

PanelBuilder32 Application Report

File Name: C:\Program Files\Allen-Bradley\PanelBuilder32\Applications\Ford Gum 2573.PVA  
Application Version 692 - Last Saved 1/10/2009 4:09:32 AM

11/29/2010 4:29:00 PM

PROGRAM SELECT

PROGRAM

TO

PROGRAM

LEVEL 4 ACCESS-VIEW ONLY

\*F1 \*F2 \*F3 \*F4 \*F5

\*F6 \*F7 \*F8 \*F9 \*F10

7 8 9

4 5 6

1 2 3

. 0 -

← ↵

← ↑ →

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Screen 1 - PRGSEL

CONFIGURATION #1

SCALE FACTOR                      TACH RESPONSE

MOTION RANGE 1 ON                      OFF

AMBLING RANGE 2 ON                      OFF

\*F1 \*F2 F3 \*F4 \*F5

F6 \*F7 \*F8 \*F9 \*F10

7 8 9

4 5 6

1 2 3

. 0 -

← ↵

← ↑ →

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Screen 2 - CONFIGURE1

CONFIGURATION #3

ANALOG OUT 1      ANALOG OUT 2

OUTPUT TYPE      OUTPUT TYPE

ZERO RPM OUT      ZERO RPM OUT

MAX RPM      MAX RPM

\*F1 \*F2 \*F3 \*F4 \*F5

\*F6 \*F7 \*F8 \*F9 \*F10

7 8 9

4 5 6

1 2 3

. 0 -

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Screen 3 - CONFIGURE 3

CONFIGURATION #2

INPUT ACTIVE STATE

IN1	IN2	IN3	IN4
IN5	IN6	IN7	IN8

\*F1 \*F2 \*F3 \*F4 \*F5

\*F6 \*F7 \*F8 \*F9 \*F10

7	8	9
4	5	6
1	2	3
.	0	-
←	↶	
←	↑	→
	↓	

Screen 4 - CONFIGURE 2

SHREDDER MANUAL SCREEN

CONVEYOR MANUAL START

OFF

RAM MANUAL CYCLE

CYCLE

Return

\*F1 \*F2 F3 F4 F5

F6 F7 F8 F9 F10

7 8 9

4 5 6

1 2 3

. 0 -

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← ↑ →

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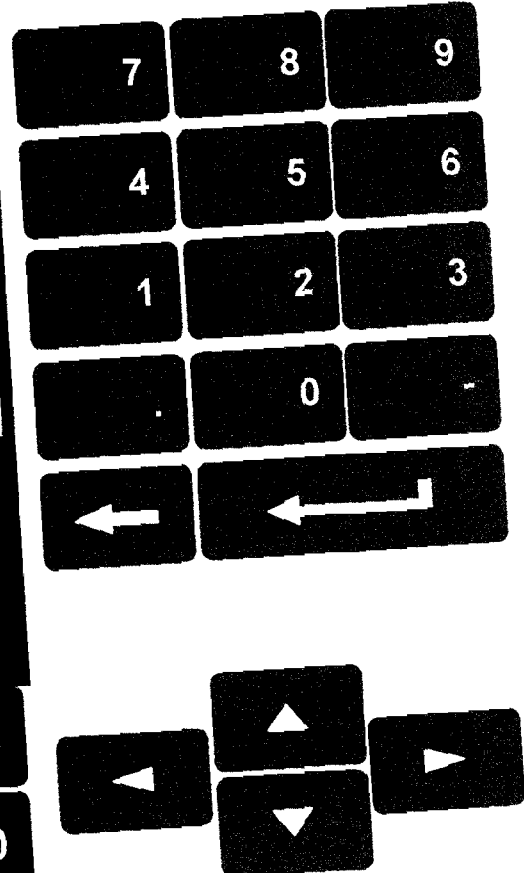
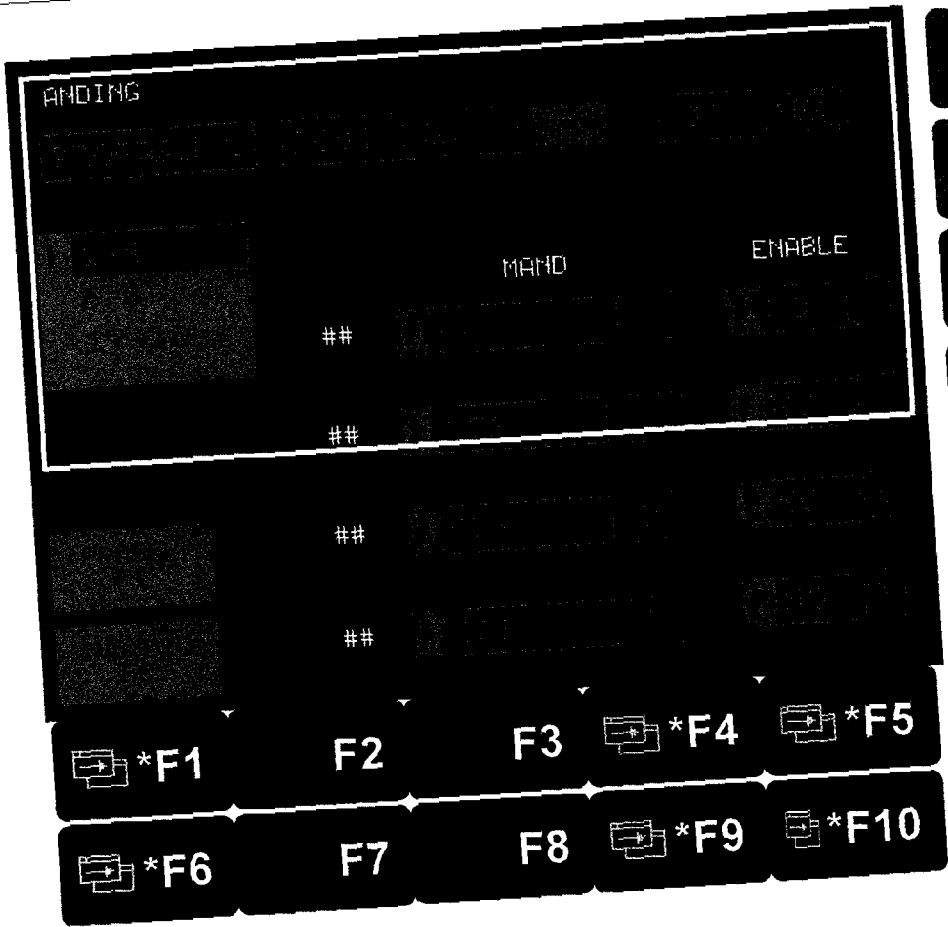
RPM	POSITION
##	ON OFF
SETPOINT	##
	ON OFF
##	ON OFF
##	

\*F1 F2 F3 \*F4 \*F5

\*F6 F7 F8 F9 \*F10

7	8	9
4	5	6
1	2	3
.	0	-
←	←	
←	↑	→
	↓	

Screen 6 - LIMIT SWITCH



Screen 8 - ANDING

VIRTUAL I/O STATUS

VIRTUAL INPUTS 17-24

VIRTUAL OUTPUTS 17-24

VIRTUAL OUTPUTS 25-32

\*F1 \*F2 \*F3 \*F4 \*F5

\*F6 \*F7 F8 \*F9 \*F10

7 8 9

4 5 6

1 2 3

. 0 -

← ←

← ↑ →

↓

Screen 13 - VIRTUAL I/O STATUS

**FORCE REAL INPUTS**

IN 1	IN 2
IN 3	IN 4
IN 5	IN 6
IN 7	IN 8

7	8	9
4	5	6
1	2	3
.	0	-
←	←	

←	↑	→
	↓	

*F1	*F2	*F3	*F4	*F5
*F6	*F7	*F8	*F9	*F10

Screen 14 - FORCE REAL INPUTS

FORCE REAL OUTPUTS

OUT1	OUT2
OUT3	OUT4
OUT5	OUT6
OUT7	OUT8

\*F1 \*F2 \*F3 \*F4 \*F5  
\*F6 \*F7 \*F8 \*F9 \*F10

7	8	9
4	5	6
1	2	3
.	0	-
←	↶	
←	↑	→
	↓	

Screen 15 - FORCE REAL OUTPUTS

FORCE VIRTUAL INPUTS

IN 17		IN 18
IN 19		IN 20
IN 21		IN 22
IN 23		IN 24

\*F1 \*F2 \*F3 \*F4 \*F5

\*F6 \*F7 \*F8 \*F9 \*F10

7 8 9

4 5 6

1 2 3

. 0 -

← ↵



← ↑ →






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Screen 16 - FORCE VIRTUAL INPUTS

**FORCE VIRTUAL MAPS**

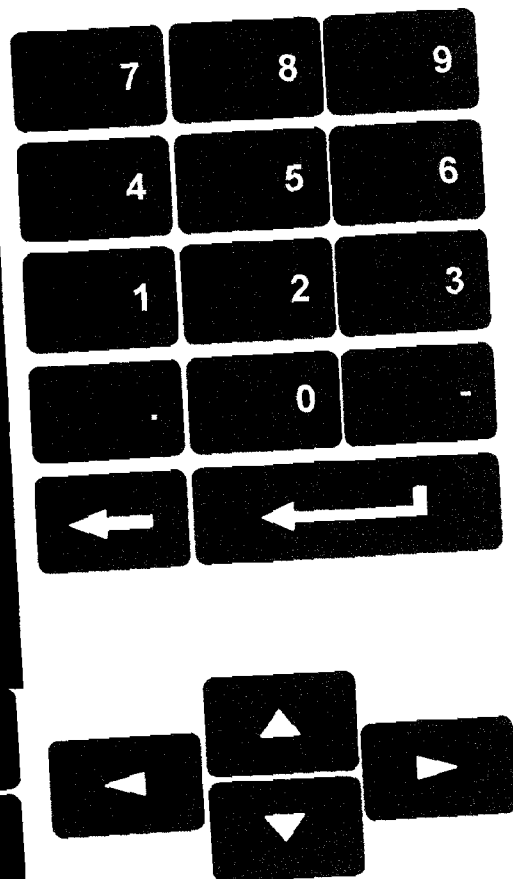
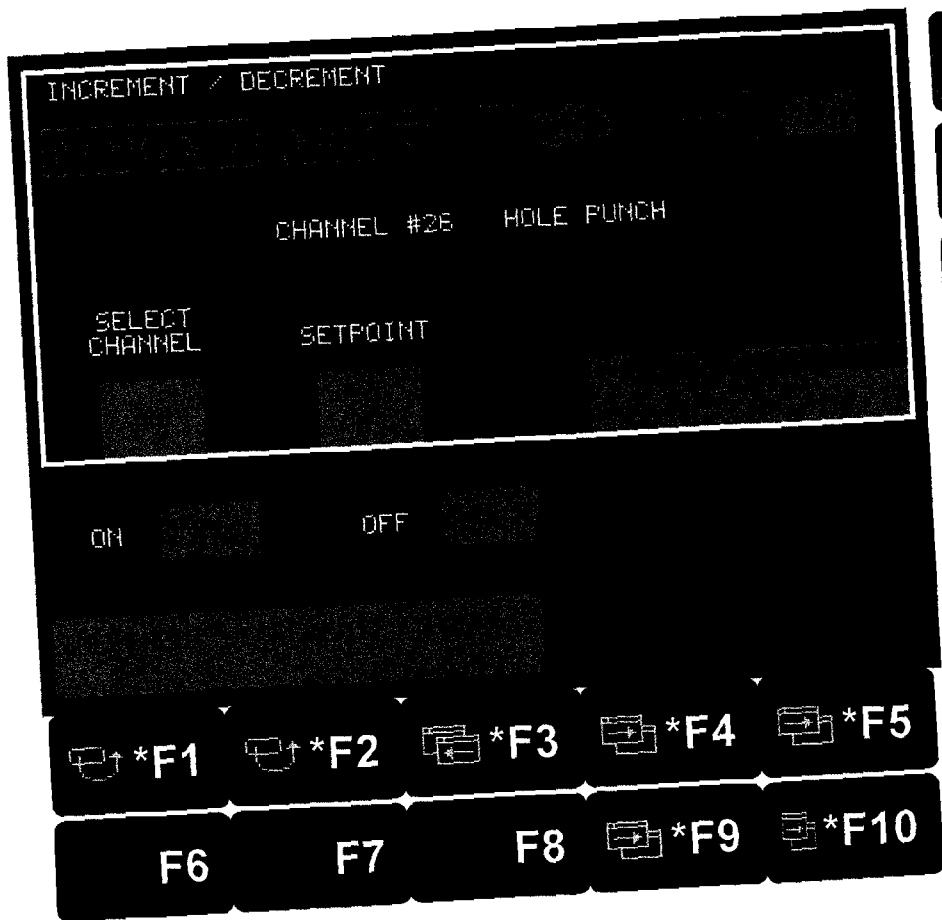
OUT17	OUT18
OUT19	OUT20
OUT21	OUT22
OUT23	OUT24
OUT25	OUT26
OUT27	OUT28
OUT29	OUT30
OUT31	OUT32

**F1**   **F2**   **F3**    **\*F4**    **\*F5**

 **\*F6**    **\*F7**    **\*F8**    **\*F9**    **\*F10**

7	8	9
4	5	6
1	2	3
.	0	-
		
	 	

Screen 17 - FORCE VIRTUAL OUTPUTS



Screen 18 - INC/DEC

THE MACHINE IS AT THE WRONG POSITION  
TO JOG THE SERVO.

CODE NUMBER

\*F1 F2 F3 \*F4 \*F5  
F6 F7 F8 \*F9 \*F10

7 8 9  
4 5 6  
1 2 3  
. 0 -  
← ←



← ↑ →  
↓

Screen 19 - MESSAGE SCREEN



SET-UP ERROR TYPE



GROUP ERROR TYPE



LIMIT SWITCH ERROR TYPE




OUTPUT NUMBER  SETPOINT 




 \*F1    F2    F3     \*F4     \*F5

F6    F7    F8     \*F9     \*F10

7	8	9
4	5	6
1	2	3
.	0	-
		



Screen 20 - ERROR SCREEN



TIME 2H:MM:SS      DATE MM/DD/YYYY

SERVO    FILLER    FILLER    FILLER  
#1       #2       #3

**ADVANTAGE LINKER SYSTEM**

STATUS    ACCESSORY    VACUUM    PNEUMATIC    PRGSEL  
(F1)       (F2)       (F3)       (F6)       (F7)

\*F1   \*F2   \*F3   \*F4   F5

\*F6   \*F7   F8   \*F9   \*F10

7 8 9

4 5 6

1 2 3

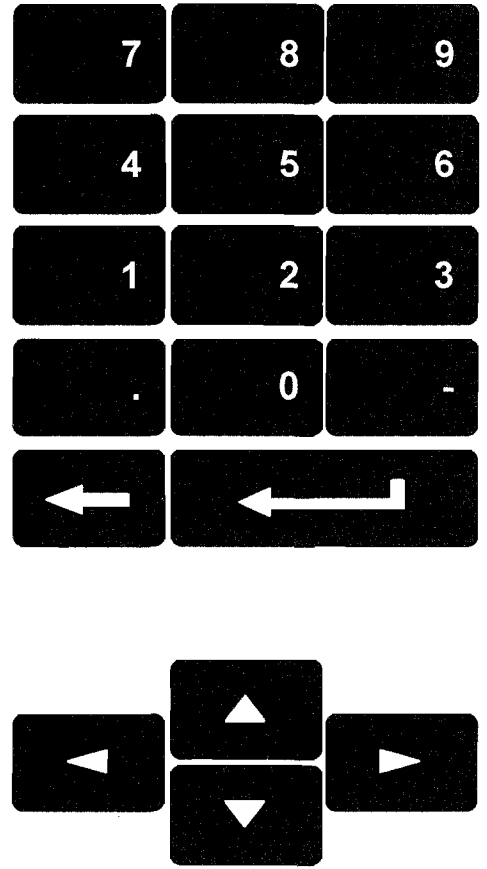
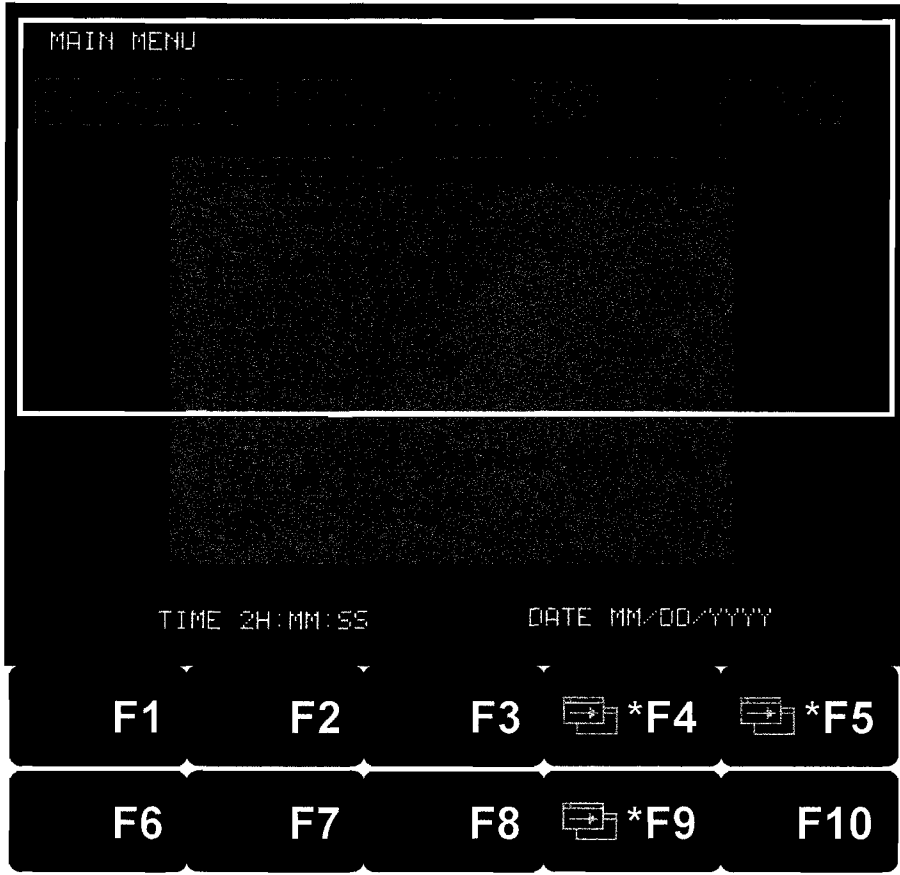
. 0 -

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Screen 22 - MACHINE LAYOUT



Screen 23 - MAIN MENU

AIR ON (F1)      AIR OFF (F2)

OFF

MACHINE  
RESET  
F3

ENABLE ALL MOTORS (F6)

GUARDS BYPASSED

AIR PRESSURE OK

MOTORS ENABLED

TORQUE OVERLORD OK

MOVE TO REGISTRATION

TIME 2H:MM:SS      DATE MM/DD/YYYY

\*F1 \*F2 \*F3 \*F4 \*F5

\*F6 \*F7 \*F8 \*F9 \*F10

7 8 9

4 5 6

1 2 3

. 0 -

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← ↑ →

← ↓ →

Screen 24 - START-UP

KEYWAY IS UP AT 90 DEGREES

REAR                      MAIN SHAFT                      FRONT

1. JOG MACHINE UNTIL KEYWAY IS ALMOST AT THE UP POSITION.
2. PLACE A LEVEL ON THE KEYWAY AND CONTINUE TO "BUMP" THE MAIN SHAFT UNTIL YOU REACH LEVEL.
3. THE MAIN SHAFT IS NOW AT 90 DEGREES.
4. PRESS F8 AND ENTER 90.
5. THE OFFSET HAS NOW BEEN SET. THE POSITION INDICATOR SHOULD DISPLAY 90 WHENEVER THE MAIN SHAFT KEYWAY IS STRAIGHT UP.

POSITION = 90

F1      F2      F3      \*F4      \*F5

F6      F7      \*F8      \*F9      \*F10

7      8      9

4      5      6

1      2      3

.      0      -

←      ←

←      ↑      →

    ↓     

Screen 25 - MACHINE OFFSET


		NO POUCH FAILURE		
		LSWF WAS TRIPPED		
REGISTRATION OFF		HOLE PUNCH OFF		
*F1	F2	F3	*F4	*F5
F6	F7	F8	*F9	*F10

7	8	9
4	5	6
1	2	3
.	0	-
←	↶	
←	↑	→
	↓	


Screen 26 - MACHINE STATUS

VACUUM OPENERS

FILLER #1 (F1)      FILLER #2 (F2)      FILLER #3 (F3)

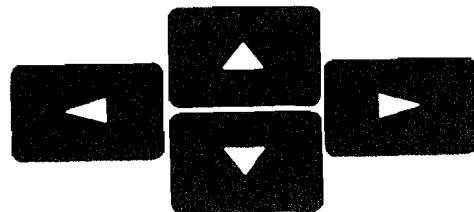
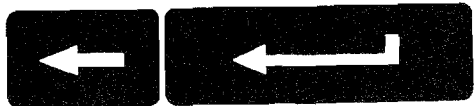
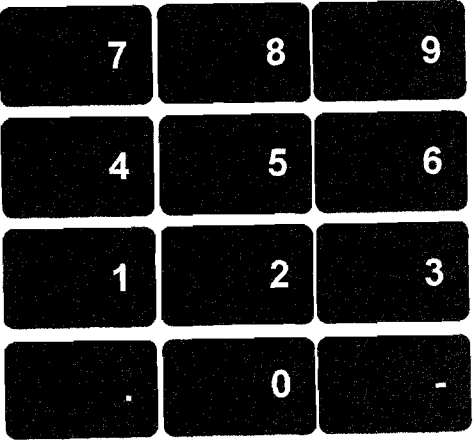


VACUUM PICKOFF (F8)



\*F1 \*F2 \*F3 \*F4 \*F5

F6 \*F7 \*F8 \*F9 \*F10



Screen 27 - VACUUM

FILLER #1 FILL CONTROL (SCREEN #1)

FILLER TYPE      MANUAL FILL (F6)

F1   \*F2   F3   \*F4   \*F5

\*F6   F7   F8   \*F9   \*F10

7 8 9

4 5 6

1 2 3

. 0 -

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←   ↑   →

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Screen 28 - FILLER1

ACCESSORIES

SERVO FEEDROLL F1	SHREDDER F2
PRODUCT SETTLER F7	LABELER DATE CODE F8

\*F1 \*F2 F3 \*F4 \*F5  
\*F6 \*F7 \*F8 \*F9 \*F10

7	8	9
4	5	6
1	2	3
.	0	-
←	←	
←	↑	→
	↓	

COUNTER/RUN TIMER

POUCHES FILLED PER-SHIFT

TOTAL POUCHES FILLED

INDEX COUNTER

RUN TIME DAYS ##### HR ## MIN ##

TIME 2H:MM:SS DATE MM/DD/YYYY

\*F1 \*F2 F3 \*F4 \*F5

F6 F7 F8 \*F9 \*F10

7 8 9

4 5 6

1 2 3

. 0 -

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Screen 30 - PARTS COUNTER/RUN TIME

PRODUCT SETTLER#1  
(F1)

PRODUCT  
SETTLER  
ON


\*F1 \*F2 F3 \*F4 \*F5  
F6 F7 F8 \*F9 \*F10

7 8 9  
4 5 6  
1 2 3  
. 0 -  
← ←

← ↑ →  
↓

PNEUMATICS

F(1)



\*F1 F2 \*F3 \*F4 \*F5

F6 F7 F8 \*F9 \*F10

7 8 9

4 5 6

1 2 3

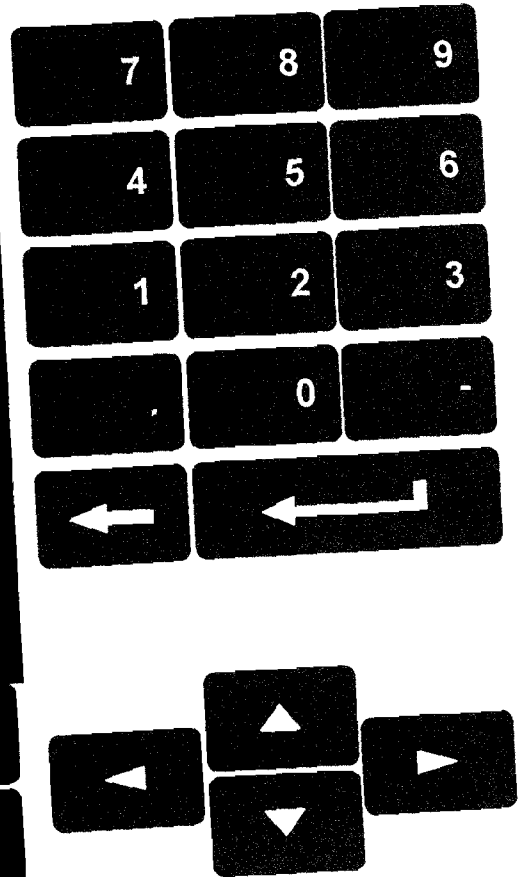
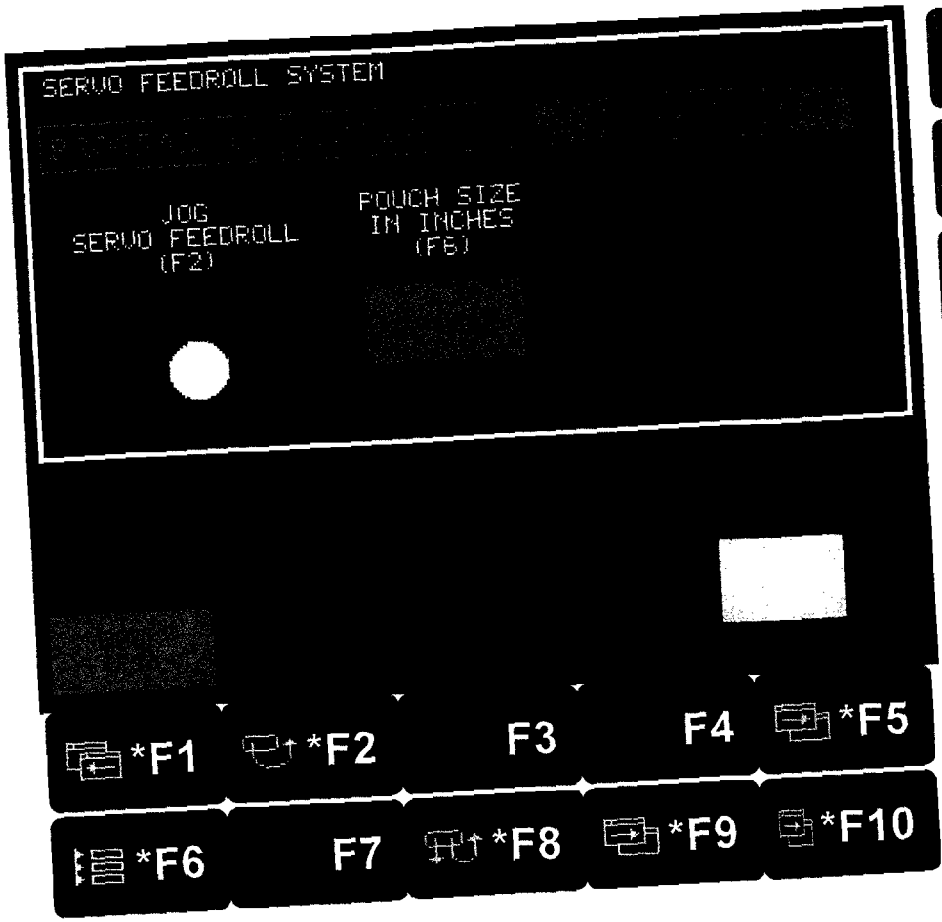
. 0 -

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▼ ▶





Screen 39 - Servo Feedroll

\*\*\* WARNING \*\*\*  
Homming this machine may cause  
automatic movment!

Make sure all personnel and equipment  
are clear before you home this machine!

Press "GO" or F1 to home the machine.

Press "STOP" or F2 to exit this  
operation.

GO  
(F1)

\*F1 \*F2 F3 \*F4 \*F5  
F6 F7 F8 \*F9 \*F10

7 8 9  
4 5 6  
1 2 3  
. 0 -  
← ↵  
← ↑ →  
↓

\*\*\* CAUTION \*\*\*

Jogging or Homming this machine is not allowed while the machine is in the "RUN" mode!

\*F1 F2 F3 \*F4 \*F5

F6 F7 F8 \*F9 \*F10

7 8 9

4 5 6

1 2 3

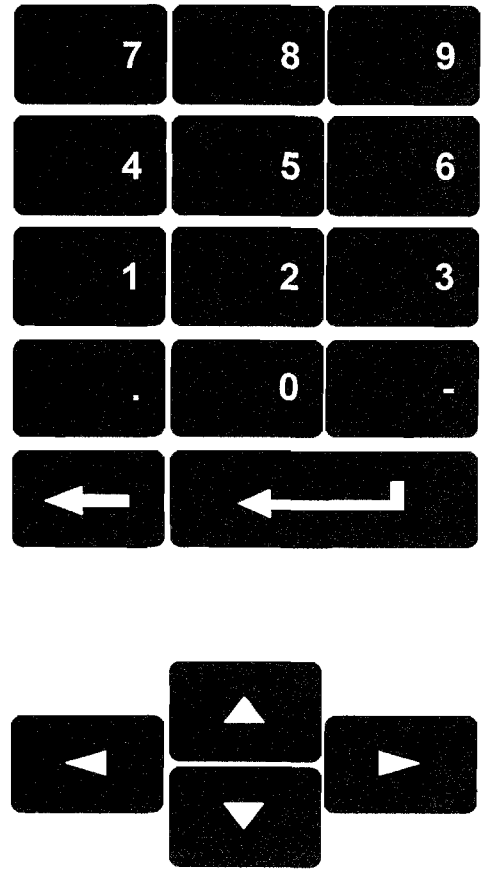
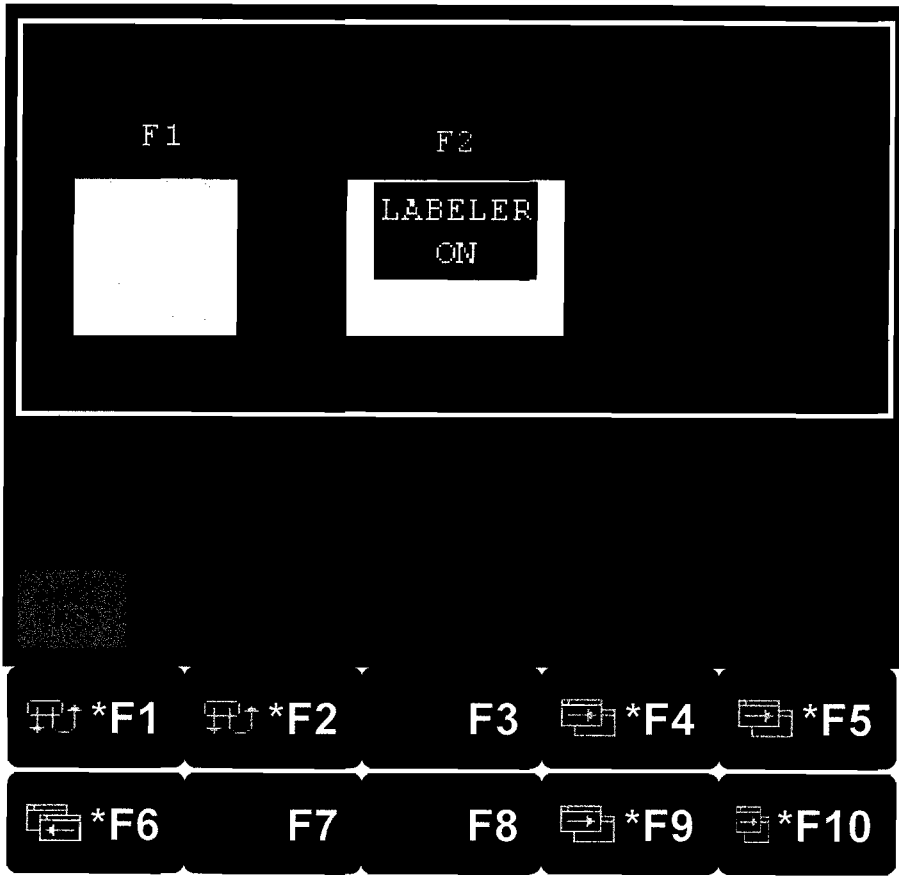
. 0 -

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Screen 41 - Servo Run Mode Caution



Screen 42 - LABELER DATE CODE

**Amurool  
Confections<sup>®</sup>**

2800 N. ROUTE 47 YORKVILLE, IL. 60560

MACHINE NUMBER 2573

**ADVANTAGE CONTROL SYSTEMS**

\*F1 F2 F3 F4 F5

F6 F7 F8 F9 F10

7 8 9

4 5 6

1 2 3

. 0 -

← ↵

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↶ ↷

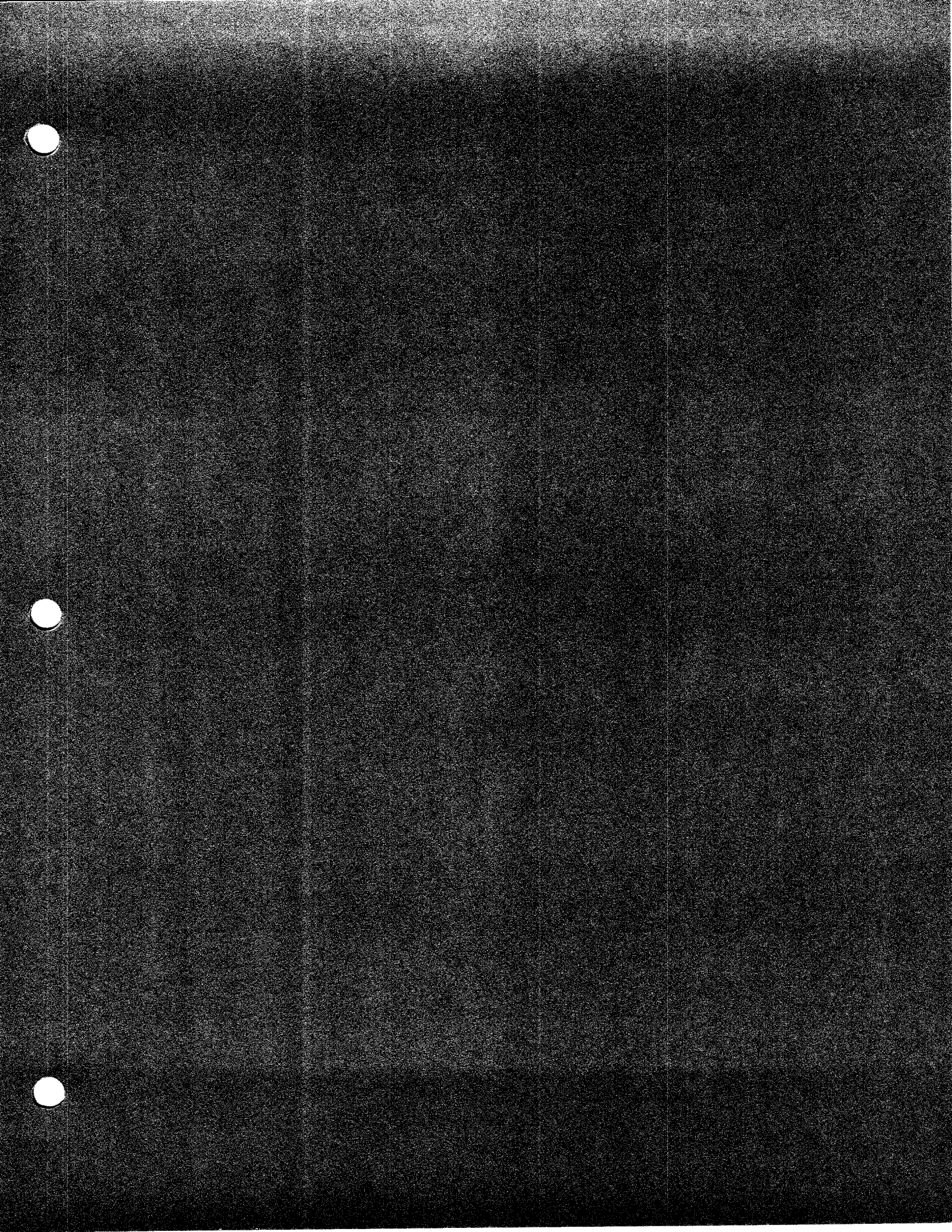
POSITION STOP NORMAL STOP  
FILLER#1 PUSH BUTTON PUSHED IN

Ack

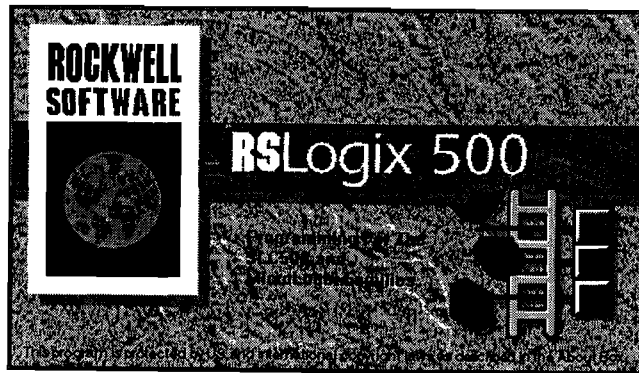
F1 F2 F3 F4 F5  
F6 F7 F8 F9 F10

7 8 9  
4 5 6  
1 2 3  
. 0 -  
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← ↑ →  
↓ →

Screen Alarm Banner



RSLogix500 Project Report



Processor Information

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Processor Type: 1747-L541C 5/04 CPU - 16K Mem. OS401 Series C FRN 3-8

Processor Name: 2573

Total Memory Used: 3402 Instruction Words Used - 4655 Data Table Words Used

Total Memory Left: 7130 Instruction Words Left

Program Files: 26

Data Files: 54

Program ID: 2195

## I/O Configuration

---

0	1747-L541C	5/04 CPU - 16K Mem. OS401 Series C F
1	1746-IB32	32-Input (SINK) 24 VDC
2	1746-OA16	16-Output (TRIAC) 100/240 VAC
3	OTHER	I/O Module - ID Code = 9935
4	1746-OA16	16-Output (TRIAC) 100/240 VAC
5	1746-OX8	8-Output Isolated Relay
6		
7	1747-SDN	DeviceNet Scanner Module
8		
9		

## Channel Configuration

## GENERAL

Channel 1 Write Protected: No  
Channel 1 Edit Resource/Owner Timeout: 60  
Channel 1 Passthru Link ID: 2  
  
Channel 0 Write Protected: No  
Channel 0 Edit Resource/Owner Timeout: 60  
Channel 0 Passthru Link ID: 1  
Channel 0 Current Mode: System  
Channel 0 Mode Change Enabled: No  
Channel 0 Mode Change Attention Character: \1b  
Channel 0 Mode Change System Character: S  
Channel 0 Mode Change User Character: U

## CHANNEL 1 (SYSTEM) - Driver: DH+

Node : 1 (octal)  
Baud: 57.6K

## CHANNEL 0 (SYSTEM) - Driver: DH485

Node : 1 (decimal)  
Baud: 19200  
Token Hold Factor: 1  
Max Node Address: 31

## CHANNEL 0 (USER) - Driver: ASCII

Baud: 19200  
Parity: NONE  
Stop Bits: 1  
Data Bits: 8  
Control Line : No Handshaking  
Dtelete mode: Ignore  
Echo: No  
XON/XOFF: No  
Termination Character 1: \d  
Termination Character 2: \ff  
Append Character 1: \d  
Append Character 2: \a

## Program File List

---

Name	Number	Type	Rungs	Debug	Bytes
[EM]	0	SYS	0	No	0
	1	SYS	0	No	0
	2	LADDER	185	No	9385
	3	LADDER	12	No	736
	4	LADDER	7	No	429
	5	LADDER	7	No	525
	6	LADDER	11	No	721
	7	LADDER	7	No	425
	8	LADDER	107	No	1712
	9	LADDER	20	No	653
	10	LADDER	14	No	1136
	11	LADDER	6	No	299
	12	LADDER	5	No	180
	13	LADDER	7	No	474
	14	LADDER	2	No	65
	25	LADDER	12	No	567

Address/Symbol Database

Address	Symbol	Scope	Description	S:
	I	Global		
	N	Global		
B3:1	RESET	Global	subroutine OSRs	
B3:2			subroutine OSRs	
B3:3			PLS DO NOT USE	
B3:4			PLS DO NOT USE	
B3/80			START ALL MOTORS PB. IN PANEL VIEW	
B3/81			MAIN AIR SUPPLY ON P.B. (IN) PANEL VIEW	
B3/82			MAIN AIR SUPPLY OFF P.B. (IN) PANEL VIEW	
B3/83			VACUUM ON-OFF SELECTOR SWITCH IN PANELVIEW	
B3/84			VACCUM OPENER #1 SELECTOR SWITCH IN PANEL VIEW	
B3/85			VACCUM OPENER #2 SELECTOR SWITCH IN PANEL VIEW	
B3/86			VACCUM OPENER #3 SELECTOR SWITCH IN PANEL VIEW	
B3/87			FILLER#1 MANUAL FILL PB IN PANELVIEW	
B3/88			FILLER#2 MANUAL FILL PB IN PANELVIEW	
B3/89			FILLER#3 MANUAL FILL PB IN PANELVIEW	
B3/90			VACUUM PICK-OFF SS (IN) PANEL VIEW 550	
B3/91			REGISTRAT- -ION LATCH ON CR	
B3/92			CRWF-1 FAILURE NO-BAG PRESENT	
B3/93			START ALL MOTORS CR	
B3/94			POSITION STOP CR	
B3/95			START ALL FILLERS CR	
B3/96			CRWF-2 WEB FAILURE LSWF WAS TRIPPED	
B3/97			GAS FLUSH (PRIOR TO TOP SEAL) SELECTOR IN PANEL VIEW	
B3/98			FIFE EDGE GIUDE SELECTOR IN PANEL VIEW	
B3/99			CLEAR ERROR AND RETURN MACHINE LAYOUT SCREEN PB IN PANEL VIEW	
B3/100			AMCI PROGRAMABLE LIMIT SWITCH FAILURE	
B3/101			CLEAR DAY PARTS COUNTER PB IN PANEL VIEW	
B3/102			CLEAR SHIFT PARTS COUNTER PB IN PANEL VIEW	
B3/103			AUTO-OFFSET FOR MACHINE POSITION	
B3/104			TOP SEAL HOLE PUNCH PB IN PANEL VIEW	
B3/105			TORQUE OVERLOAD CR	
B3/106			FILLER #1 TRAILING EDGE ACTUATOR SELECTOR IN PANEL VIEW	
B3/107			FILLER #2 TRAILING EDGE ACTUATOR SELECTOR IN PANEL VIEW	
B3/108			FILLER #3 TRAILING EDGE ACTUATOR SELECTOR IN PANEL VIEW	
B3/109			PICKOFF TRAILING EDGE ACTUATOR SELECTOR	
B3/110			GUSSET HOLE PUNCH SELECTOR IN PANELVIEW	
B3/111			ZIPPER POWER UNWIND SELECTOR IN PANEL VIEW	
B3/112			WEB POWER UNWIND SELECTOR IN PANELVIEW	
B3/113			PRINTER ON OFF SELECTOR IN PANELVIEW	
B3/114			SEALBAR ON/OFF SELECTOR	
B3/115			AIR CURTIN SELECTOR	
B3/116			HOLE PUNCH OFF-ON SELECTOR IN PANEL VIEW	
B3/117			SIDE & TOP SEAL COOLING SELECTOR IN PANEL VIEW	
B3/118			WIRE OPENER ON-OFF SELECTOR	
B3/119			START MACHINE AUTO OFFSET	
B3/120			VACUUM OPENERS NOT ON IND. IN PANEL VIEW	
B3/121			TEA. OFF IND. IN PANEL VIEW	
B3/122			FILLER#1 GAS FLUSH ASSIST SEL.	
B3/123			FILLER#2 GAS FLUSH ASSIST SEL.	
B3/124			FILLER#3 GAS FLUSH ASSIST SEL.	
B3/125			ON-DEMAND CYCLE ENABLED	
B3/126			ON-DEMAND POS. STOP	
B3/127			ON-DEMAND RESTART MACHINE	
B3/128			BAG-RETURN	
B3/129			WIRE OPENER DIVER MANUAL PB	
B3/130			WIRE OPENER OPEN MANUAL PB	
B3/131			WIRE OPENER MANUAL PB ON IND.	
B3/132			GAS FLUSH DIVER MANUAL PB	
B3/133			BAG PRESENT	
B3/134			NO-BAG FAILURE CALLUP ERROR SCREEN	
B3/135			START ALL FILLERS SS ONE SHOT	
B3/136			FILLER1 FILLED	
B3/137			FILLER2 FILLED	
B3/138			FILLER3 FILLED	
B3/139			PRODUCT SETTLER #1 SELECTOR IN PANELVIEW	
B3/140			PRODUCT SETTLER #2 SELECTOR IN PANELVIEW	
B3/141			BAG REJECT SEL. IN PANELVIEW	
B3/142			DATE CODEER SELECTOR IN PANELVIEW	
B3/143			LABELER SELECTOR IN PANELVIEW	
B3:9			OSR	
B3/144			OSR	
B3/145			ONE/SHOT	
B3/146			OSR	
B3/147			OSR	
P 8			OSR	
3			OSR	
B3/150			OSR	
B3/160			SHRED CONVEYOR ON-OFF PB	
B3/161			SHRED RAM on off PB	

## Address/Symbol Database

Address	Symbol	Scope	Description	S:
B3/162			SHRED_RAM MODE IN PANELVIEW	
F				
E				
B3/165				
B3/167				
B3/176				
B3/177				
B3/178				
B3/179				
B3/180				
B3/181				
B3/182				
B3/183				
B3/184				
B3/185				
B3/186				
B3/187				
B3/208				
B3/209				
B3/210			PLS DOWNLOADING ALLOW ONE SCAN	
B3/211			COMPARE FOR SELECTOR CHANGE ALLOW ONE SCAN	
B3/212			PLS DOWNLOADING	
B3/213				
B3/214				
B3/215				
B3:14				
B3/224			JOG FEEDROLL PB IN PANELVIEW	
B3/225			DISABLE SERVO PB IN PANELVIEW	
B3/226			HOME SERVO PB IN PANELVIEW	
B3/227			START_HOME_SEQ	
B3/233				
B3:15			THIS BSR KEEPS TRACK OF POUCHES FOR FILLER CONTROL AND PICK-OFF CONTROL	
B3/243			POUCH PRESENT	
B3/244			POUCH PRESENT	
B3/245				
B3/246			BAG PRESENT AT PICKOFF	
B3/247			POUCH PRESENT AT TOP SEAL HOLE PUNCH	
B3/250			GOOD BAG PRES. AT GAS FLUSH STA	
B3/251			BAG PRESENT AT FILLER3 FORM BSR R6:0	
F			BAG PRES ONE STA PAST FILLER 2	
B3/253			BAG PRESENT AT FILLER #2 FORM BSR R6:0	
B3/254			BAG PRESENT ONE STA. PAST FILLER1	
B3/255			BAG PRESENT AT FILLER #1 FORM BSR R6:0	
B3/256				
B3/257			START HOME SEQ. CR FOR MAIN DRIVE	
B3/259			HOME SERVO CR	
B3/272			GUARD OPEN	
B3/288			SHREDDER_START_conve yor	
B3/289			SHREDDER_STOP CONVEYOR	
B3/290			MANUAL CYCLE RAM	
B3/291			ADVANCE TO REGISTRATION	
C5:0			SHIFT PARTS UNDER 1000 COUNTER	
C5:0/DN			PARTS UNDER 1000 COUNTER	
C5:1			SHIFT PARTS OVER 1000 COUNTER	
C5:2			REGISTRATION FAILURE COUNTER	
C5:2/DN			REGISTRATION FAILURE COUNTER	
C5:3			UP COUNTS EVERY MINUTE DONE/BIT SETS EVERY HOUR	
C5:3/DN			DONE/BIT SETS EVERY HOUR FOR HOUR COUNTER	
C5:4			HOUR COUNTER SETS DONE/BIT FOR DAY COUNTER	
C5:4/DN			HOUR COUNTER DONE/BIT SETS FOR DAY COUNTER	
C5:5			UP COUNTS FOR EVERY DAY OFF RUN TIME	
C5:5/DN			RESETS DAY COUNTER AUTOMATICLY AFTER 32765 DAYS OF RUN TIME 32765DY.=89.7YR.	
C5:6			WEB FAILURE SELECTOR NOT ON ALLOW 3 INDEXES BEFORE POSTION STOP	
C5:6/DN			WEB FAILURE SELECTOR NOT ON ALLOW 3 INDEXES BEFORE POSTION STOP	
C5:7			DAY PARTS UNDER 1000 COUNTER	
C5:7/DN			DAY PARTS UNDER 1000 COUNTER	
C5:8			DAY PARTS OVER 1000 COUNTER	
C5:9			INDEX COUNTER1	
C5:10			INDEX COUNTER2	
C5:10/DN				
C5:11			NO-BAG EYE BLOCKED	
C5:11/DN				
C5:13			ACS LOGO COUNTER	
I:1.0/0			EMERGANCY STOP PB #1	
I:1.0/1			EMERGANCY STOP PB #2	
I:1.0/2			GUARDS BYPASSED S ELECTOR	
I			POSITION STOP PB	
I			RUN - JOG SELECTOR SWITCH	
I:1.0/5			MACHINE START PB	
I:1.0/6			START ALL FILLERS SS	
I:1.0/7			WEB FAILURE SELECTOR SWITCH	

Address/Symbol Database

Address	Symbol	Scope	Description	S:
I:0/8			MAIN AIR PRESSURE SWITCH	
I:0/9			TORQUE OVERLOAD LIMIT SWITCH	
I:0/10			POWER UNWIND GUARD OPEN	
I:1.0/11			MANUAL REGISTRATI -ON RESET	
I:1.0/12			NO-BAG PHOTO-EYE	
I:1.0/13			TRI-TRONIC PHOTO-EYE	
I:1.0/14			LIMIT SWITCH LSWF	
I:1.0/15			ZIPPER FAILURE LIMIT SWITCH	
I:1.1/0			PROGRAM ENABLE MASTER	
I:1.1/1			REGISTRATION SELECTOR	
I:1.1/2			BAG-RETURN PHOTOEYE	
I:1.1/3				
I:1.1/4			GUARD #0	
I:1.1/5			GUARD #1	
I:1.1/6			GUARD #2	
I:1.1/7			GUARD #3	
I:1.1/8			GUARD #4	
I:1.1/9			GUARD #5	
I:1.1/10			GUARD #6	
I:1.1/11			GUARD #7	
I:1.1/12			GUARD #8	
I:1.1/13			GUARD #9	
I:1.1/14			GUARD #10	
I:1.1/15			GUARD #11	
I:3.0/8			MOTION DETECT 1	
I:3.1			MACHINE POSITION IN DEG.	
I:3.2			MAIN CYCLE SHAFT RPM	
I:3.3/0			CHANNEL #1 PSVOBB VACUUM OPENER BLOW BACK	
I:3.3/1			CHANNEL #2 PSFC-1 FILL CONTROL FILLER #1	
I:3.3/2			CHANNEL #3 PSFC-2 FILL CONTROL FILLER #2	
I:3.3/3			CHANNEL #4 PSFC-3 FILL CONTROL FILLER #3	
I:3.3/4			CHANNEL #5 PS	
I:3.3/5			CHANNEL #6 PSGHPSB GUSSET HOLE PUNCH SLUG BLOWER	
I:3.3/6			CHANNEL #7 PS SHRED CONVEYOR	
I:3.3/7			CHANNEL #8 PS SHRED RAM	
I:3.3/8			CHANNEL #9 PS	
I:3.3/9			CHANNEL #10 PS	
I:3.3/10			CHANNEL #11 PS	
I:3.3/11			CHANNEL #12 PS	
I:3.3/12			CHANNEL #13 PS	
I:3.3/13			CHANNEL #14 PS	
I:3.3/14			CHANNEL #15 PS	
I:3.3/15			CHANNEL #16 PS	
I:3.4/0			CHANNEL #17 PSB MAIN DRIVE BRAKE	
I:3.4/1			CHANNEL #18 PSBR POUCH RETURN TIMING	
I:3.4/2			CHANNEL #19 PSR REGISTRATION RESET	
I:3.4/3			CHANNEL #20 PS VACUUM OPENERS BLOW BACK	
I:3.4/4			CHANNEL #21 AIR-JET	
I:3.4/5			CHANNEL #22 PSVO-1 VACCUM OPENER 1	
I:3.4/6			CHANNEL #23 PSVO-2 VACUUM OPENER 2	
I:3.4/7			CHANNEL #24 PSVO-3 VACCUM OPENER #3	
I:3.4/8			CHANNEL #25 PSVPO VACCUM PICKOFF	
I:3.4/9			CHANNEL #26 PSGHP GUSSET HOLE PUNCH	
I:3.4/10			CHANNEL #27 PSCD CODE DATE	
I:3.4/11			CHANNEL #28 PSLABELER LABELER	
I:3.4/12			CHANNEL #29 PSTEAF-3 FILLER #3 TRAILING EDGE ACTUATOR	
I:3.4/13			CHANNEL#30 PSVPBB PICKOFF BLOW BACK	
I:3.4/14			CHANNEL#31 ESTEAP0 PICKOFF TRAILING EDGE ACTUATOR	
I:3.4/15			Channel#32 PSTO TORQUE OVERLOAD	
I:7.0/15			Scanner response received	
M0:5.0				
M0:5.1				
M0:5.20				
M0:5.22				
M1:5.0				
M1:5.2				
N7:4/0			clear error bit	
N7:9	SCREEN	Global	control set to access message	
N7:10	TEST	Global	screen changed from last scan	
N7:11	STORE	Global	current scan's active screen #	
N7:12	SAVES	Global	previous screen number	
N7:13			FALT CODE NUMBER	
N7:13/0			access denied message	
N7:13/1			command denied message	
N7:13/2			NO-BAG FAILURE CALLUP ERROR SCREEN	
N7:13/3				
N7:13/4				
N7:13/5			LOCKED ROTOR FAULT	
N7:13/6			TORQUE OVERLOAD	
N7:13/7			FUNNEL OVERLOAD	
N7:20			input imag table to integer file	

Address/Symbol Database

Address	Symbol	Scope	Description	S:
N7:20/0			set-up error	
N7:20/1			Group error	
N7:20/2			Limit Switch error	
N7:20/4			setpoint error	
N7:20/7	TRANSDUCER	Global	fault	
N7:20/10			Tach Overflow error	
N7:20/15			LS aknowledge bit	
N7:30			setup command word for verifying	
N7:31	DISPLAYS	Global	setup stat us in integer table	
N7:37/2				
N7:40	COPIES	Global	group stat us into integer file	
N7:50			status to integer file	
N11:0				
N11:0/15			transmit config data	
N11:14/15			group data transmit	
N11:15/15			Limit Swit ch transmi t bit	
N12:0			CHANNEL SELECTOR IN PANEL VIEW	
N12:3			output type	
N12:4			on setpnt	
N12:5			off setpnt	
N12:7			output type	
N12:8			on setpnt	
N12:9			off setpnt	
N12:11			output type	
N12:12			on setpnt	
N12:13			off setpnt	
N12:15			output type	
N12:16			on setpnt	
N12:17			off setpnt	
N12:18			Channel 1 ON advance	
N12:19			Channel 1 OFF advnce	
N12:20			Channel 2 ON advance	
N12:21			Channel 2 OFF Advnce	
N12:22			ON advance	
N12:23			Channel 3 OFF advnce	
N12:24			Channel 4 ON advance	
N12:25			Channel 4 OFF advnce	
N12:26			Channel 1 motion ANDing	
N12:27			channel 2 motion ANDing	
N12:28			Channel 3 motion ANDing	
N12:29			Channel 4 Motion ANDing	
N12:30			Channel 1 qty/length	
N12:31			Channel 1 pulse duration	
N12:32			Channel 2 qty/length	
N12:33			Channel 2 pulse duration	
N12:34			Channel 3 qty/length	
N12:35			Channel 3 pulse duration	
N12:36			Channel 4 qty/length	
N12:37			Channel 4 pulse duration	
N12:38			Group position	
N12:40				
N12:42				
N12:43	INDEX	Global	value same as last scan	
N12:44			value same as last scan	
N12:45				
N12:48			current scan's channel index	
N12:49			current scan's setpoint index	
N12:50	PROGRAM	Global	function 1=edit 2=copy 3=load	
N12:50/0			edit command	
N12:50/1			copy command: both on load command	
N12:51	SELECTED	Global	program number	
N12:52			program number	
N12:53			selected program to load prg address	
N12:54/0			command selected	
N12:54/1			loaded program same as edit program	
N12:56/0			edits allowed	
N12:59			CODE# ENTERD IN BY PANEL VIEW	
N12:60			Channel 1 Enable ANDing	
N12:61			Channel 2 Enable ANDing	
N12:62			Channel 3 Enable ANDing	
N12:63			Channel 4 Enable ANDing	
N12:71			number of outputs in group	
N12:73			Group offset	
N12:74			Group window ON	
N12:75			Group Window OFF	
N12:76			group same as last scan	
N12:77			Group index from previous scan	
N12:78			Group mode	
N12:79			Group enable, type, and first cycle type	
N12:100/0			off	
N12:100/1			force inl on	

