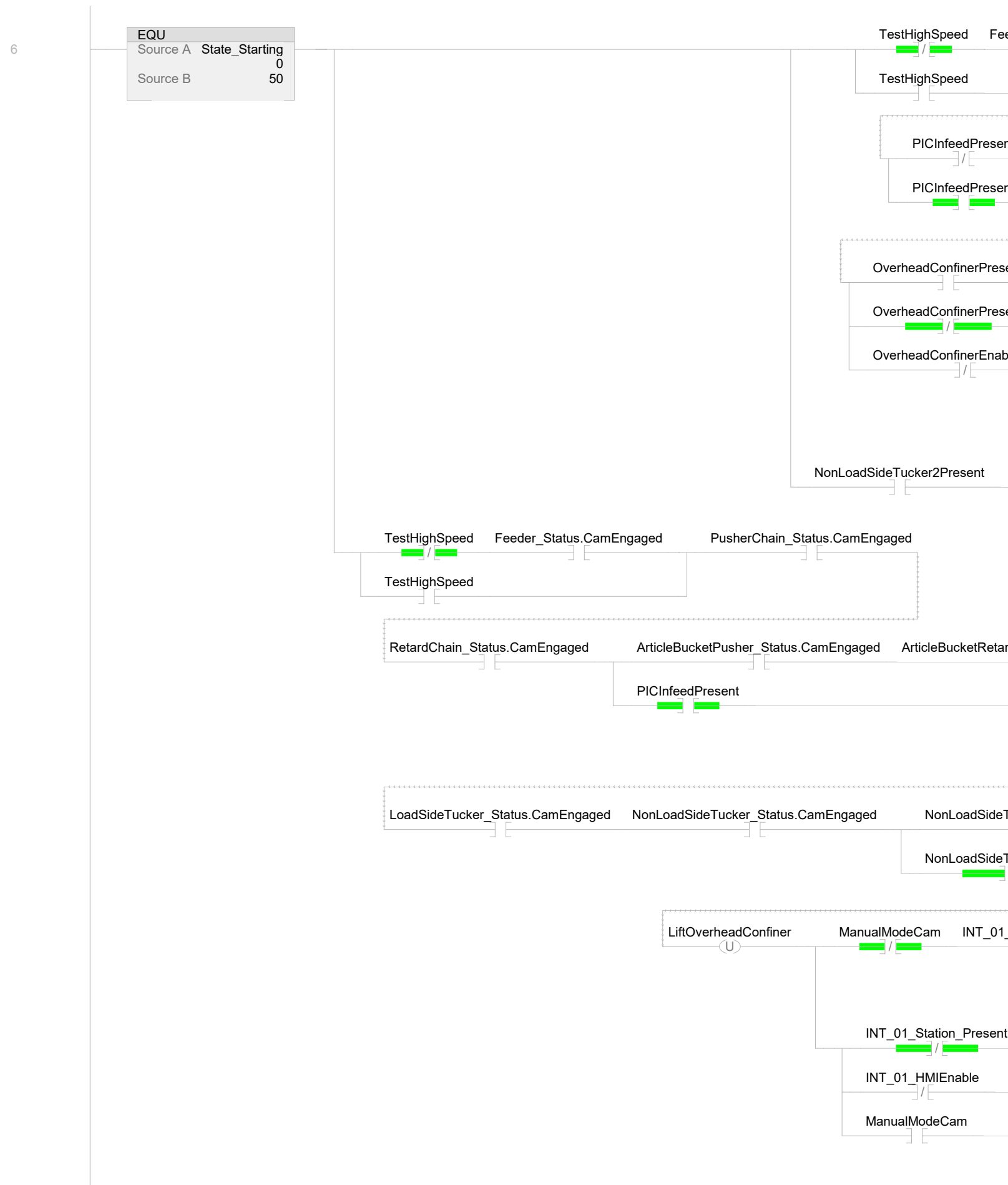
EQU	
Source A	State_Resetting
	0
Source B	20

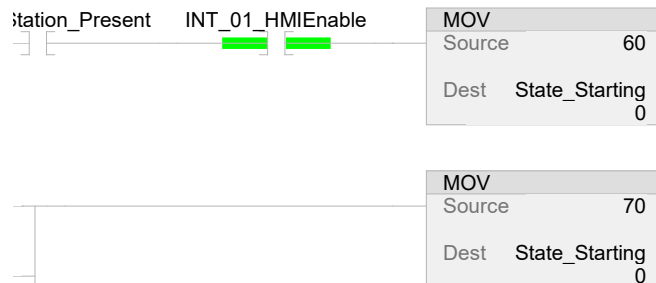
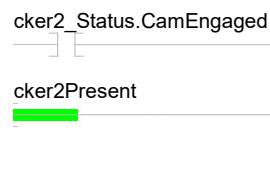
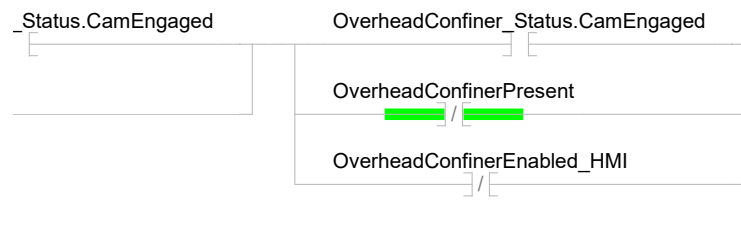
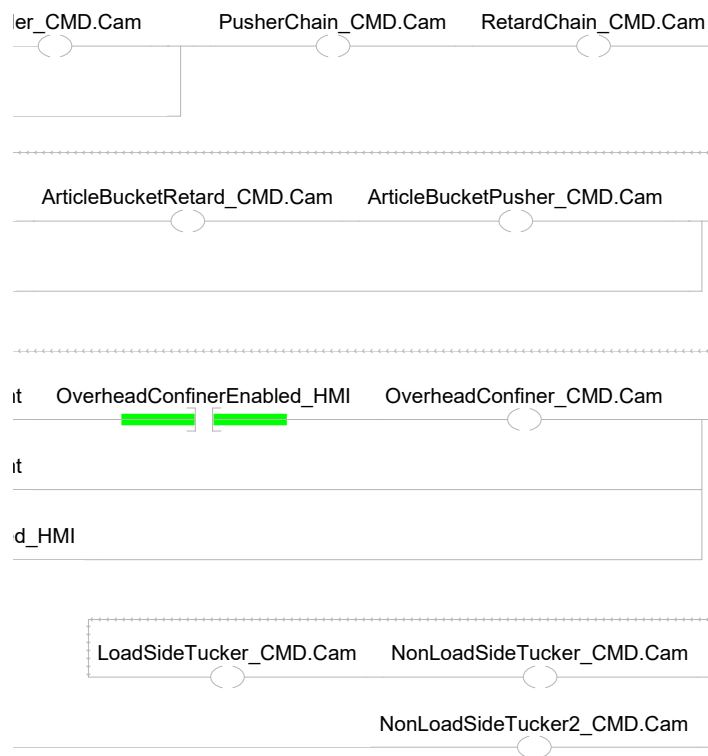


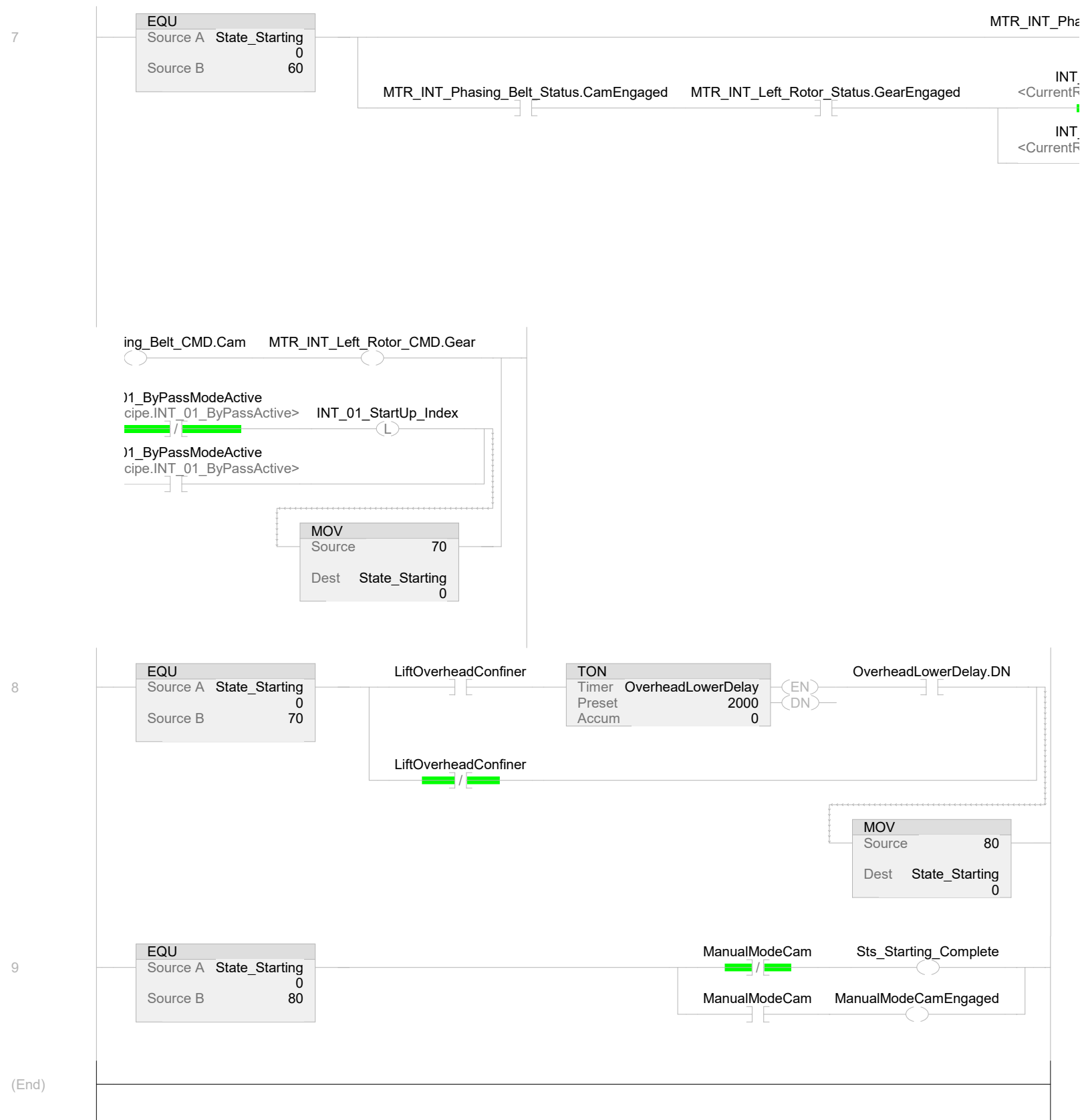


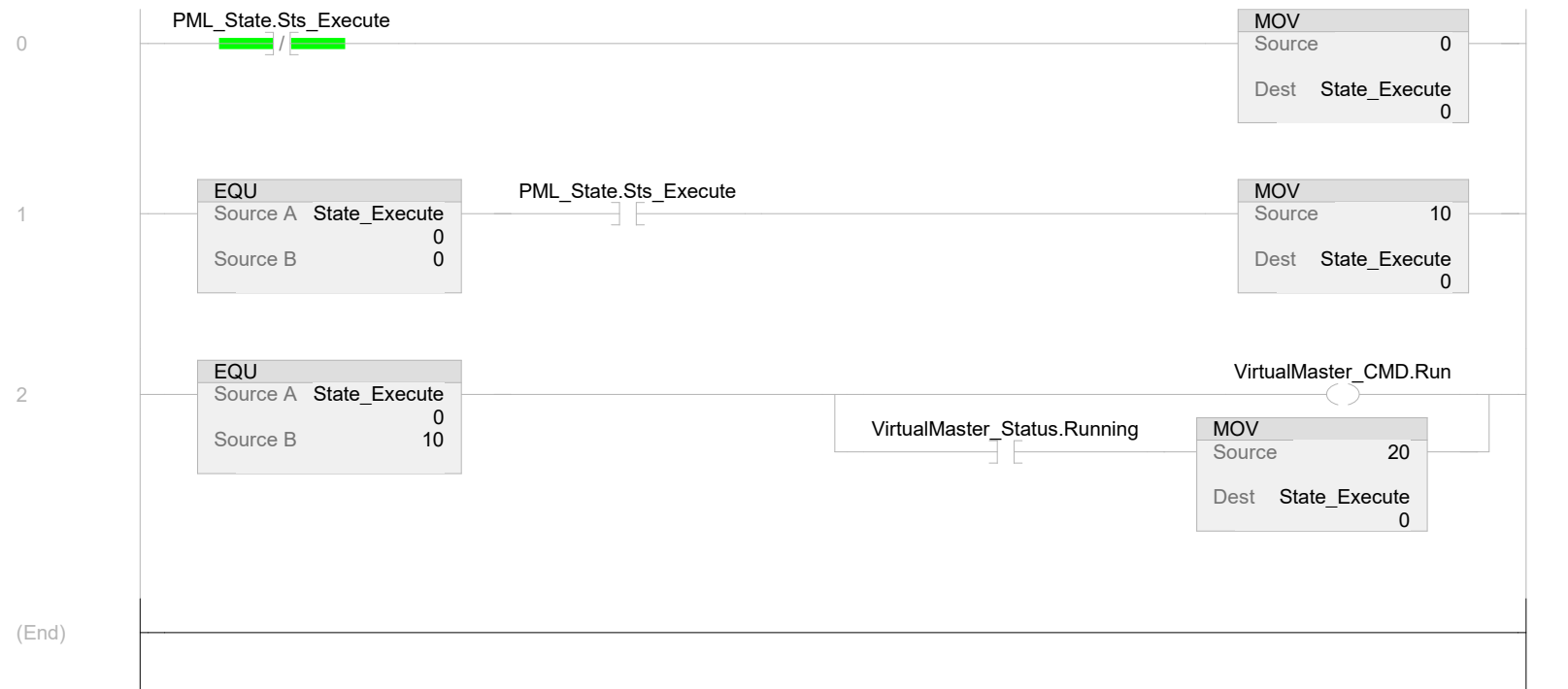


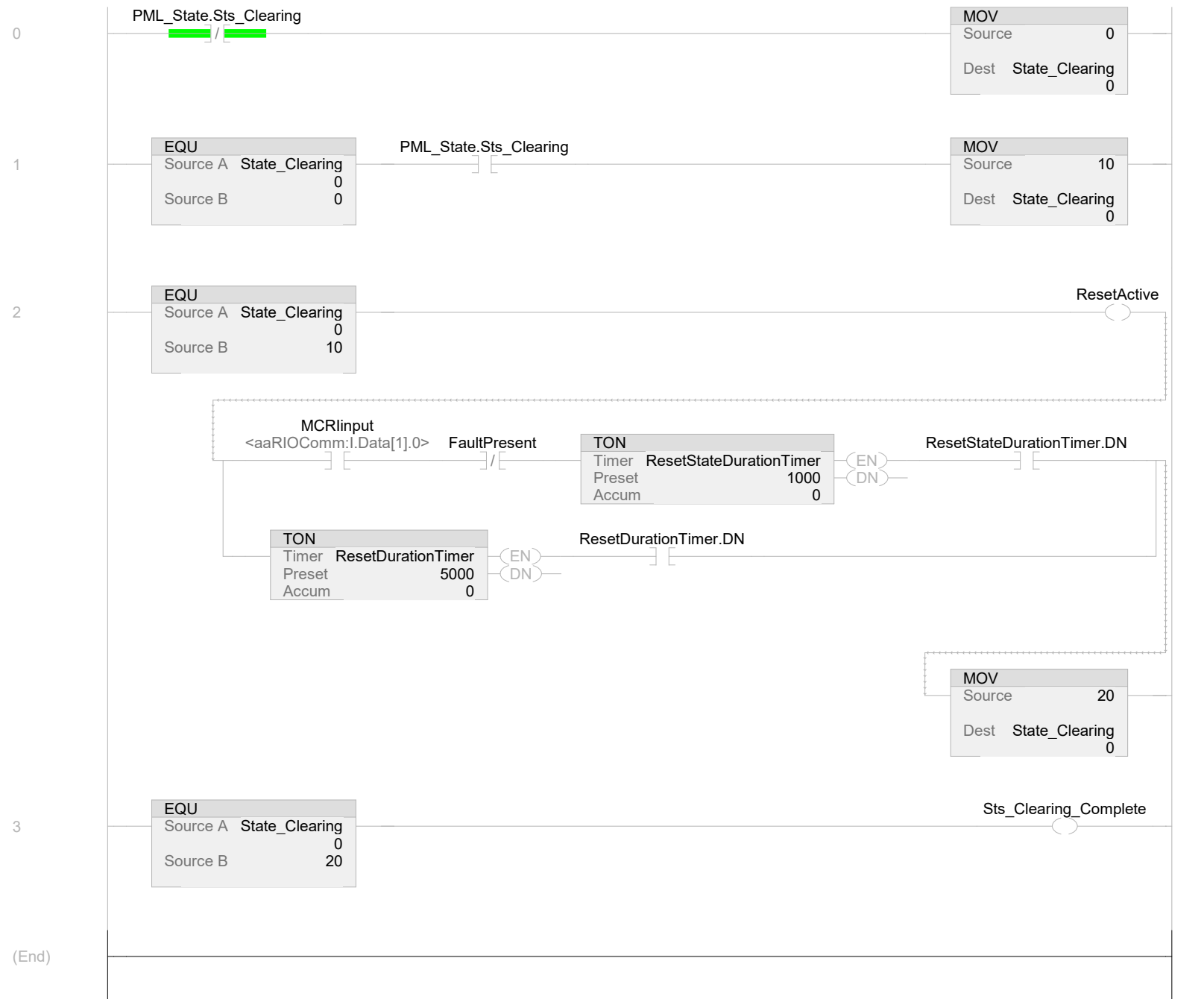


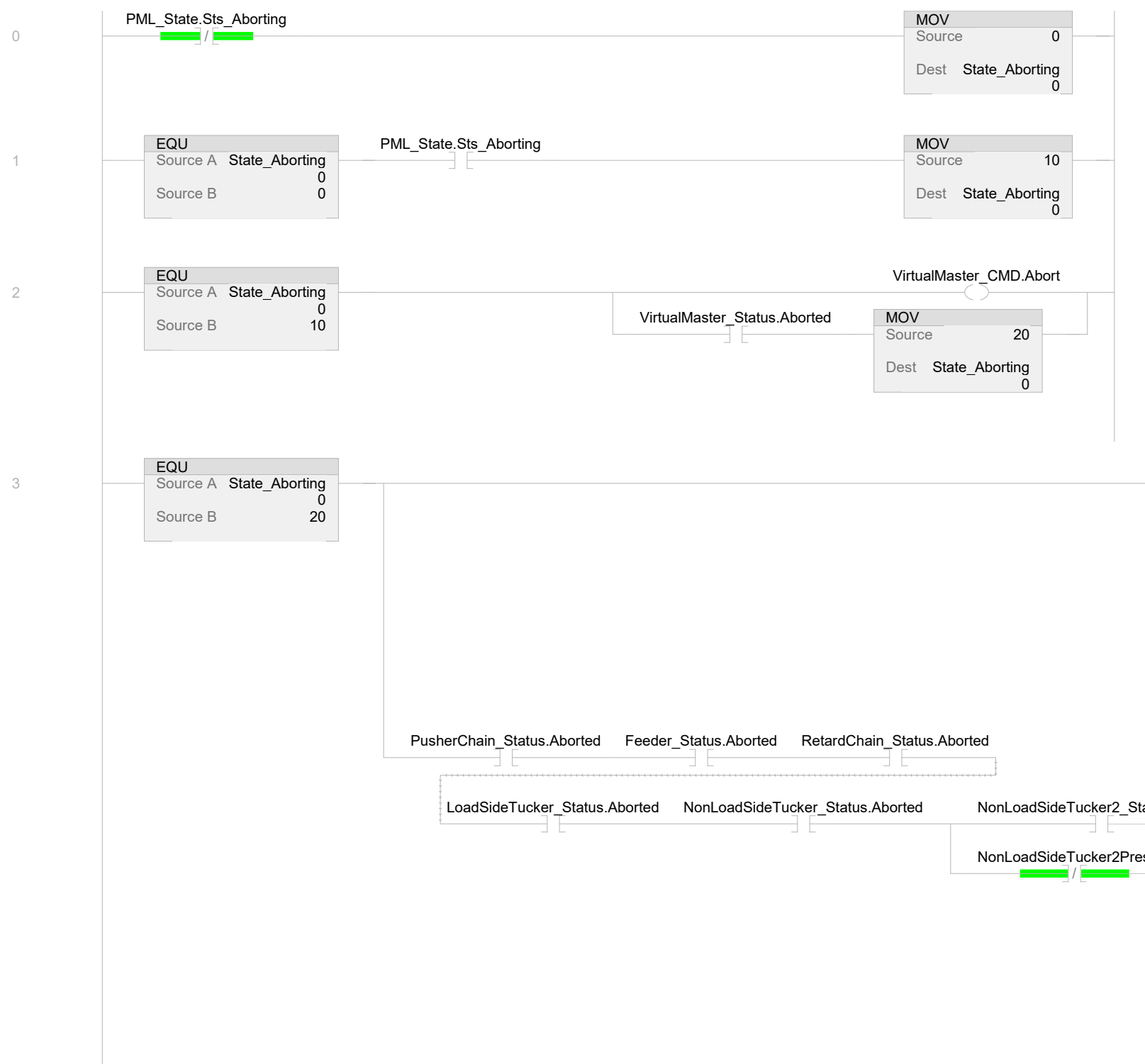


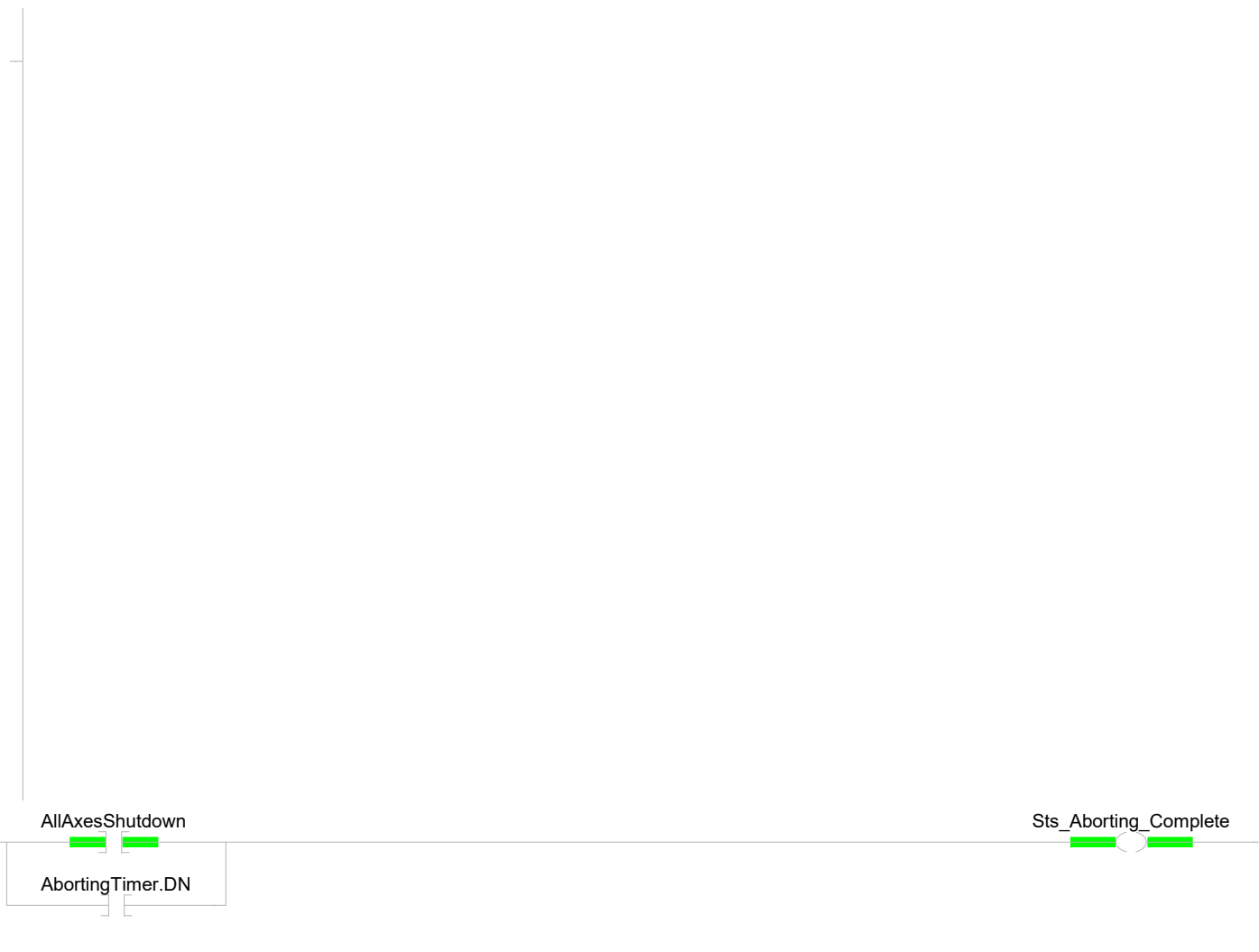
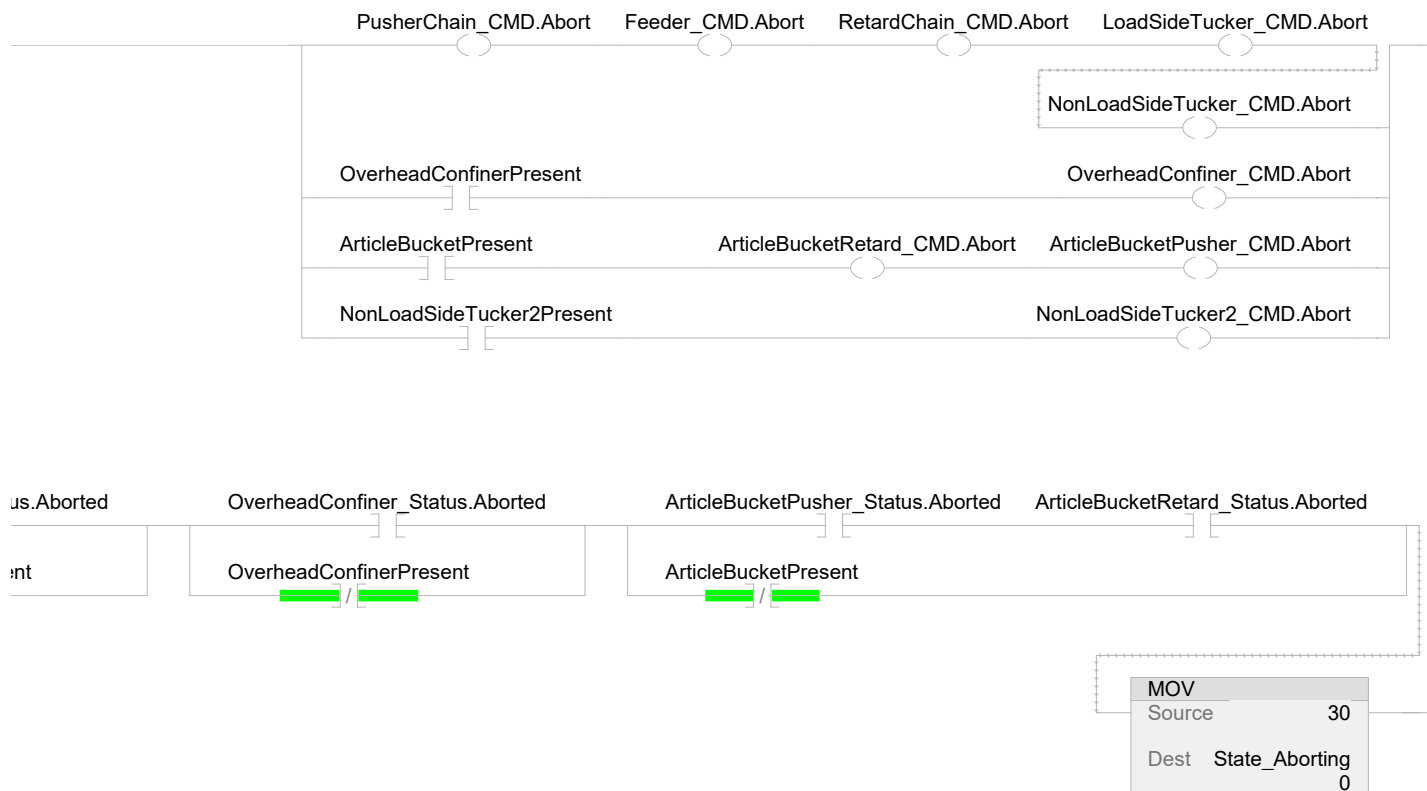




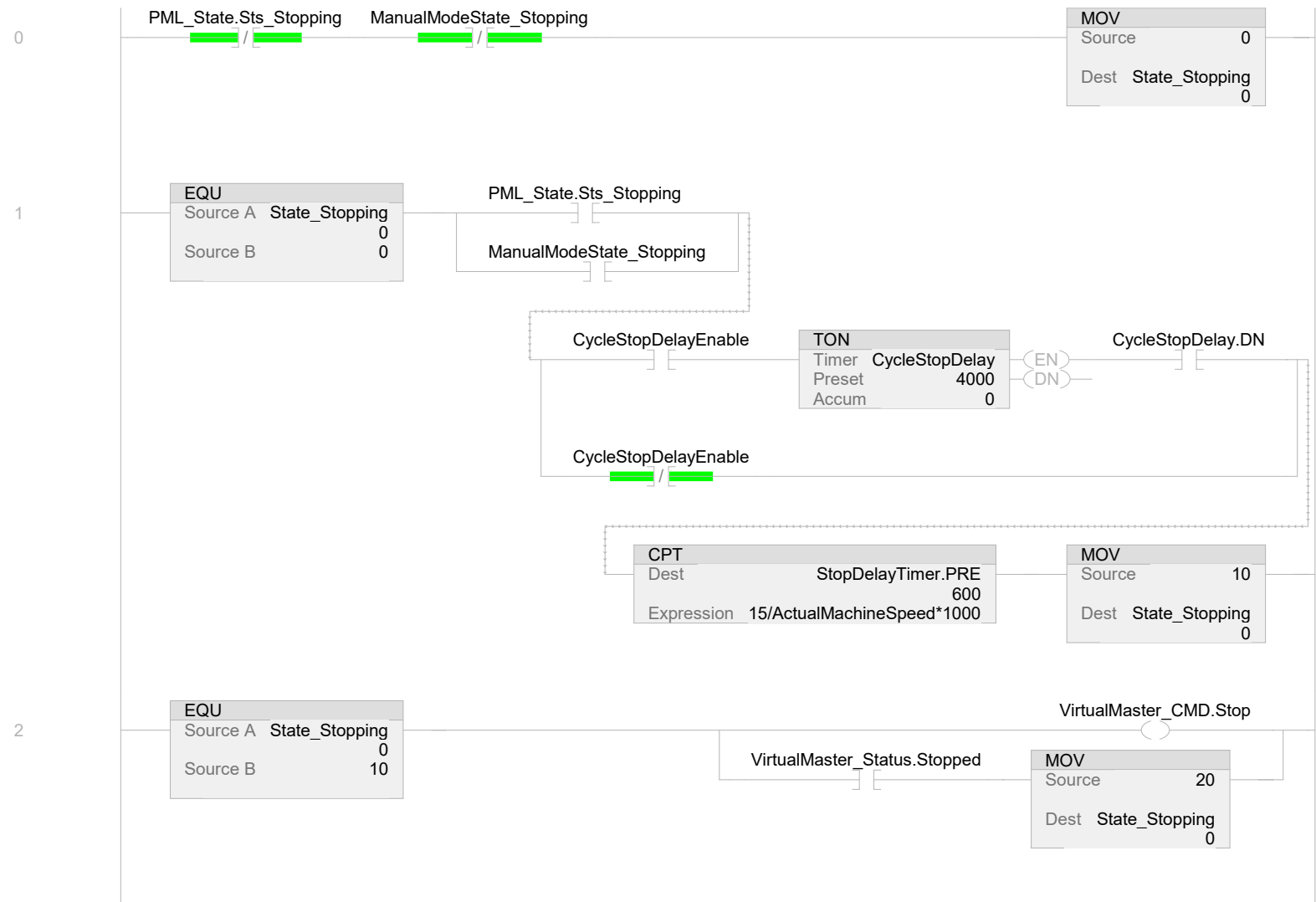












3

EQU	
Source A	State_Stopping
	0
Source B	20

Feeder_

ArticleBucketPresent

Ar

OverheadConfinerPresent

NonLoadSideTucker2Present

Feeder_Status.Stopped

ArticleBucketPusher_Status.Stopped

ArticleBucketRetard_Status.Stopped

ArticleBucketPresent

PusherChain_Status.Stopped

RetardChain_Status.Stopped

LoadSideTucker_Status.Stopped

NonLoadSideTucker_Status.Stopped

NonLoadSideTucker2_S

NonLoadSideTucker2Pr

NonLoadSideTucker2Pr

NonLoadSideTucker2Pr

NonLoadSideTucker2Pr

NonLoadSideTucker2Pr

NonLoadSideTucker2Pr

NonLoadSideTucker2Pr

NonLoadSideTucker2Pr

NonLoadSideTucker2Pr

NonLoadSideTucker2Pr

NonLoadSideTucker2Pr

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NonLoadSideTucker2Pr

NonLoadSideTucker2Pr

NonLoadSideTucker2Pr

NonLoadSideTucker2Pr

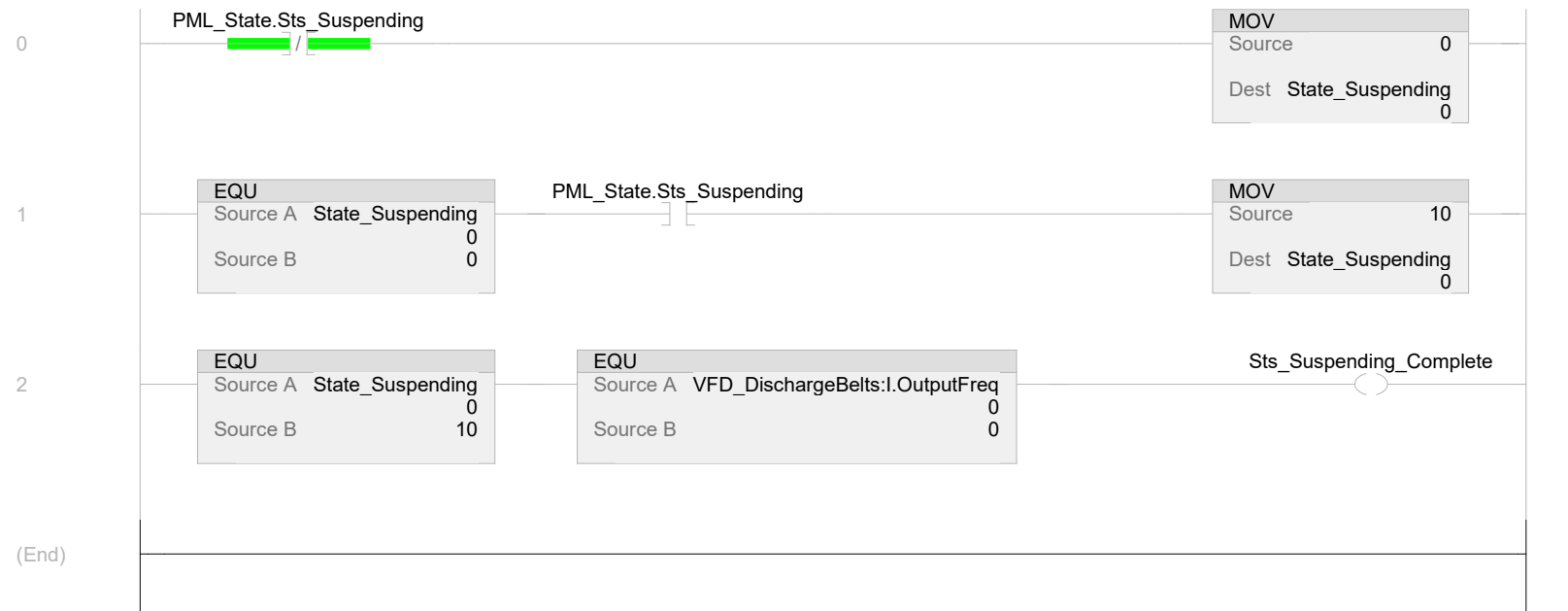
NonLoadSideTucker2Pr

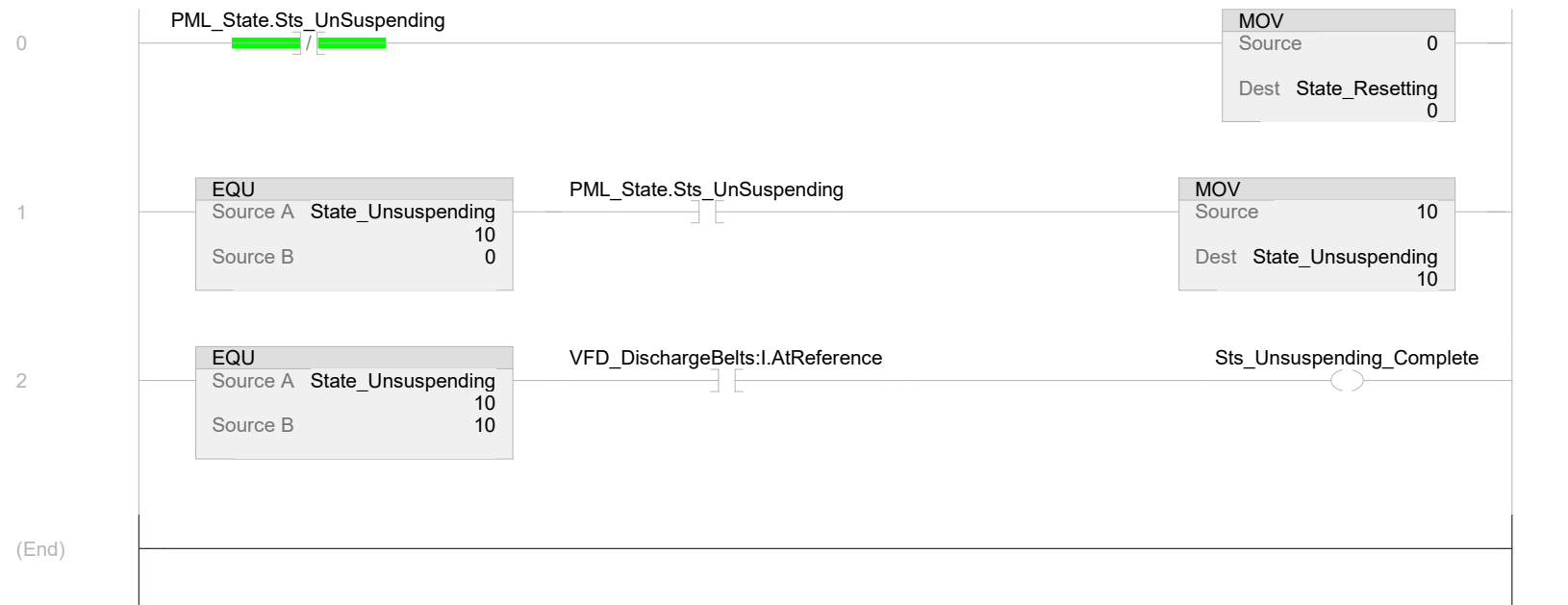
NonLoadSideTucker2Pr

NonLoadSideTucker2Pr

NonLoadSideTucker2Pr



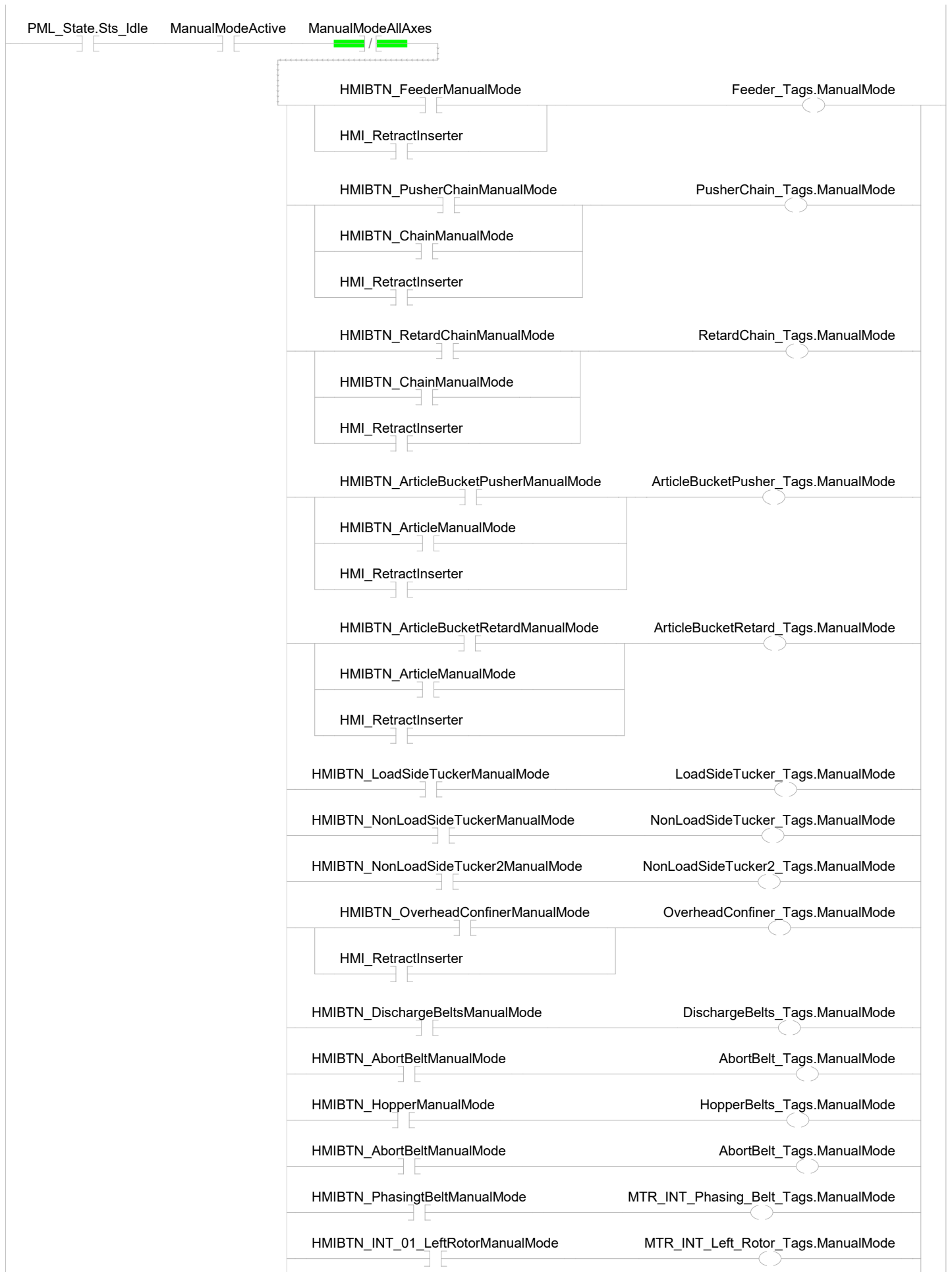


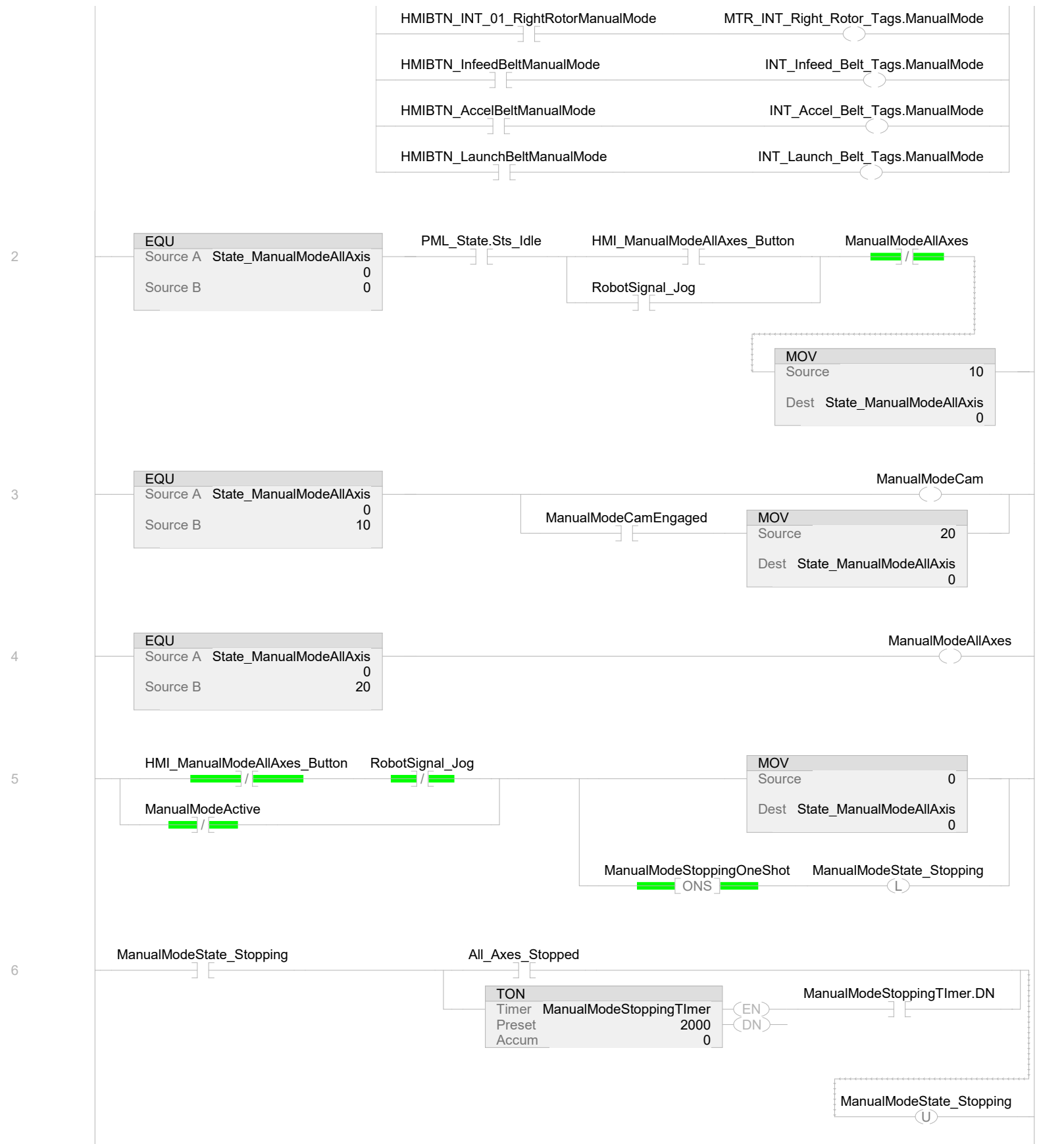


Unable to print the Routine: Language support not installed

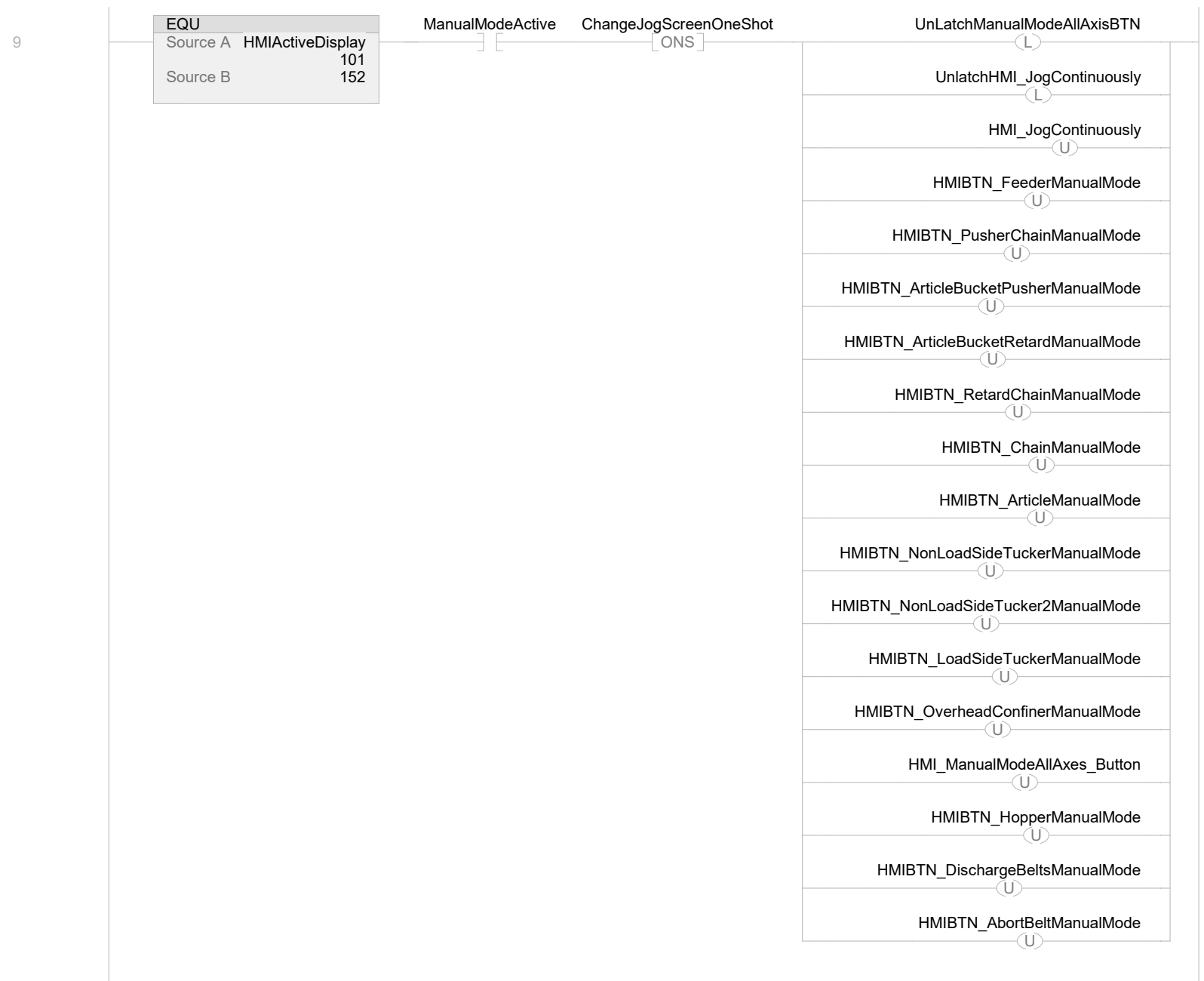


1

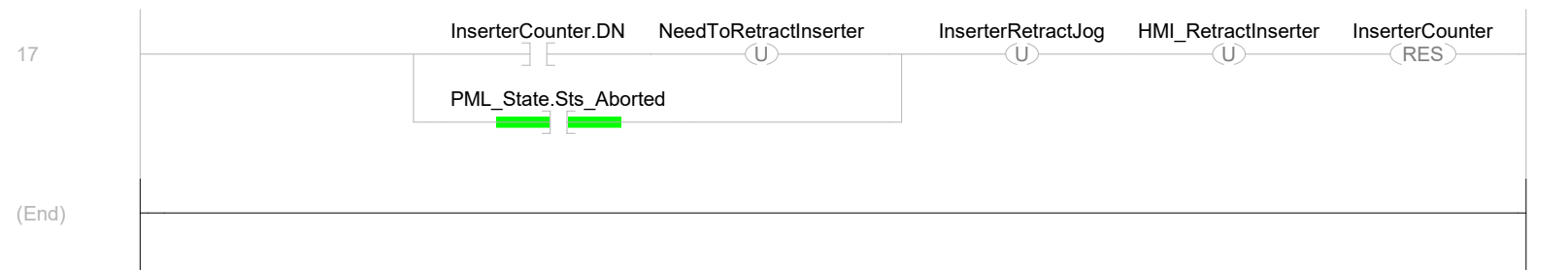


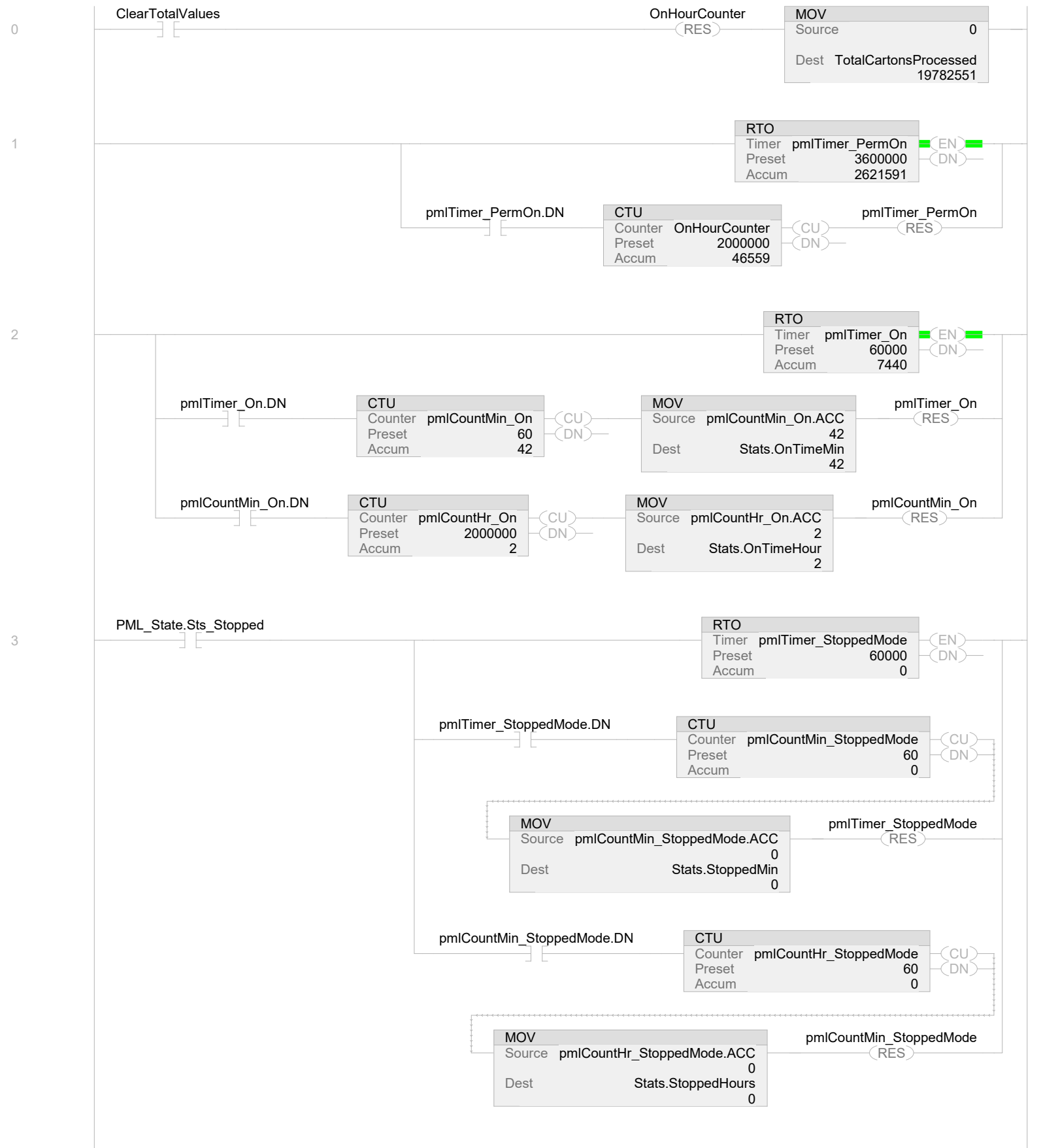


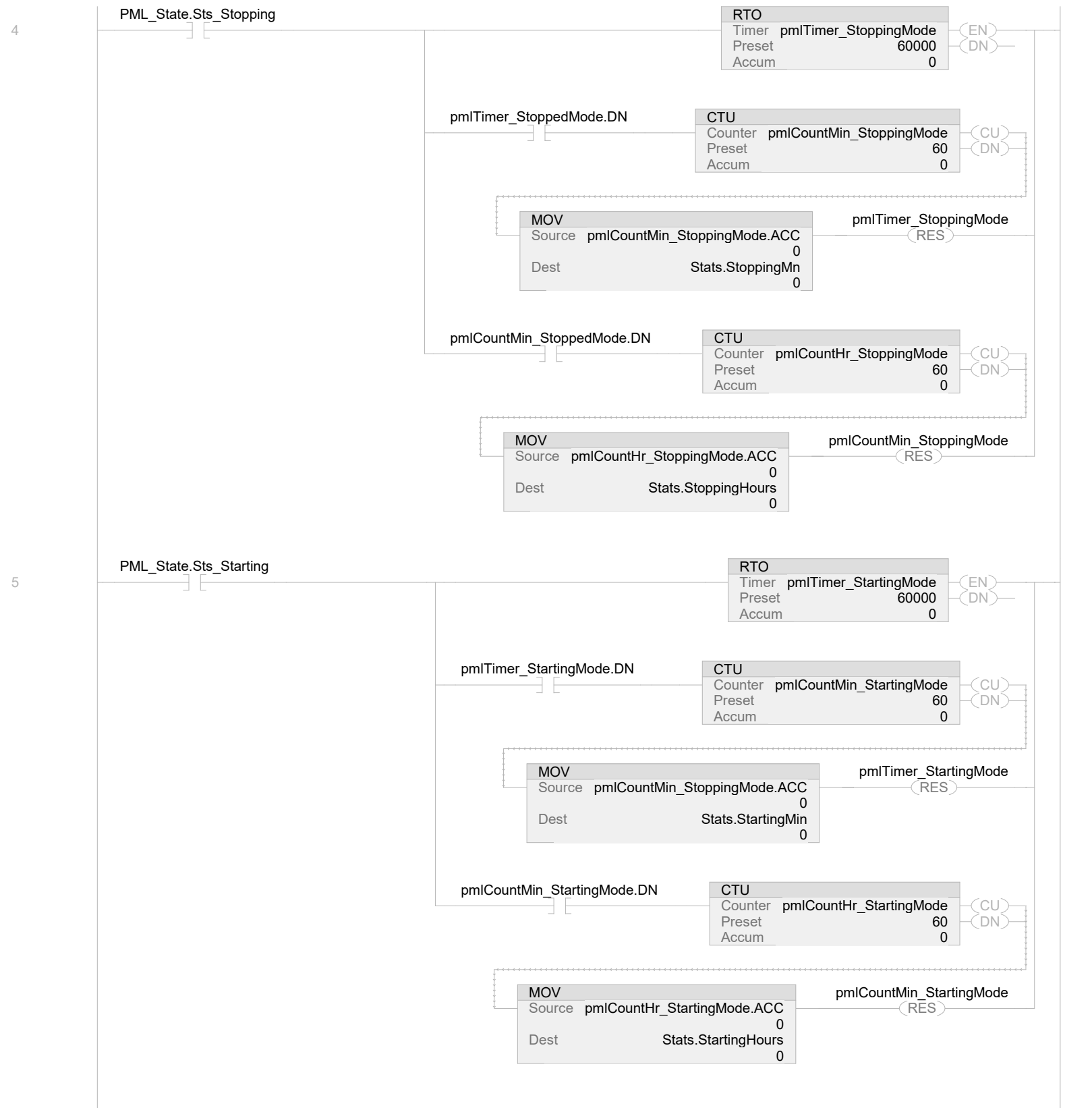


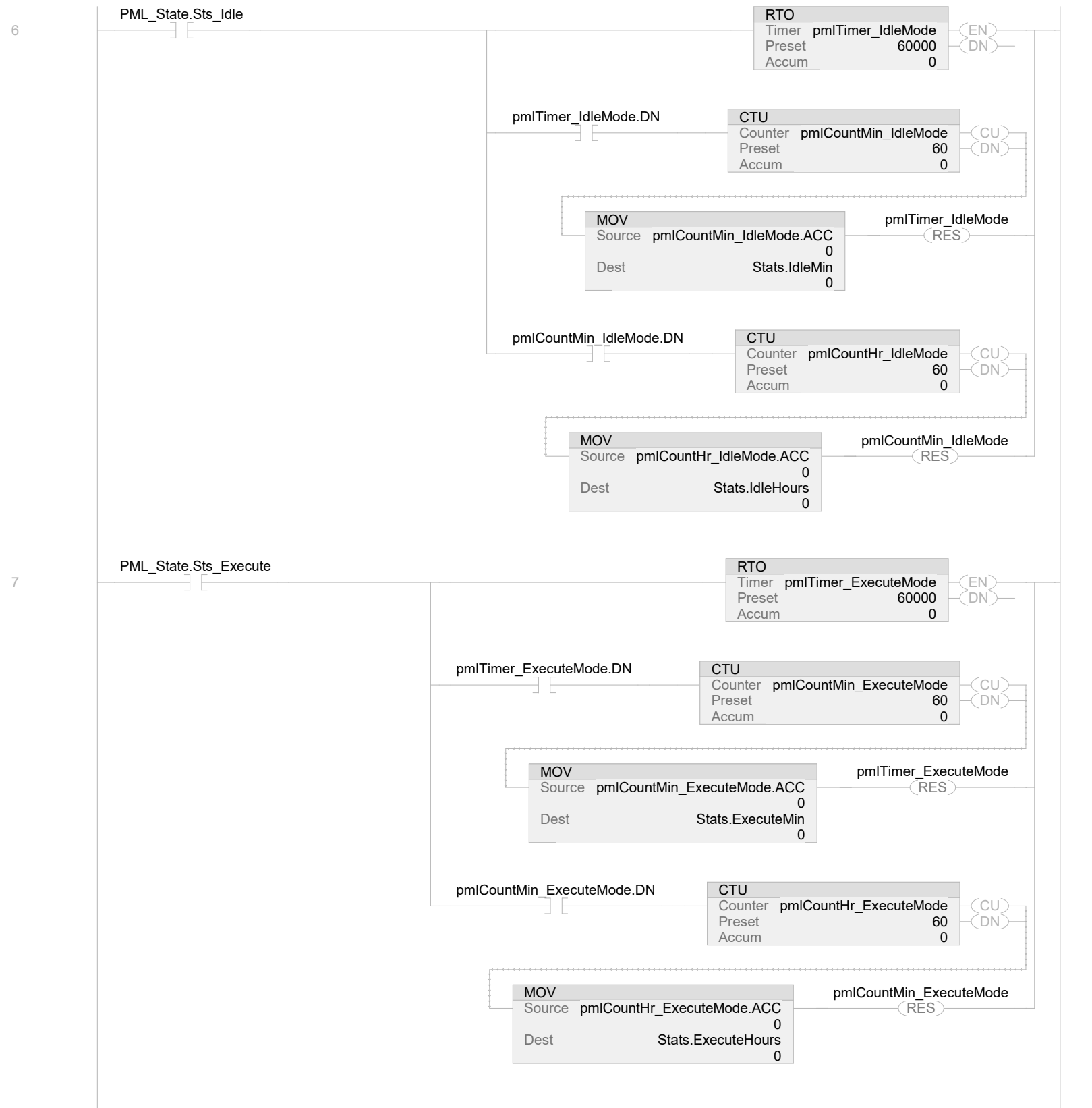


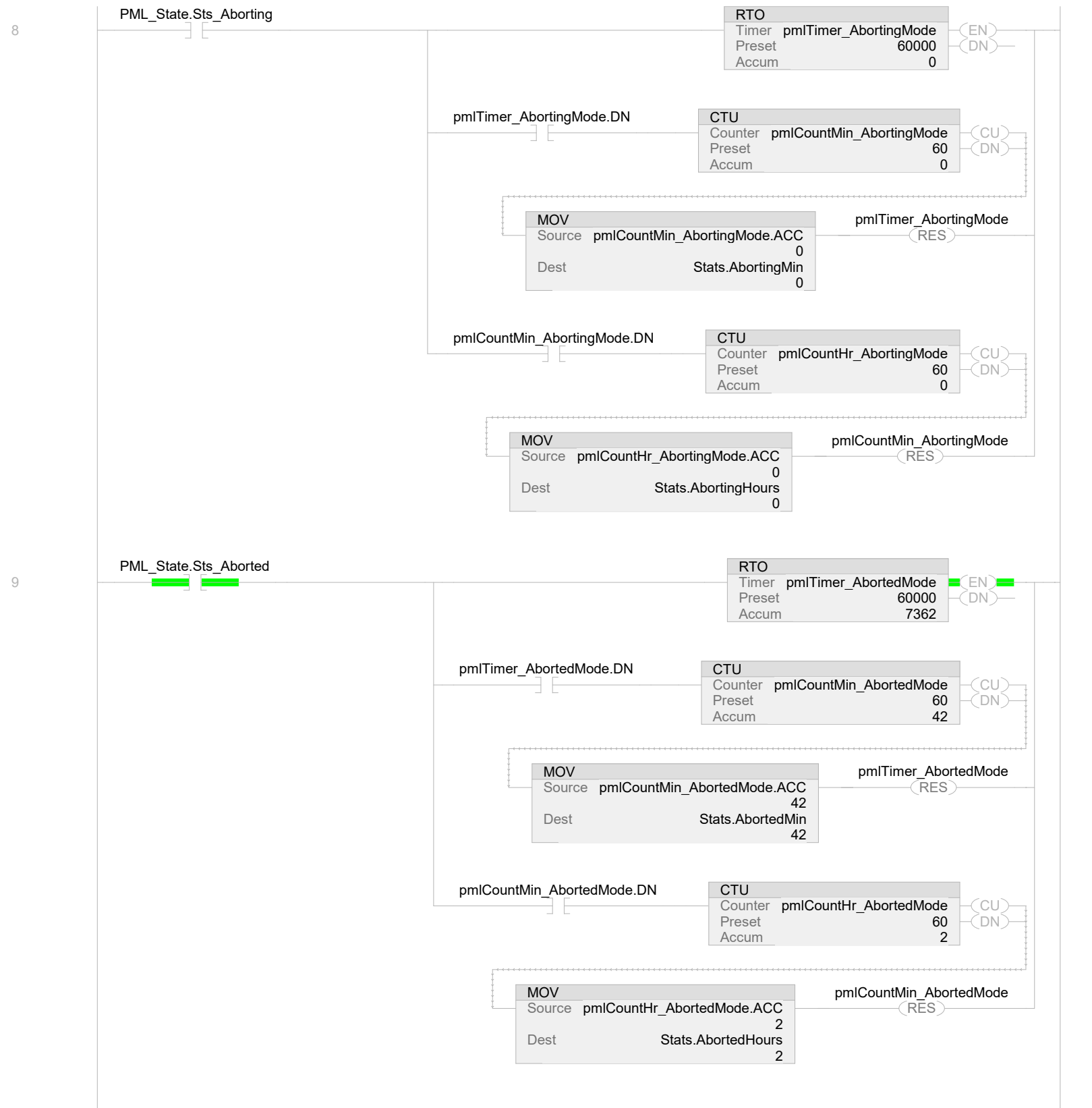












10

PML_State.Sts_Suspended

RTO		
Timer	pmlTimer_SuspendedMode	(EN)
Preset	60000	(DN)
Accum	0	

pmlTimer_SuspendedMode.DN

CTU		
Counter	pmlCountMin_SuspendedMode	(CU)
Preset	60	(DN)
Accum	0	

MOV

Source	pmlCountMin_SuspendedMode.ACC	0
Dest	Stats.SuspendedMln	0

pmlTimer_SuspendedMode

(RES)

pmlCountMin_SuspendedMode.DN

CTU		
Counter	pmlCountHr_SuspendedMode	(CU)
Preset	60	(DN)
Accum	0	

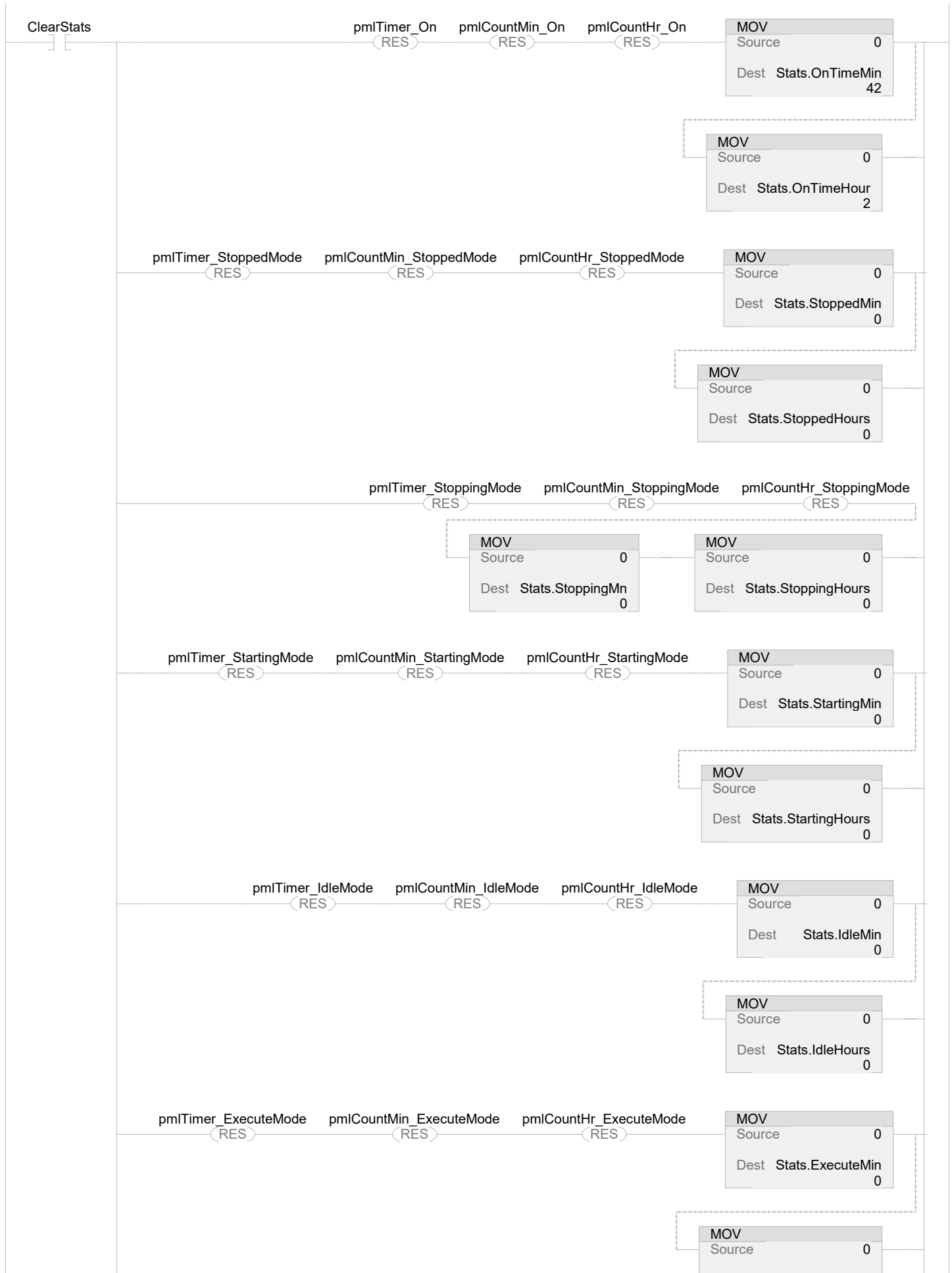
MOV

Source	pmlCountHr_SuspendedMode.ACC	0
Dest	Stats.SuspendedHours	0

pmlCountMin_SuspendedMode

(RES)

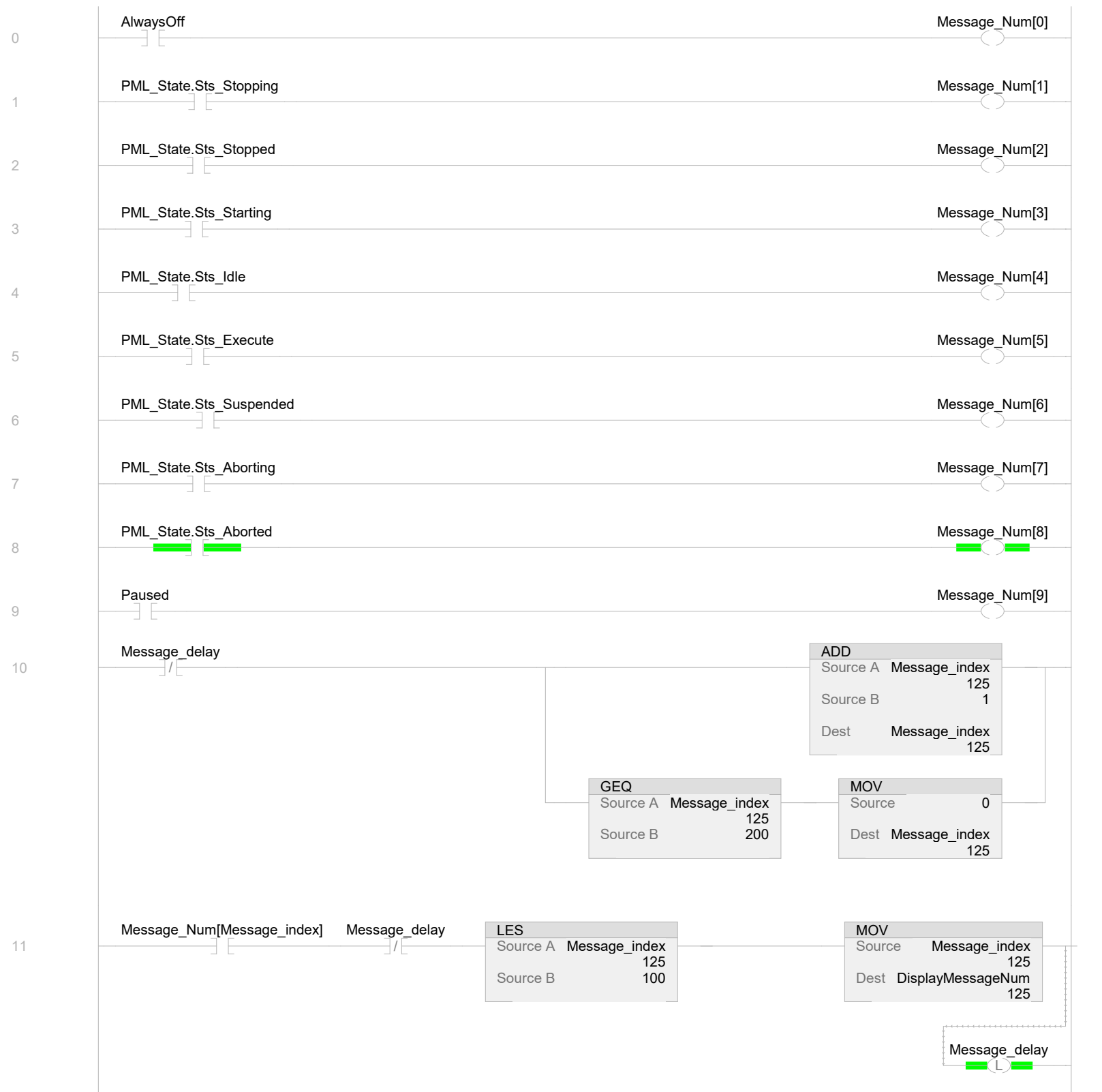
11

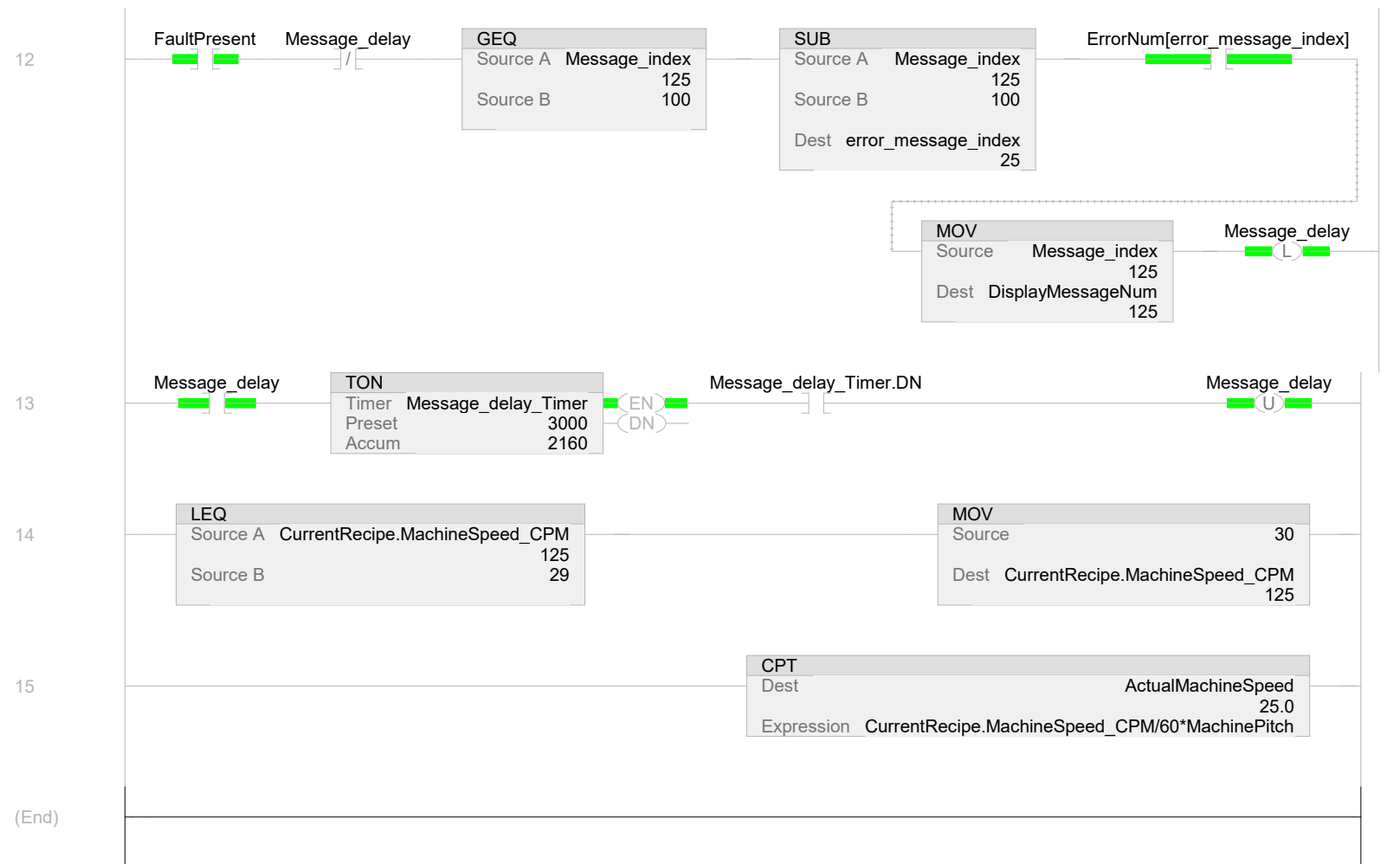


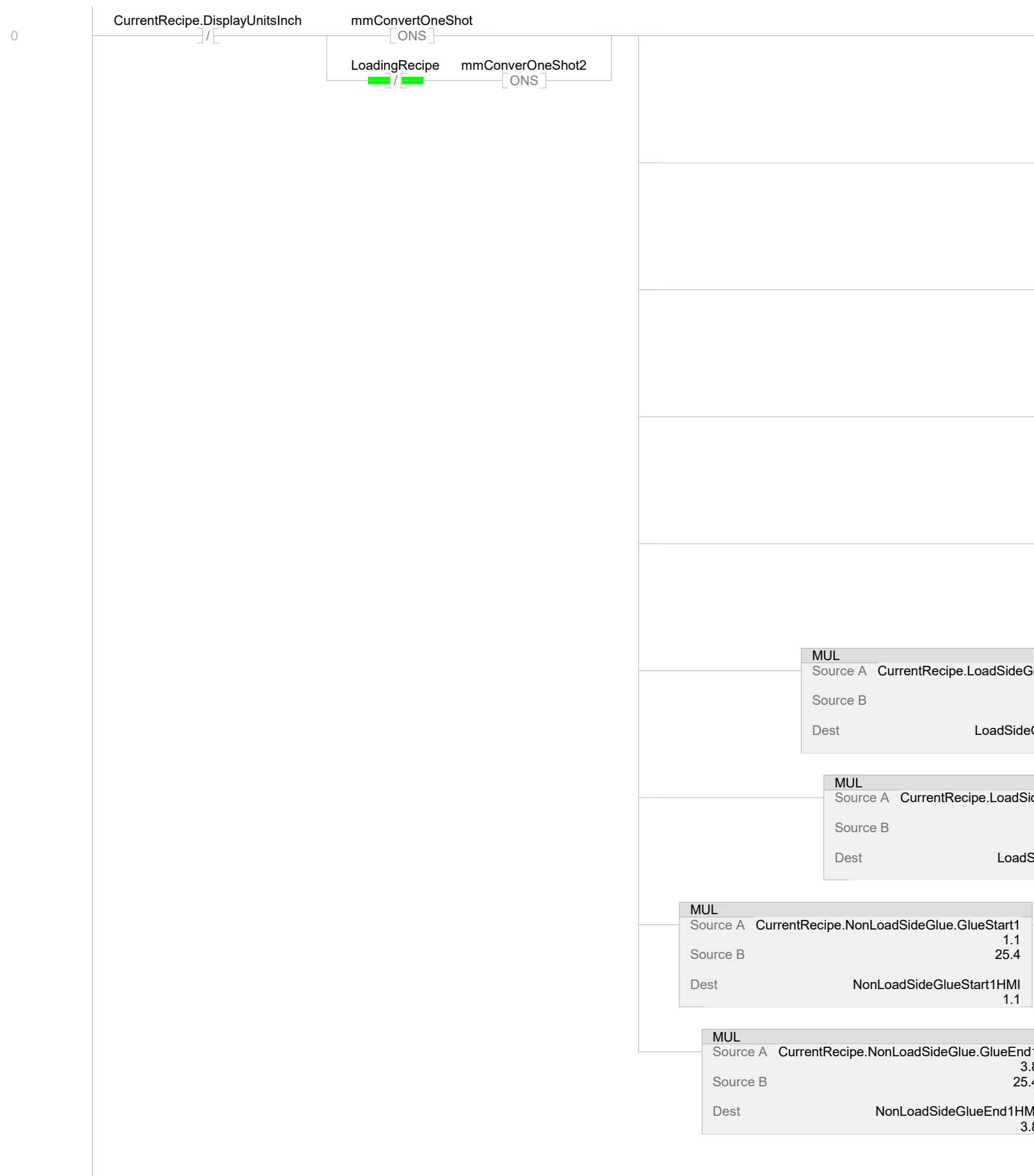


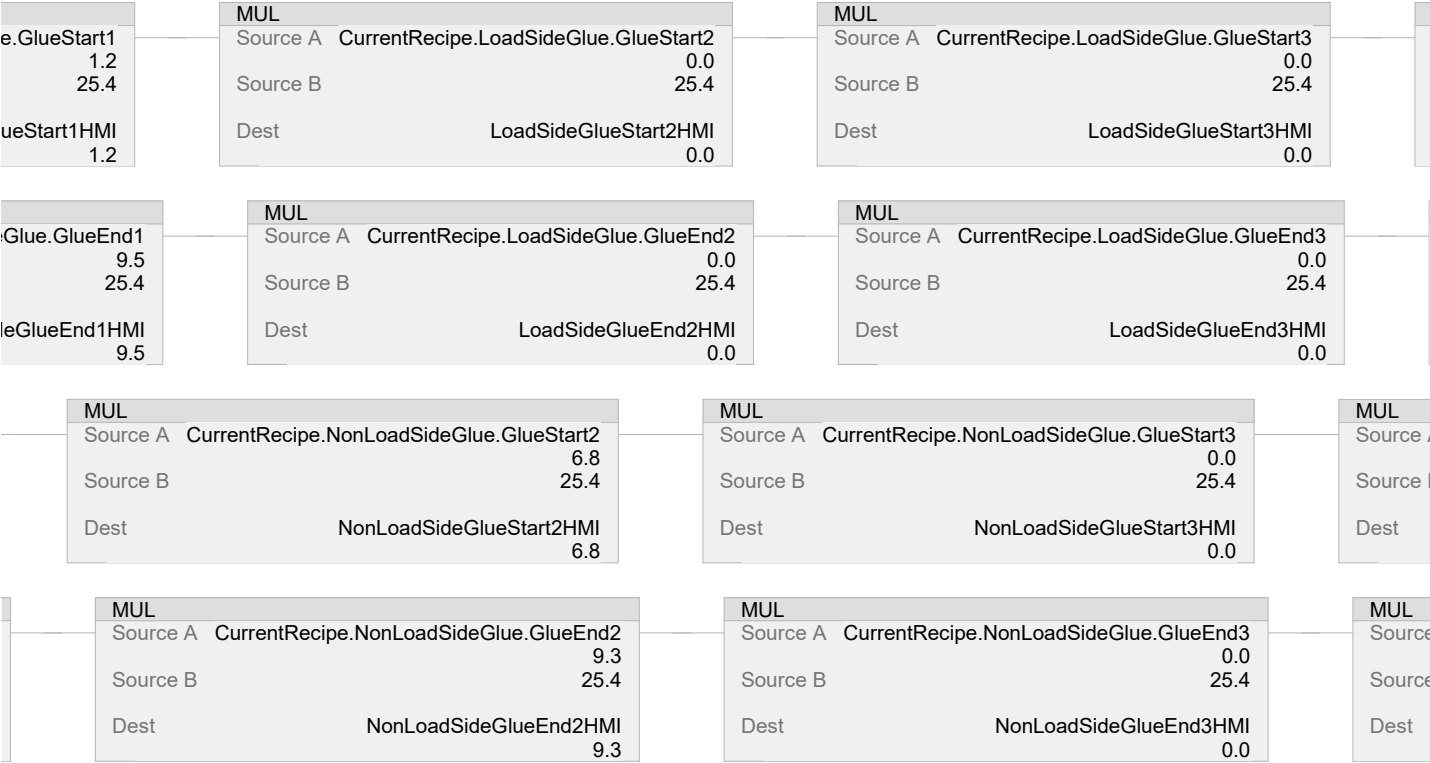
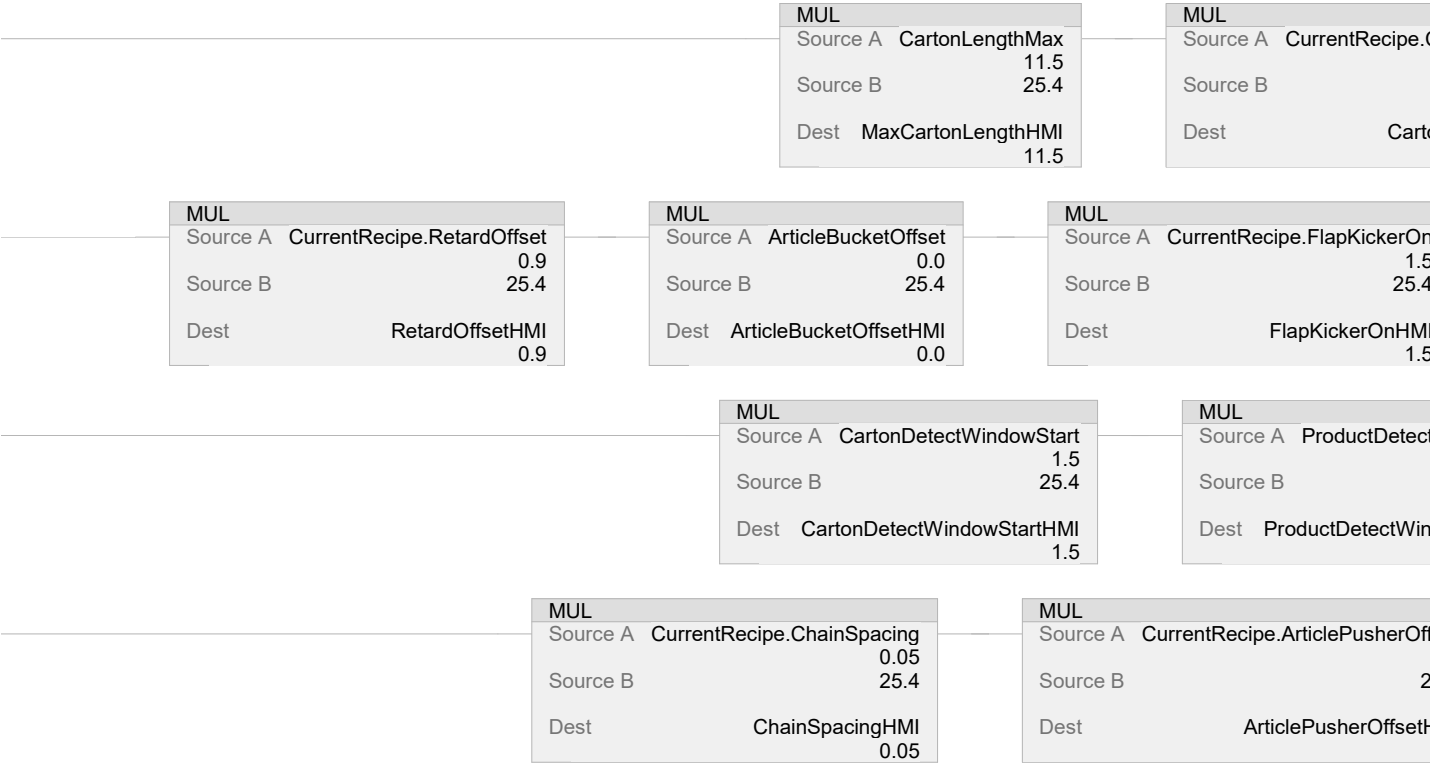
(End)

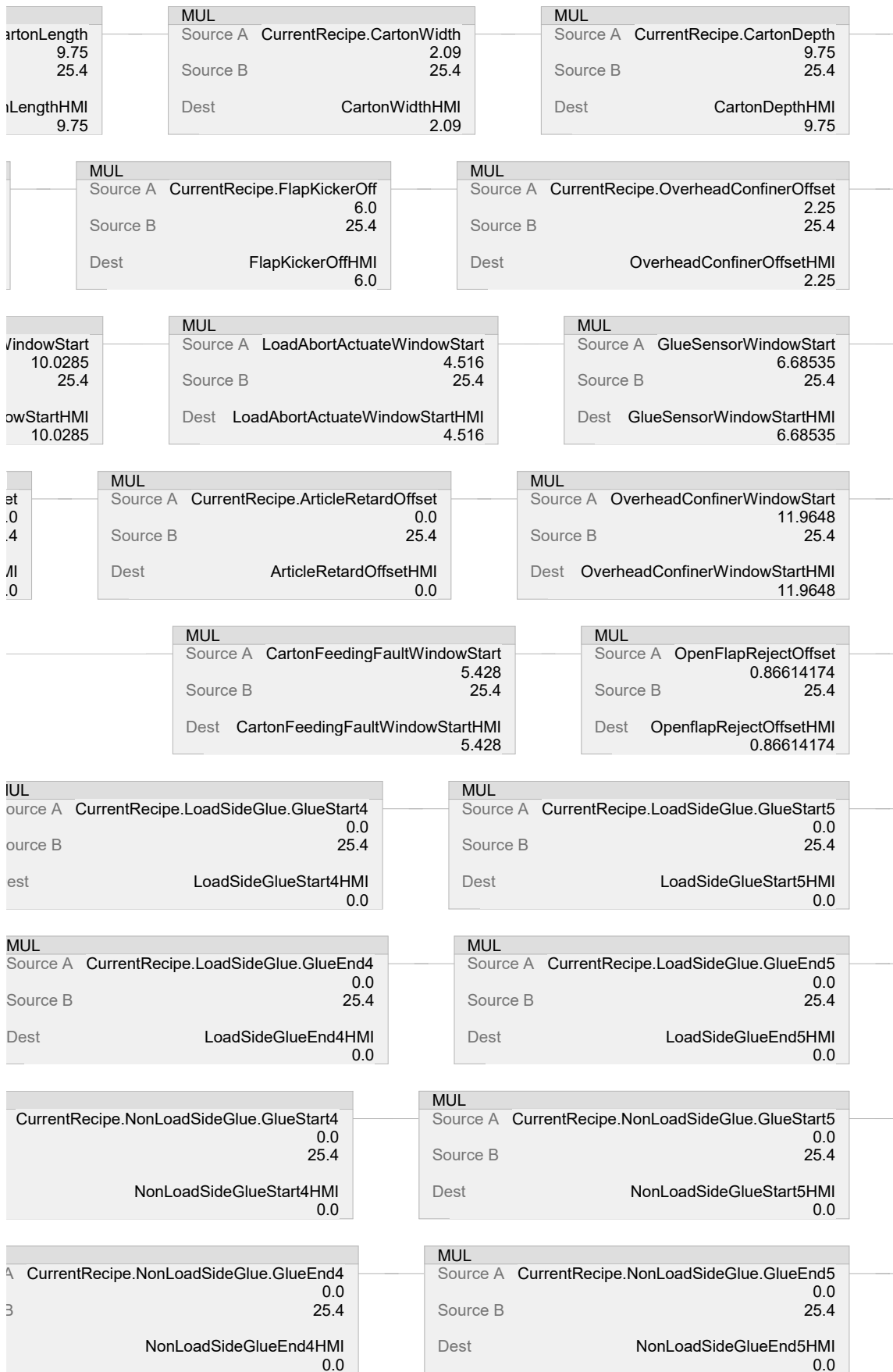












1

CurrentRecipe.DisplayUnitsInch LoadingRecipe

DIV	
Source A	Ret
Source B	
Dest	CurrentRecipe

DIV	
Source A	LoadSideGlueStart1HMI
	1.2
Source B	25.4
Dest	CurrentRecipe.LoadSideGlue.GlueStart1
	1.2

DIV	
Source A	
Source B	
Dest	Curre

DIV	
Source A	LoadSideGlueEnd1HMI
	9.5
Source B	25.4
Dest	CurrentRecipe.LoadSideGlue.GlueEnd1
	9.5

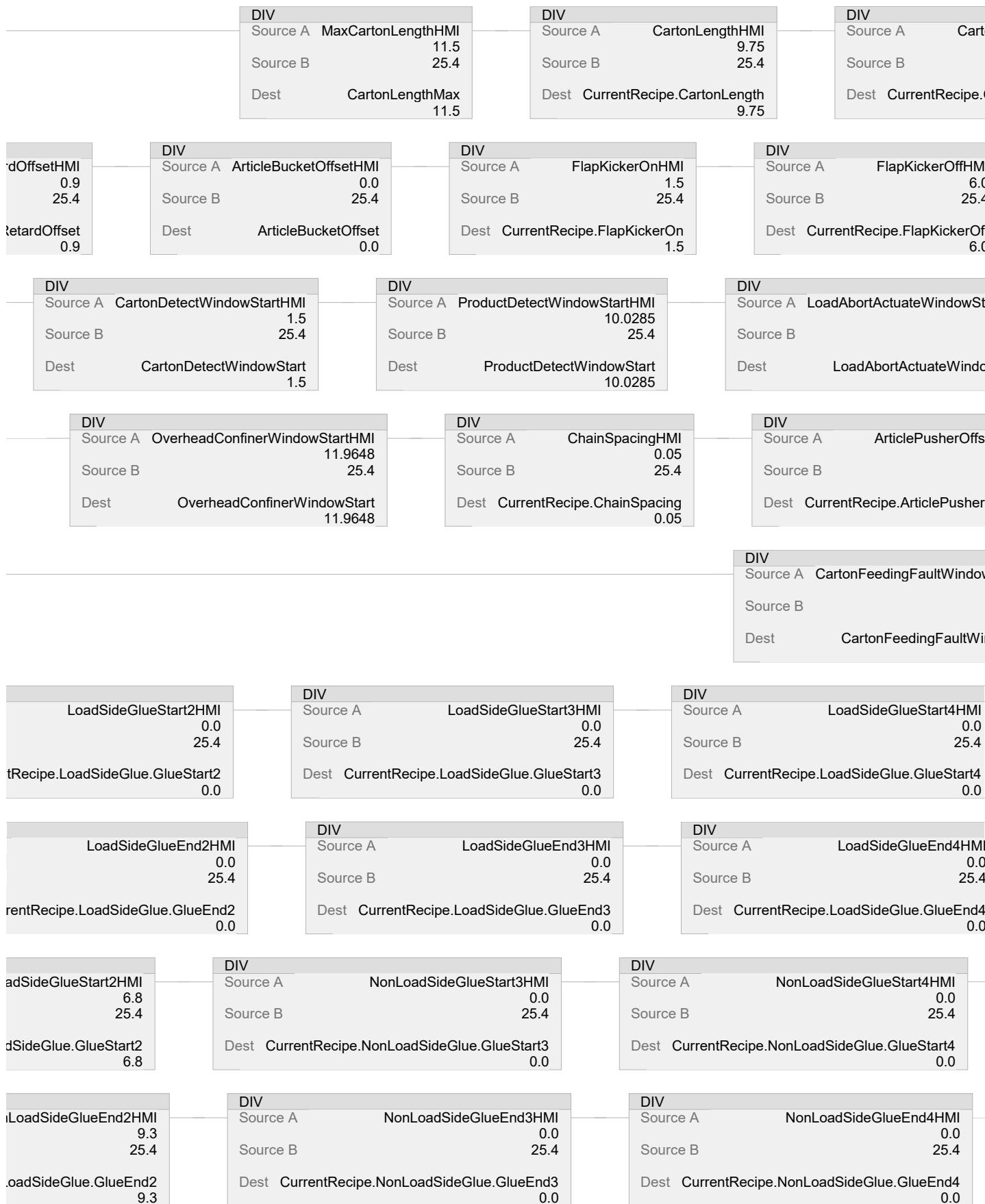
DIV	
Source A	
Source B	
Dest	C

DIV	
Source A	NonLoadSideGlueStart1HMI
	1.1
Source B	25.4
Dest	CurrentRecipe.NonLoadSideGlue.GlueStart1
	1.1

DIV	
Source A	NonL
Source B	
Dest	CurrentRecipe.NonLo

DIV	
Source A	NonLoadSideGlueEnd1HMI
	3.8
Source B	25.4
Dest	CurrentRecipe.NonLoadSideGlue.GlueEnd1
	3.8

DIV	
Source A	N
Source B	
Dest	CurrentRecipe.Nor



DIV	
Source A	CartonDepthHMI
	9.75
Source B	25.4
Dest	CurrentRecipe.CartonDepth
	9.75

DIV	
Source A	OverheadConfinerOffsetHMI
	2.25
Source B	25.4
Dest	CurrentRecipe.OverheadConfinerOffset
	2.25

DIV	
Source A	GlueSensorWindowStartHMI
	6.68535
Source B	25.4
Dest	GlueSensorWindowStart
	6.68535

DIV	
Source A	ArticleRetardOffsetHMI
	0.0
Source B	25.4
Dest	CurrentRecipe.ArticleRetardOffset
	0.0

DIV	
Source A	OpenflapRejectOffsetHMI
	0.86614174
Source B	25.4
Dest	OpenFlapRejectOffset
	0.86614174

DIV	
Source A	LoadSideGlueStart5HMI
	0.0
Source B	25.4
Dest	CurrentRecipe.LoadSideGlue.GlueStart5
	0.0

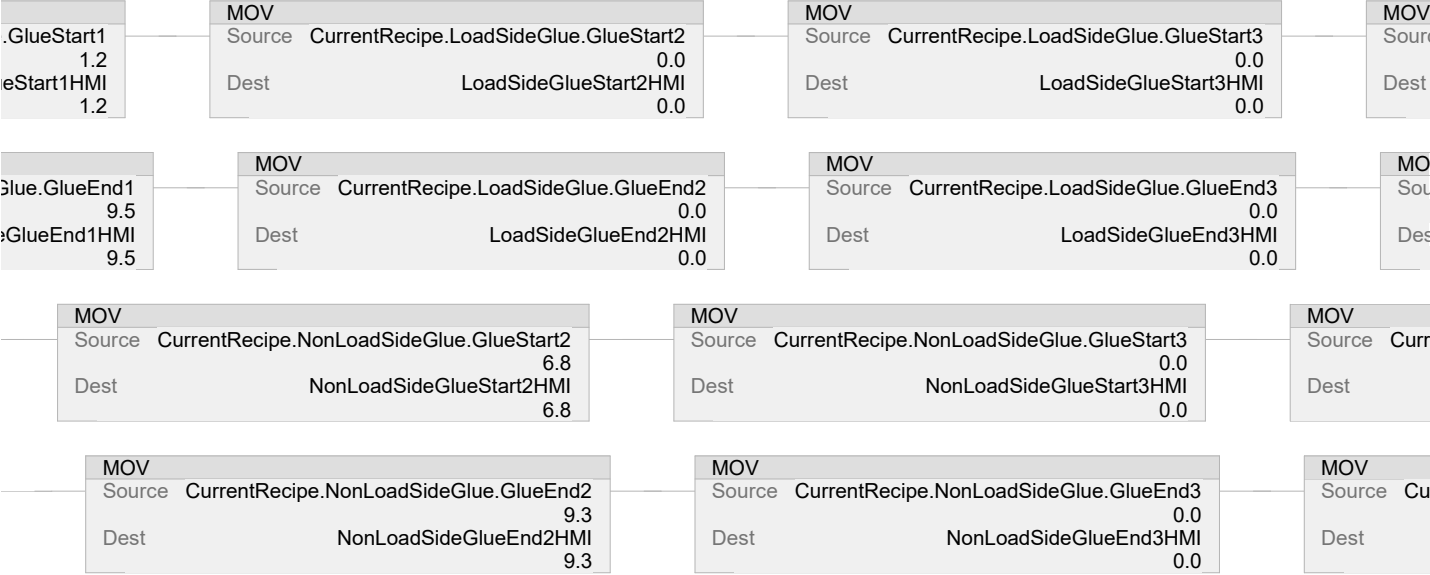
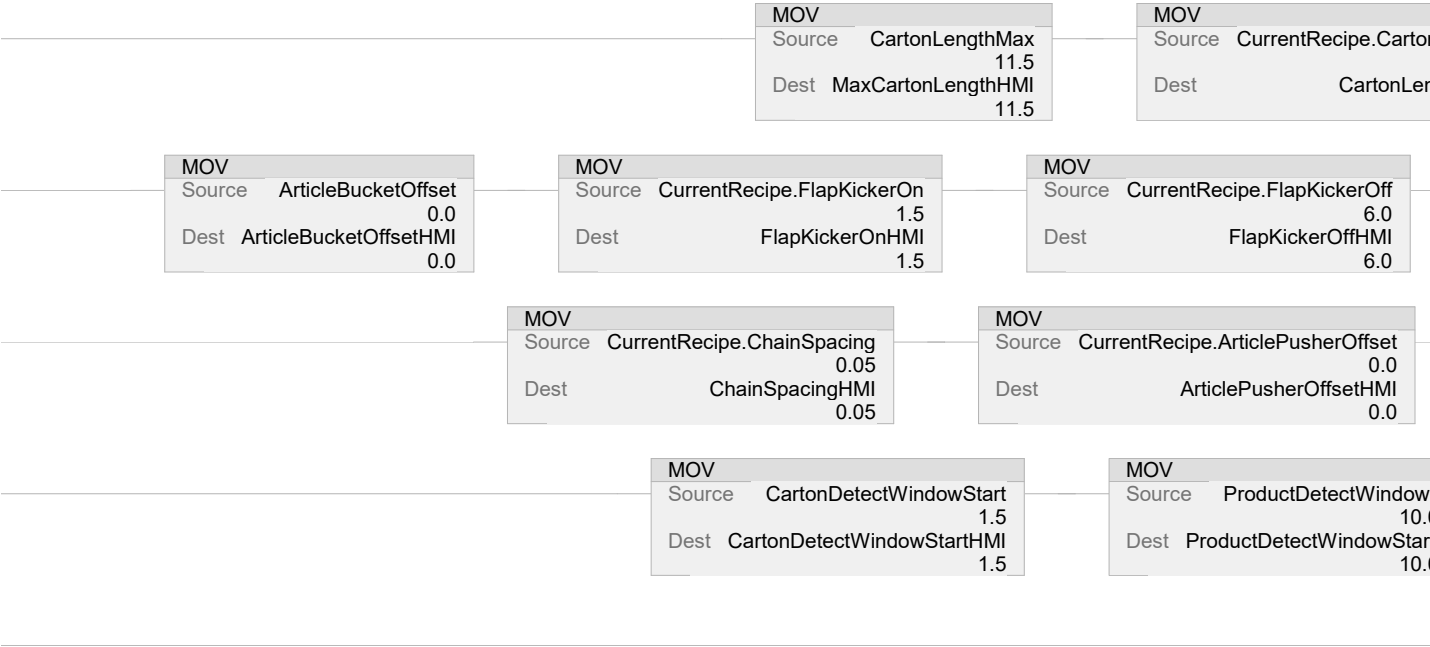
DIV	
Source A	LoadSideGlueEnd5HMI
	0.0
Source B	25.4
Dest	CurrentRecipe.LoadSideGlue.GlueEnd5
	0.0

