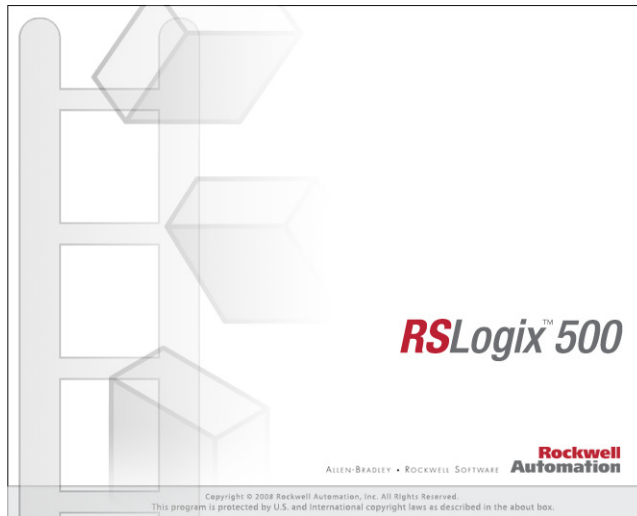


RSLogix Micro Project Report



Processor Information

Processor Type: Bul.1766 MicroLogix 1400 Series B

Processor Name: CE_V3_23

Total Memory Used: 4226 Instruction Words Used - 3229 Data Table Words Used

Total Memory Left: 8208 Instruction Words Left

Program Files: 19

Data Files: 70

Program ID: 7699

I/O Configuration

0	Bul.1766	MicroLogix 1400 Series B
1	1762-IQ16	16-Input 10/30 VDC
2	1762-OB16	16-Output (TRANS-SRC) 10/50 VDC
3	1762-IQ16	16-Input 10/30 VDC
4	1762-OB16	16-Output (TRANS-SRC) 10/50 VDC
5		
6		
7		

Channel Configuration

CHANNEL 0 (SYSTEM) - Driver: DF1 Full Duplex

CHANNEL 0 (SYSTEM) - Driver: DF1 Full Duplex Edit Resource/Owner Timeout: 60
CHANNEL 0 (SYSTEM) - Driver: DF1 Full Duplex Passthru Link ID: 1
CHANNEL 0 (SYSTEM) - Driver: DF1 Full Duplex Write Protected: No
CHANNEL 0 (SYSTEM) - Driver: DF1 Full Duplex Comms Servicing Selection: Yes
CHANNEL 0 (SYSTEM) - Driver: DF1 Full Duplex Message Servicing Selection: Yes
CHANNEL 0 (SYSTEM) - Driver: DF1 Full Duplex 1st AWA Append Character: \d
CHANNEL 0 (SYSTEM) - Driver: DF1 Full Duplex 2nd AWA Append Character: \a

Source ID: 1 (decimal)
Baud: 19200
Parity: NONE
Control Line : No Handshaking
Error Detection: CRC
Embedded Responses: Auto Detect
Duplicate Packet Detect: Yes
ACK Timeout(x20 ms): 50
NAK Retries: 3
ENQ Retries: 3

CHANNEL 1 (SYSTEM) - Driver: Ethernet

CHANNEL 1 (SYSTEM) - Driver: Ethernet Edit Resource/Owner Timeout: 60
CHANNEL 1 (SYSTEM) - Driver: Ethernet Passthru Link ID: 1
CHANNEL 1 (SYSTEM) - Driver: Ethernet Write Protected: No
CHANNEL 1 (SYSTEM) - Driver: Ethernet Comms Servicing Selection: Yes
CHANNEL 1 (SYSTEM) - Driver: Ethernet Message Servicing Selection: Yes

Hardware Address: 00:00:BC:38:E8:F2
IP Address: 192.168.68.180
Subnet Mask: 255.255.255.0
Gateway Address: 0.0.0.0
Msg Connection Timeout (x 1mS): 15000
Msg Reply Timeout (x mS): 3000
Inactivity Timeout (x Min): 30
Bootp Enable: No
Dhcp Enable: No
SMTP Enable: No
SNMP Enable: Yes
HTTP Enable: Yes
Auto Negotiate Enable: Yes
DNP3 over IP Enable: No
Modbus TCP Enable: No
Disable EtherNet/IP Incoming Connection: No
Disable Duplicate IP Address Detection: No
Port Speed Enable: 10/100 Mbps Full Duplex/Half Duplex
Contact:
Location:

CHANNEL 2 (SYSTEM) - Driver: DF1 Full Duplex

CHANNEL 2 (SYSTEM) - Driver: DF1 Full Duplex Edit Resource/Owner Timeout: 60
CHANNEL 2 (SYSTEM) - Driver: DF1 Full Duplex Passthru Link ID: 1
CHANNEL 2 (SYSTEM) - Driver: DF1 Full Duplex Write Protected: No
CHANNEL 2 (SYSTEM) - Driver: DF1 Full Duplex Comms Servicing Selection: Yes
CHANNEL 2 (SYSTEM) - Driver: DF1 Full Duplex Message Servicing Selection: Yes
CHANNEL 2 (SYSTEM) - Driver: DF1 Full Duplex 1st AWA Append Character: \d
CHANNEL 2 (SYSTEM) - Driver: DF1 Full Duplex 2nd AWA Append Character: \a

Source ID: 1 (decimal)
Baud: 19200
Parity: NONE
Control Line : No Handshaking
Error Detection: CRC
Embedded Responses: Auto Detect
Duplicate Packet Detect: Yes
ACK Timeout(x20 ms): 50
NAK Retries: 3
ENQ Retries: 3

Program File List

Name	Number	Type	Rungs	Debug	Bytes
[SYSTEM]	0	SYS	0	No	0
	1	SYS	0	No	0
MAIN	2	LADDER	17	No	601
IO	3	LADDER	46	No	2166
HMI	4	LADDER	56	No	3696
RECIPE_SET	5	LADDER	20	No	1365
MANUAL	6	LADDER	103	No	3461
SEALER	8	LADDER	25	No	1058
PRODATA	9	LADDER	77	No	3333
CE_MAIN	10	LADDER	57	No	1731
CE_CYCLE	11	LADDER	97	No	5753
CE_RECIPE	12	LADDER	7	No	893
CE_OPTIONS	13	LADDER	42	No	1187
CE_SERVO	14	LADDER	64	No	3197
LT/NT_2	18	LADDER	43	No	1691
ERECT GLUE	20	LADDER	28	No	874
SEALR GLUE	21	LADDER	13	No	304
ALARMS	30	LADDER	79	No	4067
ERROR	50	LADDER	5	No	132

Data File List

Name	Number	Type	Scope	Debug	Words	Elements	Last
OUTPUT	0	O	Global	No	24	8	O:7
INPUT	1	I	Global	No	30	10	I:9
STATUS	2	S	Global	No	0	66	S:65
BINARY	3	B	Global	No	11	11	B3:10
TIMER	4	T	Global	No	3	1	T4:0
COUNTER	5	C	Global	No	3	1	C5:0
CONTROL	6	R	Global	No	48	16	R6:15
INTEGER	7	N	Global	No	1	1	N7:0
FLOAT	8	F	Global	No	4	2	F8:1
EXT EQUIP	9	ST	Global	No	42	1	ST9:0
MAIN	10	B	Global	No	3	3	B10:2
MAIN	11	N	Global	No	11	11	N11:10
MAIN	12	T	Global	No	33	11	T12:10
HMI_B	20	B	Global	No	11	11	B20:10
HMI_I	21	N	Global	No	40	40	N21:39
HMI_T	22	T	Global	No	45	15	T22:14
HMI_ST	23	ST	Global	No	210	5	ST23:4
HMI_I	24	N	Global	No	11	11	N24:10
HMI_F	25	F	Global	No	4	2	F25:1
HMI	29	ST	Global	No	504	12	ST29:11
MANUAL_B	30	B	Global	No	15	15	B30:14
SEALER_B	40	B	Global	No	5	5	B40:4
SEALER_I	41	N	Global	No	1	1	N41:0
SEALER_T	42	T	Global	No	51	17	T42:16
PRODATA_B	45	B	Global	No	6	6	B45:5
PRODATA_I	46	N	Global	No	211	211	N46:210
PRODATA_T	47	T	Global	No	63	21	T47:20
PRODATA_C	48	C	Global	No	33	11	C48:10
PRODATA_F	49	F	Global	No	24	12	F49:11
CE_MAIN_B	50	B	Global	No	15	15	B50:14
CE_MAIN_I	51	N	Global	No	2	2	N51:1
CE_CYCLE_B	55	B	Global	No	16	16	B55:15
CE_CYCLE_T	57	T	Global	No	150	50	T57:49
CE_CYCLE_C	58	C	Global	No	12	4	C58:3
CE_CYCLE_F	59	F	Global	No	6	3	F59:2
CE_RECIP_B	60	B	Global	No	3	3	B60:2
CE_RECIP_I	61	N	Global	No	3	3	N61:2
CE RECIPE	63	F	Global	No	120	60	F63:59
CE_RECIP_F	64	F	Global	No	80	40	F64:39
CE_OPT_B	65	B	Global	No	9	9	B65:8
CE_OPT_I	66	N	Global	No	1	1	N66:0
CE_OPT_T	67	T	Global	No	30	10	T67:9
CE_OPT_C	68	C	Global	No	21	7	C68:6
CE_SERVO_B	70	B	Global	No	11	11	B70:10
CE_SERVO_I	71	N	Global	No	5	5	N71:4
CE_SERVO_T	72	T	Global	No	36	12	T72:11
CE_SERVO_F	74	F	Global	No	60	30	F74:29
TAPE_FLT_B	75	B	Global	No	6	6	B75:5
MCRI ROBOT	80	B	Global	No	16	16	B80:15
MCRI ROBOT	81	T	Global	No	15	5	T81:4
MCRI ROBOT	83	N	Global	No	1	1	N83:0
LT/NT_2	90	B	Global	No	8	8	B90:7
LT/NT_2	91	N	Global	No	20	20	N91:19
LT/NT_2	92	T	Global	No	39	13	T92:12
EREC_GLUE	100	B	Global	No	8	8	B100:7
EREC_GLUE	102	T	Global	No	60	20	T102:19
SEALR GLUE	105	B	Global	No	4	4	B105:3
SEALR GLUE	107	T	Global	No	60	20	T107:19
ALARMS_B	150	B	Global	No	22	22	B150:21
ALARMS_T	152	T	Global	No	228	76	T152:75
ALARMS_C	153	C	Global	No	30	10	C153:9
AXIS DATA	200	MG	Global	No	275	11	MG200:10
AXIS DATA	201	RIX	Global	No	275	11	RIX201:10
AXIS DATA	204	L	Global	No	2	1	L204:0
ASSBLY IN	208	L	Global	No	36	18	L208:17

Data File List

Name	Number	Type	Scope	Debug	Words	Elements	Last
ASSBLY IN	209	F	Global	No	16	8	F209:7
ASSBLY OUT	210	L	Global	No	46	23	L210:22
ASSBLY OUT	211	F	Global	No	30	15	F211:14
ERROR_I	251	N	Global	No	2	2	N251:1
ERROR_C	254	C	Global	No	3	1	C254:0

Main - Machine System Control

Program: 2EZ Family
Version: 3.3
Date: 9/30/14
Programmer: T. Biddle/A.Henry/T.Bogard

Notes:

This program is for the 2EZ with all options included, you can select which options are in use by selectivley turning them on ond off at the HMI or inside the program in CE Main.

Currently this program works with 2EZ and 2CE families including the Ergo Line.

This program follows the data structure convention of Program / Data File Allocation Table Version 3.3