Address/Symbol Database

Address	Symbol	Scope	Description	S:
N12:101/0			force in2 off	
F 01/1			force in2 on	
N 02/0			force in3 off	
N12:102/1			force in3 on	
N12:103/0			force in4 off	
N12:103/1			force in 4 on	
N12:104/0			force in5 off	
N12:104/1			force in 5 on	
N12:105/0			force in6 off	
N12:105/1			force in 6 on	
N12:106/0			force in7 off	
N12:106/1			force in 7 on	
N12:107/0			force in8 off	
N12:107/1			force in 8 on	
N12:108/0			force in9 off	
N12:108/1			force in 9 on	
N12:109/0			force in10 off	
N12:109/1			force in10 on	
N12:110/0			force in11 off	
N12:110/1			force in11 on	
N12:111/0			force in12 off	
N12:111/1			force in12 on	
N12:112/0			force in13 off	
N12:112/1			force in13 on	
N12:113/0			force in14 off	
N12:113/1			force in14 on	
N12:114/0			force in15 off	
N12:114/1			force in15 on	
N12:115/0			force in16 off	
N12:115/1			force in16 on	
N12:120/0			force out ch 1 off	
N12:120/1			force out ch 1 on	
N12:121/0			force out ch 2 off	
N12:121/1			force out ch 2 on	
N12:122/0			force out ch 3 off	
N12:122/1			force out ch 3 on	
N12:123/0			force out ch 4 off	
N12:123/1			force out ch 4 on	
N 124/0			force out ch 5 off	
I 24/1			force out ch 5 on	
N 25/0			force out ch 6 off	
N12:125/1			force out ch 6 on	
N12:126/0			force out ch 7 off	
N12:126/1			force out ch 7 on	
N12:127/0			force out ch 8 off	
N12:127/1			force out ch 8 on	
N12:128/0			force out ch 9 off	
N12:128/1			force out ch 9 on	
N12:129/0			force out ch 10 off	
N12:129/1			force out ch 10 on	
N12:130/0			force out ch 11 off	
N12:130/1			force out ch 11 on	
N12:131/0			force out ch 12 off	
N12:131/1			force out ch 12 on	
N12:132/0			force out ch 13 off	
N12:132/1			force out ch 13 on	
N12:133/0			force out ch 14 off	
N12:133/1			force out ch 14 on	
N12:134/0			force out ch 15 off	
N12:134/1			force out ch 15 on	
N12:135/0			force out ch 16 off	
N12:135/1			force out ch 16 on	
N12:140/1			force in ch 17 on	
N12:141/1			force in ch 18 on	
N12:142/1			force in ch 19 on	
N12:143/1			force in ch 20 on	
N12:144/1			force in ch 21 on	
N12:145/1			force in ch 22 on	
N12:146/1			force in ch 23 on	
N12:147/1			force in ch 24 on	
N12:150/0			force out ch 17 off	
N12:151/0			force out ch 18 off	
N12:151/1			force out ch 18 on	
N12:152/0			force out ch 19 off	
N12:152/1			force out ch 19 on	
N12:153/0			force out ch 20 off	
F 53/1			force out ch 20 on	
L 54/0			force out ch 21 off	
N12:154/1			force out ch 21 on	
N12:155/0			force out ch 22 off	
N12:155/1			force out ch 22 on	

Address/Symbol Database

Address	Symbol	Scope	Description	S:
N12:156/0			force out ch 23 off	
N12:156/1			force out ch 23 on	
N12:157/0			force out ch 24 off	
N12:157/1			force out ch 24 on	
N12:158/0			force out ch 25 off	
N12:158/1			force out ch 25 on	
N12:159/0			force out ch 26 off	
N12:159/1			force out ch 26 on	
N12:160/0			force out ch 27 off	
N12:160/1			force out ch 27 on	
N12:161/0			force out ch 28 off	
N12:161/1			force out ch 28 on	
N12:162/0			force out ch 29 off	
N12:162/1			force out ch 29 on	
N12:163/0			force out ch 30 off	
N12:163/1			force out ch 30 on	
N12:164/0			force out ch 31 off	
N12:164/1			force out ch 31 on	
N12:165/0			force out ch 32 off	
N12:165/1			force out ch 32 on	
N12:173			setpoint less than zero	
N12:174	CALCULATE	Global	setpoint less than zero	
N12:175/15			Increment button	
N12:176/12			Decrement setpoint in plc	
N12:176/15			Decrement button	
N12:177			# and move the value into outpt imagetable	
N12:178			is used to select output changed	
N12:180			nt to sele ct which s etpoint is changed	
N12:182			Index from last scan	
N12:190/0			advances used bit	
N12:191/0			ANDing used bit	
N12:192/0			TIMED/ PULSED used bit	
N12:193				
N12:200			configure file to screen registers	
N12:215			access level selector	
N12:217			password 1	
N12:218			password	
N12:219			password	
N12:220/0			level 1 access	
N12:220/1			level 2 access	
N12:220/2			level 3 access	
N17:0			in Prg 1 registers	
N18:3			CH-1 ON	
N18:4			CH-1 OFF	
N18:22			CH-2 ON	
N18:23			CH-2 OFF	
N18:41			CH-3 ON	
N18:42			CH-3 OFF	
N18:60			CH-4 ON	
N18:61			CH-4 OFF	
N18:79			CH-5 ON	
N18:80			CH-5 OFF	
N18:98			CH-6 ON	
N18:99			CH-6 OFF	
N18:117			CH-7 ON	
N18:118			CH-7 OFF	
N18:136			CH-8 ON	
N18:137			CH-8 OFF	
N20:3			CH-17 ON	
N20:4			CH-17 OFF	
N20:22			CH-18 ON	
N20:23			CH-18 OFF	
N20:41			CH-19 ON	
N20:42			CH-19 OFF	
N20:60			CH-20 ON	
N20:61			CH-20 OFF	
N20:79			CH-21 ON	
N20:80			CH-21 OFF	
N20:98			CH-22 ON	
N20:99			CH-22 OFF	
N20:117			CH-23 ON	
N20:118			CH-23 OFF	
N20:136			CH-24 ON	
N20:137			CH-24 OFF	
N21:3			CH-25 ON	
N21:4			CH-25 OFF	
N21:3			CH-26 ON	
N21:3			CH-26 OFF	
N21:41			CH-27 ON	
N21:42			CH-27 OFF	
N21:60			CH-28 ON	

Address/Symbol Database

Address	Symbol	Scope	Description	S:
N21:61			CH-28 OFF	
N21:61			CH-29 ON	
N21:61			CH-29 OFF	
N21:98			CH-30 ON	
N21:99			CH-30 OFF	
N21:117			CH-31 ON	
N21:118			CH-31 OFF	
N21:136			CH-32 ON	
N21:137			CH-32 OFF	
N22:0			in Prg 2 registers	
N27:0			in Prg3 resgisters	
N32:0			in Prg4 registers	
N37:0			MACHINE AUTO OFFSET START AUTO OFFSET WHEN EQU TO 90	
N37:1			SET TRANSMIT BIT FOR THE AMCI CARD	
N37:1/15			SETS TRANSMIT BIT AND PRESET BIT ON THE AMCI 8512	
N37:2			MONITOR SHAFT MOVEMENT LAST KNOWN POSITION	
N37:3			FAULT CODE	
N37:3/0			PLS ERROR	
N37:3/1			PLS ERROR	
N37:3/2				
N37:3/3			LSWF FAILURE CALLUP ERROR SCREEN	
N37:3/4			POS. STOP MACHINE RUNNING AUTO RESTART	
N37:3/5			WEB FAILURE SELECTOR NOT ON PANEL VIEW CALL UP SCREEN	
N37:3/6			ZIPPER FAILURE CALL UP SCREEN	
N37:3/7			POUCH RETURN PHOTO-EYE CR	
N37:3/8			REGISTRATION FAILURE	
N37:3/11			Major Error Fault Code	
N37:4			PRODUCT SETTLER#1 CONTROL	
N37:5			IOM OUTPUT MASK FOR WEB FEEDROLL BRAKE	
N37:5/3			IOM OUTPUT FOR WEB FEEDROLL	
N37:6			IIM INPUT MASK FOR REGISTRATION	
N37:6/13			IIM UPDATE INPUT BEFORE NEXT SCAN	
N37:7			PRESET MACHINE POSITION TO 90 DEG.	
N37:8			FALT CODE NUMBER	
N37:9				
N37:10			1ST ON SETPOINT COMPARE FOR CHANGE	
N37:11			1ST OFF SETPOINT COMPARE FOR CHANGE	
N37:12			2ND ON SETPOINT COMPARE FOR CHANGE	
N37:13			2ND OFF SETPOINTCOMPARE FOR CHANGE	
N37:14			3RD ON SETPOINT COMPARE FOR CHANGE	
N37:15			3RD OFF SETPOINT COMPARE FOR CHANGE	
N37:16			4TH ON SETPOINT COMPARE FOR CHANGE	
N37:17			4TH OFF SETPOINT COMPARE FOR CHANGE	
N37:18			COMPARE FOR SELECTOR SWITCH CHANGE	
N37:20				
N37:21				
N37:22				
N37:23				
N37:24				
N37:25				
N37:26			GAS FLUSH STA. DIVER ON TIMING	
N37:27			GAS FLUSH STA. DIVER OFF TIMING	
N37:28			GAS FLUSH STA. FLUSHING ON TIMING	
N37:29			GAS FLUSH STA. FLUSHING OFF TIMING	
N37:30			TOPSEAL HOLE PUNCH ON TIMING	
N37:31			TOPSEAL HOLE PUNCH OFF TIMING	
N37:32			TOPSEAL HOLE PUNCH SLUG BLOWER ON TIMING	
N37:33			TOPSEAL HOLE PUNCH SLUG BLOWER OFF TIMING	
N38:0			BSR FOR FILLERS TRACKS POUCHES THAT FILLER #1 HAS FILLED	
N38:0/6			POUCH FILLER #1 FILLED	
N38:0/13				
N38:0/14			POUCH PRESENT ( FILLER #1 FILLED )	
N38:1			BSR FOR FILLERS TRACKS POUCHES THAT FILLER #2 HAS FILLED	
N38:1/6				
N38:1/7				
N38:1/8			FULL POUCH AT PICKOFF	
N38:1/9			FULL POUCH BSR FROM FILLER #2	
N38:10/0			FILLER#1 FILL CYCLE ENABLED	
N38:10/1			FILLER#2 FILL CYCLE ENABLED	
N40:0			BSR FOR FILLERS TRACKS POUCHES THAT FILLER #1 HAS FILLED	
N40:0/13			POUCHE THAT FILLER #1 HAS FILLED	
N40:1			FILLER#1(WRIGHT TAG) FILL CONTROL 0=OFF 1=STANDARD 2=SLIDE GATE 3=ON-DEMAND	
N40:2			FILLER#1(READ TAG) FILL CONTROL 0=OFF 1=STANDARD 2=SLIDE GATE 3=ON-DEMAND	
N40:3			FILLER#1 GAS FLUSH ASSIST ON TIMING	
N40:4			FILLER#1 GAS FLUSH ASSIST OFF TIMING	
N40:5			FILLER#1 UPPER SLIDEGATE OPEN TIMING	
N40:5			FILLER#1 UPPER SLIDEGATE CLOSE TIMING	
N40:8			FILLER#1 ON-DEMAND INPUT SIGNALS WRIGHT TAG 0=BOTH 1=READY ONLY 2=DROP COMPLETE ONLY	
N40:9			FILLER#1 ON-DEMAND INPUT SIGNALS READ TAG 0=BOTH 1=READY ONLY 2=DROP COMPLETE ONLY	
N40:9/0			OSR	
N40:9/0			OSR	

Address/Symbol Database

Address	Symbol	Scope	Description	S:
N40:9/1			OSR	
N40:9/2			OSR	
N40:9/3			OSR	
N40:9/4			OSR	
N40:9/5			OSR	
N40:10			FILLER #1 FILL CONTROL CR	
N40:10/0			FILL CONTROL SELECT ENABLE BIT	
N40:10/1			FILLER#1 START LOADING SLIDE GATE	
N40:10/2			FILLER#1 SLIDE GATE LOADED	
N40:10/3			FILLER#1 SLIDE GATE DROPPING	
N40:10/4			FILLER#1 ON-DEMAND DROP TIMING	
N40:10/5			FILLER#1 DROP REQUESTED CHECK FOR SCALE DUMP COMPLETE	
N40:10/6			FILLER #1 ON-DEMAND POS. STOP	
N40:10/7			FILLER#1 ON DEMAND POS STOP FILL COMPLETE	
N40:10/8			FILLER #1 DUMP COMPLETE	
N41:0			BSR FOR FILLERS TRACKS POUCHES THAT FILLER #2 HAS FILLED	
N41:1			FILLER#2 (WRIGHT TAG) FILL CONTROL 0=OFF 1=STANDARD 2=SLIDE GATE 3=ON-DEMAND	
N41:2			FILLER#2 (READ TAG) FILL CONTROL 0=OFF 1=STANDARD 2=SLIDE GATE 3=ON-DEMAND	
N41:3			FILLER#2 GAS FLUSH ASSIST ON TIMING	
N41:4			FILLER#2 GAS FLUSH ASSIST OFF TIMING	
N41:5			FILLER#2 UPPER SLIDE GATE OPEN TIMING	
N41:6			FILLER#2 UPPER SLIDE GATE CLOSE TIMING	
N41:7			FILLER#2 ON-DEMAND INPUT SIGNALS WRIGHT TAG 0=BOTH 1=READY ONLY 2=DROP COMPLETE ONLY	
N41:8			FILLER#2 ON-DEMAND INPUT SIGNALS READ TAG 0=BOTH 1=READY ONLY 2=DROP COMPLETE ONLY	
N41:9/0			OSR	
N41:9/1			OSR	
N41:9/2			OSR	
N41:9/3			OSR	
N41:9/4			OSR	
N41:10/0			FILL CONTROL SELECT ENABLE BIT	
N41:10/1			FILLER#2 START LOADING SLIDE GATE	
N41:10/2			FILLER#2 SLIDE GATE LOADED	
N41:10/3			FILLER#2 SLIDE GATE DROPPING	
N41:10/4			FILLER#2 ON-DEMAND DROP TIMING	
N41:10/5			FILLER#2 DROP REQUESTED CHECK FOR SCALE DUMP COMPLETE	
N41:10/6			FILLER #2 ON-DEMAND POS. STOP	
N41:10/7			FILLER#2 ON DEMAND POS STOP FILL COMPLETE	
N42:0			BSR FOR FILLERS TRACKS POUCHES THAT FILLER #3 HAS FILLED	
N42:1			FILLER#3 (WRIGHT TAG) FILL CONTROL 0=OFF 1=STANDARD 2=SLIDE GATE 3=ON-DEMAND	
N42:2			FILLER#3 (READ TAG) FILL CONTROL 0=OFF 1=STANDARD 2=SLIDE GATE 3=ON-DEMAND	
N42:3			FILLER#3 GAS FLUSH ASSIST ON TIMING	
N42:4			FILLER#3 GAS FLUSH ASSIST OFF TIMING	
N42:5			FILLER#3 UPPER SLIDE GATE OPEN TIMING	
N42:6			FILLER#3 UPPER SLIDE GATE CLOSE TIMING	
N42:7			FILLER#3 ON-DEMAND INPUT SIGNALS WRIGHT TAG 0=BOTH 1=READY ONLY 2=DROP COMPLETE ONLY	
N42:8			FILLER#2 ON-DEMAND INPUT SIGNALS READ TAG 0=BOTH 1=READY ONLY 2=DROP COMPLETE ONLY	
N42:9/0			OSR	
N42:9/1			OSR	
N42:9/2			OSR	
N42:9/3			OSR	
N42:9/4			OSR	
N42:10/0			FILL CONTROL SELECT ENABLE BIT	
N42:10/1			FILLER#3 START LOADING SLIDE GATE	
N42:10/2			FILLER#3 SLIDE GATE LOADED	
N42:10/3			FILLER#3 SLIDE GATE DROPPING	
N42:10/4			FILLER#3 ON-DEMAND DROP TIMING	
N42:10/5			FILLER#3 DROP REQUESTED CHECK FOR SCALE DUMP COMPLETE	
N42:10/6			FILLER #3 ON-DEMAND POS. STOP	
N42:10/7			FILLER#3 ON DEMAND POS STOP FILL COMPLETE	
N43:0			PRODUCT SETTLER #1 1ST ON POINT	
N43:1			PRODUCT SETTLER #1 1ST OFF POINT	
N43:2			PRODUCT SETTLER #1 2ND ON POINT	
N43:3			PRODUCT SETTLER #1 2ND OFF POINT	
N43:4			PRODUCT SETTLER #1 3RD ON POINT	
N43:5			PRODUCT SETTLER #1 3RD OFF POINT	
N43:6			PRODUCT SETTLER #1 4TH ON POINT	
N43:7			PRODUCT SETTLER #1 4TH OFF POINT	
N43:8			PRODUCT SETTLER #1 5TH ON POINT	
N43:9			PRODUCT SETTLER #1 5TH OFF POINT	
N43:10			PRODUCT SETTLER #2 1ST ON POINT	
N43:11			PRODUCT SETTLER #2 1ST OFF POINT	
N43:12			PRODUCT SETTLER #2 2ND ON POINT	
N43:13			PRODUCT SETTLER #2 2ND OFF POINT	
N43:14			PRODUCT SETTLER #2 3RD ON POINT	
N43:15			PRODUCT SETTLER #2 3RD OFF POINT	
N43:16			PRODUCT SETTLER #2 4TH ON POINT	
N43:17			PRODUCT SETTLER #2 4TH OFF POINT	
N43:18			PRODUCT SETTLER #2 5TH ON POINT	
N43:19			PRODUCT SETTLER #2 5TH OFF POINT	
N53:0			PANELVIEW GUARD ALARM	
N53:1			MACHINE ALARM MESSAGE DISPLAY	

Address/Symbol Database

Address	Symbol	Scope	Description	S:
O:2.0/0			MSD MAIN DRIVE CONTACTOR	
C /1			VACUUM MOTOR CONTACTOR	
C /2			VACUUM OPENERS BLOW BACK	
O:2.0/3			Registration light	
O:2.0/4			PICKOFF BLOW BACK	
O:2.0/5			AIR-JET SOL.	
O:2.0/6			VACUUM OPENER #1	
O:2.0/7			VACUUM OPENER #2 SOL.	
O:2.0/8			VACUUM OPENER #3 SOL.	
O:2.0/9			VACUUM PICKOFF SOL	
O:2.0/10			GUSSET HOLE PUNCH SOL.	
O:2.0/11			FILLER #1 TRAILING EDGE ACTUATOR SOL.	
O:2.0/12			FILLER #2 TRAILING EDGE ACTUATOR SOL.	
O:2.0/13			FILLER #3 TRAILING EDGE ACTUATOR SOL.	
O:2.0/14			PICKOFF TRAILING EDGE ACTUATOR SOL.	
O:2.0/15			GUSSET HOLE PUNCH SLUG BLOWER	
O:4.0/0			POWER UP EDEGE GUIDE CR	
O:4.0/1			WEB UNWIND CRWU	
O:4.0/2			ZIPPER POWER UNWIND CR	
O:4.0/3			WEB FEED ROLL BRAKE CR	
O:4.0/4			HOLE PUNCH SOL	
O:4.0/5			HOLE PUNCH SLUG BLOWER SOL	
O:4.0/6			GAS FLUSH (PRIOR TO TOP SEAL) FLUSH SOL.	
O:4.0/7			SHRED CONVEYOR	
O:4.0/8			ERROR LIHGT	
O:4.0/9			MAIN AIR SUPPLY CR	
O:4.0/10			SEALBARS ON CR	
O:4.0/11				
O:4.0/12			STACK LIGHT GREEN LIGHT	
O:4.0/13			STACK LIGHT AMBER LIGHT	
O:4.0/14			STACK LIGHT RED LIGHT	
O:4.0/15			STACK LIGHT SAFTY HORN	
O:5.0				
O:5.0/0			AIR ON CR	
O:5.0/1			PRODUCT SETTLER ON	
O:5.0/2			DATE CODER CR	
O:5.0/3			LABELER	
O:5.0/4			SHRED RAM	
O:5.0/5			FILL CONTROL FILLER 1 OUTPUT	
C /6			FILL CONTROLL FILLER 2 OUTPUT	
C /7			RESET REGISTRATION	
O:5.0/10			Change ON setpoint	
O:5.0/11			Change OFF	
O:5.0/12			Decrement setpoint in module	
O:5.0/15			Transmit INC/DEC word	
O:6.0/0			FILLER#1 GAS FLUSH ASSIST SOL.	
O:6.0/1			FILLER#2 GAS FLUSH ASSIST SOL.	
O:6.0/2			FILLER#3 GAS FLUSH ASSIST SOL.	
O:6.0/3			WIRE OPENER DIVER SOL.	
O:6.0/4			WIRE OPENER OPEN SOL.	
O:6.0/5			BAG REJECT STA. ESCAPMENT SOL	
O:6.0/6			PRODUCT SETTLER #1 SOL.	
O:6.0/7			PRODUCT SETTLER #2 SOL.	
O:6.0/10			FILLER#1 UPPER SLIDEGATE	
O:6.0/11			FILLER#1 OPEN LOWER SLIDEGATE (DROP)	
O:6.0/12			FILLER#2 UPPER SLIDEGATE	
O:6.0/13			FILLER#2 OPEN LOWER SLIDEGATE (DROP)	
O:6.0/14			FILLER#3 UPPER SLIDEGATE	
O:6.0/15			FILLER#3 OPEN LOWER SLIDEGATE (DROP)	
O:7.1/15			ENABLE SERVO	
R6:0			THIS BSR KEEPS TRACK OF POUCHES FOR FILLER CONTROL AND PICK-OFF CONTROL	
R6:1			BSR FOR FILLERS TRACKS POUCHES THAT FILLER #1 HAS FILLED	
R6:1/DN			BSR FOR FILLERS TRACKS POUCHES THAT FILLER #1 HAS FILLED BSR DONE BIT	
R6:2			BSR FOR FILLERS TRACKS POUCHES THAT FILLER #2 HAS FILLED	
R6:2/DN			BSR FOR FILLERS TRACKS POUCHES THAT FILLER #2 HAS FILLED	
S:0			Arithmetic Flags	
S:0/0			Processor Arithmetic Carry Flag	
S:0/1			Processor Arithmetic Underflow/ Overflow Flag	
S:0/2			Processor Arithmetic Zero Flag	
S:0/3			Processor Arithmetic Sign Flag	
S:1			Processor Mode Status/ Control	
S:1/0			Processor Mode Bit 0	
S:1/1			Processor Mode Bit 1	
S:1/2			Processor Mode Bit 2	
S:1/3			Processor Mode Bit 3	
S:1/4			Processor Mode Bit 4	
S			Forces Enabled	
S			Forces Present	
S:1/7			Comms Active	
S:1/8			Fault Override at Powerup	
S:1/9			Startup Protection Fault	

Address/Symbol Database

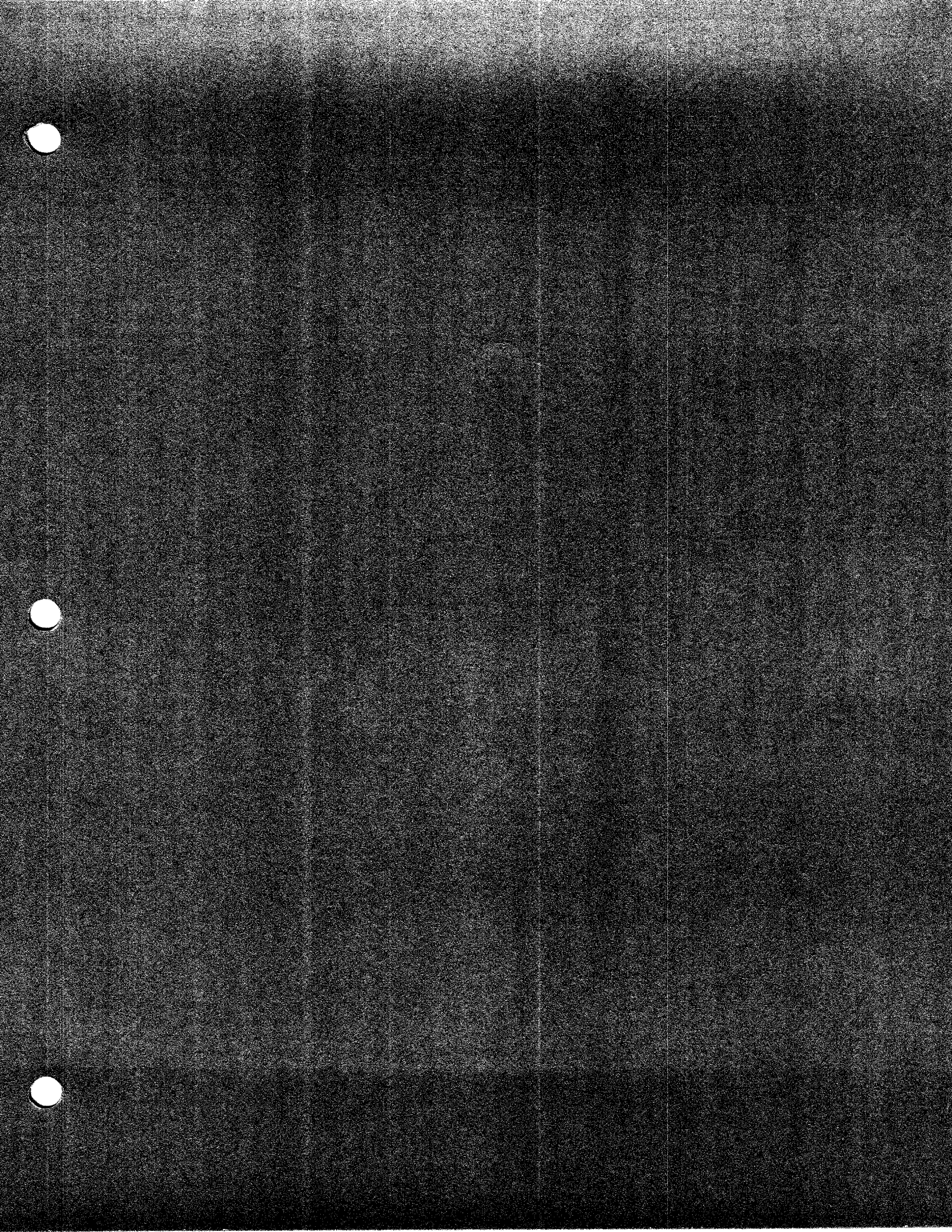
Address	Symbol	Scope	Description	S:
S:1/10			Load Memory Module on Memory Error	
S:1/11			Load Memory Module Always	
S:1/12			Load Memory Module and RUN	
S:1/13			Major Error Halted	
S:1/14			Access Denied	
S:1/15			first pass bit	
S:2/0			STI Pending	
S:2/1			STI Enabled	
S:2/2			STI Executing	
S:2/3			Index Addressing File Range	
S:2/4			Saved with Debug Single Step	
S:2/5			DH-485 Incoming Command Pending	
S:2/6			DH-485 Message Reply Pending	
S:2/7			DH-485 Outgoing Message Command Pending	
S:2/15			Comms Servicing Selection	
S:3			Current Scan Time/ Watchdog Scan Time	
S:4			Time Base	
S:5/0			Overflow Trap	
S:5/2			Control Register Error	
S:5/3			Major Err Detected Executing UserFault Routine	
S:5/4			M0-M1 Referenced on Disabled Slot	
S:5/8			Memory Module Boot	
S:5/9			Memory Module Password Mismatch	
S:5/10			STI Overflow	
S:5/11			Battery Low	
S:6			Major Error Fault Code	
S:7			Suspend Code	
S:8			Suspend File	
S:9			Active Nodes	
S:10			Active Nodes	
S:11			I/O Slot Enables	
S:12			I/O Slot Enables	
S:13			Math Register	
S:14			Math Register	
S:15			Node Address/ Baud Rate	
S:16			Debug Single Step Rung	
S:17			Debug Single Step File	
S:18			Debug Single Step Breakpoint Rung	
S:19			Debug Single Step Breakpoint File	
S:20			Debug Fault/ Powerdown Rung	
S:21			Debug Fault/ Powerdown File	
S:22			Maximum Observed Scan Time	
S:23			Average Scan Time	
S:24			index the same as last scan	
S:25			I/O Interrupt Pending	
S:26			I/O Interrupt Pending	
S:27			I/O Interrupt Enabled	
S:28			I/O Interrupt Enabled	
S:29			User Fault Routine File Number	
S:30			STI Setpoint	
S:31			STI File Number	
S:32			I/O Interrupt Executing	
S:33			Extended Proc Status Control Word	
S:33/0			Incoming Command Pending	
S:33/1			Message Reply Pending	
S:33/2			Outgoing Message Command Pending	
S:33/3			Selection Status User/DF1	
S:33/4			Communicat Active	
S:33/5			Communicat Servicing Selection	
S:33/6			Message Servicing Selection Channel 0	
S:33/7			Message Servicing Selection Channel 1	
S:33/8			Interrupt Latency Control Flag	
S:33/9			Scan Toggle Flag	
S:33/10			Discrete Input Interrupt Reconfigur Flag	
S:33/11			Online Edit Status	
S:33/12			Online Edit Status	
S:33/13			Scan Time Timebase Selection	
S:33/14			DTR Control Bit	
S:33/15			DTR Force Bit	
S:34			Pass-thru Disabled	
S:34/0			Pass-Thru Disabled Flag	
S:34/1			DH+ Active Node Table Enable Flag	
S:34/2			Floating Point Math Flag	
S:35			Last 1 ms Scan Time	
S:36			Extended Minor Error Bits	
S:36/8			Dll Lost	
S:37			STI Lost	
S:38			Memory Module Data File Overwrite Protection	
S:39			Clock Calendar Year	
S:39			Clock Calendar Month	
S:39			Clock Calendar Day	

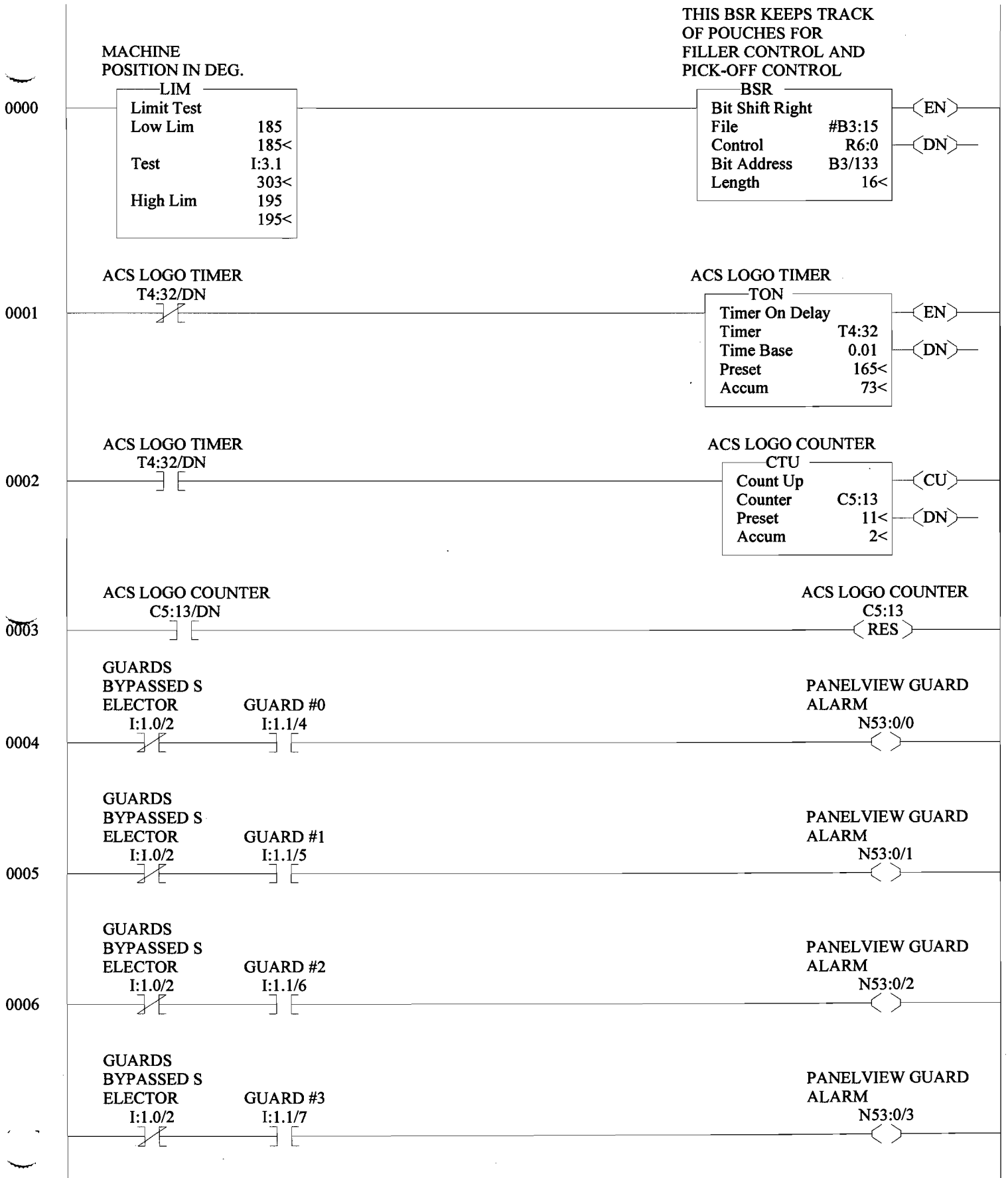
Address/Symbol Database

Address	Symbol	Scope	Description	S:
S:40			Clock Calendar Hours	
S:41			Clock Calendar Minutes	
S:42			Clock Calendar Seconds	
S:43			STI Interrupt Time	
S:44			I/O Event Interrupt Time	
S:45			Dll Interrupt Time	
S:46			Discrete Input Interrupt- File Number	
S:47			Discrete Input Interrupt- Slot Number	
S:48			Discrete Input Interrupt- Bit Mask	
S:49			Discrete Input Interrupt- Compare Value	
S:50			Processor Catalog Interrupt- Preset	
S:51			Discrete Input Interrupt- Return Number	
S:52			Discrete Input Interrupt- Accumulat	
S:53			Discrete Input Interrupt- Timer	
S:54			Discrete Input Interrupt- Timer	
S:55			Last Dll Scan Time	
S:56			Maximum Observed Dll Scan Time	
S:57			Operating System Catalog Number	
S:58			Operating System Series	
S:59			Operating System FRN	
S:61			Processor Series	
S:62			Processor Revision	
S:63			User Program Type	
S:64			User Program Functional Index	
S:65			User RAM Size	
S:66			Flash EEPROM Size	
S:67			Channel 0 Active Nodes	
S:68			Channel 0 Active Nodes	
S:69			Channel 0 Active Nodes	
S:70			Channel 0 Active Nodes	
S:71			Channel 0 Active Nodes	
S:72			Channel 0 Active Nodes	
S:73			Channel 0 Active Nodes	
S:74			Channel 0 Active Nodes	
S:75			Channel 0 Active Nodes	
S:76			Channel 0 Active Nodes	
S:77			Channel 0 Active Nodes	
S:78			Channel 0 Active Nodes	
S:79			Channel 0 Active Nodes	
S:80			Channel 0 Active Nodes	
S:81			Channel 0 Active Nodes	
S:82			Channel 0 Active Nodes	
S:83			DH+ Active Nodes	
S:84			DH+ Active Nodes	
S:85			DH+ Active Nodes	
S:86			DH+ Active Nodes	
T4:0	TIMER	Global	displays access message	
T4:0/DN				
T4:1			TIME DELAY BETEEN FALT MESSAGES	
T4:1/DN			TIME DELAY BETWEEN FALT MESSAGES	
T4:2			ON-DEMAND MAX WAIT TIME	
T4:2/DN				
T4:3			MACHINE RUN TIME IN SECONDS	
T4:3/DN			MACHINE RUN TIME IN SECONDS	
T4:4			TIME DELAY FOR CHANNEL SELECTOR	
T4:4/DN			TIME DELAY FOR CHANNEL SELECTOR	
T4:5			PLS DOWNLOADING TIMER FOR EDIT MODE	
T4:5/DN			PLS DOWNLOADING TIMER FOR EDIT MODE DONE BIT	
T4:5/EN			AUTO LOAD PROGRAM	
T4:6			MONITOR SHAFT MOVEMENT DELAY TIMER AFTER SETPOINT COMPARE POSITION WITH LAST KNOWN	
T4:6/DN			MONITOR SHAFT MOVEMENT DELAY TIMER AFTER SETPOINT DONE BIT	
T4:6/EN			MONITOR SHAFT MOVEMENT MOVE LAST KNOWN POSITION INTO DATA BASE	
T4:7			AIR CURTAIN ON DELAY TIMER	
T4:7/DN			AIR CURTAIN ON DELAY TIMER	
T4:8			HOLE PUNCH COMPLETE MACHINE NOT RUNNING OFF DELAY	
T4:8/DN			HOLE PUNCH COMPLETE MACHINE NOT RUNNING OFF DELAY	
T4:9			MAIN AIR PRESSURE SWITCH TIME DELAY	
T4:9/DN			LOW AIR PRESSURE TIME DELAY	
T4:10			GUSSET HOLE PUNCH COMPLETE MACHINE NOT RUNNING OFF DELAY	
T4:10/DN			GUSSET HOLE PUNCH COMPLETE MACHINE NOT RUNNING OFF DELAY	
T4:11			FILLER#1 SLIDEGATE LOADING MAX OPEN TIME LIMIT	
T4:11/DN			FILLER#1 SLIDEGATE LOADING MAX OPEN TIME LIMIT	
T4:12			FILLER#1 SLIDEGATE DROPPING MAX OPEN TIME LIMIT	
T4:12/DN			FILLER#1 SLIDEGATE DROPPING MAX OPEN TIME LIMIT	
T4:13			FILLER#2 SLIDEGATE LOADING MAX OPEN TIME LIMIT	
T4:13/DN			FILLER#2 SLIDEGATE LOADING MAX OPEN TIME LIMIT	
T4:13/EN			MACHINE HOLDING DUMP REQUEST	
T4:14			FILLER#2 SLIDEGATE DROPPING MAX OPEN TIME LIMIT	
T4:14/DN			FILLER#2 SLIDEGATE DROPPING MAX OPEN TIME LIMIT	
T4:15			FILLER#3 SLIDEGATE LOADING MAX OPEN TIME LIMIT	
T4:15/DN			FILLER#3 SLIDEGATE LOADING MAX OPEN TIME LIMIT	

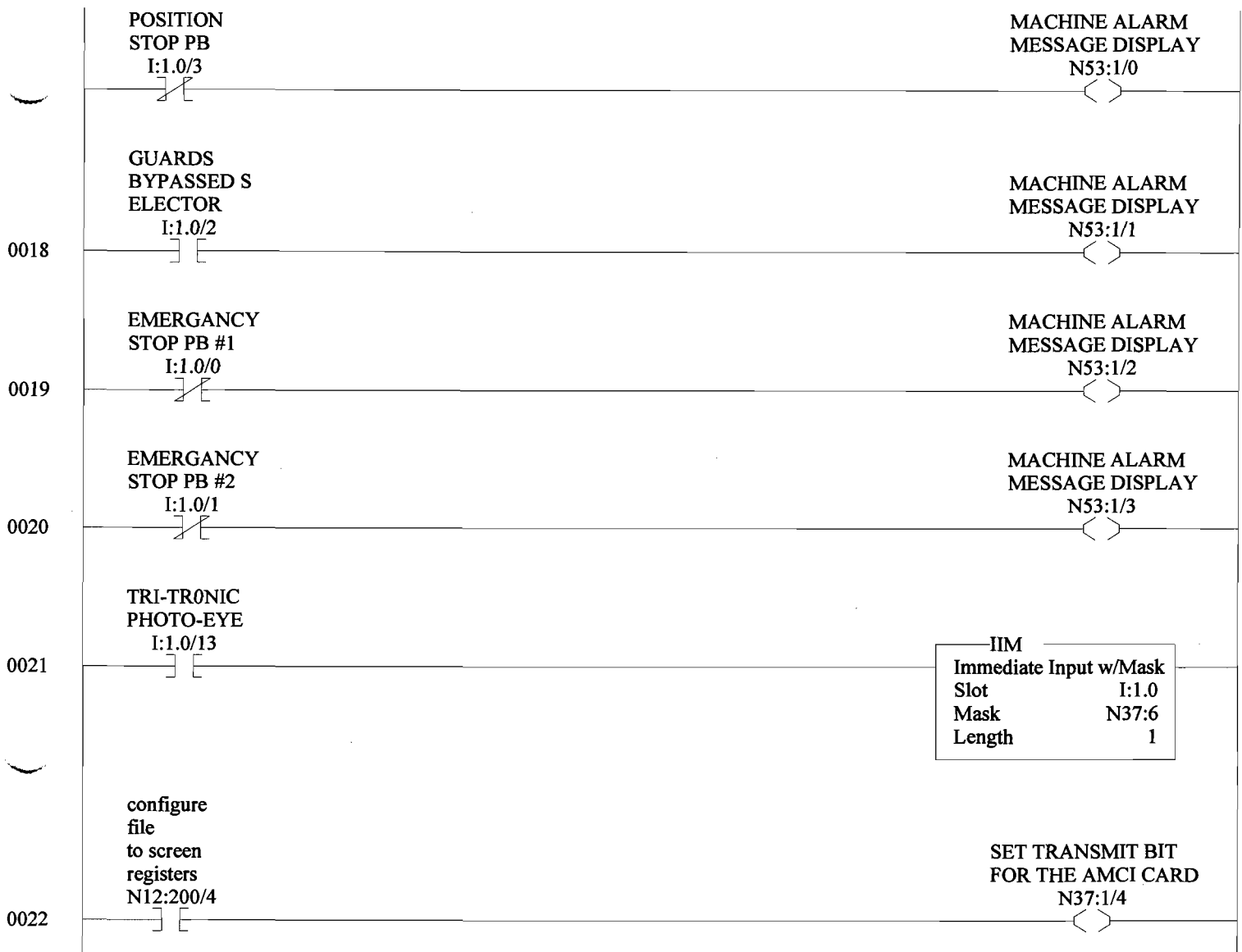
Address/Symbol Database

Address	Symbol	Scope	Description	S:
T4:16			FILLER#3 SLIDEGATE DROPPING MAX OPEN TIME LIMIT	
T4:17/DN			FILLER#3 SLIDEGATE DROPPING MAX OPEN TIME LIMIT	
T4:17			GAS FLUSH ASSIST OFF DELAY	
T4:17/DN			GAS FLUSH ASSIST OFF DELAY	
T4:18			GAS FLUSH STA. OFFDELAY	
T4:18/DN			GAS FLUSH STA OFFDELAY	
T4:19			LOW RIBBON POS.STOP DELAY TIME	
T4:19/DN			LOW RIBBON POS.STOP DELAY TIME	
T4:20			FILLER#1 ON-DEMAND POS. STOP DELAY DROP REQUEST	
T4:20/DN			FILLER#1 ON-DEMAND POS. STOP DELAY DROP REQUEST	
T4:21			FILLER#1 ON-DEMAND POS. STOP DROP REQUEST TIME	
T4:21/DN			FILLER#1 ON-DEMAND POS. STOP DROP REQUEST TIME	
T4:21/TT			FILLER#1 ON-DEMAND POS. STOP DROP REQUEST TIME	
T4:22			RESTART MACHINE DELAY TIME FOR RESTART HORN	
T4:22/DN			RESTART MACHINE DELAY TIME FOR RESTART HORN	
T4:23			FILLER#2 ON-DEMAND POS. STOP DELAY DROP REQUEST	
T4:23/DN			FILLER#2 ON-DEMAND POS. STOP DELAY DROP REQUEST	
T4:23/EN			FILLER#2 ON-DEMAND POS. STOP DELAY DROP REQUEST	
T4:24			FILLER#2 ON-DEMAND POS. STOP DROP REQUEST TIME	
T4:24/DN			FILLER#2 ON-DEMAND POS. STOP DROP REQUEST TIME	
T4:24/TT			FILLER#1 ON-DEMAND POS. STOP DROP REQUEST TIME	
T4:25			STACK LIGHT ON-DEMAND POS. STOP AMBER LIGHT	
T4:25/DN			STACK LIGHT ON-DEMAND POS. STOP AMBER LIGHT	
T4:26			STACK LIGHT ON-DEMAND POS. STOP AMBER LIGHT	
T4:27			FILLER#3 ON-DEMAND POS. STOP DELAY DROP REQUEST	
T4:27/DN			FILLER#3 ON-DEMAND POS. STOP DELAY DROP REQUEST	
T4:27/EN			FILLER#3 ON-DEMAND POS. STOP DELAY DROP REQUEST	
T4:28			FILLER#3 ON-DEMAND POS. STOP DROP REQUEST TIME	
T4:28/DN			FILLER#3 ON-DEMAND POS. STOP DROP REQUEST TIME	
T4:32			ACS LOGO TIMER	
T4:33			MAX HOMEING TIME	
U:3			subroutine	
U:4			advances subroutine	
U:5			ANDing subroutine	
U:6			TIME/PULSE subroutine	
U:7			GROUPS subroutine	
U:8			FORCE subroutine	
U:9			INC/DEC subroutine	
U:10			program select subroutine	
U:11			CONFIGURE subroutine	
U:12			ERRORS subroutine	
U:13			CHTYPE subroutine	
U:15			FILLER#1 SLIDEGATE FILL CONTROLL	
U:16				
U:17			FILLER#2 SLIDEGATE FILL CONTROLL	
U:18			FILLER#2 ON-DEMAND	
U:19			FILLER#3 SLIDEGATE FILL CONTROLL	
U:20			FILLER#1 & FILLER#2 ON-DEMAND	
U:22			filler #3 on-demand fill cycle	









0023

CODE# ENTERD  
IN BY PANEL VIEW

EQU	
Equal	
Source A	N12:59
	2573<
Source B	2573
	2573<

MACHINE AUTO OFFSET  
START AUTO OFFSET  
WHEN EQU TO 90

EQU	
Equal	
Source A	N37:0
	0<
Source B	90
	90<

MSD  
MAIN DRIVE  
CONTACTOR

O:2.0/0



MOV	
Move	
Source	N37:7
	90<
Dest	M0:3.2
	?<

MOV	
Move	
Source	M0:3.101
	?<
Dest	M0:3.3
	?<

AUTO-OFFSET  
FOR MACHINE  
POSITION

B3/103

EQU	
Equal	
Source A	M0:3.101
	?<
Source B	M0:3.3
	?<

0024

CODE# ENTERD  
IN BY PANEL VIEW

EQU  
Equal  
Source A N12:59  
2573<  
Source B 2573  
2573<

AUTO-OFFSET  
FOR MACHINE  
POSITION

B3/103

EQU  
Equal  
Source A M0:3.101  
?<  
Source B M0:3.3  
?<

MACHINE AUTO OFFSET  
START AUTO OFFSET  
WHEN EQU TO 90

EQU  
Equal  
Source A N37:0  
0<  
Source B 90  
90<

MSD  
MAIN DRIVE  
CONTACTOR

O:2.0/0

MOV  
Move  
Source M0:3.101  
?<  
Dest N11:3  
73<

EQU  
Equal  
Source A M0:3.101  
?<  
Source B N11:3  
73<

MOV  
Move  
Source M0:3.101  
?<  
Dest N17:3  
73<

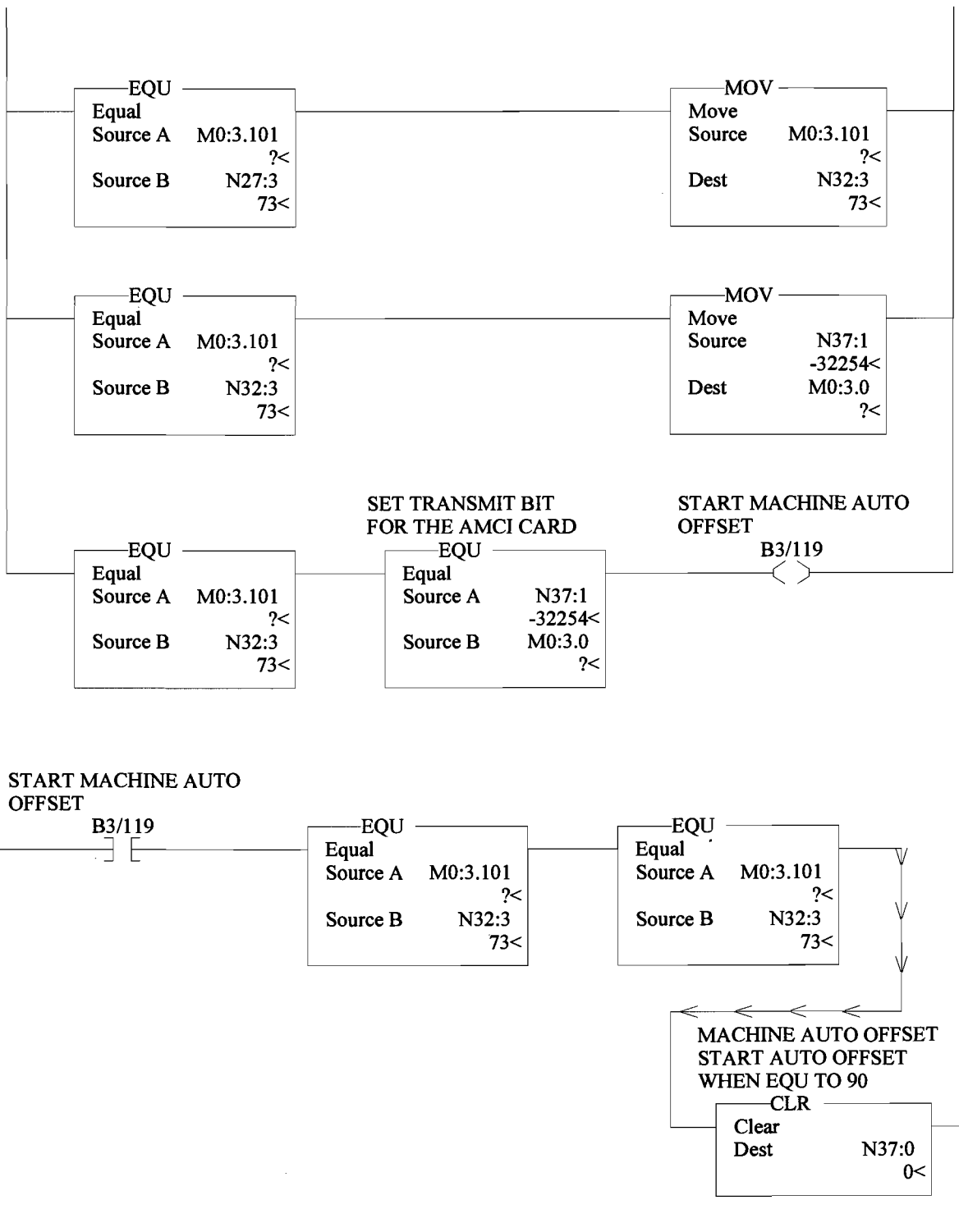
EQU  
Equal  
Source A M0:3.101  
?<  
Source B N17:3  
73<

MOV  
Move  
Source M0:3.101  
?<  
Dest N22:3  
73<

EQU  
Equal  
Source A M0:3.101  
?<  
Source B N22:3  
73<

MOV  
Move  
Source M0:3.101  
?<  
Dest N27:3  
73<

0025



0026

first  
pass  
bit  
S:1/15

PLS DOWNLOADING  
B3/212

(U)

ON-DEMAND CYCLE  
ENABLED  
B3/125

(U)

FILLER #1  
DUMP COMPLETE  
N40:10/8

(U)

ON-DEMAND  
RESTART MACHINE  
B3/127

(U)

FILLER#1  
ON DEMAND  
POS STOP  
FILL COMPLETE  
N40:10/7

(U)

FILLER#2  
ON DEMAND  
POS STOP  
FILL COMPLETE  
N41:10/7

(U)

RESTART MACHINE  
DELAY TIME FOR  
RESTART HORN  
T4:22

(RES)

MAIN AIR SUPPLY ON  
P.B. (IN) PANEL  
VIEW

B3/81

(U)

FILLER #1  
ON-DEMAND  
POS. STOP  
N40:10/6

(U)

FILLER #2  
ON-DEMAND  
POS. STOP  
N41:10/6

(U)

FILLER #3  
ON-DEMAND  
POS. STOP  
N42:10/6

(U)

B3/256

(U)

START HOME SEQ. CR  
FOR MAIN DRIVE

B3/257

(U)

B3/258

(U)

START ALL MOTORS PB.  
IN PANEL VIEW

B3/80

(U)

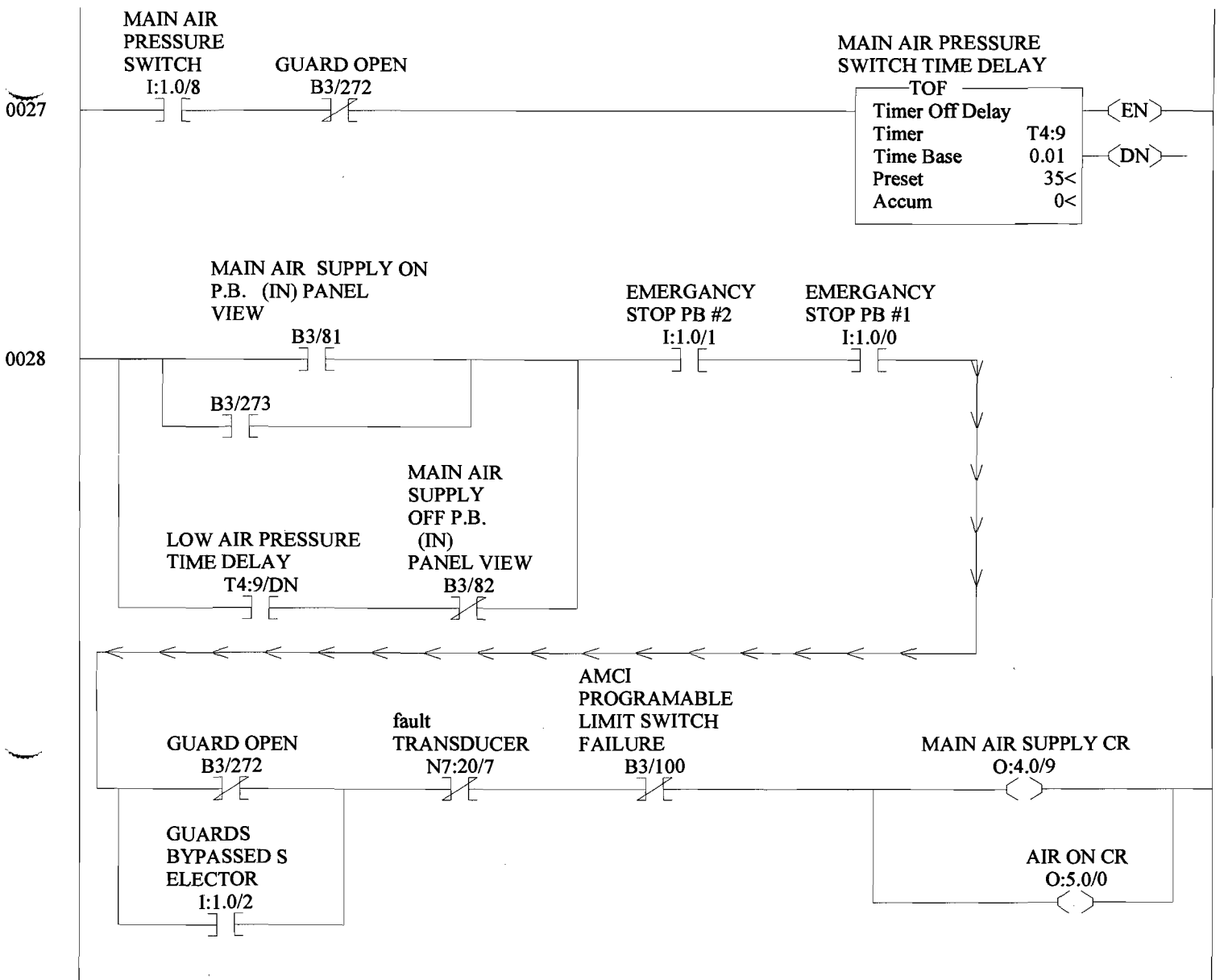
O:7.0/0

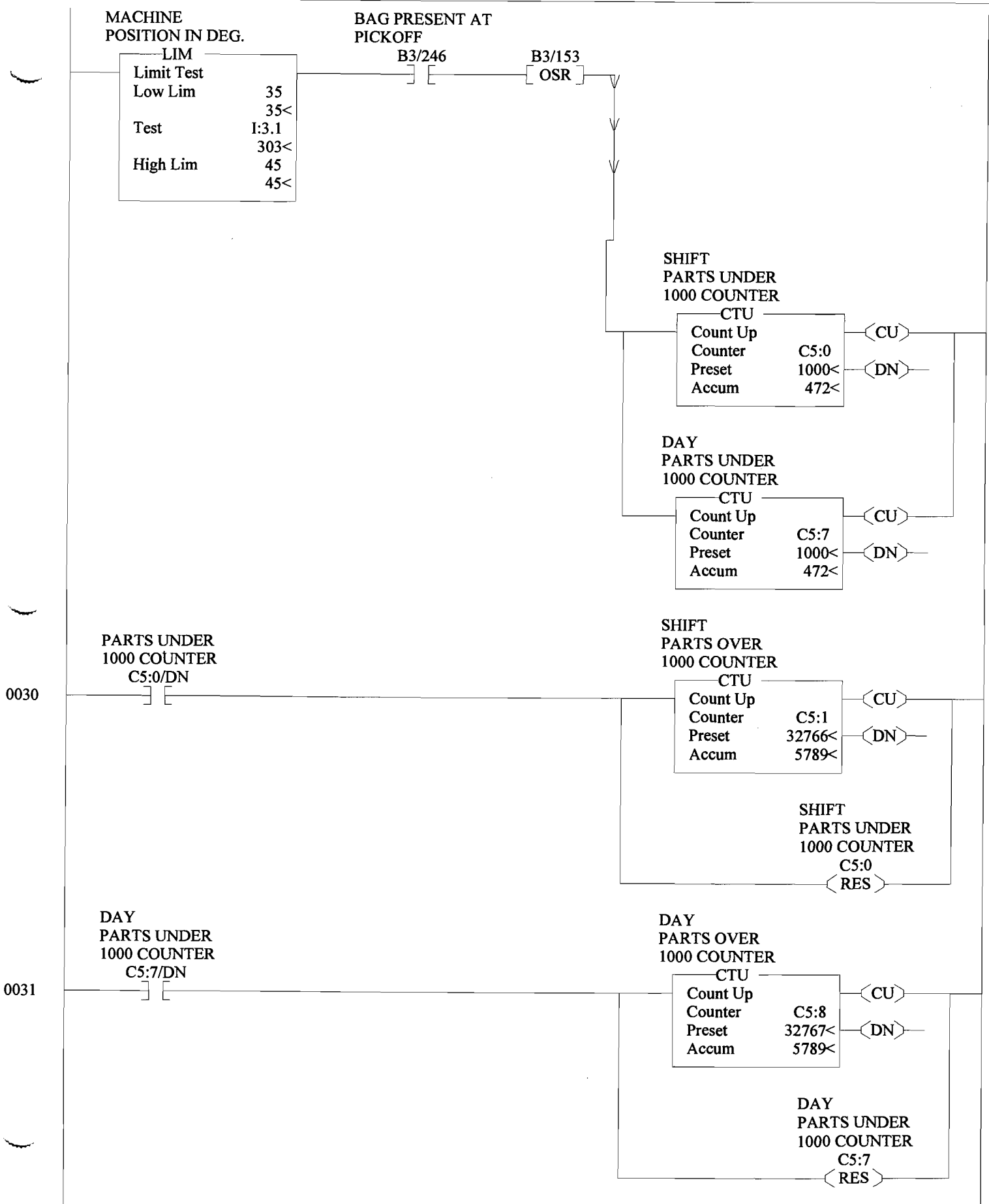
(L)

