MainRoutine - Ladder Diagram

Page 1

Smart_Conveyor:Smart_Conveyor_Line:MainProgram

30/09/2025 15:38:02

Total number of rungs in routine: 8

C:\Users\Admin\Desktop\Smart_Conveyor.ACD

All alarms:
1001-1003 safety
stop system
200x/201x/202x
process diagnostics
AOI_Alarm latches
until Ack + Reset.

JSR
Routine Name_Alarm_Notification

(End)

MainRoutine - Ladder Diagram

Page 2

30/09/2025 15:39:15 C:\Users\Admin\Desktop\Smart_Conveyor.ACD

Page 1

Smart Conveyor:Smart Conveyor Line:MainProgram Total number of rungs in routine: 14

I_PB_Start PB Start 0 I_PB_EStop PB_EStop $\exists \vdash$ I_PB_Reset PB_Reset 2 JE I_PB_Ack PB_Ack 3 I_Sensor_PartDetect Sensor_PartDetect I_Sensor_LabelOK Sensor_LabelOK 5 I_Sensor_SealOK Sensor_SealOK 6 I_Sensor_PhotoEye_Entry Sensor_PhotoEye_Entry 7 Sensor_PhotoEye_Inspect I_Sensor_PhotoEye_Inspect 8 I_Sensor_PhotoEye_Exit Sensor_PhotoEye_Exit 9 ConveyorMTR O_ConveyorMTR -()-10 $\exists \vdash$ RejectCylinder O_RejectCylinder 11 MOV 12 I_Weight_Raw Source WeightRaw Dest CPT Weight_KG 13 Dest Expression (WeightRaw*50)/32767 (End)

ONS_RE - Ladder Diagram

Smart_Conveyor:Smart_Conveyor_Line:MainProgram Total number of rungs in routine: 3

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Page 1

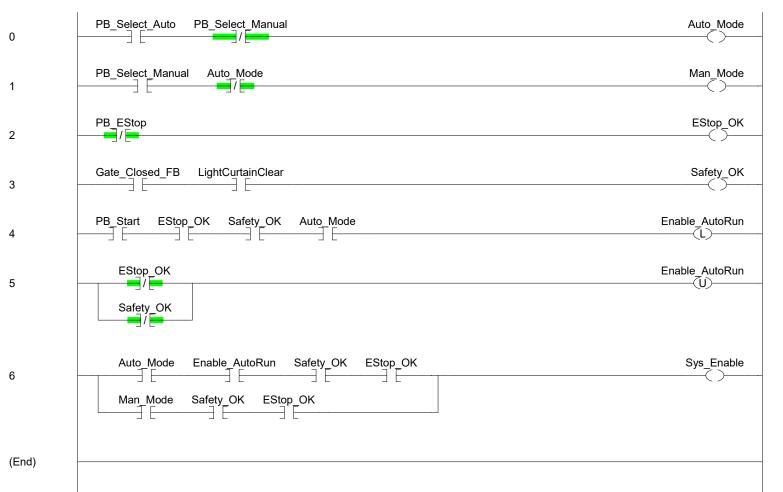
C:\Users\Admin\Desktop\Smart_Conveyor.ACD

Sensor_PhotoEye_Entry ONS_PE_Entry PE_Entry_RE 0 PE_Inspect_RE Sensor_PhotoEye_Inspect ONS_PE_Inspect ONS_ 1 Sensor_PhotoEye_Exit ONS_PE_Exit PE_Exit_RE 2 (End)

Page 1

Smart_Conveyor:Smart_Conveyor_Line:MainProgram Total number of rungs in routine: 7

