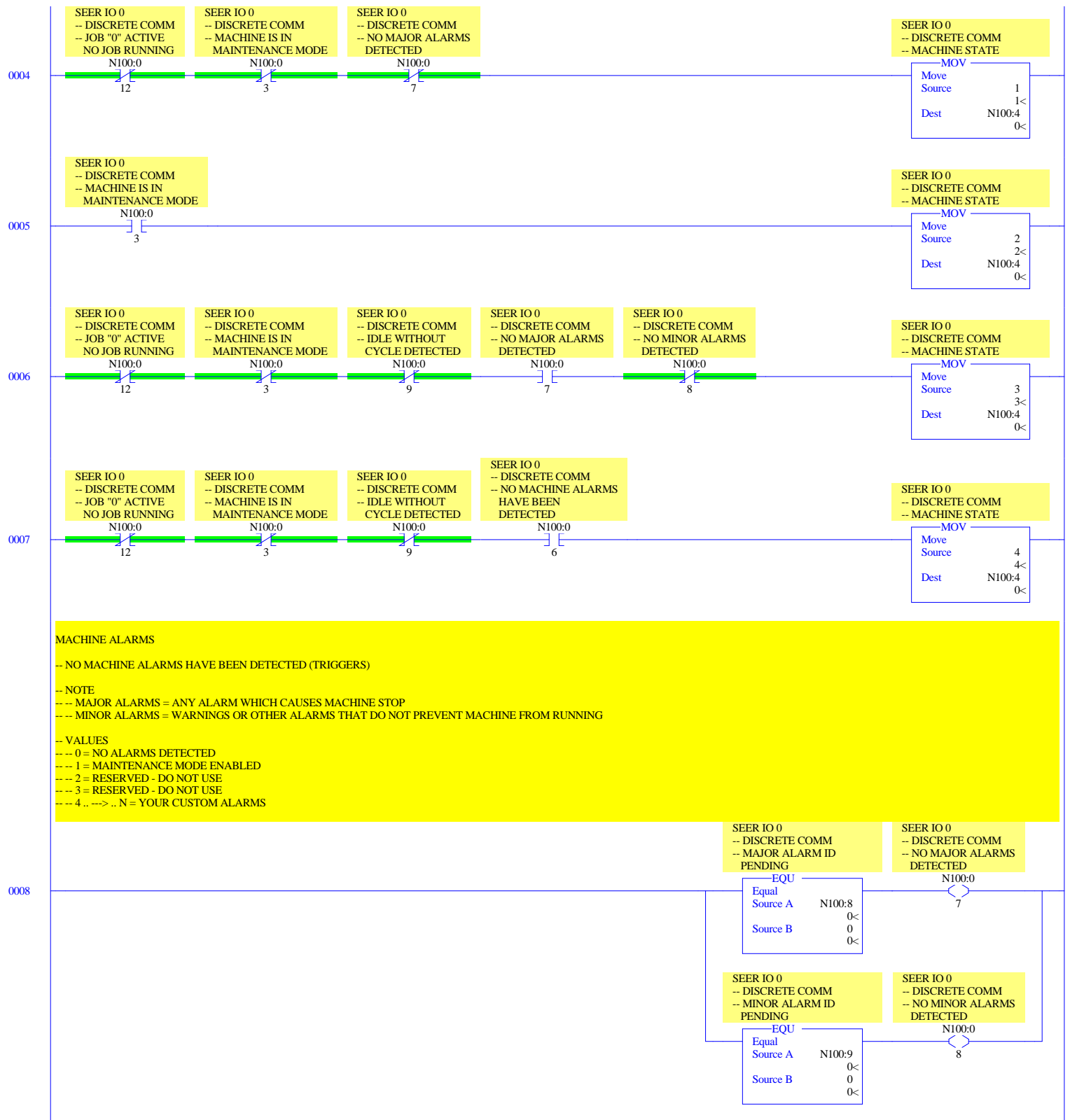
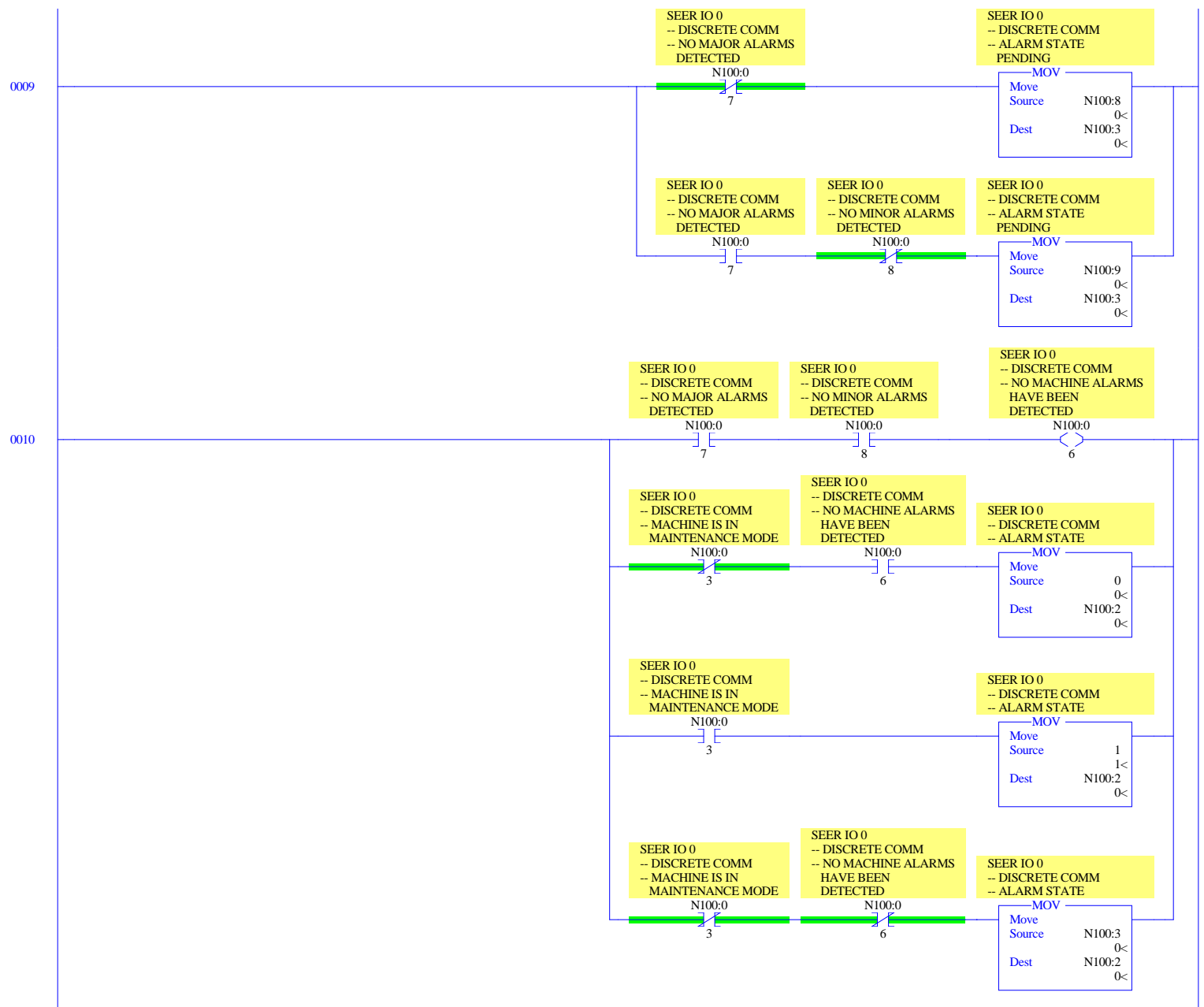