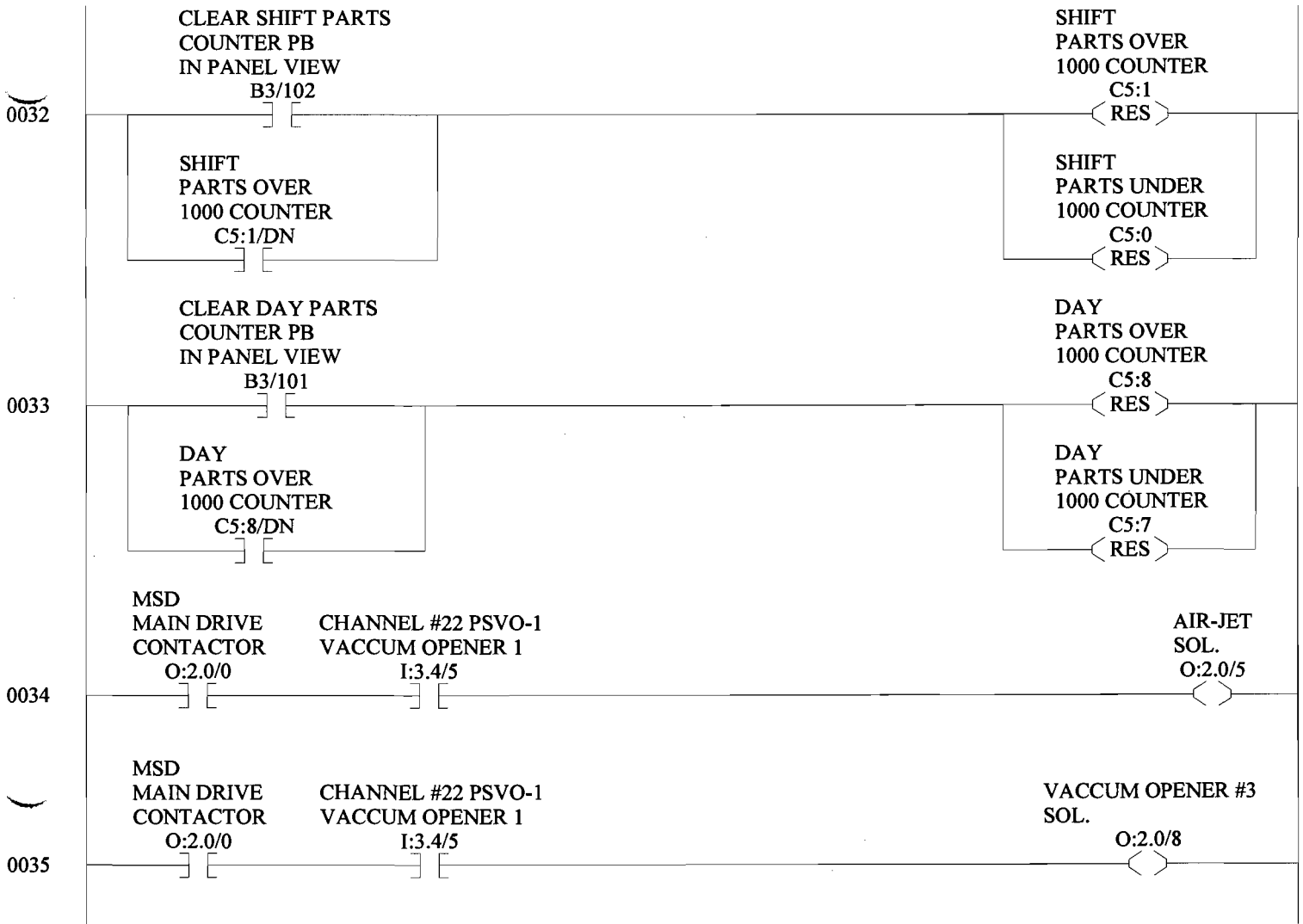
control  
set to  
access  
message  
SCREEN

MOV

Move	
Source	5
	5<
Dest	N7:9
	0<







0036

PRODUCT SETTLER #1  
SELECTOR IN  
PANEL VIEW  
B3/139

START ALL  
MOTORS  
CR  
B3/93

PRODUCT SETTLER#1  
CONTROL

EQU  
Equal Source A N37:4  
1<  
Source B 0  
0<

START ALL  
FILLERS  
CR  
B3/95

PRODUCT SETTLER#1  
CONTROL

EQU  
Equal Source A N37:4  
1<  
Source B 1  
1<

MSD  
MAIN DRIVE  
CONTACTOR  
O:2.0/0

PRODUCT SETTLER#1  
CONTROL

EQU  
Equal Source A N37:4  
1<  
Source B 3  
3<

PRODUCT SETTLER  
ON  
O:5.0/1

0037

START ALL  
FILLERS SS  
I:1.0/6

RUN - JOG  
SELECTOR  
SWITCH  
I:1.0/4

MSD  
MAIN DRIVE  
CONTACTOR  
O:2.0/0

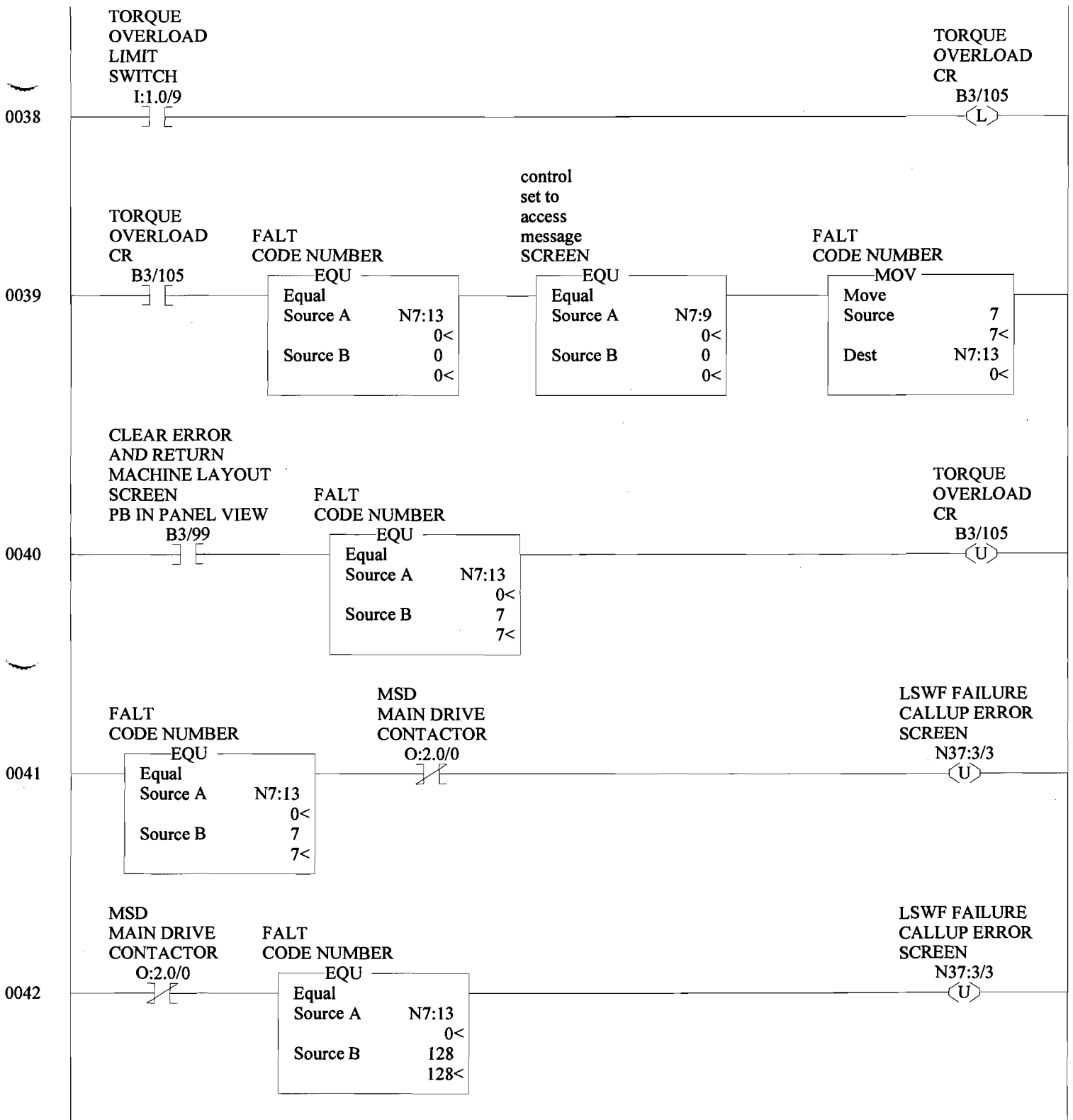
ON-DEMAND  
RESTART MACHINE  
B3/127

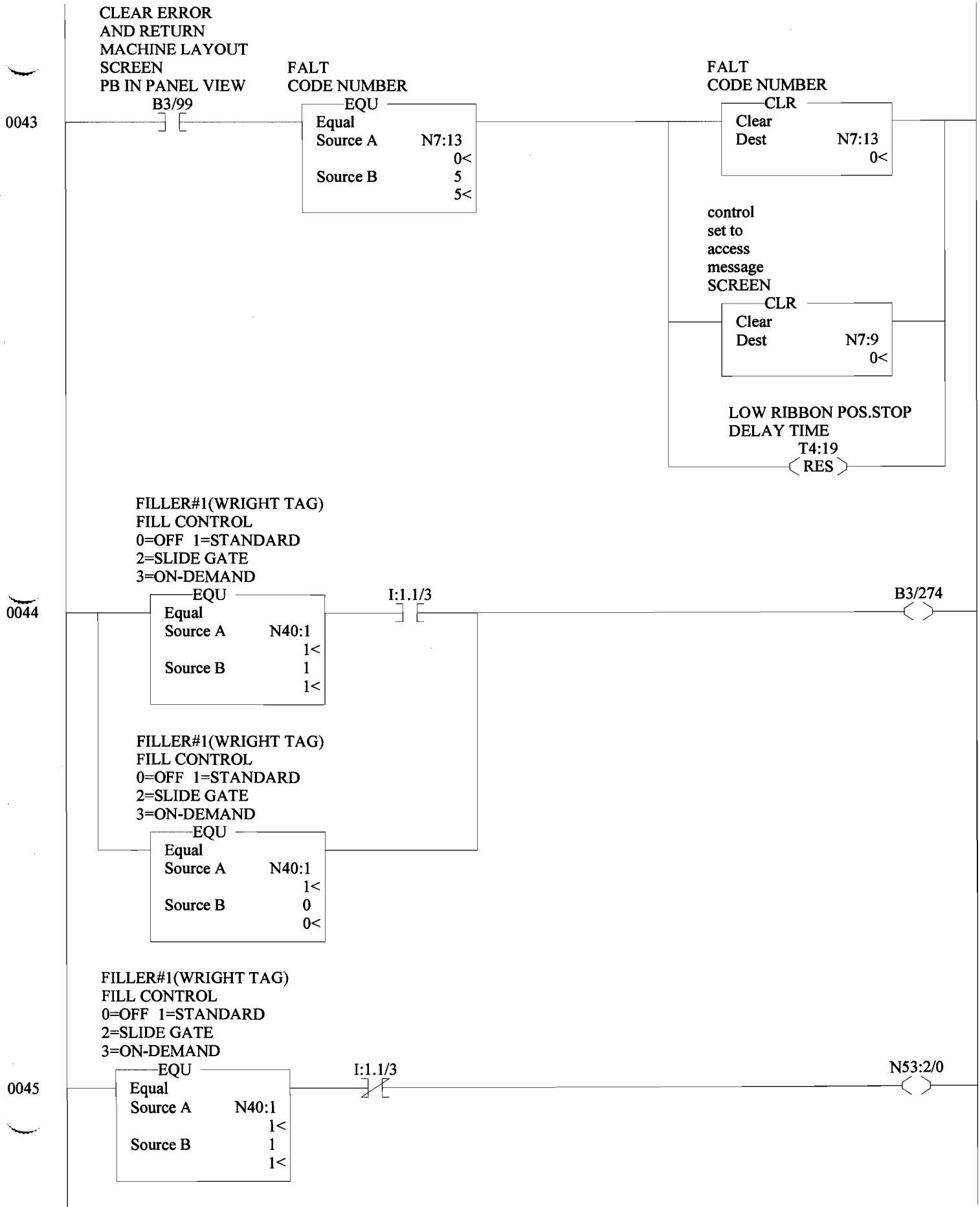
RESTART MACHINE  
DELAY TIME FOR  
RESTART HORN  
T4:22/DN

START ALL  
FILLERS  
CR  
B3/95

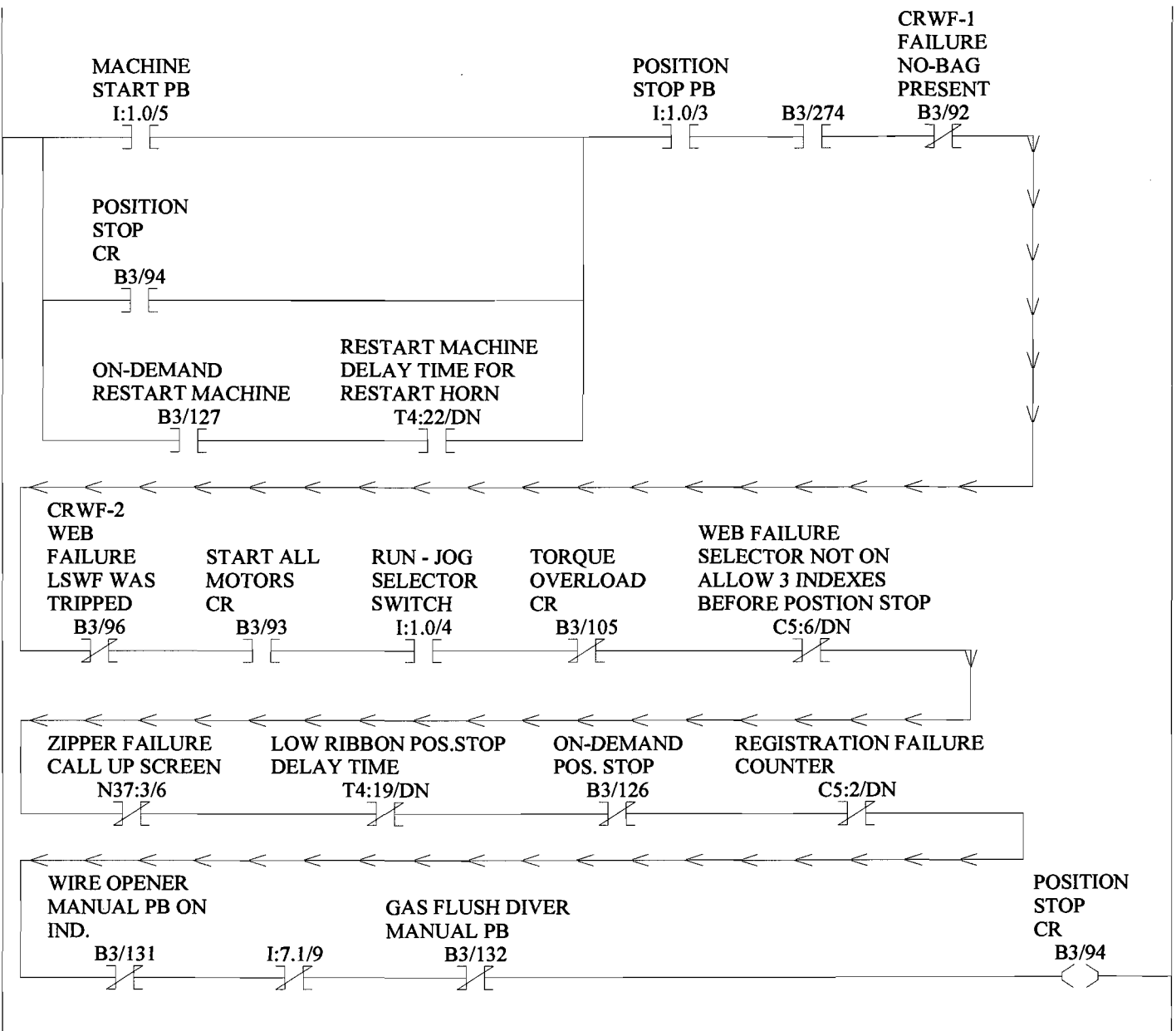
MSD  
MAIN DRIVE  
CONTACTOR  
O:2.0/0

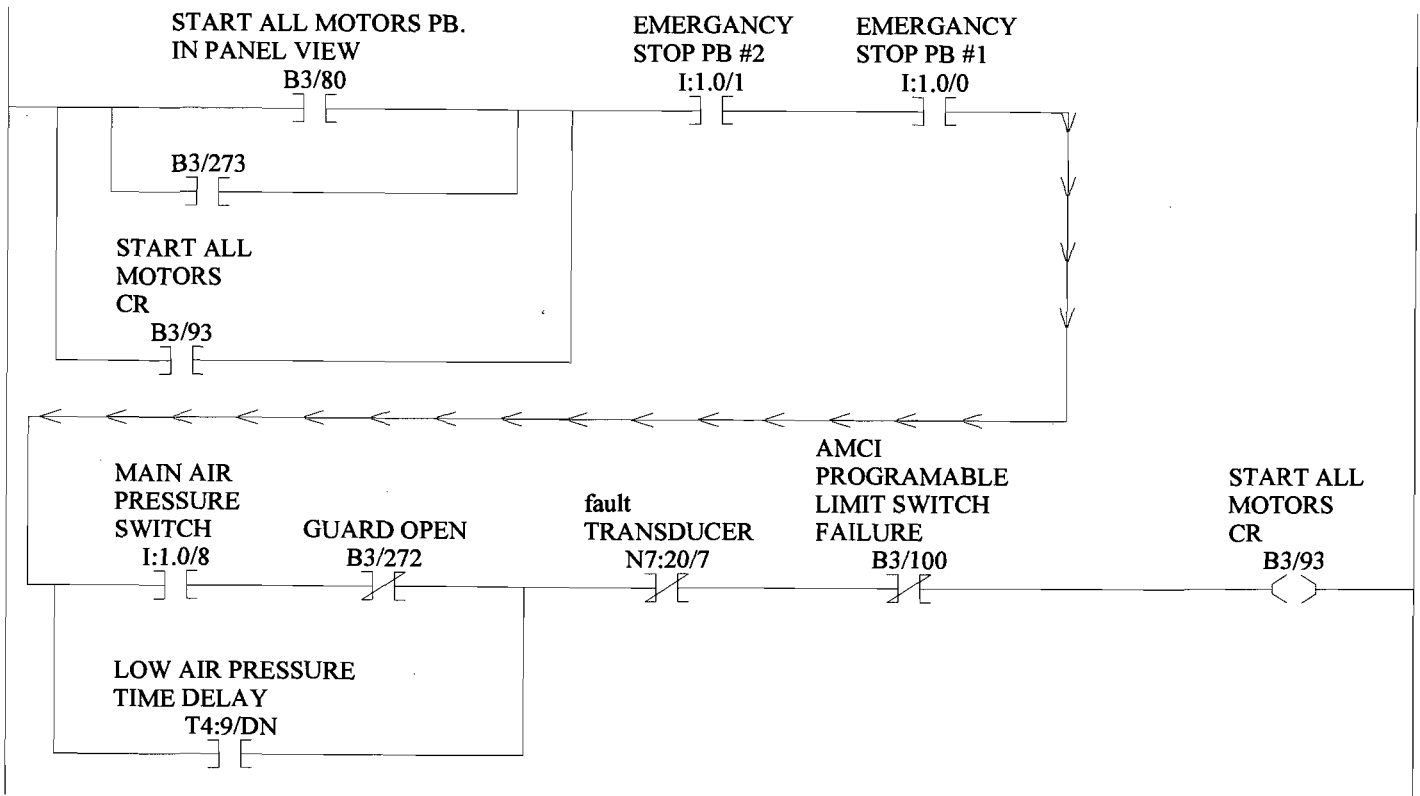
START ALL  
FILLERS  
CR  
B3/95





0046





0048

START ALL MOTORS CR

B3/93

RUN - JOG SELECTOR SWITCH I:1.0/4

MACHINE START PB I:1.0/5

RUN - JOG SELECTOR SWITCH I:1.0/4

MACHINE START PB I:1.0/5

TORQUE OVERLOAD CR B3/105

MSD MAIN DRIVE CONTACTOR O:2.0/0

RUN - JOG SELECTOR SWITCH I:1.0/4

CHANNEL #17 PSB MAIN DRIVE BRAKE I:3.4/0

TORQUE OVERLOAD CR B3/105

POSITION STOP CR B3/94

START HOME SEQ. CR FOR MAIN DRIVE B3/257

AMCI PROGRAMABLE LIMIT SWITCH FAILURE B3/100

fault TRANSDUCER N7:20/7

ON-DEMAND POS. STOP B3/126

WIRE OPENER MANUAL PB ON IND. B3/131

GAS FLUSH DIVER MANUAL PB B3/132

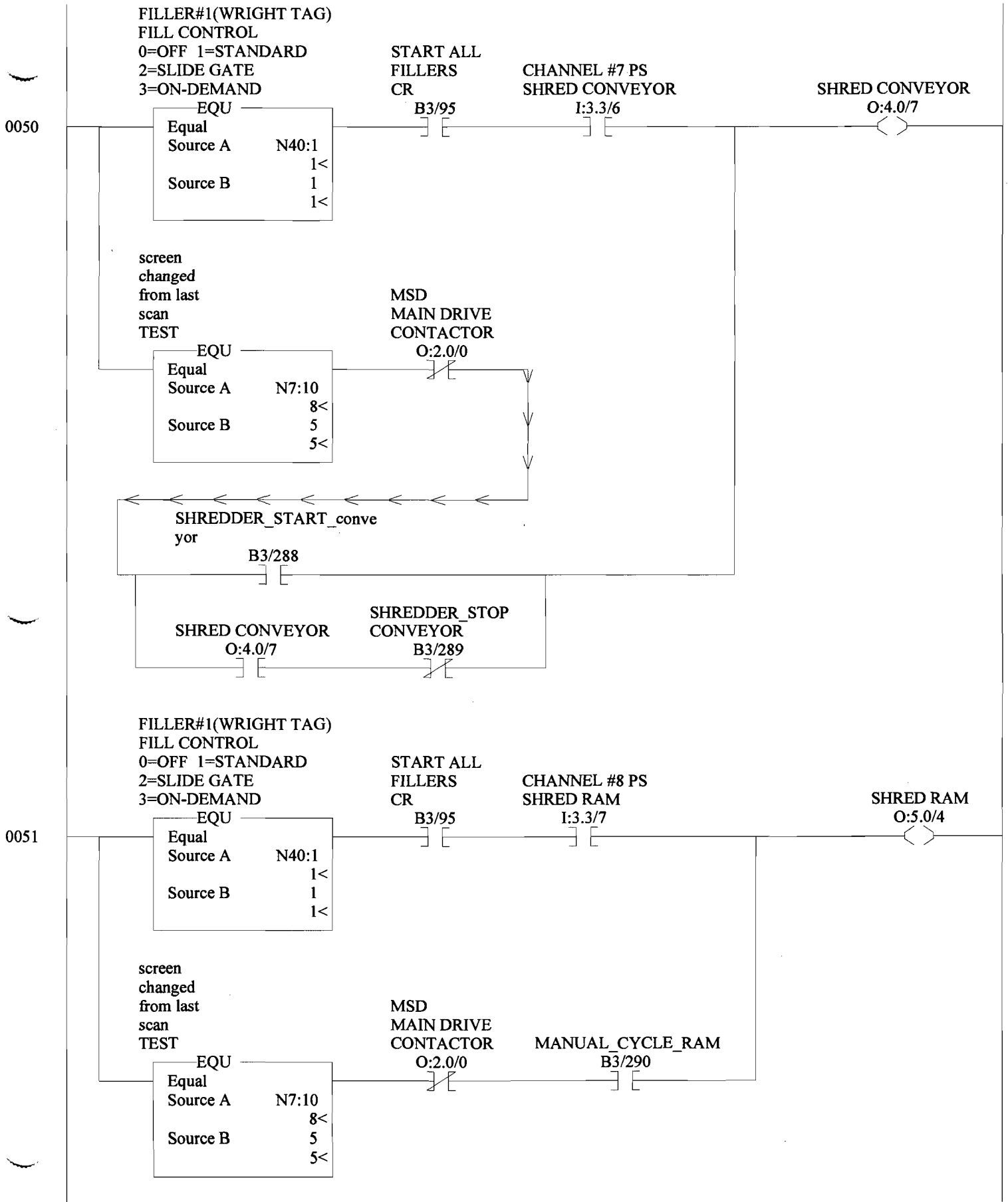
MSD MAIN DRIVE CONTACTOR O:2.0/0

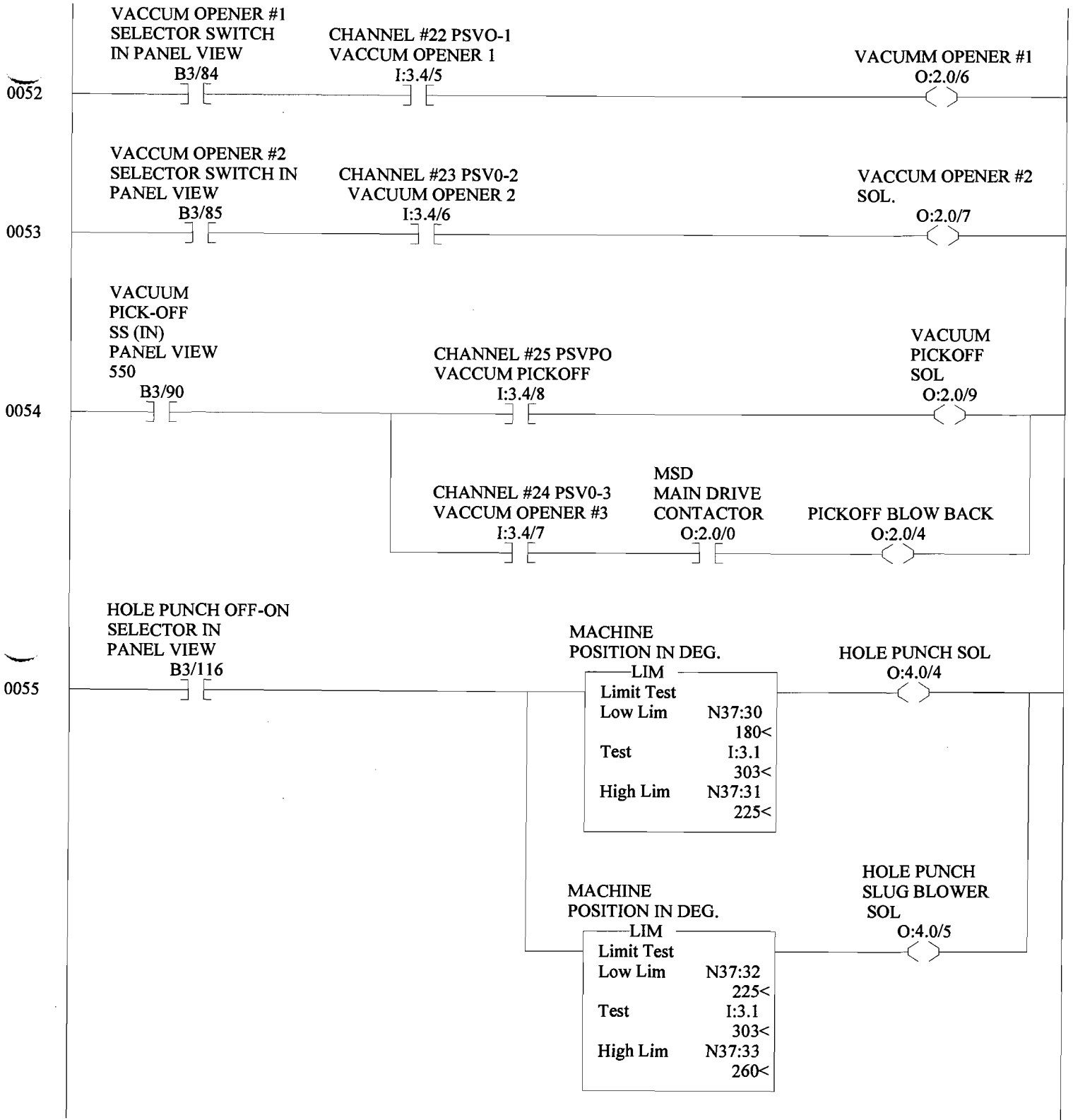
MSD MAIN DRIVE CONTACTOR O:2.0/0

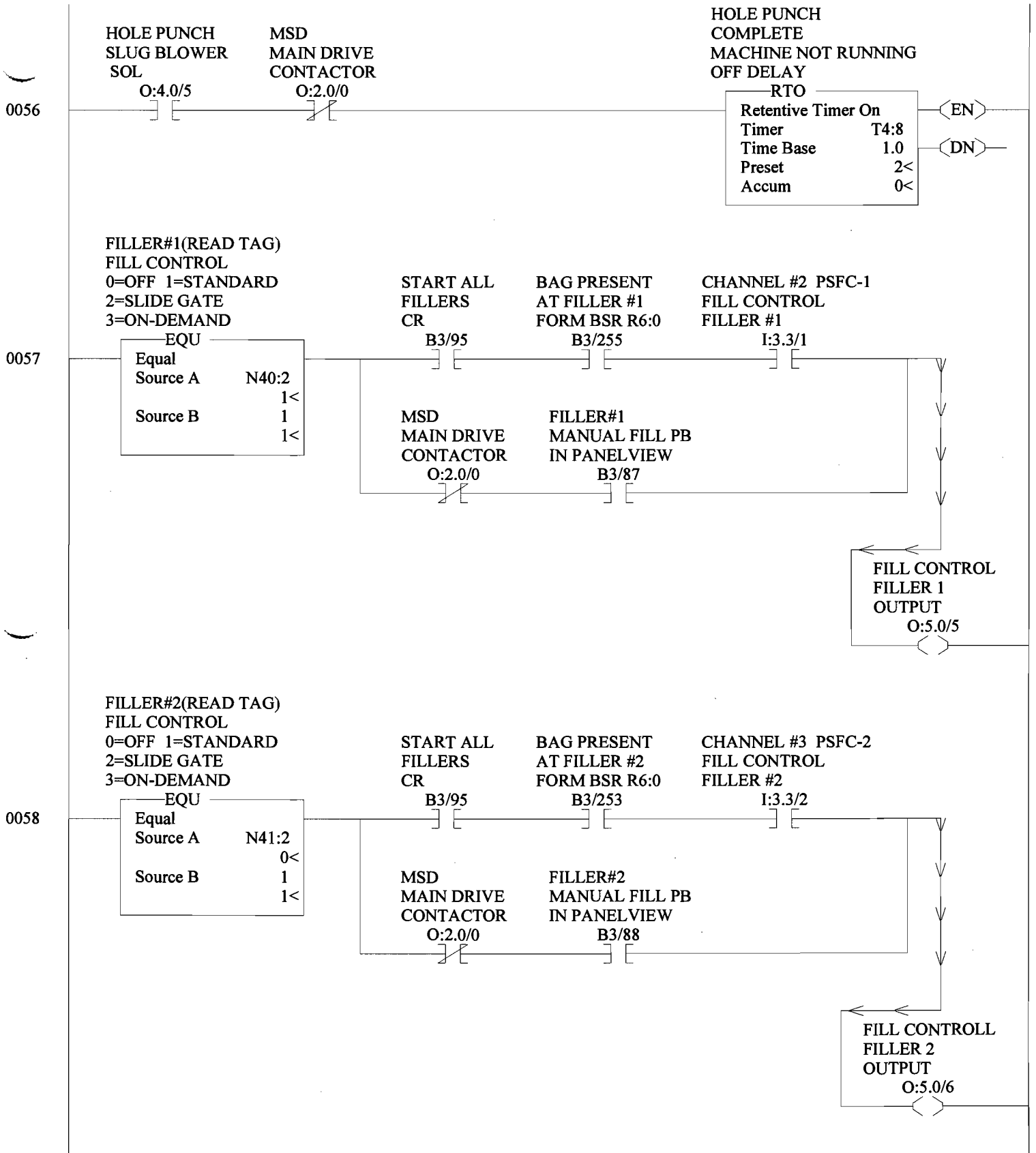
CHANNEL #20 PS VACUUM OPENERS BLOW BACK I:3.4/3

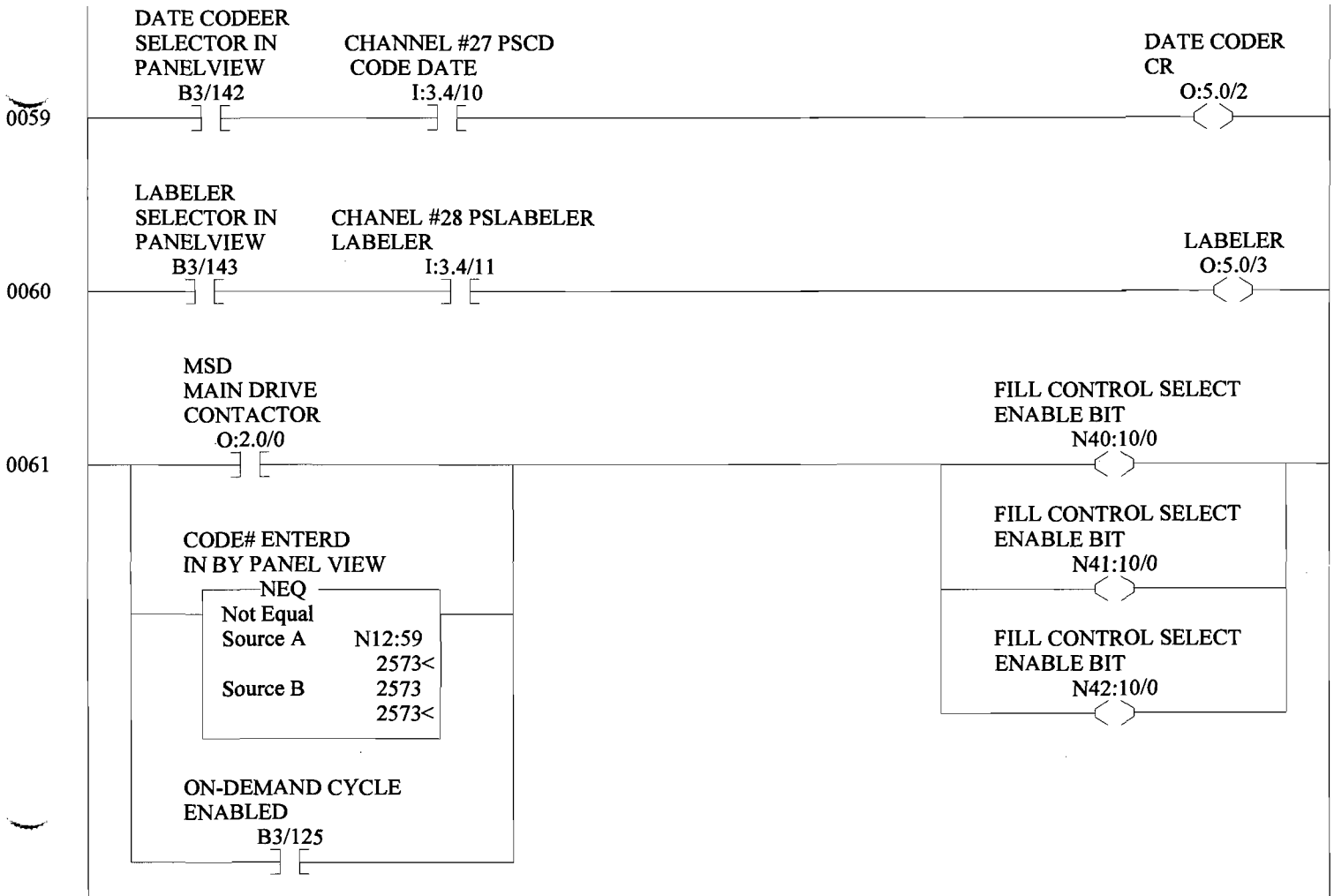
VACUUM OPENERS BLOW BACK O:2.0/2

0049









0062

MSD  
MAIN DRIVE  
CONTACTOR  
O:2.0/0

0:2.0/0

CODE# ENTERD  
IN BY PANEL VIEW

EQU	
Equal	
Source A	N12:59
	2573<
Source B	2573
	2573<

FILLER#1(READ TAG)  
FILL CONTROL  
0=OFF 1=STANDARD  
2=SLIDE GATE  
3=ON-DEMAND

MOV	
Move	
Source	N40:1
	1<
Dest	N40:2
	1<

FILLER#1 ON-DEMAND  
INPUT SIGNALS  
READ TAG  
0=BOTH 1=READY ONLY  
2=DROP COMPLETE ONLY

MOV	
Move	
Source	N40:7
	1<
Dest	N40:8
	1<

FILLER#2(READ TAG)  
FILL CONTROL  
0=OFF 1=STANDARD  
2=SLIDE GATE  
3=ON-DEMAND

MOV	
Move	
Source	N41:1
	0<
Dest	N41:2
	0<

FILLER#2 ON-DEMAND  
INPUT SIGNALS  
READ TAG  
0=BOTH 1=READY ONLY  
2=DROP COMPLETE ONLY

MOV	
Move	
Source	N41:7
	0<
Dest	N41:8
	0<

FILLER#3(READ TAG)  
FILL CONTROL  
0=OFF 1=STANDARD  
2=SLIDE GATE  
3=ON-DEMAND

MOV	
Move	
Source	N42:1
	1<
Dest	N42:2
	1<

0063

CODE# ENTERED  
IN BY PANEL VIEW

NEQ	
Not Equal	
Source A	N12:59
	2573<
Source B	2573
	2573<

FILLER#1(WRIGHT TAG)  
FILL CONTROL  
0=OFF 1=STANDARD  
2=SLIDE GATE  
3=ON-DEMAND

MOV	
Move	
Source	N40:2
	1<
Dest	N40:1
	1<

FILLER#1 ON-DEMAND  
INPUT SIGNALS  
WRIGHT TAG  
0=BOTH 1=READY ONLY  
2=DROP COMPLETE ONLY

MOV	
Move	
Source	N40:8
	1<
Dest	N40:7
	1<

FILLER#2(WRIGHT TAG)  
FILL CONTROL  
0=OFF 1=STANDARD  
2=SLIDE GATE  
3=ON-DEMAND

MOV	
Move	
Source	N41:2
	0<
Dest	N41:1
	0<

FILLER#2 ON-DEMAND  
INPUT SIGNALS  
WRIGHT TAG  
0=BOTH 1=READY ONLY  
2=DROP COMPLETE ONLY

MOV	
Move	
Source	N41:8
	0<
Dest	N41:7
	0<

FILLER#3(WRIGHT TAG)  
FILL CONTROL  
0=OFF 1=STANDARD  
2=SLIDE GATE  
3=ON-DEMAND

MOV	
Move	
Source	N42:2
	1<
Dest	N42:1
	1<

NO-BAG  
PHOTO-EYE  
I:1.0/12

MACHINE  
POSITION IN DEG.

BAG PRESENT  
B3/133

LIM	
Limit Test	310
Low Lim	310<
Test	I:3.1
	303<
High Lim	195
	195<

(L)

MACHINE  
POSITION IN DEG.

BAG PRESENT  
B3/133

0065

LIM	
Limit Test	200
Low Lim	200<
Test	I:3.1
	303<
High Lim	220
	220<

(U)

LAD 2 - --- Total Rungs in File = 185

0066

WEB  
FAILURE  
SELECTOR  
SWITCH  
I:1.0/7

CRWF-1  
FAILURE  
NO-BAG  
PRESENT  
B3/92

BAG PRESENT  
B3/133

MACHINE  
POSITION IN DEG.

LIM	
Limit Test	
Low Lim	185
	185<
Test	I:3.1
	303<
High Lim	195
	195<

BAG-RETURN PHOTOEYE  
I:1.1/2

CHANNEL #18 PSBR  
POUCH RETURN  
TIMING  
I:3.4/1

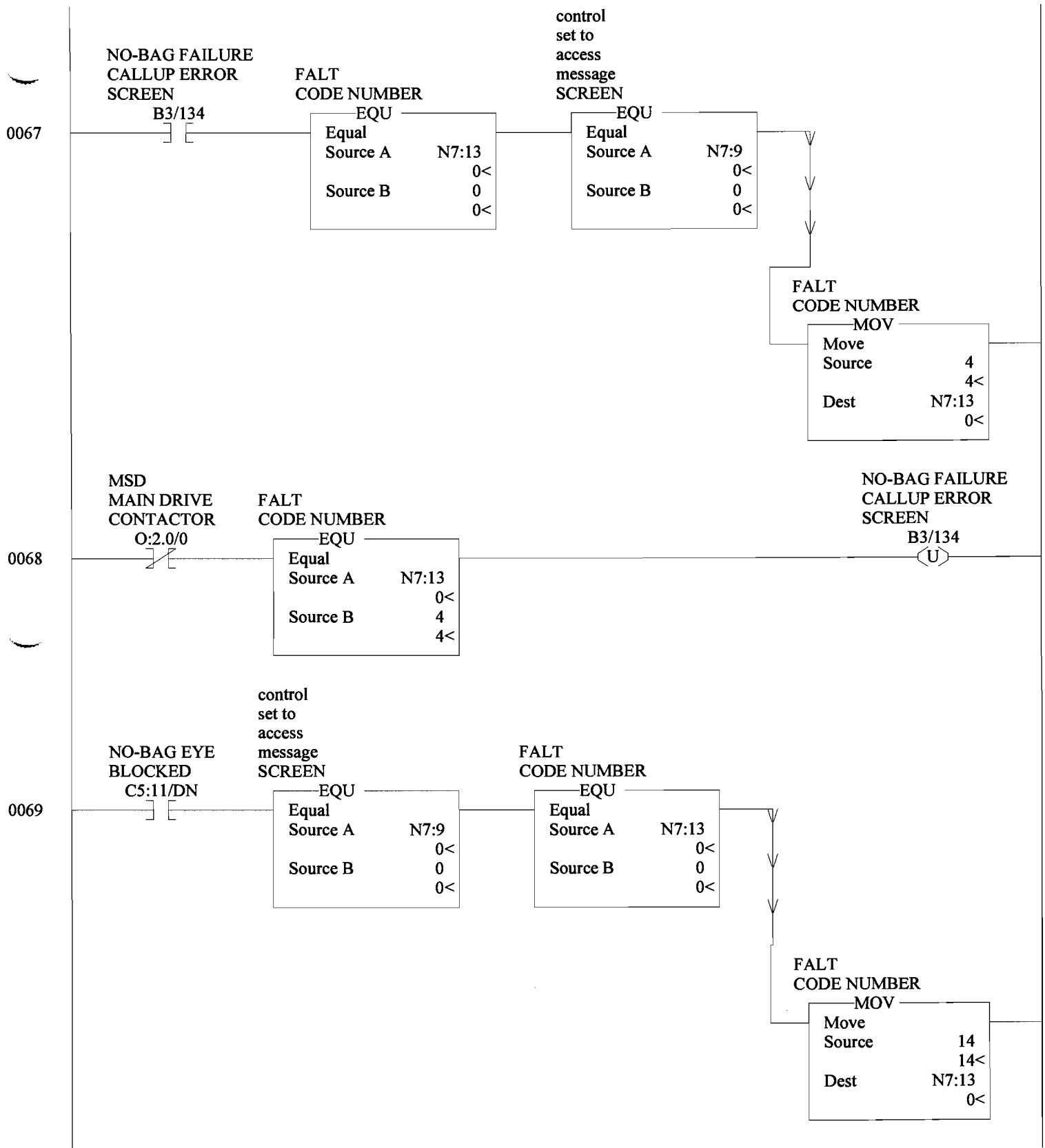
CRWF-1  
FAILURE  
NO-BAG  
PRESENT  
B3/92

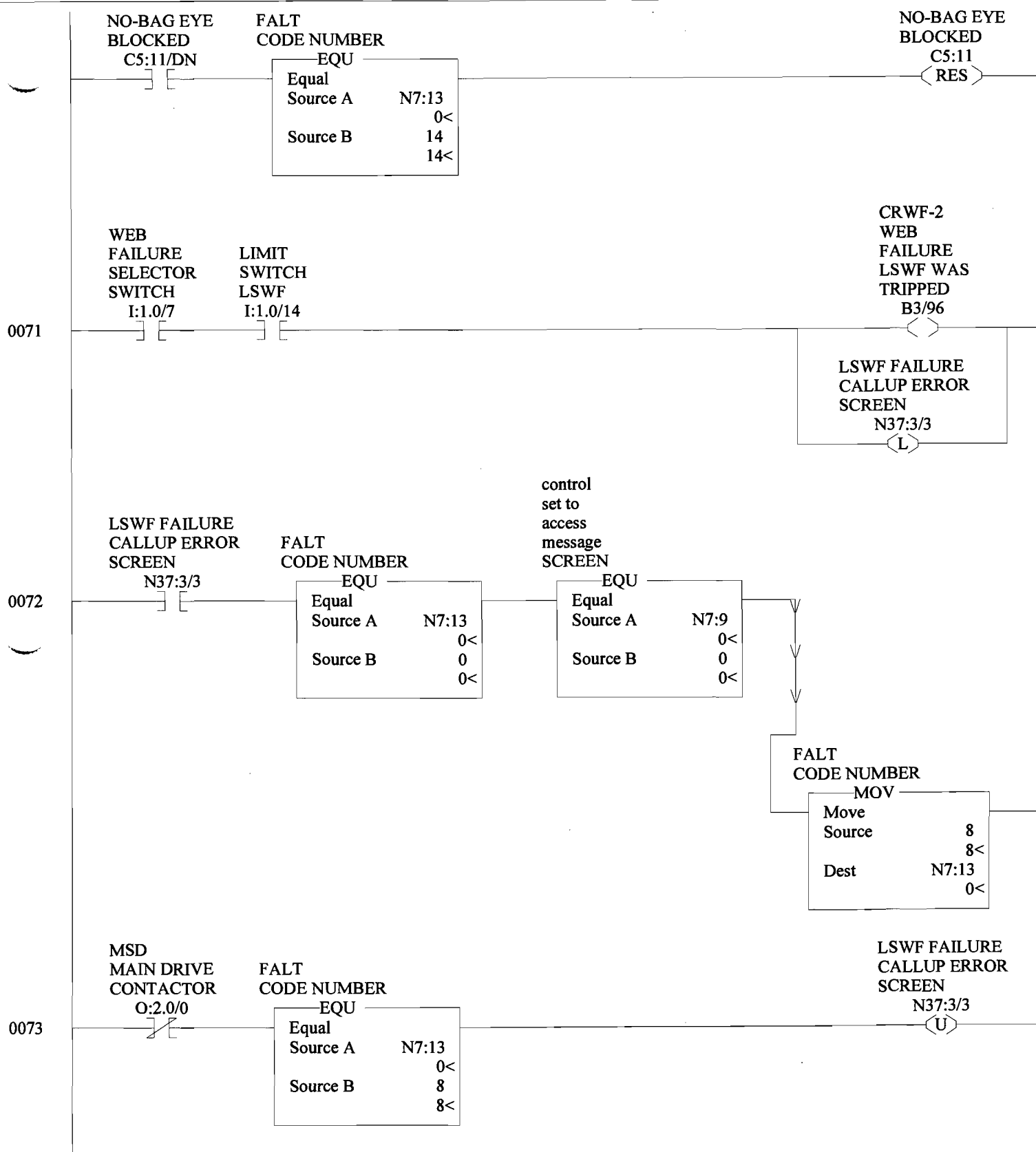
BAG PRESENT  
B3/133

NO-BAG FAILURE  
CALLUP ERROR  
SCREEN  
B3/134

BAG-RETURN PHOTOEYE  
I:1.1/2

BAG-RETURN  
B3/128





0074

GUARDS BYPASSED S ELECTOR I:1.0/2  
 WEB FAILURE SELECTOR SWITCH I:1.0/7  
 RUN - JOG SELECTOR SWITCH I:1.0/4  
 MACHINE POSITION IN DEG.

LIM	
Limit Test	180
Low Lim	180<
Test	I:3.1
	303<
High Lim	200
	200<

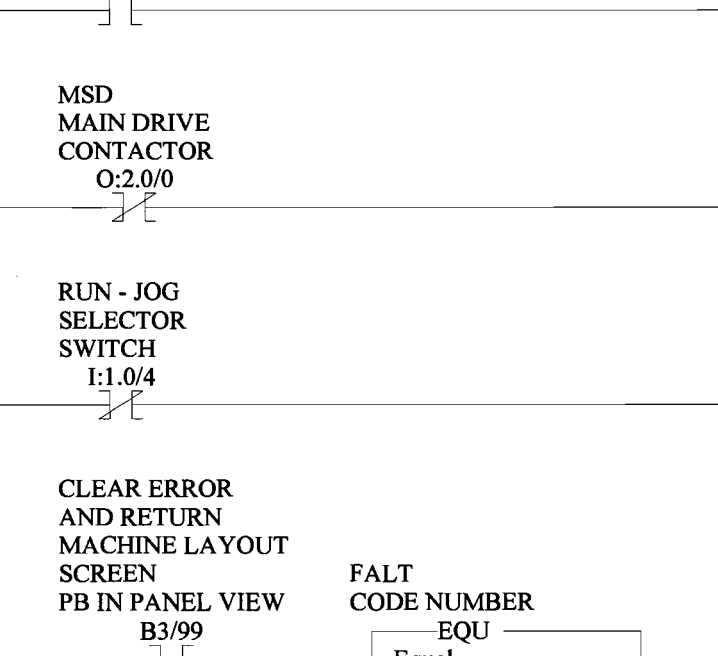
WEB FAILURE SELECTOR NOT ON ALLOW 3 INDEXES BEFORE POSTION STOP

CTU	
Count Up Counter	C5:6
Preset	3<
Accum	0<

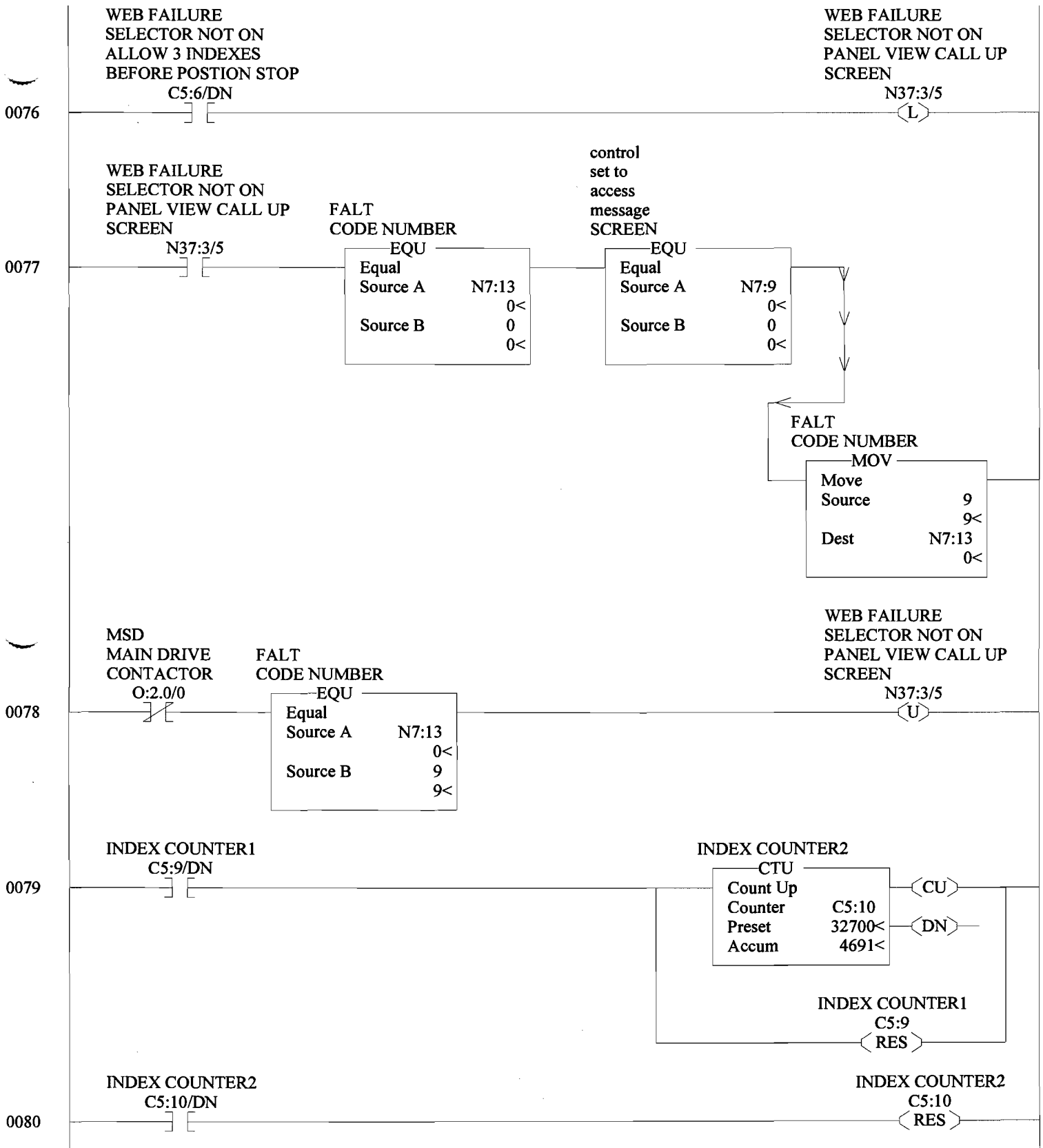
(CU)  
(DN)

