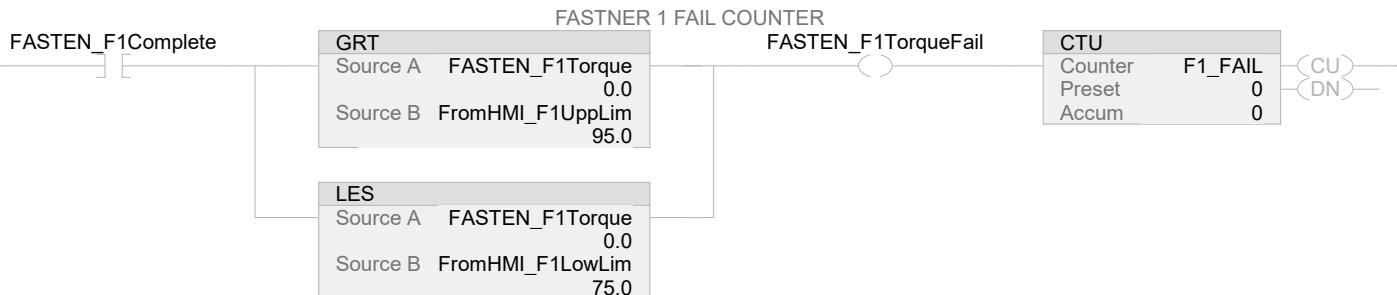
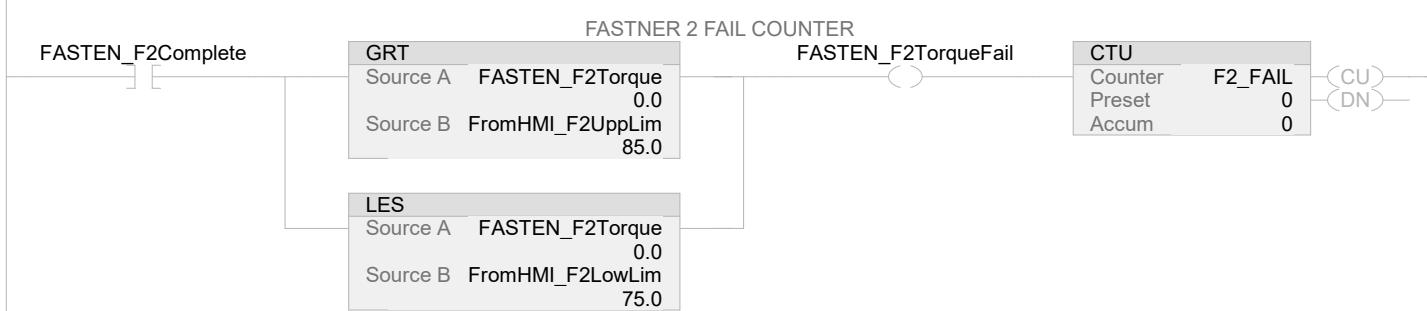