DIV	
Source A	NonLoadSideGlueStart5HMI
	0.0
Source B	25.4
Dest	CurrentRecipe.NonLoadSideGlue.GlueStart5
	0.0

DIV	
Source A	NonLoadSideGlueEnd5HMI
	0.0
Source B	25.4
Dest	CurrentRecipe.NonLoadSideGlue.GlueEnd5
	0.0

(End)







1

CurrentRecipe.DisplayUnitsInch LoadingRecipe

MOV	
Source	ArticleBuc
Dest	Article

MOV	
Source	LoadSideGlueStart1HMI 1.2
Dest	CurrentRecipe.LoadSideGlue.GlueStart1 1.2

MOV	
Source	
Dest	Curre

MOV	
Source	LoadSideGlueStart1HMI 1.2
Dest	CurrentRecipe.LoadSideGlue.GlueStart1 1.2

MOV	
Source	
Dest	Curre

MOV	
Source	LoadSideGlueEnd1HMI 9.5
Dest	CurrentRecipe.LoadSideGlue.GlueEnd1 9.5

MOV	
Source	
Dest	Cr

MOV	
Source	NonLoadSideGlueStart1HMI 1.1
Dest	CurrentRecipe.NonLoadSideGlue.GlueStart1 1.1

MOV	
Source	NonL
Dest	CurrentRecipe.NonLo

MOV	
Source	NonLoadSideGlueEnd1HMI 3.8
Dest	CurrentRecipe.NonLoadSideGlue.GlueEnd1 3.8

MOV	
Source	N
Dest	CurrentRecipe.Nor



CartonWidthHMI
2.09
CartonWidth
2.09

MOV
Source CartonDepthHMI
9.75
Dest CurrentRecipe.CartonDepth
9.75

MOV
Source OverheadConfinerOffsetHMI
2.25
Dest CurrentRecipe.OverheadConfinerOffset
2.25

StartHMI
4.516
WindowStart
4.516

MOV
Source GlueSensorWindowStartHMI
6.68535
Dest GlueSensorWindowStart
6.68535

MOV
Source OverheadConfinerWindowStartHMI
11.9648
Dest OverheadConfinerWindowStart
11.9648

WindowStartHMI
5.428
WindowStart
5.428

MOV
Source OpenflapRejectOffsetHMI
0.86614174
Dest OpenFlapRejectOffset
0.86614174

MOV
Source LoadSideGlueStart5HMI
0.0
Dest CurrentRecipe.LoadSideGlue.GlueStart5
0.0

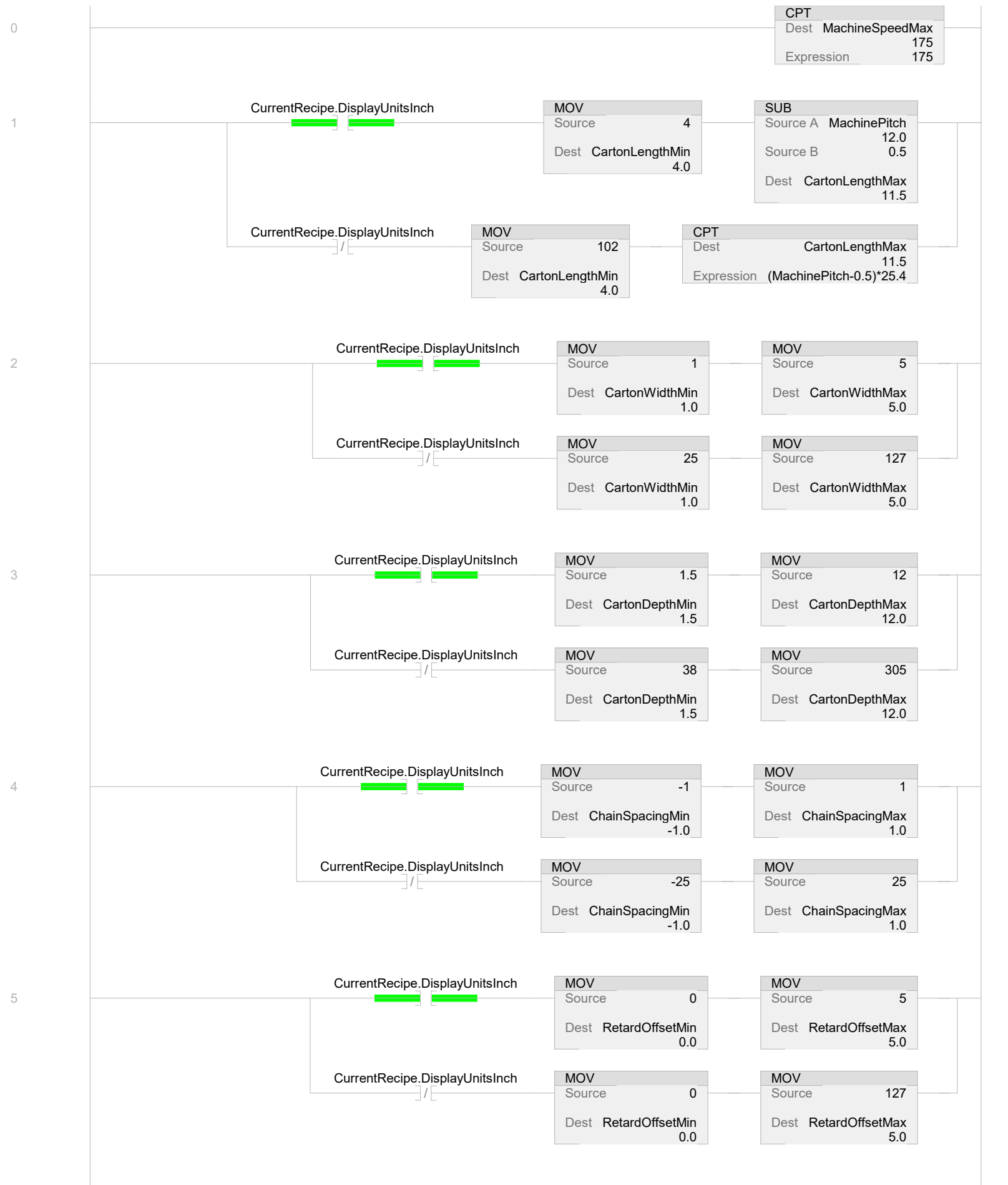
MOV
Source LoadSideGlueStart5HMI
0.0
Dest CurrentRecipe.LoadSideGlue.GlueStart5
0.0

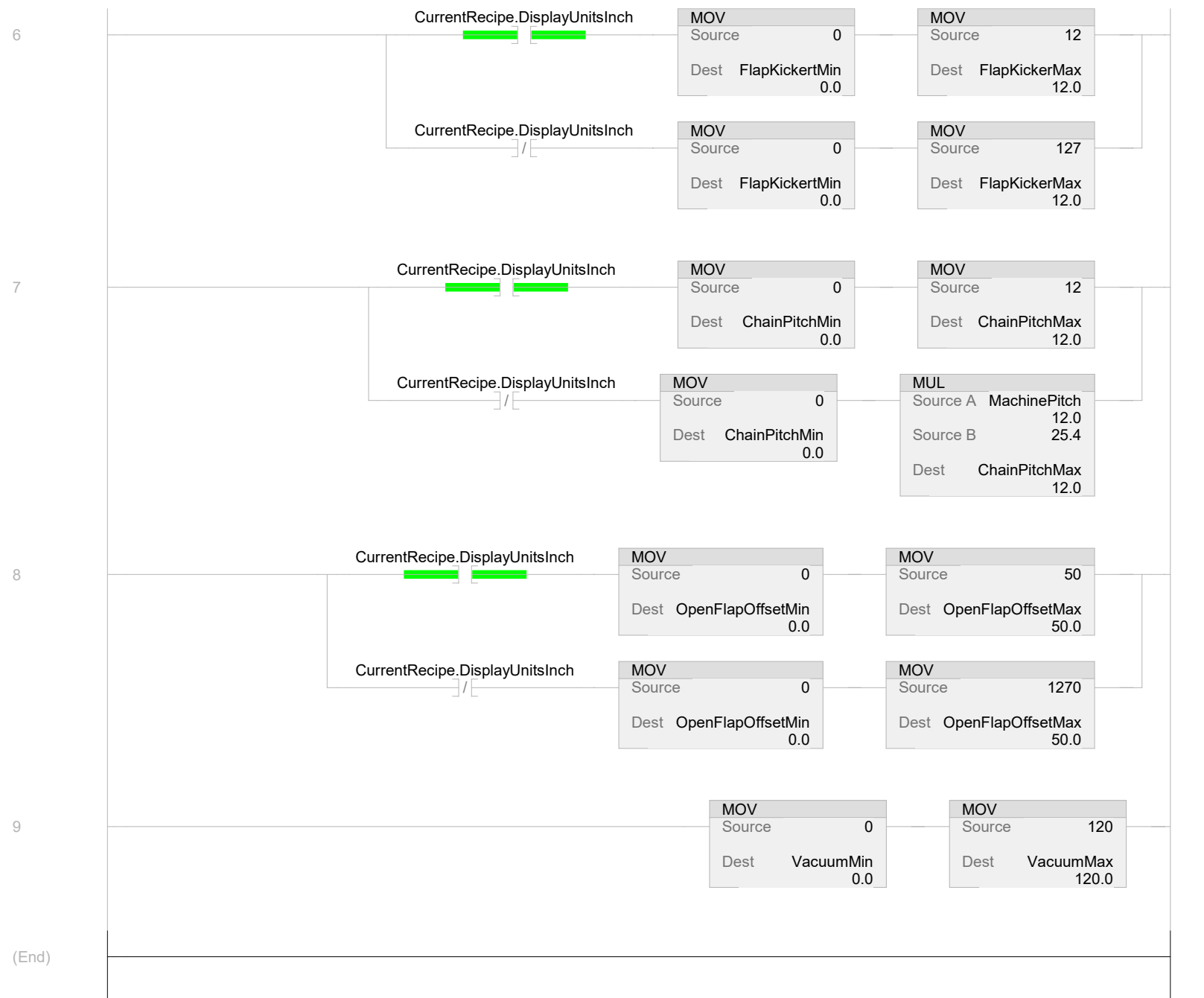
MOV
Source LoadSideGlueEnd5HMI
0.0
Dest CurrentRecipe.LoadSideGlue.GlueEnd5
0.0

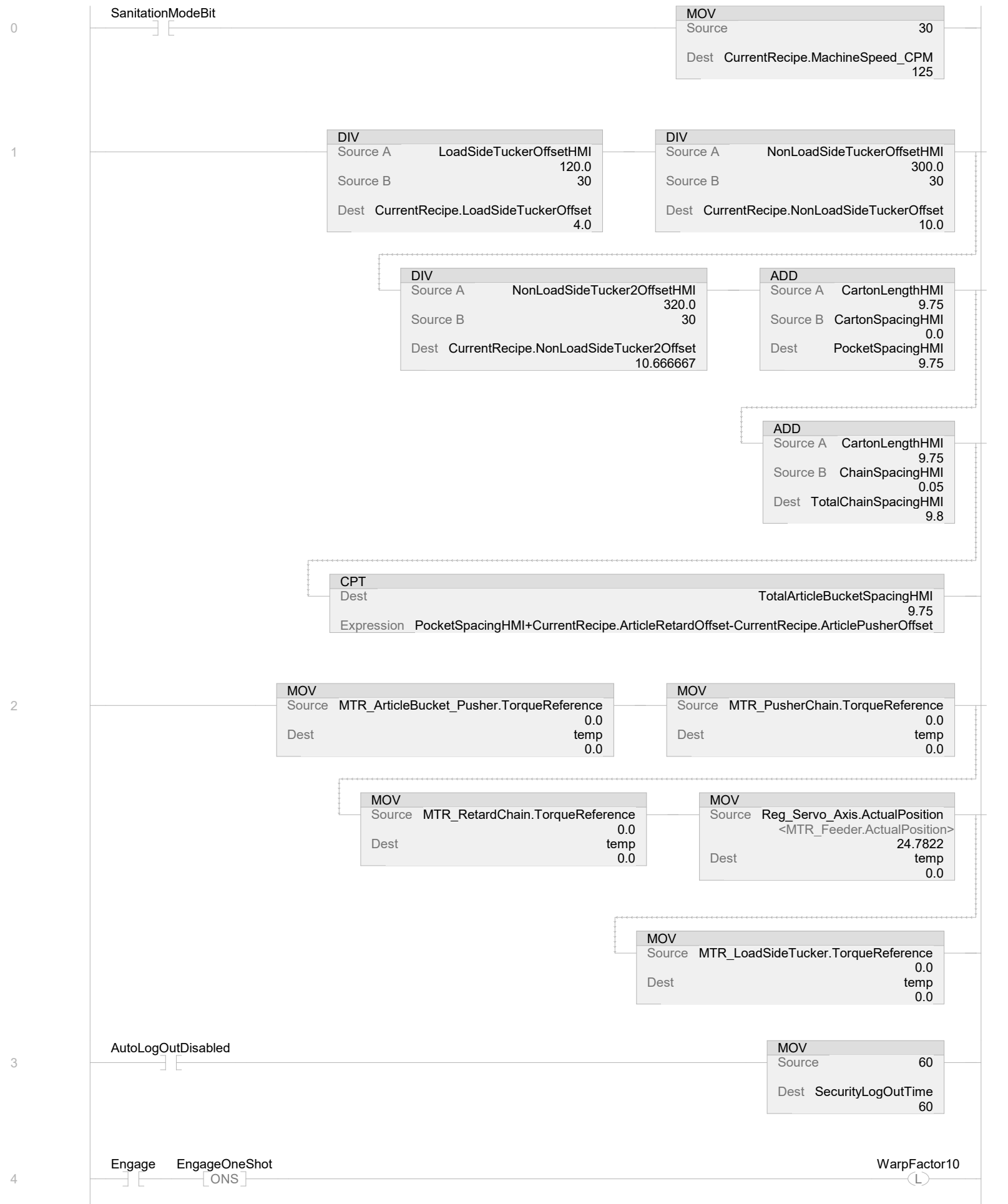
MOV
Source NonLoadSideGlueStart5HMI
0.0
Dest CurrentRecipe.NonLoadSideGlue.GlueStart5
0.0

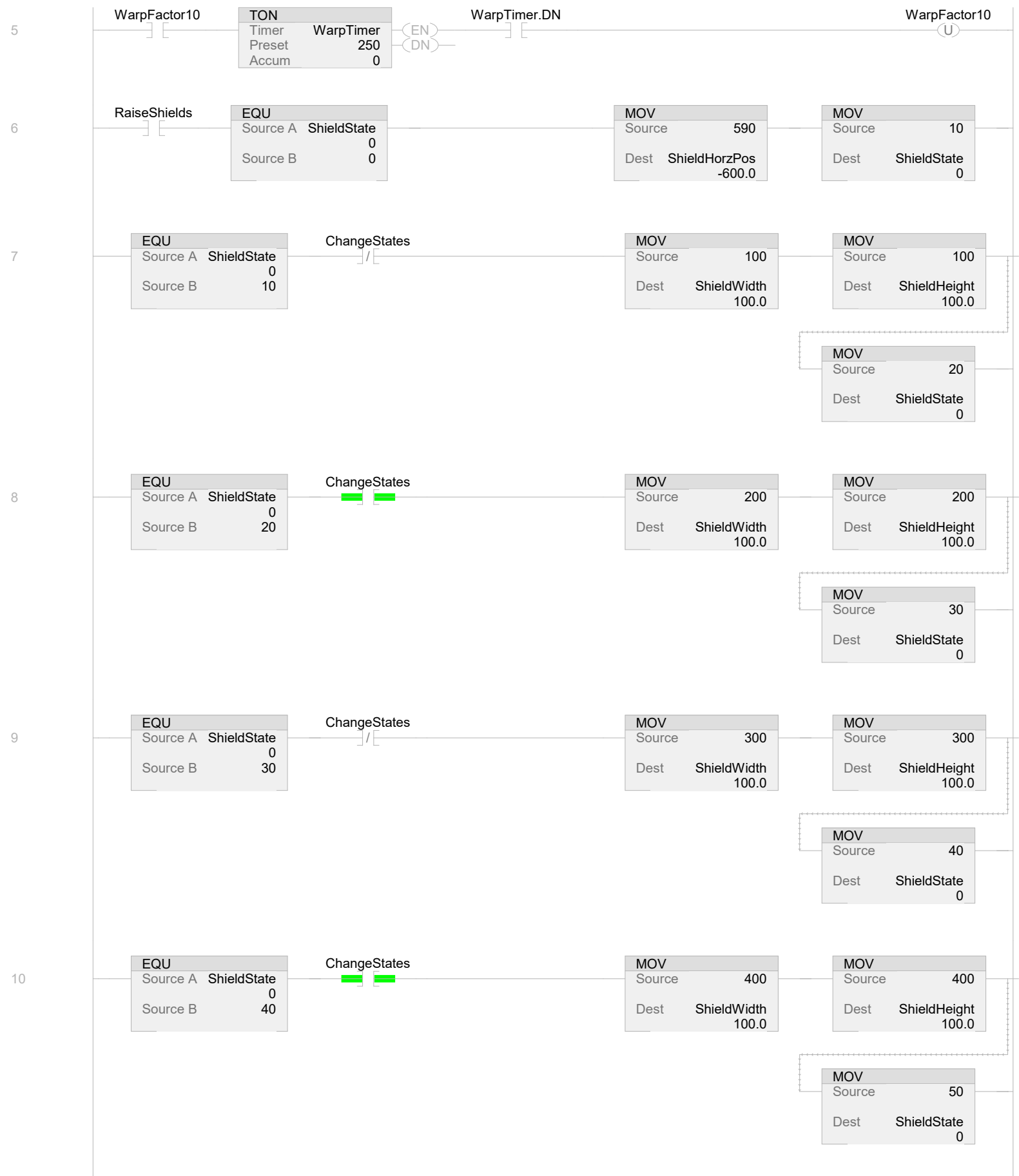
MOV
Source NonLoadSideGlueEnd5HMI
0.0
Dest CurrentRecipe.NonLoadSideGlue.GlueEnd5
0.0

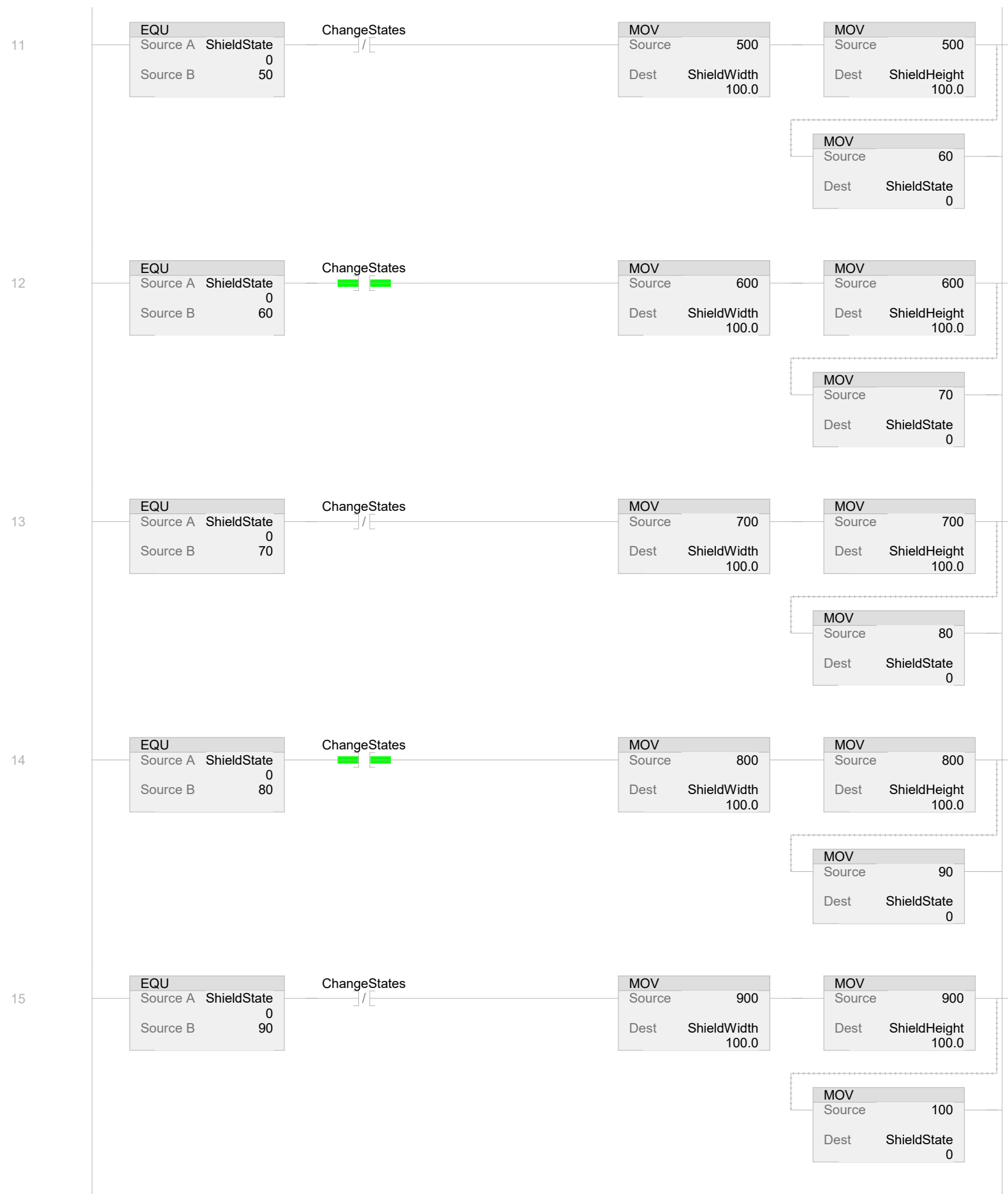
(End)

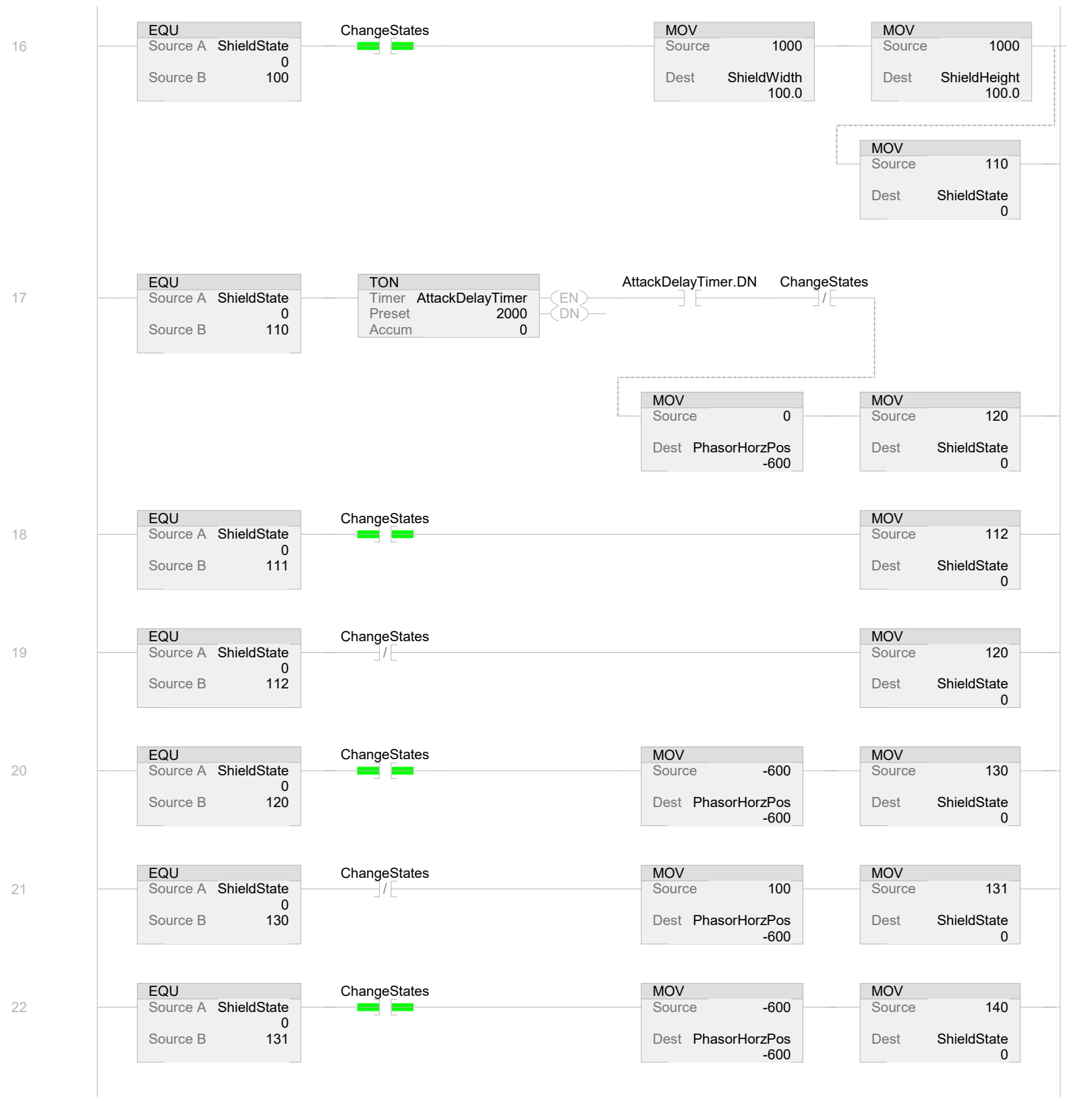


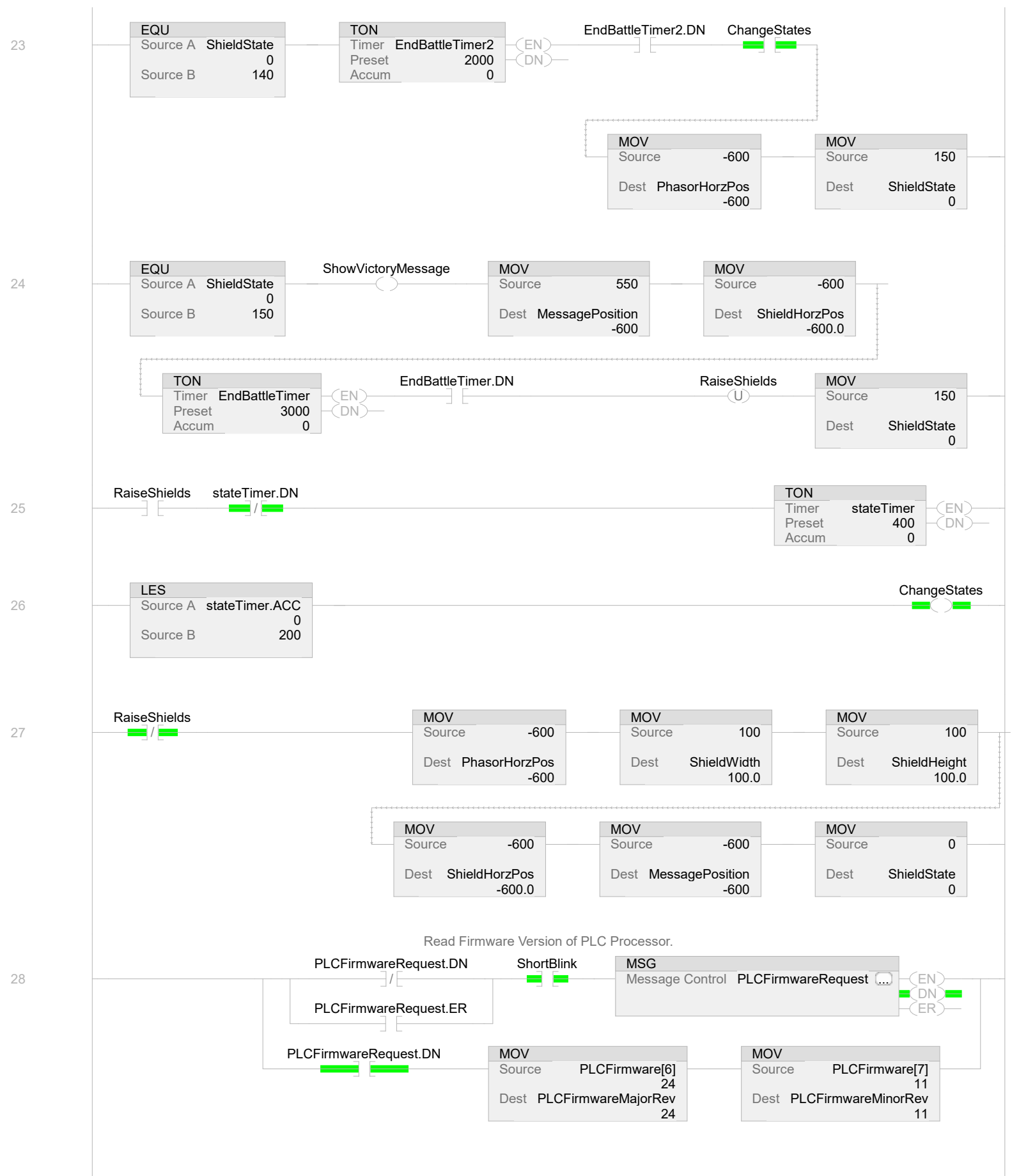




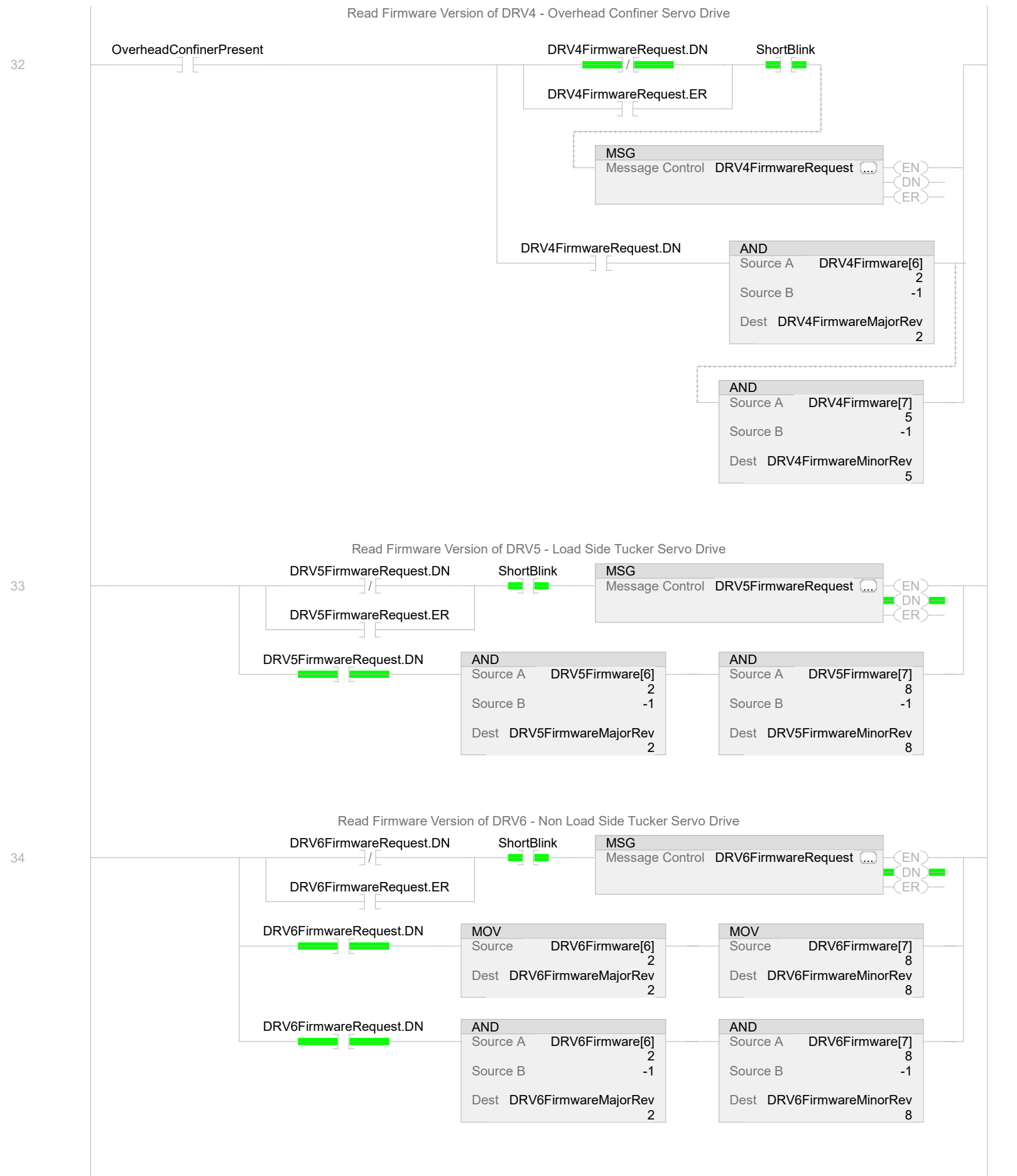


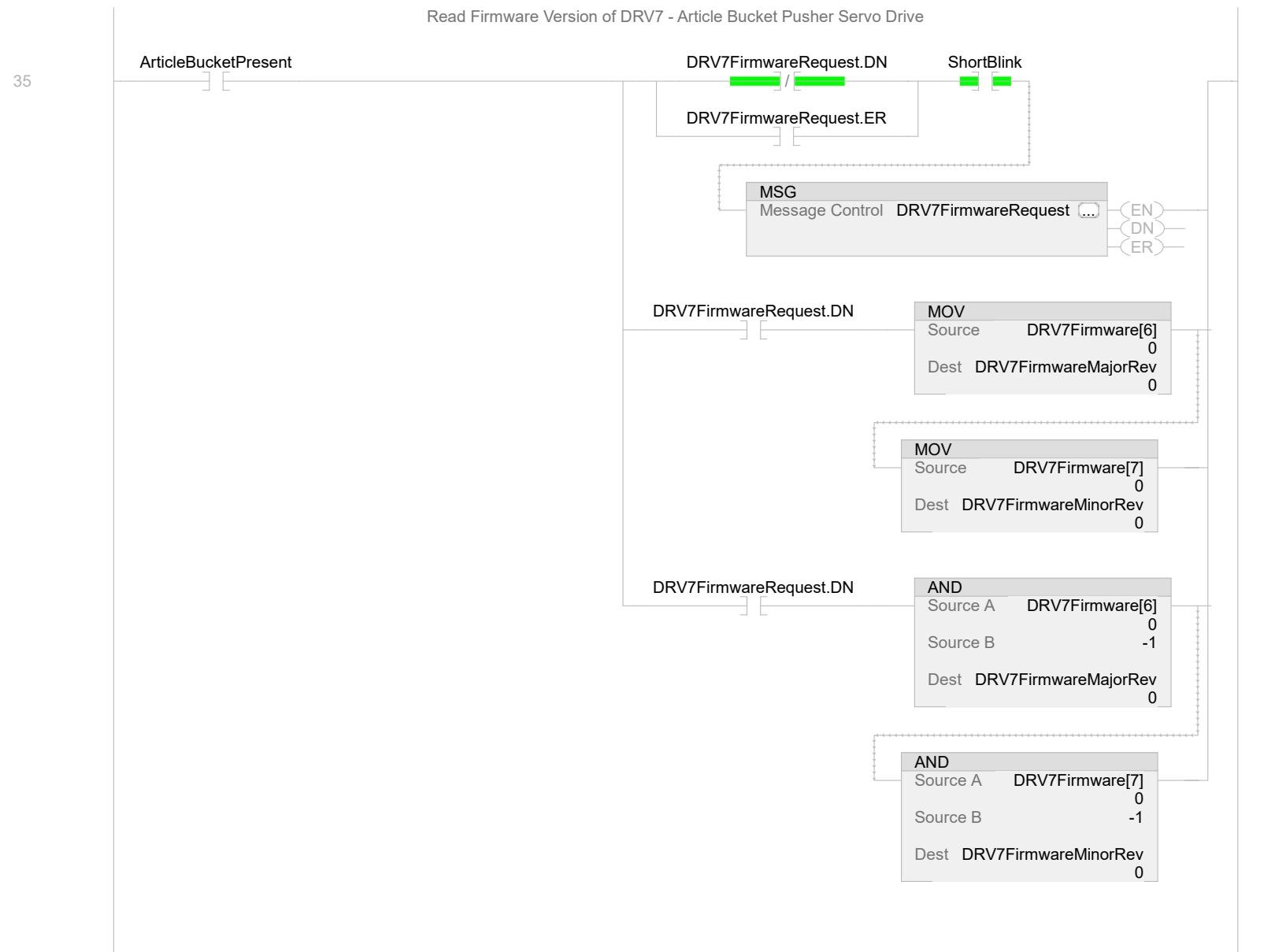




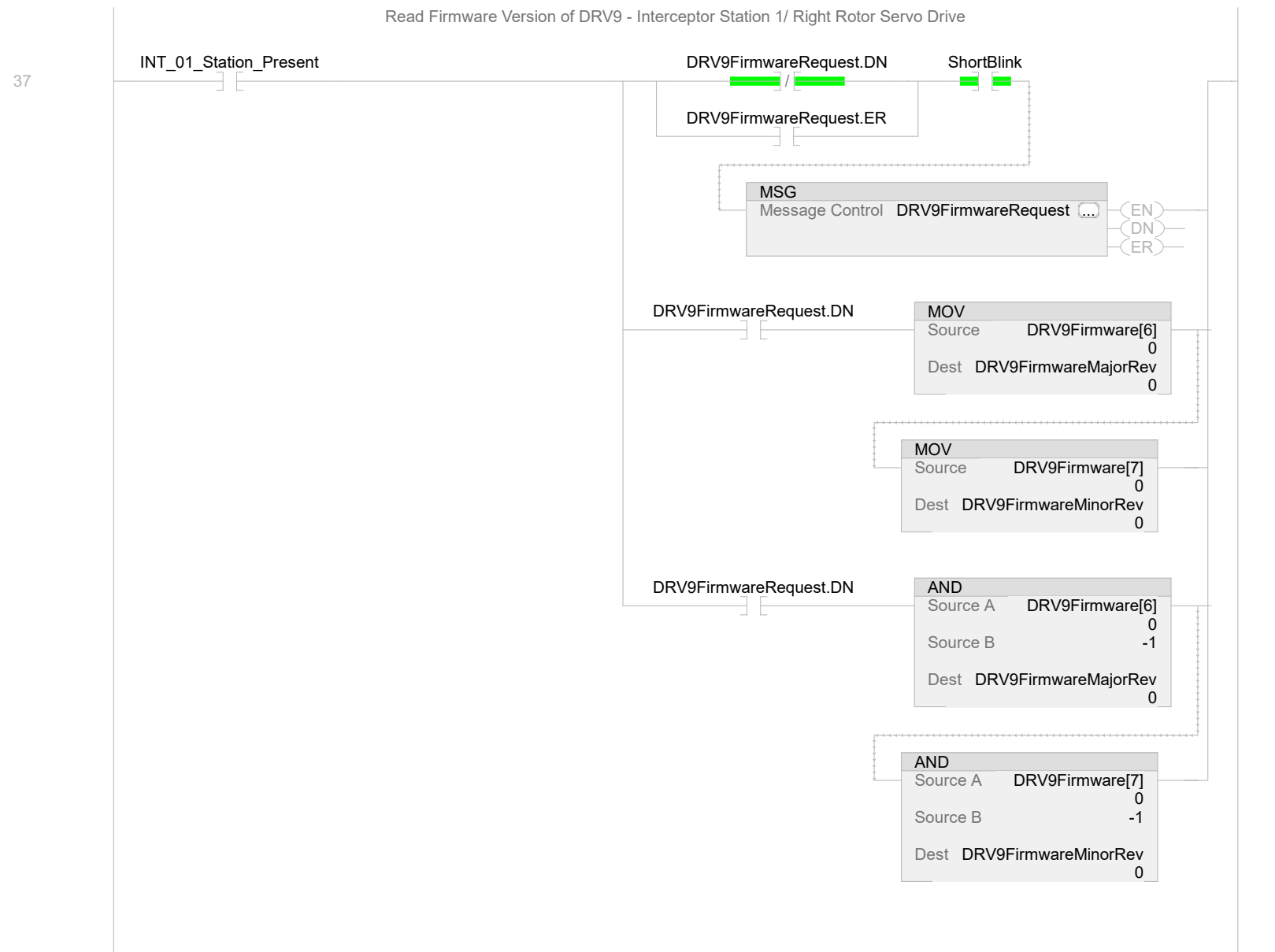




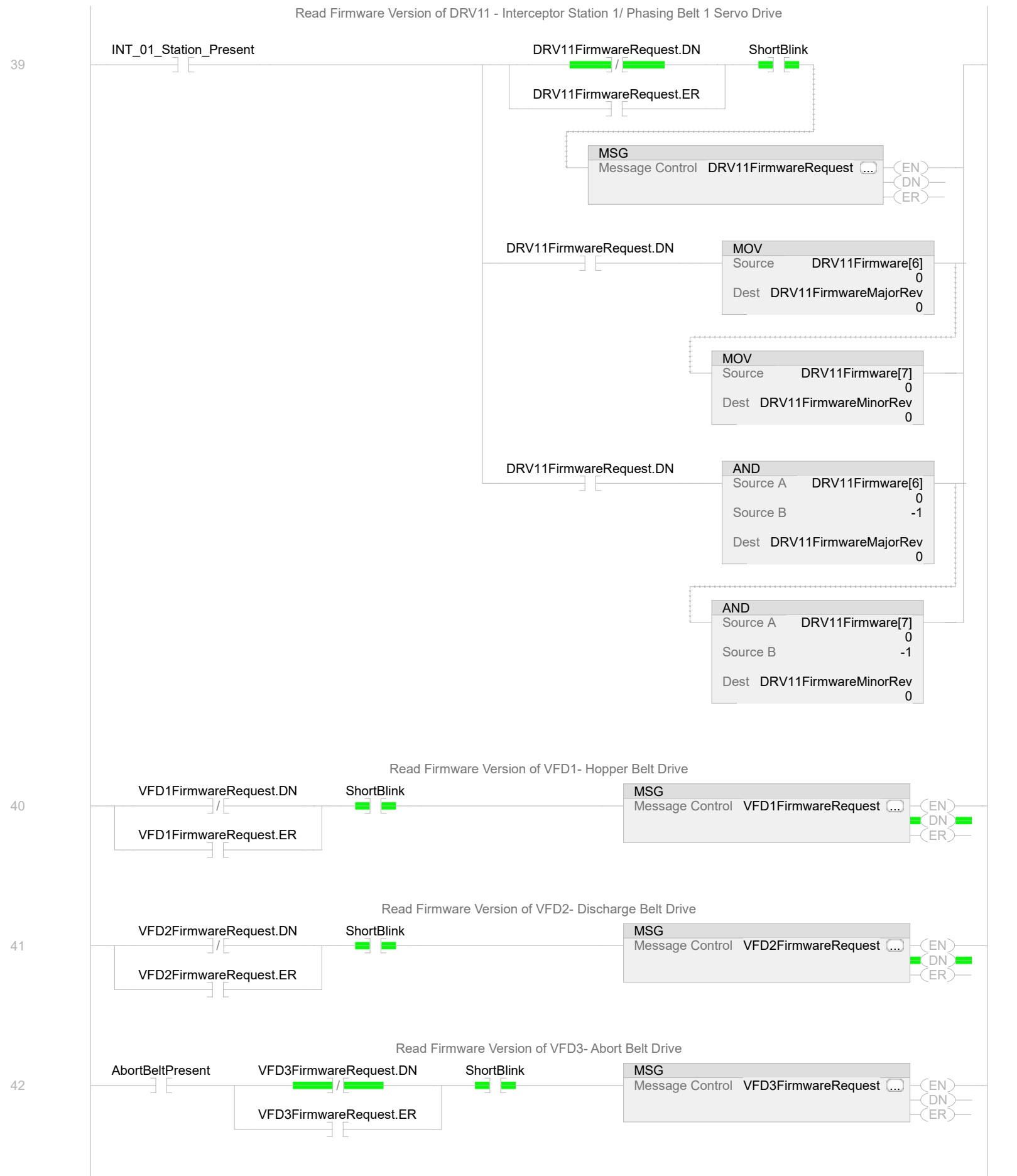


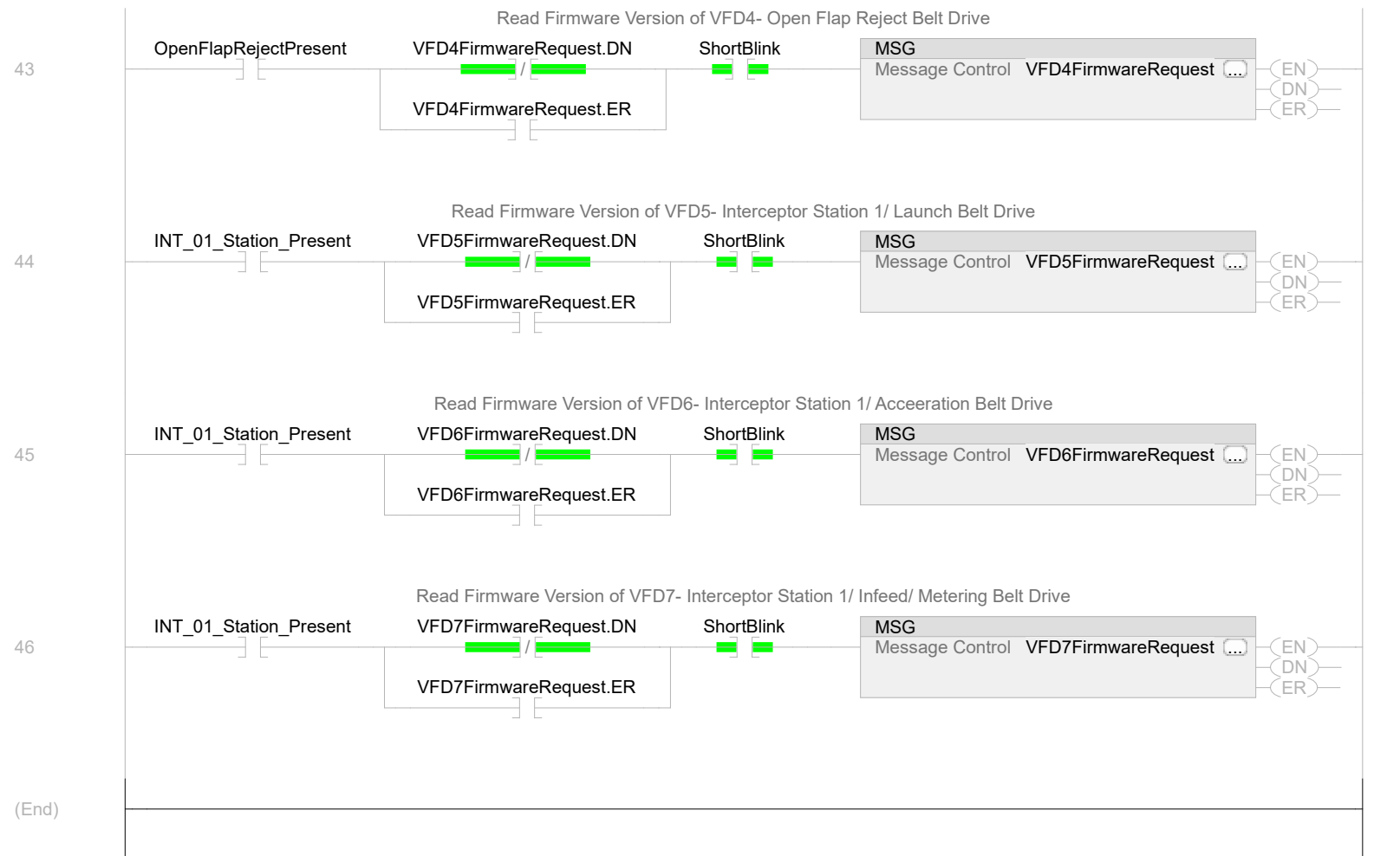


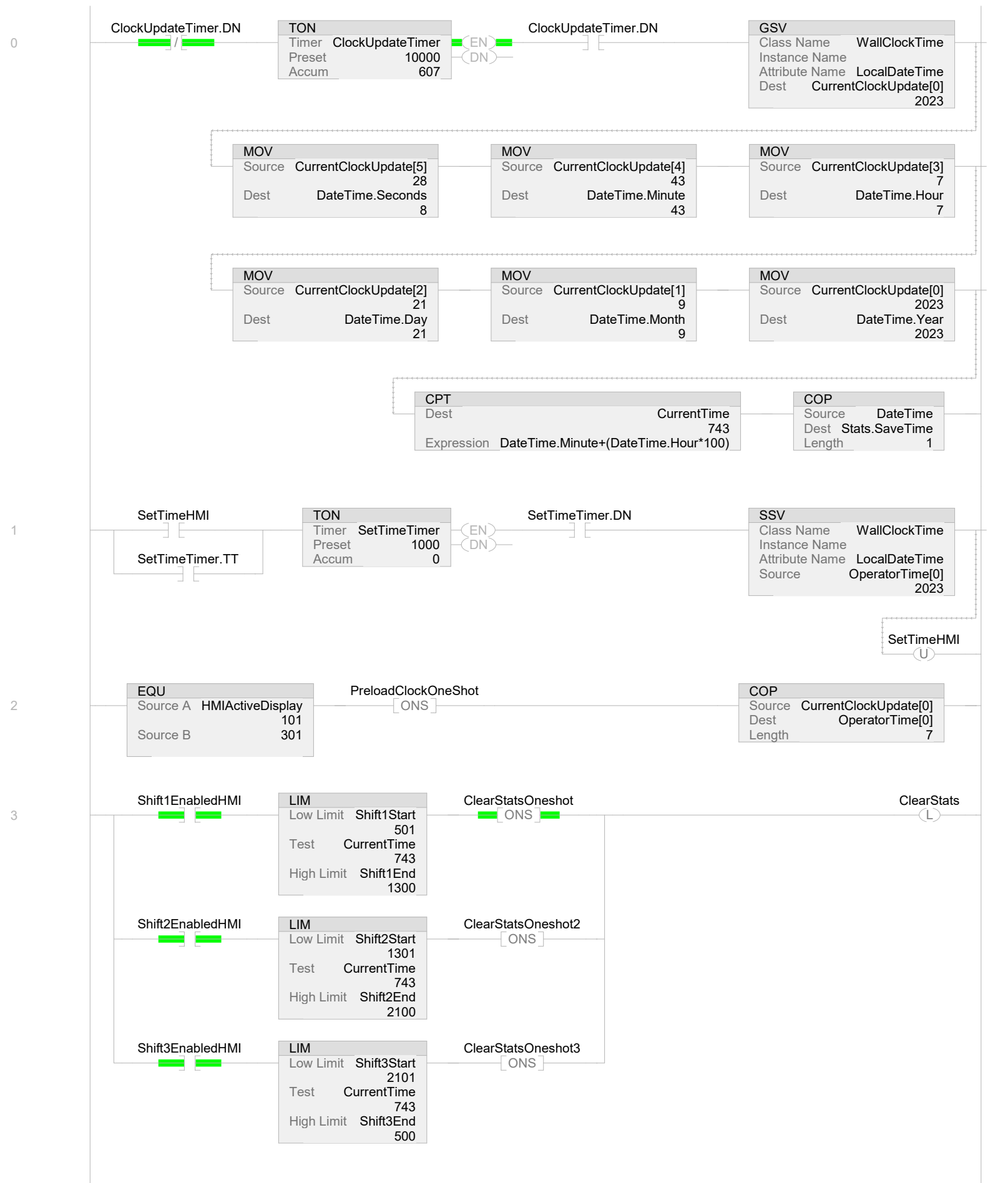


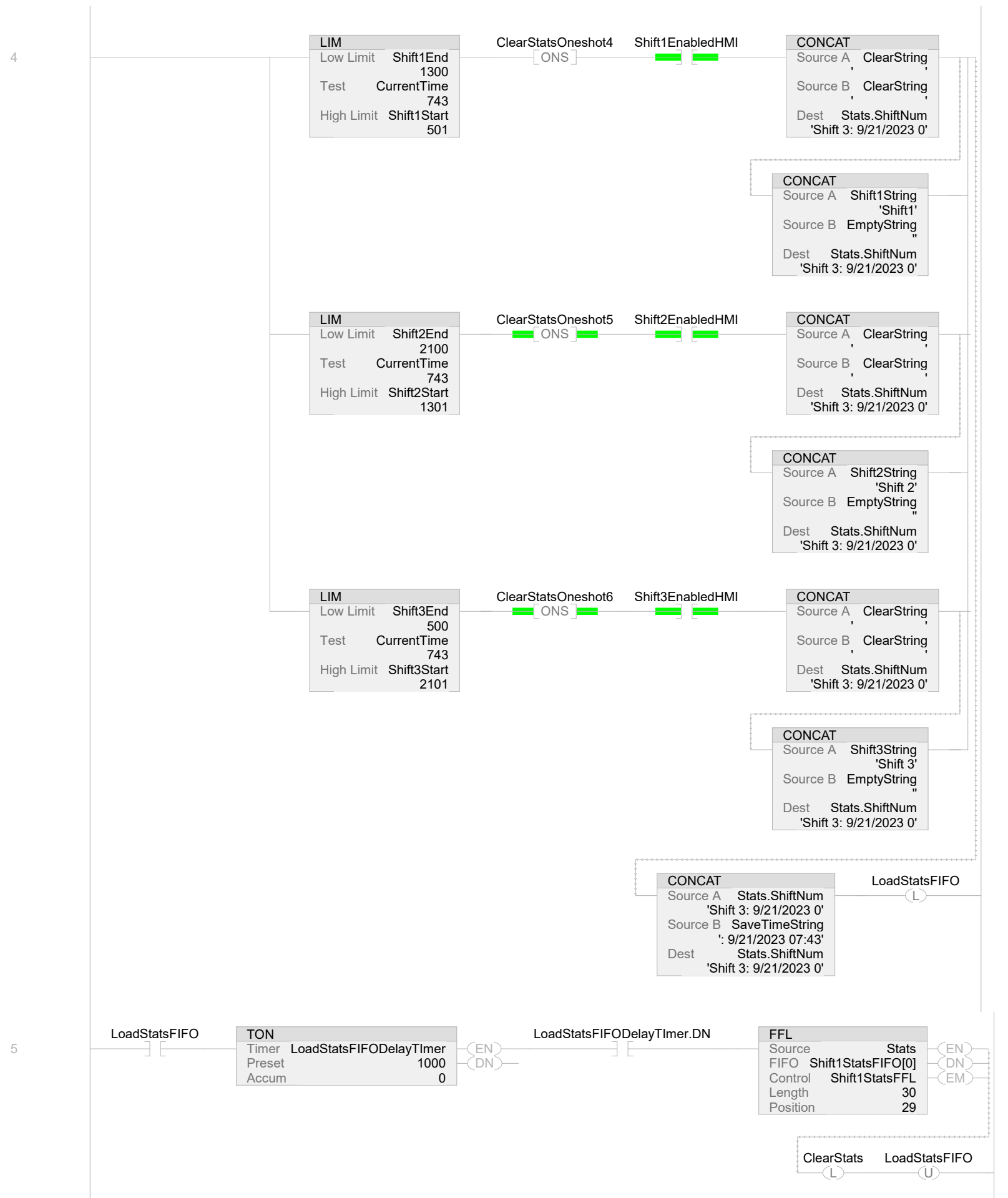












6

ClockUpdateTimer.DN

CONCAT		
Source A	EmptyString	"
Source B	ColonString	":"
Dest	SaveTimeString	': 9/21/2023 07:43'

CONCAT		
Source A	SaveTimeString	': 9/21/2023 07:43'
Source B	SpaceString	" "
Dest	SaveTimeString	': 9/21/2023 07:43'

DTOS		
Source	Stats.SaveTime.Month	9
Dest	TempString	'43'

CONCAT		
Source A	SaveTimeString	': 9/21/2023 07:43'
Source B	TempString	'43'
Dest	SaveTimeString	': 9/21/2023 07:43'

CONCAT		
Source A	SaveTimeString	': 9/21/2023 07:43'
Source B	HyphenString	'/'
Dest	SaveTimeString	': 9/21/2023 07:43'

DTOS		
Source	Stats.SaveTime.Day	21
Dest	TempString	'43'

CONCAT		
Source A	SaveTimeString	': 9/21/2023 07:43'
Source B	TempString	'43'
Dest	SaveTimeString	': 9/21/2023 07:43'

CONCAT		
Source A	SaveTimeString	': 9/21/2023 07:43'
Source B	HyphenString	'/'
Dest	SaveTimeString	': 9/21/2023 07:43'

DTOS		
Source	Stats.SaveTime.Year	2023
Dest	TempString	'43'

CONCAT		
Source A	SaveTimeString	': 9/21/2023 07:43'
Source B	TempString	'43'
Dest	SaveTimeString	': 9/21/2023 07:43'

CONCAT		
Source A	SaveTimeString	': 9/21/2023 07:43'
Source B	SpaceString	" "
Dest	SaveTimeString	': 9/21/2023 07:43'

GEQ		
Source A	Stats.SaveTime.Hour	7
Source B		10

DTOS		
Source	Stats.SaveTime.Hour	7
Dest	TempString	'43'

LES		
Source A	Stats.SaveTime.Hour	7
Source B		10

CONCAT		
Source A	SaveTimeString	': 9/21/2023 07:43'
Source B	ZeroString	'0'
Dest	SaveTimeString	': 9/21/2023 07:43'

CONCAT		
Source A	SaveTimeString	': 9/21/2023 07:43'
Source B	TempString	'43'
Dest	SaveTimeString	': 9/21/2023 07:43'

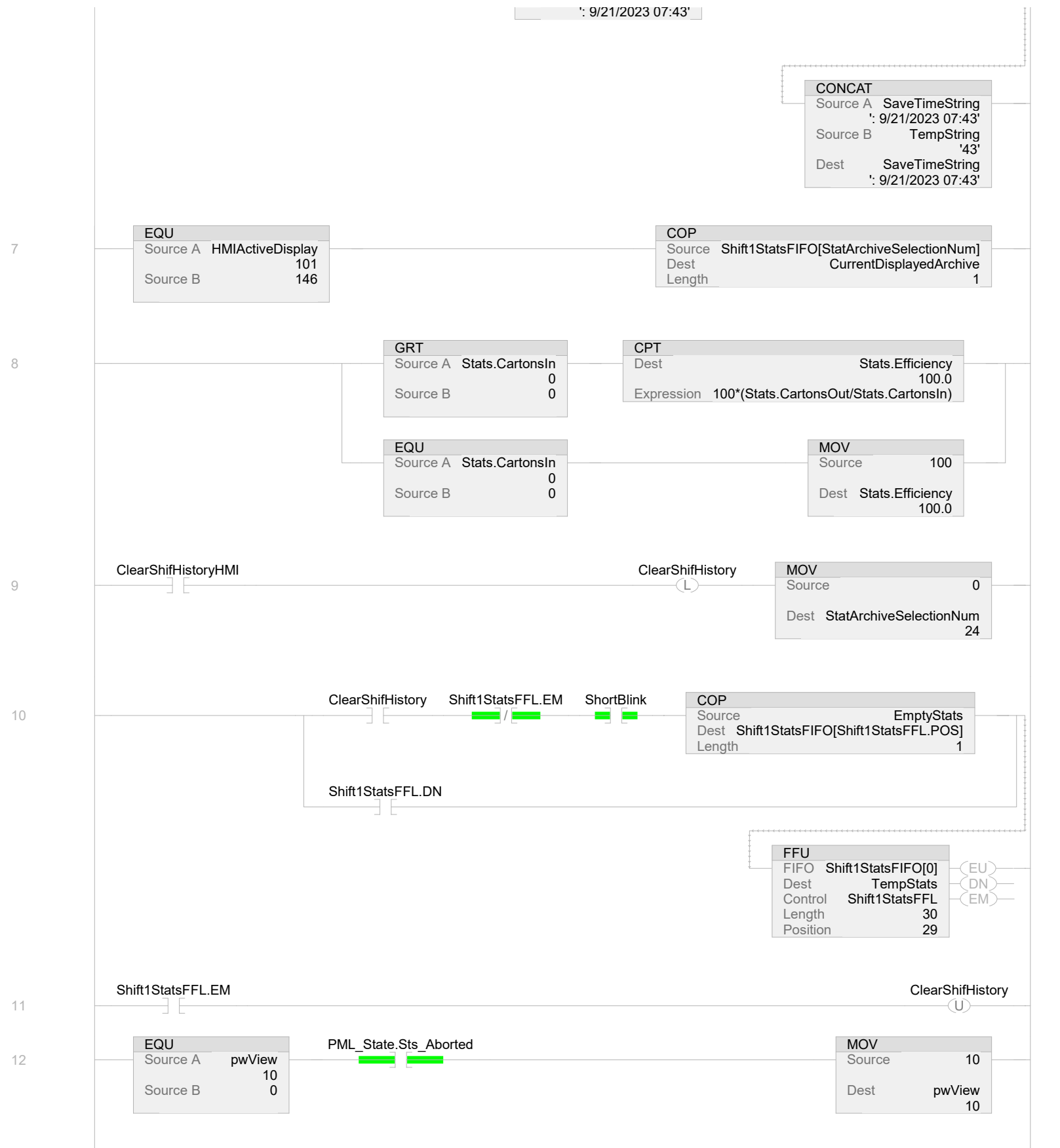
CONCAT		
Source A	SaveTimeString	': 9/21/2023 07:43'
Source B	ColonString	":"
Dest	SaveTimeString	': 9/21/2023 07:43'

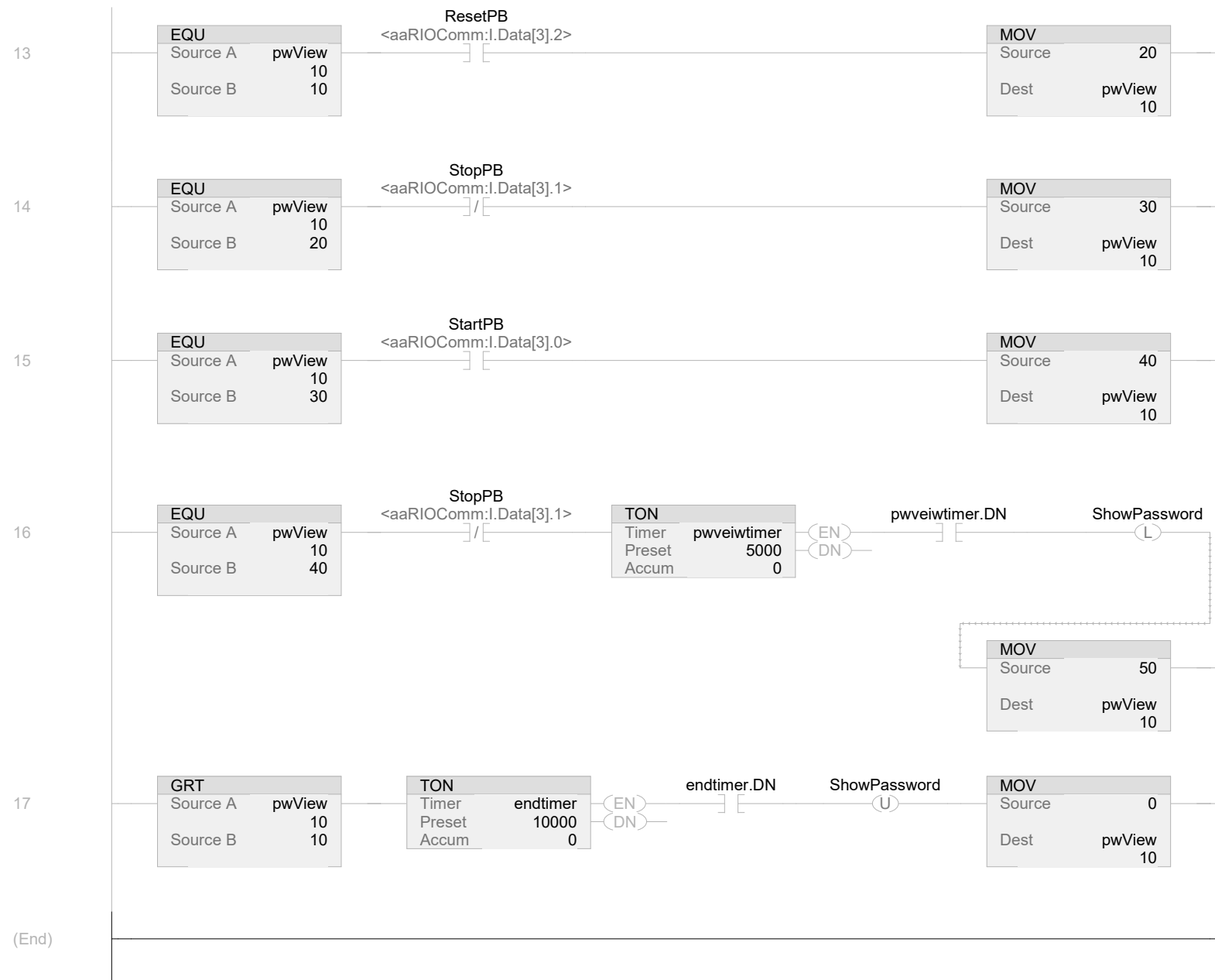
GEQ		
Source A	Stats.SaveTime.Minute	43
Source B		10

DTOS		
Source	Stats.SaveTime.Minute	43
Dest	TempString	'43'

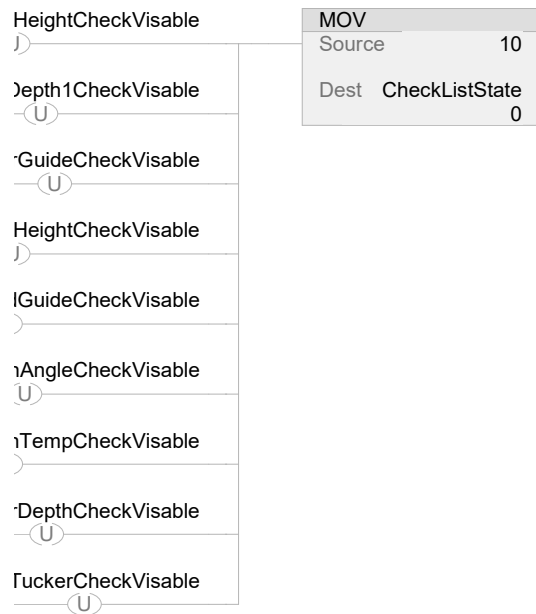
LES		
Source A	Stats.SaveTime.Minute	43
Source B		10

CONCAT		
Source A	SaveTimeString	': 9/21/2023 07:43'
Source B	ZeroString	'0'
Dest	SaveTimeString	': 9/21/2023 07:43'









10



2

EQU	
Source A	CheckListState
	0
Source B	20

MOV	
Source	20
Dest	CheckListState
	0

CONCAT	
Source A	ClearString
Source B	ClearString
Dest	CheckList.ChangedBy
	'me'

NEQ	
Source A	CurrentRecipe.GateNote
	'Red'
Source B	PrevRecipe.GateNote
	'Red'

GateCheckVisable
(L)

NEQ	
Source A	CurrentRecipe.FeederHeight
	60.0
Source B	PrevRecipe.FeederHeight
	60.0

FeederHeightCheckVisable
(L)

NEQ	
Source A	CurrentRecipe.DepthOfInsertion
	245.0
Source B	PrevRecipe.DepthOfInsertion
	245.0

DepthOfInserionCheckVisable
(L)

NEQ	
Source A	CurrentRecipe.LoadSideOverheadGuideHeight
	60.0
Source B	PrevRecipe.LoadSideOverheadGuideHeight
	60.0

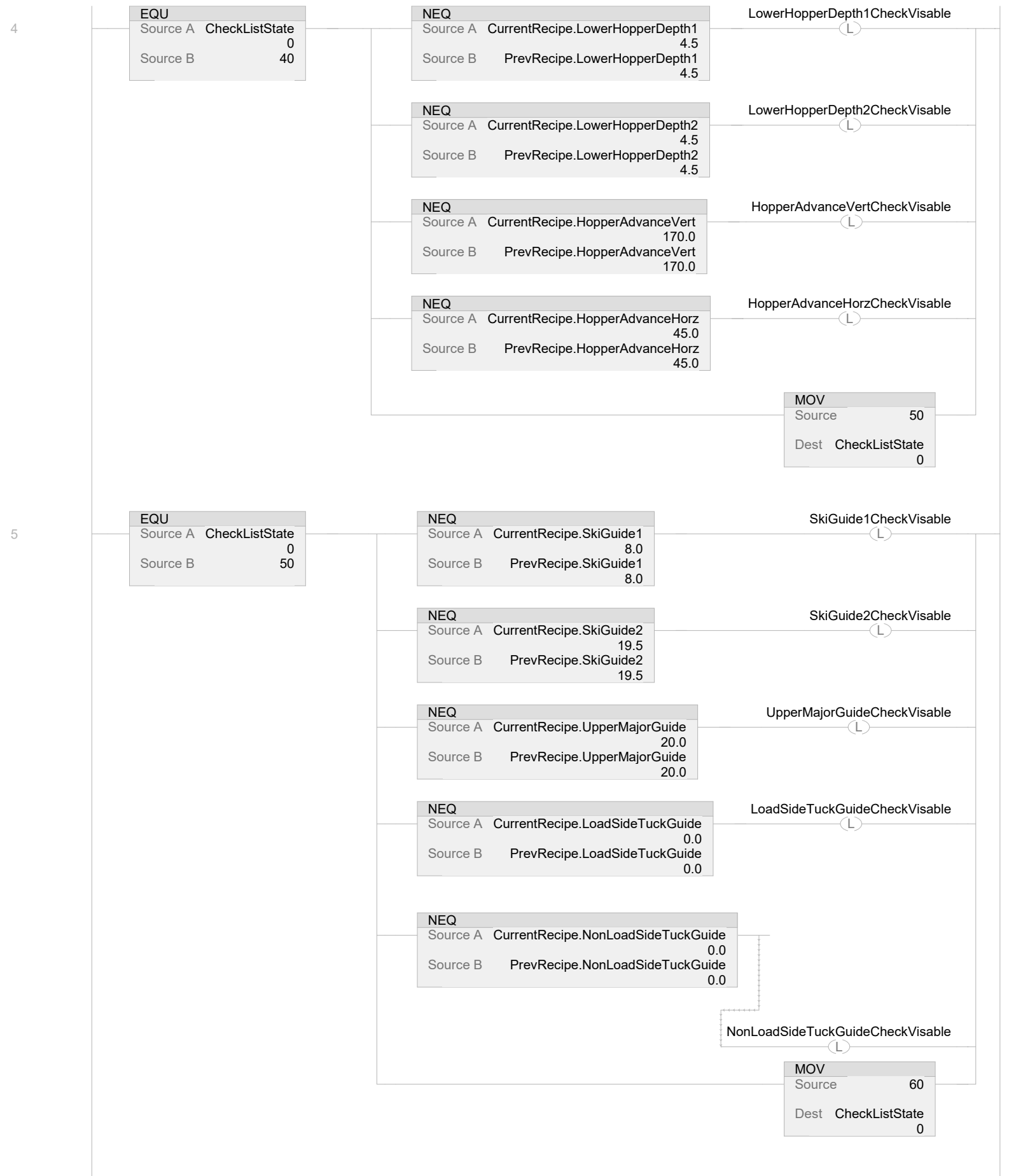
LSOverheadGuideHeightCheckVisable
(L)

NEQ	
Source A	CurrentRecipe.NonLoadSideOverheadGuideHeight
	60.0
Source B	PrevRecipe.NonLoadSideOverheadGuideHeight
	60.0

NLSOverheadGuideHeightCheckVisable
(L)

MOV	
Source	30
Dest	CheckListState
	0





6

EQU		
Source A	CheckListState	0
Source B		60

NEQ		
Source A	CurrentRecipe.NonLoadSidePlowDownGuideHeight	1.0
Source B	PrevRecipe.NonLoadSidePlowDownGuideHeight	1.0

NLSPlowDownGuideHeightCheckVisable
(L)

NEQ		
Source A	CurrentRecipe.LoadSidePlowDownGuideHeight	1.0
Source B	PrevRecipe.LoadSidePlowDownGuideHeight	1.0

LSPlowDownGuideHeightCheckVisable
(L)

NEQ		
Source A	CurrentRecipe.NonLoadSideOverheadGuideHeight	60.0
Source B	PrevRecipe.NonLoadSideOverheadGuideHeight	60.0

NonLoadSideOverheadGuideCheckVisable
(L)

NEQ		
Source A	CurrentRecipe.LoadSideOverheadGuideHeight	60.0
Source B	PrevRecipe.LoadSideOverheadGuideHeight	60.0

LoadSideOverheadGuideCheckVisable
(L)

NEQ		
Source A	CurrentRecipe.NonLoadSideUpstreamOverheadGuideHeight	6.0
Source B	PrevRecipe.NonLoadSideUpstreamOverheadGuideHeight	6.0

NLSUpstreamOverheadGuideCheckVisable
(L)

MOV		
Source		70
Dest	CheckListState	0

7

EQU		
Source A	CheckListState	0
Source B		70

NEQ		
Source A	CurrentRecipe.NonLoadSidePlowDownGuideHeight	1.0
Source B	PrevRecipe.NonLoadSidePlowDownGuideHeight	1.0

NonLoadSidePlowDownGuideCheckVisable
L

NEQ		
Source A	CurrentRecipe.LoadSidePlowDownGuideHeight	1.0
Source B	PrevRecipe.LoadSidePlowDownGuideHeight	1.0

LoadSidePlowDownGuideCheckVisable
L

NEQ		
Source A	CurrentRecipe.NonLoadSideOverheadGuideHeight	60.0
Source B	PrevRecipe.NonLoadSideOverheadGuideHeight	60.0

NonLoadSideOverheadGuideCheckVisable
L

NEQ		
Source A	CurrentRecipe.LoadSideOverheadGuideHeight	60.0
Source B	PrevRecipe.LoadSideOverheadGuideHeight	60.0

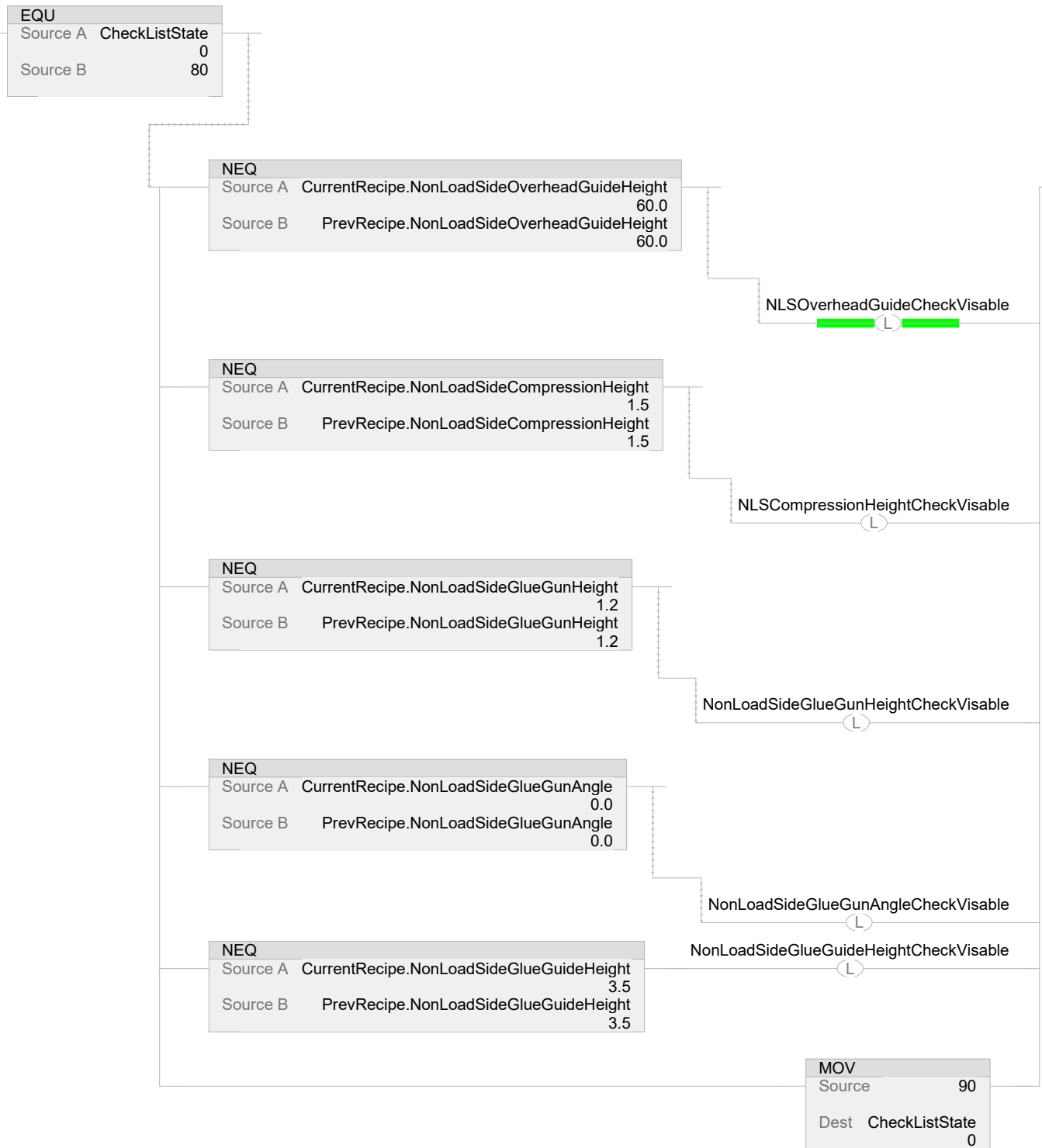
LoadSideOverheadGuideCheckVisable
L

NEQ		
Source A	CurrentRecipe.NonLoadSideUpstreamOverheadGuideHeight	6.0
Source B	PrevRecipe.NonLoadSideUpstreamOverheadGuideHeight	6.0

NLSUpstreamOverheadGuideCheckVisable
L

MOV		
Source		80
Dest	CheckListState	0

8









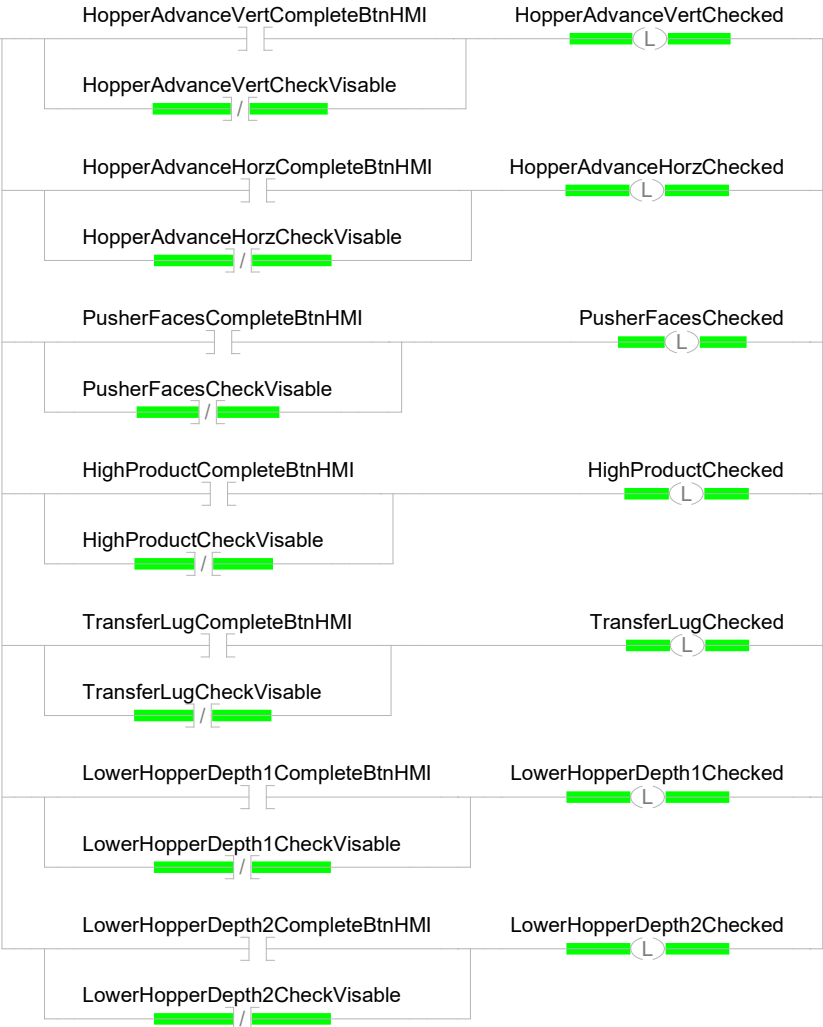
12

EQU		
Source A	CheckListState	0
Source B		120



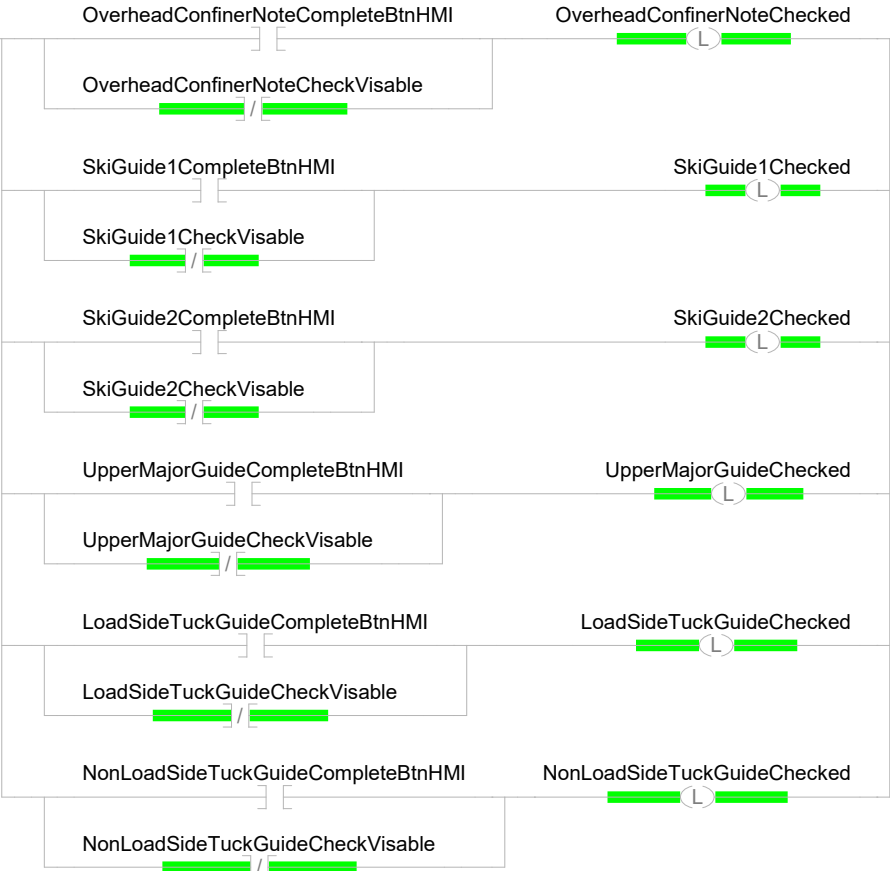
13

EQU	
Source A	CheckListState
	0
Source B	120



14

EQU		
Source A	CheckListState	0
Source B		120



15

EQU		
Source A	CheckListState	0
Source B		120



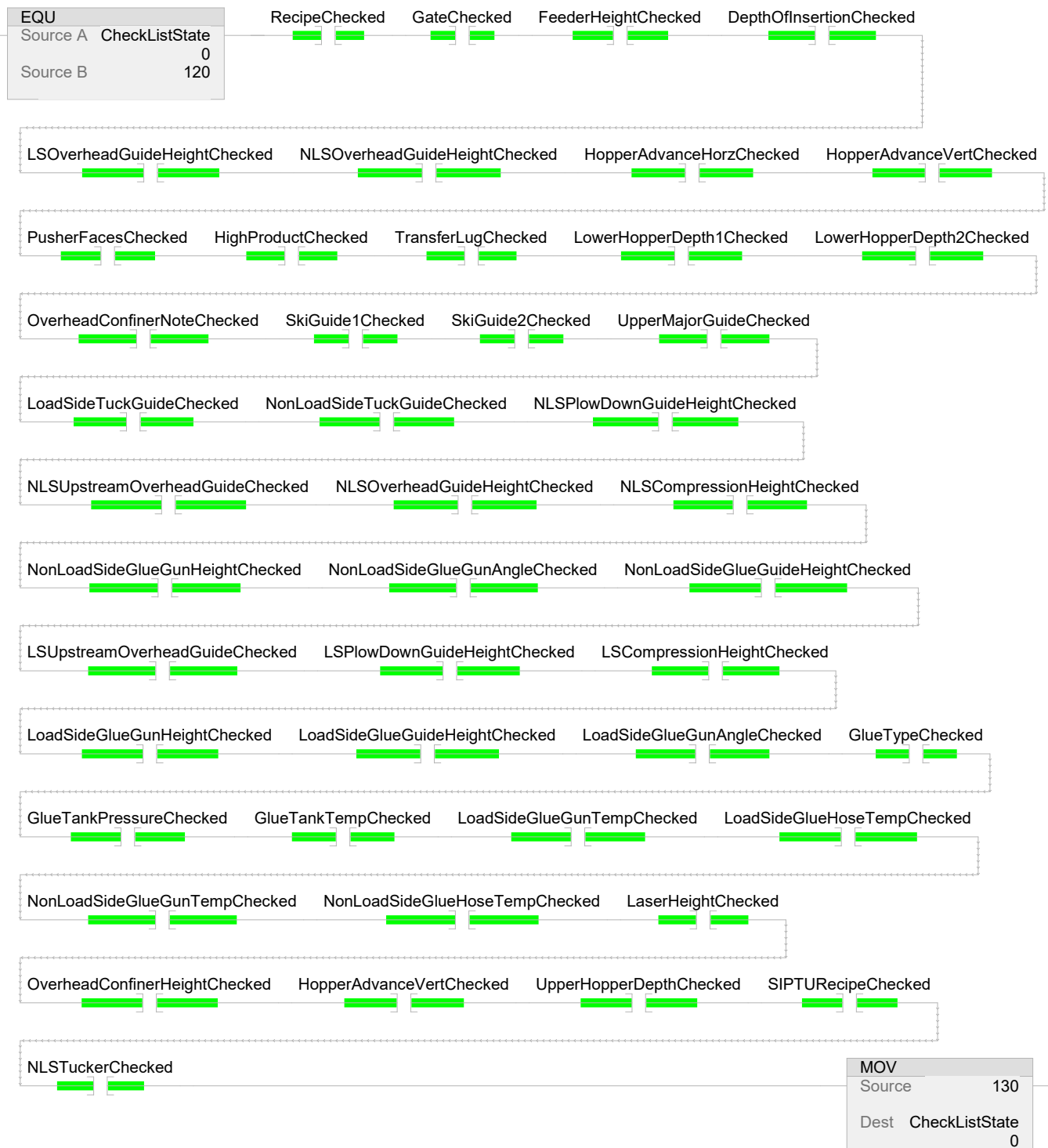


18

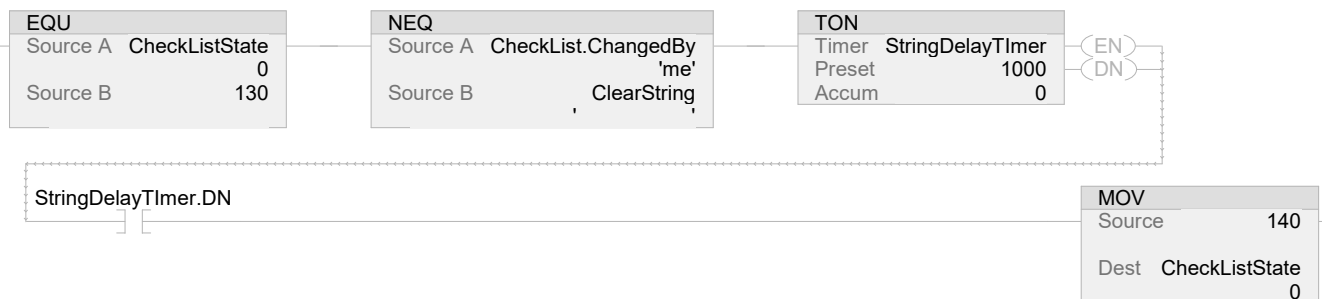
EQU	
Source A	CheckListState
	0
Source B	120



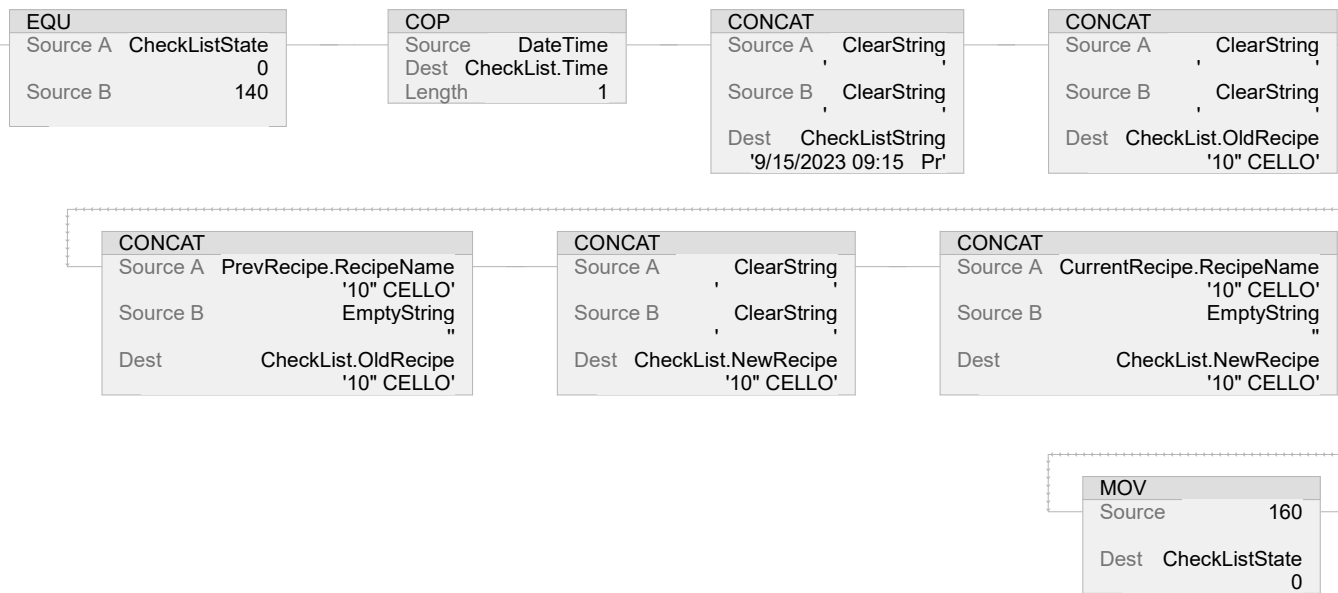
19



20



21



22

EQU		
Source A	CheckListState	
		0
Source B		160

DTOS		
Source	CheckList.Time.Month	
		9
Dest	TempString	'43'

CONCAT		
Source A	BlankString	
		"
Source B	TempString	'43'
Dest	CheckListString	'9/15/2023 09:15 Pr'

CONCAT		
Source A	CheckListString	'9/15/2023 09:15 Pr'
Source B	HyphenString	'/'
Dest	CheckListString	'9/15/2023 09:15 Pr'

DTOS		
Source	CheckList.Time.Day	
		15
Dest	TempString	'43'

CONCAT		
Source A	CheckListString	'9/15/2023 09:15 Pr'
Source B	TempString	'43'
Dest	CheckListString	'9/15/2023 09:15 Pr'

CONCAT		
Source A	CheckListString	'9/15/2023 09:15 Pr'
Source B	HyphenString	'/'
Dest	CheckListString	'9/15/2023 09:15 Pr'

DTOS		
Source	CheckList.Time.Year	
		2023
Dest	TempString	'43'

CONCAT		
Source A	CheckListString	'9/15/2023 09:15 Pr'
Source B	TempString	'43'
Dest	CheckListString	'9/15/2023 09:15 Pr'

CONCAT		
Source A	CheckListString	'9/15/2023 09:15 Pr'
Source B	SpaceString	' '
Dest	CheckListString	'9/15/2023 09:15 Pr'

GEQ		
Source A	CheckList.Time.Hour	
		9
Source B		10

LES		
Source A	CheckList.Time.Hour	
		9
Source B		10

CONCAT		
Source A	CheckListString	'9/15/2023 09:15 Pr'
Source B	ZeroString	'0'
Dest	CheckListString	'9/15/2023 09:15 Pr'

DTOS		
Source	CheckList.Time.Hour	
		9
Dest	TempString	'43'

CONCAT		
Source A	CheckListString	'9/15/2023 09:15 Pr'
Source B	TempString	'43'
Dest	CheckListString	'9/15/2023 09:15 Pr'

CONCAT		
Source A	CheckListString	'9/15/2023 09:15 Pr'
Source B	ColonString	':'
Dest	CheckListString	'9/15/2023 09:15 Pr'

GEQ		
Source A	CheckList.Time.Minute	
		15
Source B		10

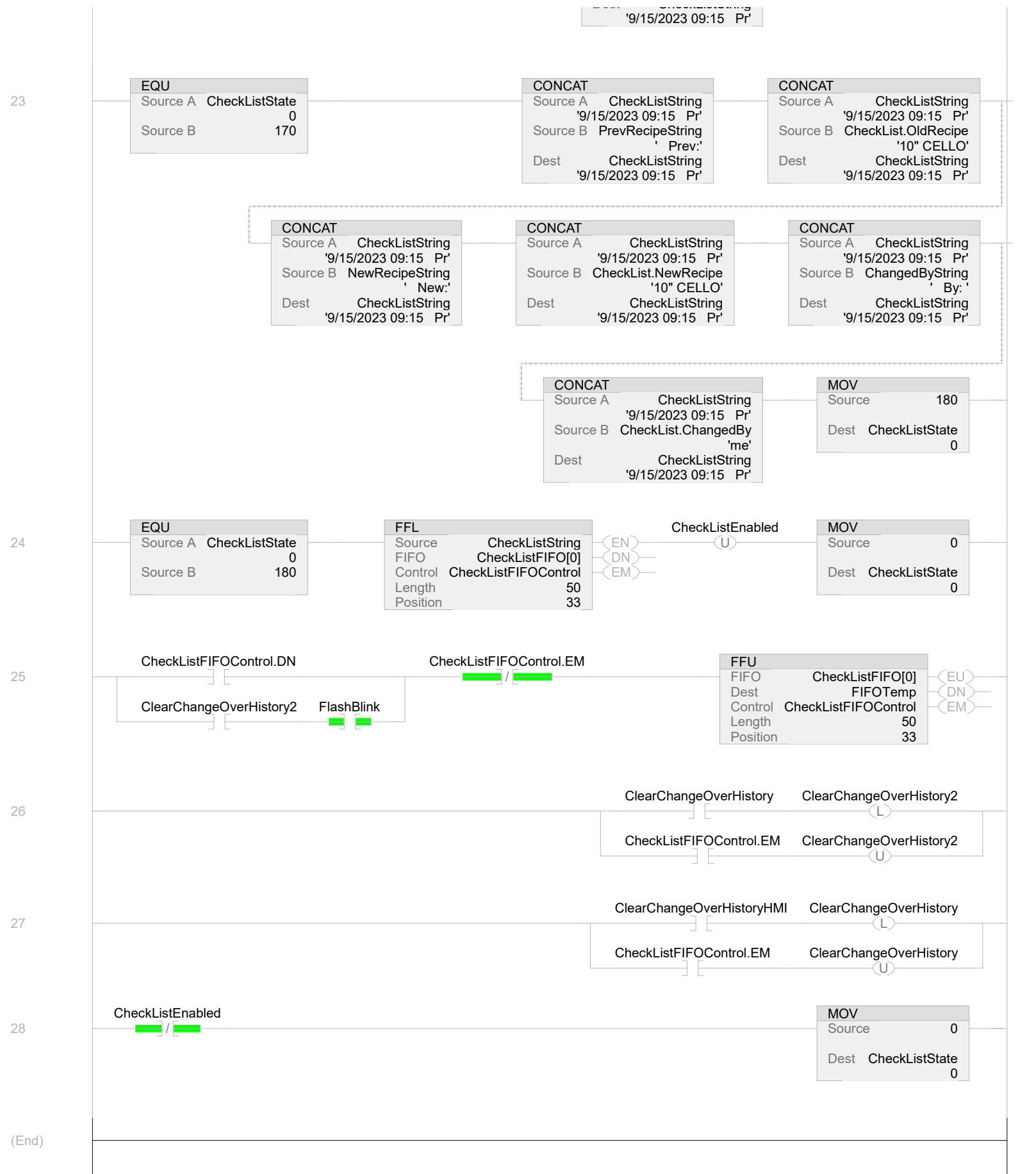
DTOS		
Source	CheckList.Time.Minute	
		15
Dest	TempString	'43'

LES		
Source A	CheckList.Time.Minute	
		15
Source B		10

CONCAT		
Source A	CheckListString	'9/15/2023 09:15 Pr'
Source B	ZeroString	'0'
Dest	CheckListString	'9/15/2023 09:15 Pr'

CONCAT		
Source A	CheckListString	'9/15/2023 09:15 Pr'
Source B	TempString	'43'
Dest	CheckListString	

MOV		
Source		170
Dest	CheckListState	0





HMI_9_Inch_Pitch_Selected

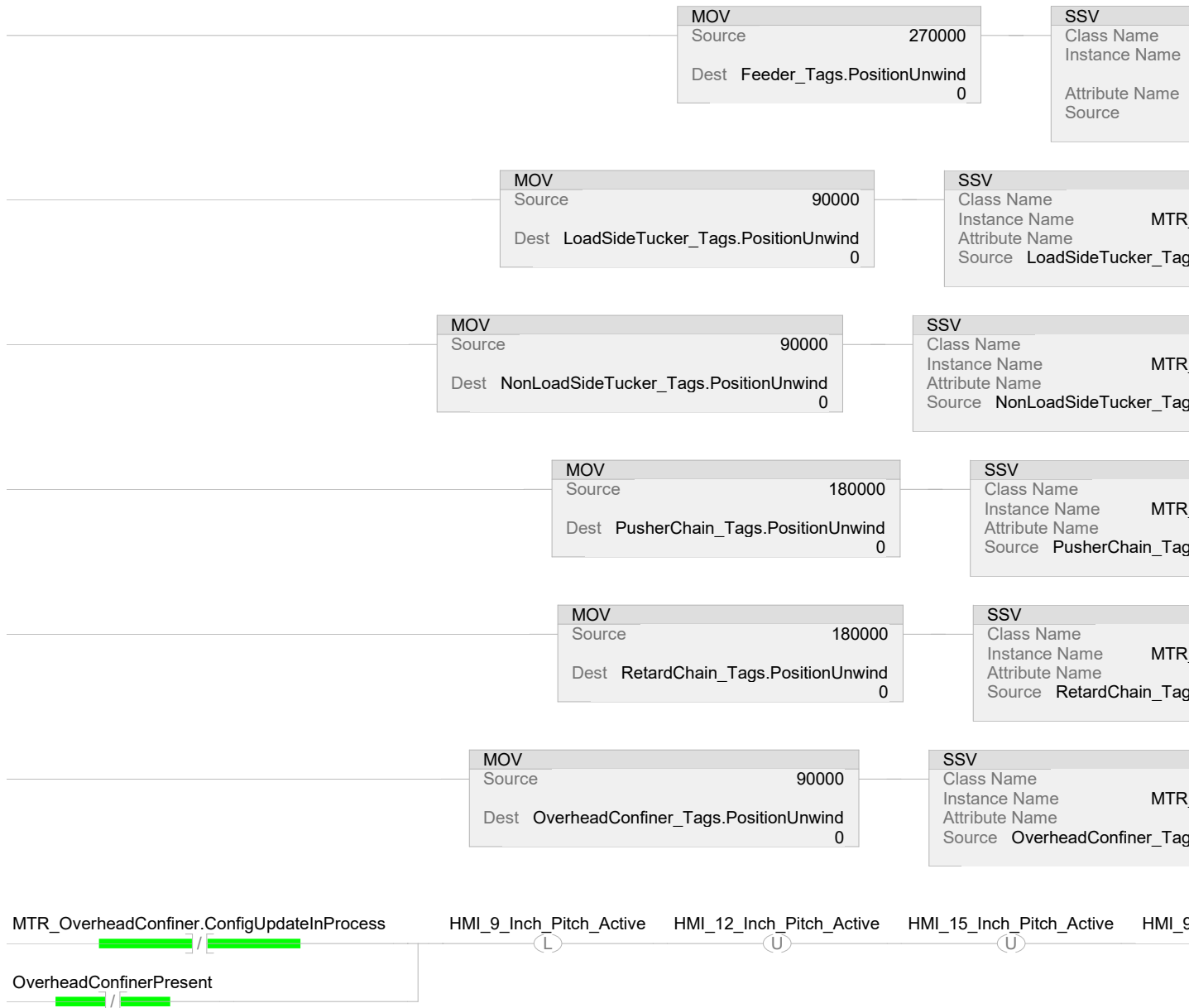
HMI_9_Inch_Pitch_Active

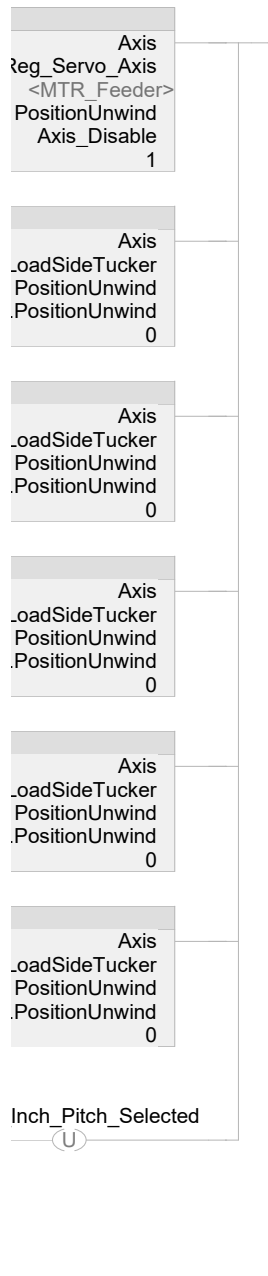
Reg_Servo_Axis.ConfigUpdateInProgress
<MTR_Feeder.ConfigUpdateInProgress>

