Process 3.1 - Vibration In

Communication Sequence

PLC WRITE			PC WRITE		Remarks
PLC STATUS (BCD)	SERIAL NO. (ASCII)		PC STATUS (BCD)	RESULT (ASCII)	
0	" "		0	" "	Initial State
0	14000001-RH-...		0	" "	Scan QR Code
1	14000001-RH-...		0	" "	PLC Inform PC to start operate
1	14000001-RH-...		1	" "	PC acknowledge and start operate
1	14000001-RH-...		1	"OK" or "NG"	PC Write Test Result
1	14000001-RH-...		2	"OK" or "NG"	PC Record To Database Complete PC Status 2 - Complete 3 - Duplicate Serial 4 - Invalid Serial Format
0	" "		2	"OK" or "NG"	PLC clear data
0	" "		0	" "	PC clear data and wait for next request from PLC

Memory Map

No.	Address		Type		Detail
			PC Write		
1	DM00100	DM25100	BCD		PC Online - PC always write 1, PLC always clear to 0. If PC not write 1 more than xx seconds, show PC offline
2	DM00101	DM25101	BCD		PC Status 0 - Waiting for request 1 - Processing 2 - Process Complete 3 - Duplicate Data 4 - Invalid QR Format
3	DM00102	DM25102	ASCII		Previous Process Test Result "OK" or "NG"
4	DM00103	DM25103			Reserve
5	DM00104	DM25104			Reserve
6	DM00105	DM25105			Reserve
7	DM00106	DM25106			Reserve
8	DM00107	DM25107			Reserve
9	DM00108	DM25108			Reserve
10	DM00109	DM25109			Reserve
			PLC Write		
11	DM00110	DM25110	BCD		PLC Status 0 - Waiting for user to scan 1 - Request PC to start process
12	DM00111	DM25111	ASCII	14	
13	DM00112	DM25112	ASCII	00	
14	DM00113	DM25113	ASCII	00	
15	DM00114	DM25114	ASCII	01	
16	DM00115	DM25115	ASCII	-R	
17	DM00116	DM25116	ASCII	H-	
18	DM00117	DM25117	ASCII	15	
19	DM00118	DM25118	ASCII	11	
20	DM00119	DM25119	ASCII	20	
21	DM00120	DM25120	ASCII	14	QR Code
22	DM00121	DM25121	ASCII	-1	14000001-RH-15112014-16:30:40-015-INJ-OK
23	DM00122	DM25122	ASCII	6:	
24	DM00123	DM25123	ASCII	30	
25	DM00124	DM25124	ASCII	:4	
26	DM00125	DM25125	ASCII	0-	
27	DM00126	DM25126	ASCII	01	
28	DM00127	DM25127	ASCII	5-	
29	DM00128	DM25128	ASCII	IN	
30	DM00129	DM25129	ASCII	J-	
31	DM00130	DM25130	ASCII	OK	
32	DM00131	DM25131			Reserve
33	DM00132	DM25132			Reserve
34	DM00133	DM25133			Reserve
35	DM00134	DM25134			Reserve
36	DM00135	DM25135			Reserve
37	DM00136	DM25136			Reserve
38	DM00137	DM25137			Reserve
39	DM00138	DM25138			Reserve
40	DM00139	DM25139			Reserve

Process 3.2 - Vibration Out

Communication Sequence

PLC STATUS (BCD)	SERIAL NO. (ASCII)	PLC WRITE	RESULT (ASCII)	PC WRITE PC STATUS (BCD)	Remarks
0	" "		" "	0	Initial State
0	14000001-RH-…		OK	0	Scan QR Code
1	14000001-RH-…		OK	0	PLC Inform PC to start operate
1	14000001-RH-…		OK	1	PC acknowledge and start operate
1	14000001-RH-…		OK	2	PC Record To Database Complete
					PC Status
					2 - Complete
					3 - Duplicate Serial
					4 - Invalid Serial Format
0	" "		" "	2	PLC clear data
0	" "		" "	0	PC clear data and wait for next request from PLC