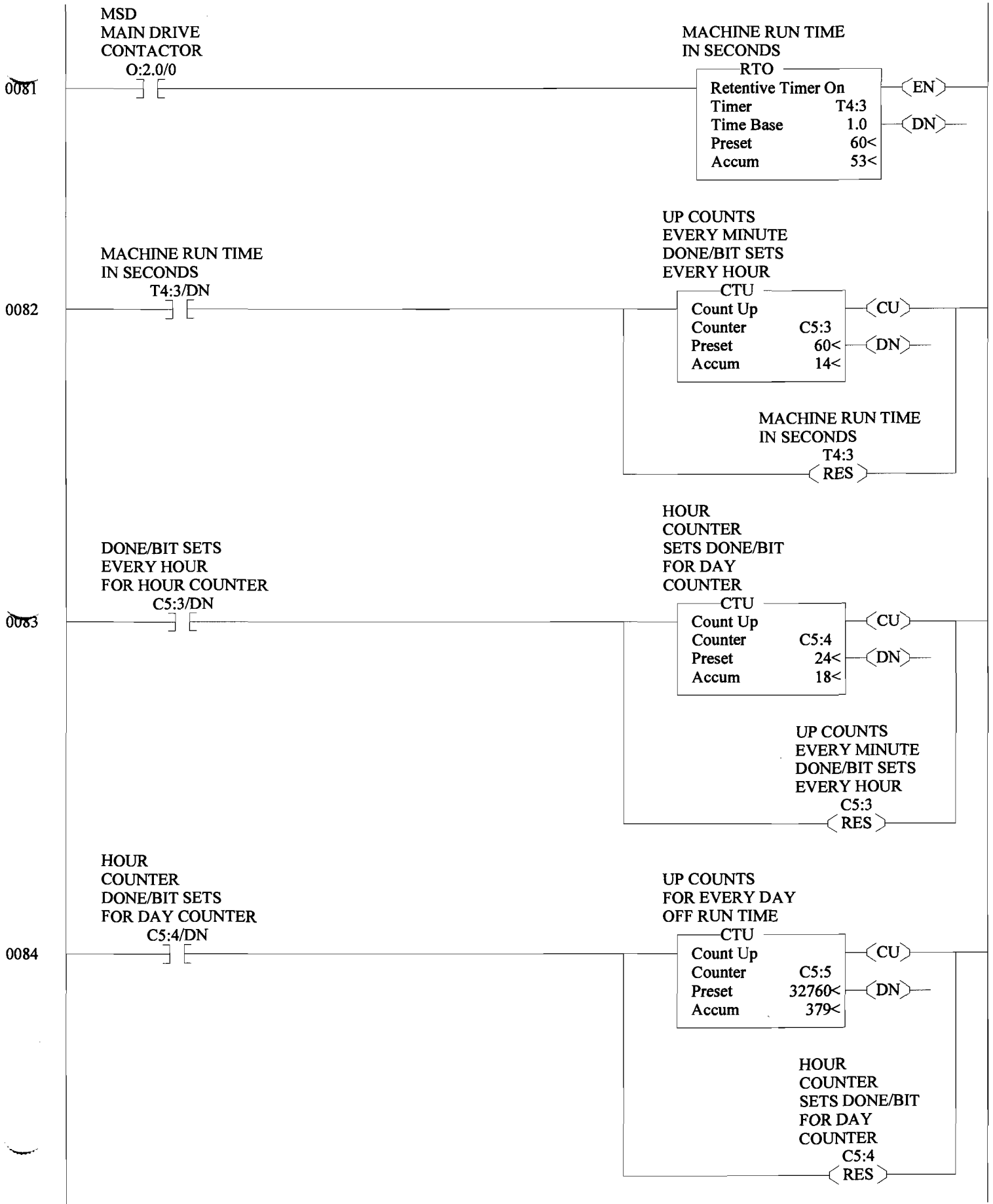
WEB FAILURE SELECTOR SWITCH I:1.0/7

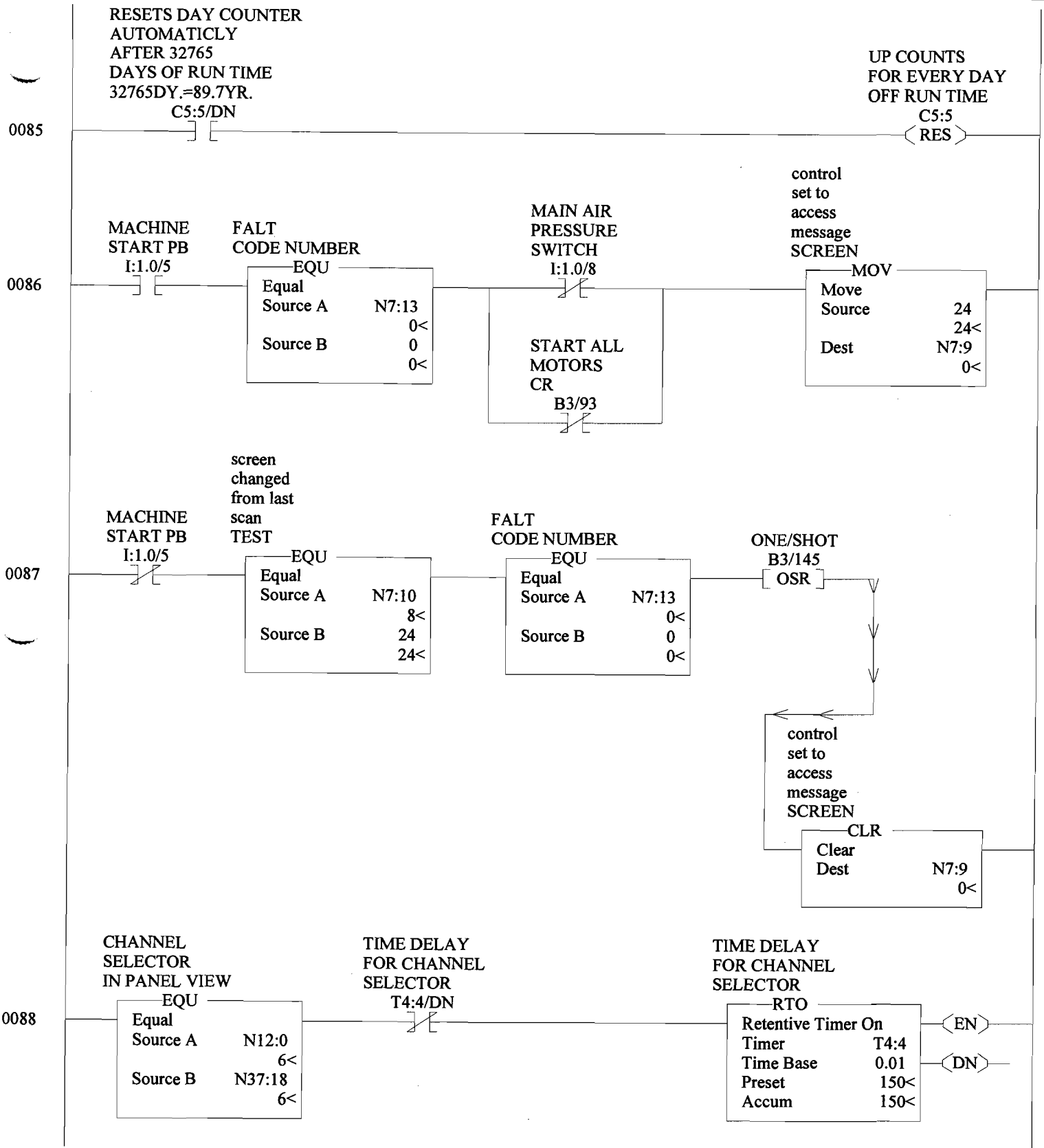
WEB FAILURE SELECTOR NOT ON ALLOW 3 INDEXES BEFORE POSTION STOP  
 C5:6  
 (RES)



FALT CODE NUMBER EQU	
Equal Source A	N7:13
	0<
Source B	9
	9<







0089

CHANNEL  
SELECTOR  
IN PANEL VIEW

NEQ	
Not Equal	
Source A	N12:0
	6<
Source B	N37:18
	6<

TIME DELAY  
FOR CHANNEL  
SELECTOR  
T4:4  
(RES)

COMPARE FOR  
SELECTOR CHANGE  
ALLOW ONE SCAN  
B3/211

(U)

1ST ON  
SETPOINT  
COMPARE FOR CHANGE

MOV

Move	
Source	N12:4
	95<
Dest	N37:10
	95<

1ST OFF  
SETPOINT  
COMPARE FOR CHANGE

MOV

Move	
Source	N12:5
	200<
Dest	N37:11
	200<

2ND ON  
SETPOINT  
COMPARE FOR CHANGE

MOV

Move	
Source	N12:8
	95<
Dest	N37:12
	95<

2ND OFF  
SETPOINT  
COMPARE FOR  
CHANGE

MOV

Move	
Source	N12:9
	200<
Dest	N37:13
	200<

3RD ON  
SETPOINT  
COMPARE FOR CHANGE

MOV	
Move	
Source	N12:12 10<
Dest	N37:14 10<

3RD OFF  
SETPOINT  
COMPARE FOR CHANGE

MOV	
Move	
Source	N12:13 205<
Dest	N37:15 205<

4TH ON  
SETPOINT  
COMPARE FOR CHANGE

MOV	
Move	
Source	N12:16 0<
Dest	N37:16 0<

4TH OFF  
SETPOINT  
COMPARE FOR CHANGE

MOV	
Move	
Source	N12:17 0<
Dest	N37:17 0<

COMPARE FOR  
SELECTOR  
SWITCH CHANGE

MOV	
Move	
Source	N12:0 6<
Dest	N37:18 6<

TIME DELAY  
FOR CHANNEL  
SELECTOR  
T4:4/DN

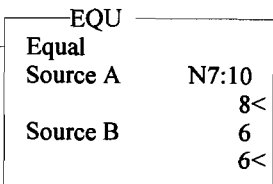
COMPARE FOR  
SELECTOR CHANGE  
ALLOW ONE SCAN  
B3/211

0090

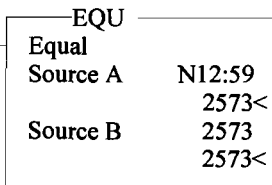
L

0091

screen  
changed  
from last  
scan  
TEST



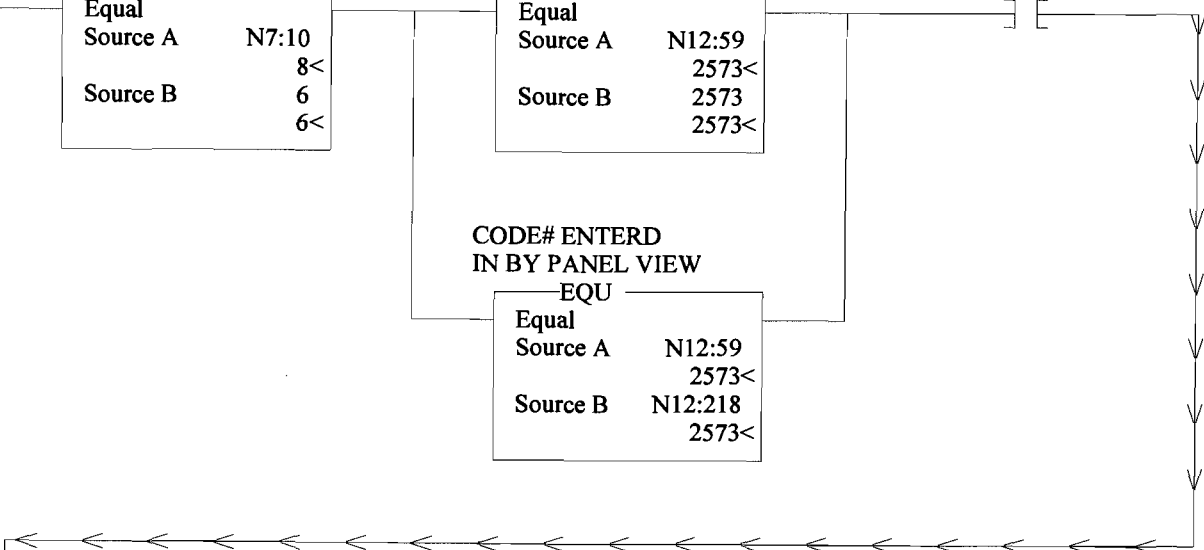
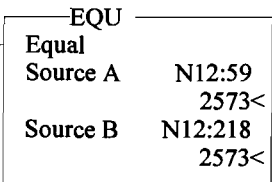
CODE# ENTERD  
IN BY PANEL VIEW



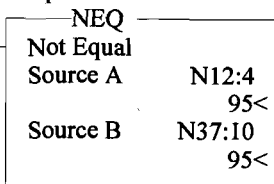
COMPARE FOR  
SELECTOR CHANGE  
ALLOW ONE SCAN

B3/211

CODE# ENTERD  
IN BY PANEL VIEW

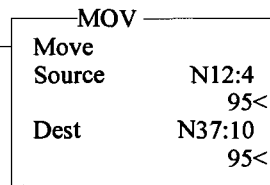


on setpnt

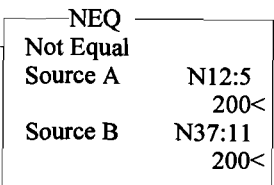


OSR  
B3/147  
OSR

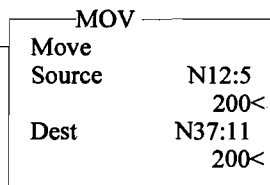
1ST ON  
SETPOINT  
COMPARE FOR CHANGE



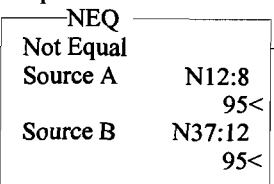
off setpnt



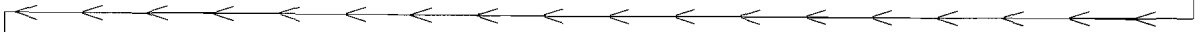
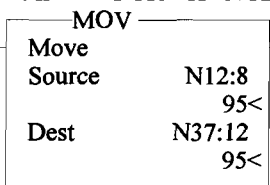
1ST OFF  
SETPOINT  
COMPARE FOR CHANGE

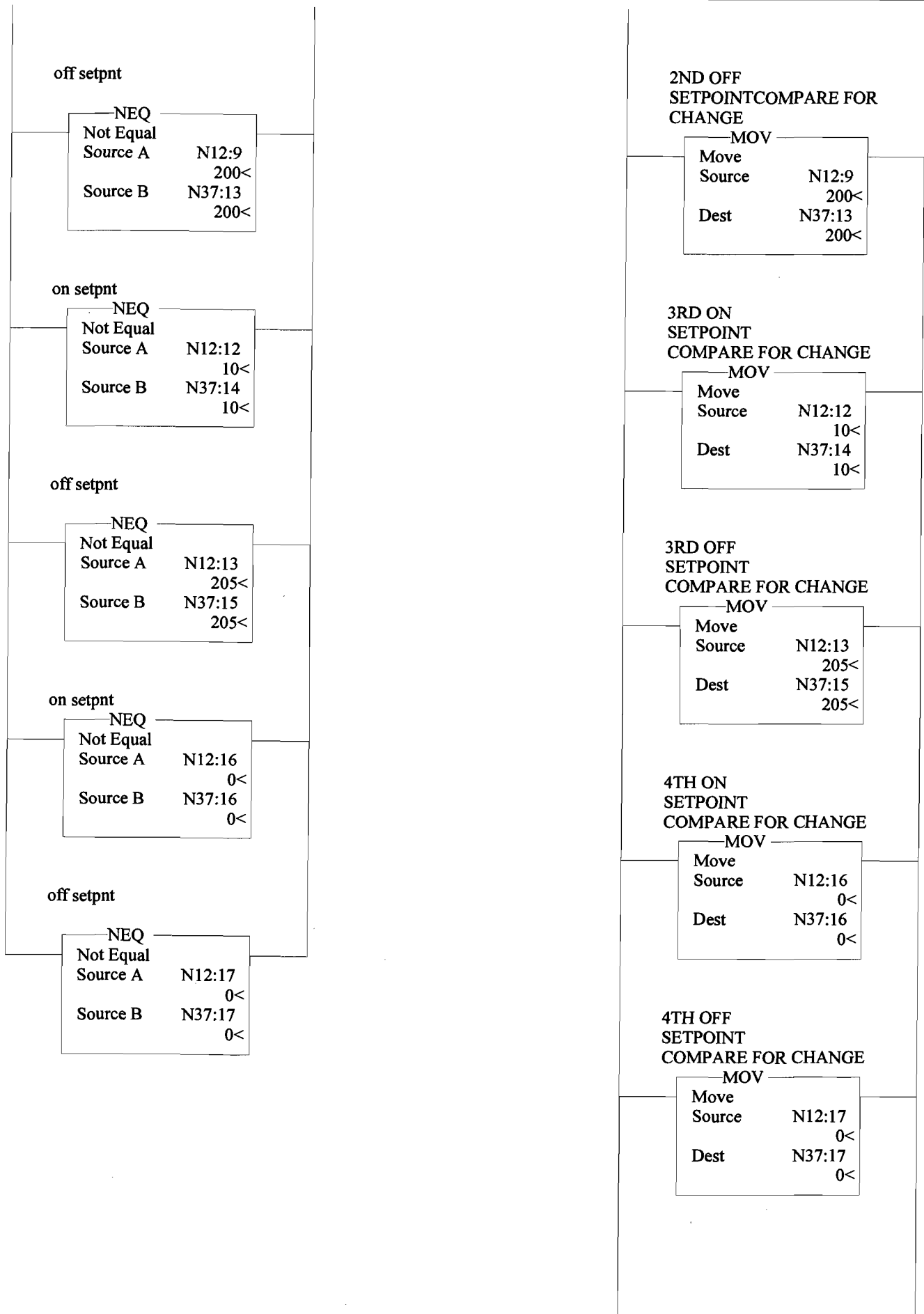


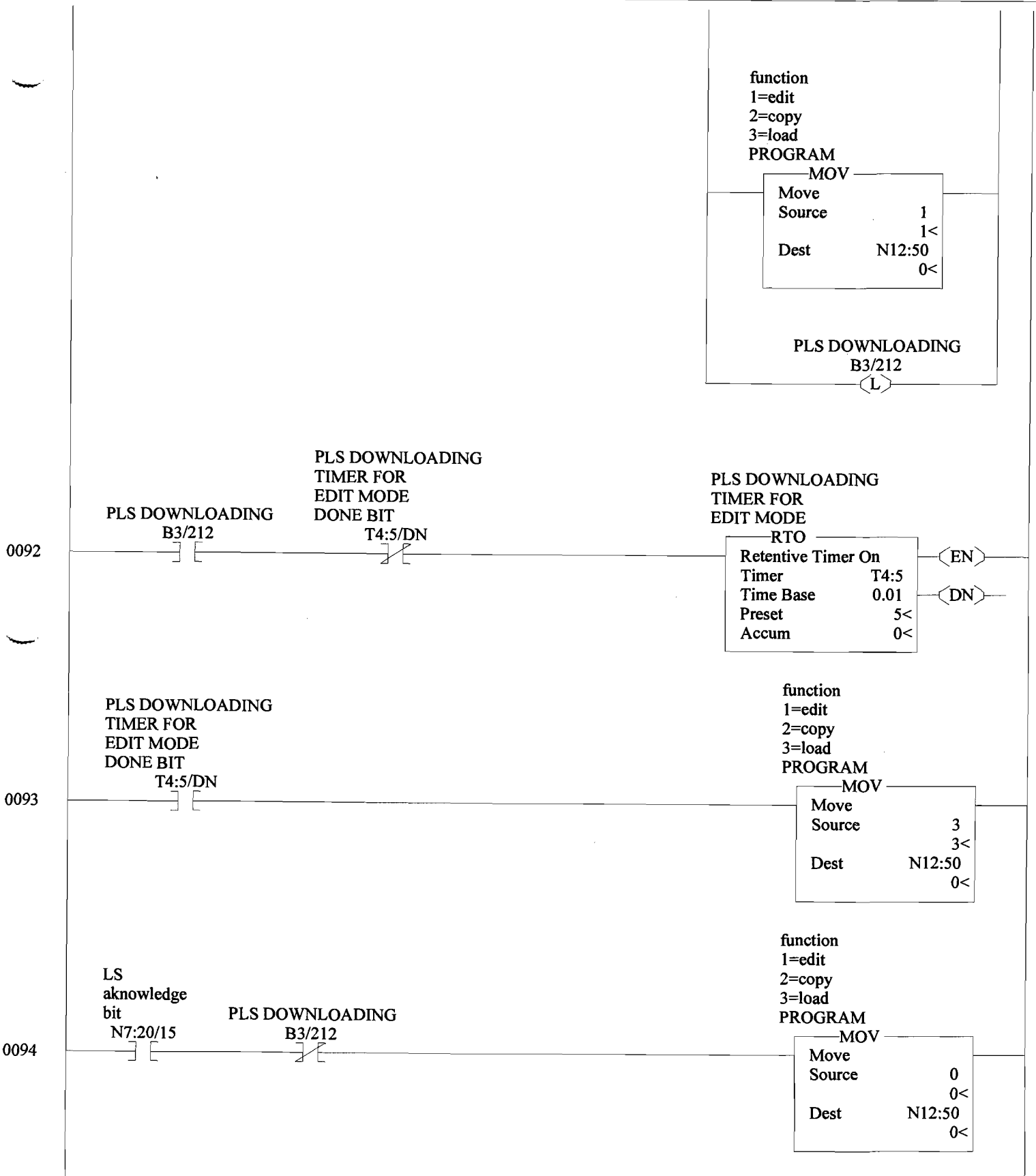
on setpnt

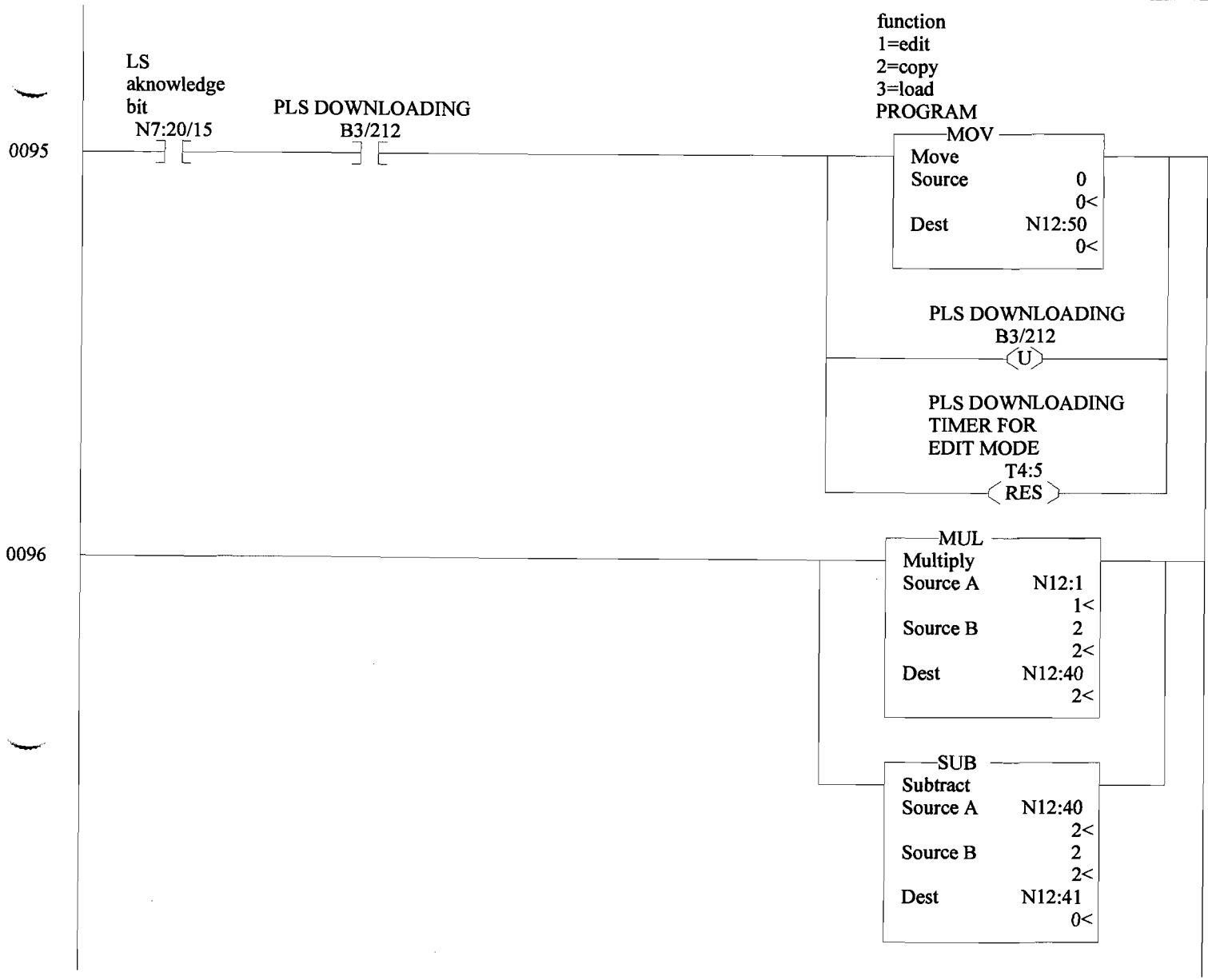


2ND ON  
SETPOINT  
COMPARE FOR CHANGE









0097

MUL  
 Multiply  
 Source A N12:0  
 6<  
 Source B 76  
 76<  
 Dest N12:42  
 456<

value same  
 as last  
 scan  
 INDEX

SUB  
 Subtract  
 Source A N12:42  
 456<  
 Source B 76  
 76<  
 Dest N12:43  
 380<

value same  
 as last  
 scan

0098

ADD  
 Add  
 Source A N12:43  
 380<  
 Source B N12:41  
 0<  
 Dest N12:44  
 380<

0099

MUL  
 Multiply  
 Source A N12:0  
 6<  
 Source B 4  
 4<  
 Dest N12:45  
 24<

SUB  
 Subtract  
 Source A N12:45  
 24<  
 Source B 3  
 3<  
 Dest N12:2  
 21<

0100

MUL  
Multiply  
Source A N12:0  
6<  
Source B 4  
4<  
Dest N12:46  
24<

SUB  
Subtract  
Source A N12:46  
24<  
Source B 2  
2<  
Dest N12:6  
22<

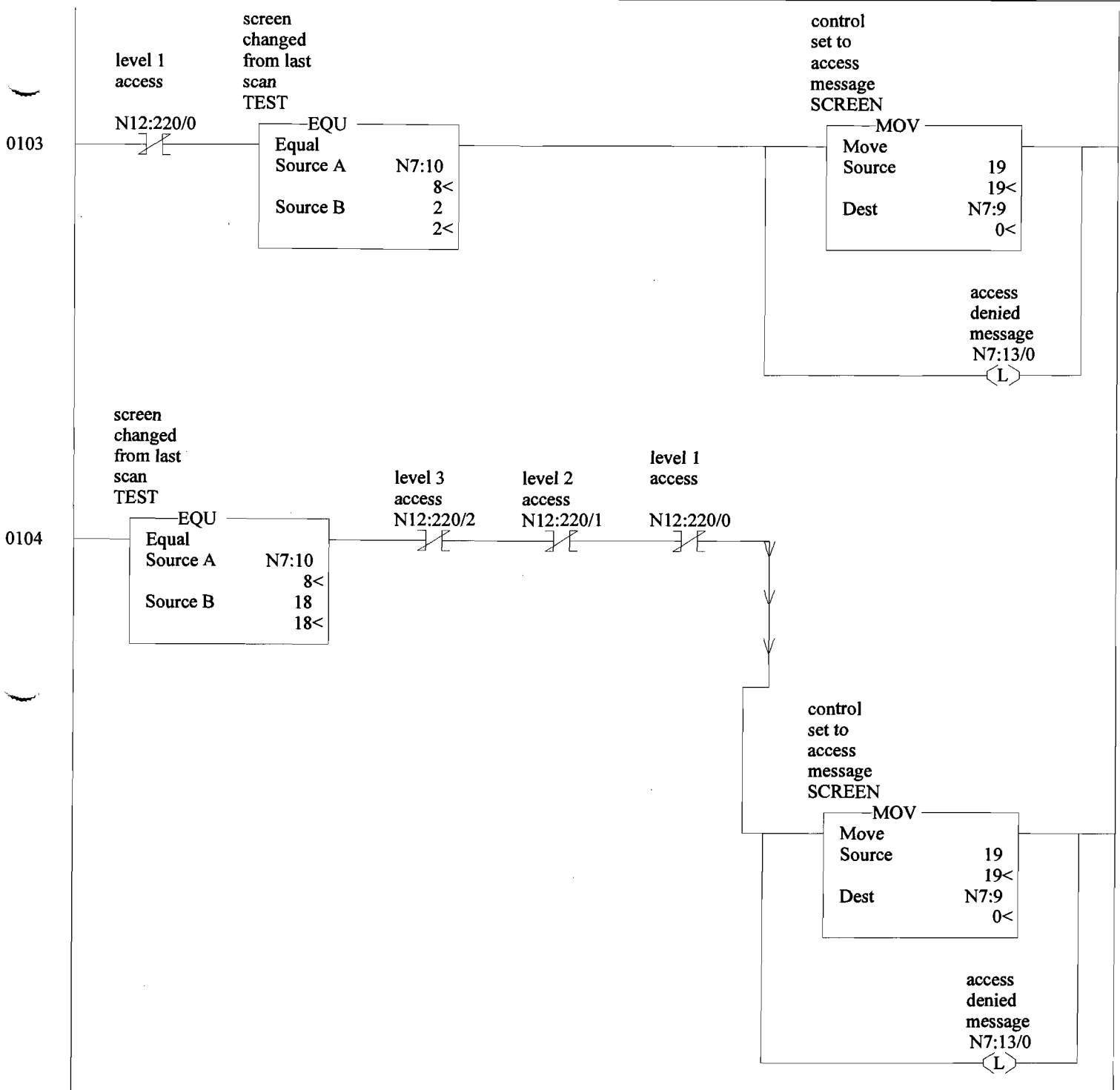
0101

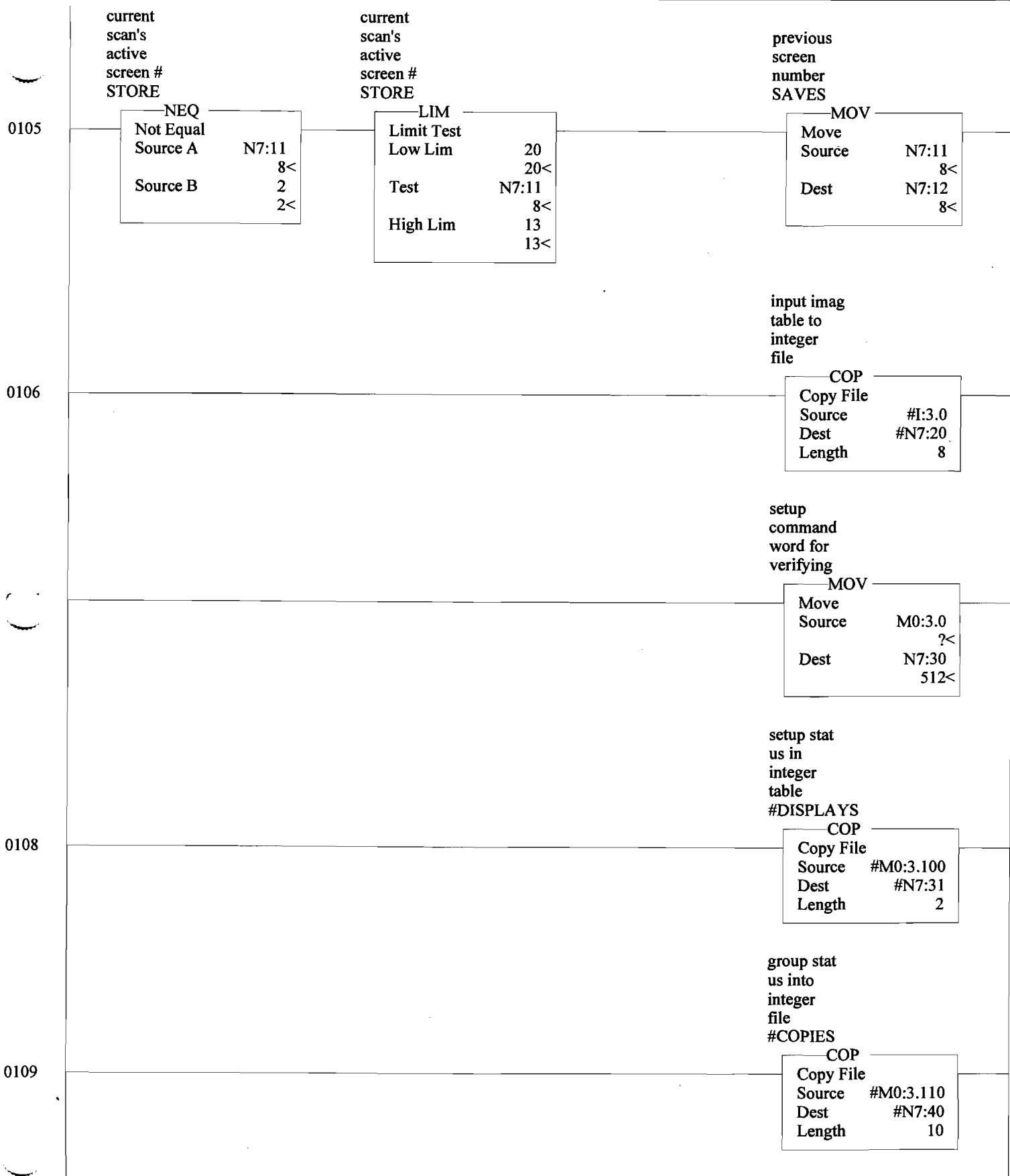
MUL  
Multiply  
Source A N12:0  
6<  
Source B 4  
4<  
Dest N12:47  
24<

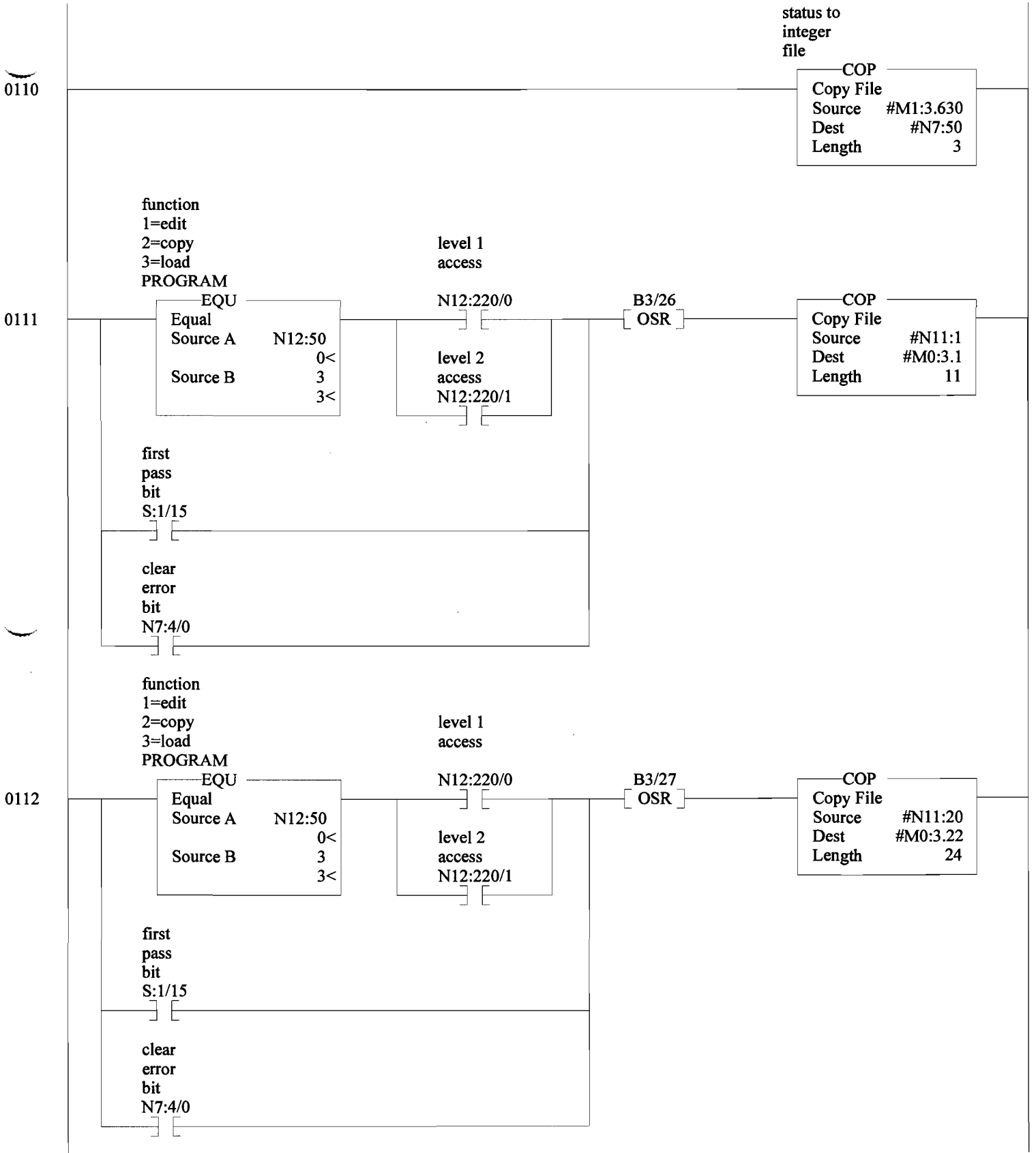
SUB  
Subtract  
Source A N12:47  
24<  
Source B 1  
1<  
Dest N12:10  
23<

0102

MUL  
Multiply  
Source A N12:0  
6<  
Source B 4  
4<  
Dest N12:14  
24<

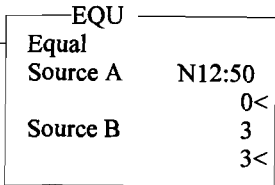






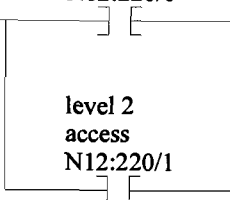
0113

function  
1=edit  
2=copy  
3=load  
PROGRAM



level 1  
access

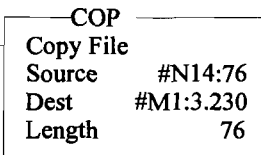
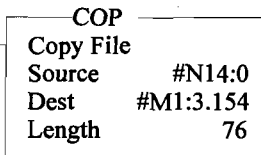
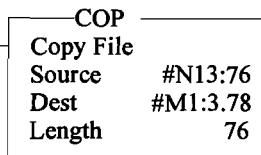
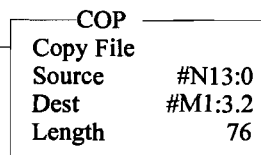
N12:220/0

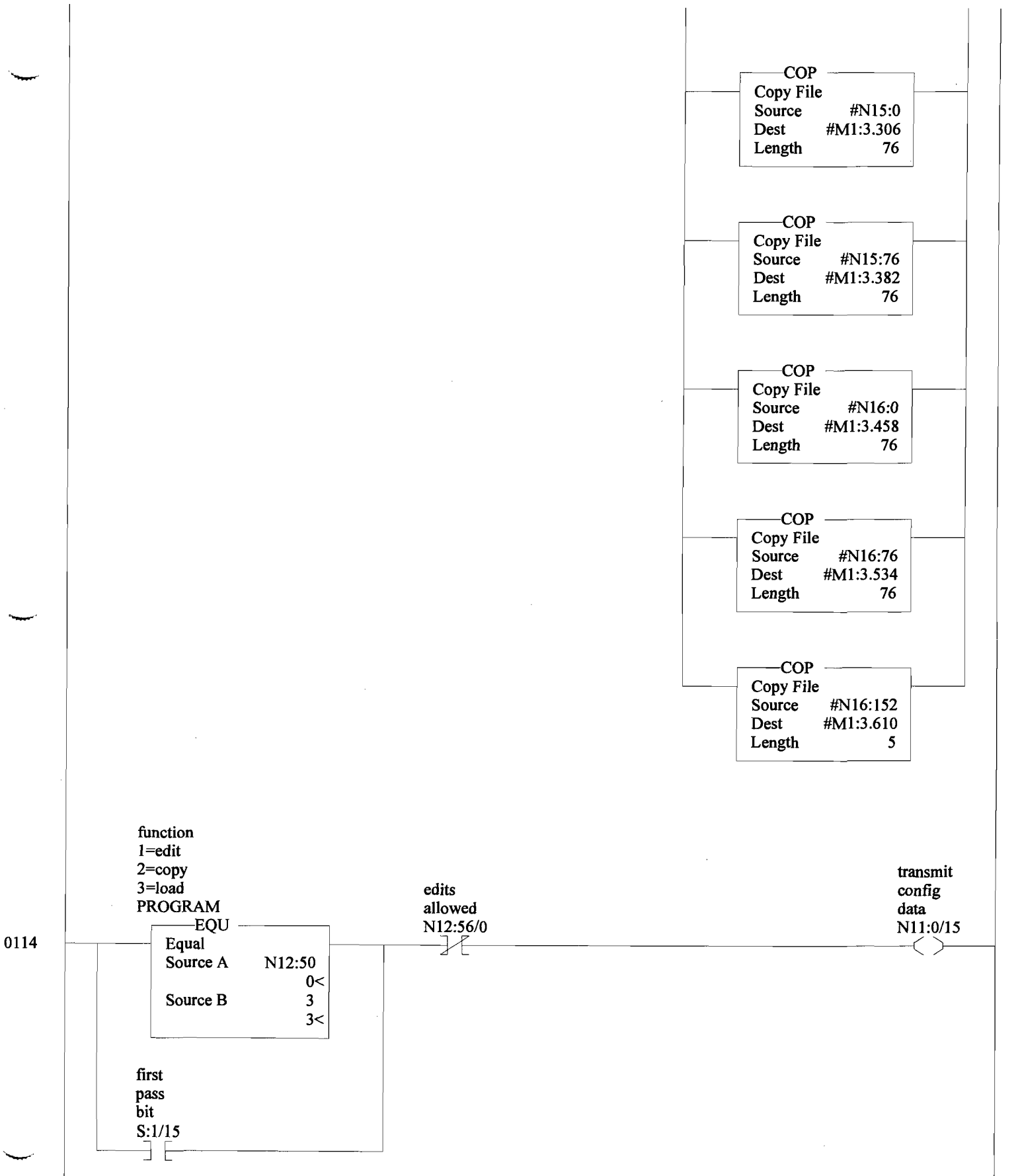


B3/28  
OSR

first  
pass  
bit  
S:1/15

clear  
error  
bit  
N7:4/0





0114

0115

function  
1=edit  
2=copy  
3=load  
PROGRAM

EQU  
Equal  
Source A    N12:50  
              0<  
Source B     3  
              3<

level 1  
access

N12:220/0

edits  
allowed  
N12:56/0

level 2  
access

N12:220/1

function  
1=edit  
2=copy  
3=load  
PROGRAM

NEQ  
Not Equal  
Source A    N12:50  
              0<  
Source B     3  
              3<

input imag  
table to  
integer  
file  
N7:20/13

first  
pass  
bit  
S:1/15

clear  
error  
bit  
N7:4/0

MOV

Move  
Source        N11:0  
              512<  
Dest         M0:3.0  
              ?<

0116

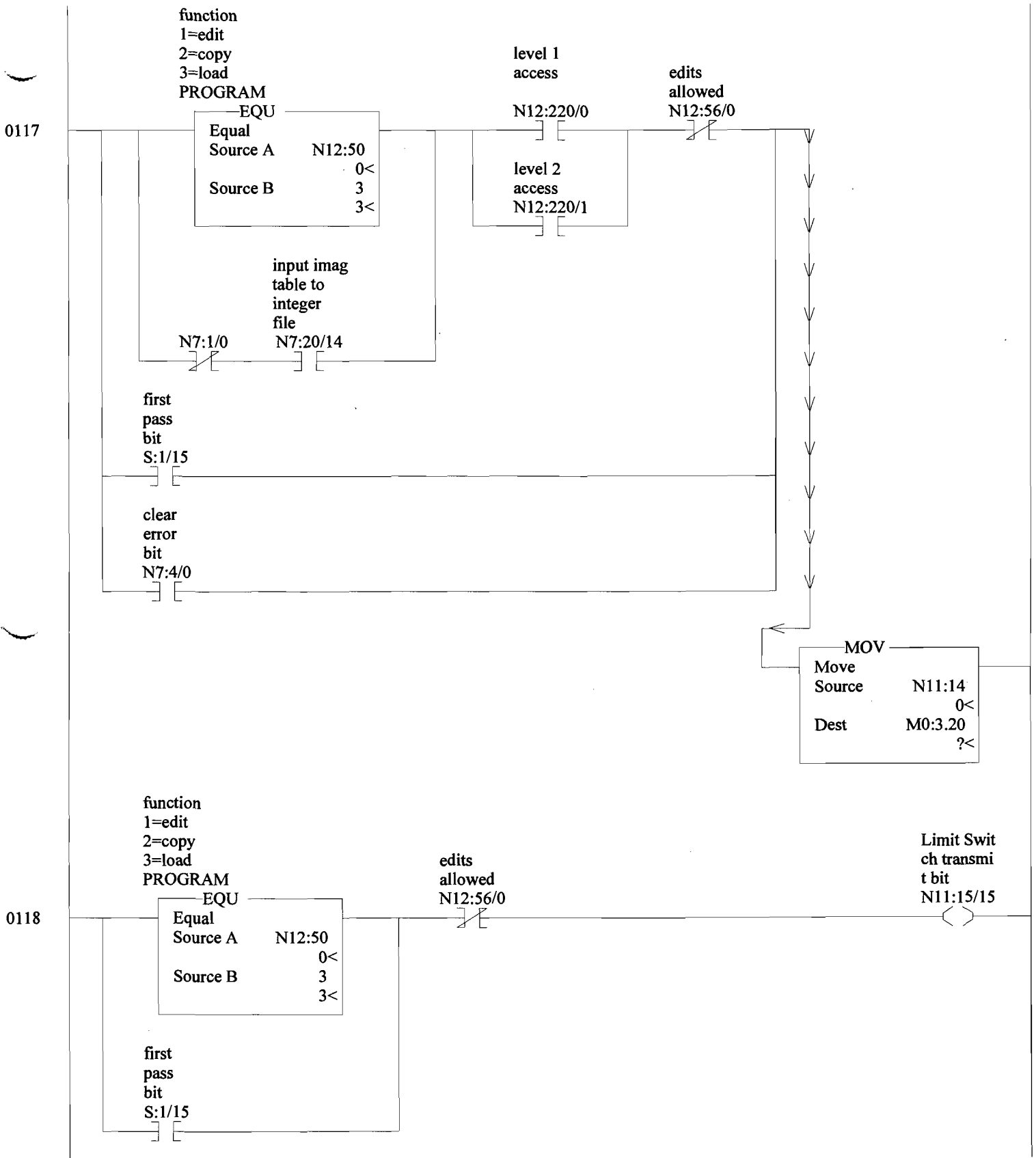
function  
1=edit  
2=copy  
3=load  
PROGRAM

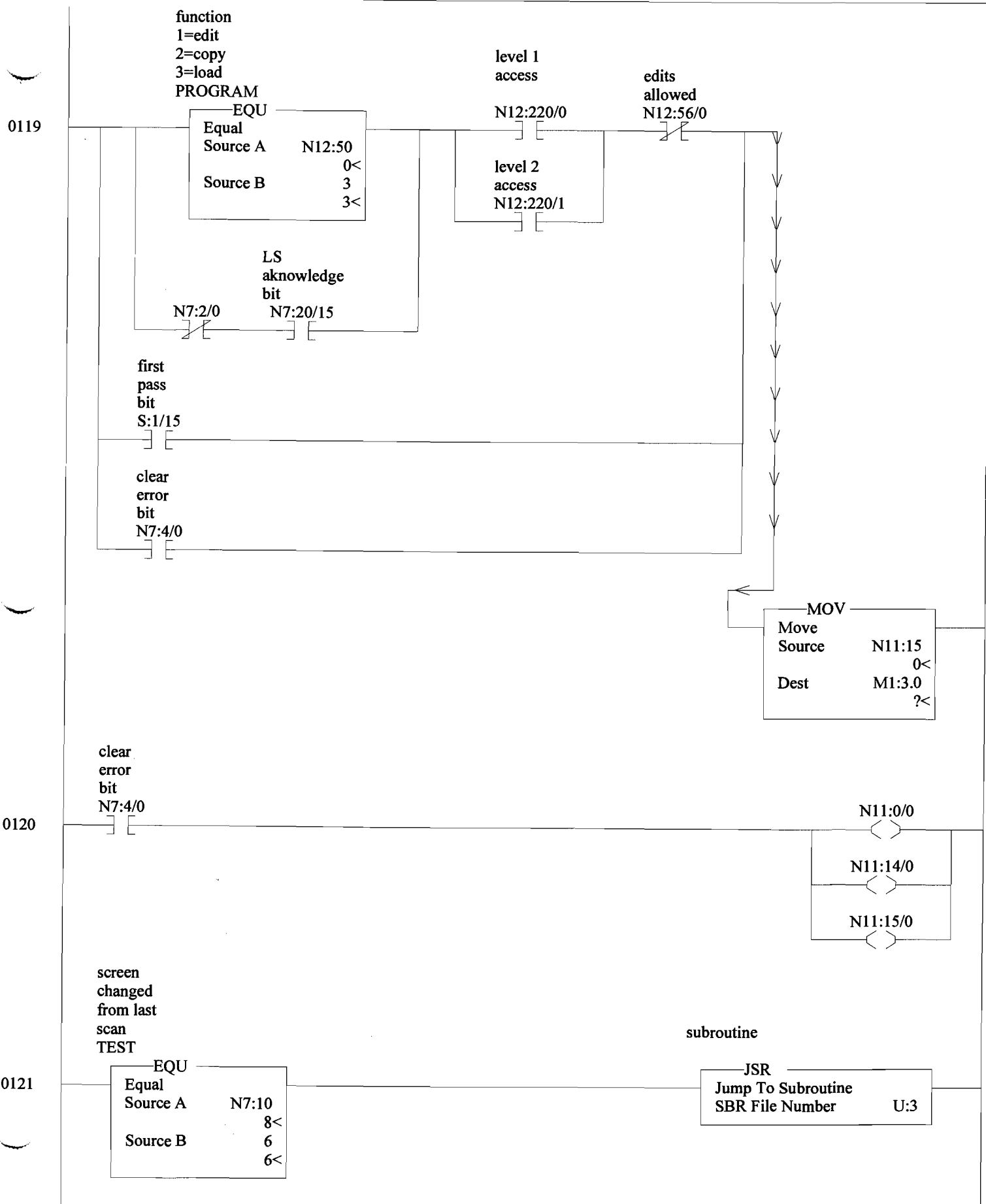
EQU  
Equal  
Source A    N12:50  
              0<  
Source B     3  
              3<

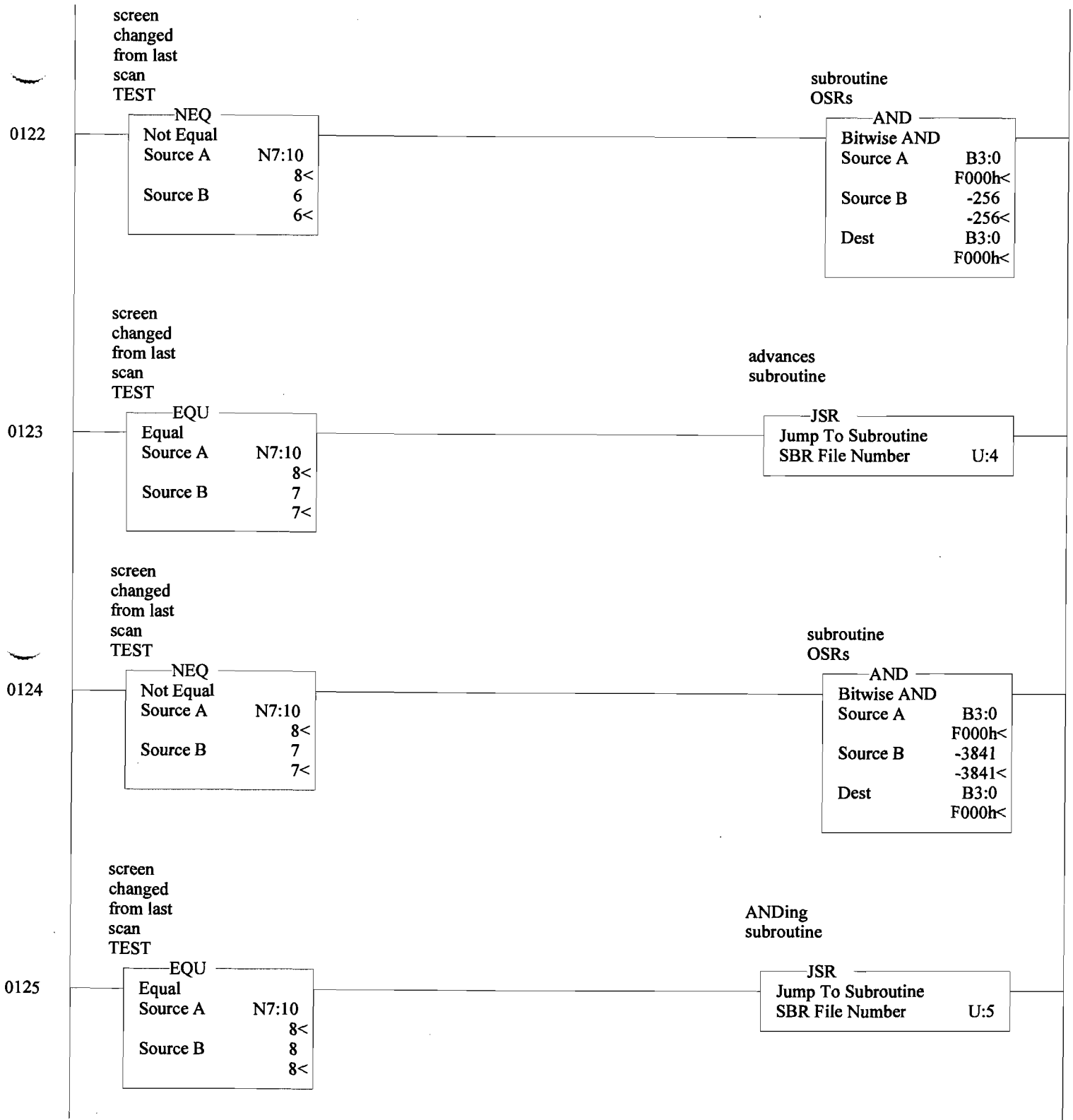
edits  
allowed  
N12:56/0

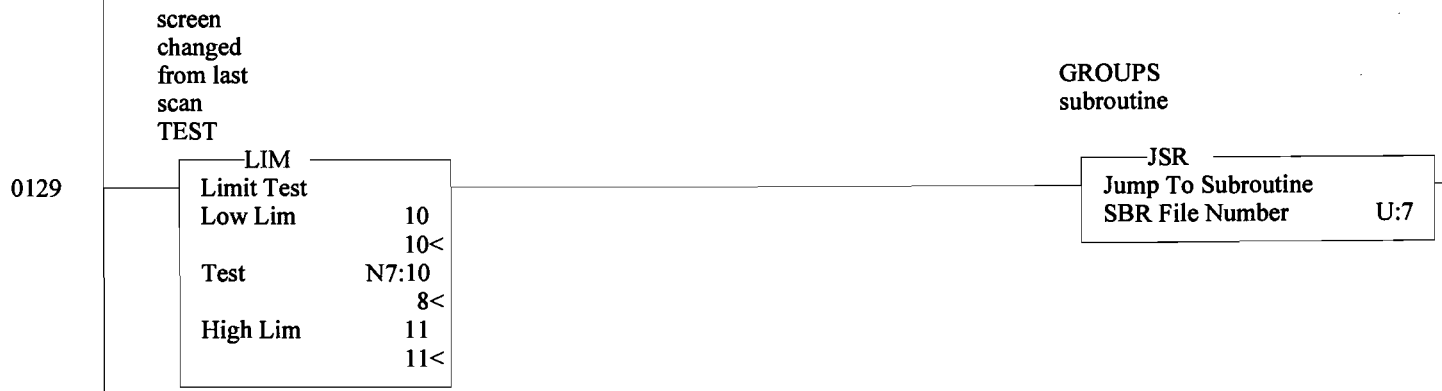
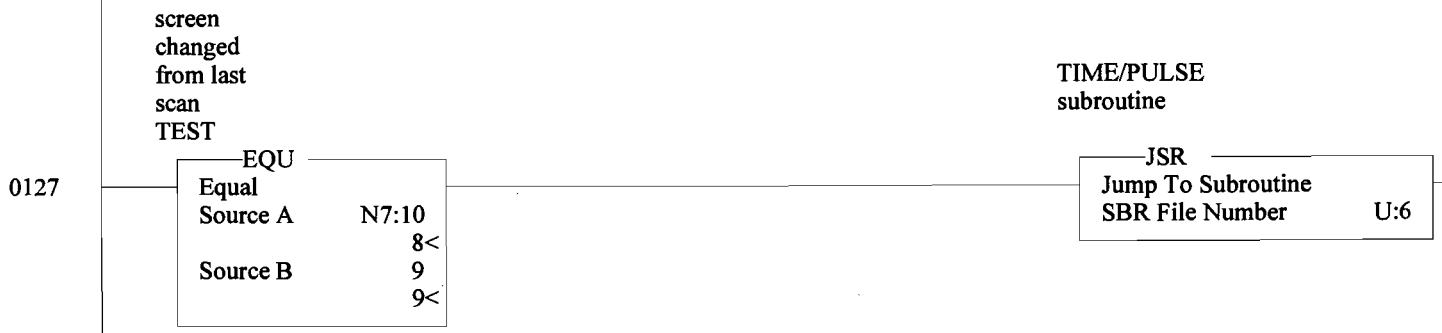
group data  
transmit  
N11:14/15