Always off
Bit

ALWAYS_OFF

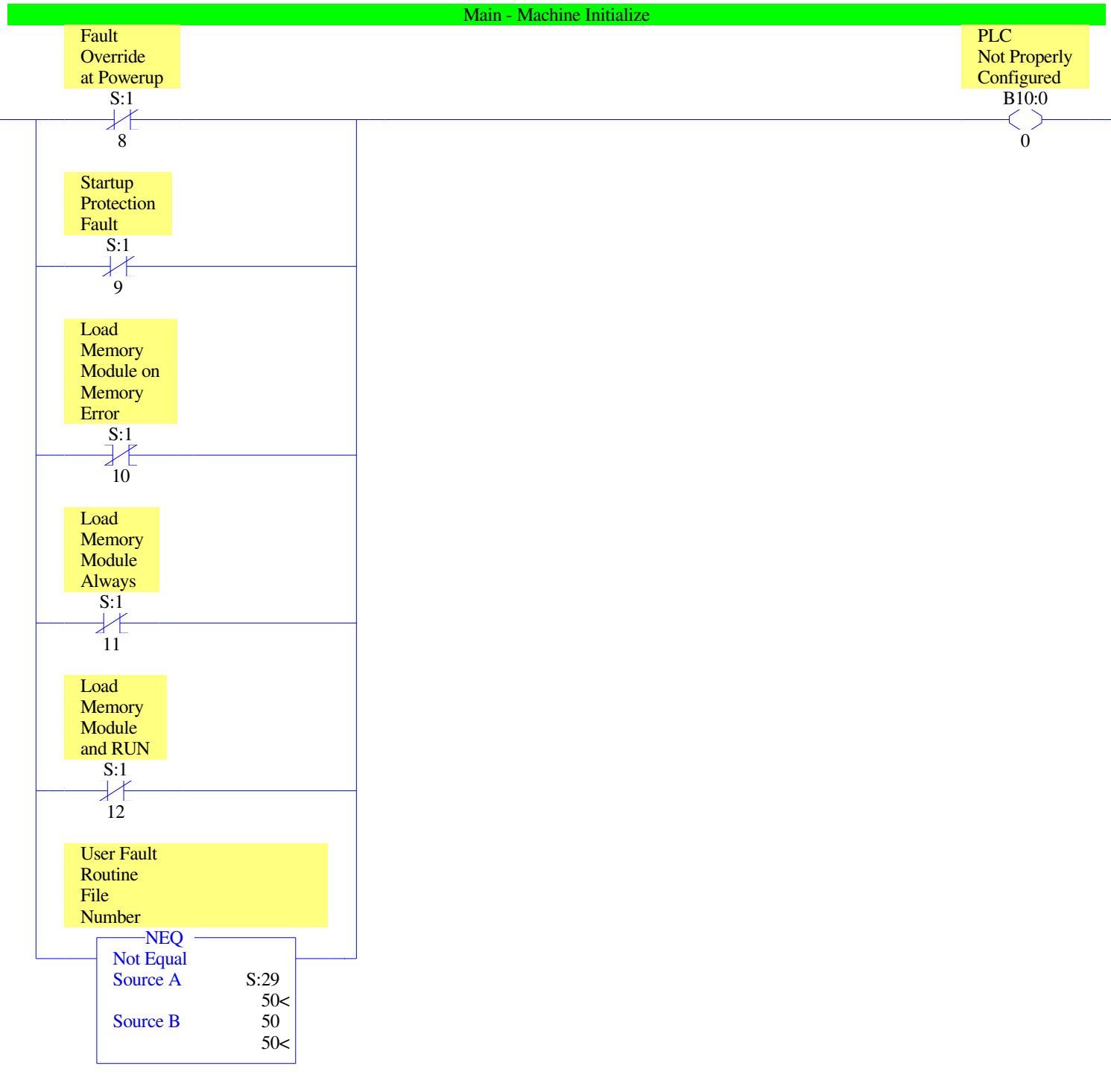
B3:0

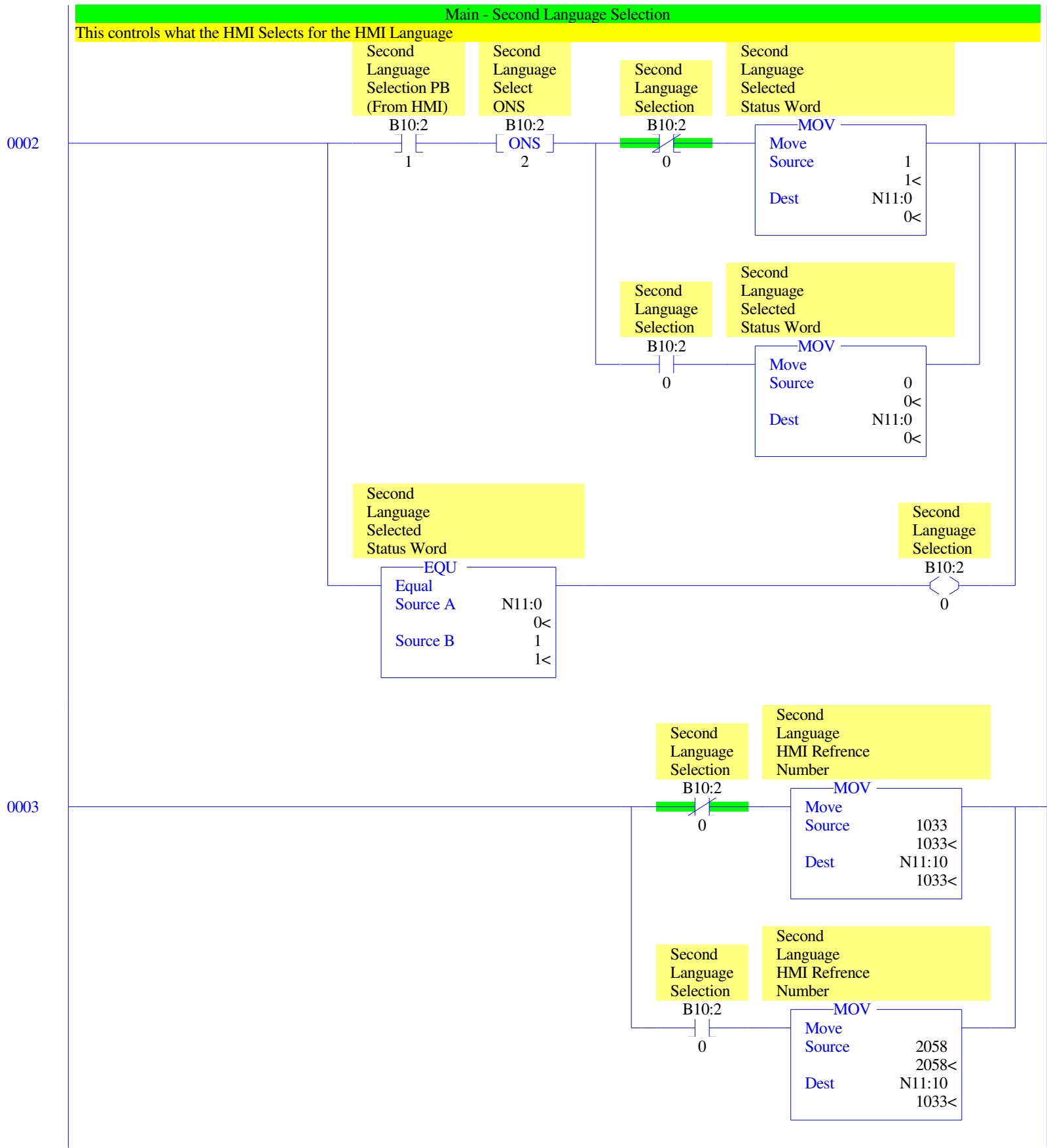
U

0

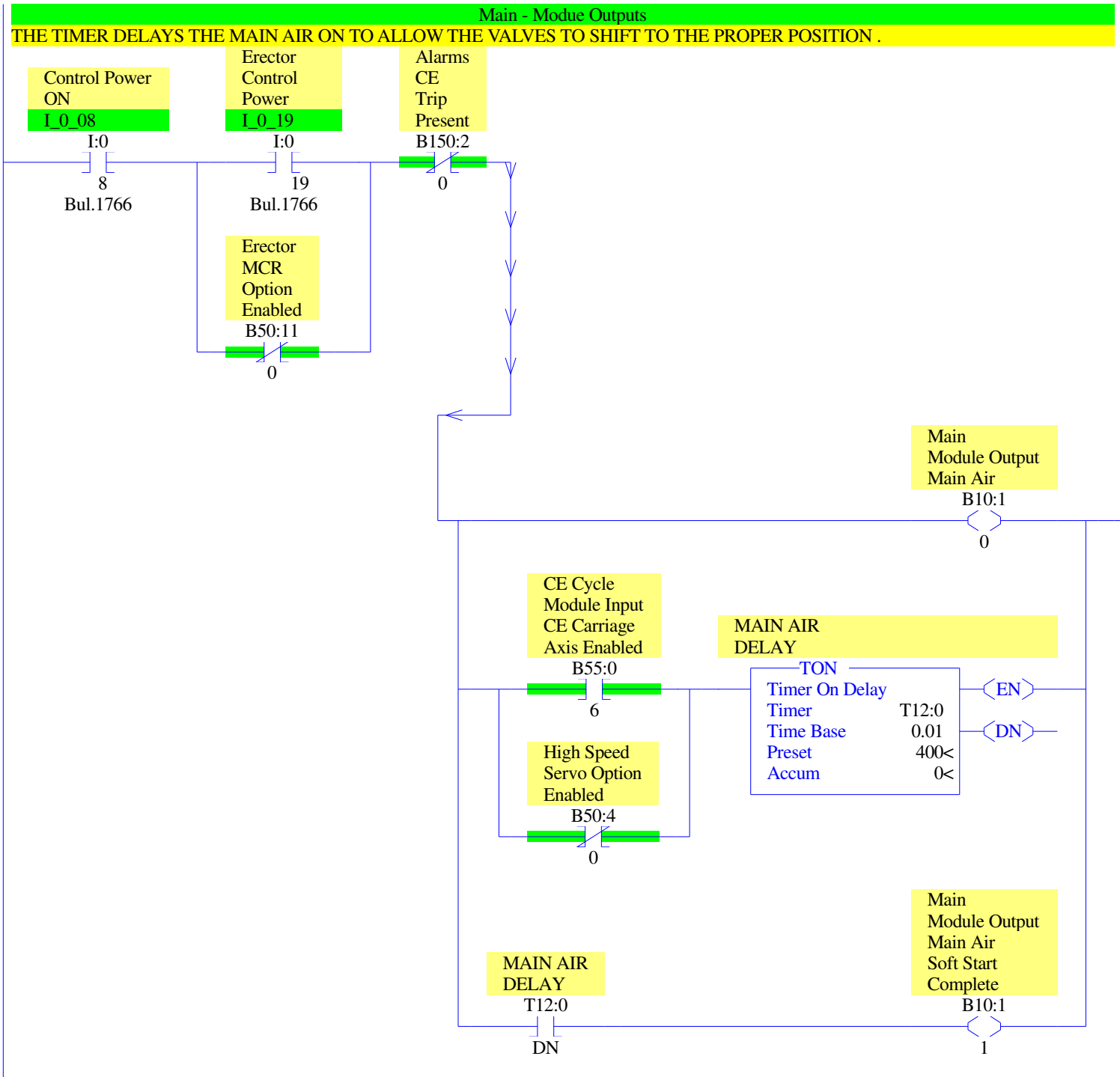
0000

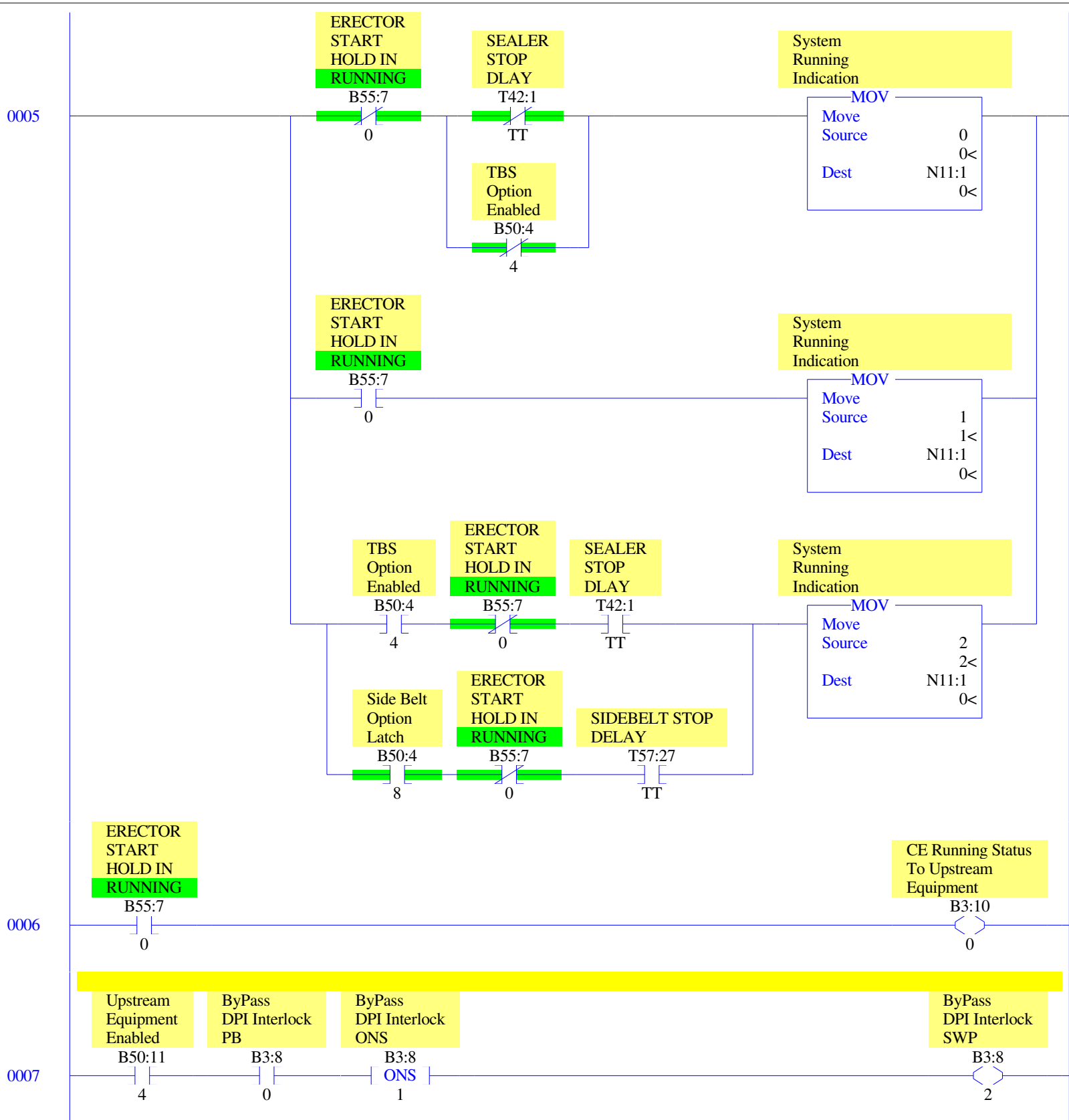
0001

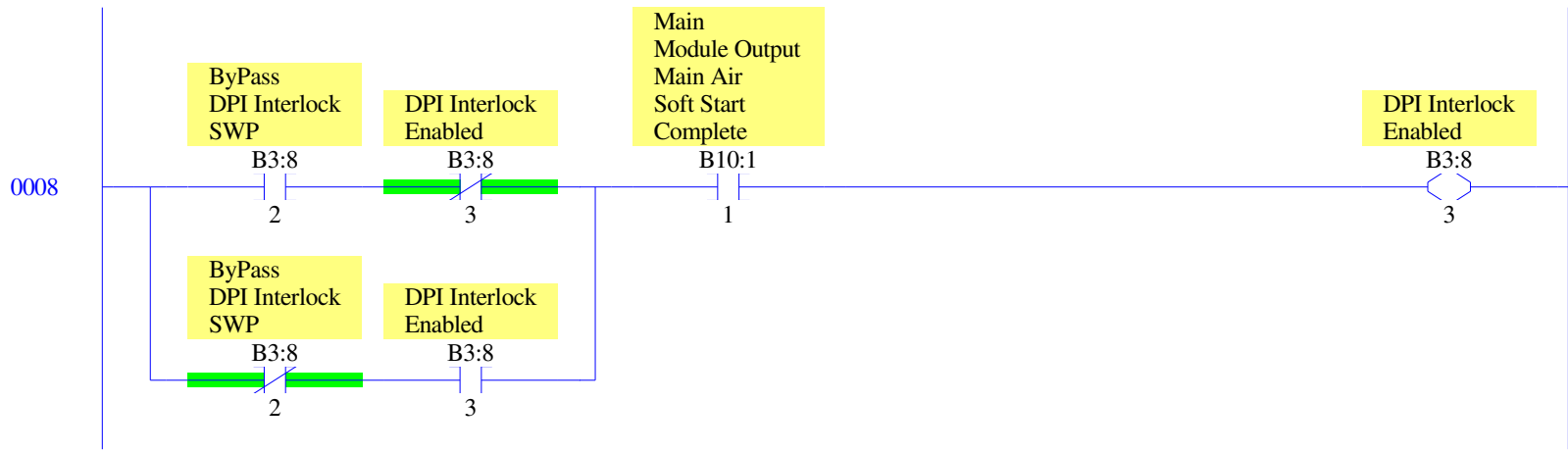




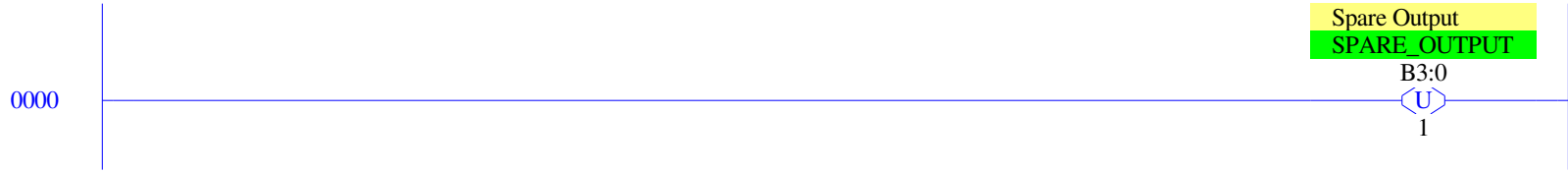
0004









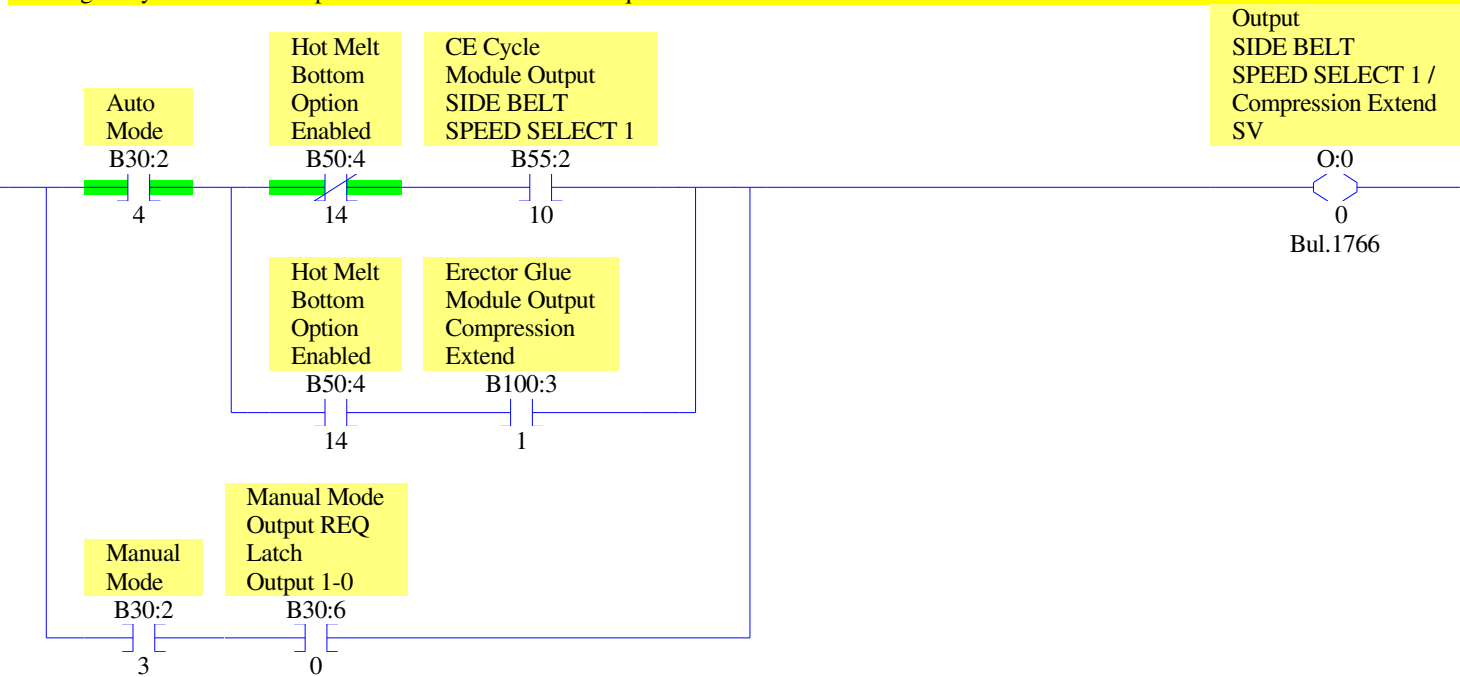


IO - Output Control

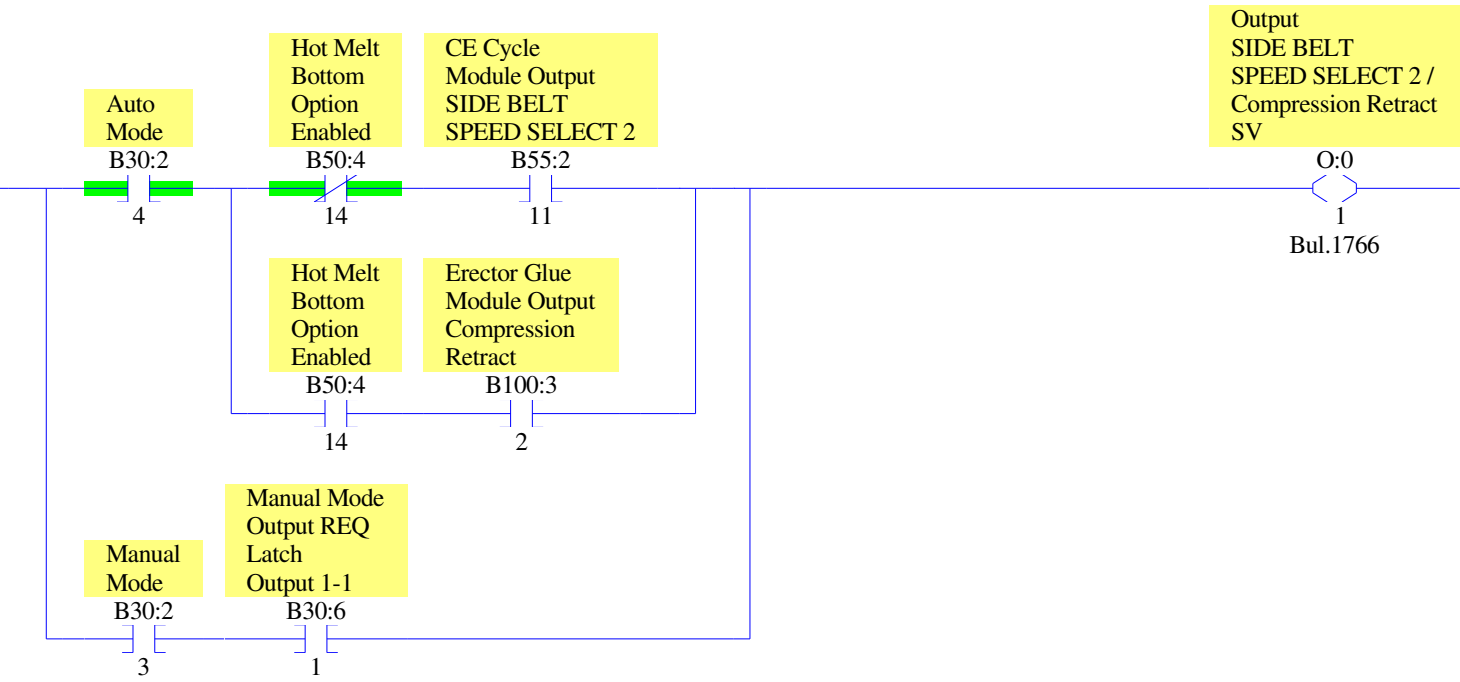
Leave the Physical Outputs in the proper order

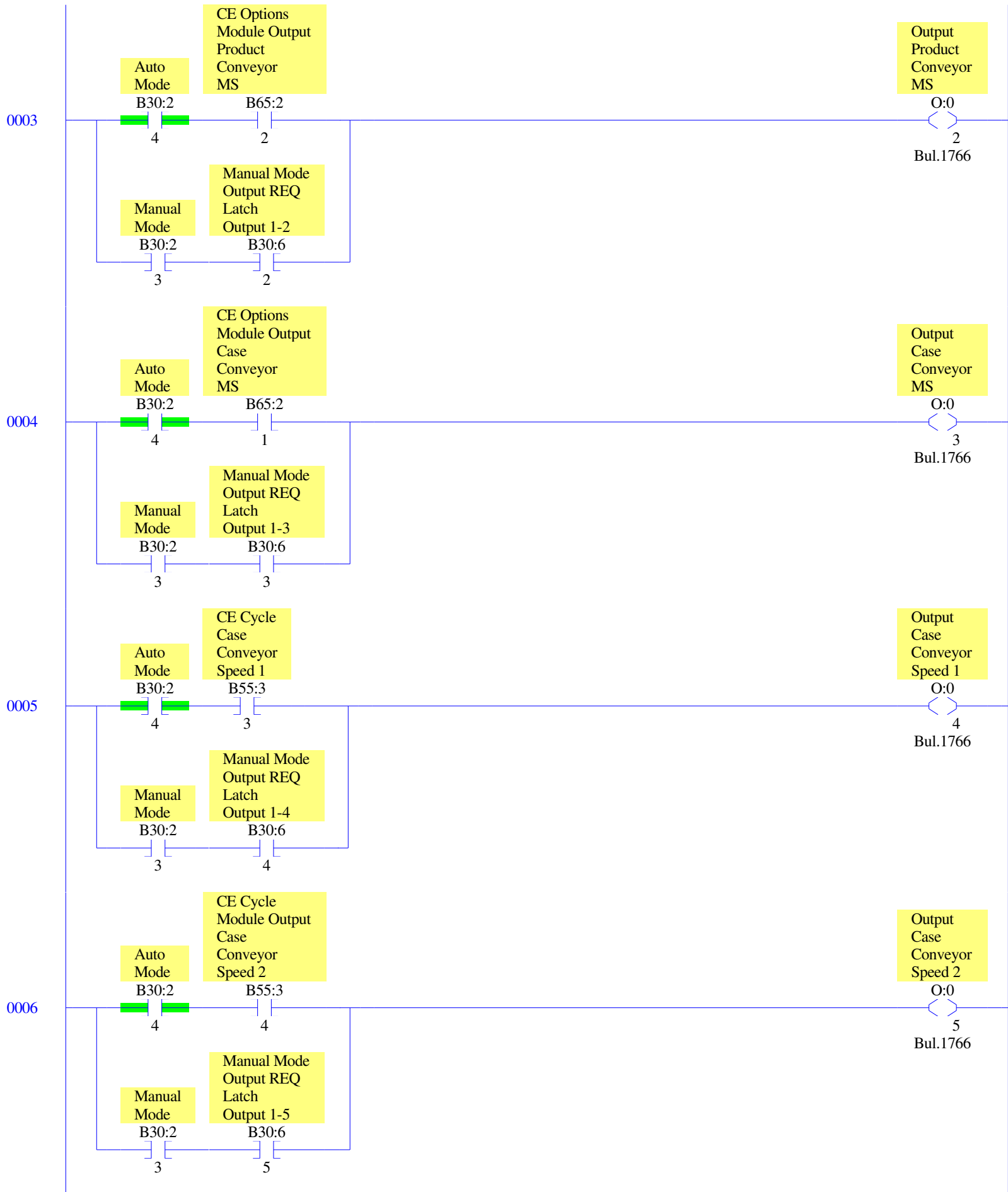
- Change only the Module Output that fits the machines IO requirement.