<MTR_Feeder.ConfigUpdateInProgress>

MTR_LoadSideTucker.ConfigUpdateInProce:

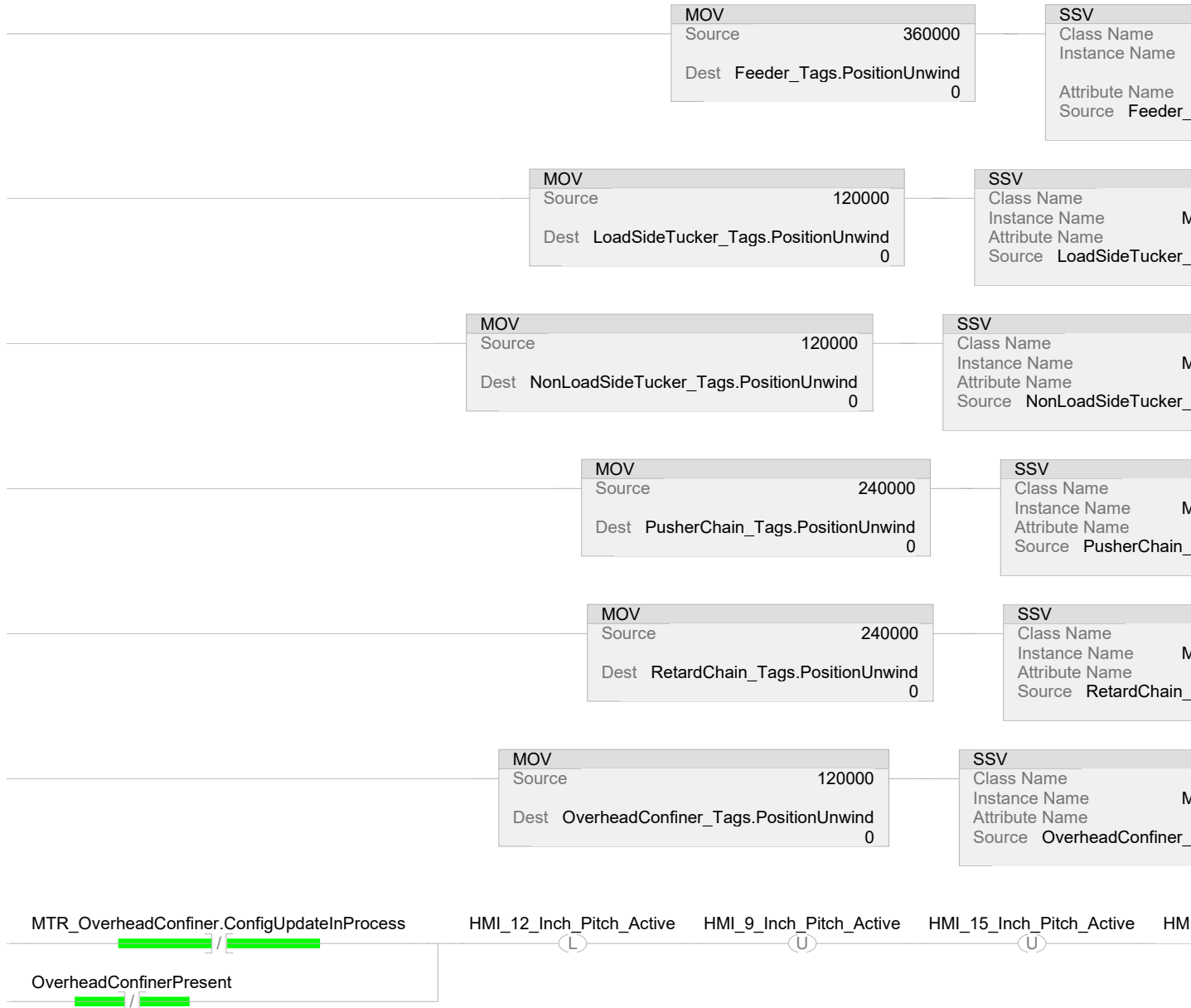
; MTR_NonLoadSideTucker.ConfigUpdateInProgress MTR_PusherChain.ConfigUpdateInProgress MTR_RetardChain.ConfigUpdateInProgress

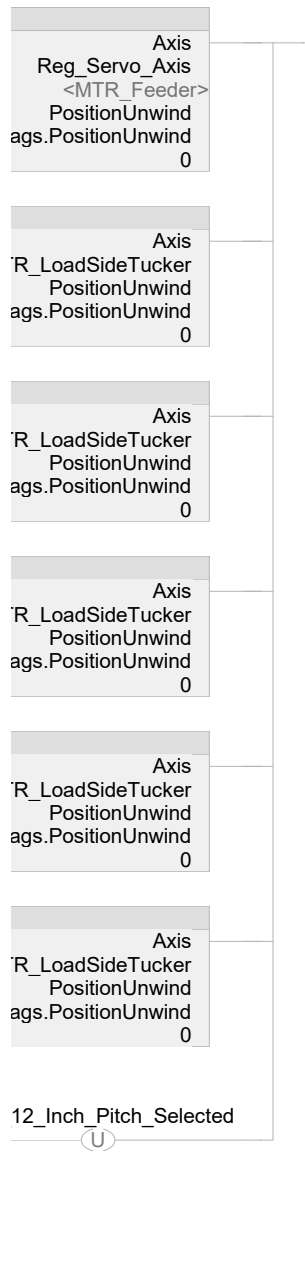






ess	MTR_NonLoadSideTucker.ConfigUpdateInProcess	MTR_PusherChain.ConfigUpdateInProcess	MTR_RetardChain.ConfigUpdateInProcess
			




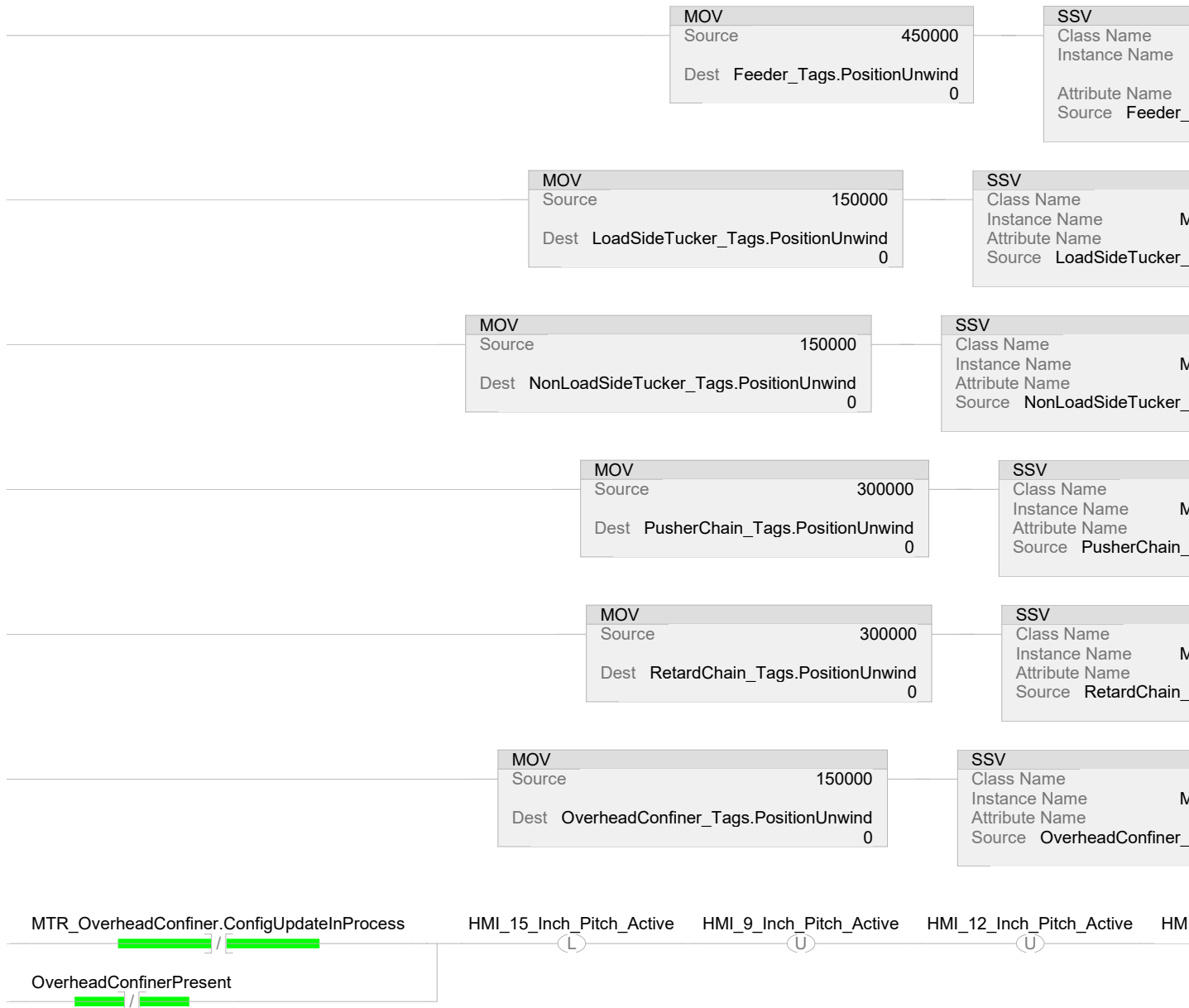


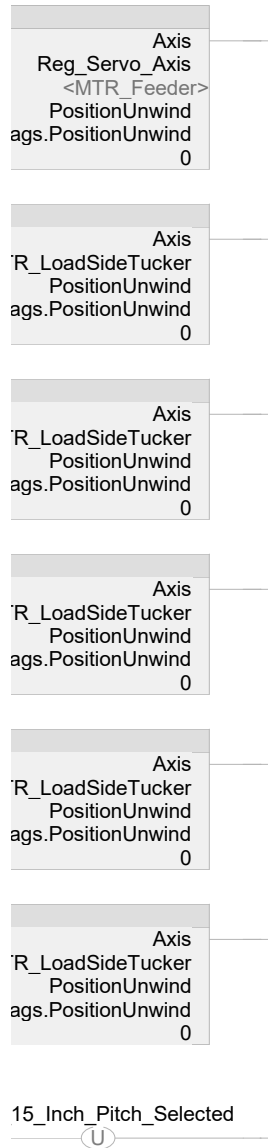
6

HMI_15_Inch_Pitch_Selected HMI_15_Inch_Pitch_Active

Reg_Servo_Axis.ConfigUpdateInProgress
<MTR_Feeder.ConfigUpdateInProgress> MTR_LoadSideTucker.ConfigUpdateInPro

ess	MTR_NonLoadSideTucker.ConfigUpdateInProcess	MTR_PusherChain.ConfigUpdateInProcess	MTR_RetardChain.ConfigUpdateInProcess
	 / 	 / 	 / 

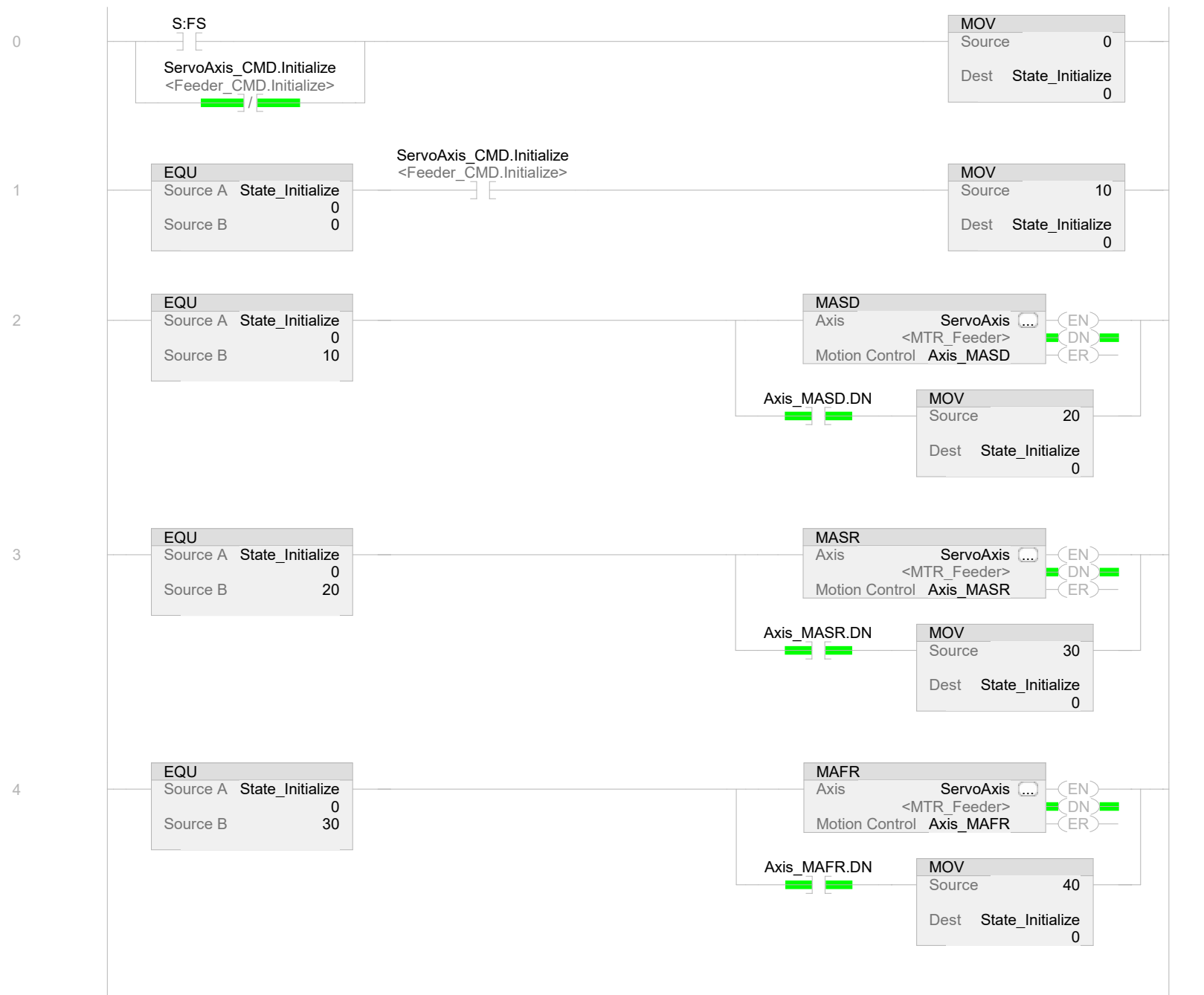


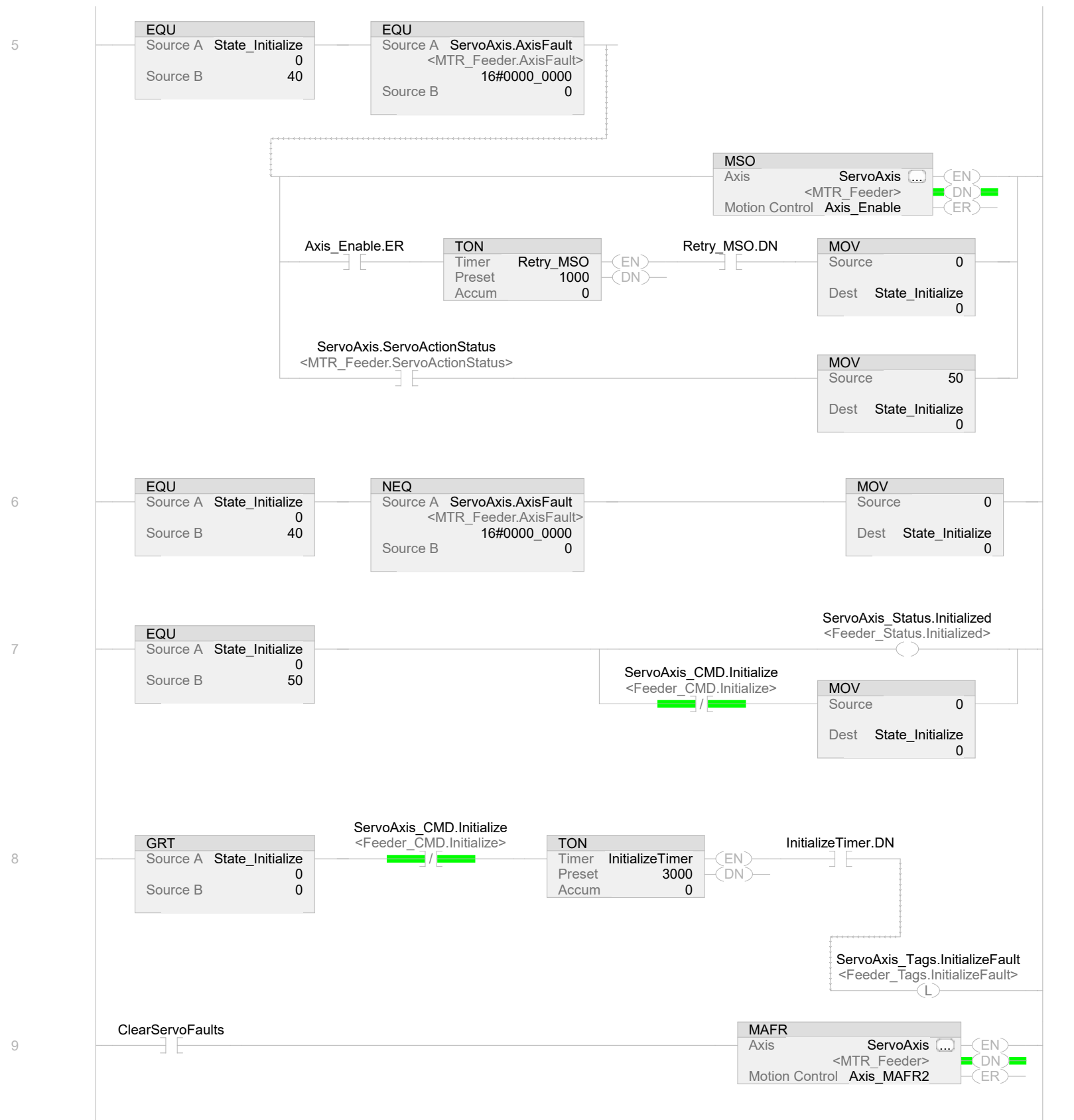


7

(End)















3

EQU	
Source A	State_Cam
	0
Source B	20

SUB	
Source A	TargetSlavePosition
	9.605844
Source B	MODFeederPosition
	10.6311
Dest	AxisMoveDist
	1.5615435

MUL	
Source A	MachinePitch
	12.0
Source B	0.5
Dest	FeederPosTolerance
	6.0

MUL	
Source A	MachinePitch
	12.0
Source B	-0.5
Dest	FeederNegTolerance
	-6.0

GRT	
Source A	AxisMoveDist
	1.5615435
Source B	FeederPosTolerance
	6.0

SUB	
Source A	AxisMoveDist
	1.5615435
Source B	MachinePitch
	12.0
Dest	AxisMoveDist
	1.5615435

LES	
Source A	AxisMoveDist
	1.5615435
Source B	FeederNegTolerance
	-6.0

ADD	
Source A	AxisMoveDist
	1.5615435
Source B	MachinePitch
	12.0
Dest	AxisMoveDist
	1.5615435

LIM	
Low Limit	FeederNegTolerance
	-6.0
Test	AxisMoveDist
	1.5615435
High Limit	FeederPosTolerance
	6.0

MOV	
Source	30
Dest	State_Cam
	0

4

EQU

Source A	State_Cam
	0
Source B	30

MAM

Axis	ServoAxis	(EN)
Motion Control	<MTR_Feeder>	
Move Type	MAM_command	(DN)
	Incremental	
Position	1	(ER)
	AxisMoveDist	
	1.5615435	(IP)
Speed	AxisMoveSpeed	
	2.0	(PC)
Speed Units	Units per sec	
Accel Rate	AxisAccelRate	
	2.0	
Accel Units	Units per sec2	
Decel Rate	AxisDecelRate	
	2.0	
Decel Units	Units per sec2	
Profile	S-Curve	
Accel Jerk	100.0	
Decel Jerk	100.0	
Jerk Units	% of Time	
Merge	Disabled	
Merge Speed	Programmed	
Lock Position	0	
Lock Direction	None	
Event Distance	0	
Calculated Data	0	

MAM_command.IP

MAM_command.PC

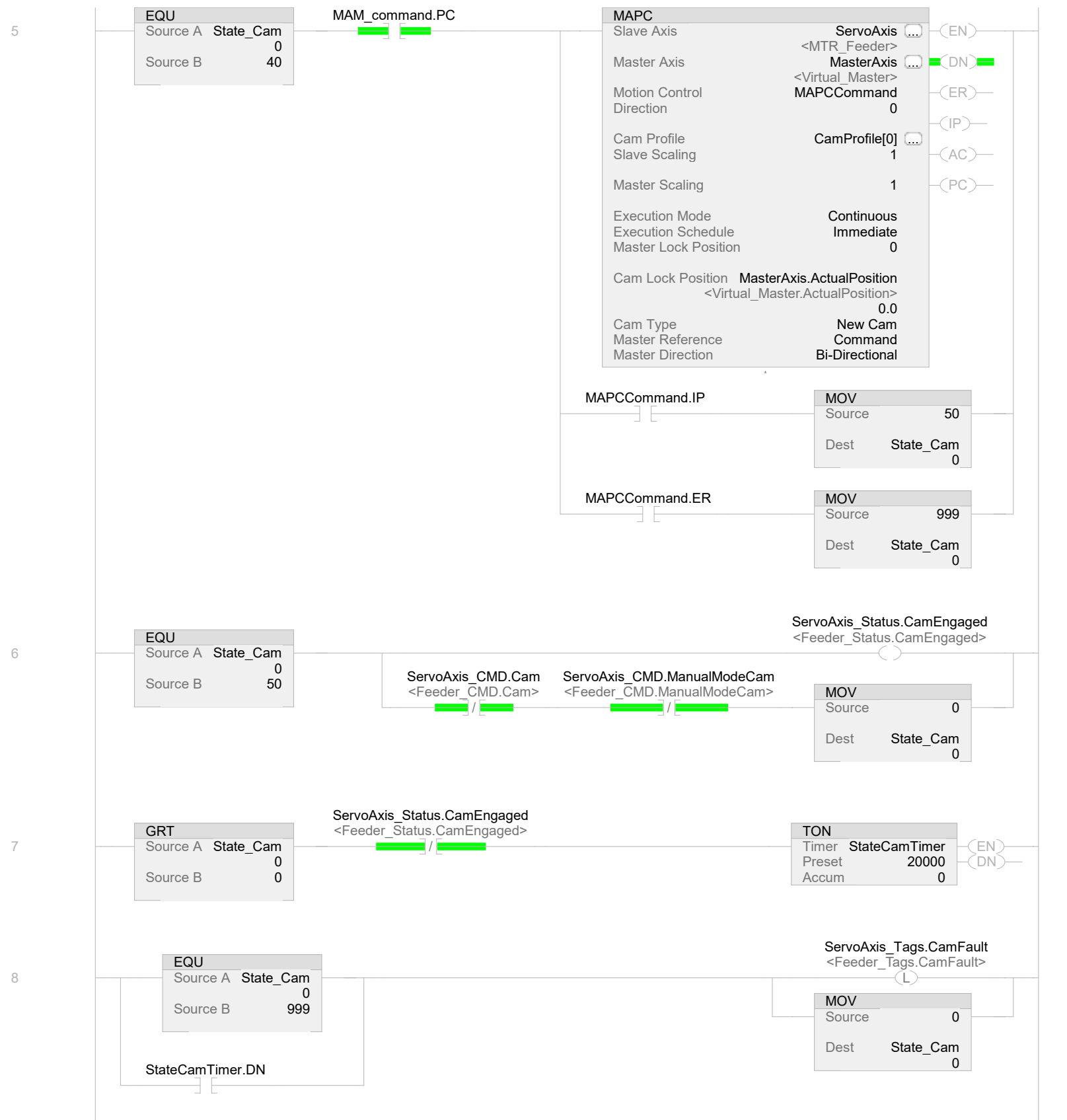
MAM_command.ER

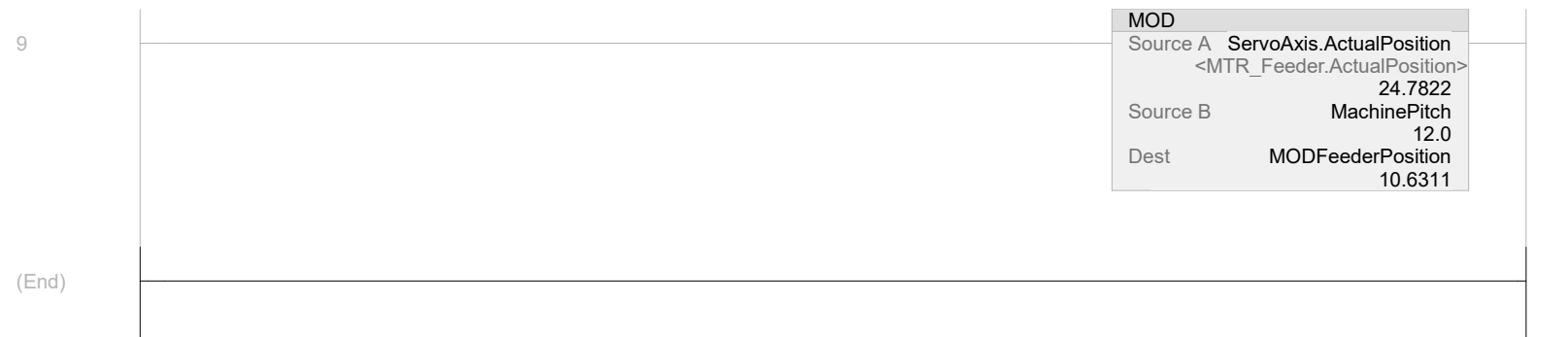
MOV

Source	40
Dest	State_Cam
	0

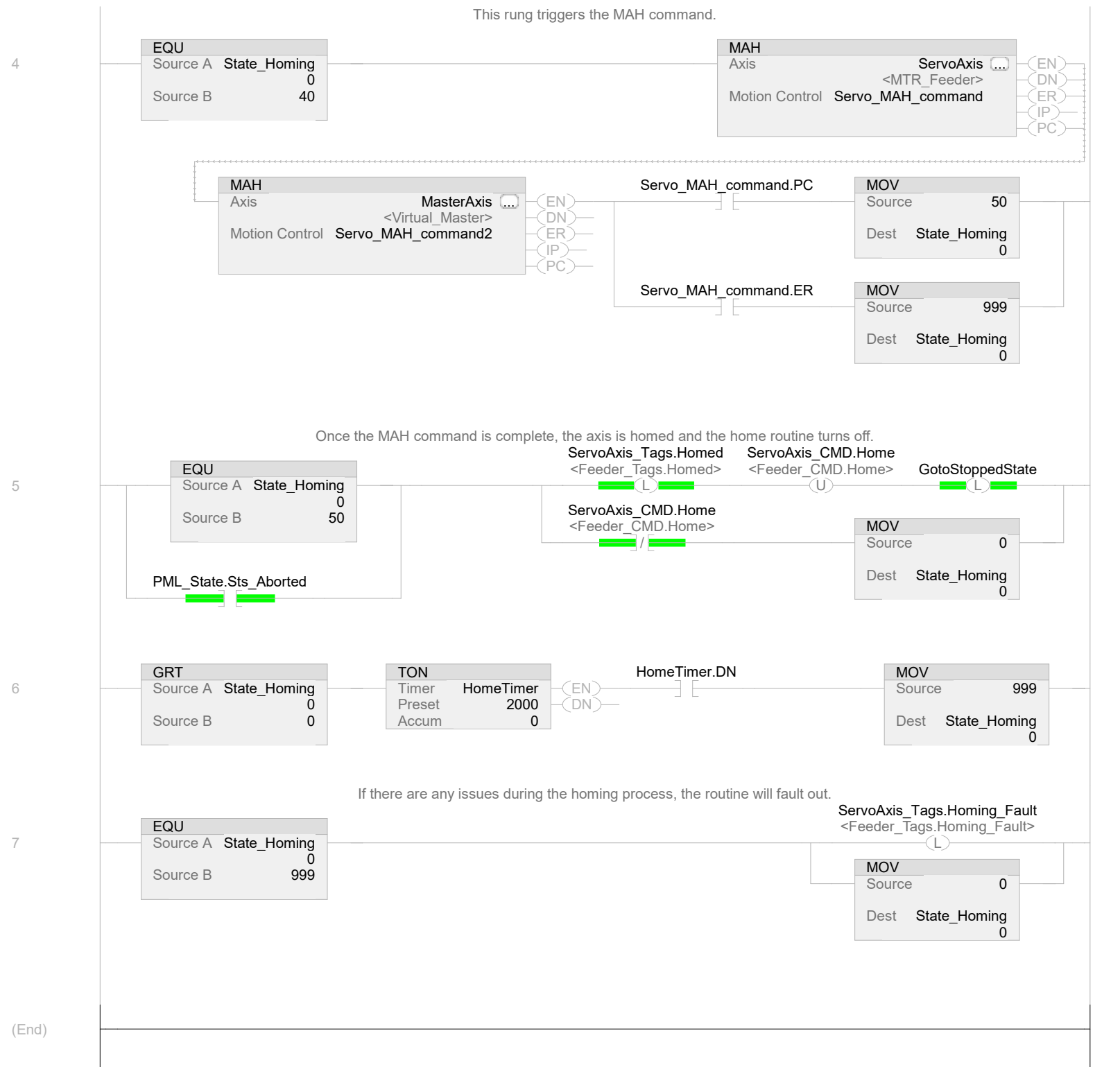
MOV

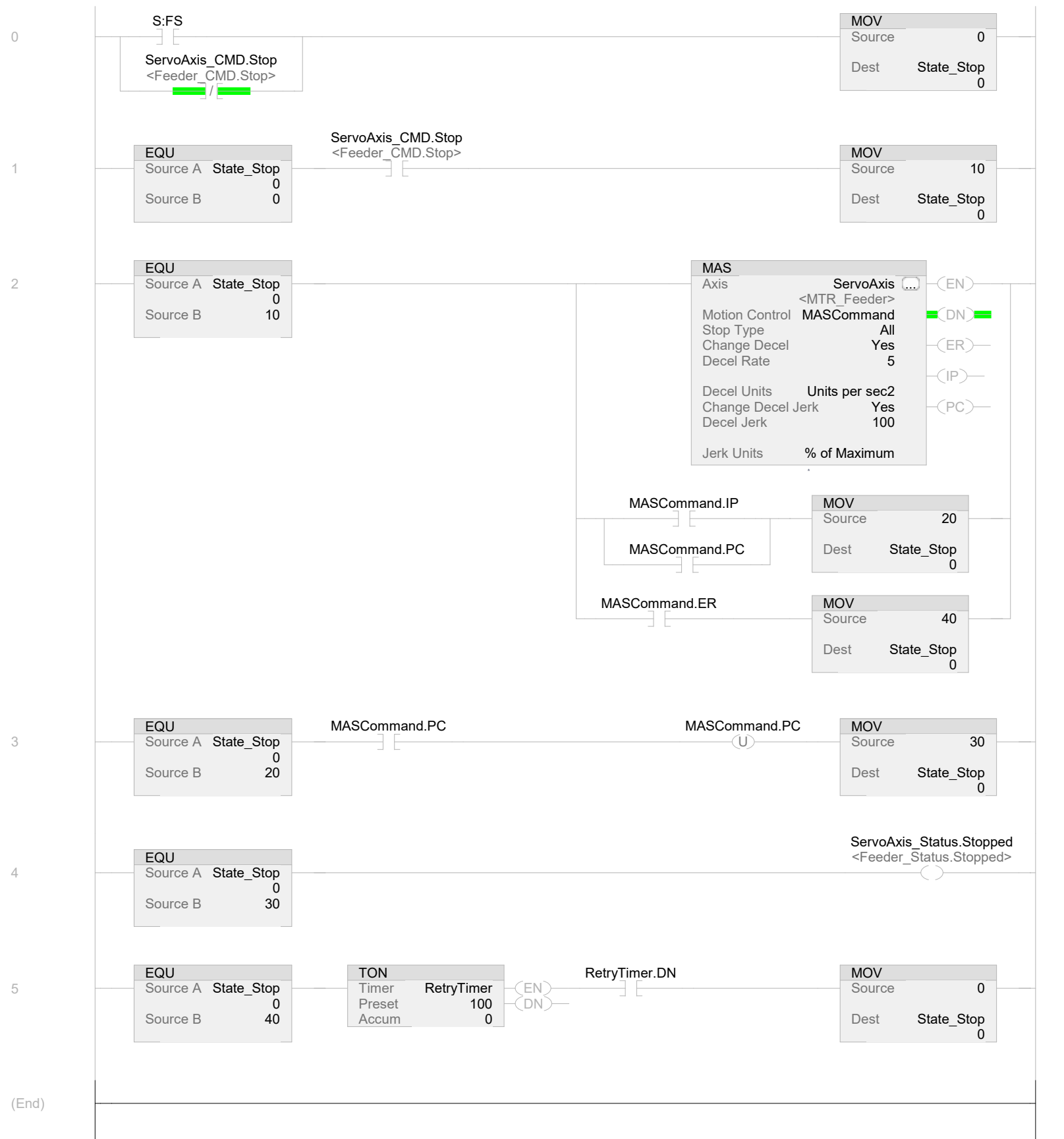
Source	999
Dest	State_Cam
	0

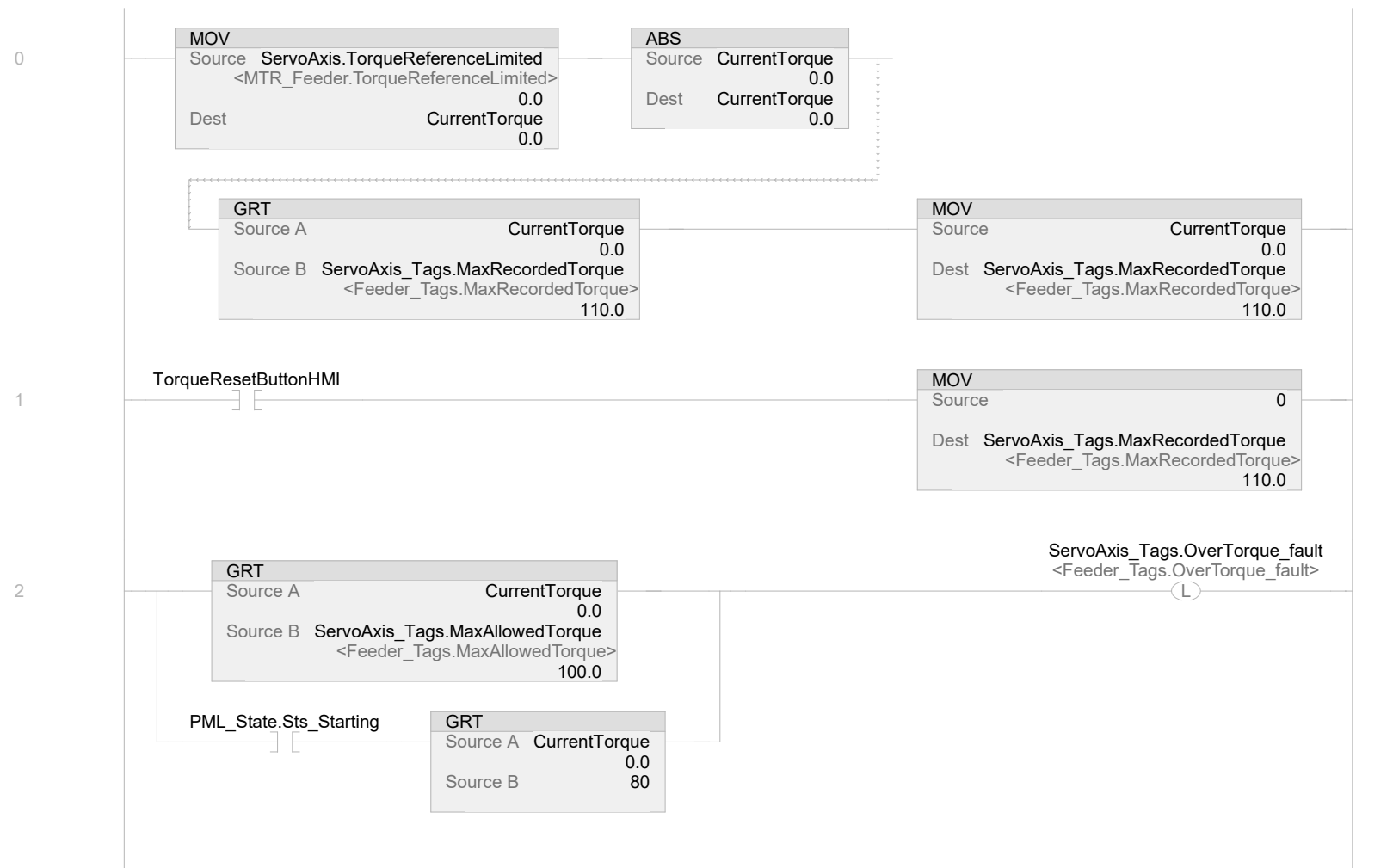


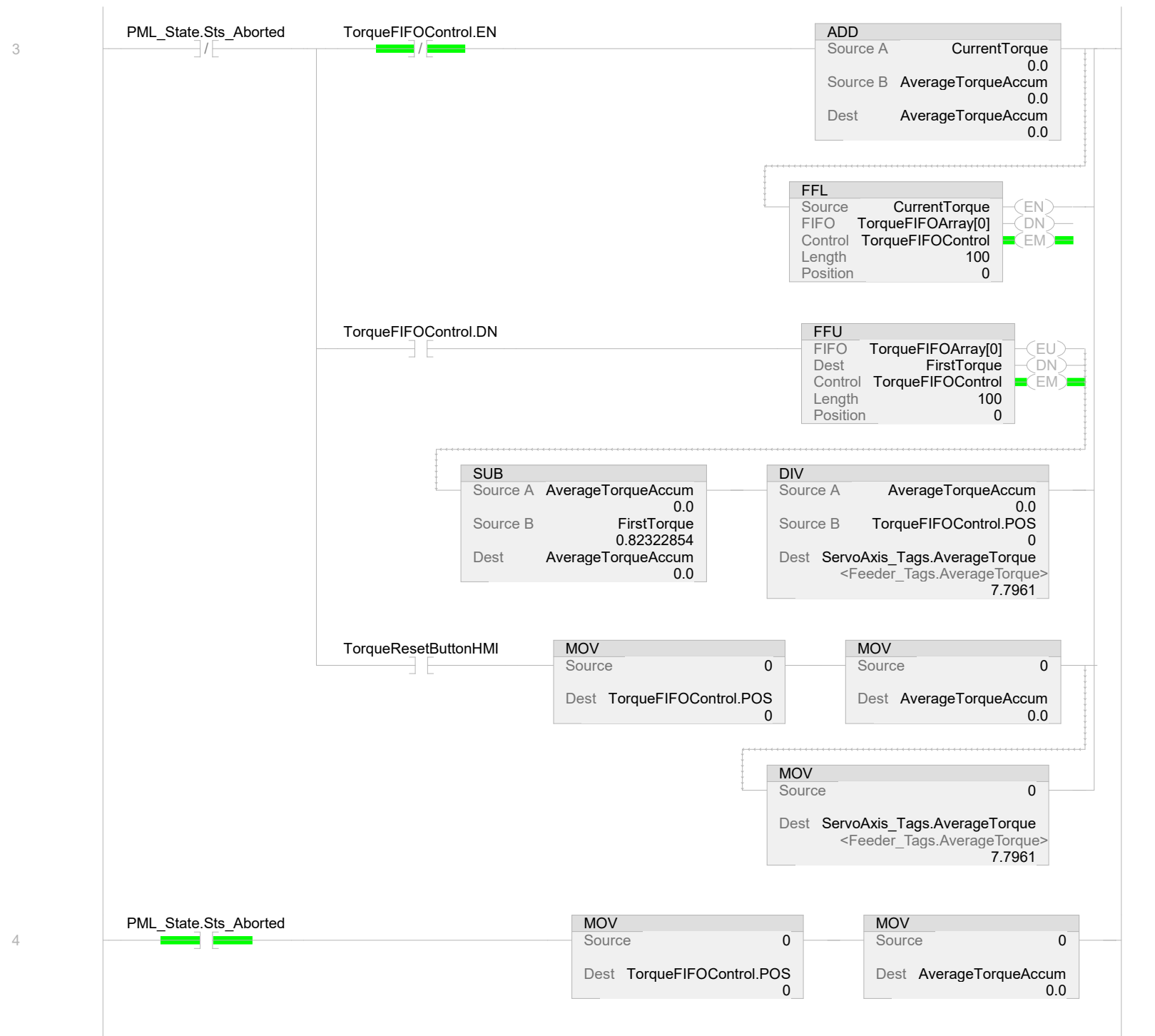








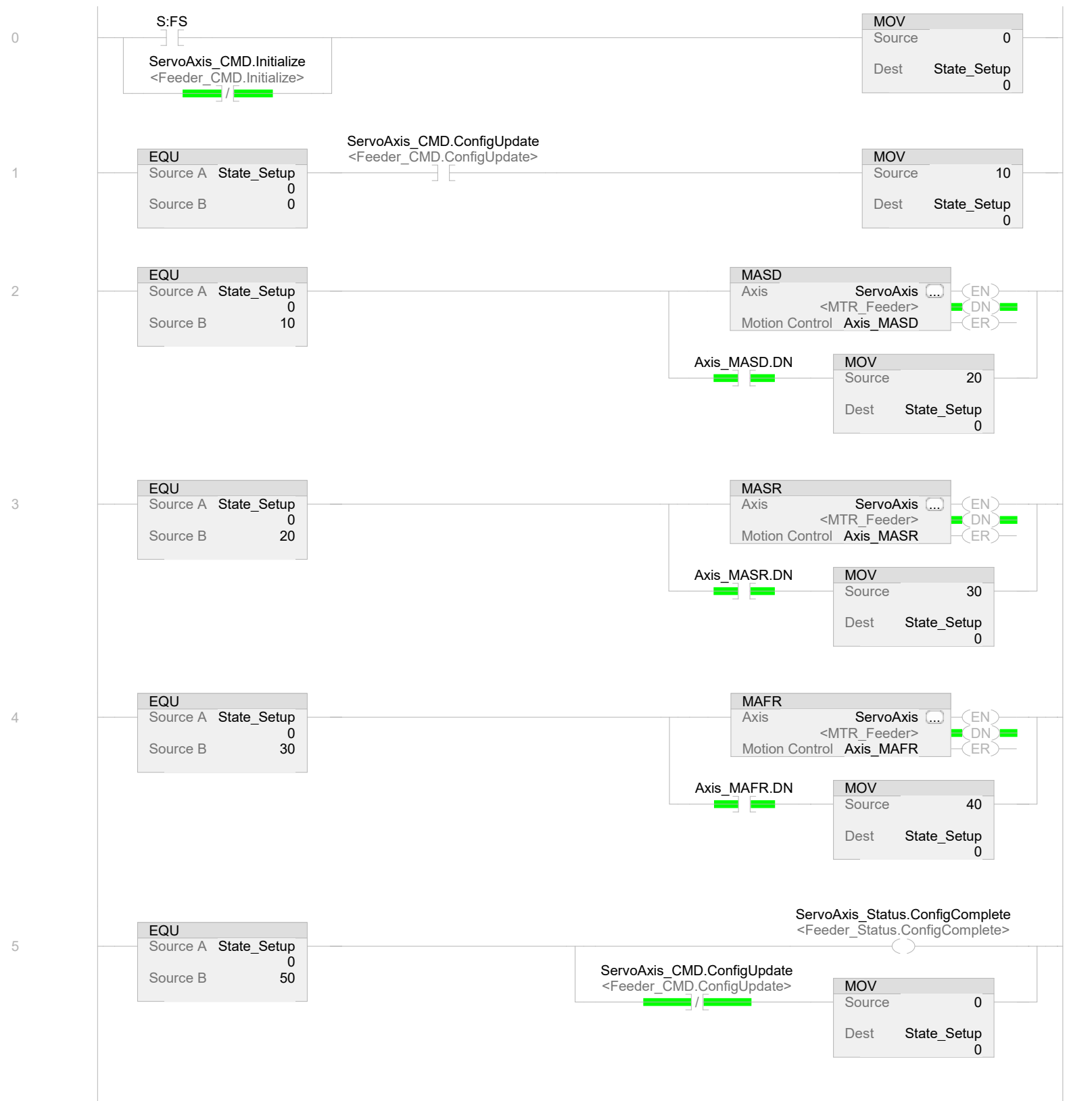


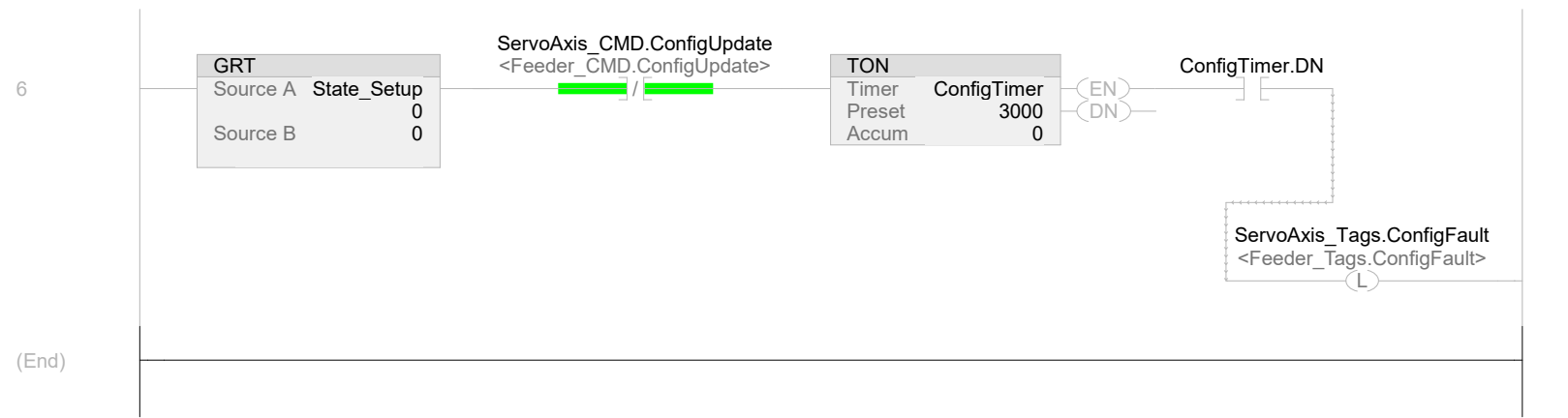


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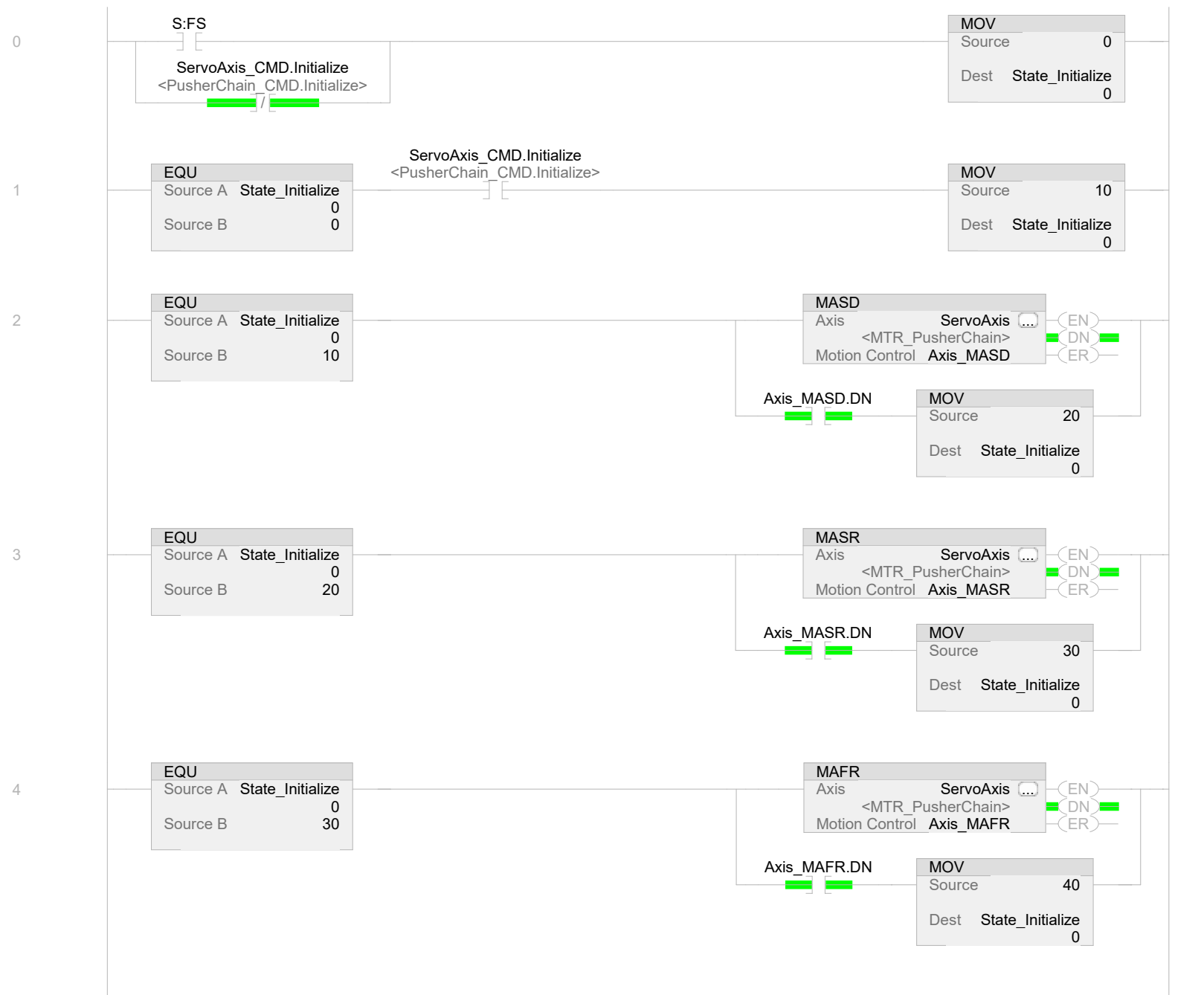


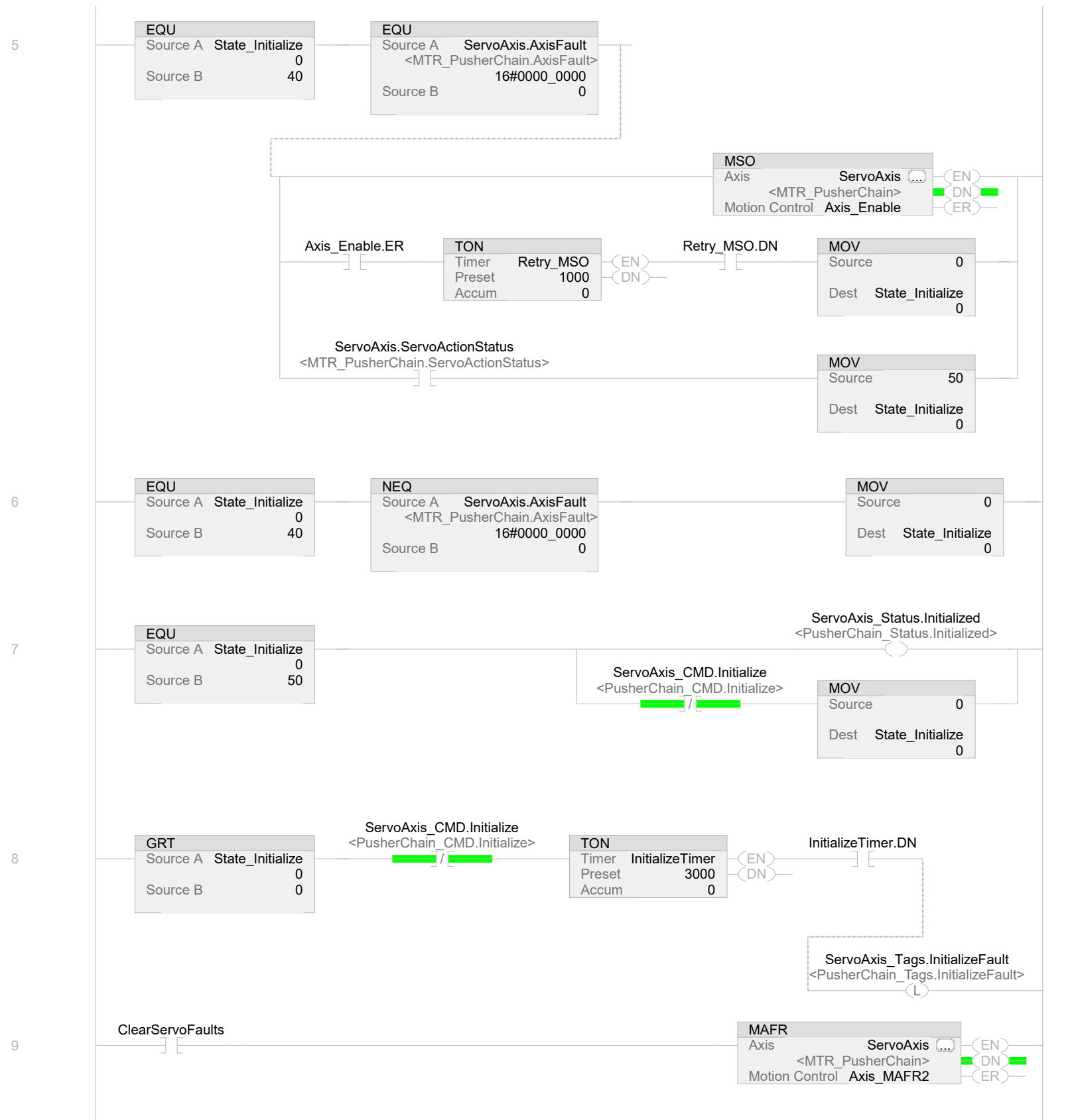
(End)



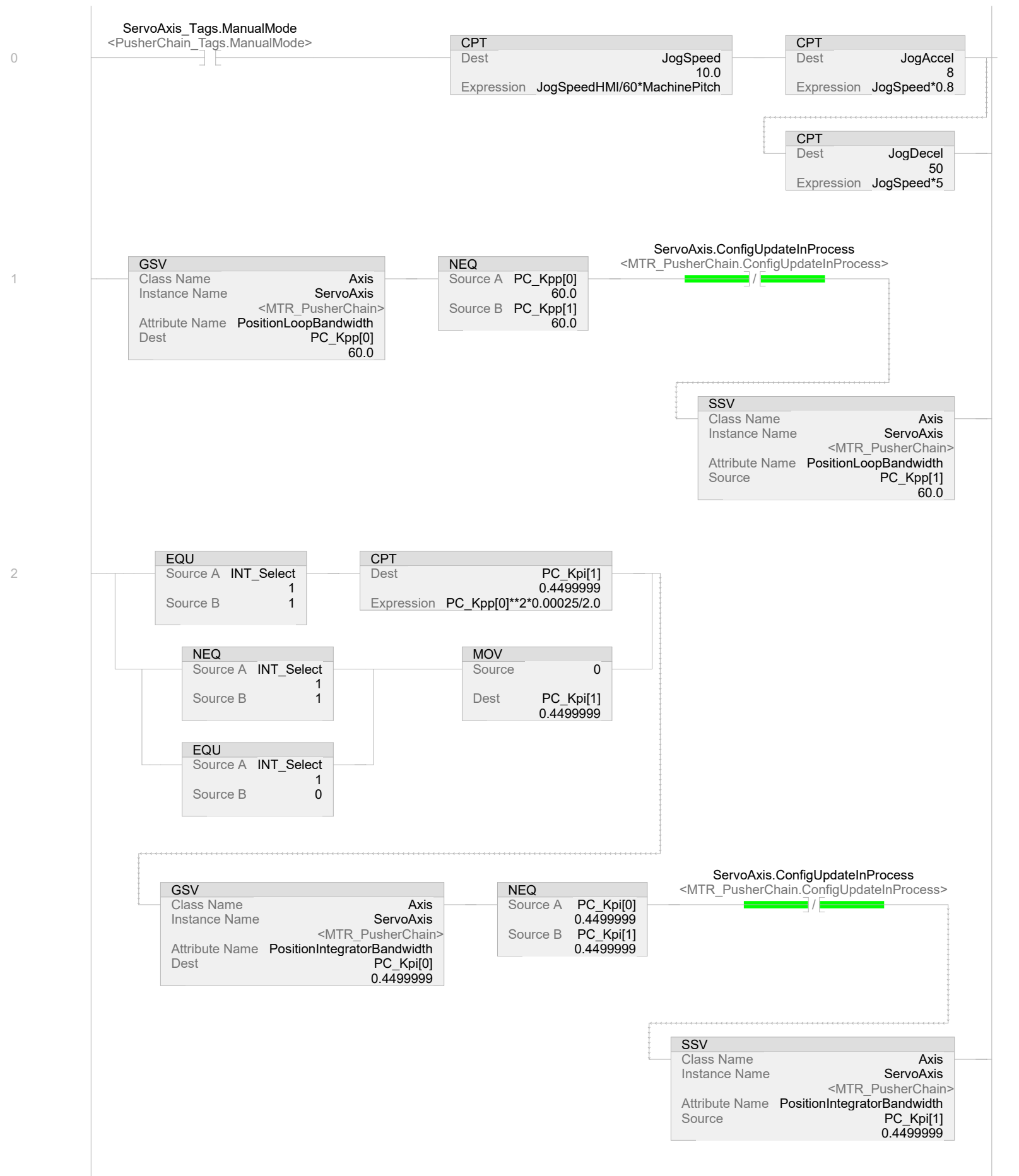


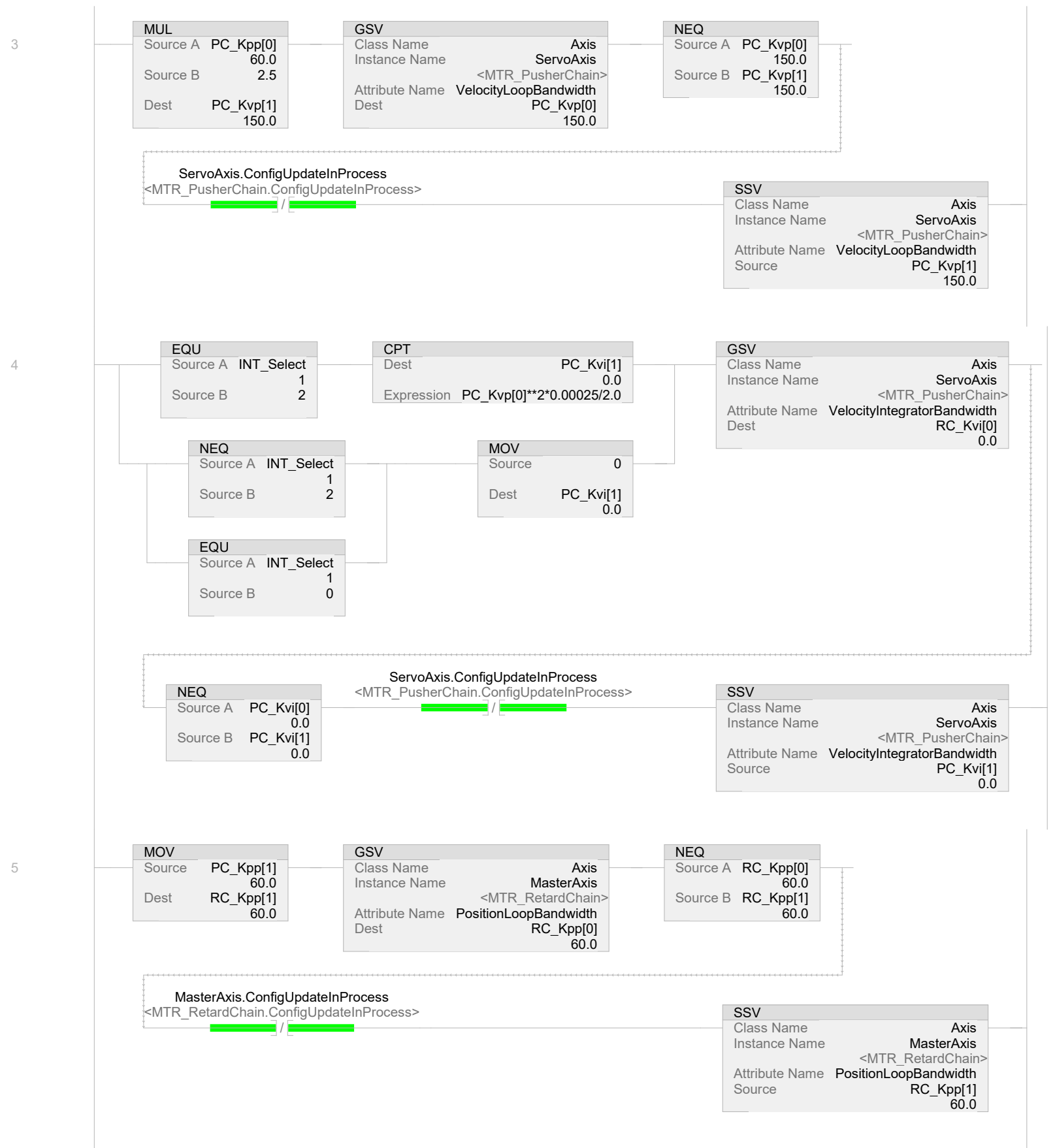


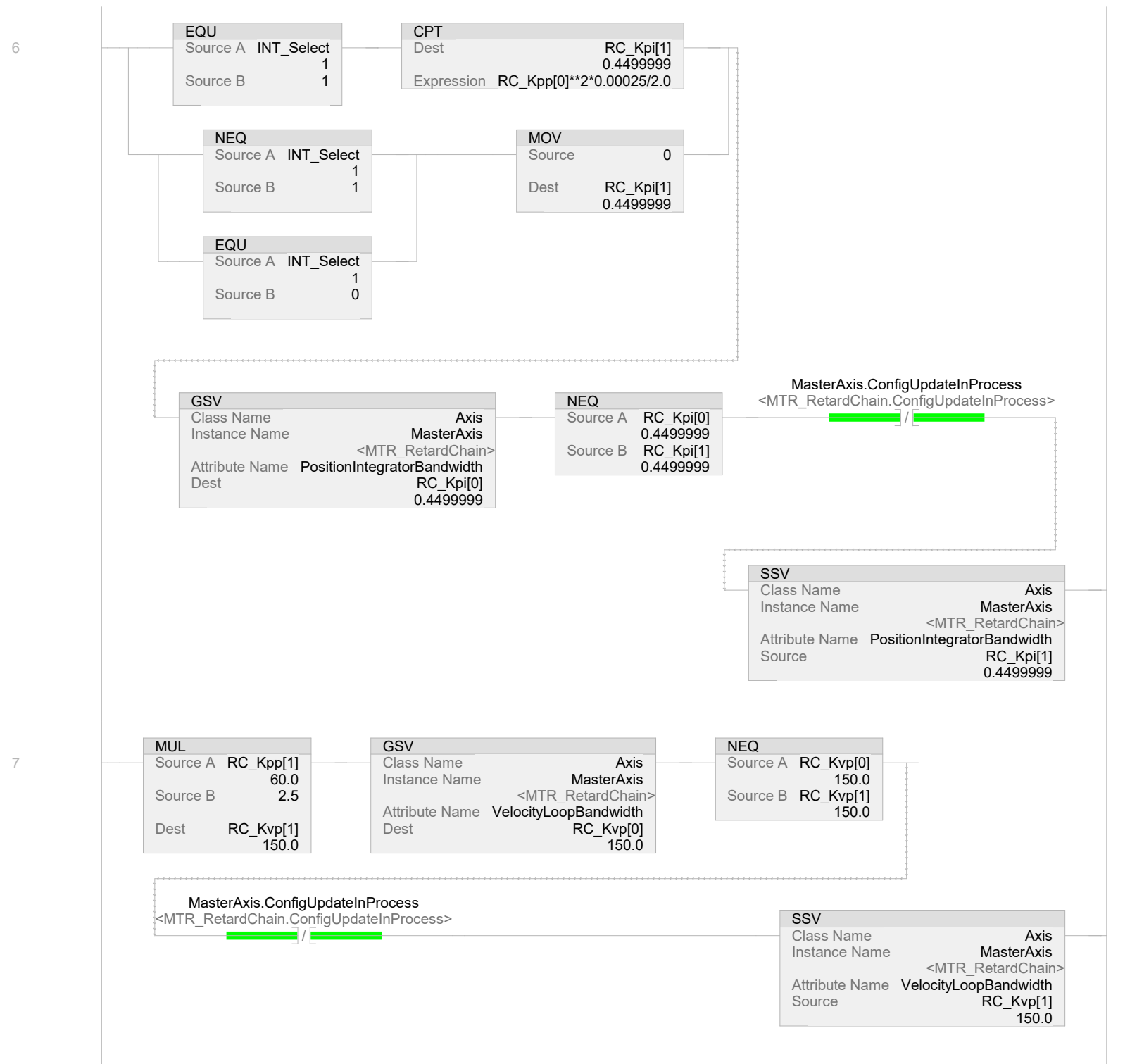






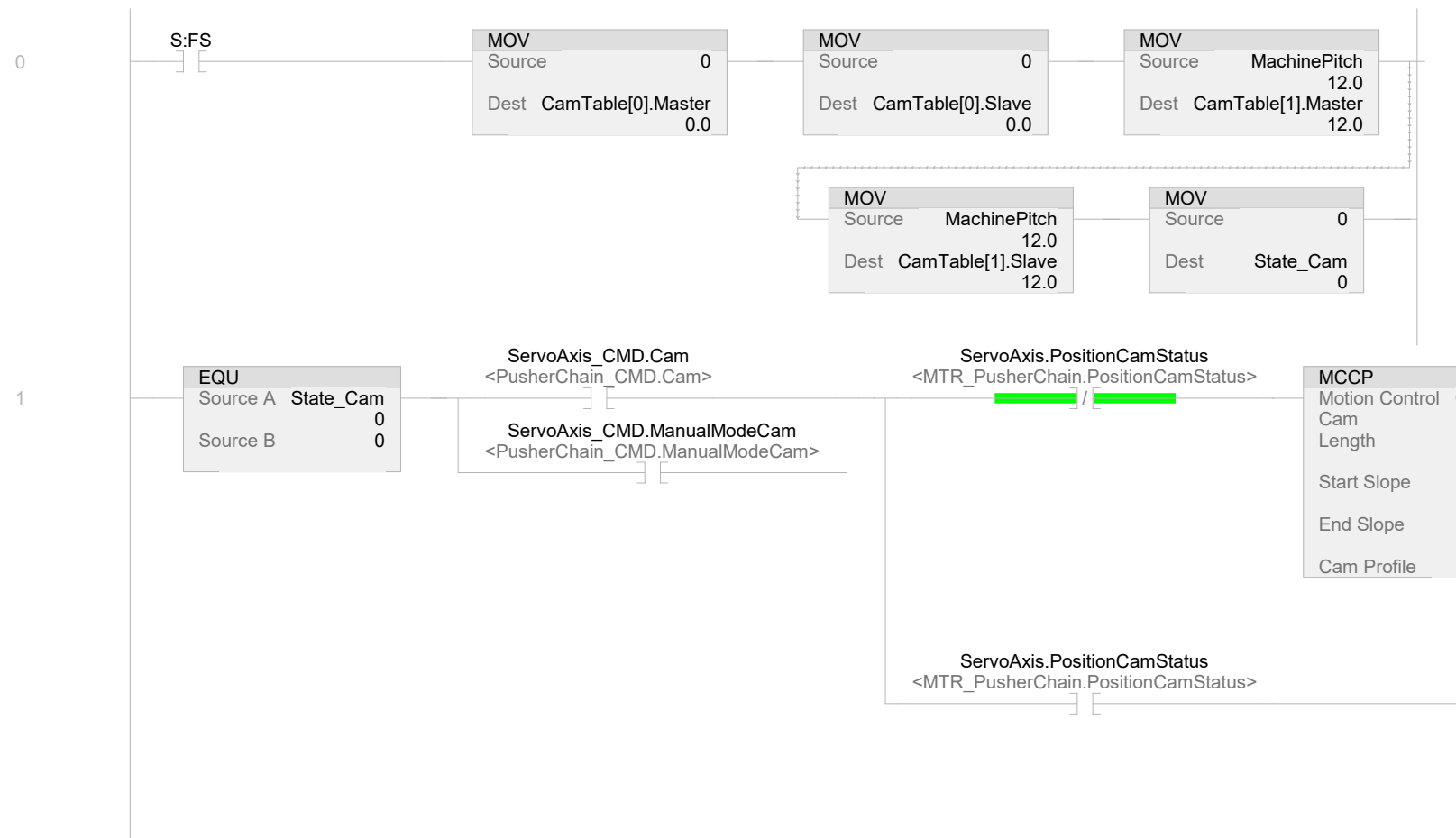


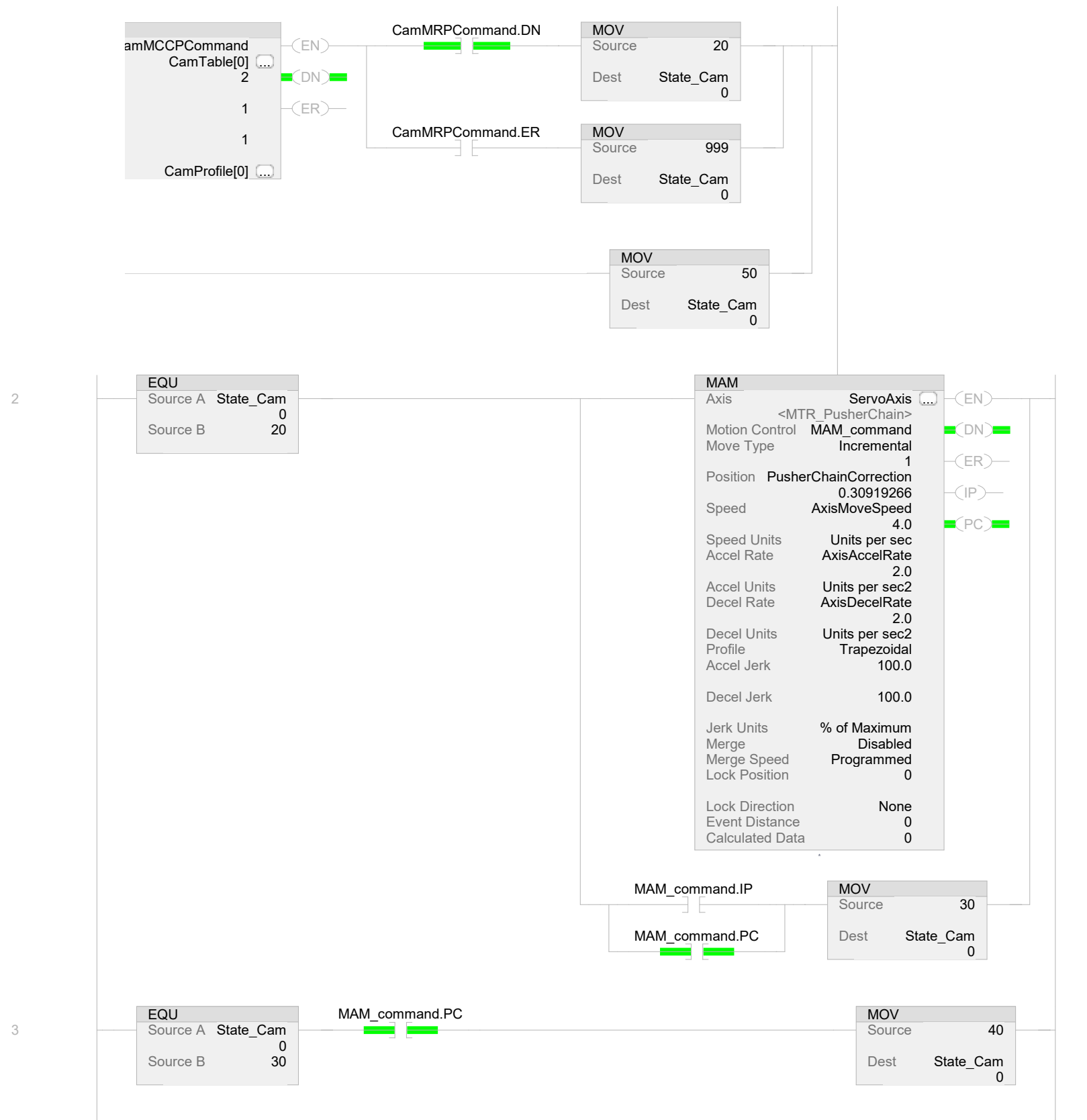


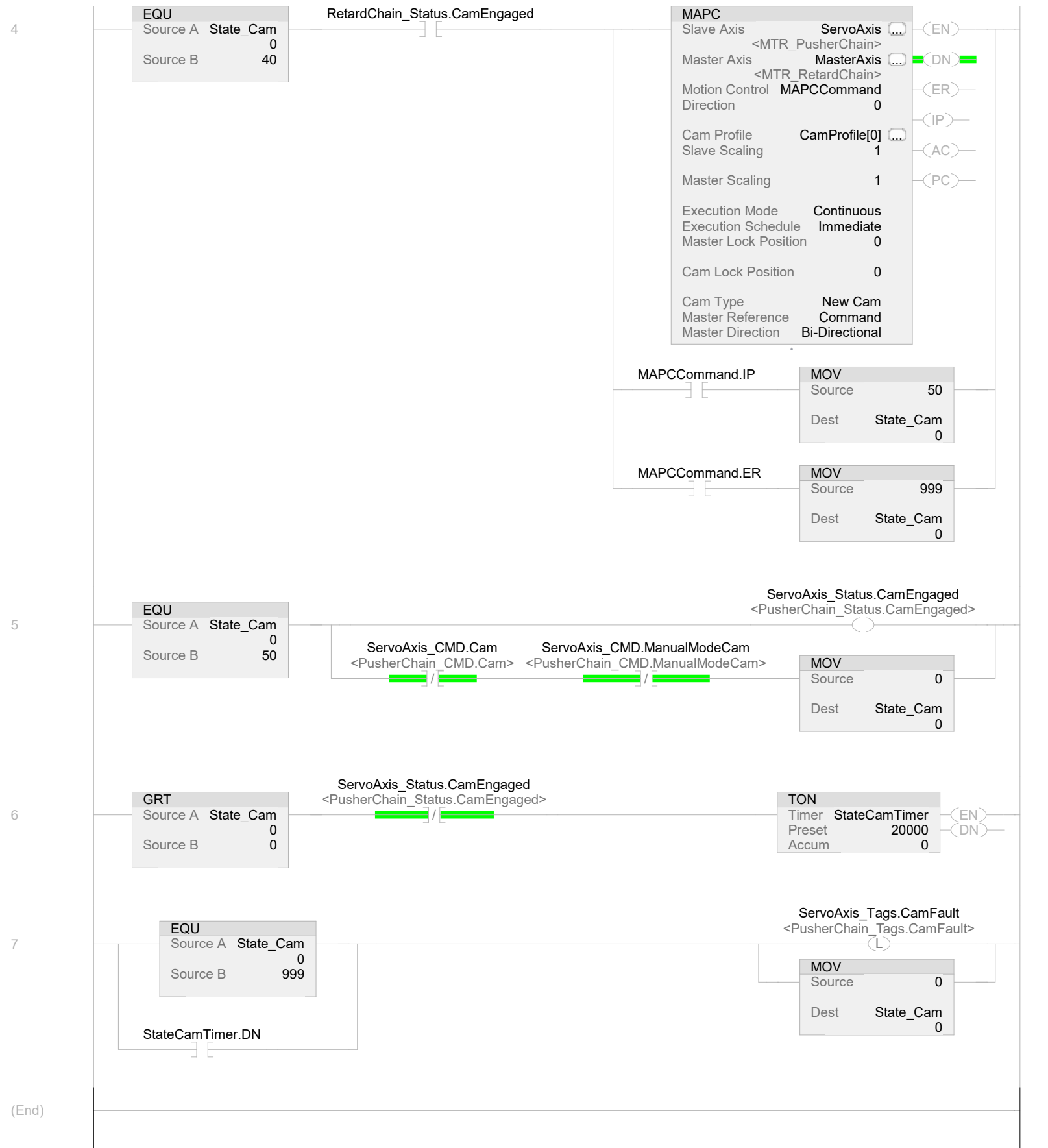


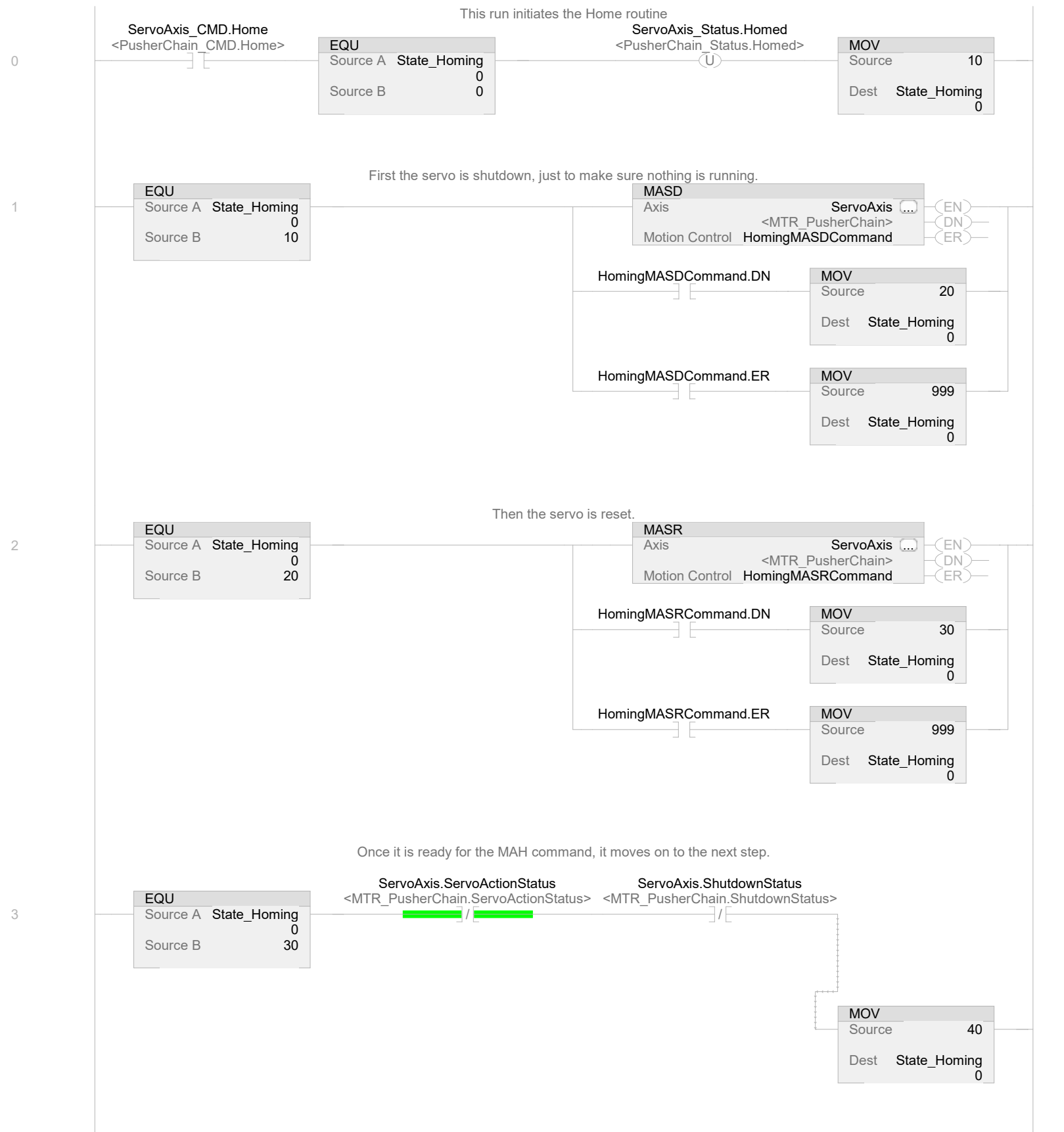


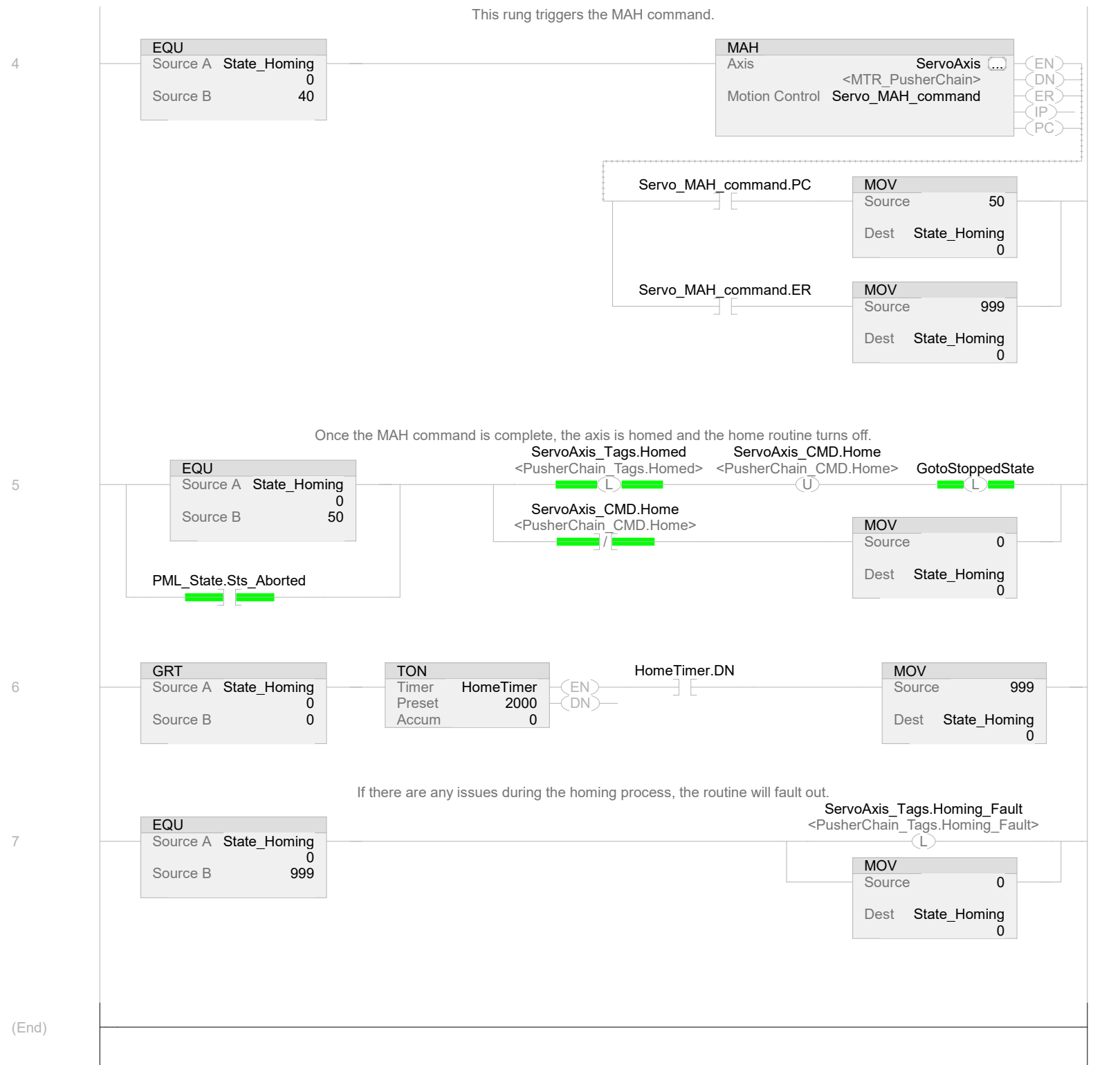


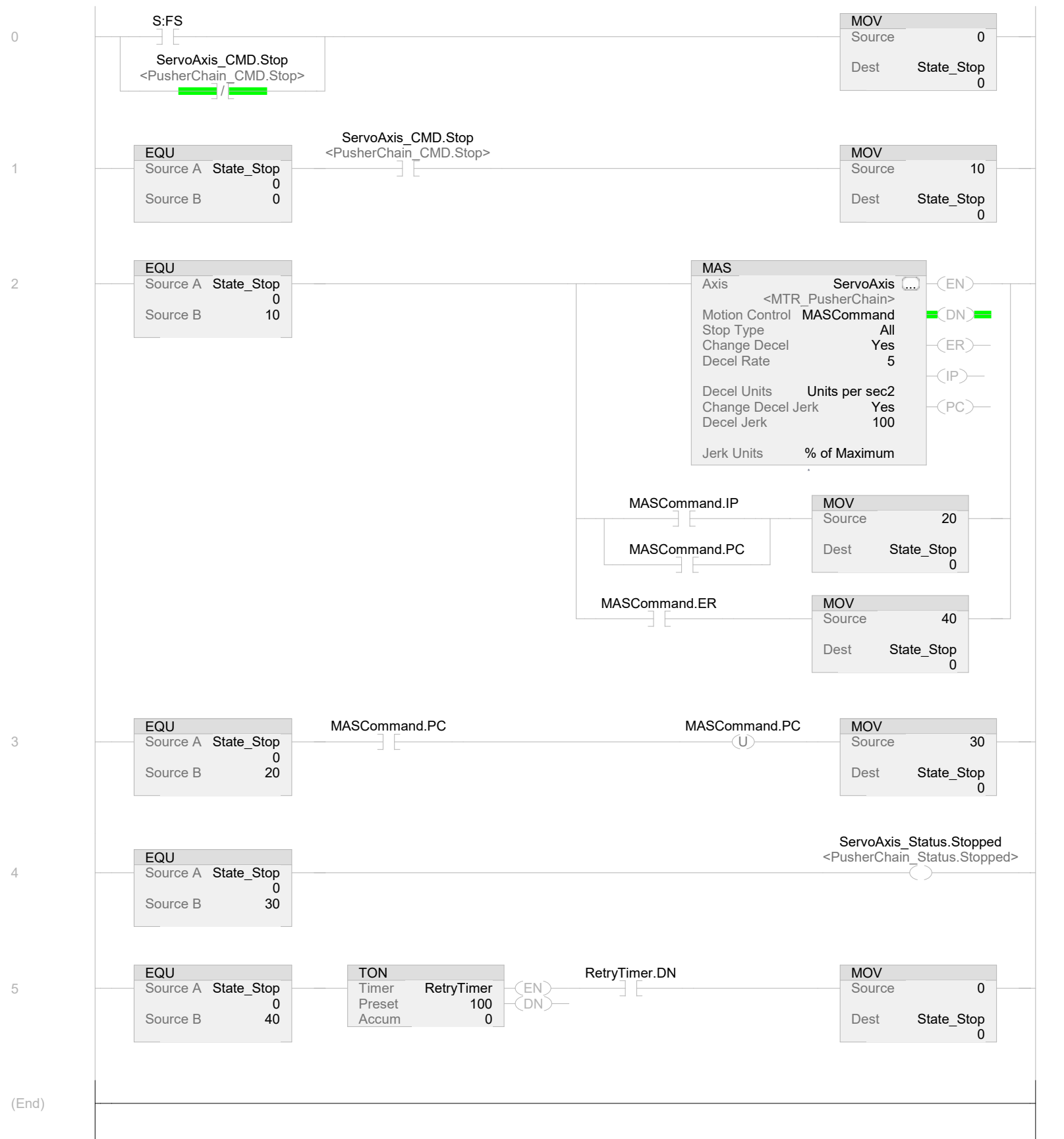


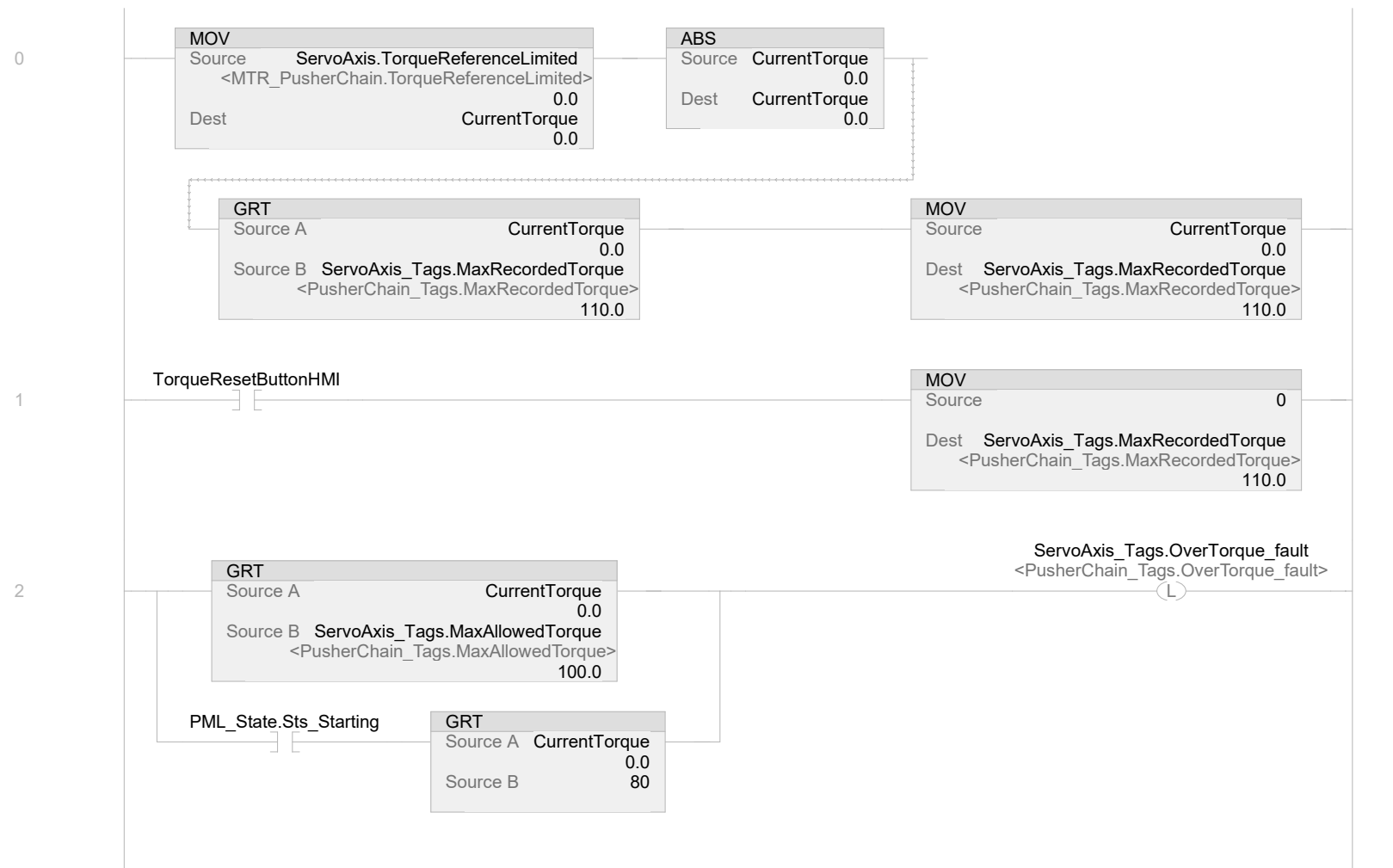


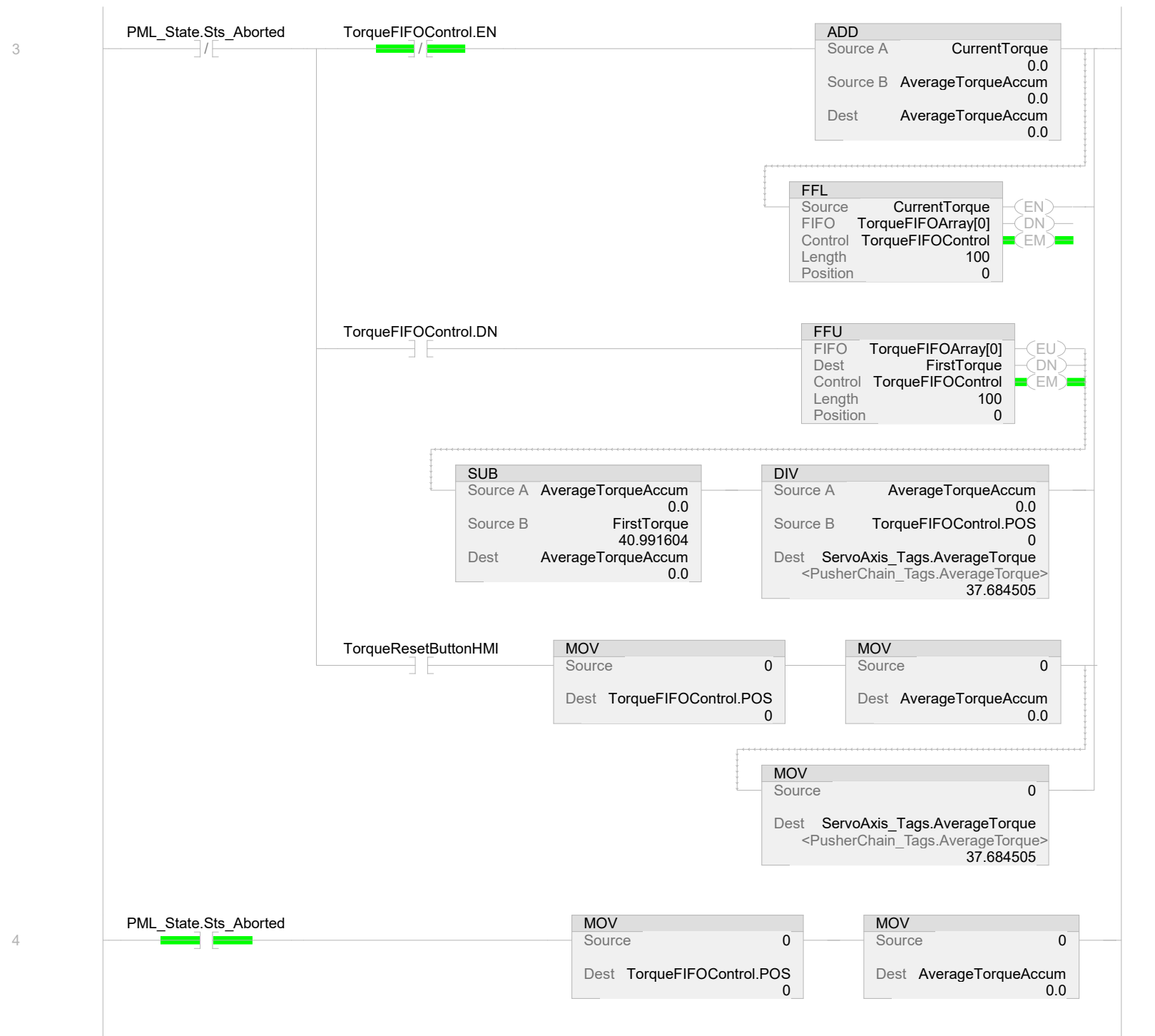








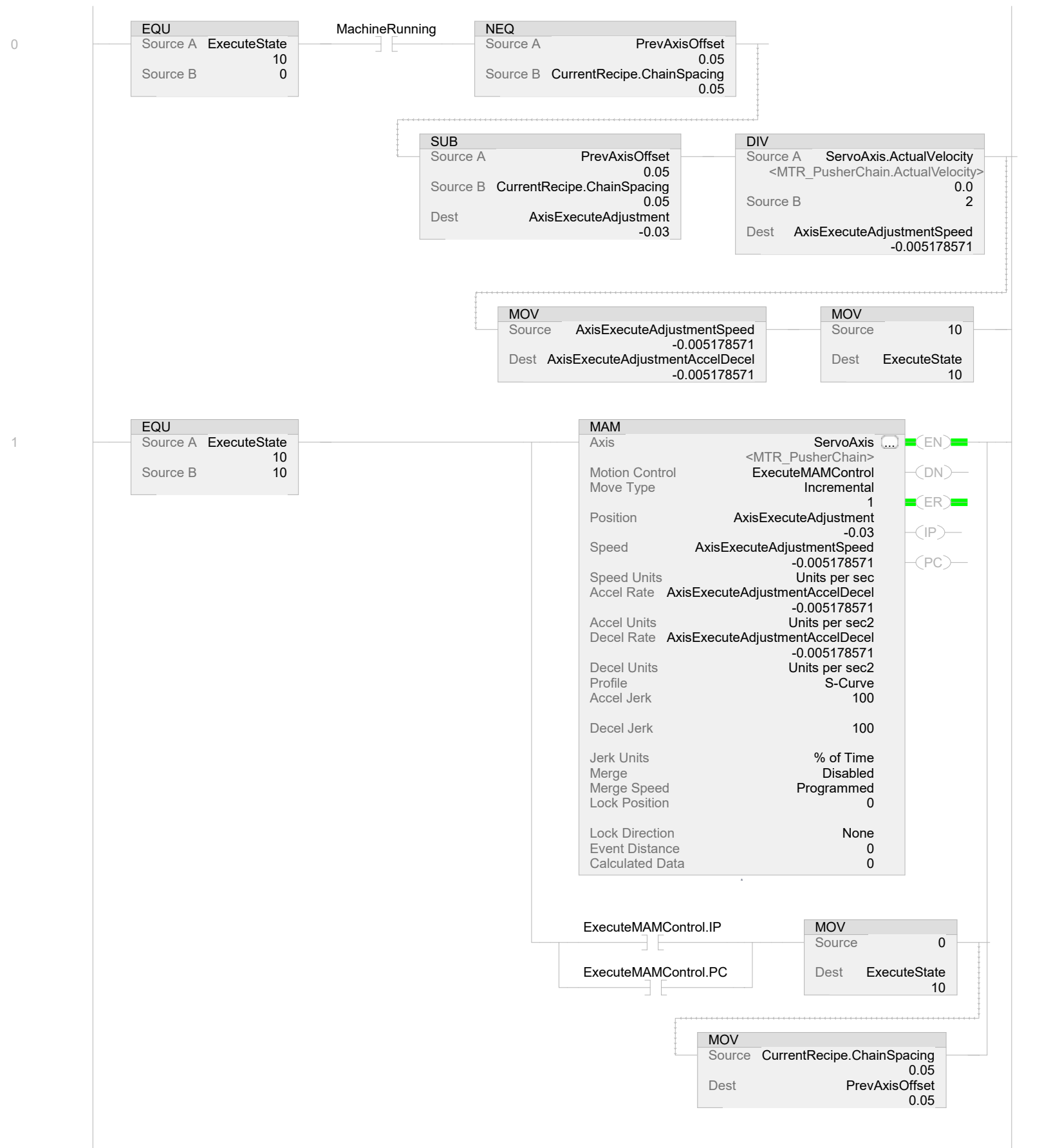


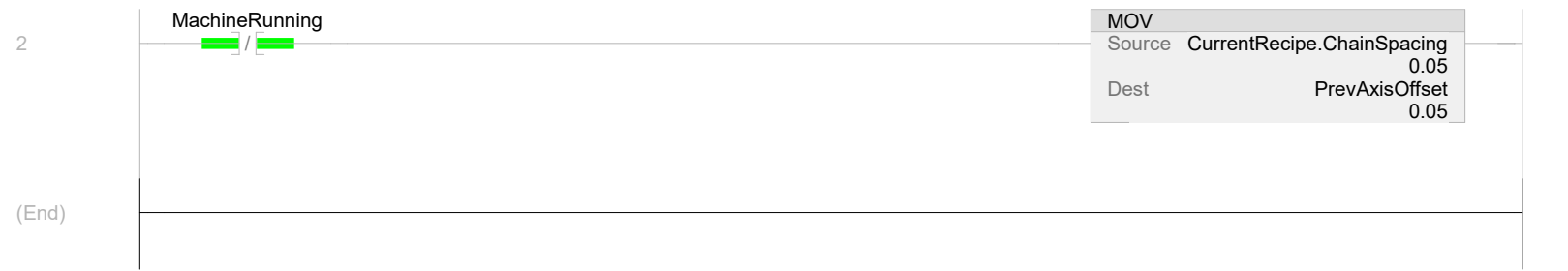


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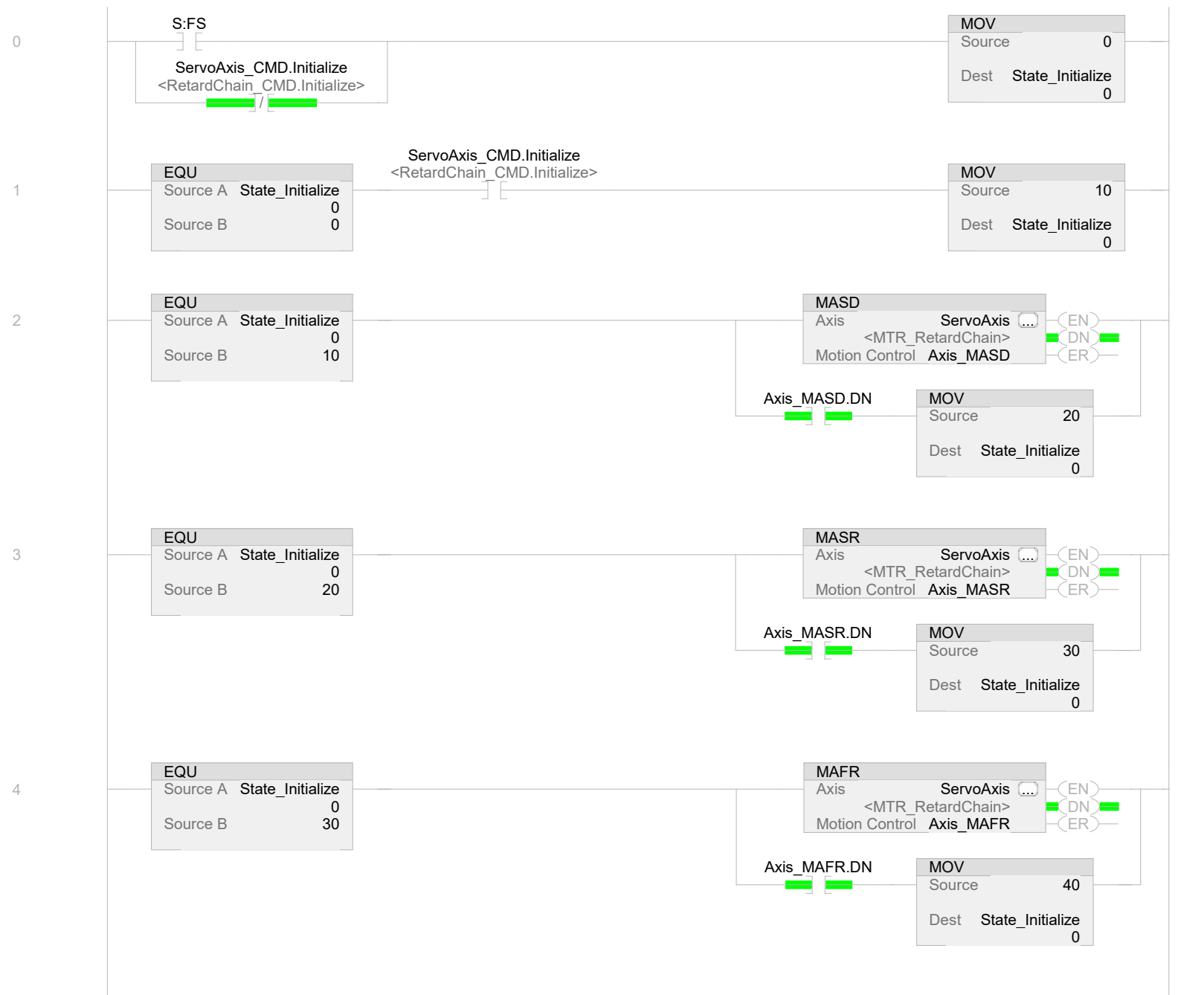