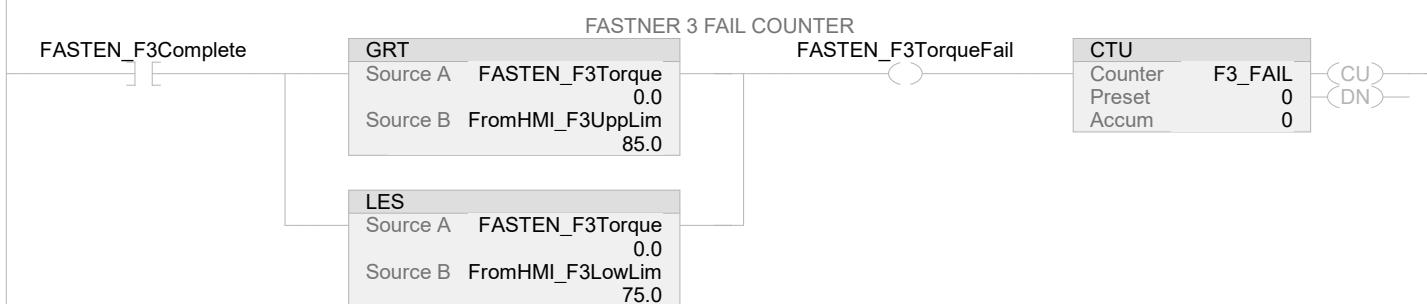
17



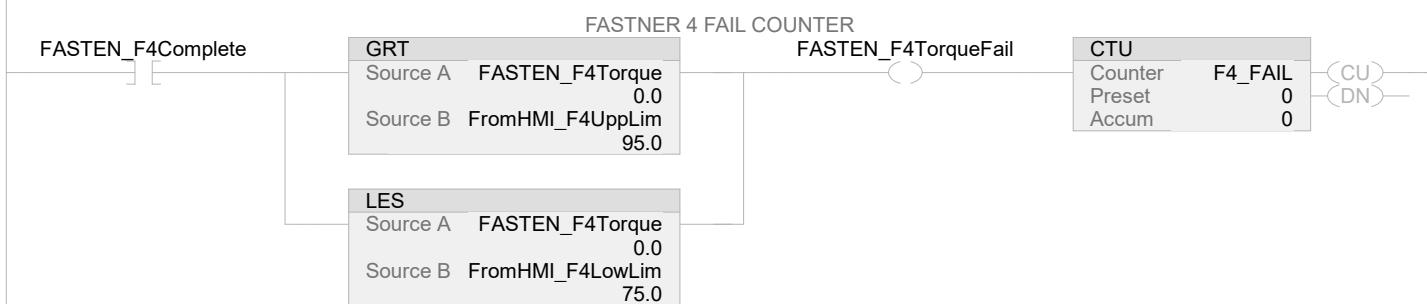
18



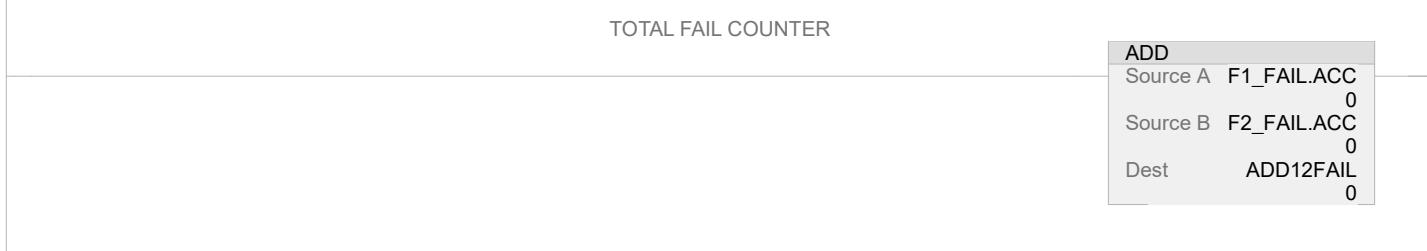
19



20



21



22

ADD		
Source A	ADD12FAIL	0
Source B	F3_FAIL.ACC	0
Dest	ADD123FAIL	0

23

ADD		
Source A	ADD123FAIL	0
Source B	F4_FAIL.ACC	0
Dest	CURRENT_SHIFT.FAILED	0

24

EFFICIENCY COUNTER FOR THE CURRENT SHIFT

CPT	Dest	CURRENT_SHIFT.EFFICIENT
		0.0
Expression <code>(CURRENT_SHIFT.PASSED) / (CURRENT_SHIFT.COMPLETED)*100</code>		