LAD 101 - SEER_1 - SEER_1 --- Total Rungs in File = 16



LAD 101 - SEER_1 - SEER_1 --- Total Rungs in File = 16



0011

CORRECTIVE ACTION REGISTER

-- WHEN MACHINE IS RUNNING WITHOUT FAULTS (STATE = 4)
 -- (FORCE) SET CORRECTIVEACTION = 0
 -- (FORCE) SET ALARM = 0

-- REQUIRED
 -- 0 = NONE ENTERED
 -- 2 = SCHEDULED DOWN OR CLEANING
 -- 3 = OPERATOR ON LUNCH OR BREAK

-- NOTE
 -- 1 DOES NOT EXIST - DEPRECATED AFTER INITIAL DEPLOYMENT
 -- 2 AND 3 ARE SET BY SEER, NOT BY THE LOCAL CONTROLLER

SEER IO 0
 -- DISCRETE COMM
 -- MACHINE STATE

-- EQU

Equal	N100:4	
Source A		0<
Source B		4<
		4<

SEER IO 0
 -- DISCRETE COMM
 -- CORRECTIVE ACTION

-- MOV

Move	0	
Source		0<
Dest	N100:5	0<

SEER IO 0
 -- DISCRETE COMM
 -- ALARM STATE

-- MOV

Move	0	
Source		0<
Dest	N100:2	0<

ACTIVE JOB HOLDING REGISTERS

-- REQUIRED
 -- OPERATOR ID (FLOAT OR BIGINT)
 -- JOB NUMBER (FLOAT OR BIGINT)
 -- SCHEDULE NUMBER (FLOAT OR BIGINT)

-- JOB "0"
 -- JOB ID "0" IS ALWAYS "NONE" (NOT RUNNING)
 -- BY SETTING JOB ID TO "0", THE OPERATOR IS EFFECTIVELY PUTTING THE MACHINE INTO
 A FORCED "SCHEDULED DOWN OR CLEANING" ACTION, SO LET'S FORCE THAT.

-- NOTES
 -- DO -NOT- EXECUTE LOGIC UPON THESE REGISTERS, THEY EXIST
 PURELY FOR USE BY SEER, WHICH WILL WRITE AND READ BACK
 DATA AS NEEDED.
 -- THE 'ALWAYS FALSE' BIT IN FRONT OF THIS RUNG RENDERS
 THIS LADDER AS NOTHING MORE THAN A PLACEHOLDER FOR
 YOUR REFERENCE.

SEER IO 0
 -- DISCRETE COMM
 -- ALWAYS FALSE
 INSTRUCTION
 (ALWAYS = 0)

N100:0
 10

SEER IO 1
 -- ANALOG COMM
 -- JOB NUMBER

-- ADD

Add	F101:2	
Source A		0.0<
Source B	0.0	0.0<
Dest	F101:2	0.0<

SEER IO 1
 -- ANALOG COMM
 -- SCHEDULE NUMBER

-- ADD

Add	F101:3	
Source A		0.0<
Source B	0.0	0.0<
Dest	F101:3	0.0<

SEER IO 1
 -- ANALOG COMM
 -- OPERATOR ID

-- ADD

Add	F101:4	
Source A		0.0<
Source B	0.0	0.0<
Dest	F101:4	0.0<

0012

LAD 101 - SEER_1 - SEER_1 --- Total Rungs in File = 16