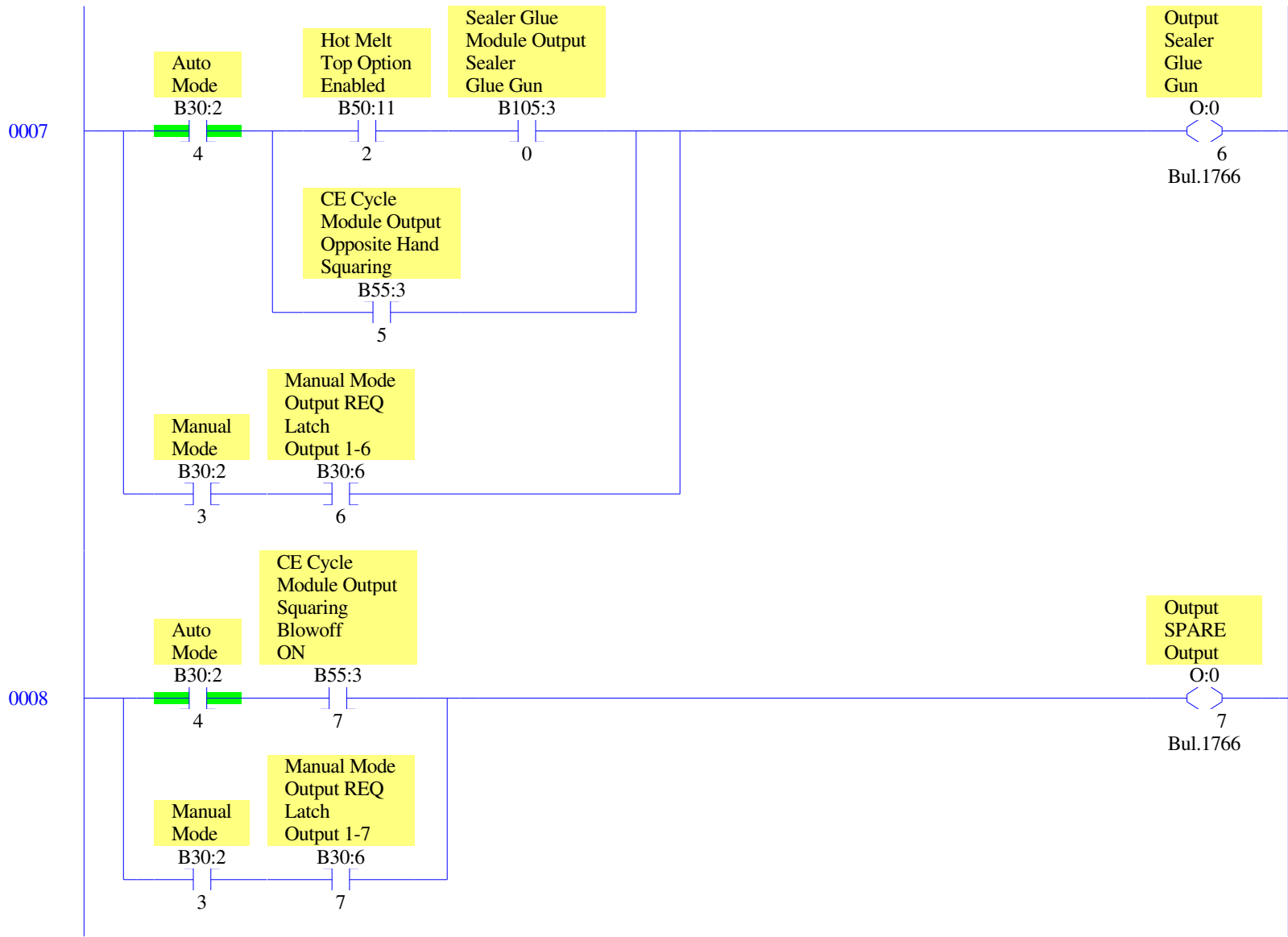
0001



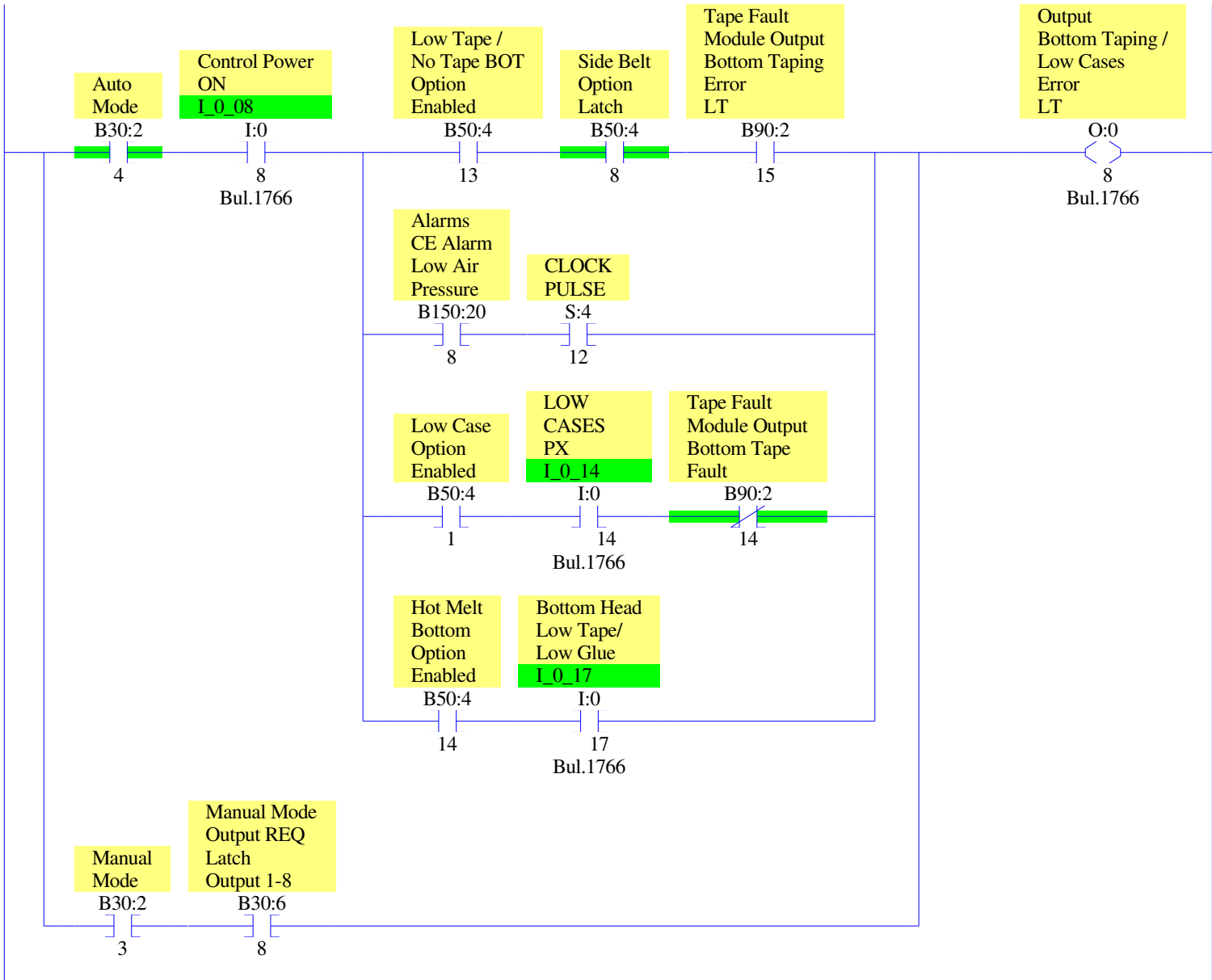
0002

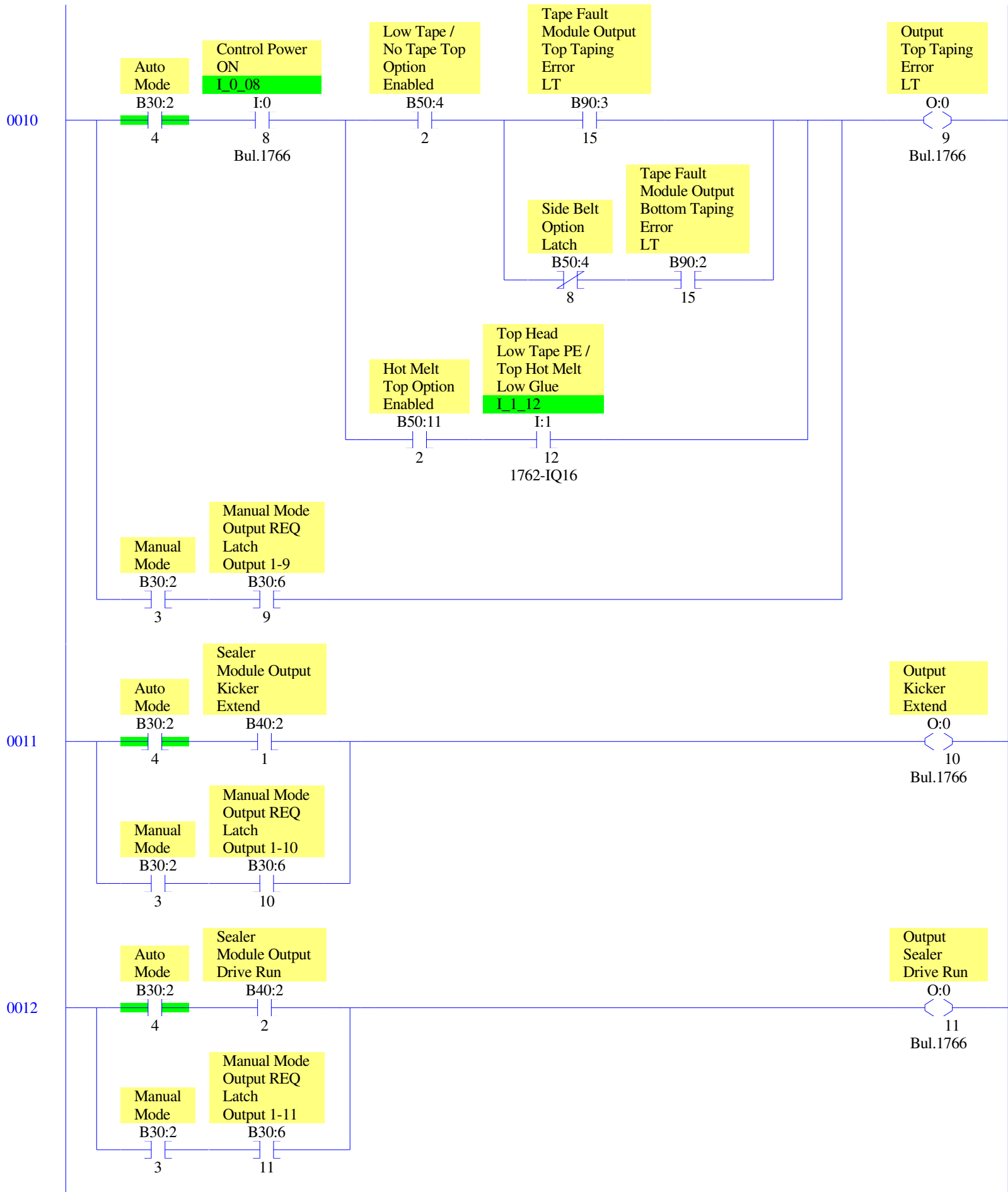


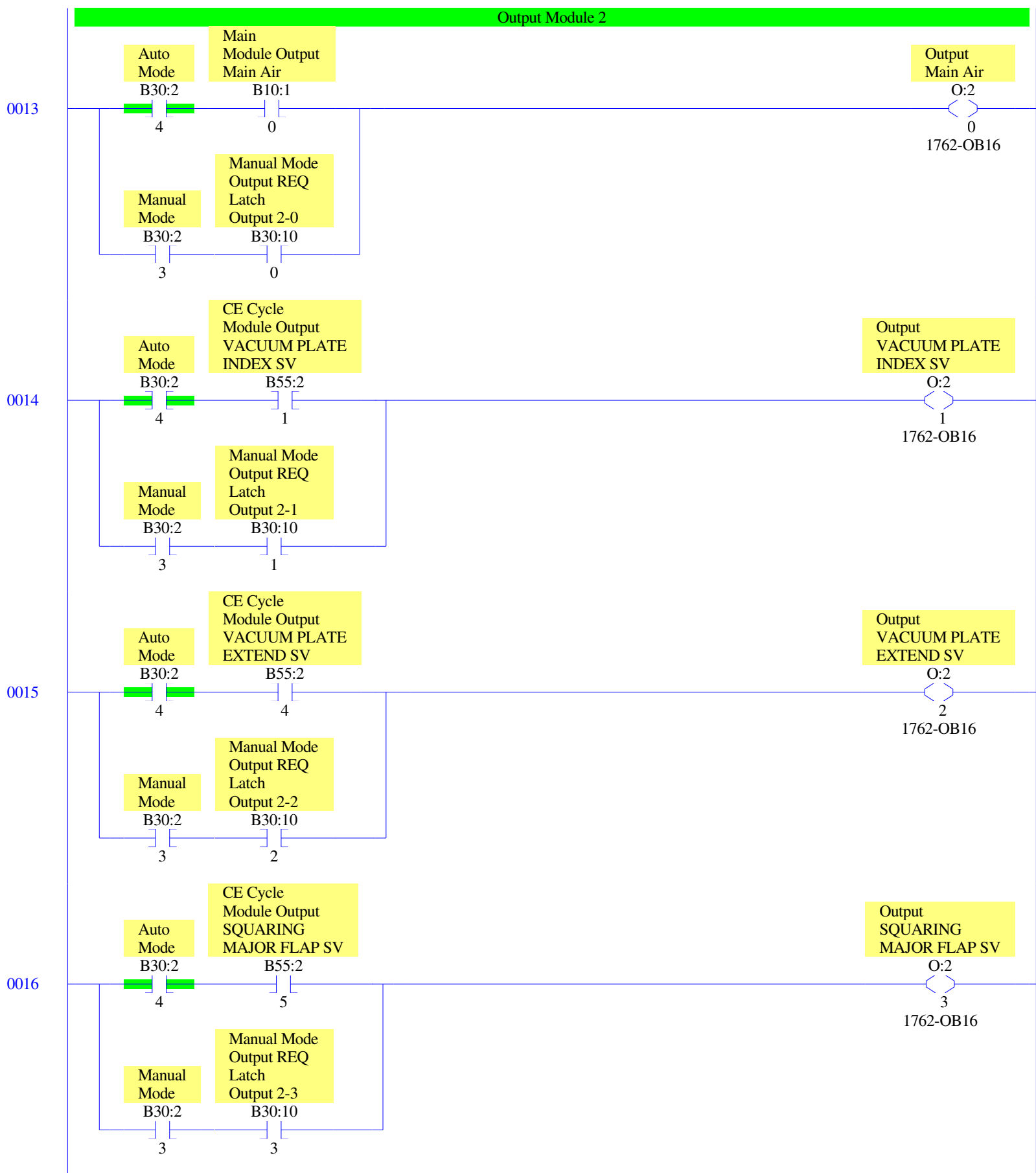


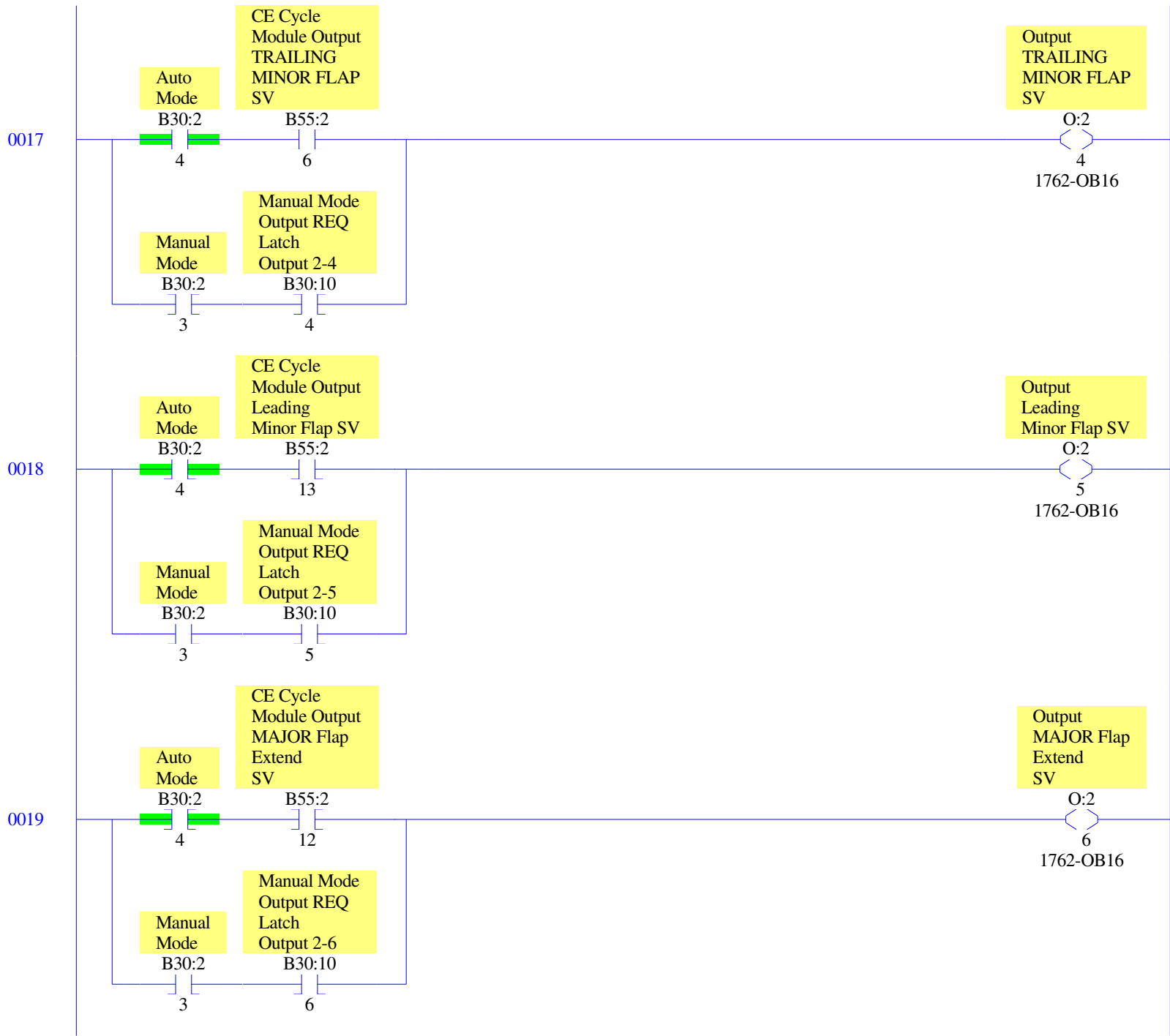


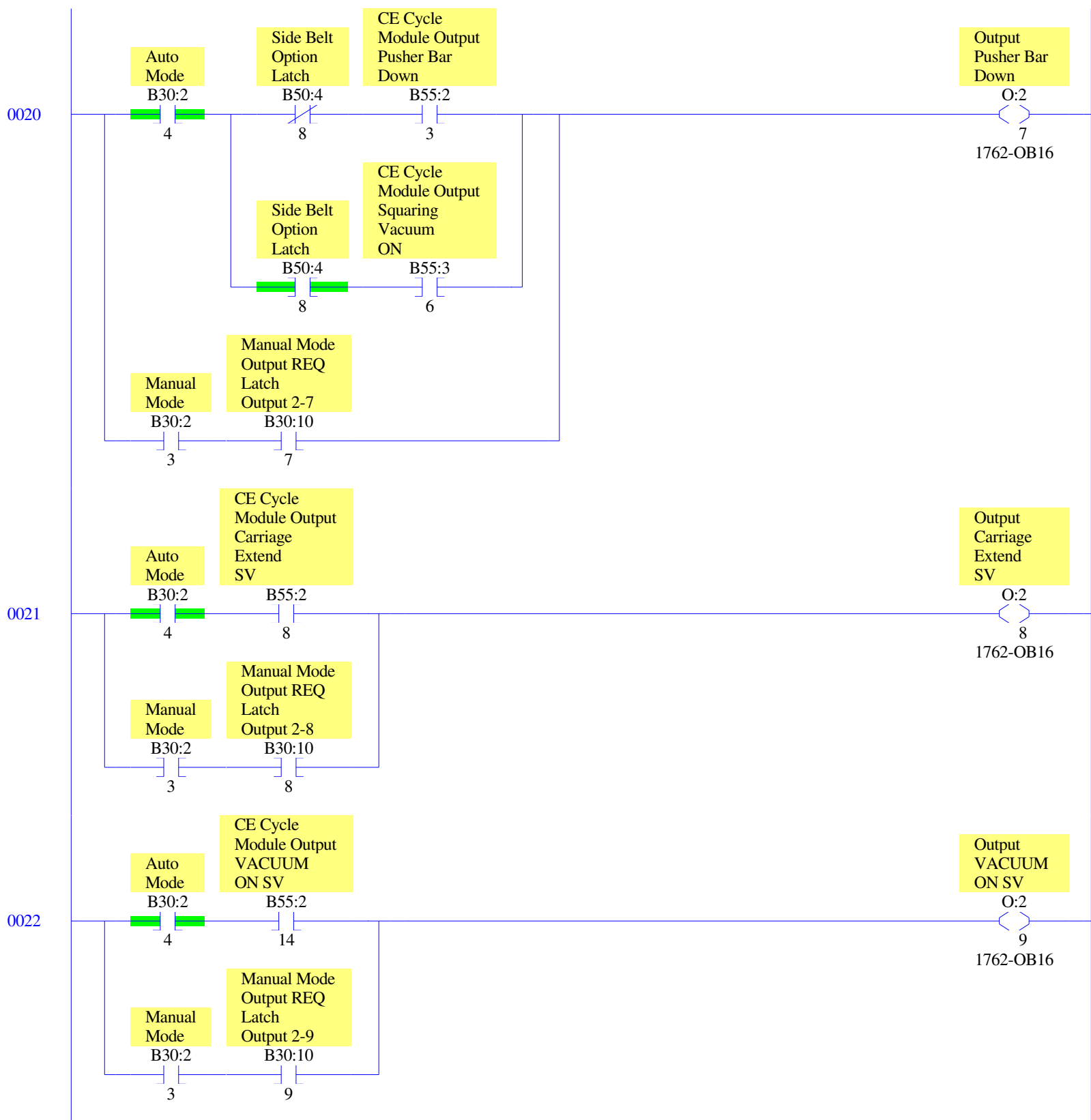
0009

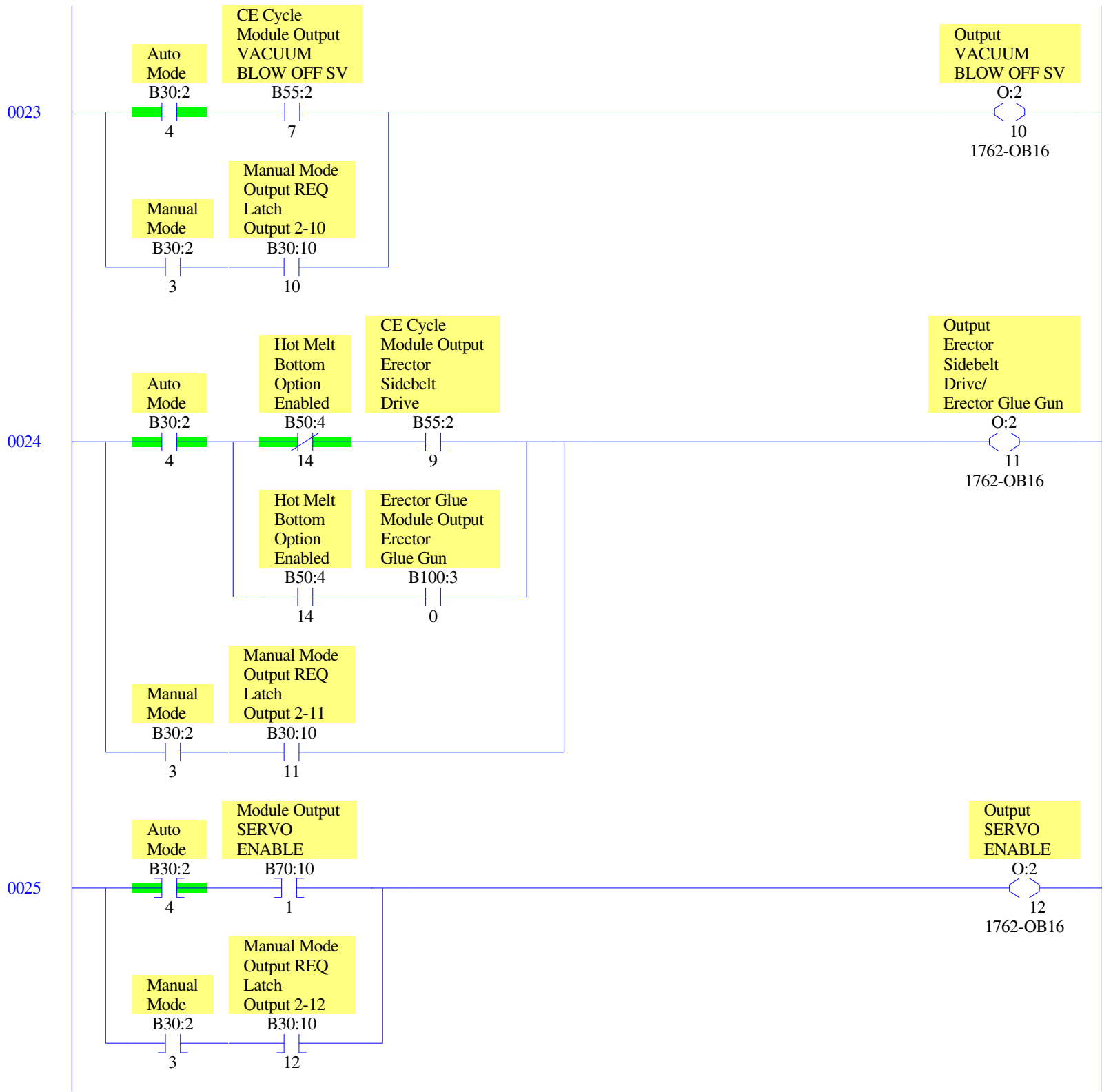


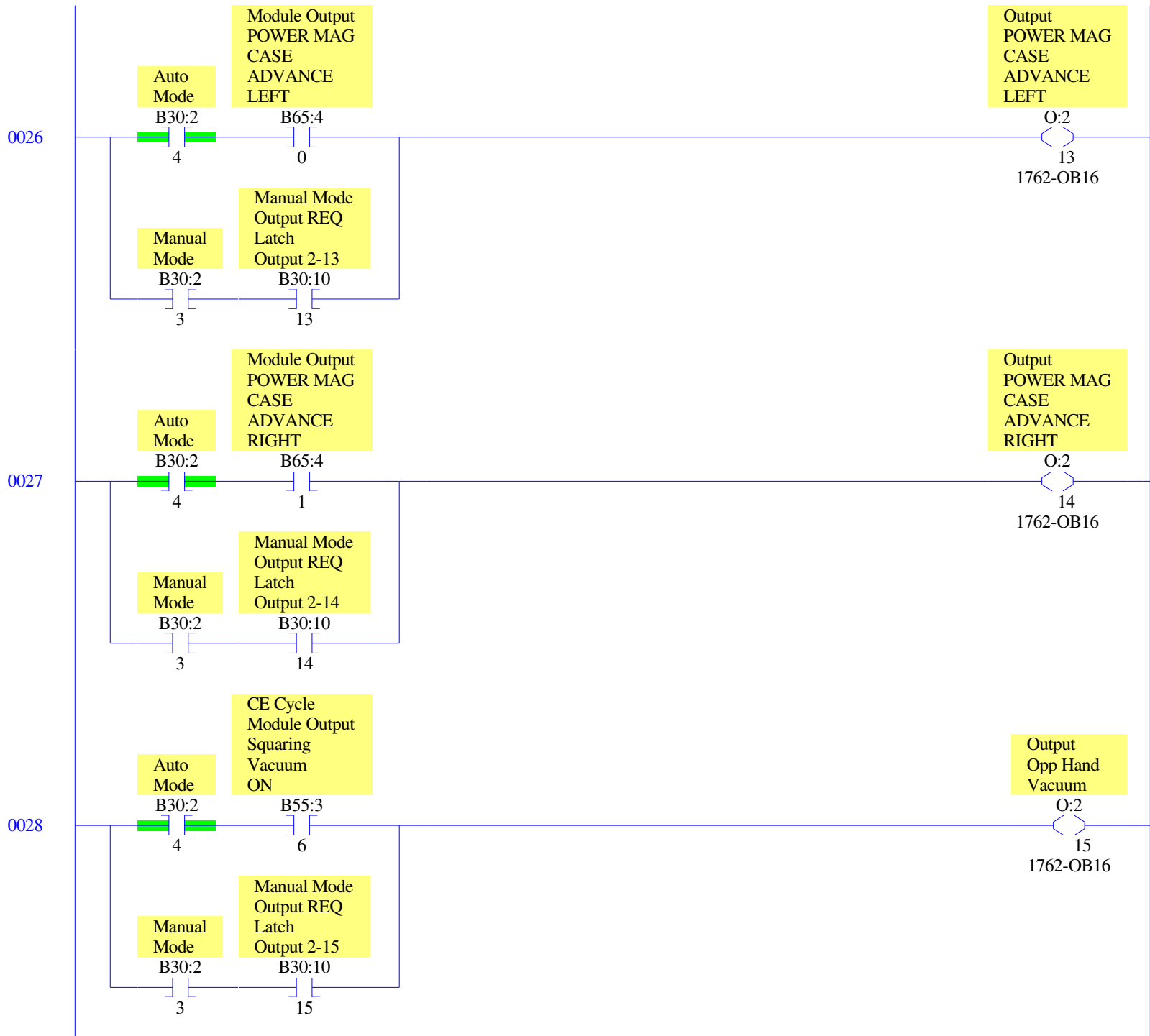


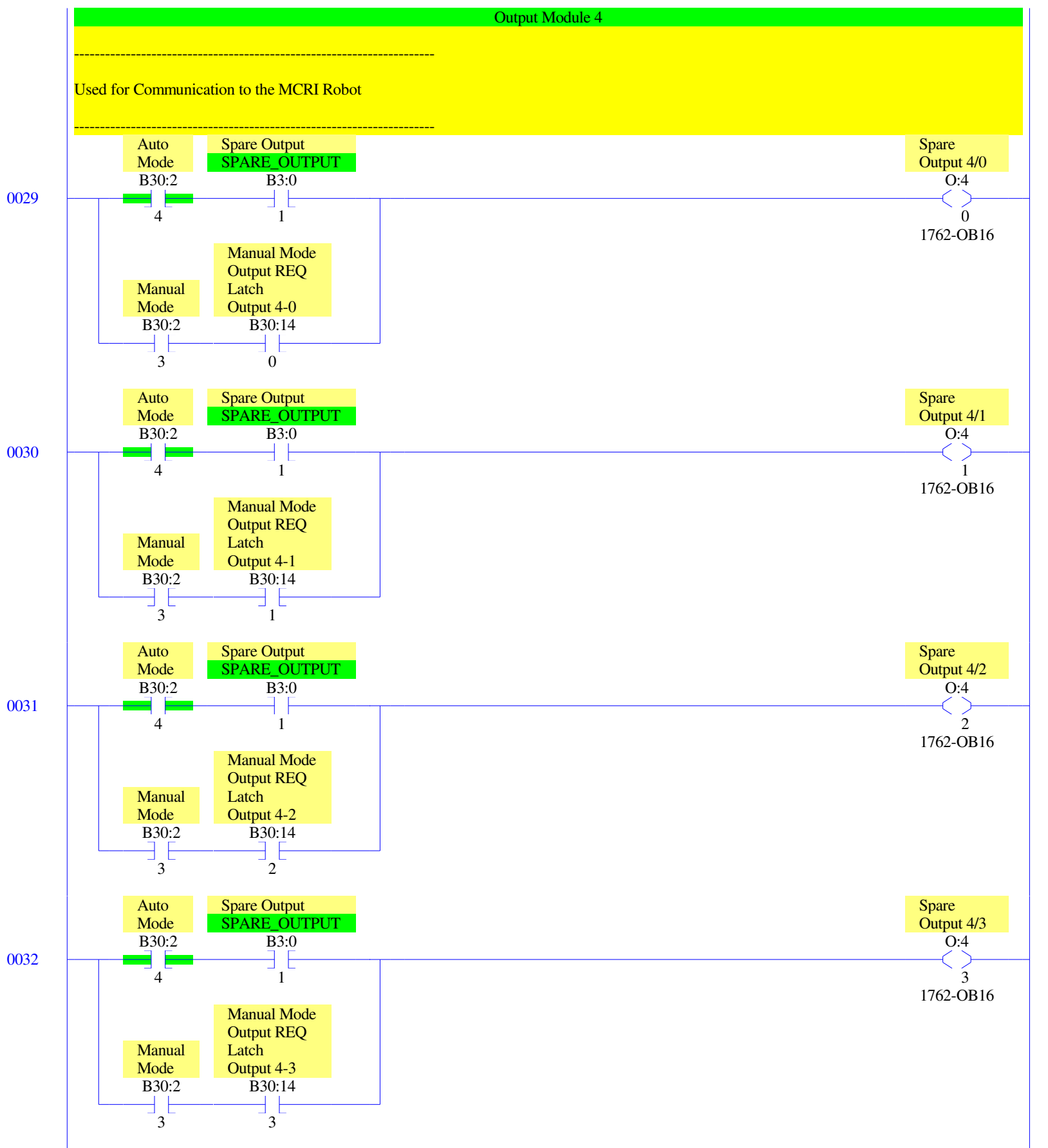


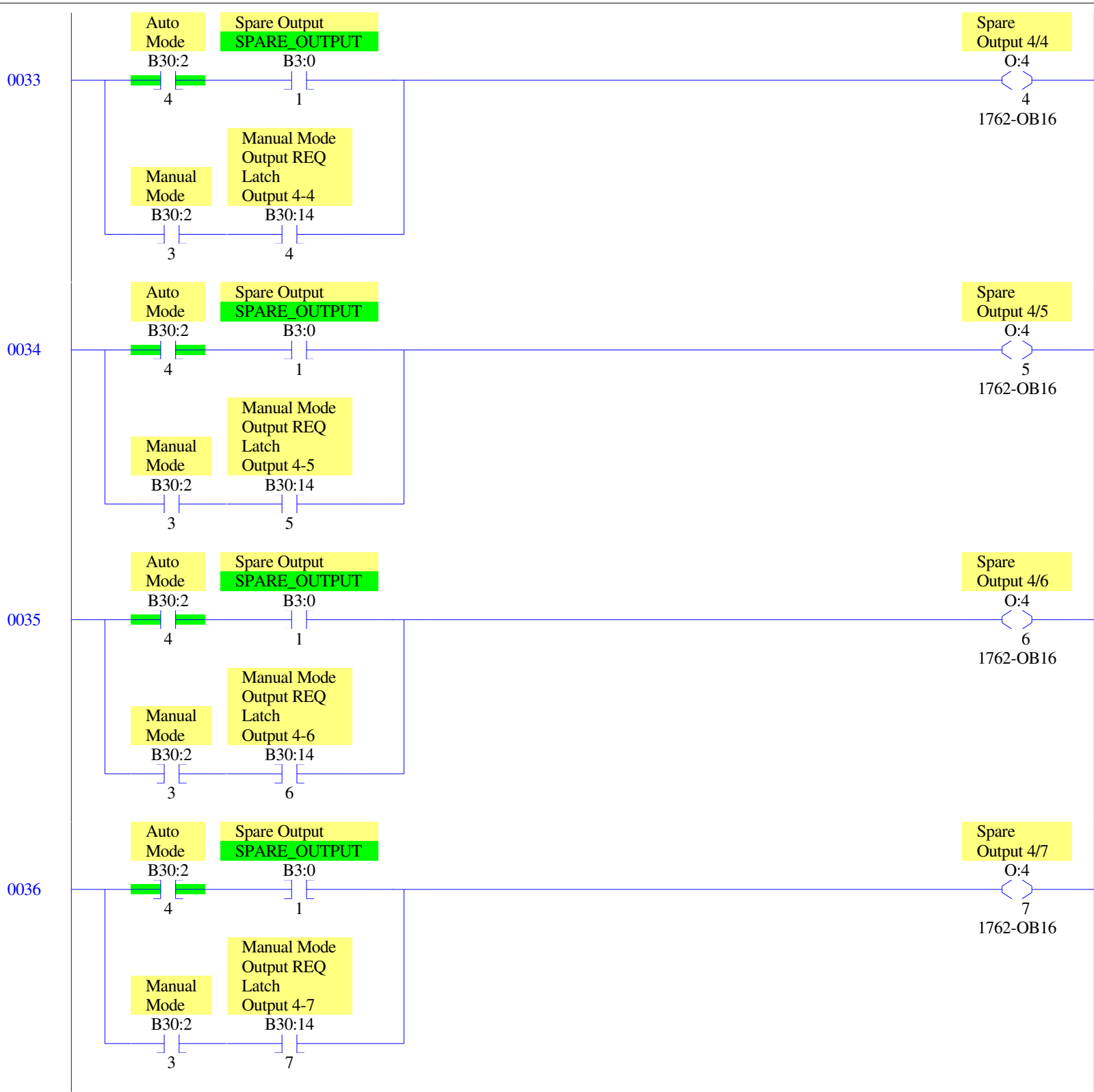


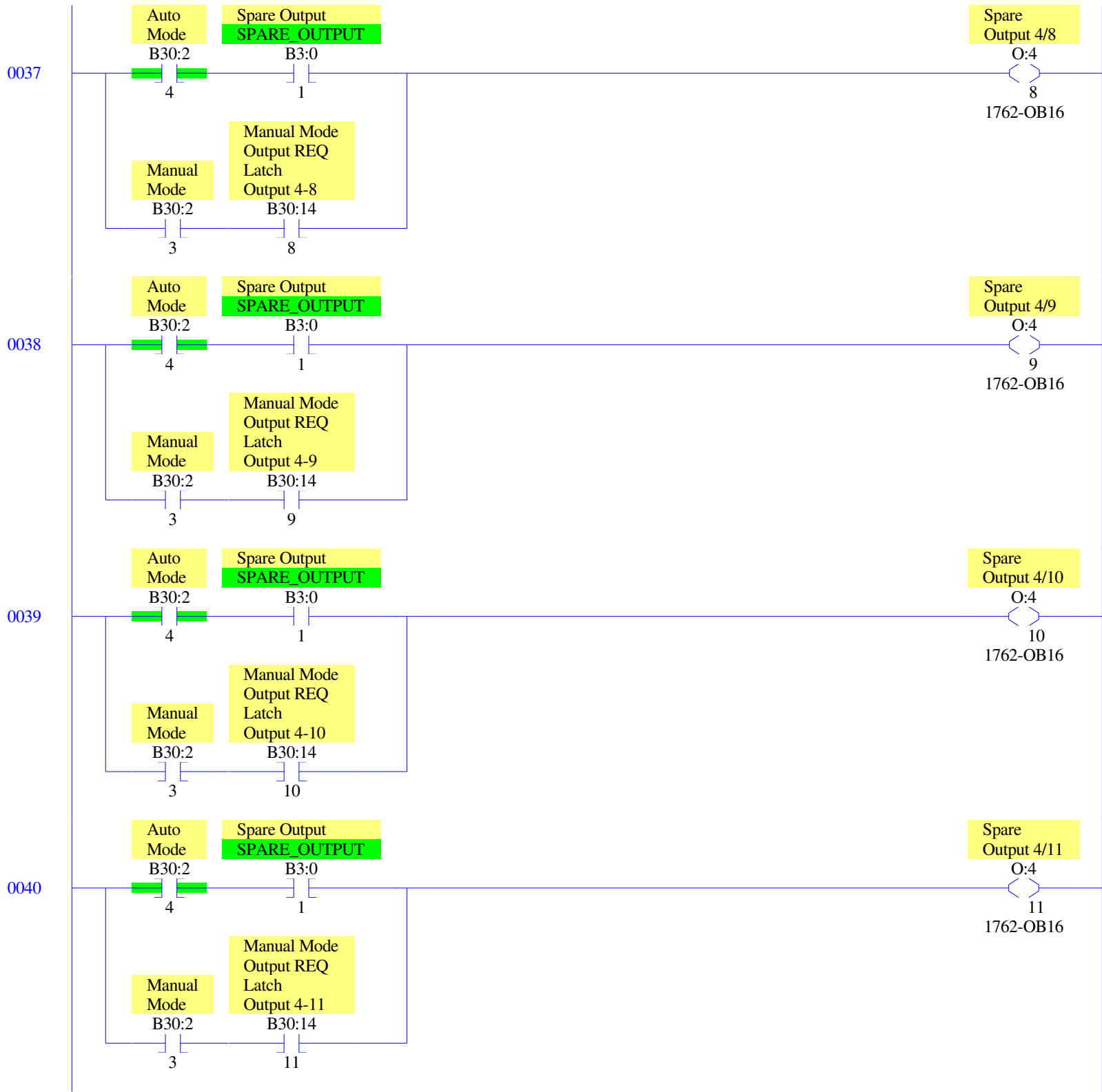


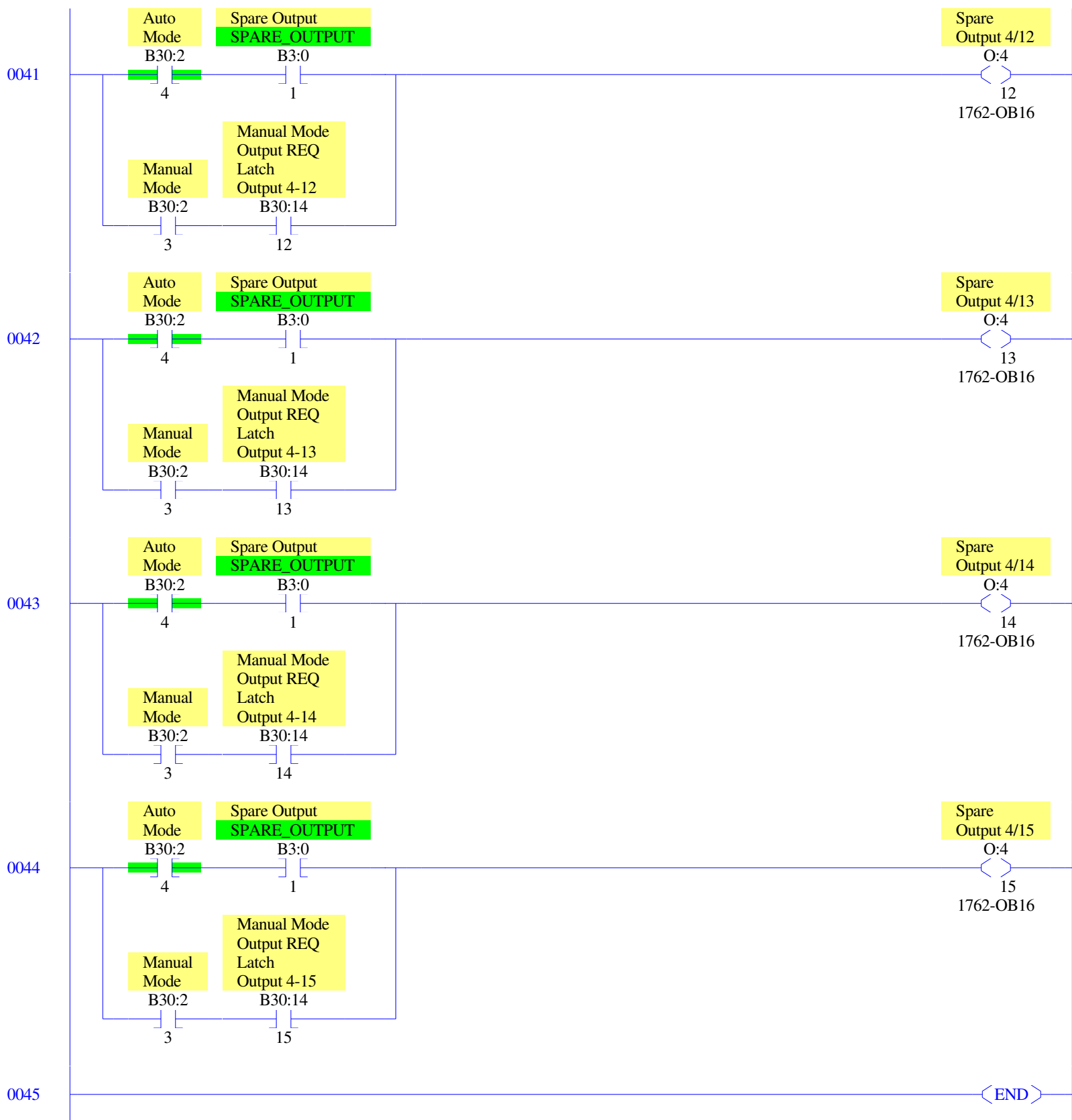


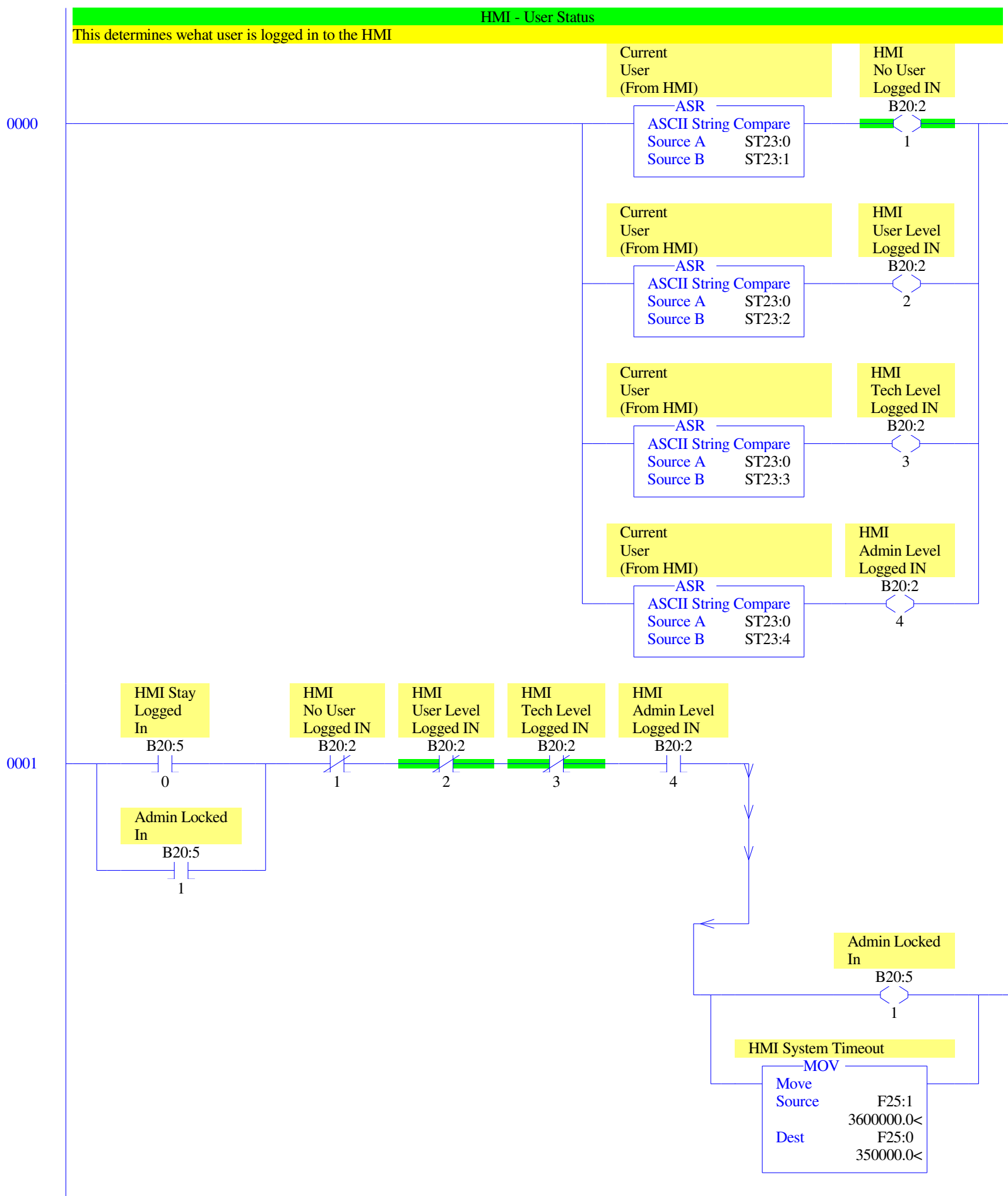


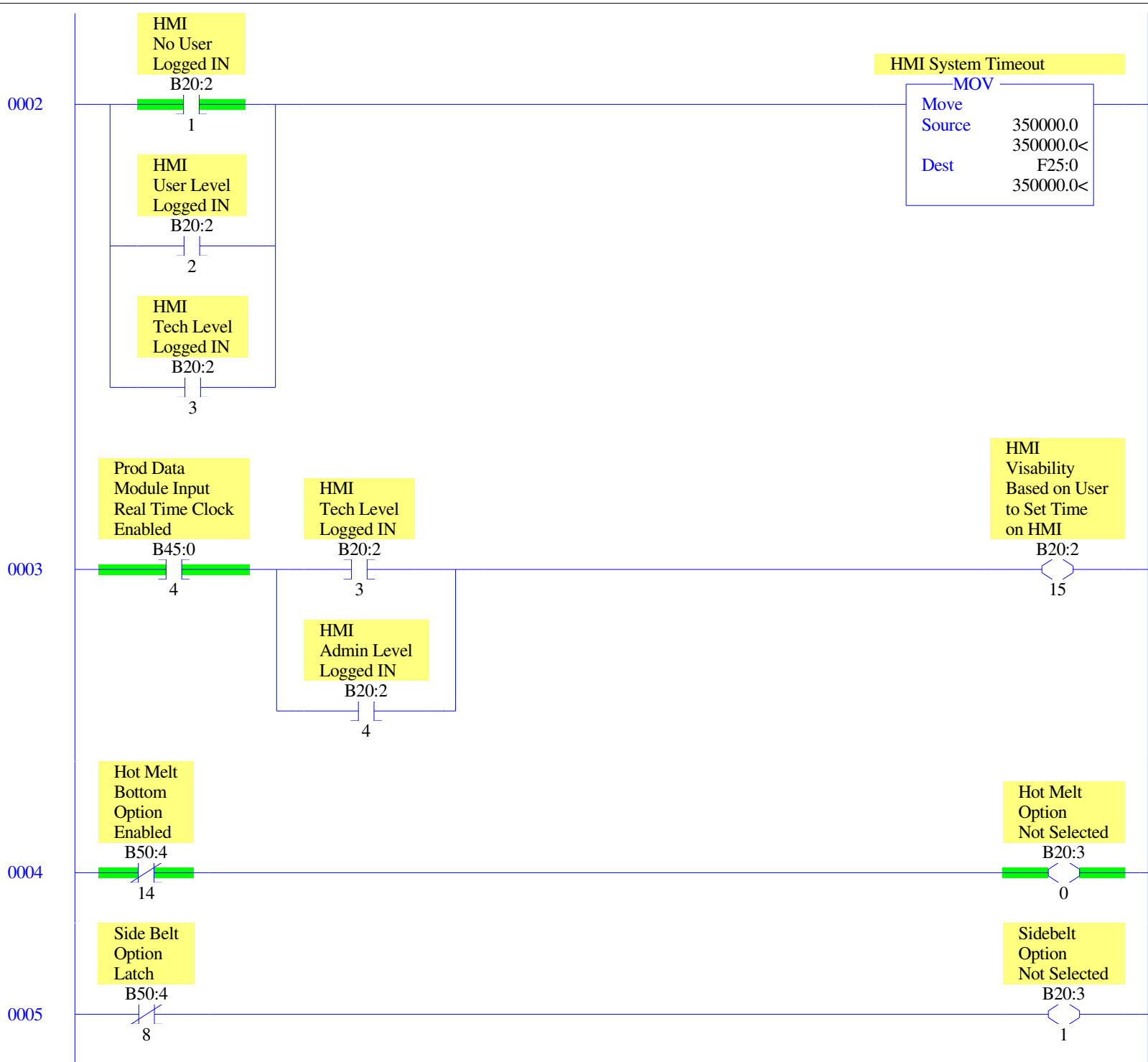












HMI - IO Status Update

The following rungs will update the IO Based on which screen is active.