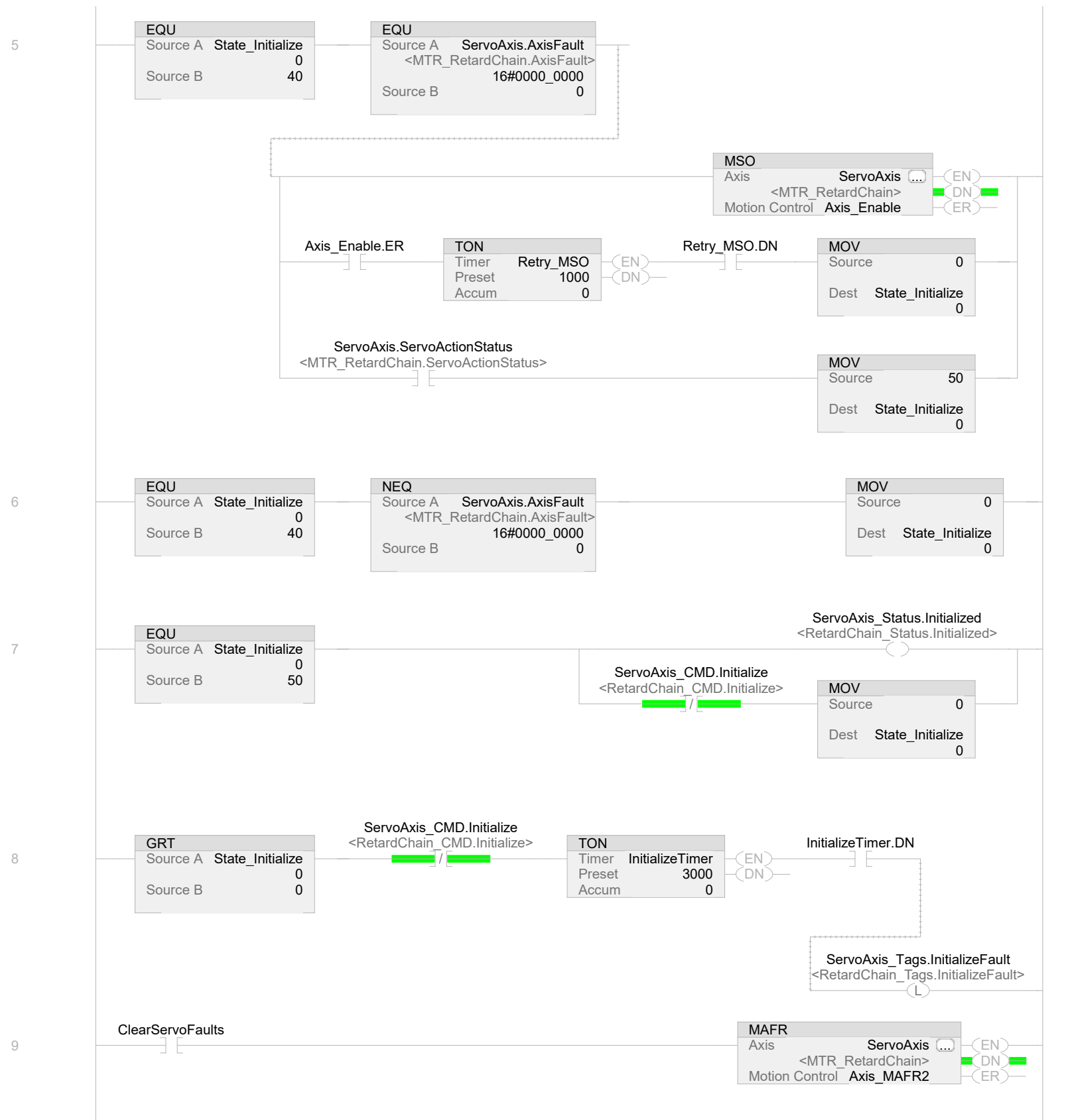
(End)

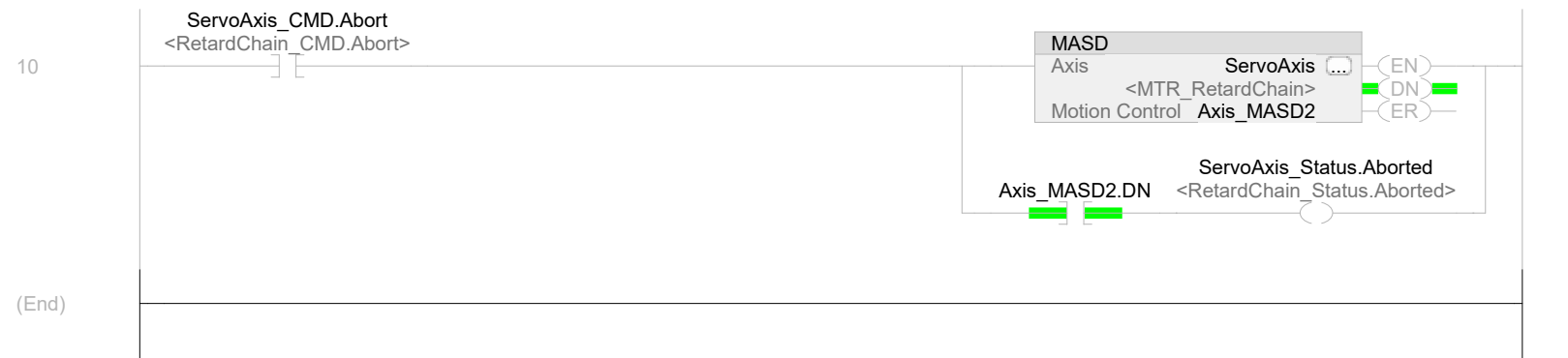


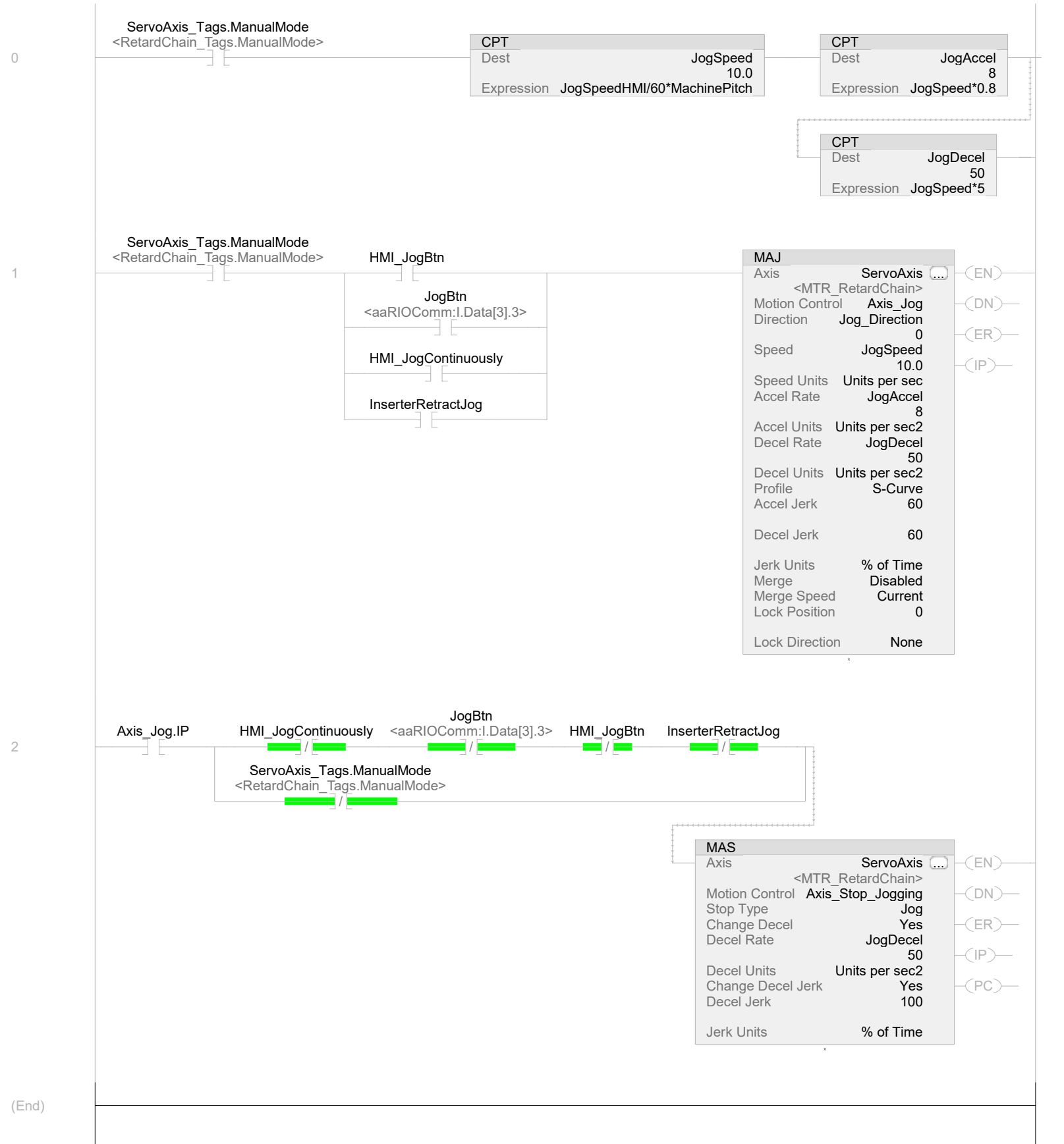


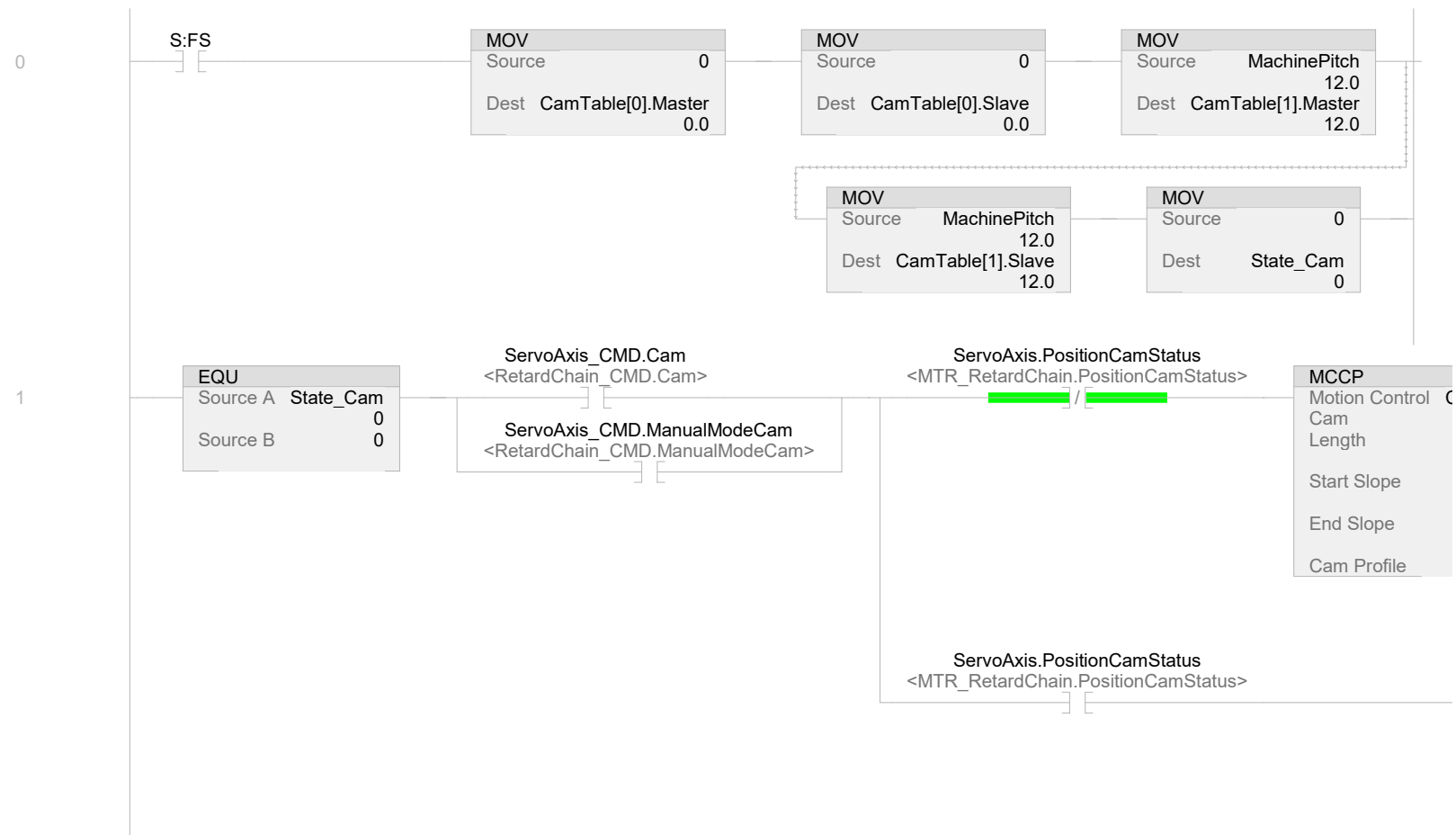


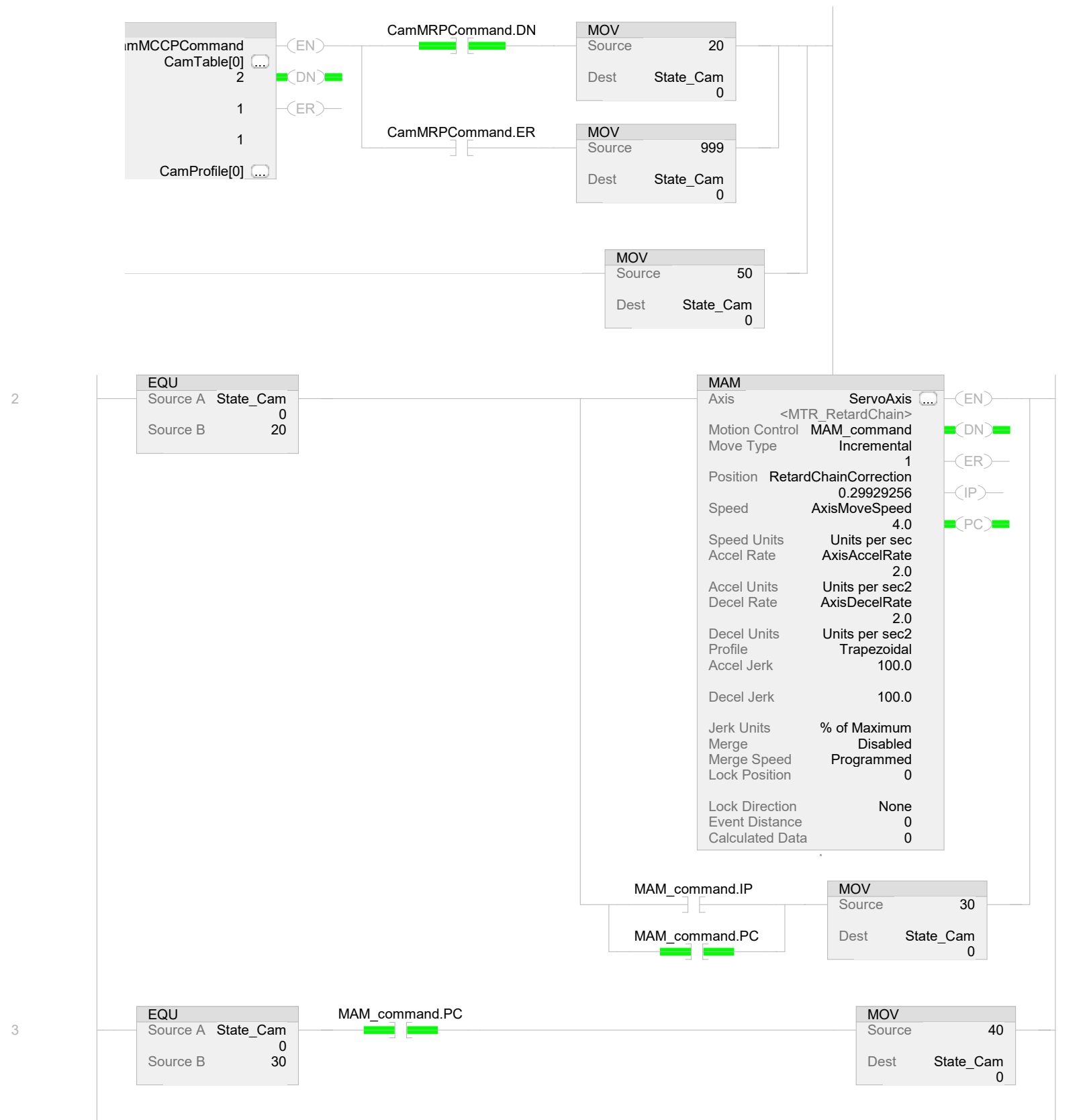


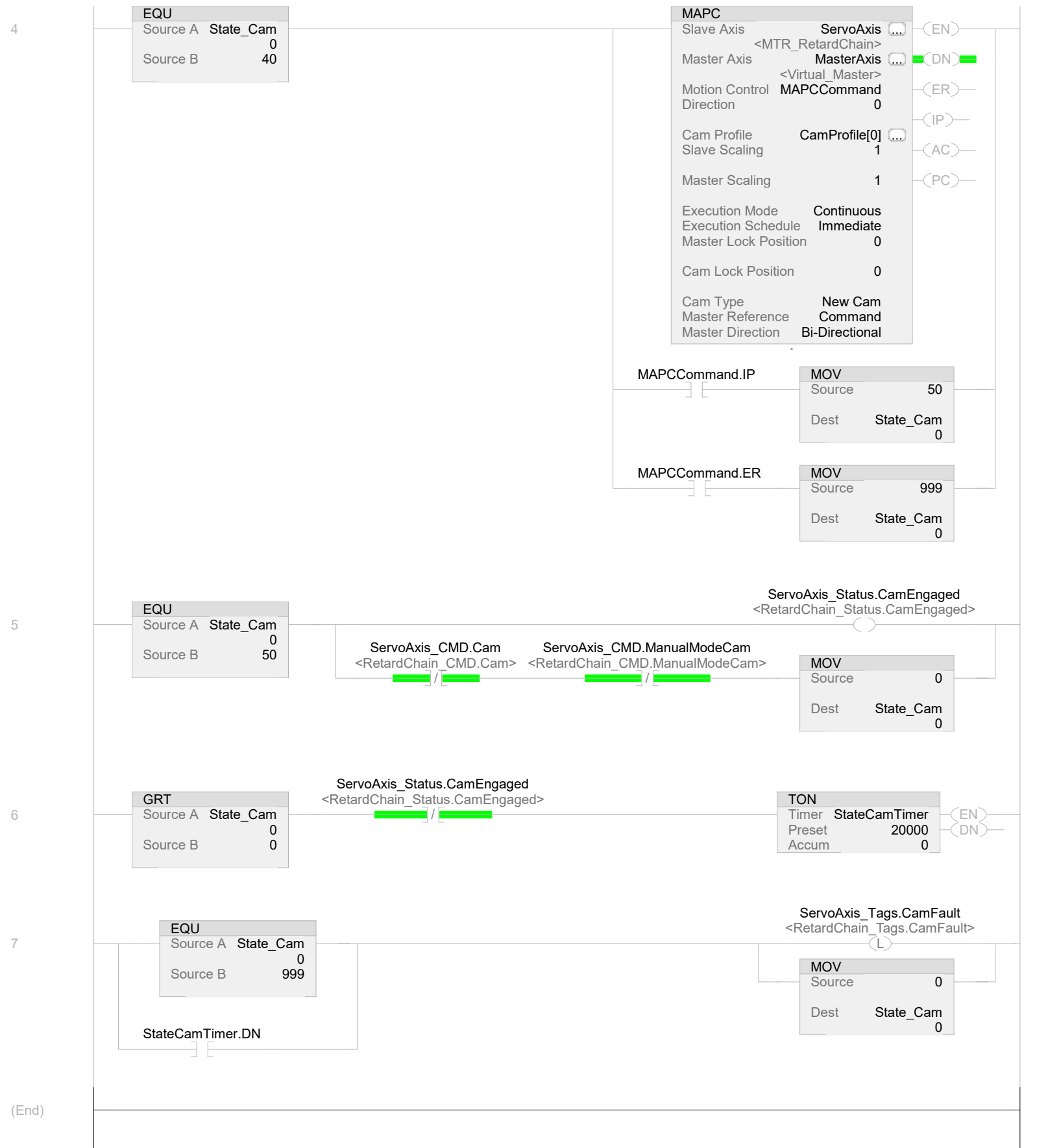


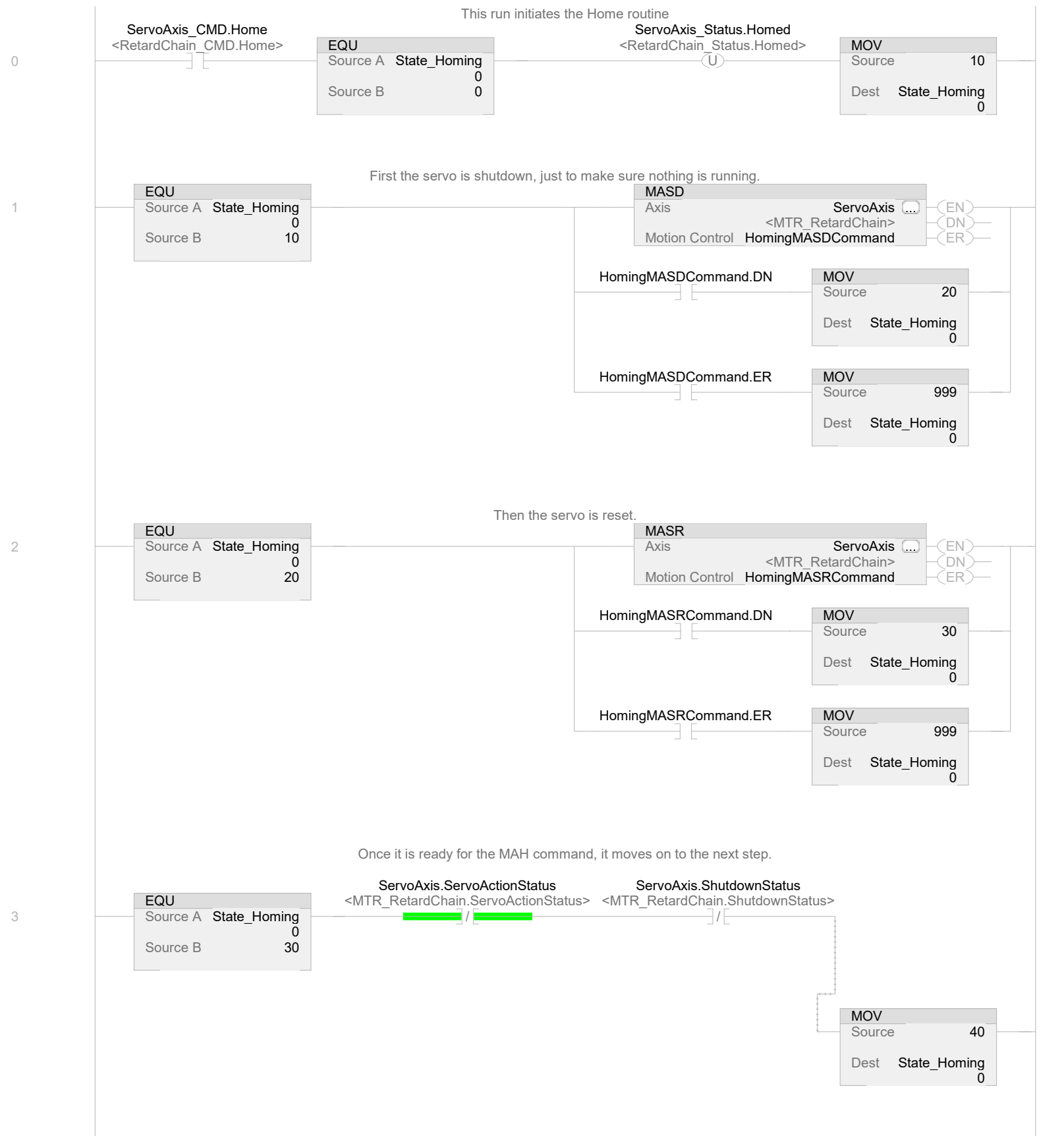


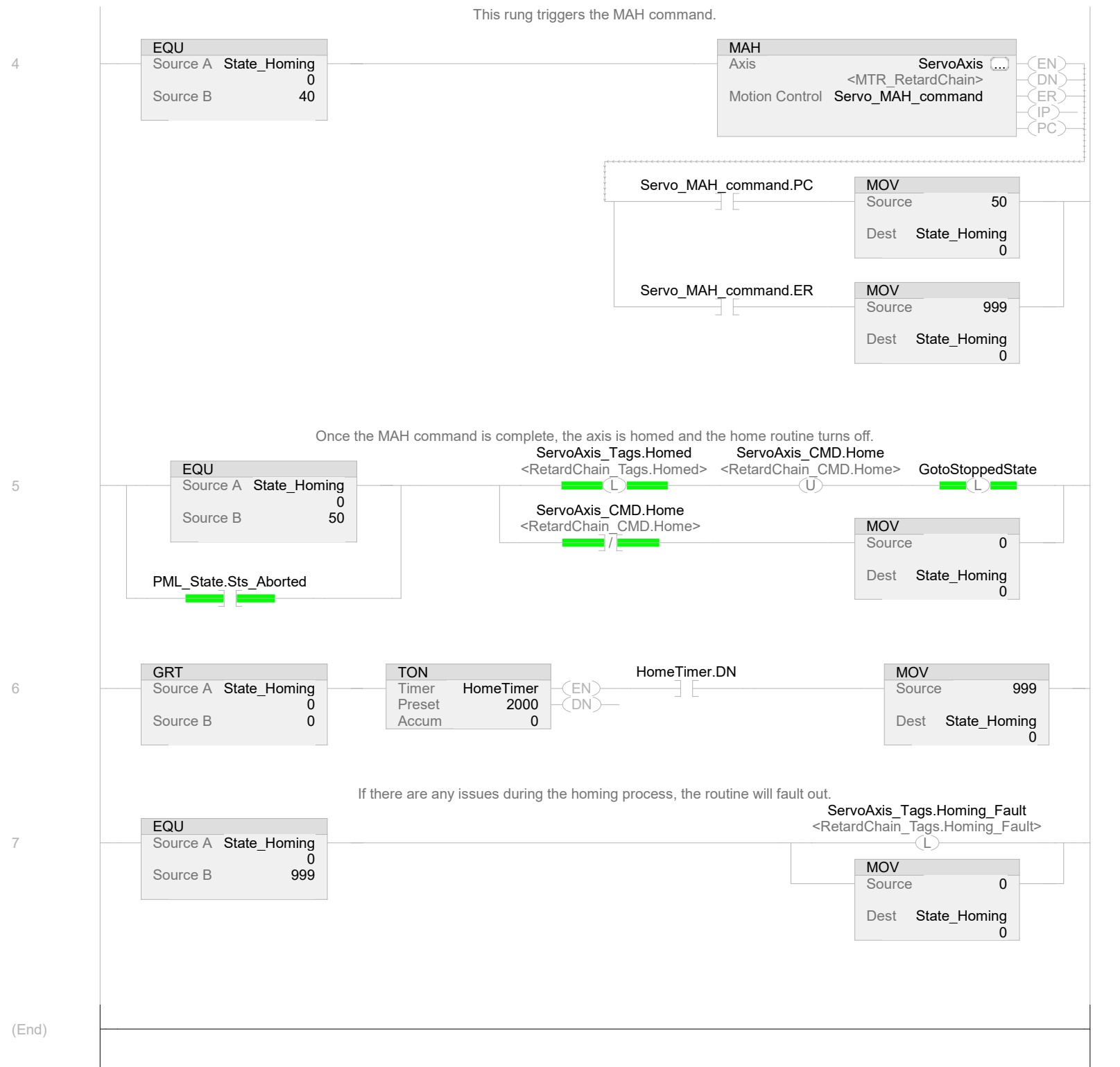


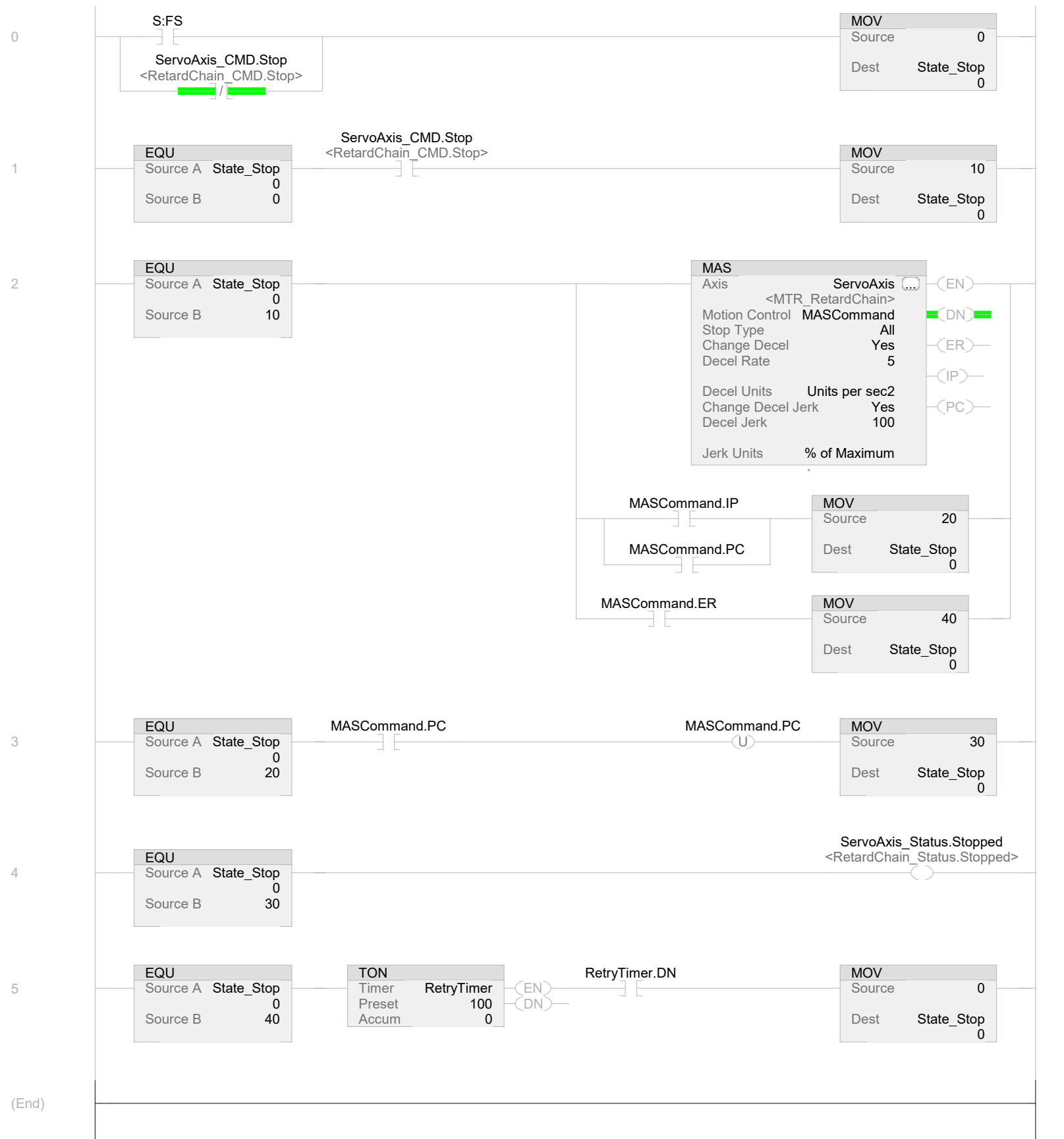


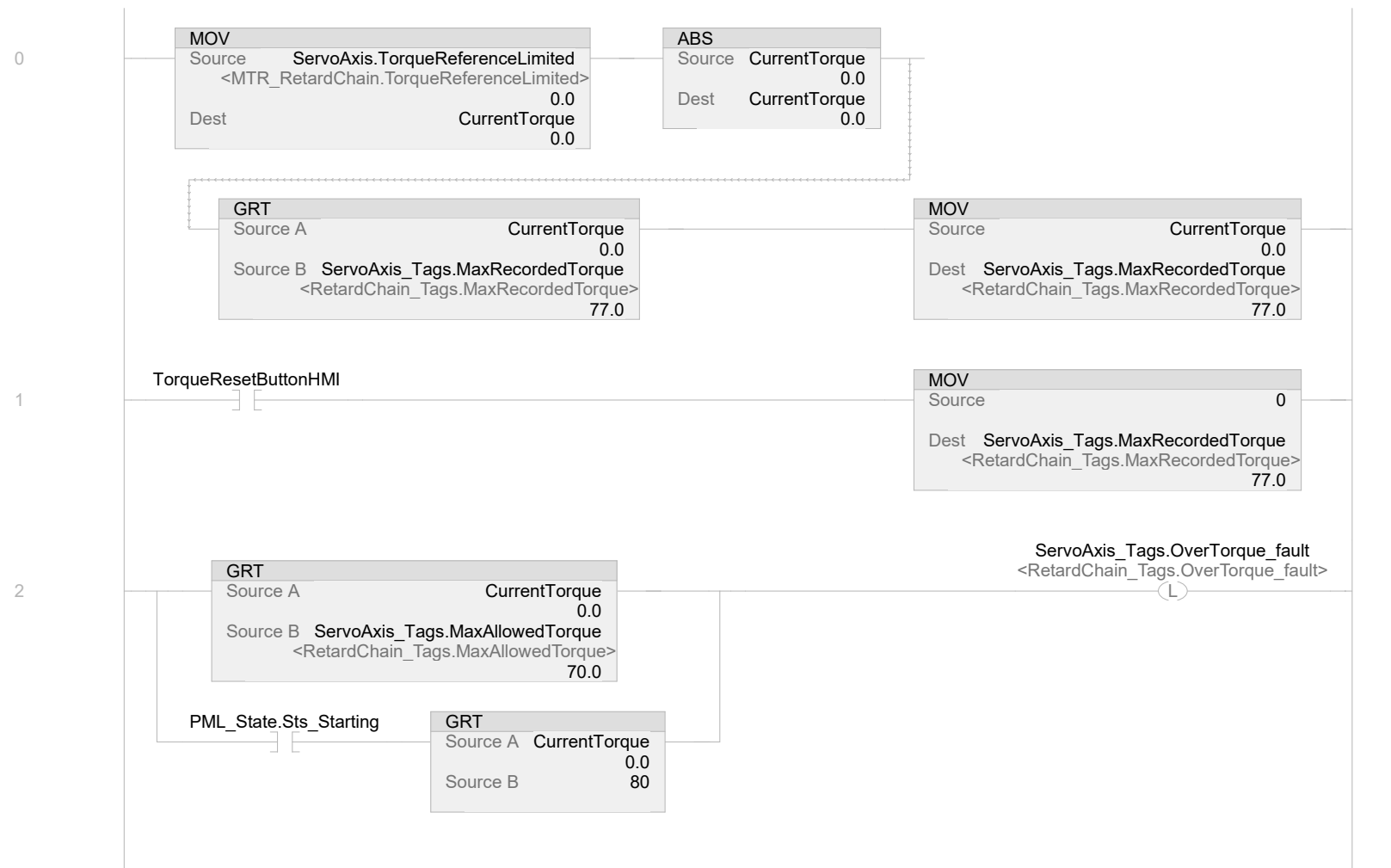


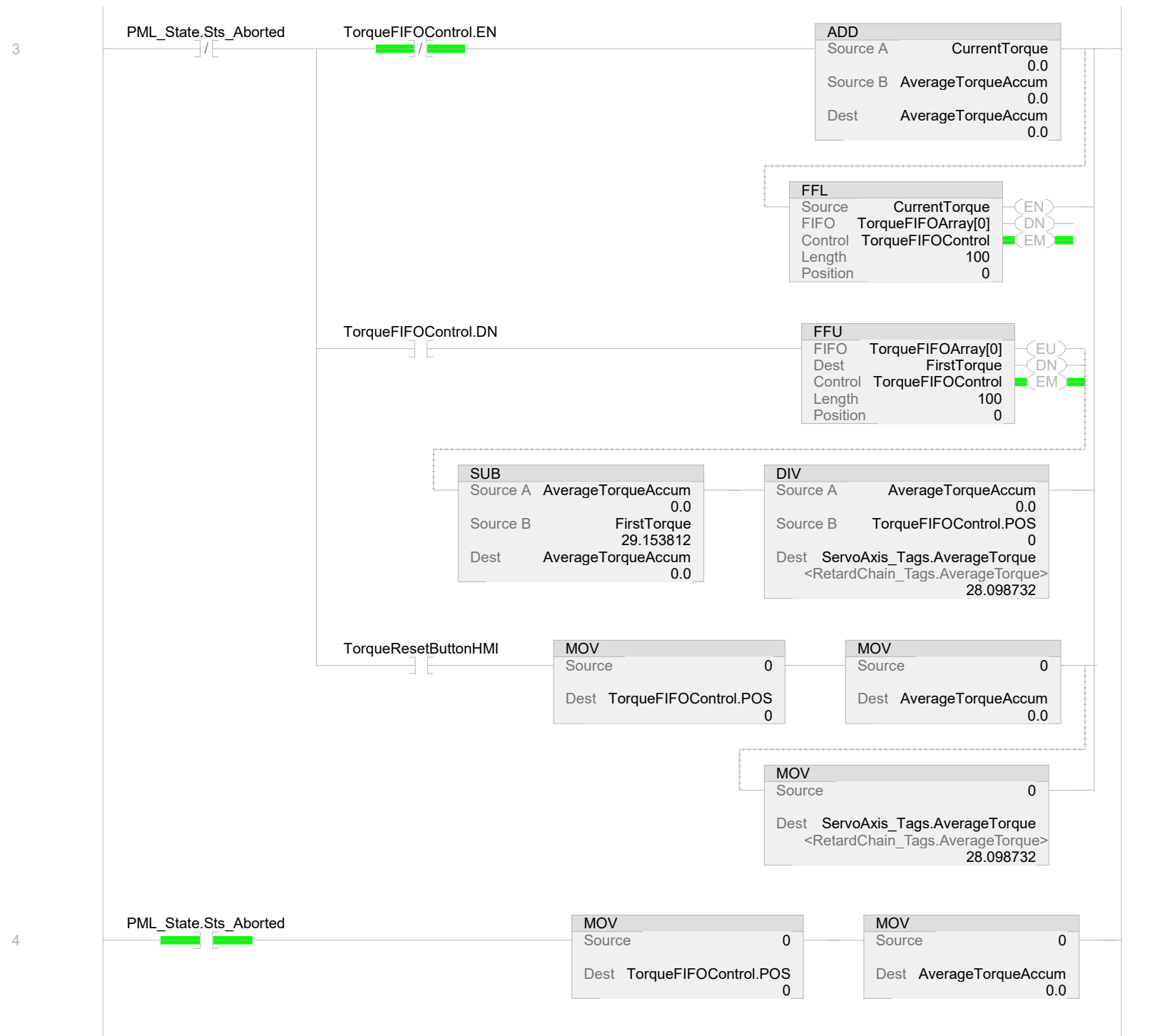








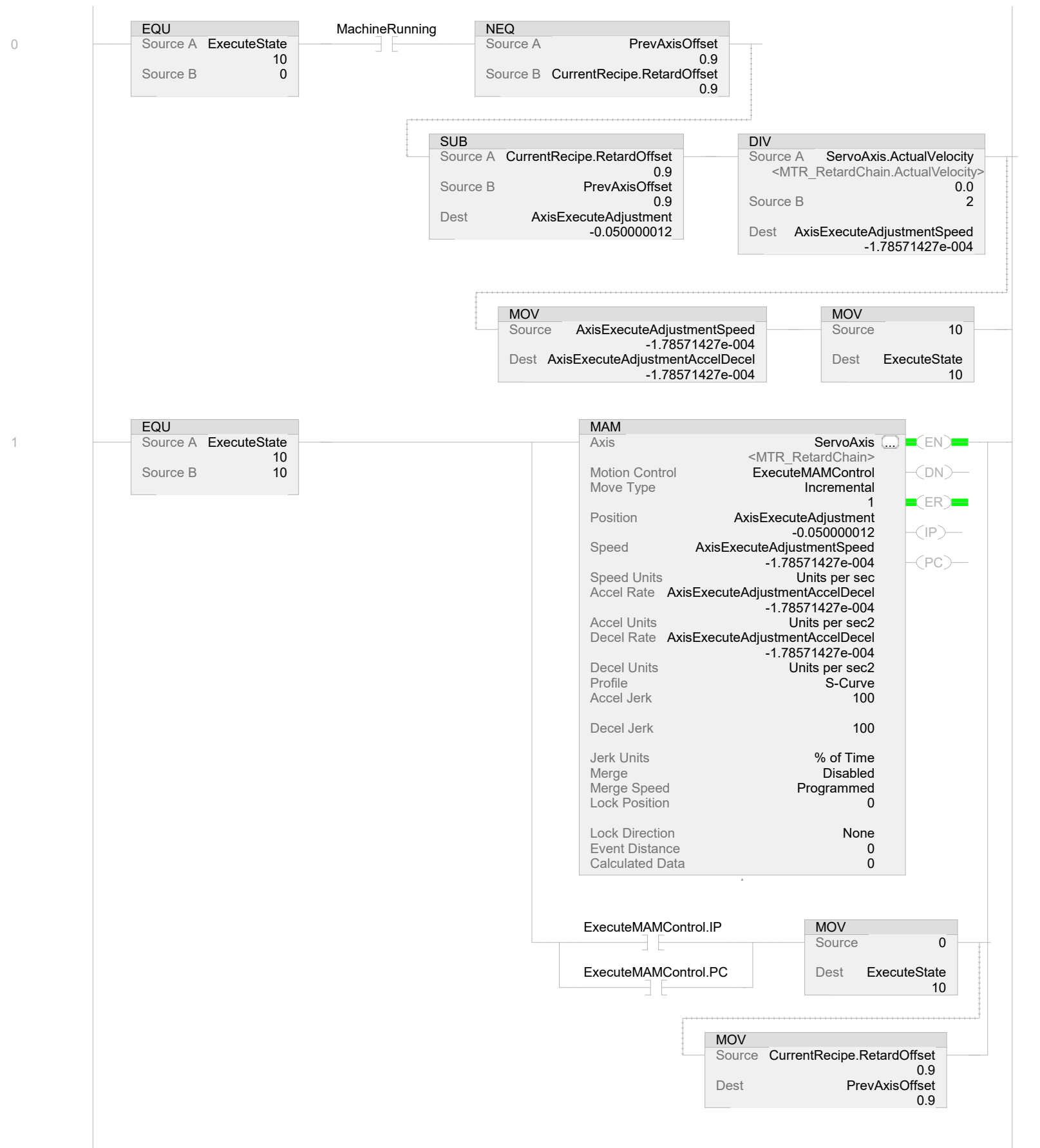




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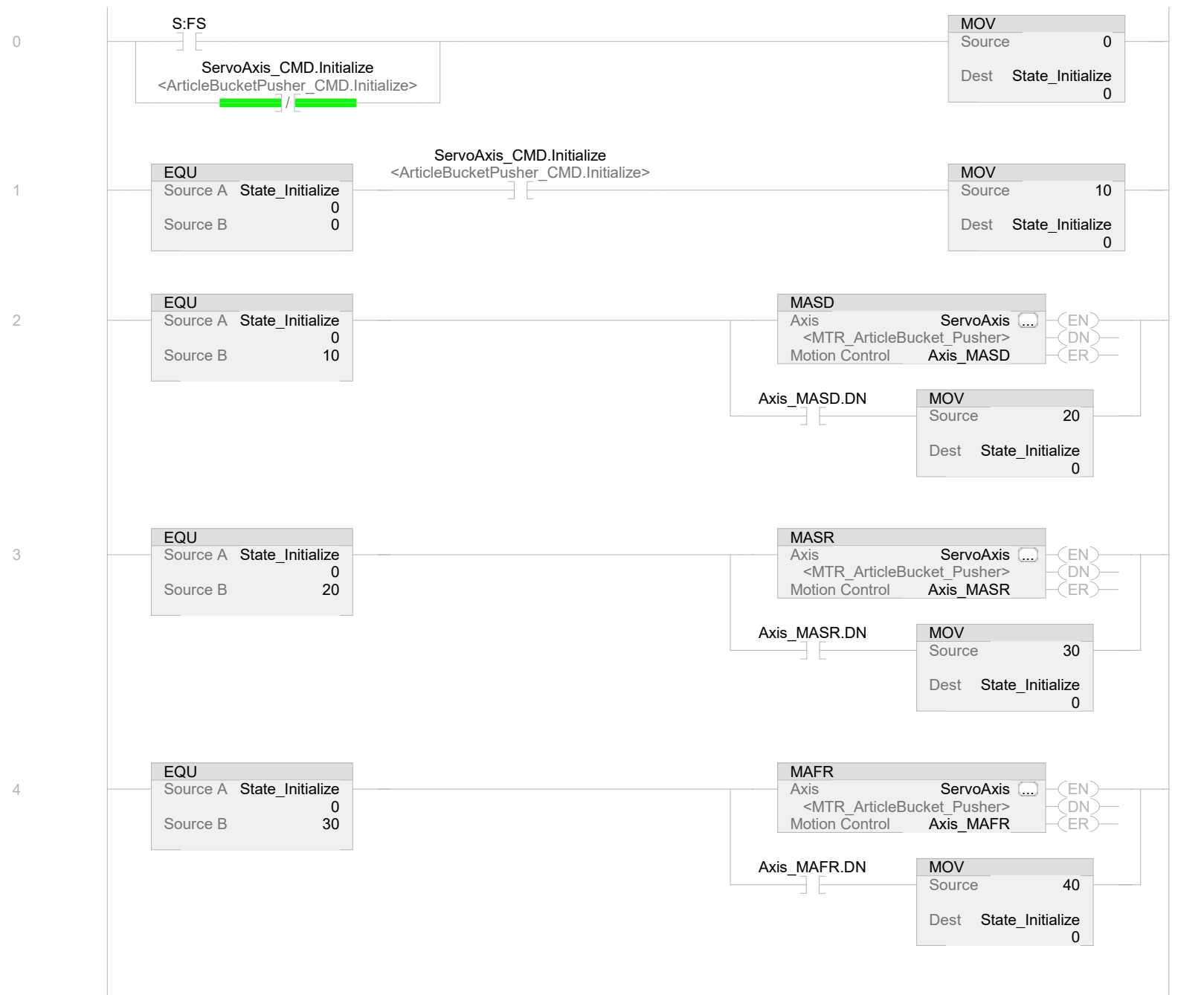


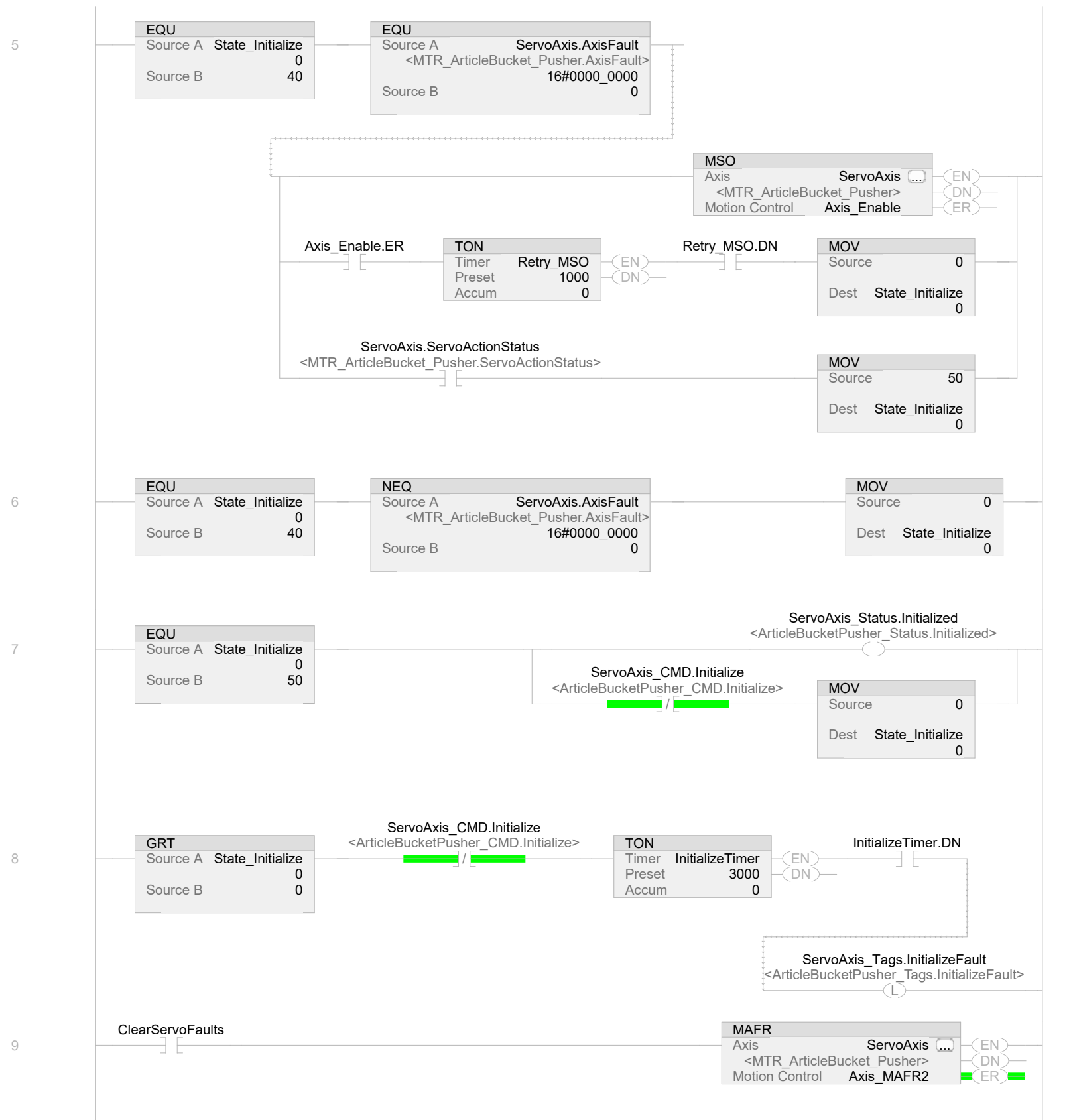
(End)



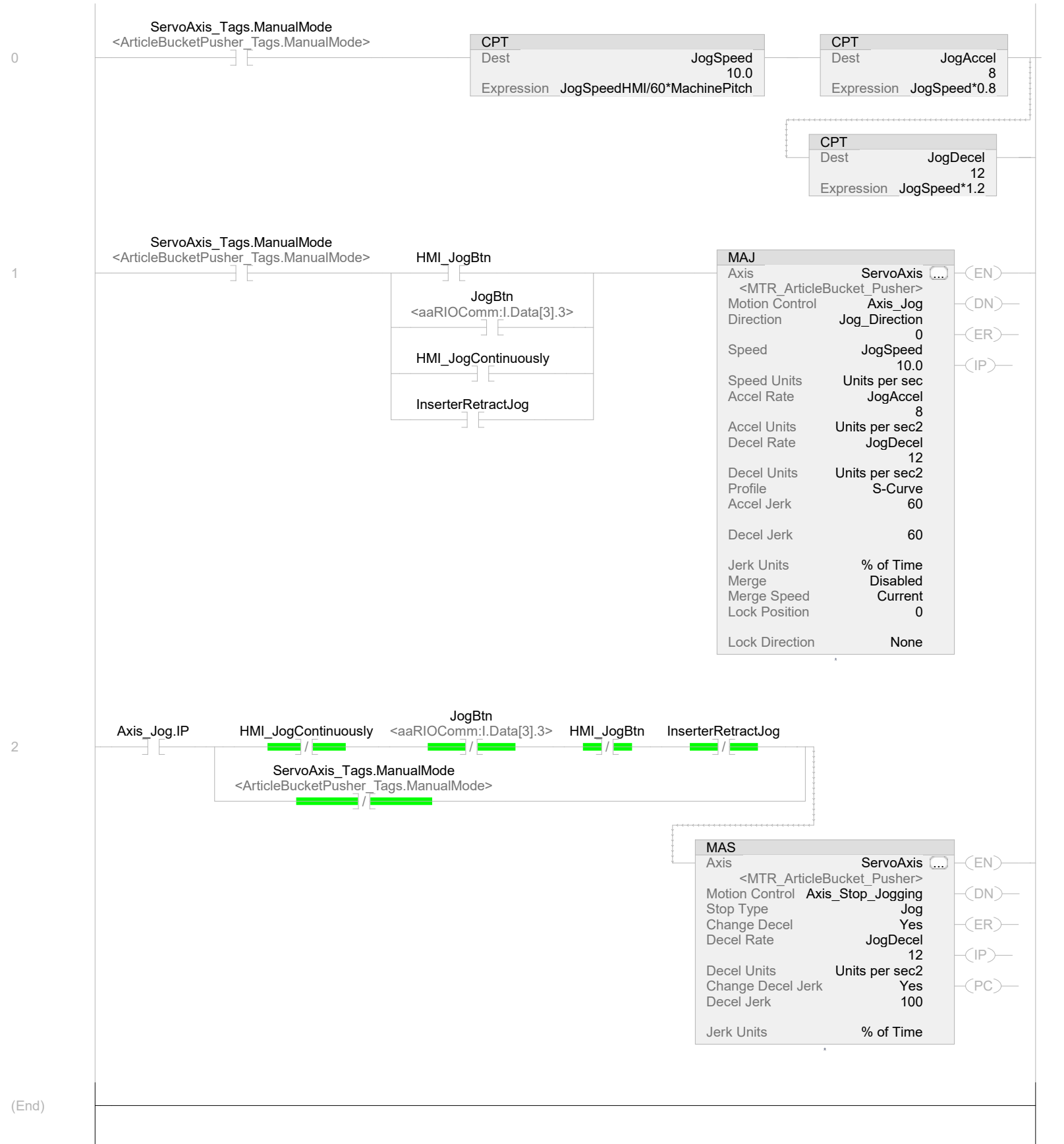


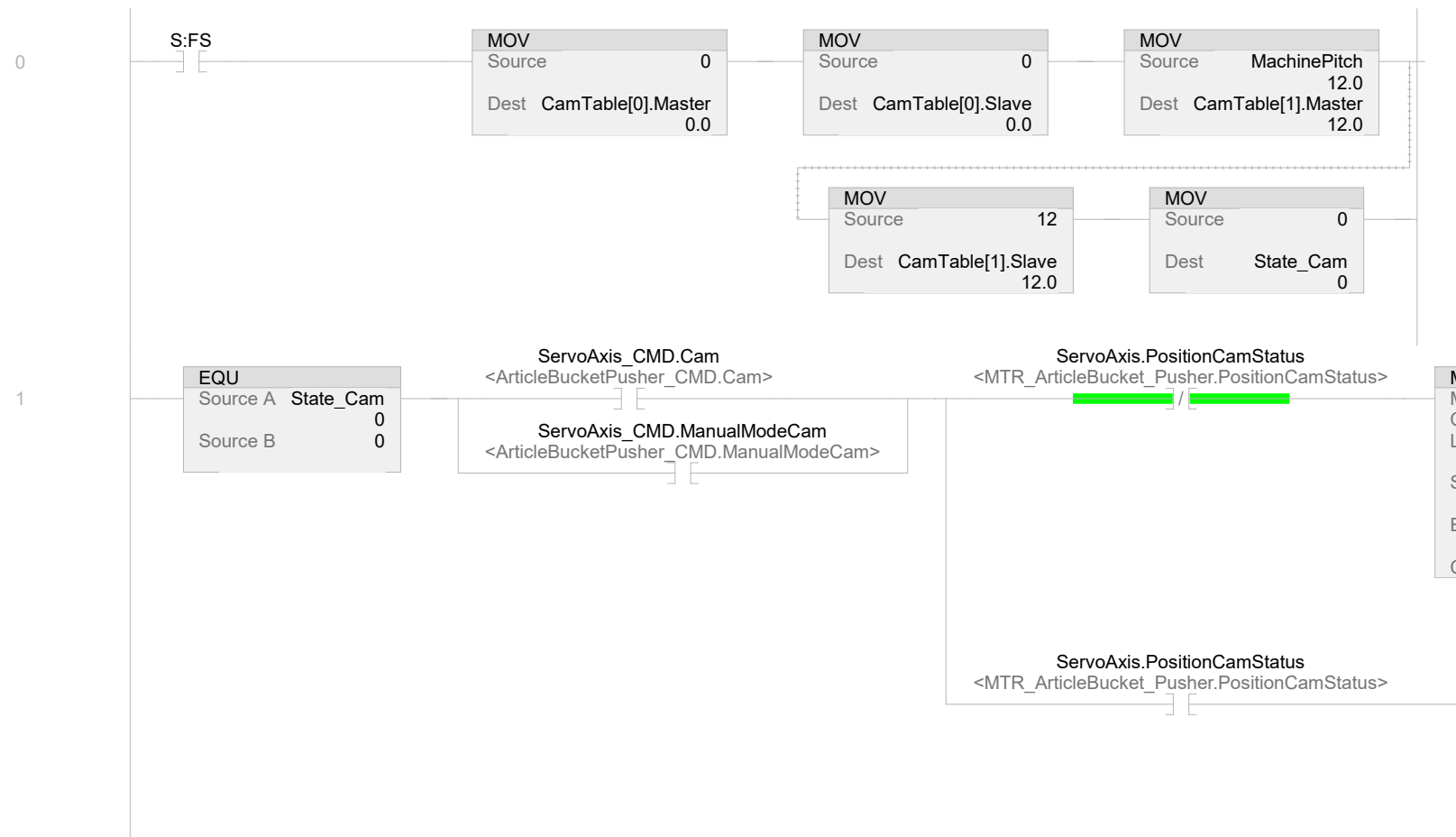












CCP	
Motion Control	CamMCCPCommand
Cam	CamTable[0]
Length	2
Start Slope	1
End Slope	1
Cam Profile	CamProfile[0]



CamMRPCCommand.DN

CamMRPCCommand.ER

MOV	
Source	20
Dest	State_Cam 0

MOV	
Source	999
Dest	State_Cam 0

MOV	
Source	50
Dest	State_Cam 0

EQU	
Source A	State_Cam 0
Source B	20

MAM	
Axis	ServoAxis
Motion Control	<MTR_ArticleBucket_Pusher>
Move Type	MAM_command
	Incremental
	1
Position	ArticlePusherChainCorrection
	11.958543
Speed	AxisMoveSpeed
	4.0
Speed Units	Units per sec
Accel Rate	AxisAccelRate
	2.0
Accel Units	Units per sec2
Decel Rate	AxisDecelRate
	2.0
Decel Units	Units per sec2
Profile	Trapezoidal
Accel Jerk	100.0
Decel Jerk	100.0
Jerk Units	% of Maximum
Merge	Disabled
Merge Speed	Programmed
Lock Position	0
Lock Direction	None
Event Distance	0
Calculated Data	0



MAM_command.IP

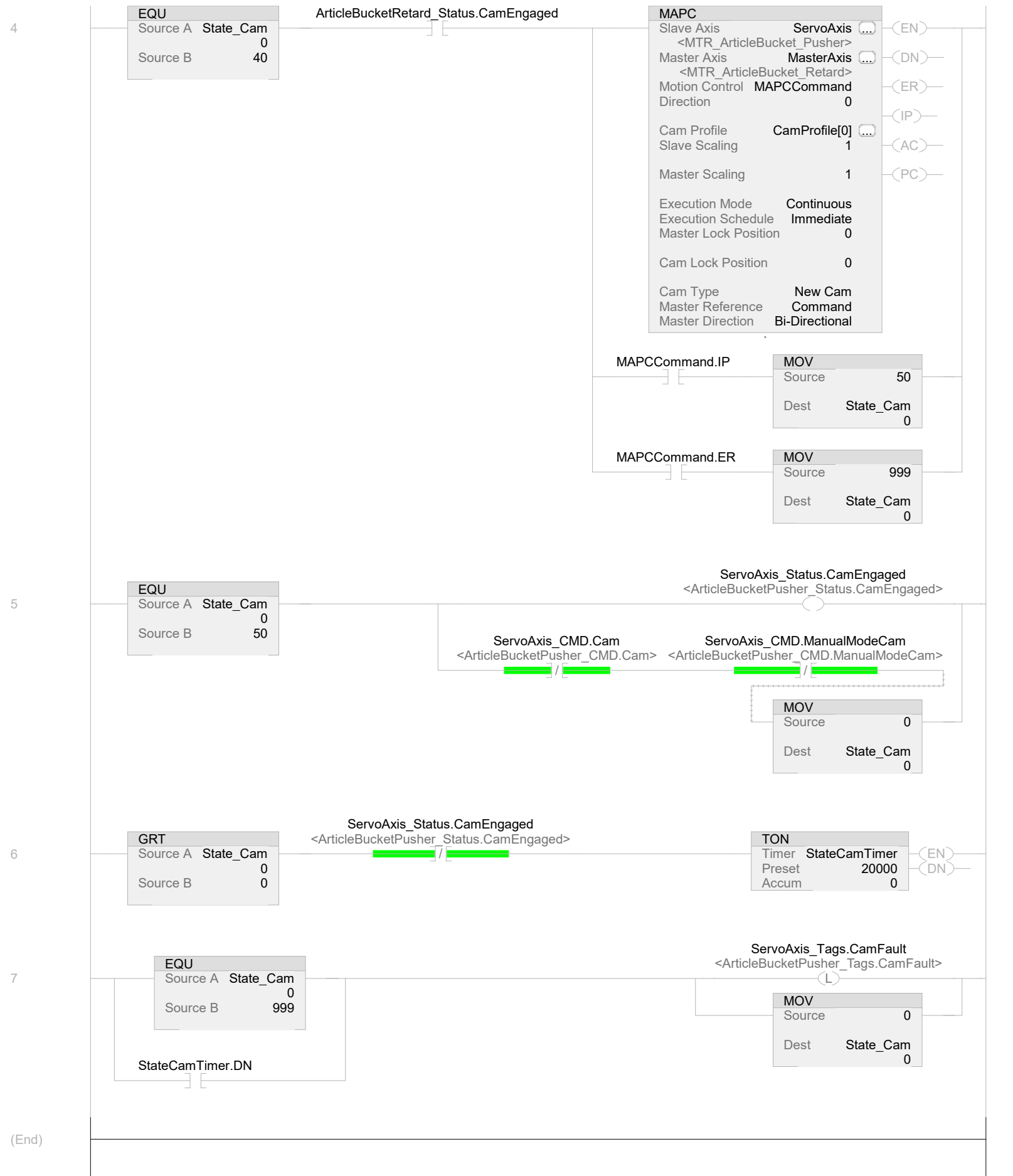
MAM_command.PC

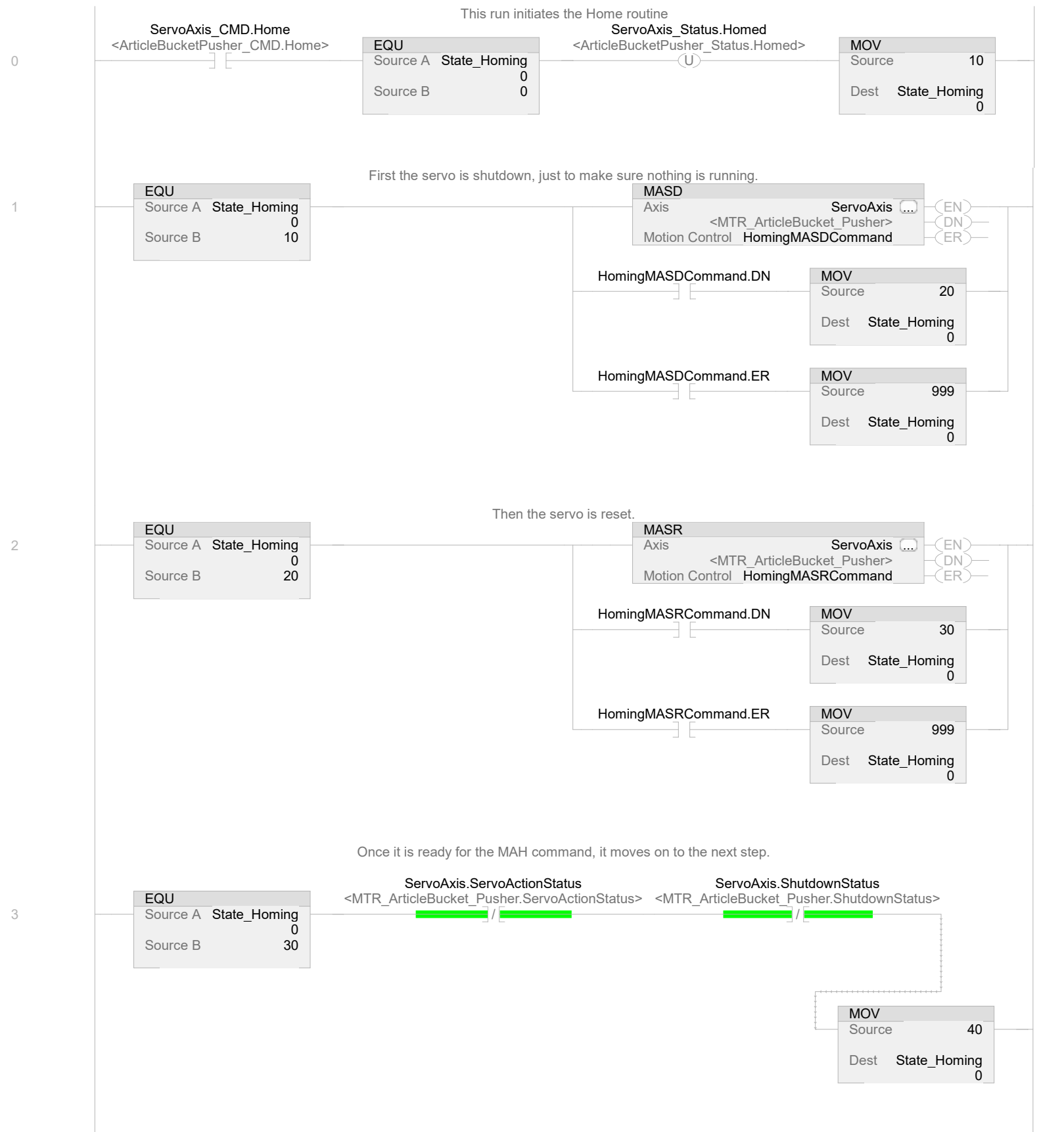
MOV	
Source	30
Dest	State_Cam 0

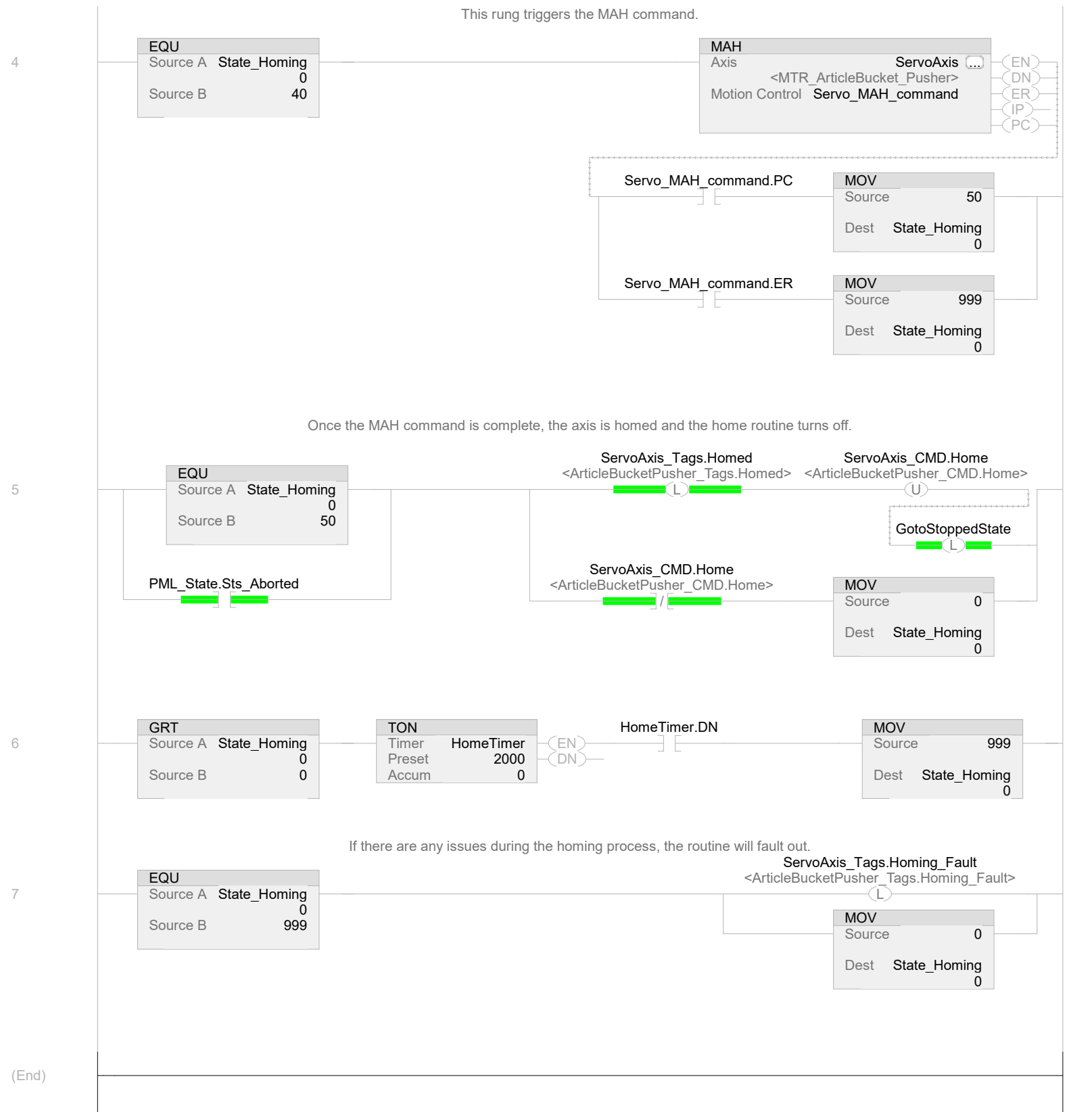
EQU	
Source A	State_Cam 0
Source B	30

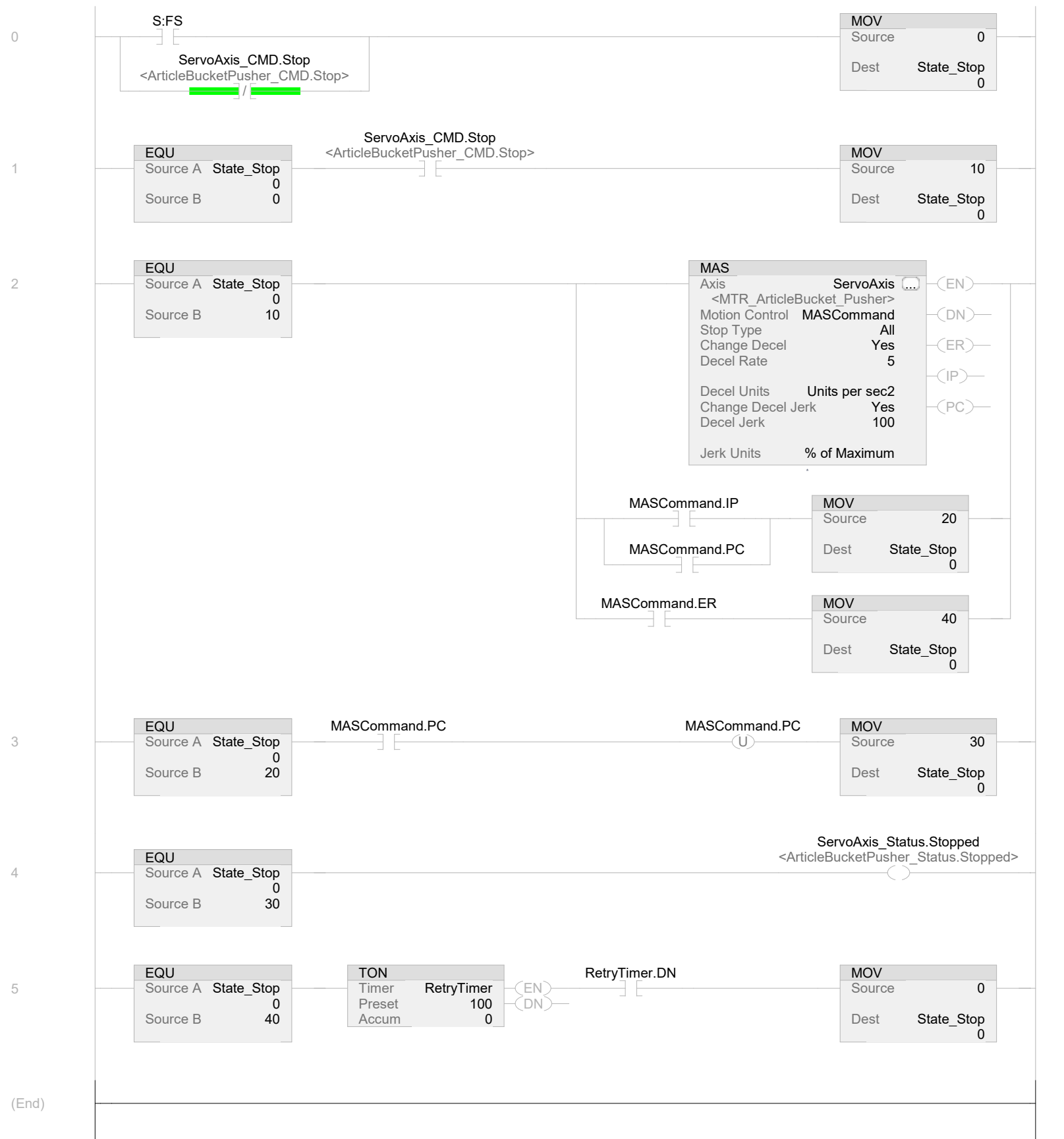
MAM_command.PC

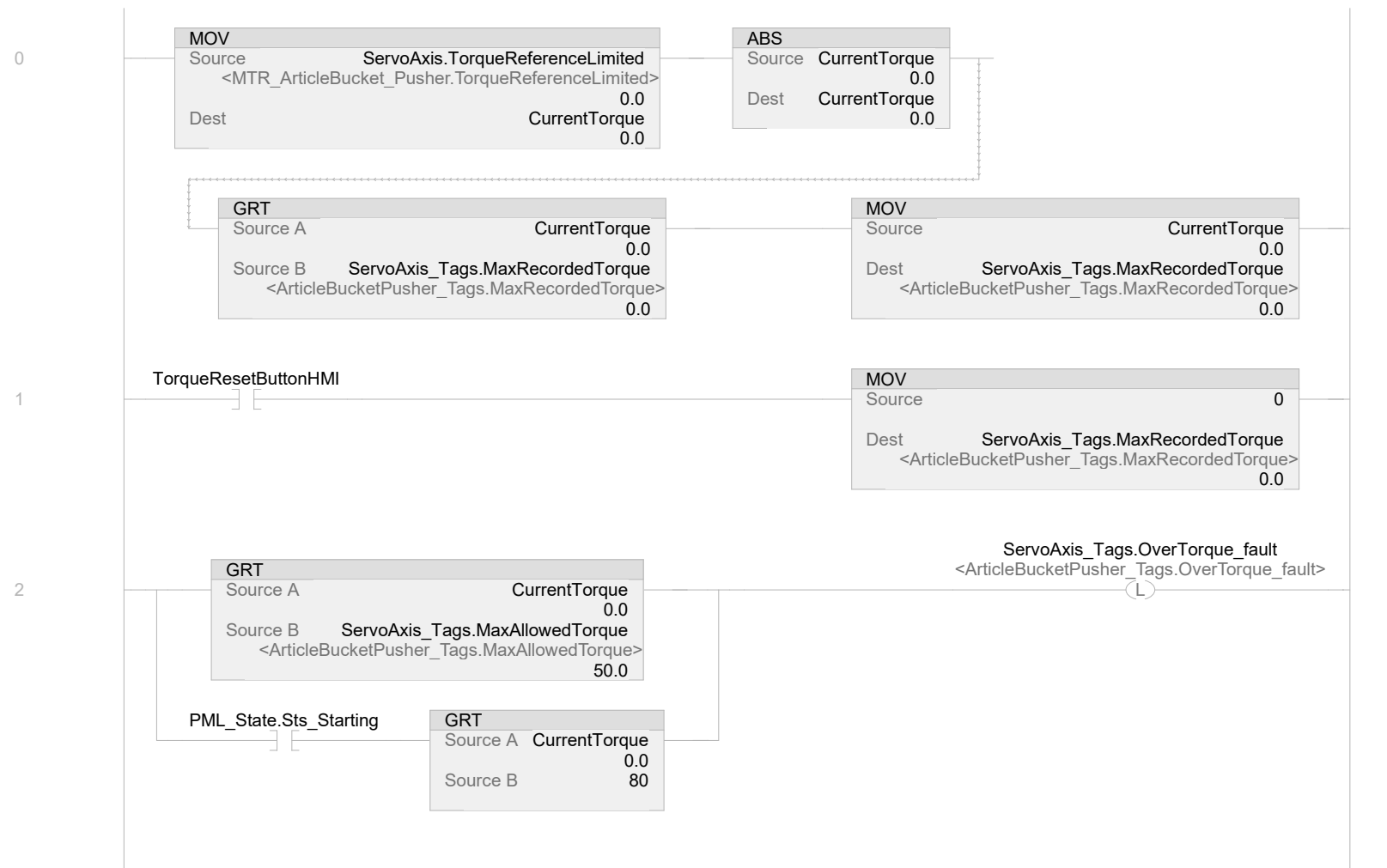
MOV	
Source	40
Dest	State_Cam 0

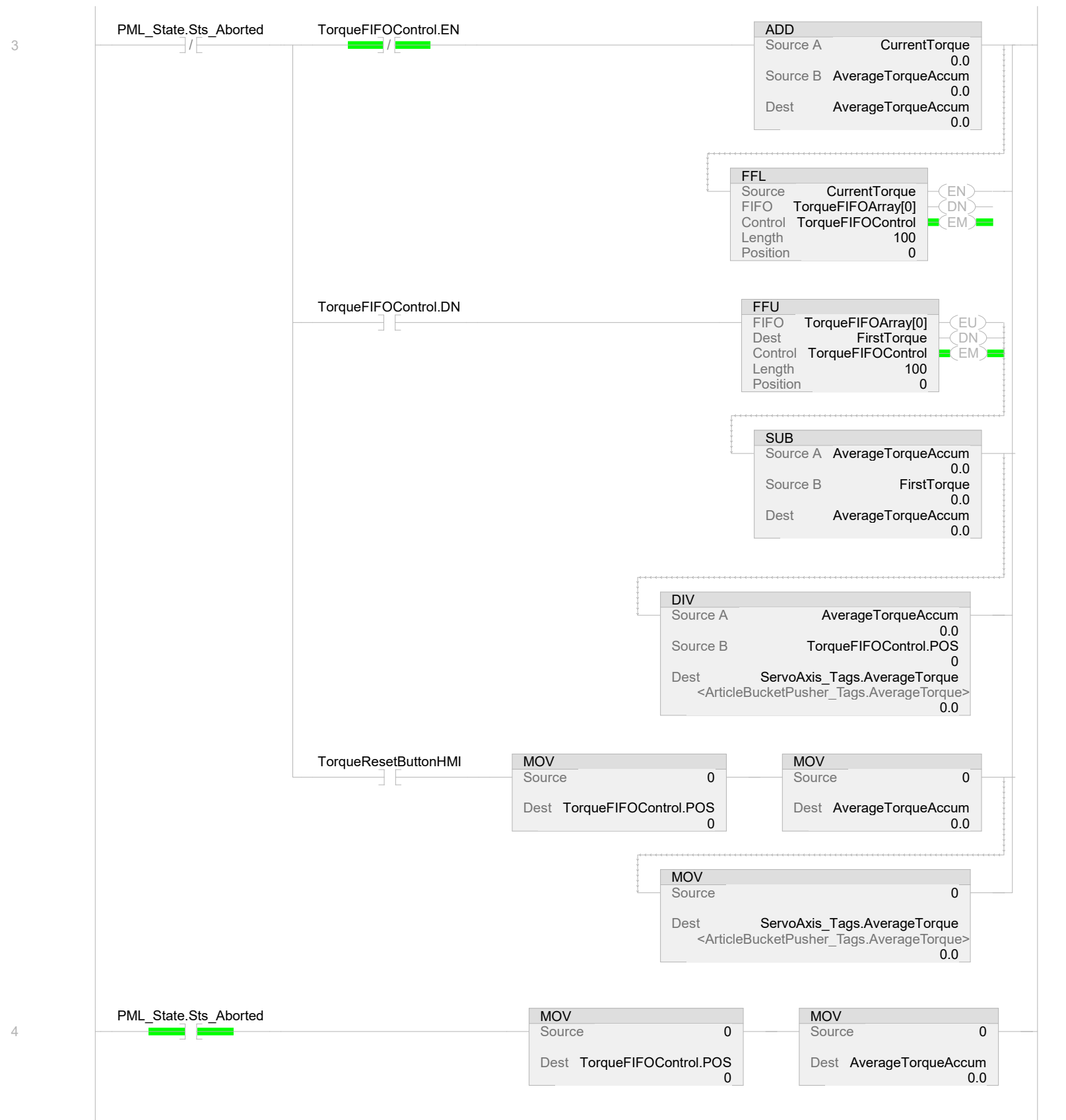












MUL

Source A

ServoAxis_Tags.MaxAllowedTorque

<ArticleBucketPusher_Tags.MaxAllowedTorque>

50.0

Source B

-1.1

Dest

ServoAxis_Tags.Drive_Internal_TorqueLimit_NEG

<ArticleBucketPusher_Tags.Drive_Internal_TorqueLimit_NEG>

-55.0

NEQ

Source A

ServoAxis_Tags.Drive_Internal_TorqueLimit_POS

<ArticleBucketPusher_Tags.Drive_Internal_TorqueLimit_POS>

199.04

Source B

ServoAxis_Tags.Drive_Internal_TorqueLimit_POS

<ArticleBucketPusher_Tags.Drive_Internal_TorqueLimit_POS>

5

NEQ

Source A

ServoAxis_Tags.Drive_Internal_TorqueLimit_NEG

<ArticleBucketPusher_Tags.Drive_Internal_TorqueLimit_NEG>

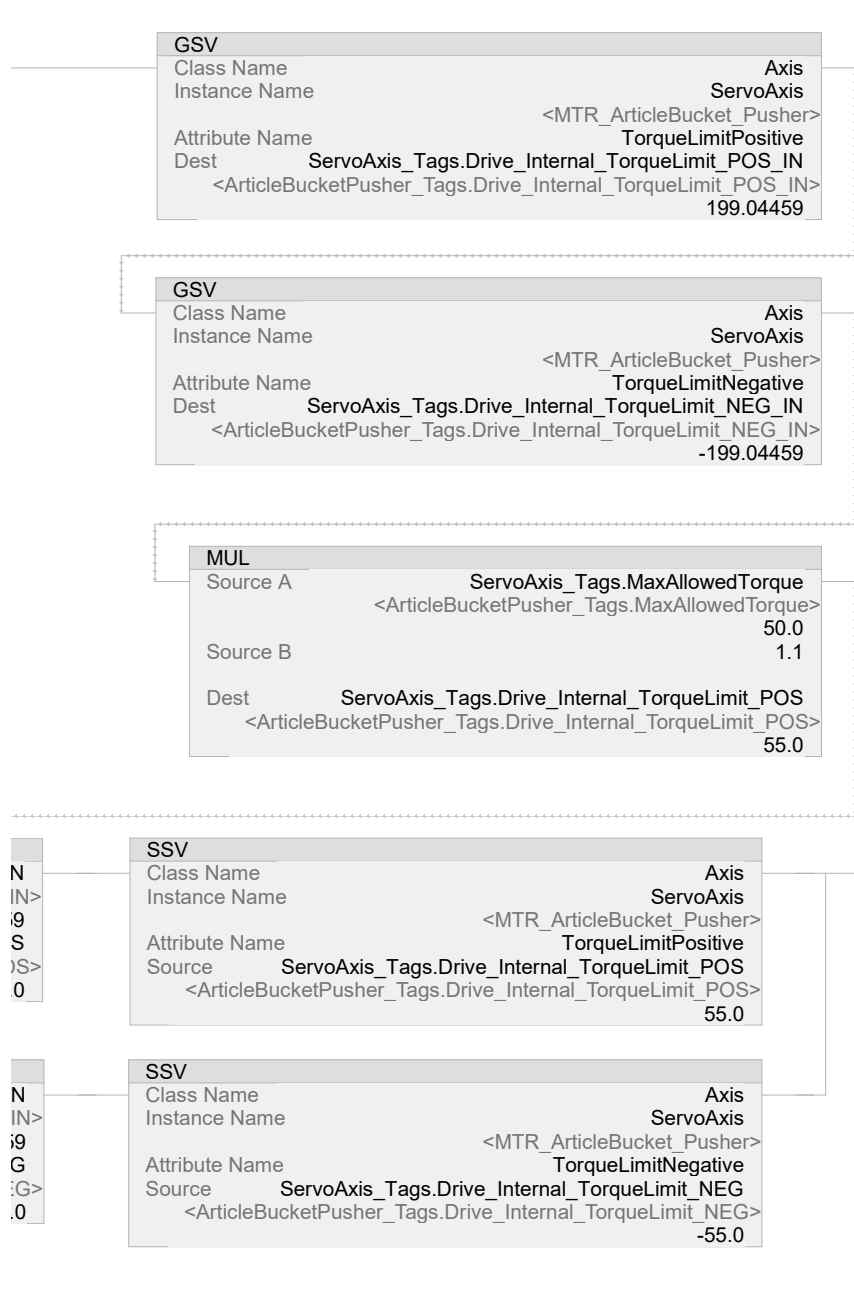
-199.04

Source B

ServoAxis_Tags.Drive_Internal_TorqueLimit_NEG

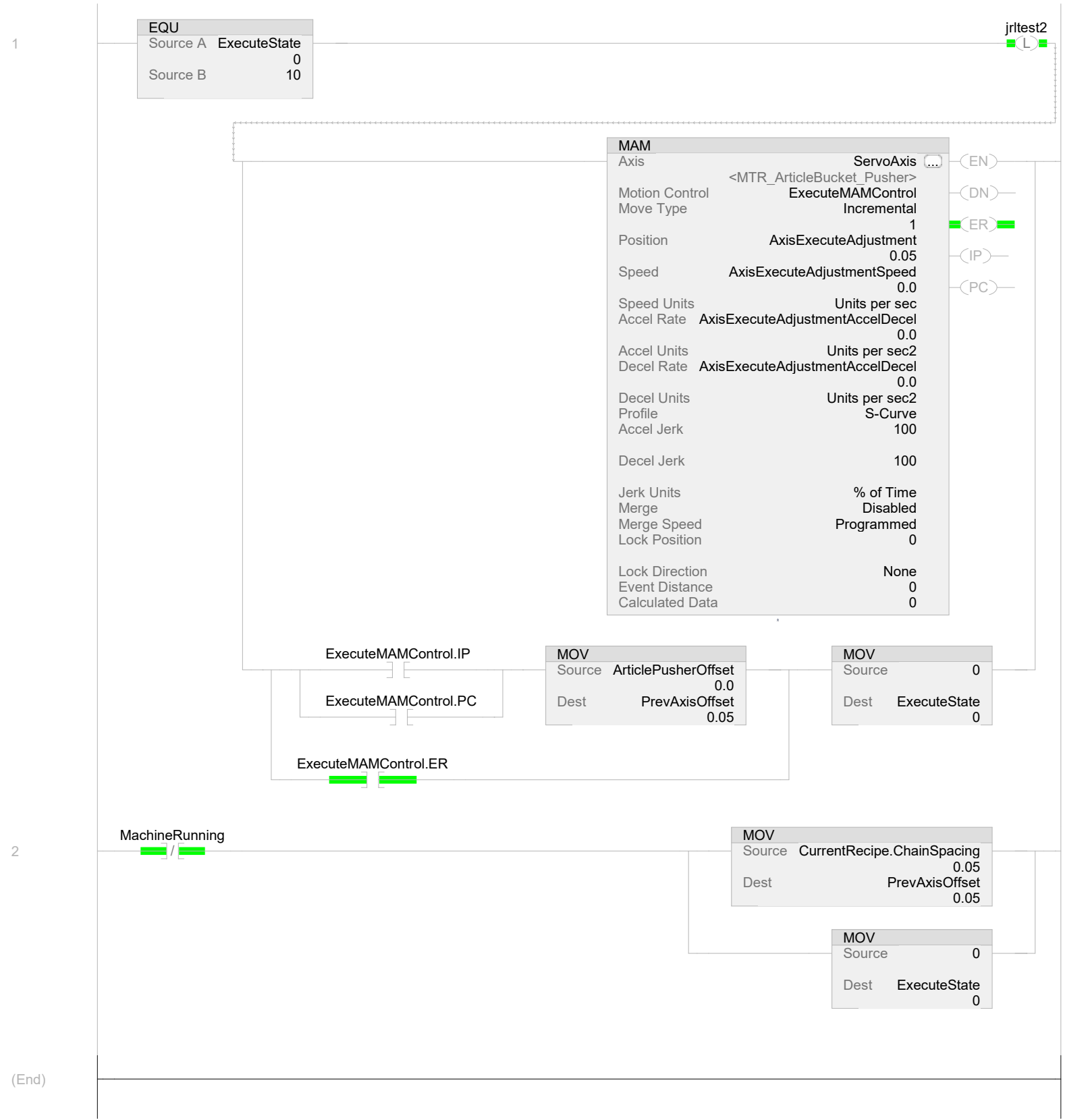
<ArticleBucketPusher_Tags.Drive_Internal_TorqueLimit_NEG>

-5

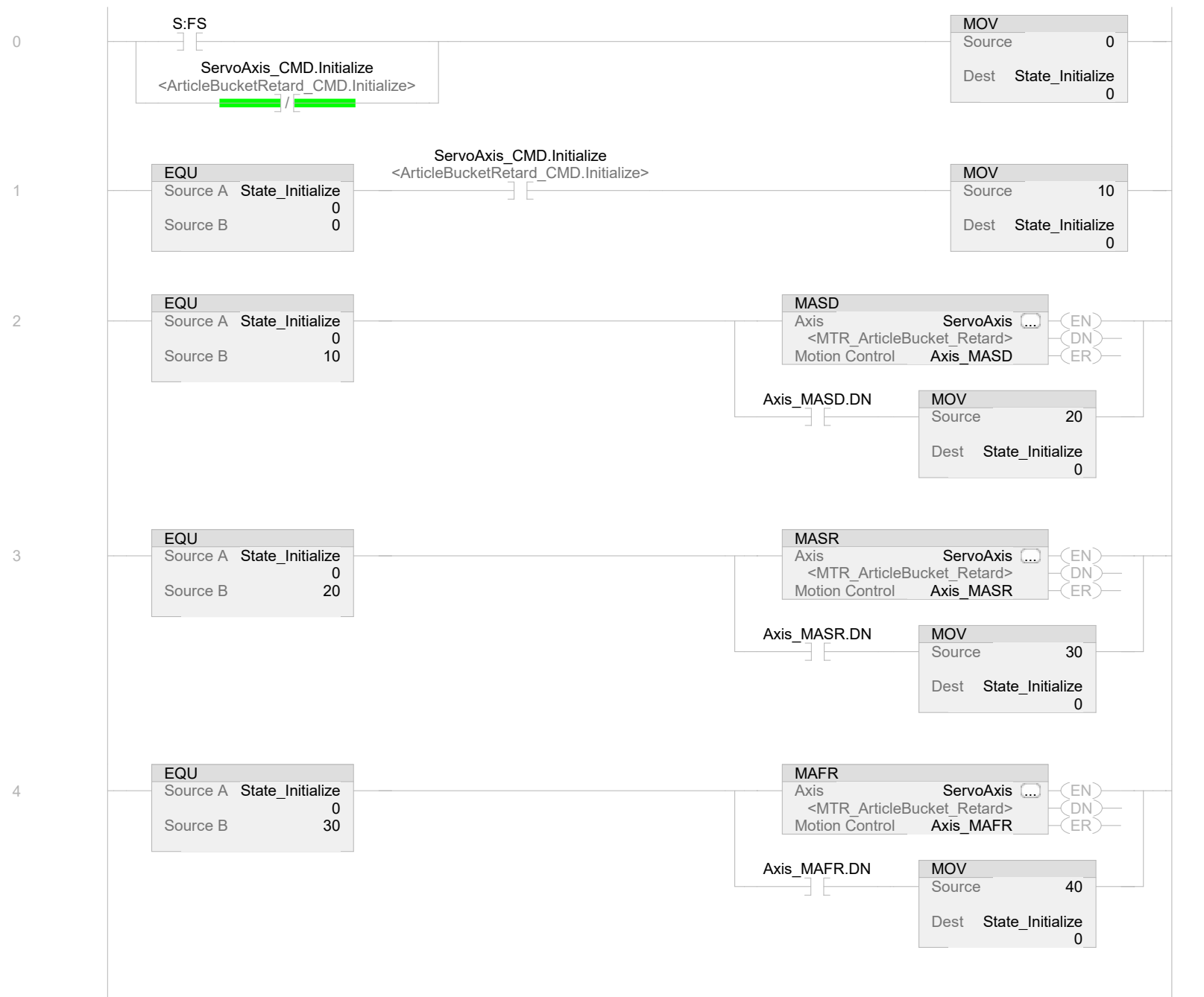


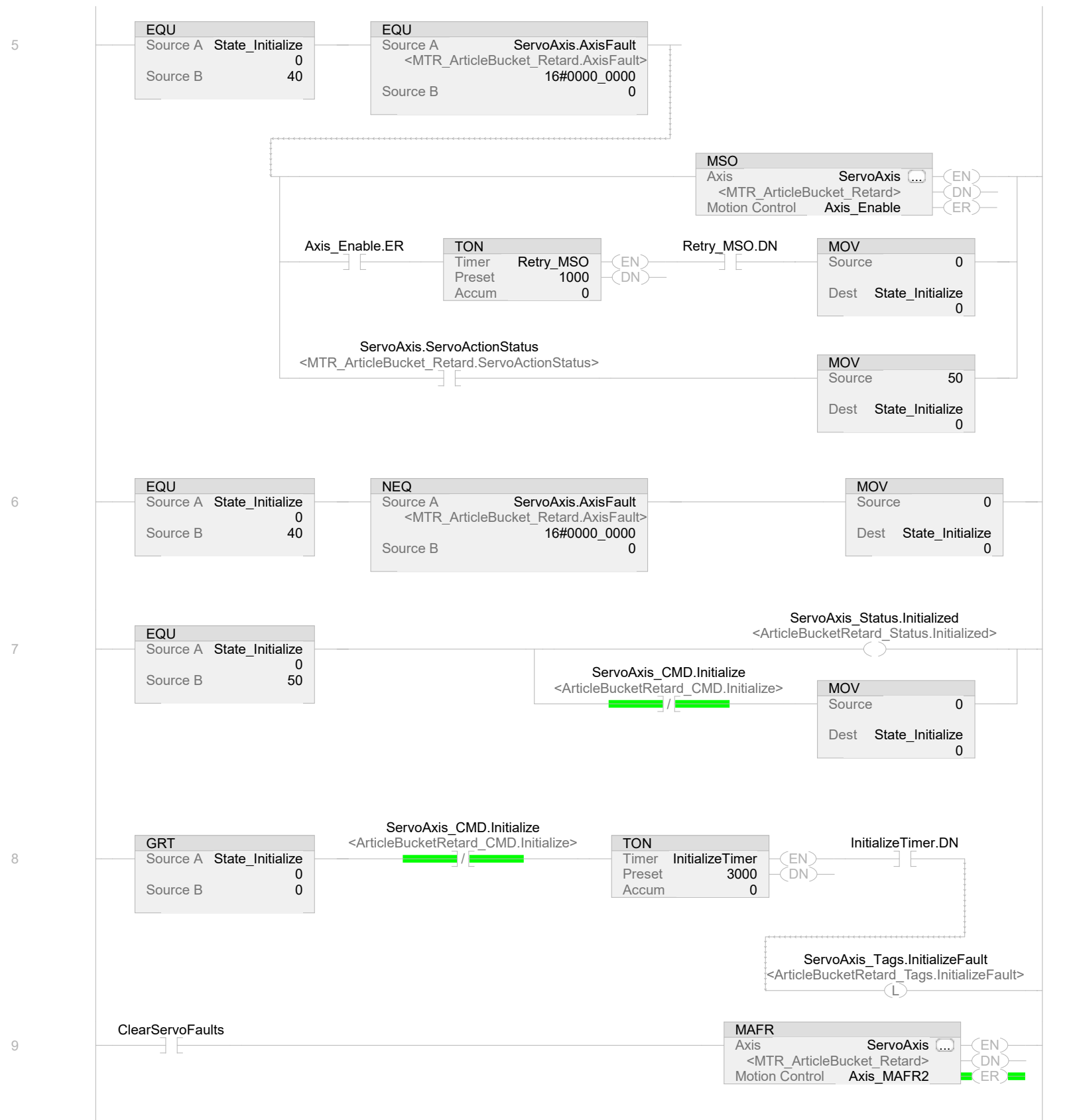
(End)