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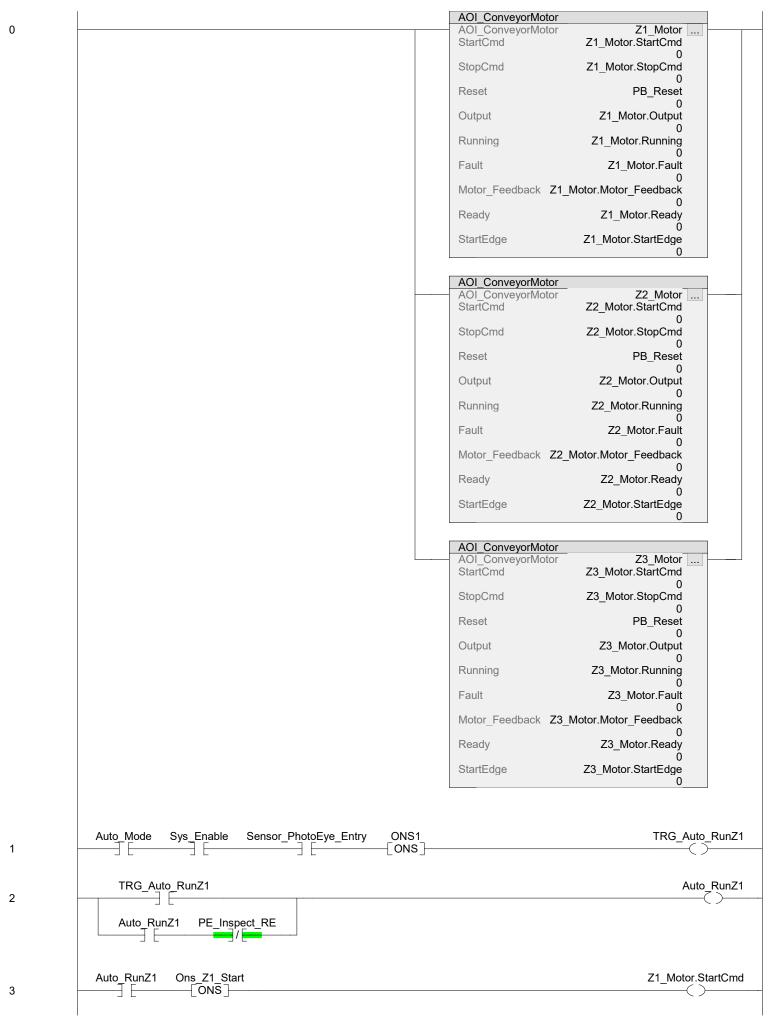
Sim_Routine - Ladder DiagramPage 1Smart_Conveyor:Smart_Conveyor_Line:MainProgram30/09/2025 15:40:13Total number of rungs in routine: 3C:\Users\Admin\Desktop\Smart_Conveyor.ACD

0	Z1_Motor.Output	Z1_Motor.Motor_Feedback
1	Z2_Motor.Output	Z2_Motor.Motor_Feedback
2	Z3_Motor.Output	Z3_Motor.Motor_Feedback
(End)		