0006

SCREEN
NUMBER
FROM
HMI

EQU
Equal
Source A N24:10
 1<
Source B 11
 11<

IO Status
to HMI
Word 0
Bits 0-15

MOV
Move
Source I:0.0
 2560<
Dest B20:0
 0000000000000000<

IO Status
to HMI
Word 1
Bits 0-15

MOV
Move
Source I:0.1
 0<
Dest B20:1
 0000000000000000<

0007

SCREEN
NUMBER
FROM
HMI

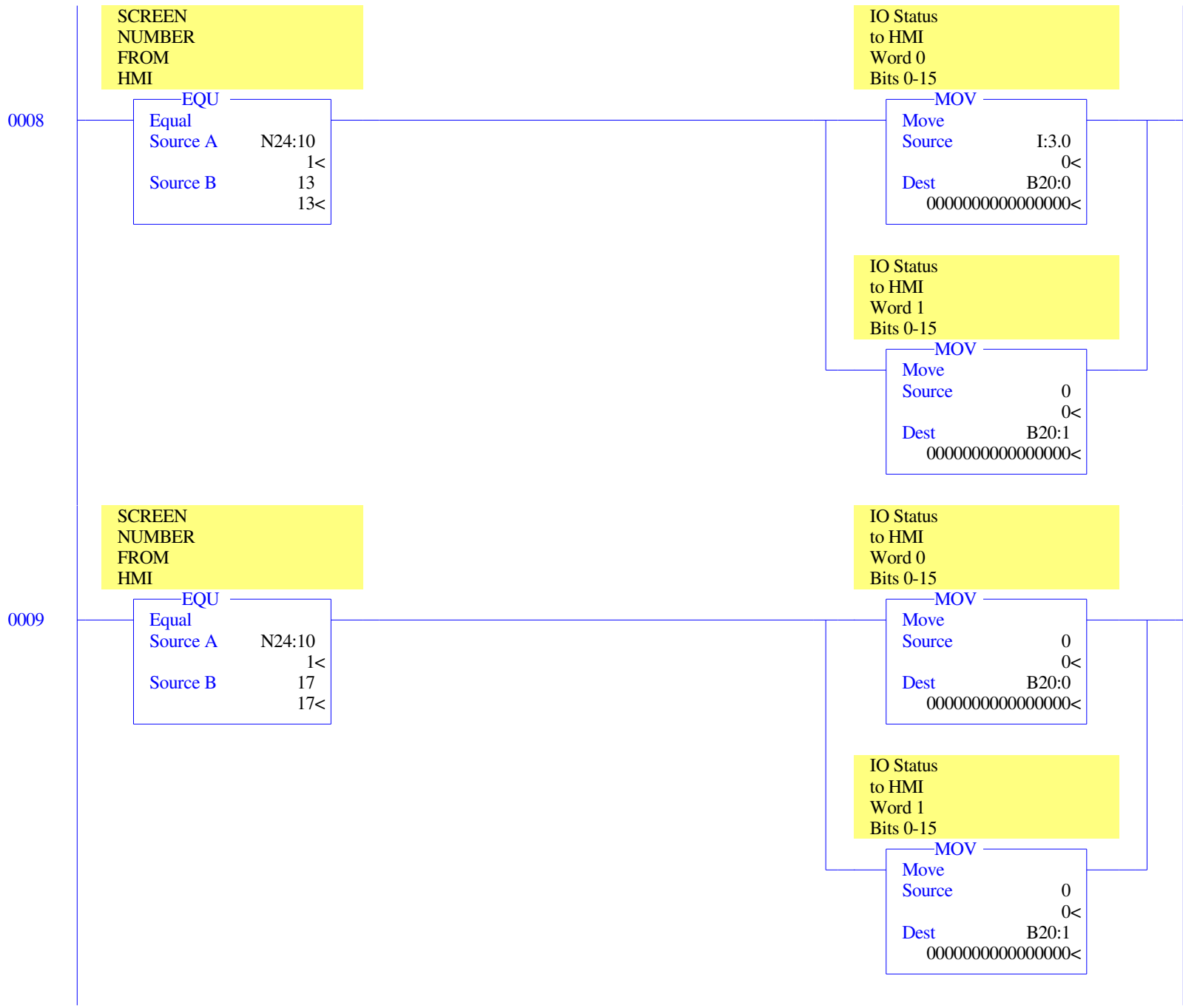
EQU
Equal
Source A N24:10
 1<
Source B 12
 12<

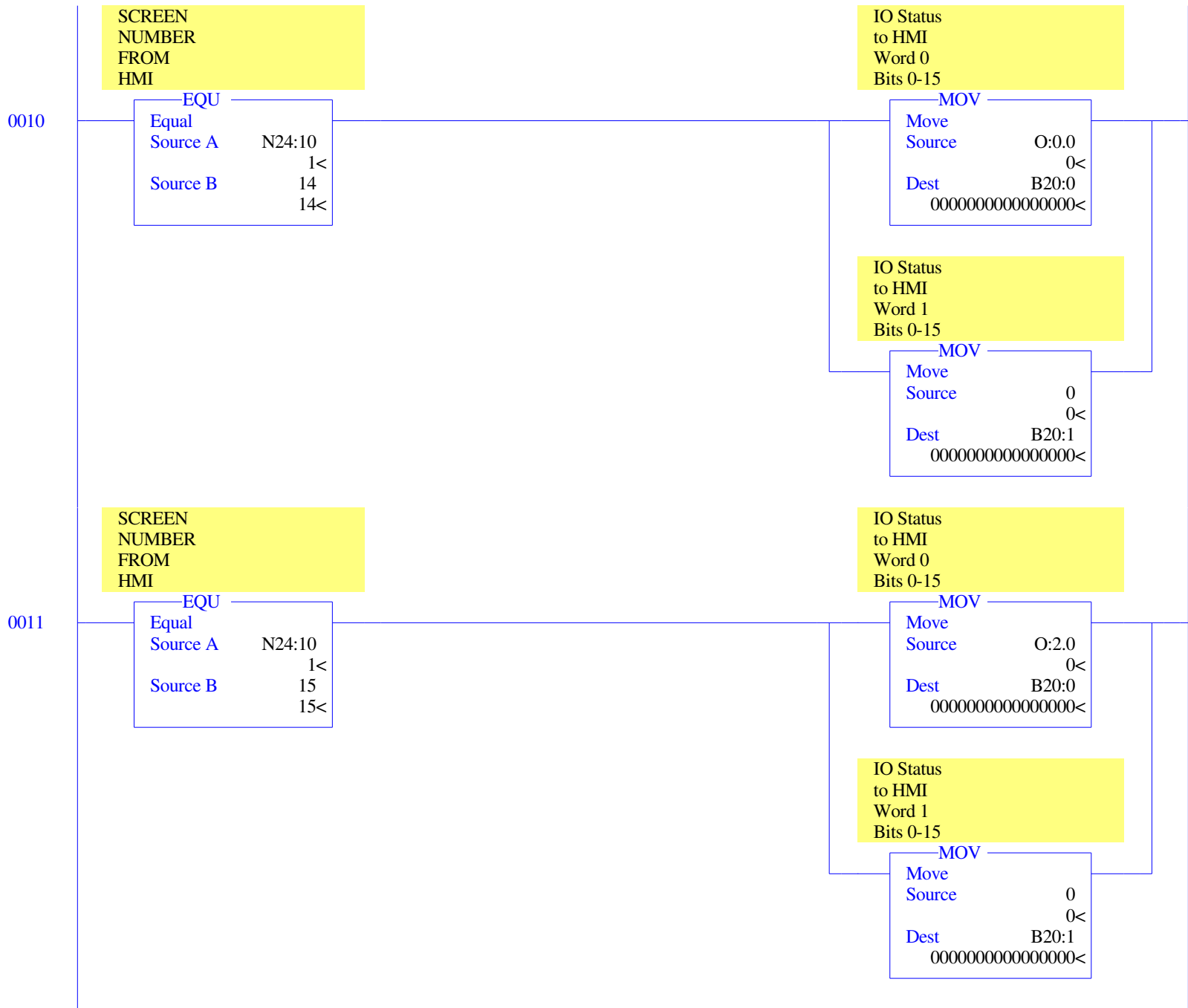
IO Status
to HMI
Word 0
Bits 0-15

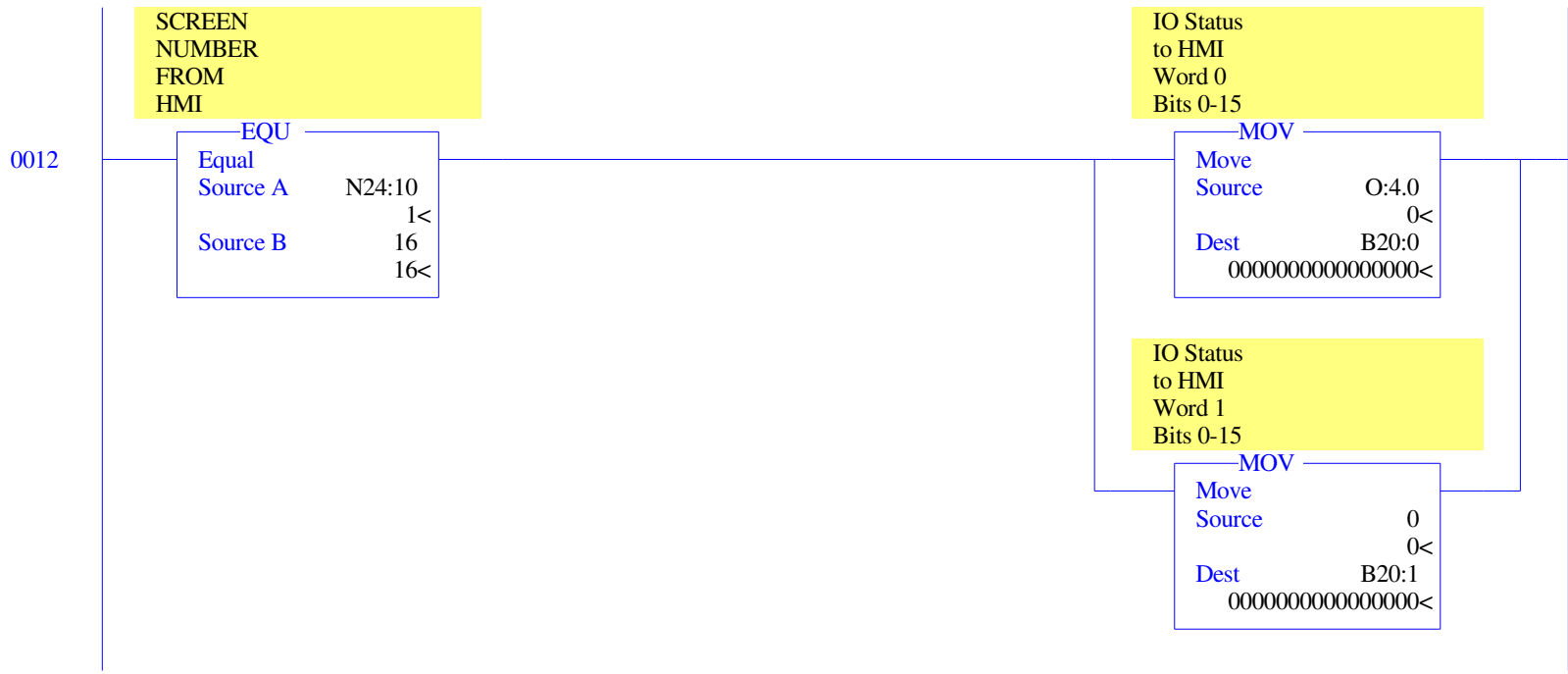
MOV
Move
Source I:1.0
 0<
Dest B20:0
 0000000000000000<

IO Status
to HMI
Word 1
Bits 0-15

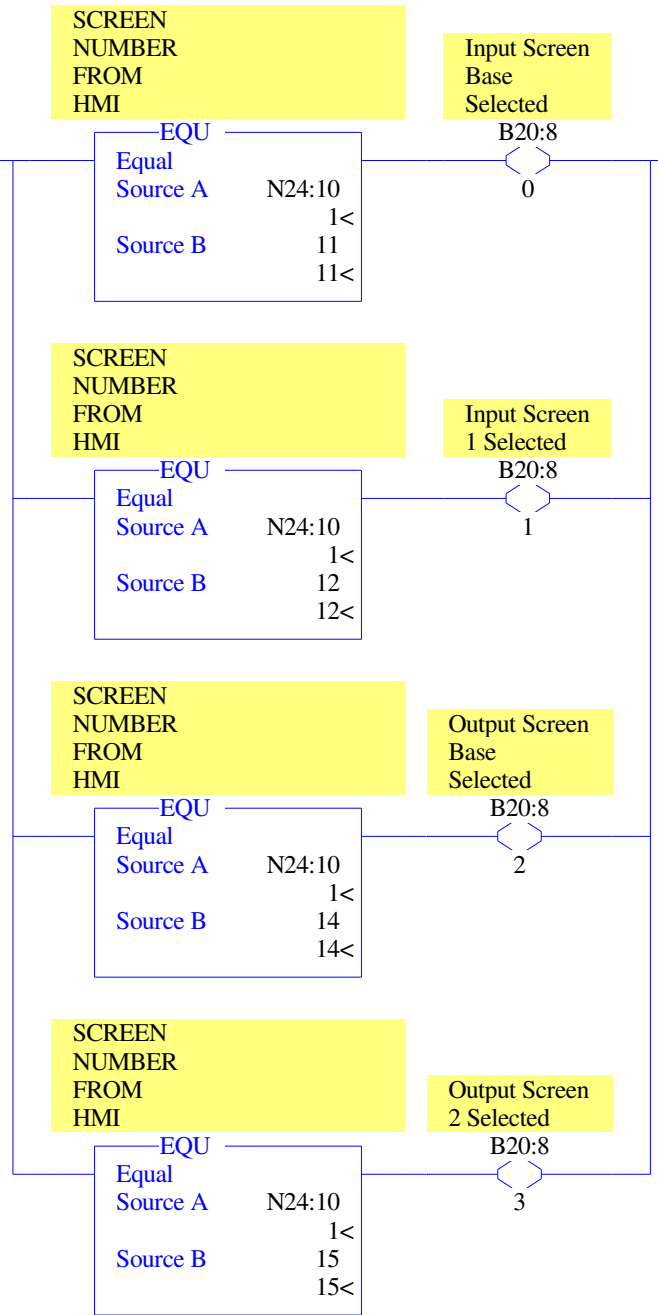
MOV
Move
Source 0
 0<
Dest B20:1
 0000000000000000<







