Sorting - Ladder Diagram
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PLC2_Project_3:MainTask:MainProgram
28/07/2020 10:25:02 PM
Total number of rungs in routine: 6
C:\RSLogix 5000\Projects\PLC2_Project_3.ACD

0

NEQ
Not Equal
Source A String_BarcodeInput
"
Source B String_Null
"

String_Sort_Bit
( )

Sort the barcode input string into usable data (integer format)

1 String_Sort_Bit

MID
Middle String
Source String_BarcodeInput
"
Qty 3
Start 1
Dest Temp_ID
"

STOD
String To DINT
Source Temp_ID
"
Dest Material_ID
0

MID
Middle String
Source String_BarcodeInput
"
Qty 2
Start 5
Dest Temo_Qty
"

STOD
String To DINT
Source Temo_Qty
"
Dest Material_Qty
0

0 = Subtraction
1 = Addition

MID
Middle String
Source String_BarcodeInput
"
Qty 1
Start 8
Dest Temp_Direction
"

STOD
String To DINT
Source Temp_Direction
"
Dest Material_AddSubtract
0

Update data for identifier "123" - Widgets

2

EQU
Equal
Source A 123
Source B Material_ID
0

EQU
Equal
Source A Material_AddSubtract
0
Source B 1

ADD
Add
Source A Material_Qty
0
Source B Item_123_Qty
0
Dest Item_123_Qty
0

EQU
Equal
Source A Material_AddSubtract
0
Source B 0

SUB
Subtract
Source A Item_123_Qty
0
Source B Material_Qty
0
Dest Item_123_Qty
0

CleanTempData

Update data for identifier "456" - Doodads

3

EQU
Equal
Source A   456
Source B   Material_ID
                        0

EQU
Equal
Source A   Material_AddSubtract
                              0
Source B   1

ADD
Add
Source A   Material_Qty
                        0
Source B   Item_456_Qty
                        0
Dest   Item_456_Qty
                        0

EQU
Equal
Source A   Material_AddSubtract
                              0
Source B   0

SUB
Subtract
Source A   Item_456_Qty
                        0
Source B   Material_Qty
                        0
Dest   Item_456_Qty
                        0

CleanTempData

Update data for identifier "789" - Wockies

4

EQU
Equal
Source A   789
Source B   Material_ID
                        0

EQU
Equal
Source A   Material_AddSubtract
                              0
Source B   1

ADD
Add
Source A   Material_Qty
                        0
Source B   Item_789_Qty
                        0
Dest   Item_789_Qty
                        0

EQU
Equal
Source A   Material_AddSubtract
                              0
Source B   0

SUB
Subtract
Source A   Item_789_Qty
                        0
Source B   Material_Qty
                        0
Dest   Item_789_Qty
                        0

CleanTempData

Clean input and temp data in preparation for next scan

5   CleanTempData

DELETE
String Delete
Source   String_BarcodeInput
                          "
Qty   999
Start   1
Dest   String_BarcodeInput
                          "

MOV
Move
Source   0
Dest   Material_ID
                          0

MOV
Move
Source   0
Dest   Material_Qty
                          0

MOV
Move
Source   0
Dest   Material_AddSubtract
                          0

DELETE
String Delete
Source   Temp_ID
                          "
Qty   999
Start   1
Dest   Temp_ID
                          "

DELETE
String Delete
Source   Temo_Qty
                          "
Qty   999
Start   1
Dest   Temo_Qty
                          "

0 = Subtraction
1 = Addition

DELETE
String Delete
Source   Temp_Direction
                          "
Qty   999
Start   1
Dest   Temp_Direction
                          "

(End)