Memory Map

No.	Address		Type		Detail
				PC Write	
1	DM00100	DM26100	BCD		PC Online - PC always write 1, PLC always clear to 0. If PC not write 1 more than xx seconds, show PC offline
2	DM00101	DM26101	BCD		PC Status 0 - Waiting for request 1 - Processing 2 - Process Complete 3 - Duplicate Data 4 - Invalid Serial Format
3	DM00102	DM26102			Reserve
4	DM00103	DM26103			Reserve
5	DM00104	DM26104			Reserve
6	DM00105	DM26105			Reserve
7	DM00106	DM26106			Reserve
8	DM00107	DM26107			Reserve
9	DM00108	DM26108			Reserve
10	DM00109	DM26109			Reserve
				PLC Write	
11	DM00110	DM26110	BCD		PLC Status 0 - Waiting for user to scan 1 - Request PC to start process
12	DM00111	DM26111	ASCII	14	
13	DM00112	DM26112	ASCII	00	
14	DM00113	DM26113	ASCII	00	
15	DM00114	DM26114	ASCII	01	
16	DM00115	DM26115	ASCII	-R	
17	DM00116	DM26116	ASCII	H-	
18	DM00117	DM26117	ASCII	15	
19	DM00118	DM26118	ASCII	11	
20	DM00119	DM26119	ASCII	20	
21	DM00120	DM26120	ASCII	14	
22	DM00121	DM26121	ASCII	-1	
23	DM00122	DM26122	ASCII	6	QR Code
24	DM00123	DM26123	ASCII	30	14000001-RH-15112014-16:30:40-015-VIB-OK
25	DM00124	DM26124	ASCII	:4	
26	DM00125	DM26125	ASCII	0-	
27	DM00126	DM26126	ASCII	01	
28	DM00127	DM26127	ASCII	5-	
29	DM00128	DM26128	ASCII	VI	
30	DM00129	DM26129	ASCII	B-	
31	DM00130	DM26130	ASCII	OK	
32	DM00131	DM26131	ASCII	" "	
33	DM00132	DM26132	ASCII	" "	
34	DM00133	DM26133	ASCII	" "	
35	DM00134	DM26134	ASCII	" "	
36	DM00135	DM26135	ASCII	" "	
37	DM00136	DM26136			Reserve
38	DM00137	DM26137			Reserve
39	DM00138	DM26138			Reserve
40	DM00139	DM26139	ASCII	OK or NG	Reserve

Process 4.1 - Assy In

Communication Sequence

PLC WRITE			PC WRITE		Remarks
PLC STATUS (BCD)	SERIAL NO. (ASCII)		PC STATUS (BCD)	RESULT (ASCII)	
0	" "		0	" "	Initial State
0	14000001-RH-…		0	" "	Scan QR Code
1	14000001-RH-…		0	" "	PLC Inform PC to start operate
1	14000001-RH-…		1	" "	PC acknowledge and start operate
1	14000001-RH-…		1	"OK" or "NG"	PC Write Test Result
1	14000001-RH-…		2	"OK" or "NG"	PC Record To Database Complete PC Status 2 - Complete 3 - Duplicate Serial 4 - Invalid Serial Format
0	" "		2	"OK" or "NG"	PLC clear data
0	" "		0	" "	PC clear data and wait for next request from PLC

Memory Map

No.	Address		Type		Detail
			PC Write		
1	DM00100	DM25100	BCD		PC Online - PC always write 1, PLC always clear to 0 If PC not write 1 more than xx seconds, show PC offline
2	DM00101	DM25101	BCD		PC Status 0 - Waiting for request 1 - Processing 2 - Process Complete 3 - Duplicate Data 4 - Invalid QR Format
3	DM00102	DM25102	ASCII		Previous Process Test Result "OK" or "NG"
4	DM00103	DM25103			Reserve
5	DM00104	DM25104			Reserve
6	DM00105	DM25105			Reserve
7	DM00106	DM25106			Reserve
8	DM00107	DM25107			Reserve
9	DM00108	DM25108			Reserve
10	DM00109	DM25109			Reserve
			PLC Write		
11	DM00110	DM25110	BCD		PLC Status 0 - Waiting for user to scan 1 - Request PC to start process
12	DM00111	DM25111	ASCII	14	
13	DM00112	DM25112	ASCII	00	
14	DM00113	DM25113	ASCII	00	
15	DM00114	DM25114	ASCII	01	
16	DM00115	DM25115	ASCII	-R	
17	DM00116	DM25116	ASCII	H-	
18	DM00117	DM25117	ASCII	15	
19	DM00118	DM25118	ASCII	11	
20	DM00119	DM25119	ASCII	20	
21	DM00120	DM25120	ASCII	14	QR Code
22	DM00121	DM25121	ASCII	-1	14000001-RH-15112014-16:30:40-015-INJ-OK
23	DM00122	DM25122	ASCII	6:	
24	DM00123	DM25123	ASCII	30	
25	DM00124	DM25124	ASCII	:4	
26	DM00125	DM25125	ASCII	0-	
27	DM00126	DM25126	ASCII	01	
28	DM00127	DM25127	ASCII	5-	
29	DM00128	DM25128	ASCII	IN	
30	DM00129	DM25129	ASCII	J-	
31	DM00130	DM25130	ASCII	OK	
32	DM00131	DM25131			Reserve
33	DM00132	DM25132			Reserve
34	DM00133	DM25133			Reserve
35	DM00134	DM25134			Reserve
36	DM00135	DM25135			Reserve
37	DM00136	DM25136			Reserve
38	DM00137	DM25137			Reserve
39	DM00138	DM25138			Reserve
40	DM00139	DM25139			Reserve