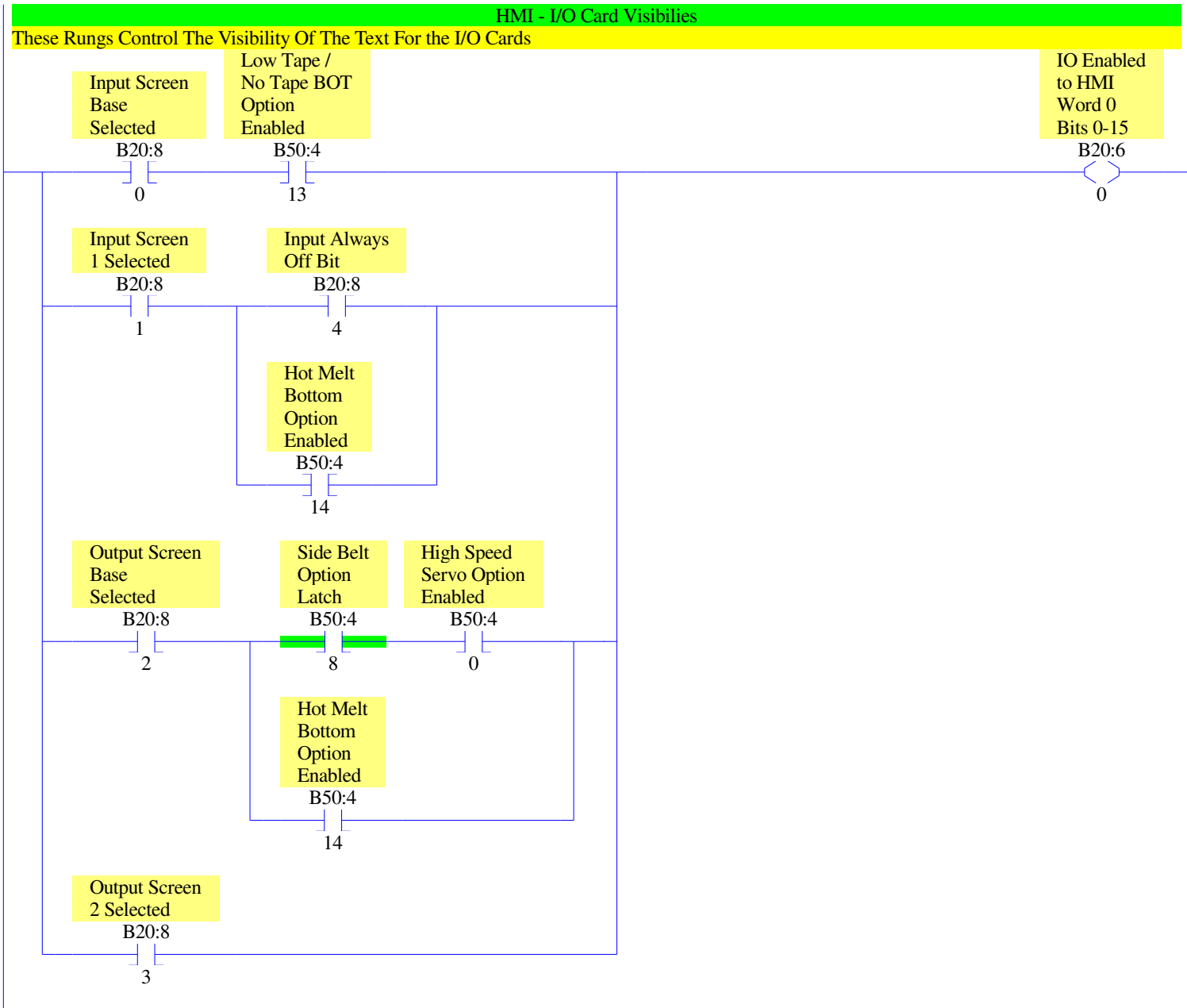
0013



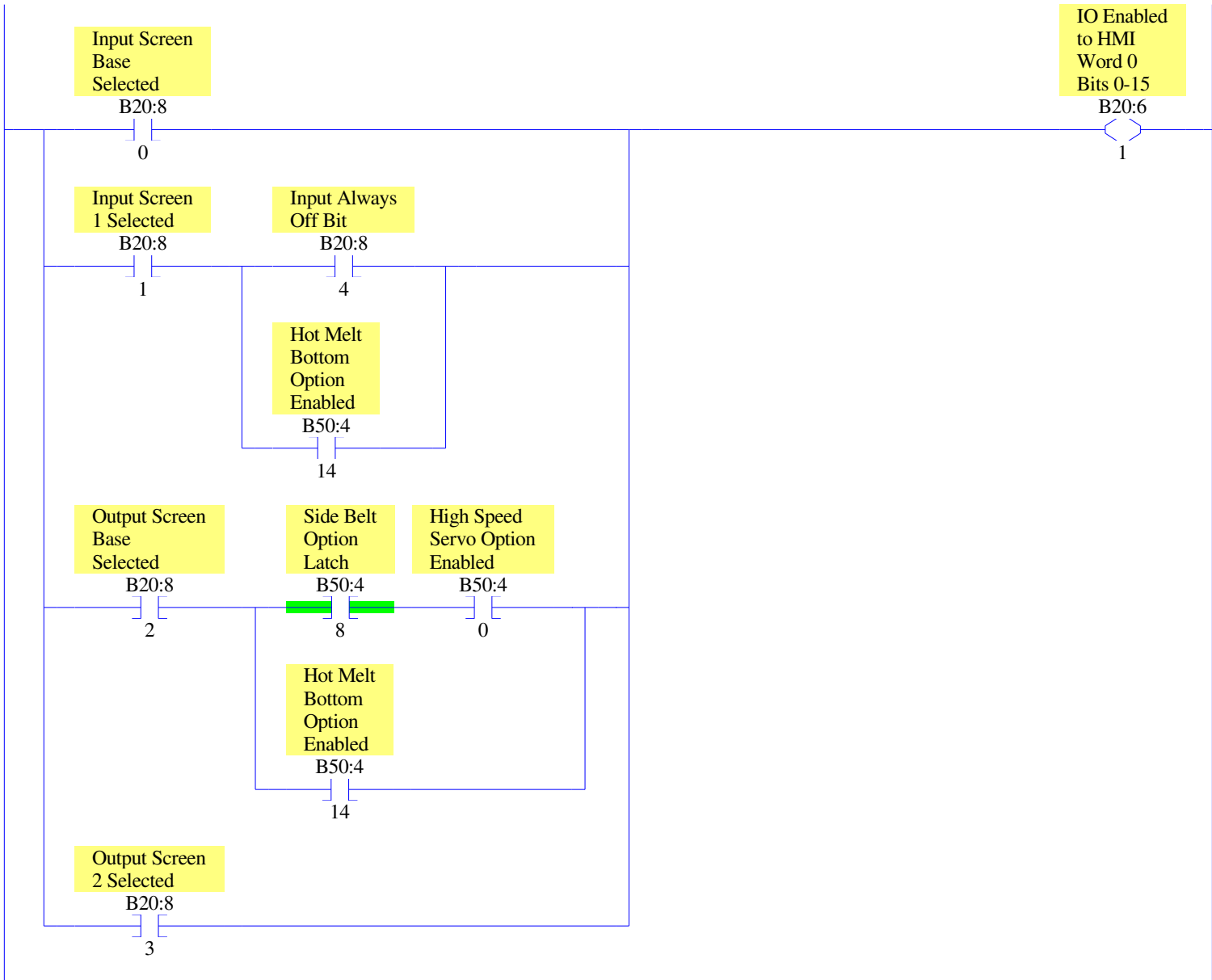
HMI - I/O Card Visibilities

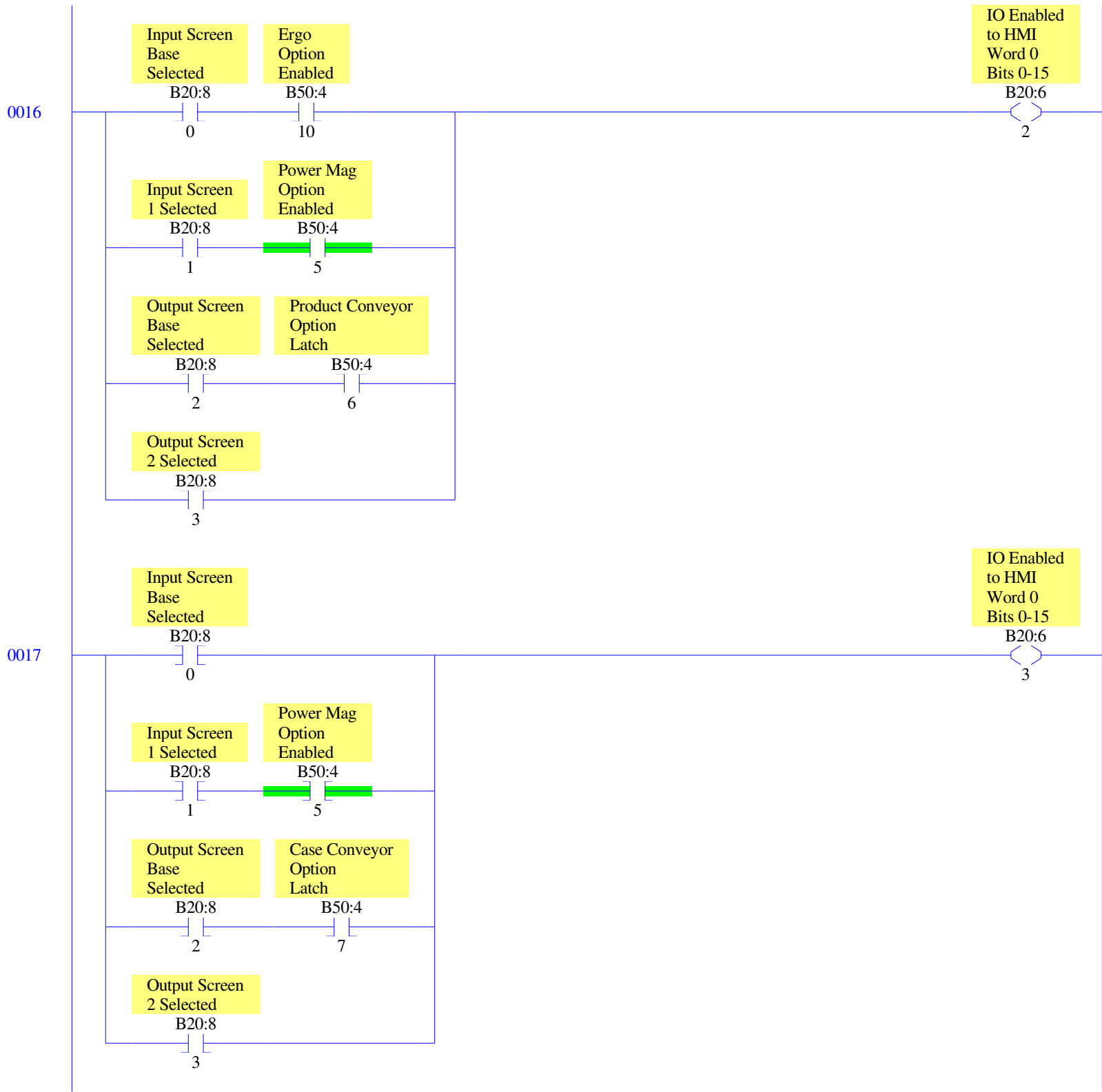
These Rungs Control The Visibility Of The Text For the I/O Cards