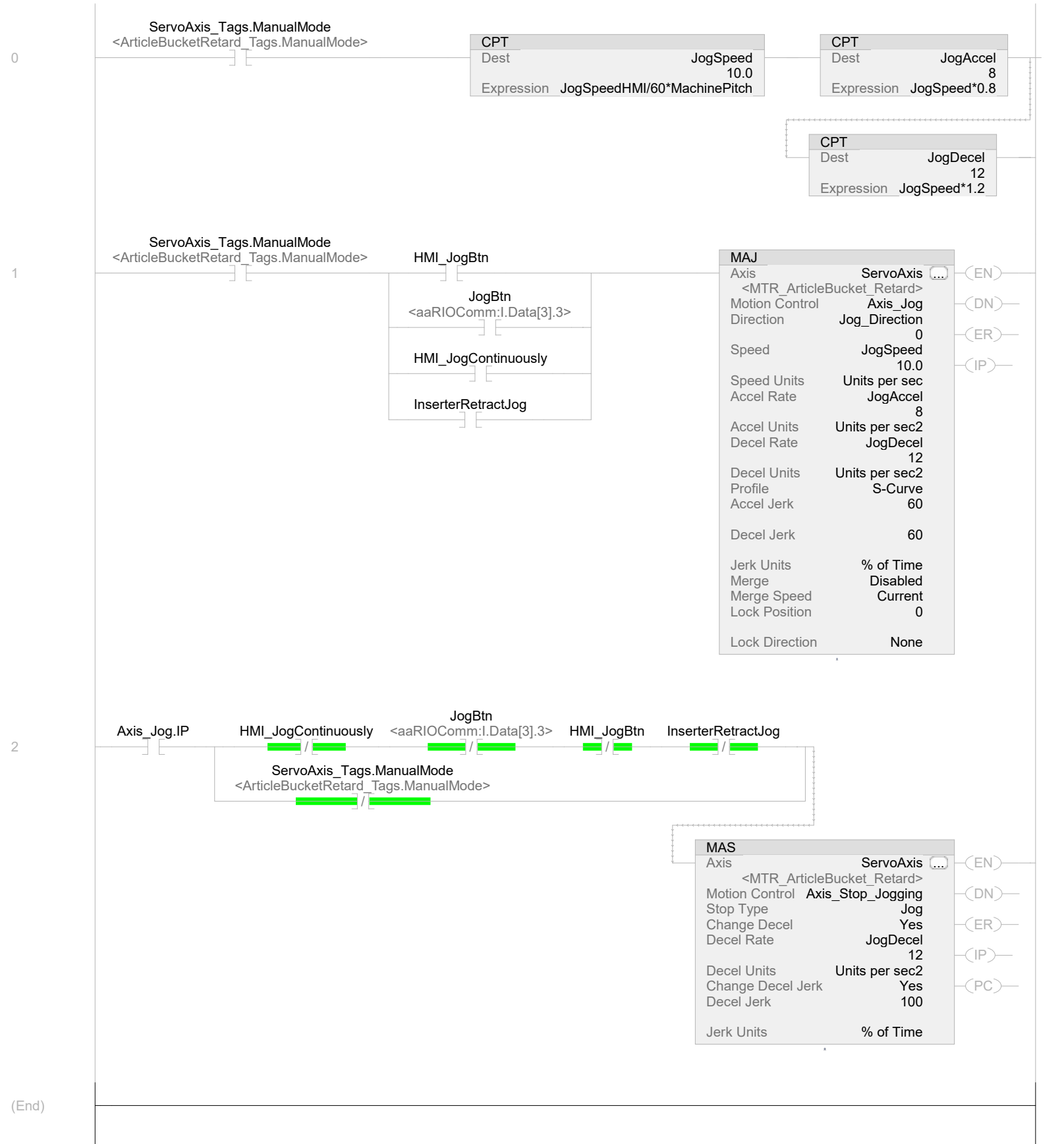


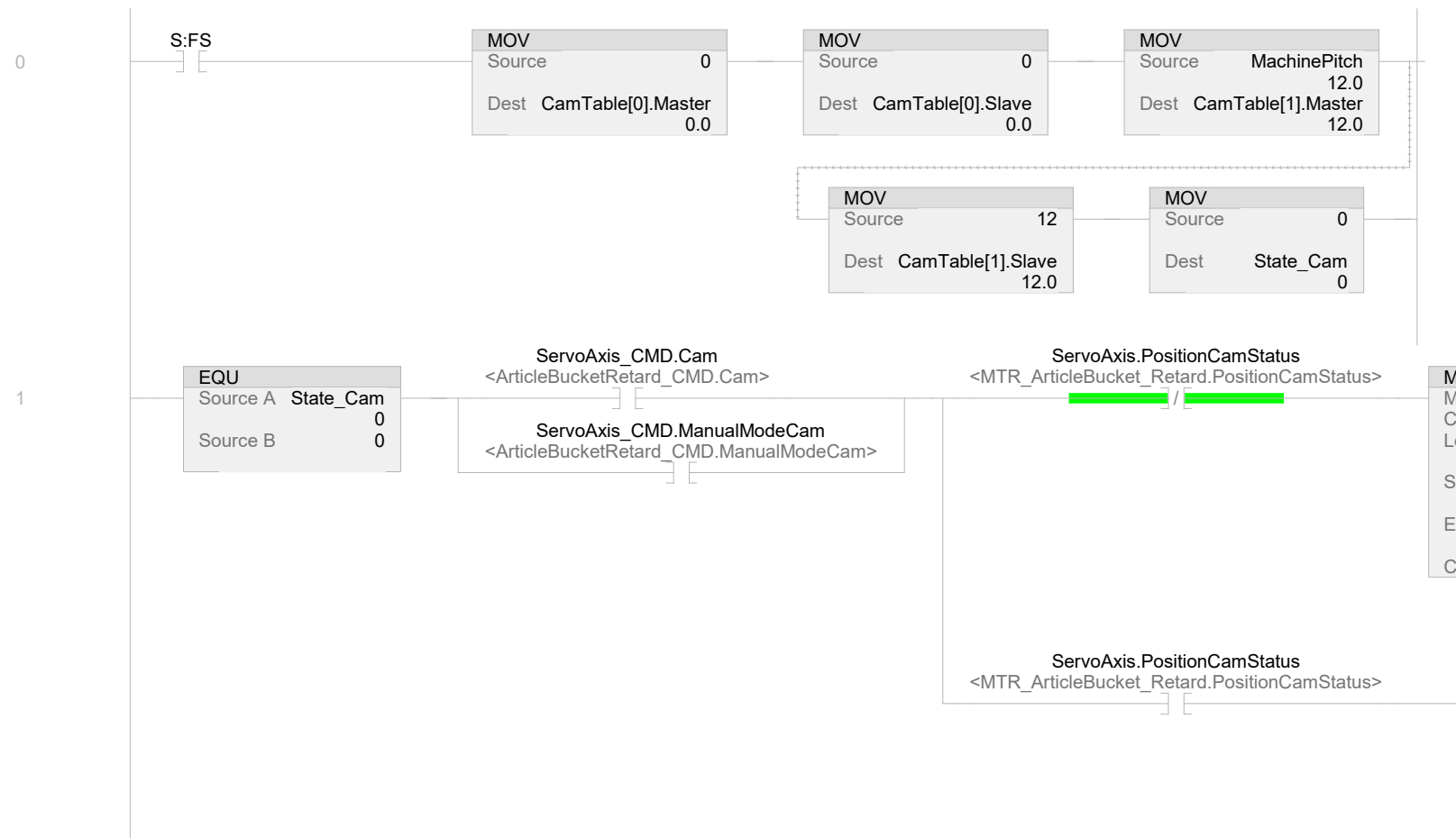


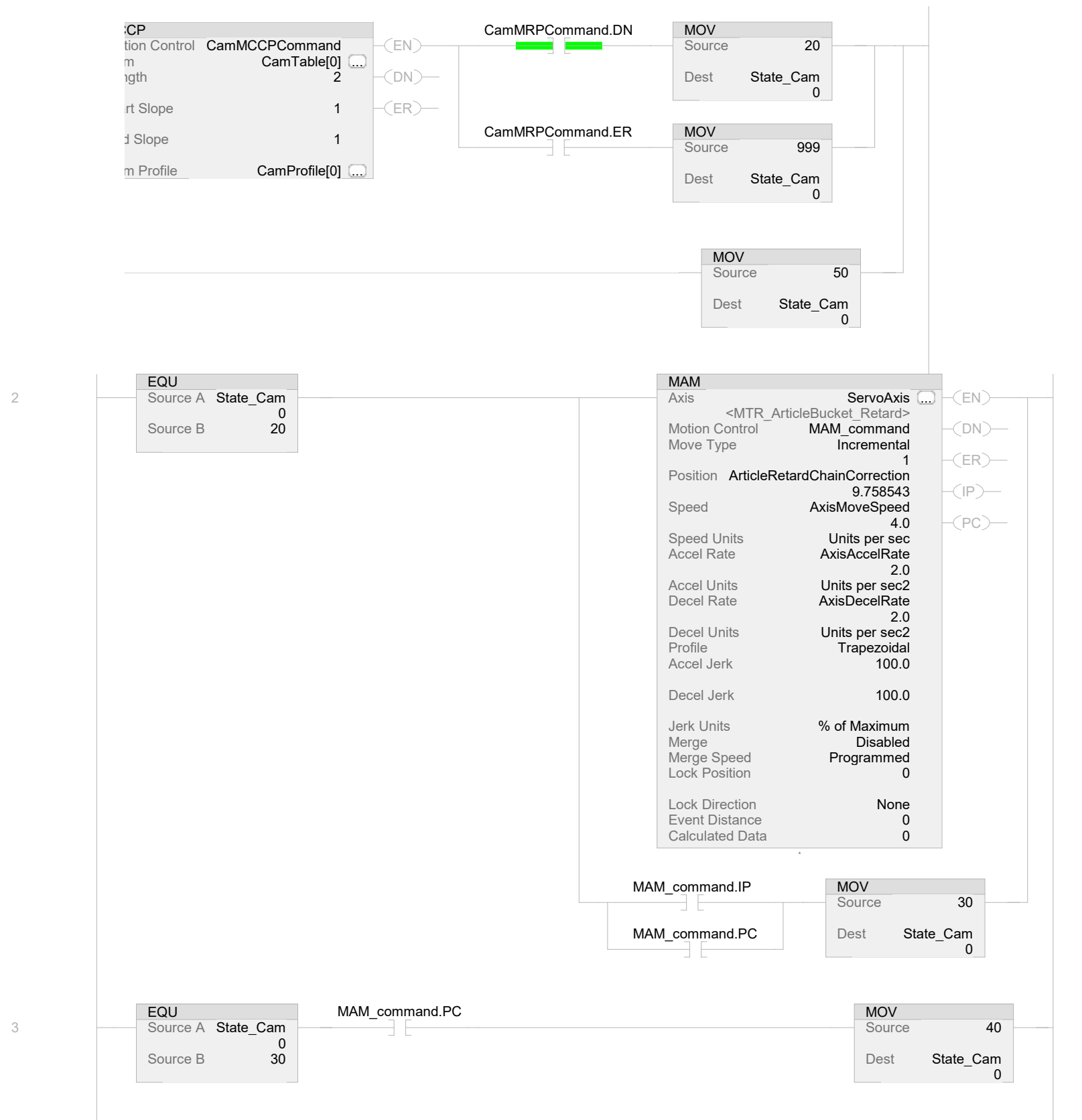


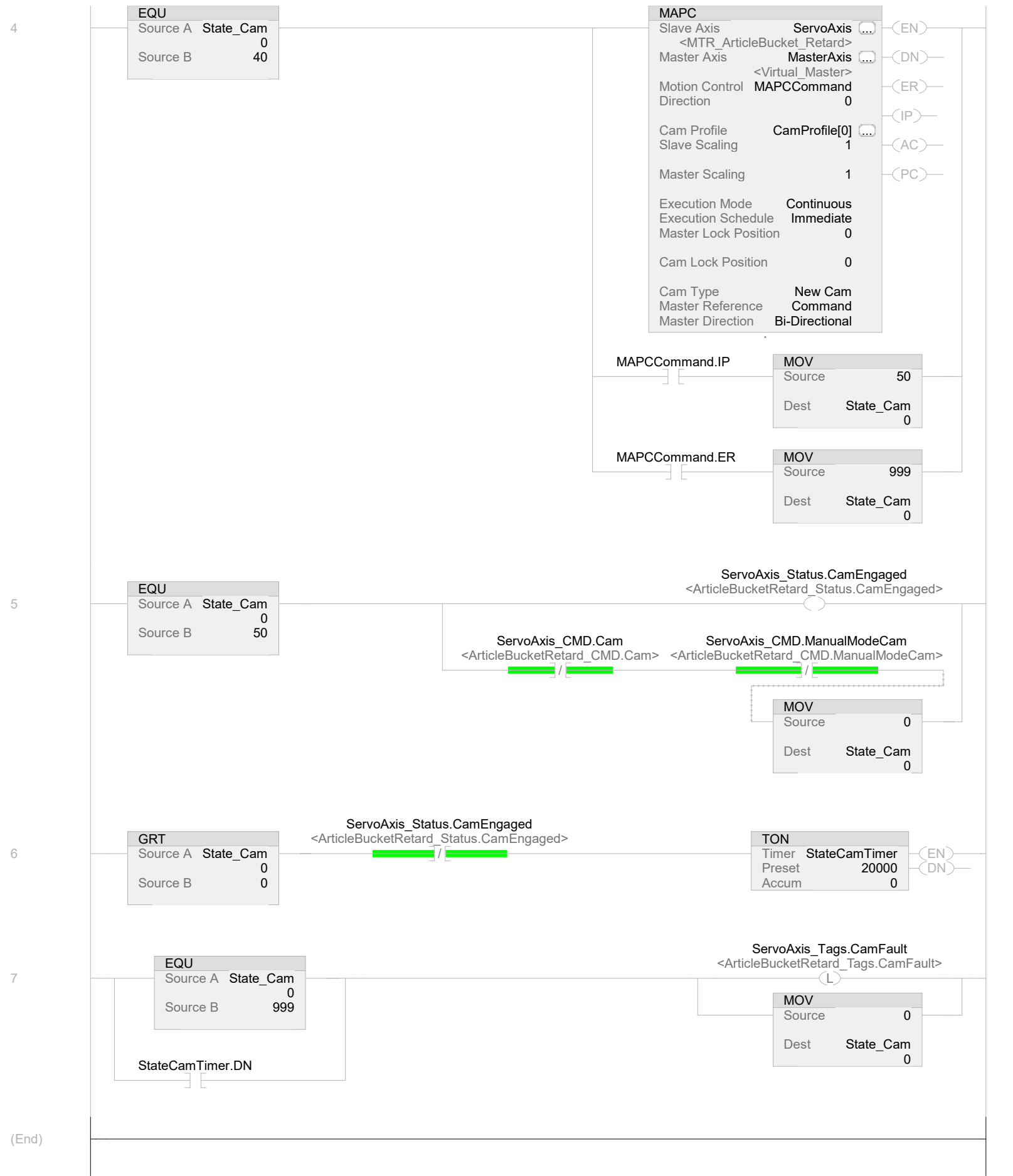


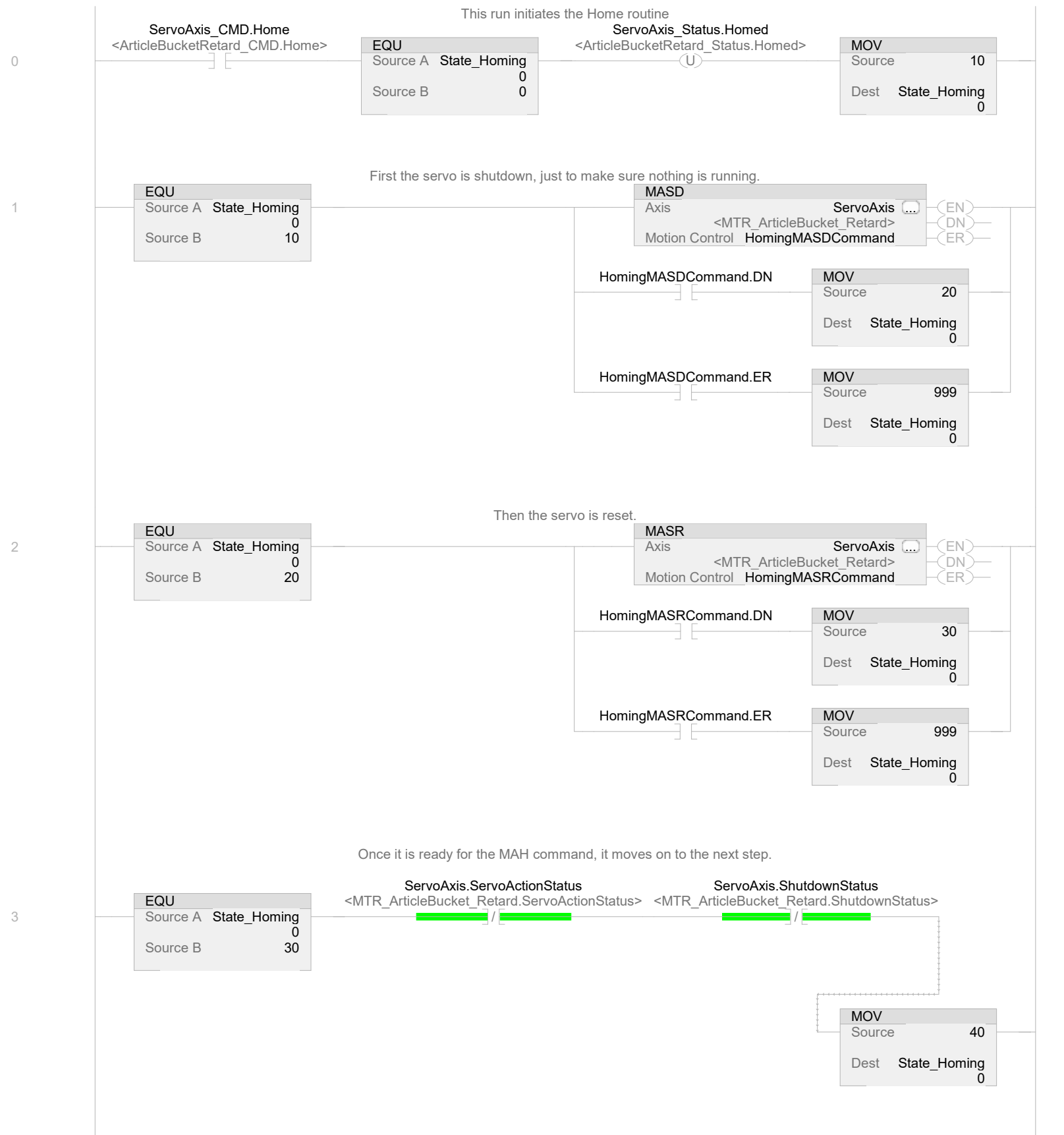


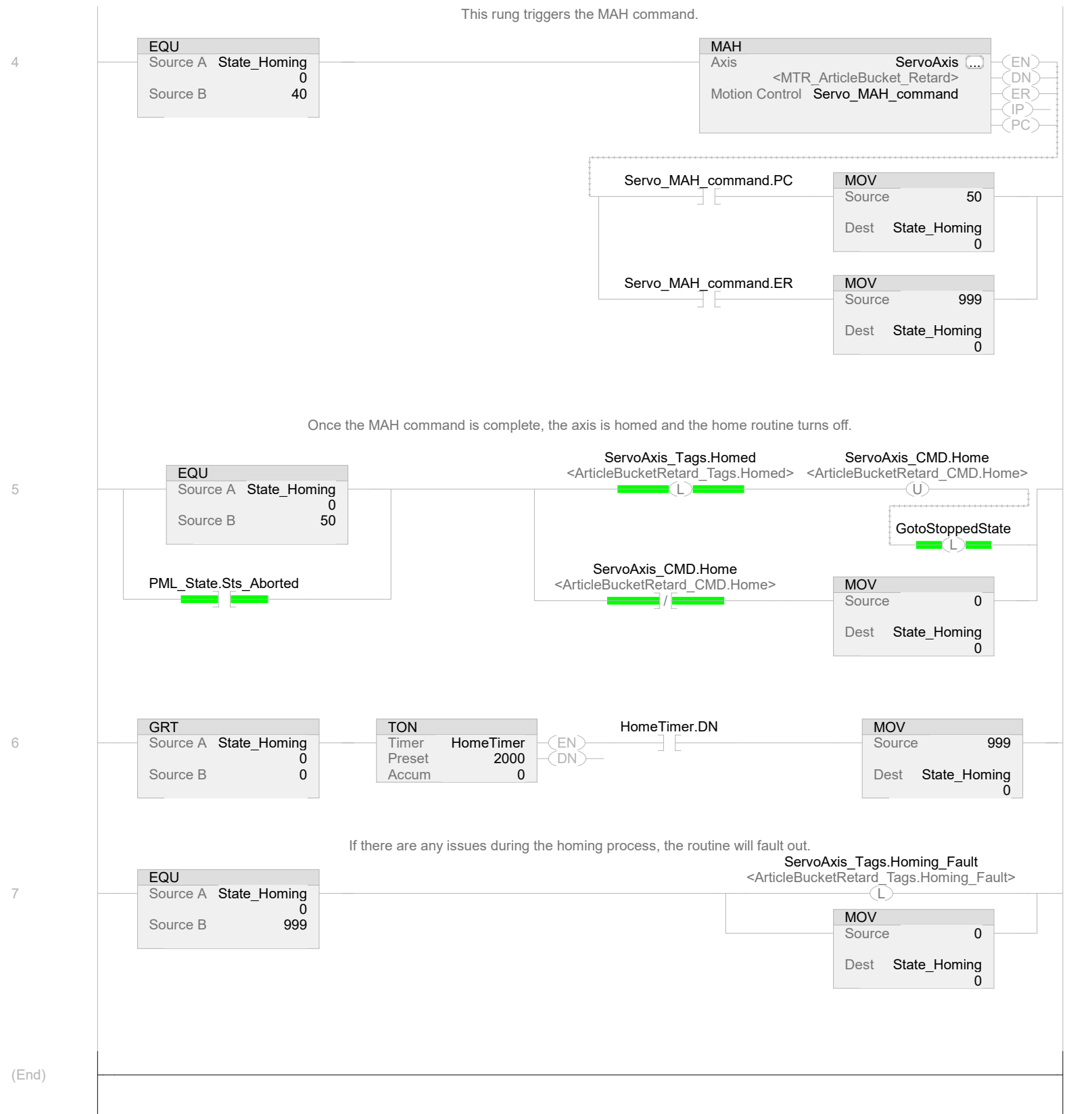


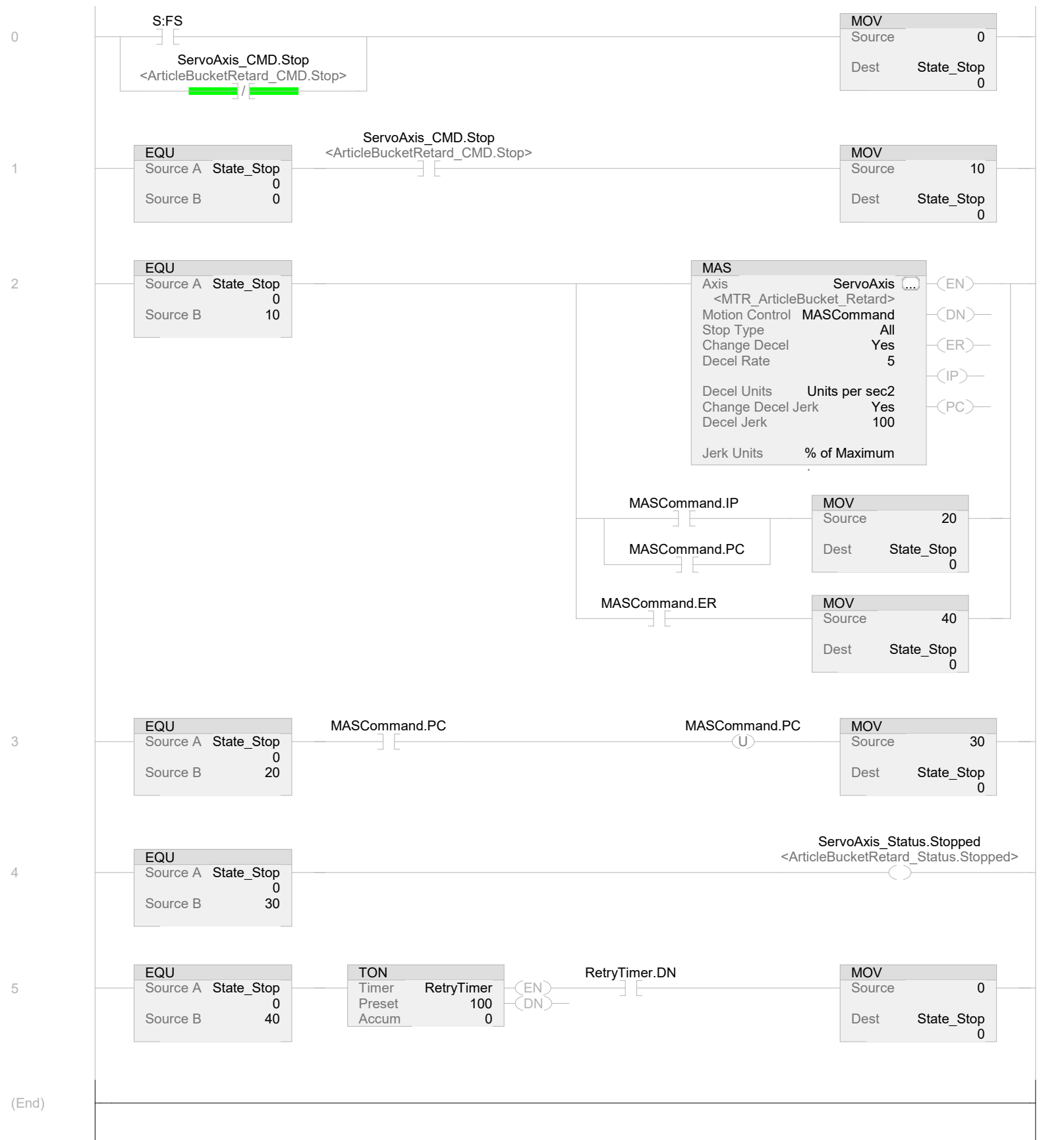


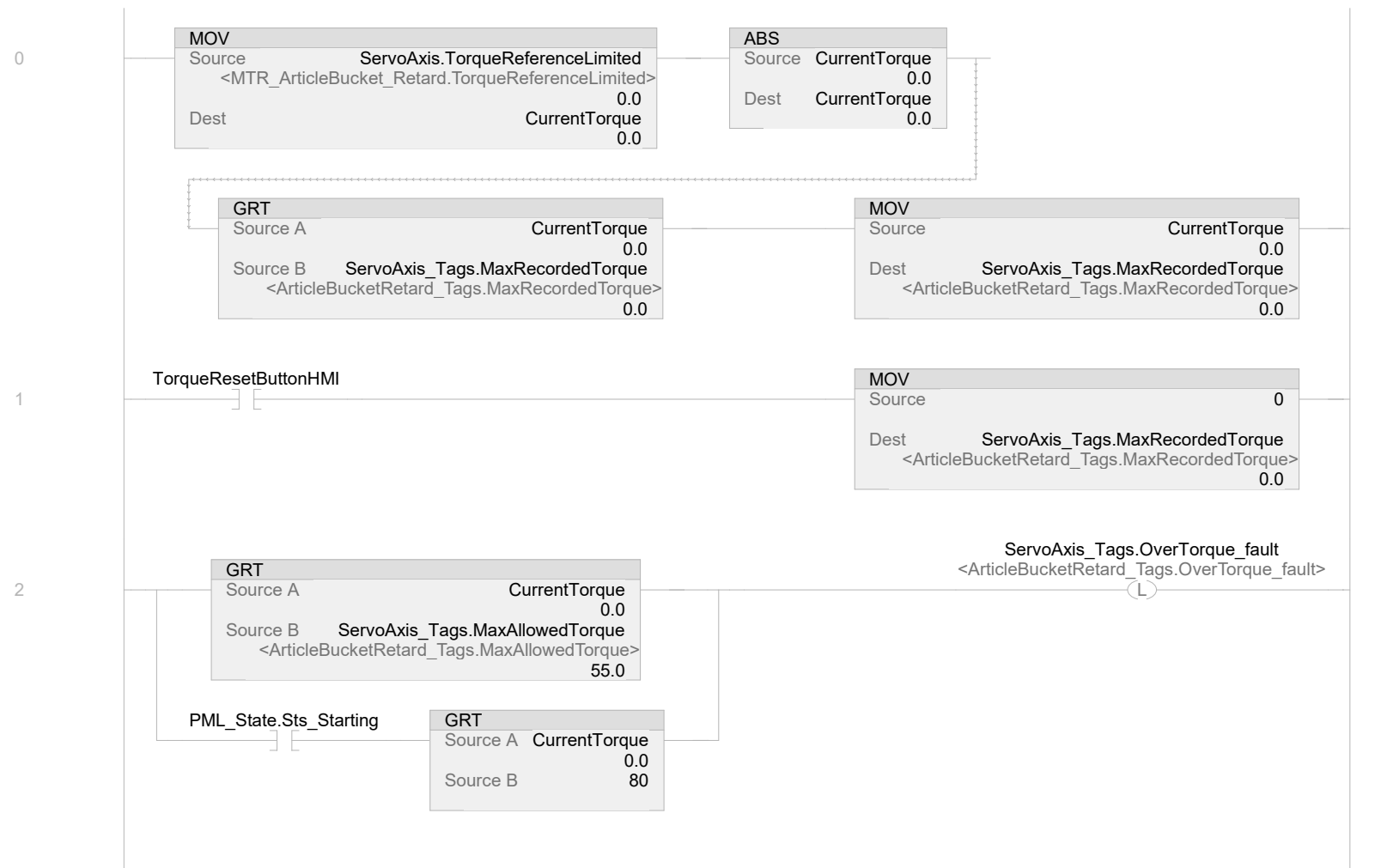


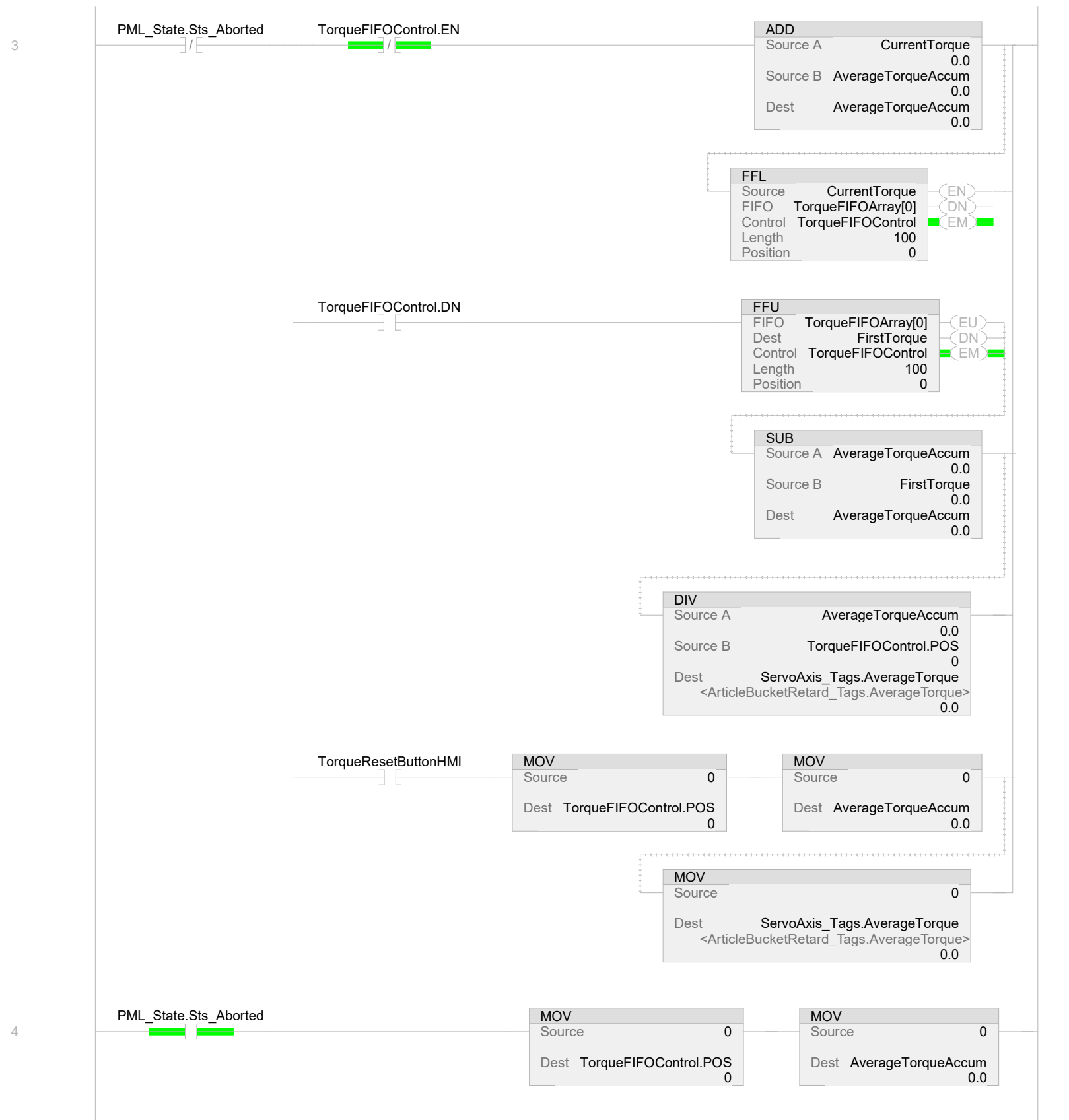




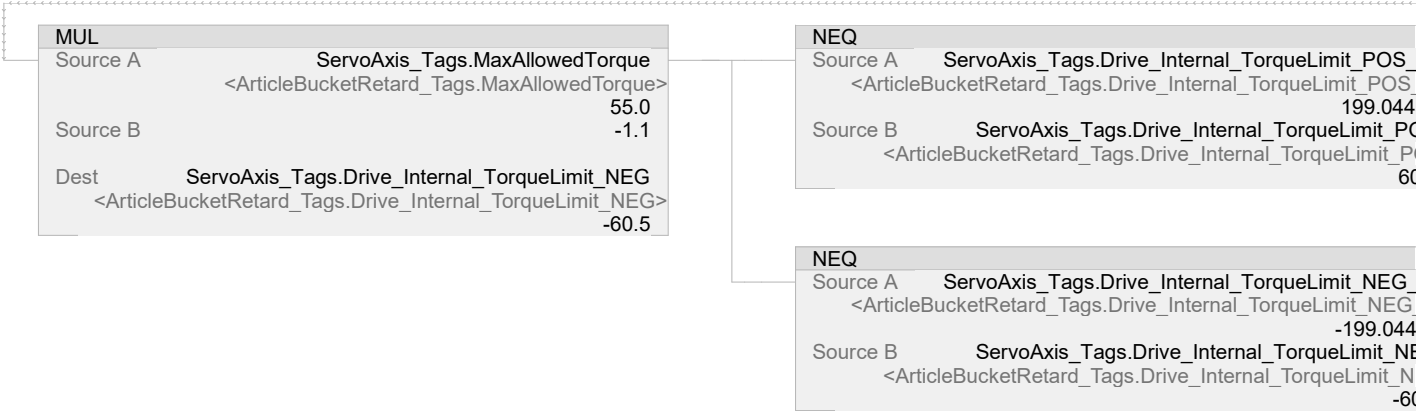


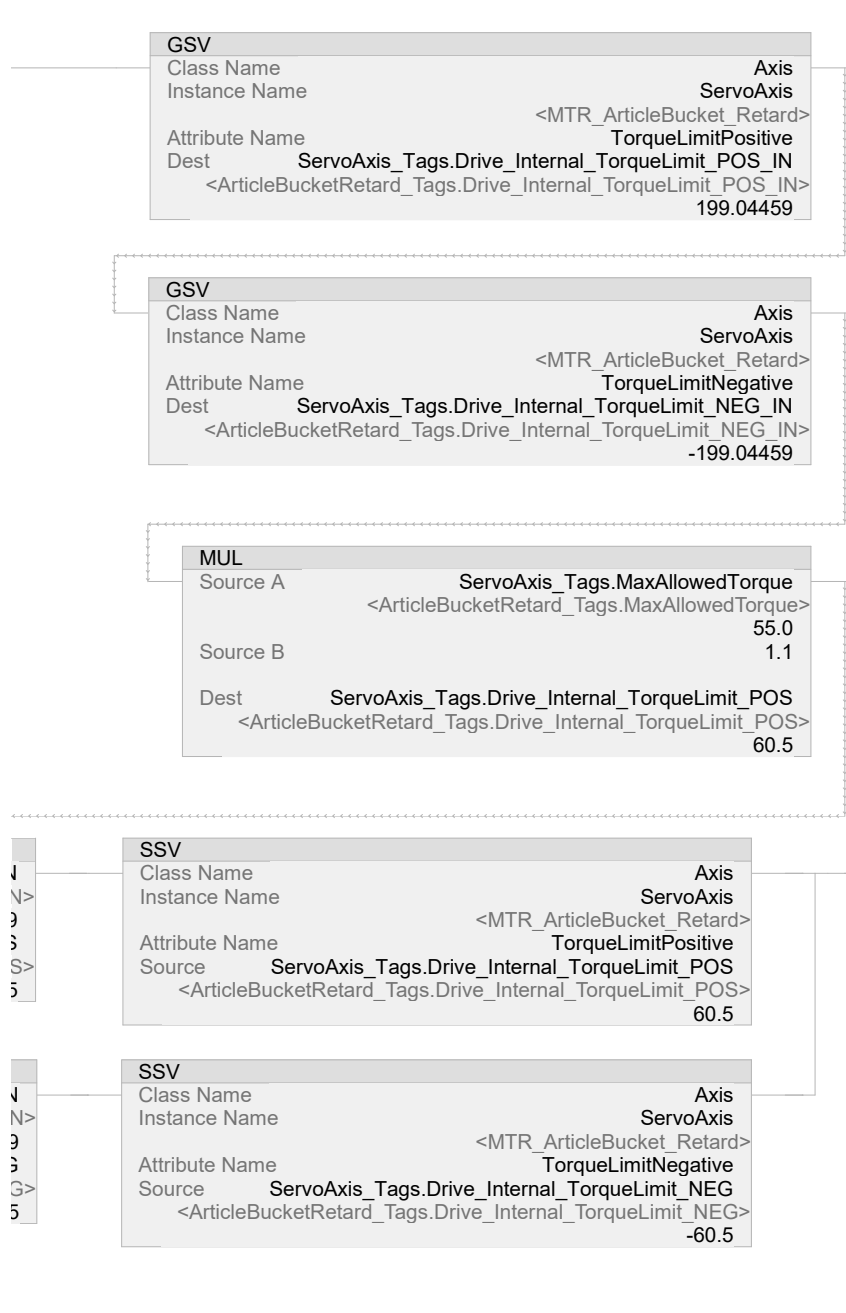






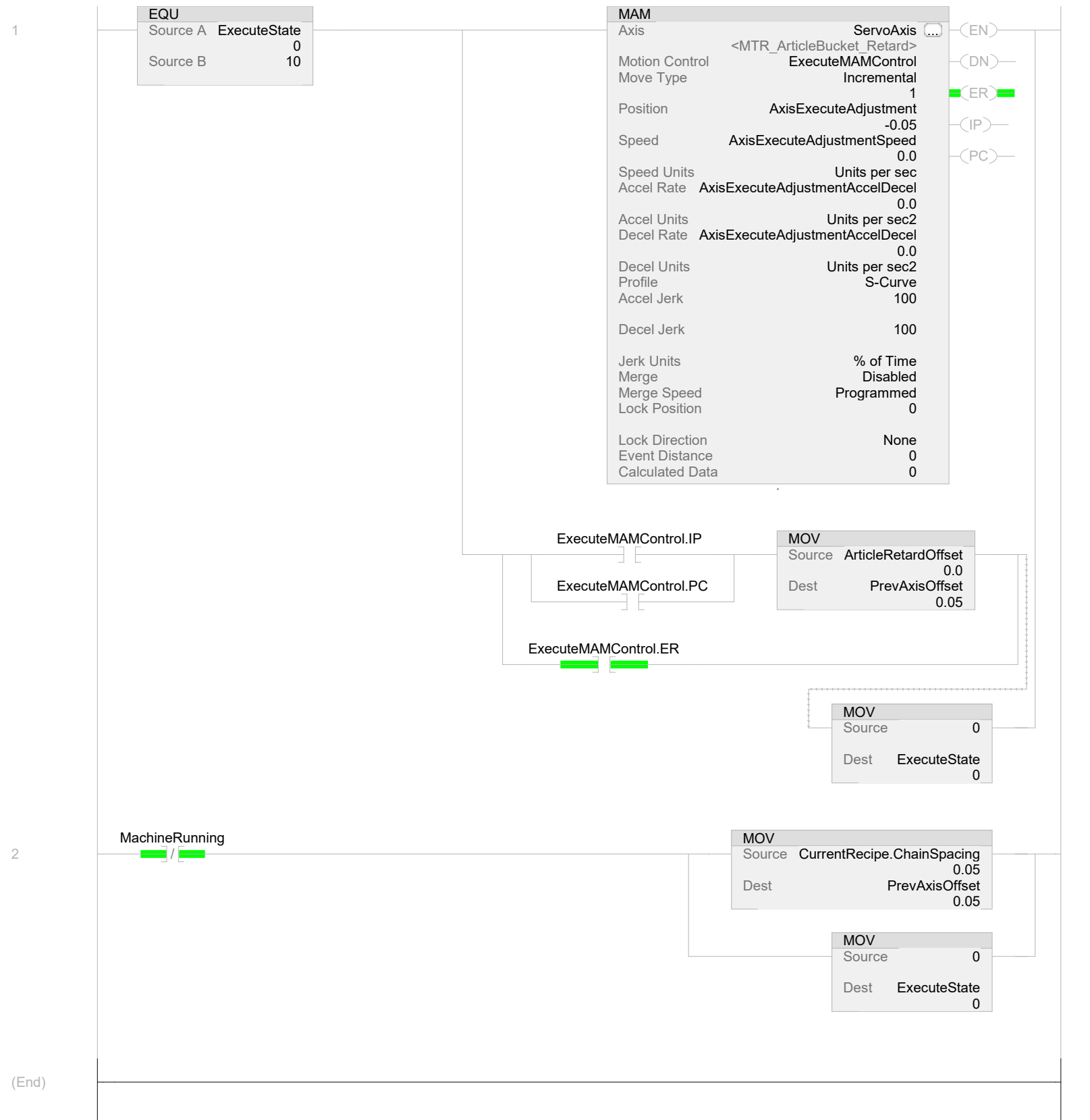
5



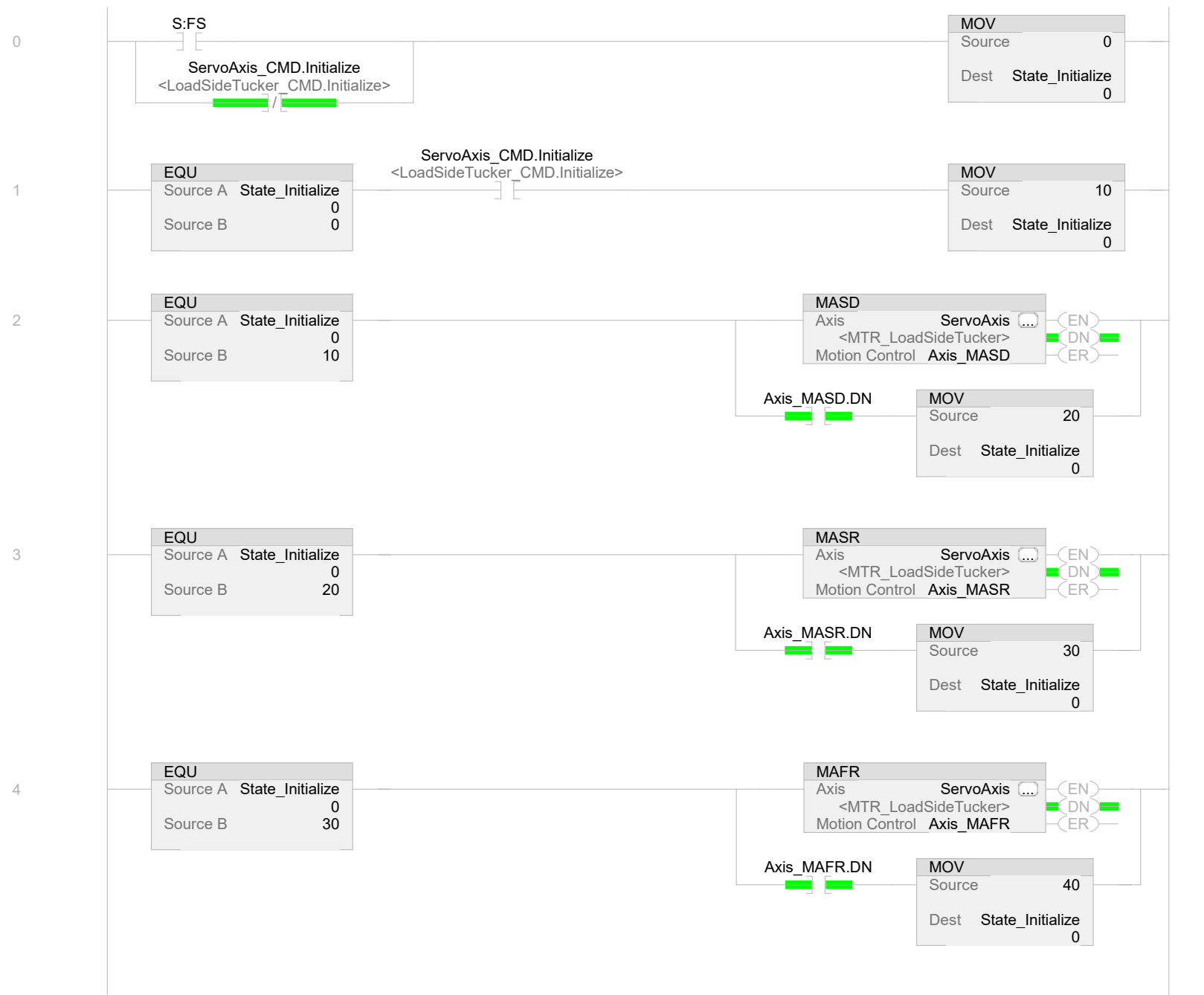


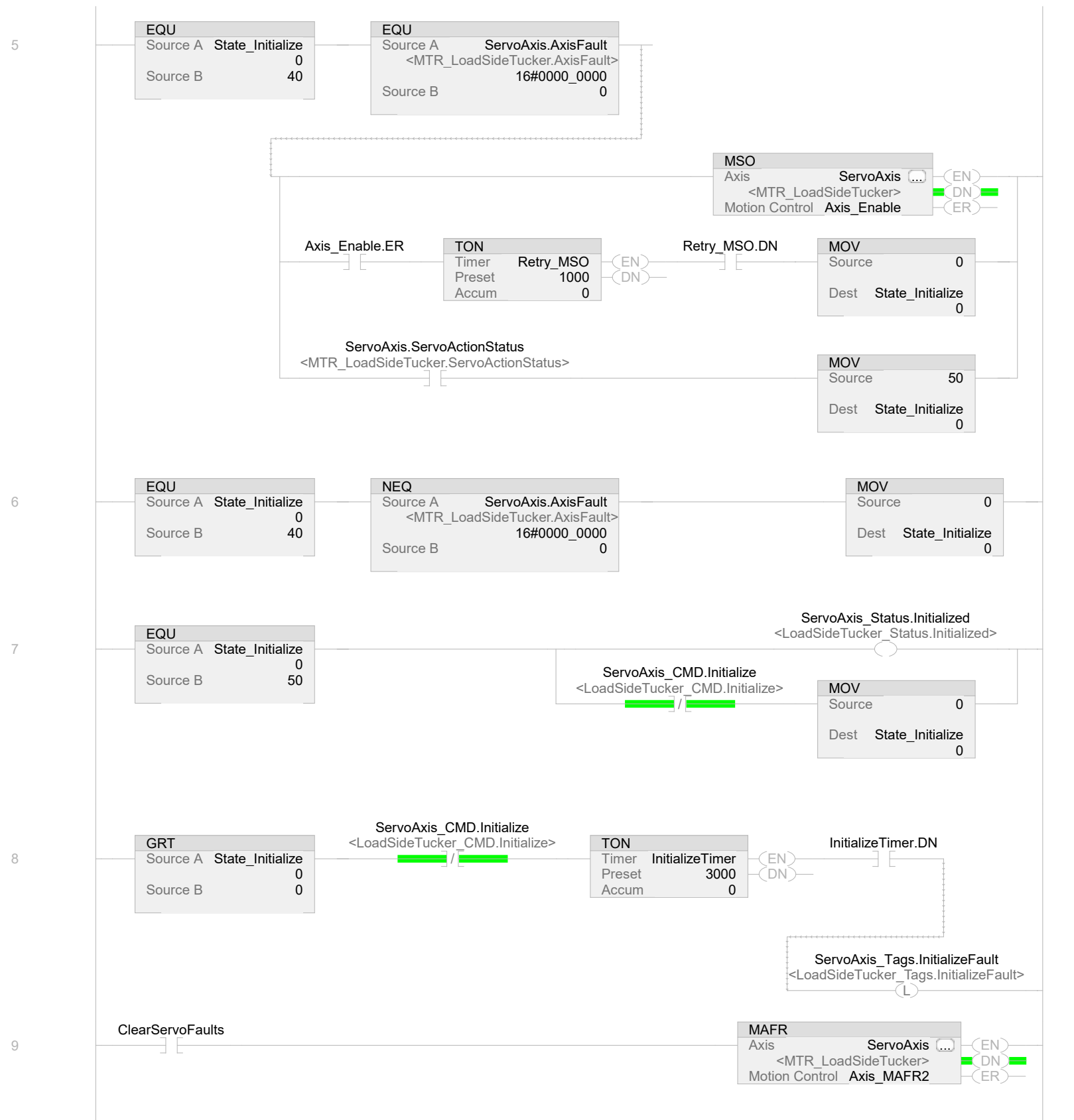
(End)



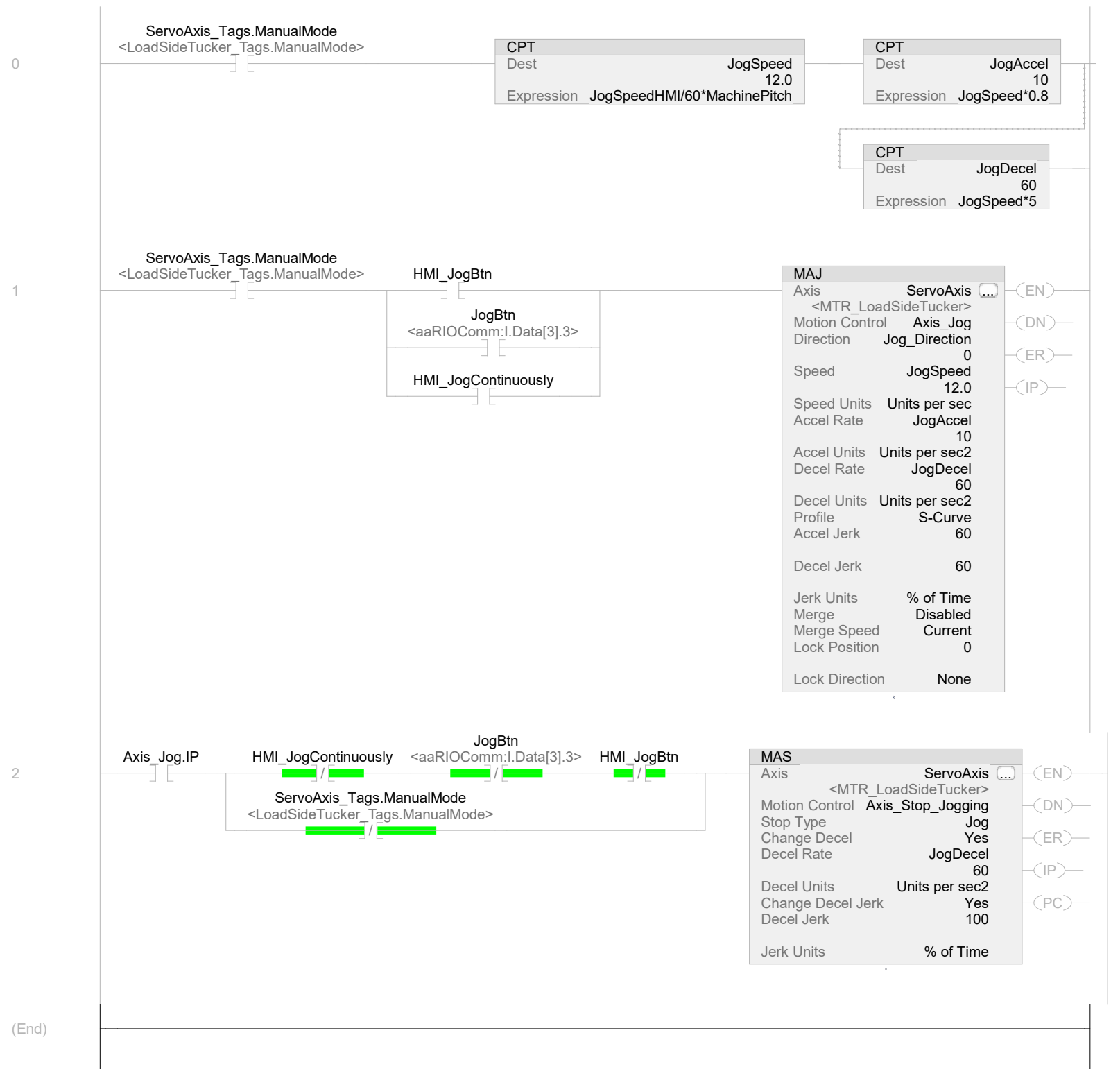


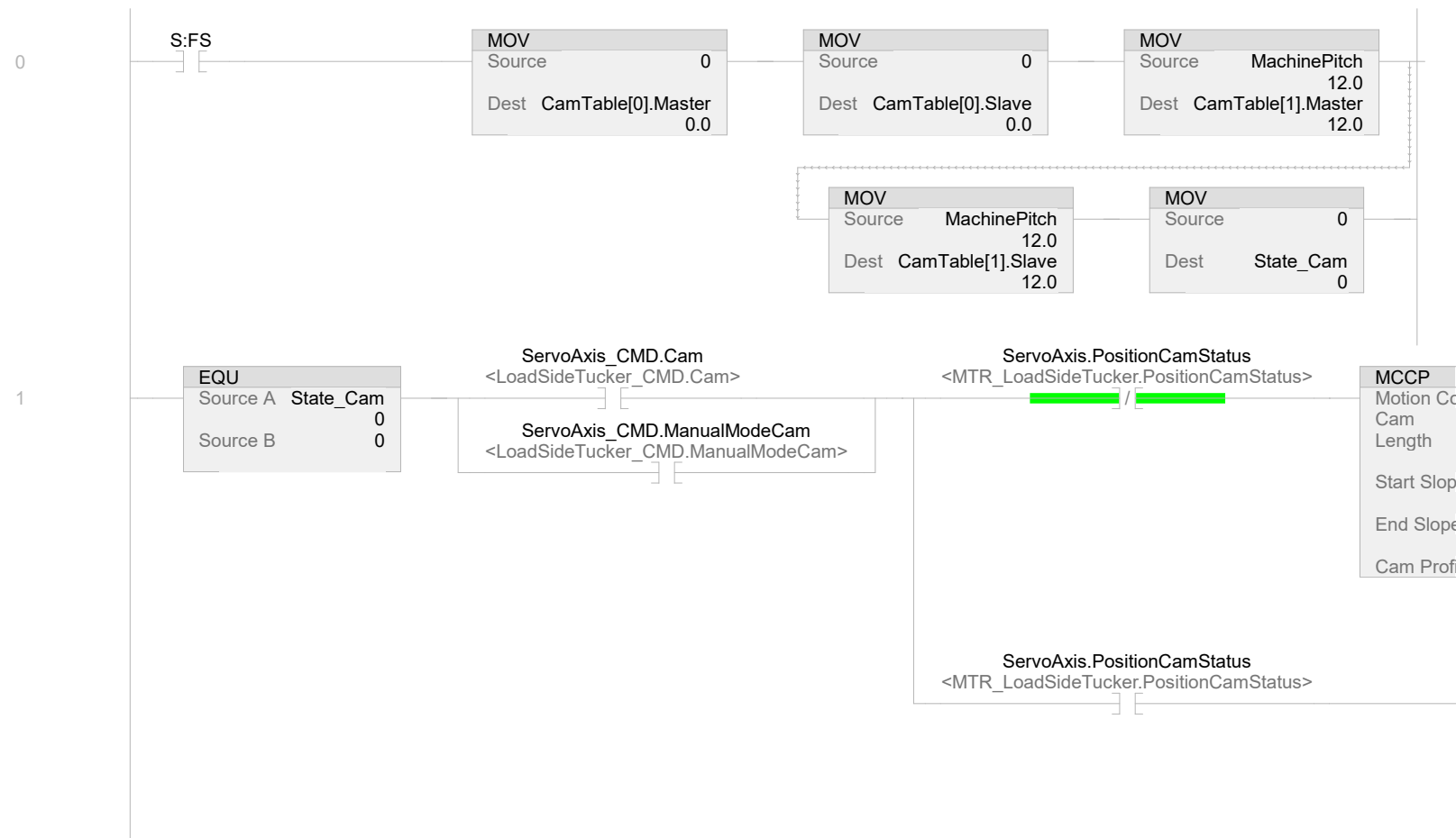


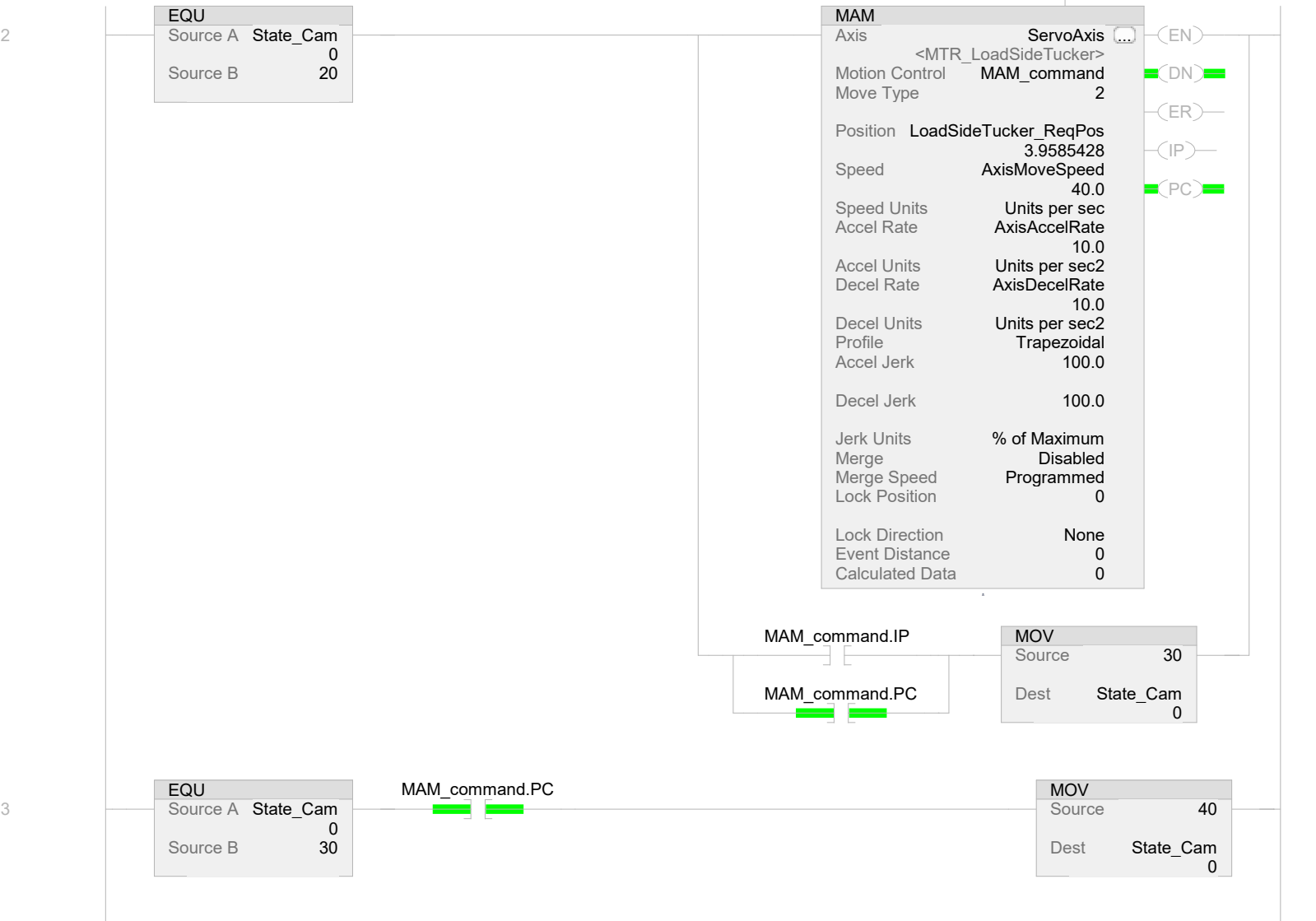
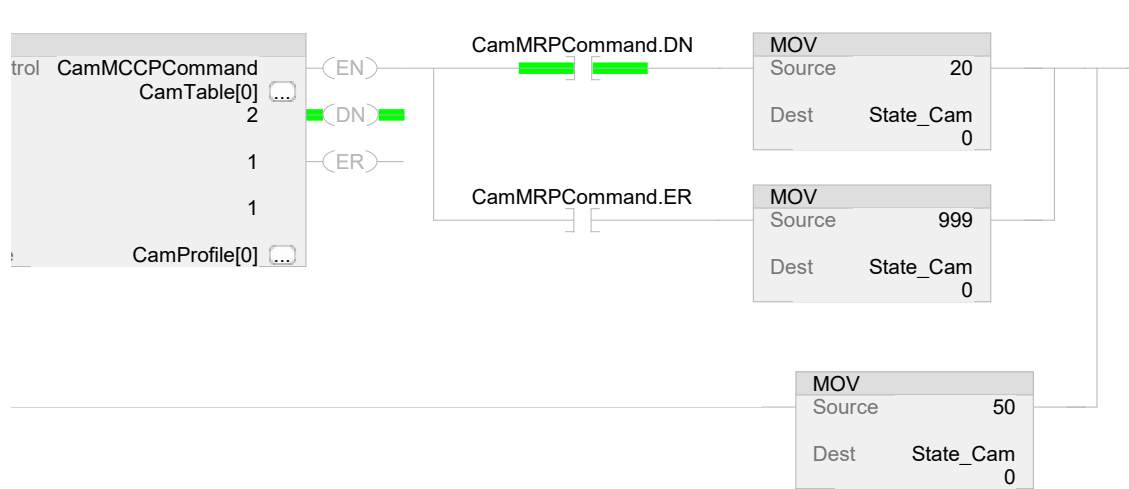


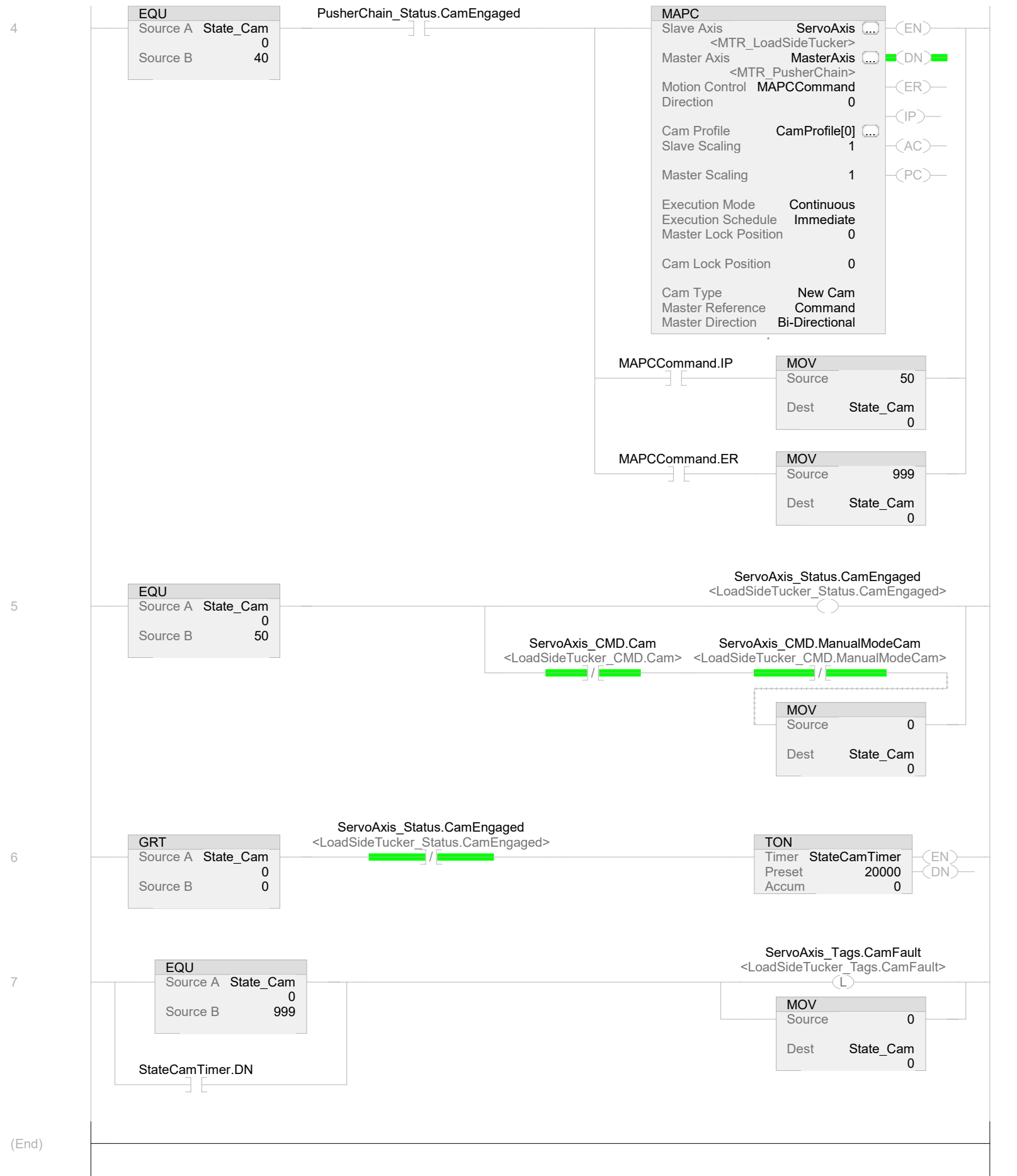


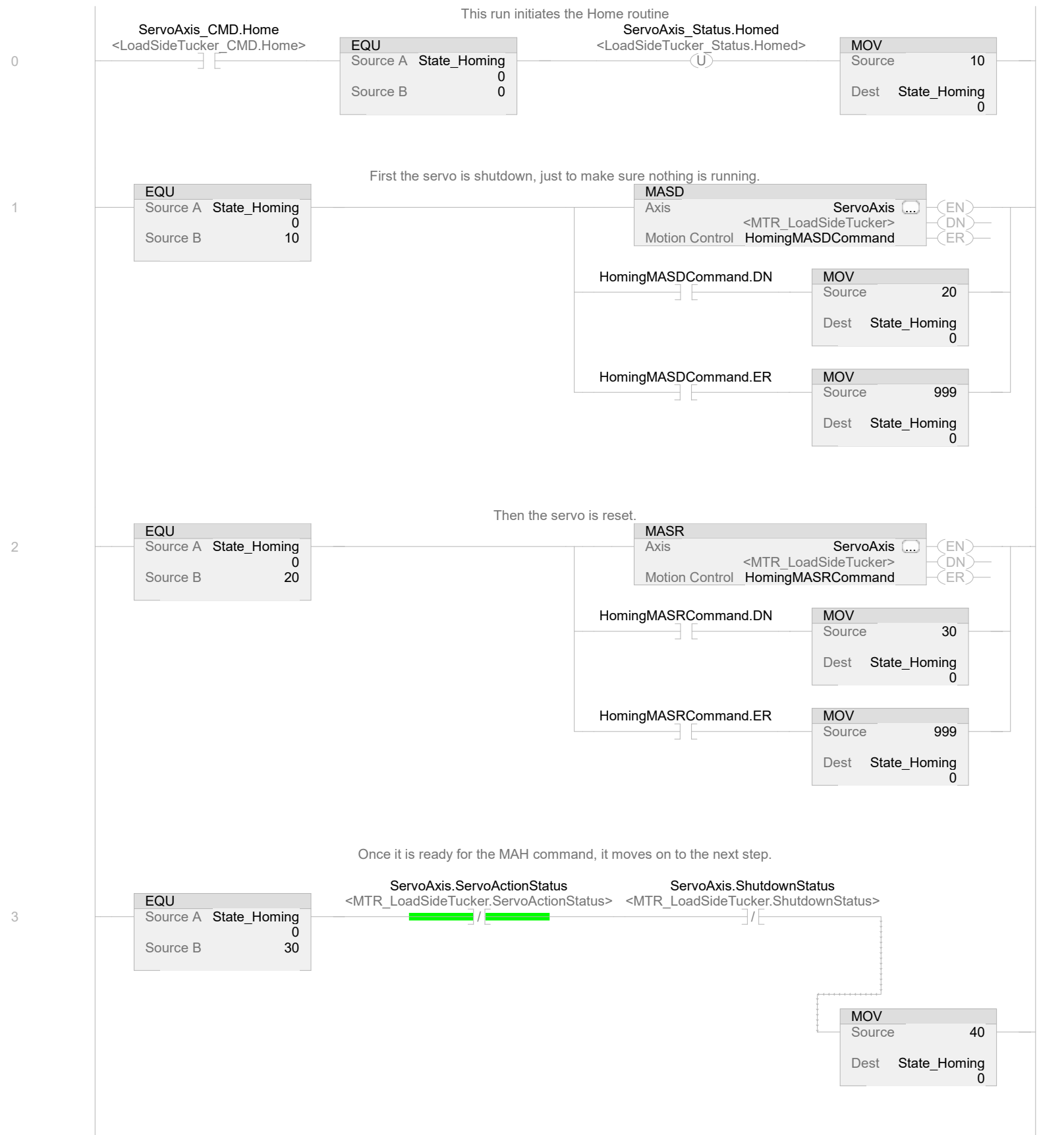


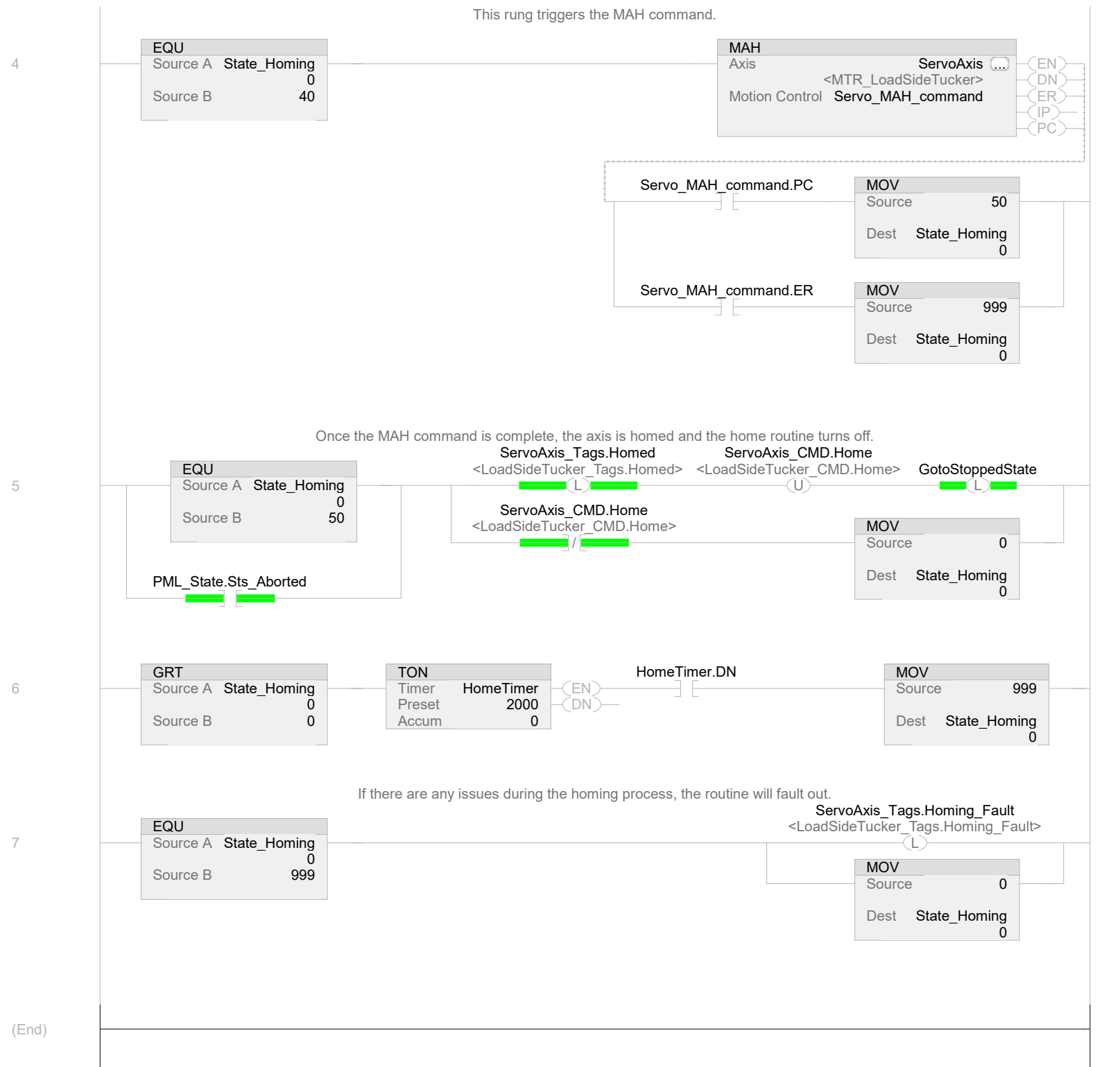


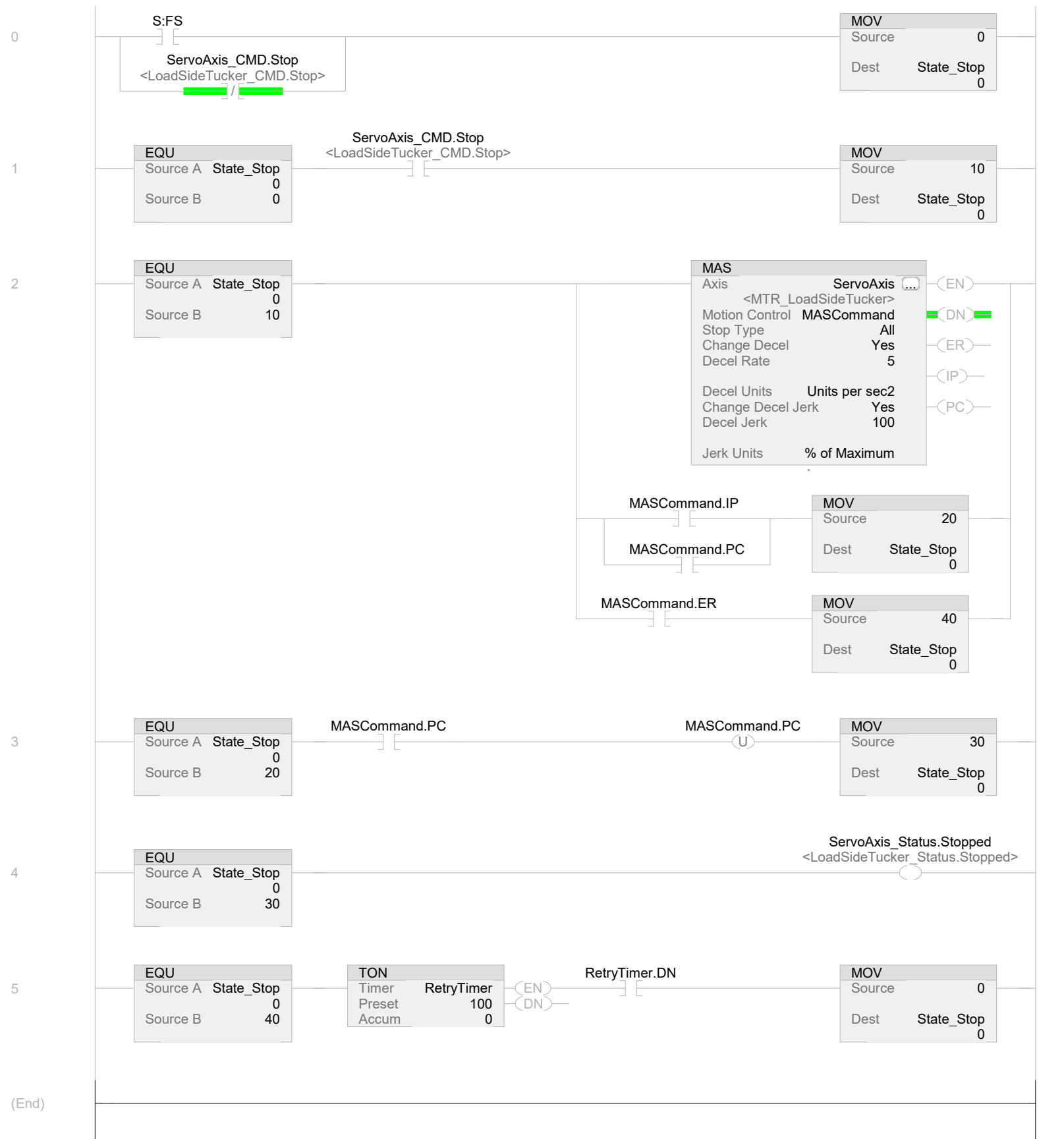


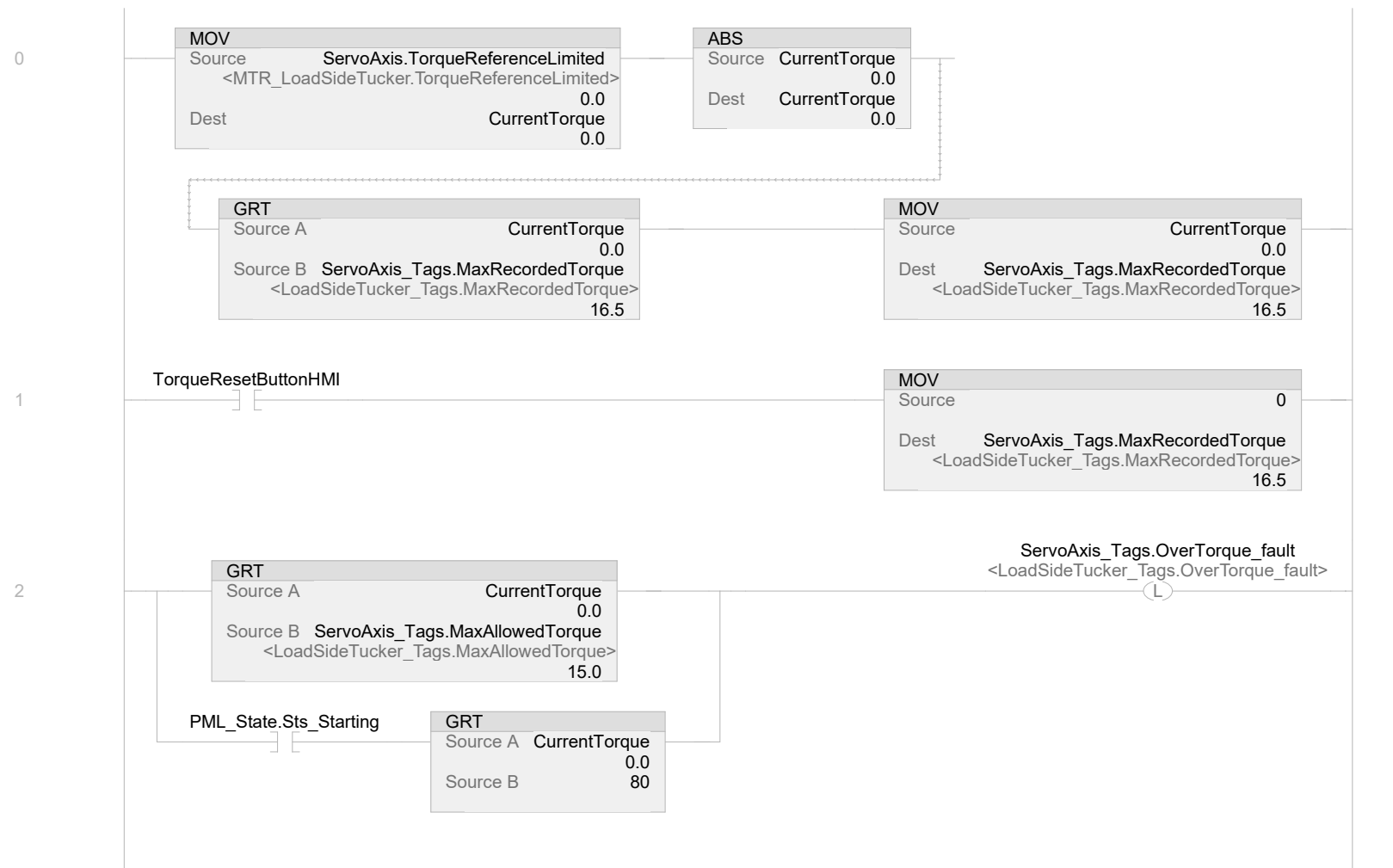


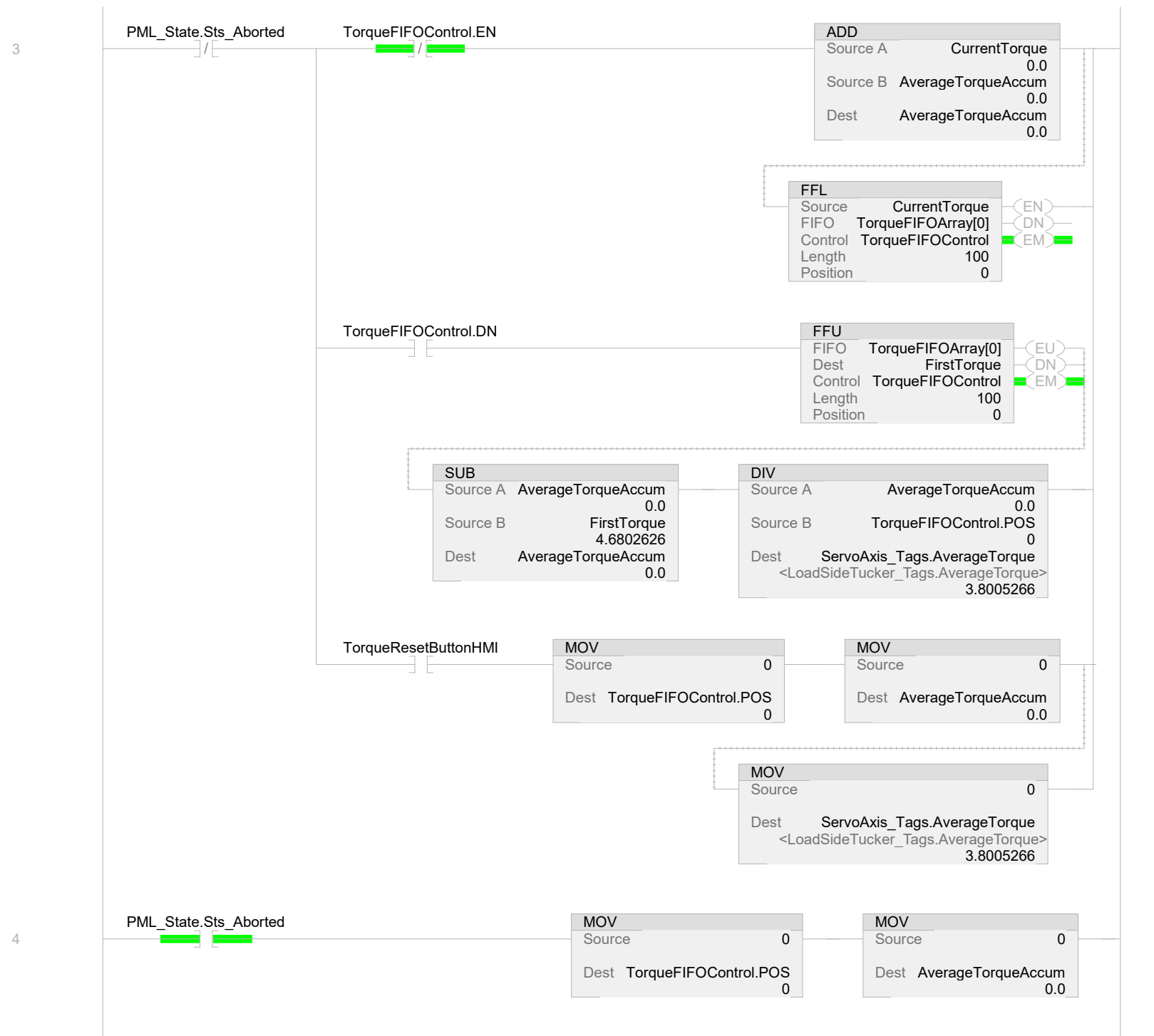












MUL

Source A

ServoAxis_Tags.MaxAllowedTorque

<LoadSideTucker_Tags.MaxAllowedTorque>

15.0

Source B

-1.1

Dest

ServoAxis_Tags.Drive_Internal_TorqueLimit_NEG

<LoadSideTucker_Tags.Drive_Internal_TorqueLimit_NEG>

-16.5

NEQ

Source A

ServoAxis_Tags.Drive_Internal_TorqueLimit_POS_IN

<LoadSideTucker_Tags.Drive_Internal_TorqueLimit_POS_IN>

16.5

Source B

ServoAxis_Tags.Drive_Internal_TorqueLimit_POS

<LoadSideTucker_Tags.Drive_Internal_TorqueLimit_POS>

16.5

NEQ

Source A

ServoAxis_Tags.Drive_Internal_TorqueLimit_NEG_IN

<LoadSideTucker_Tags.Drive_Internal_TorqueLimit_NEG_IN>

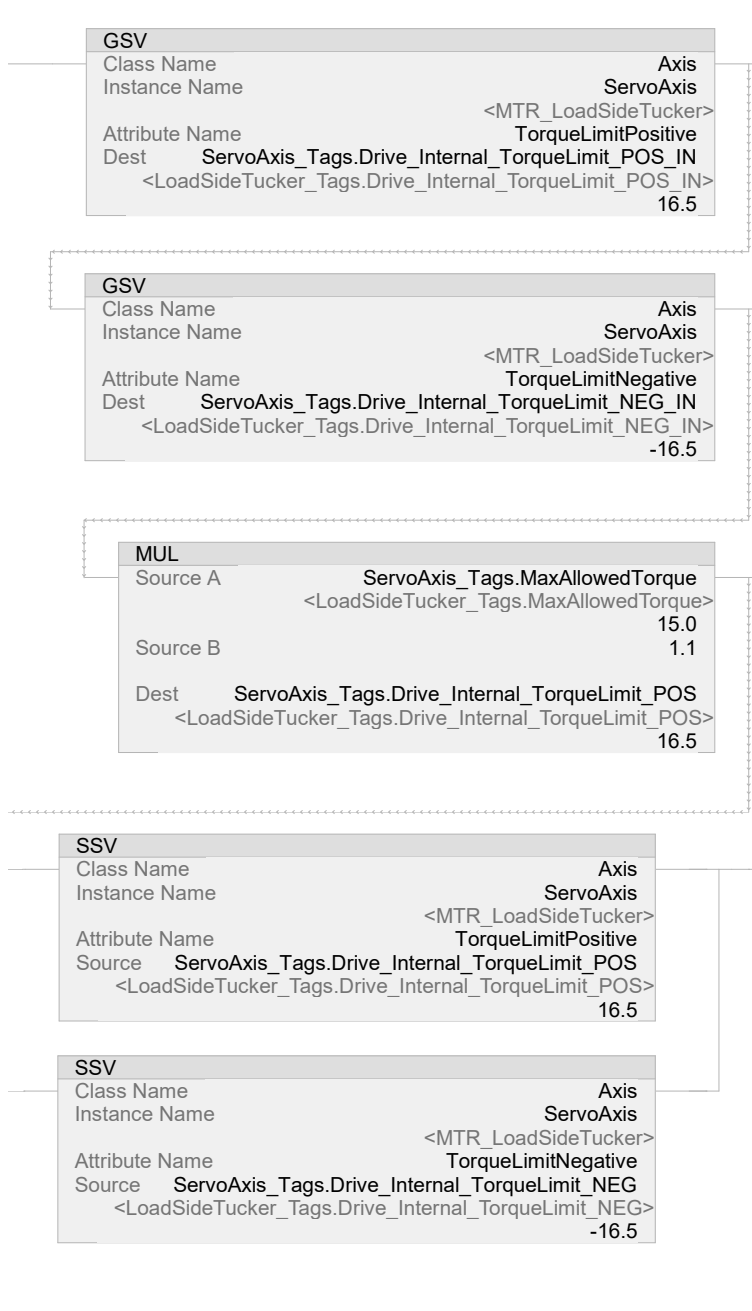
-16.5

Source B

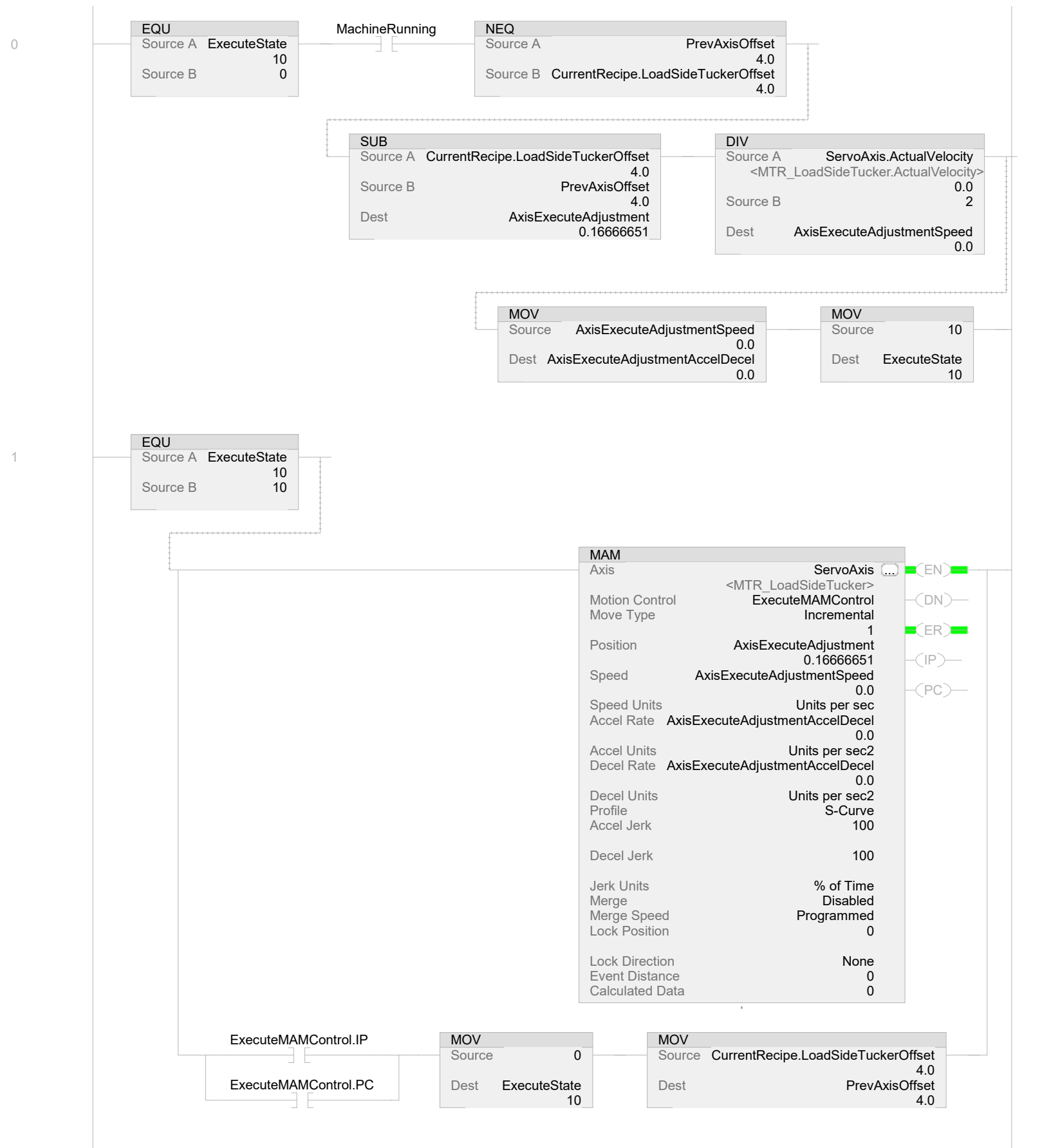
ServoAxis_Tags.Drive_Internal_TorqueLimit_NEG

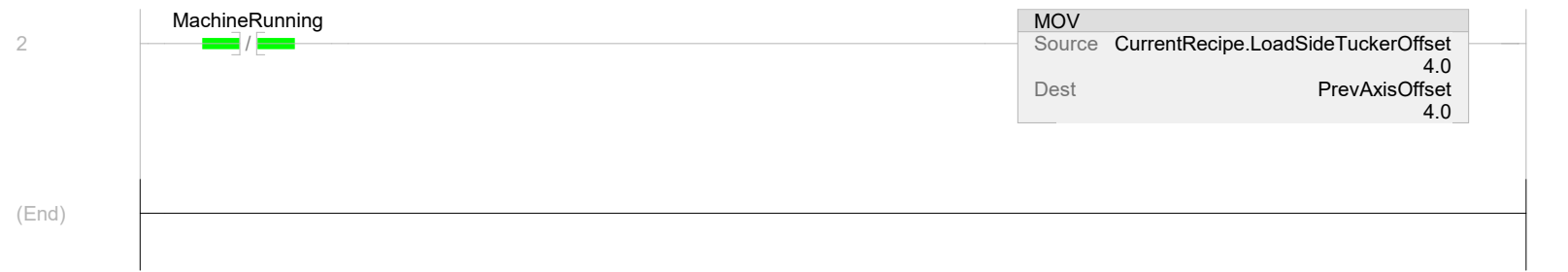
<LoadSideTucker_Tags.Drive_Internal_TorqueLimit_NEG>

-16.5

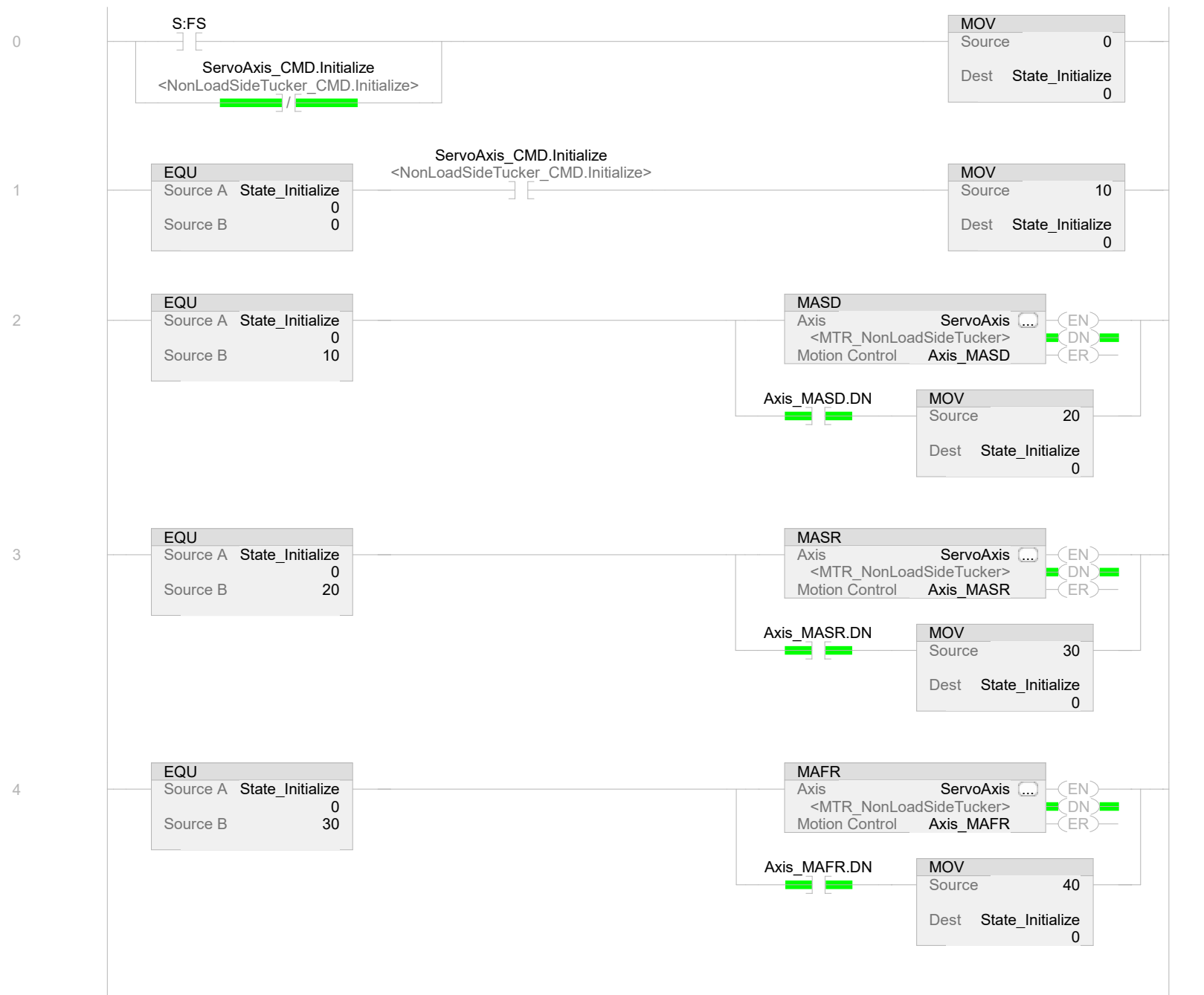


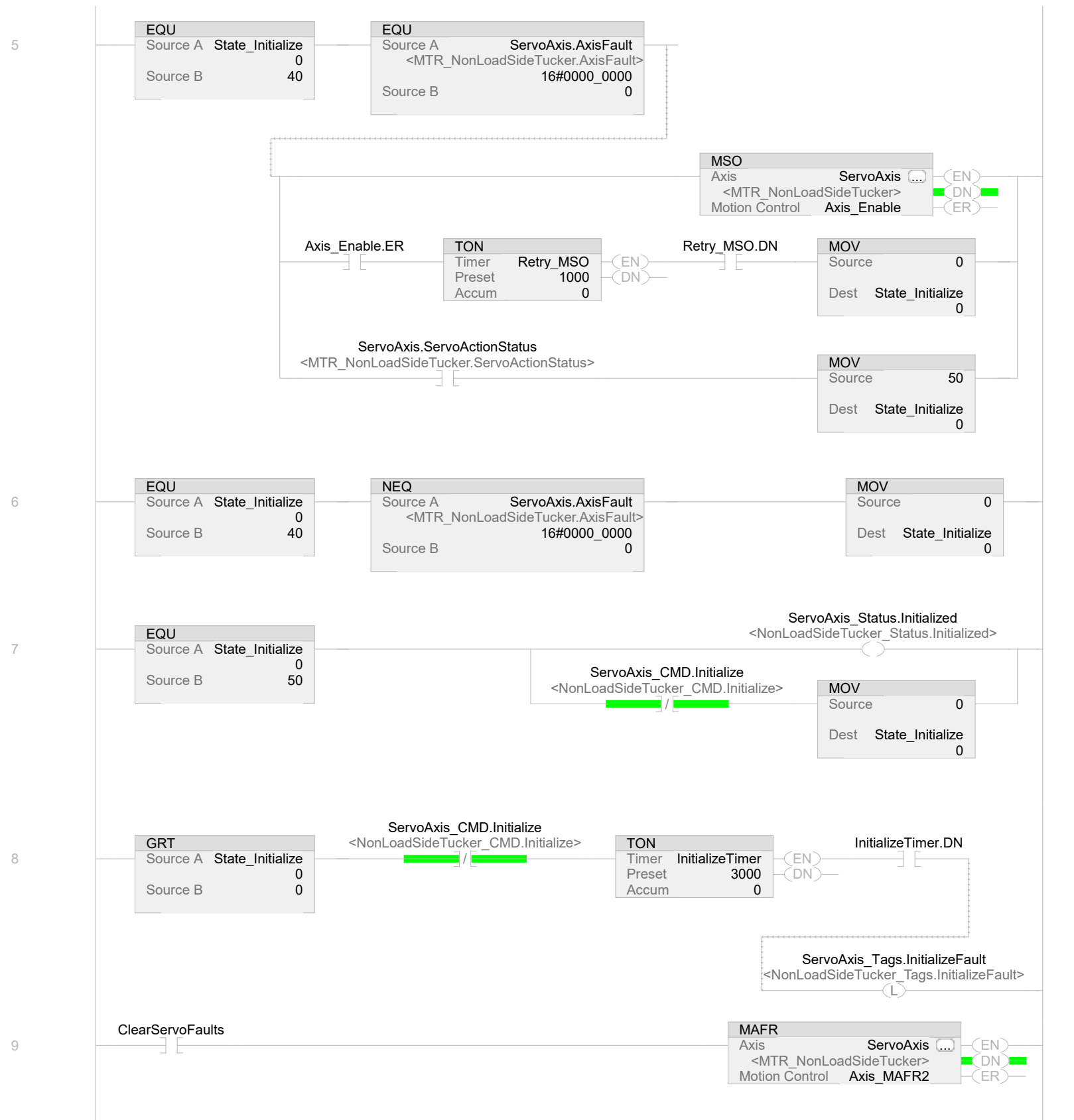
(End)