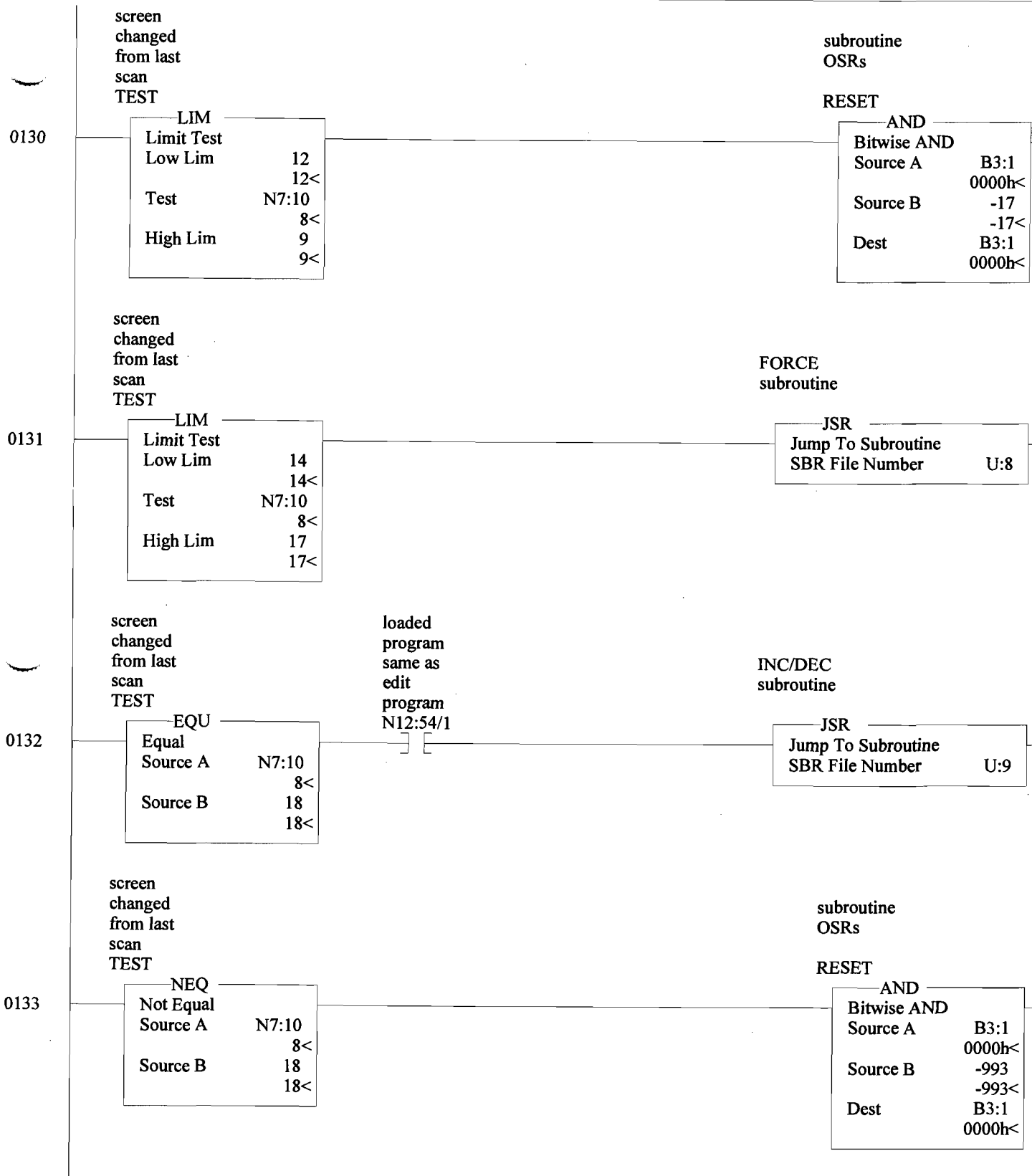
first  
pass  
bit  
S:1/15

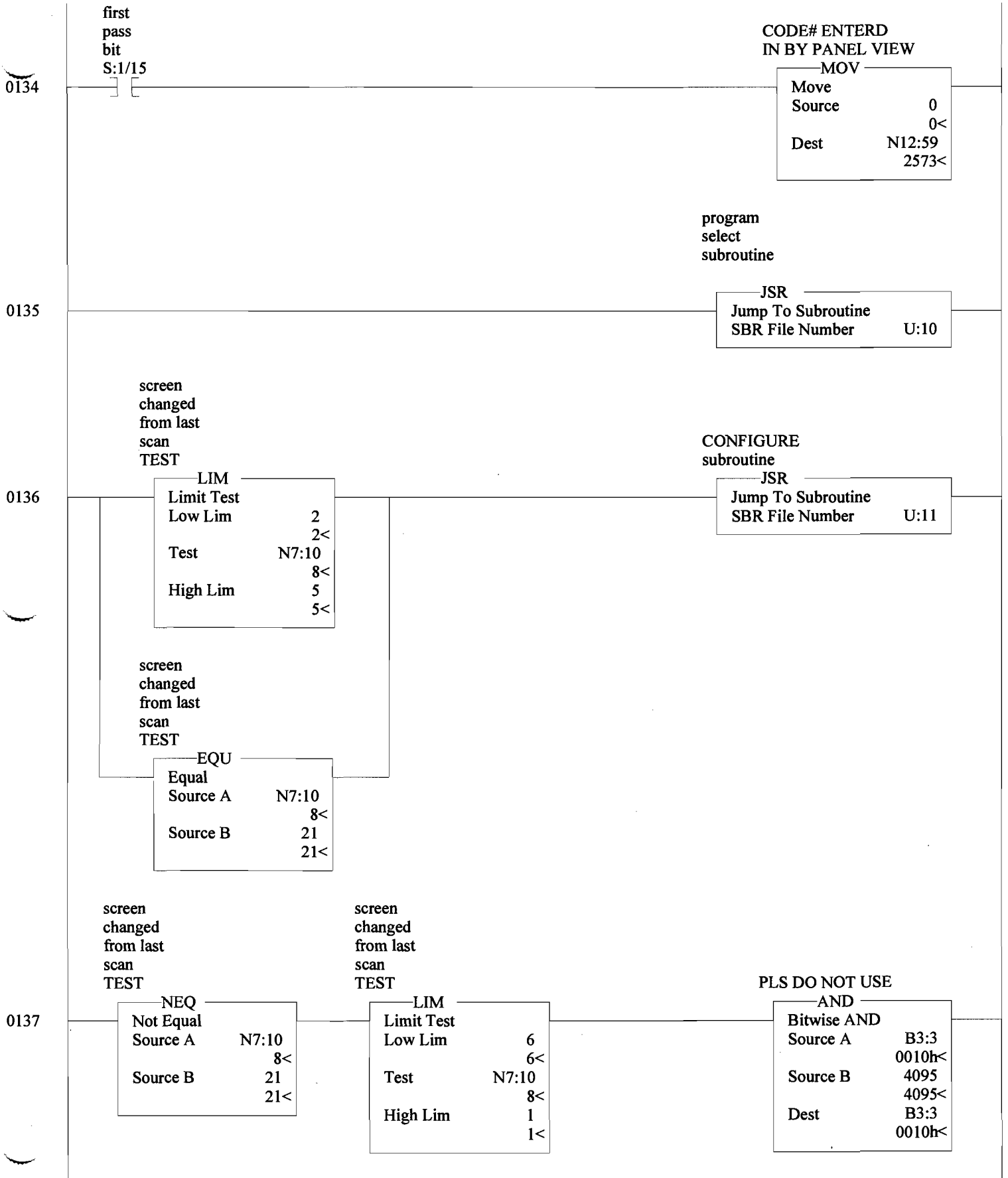


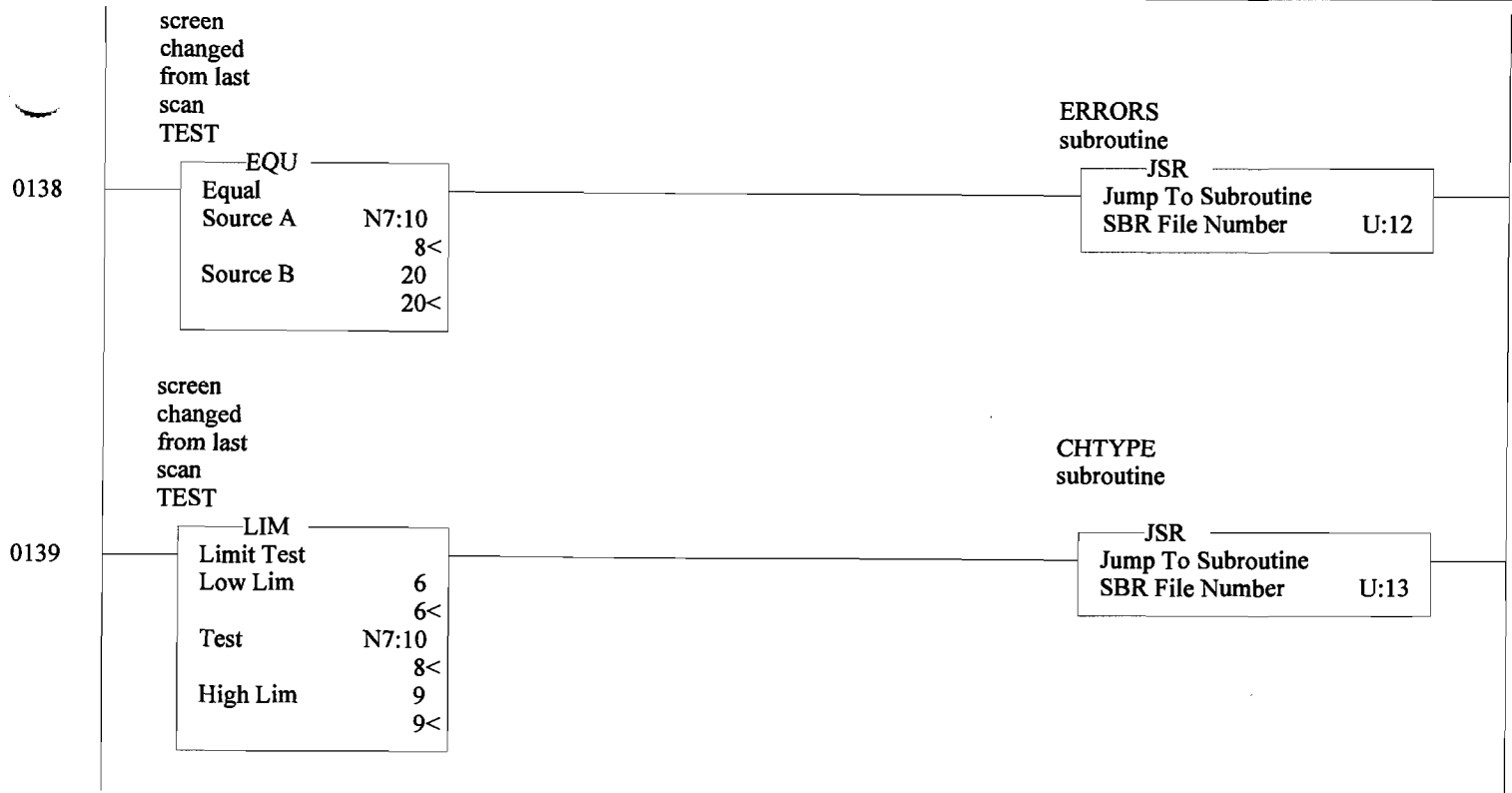






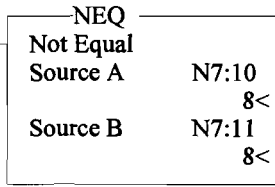




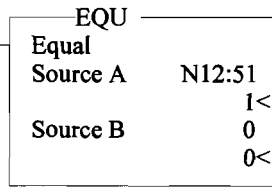


0140

screen  
changed  
from last  
scan  
TEST



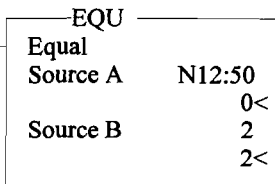
program  
number  
SELECTED



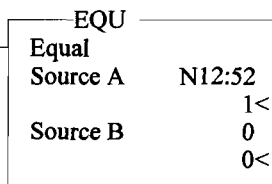
edits  
allowed  
N12:56/0



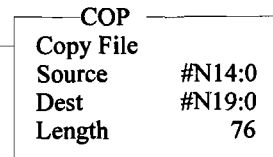
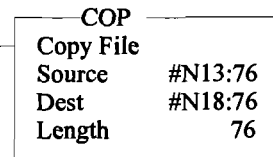
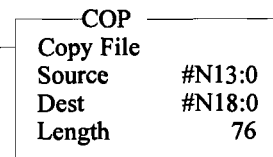
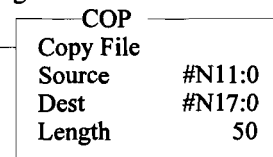
function  
1=edit  
2=copy  
3=load  
PROGRAM



program  
number



in Prg 1  
registers



COP  
Copy File  
Source #N14:76  
Dest #N19:76  
Length 76

COP  
Copy File  
Source #N15:0  
Dest #N20:0  
Length 76

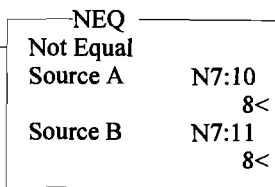
COP  
Copy File  
Source #N15:76  
Dest #N20:76  
Length 76

COP  
Copy File  
Source #N16:0  
Dest #N21:0  
Length 76

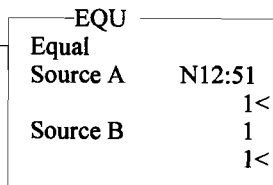
COP  
Copy File  
Source #N16:76  
Dest #N21:76  
Length 81

0141

screen  
changed  
from last  
scan  
TEST



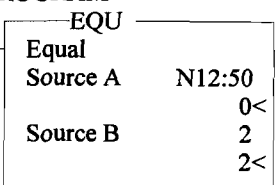
program  
number  
SELECTED



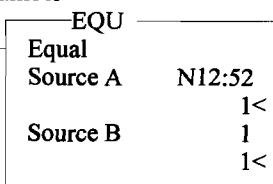
edits  
allowed  
N12:56/0



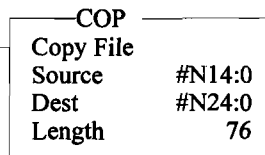
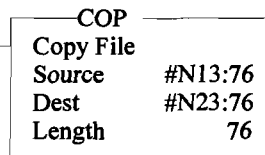
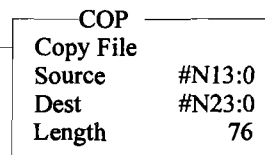
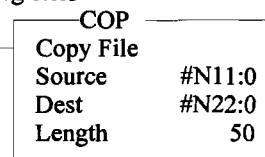
function  
1=edit  
2=copy  
3=load  
PROGRAM

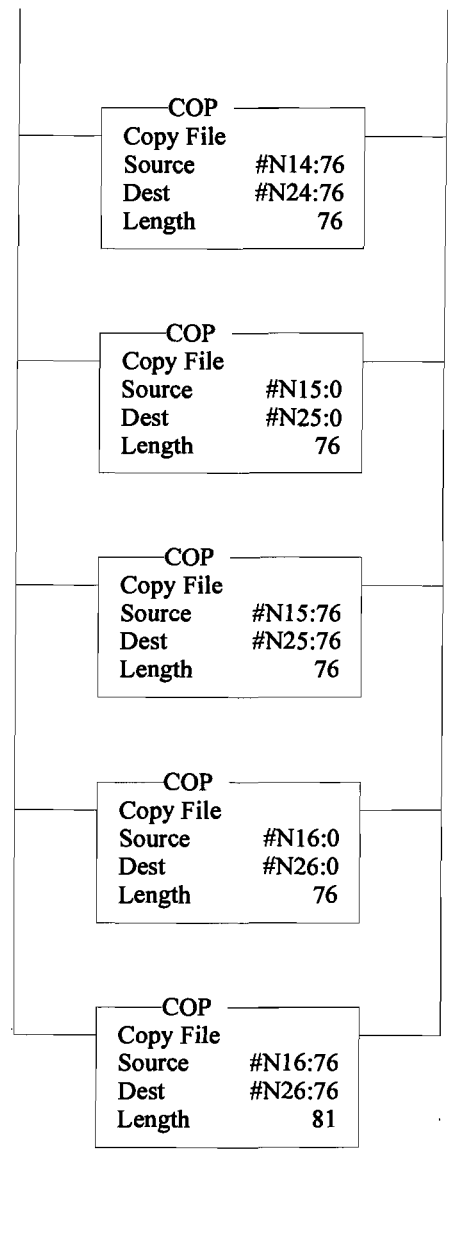


program  
number



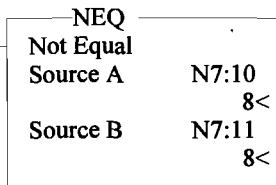
in Prg 2  
registers



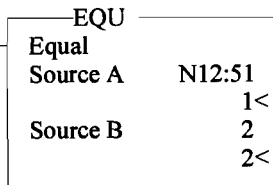


0142

screen  
changed  
from last  
scan  
TEST



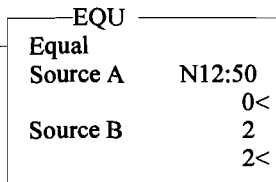
program  
number  
SELECTED



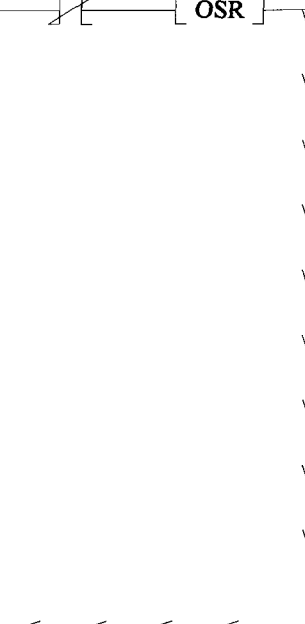
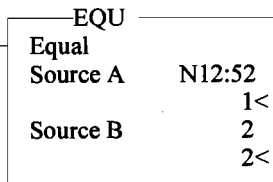
edits  
allowed  
N12:56/0



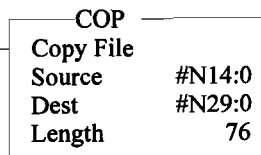
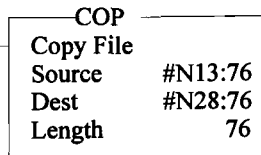
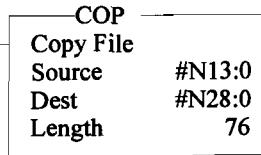
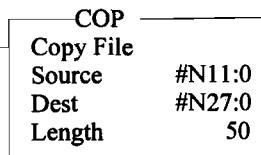
function  
1=edit  
2=copy  
3=load  
PROGRAM

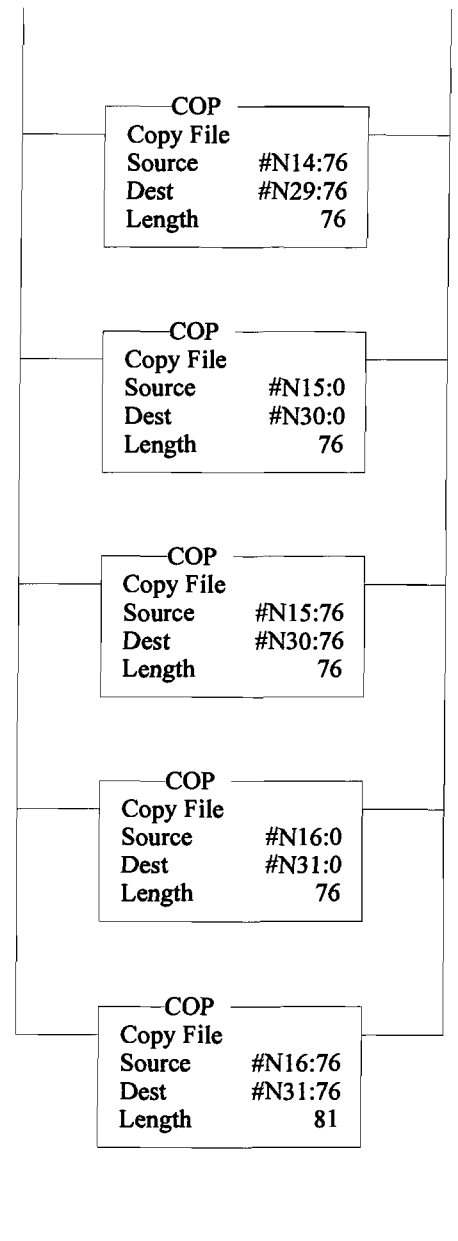


program  
number



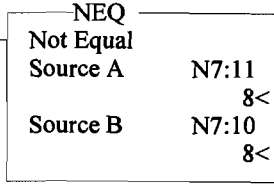
in Prg3  
resgisters



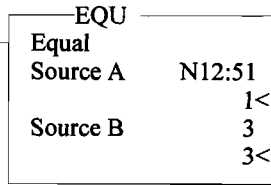


0143

current scan's active screen # STORE



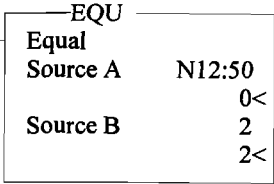
program number SELECTED



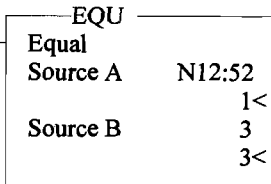
edits allowed N12:56/0



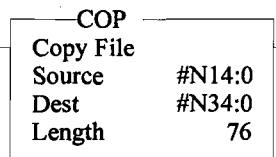
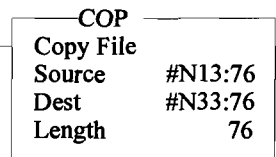
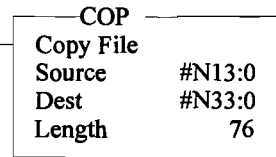
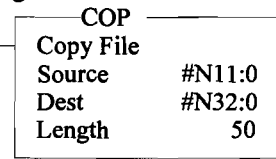
function 1=edit 2=copy 3=load PROGRAM



program number



in Prg4 registers



COP  
Copy File  
Source #N14:76  
Dest #N34:76  
Length 76

COP  
Copy File  
Source #N15:0  
Dest #N35:0  
Length 76

COP  
Copy File  
Source #N15:76  
Dest #N35:76  
Length 76

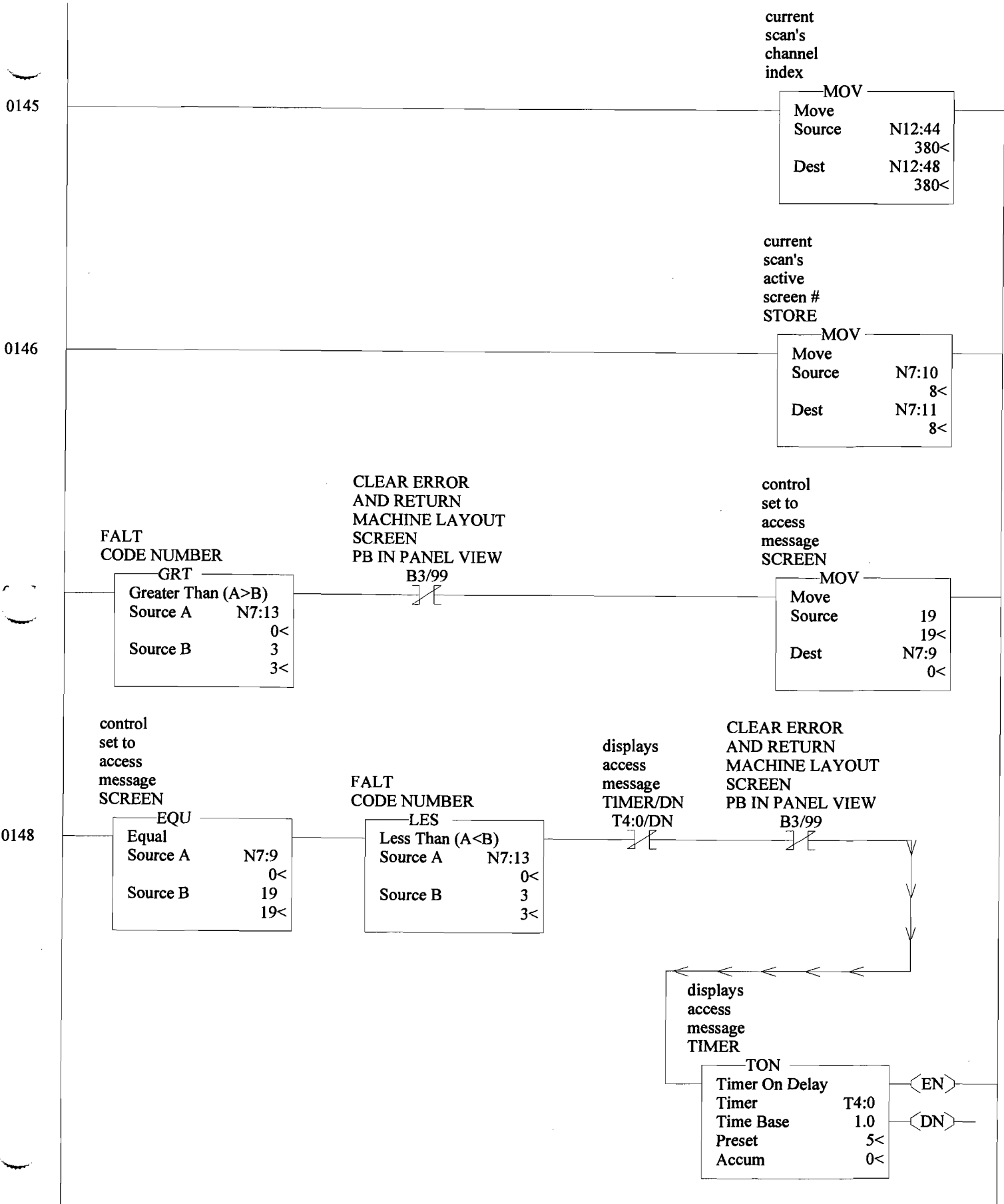
COP  
Copy File  
Source #N16:0  
Dest #N36:0  
Length 76

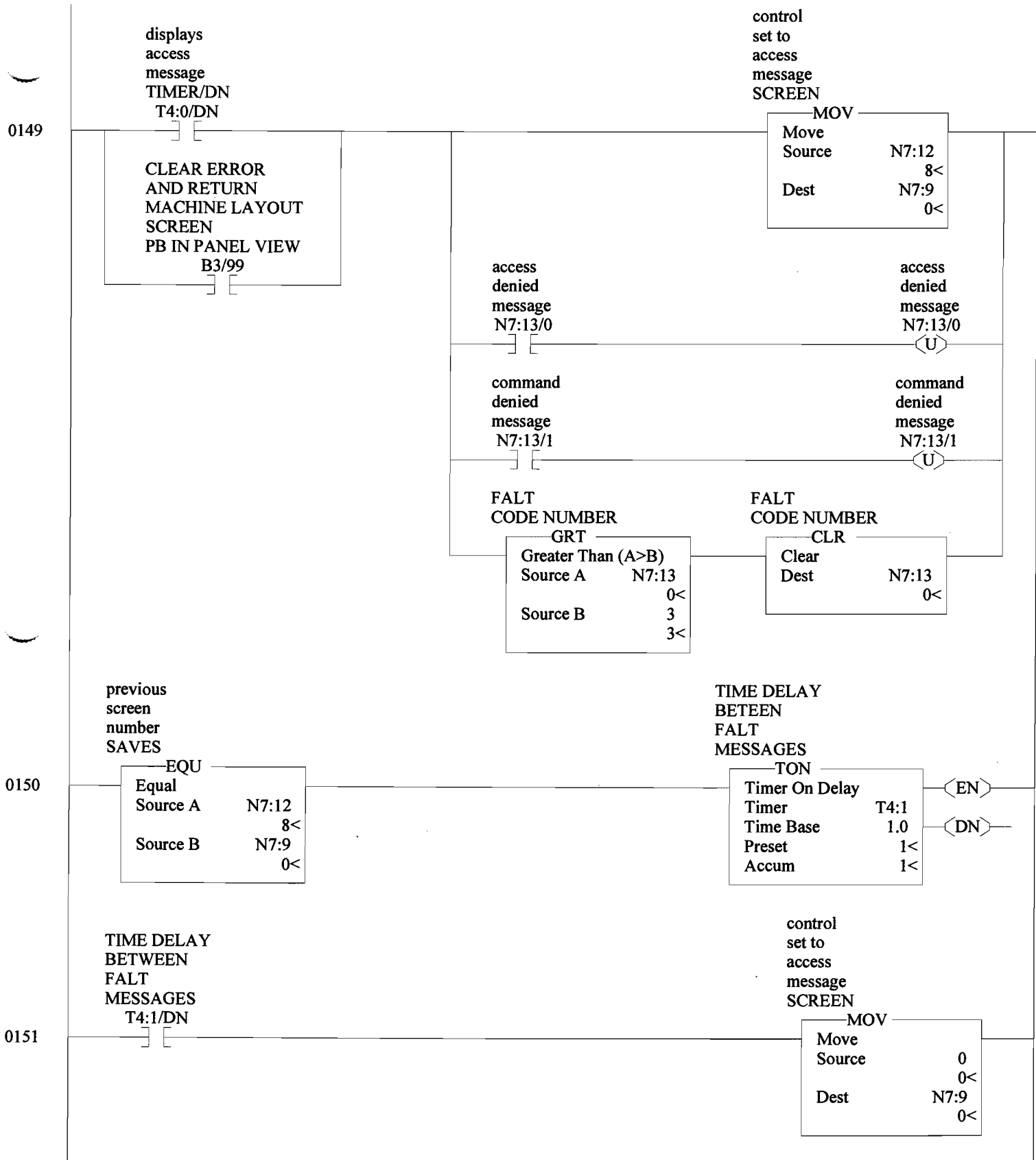
COP  
Copy File  
Source #N16:76  
Dest #N36:76  
Length 81

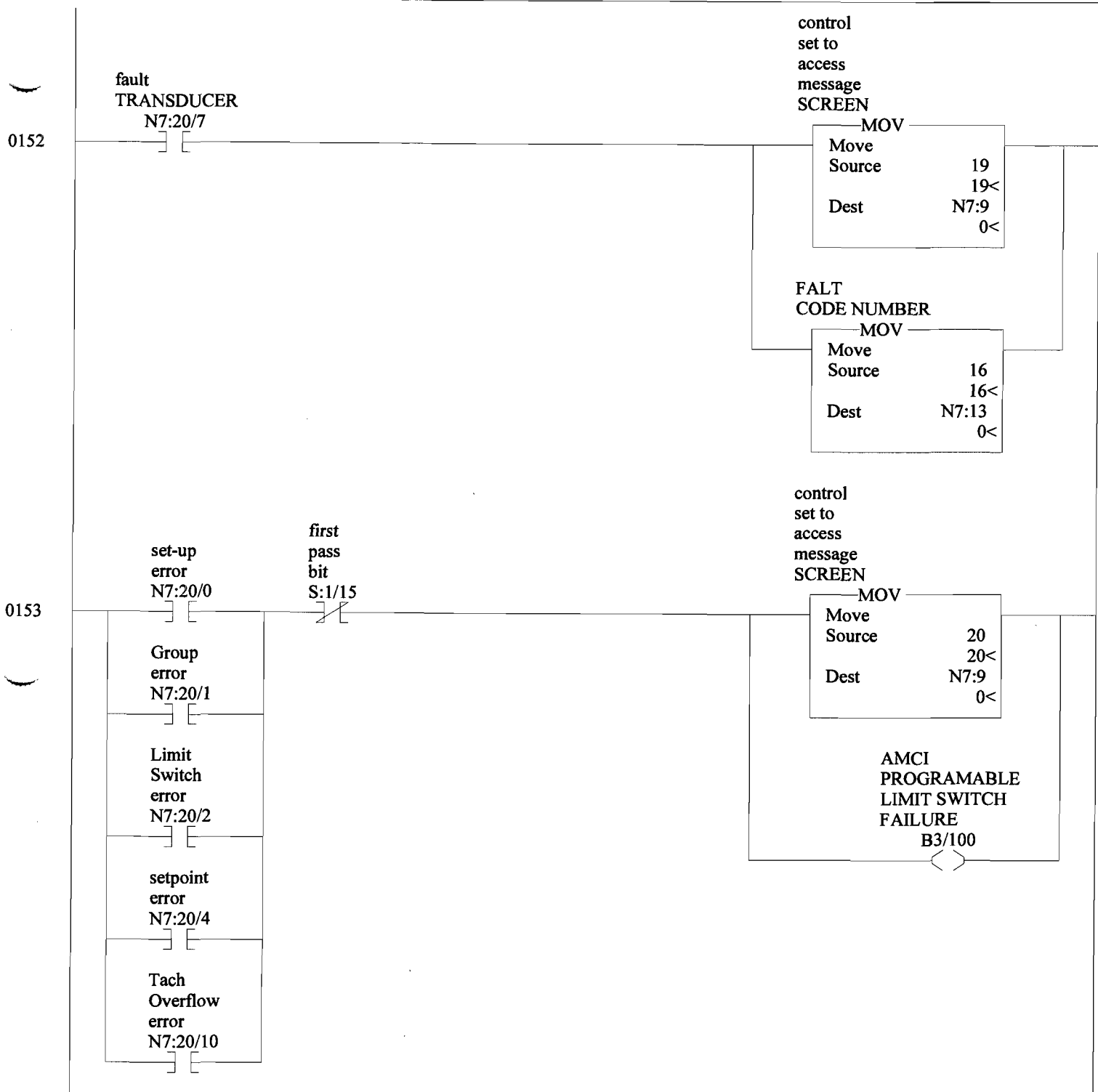
current  
scan's  
setpoint  
index

MOV  
Move  
Source N12:43  
380<  
Dest N12:49  
380<

0144







0154

AMCI  
PROGRAMMABLE  
LIMIT SWITCH  
FAILURE  
B3/100

ERROR LIHGT  
O:4.0/8

TORQUE  
OVERLOAD  
CR  
B3/105

GUARD OPEN  
B3/272

GUARDS  
BYPASSED S  
ELECTOR  
I:1.0/2      Time Base  
S:4/5

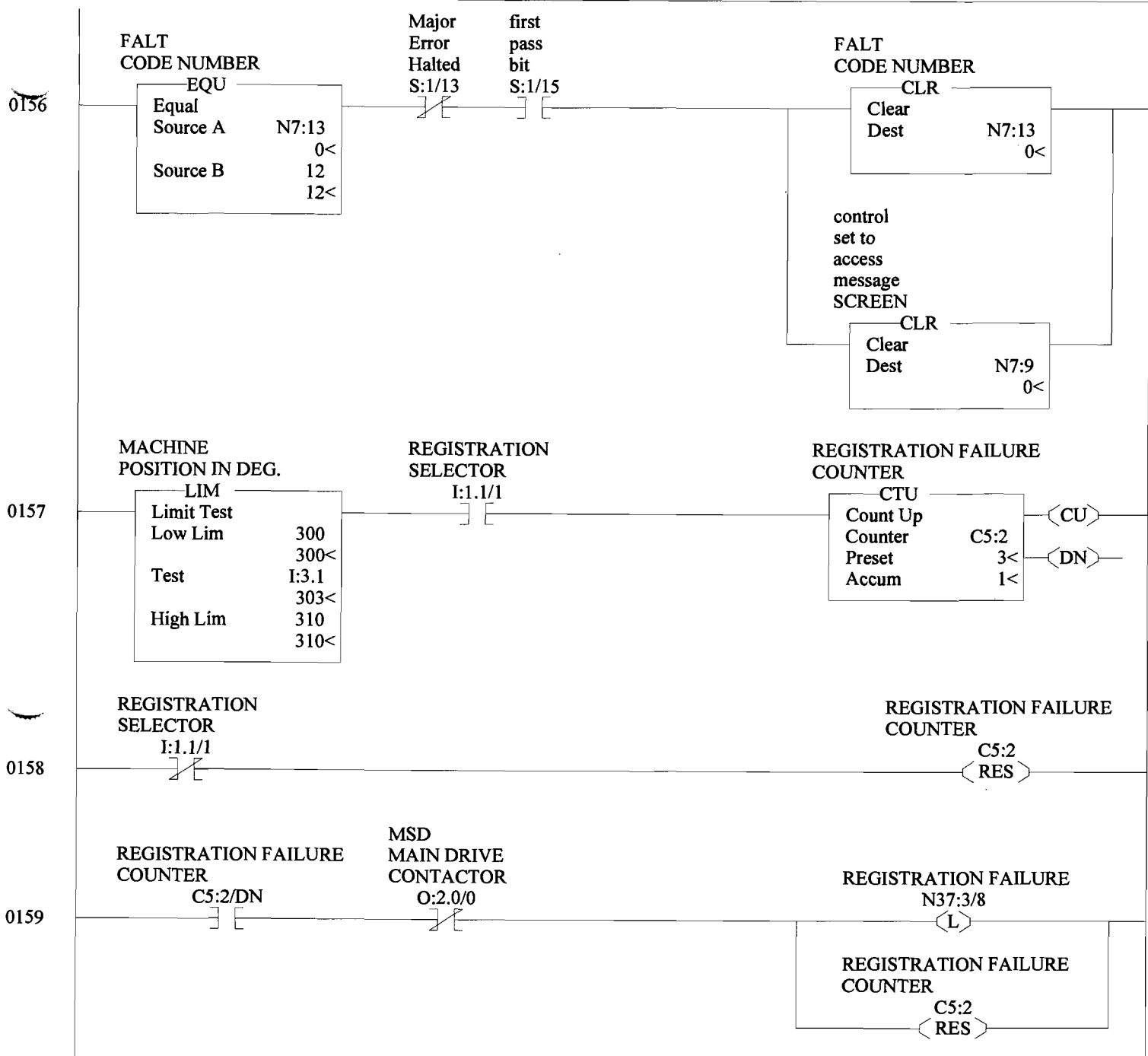
CRWF-1  
FAILURE  
NO-BAG  
PRESENT  
B3/92

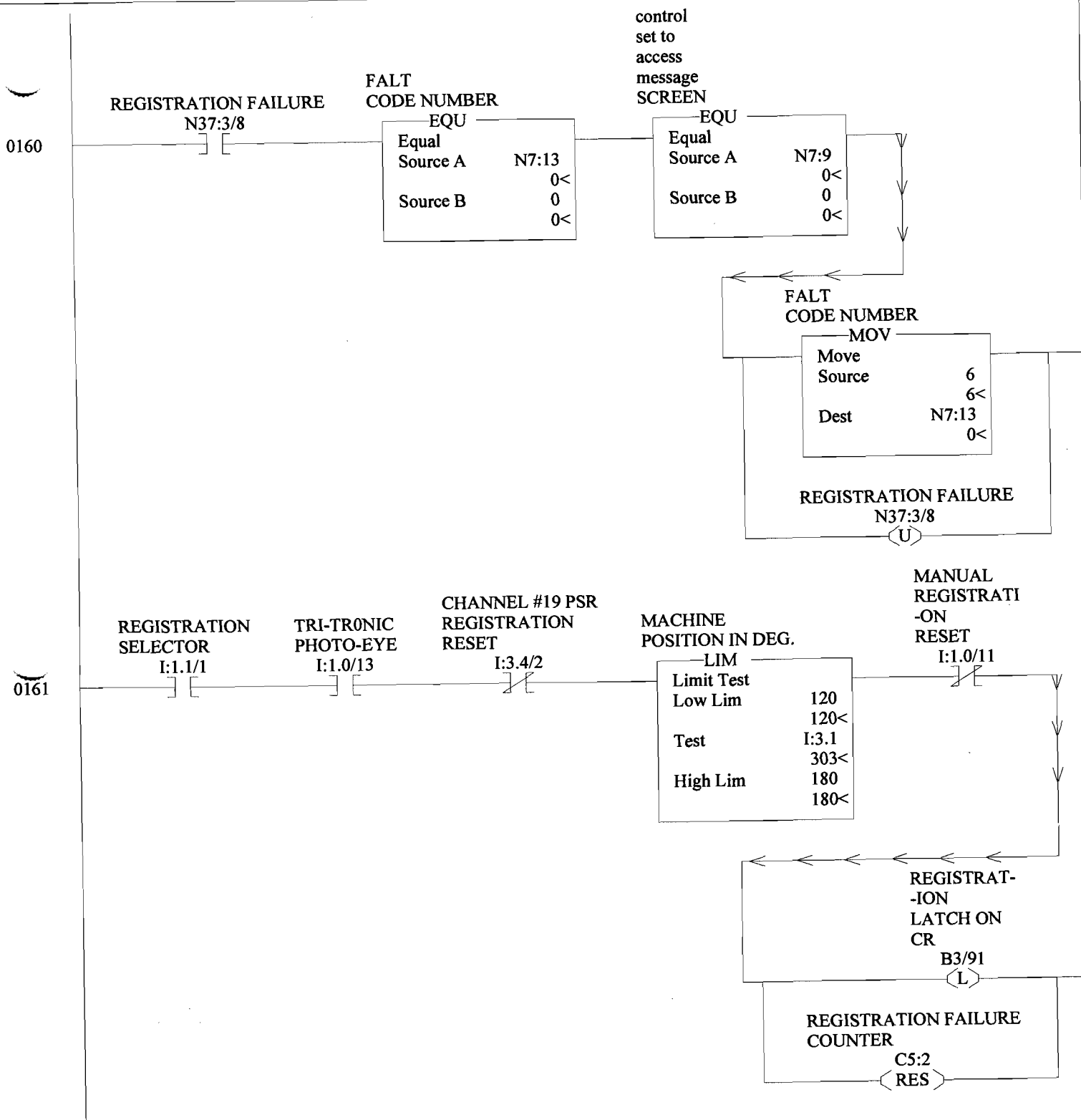
CRWF-2  
WEB  
FAILURE  
LSWF WAS  
TRIPPED  
B3/96

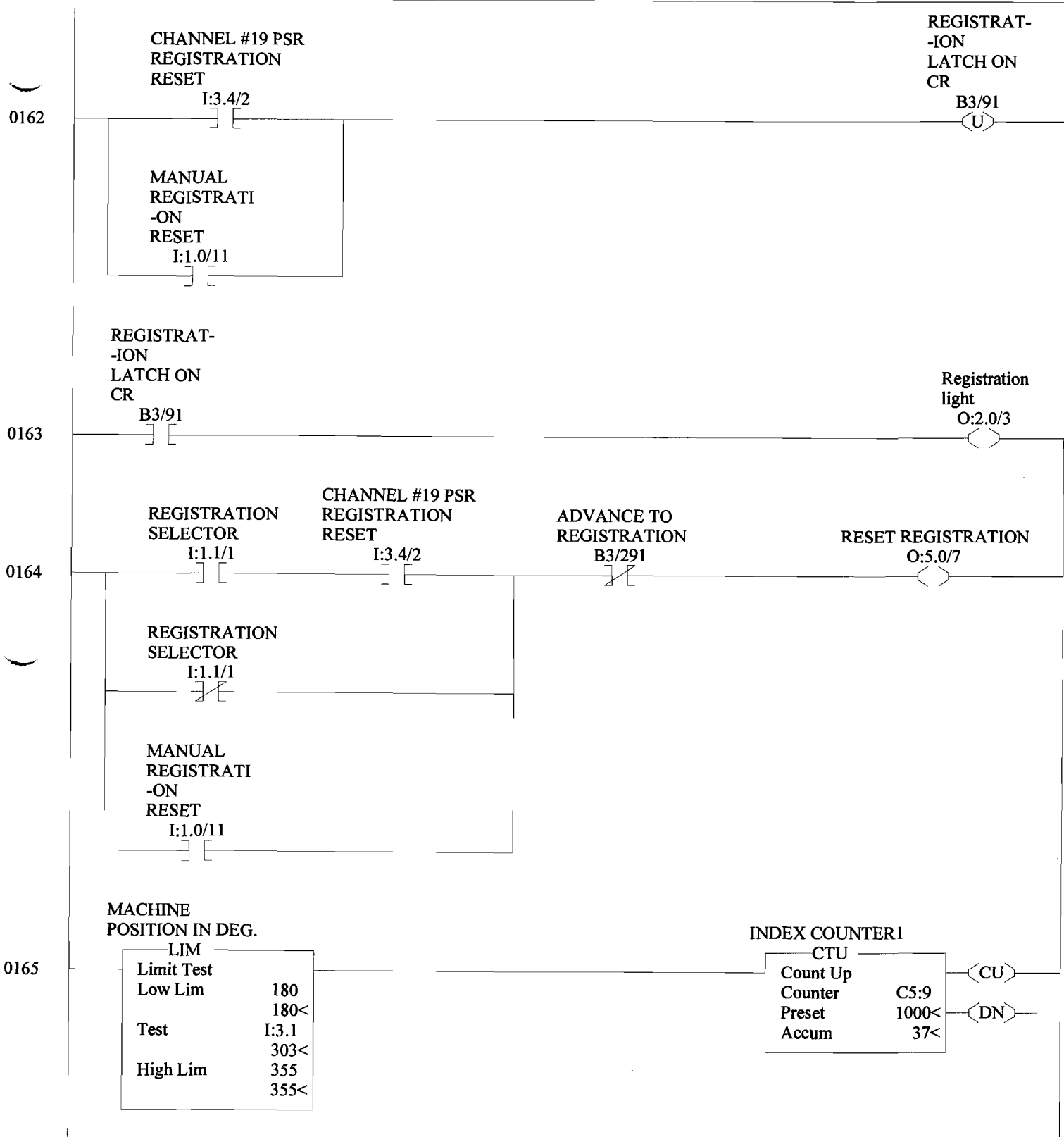
Major  
Error  
Halted  
S:1/13

0155

JSR  
Jump To Subroutine  
SBR File Number      U:14







66

I:7.1/9

NEQ  
Not Equal  
Source A F8:0 5.75<  
Source B F8:1 5.75<

Scanner response received  
I:7.0/15

JSR  
Jump To Subroutine  
SBR File Number U:25

0167

EQU  
Equal  
Source A F8:0 5.75<  
Source B F8:1 5.75<

B9/19 OSR

CLR  
Clear  
Dest B9:0  
0000000000000000<

C5:12 RES

0168

I:7.1/9

DISABLE SERVO PB  
IN PANELVIEW  
B3/225

START ALL  
MOTORS  
CR  
B3/93

HOME SERVO CR  
B3/259

ENABLE SERVO  
O:7.1/15

control  
set to  
access  
message  
SCREEN

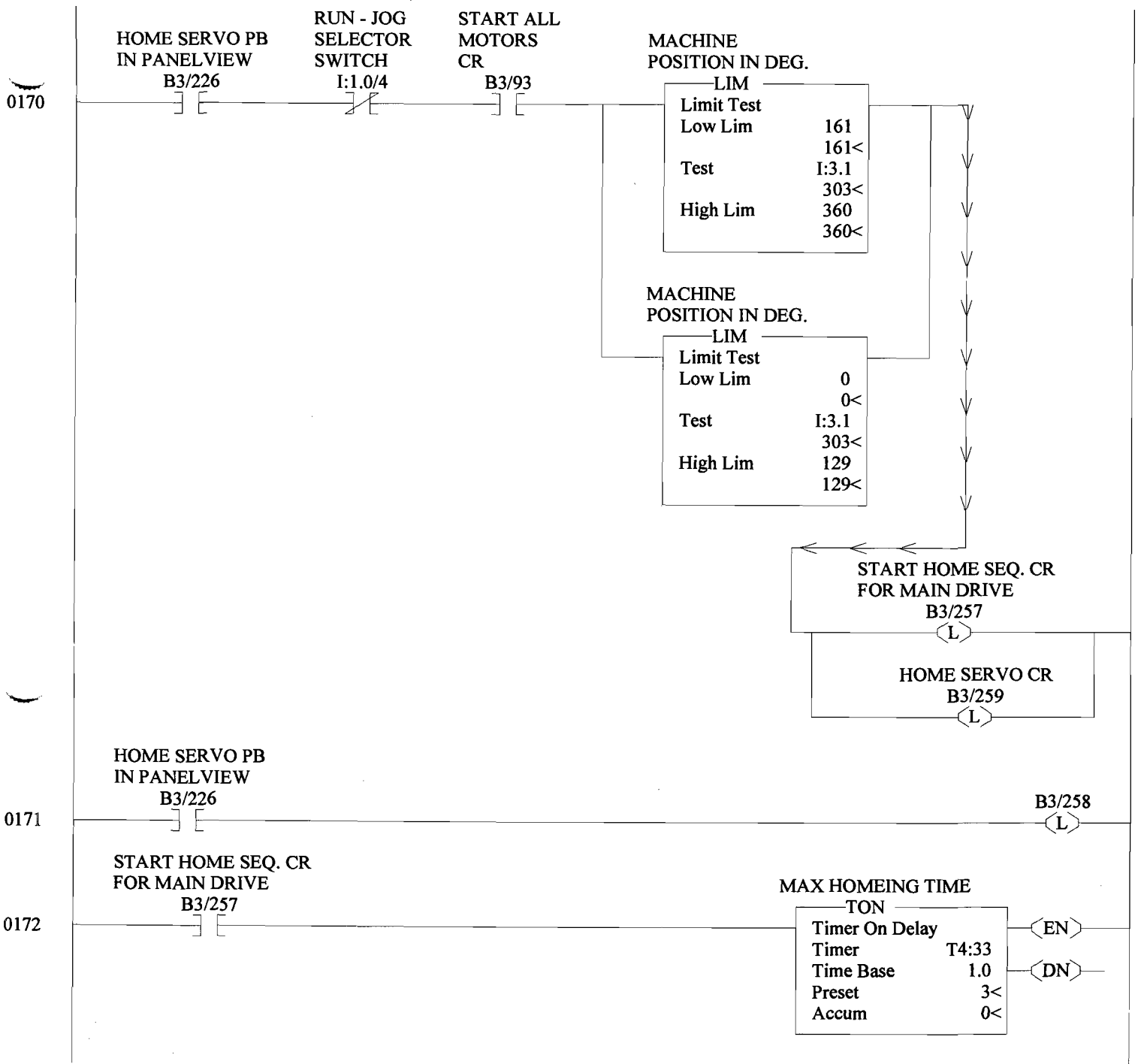
0169

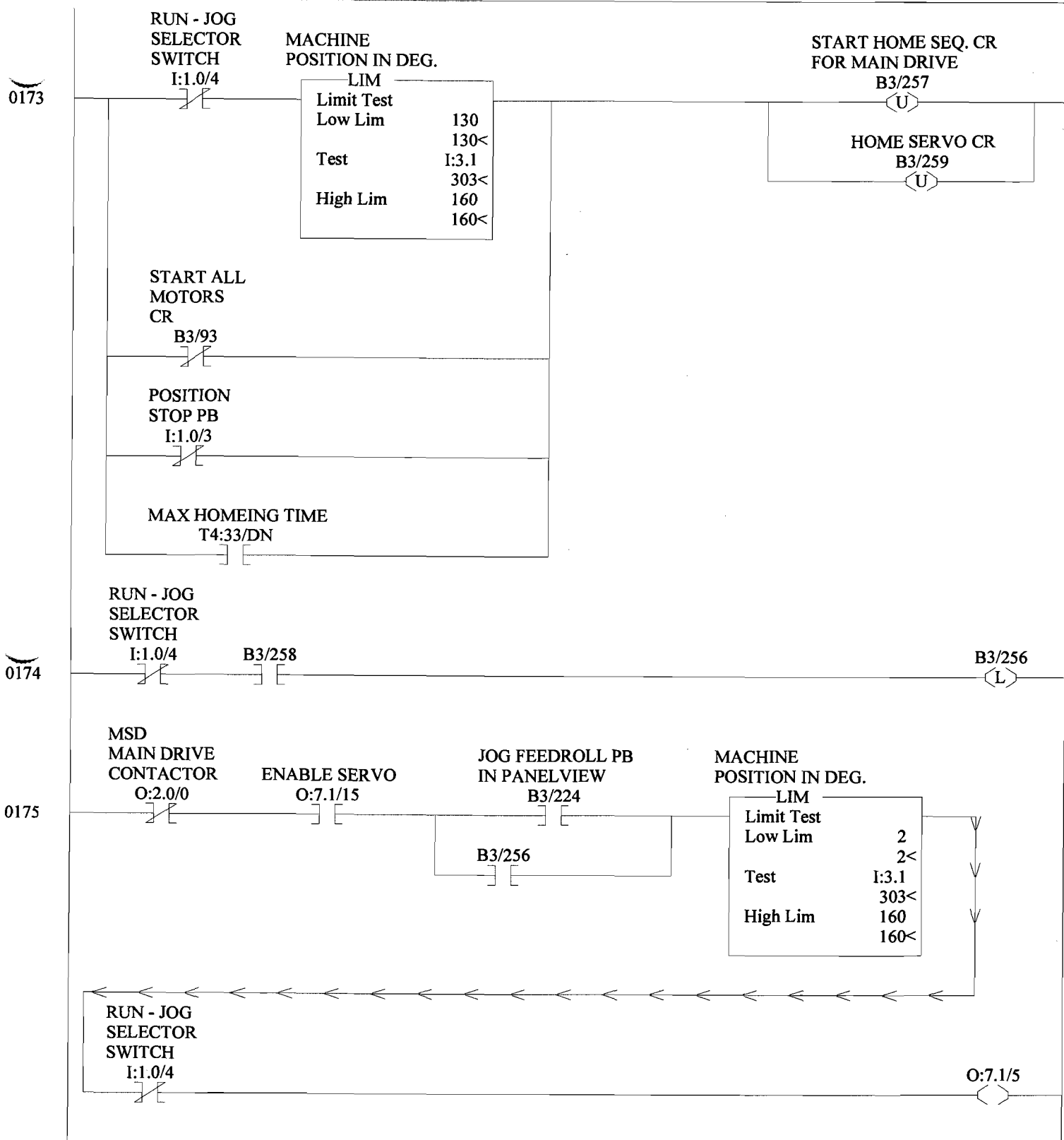
START\_HOME\_SEQ  
B3/227

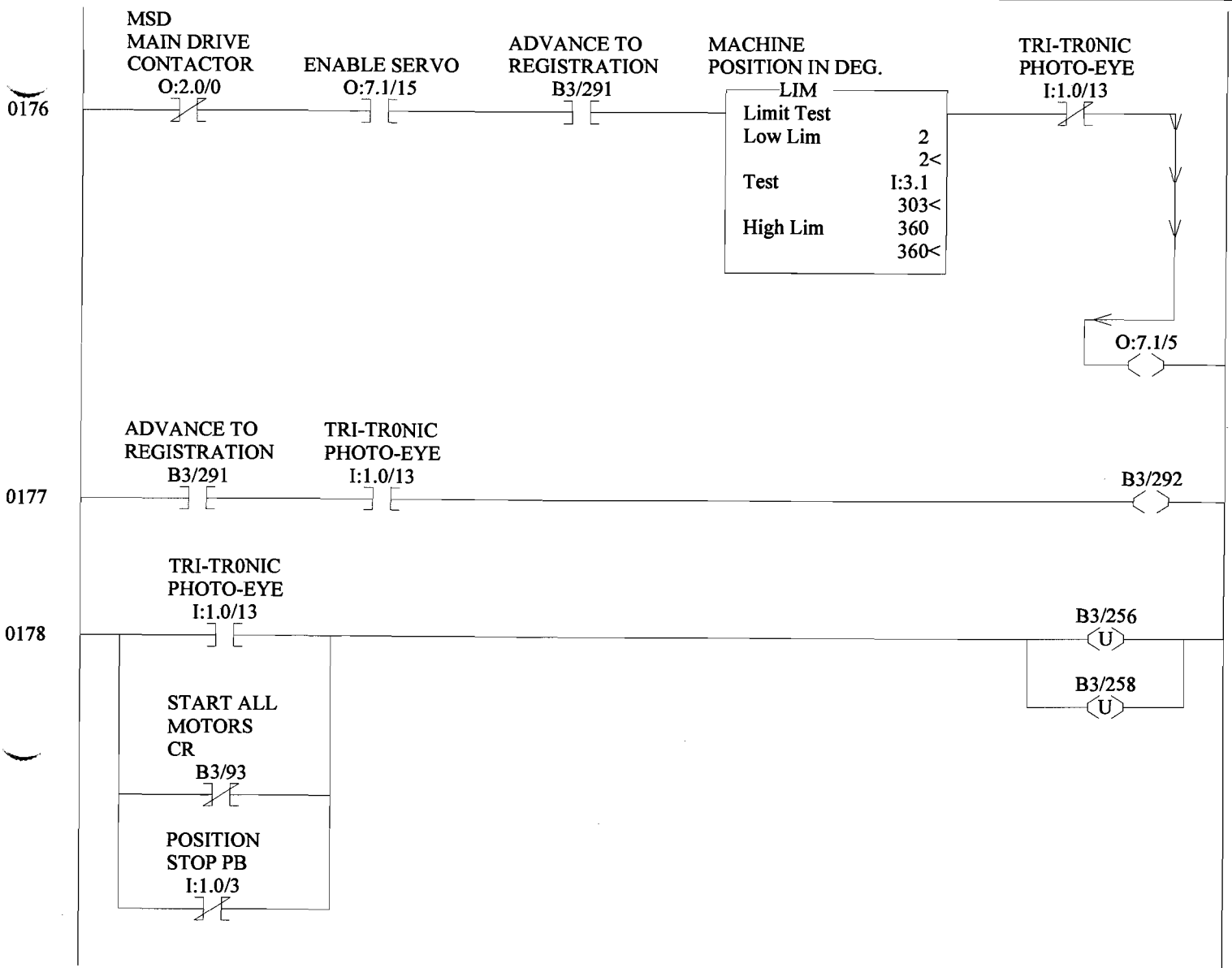
RUN - JOG  
SELECTOR  
SWITCH  
I:1.0/4

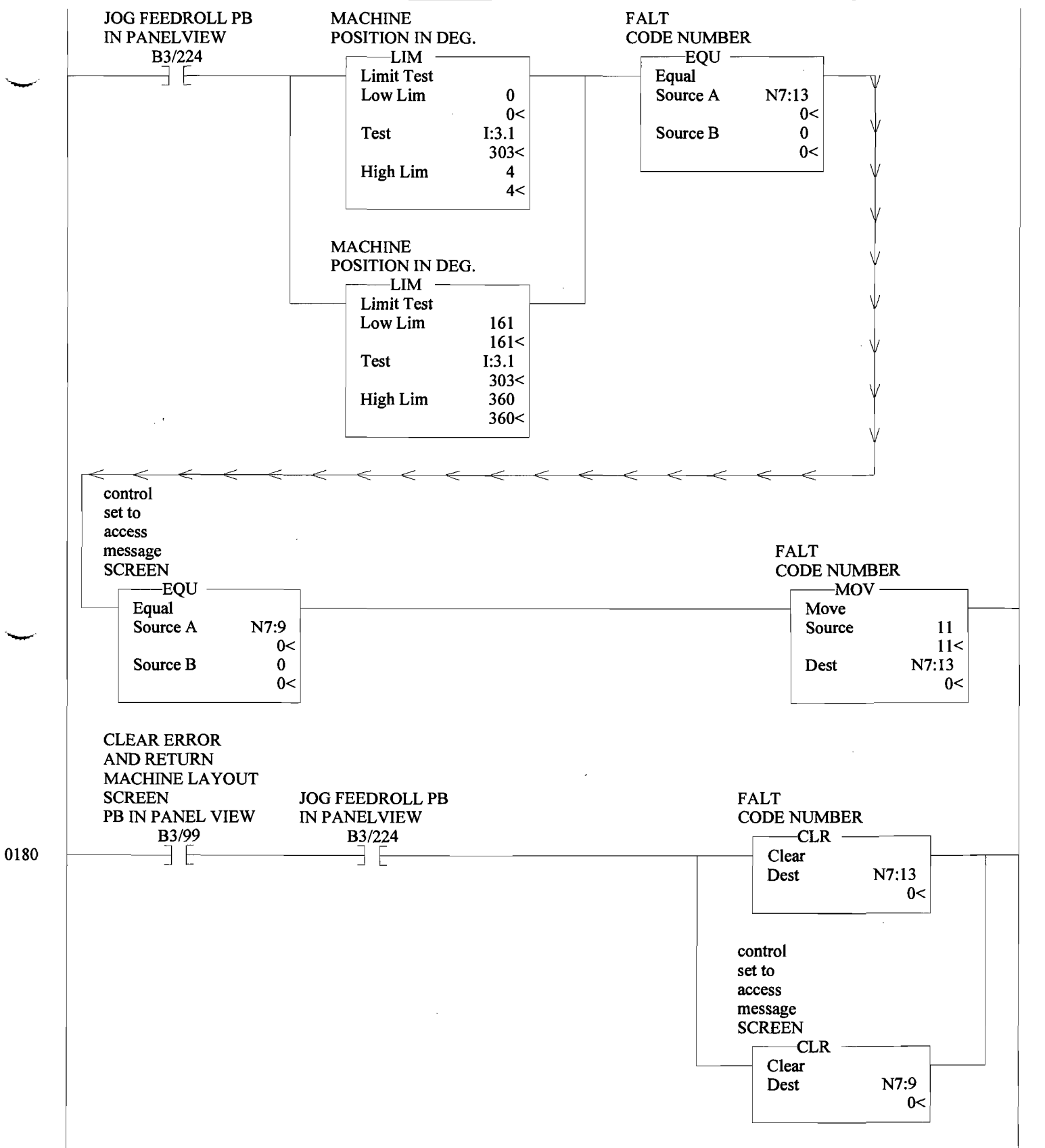
TRI-TRONIC  
PHOTO-EYE  
I:1.0/13

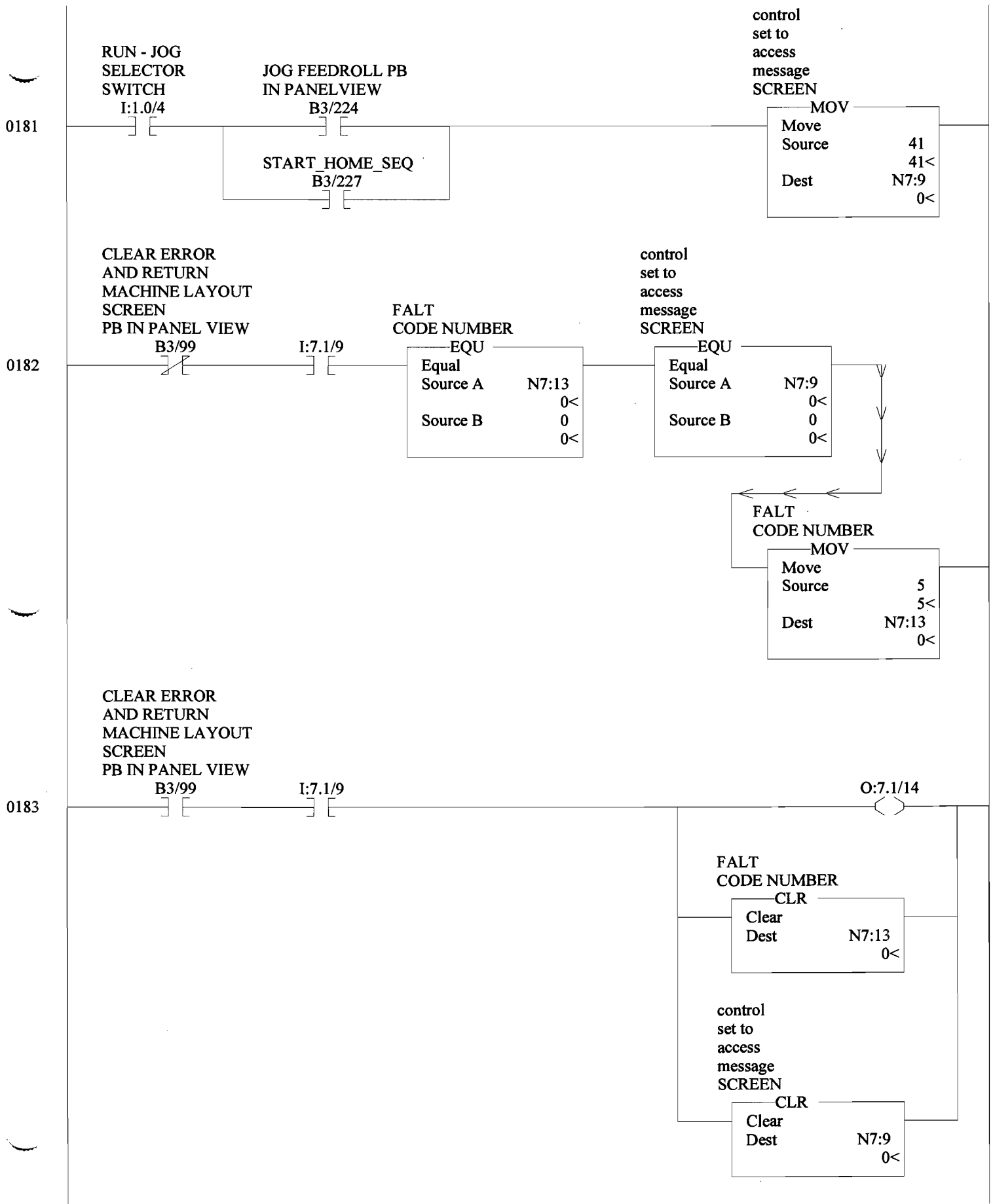
MOV  
Move  
Source 40  
40<  
Dest N7:9  
0<