25

IT WILL RESET ALL THE STATS

RESET_STATS

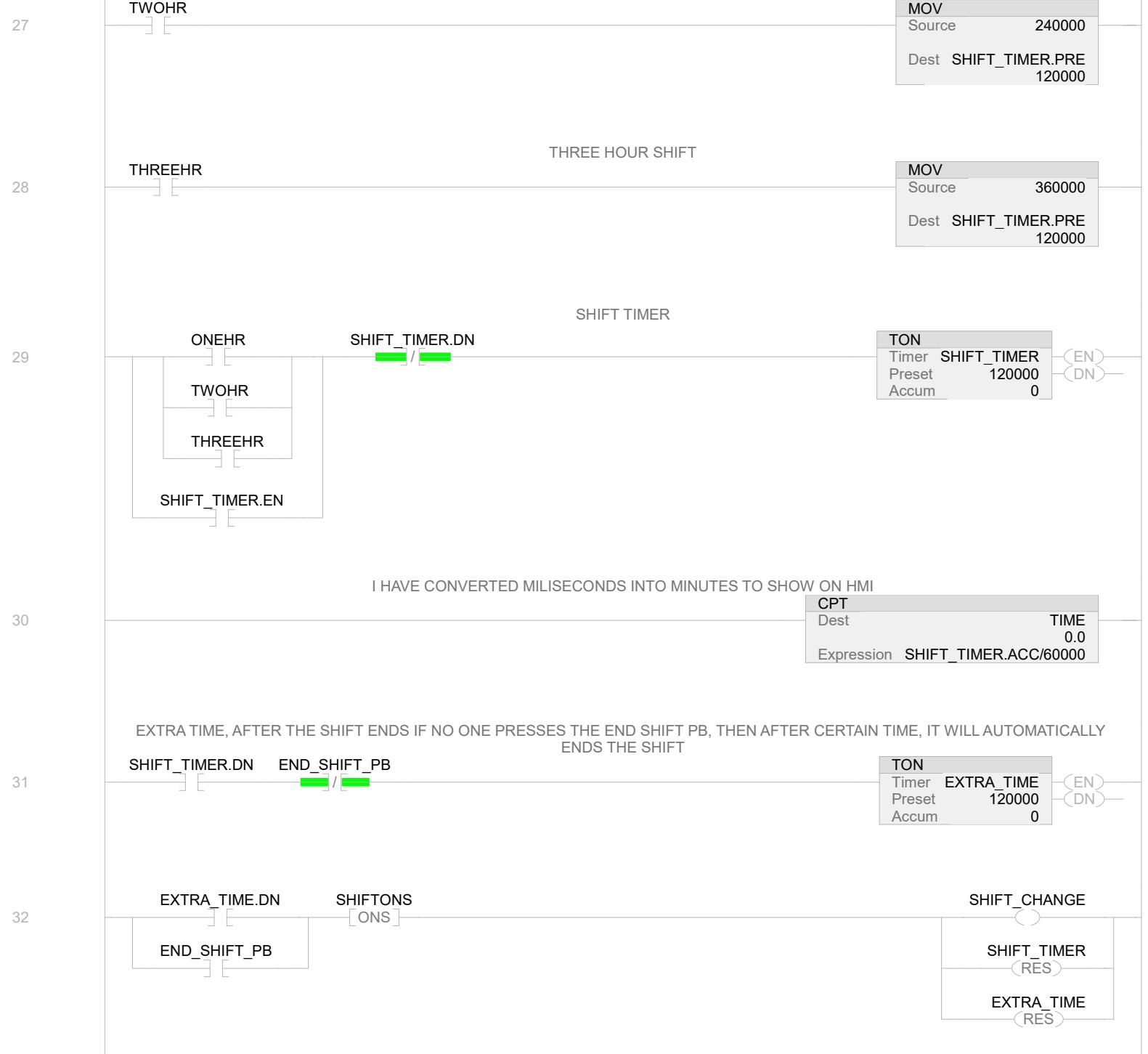
F1_Count	(RES)
F2_Count	(RES)
F3_Count	(RES)
F4_Count	(RES)
F1_PASS	(RES)
F2_PASS	(RES)
F3_PASS	(RES)
F4_PASS	(RES)
F1_FAIL	(RES)
F2_FAIL	(RES)
F3_FAIL	(RES)
F4_FAIL	(RES)