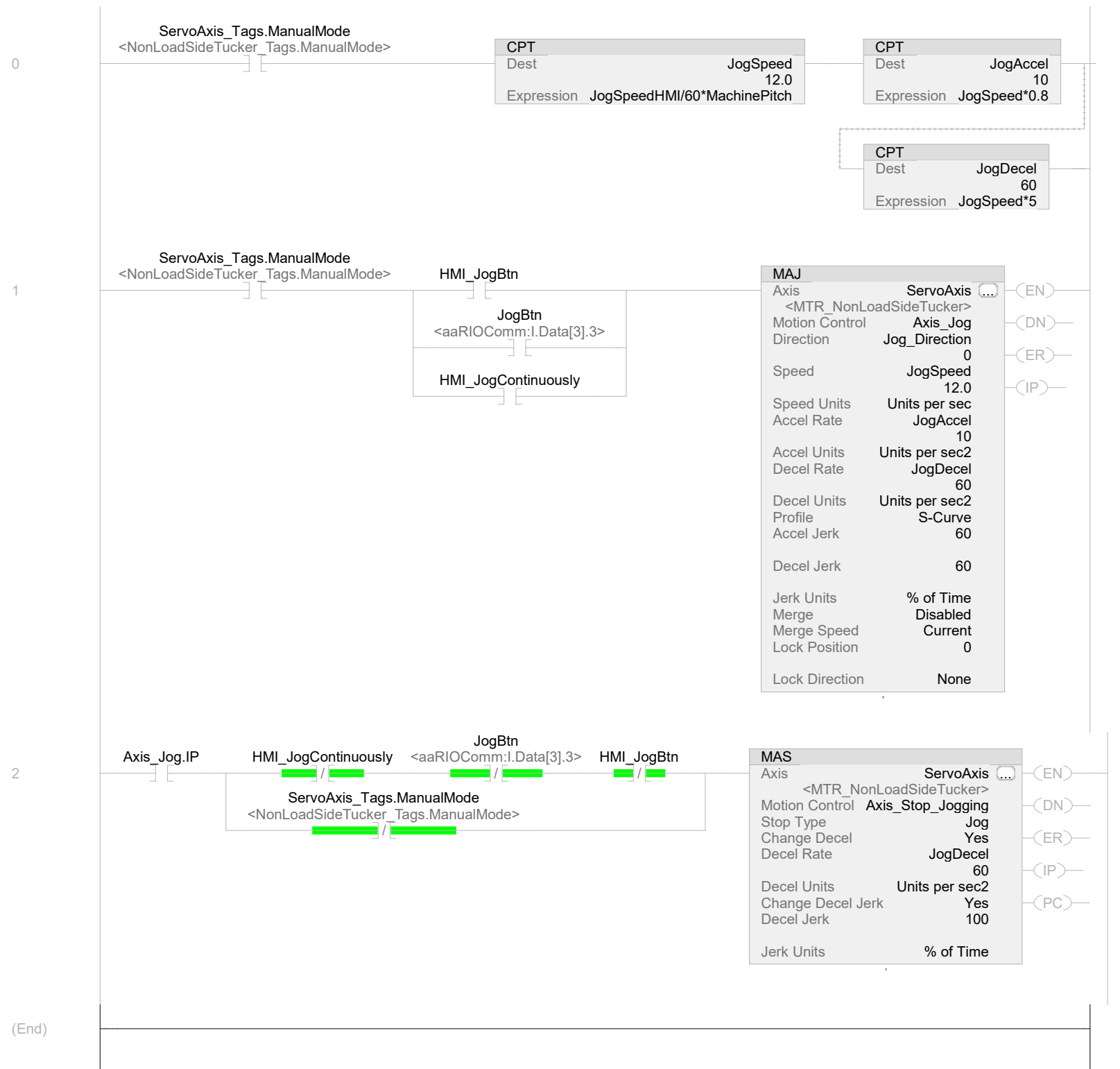


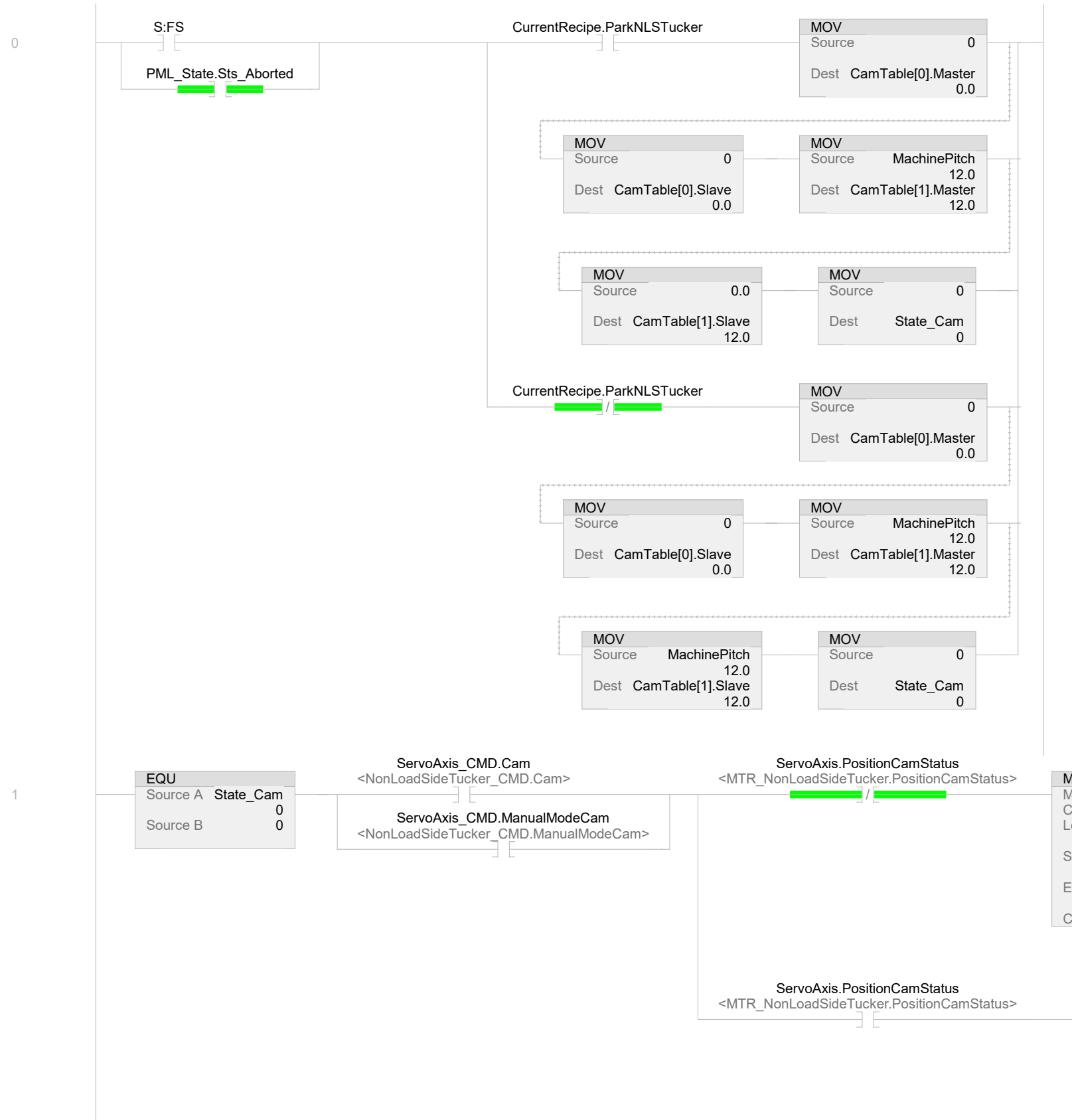




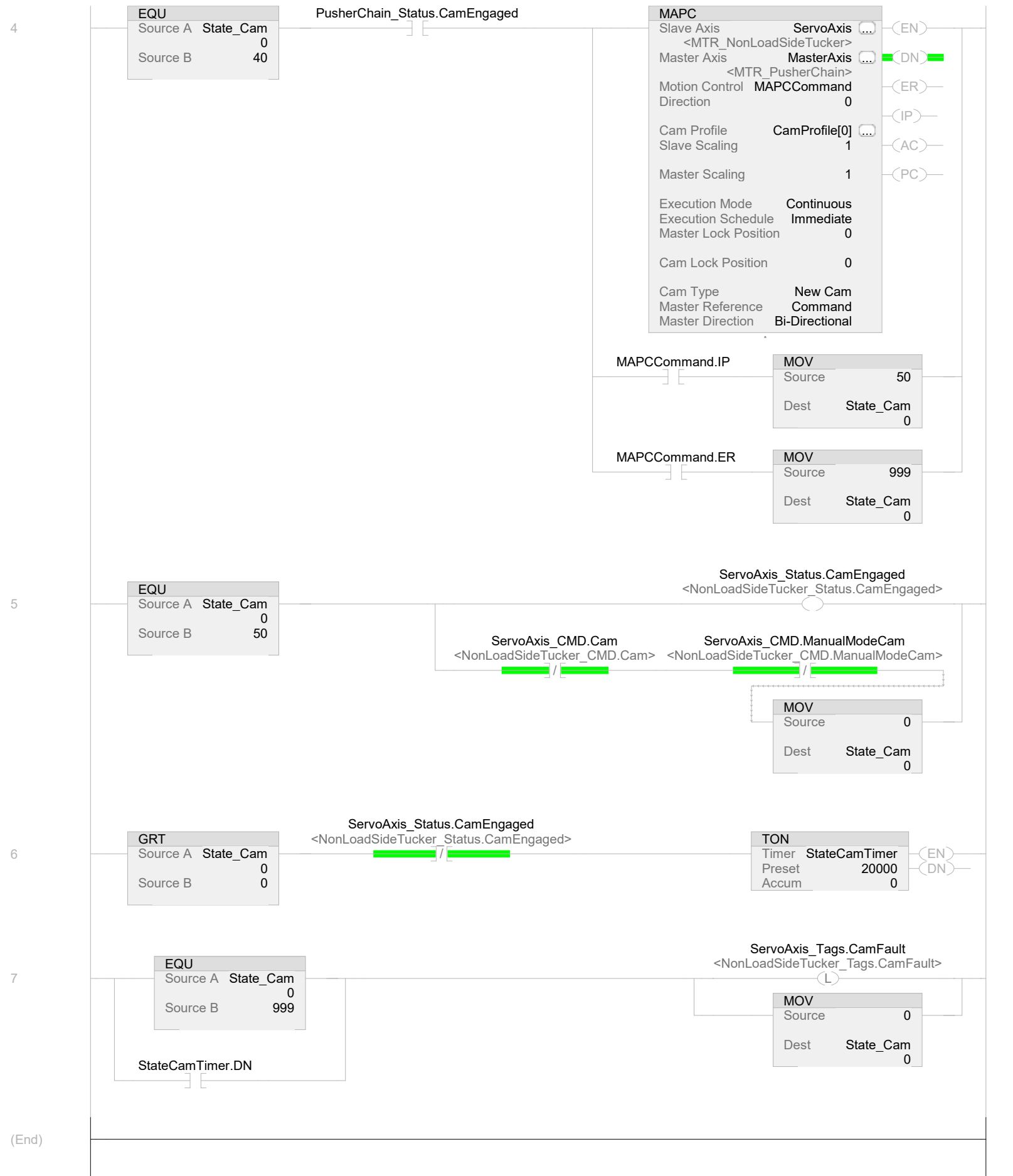


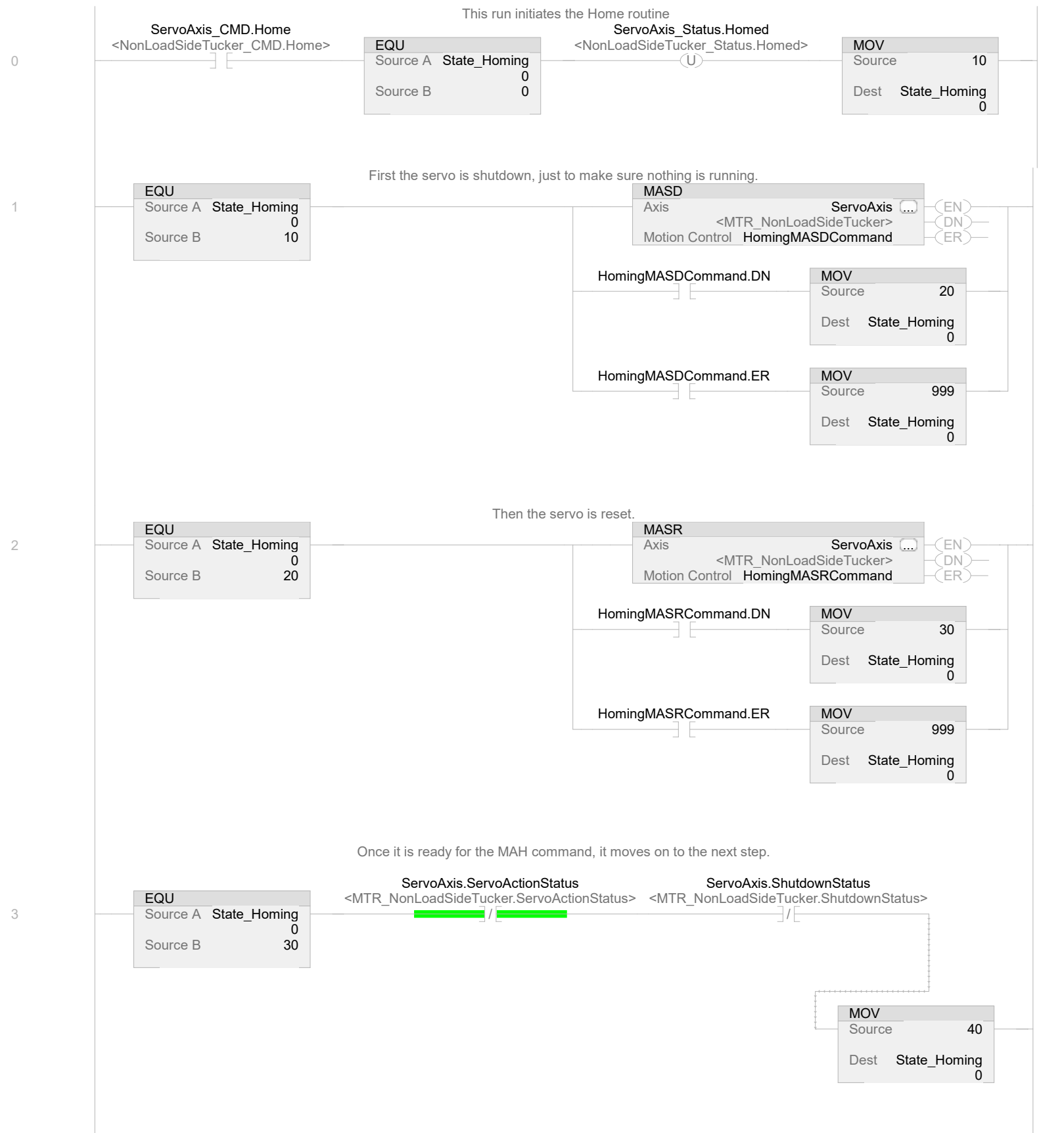


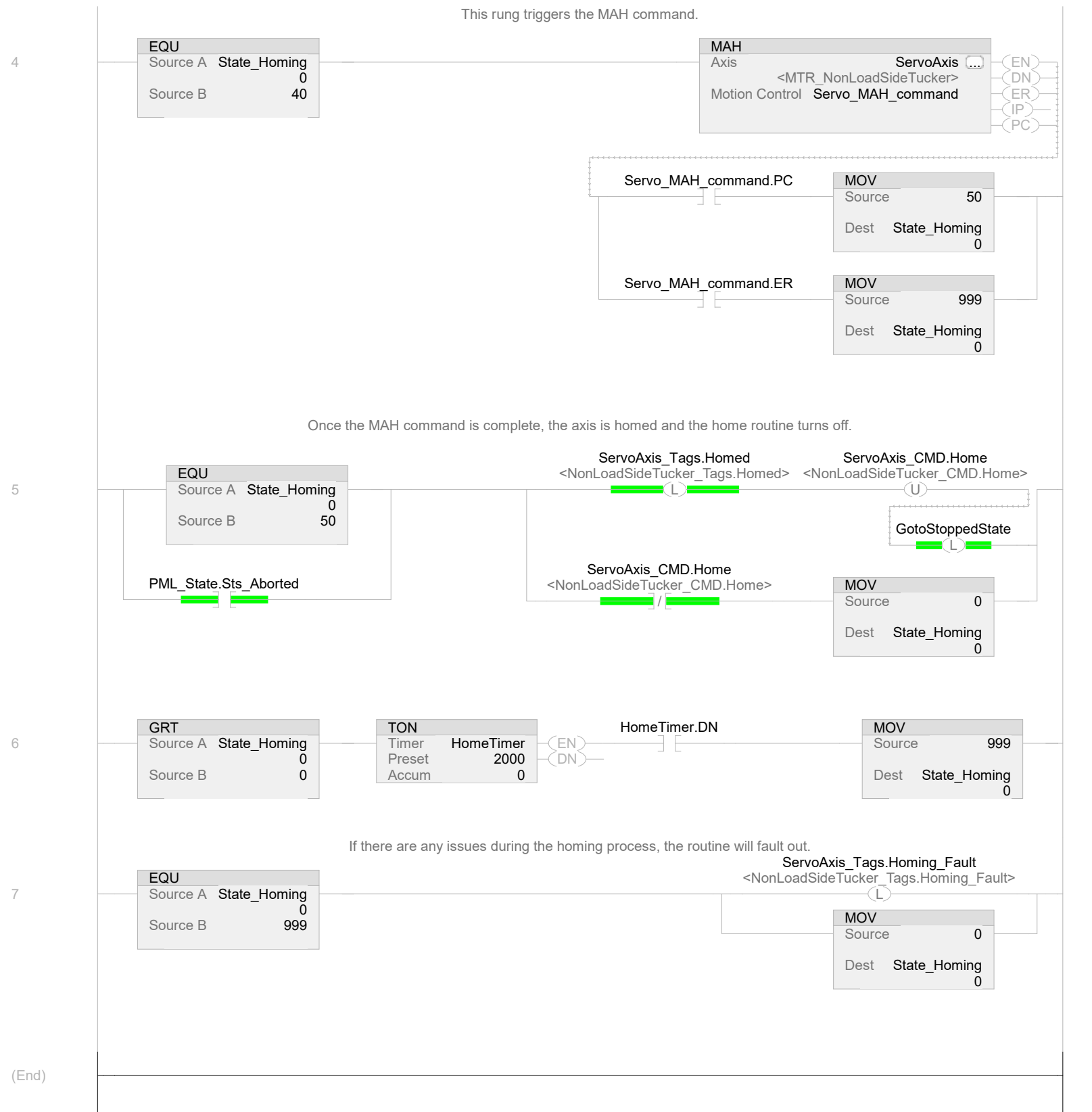


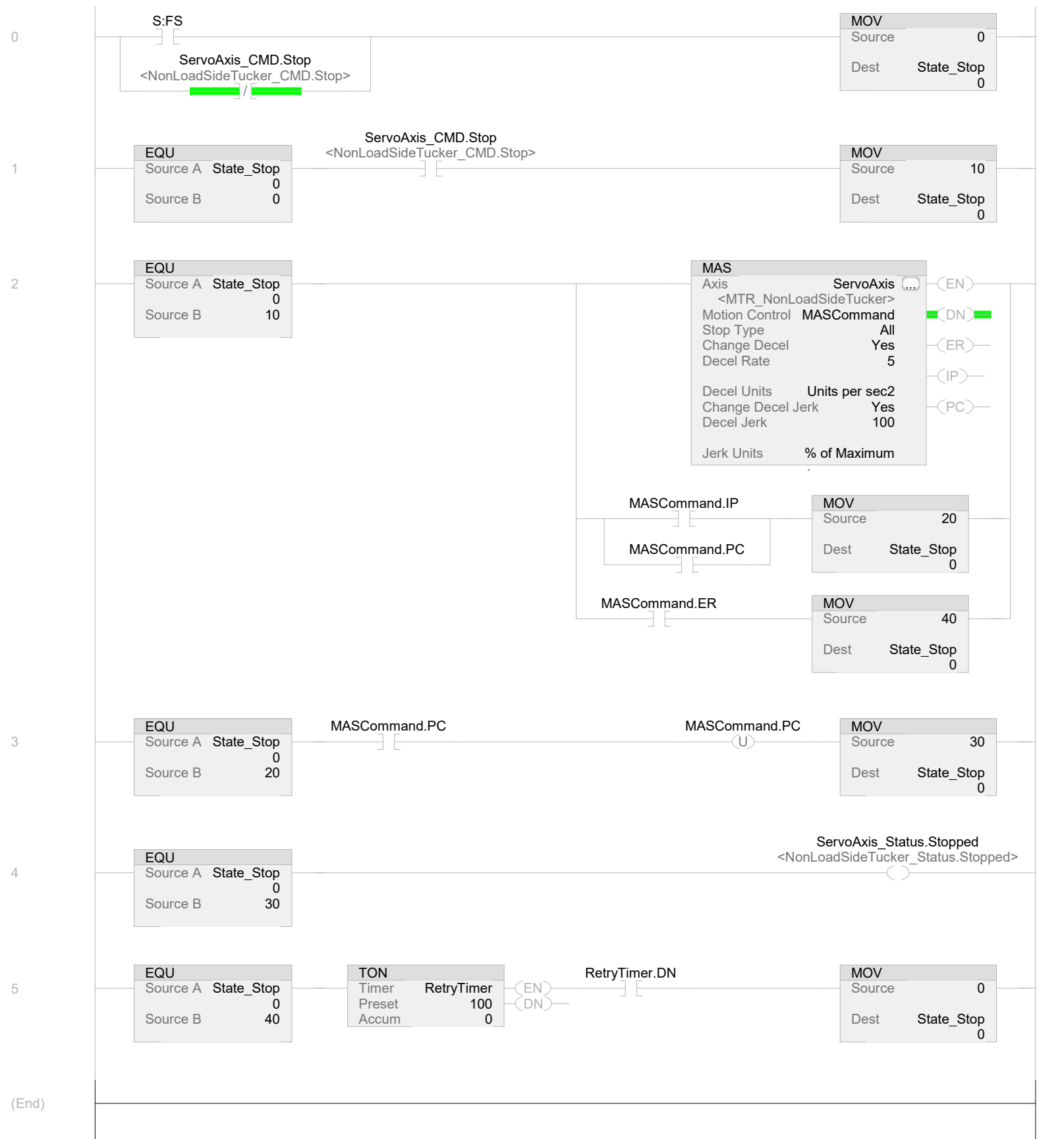


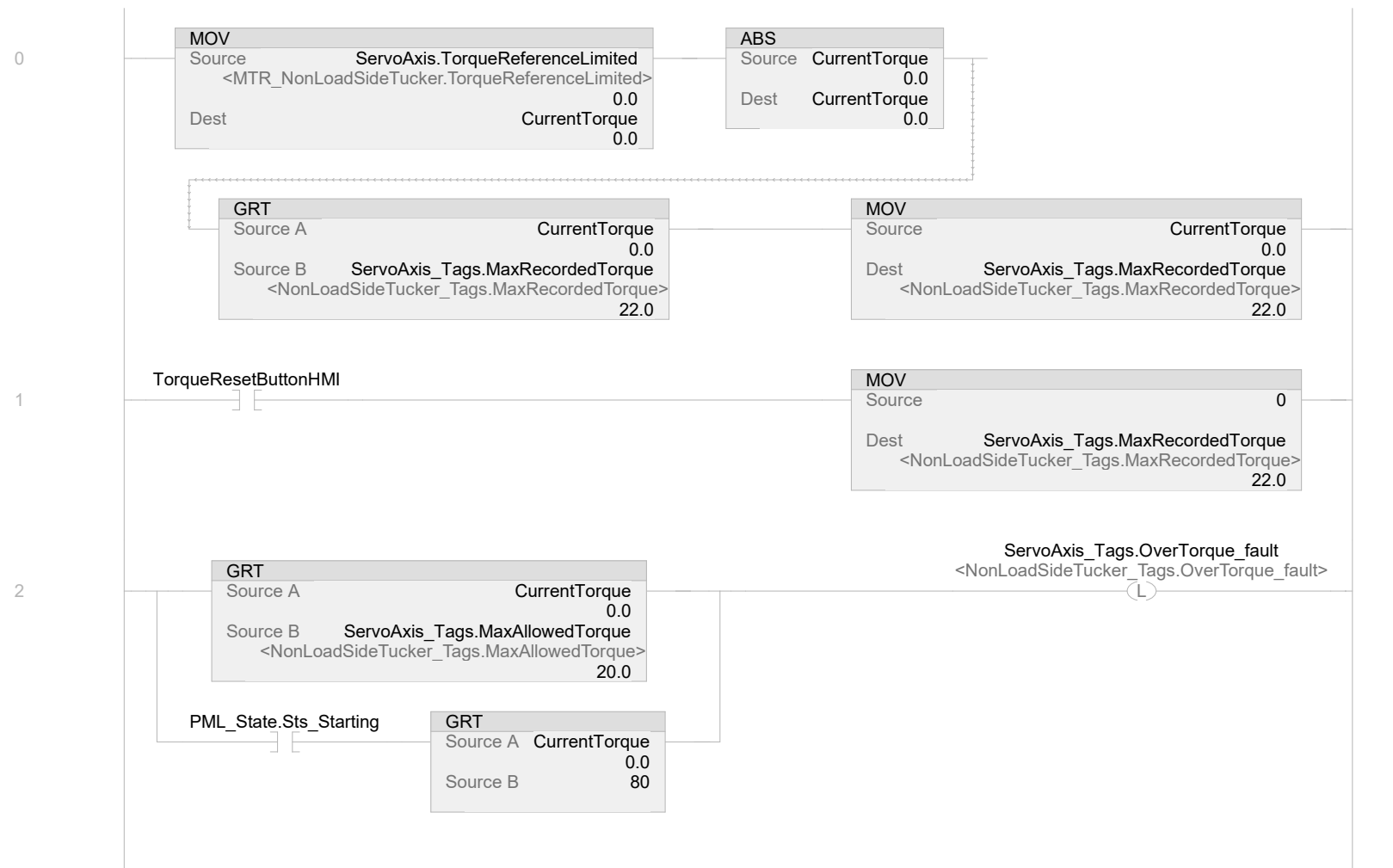


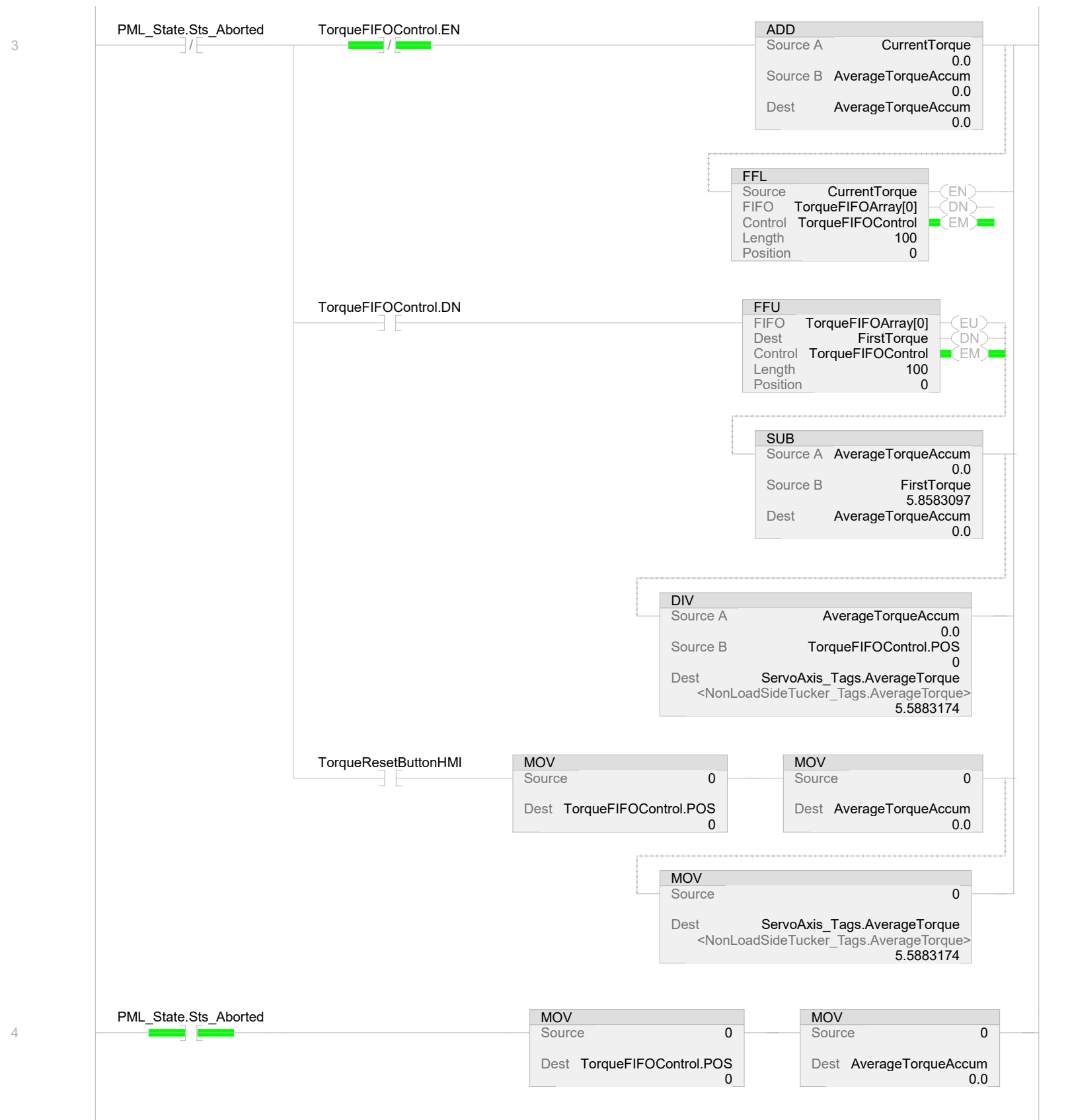












MUL

Source A

ServoAxis_Tags.MaxAllowedTorque

<NonLoadSideTucker_Tags.MaxAllowedTorque>

20.0

Source B

-1.1

Dest

ServoAxis_Tags.Drive_Internal_TorqueLimit_NEG

<NonLoadSideTucker_Tags.Drive_Internal_TorqueLimit_NEG>

-22.0

NEQ

Source A

ServoAxis_Tags.Drive_Internal_TorqueLimit_POS

<NonLoadSideTucker_Tags.Drive_Internal_TorqueLimit_POS>

2

Source B

ServoAxis_Tags.Drive_Internal_TorqueLimit_NEG

<NonLoadSideTucker_Tags.Drive_Internal_TorqueLimit_NEG>

-2

NEQ

Source A

ServoAxis_Tags.Drive_Internal_TorqueLimit_NEG

<NonLoadSideTucker_Tags.Drive_Internal_TorqueLimit_NEG>

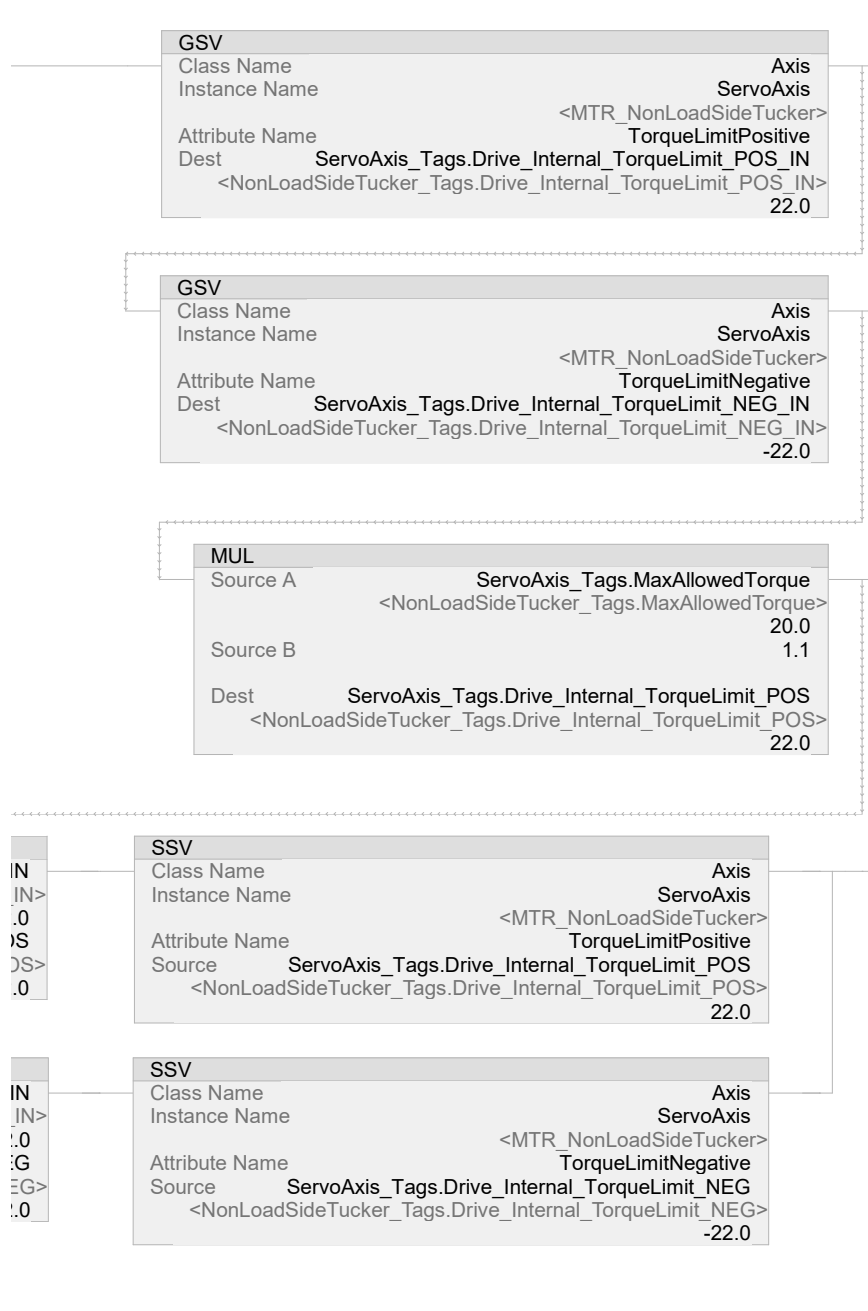
-2

Source B

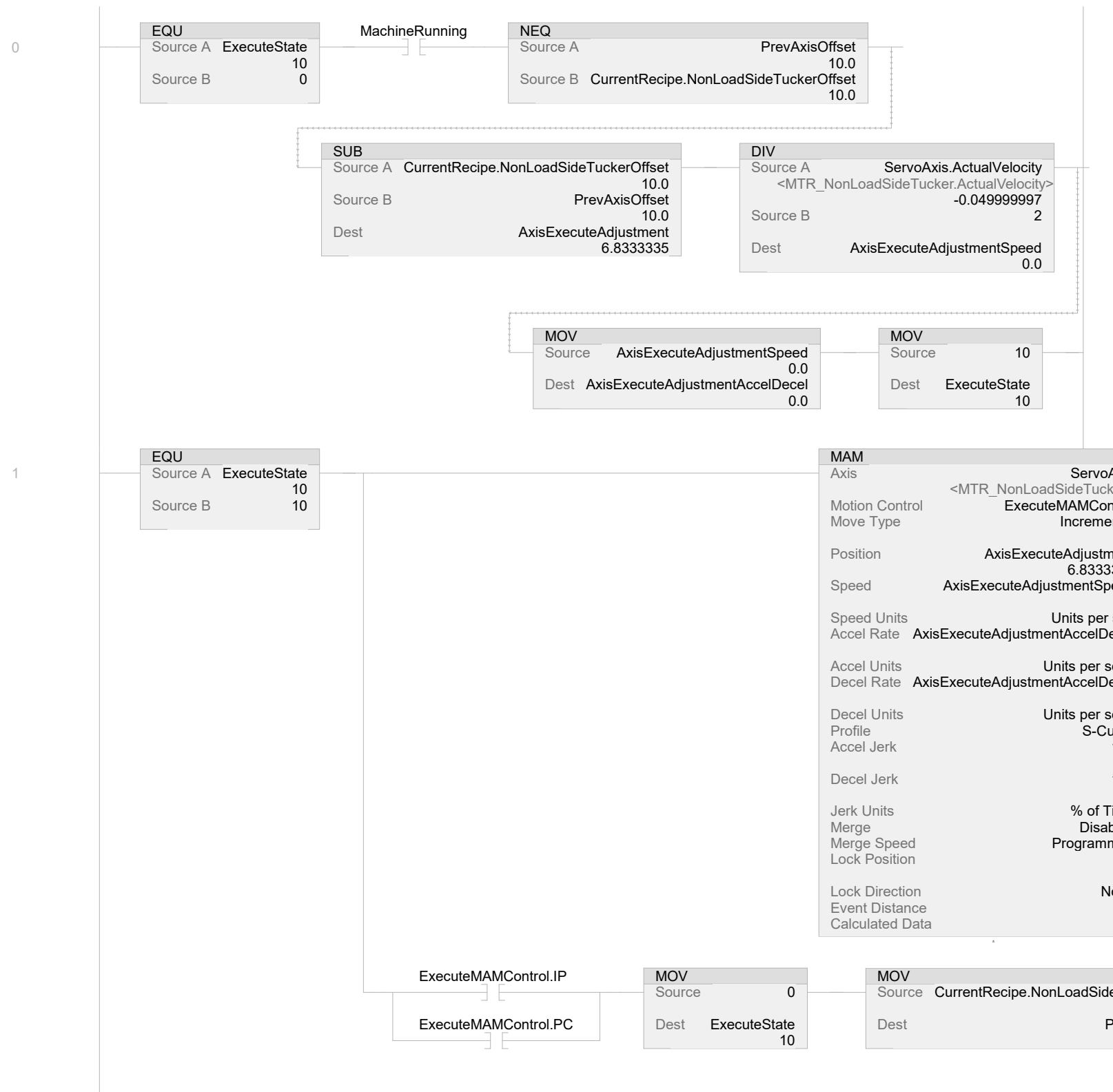
ServoAxis_Tags.Drive_Internal_TorqueLimit_POS

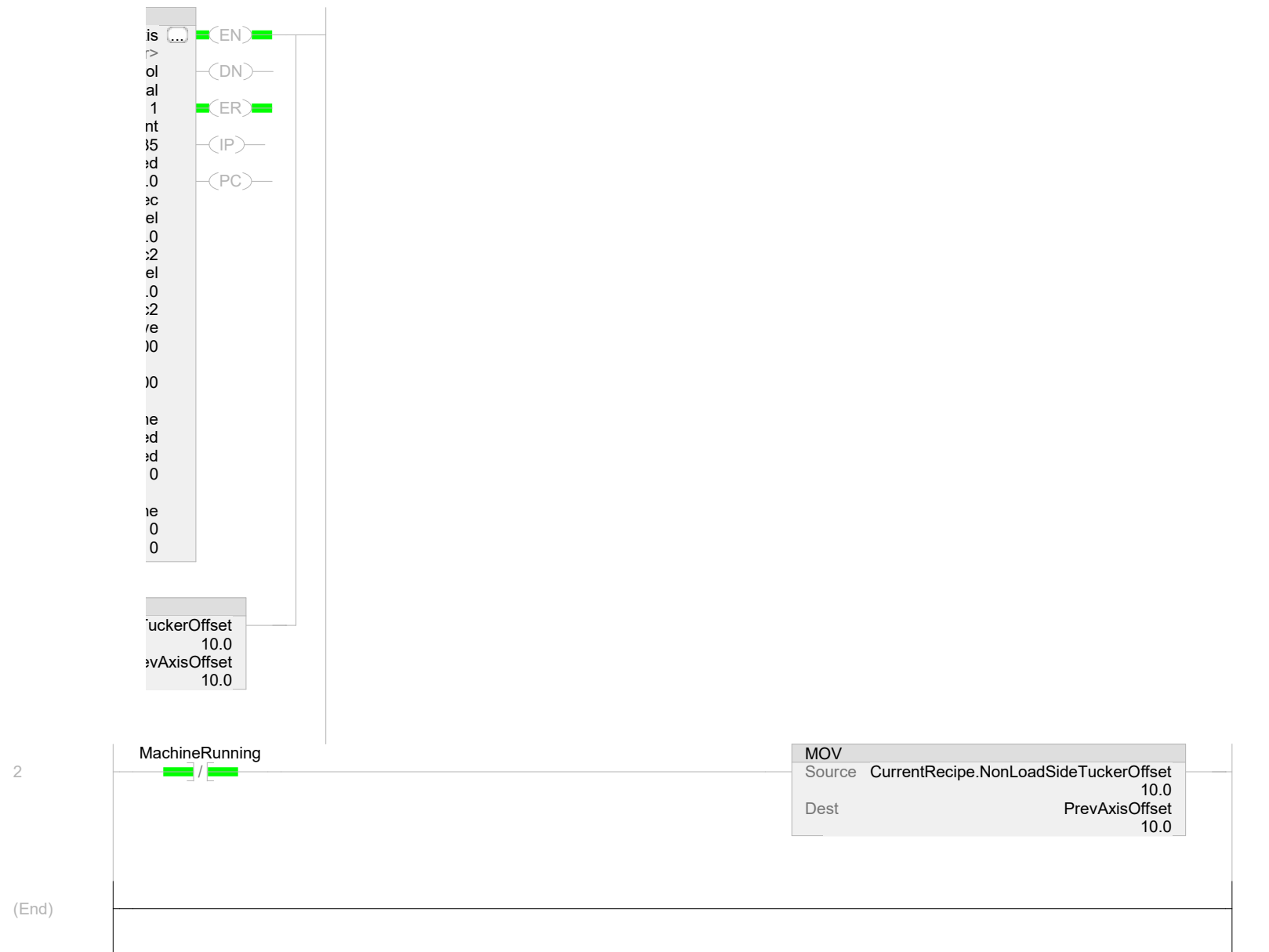
<NonLoadSideTucker_Tags.Drive_Internal_TorqueLimit_POS>

2

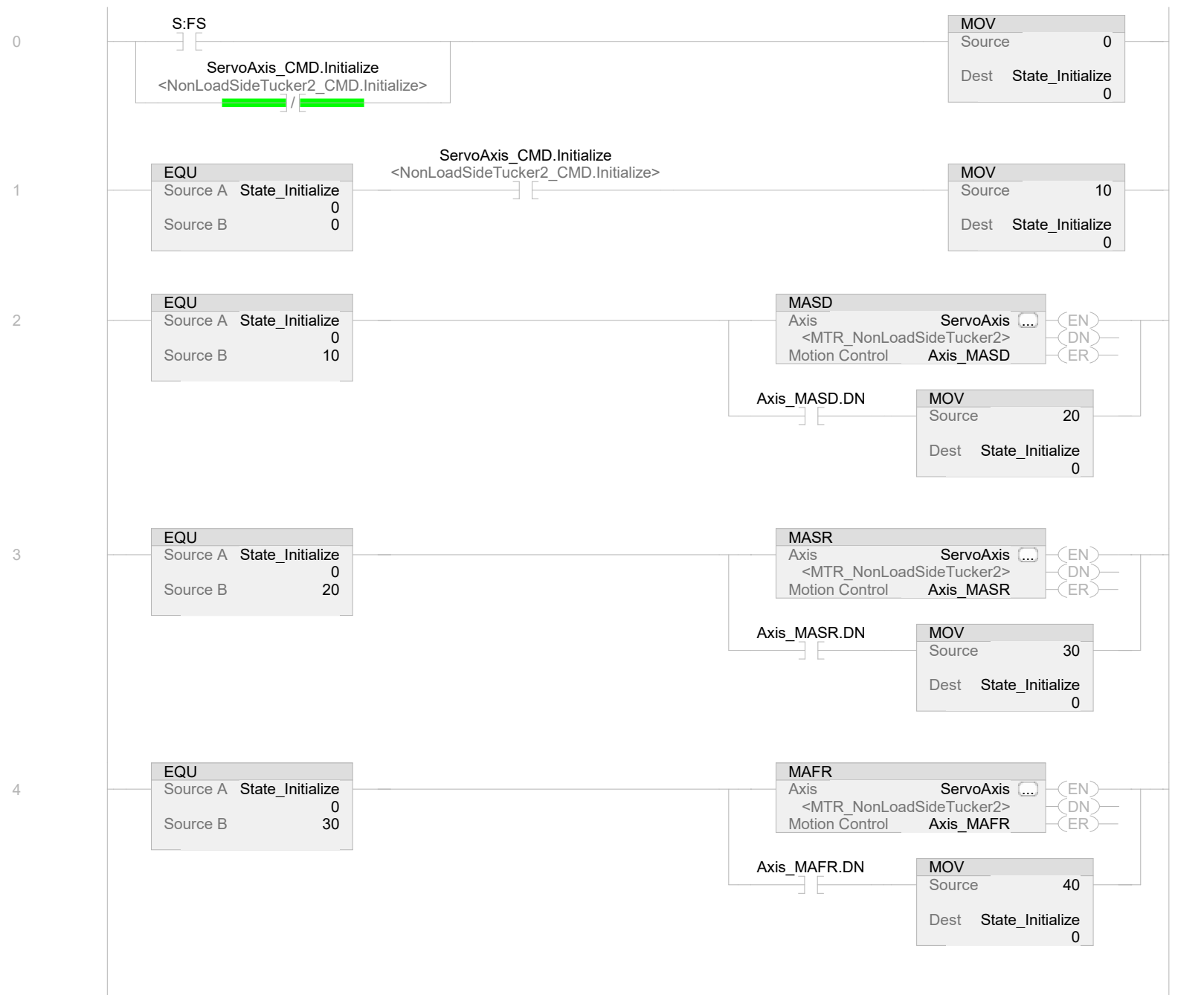


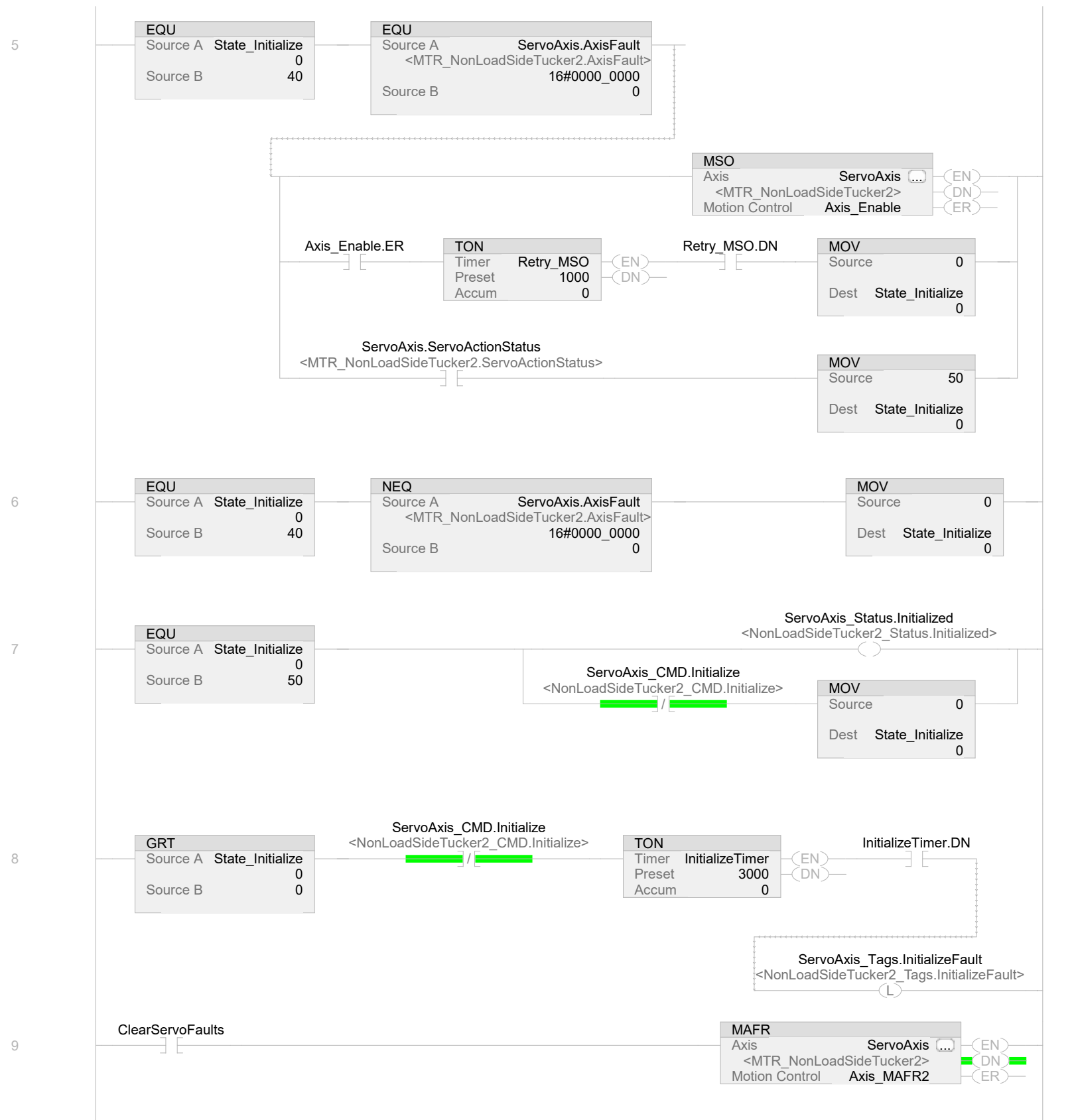
(End)



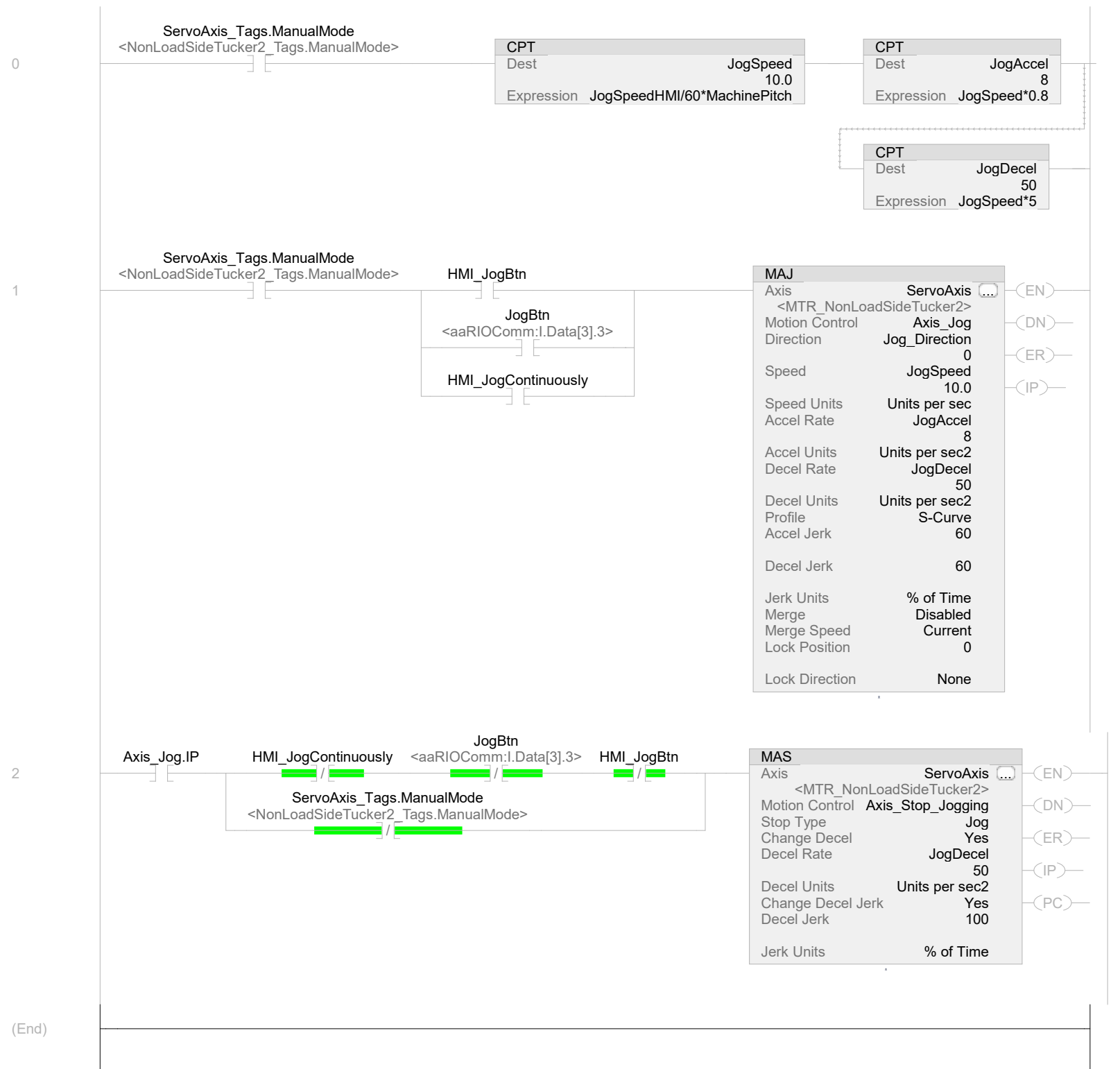


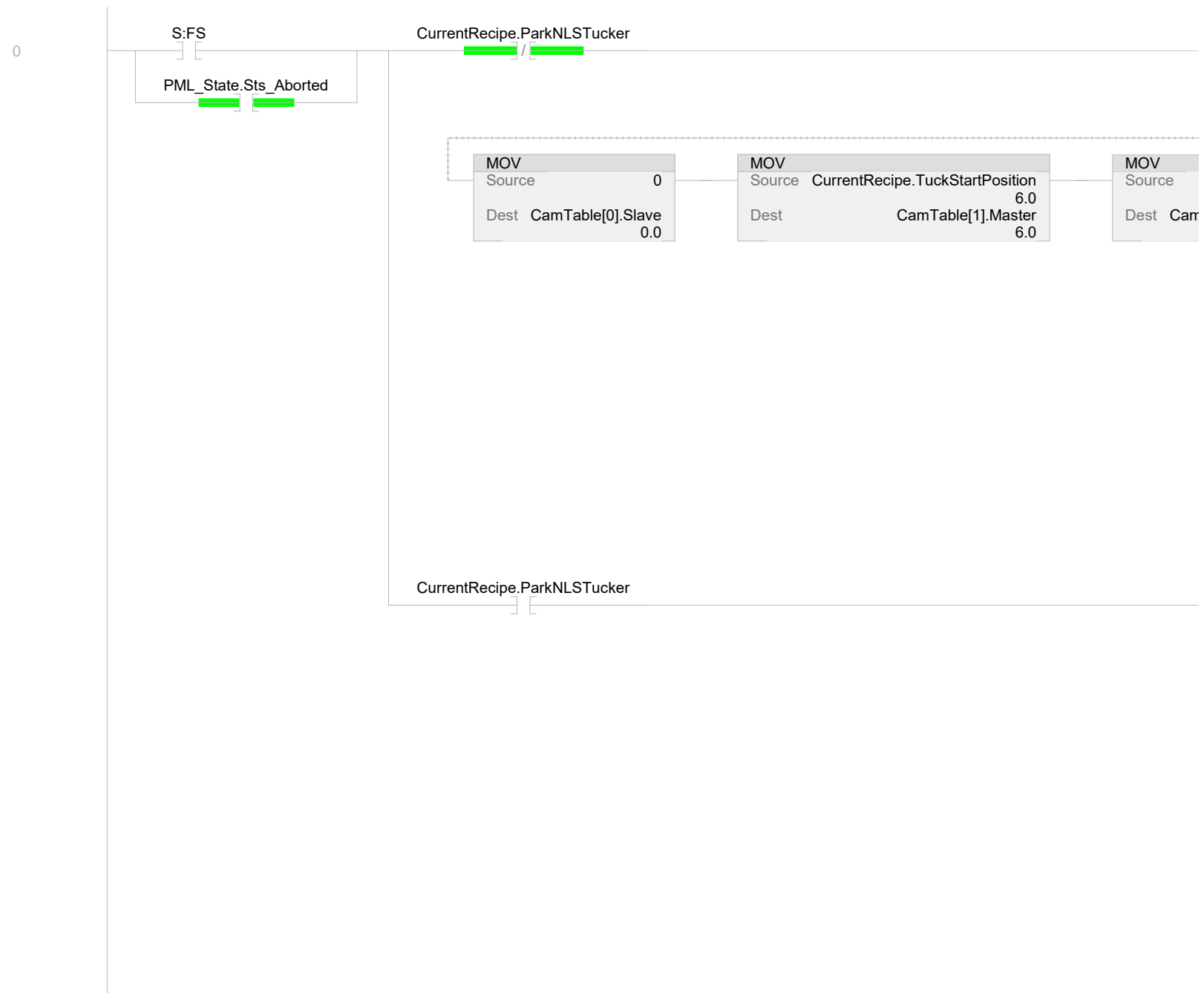


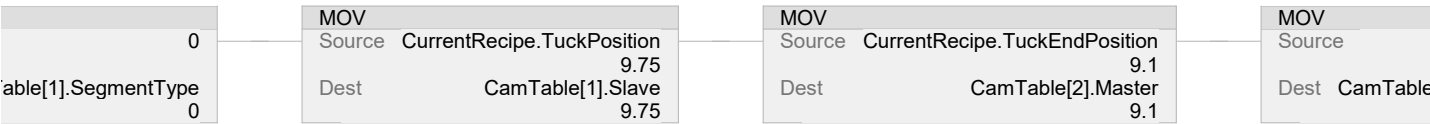






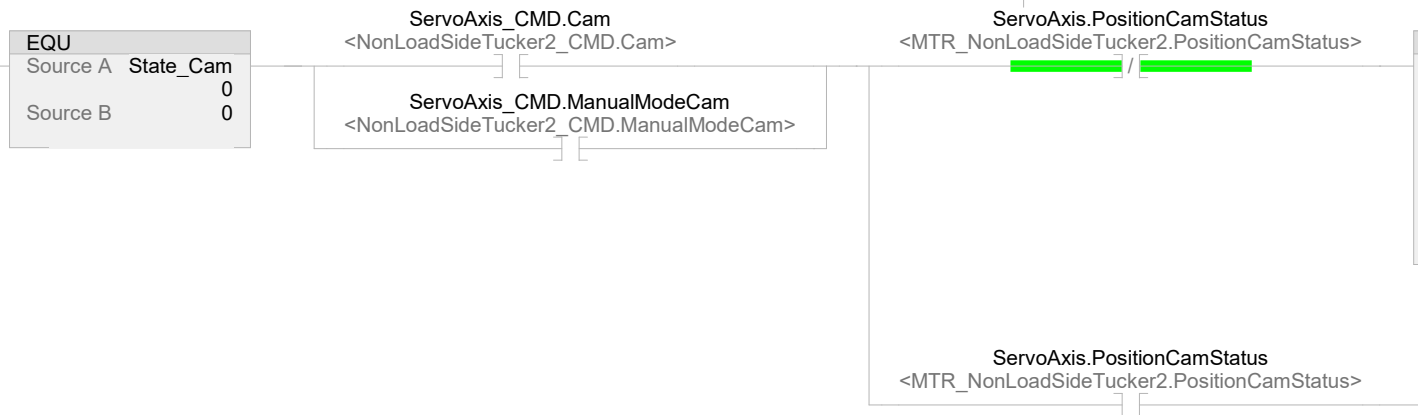


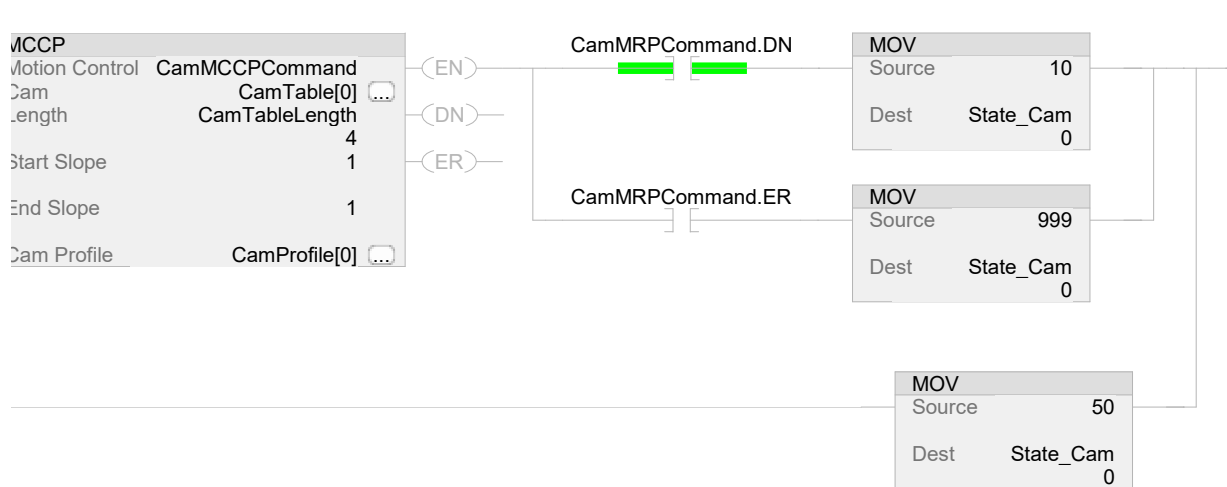






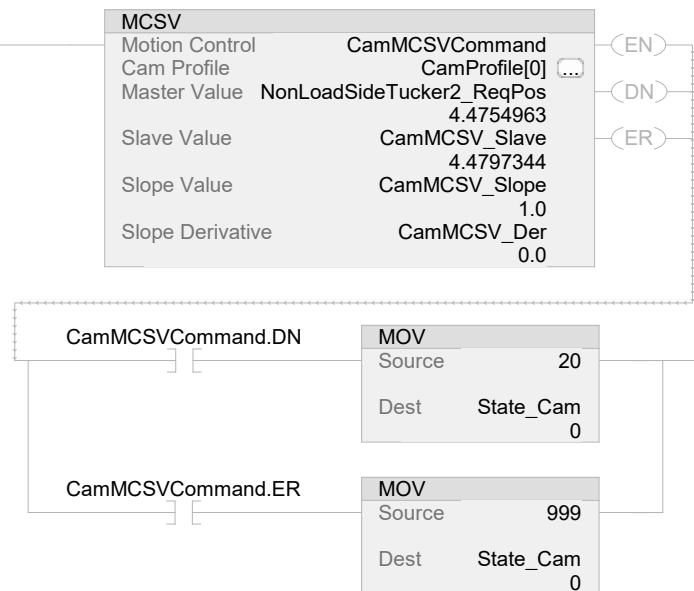
1

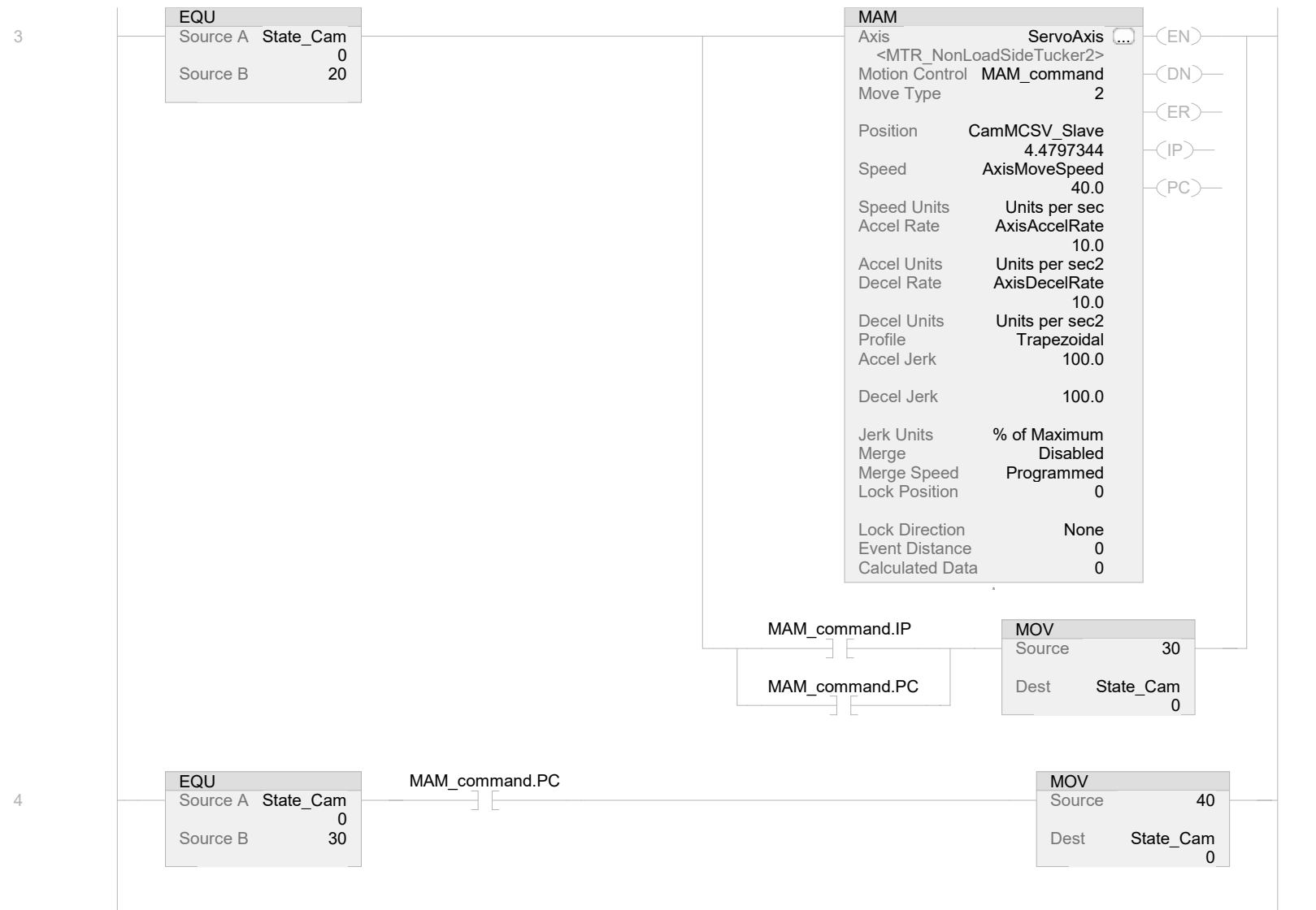




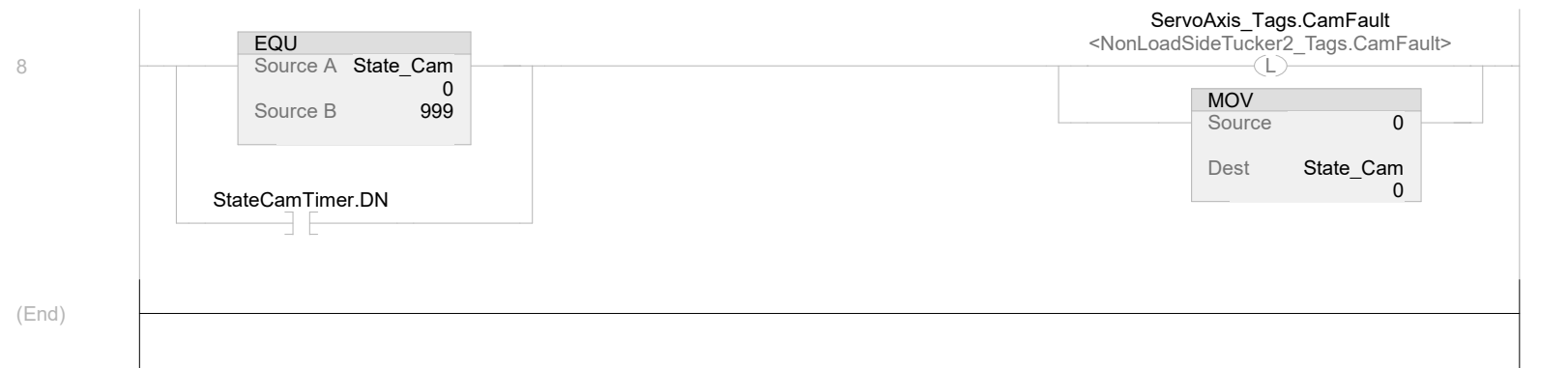
2

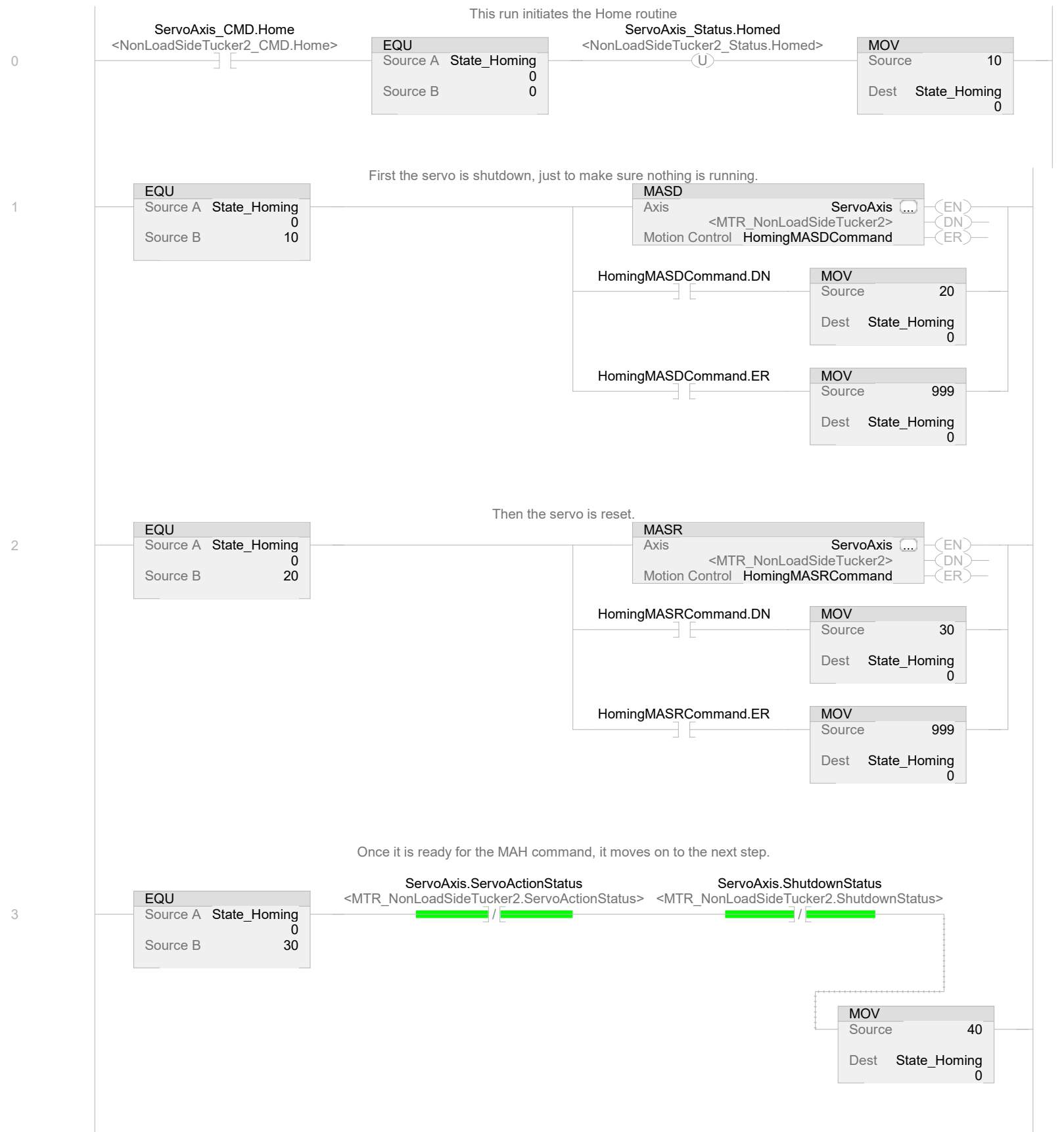
EQU	
Source A	State_Cam
	0
Source B	10

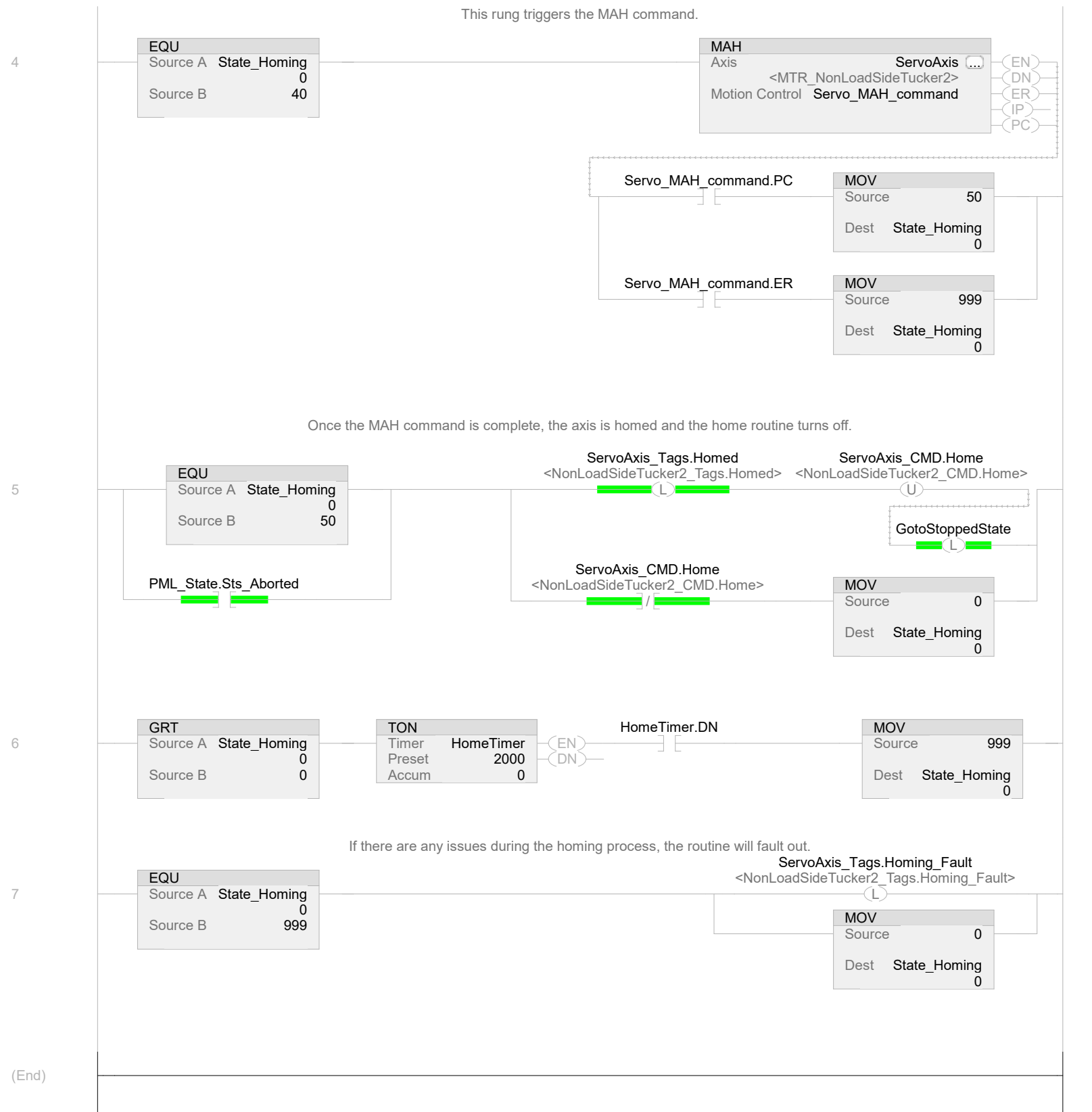


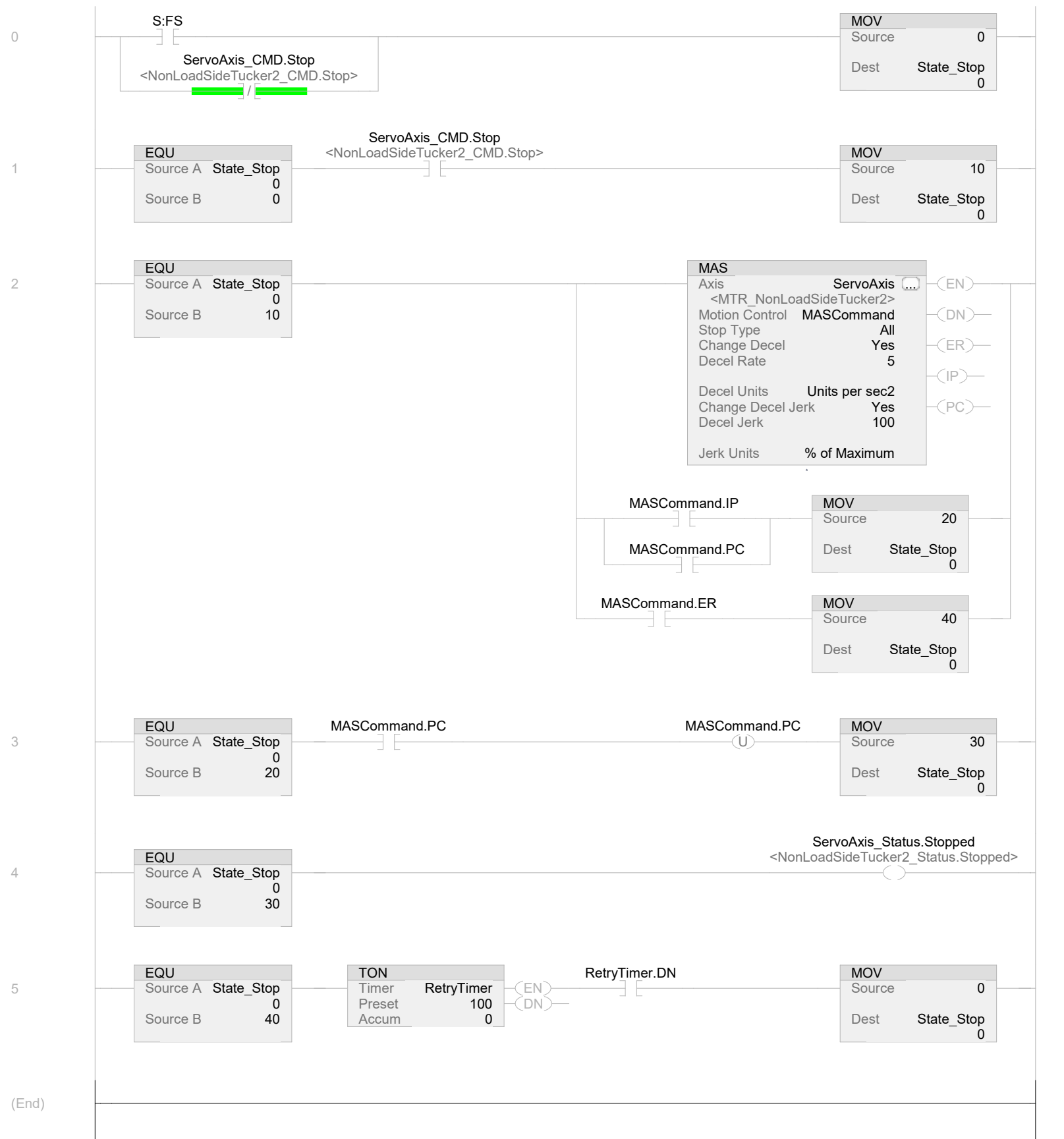


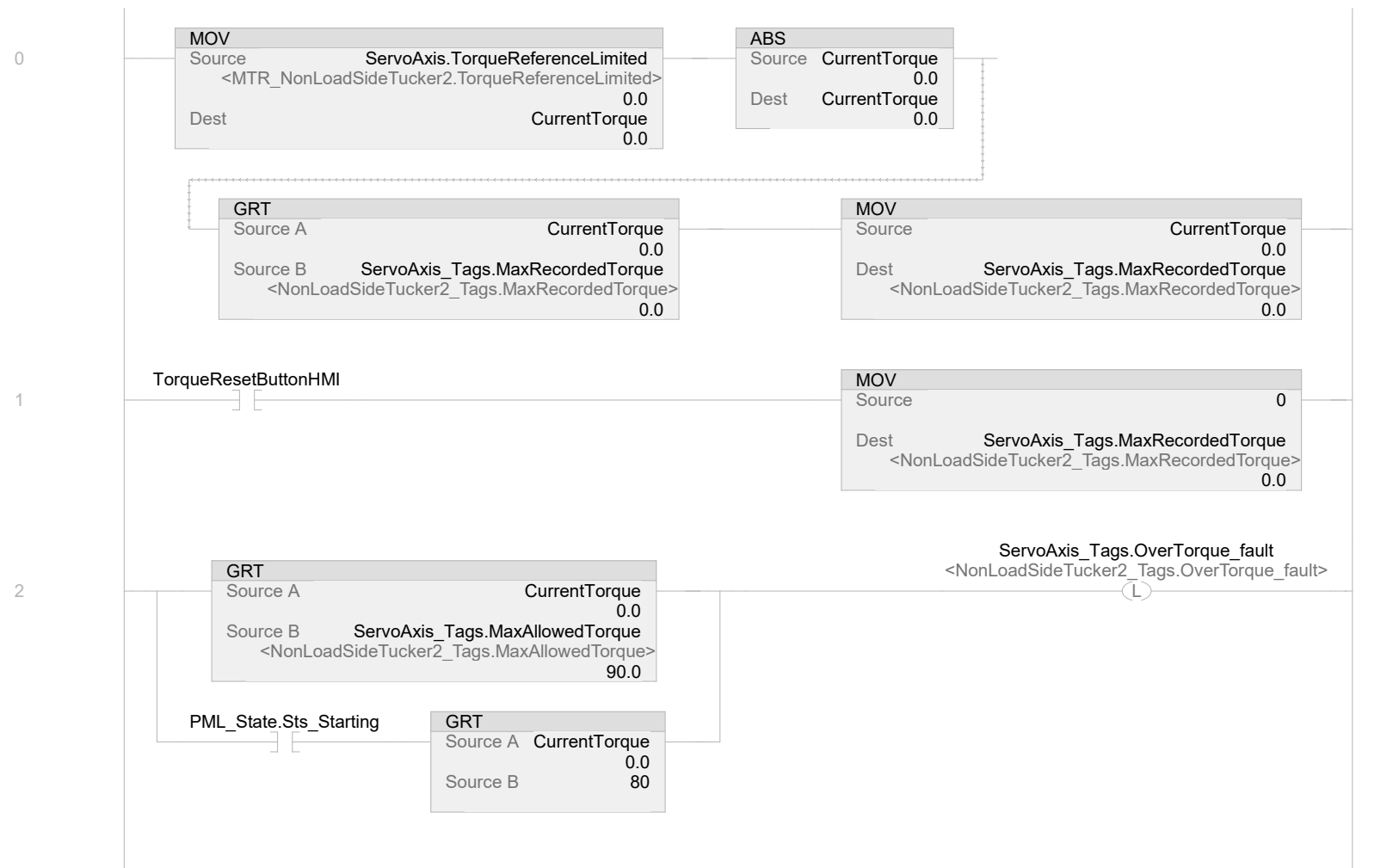


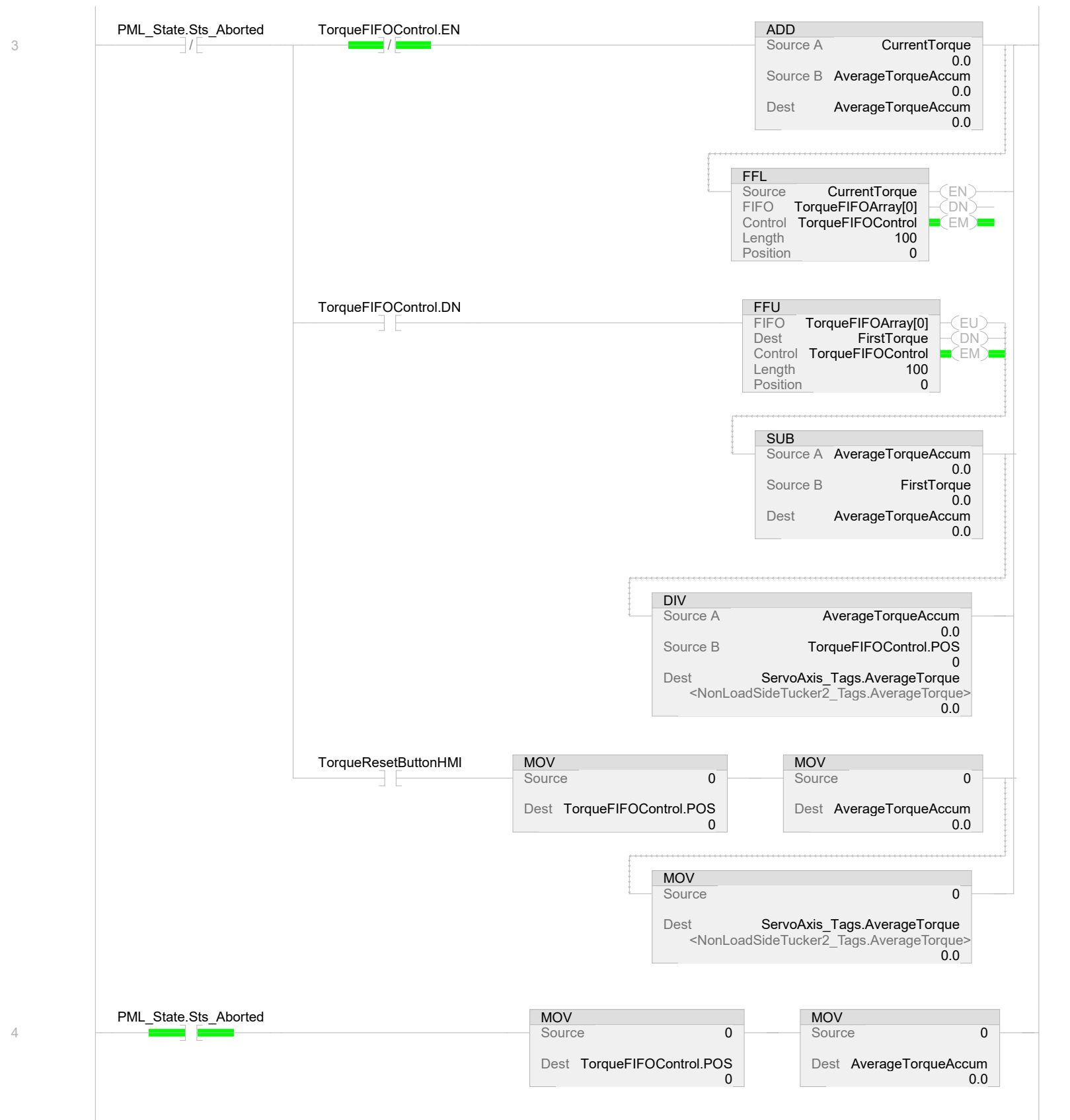




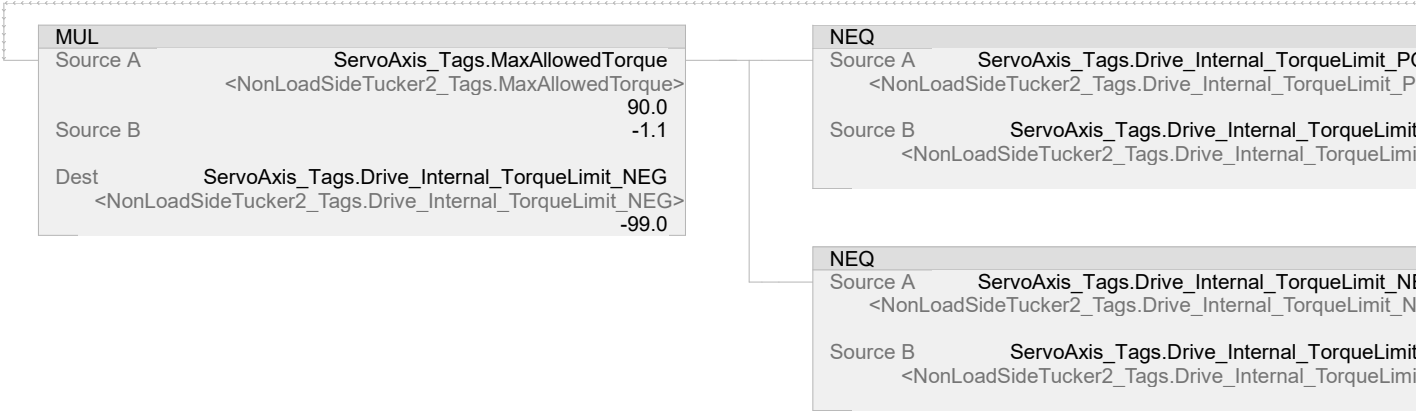


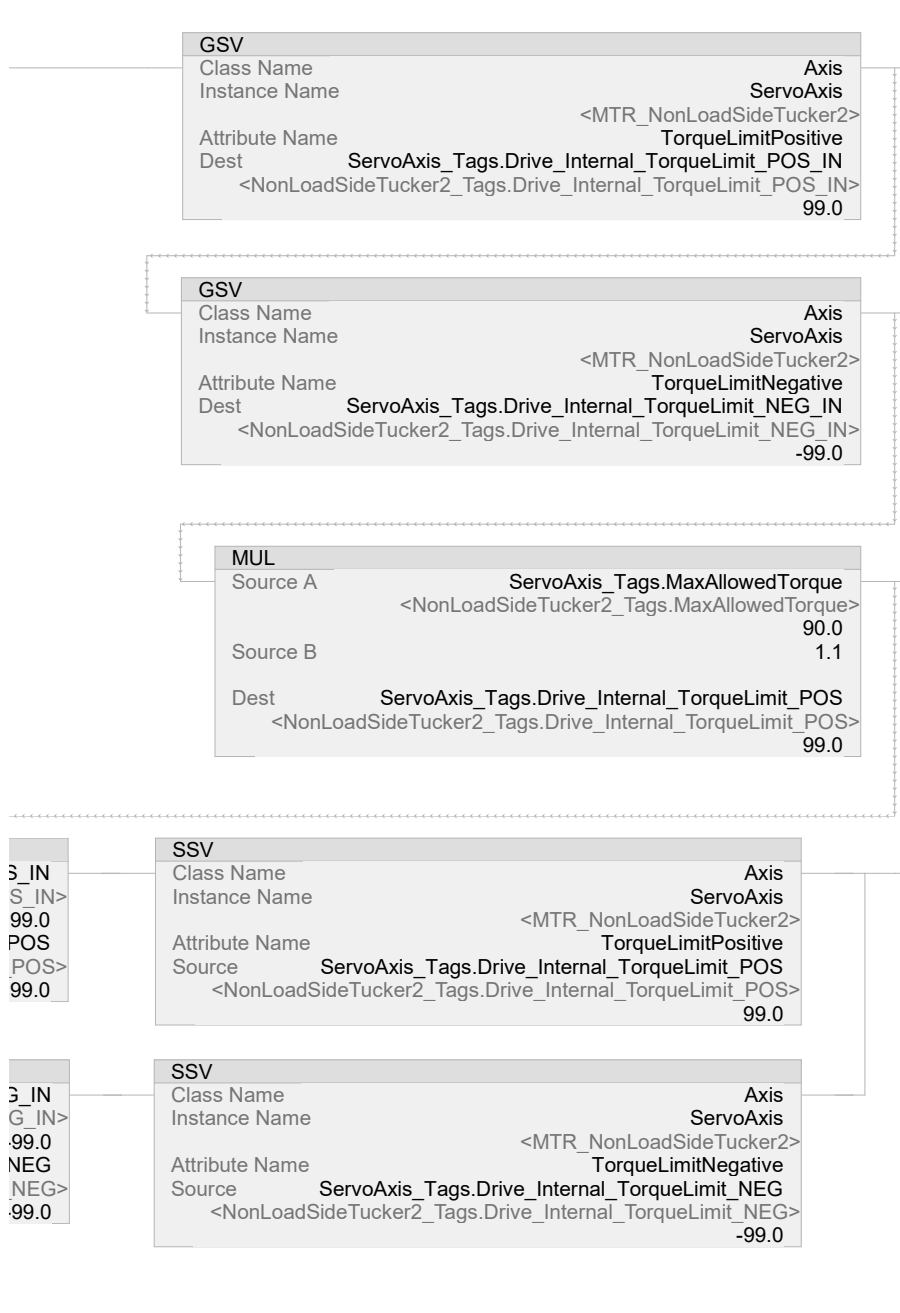






5

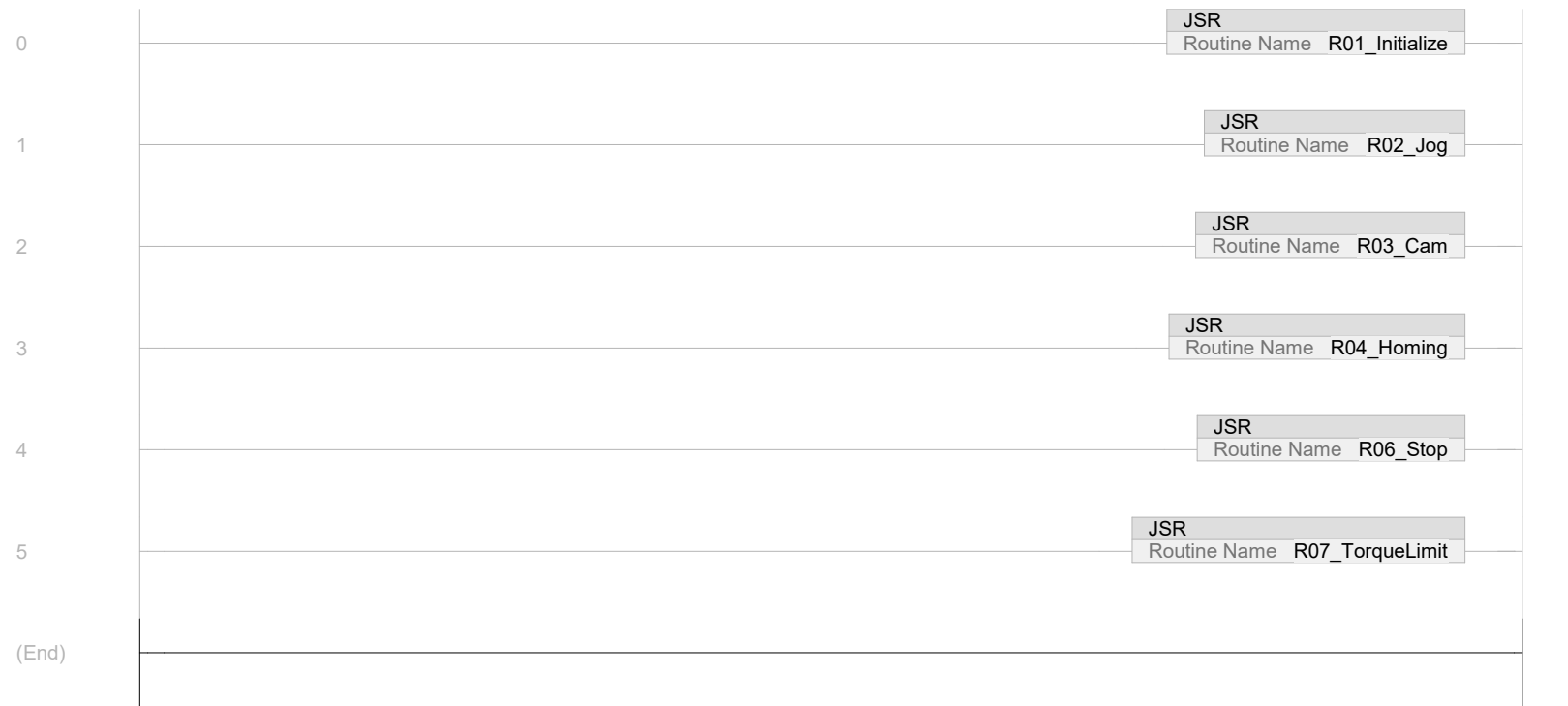


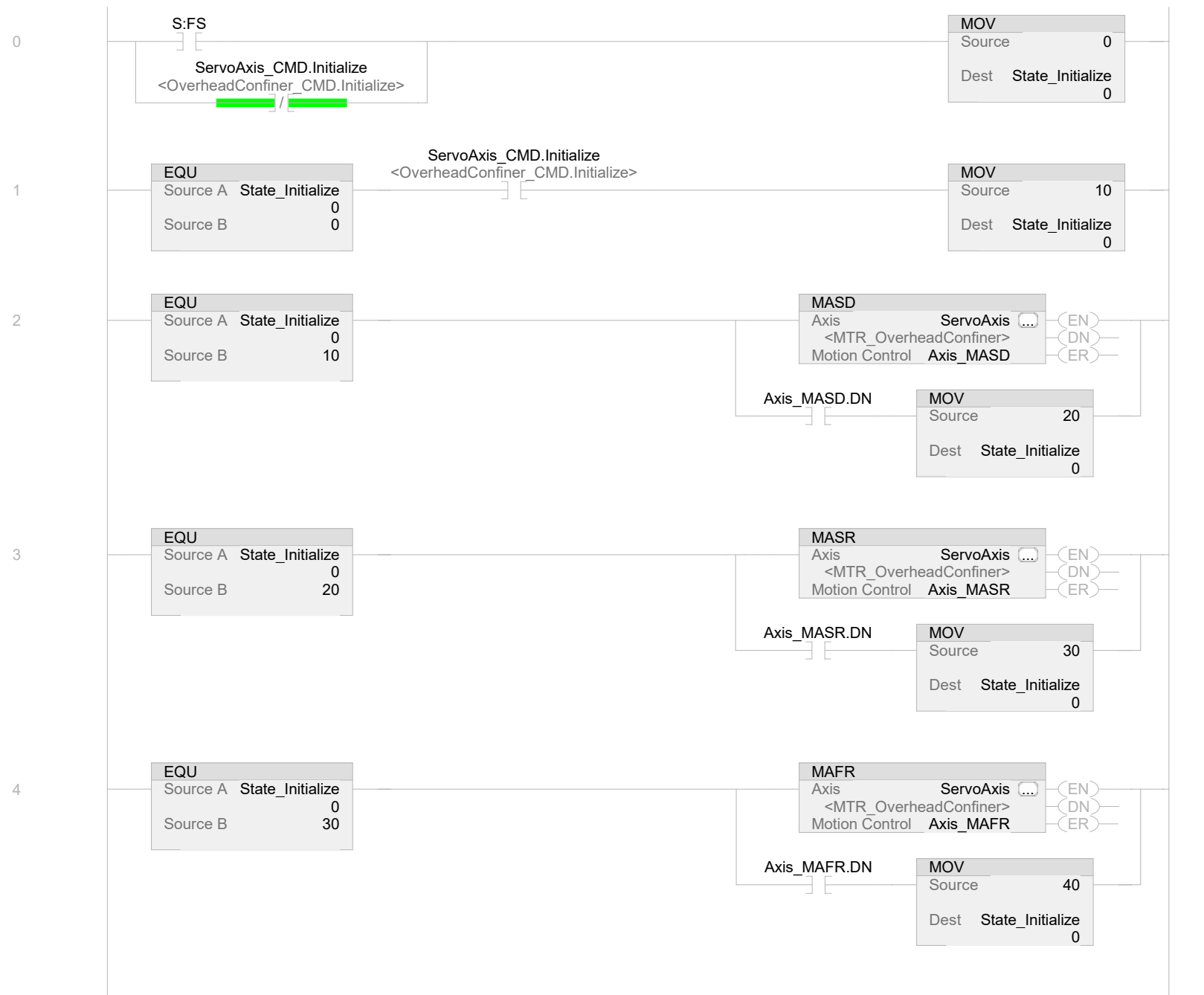


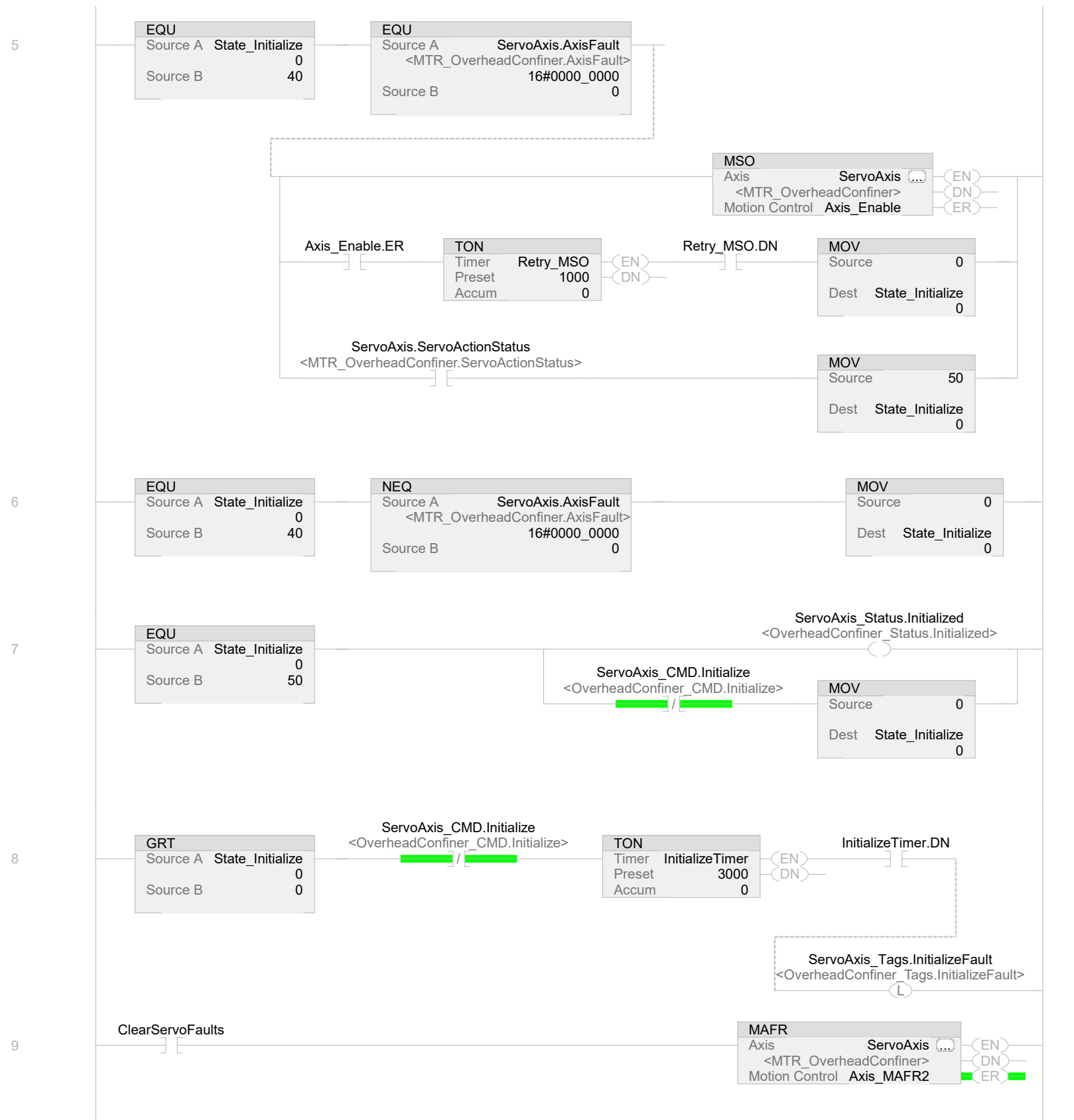
(End)



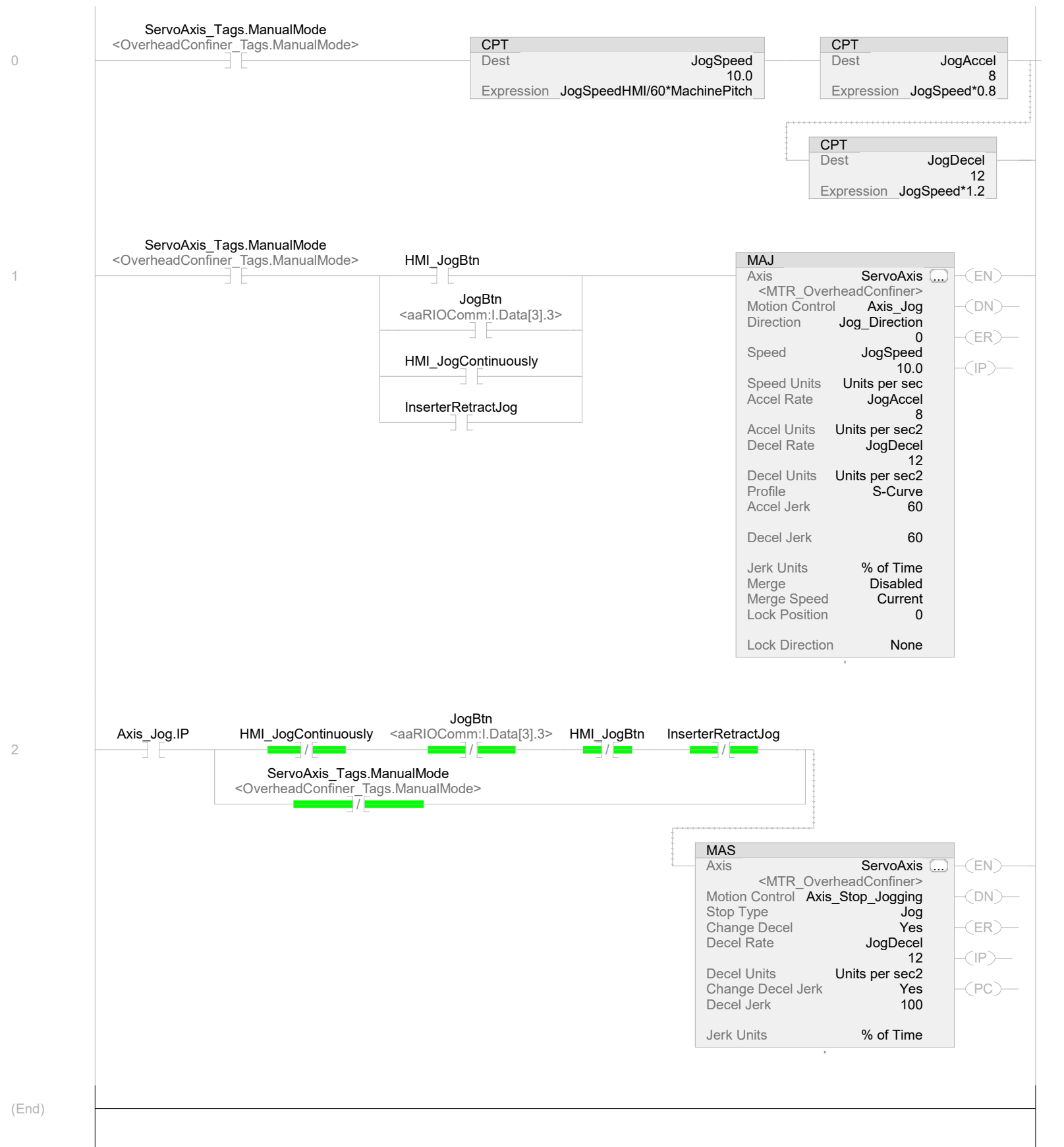


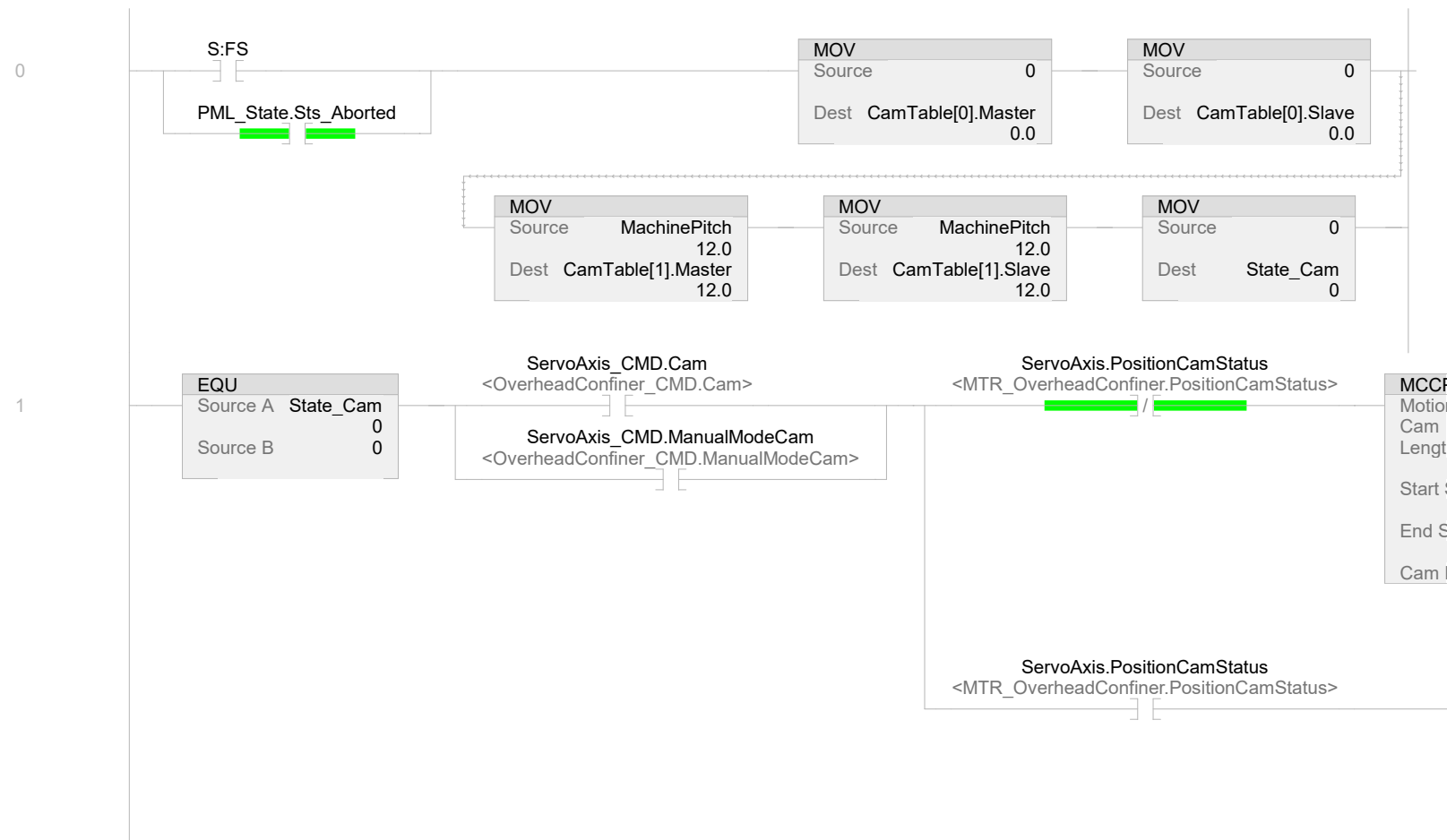












Control	CamMCCPCommand
	CamTable[0]
	2
ope	1
ope	1
ofile	CamProfile[0]