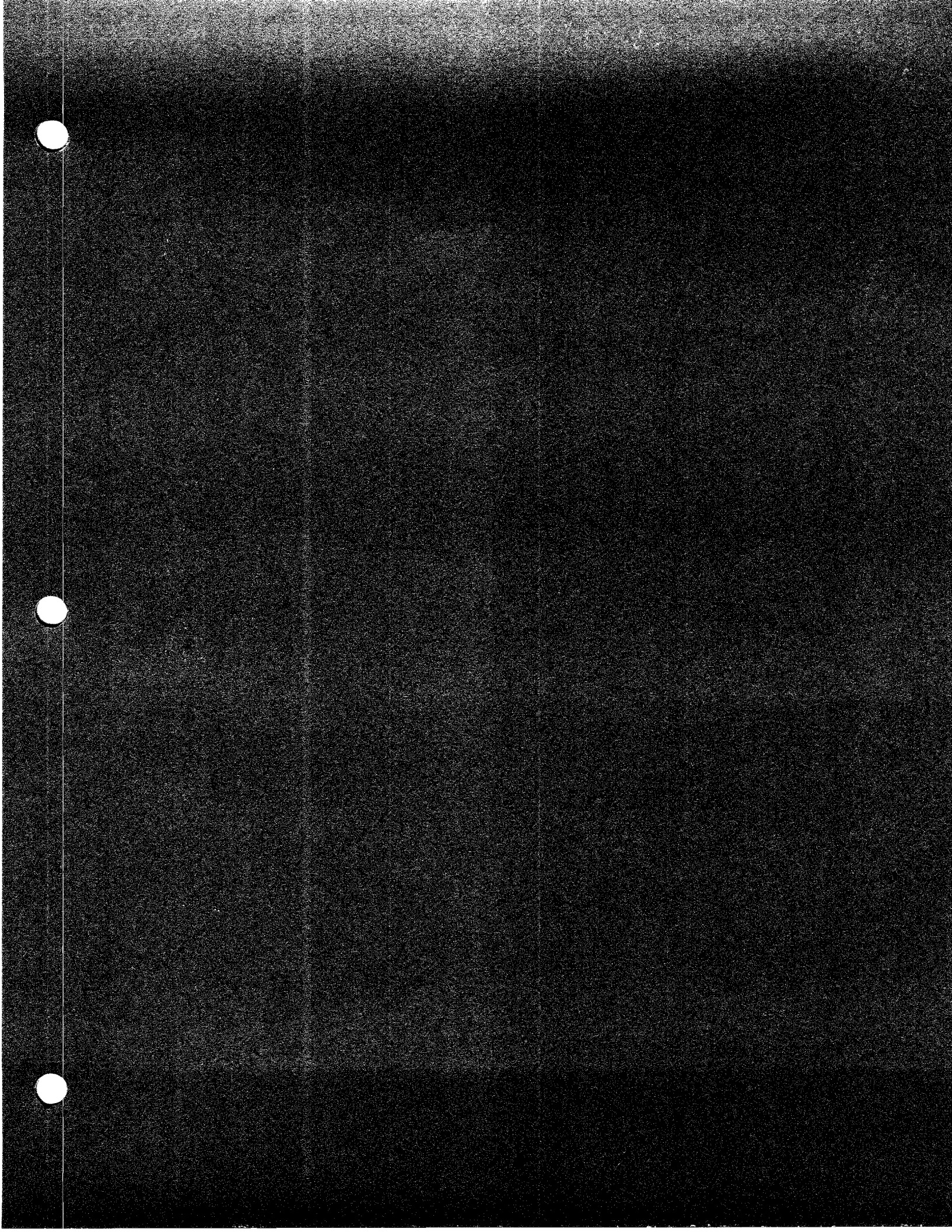


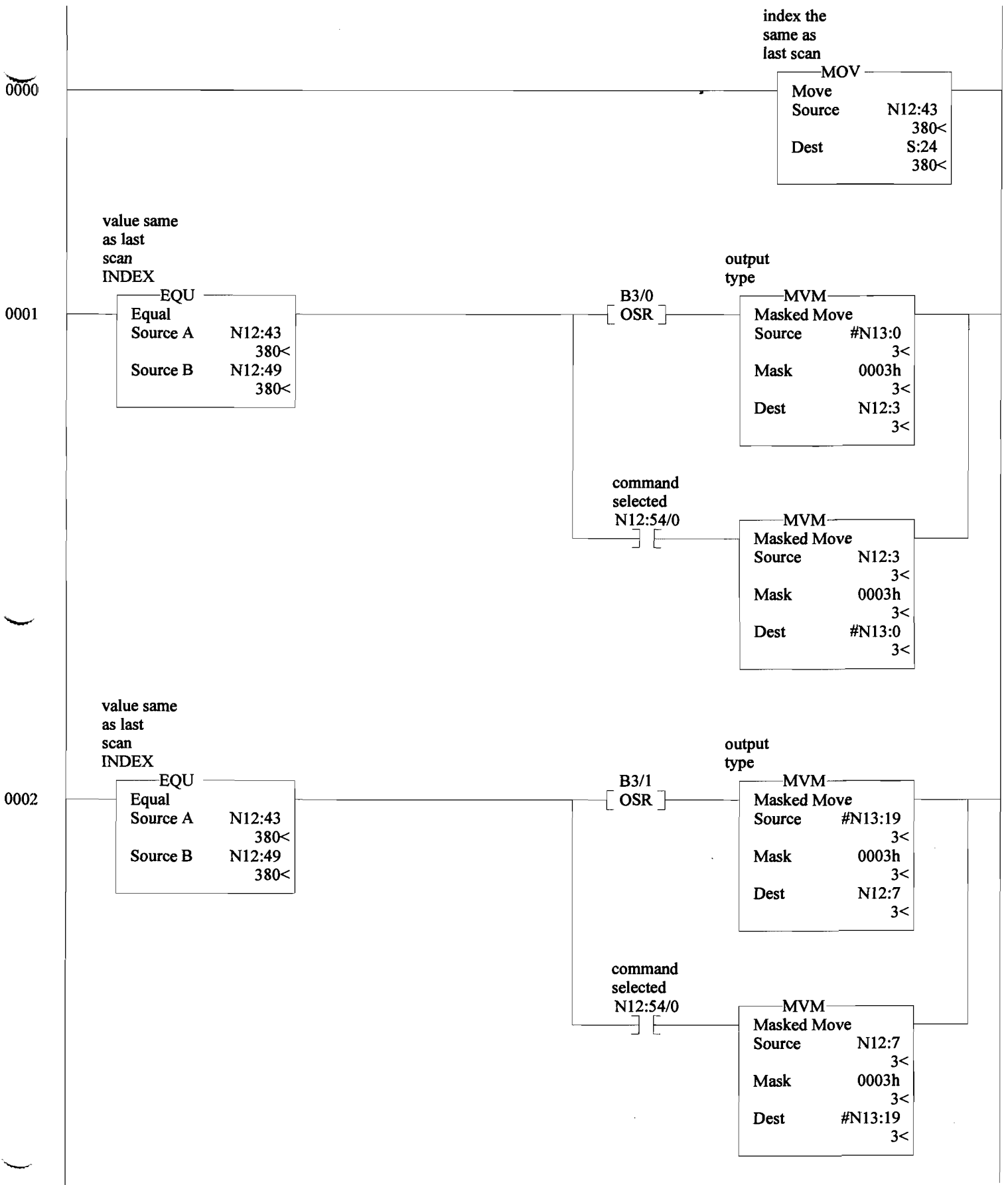


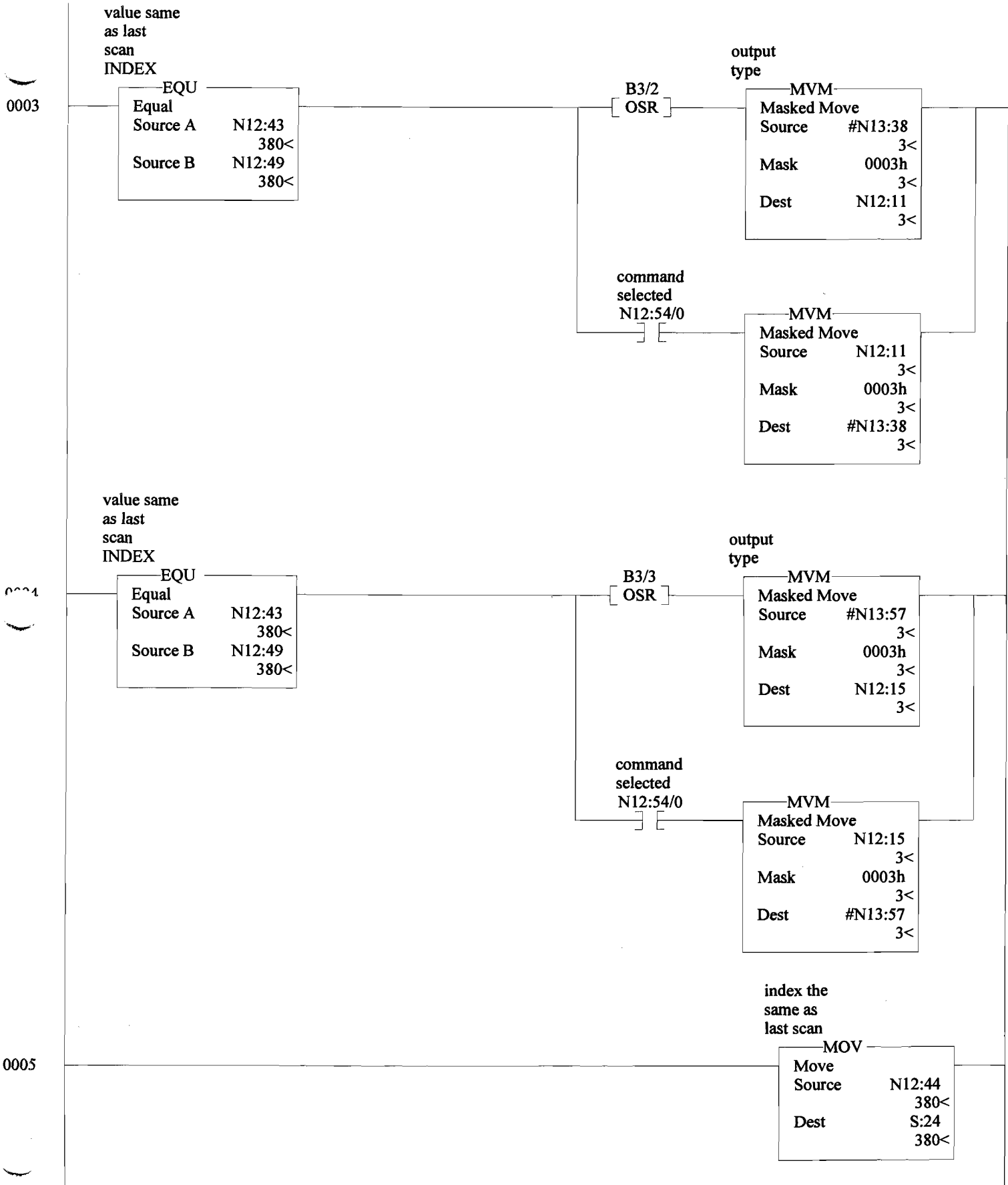


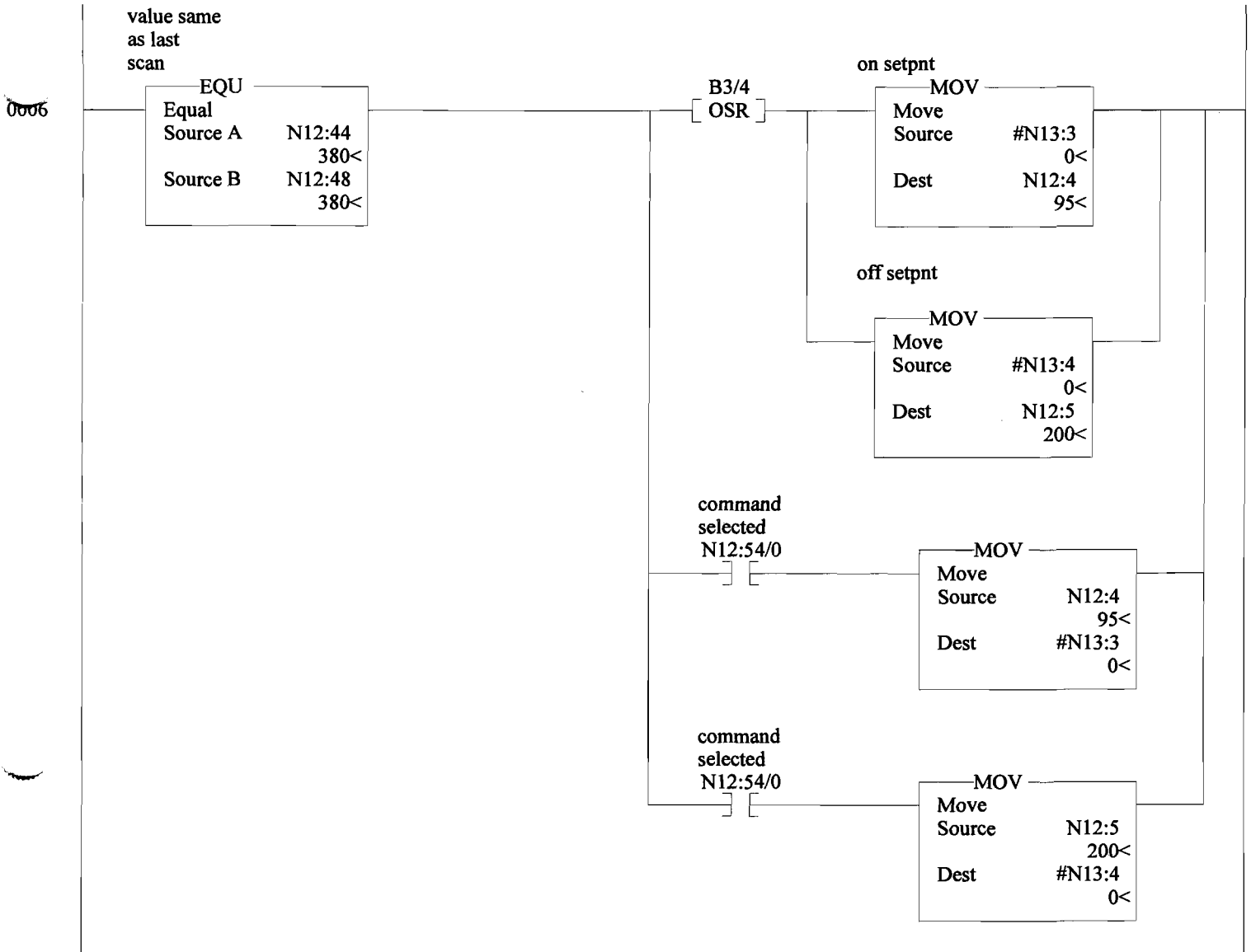
0184

END









0007

value same  
as last  
scan

EQU	
Equal	
Source A	N12:44 380<
Source B	N12:48 380<

B3/5  
OSR

on setpnt

MOV	
Move	
Source	#N13:22 80<
Dest	N12:8 95<

off setpnt

MOV	
Move	
Source	#N13:23 120<
Dest	N12:9 200<

command  
selected  
N12:54/0

MOV	
Move	
Source	N12:8 95<
Dest	#N13:22 80<

command  
selected  
N12:54/0

MOV	
Move	
Source	N12:9 200<
Dest	#N13:23 120<

0008

value same  
as last  
scan

**EQU**  
Equal  
Source A N12:44  
380<  
Source B N12:48  
380<

**B3/6**  
**OSR**

on setpnt

**MOV**  
Move  
Source #N13:41  
80<  
Dest N12:12  
10<

off setpnt

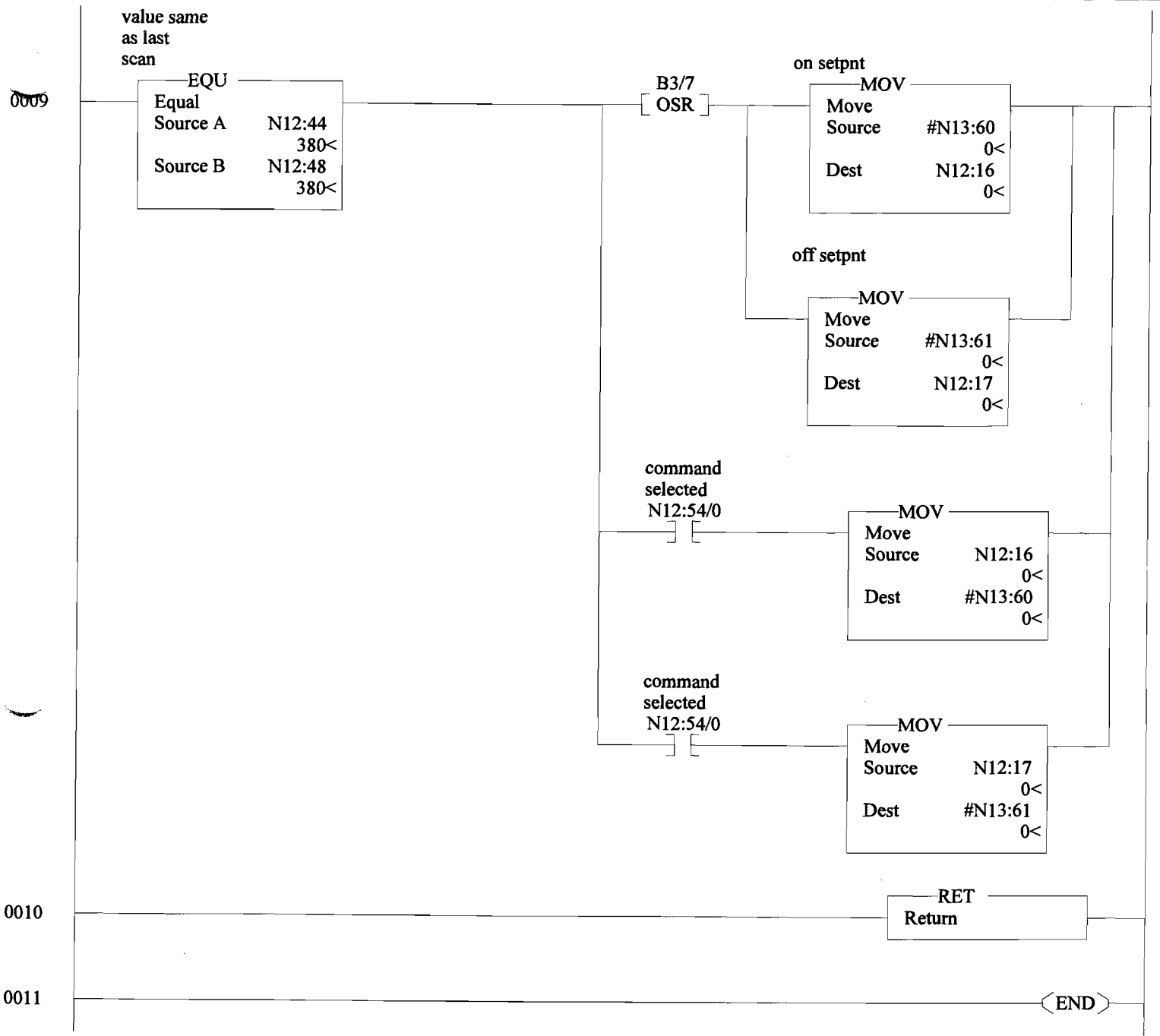
**MOV**  
Move  
Source #N13:42  
120<  
Dest N12:13  
205<

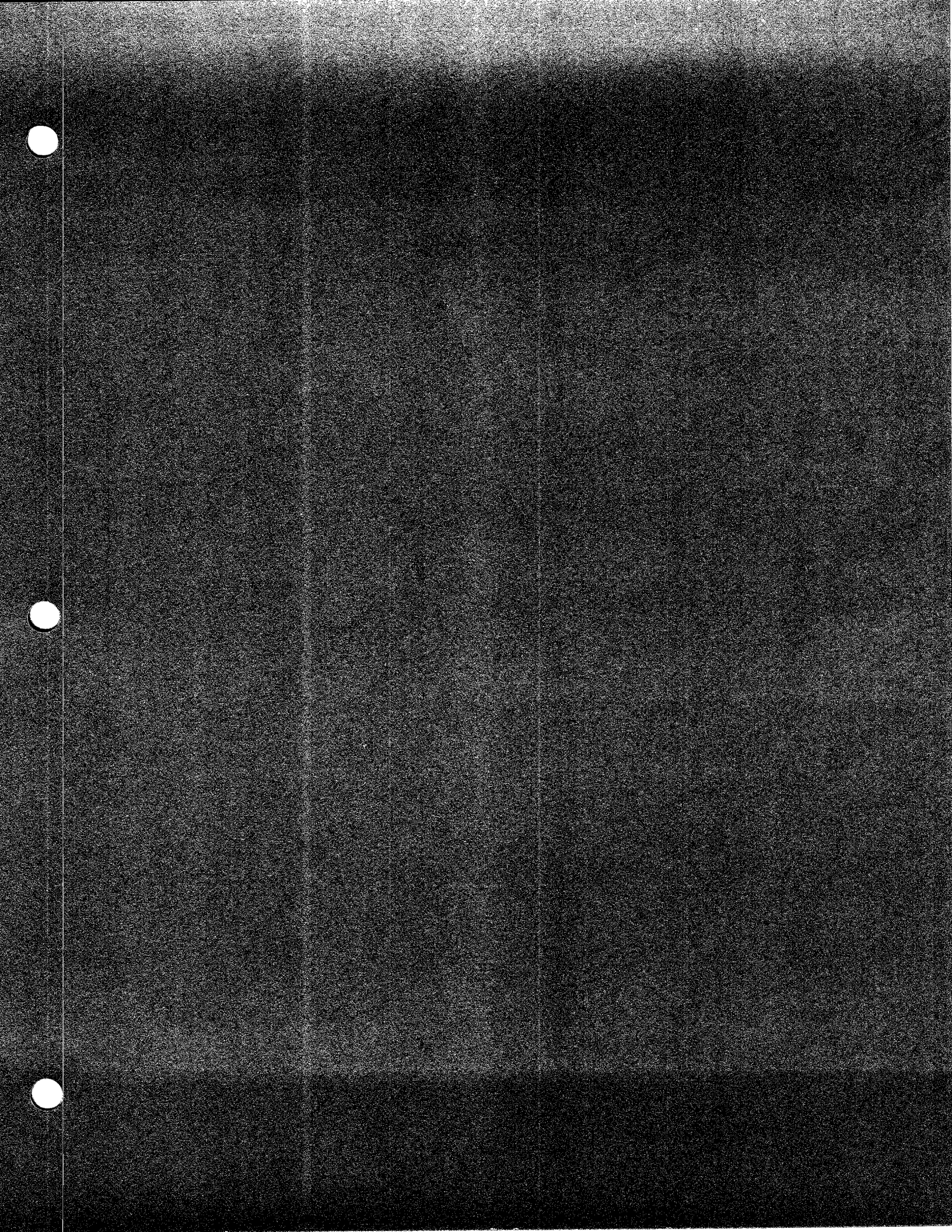
command  
selected  
N12:54/0

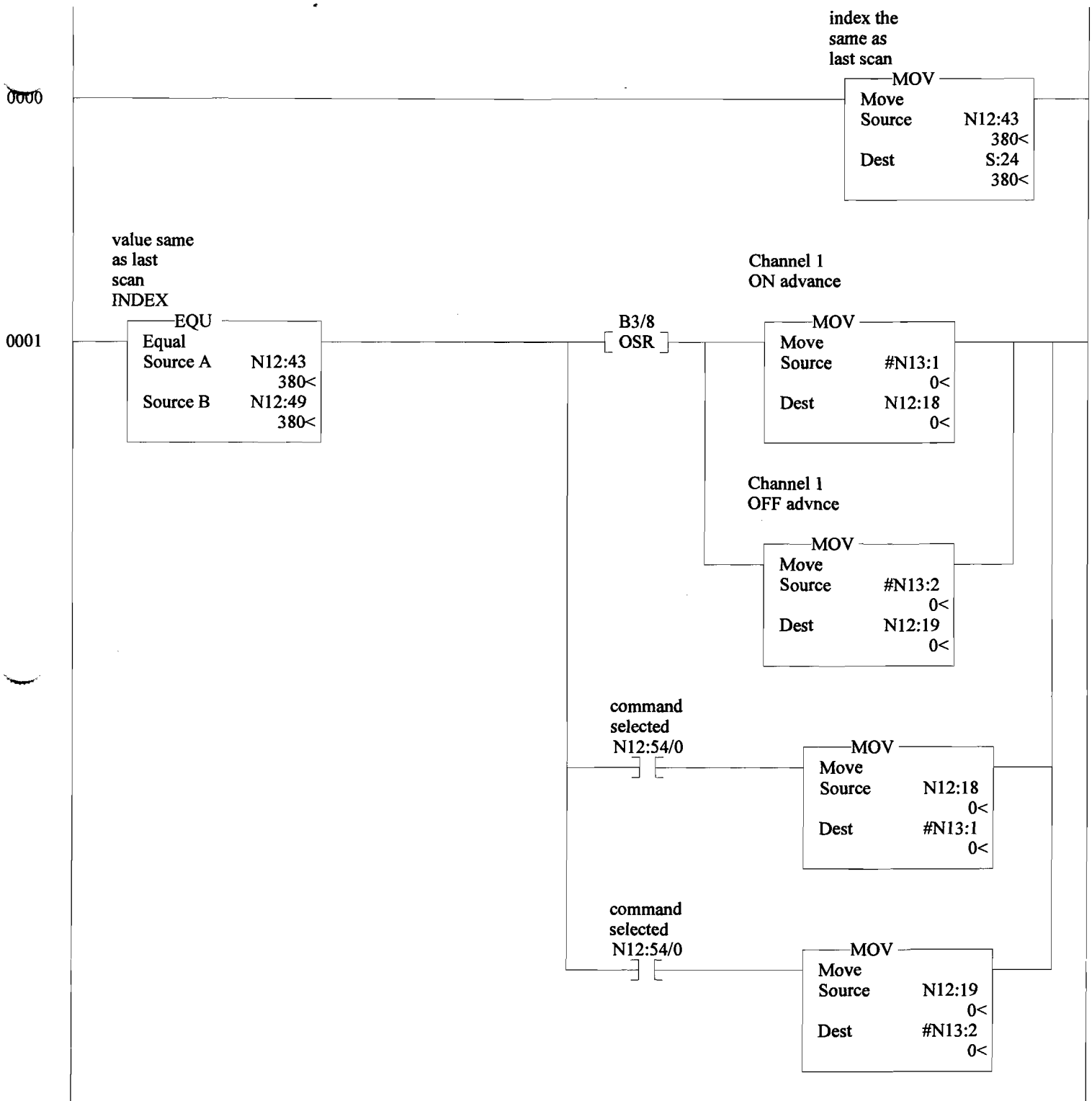
**MOV**  
Move  
Source N12:12  
10<  
Dest #N13:41  
80<

command  
selected  
N12:54/0

**MOV**  
Move  
Source N12:13  
205<  
Dest #N13:42  
120<







0002

value same  
as last  
scan  
INDEX

EQU	
Equal	
Source A	N12:43 380<
Source B	N12:49 380<

B3/9  
OSR

Channel 2  
ON advance

MOV	
Move	
Source	#N13:20 0<
Dest	N12:20 0<

Channel 2  
OFF Advnce

MOV	
Move	
Source	#N13:21 0<
Dest	N12:21 0<

command  
selected  
N12:54/0

MOV	
Move	
Source	N12:20 0<
Dest	#N13:20 0<

command  
selected  
N12:54/0

MOV	
Move	
Source	N12:21 0<
Dest	#N13:21 0<

0003

value same  
as last  
scan  
INDEX

EQU	
Equal	
Source A	N12:43 380<
Source B	N12:49 380<

B3/10  
OSR

ON advance

MOV	
Move	
Source	#N13:39 0<
Dest	N12:22 0<

Channel 3  
OFF advnce

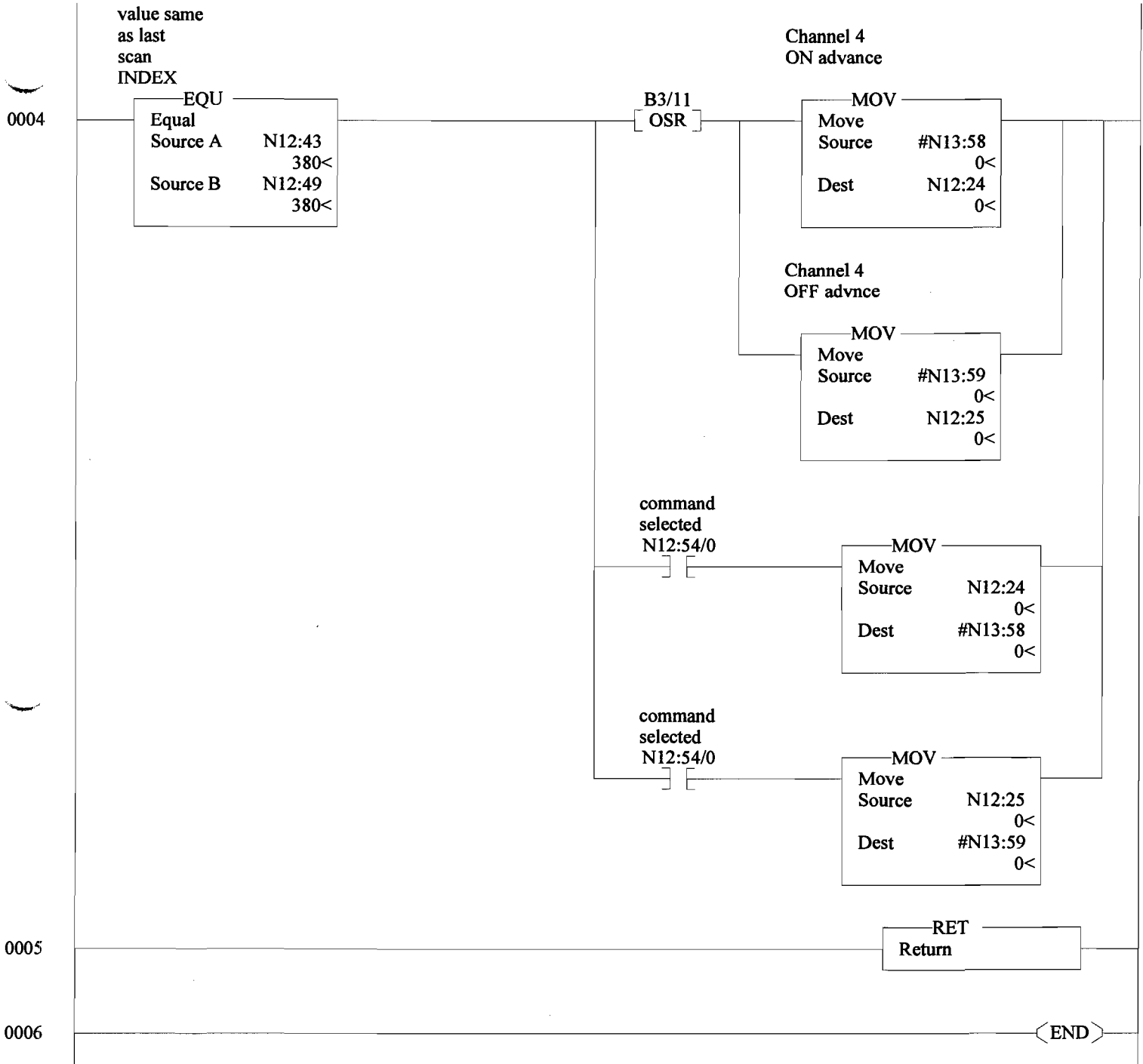
MOV	
Move	
Source	#N13:40 0<
Dest	N12:23 0<

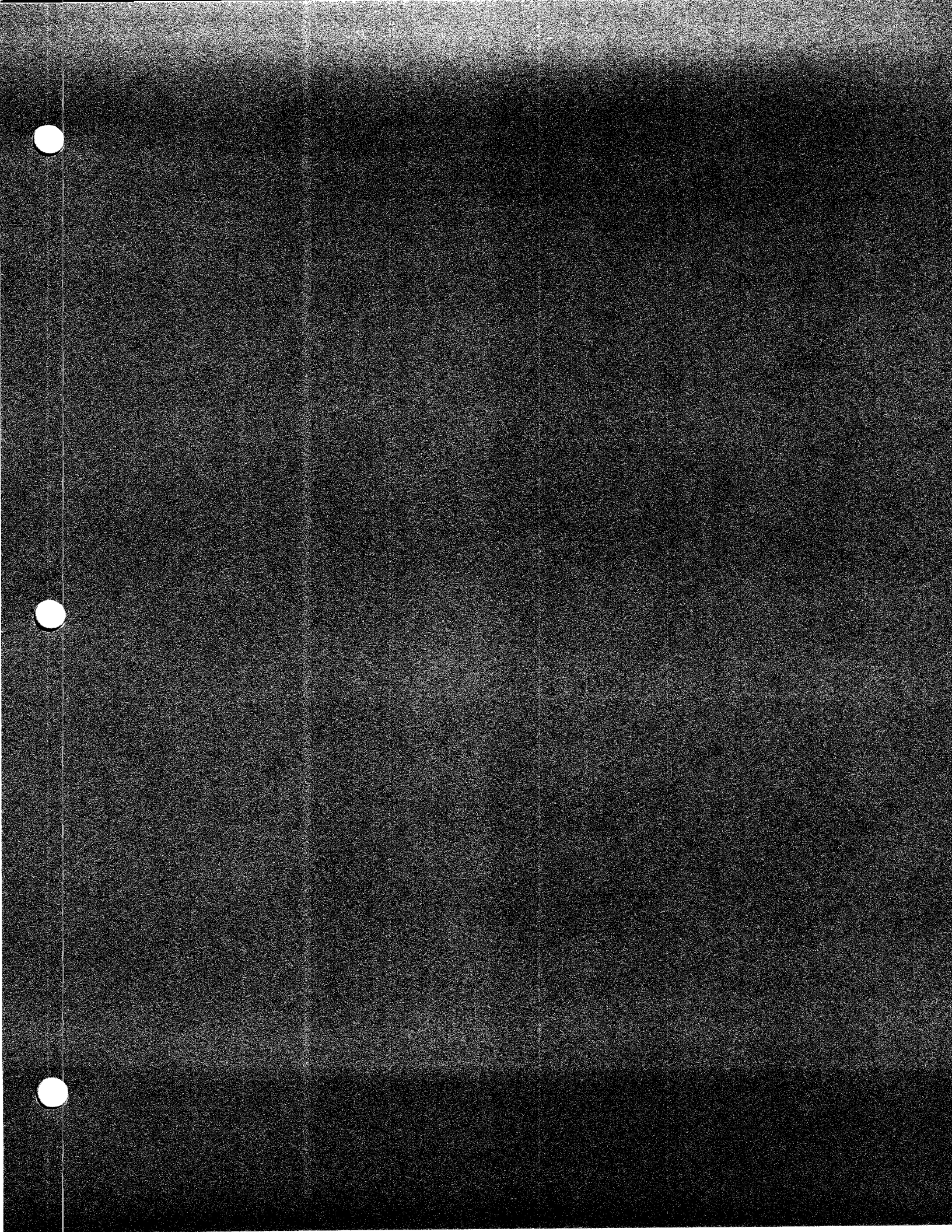
command  
selected  
N12:54/0

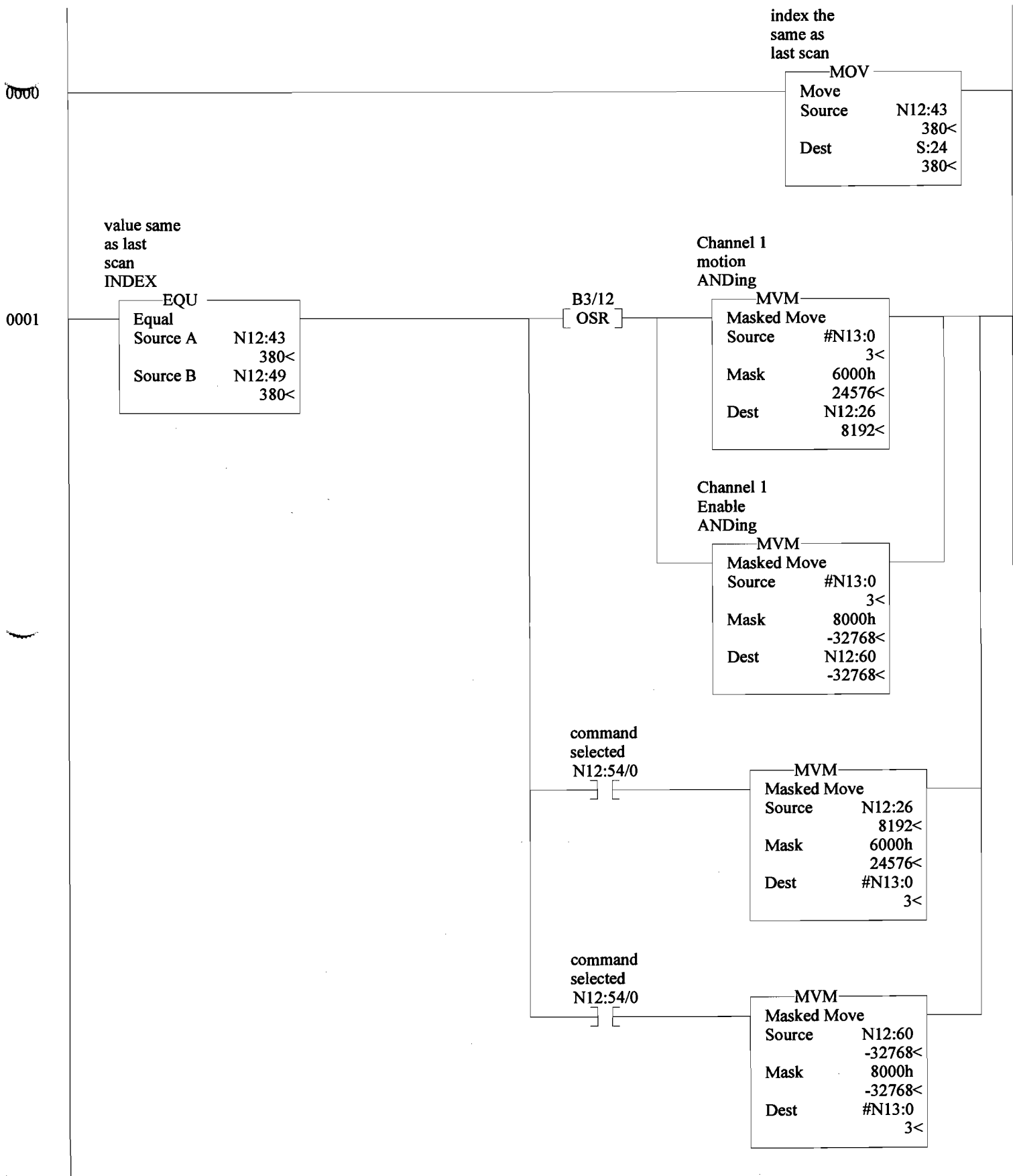
MOV	
Move	
Source	N12:22 0<
Dest	#N13:39 0<

command  
selected  
N12:54/0

MOV	
Move	
Source	N12:23 0<
Dest	#N13:40 0<







0002

value same  
as last  
scan  
INDEX

EQU	
Equal	
Source A	N12:43 380<
Source B	N12:49 380<

B3/13  
OSR

channel 2  
motion  
ANDing

MVM	
Masked Move	
Source	#N13:19 3<
Mask	6000h 24576<
Dest	N12:27 0<

Channel 2  
Enable  
ANDing

MVM	
Masked Move	
Source	#N13:19 3<
Mask	8000h -32768<
Dest	N12:61 0<

command  
selected  
N12:54/0

MVM	
Masked Move	
Source	N12:27 0<
Mask	6000h 24576<
Dest	#N13:19 3<

command  
selected  
N12:54/0

MVM	
Masked Move	
Source	N12:61 0<
Mask	8000h -32768<
Dest	#N13:19 3<

0003

value same  
as last  
scan  
INDEX

EQU	
Equal	
Source A	N12:43 380<
Source B	N12:49 380<

B3/14  
OSR

Channel 3  
motion  
ANDing

MVM	
Masked Move	
Source	#N13:38 3<
Mask	6000h 24576<
Dest	N12:28 0<

Channel 3  
Enable  
ANDing

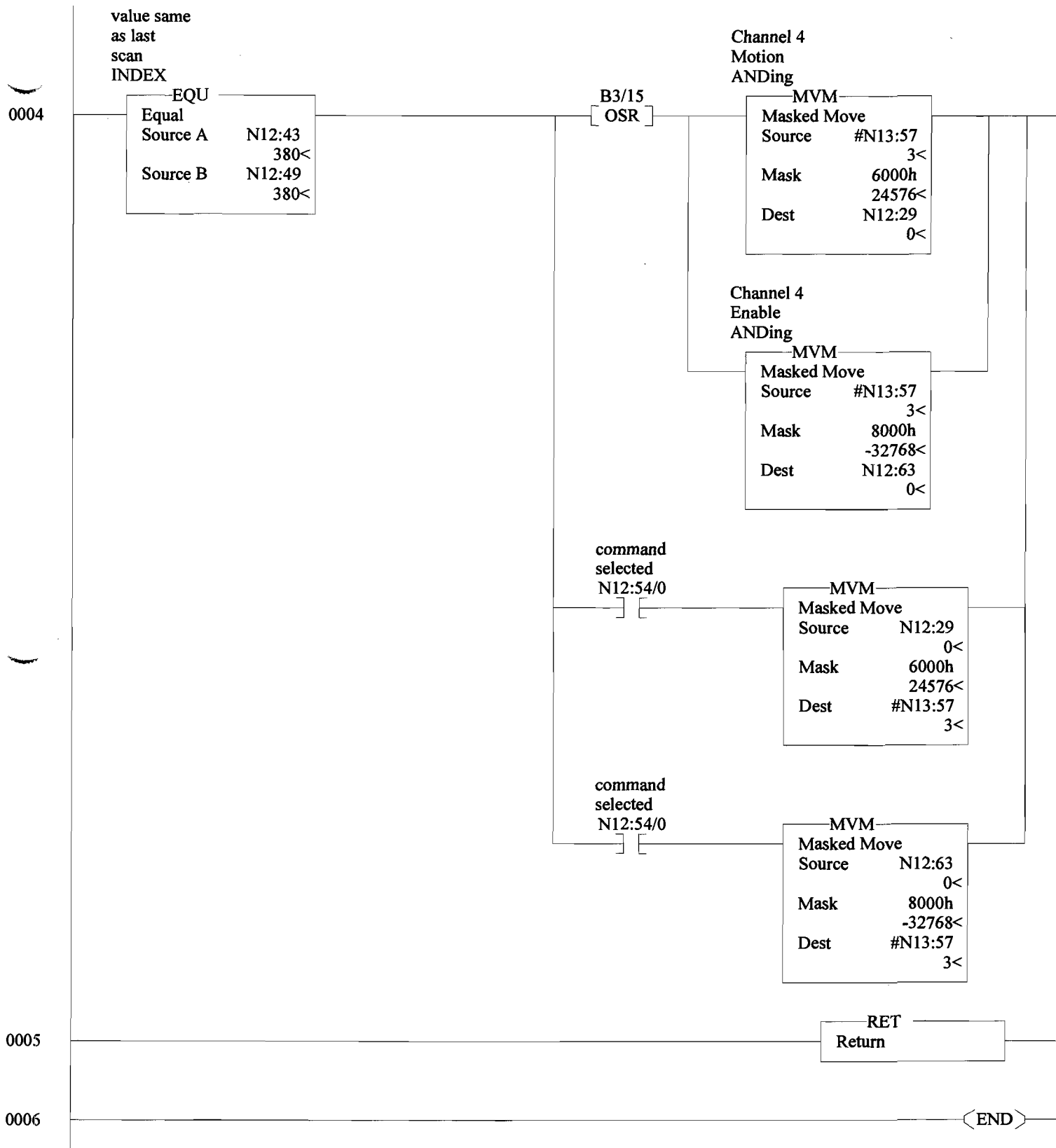
MVM	
Masked Move	
Source	#N13:38 3<
Mask	8000h -32768<
Dest	N12:62 0<

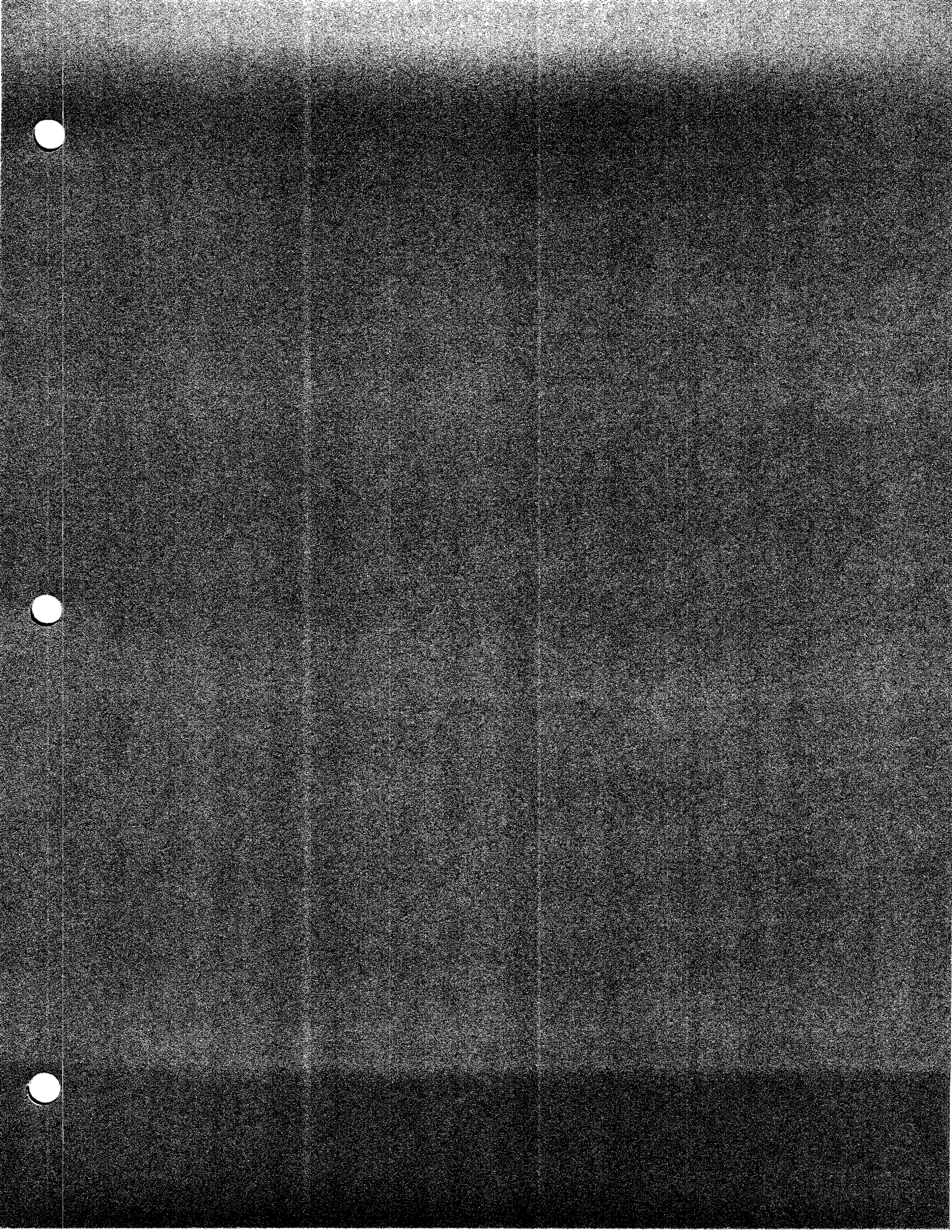
command  
selected  
N12:54/0

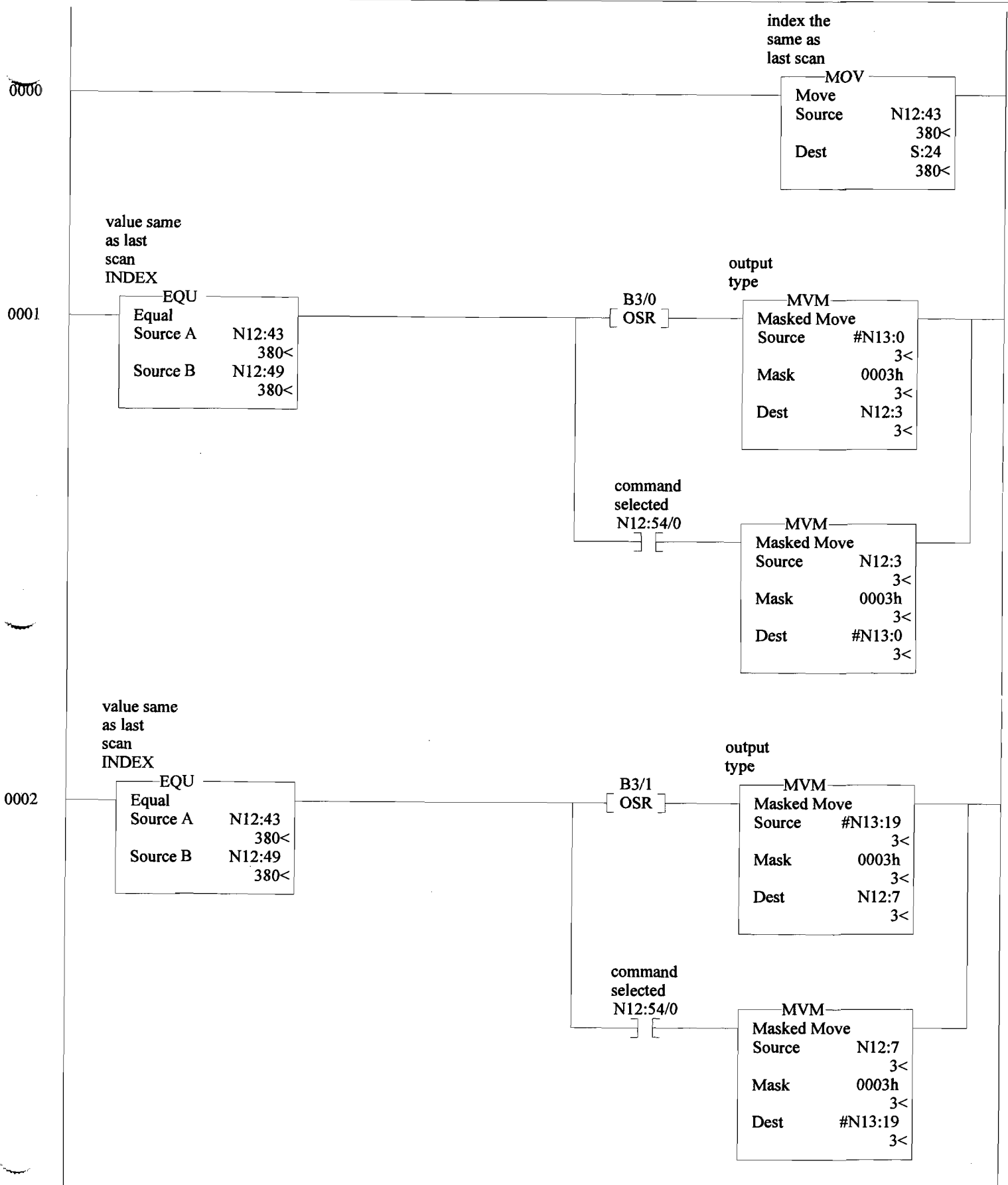
MVM	
Masked Move	
Source	N12:28 0<
Mask	6000h 24576<
Dest	#N13:38 3<

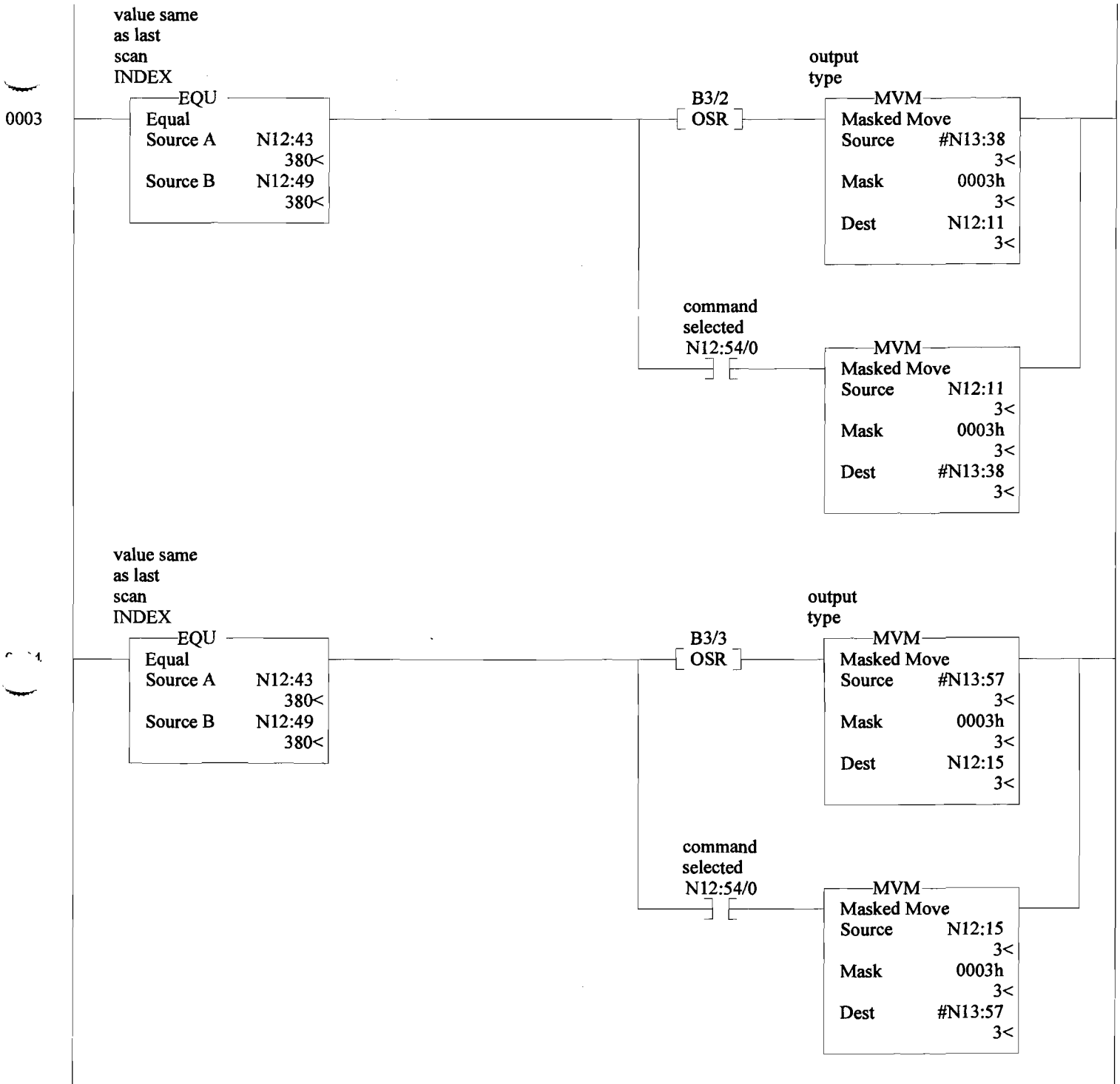
command  
selected  
N12:54/0

MVM	
Masked Move	
Source	N12:62 0<
Mask	8000h -32768<
Dest	#N13:38 3<









0005

value same  
as last  
scan  
INDEX

EQU	
Equal	
Source A	N12:43 380<
Source B	N12:49 380<

B3/16  
OSR

Channel 1  
qty/length

MOV	
Move	
Source	#N13:5 0<
Dest	N12:30 0<

Channel 1  
pulse  
duration

MOV	
Move	
Source	#N13:6 0<
Dest	N12:31 0<

command  
selected  
N12:54/0

MOV	
Move	
Source	N12:30 0<
Dest	#N13:5 0<

command  
selected  
N12:54/0

MOV	
Move	
Source	N12:31 0<
Dest	#N13:6 0<

0006

value same  
as last  
scan  
INDEX

EQU	
Equal	
Source A	N12:43 380<
Source B	N12:49 380<

B3/17  
OSR

Channel 2  
qty/length

MOV	
Move	
Source	#N13:24 0<
Dest	N12:32 0<

Channel 2  
pulse  
duration

MOV	
Move	
Source	#N13:25 0<
Dest	N12:33 0<

command  
selected  
N12:54/0

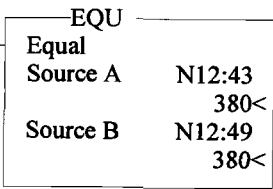
MOV	
Move	
Source	N12:32 0<
Dest	#N13:24 0<

command  
selected  
N12:54/0

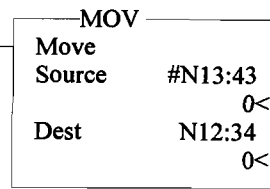
MOV	
Move	
Source	N12:33 0<
Dest	#N13:25 0<