0014

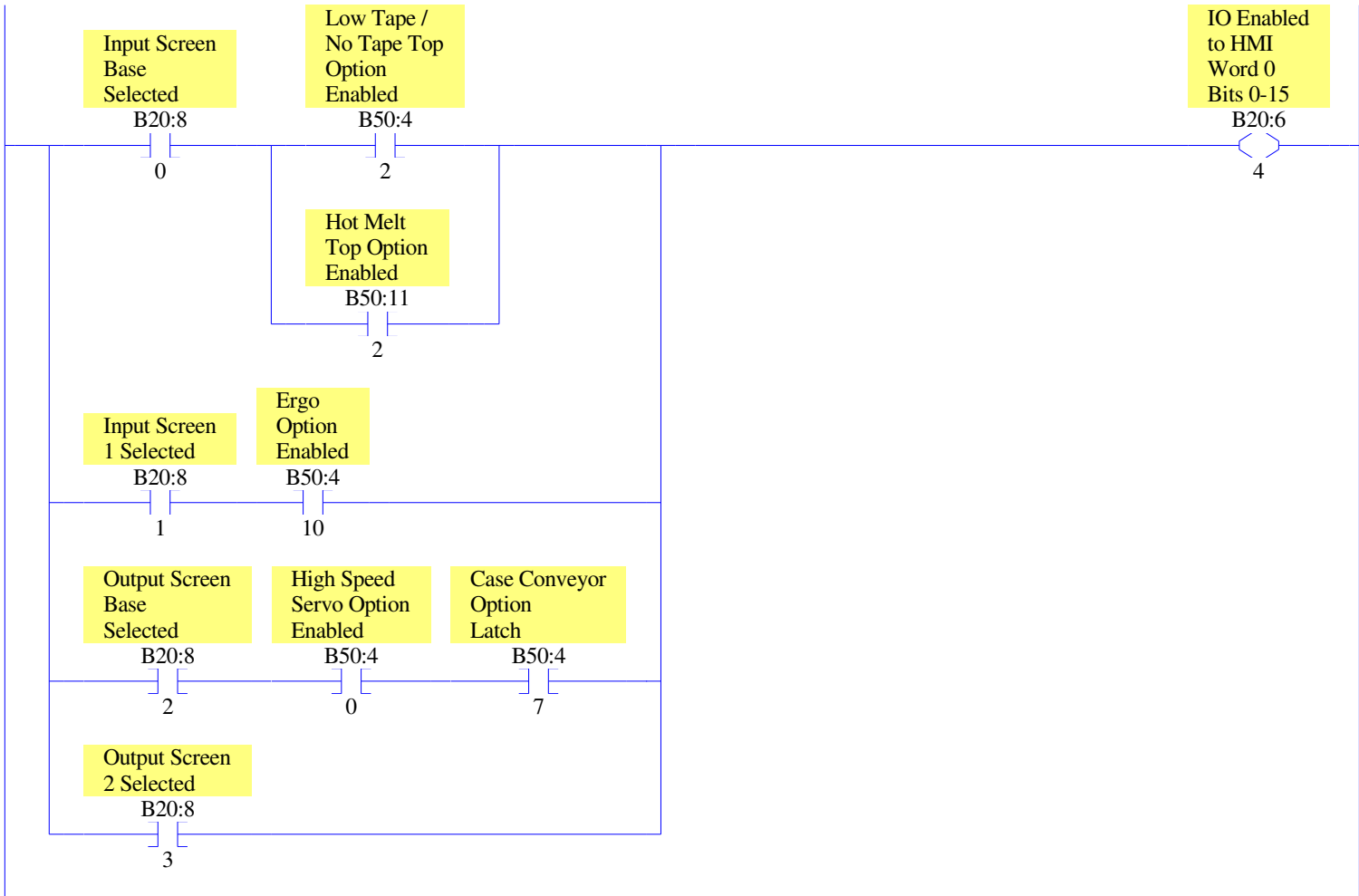


0015

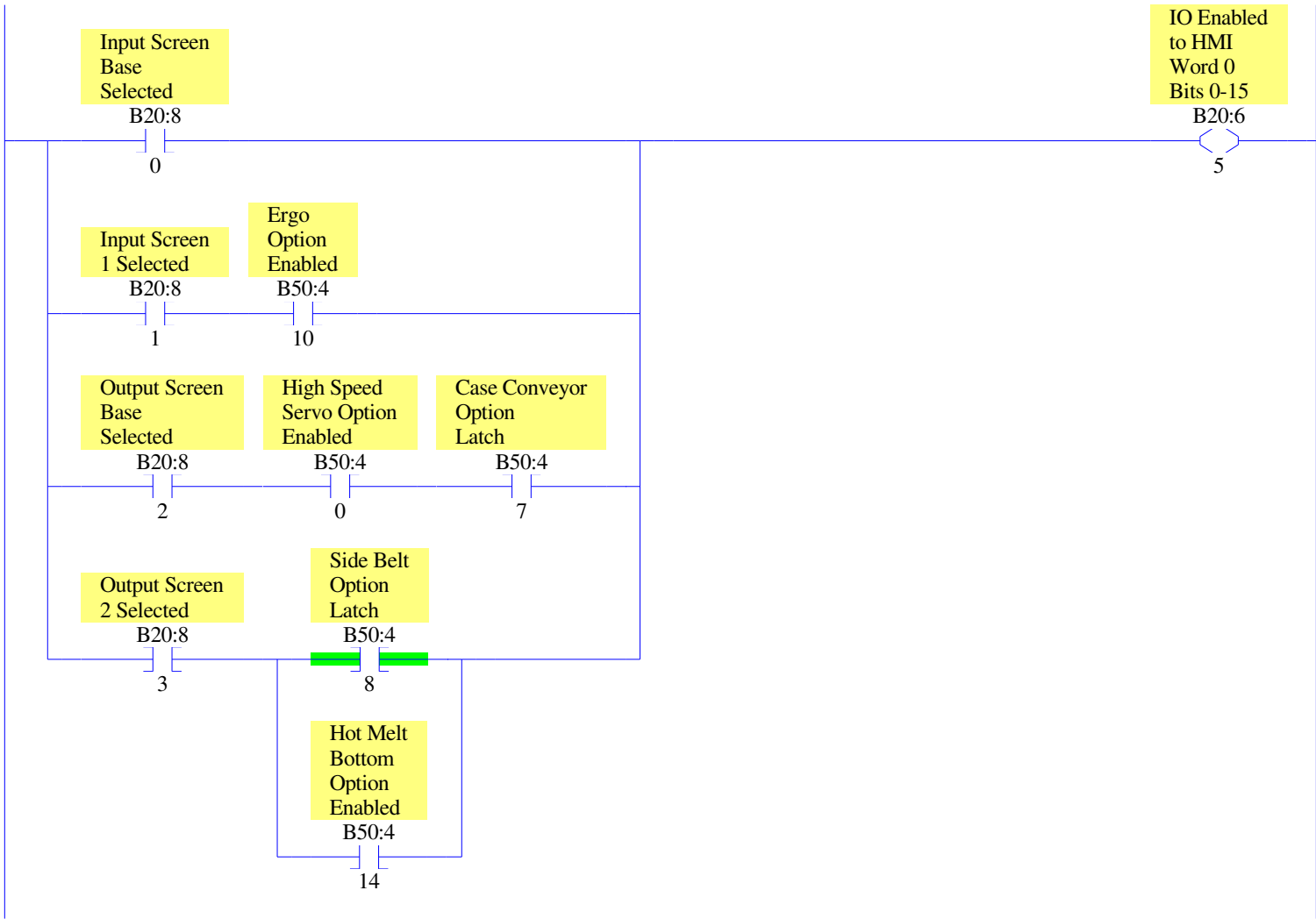




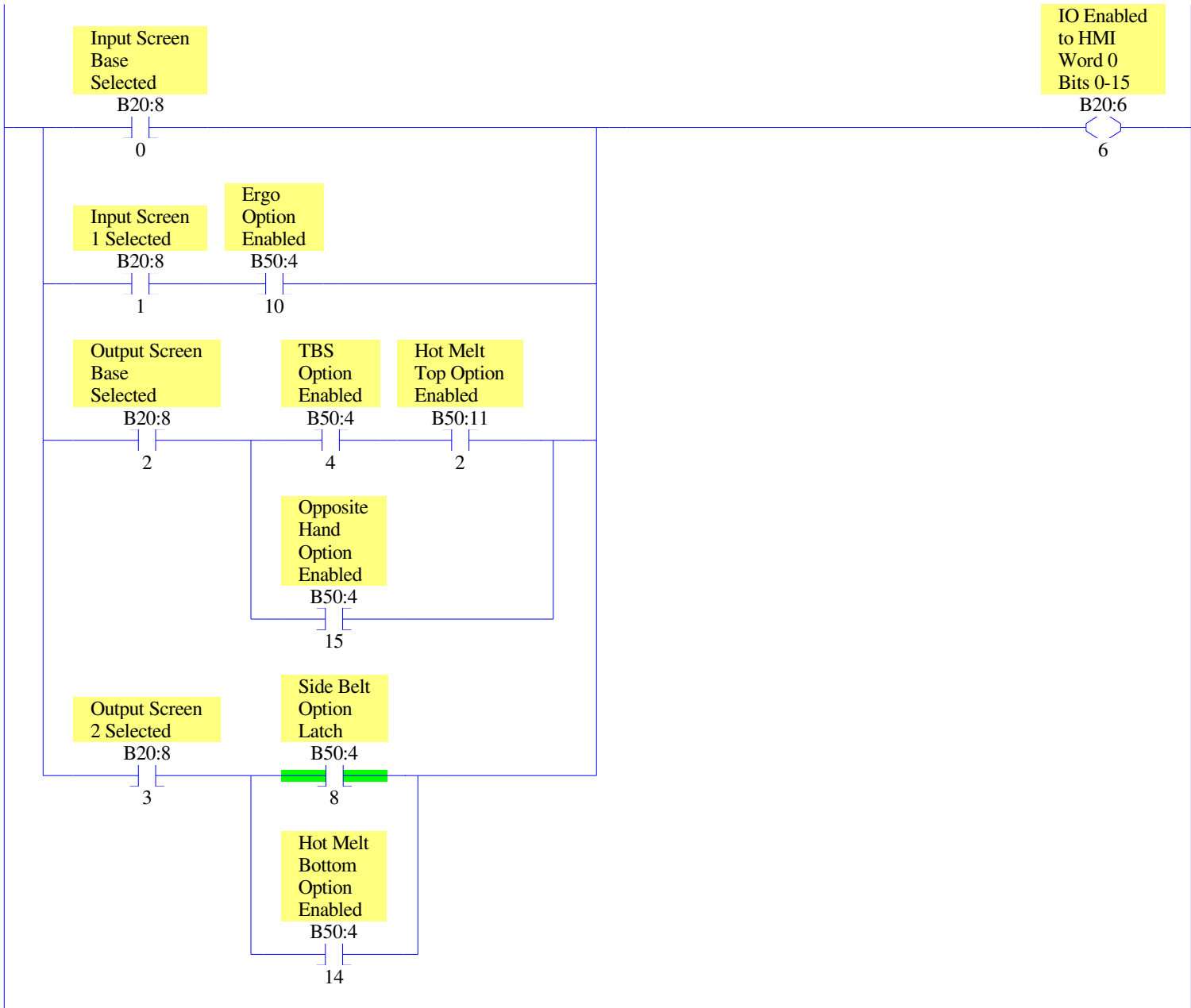
0018



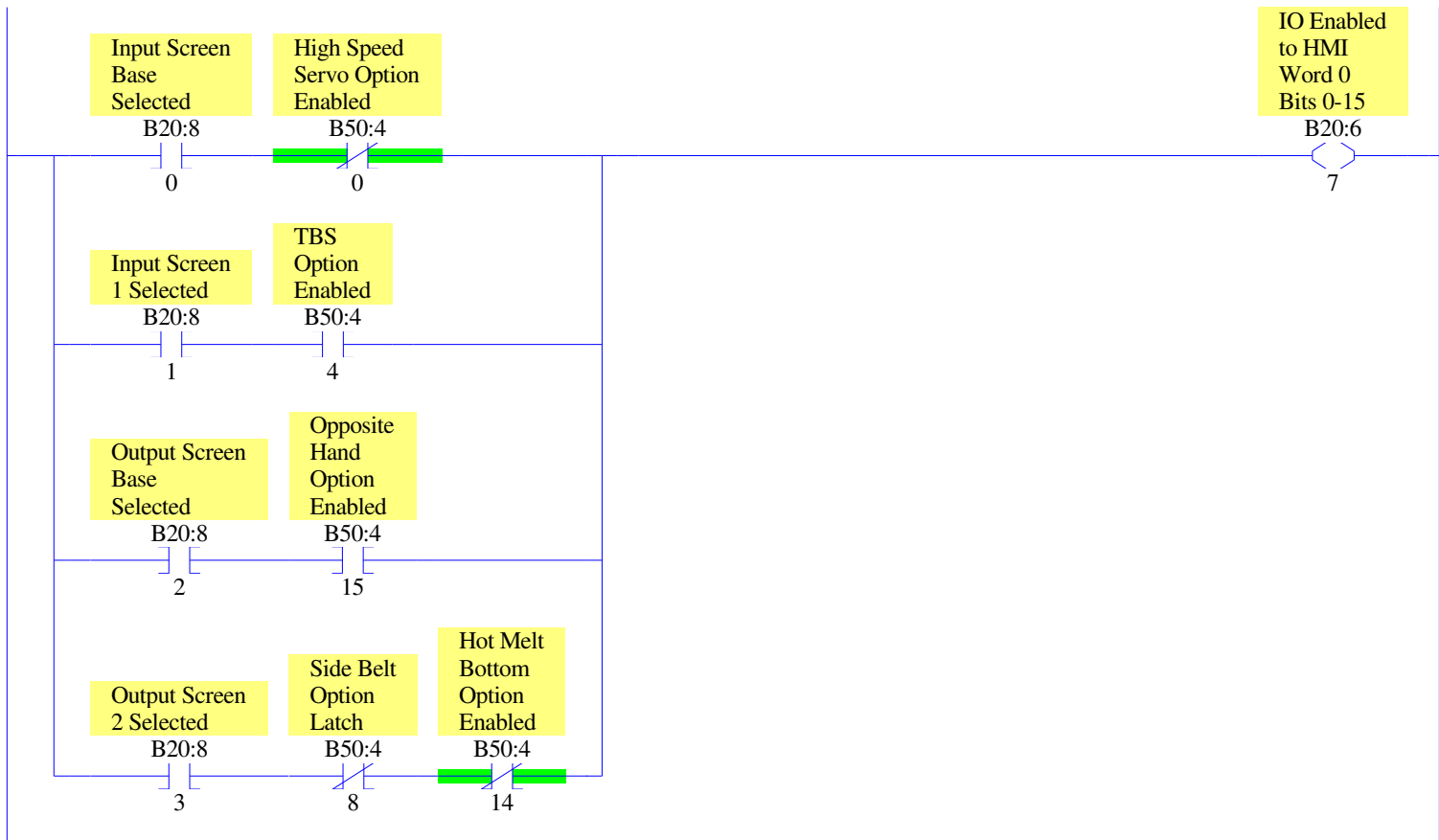
0019



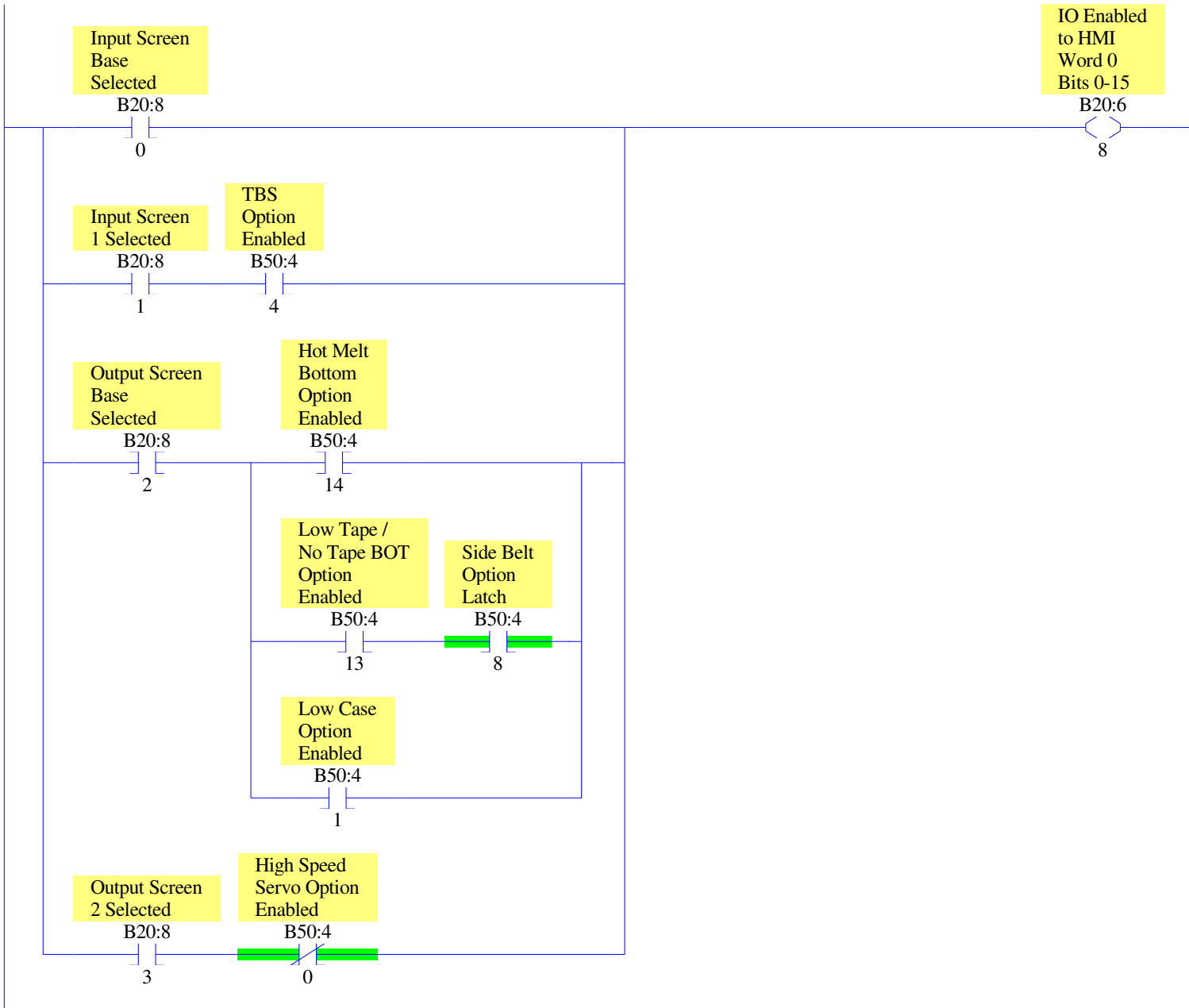
0020



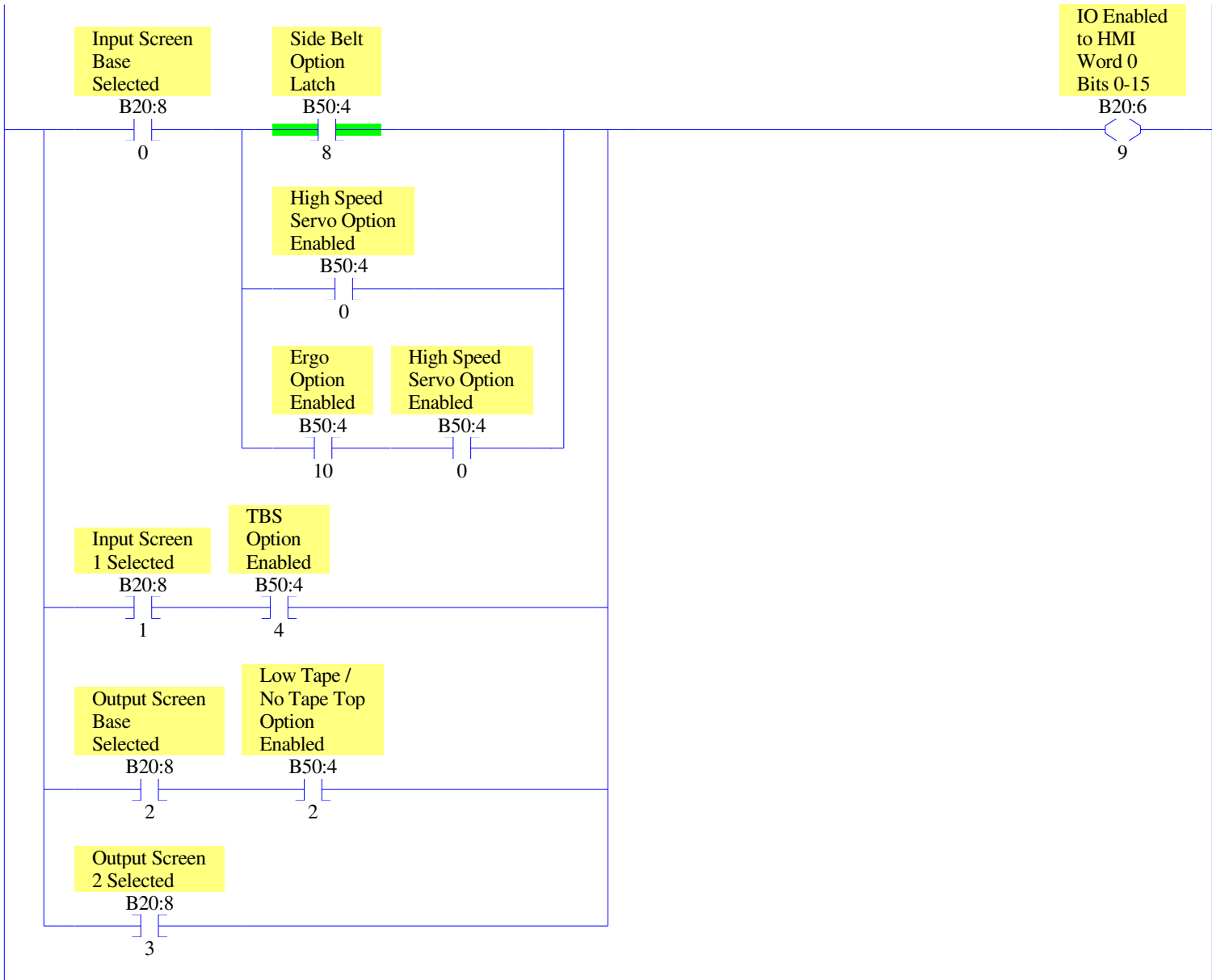
0021



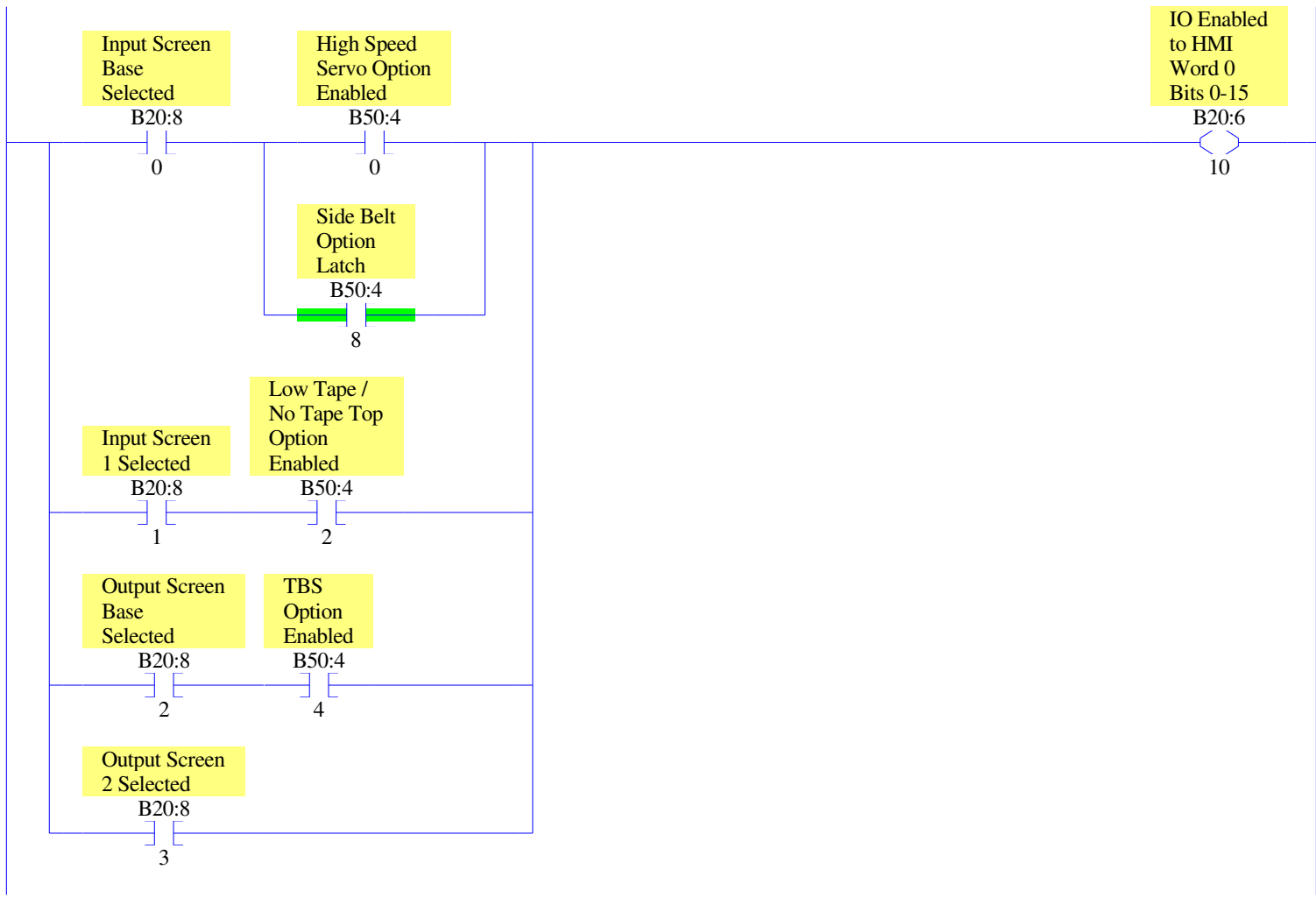
0022

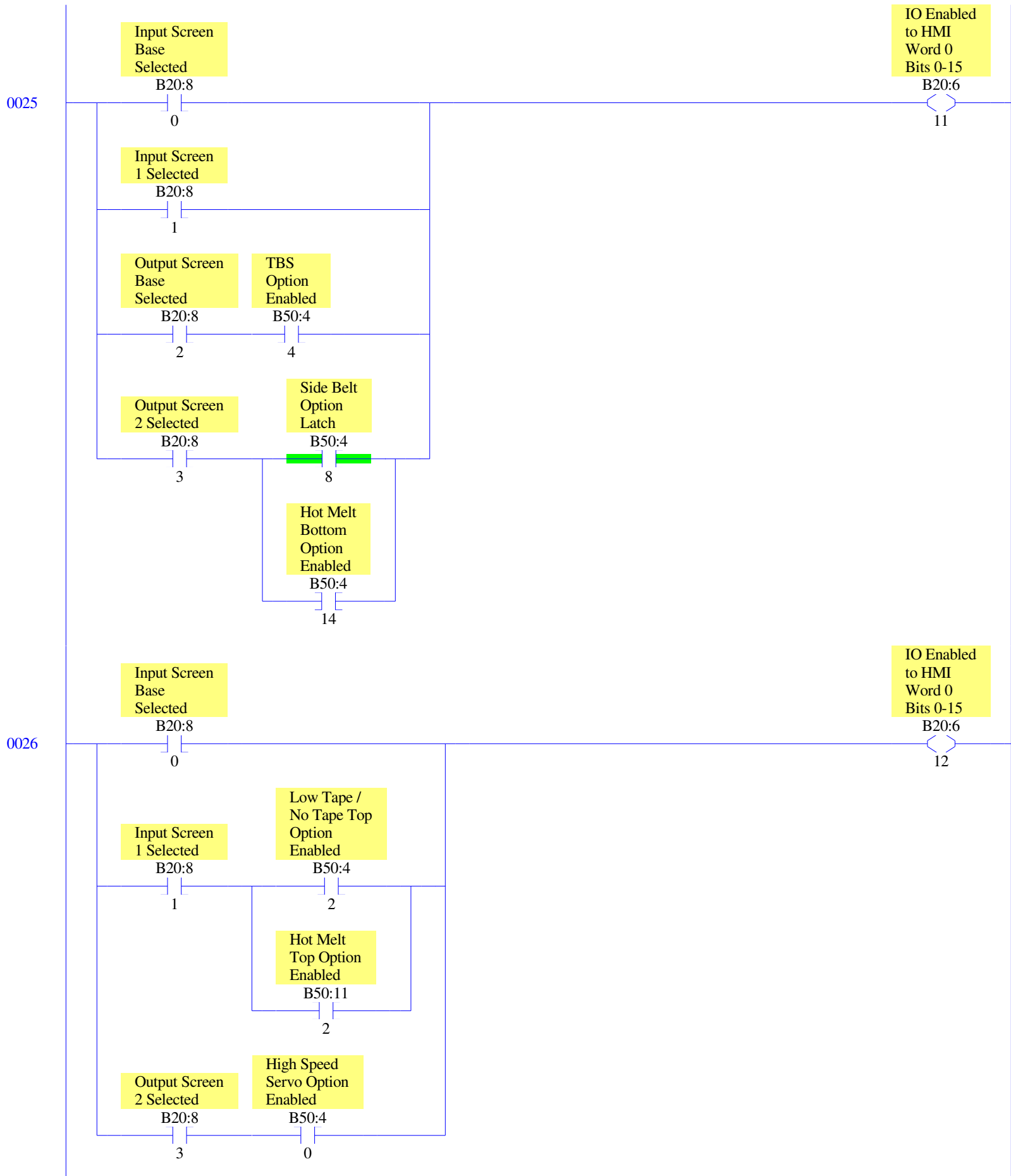


0023



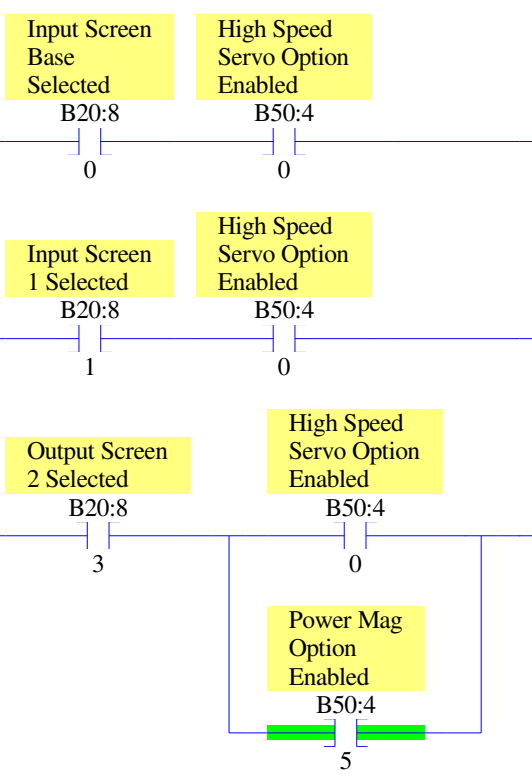
0024





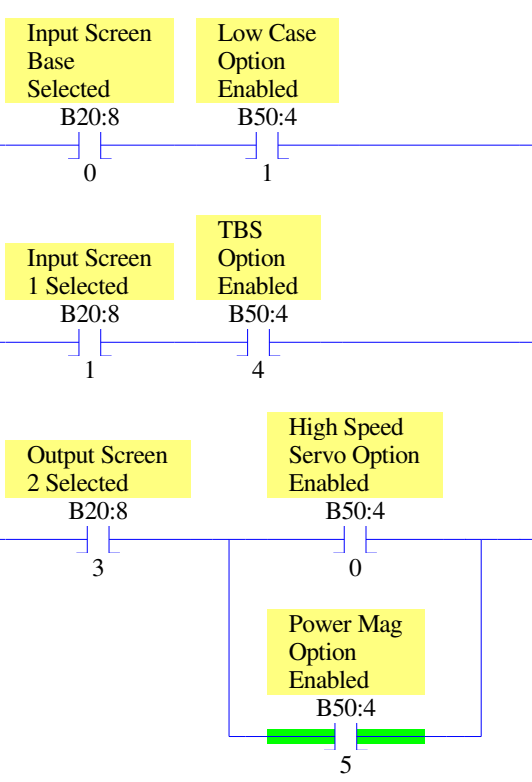
0027

IO Enabled to HMI Word 0 Bits 0-15 B20:6

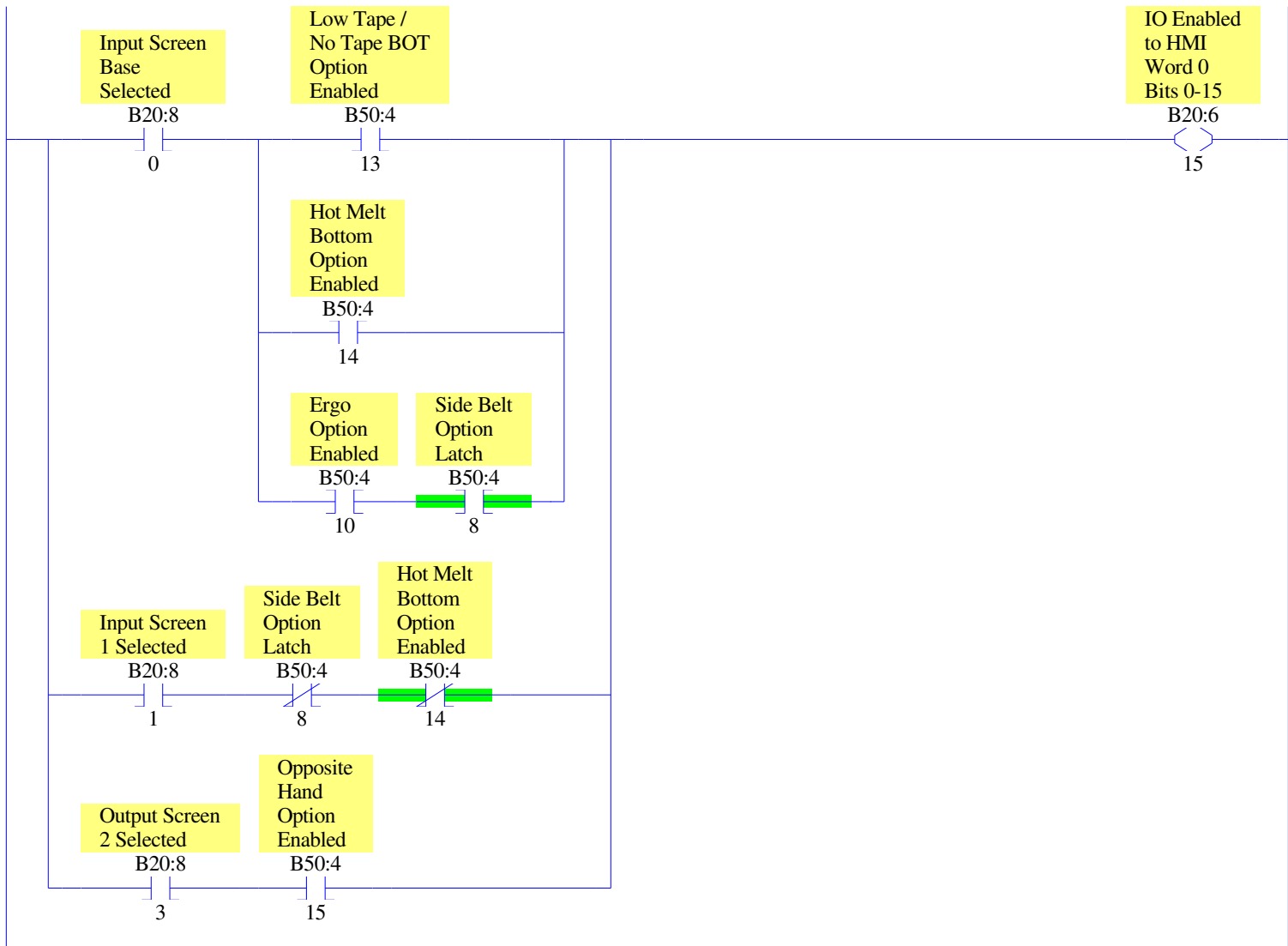


IO Enabled to HMI Word 0 Bits 0-15 B20:6

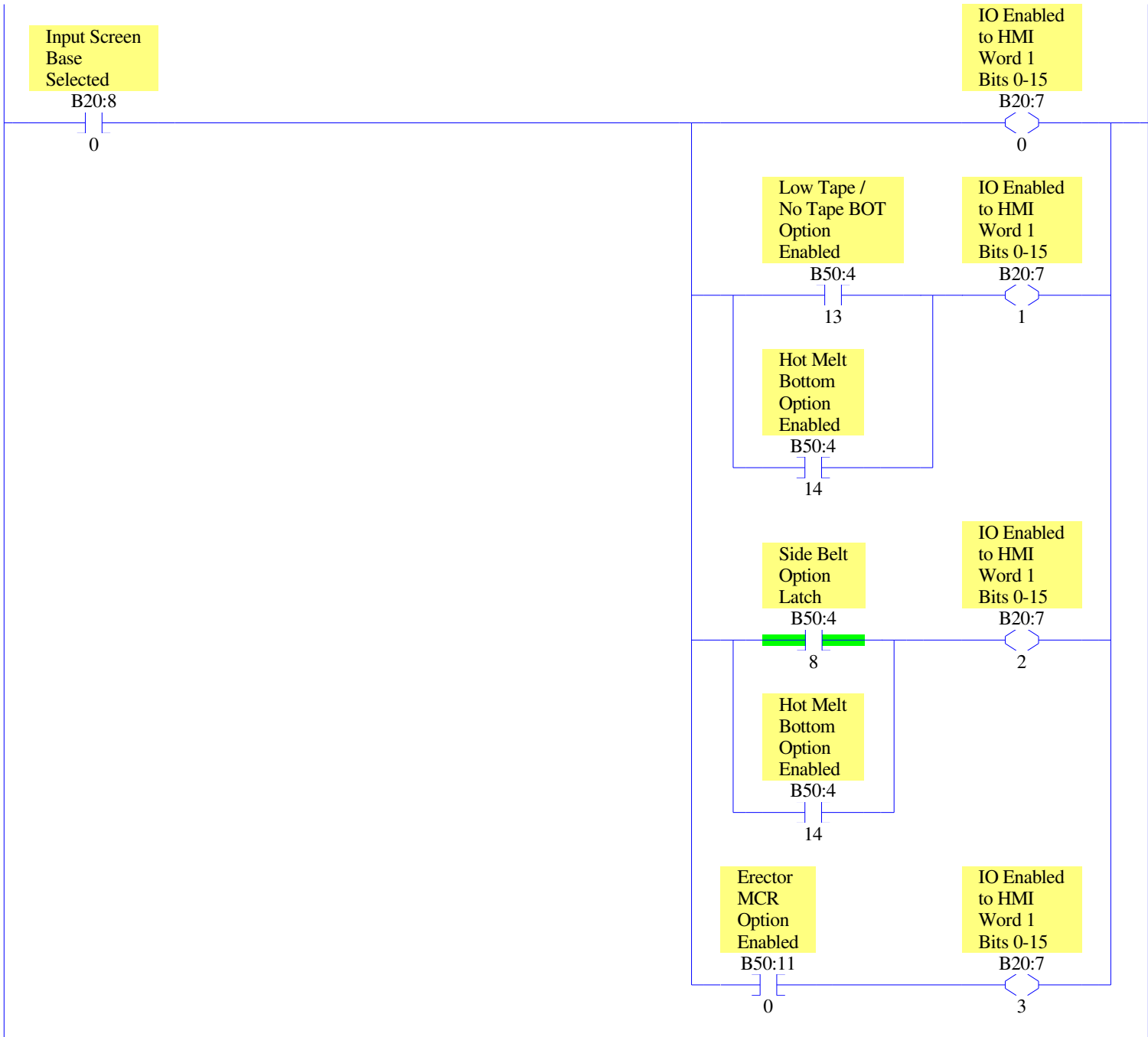
0028



0029



0030



HMI - Alarm Definitions

The following rungs display alarms if the control power is on and alarms exist

0031

Control Power ON

I_0_08

I:0

8

Bul.1766

MOV