26

ONE HOUR SHIFT

ONEHR

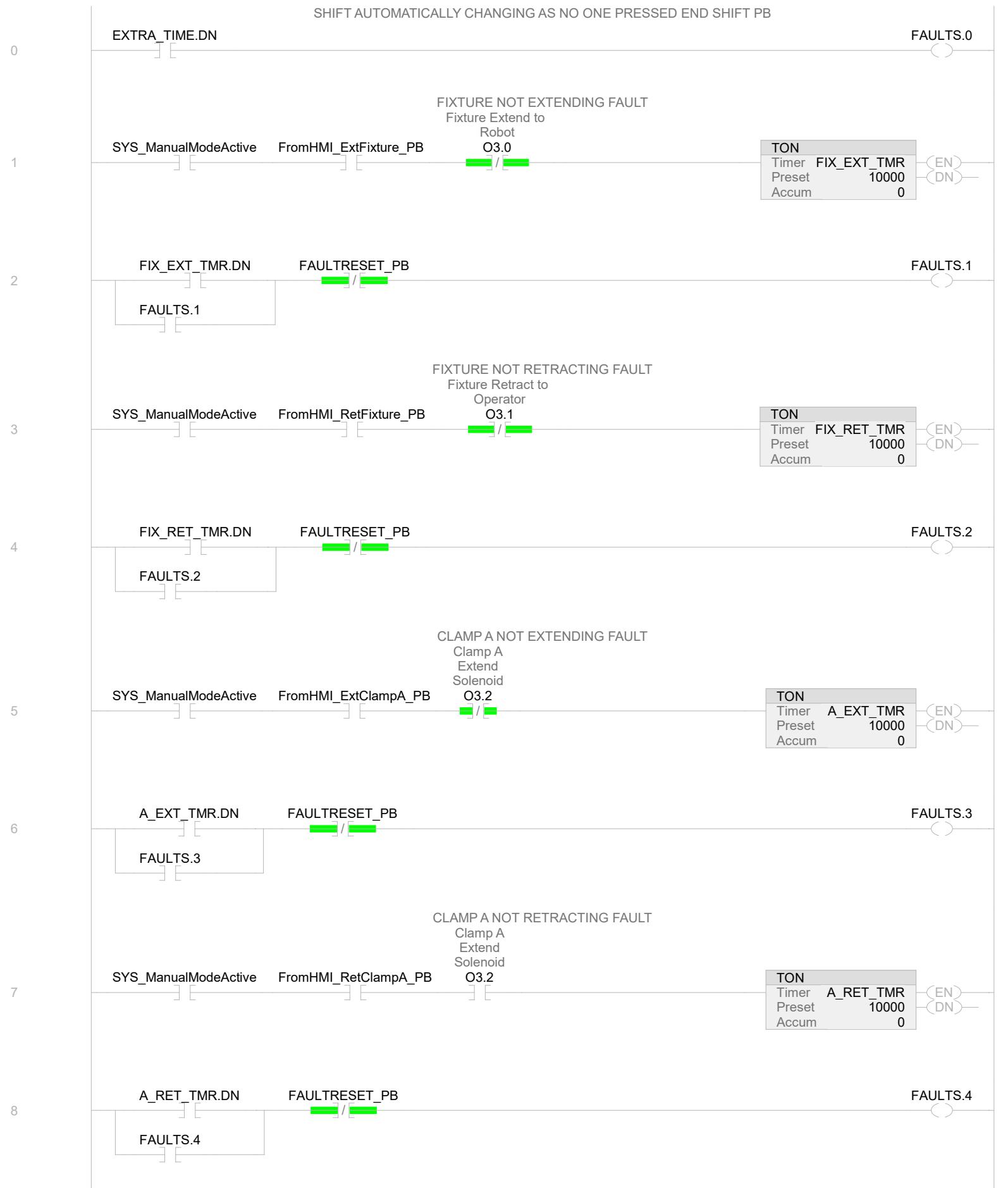
MOV		
Source	120000	
Dest	SHIFT_TIMER.PRE	120000