(EN)
(DN)
(ER)

CamMRPCommand.DN

MOV	
Source	20
Dest	State_Cam 0

CamMRPCommand.ER

MOV	
Source	999
Dest	State_Cam 0

MOV	
Source	50
Dest	State_Cam 0

EQU	
Source A	State_Cam 0
Source B	20

MAM	
Axis	ServoAxis
Motion Control	<MTR_OverheadConfiner>
Move Type	MAM_command
	Incremental
	1
Position	OverheadConfinerCorrection
	14.208543
Speed	AxisMoveSpeed
	4.0
Speed Units	Units per sec
Accel Rate	AxisAccelRate
	2.0
Accel Units	Units per sec2
Decel Rate	AxisDecelRate
	2.0
Decel Units	Units per sec2
Profile	Trapezoidal
Accel Jerk	100.0
Decel Jerk	100.0
Jerk Units	% of Maximum
Merge	Disabled
Merge Speed	Programmed
Lock Position	0
Lock Direction	None
Event Distance	0
Calculated Data	0

(EN)
(DN)
(ER)
(IP)
(PC)

MAM_command.IP

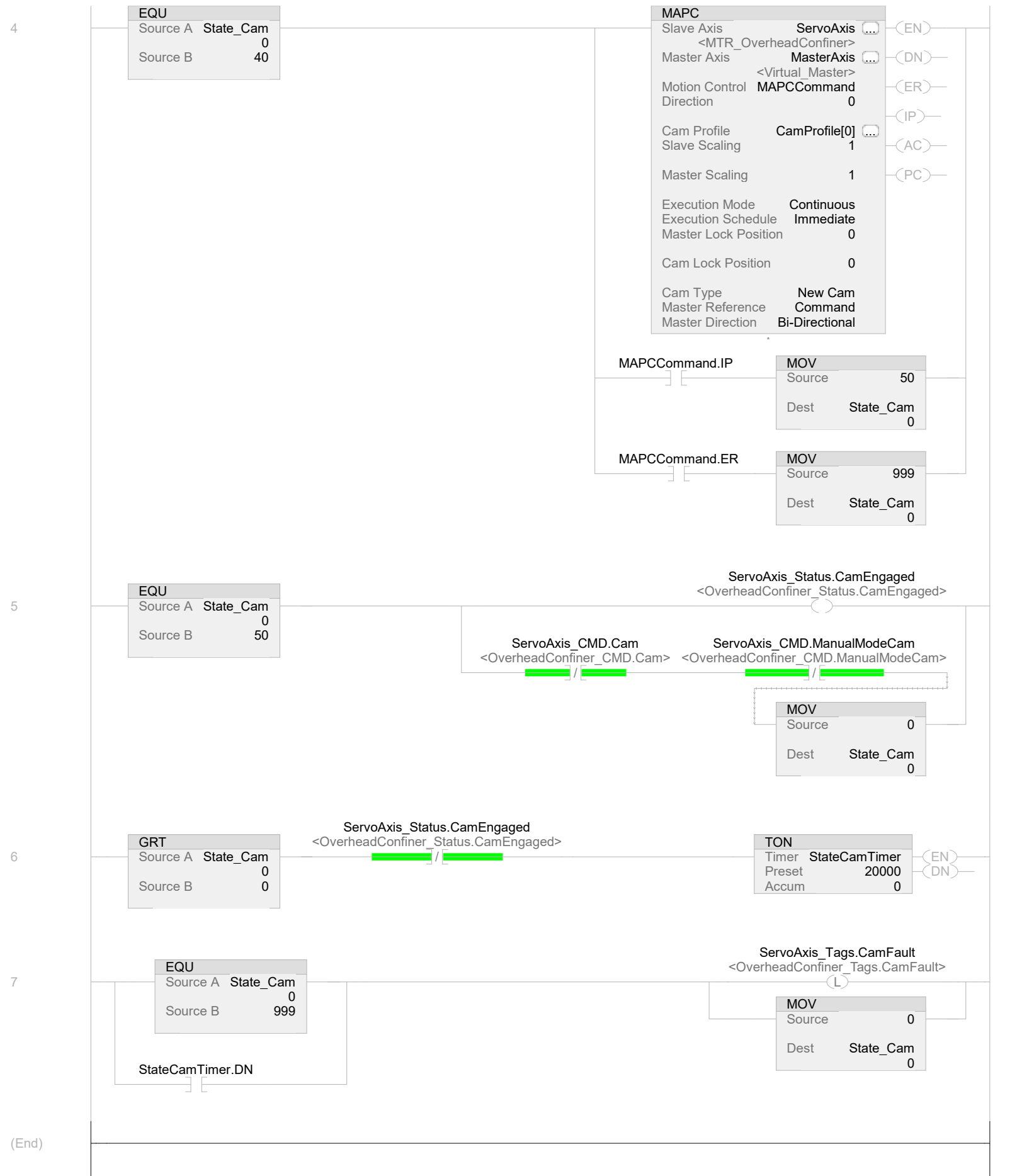
MAM_command.PC

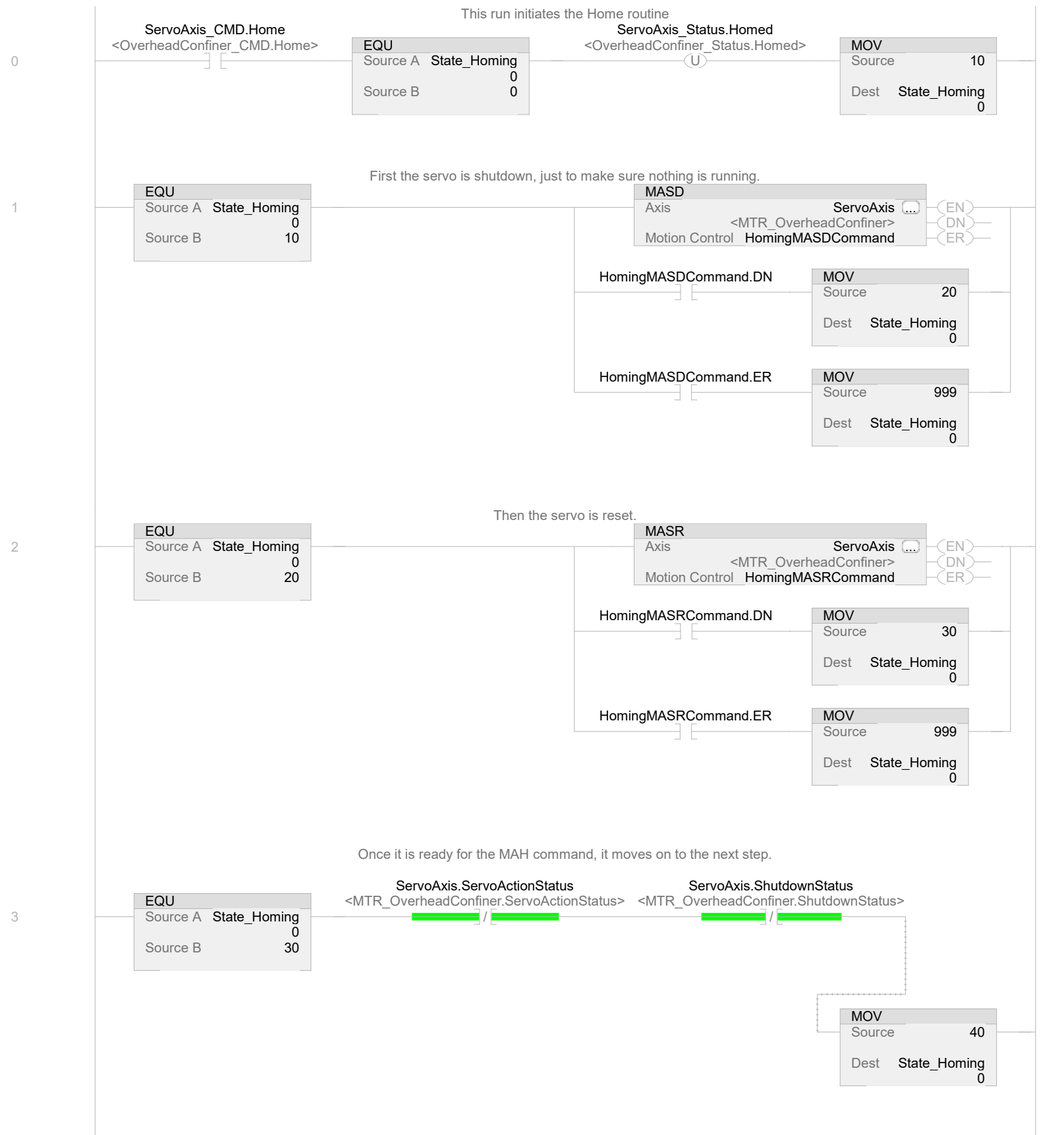
MOV	
Source	30
Dest	State_Cam 0

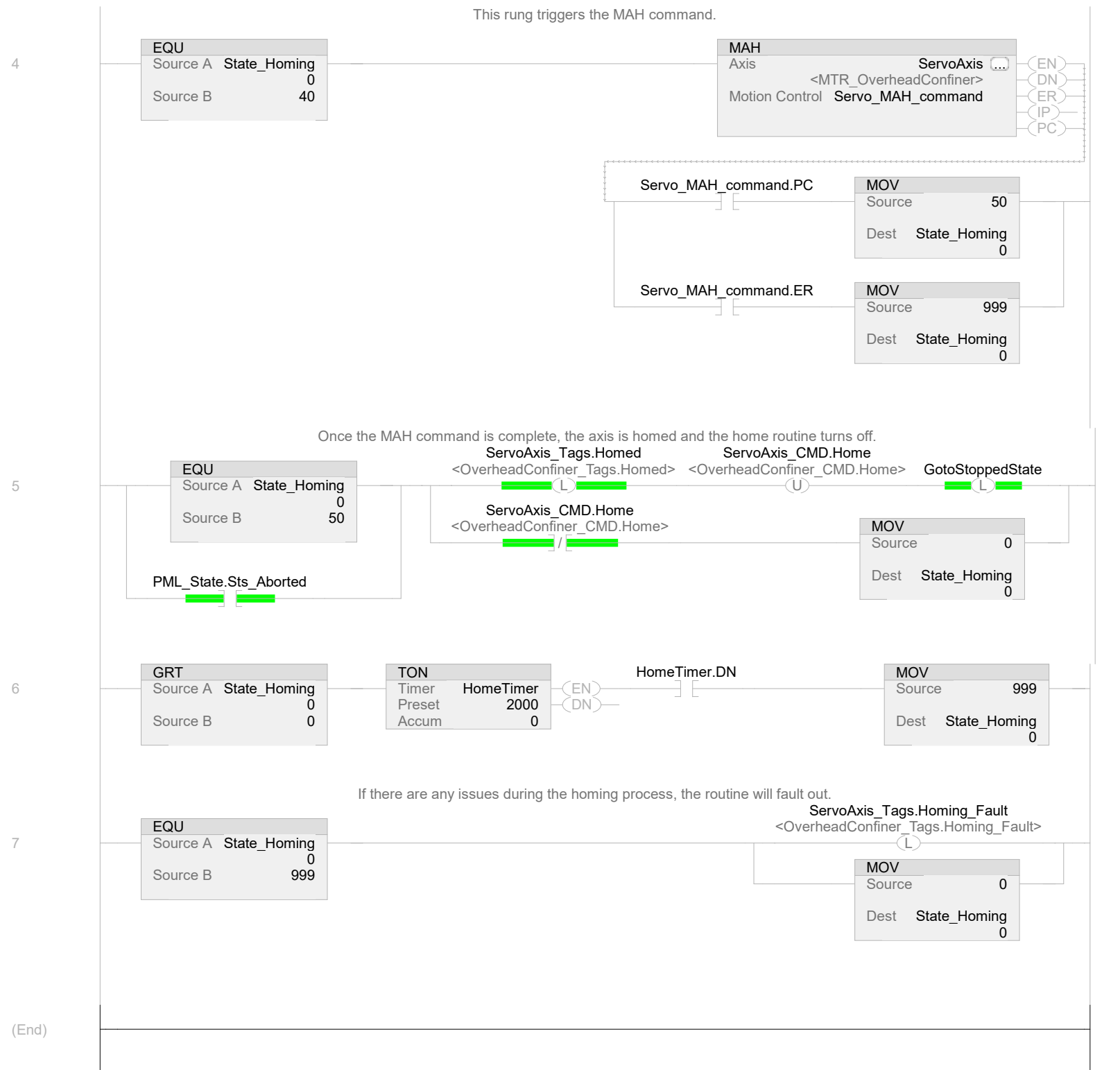
EQU	
Source A	State_Cam 0
Source B	30

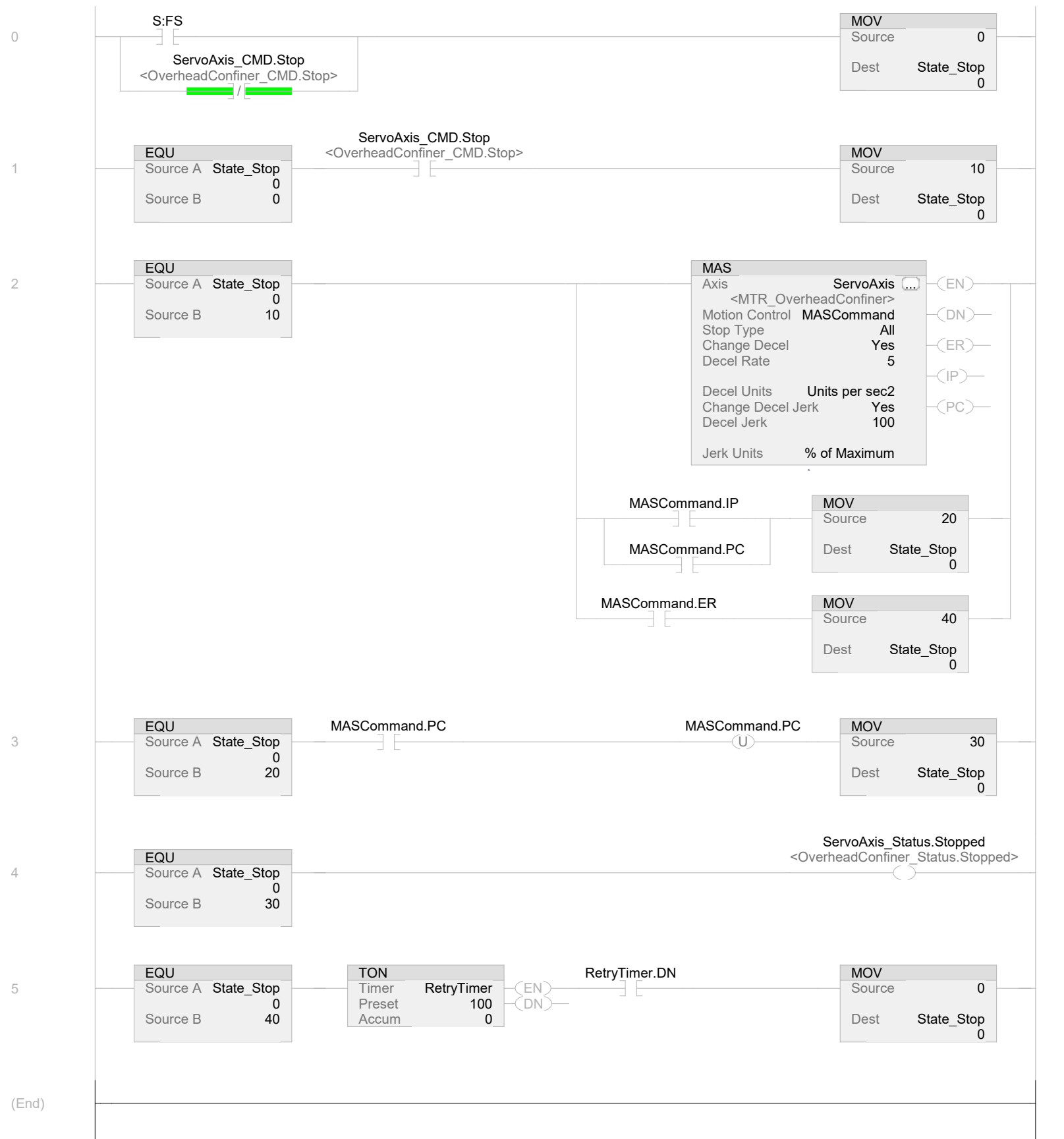
MAM_command.PC

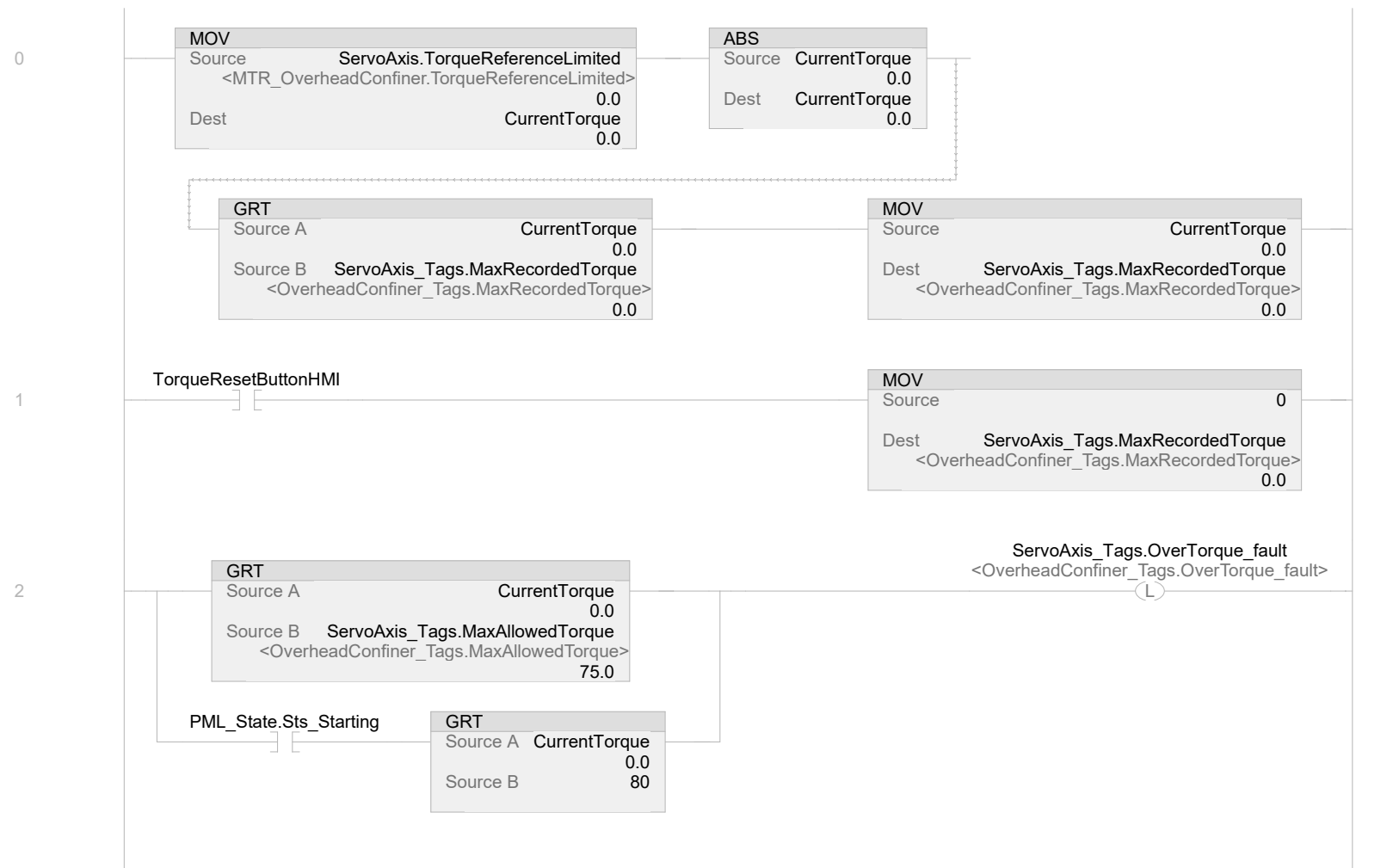
MOV	
Source	40
Dest	State_Cam 0

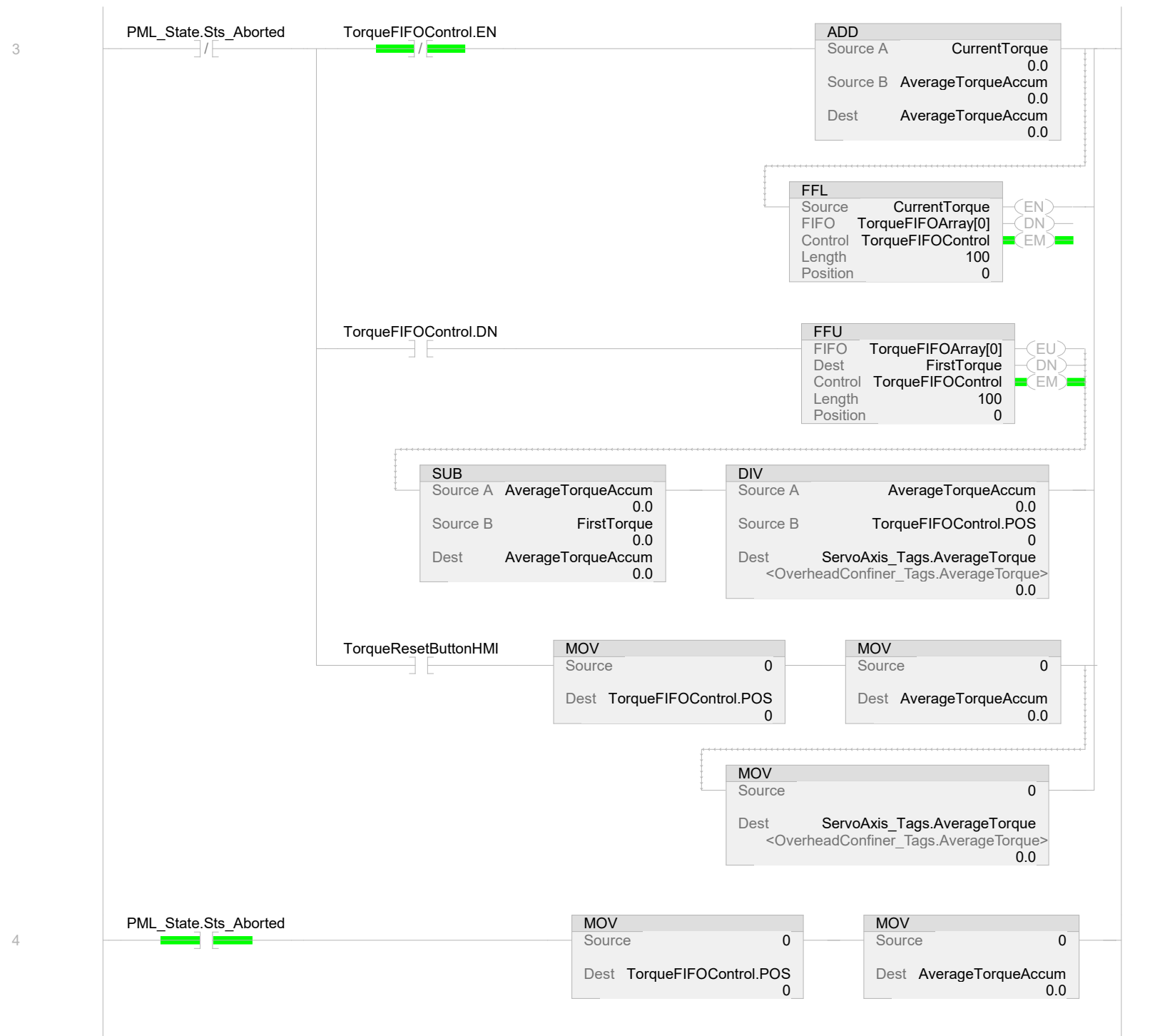




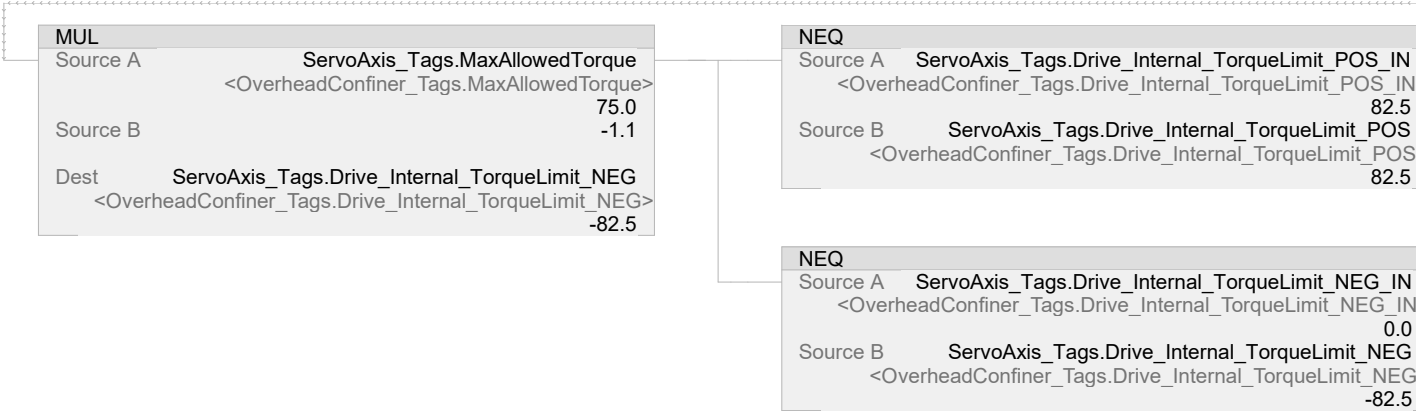


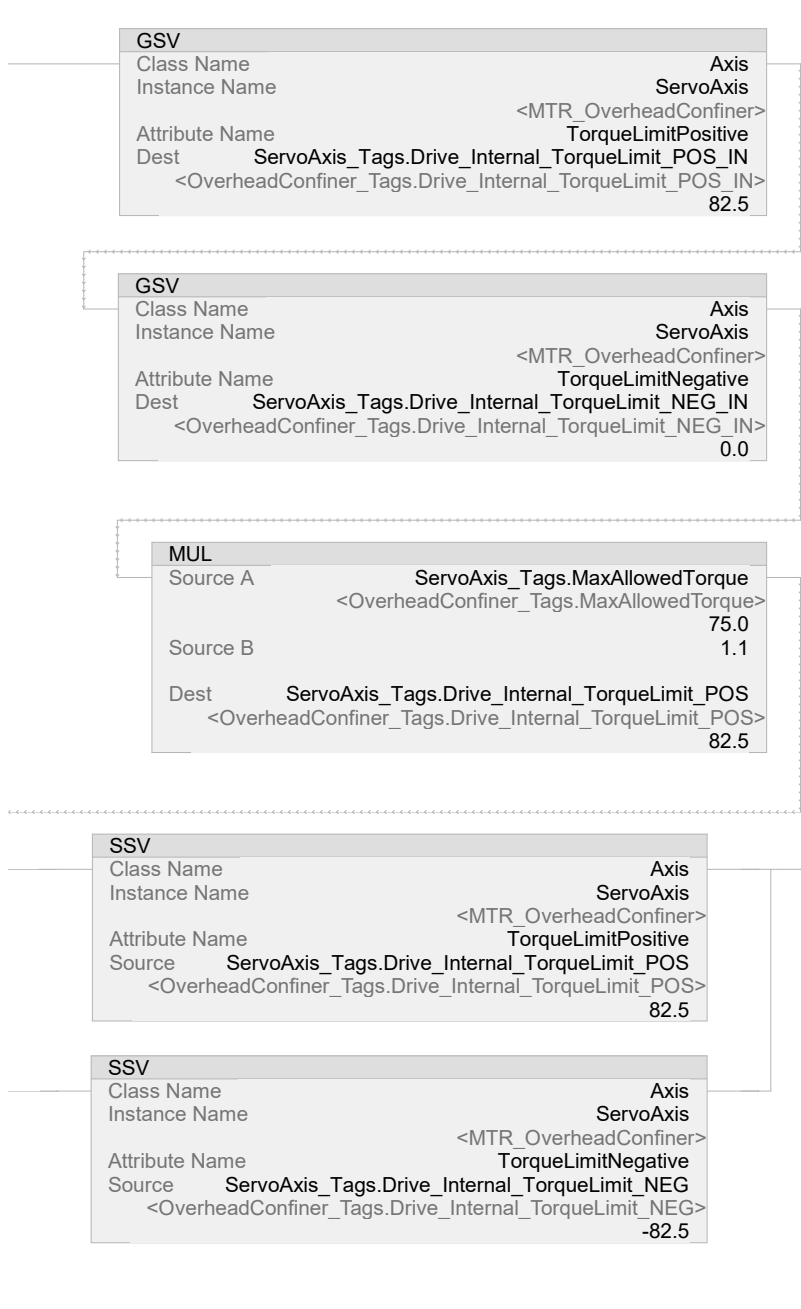




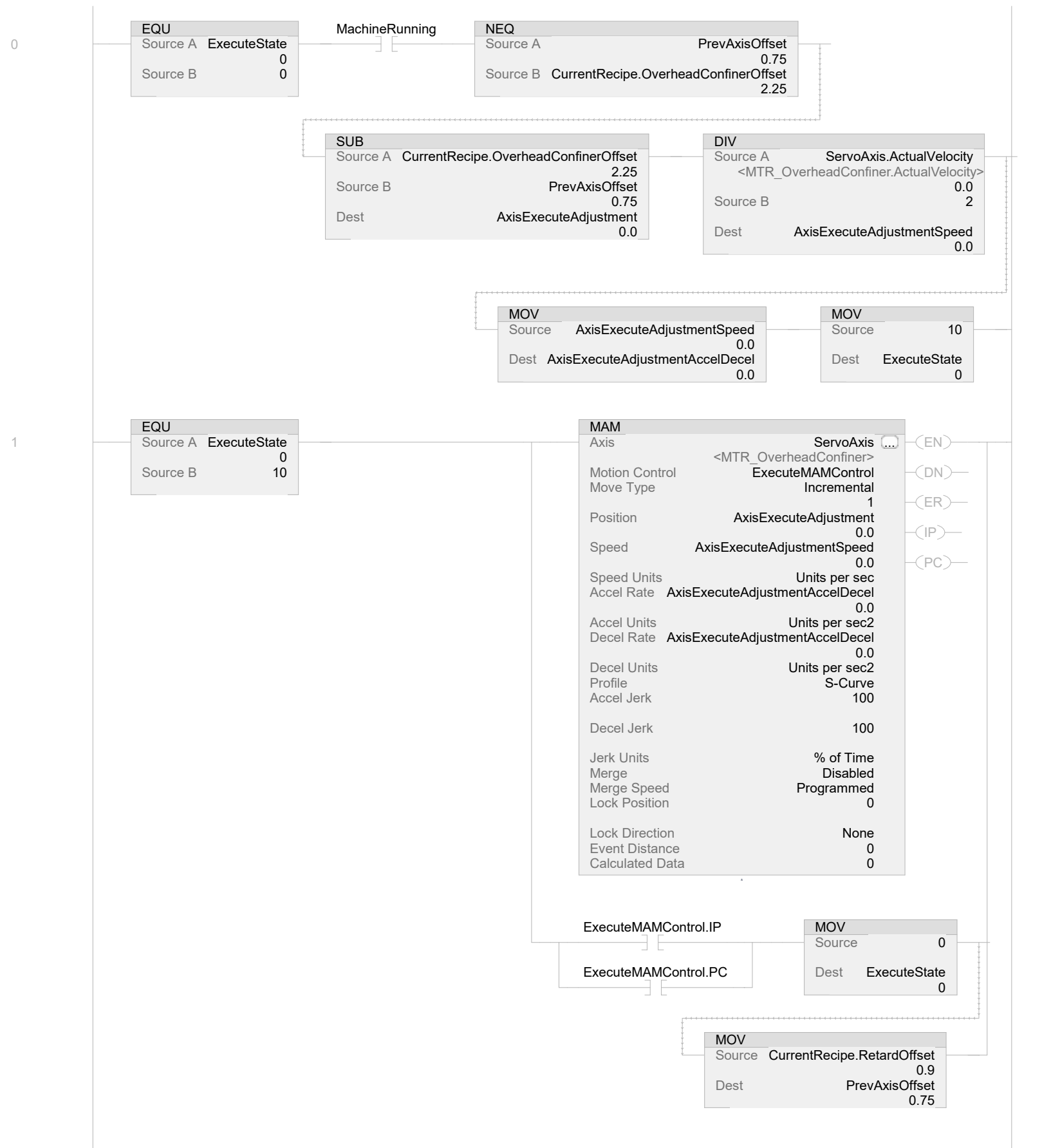


5

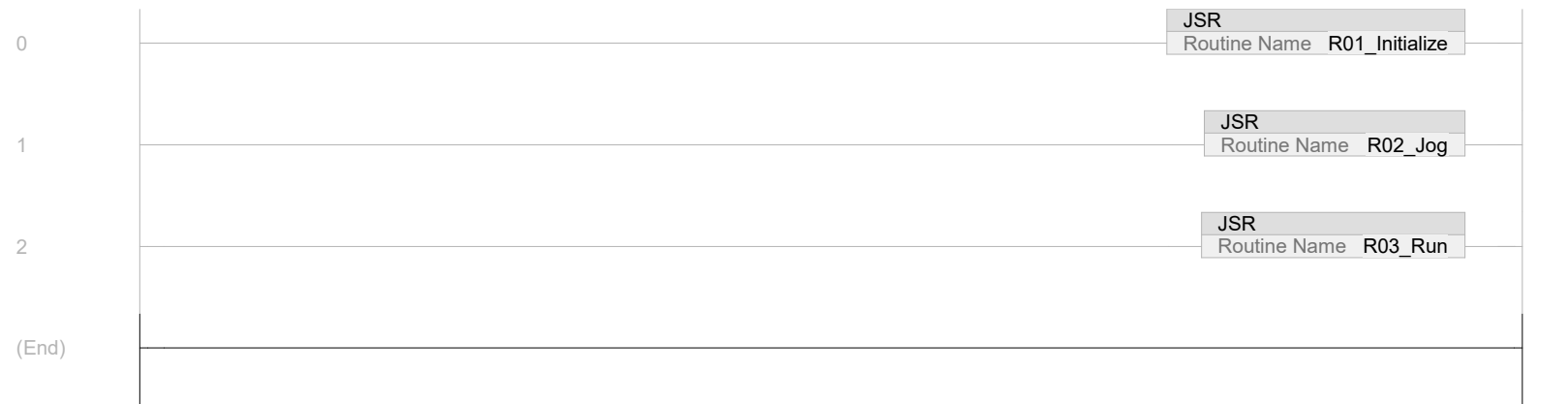


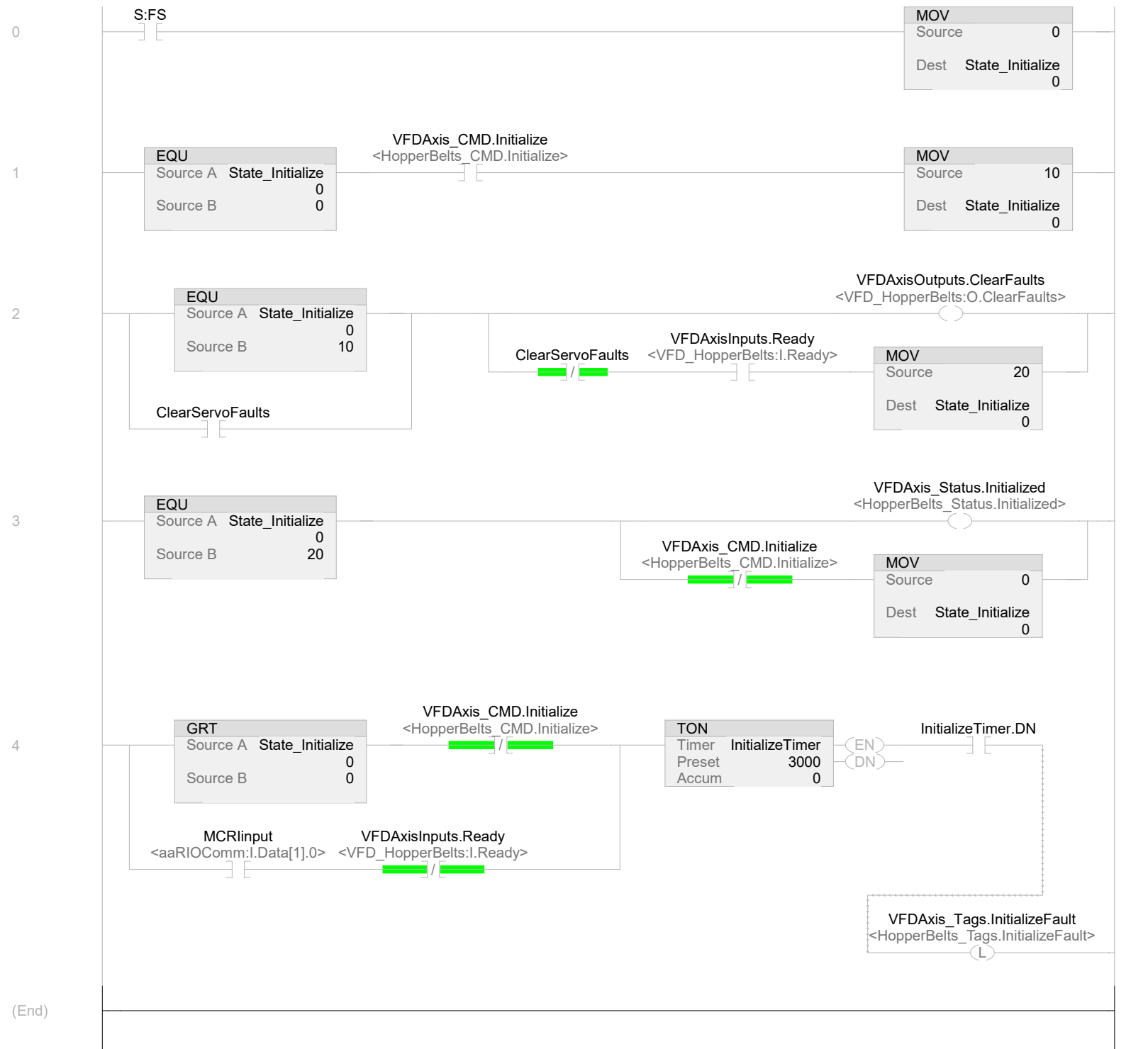


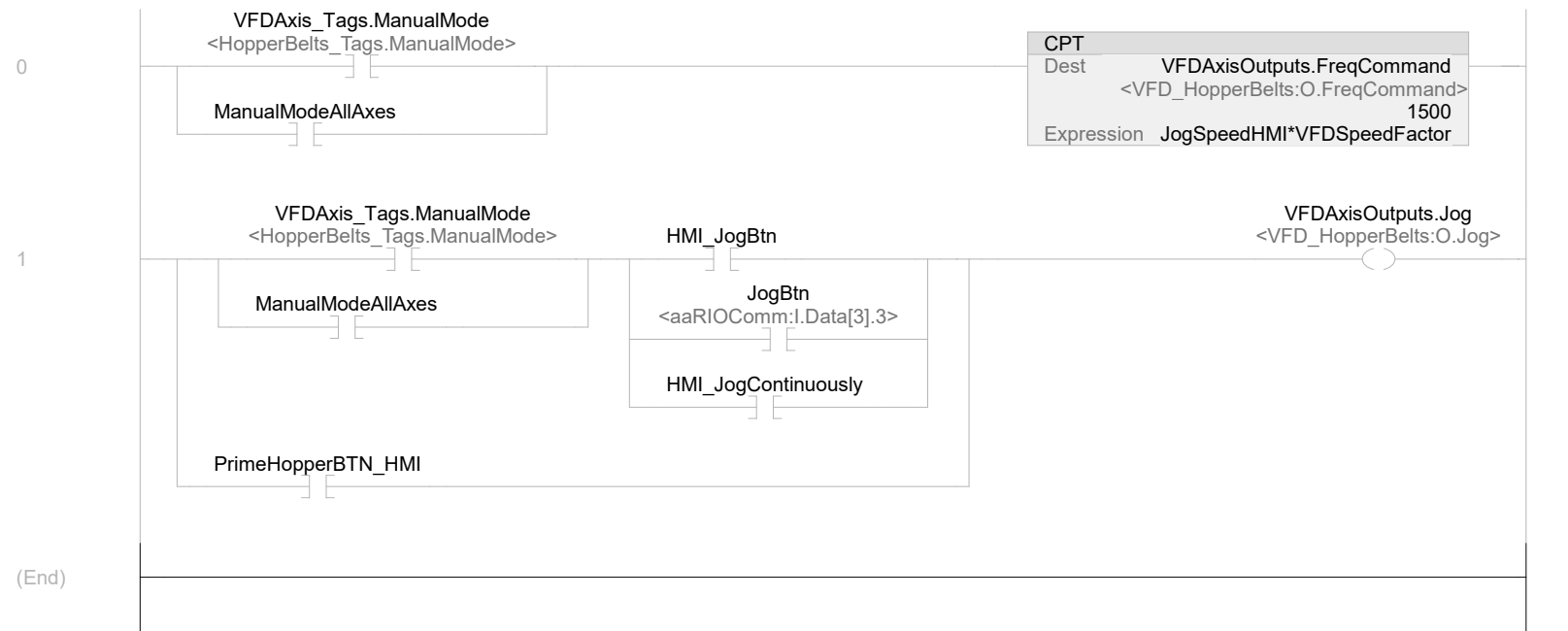
(End)

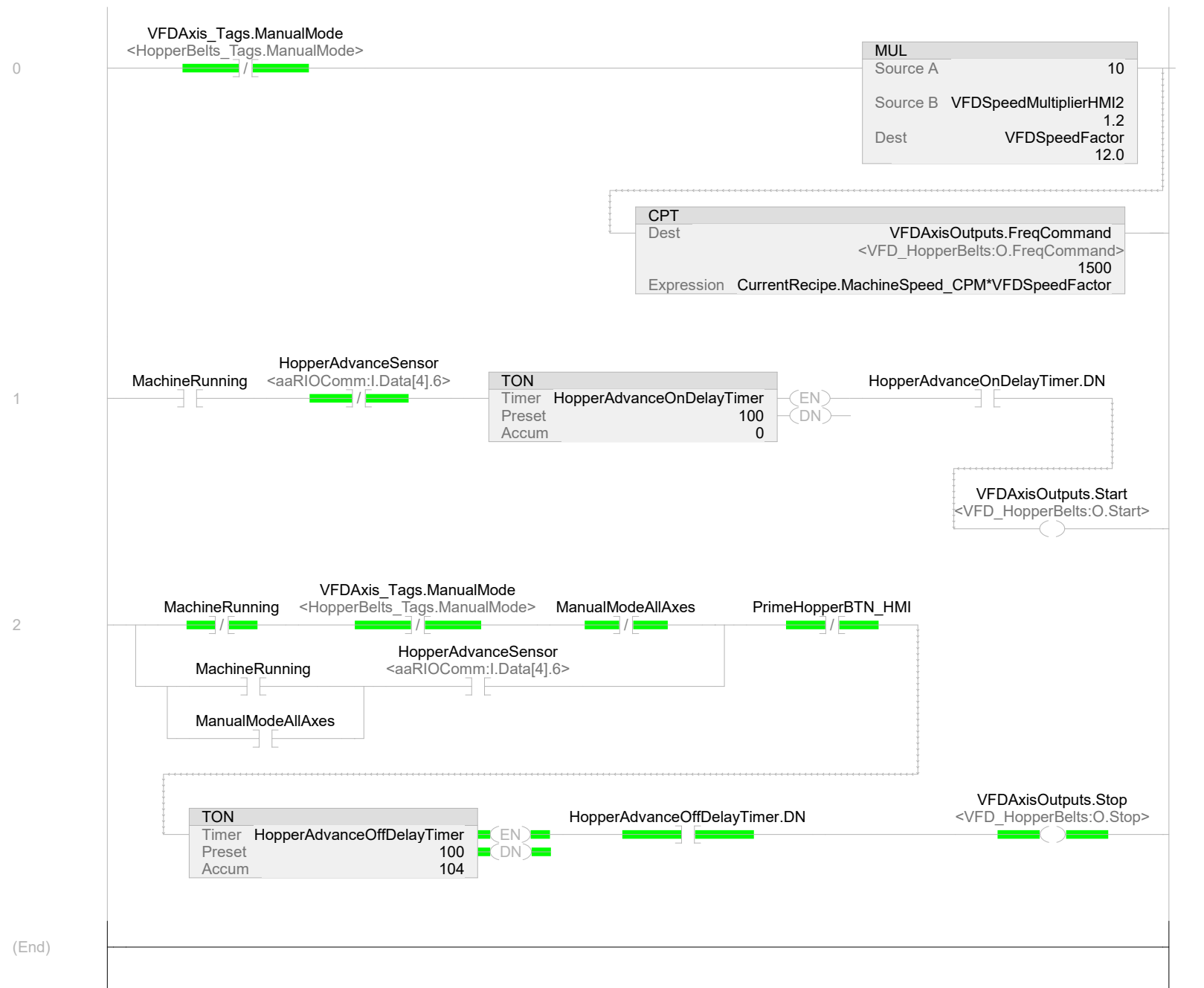


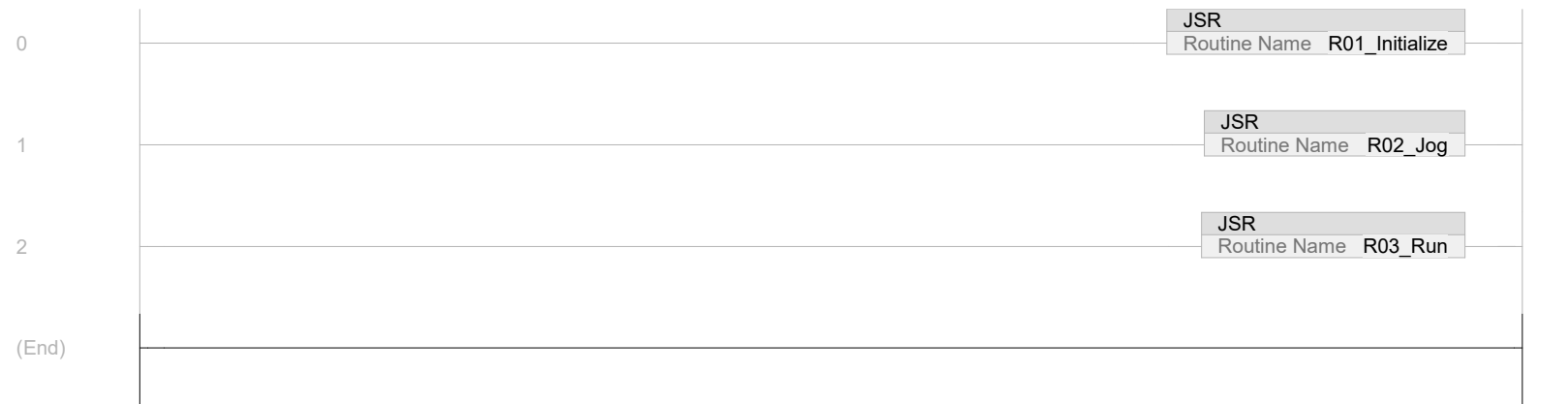


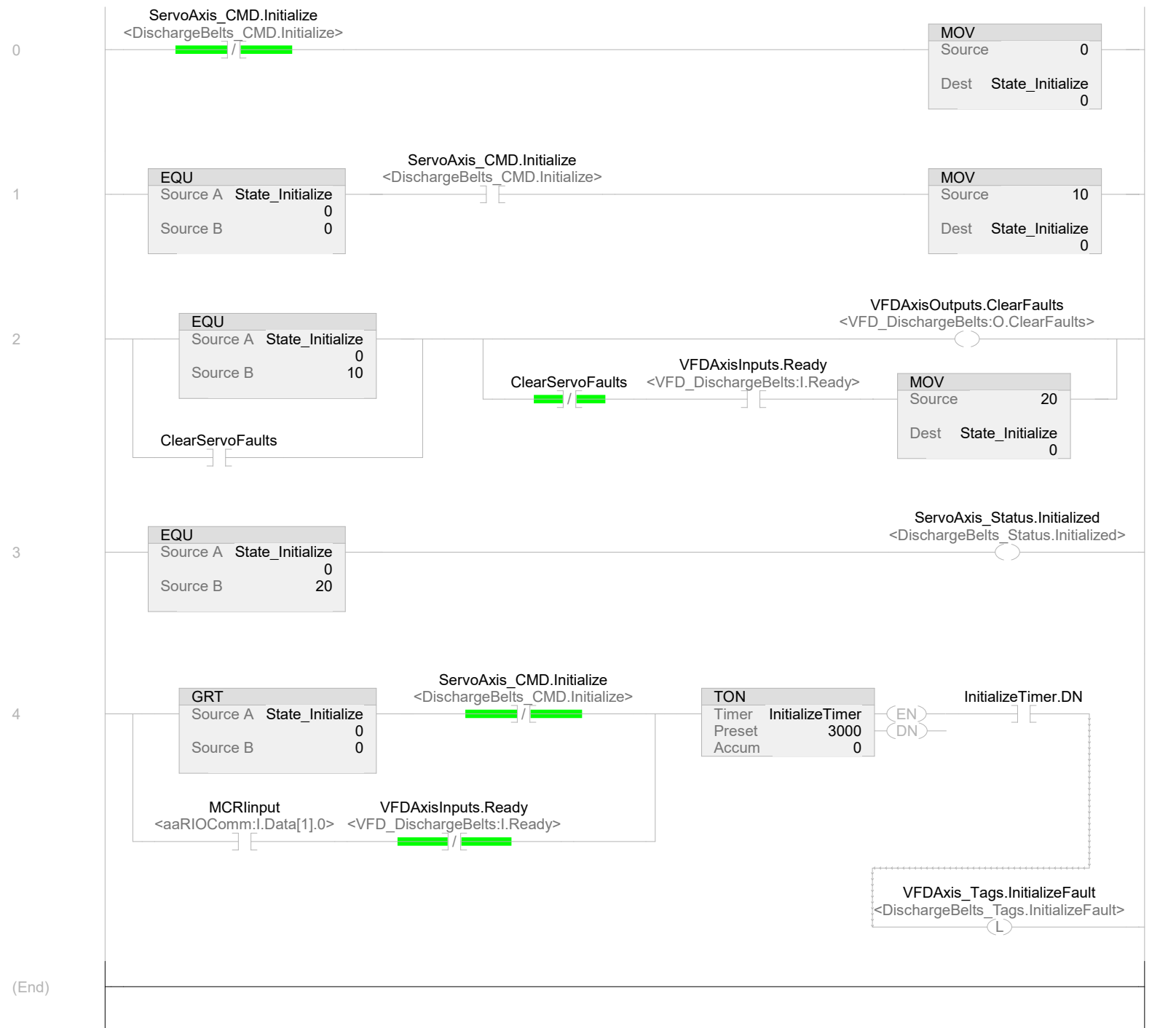


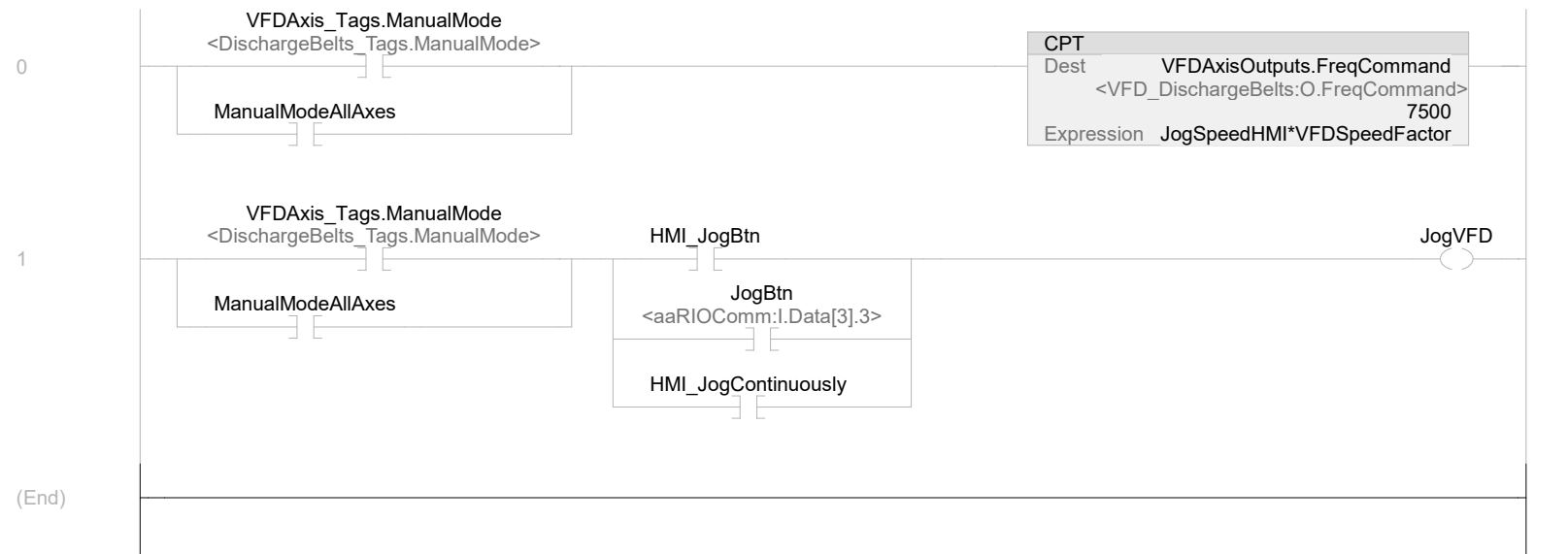


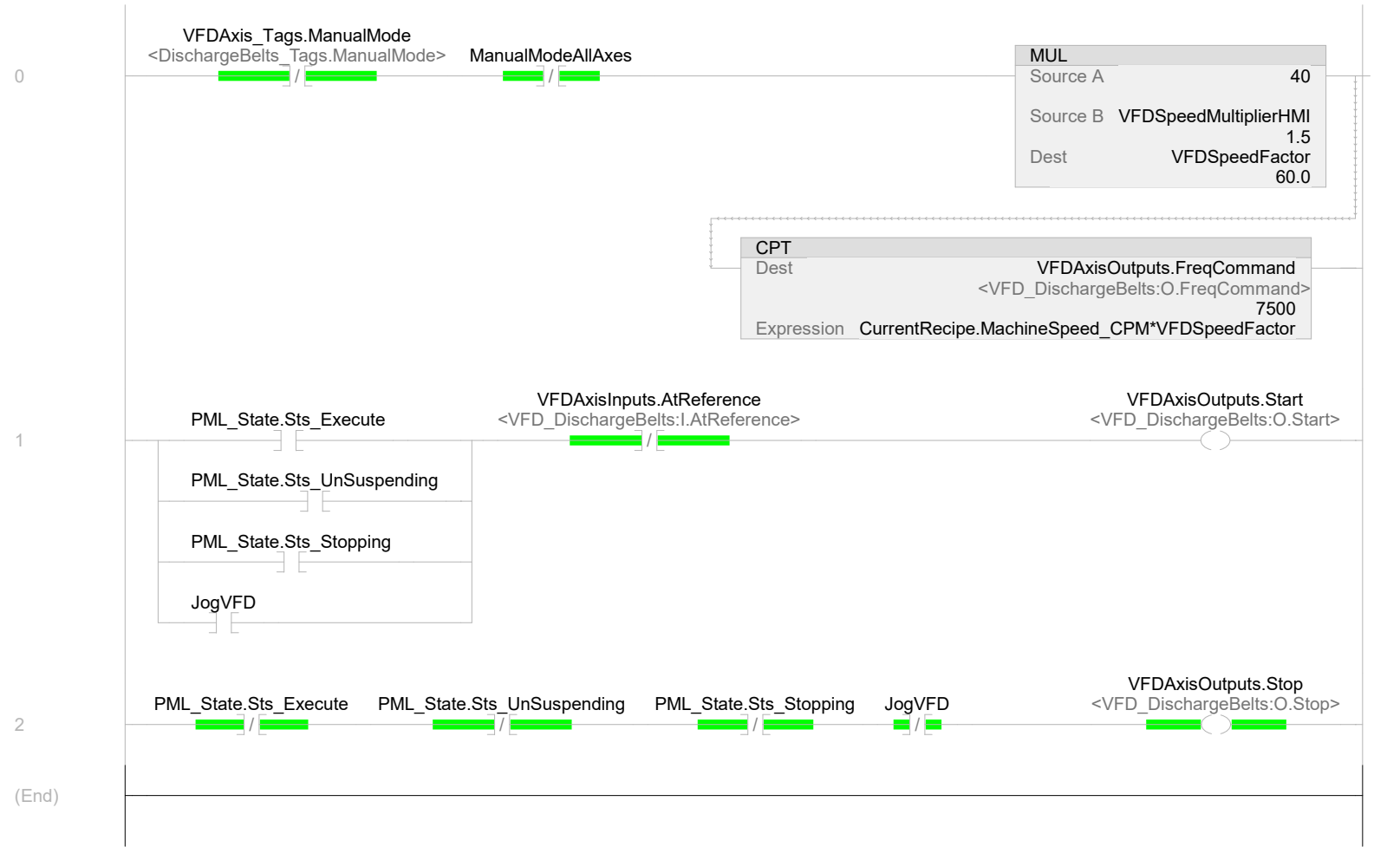


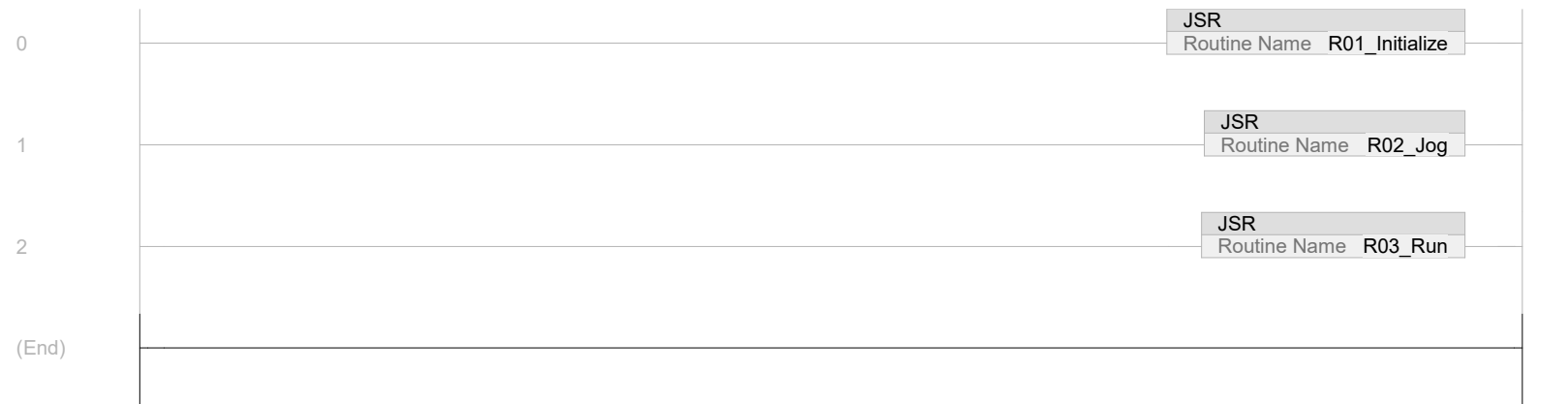


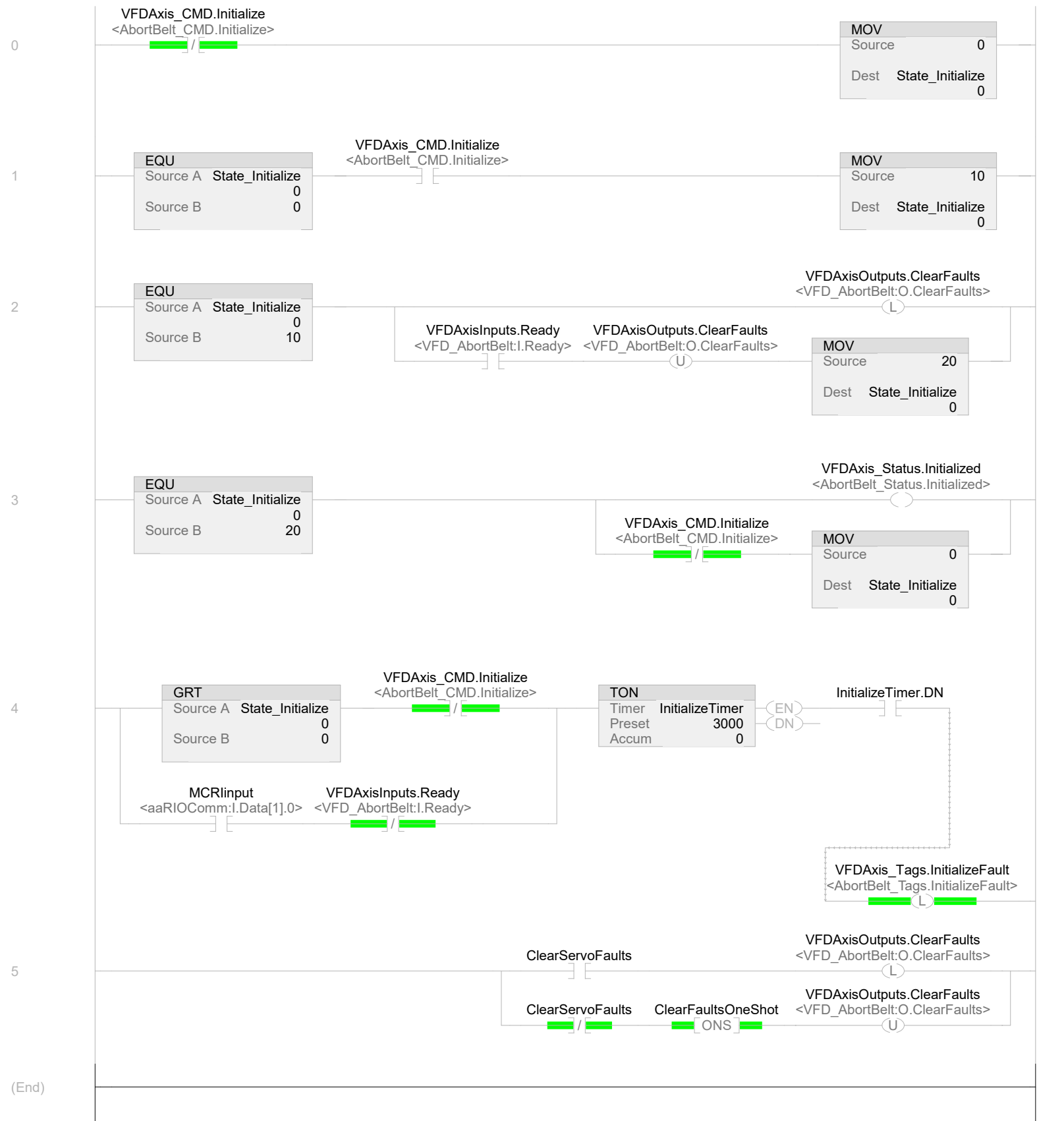




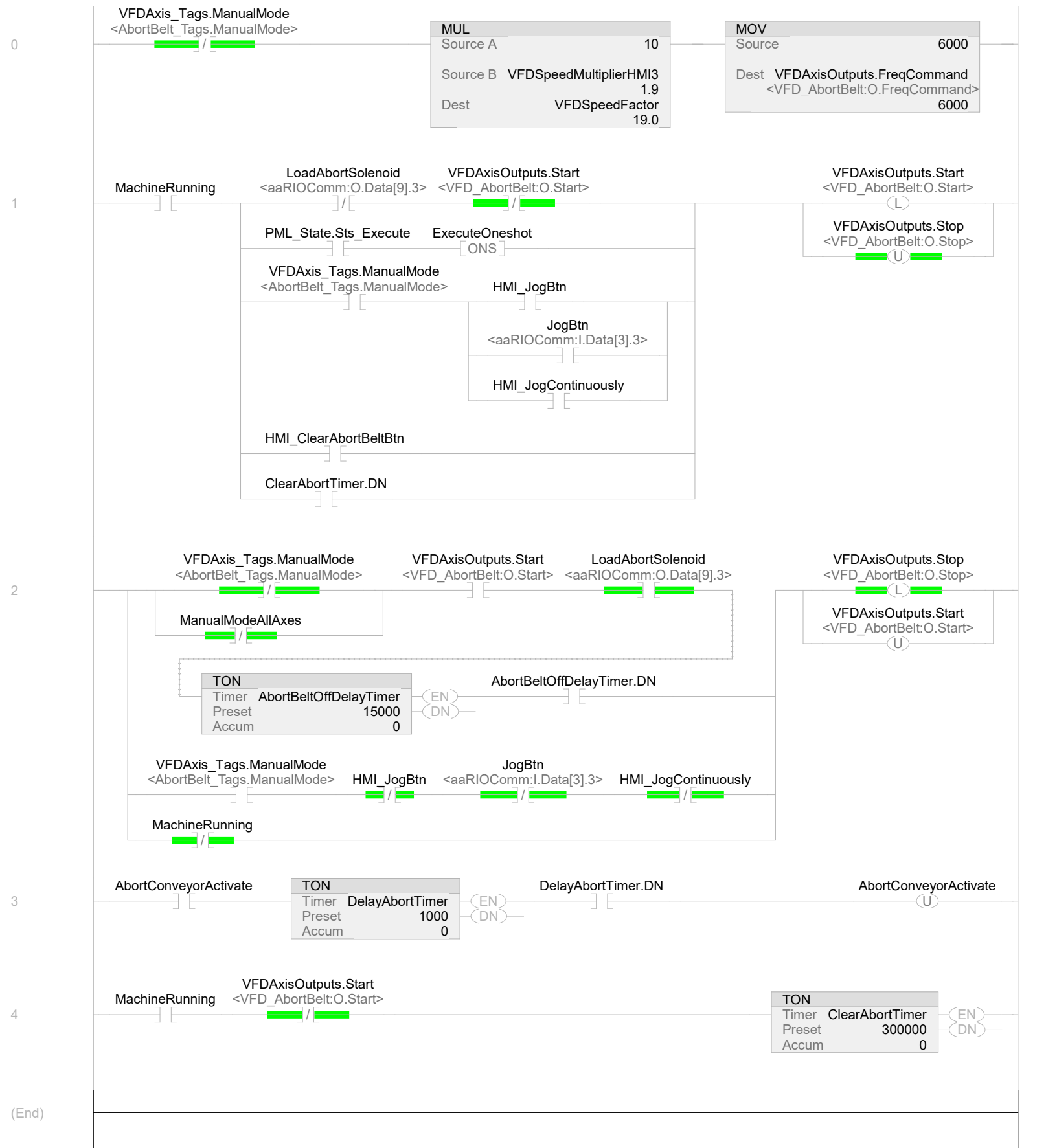


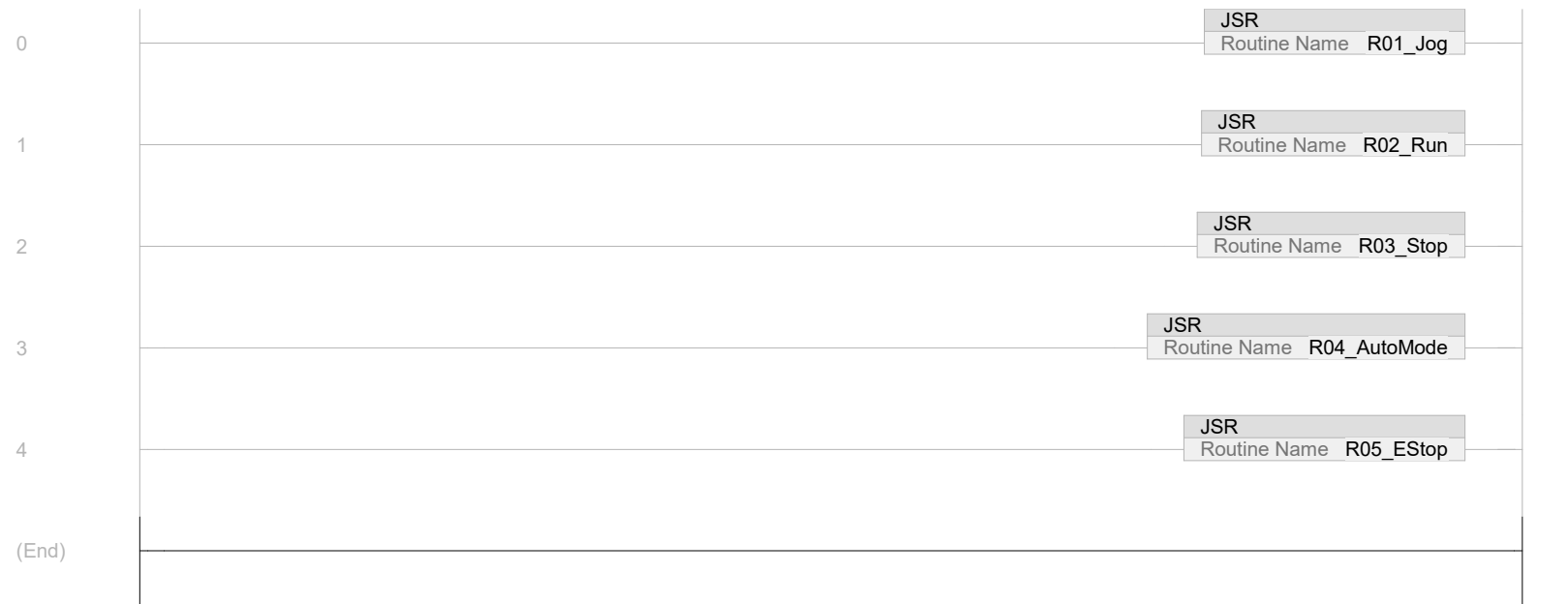














3

Axis_Jog.IP

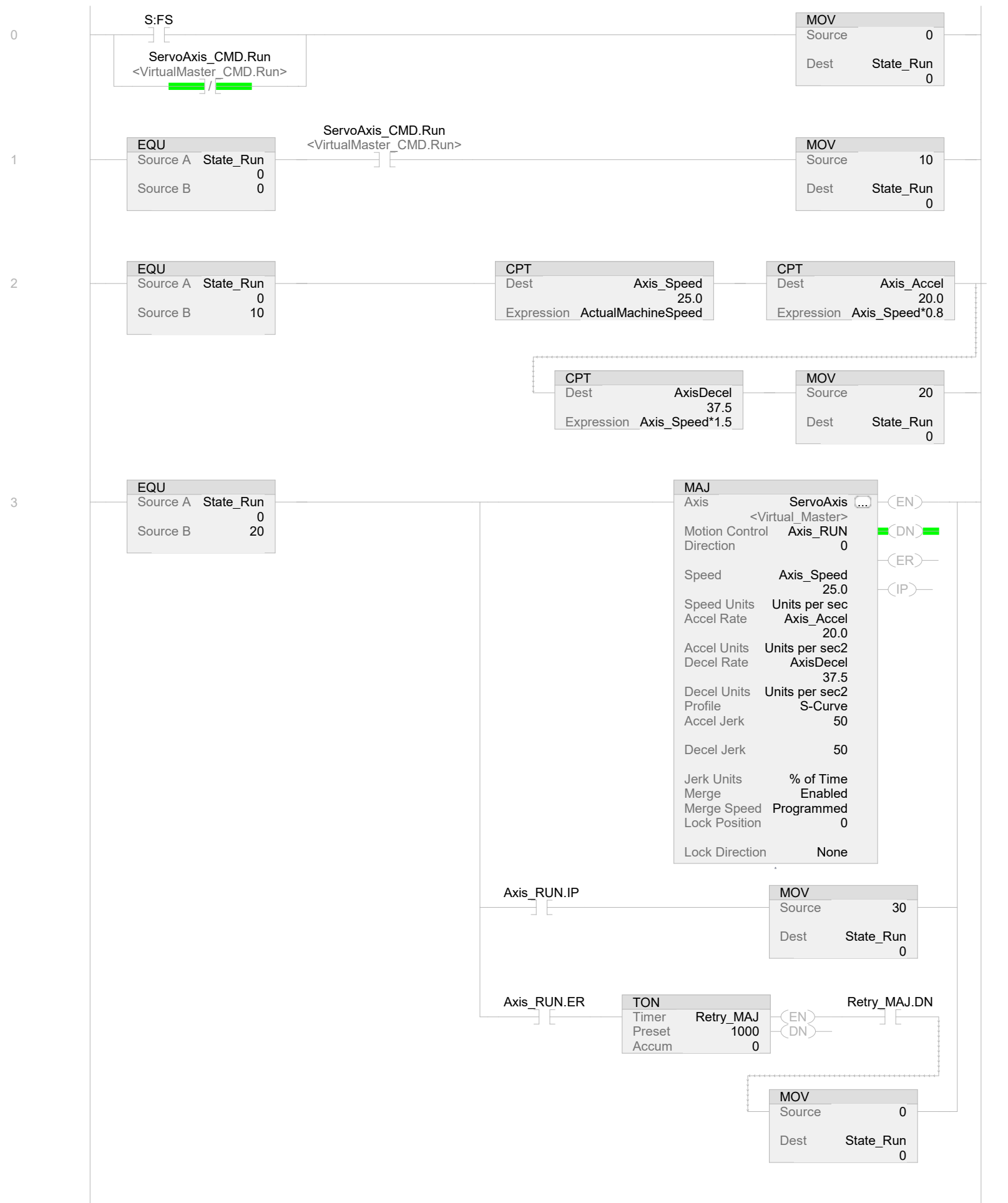
NEQ	
Source A	JogSpeed 8.0
Source B	CurrentJogSpeed 8.0

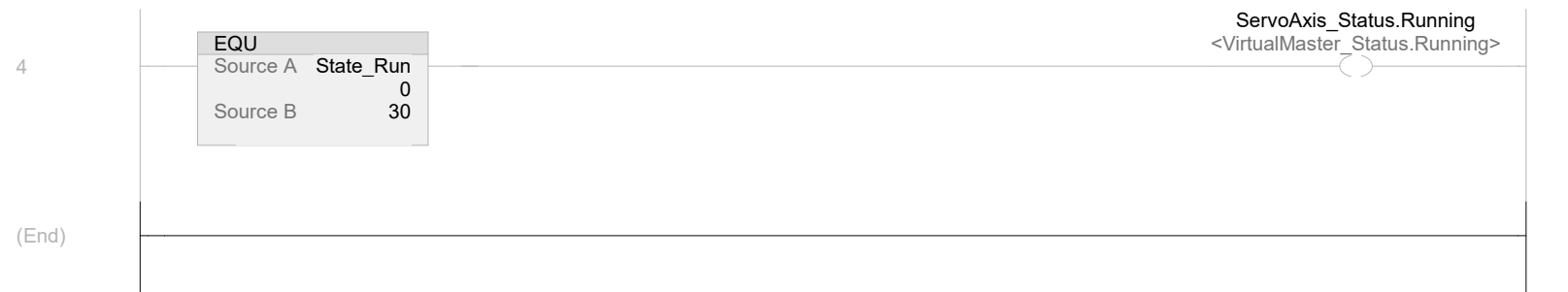
MCD	
Axis	ServoAxis
<Virtual_Master>	
Motion Control	Virtual_MCD_command
Motion Type	Jog
Change Speed	Yes
Speed	JogSpeed 8.0
Change Accel	Yes
Accel Rate	20
Change Decel	Yes
Decel Rate	20
Change Accel Jerk	Yes
Accel Jerk	100.0
Change Decel Jerk	Yes
Decel Jerk	100.0
Speed Units	Units per sec
Accel Units	Units per sec2
Decel Units	Units per sec2
Jerk Units	% of Maximum

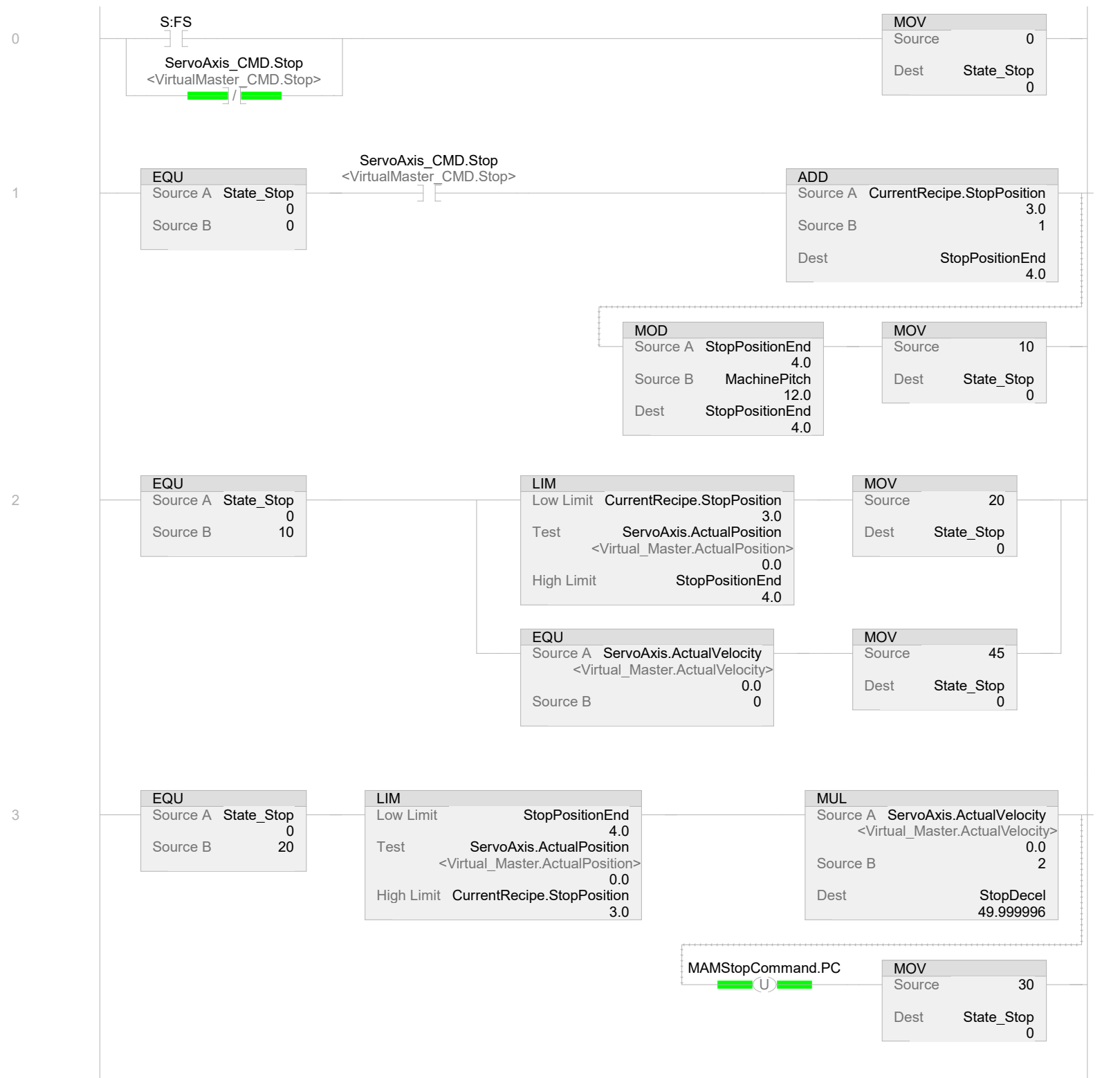
(EN)
(DN)
(ER)

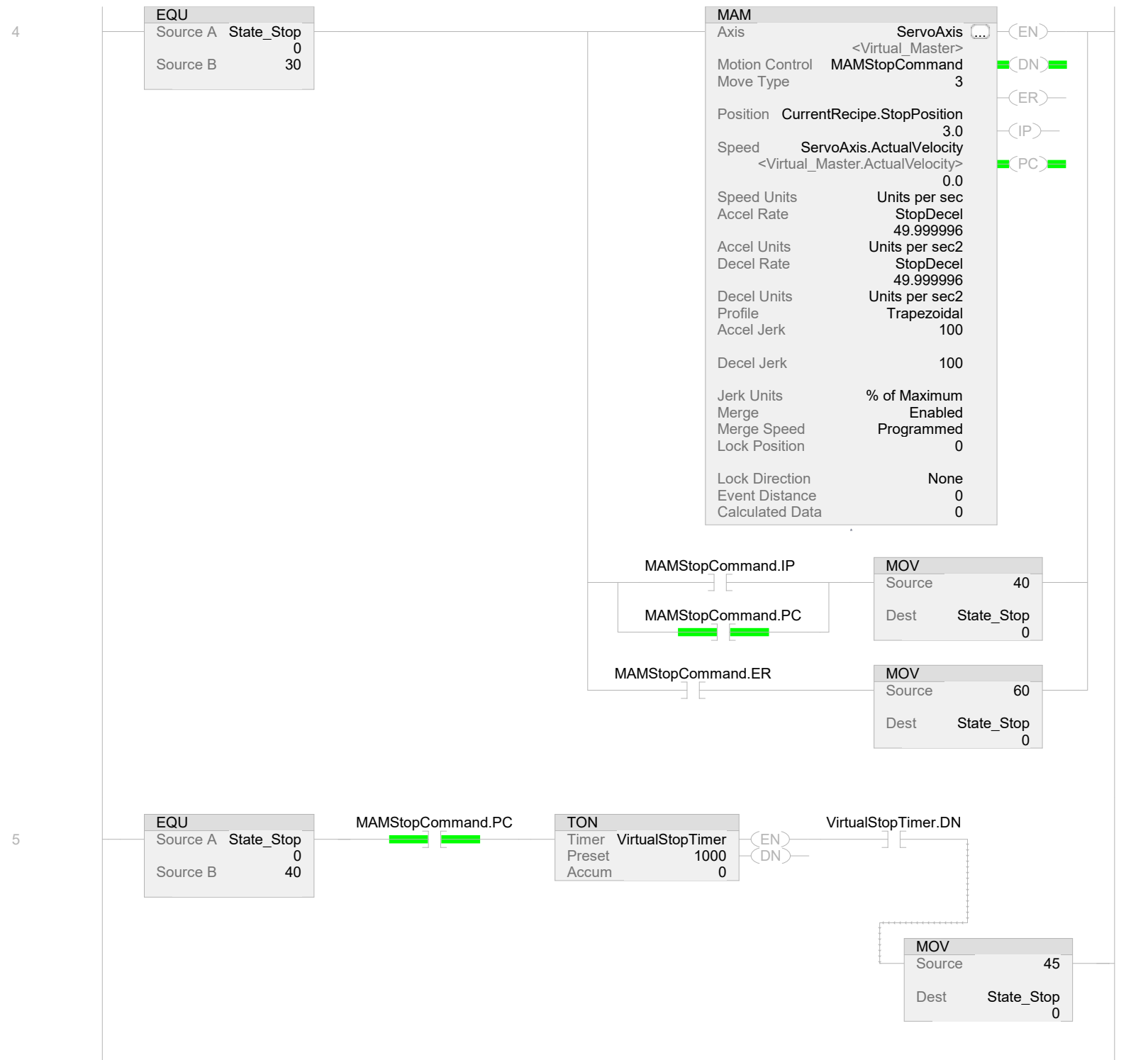
MOV	
Source	JogSpeed 8.0
Dest	CurrentJogSpeed 8.0

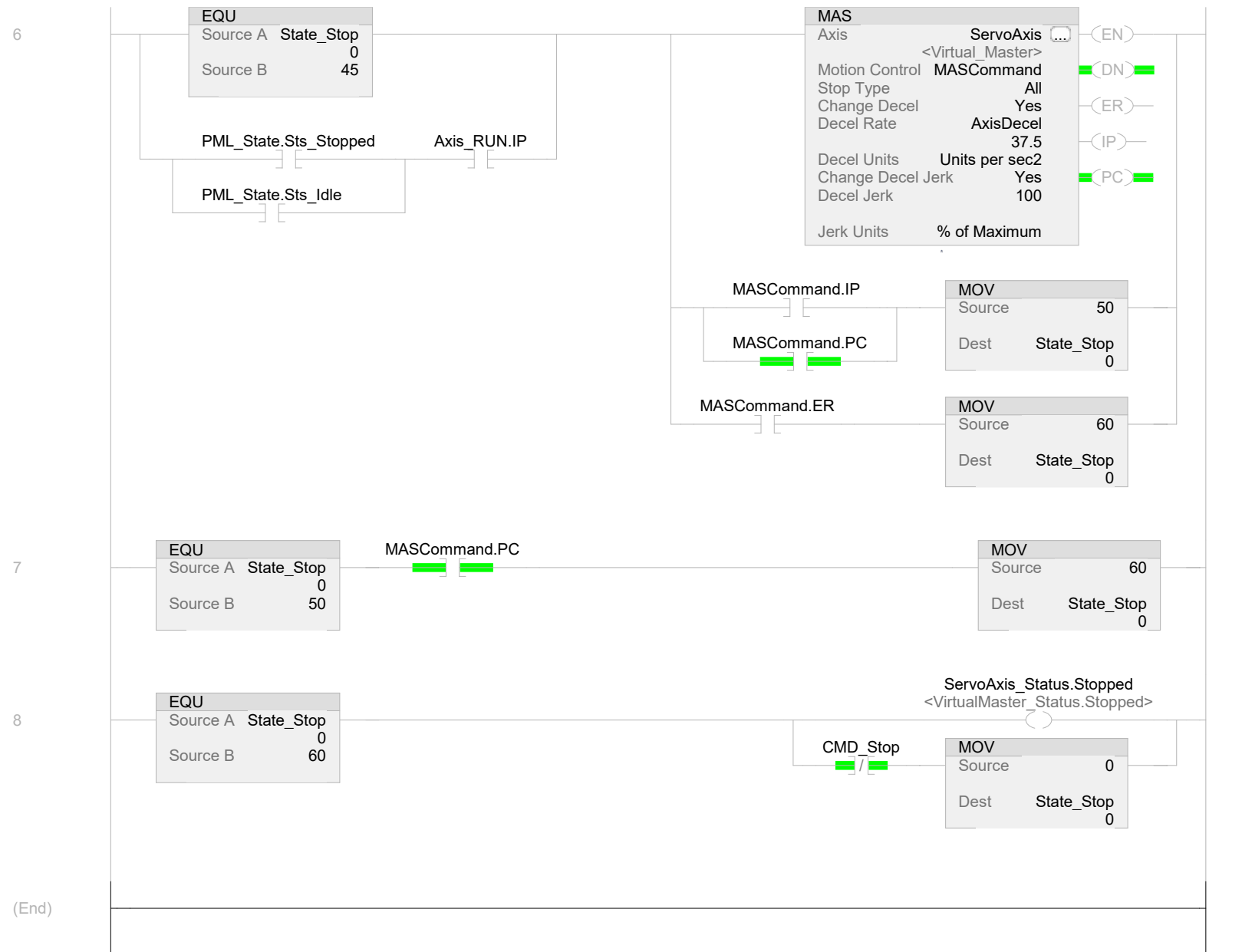
(End)