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Page 1

Total number of rungs in routine: 15 C:\Users\Admin\Desktop\Smart Conveyor.ACD

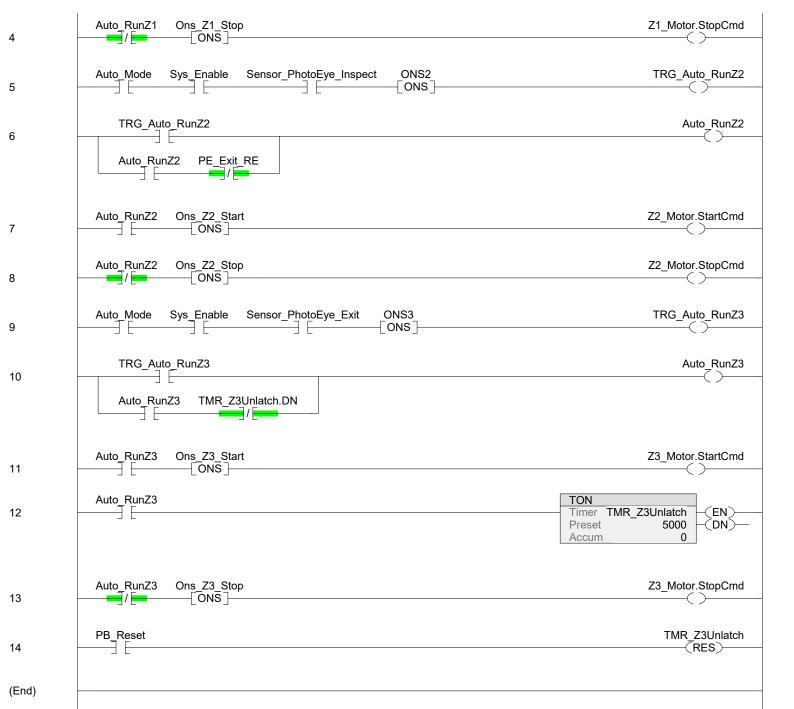


30/09/2025 15:38:46

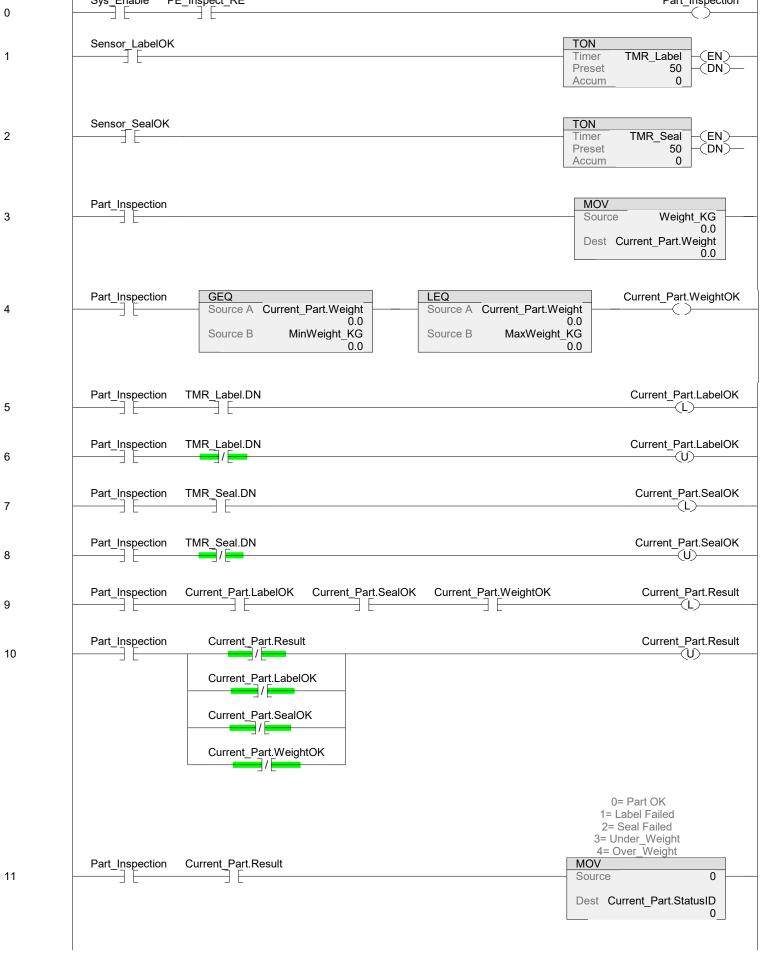
Page 2

Smart_Conveyor:Smart_Conveyor_Line:MainProgram Total number of rungs in routine: 15

C:\Users\Admin\Desktop\Smart_Conveyor.ACD



Page 1 30/09/2025 15:39:59 Smart_Conveyor:Smart_Conveyor_Line:MainProgram Total number of rungs in routine: 17 C:\Users\Admin\Desktop\Smart Conveyor.ACD Sys_Enable PE_Inspect_RE Part Inspection 0



Current_Part.SealOK

Ⅎ╘

Current_Part.SealOK

LES

GRT

Source B

Source B

Source A Current_Part.Weight

Source A Current_Part.Weight

0.0

0= Part OK 1= Label Failed 2= Seal Failed 3= Under_Weight 4= Over_Weight

Dest Current_Part.StatusID

0= Part OK 1= Label Failed 2= Seal Failed 3= Under_Weight 4= Over_Weight

Dest Current_Part.StatusID

Current Part

PartQ_CTRL

PartQ

64

0

3

4

0

(EN)

(DN)

(EM)

MinWeight_KG

MOV Source

0.0

0.0

MOV

FFL

Source FIFO

Control

Length

Position

Source

MaxWeight_KG

Current_Part.LabelOK

Ⅎ╘

Current_Part.LabelOK

╛╘

Part_Inspection

Part_Inspection

Part_Inspection

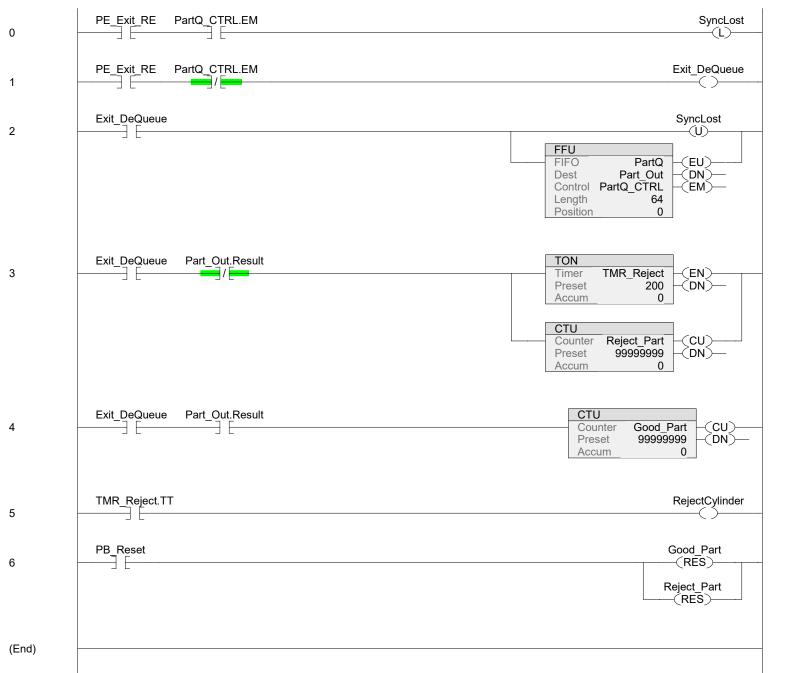
14

15

16

(End)

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Page 1

Page 1

Alarm Notification - Ladder Diagram

Logix Designer

Alarm_Notification - Ladder Diagram
Smart_Conveyor:Smart_Conveyor_Line:MainProgram
Total number of rungs in routine: 31 **Page 5** 30/09/2025 15:38:21 $\underline{C:} \underline{Vsers}\underline{Admin}\underline{Desktop}\underline{Smart}\underline{Conveyor}.\underline{ACD}$ (End)