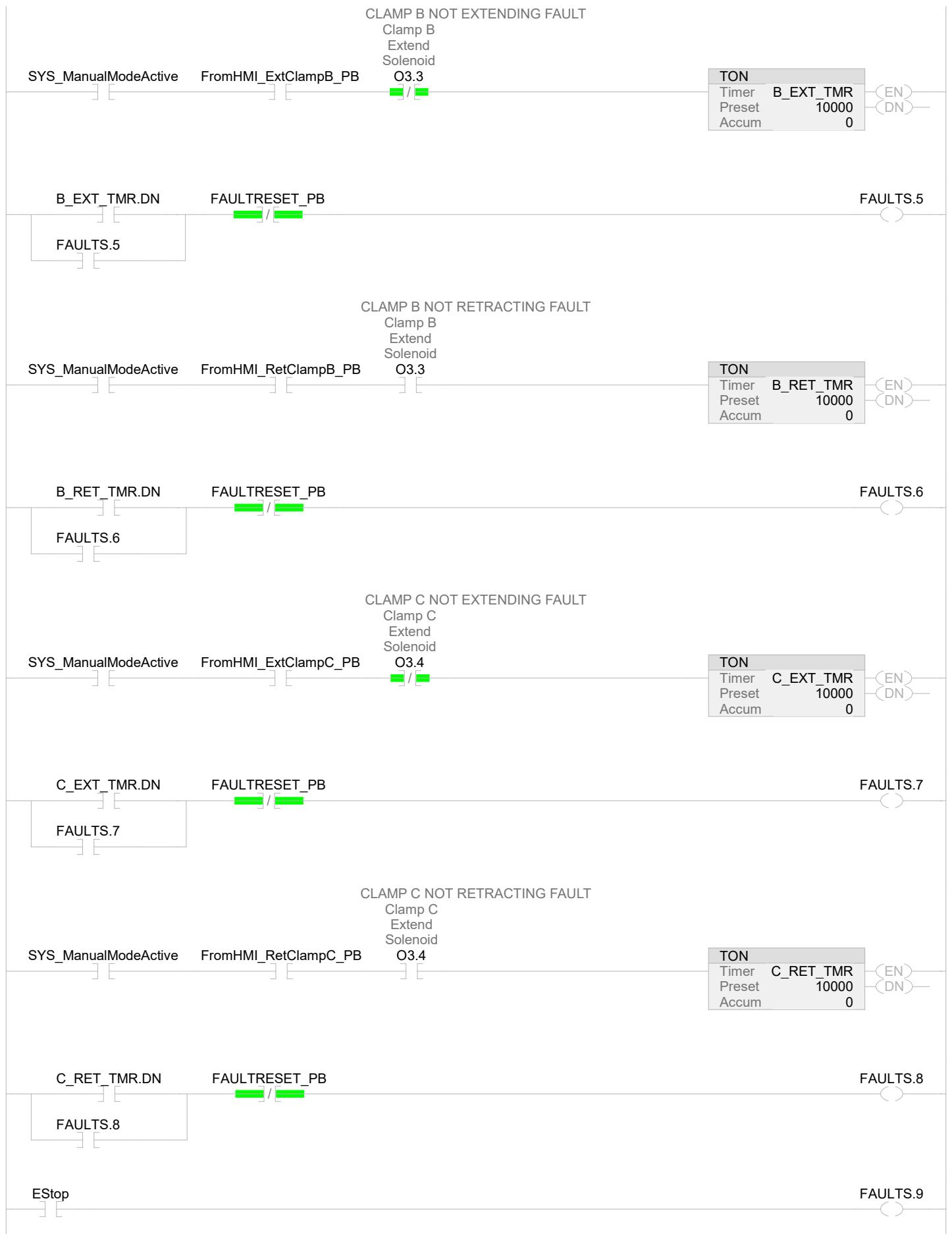


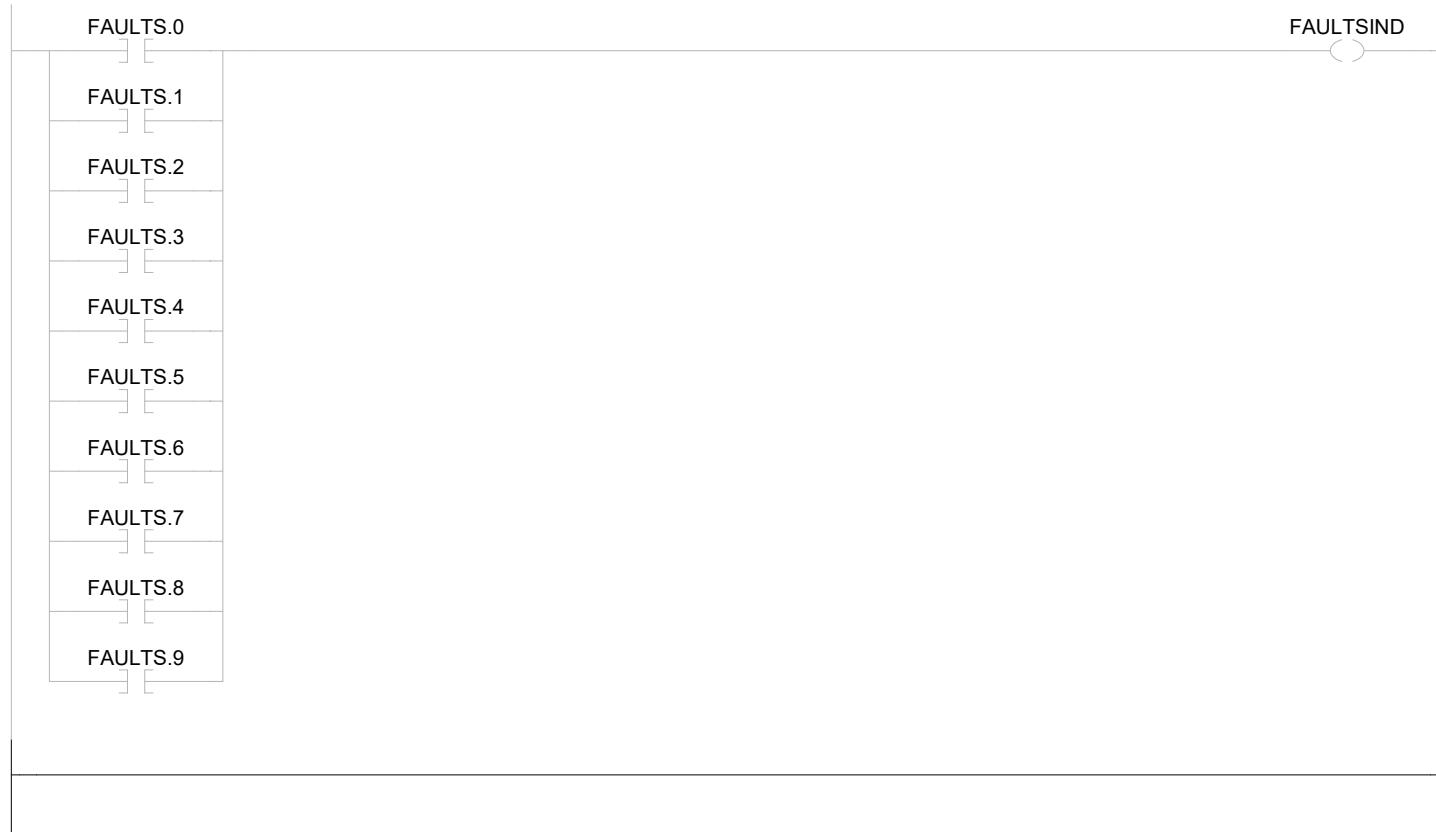
5 PAST SHIFT DATA , IT IS CONTINUOUS SO WE CAN CHECK THE HISTORY FOR LAST 5 SHIFTS



(End)









Data type Name: SHIFT_DATA

Description:

Size: 16 byte(s)

Name	Value	Data Type	Style
COMPLETED External Access:	Read/Write	DINT	Decimal
PASSED External Access:	Read/Write	DINT	Decimal
FAILED External Access:	Read/Write	DINT	Decimal
EFFICIENT External Access:	Read/Write	REAL	Float