Move Source	1
	1<
Dest	N21:1
	1<

Control Power ON

I_0_08

I:0

8

Bul.1766

MOV

Move Source	0
	0<
Dest	N21:1
	1<

Control Power ON

I_0_08

I:0

8

Bul.1766

FLL

Fill File Source	0
Dest	#N21:2
Length	20

Q4:1

JMP

0032

Alarms CE Trip Present

B150:2

0

MOV

Move Source	2
	2<
Dest	N21:2
	0<

Alarms Sealer Trip Present

B150:2

1

Alarms CE Trip Present

B150:2

0

Alarms Sealer Trip Present

B150:2

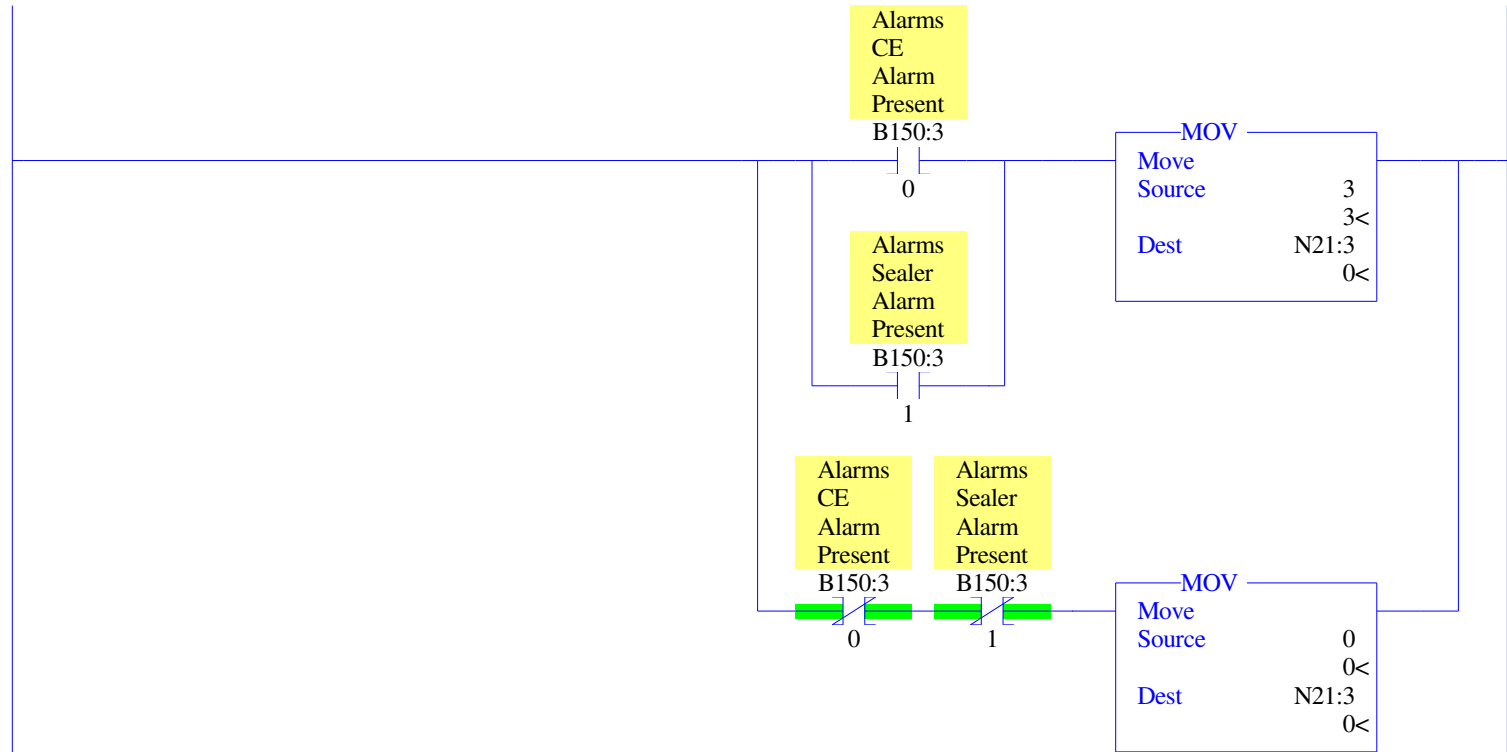
1

MOV

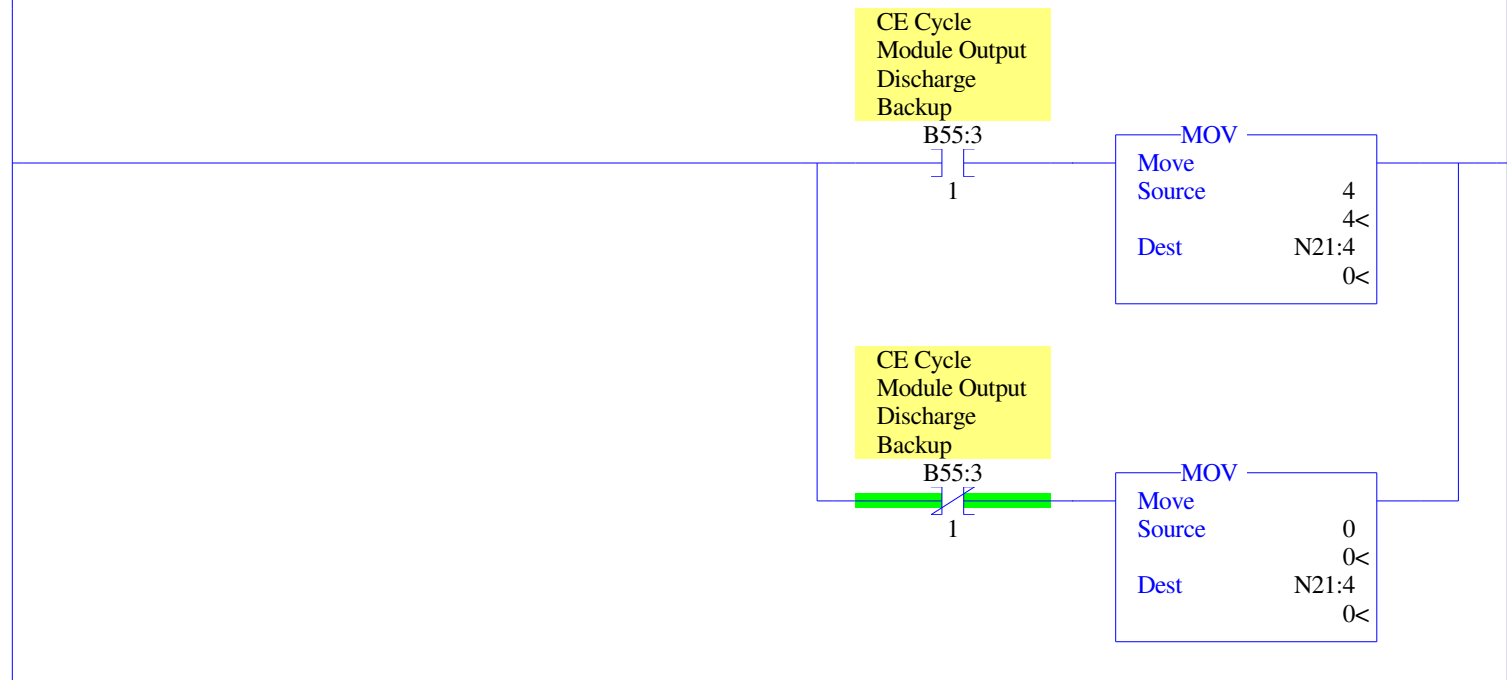
Move Source	0
	0<
Dest	N21:2
	0<

0033

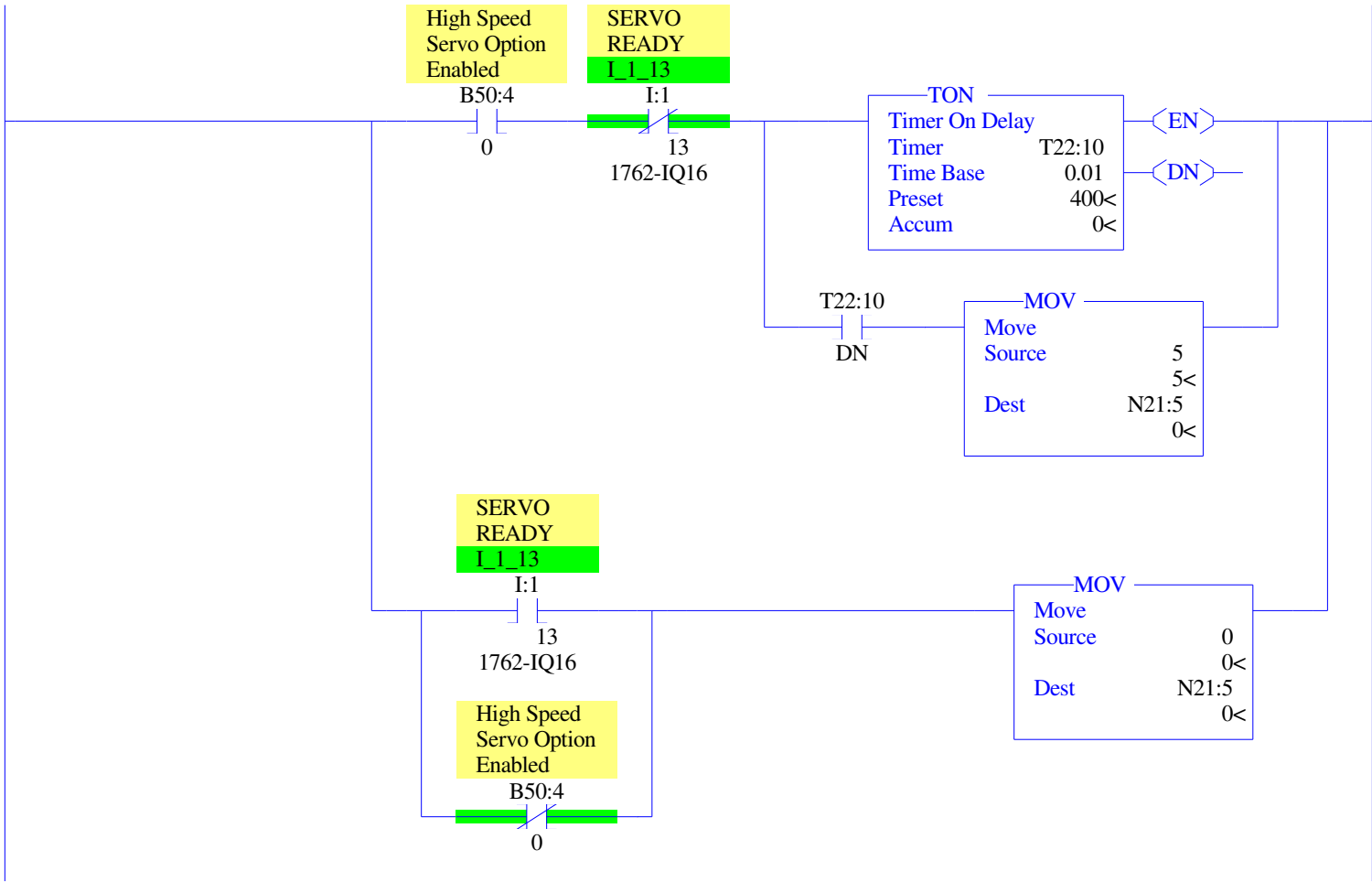
0034



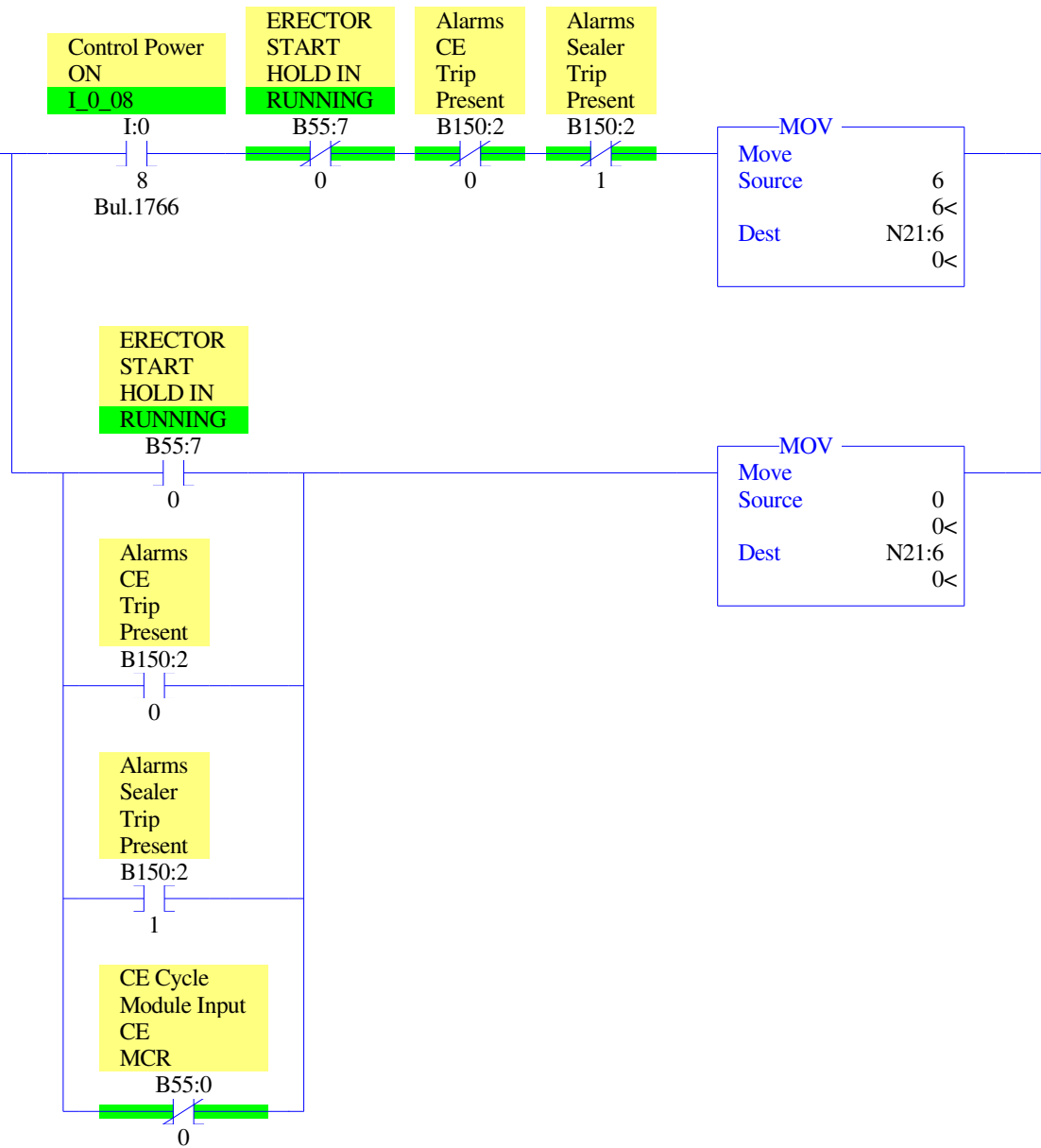
0035



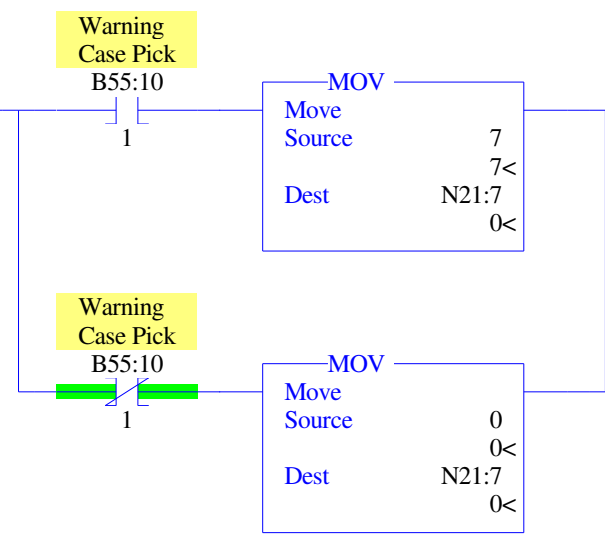
0036



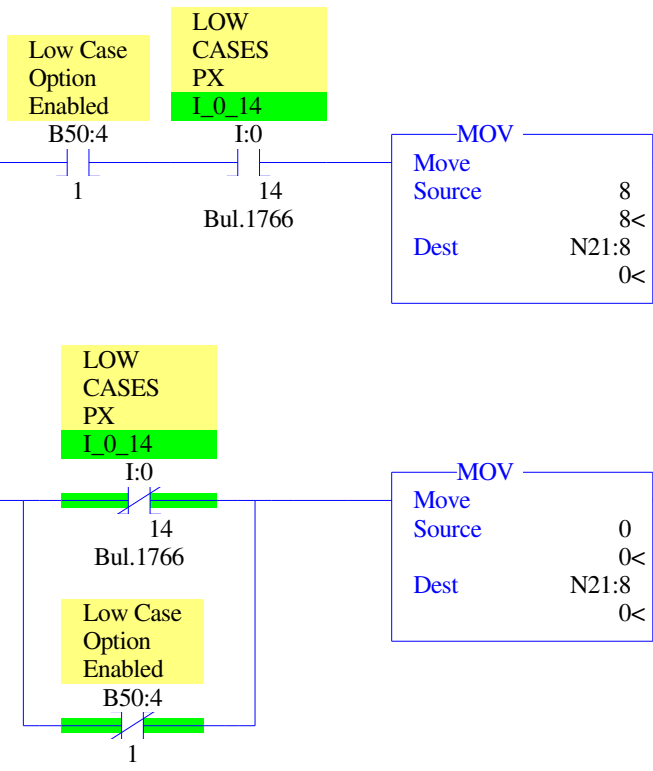
0037



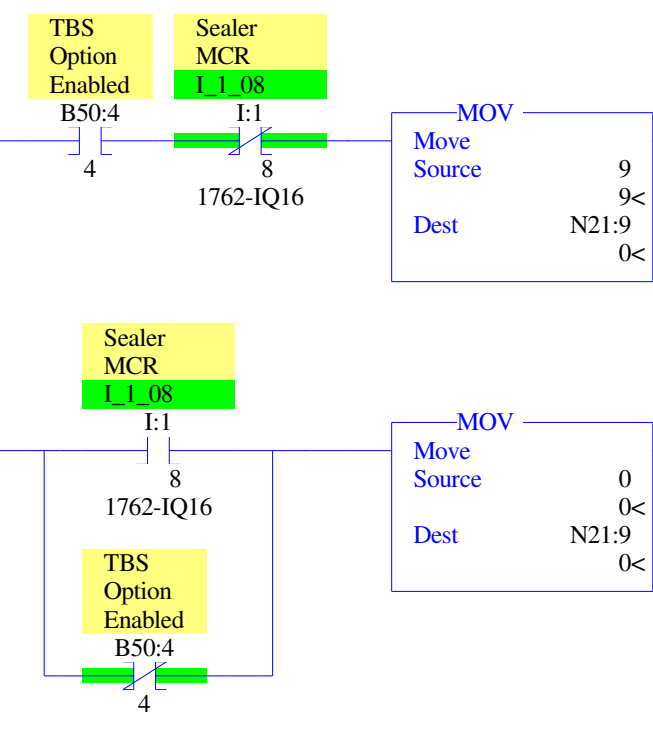
0038

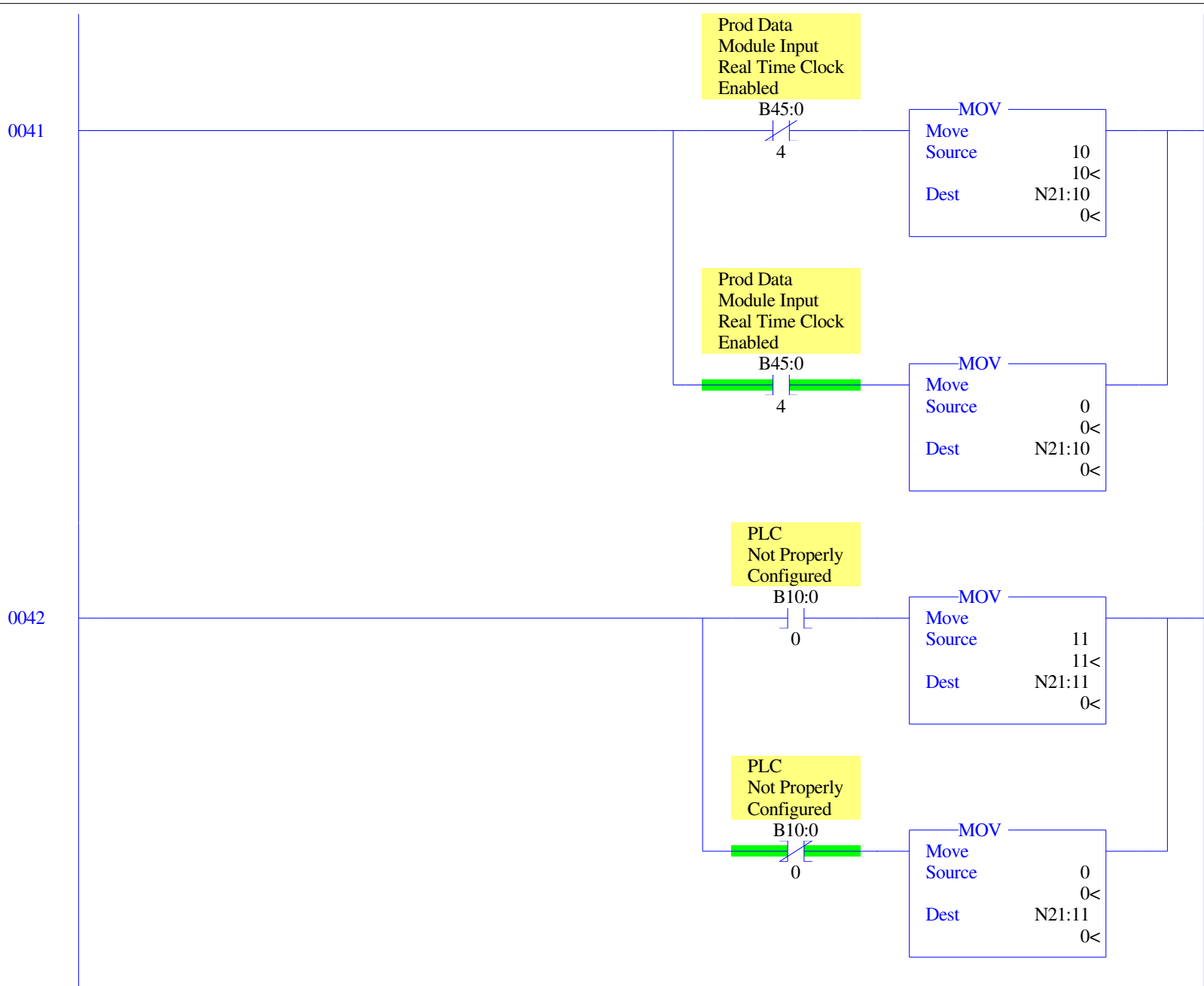


0039