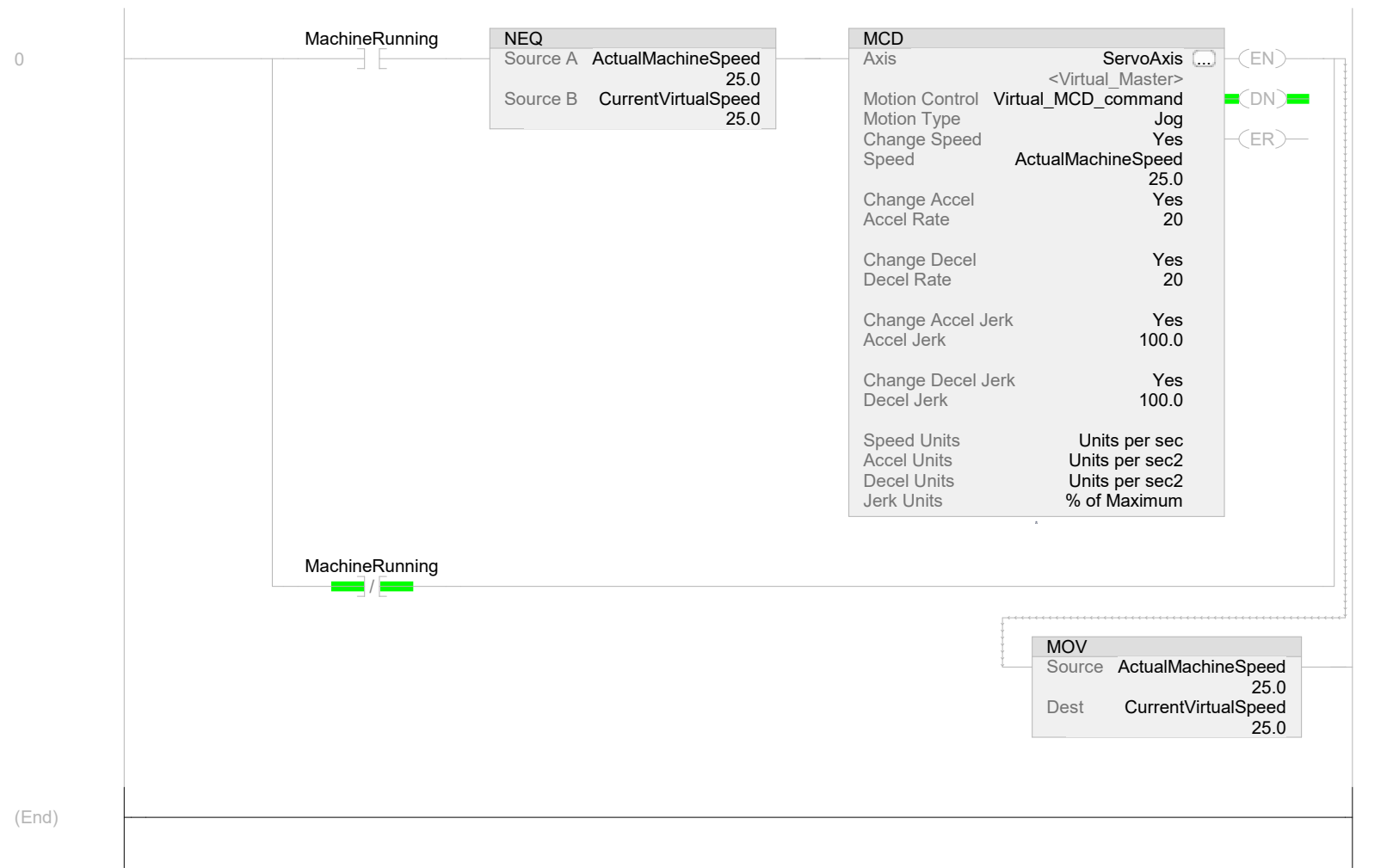


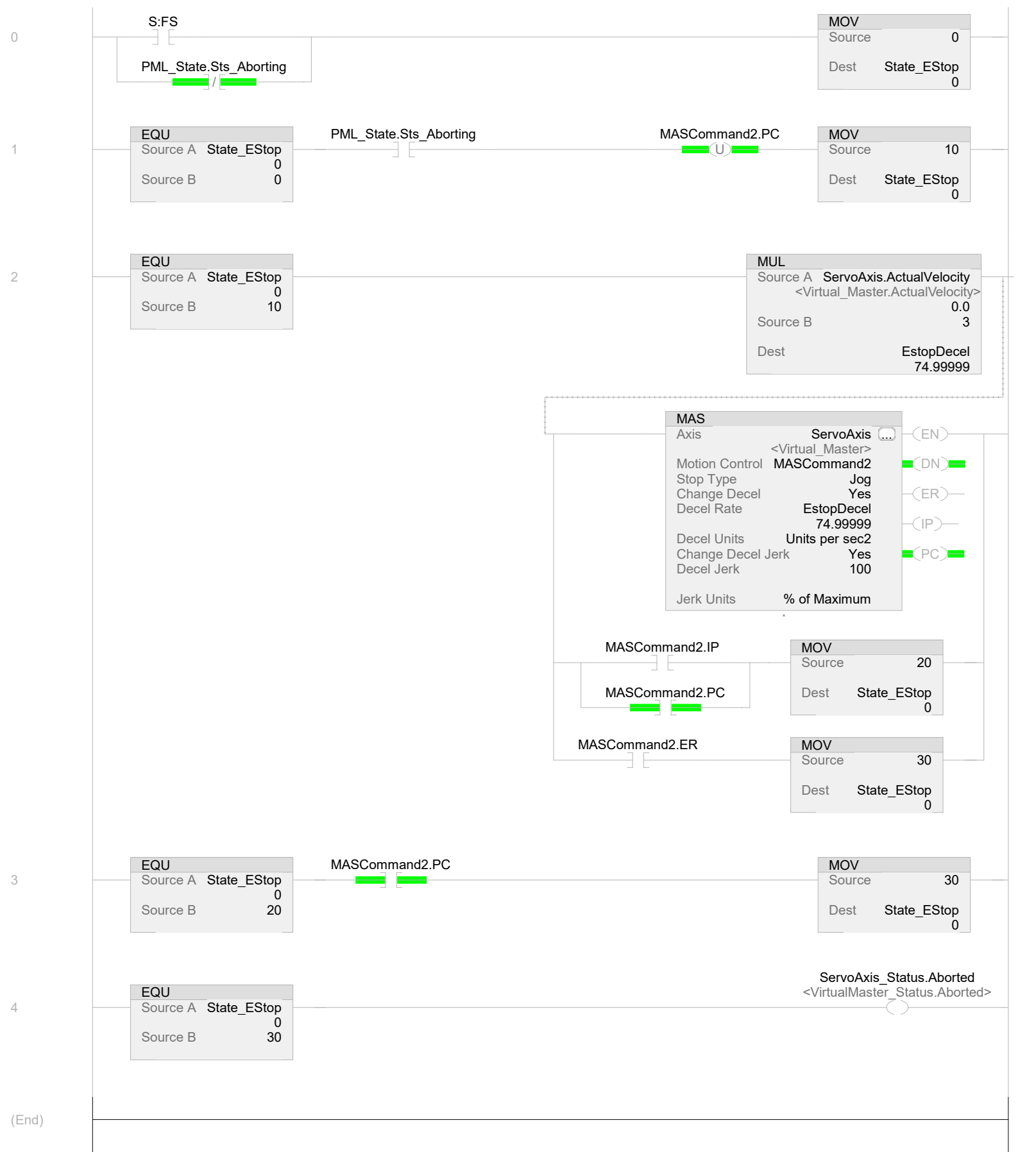


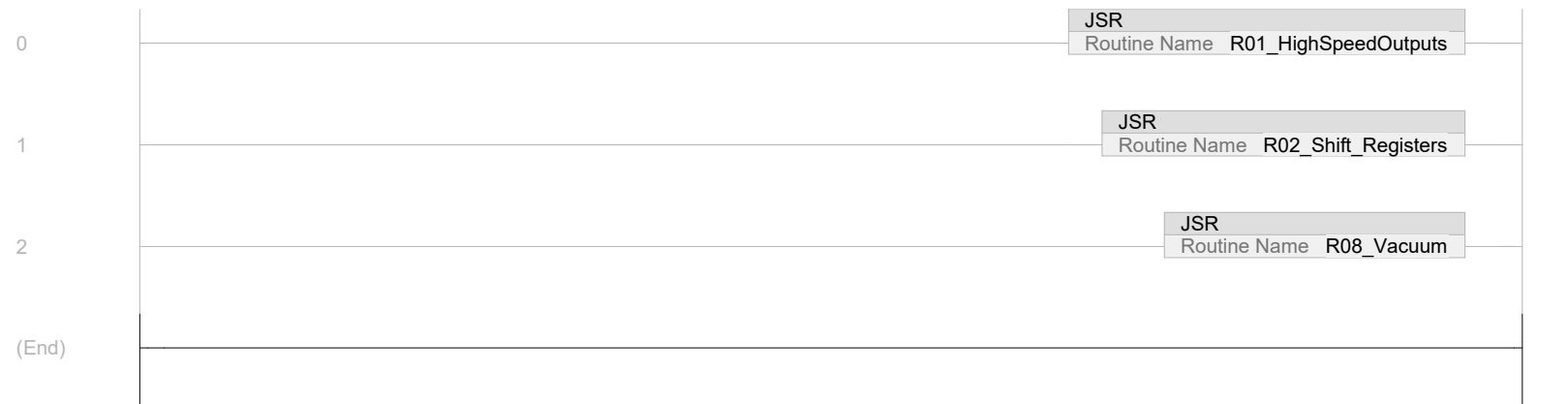


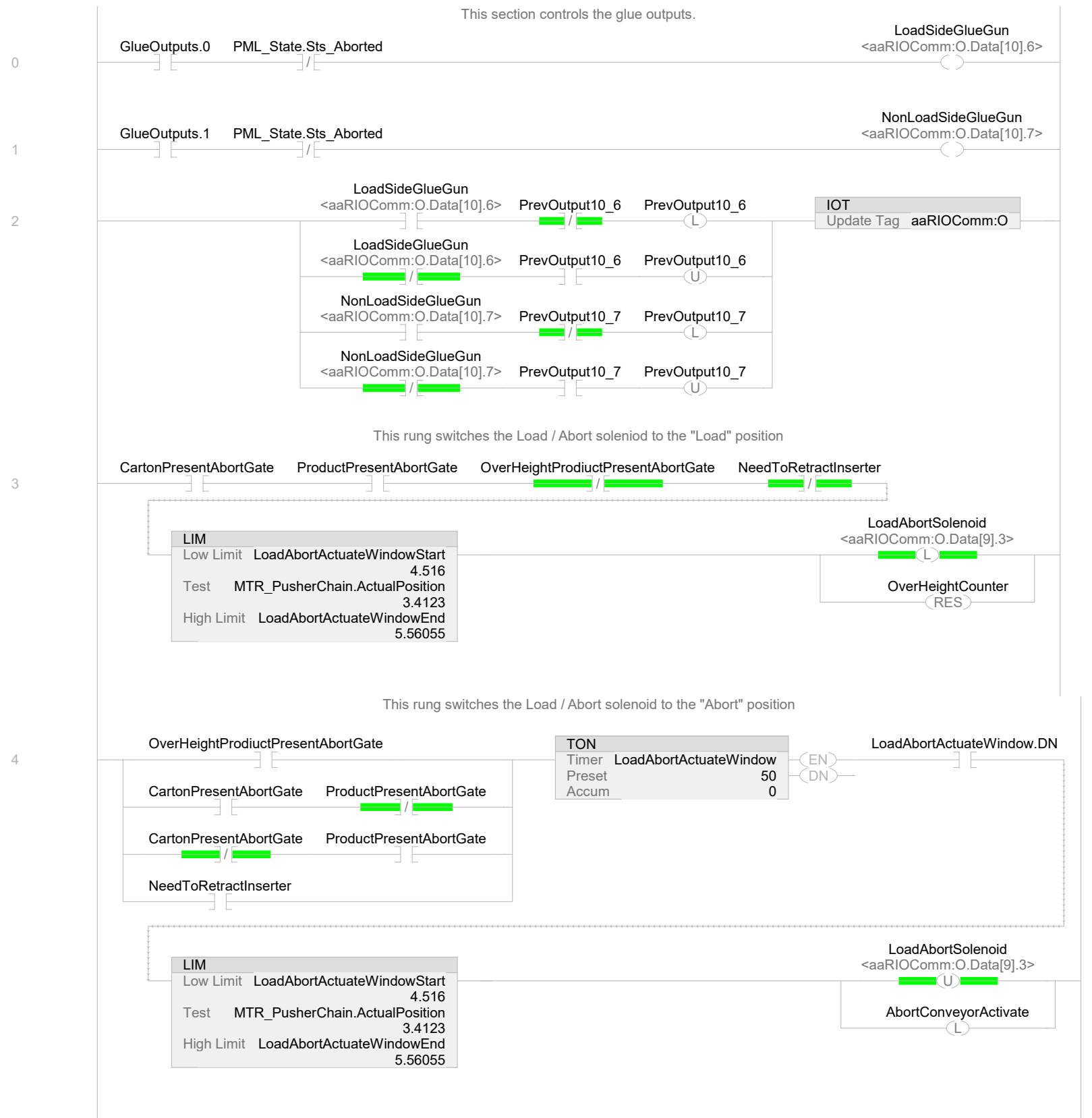


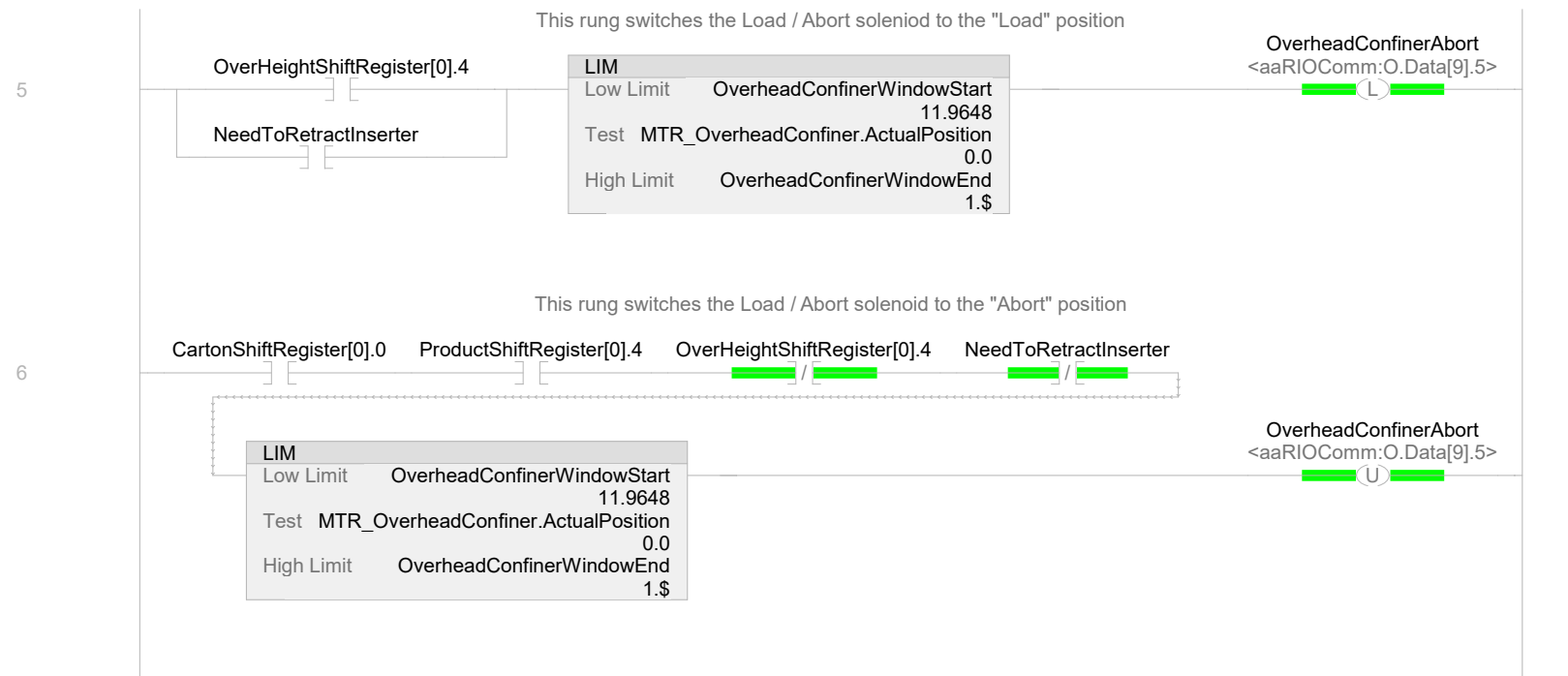


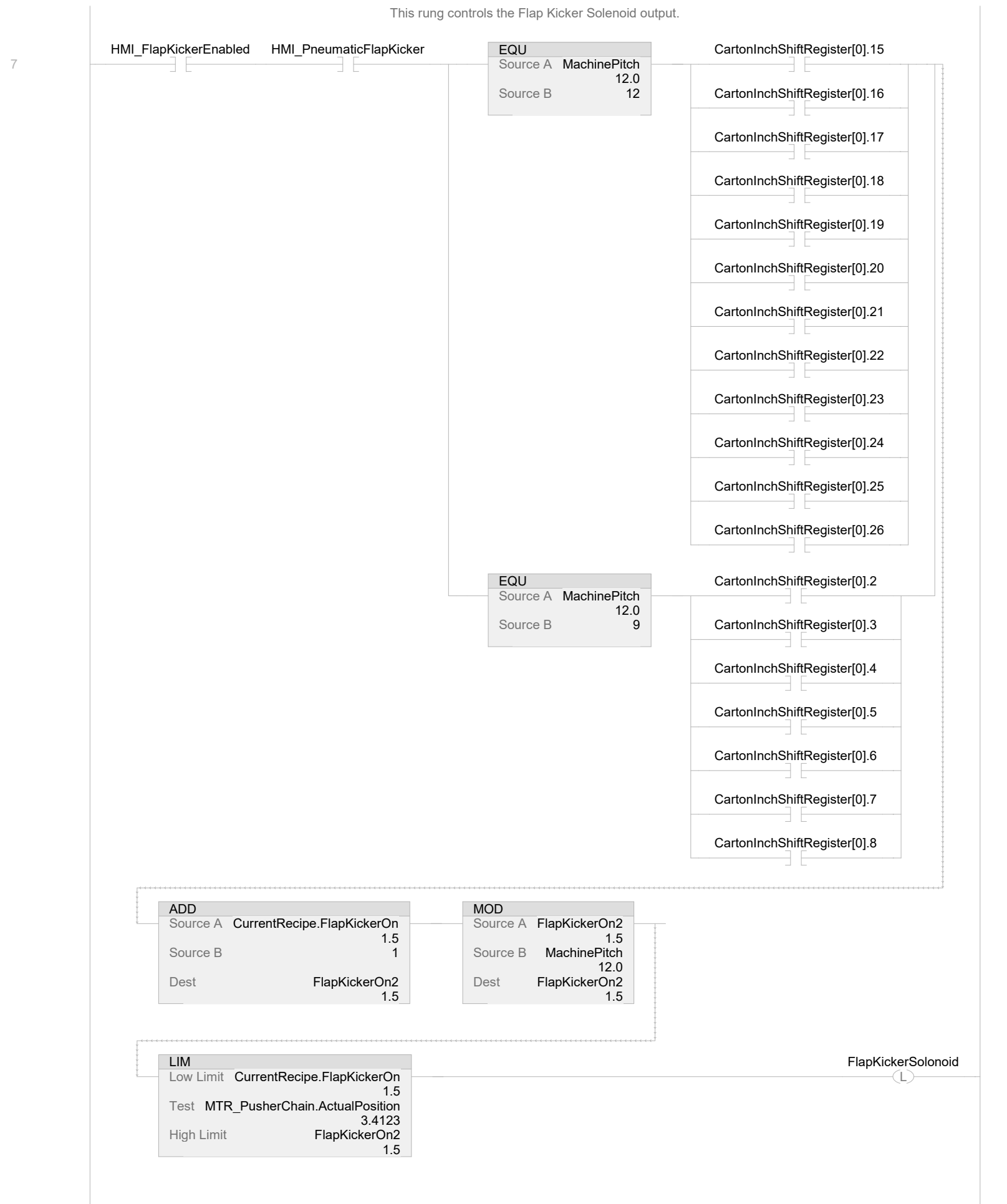


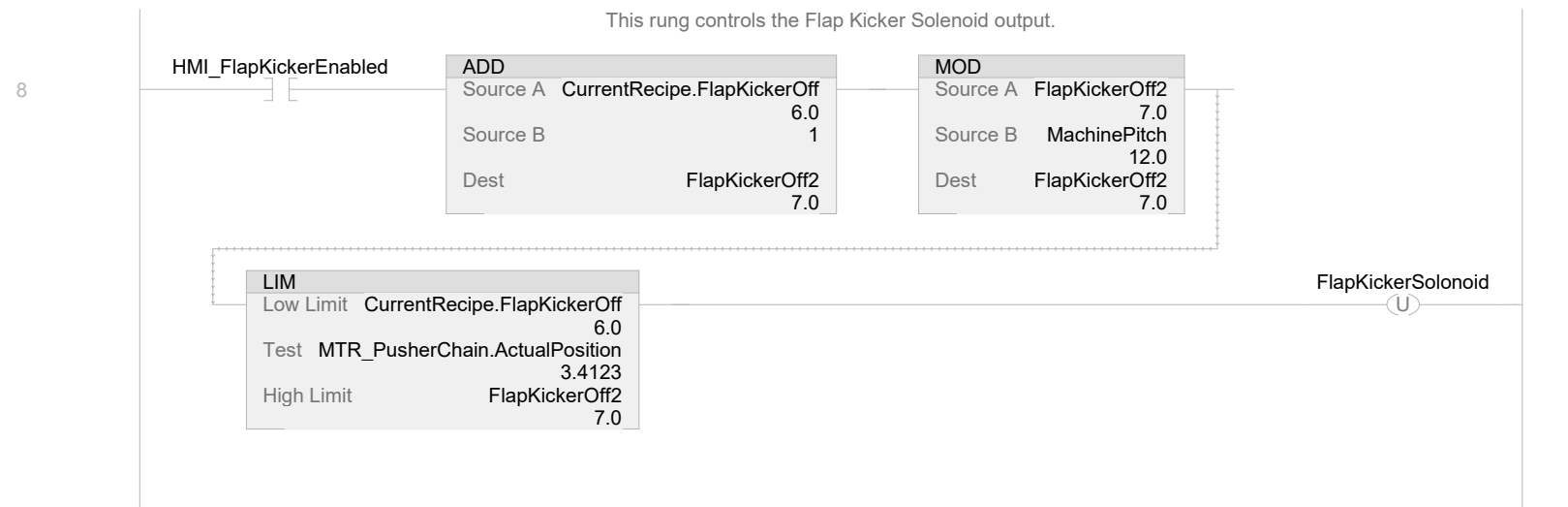






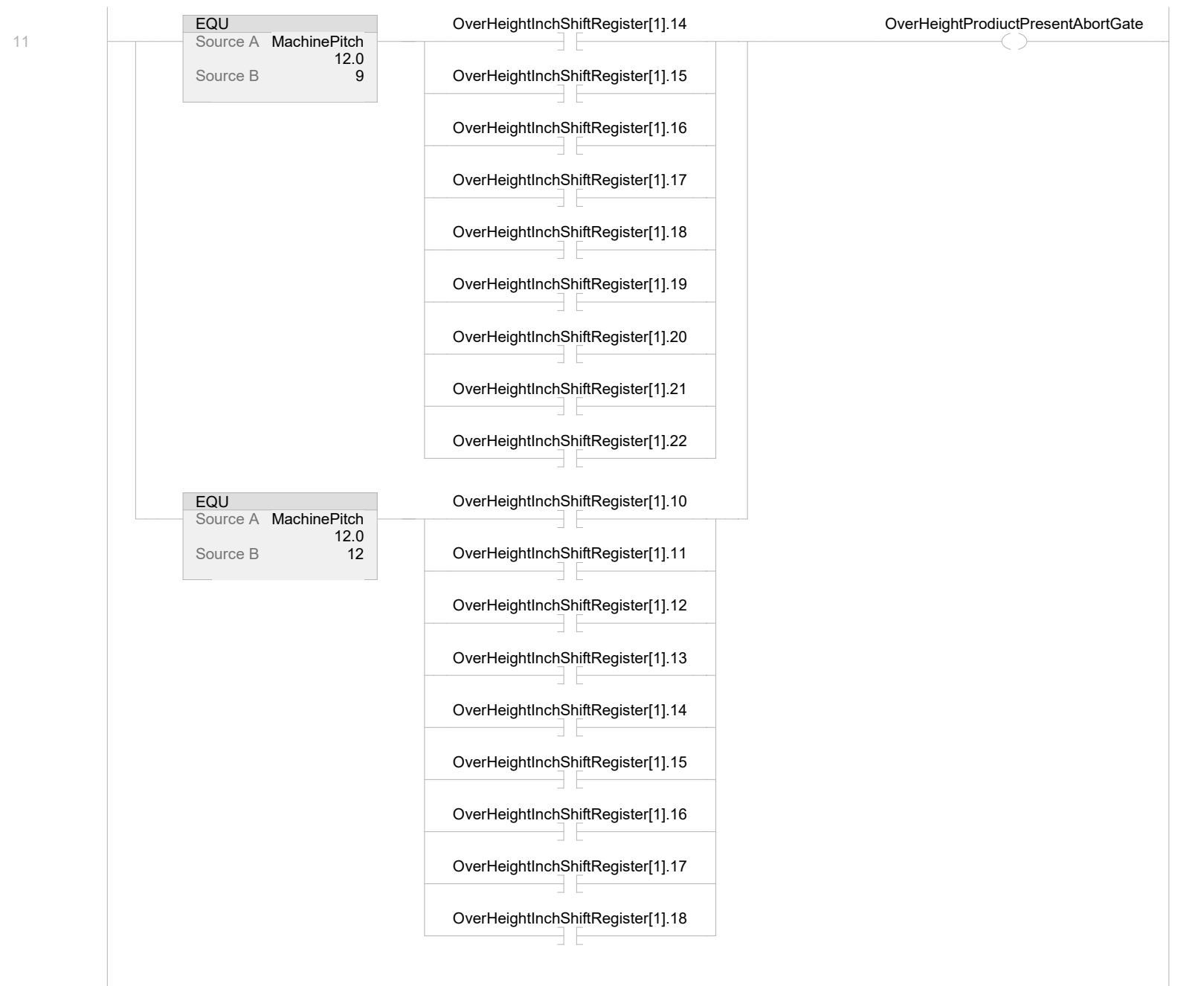




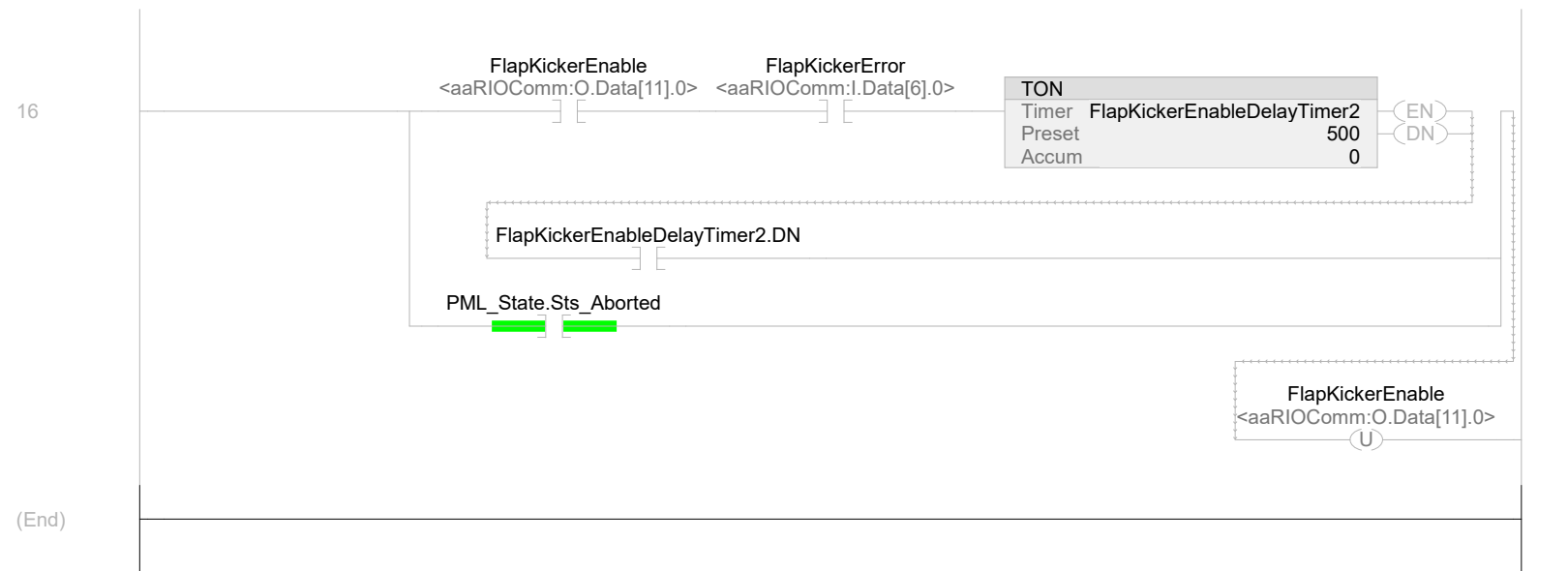


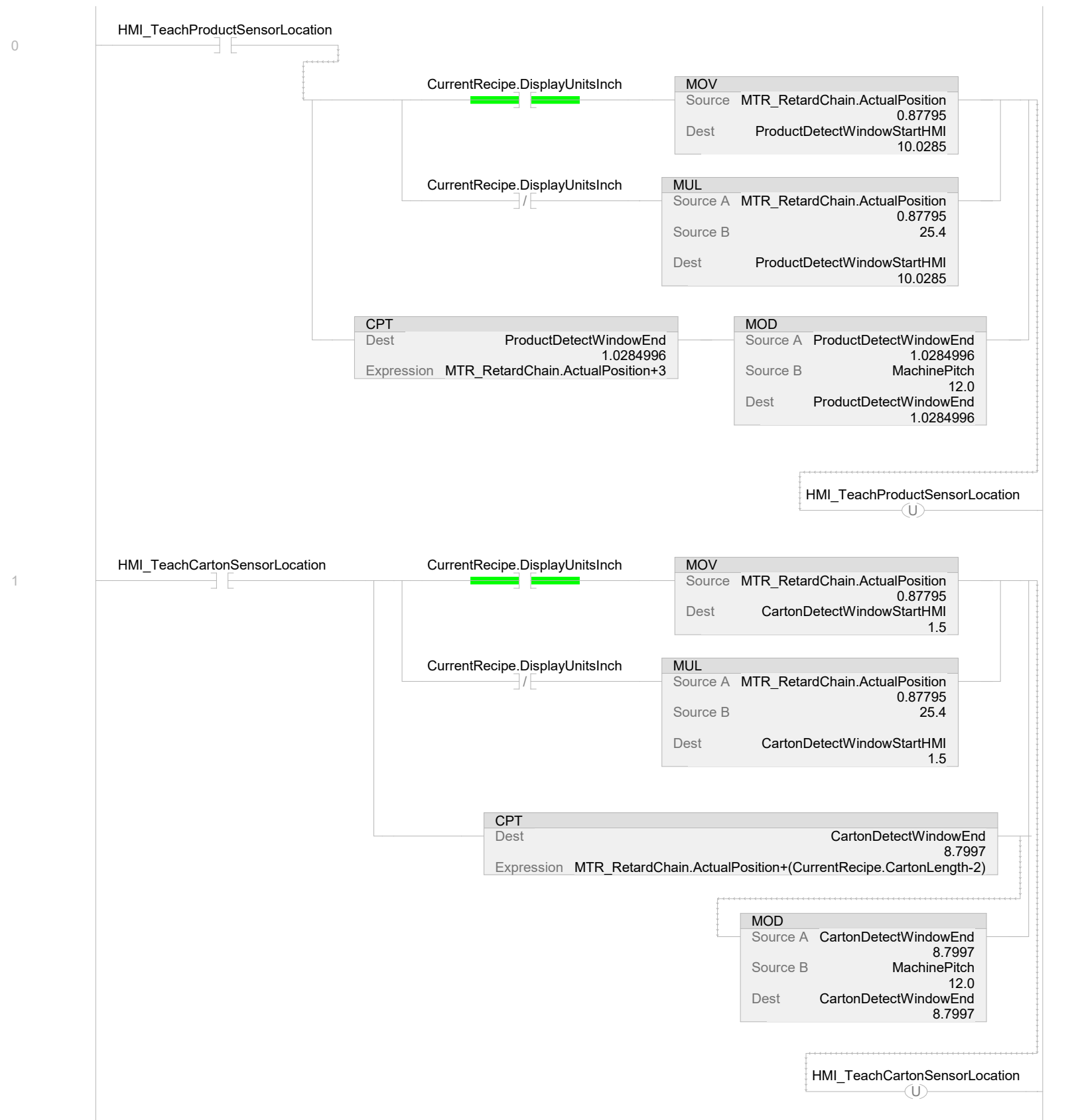


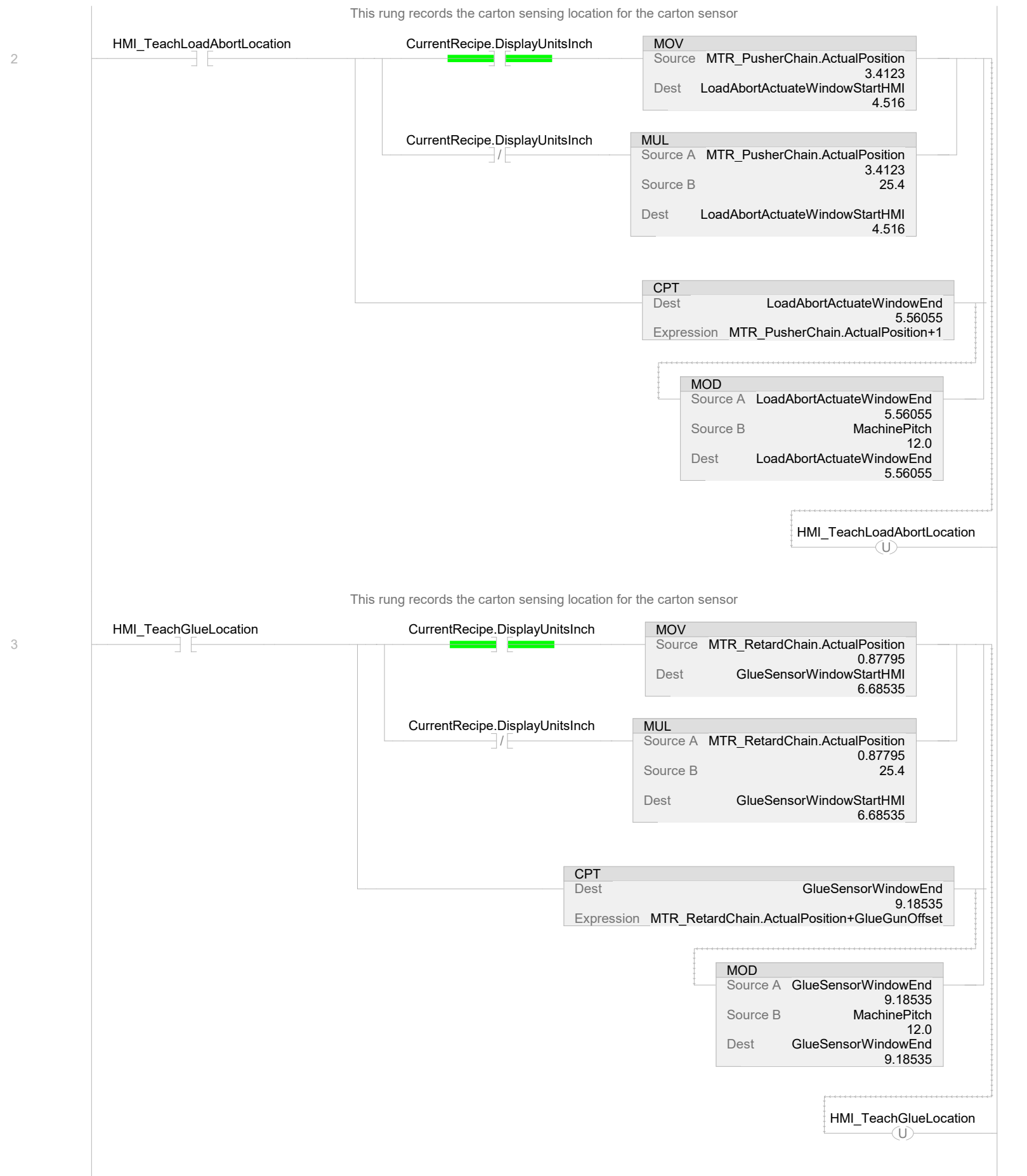


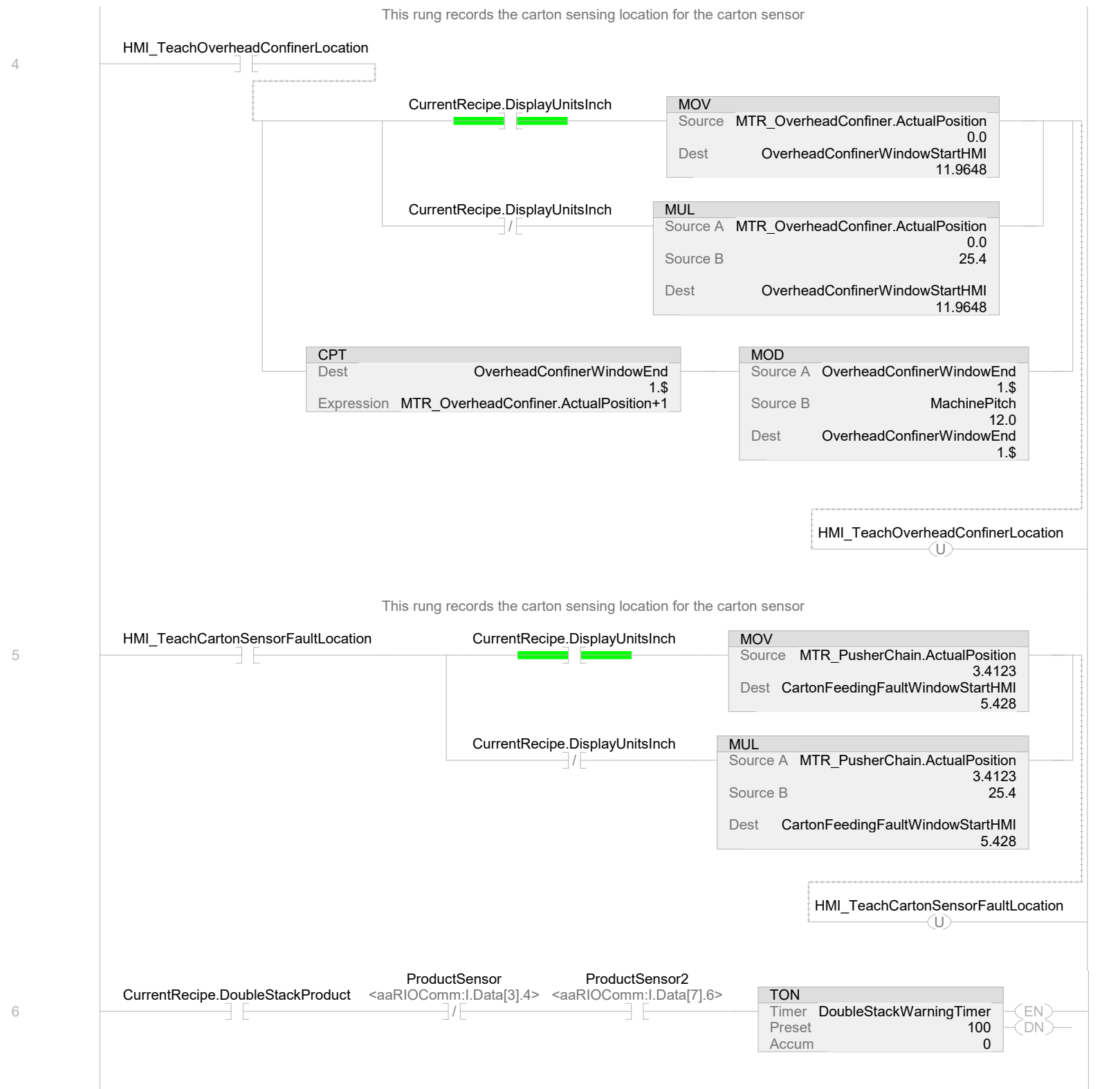






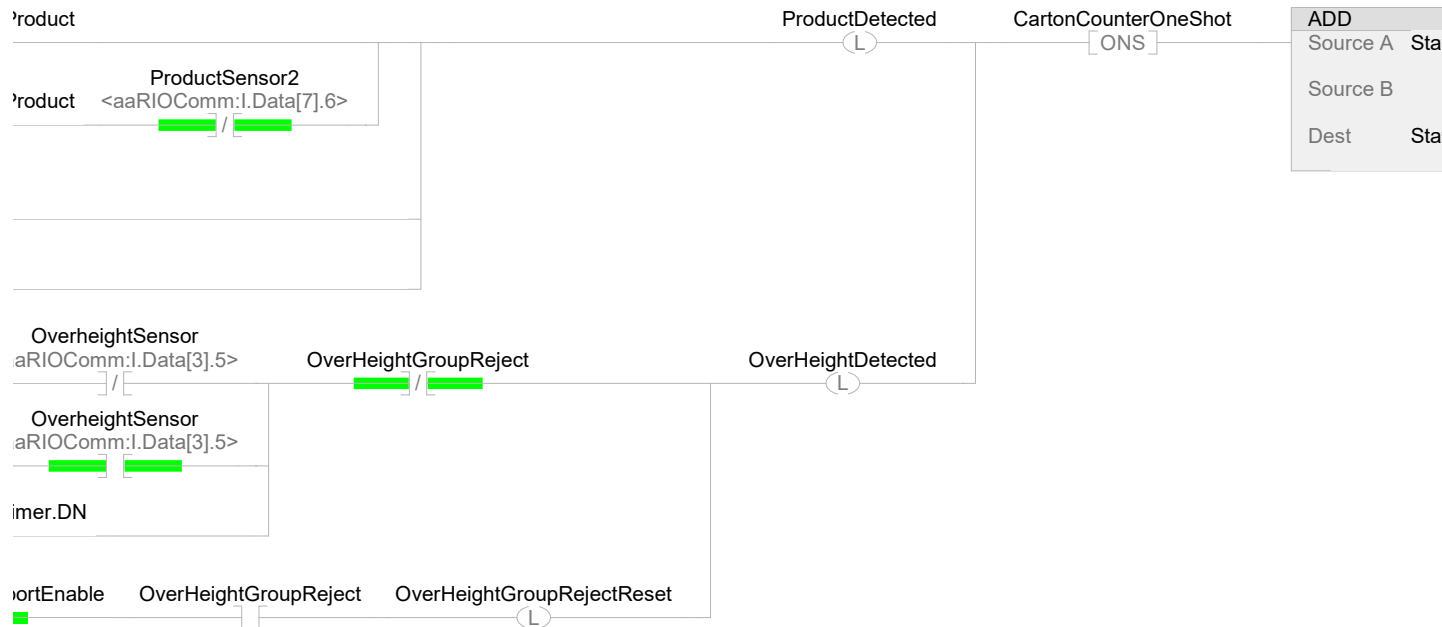






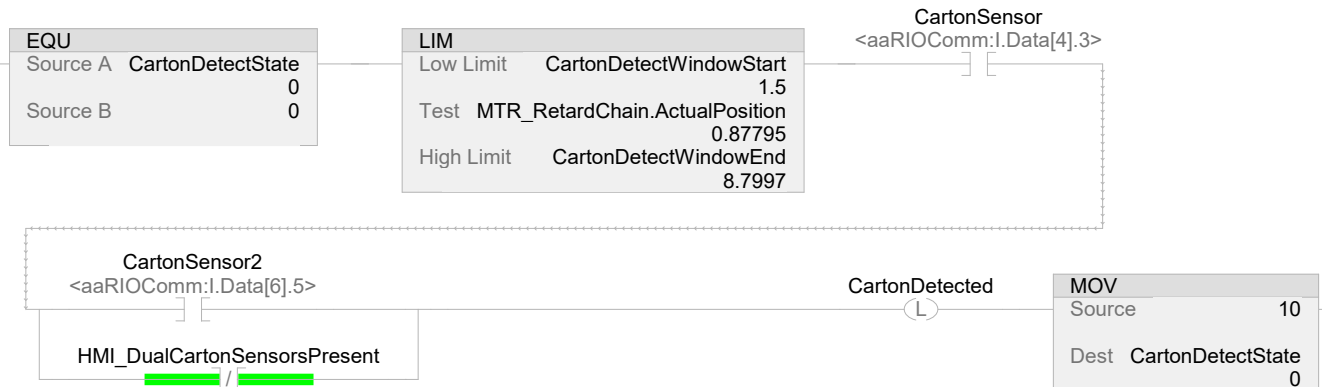


test tag and / or the Overheight Detect tag if a product is seen inside of the position window.



.CartonsIn		ADD	
0		Source A	TotalCartonsProcessed
1			19782551
		Source B	1
.CartonsIn		Dest	TotalCartonsProcessed
0			19782551

This rung sets the Carton Detect tag if a product is seen inside of the position window.



This rung sets the Carton Detect tag if a product is seen inside of the position window.

9

EQU	
Source A	CartonDetectState
Source B	0
	10

LIM	
Low Limit	CartonDetectWindowStart 1.5
Test	MTR_RetardChain.ActualPosition 0.87795
High Limit	CartonDetectWindowEnd 8.7997

CartonSensor	
<aaRIOComm:I.Data[4].3>	
HMI_DualCartonSensorsPresent	

CartonSensor2	
<aaRIOComm:I.Data[6].5>	
HMI_DualCartonSensorsPresent	

CartonDetected
(U)

LIM	
Low Limit	CartonDetectWindowEnd 8.7997
Test	MTR_RetardChain.ActualPosition 0.87795
High Limit	CartonDetectWindowStart 1.5

CartonSensor	
<aaRIOComm:I.Data[4].3>	
HMI_DualCartonSensorsPresent	

CartonSensor2	
<aaRIOComm:I.Data[6].5>	
HMI_DualCartonSensorsPresent	

MOV	
Source	0
Dest	CartonDetectState 0

10

LIM	
Low Limit	ProductDetectWindowEnd 1.0284996
Test	MTR_RetardChain.ActualPosition 0.87795
High Limit	ProductDetectWindowStart 10.0285

ShiftRegisterOneShot
(ONS)

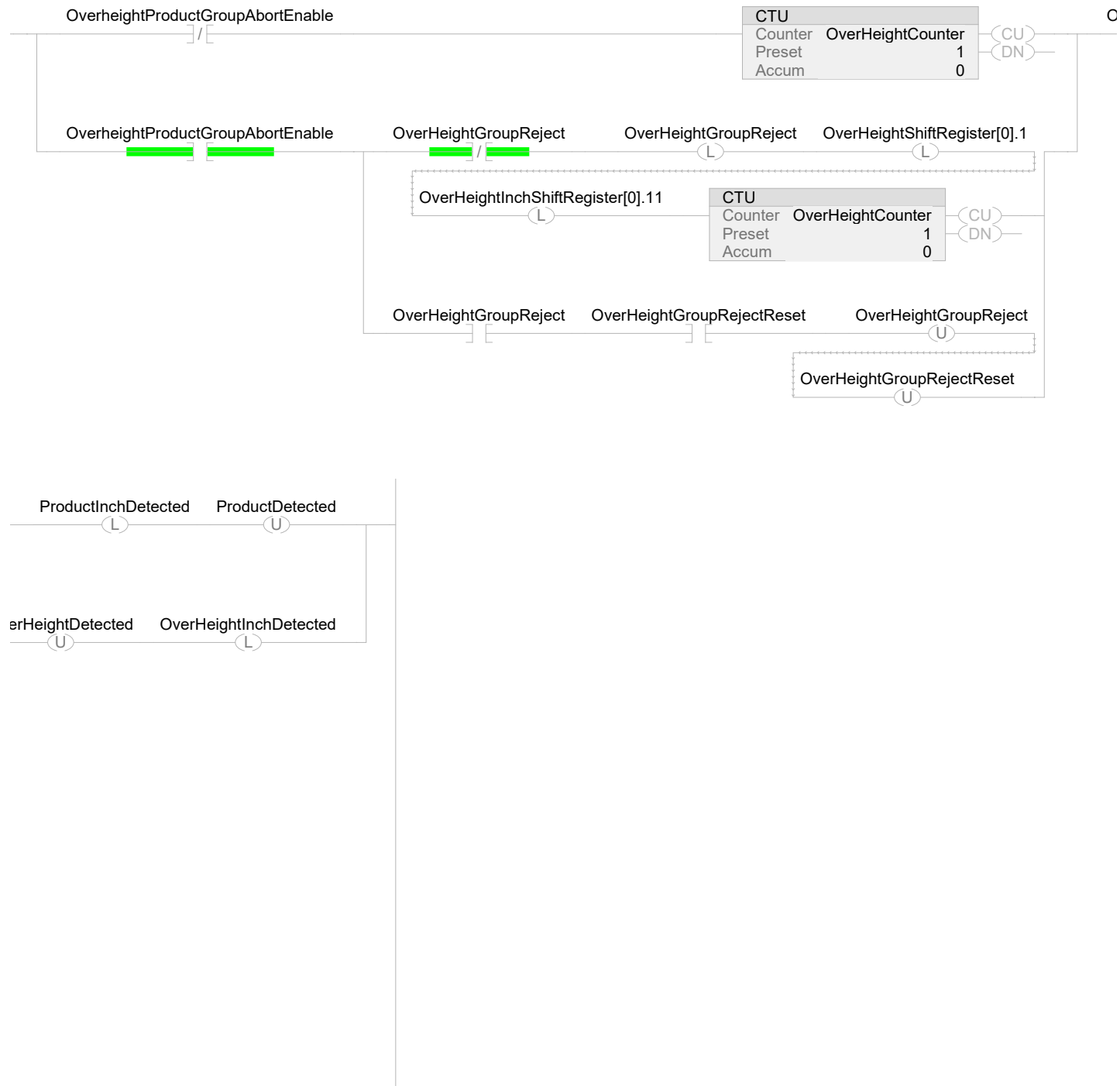
BSL	
Array	ProductShiftRegister[0]
Control	ProductShiftBSL
Source Bit	ProductDetected
Length	32

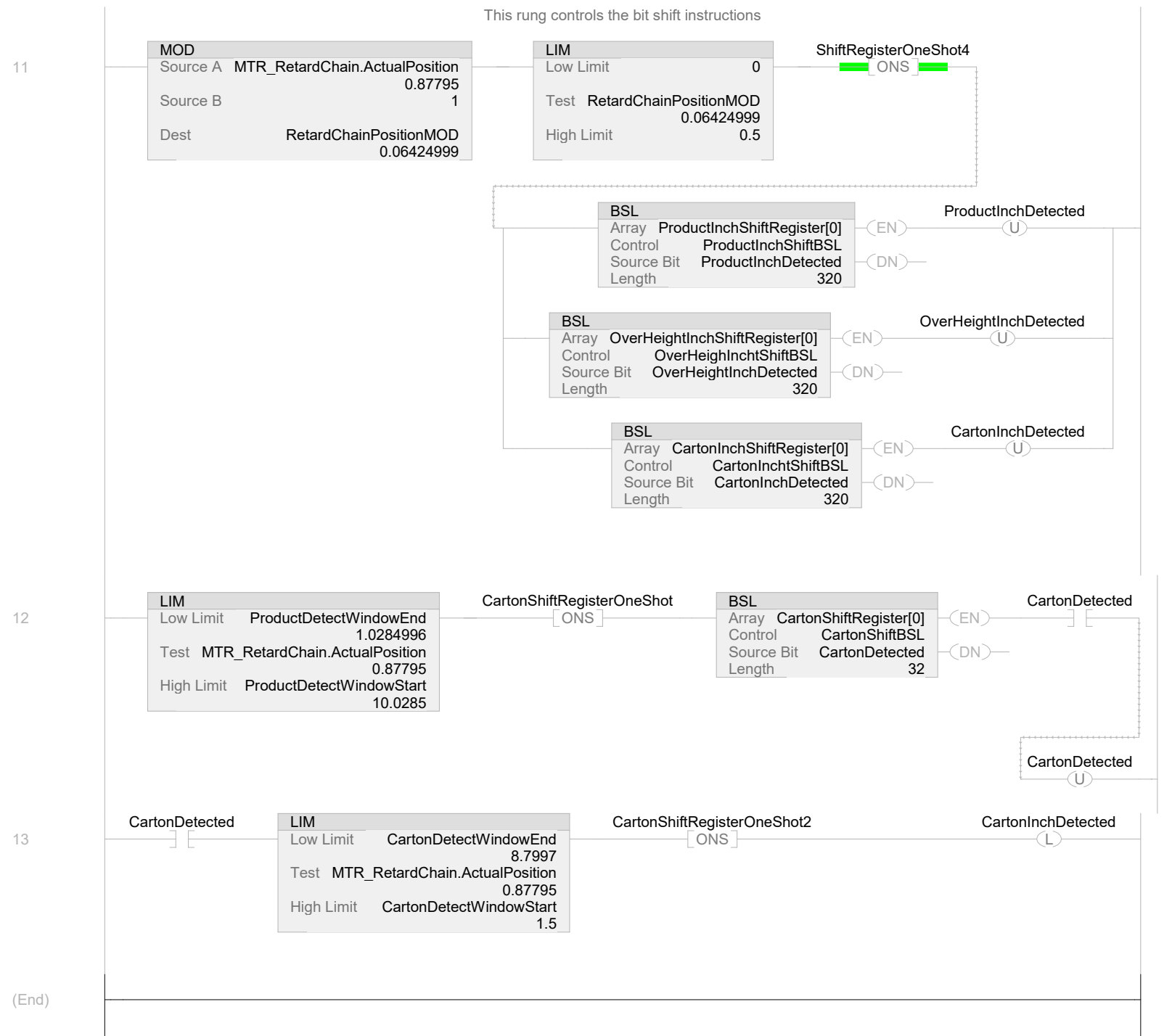
ProductDetected

BSL	
Array	OverHeightShiftRegister[0]
Control	OverHeightShiftBSL
Source Bit	OverHeightDetected
Length	32

OverHeightDetected

This rung controls the bit shift instructions





0

CPT		
Dest	FeederPosition_Degrees	106.311
Expression	360*MTR_Feeder.ActualPosition/(3*MachinePitch)	

LIM		
Low Limit		0
Test	FeederPositionMod	10.6311
High Limit		1

OnPositionCalcOneshot
[ONS]

CPT		
Dest	VacuumOnPosition	0.5
Expression	3*MachinePitch*(CurrentRecipe.FeederVacuumOnPos/360)	

MUL		
Source A	VacActuationTime_ON	0.0
Source B	MTR_Feeder.AverageVelocity	0.0
Dest	VacuumOnPositionAdjustment	0.0

SUB		
Source A	VacuumOnPosition	0.5
Source B	VacuumOnPositionAdjustment	0.0
Dest	VacuumOnPosition	0.5

MOD		
Source A	VacuumOnPosition	0.5
Source B	MachinePitch	12.0
Dest	VacuumOnPosition	0.5

ADD		
Source A	VacuumOnPosition	0.5
Source B		2
Dest	VacuumONPosition2	2.5

MOD		
Source A	VacuumONPosition2	2.5
Source B	MachinePitch	12.0
Dest	VacuumONPosition2	2.5

1

LIM		
Low Limit		0
Test	FeederPositionMod	10.6311
High Limit		1

OffPositionCalcOneshot
ONS

CPT		
Dest		VacuumOffPosition 11.882061
Expression	3*MachinePitch*(CurrentRecipe.FeederVacuumOffPos/360)	

MUL		
Source A	VacActuationTime_OFF	0.03
Source B	MTR_Feeder.AverageVelocity	0.0
Dest	VacuumOffPositionAdjustment	0.6179395

SUB		
Source A	VacuumOffPosition	11.882061
Source B	VacuumOffPositionAdjustment	0.6179395
Dest	VacuumOffPosition	11.882061

LIM		
Low Limit	MachinePitch	12.0
Test	VacuumOffPosition	11.882061
High Limit	MachinePitchX2	24.0

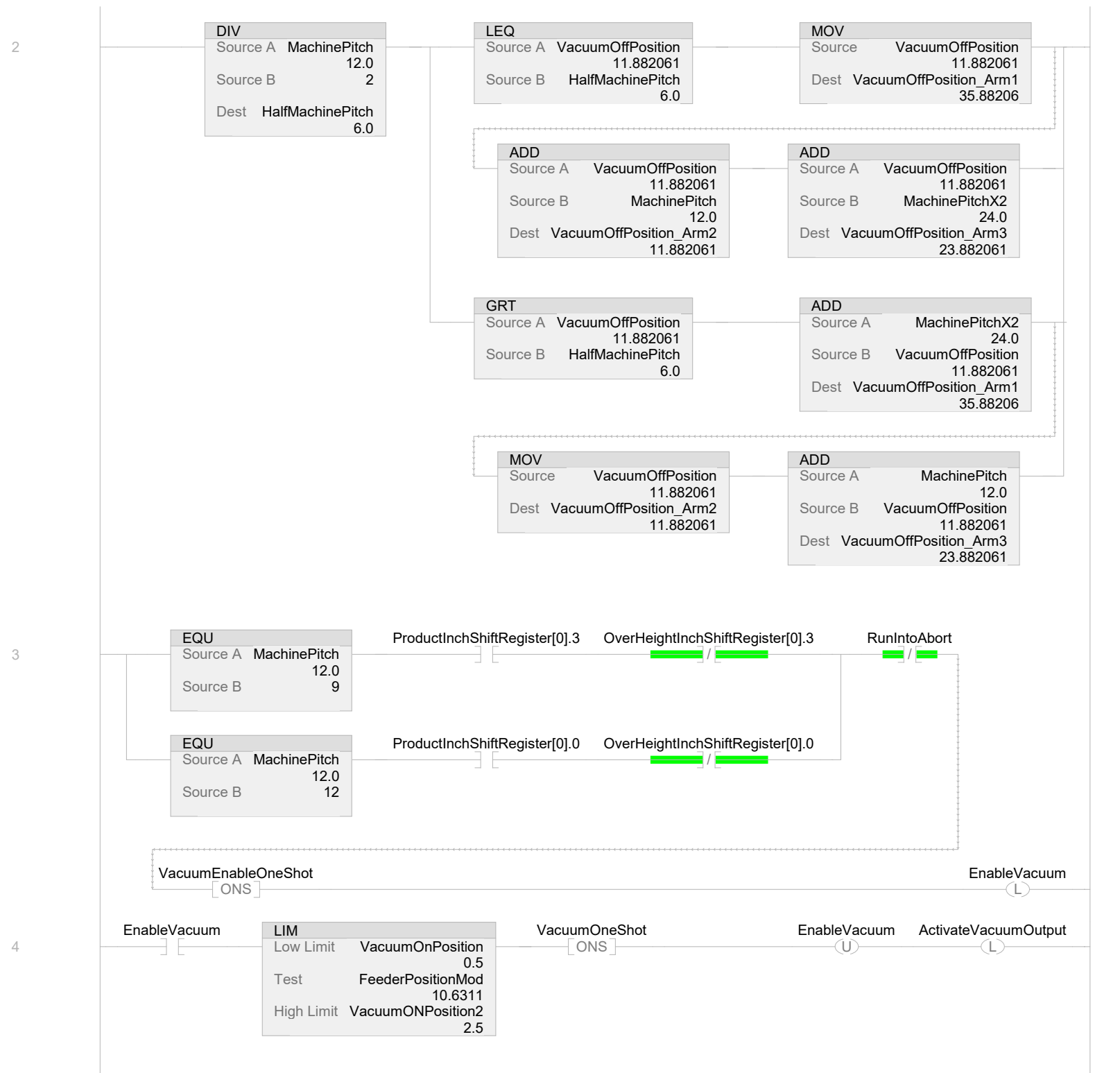
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Source A	VacuumOffPosition	11.882061
Source B	MachinePitch	12.0
Dest	VacuumOffPosition	11.882061

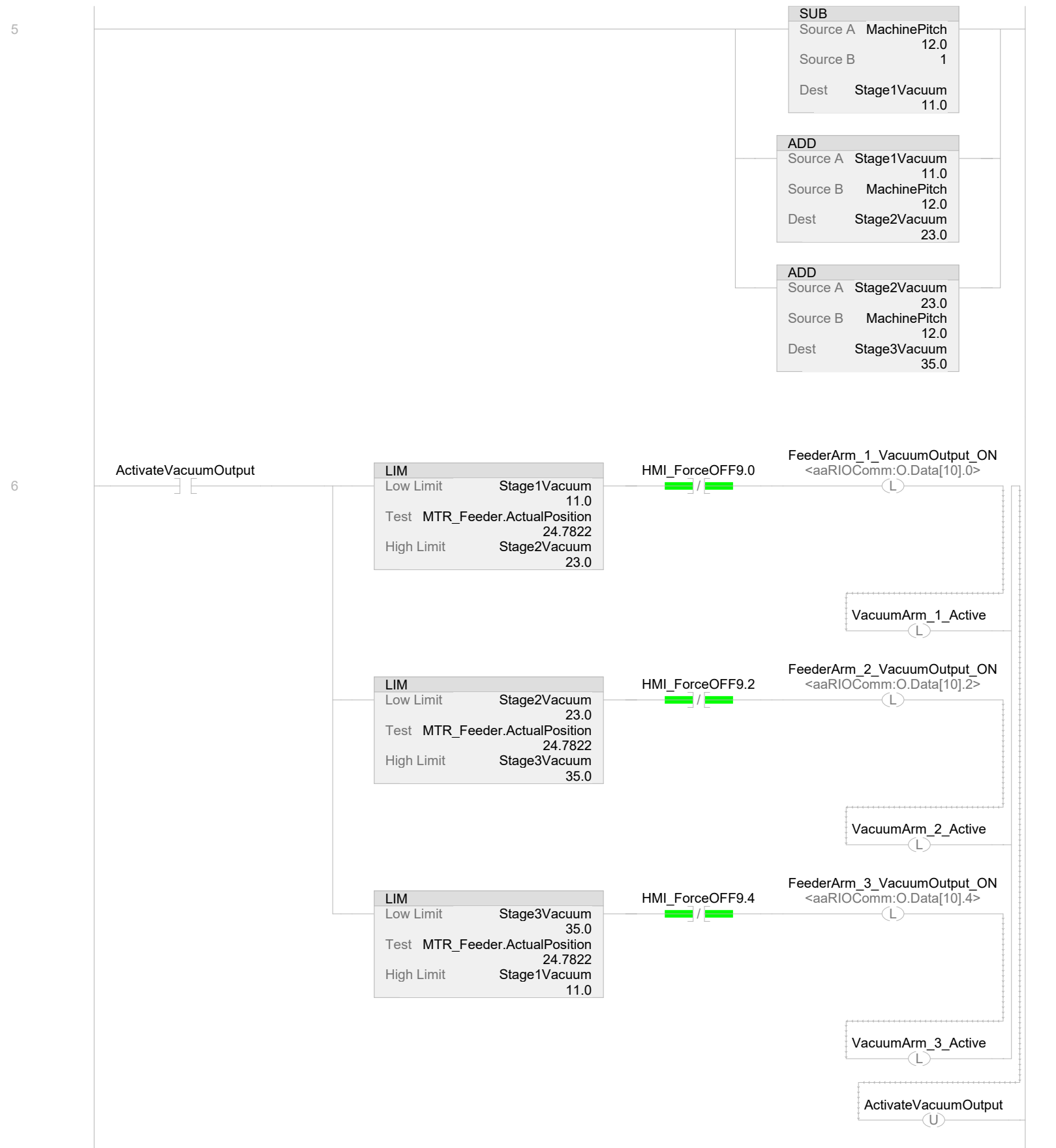
LIM		
Low Limit	MachinePitchX2	24.0
Test	VacuumOffPosition	11.882061
High Limit	MachinePitchX3	36.0

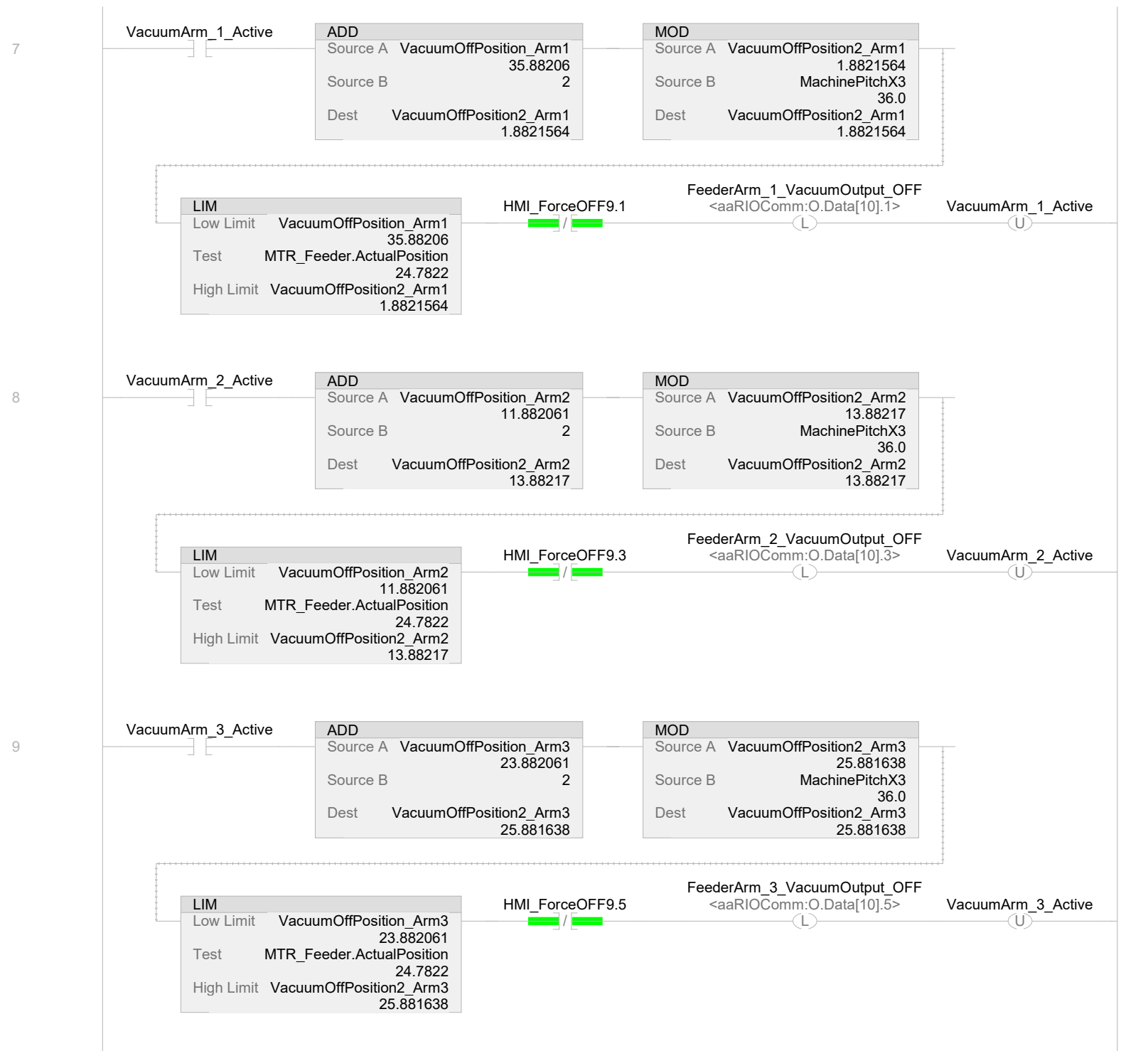
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Source A	VacuumOffPosition	11.882061
Source B	MachinePitchX2	24.0
Dest	VacuumOffPosition	11.882061

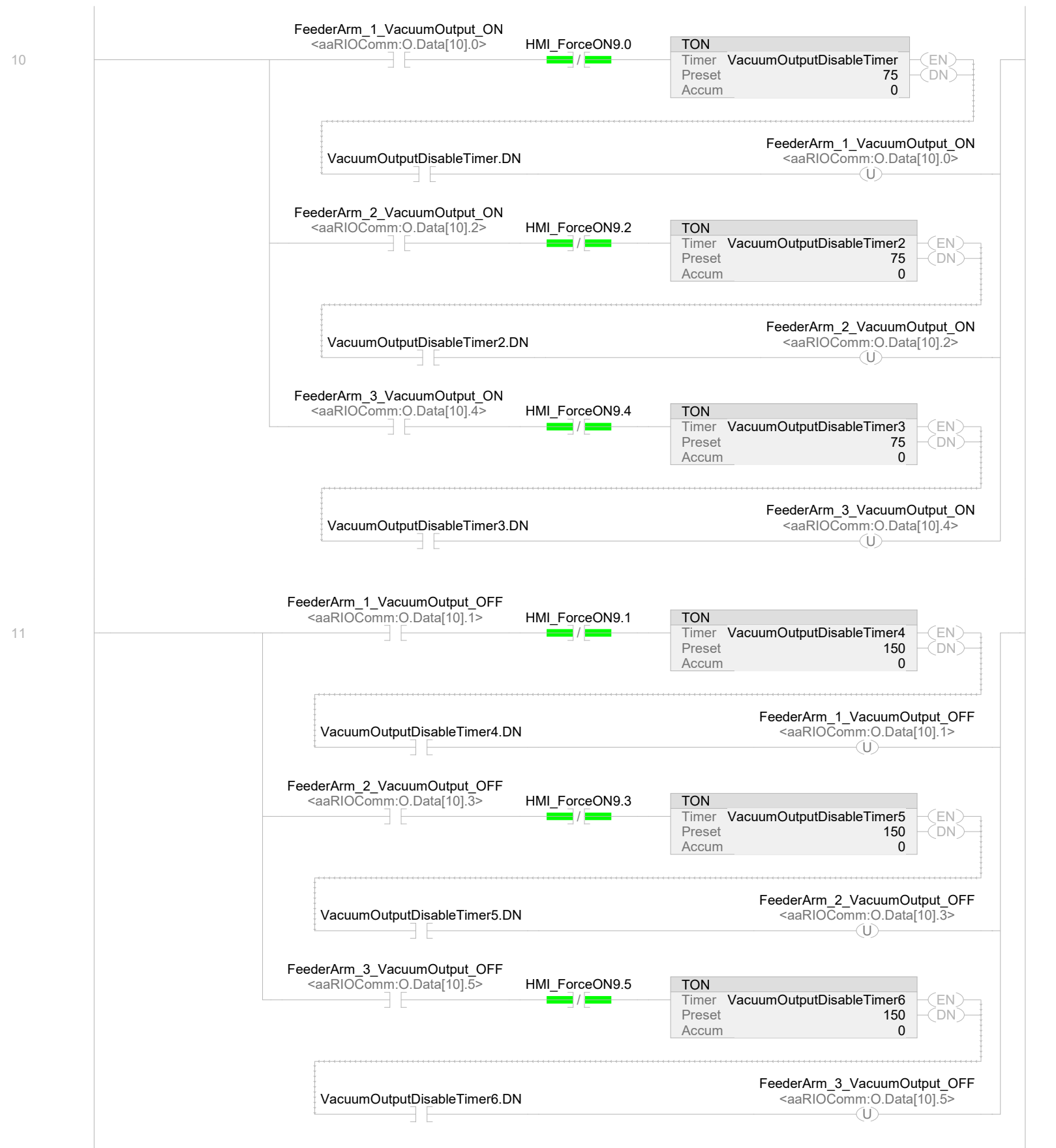
LES		
Source A	VacuumOffPosition	11.882061
Source B		0

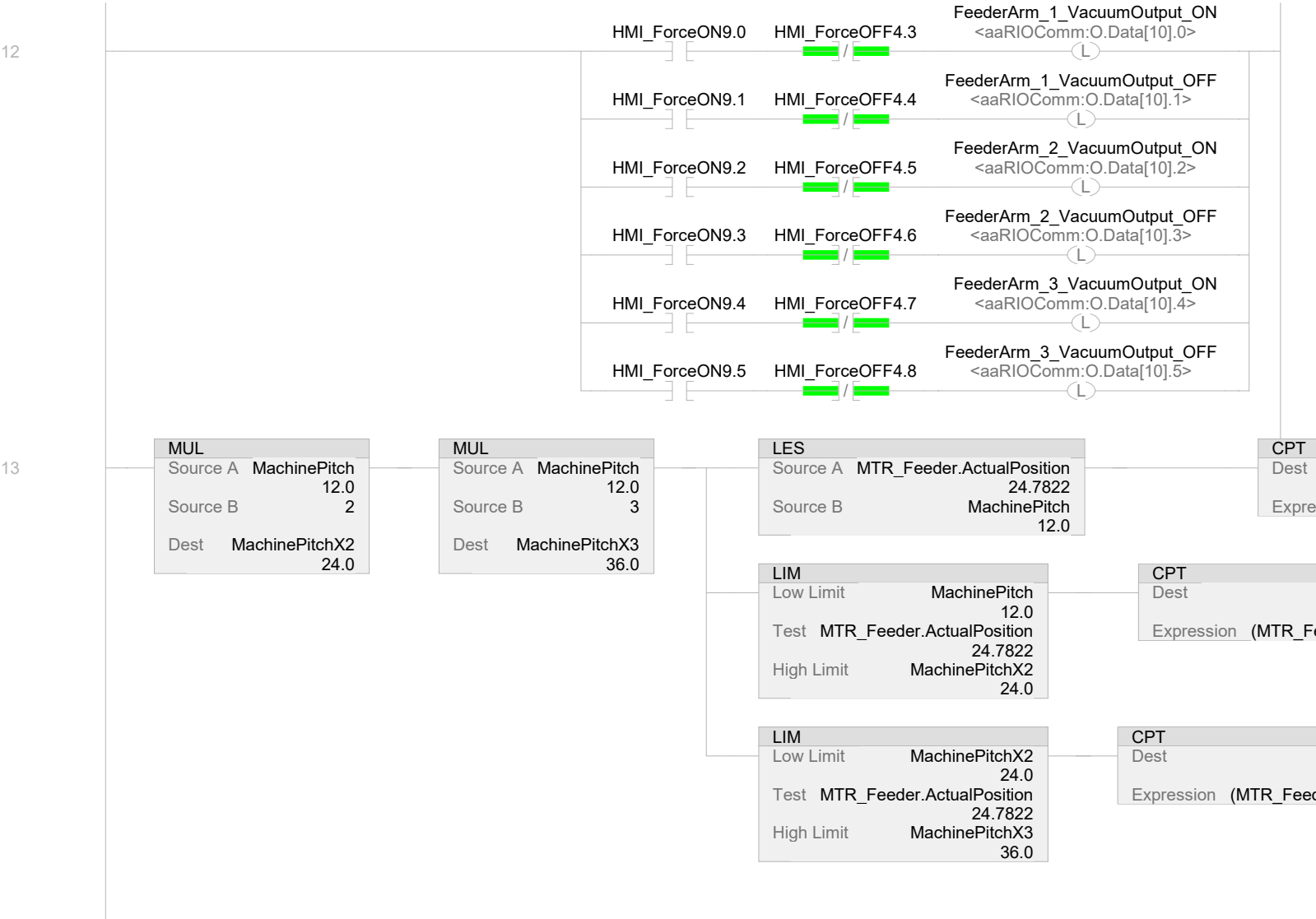
ADD		
Source A	MachinePitch	12.0
Source B	VacuumOffPosition	11.882061
Dest	VacuumOffPosition	11.882061











14

(End)

FeederPositionDegrees_HMI
106.311
sion MTR_Feeder.ActualPosition/MachinePitch*120

FeederPositionDegrees_HMI
106.311
der.ActualPosition-MachinePitch)/MachinePitch*120

FeederPositionDegrees_HMI
106.311
r.ActualPosition-MachinePitchX2)/MachinePitch*120

MUL
Source A MachinePitch
12.0
Source B 2
Dest MachinePitchX2
24.0

MUL
Source A MachinePitch
12.0
Source B 3
Dest MachinePitchX3
36.0

LES
Source A MTR_Feeder.ActualPosition
24.7822
Source B MachinePitch
12.0

CPT
Dest FeederPositionMod
10.6311
Expression MTR_Feeder.ActualPosition

LIM
Low Limit MachinePitch
12.0
Test MTR_Feeder.ActualPosition
24.7822
High Limit MachinePitchX2
24.0

CPT
Dest FeederPositionMod
10.6311
Expression MTR_Feeder.ActualPosition-MachinePitch

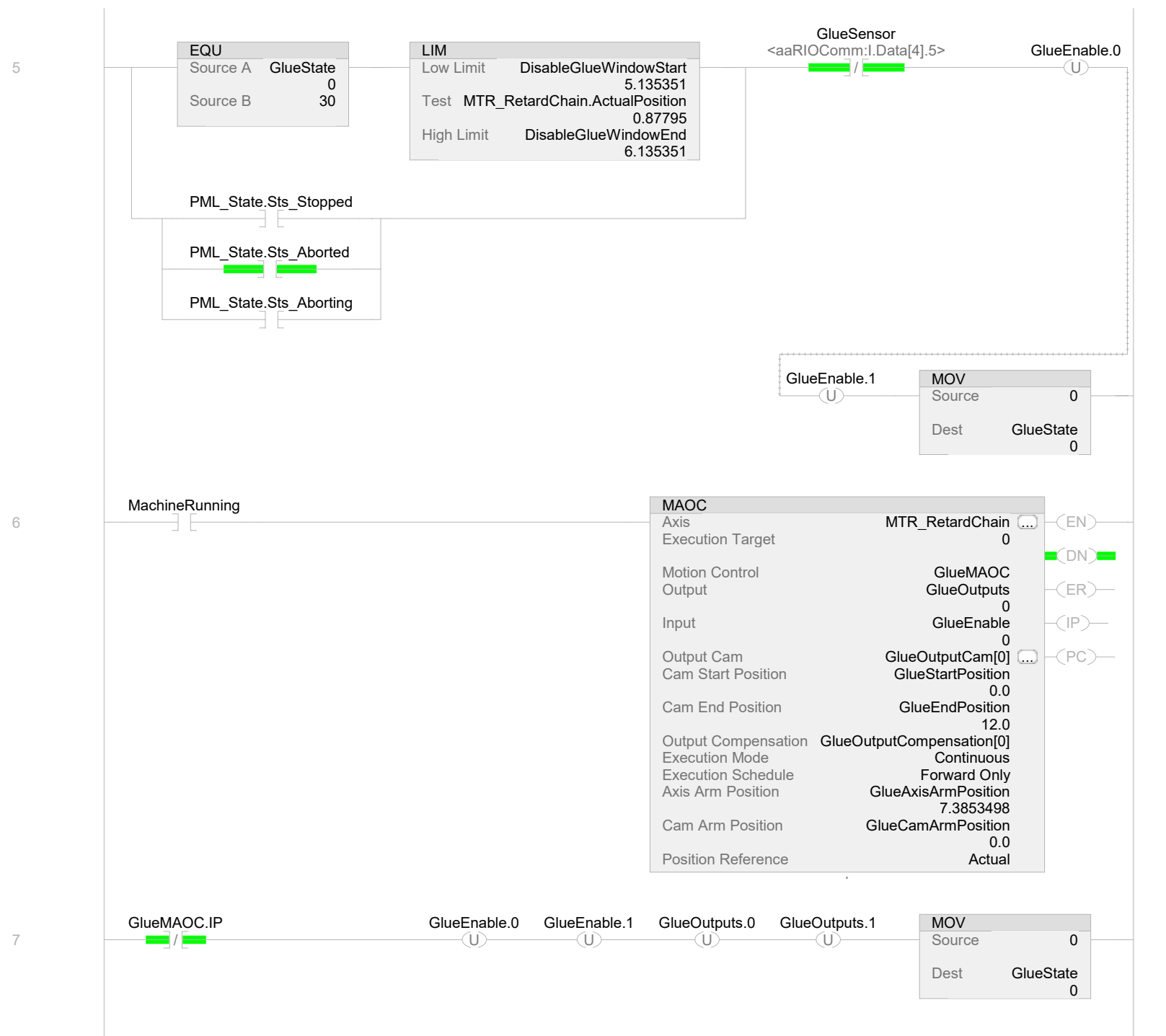
LIM
Low Limit MachinePitchX2
24.0
Test MTR_Feeder.ActualPosition
24.7822
High Limit MachinePitchX3
36.0

CPT
Dest FeederPositionMod
10.6311
Expression MTR_Feeder.ActualPosition-MachinePitchX2

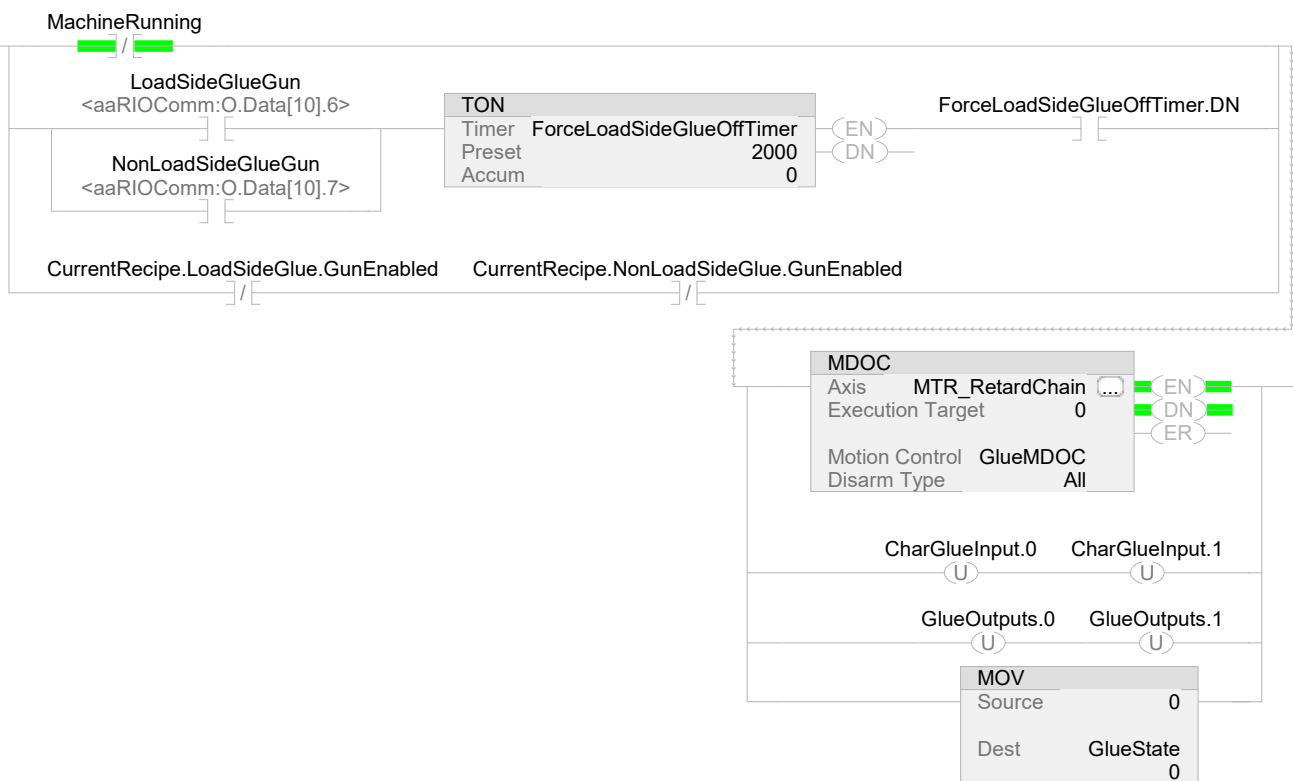






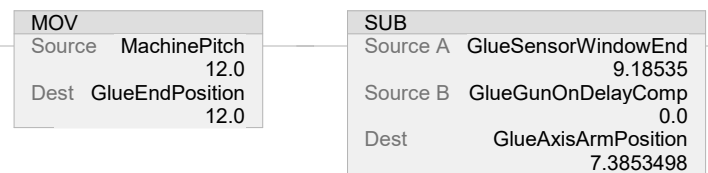


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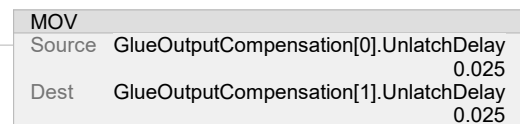
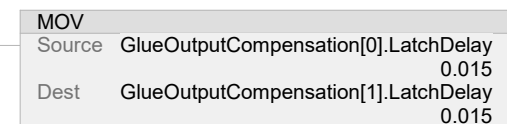


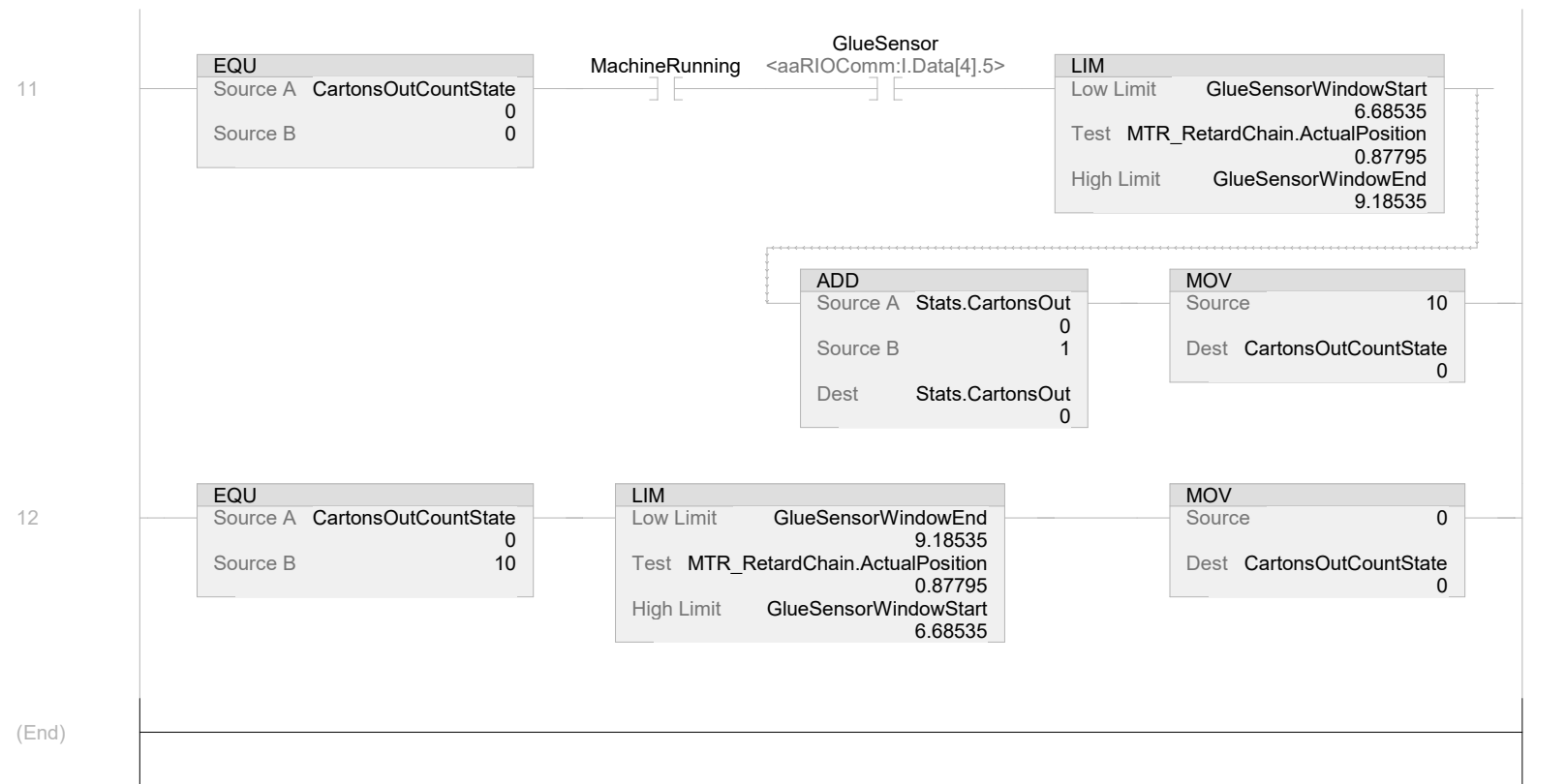
9

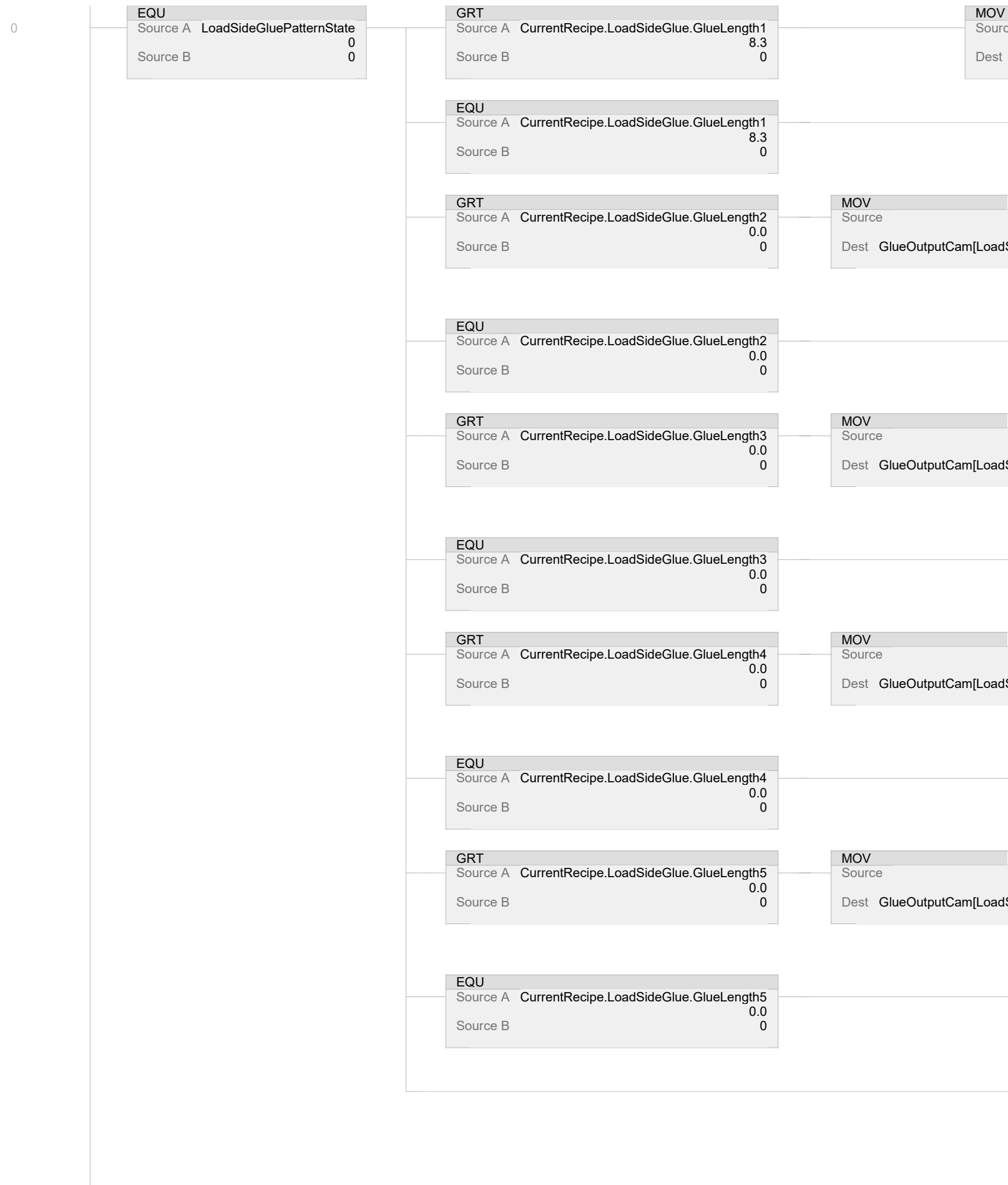
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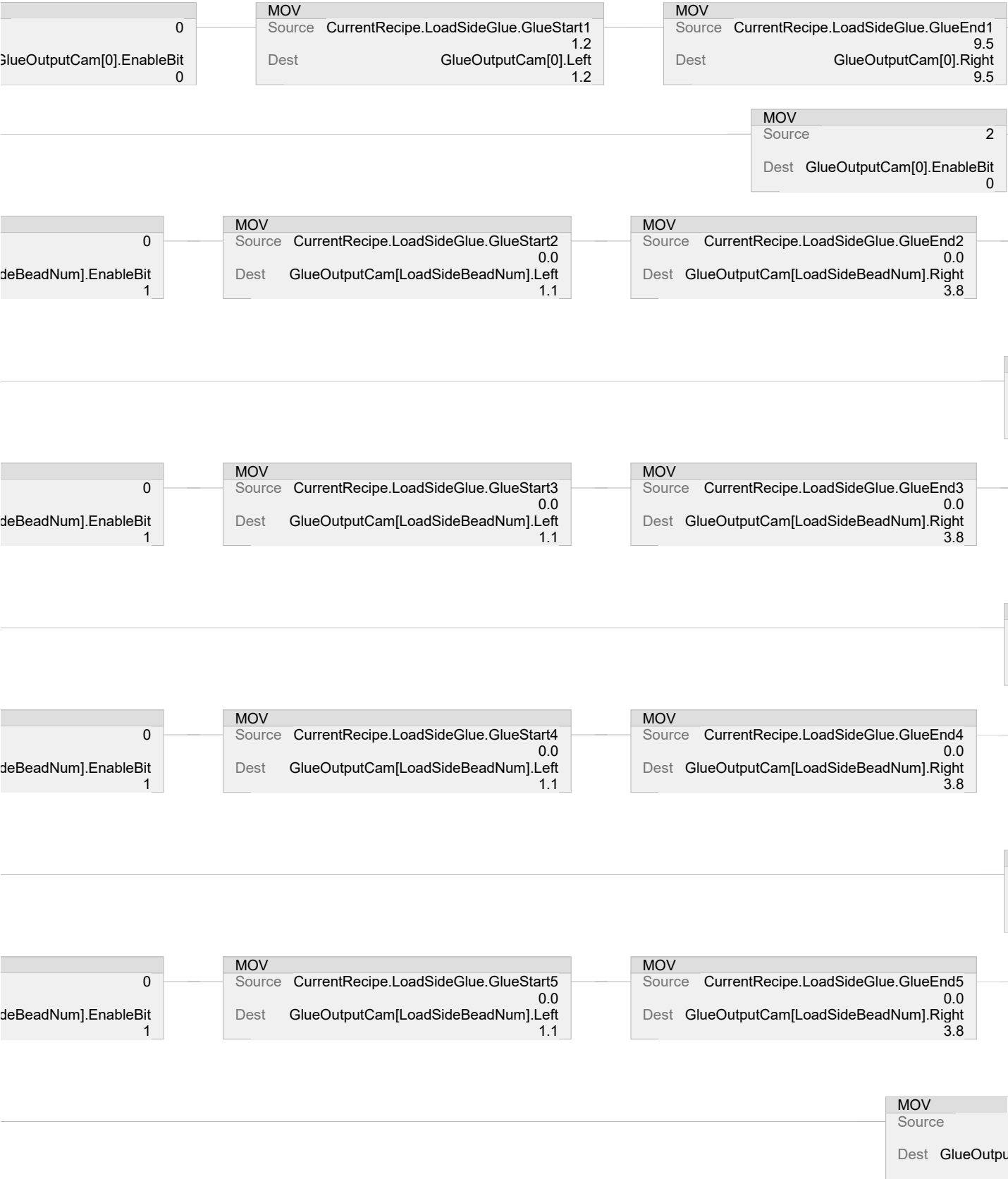


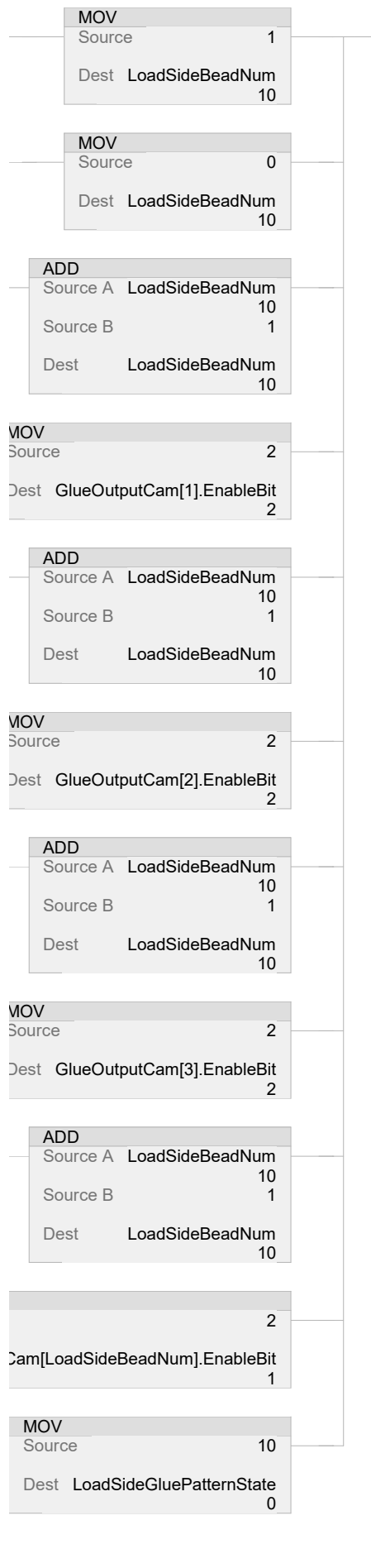
10











1

EQU

Source A

LoadSideGluePatternState

0

Source B

10

MOV

Source

Dest

GlueOutputCam[LoadSideBeadNum

MOV

Source

3

Dest

GlueOutputCam[LoadSideBeadNum].LatchType

3

MOV

Source

0

Dest

GlueOutputCompensation[3].Offset

0.0

MOV

Source

Dest

GlueOutputCompensation[3].Latch

LES

Source A

LoadSideBeadNum

10

Source B

10

GEQ

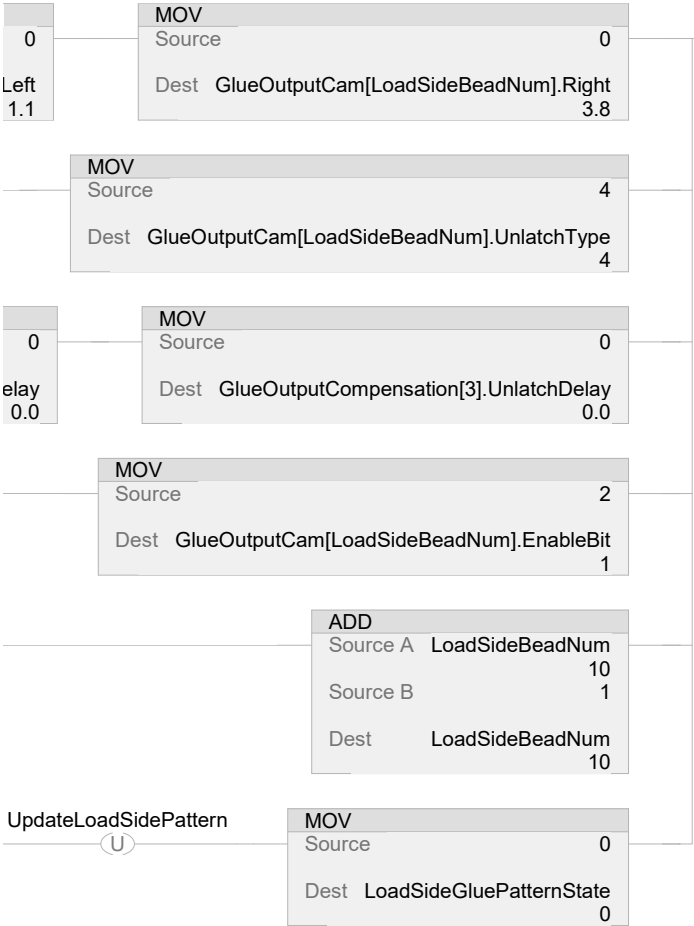
Source A

LoadSideBeadNum

10

Source B

10



(End)

0

EQU		
Source A	NonLoadSideGluePatternState	0
Source B		0

GRT		
Source A	CurrentRecipe.NonLoadSideGlue.GlueLength1	2.6999998
Source B		0

EQU		
Source A	CurrentRecipe.NonLoadSideGlue.GlueLength1	2.6999998
Source B		0

GRT		
Source A	CurrentRecipe.NonLoadSideGlue.GlueLength2	2.5
Source B		0

MOV		
Source		
Dest	GlueOutputCa	

EQU		
Source A	CurrentRecipe.NonLoadSideGlue.GlueLength2	2.5
Source B		0

GRT		
Source A	CurrentRecipe.NonLoadSideGlue.GlueLength3	0.0
Source B		0

MOV		
Source		
Dest	GlueOutputCa	

EQU		
Source A	CurrentRecipe.NonLoadSideGlue.GlueLength3	0.0
Source B		0

GRT		
Source A	CurrentRecipe.NonLoadSideGlue.GlueLength4	0.0
Source B		0

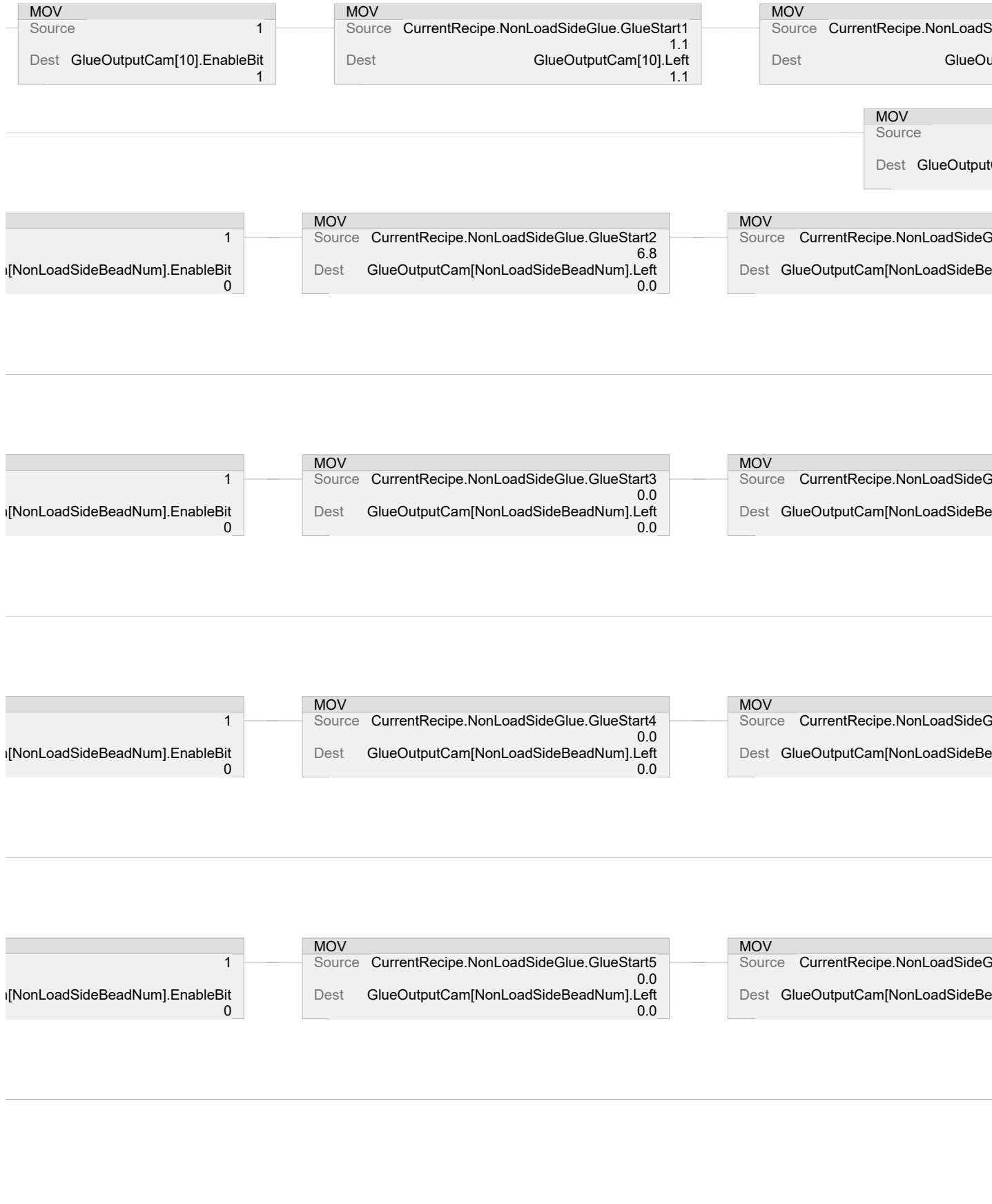
MOV		
Source		
Dest	GlueOutputCa	

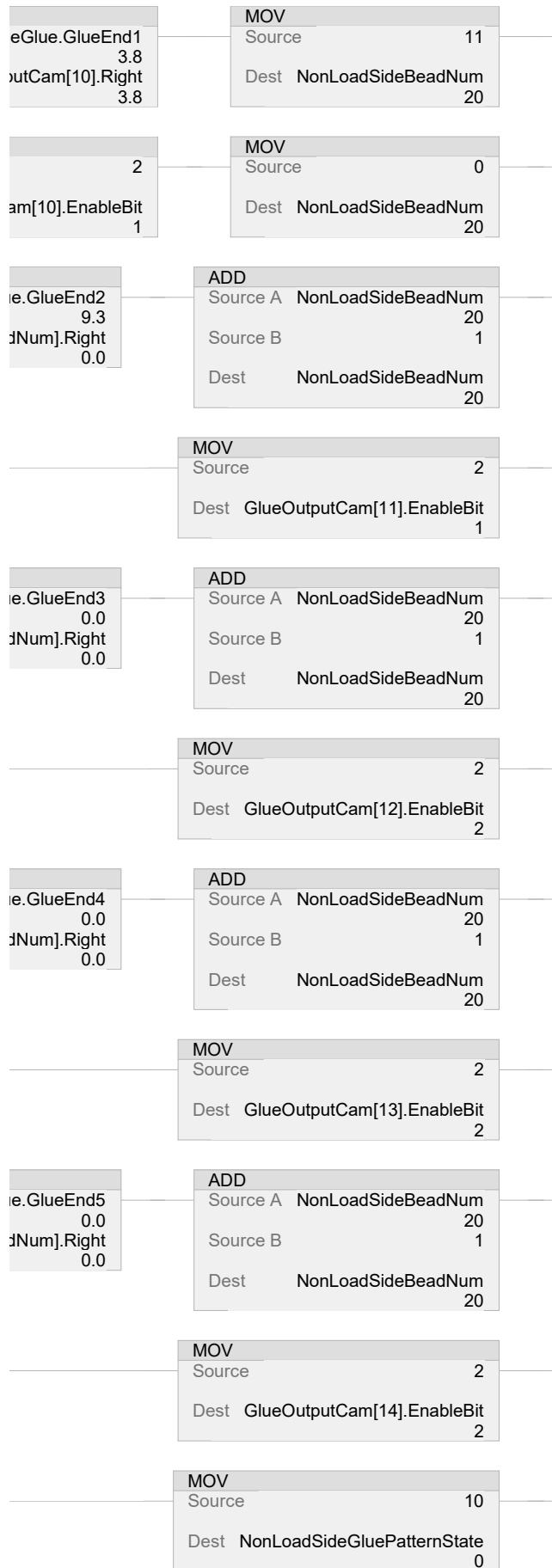
EQU		
Source A	CurrentRecipe.NonLoadSideGlue.GlueLength4	0.0
Source B		0

GRT		
Source A	CurrentRecipe.NonLoadSideGlue.GlueLength5	0.0
Source B		0

MOV		
Source		
Dest	GlueOutputCa	

EQU		
Source A	CurrentRecipe.NonLoadSideGlue.GlueLength5	0.0
Source B		0





1

EQU

Source A

NonLoadSideGluePatternState

0

Source B

10

MOV

Source

Dest

GlueOutputCam[NonLoadSideBeadNum]

MOV

Source

3

Dest

GlueOutputCam[NonLoadSideBeadNum].LatchType

0

MOV

Source

0

Dest

GlueOutputCompensation[3].Offset

0.0

MOV

Source

Dest

GlueOutputCompensation[3].L

LES

Source A

NonLoadSideBeadNum

20

Source B

20

GEQ

Source A

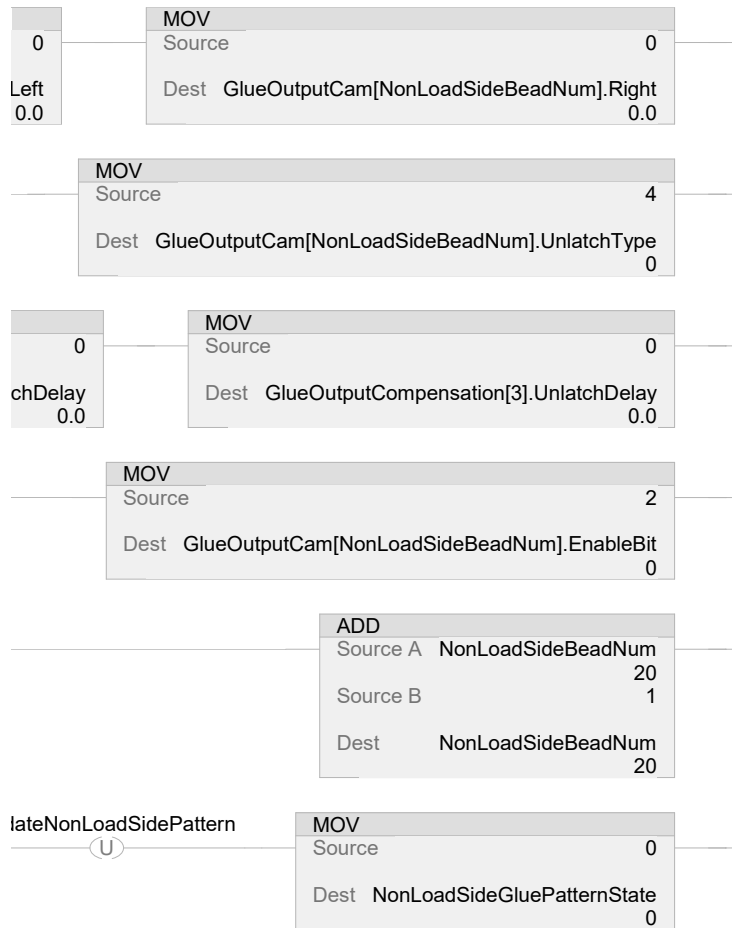
NonLoadSideBeadNum

20

Source B

20

U1



(End)

0

SUB		
Source A	CurrentRecipe.LoadSideGlue.GlueEnd1	9.5
Source B	CurrentRecipe.LoadSideGlue.GlueStart1	1.2
Dest	CurrentRecipe.LoadSideGlue.GlueLength1	8.3

ADD		
Source A	CurrentRecipe.LoadSideGlue.GlueLength1	8.3
Source B	CurrentRecipe.LoadSideGlue.GlueLength2	0.0
Dest	CurrentRecipe.LoadSideGlue.GlueLengthTotal	8.3

SUB		
Source A	CurrentRecipe.LoadSideGlue.GlueEnd2	0.0
Source B	CurrentRecipe.LoadSideGlue.GlueStart2	0.0
Dest	CurrentRecipe.LoadSideGlue.GlueLength2	0.0

ADD		
Source A	CurrentRecipe.LoadSideGlue.GlueLengthTotal	8.3
Source B	CurrentRecipe.LoadSideGlue.GlueLength3	0.0
Dest	CurrentRecipe.LoadSideGlue.GlueLengthTotal	8.3

SUB		
Source A	CurrentRecipe.LoadSideGlue.GlueEnd3	0.0
Source B	CurrentRecipe.LoadSideGlue.GlueStart3	0.0
Dest	CurrentRecipe.LoadSideGlue.GlueLength3	0.0

ADD		
Source A	CurrentRecipe.LoadSideGlue.GlueLengthTotal	8.3
Source B	CurrentRecipe.LoadSideGlue.GlueLength4	0.0
Dest	CurrentRecipe.LoadSideGlue.GlueLengthTotal	8.3

SUB		
Source A	CurrentRecipe.LoadSideGlue.GlueEnd4	0.0
Source B	CurrentRecipe.LoadSideGlue.GlueStart4	0.0
Dest	CurrentRecipe.LoadSideGlue.GlueLength4	0.0

ADD		
Source A	CurrentRecipe.LoadSideGlue.GlueLengthTotal	8.3
Source B	CurrentRecipe.LoadSideGlue.GlueLength5	0.0
Dest	CurrentRecipe.LoadSideGlue.GlueLengthTotal	8.3

SUB		
Source A	CurrentRecipe.LoadSideGlue.GlueEnd5	0.0
Source B	CurrentRecipe.LoadSideGlue.GlueStart5	0.0
Dest	CurrentRecipe.LoadSideGlue.GlueLength5	0.0

NEQ		
Source A	CurrentRecipe.LoadSideGlue.GlueLengthTotal	8.3
Source B	LoadSideGlueTotalCurrent	8.3

GEQ		
Source A	CurrentRecipe.LoadSideGlue.GlueLengthTotal	8.3
Source B		0

GEQ		
Source A	CurrentRecipe.LoadSideGlue.GlueLength1	8.3
Source B		0

GEQ		
Source A	CurrentRecipe.LoadSideGlue.GlueLength2	0.0
Source B		0

GEQ		
Source A	CurrentRecipe.LoadSideGlue.GlueLength3	0.0
Source B		0

GEQ		
Source A	CurrentRecipe.LoadSideGlue.GlueLength4	0.0
Source B		0

GEQ		
Source A	CurrentRecipe.LoadSideGlue.GlueLength5	0.0
Source B		0

MOV		
Source	CurrentRecipe.LoadSideGlue.GlueLengthTotal	8.3
Dest	LoadSideGlueTotalCurrent	8.3

UpdateLoadSidePattern

L

1

SUB

Source A	CurrentRecipe.NonLoadSideGlue.GlueEnd1	3.8
Source B	CurrentRecipe.NonLoadSideGlue.GlueStart1	1.1
Dest	CurrentRecipe.NonLoadSideGlue.GlueLength1	2.6999998

SUB

Source A	CurrentRecipe.NonLoadSideGlue.GlueEnd2	9.3
Source B	CurrentRecipe.NonLoadSideGlue.GlueStart2	6.8
Dest	CurrentRecipe.NonLoadSideGlue.GlueLength2	2.5

SUB

Source A	CurrentRecipe.NonLoadSideGlue.GlueEnd3	0.0
Source B	CurrentRecipe.NonLoadSideGlue.GlueStart3	0.0
Dest	CurrentRecipe.NonLoadSideGlue.GlueLength3	0.0

SUB

Source A	CurrentRecipe.NonLoadSideGlue.GlueEnd4	0.0
Source B	CurrentRecipe.NonLoadSideGlue.GlueStart4	0.0
Dest	CurrentRecipe.NonLoadSideGlue.GlueLength4	0.0

SUB

Source A	CurrentRecipe.NonLoadSideGlue.GlueEnd5	0.0
Source B	CurrentRecipe.NonLoadSideGlue.GlueStart5	0.0
Dest	CurrentRecipe.NonLoadSideGlue.GlueLength5	0.0

ADD

Source A	CurrentRecipe.NonLoadSideGlue.GlueLength1	2.6999998
Source B	CurrentRecipe.NonLoadSideGlue.GlueLength2	2.5
Dest	CurrentRecipe.NonLoadSideGlue.GlueLengthTotal	5.2

ADD

Source A	CurrentRecipe.NonLoadSideGlue.GlueLengthTotal	5.2
Source B	CurrentRecipe.NonLoadSideGlue.GlueLength3	0.0
Dest	CurrentRecipe.NonLoadSideGlue.GlueLengthTotal	5.2

ADD

Source A	CurrentRecipe.NonLoadSideGlue.GlueLengthTotal	5.2
Source B	CurrentRecipe.NonLoadSideGlue.GlueLength4	0.0
Dest	CurrentRecipe.NonLoadSideGlue.GlueLengthTotal	5.2

ADD

Source A	CurrentRecipe.NonLoadSideGlue.GlueLengthTotal	5.2
Source B	CurrentRecipe.NonLoadSideGlue.GlueLength5	0.0
Dest	CurrentRecipe.NonLoadSideGlue.GlueLengthTotal	5.2

NEQ



(End)

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