0007

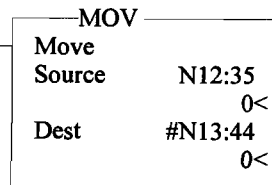
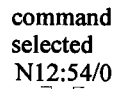
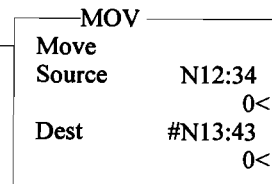
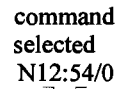
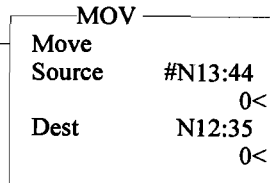
value same  
as last  
scan  
INDEX

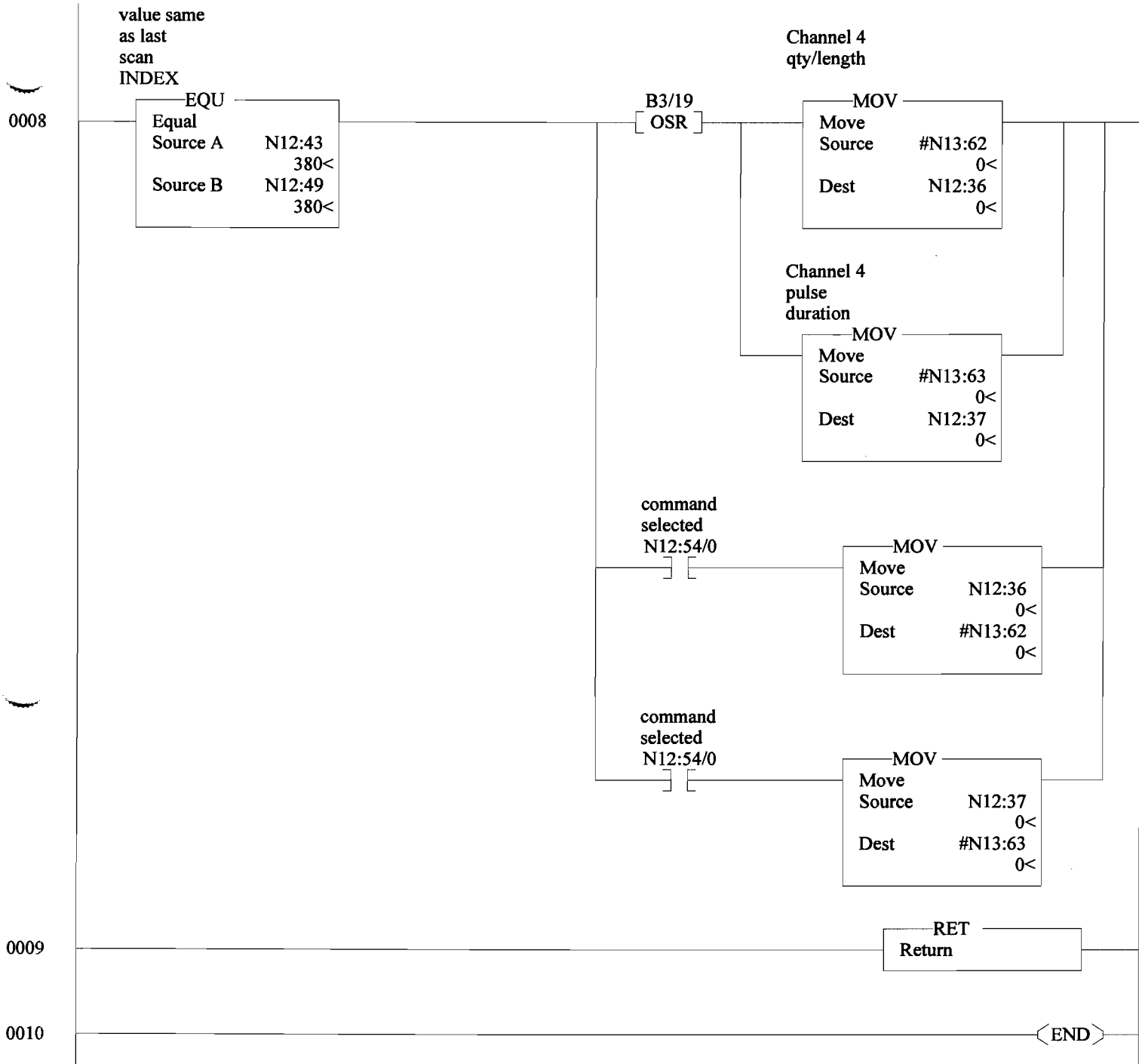


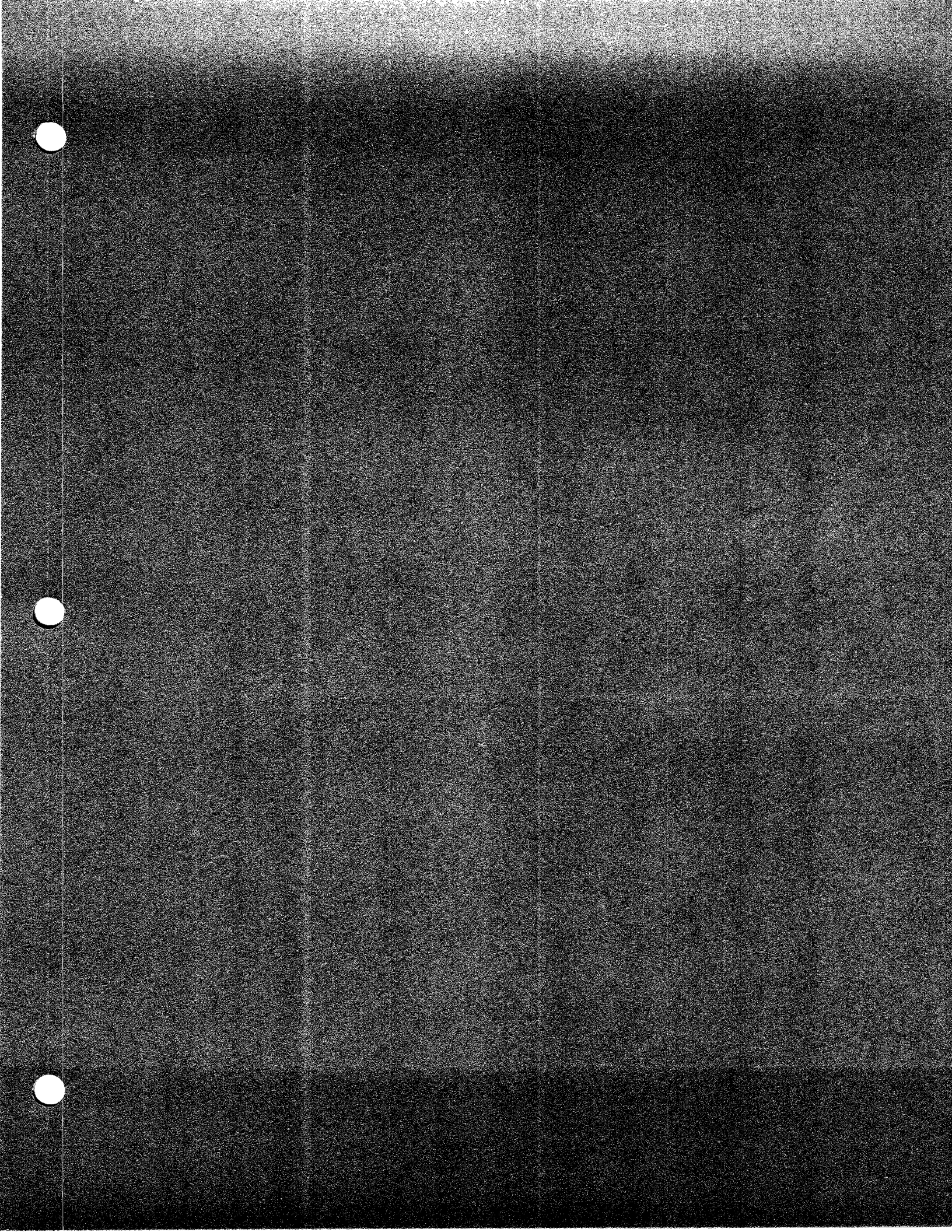
Channel 3  
qty/length



Channel 3  
pulse  
duration







0000

group same  
as last  
scan

MUL

Multiply	N12:70
Source A	1<
Source B	4
	4<
Dest	N12:76
	4<

index the  
same as  
last scan

SUB

Subtract	N12:76
Source A	4<
Source B	4
	4<
Dest	S:24
	380<

0001

group same  
as last  
scan

**EQU**

Equal	
Source A	N12:76 4<
Source B	N12:77 4<

**B3/20**  
**OSR**

number of  
outputs in  
group

**MVM**

Masked Move	
Source	#N11:20 0<
Mask	003Fh 63<
Dest	N12:71 0<

Group  
window ON

**MOV**

Move	
Source	#N11:21 0<
Dest	N12:74 0<

Group  
Window OFF

**MOV**

Move	
Source	#N11:22 0<
Dest	N12:75 0<

Group  
offset

**MOV**

Move	
Source	#N11:23 0<
Dest	N12:73 0<

Group  
enable,  
type, and  
first  
cycle type

**MVM**

Masked Move	
Source	#N11:20 0<
Mask	0E000h -8192<
Dest	N12:79 0<

Group mode

MVM  
Masked Move  
Source #N11:20  
0<  
Mask 0700h  
1792<  
Dest N12:78  
0<

DIV  
Divide  
Source A N12:78  
0<  
Source B 256  
256<  
Dest N12:72  
0<

command selected  
N12:54/0

MVM  
Masked Move  
Source N12:71  
0<  
Mask 001Fh  
31<  
Dest #N11:20  
0<

command selected  
N12:54/0

MVM  
Masked Move  
Source N12:79  
0<  
Mask 0E000h  
-8192<  
Dest #N11:20  
0<

command selected  
N12:54/0

MOV  
Move  
Source N12:73  
0<  
Dest #N11:23  
0<

command selected  
N12:54/0

MOV  
Move  
Source N12:74  
0<  
Dest #N11:21  
0<

command selected  
N12:54/0

MOV  
Move  
Source N12:75  
0<  
Dest #N11:22  
0<

Group mode

MUL  
Multiply  
Source A N12:72  
0<  
Source B 256  
256<  
Dest N12:78  
0<

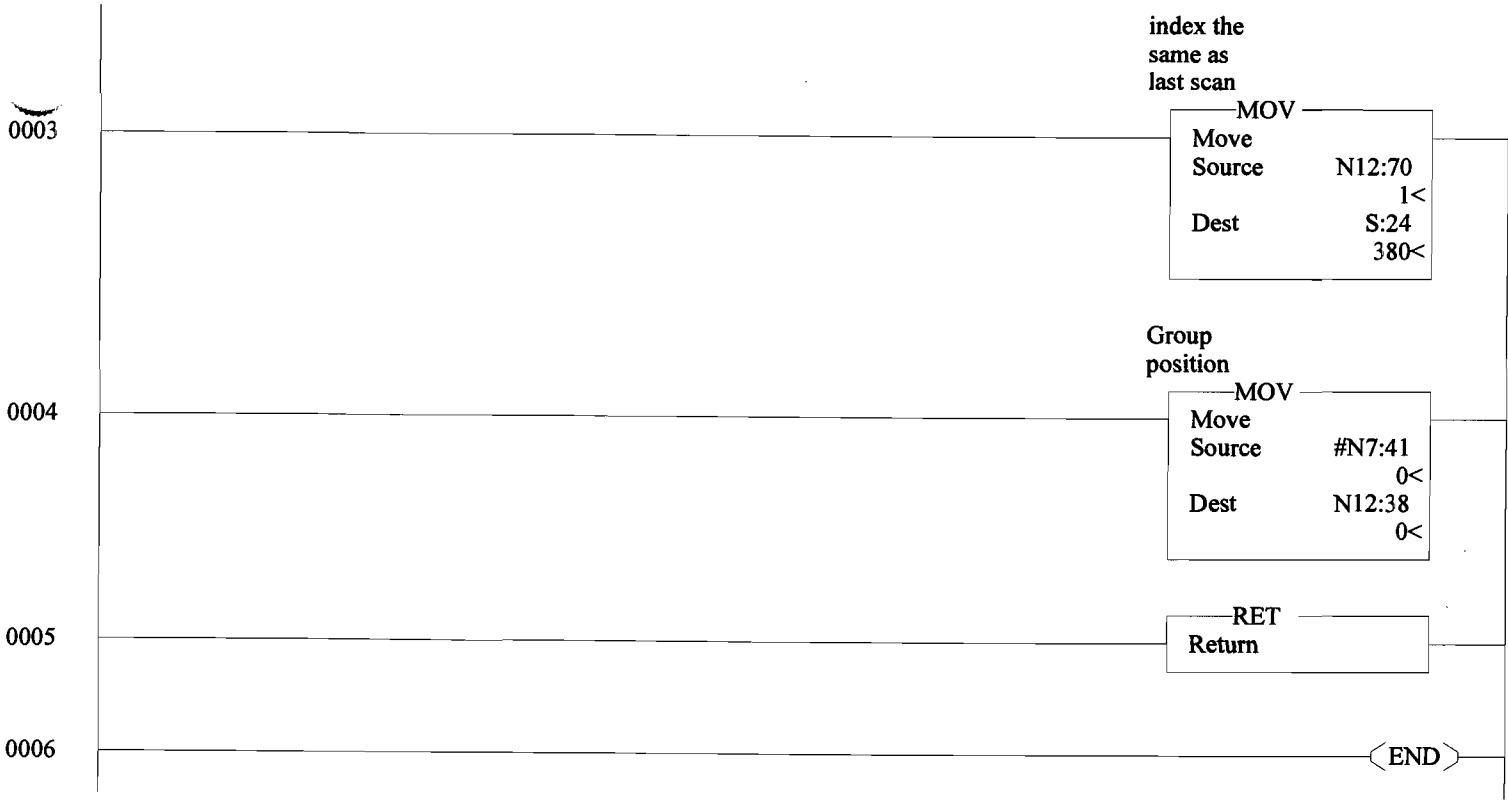
command selected  
N12:54/0

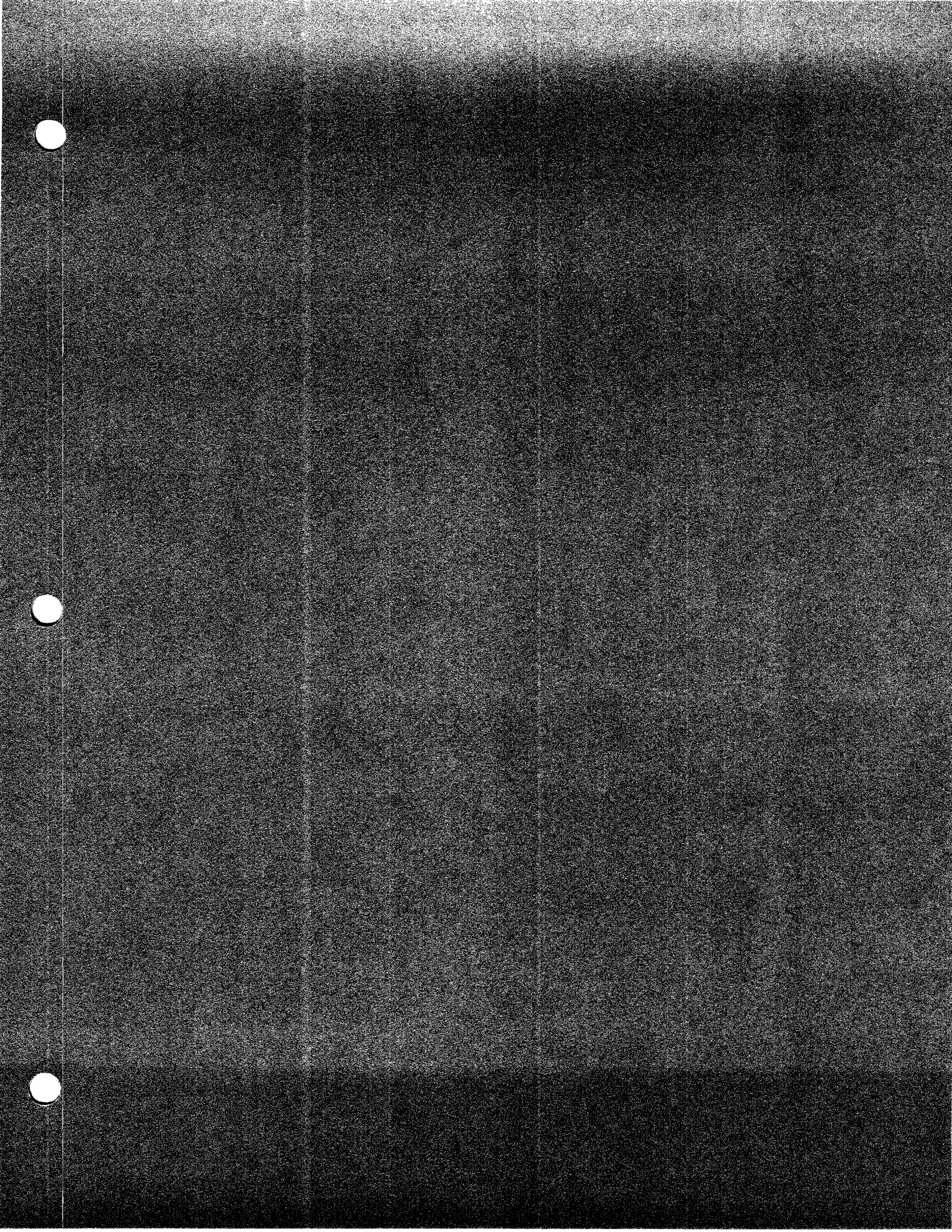
MVM  
Masked Move  
Source N12:78  
0<  
Mask 0700h  
1792<  
Dest #N11:20  
0<

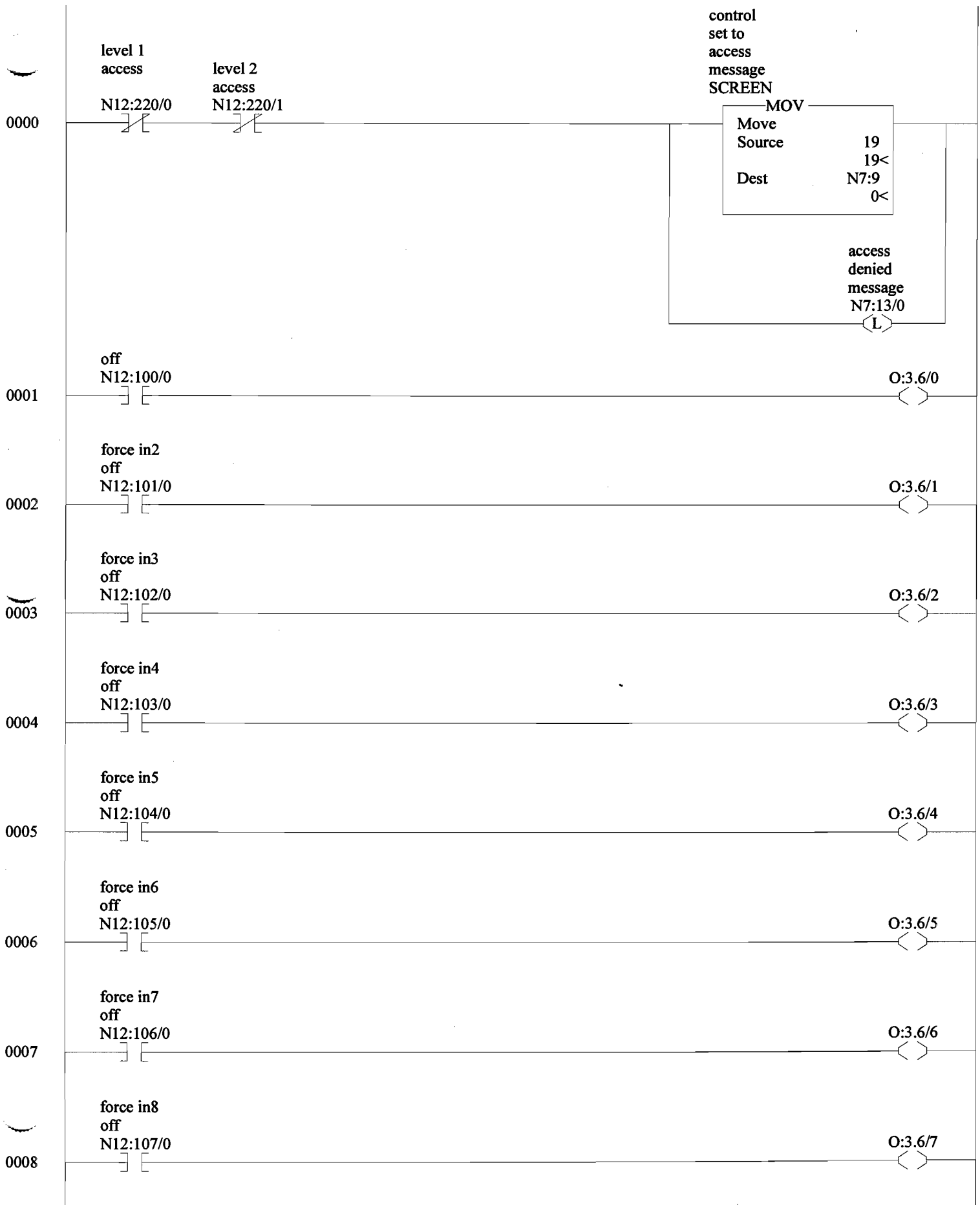
Group  
index from  
previous  
scan

MOV  
Move  
Source N12:76  
4<  
Dest N12:77  
4<

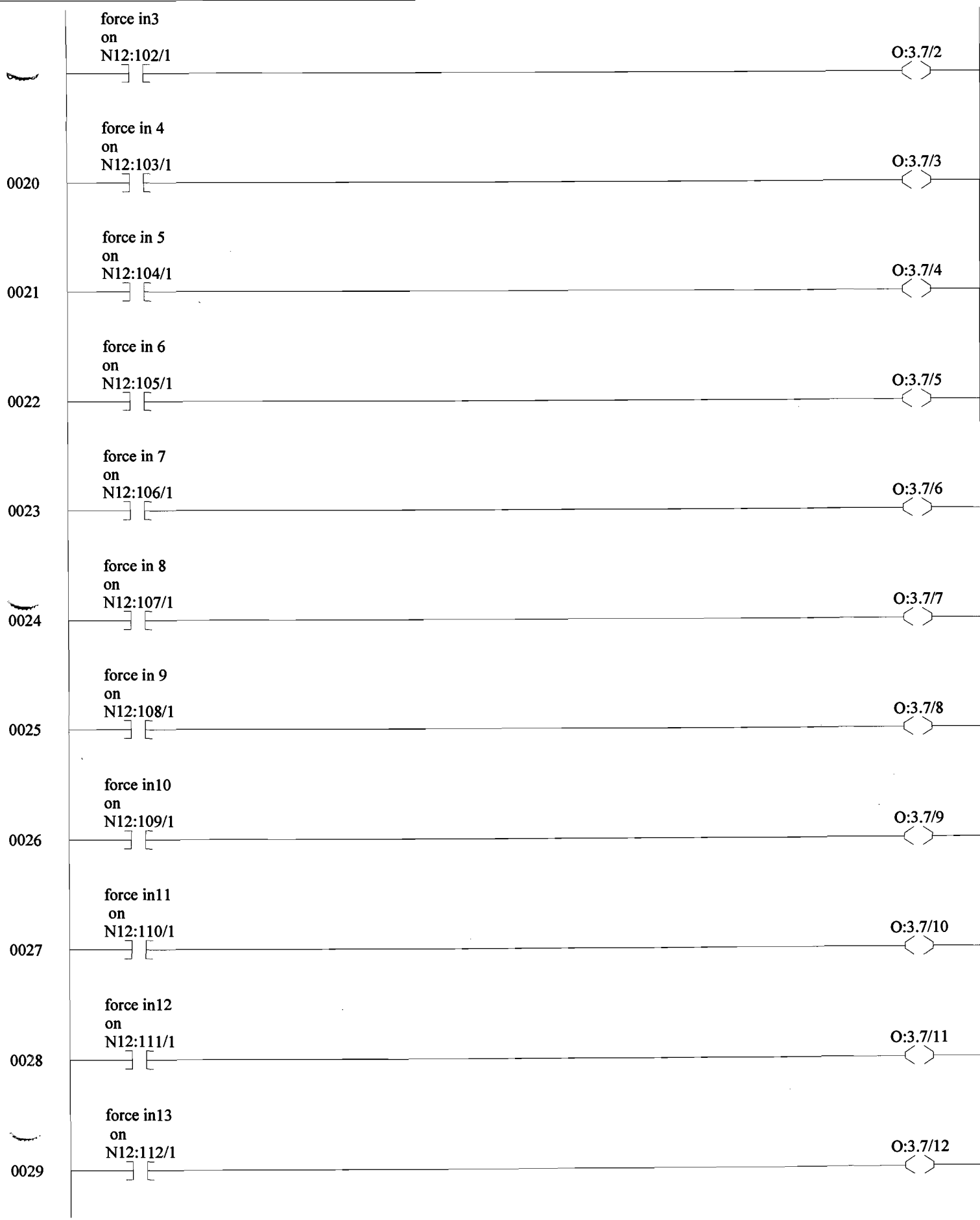
0002

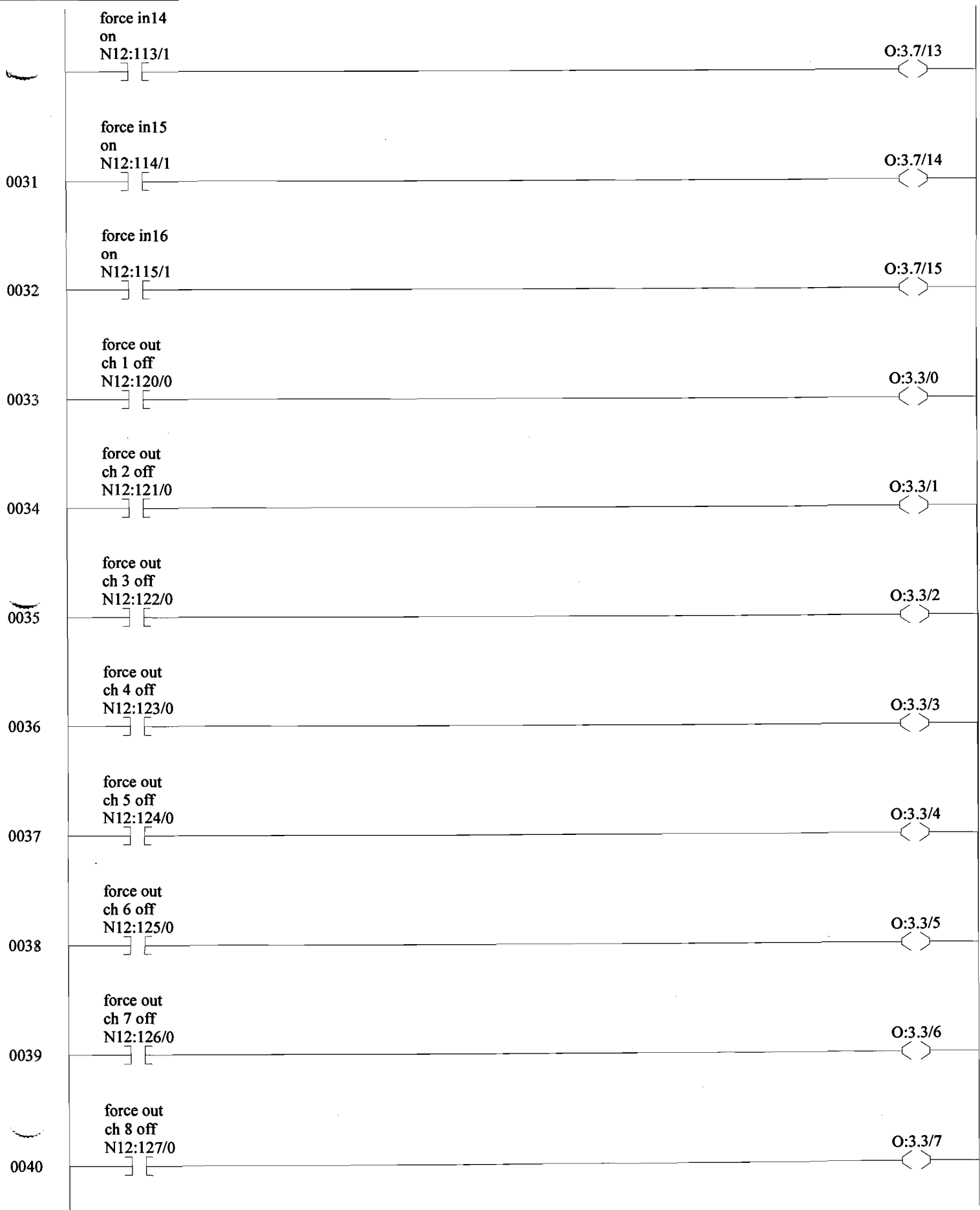


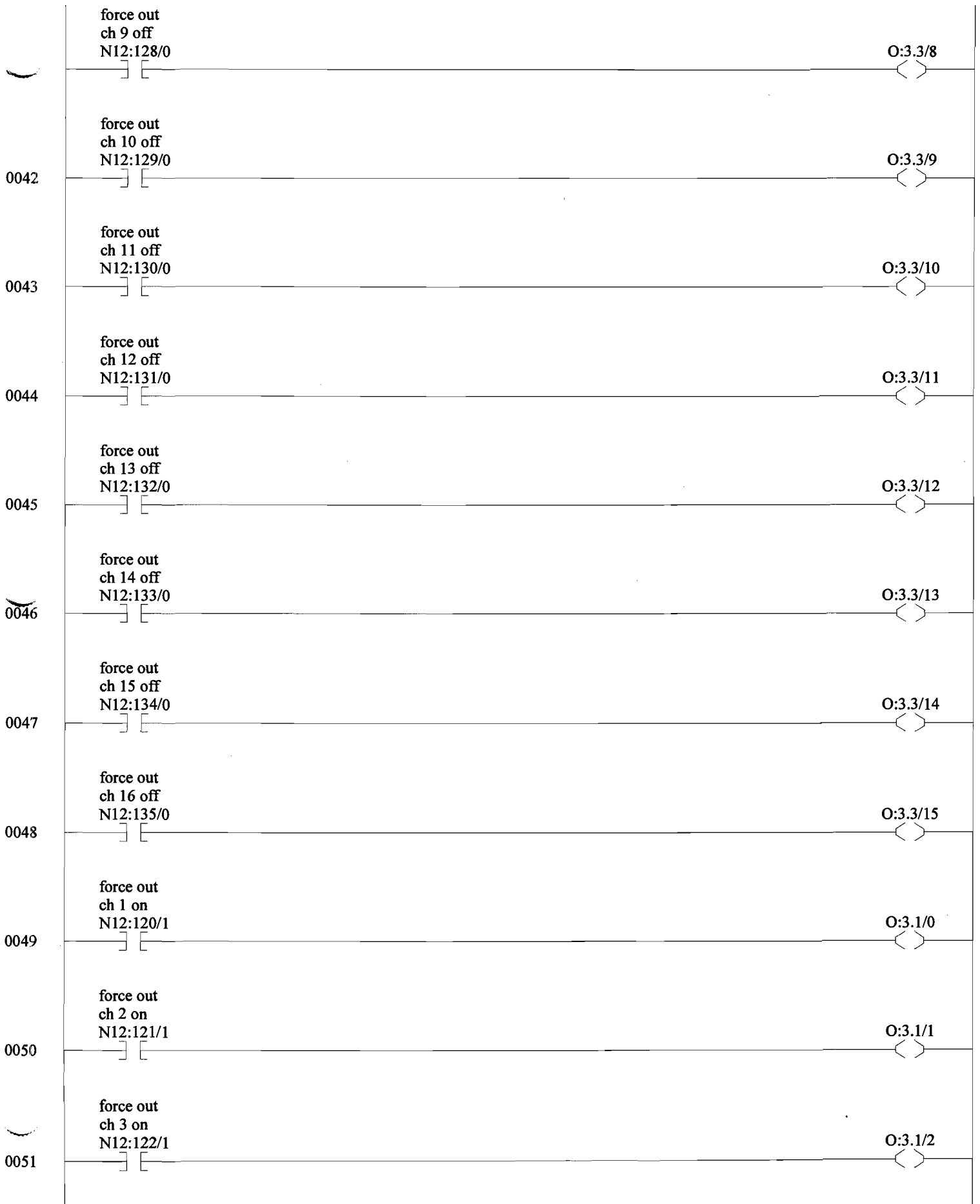






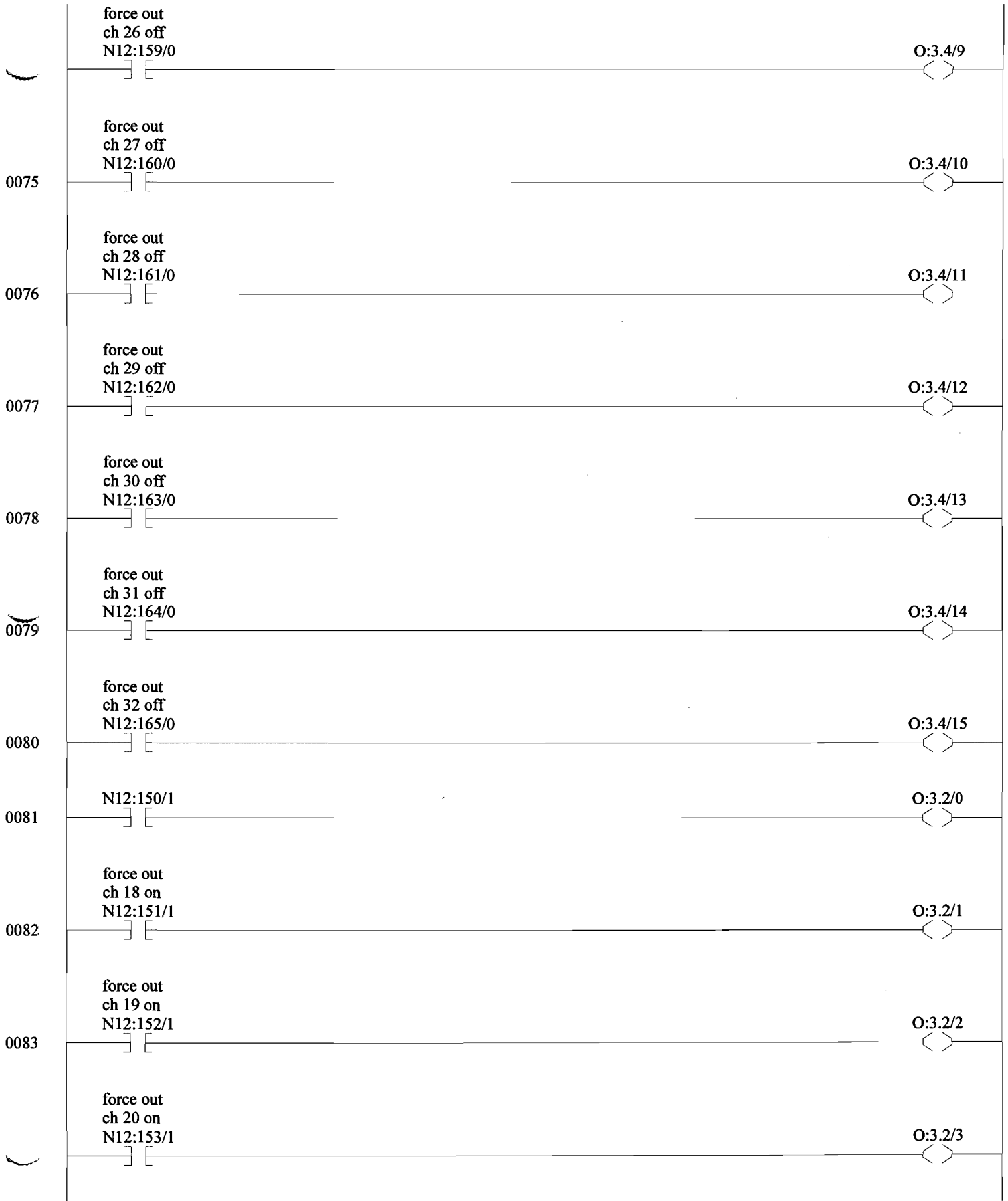






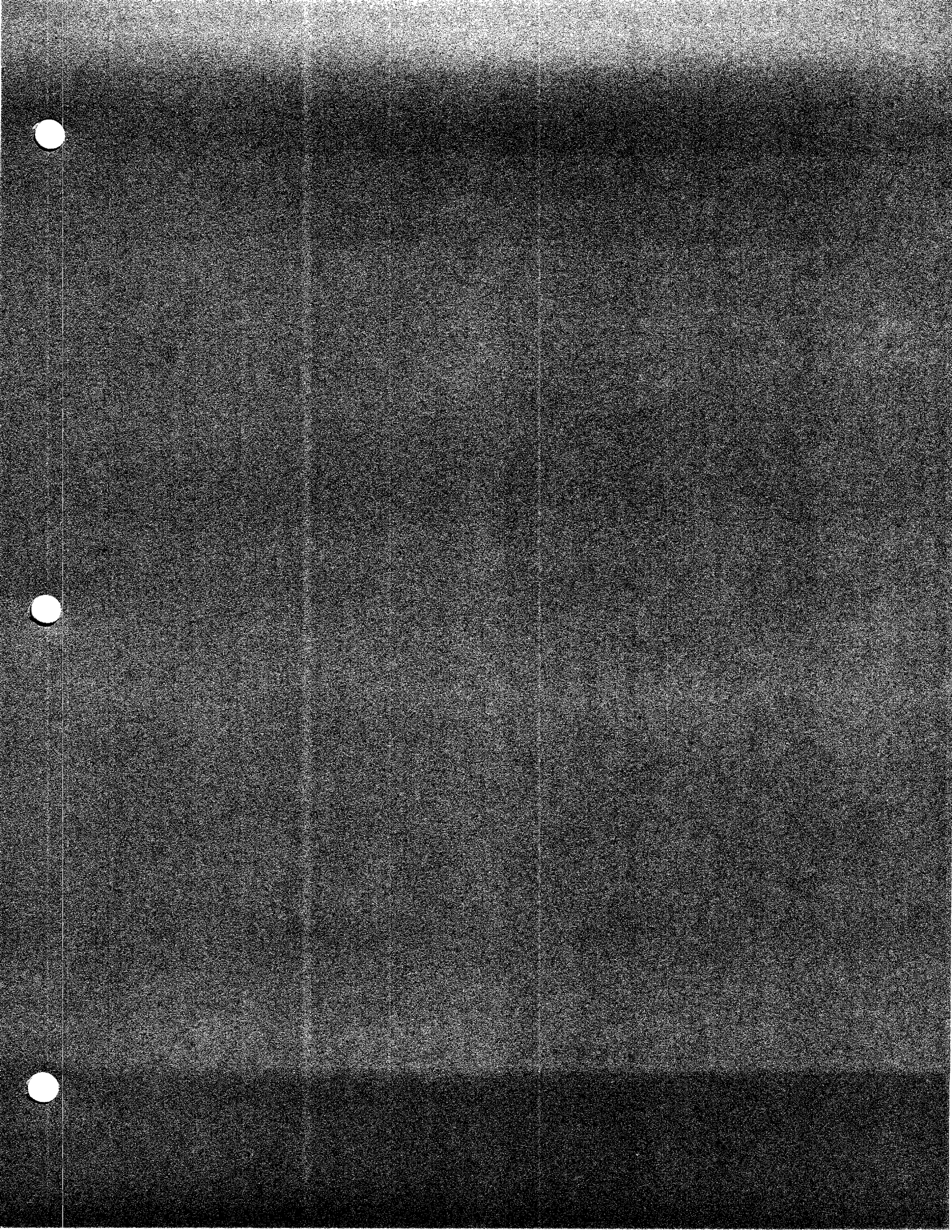


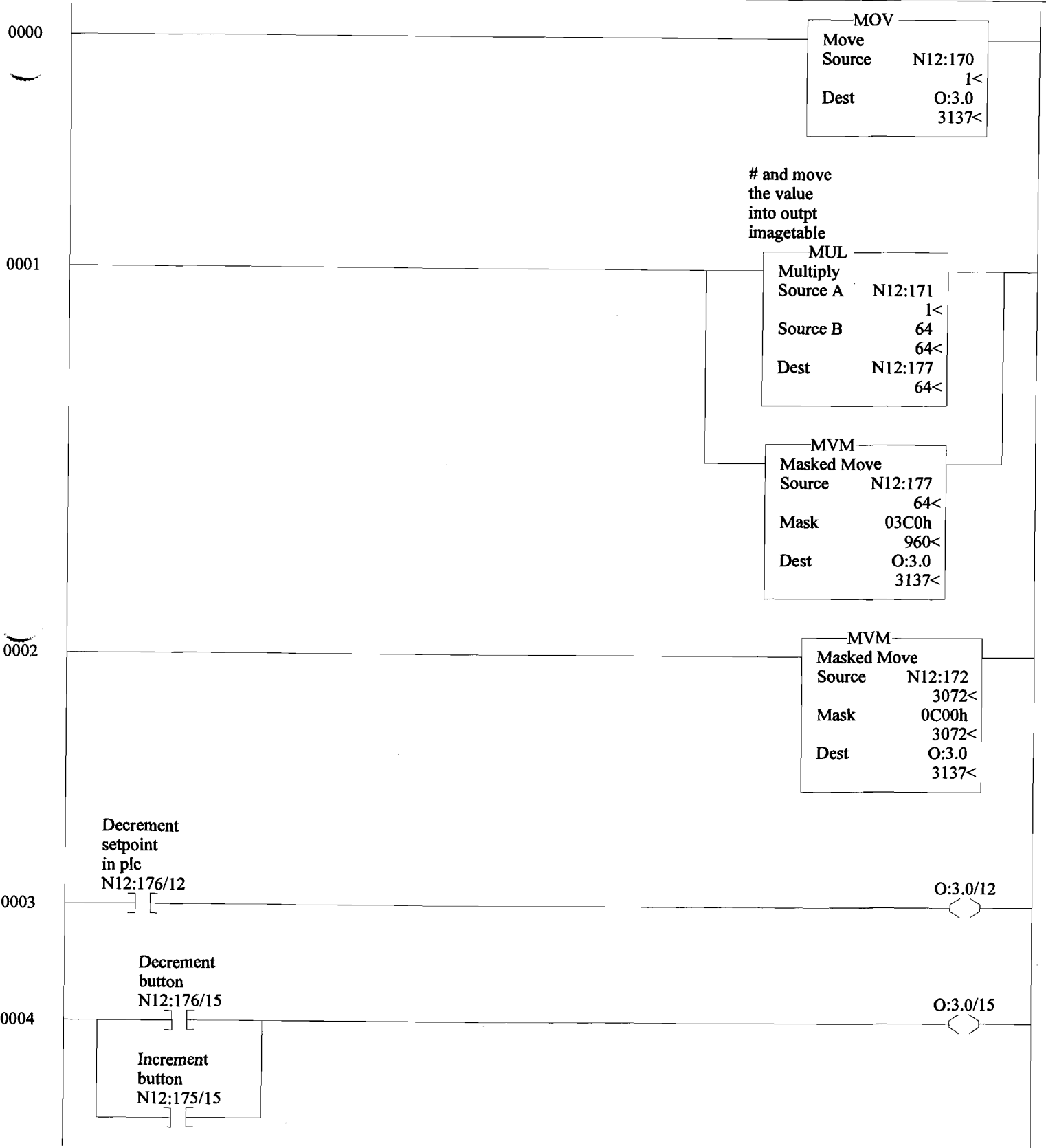












0005

is used to  
select  
output  
changed

MUL

Multiply	
Source A	N12:170
	1<
Source B	19
	19<
Dest	N12:178
	19<

SUB

Subtract	
Source A	N12:178
	19<
Source B	19
	19<
Dest	N12:179
	0<

0006

nt to sele  
ct which s  
etpoint is  
changed

MUL

Multiply	
Source A	N12:171
	1<
Source B	2
	2<
Dest	N12:180
	2<

SUB

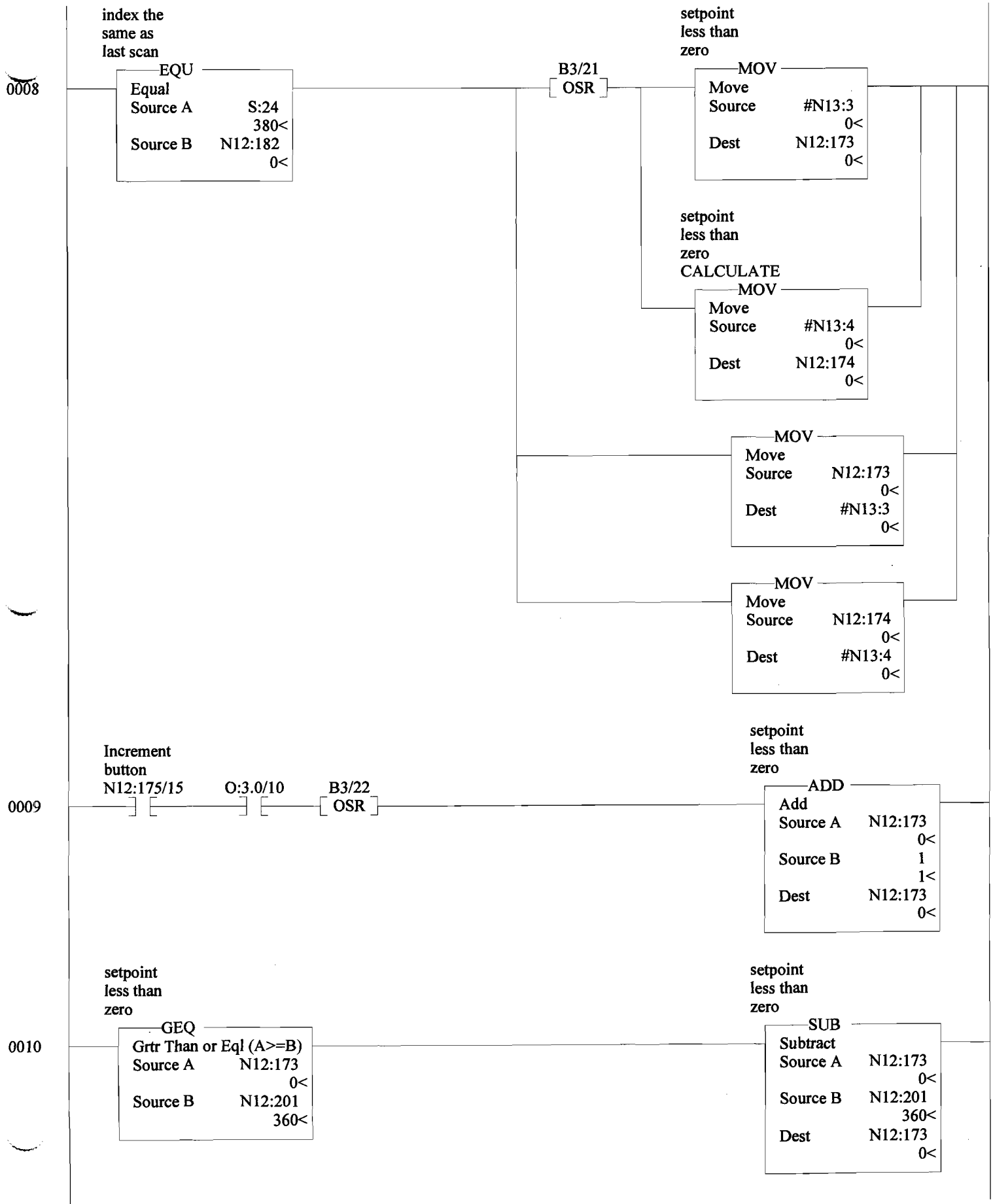
Subtract	
Source A	N12:180
	2<
Source B	2
	2<
Dest	N12:181
	0<

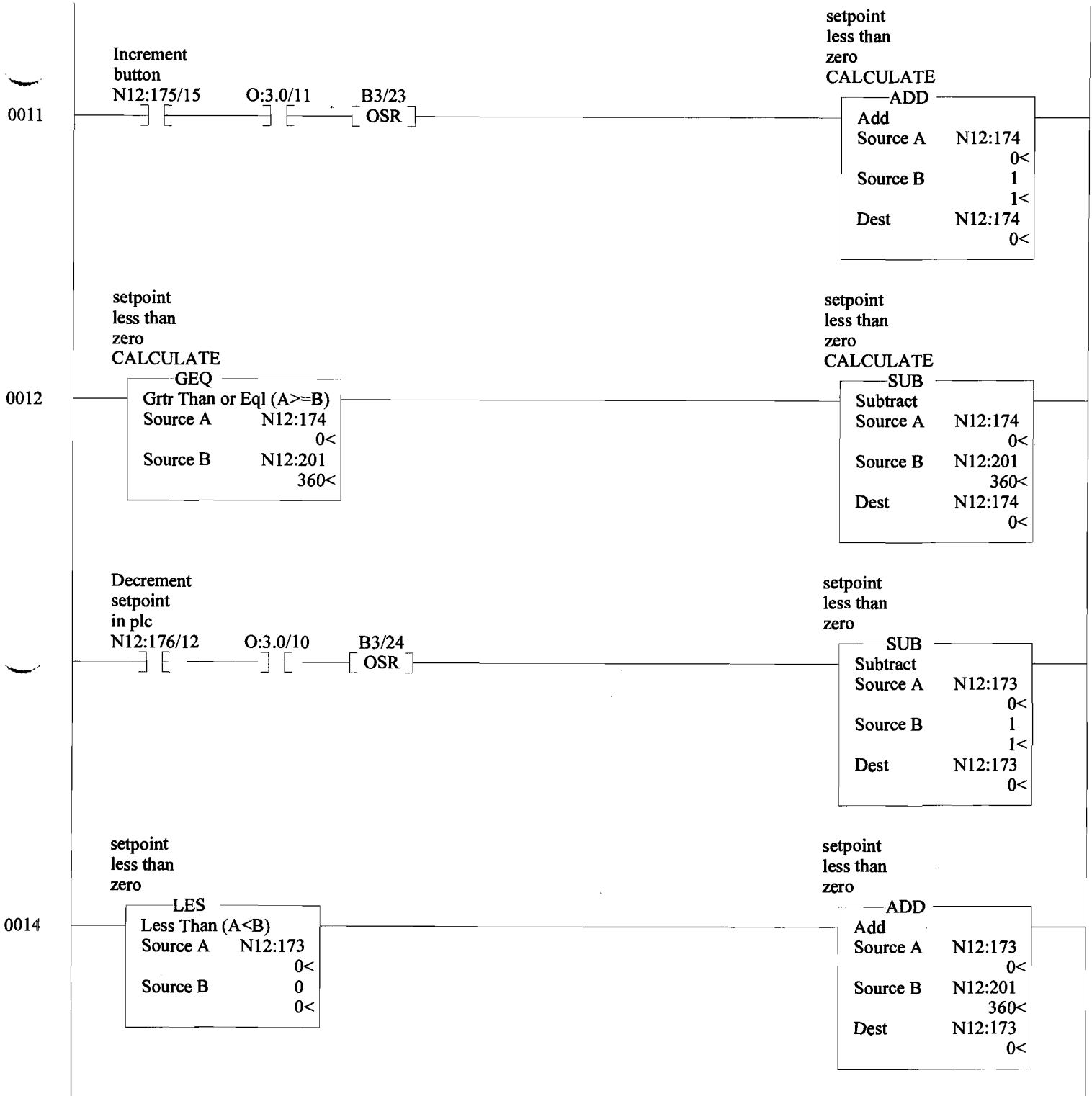
0007

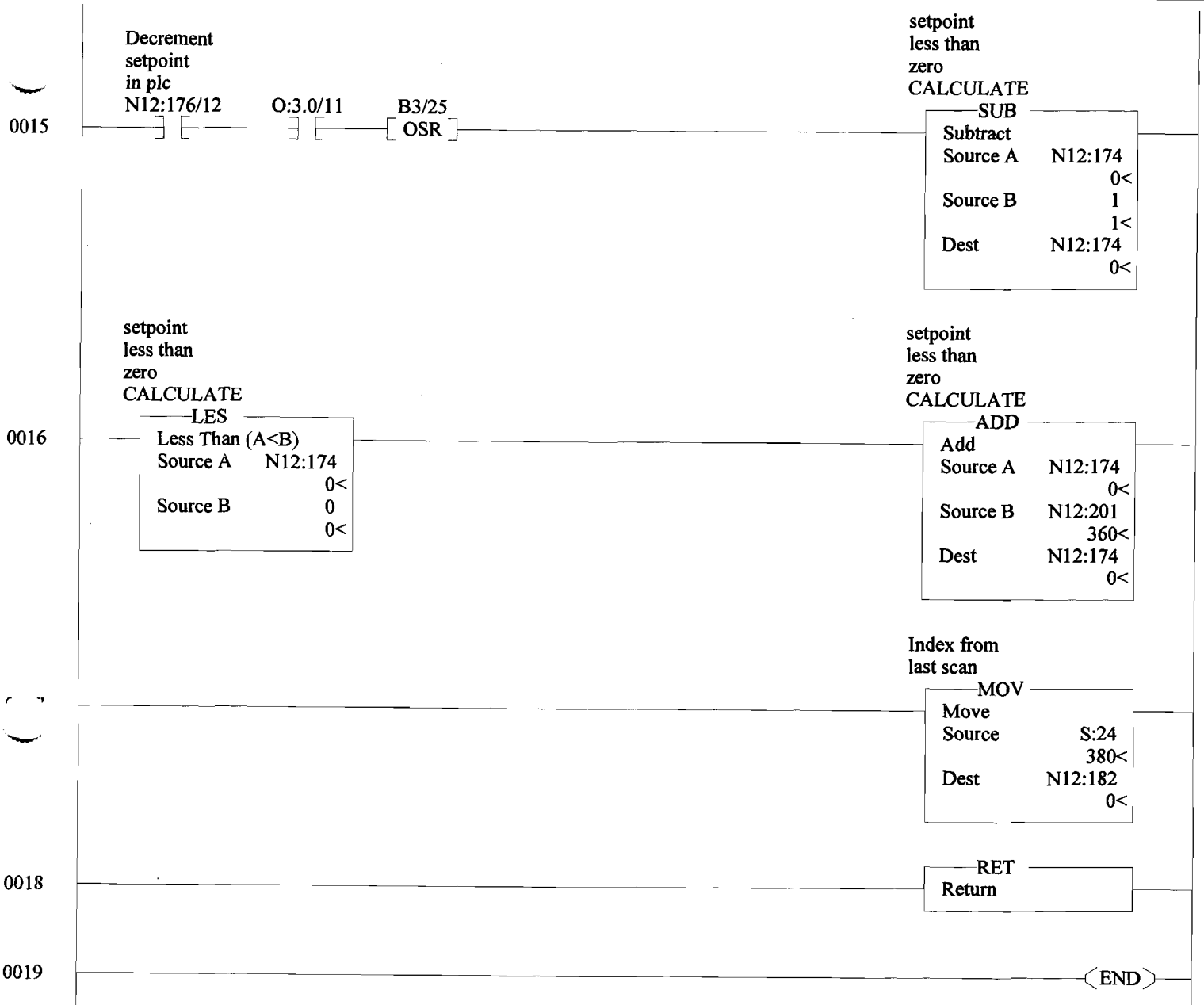
index the  
same as  
last scan

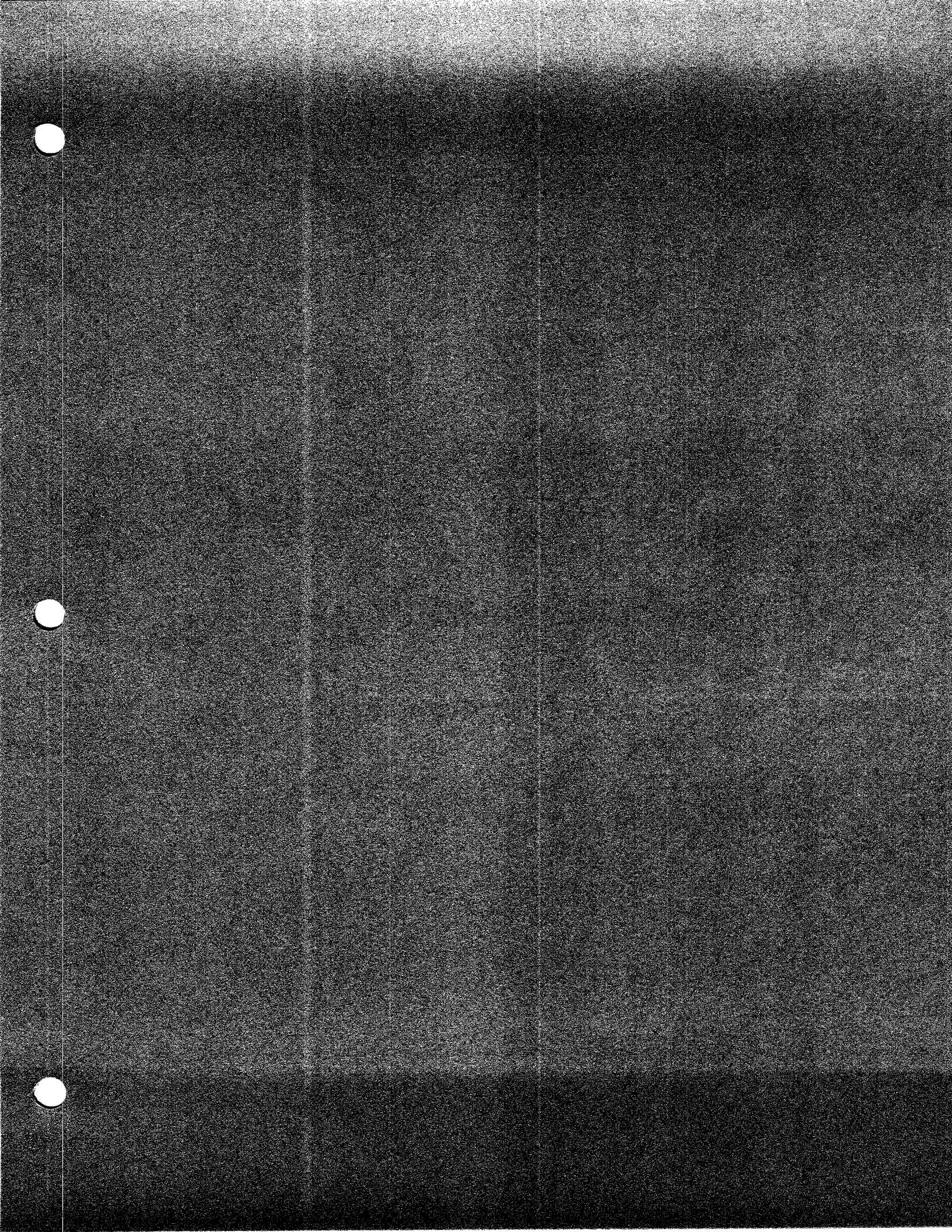
ADD

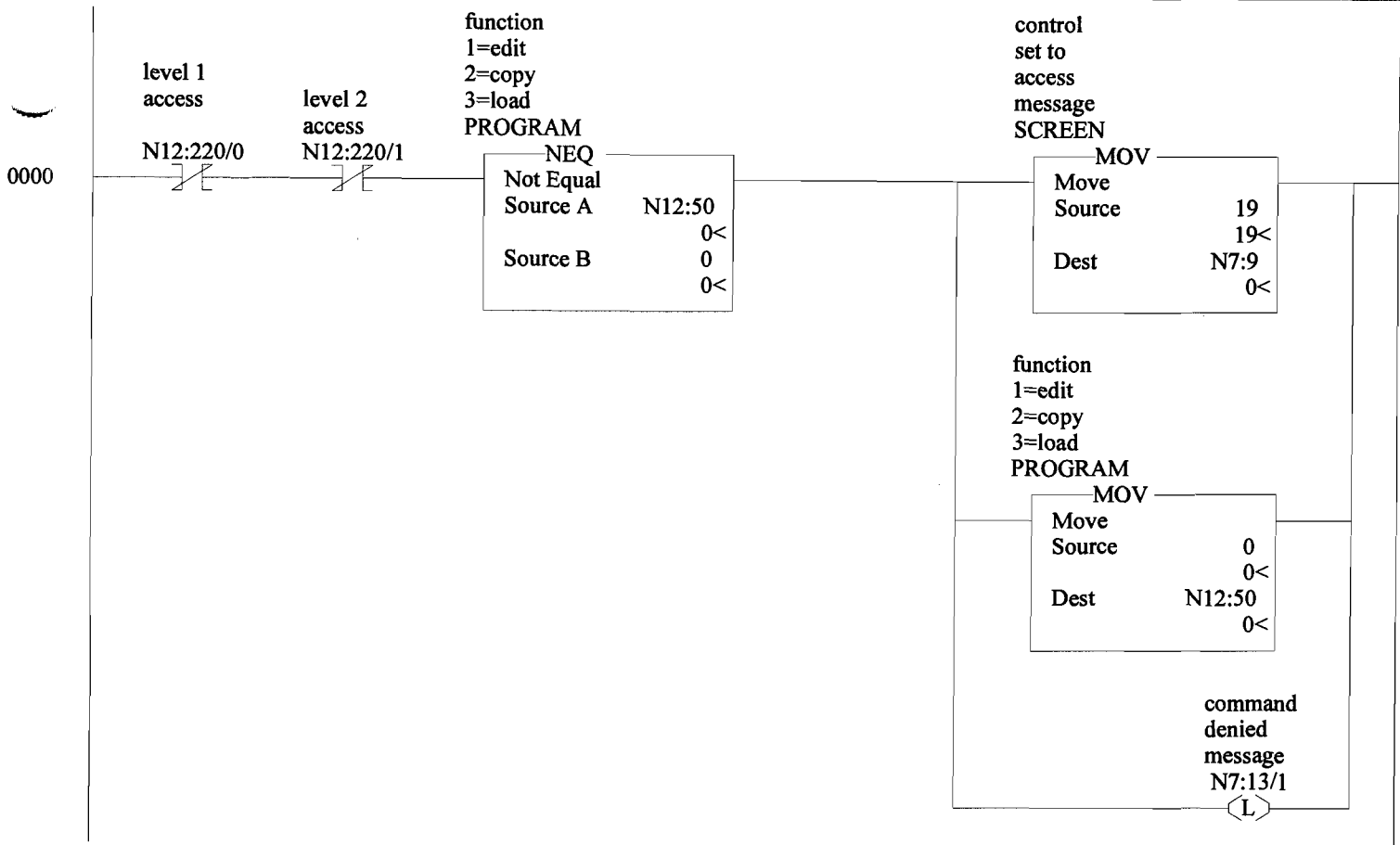
Add	
Source A	N12:179
	0<
Source B	N12:181
	0<
Dest	S:24
	380<