Process 4.2 - Assy Out

Communication Sequence

PLC STATUS (BCD)	SERIAL NO. (ASCII)		RESULT (ASCII)	PC STATUS (BCD)	Remarks
0	" "		" "	0	Initial State
0	14000001-RH-...		OK	0	Scan QR Code
1	14000001-RH-...		OK	0	PLC Inform PC to start operate
1	14000001-RH-...		OK	1	PC acknowledge and start operate
1	14000001-RH-...		OK	2	PC Record To Database Complete
					PC Status
					2 - Complete
					3 - Duplicate Serial
					4 - Invalid Serial Format
0	" "		" "	2	PLC clear data
0	" "		" "	0	PC clear data and wait for next request from PLC

Header spanning: "PLC WRITE" spans SERIAL NO. and the adjacent column; "PC WRITE" spans RESULT and PC STATUS.

Memory Map

No.	Address		Type		Detail
			PC Write		
1	DM00100	DM26100	BCD		PC Online - PC always write 1, PLC always clear to 0. If PC not write 1 more than xx seconds, show PC offline
2	DM00101	DM26101	BCD		PC Status 0 - Waiting for request 1 - Processing 2 - Process Complete 3 - Duplicate Data 4 - Invalid Serial Format
3	DM00102	DM26102			Reserve
4	DM00103	DM26103			Reserve
5	DM00104	DM26104			Reserve
6	DM00105	DM26105			Reserve
7	DM00106	DM26106			Reserve
8	DM00107	DM26107			Reserve
9	DM00108	DM26108			Reserve
10	DM00109	DM26109			Reserve
			PLC Write		
11	DM00110	DM26110	BCD		PLC Status 0 - Waiting for user to scan 1 - Request PC to start process
12	DM00111	DM26111	ASCII	14	
13	DM00112	DM26112	ASCII	00	
14	DM00113	DM26113	ASCII	00	
15	DM00114	DM26114	ASCII	01	
16	DM00115	DM26115	ASCII	-R	
17	DM00116	DM26116	ASCII	H-	
18	DM00117	DM26117	ASCII	15	
19	DM00118	DM26118	ASCII	11	
20	DM00119	DM26119	ASCII	20	
21	DM00120	DM26120	ASCII	14	QR Code
22	DM00121	DM26121	ASCII	-1	14000001-RH-15112014-16:30:40-015-W-AB-OK
23	DM00122	DM26122	ASCII	6	14000001-RH-15112014-16:30:40-015-W-OAB-OK
24	DM00123	DM26123	ASCII	30	14000001-RH-15112014-16:30:40-015-W-DEF-OK
25	DM00124	DM26124	ASCII	:4	14000001-RH-15112014-16:30:40-015-W-ODEF-OK
26	DM00125	DM26125	ASCII	0-	
27	DM00126	DM26126	ASCII	01	
28	DM00127	DM26127	ASCII	5-	
29	DM00128	DM26128	ASCII	W	
30	DM00129	DM26129	ASCII	OD	
31	DM00130	DM26130	ASCII	EF	
32	DM00131	DM26131	ASCII	-O	
33	DM00132	DM26132	ASCII	"K"	
34	DM00133	DM26133	ASCII	" "	
35	DM00134	DM26134	ASCII	" "	
36	DM00135	DM26135	ASCII	" "	
37	DM00136	DM26136			Reserve
38	DM00137	DM26137			Reserve
39	DM00138	DM26138			Reserve
40	DM00139	DM26139	ASCII	OK or NG	Result, "OK" or "NG"