0001

program  
number  
SELECTED

EQU	
Equal	
Source A	N12:51
	1<
Source B	0
	0<

B3/32  
OSR

COP	
Copy File	
Source	#N17:0
Dest	#N11:0
Length	50

COP	
Copy File	
Source	#N18:0
Dest	#N13:0
Length	76

COP	
Copy File	
Source	#N18:76
Dest	#N13:76
Length	76

COP	
Copy File	
Source	#N19:0
Dest	#N14:0
Length	76

COP	
Copy File	
Source	#N19:76
Dest	#N14:76
Length	76

COP	
Copy File	
Source	#N20:0
Dest	#N15:0
Length	76

COP	
Copy File	
Source	#N20:76
Dest	#N15:76
Length	76

COP	
Copy File	
Source	#N21:0
Dest	#N16:0
Length	76

COP	
Copy File	
Source	#N21:76
Dest	#N16:76
Length	81

0002

program  
number  
SELECTED

EQU	
Equal	
Source A	N12:51
	1<
Source B	1
	1<

B3/33  
OSR

COP	
Copy File	
Source	#N22:0
Dest	#N11:0
Length	50

COP	
Copy File	
Source	#N23:0
Dest	#N13:0
Length	76

COP	
Copy File	
Source	#N23:76
Dest	#N13:76
Length	76

COP	
Copy File	
Source	#N24:0
Dest	#N14:0
Length	76

COP	
Copy File	
Source	#N24:76
Dest	#N14:76
Length	76

COP	
Copy File	
Source	#N25:0
Dest	#N15:0
Length	76

COP	
Copy File	
Source	#N25:76
Dest	#N15:76
Length	76

COP	
Copy File	
Source	#N26:0
Dest	#N16:0
Length	76

COP	
Copy File	
Source	#N26:76
Dest	#N16:76
Length	81

0003

program  
number  
SELECTED

EQU	
Equal	
Source A	N12:51
	1<
Source B	2
	2<

B3/34  
OSR

COP	
Copy File	
Source	#N27:0
Dest	#N11:0
Length	50

COP	
Copy File	
Source	#N28:0
Dest	#N13:0
Length	76

COP	
Copy File	
Source	#N28:76
Dest	#N13:76
Length	76

COP	
Copy File	
Source	#N29:0
Dest	#N14:0
Length	76

COP	
Copy File	
Source	#N29:76
Dest	#N14:76
Length	76

COP	
Copy File	
Source	#N30:0
Dest	#N15:0
Length	76

COP	
Copy File	
Source	#N30:76
Dest	#N15:76
Length	76

COP	
Copy File	
Source	#N31:0
Dest	#N16:0
Length	76

COP	
Copy File	
Source	#N31:76
Dest	#N16:76
Length	81

0004

program  
number  
SELECTED

EQU	
Equal	
Source A	N12:51
	1<
Source B	3
	3<

B3/35  
OSR

COP	
Copy File	
Source	#N32:0
Dest	#N11:0
Length	50

COP	
Copy File	
Source	#N33:0
Dest	#N13:0
Length	76

COP	
Copy File	
Source	#N33:76
Dest	#N13:76
Length	76

COP	
Copy File	
Source	#N34:0
Dest	#N14:0
Length	76

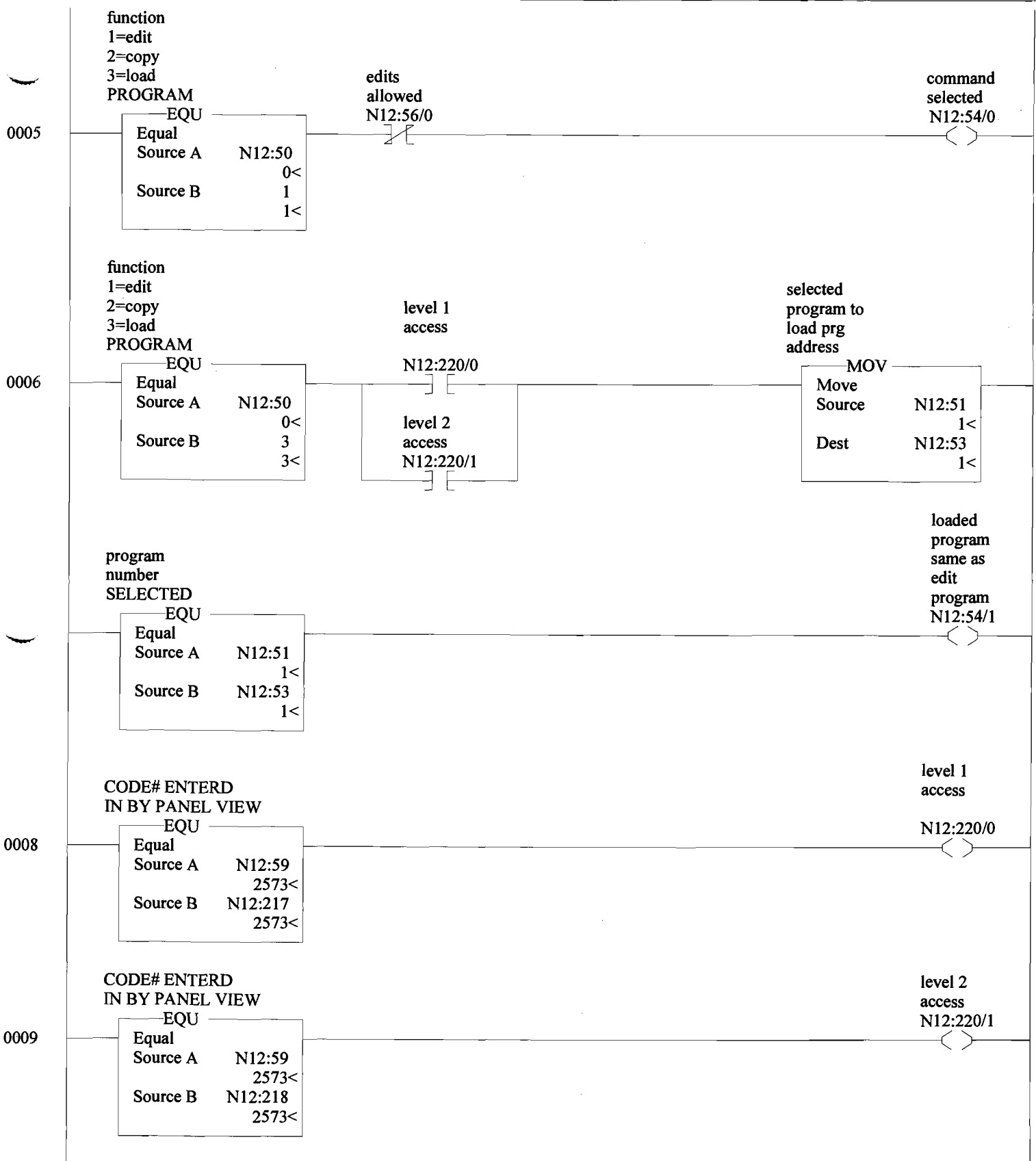
COP	
Copy File	
Source	#N34:76
Dest	#N14:76
Length	76

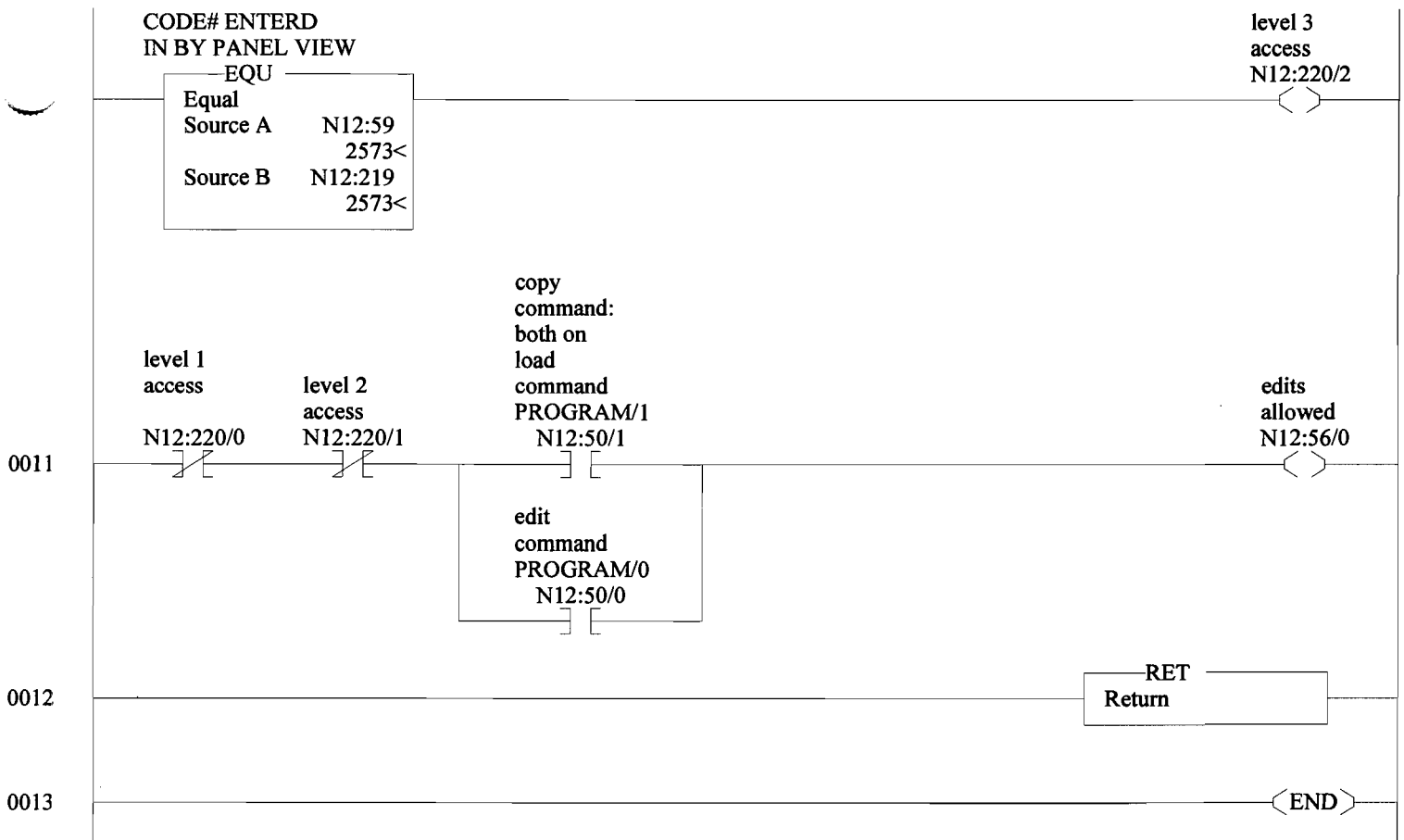
COP	
Copy File	
Source	#N35:0
Dest	#N15:0
Length	76

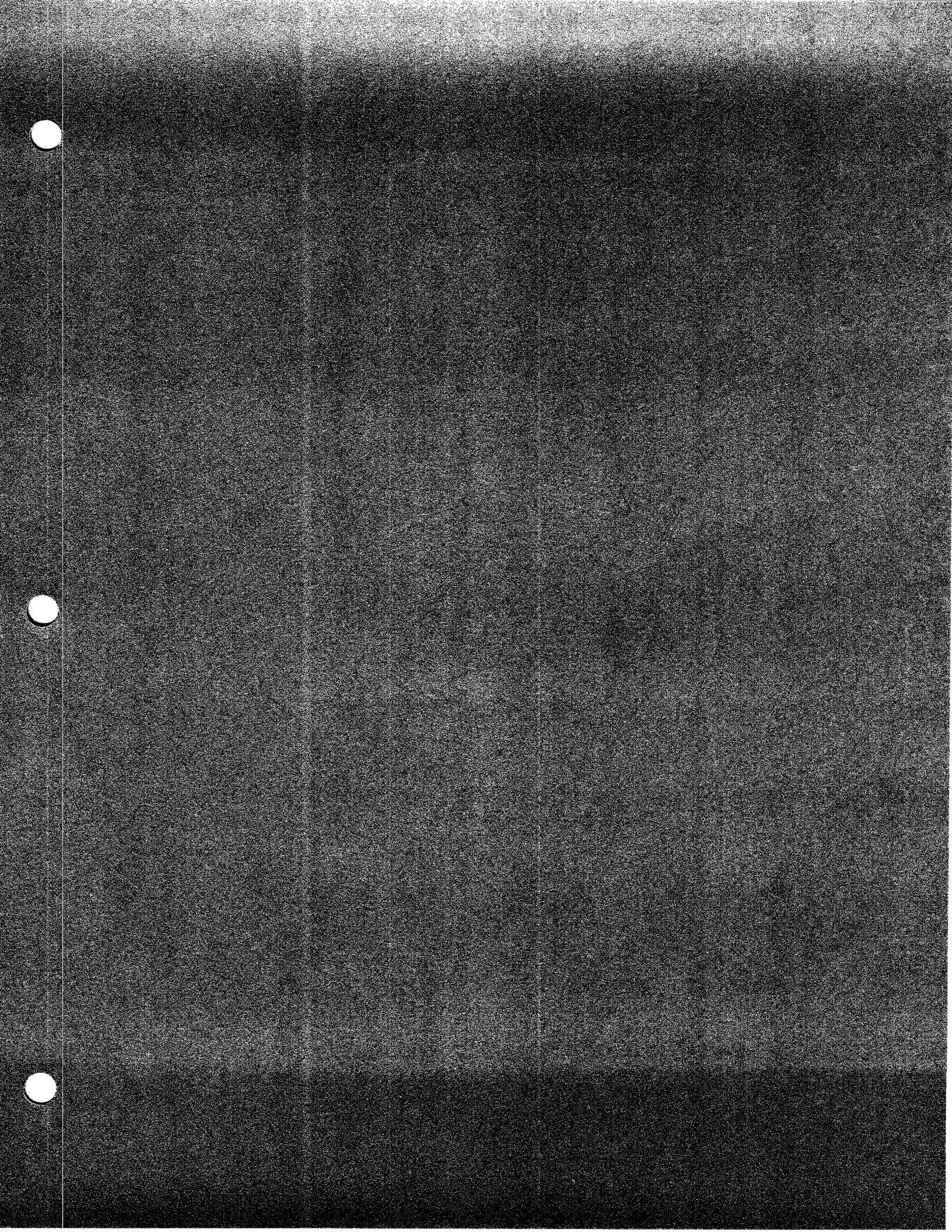
COP	
Copy File	
Source	#N35:76
Dest	#N15:76
Length	76

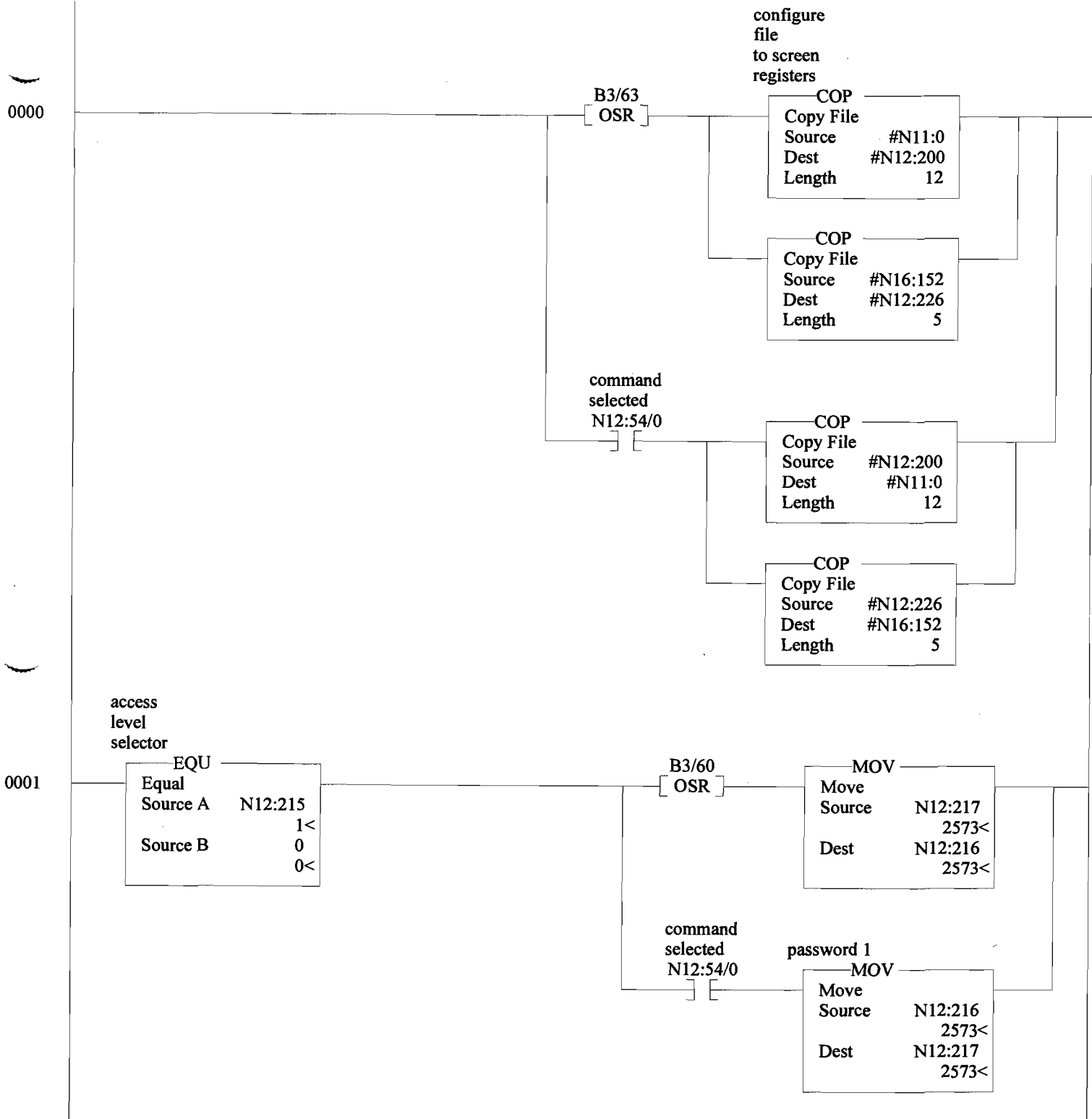
COP	
Copy File	
Source	#N36:0
Dest	#N16:0
Length	76

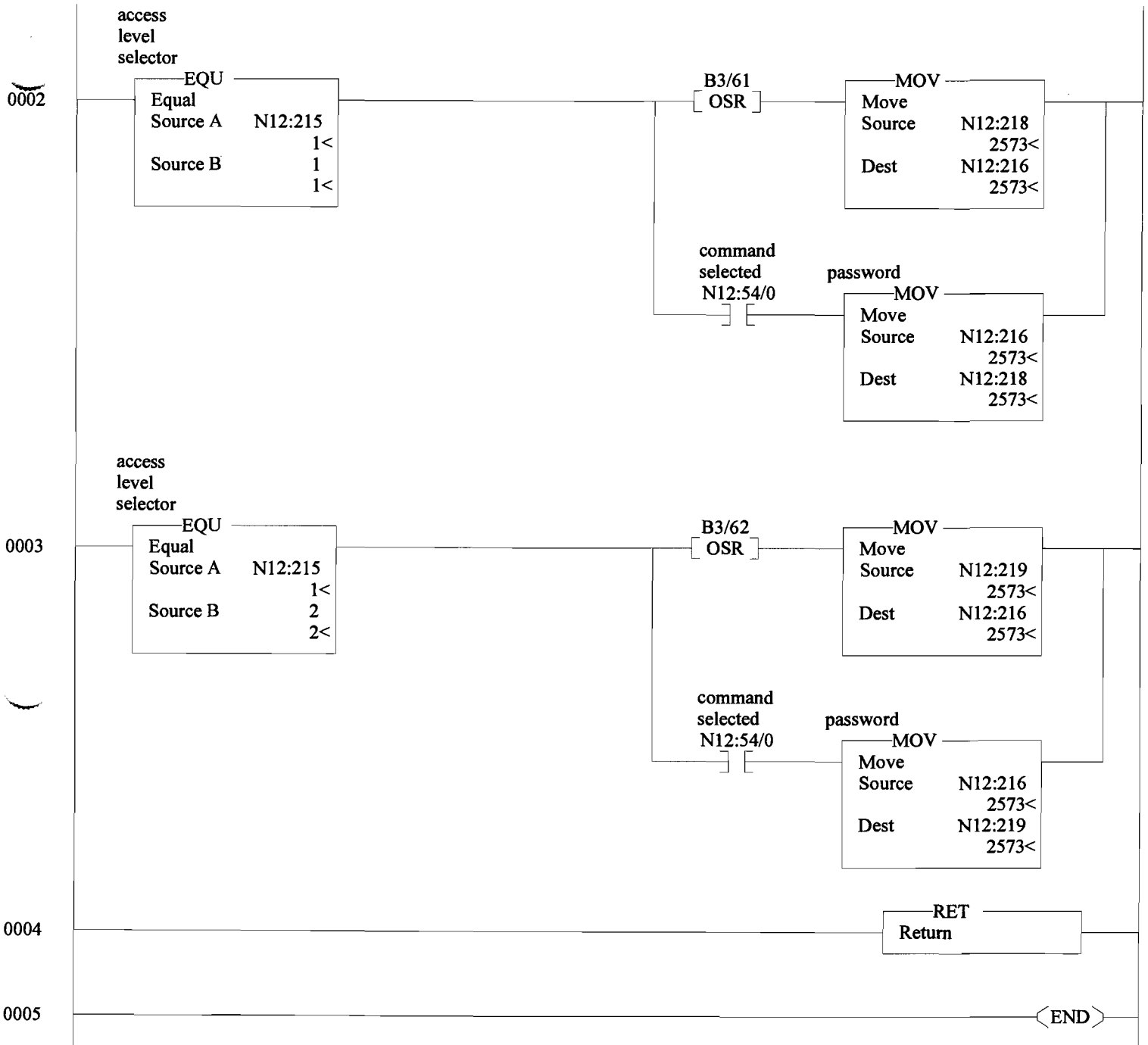
COP	
Copy File	
Source	#N36:76
Dest	#N16:76
Length	81

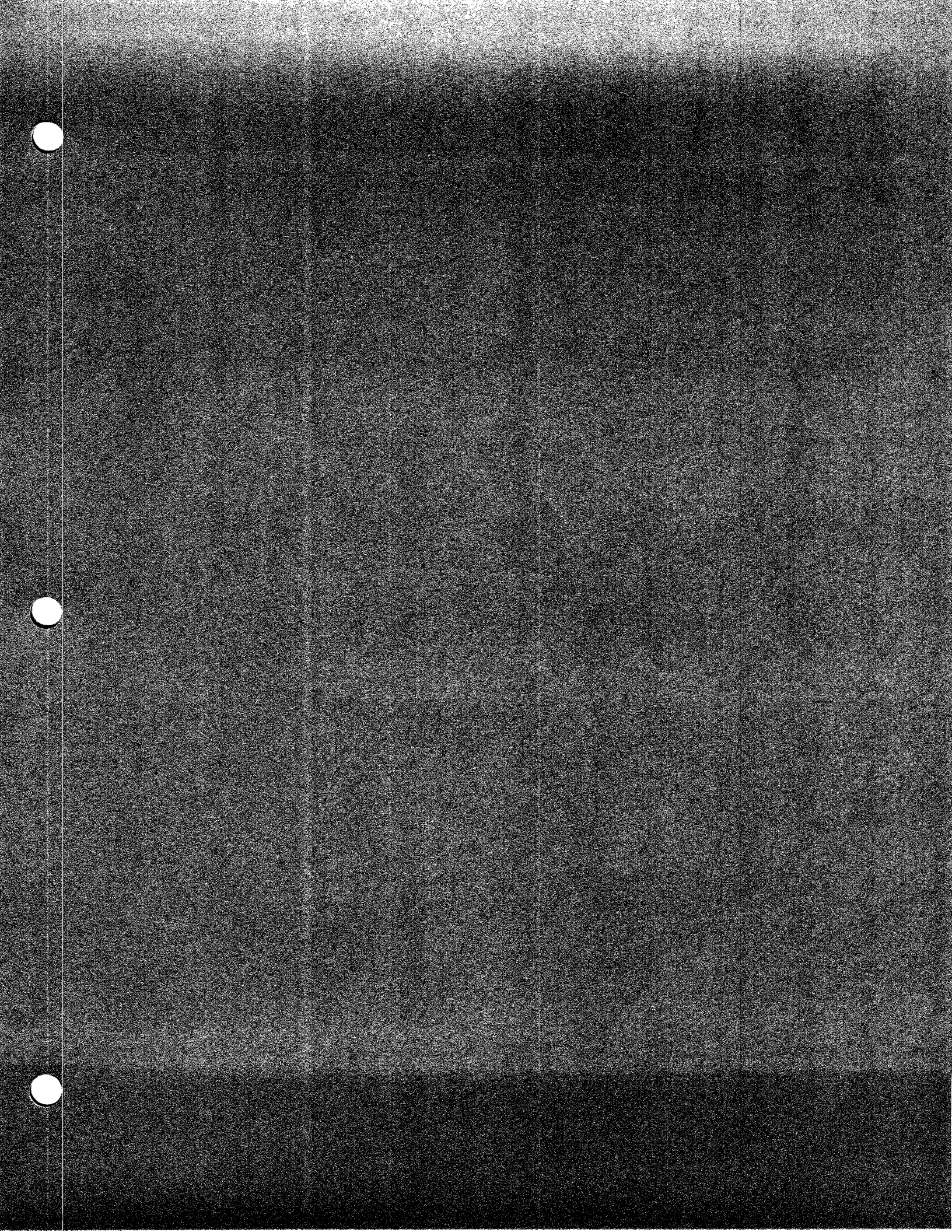












0000

clear  
error  
bit  
N7:4/0

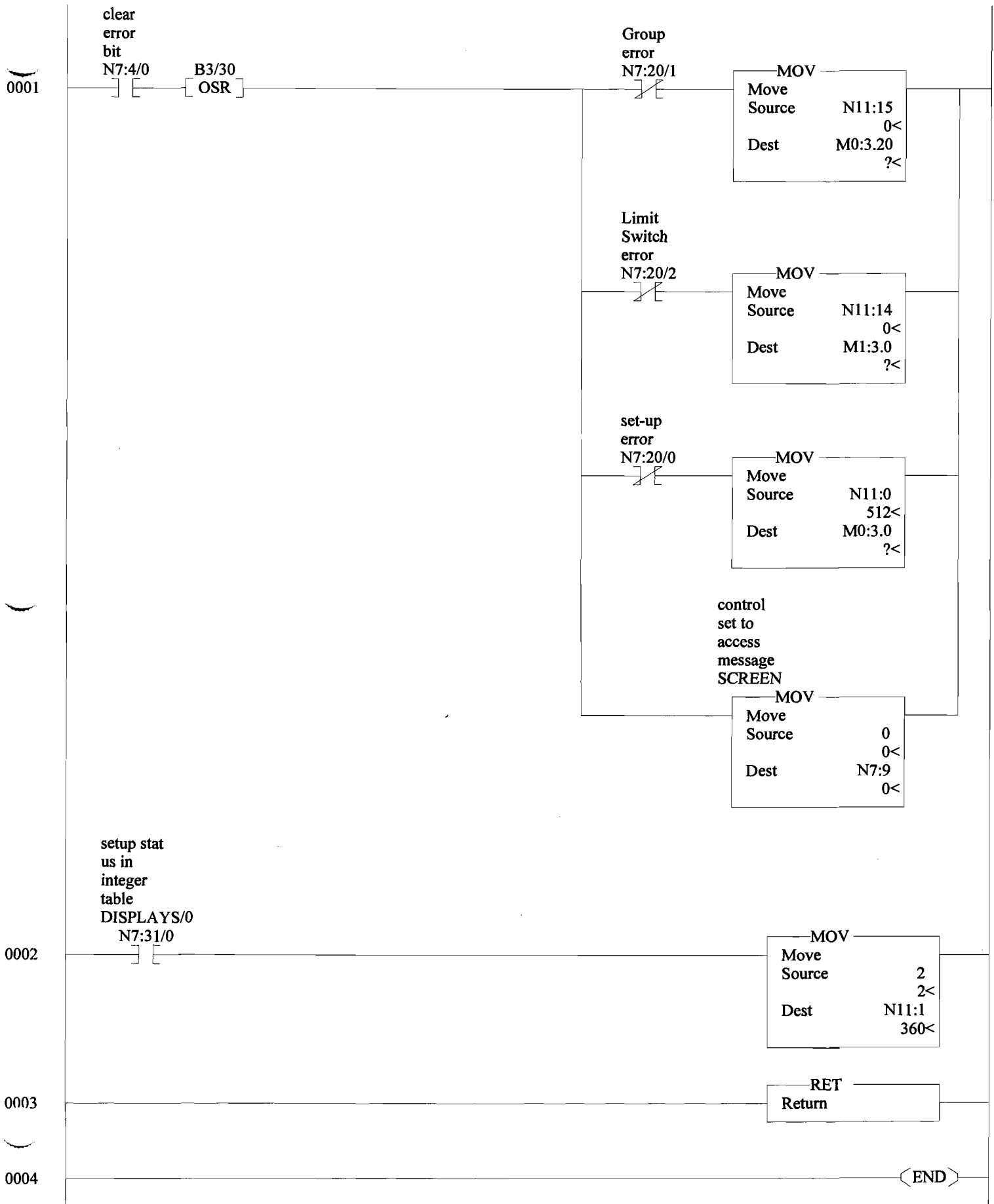
function  
1=edit  
2=copy  
3=load  
PROGRAM

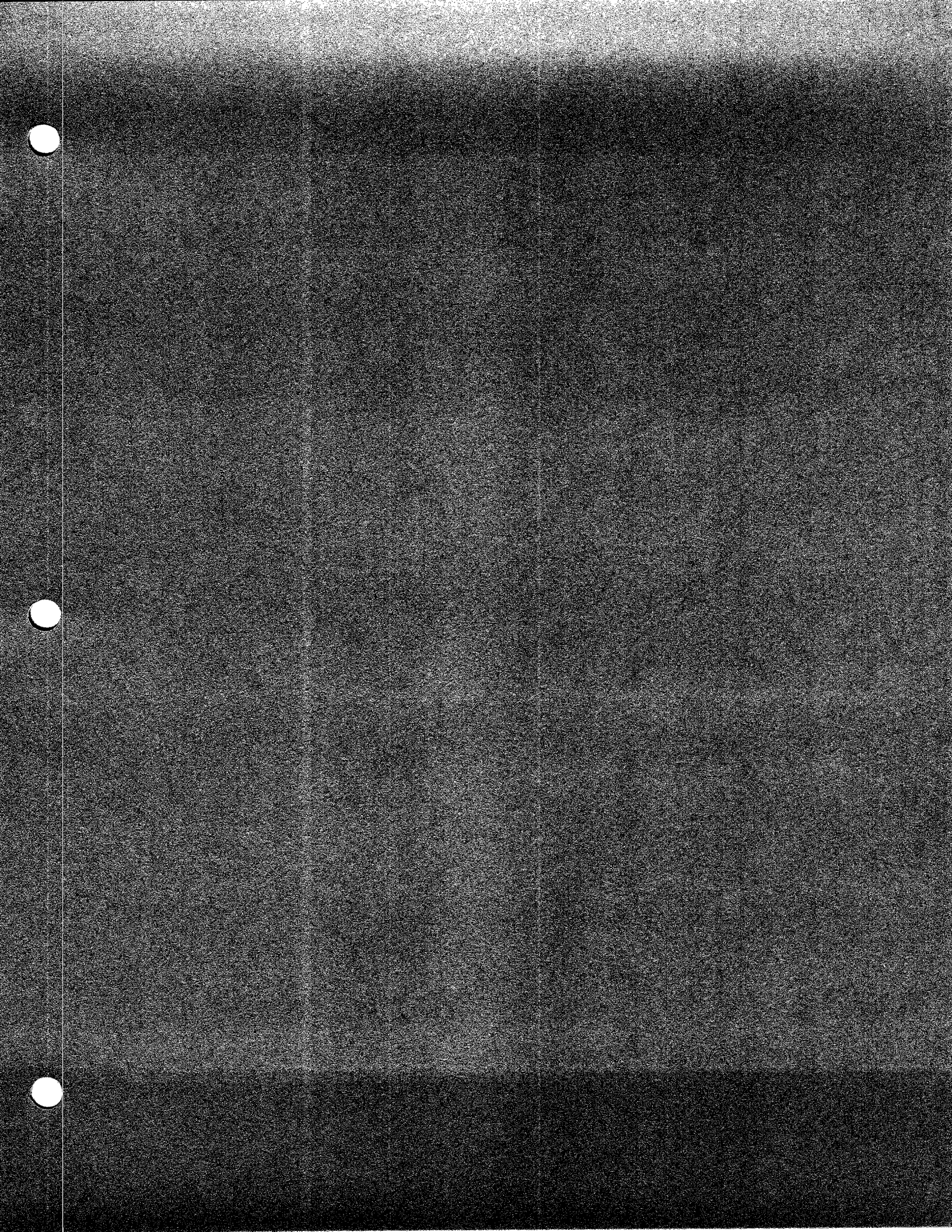
MOV  
Move  
Source 1  
1<  
Dest N12:50  
0<

Limit Swit  
ch transmi  
t bit  
N11:15/15

transmit  
config  
data  
N11:0/15

group data  
transmit  
N11:14/15





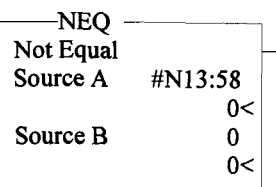
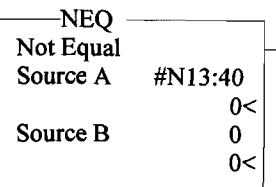
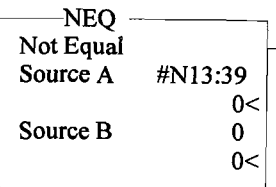
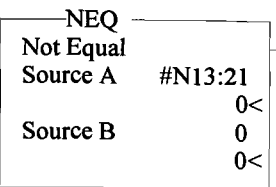
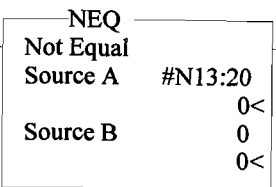
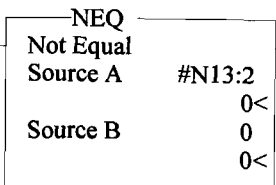
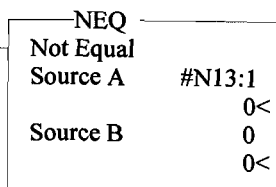
0000

index the  
same as  
last scan

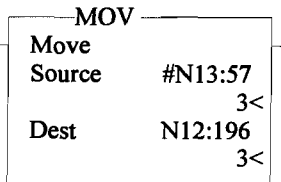
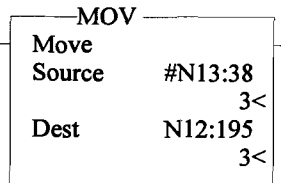
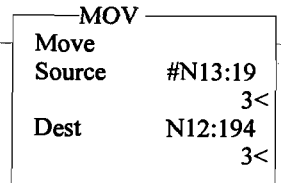
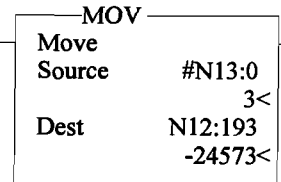
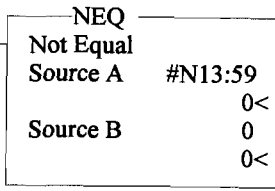
MOV	
Move	
Source	N12:43 380<
Dest	S:24 380<

advances  
used  
bit  
N12:190/0

0001



0002



ANDing  
used bit  
N12:191/0

N12:193/13

N12:193/14

N12:193/15

N12:194/13

N12:194/14

N12:194/15

N12:195/13

N12:195/14

N12:195/15

N12:196/13

N12:196/14

N12:196/15

TIMED/  
PULSED  
used bit  
N12:192/0

0004

N12:193/0    N12:193/1

N12:193/0    N12:193/1

N12:194/0    N12:194/1

N12:194/0    N12:194/1

N12:195/0    N12:195/1

N12:195/0    N12:195/1

N12:196/0    N12:196/1

N12:196/0    N12:196/1

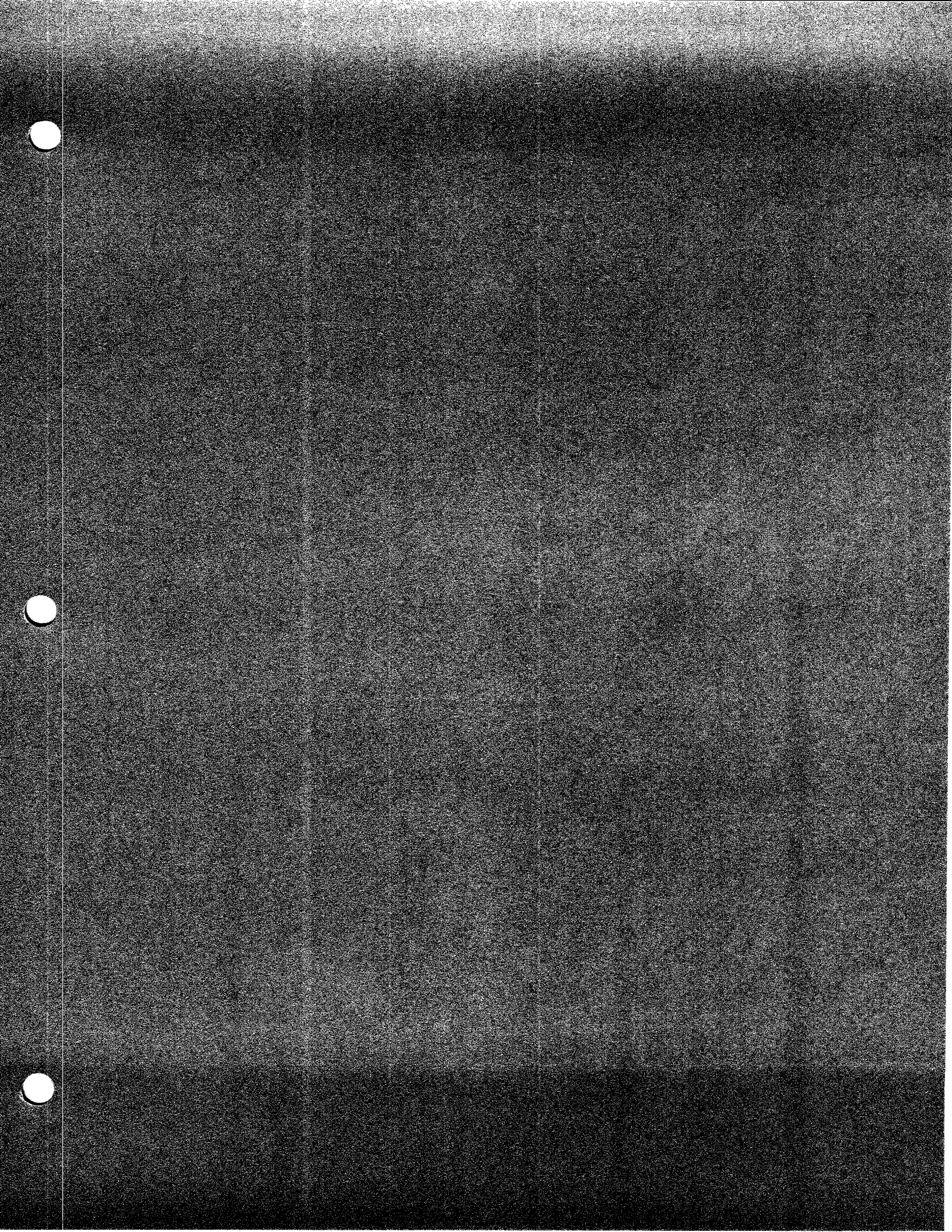
LAD 13 - --- Total Rungs in File = 7

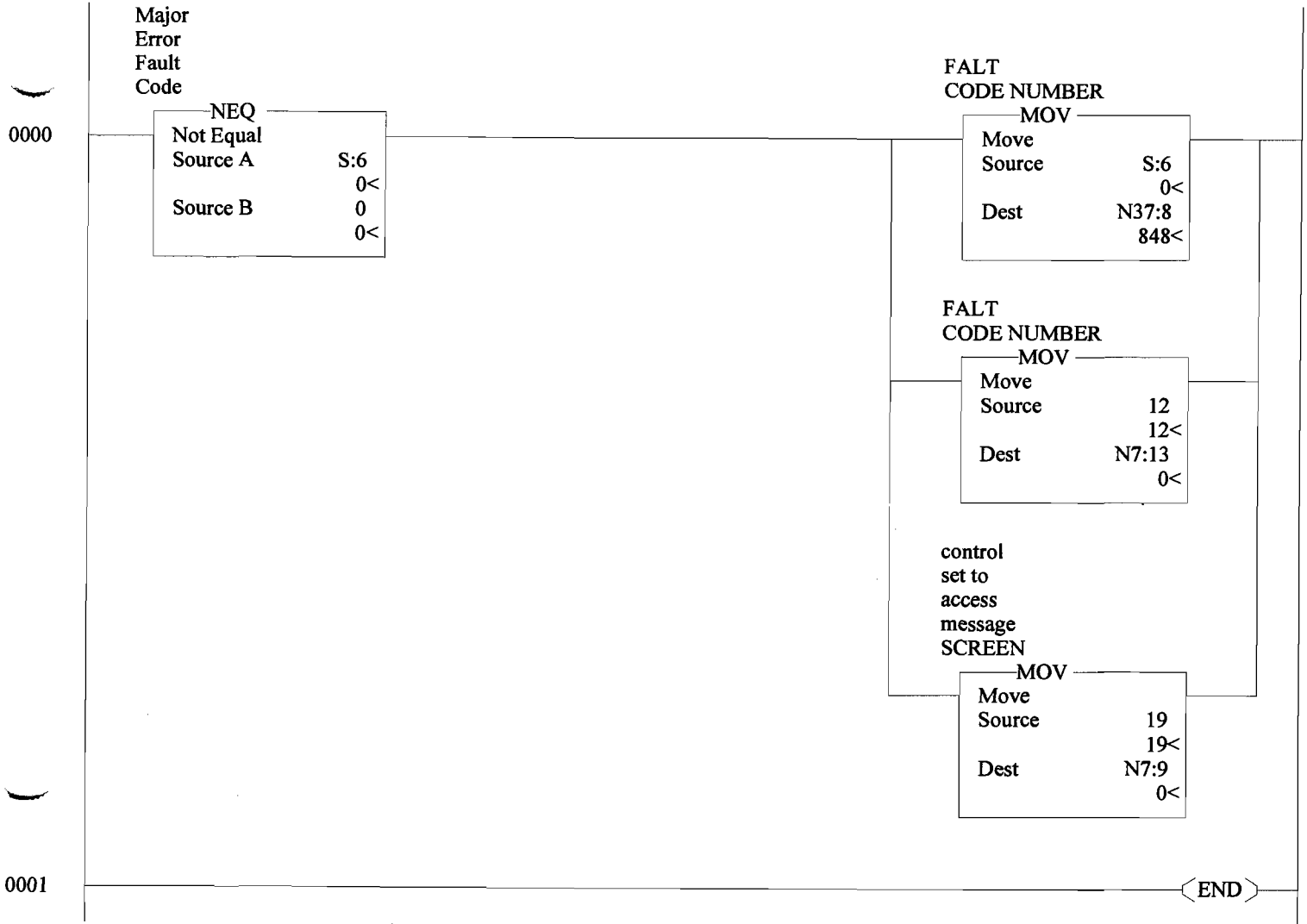
0005

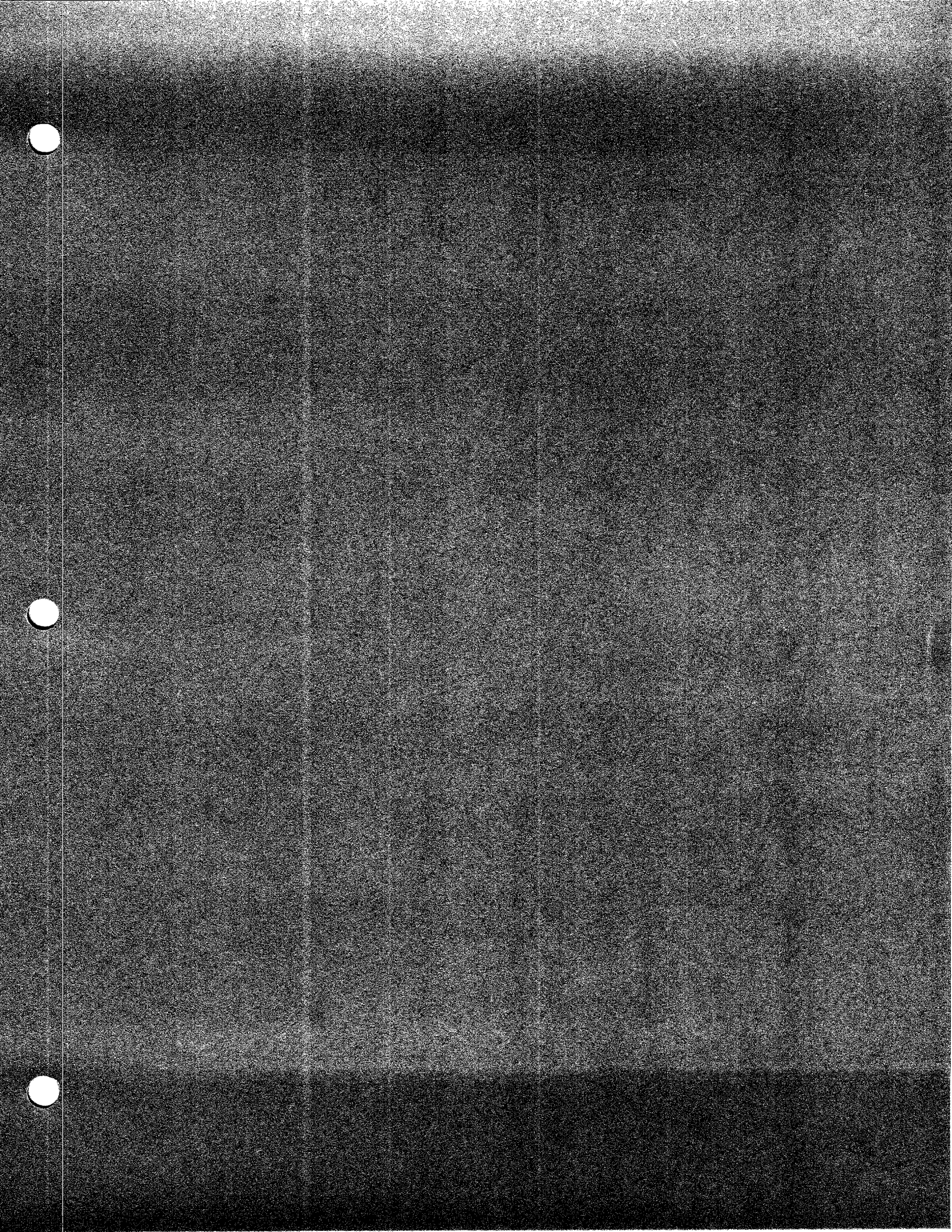
RET  
Return

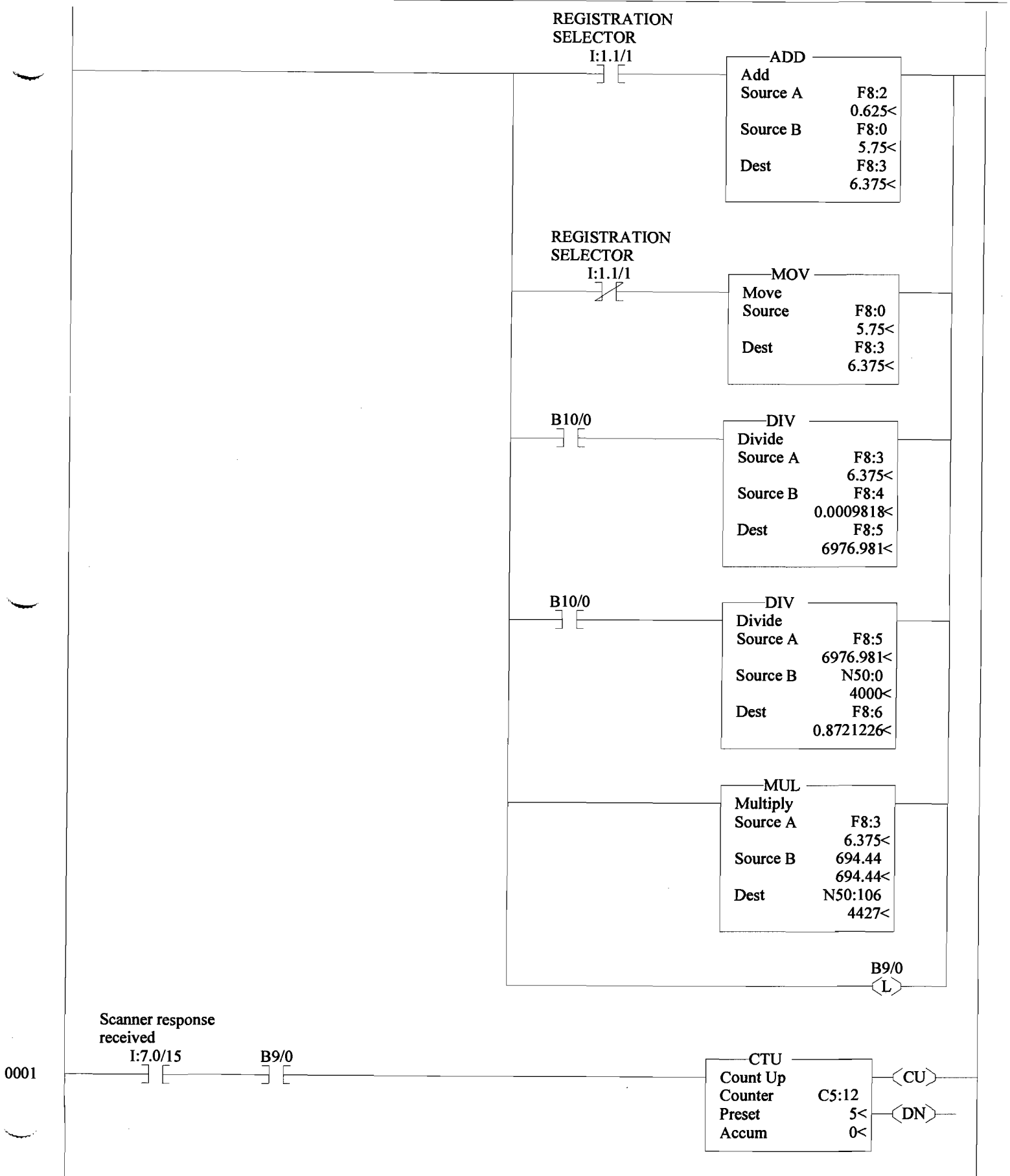
0006

END









0001

Scanner response received

I:7.0/15

B9/0

CTU

Count Up Counter  
Preset  
Accum

C5:12

5<

0<

CU

DN

B9/0

L