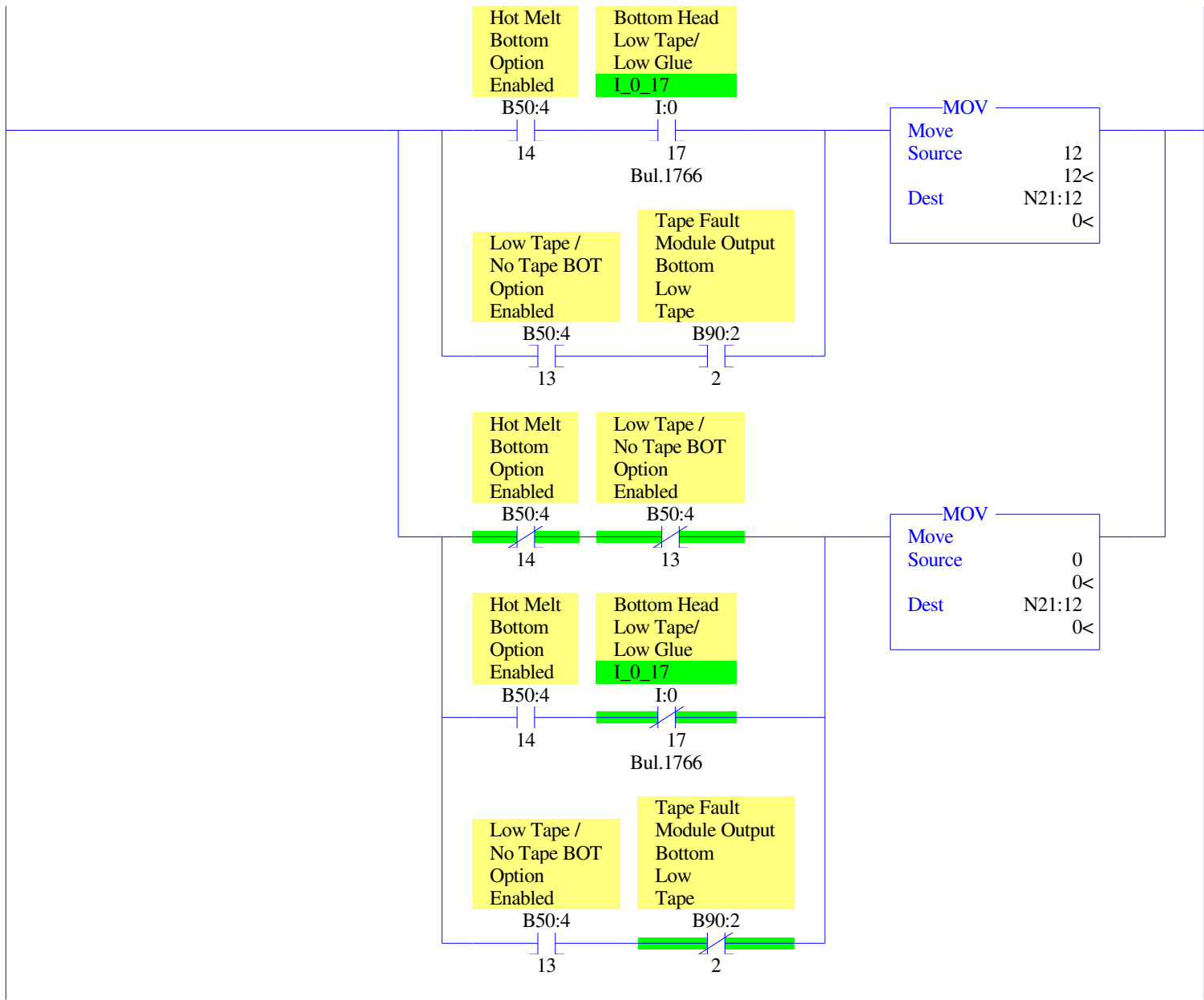


0040

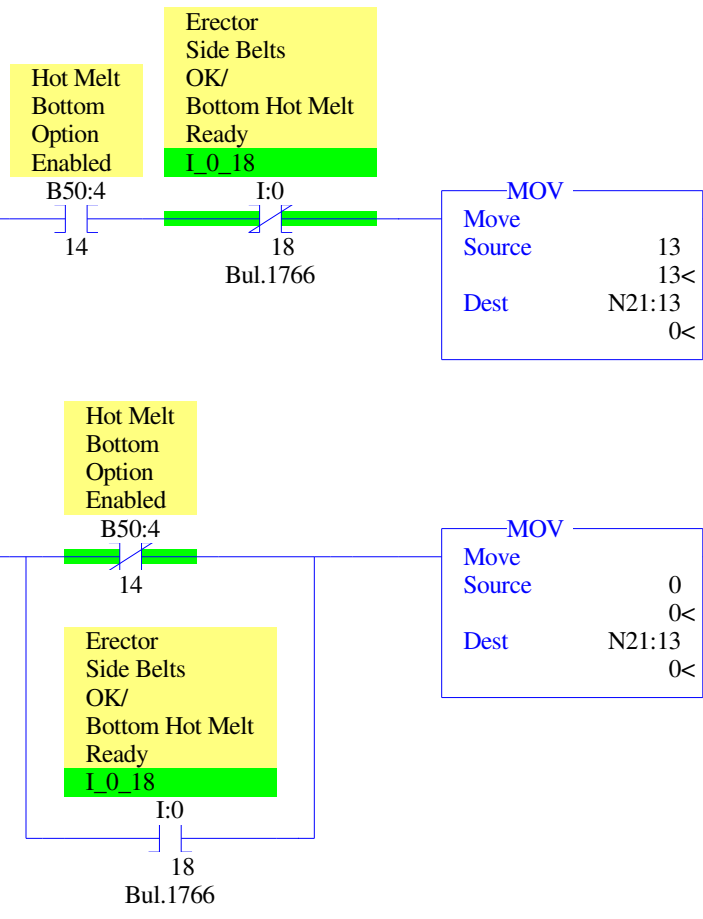




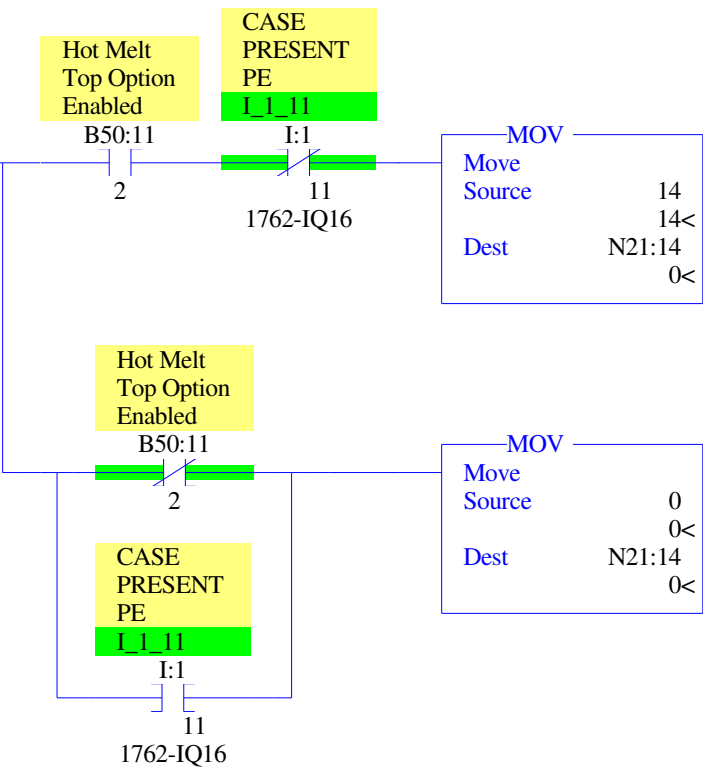
0043



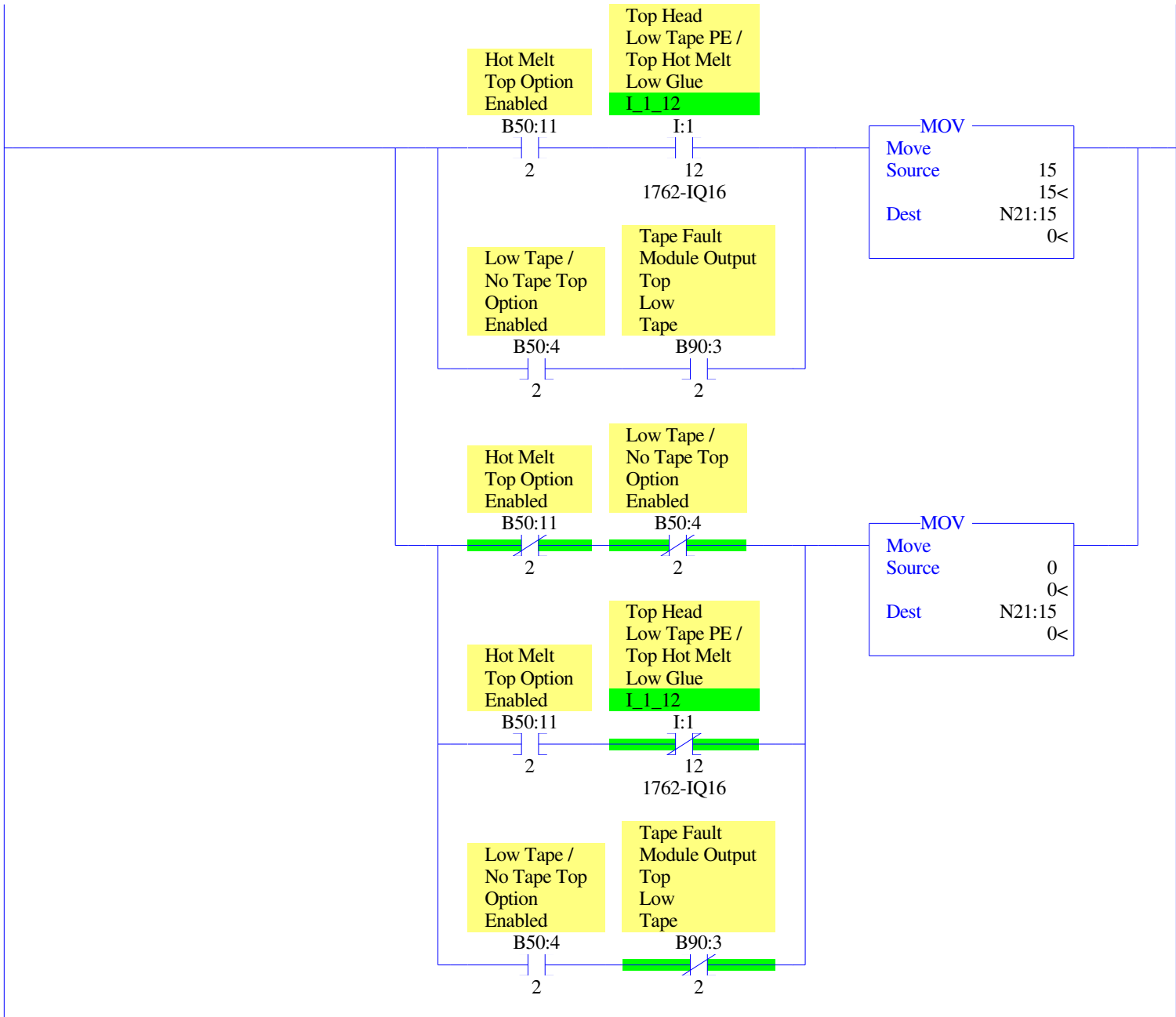
0044



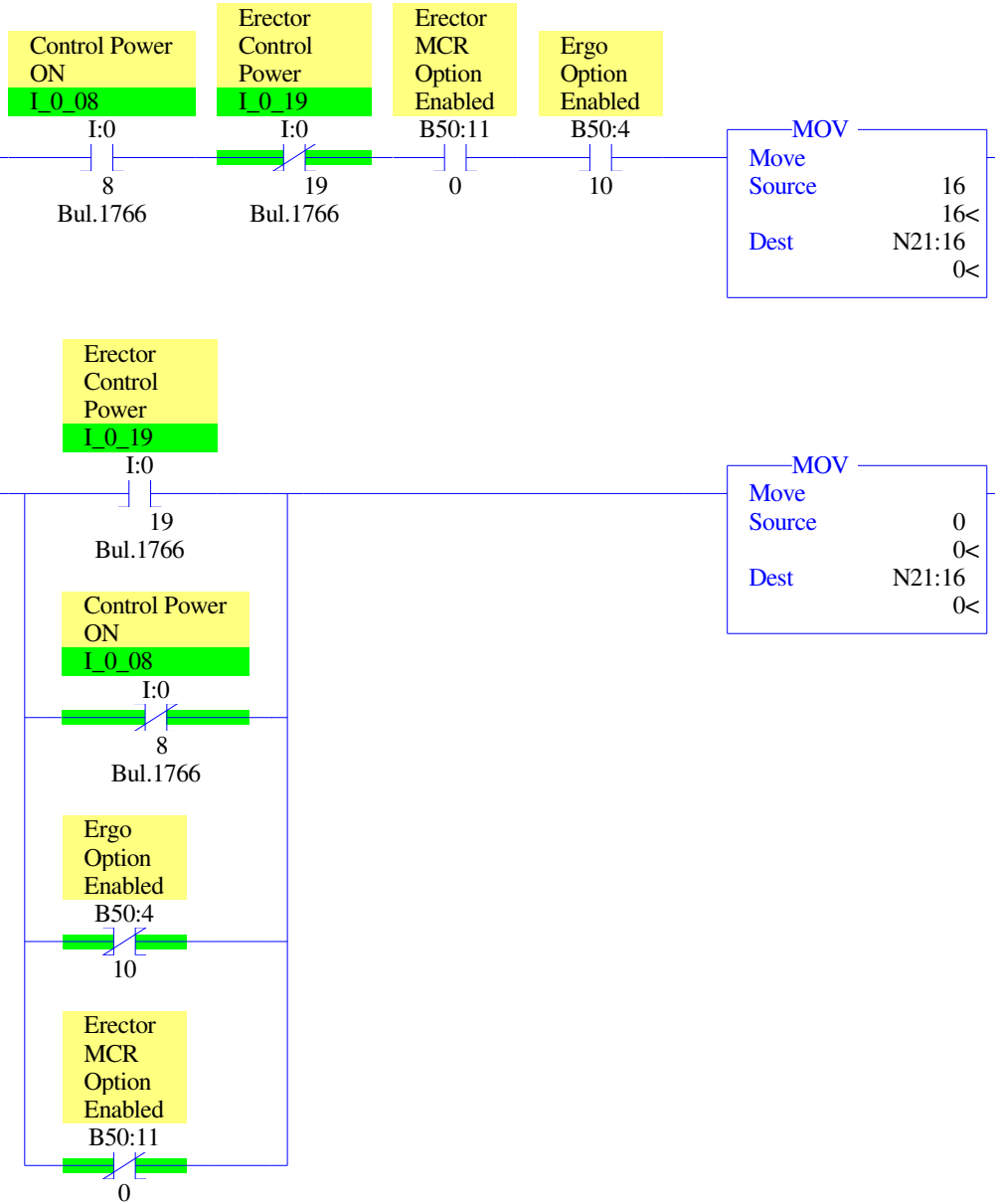
0045



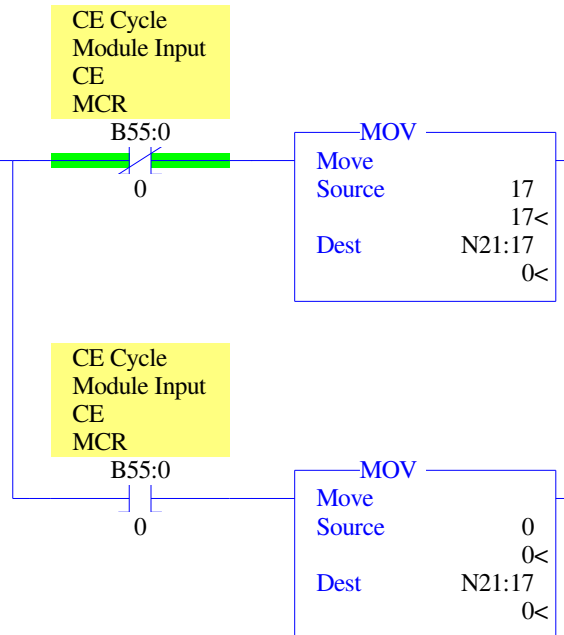
0046



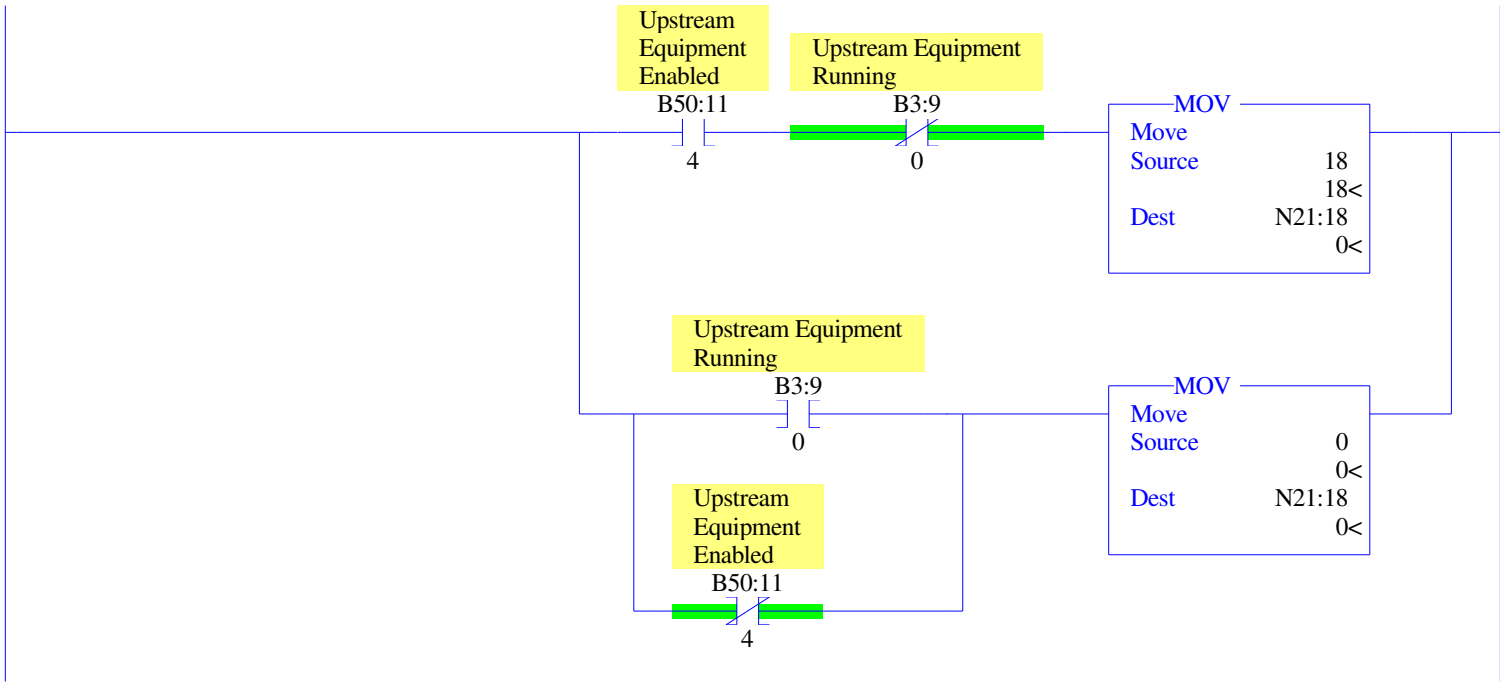
0047

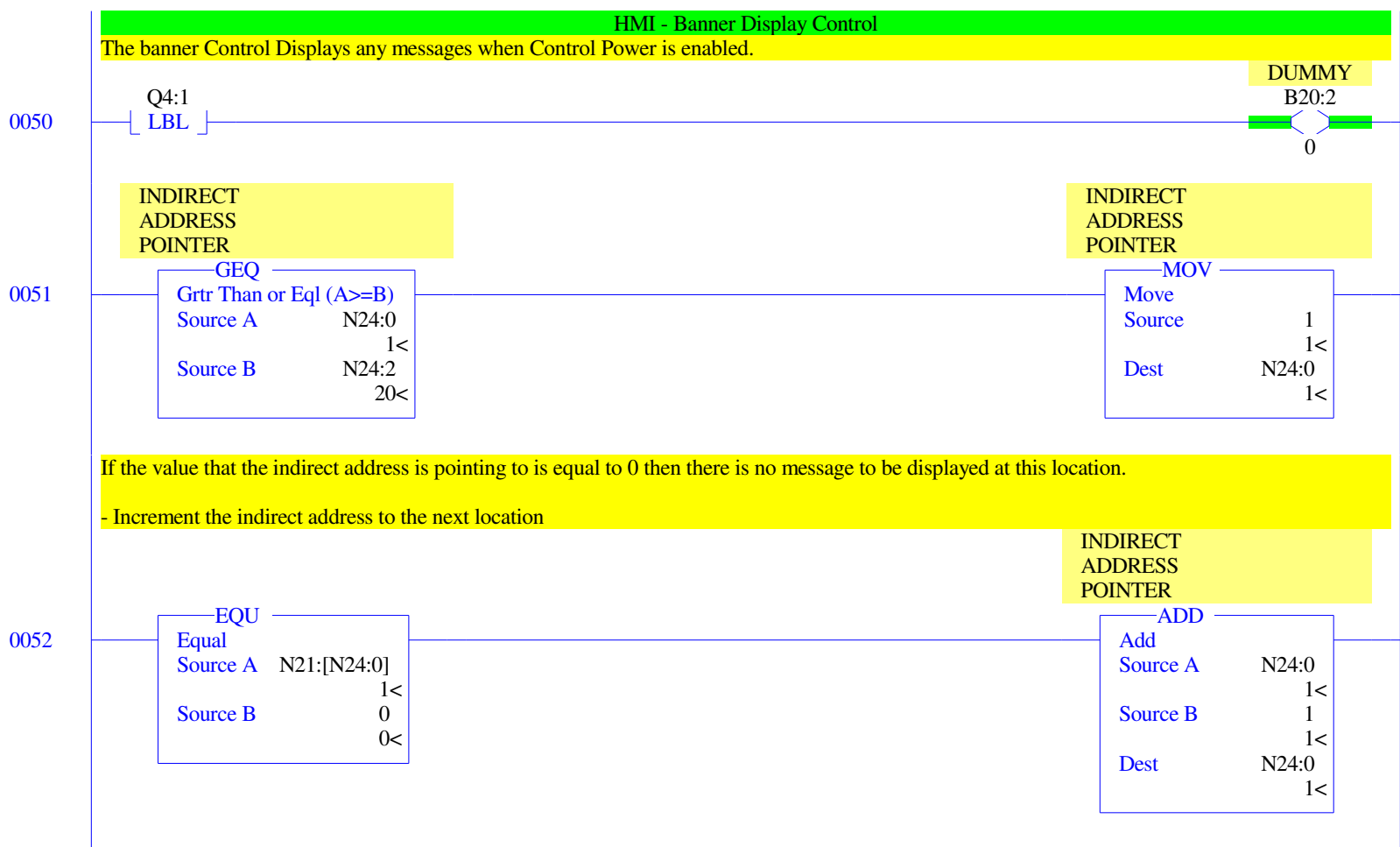


0048



0049

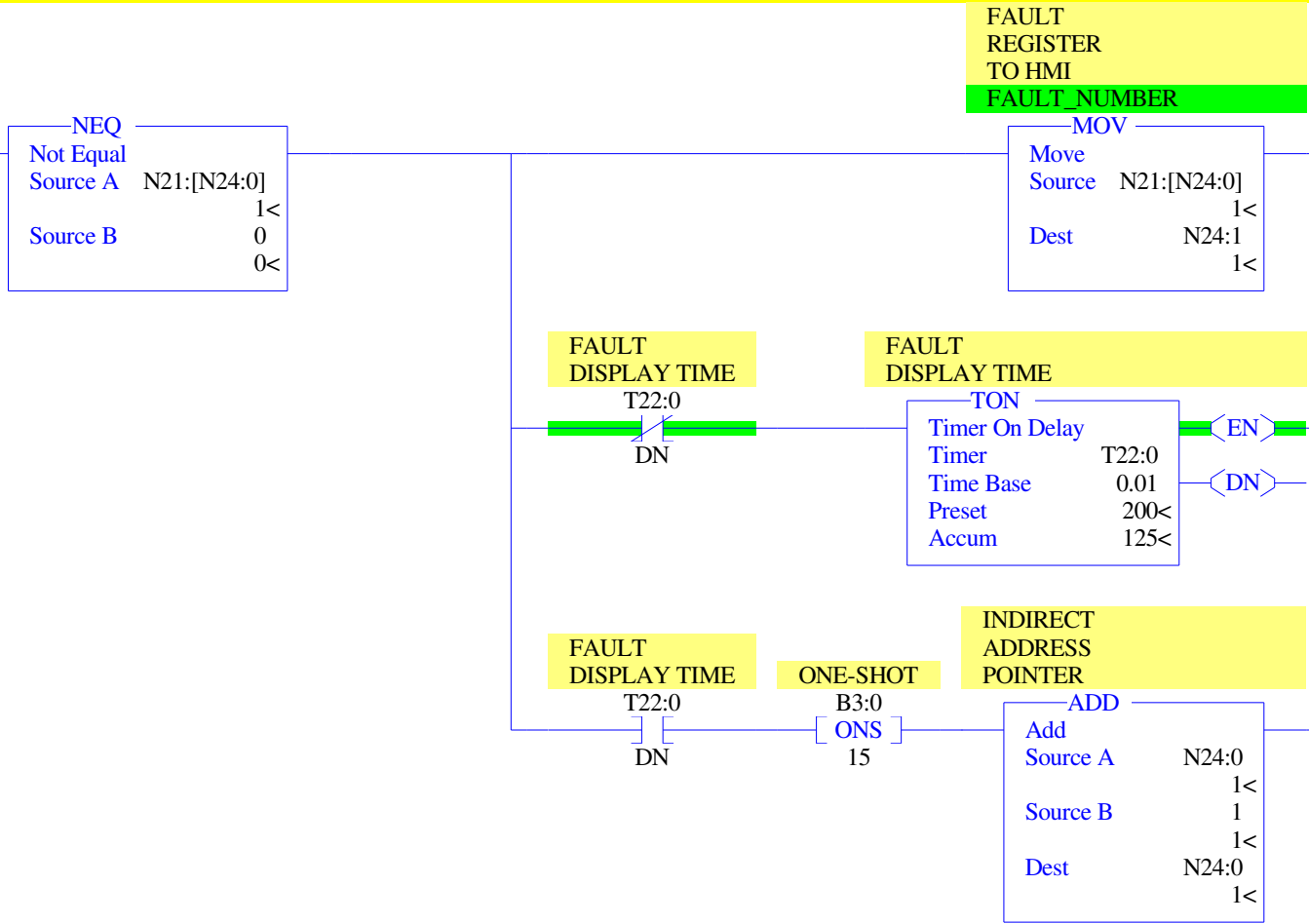




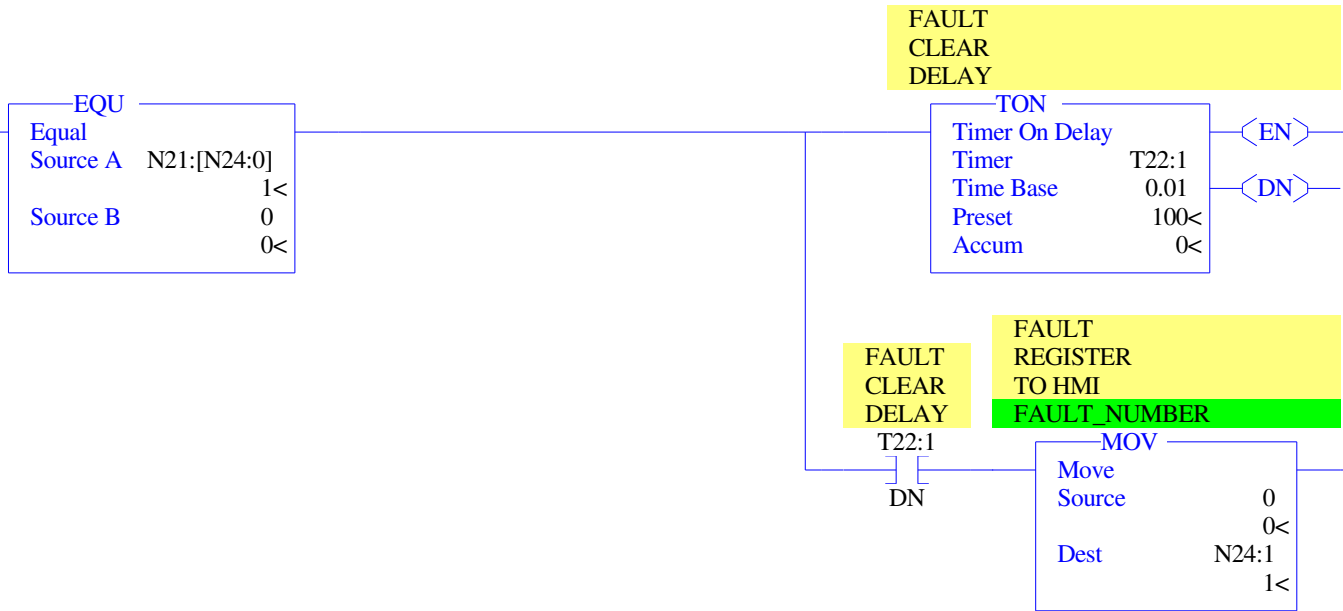
If the value that the indirect address is pointing to is does not equal 0 then there is a message to be displayed at this location.

- Move the number to the HMI Message Display Data location for the HMI to Display that message.
- Wait for the message timer to time out
- Increment the indirect address to the next location

0053

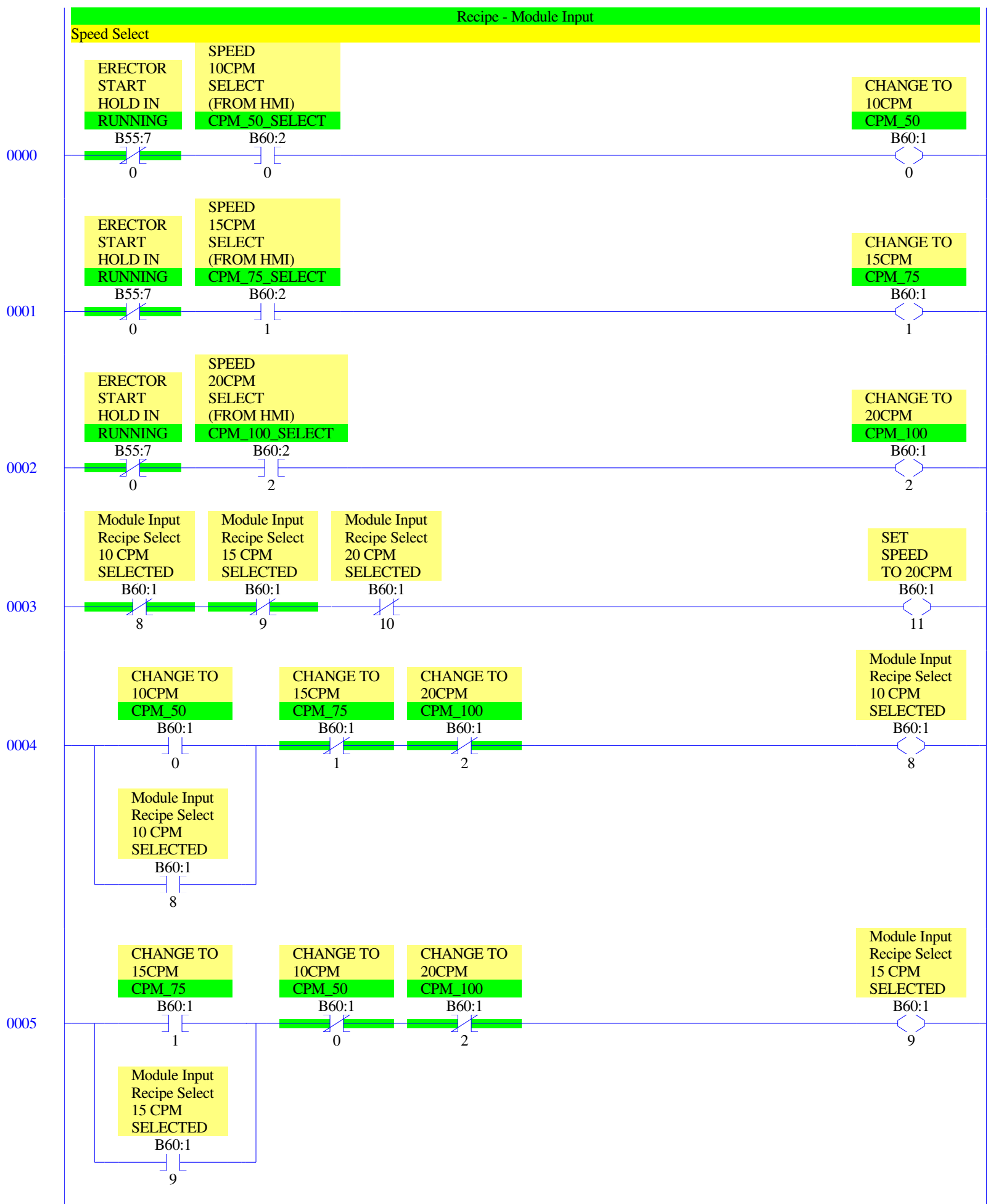


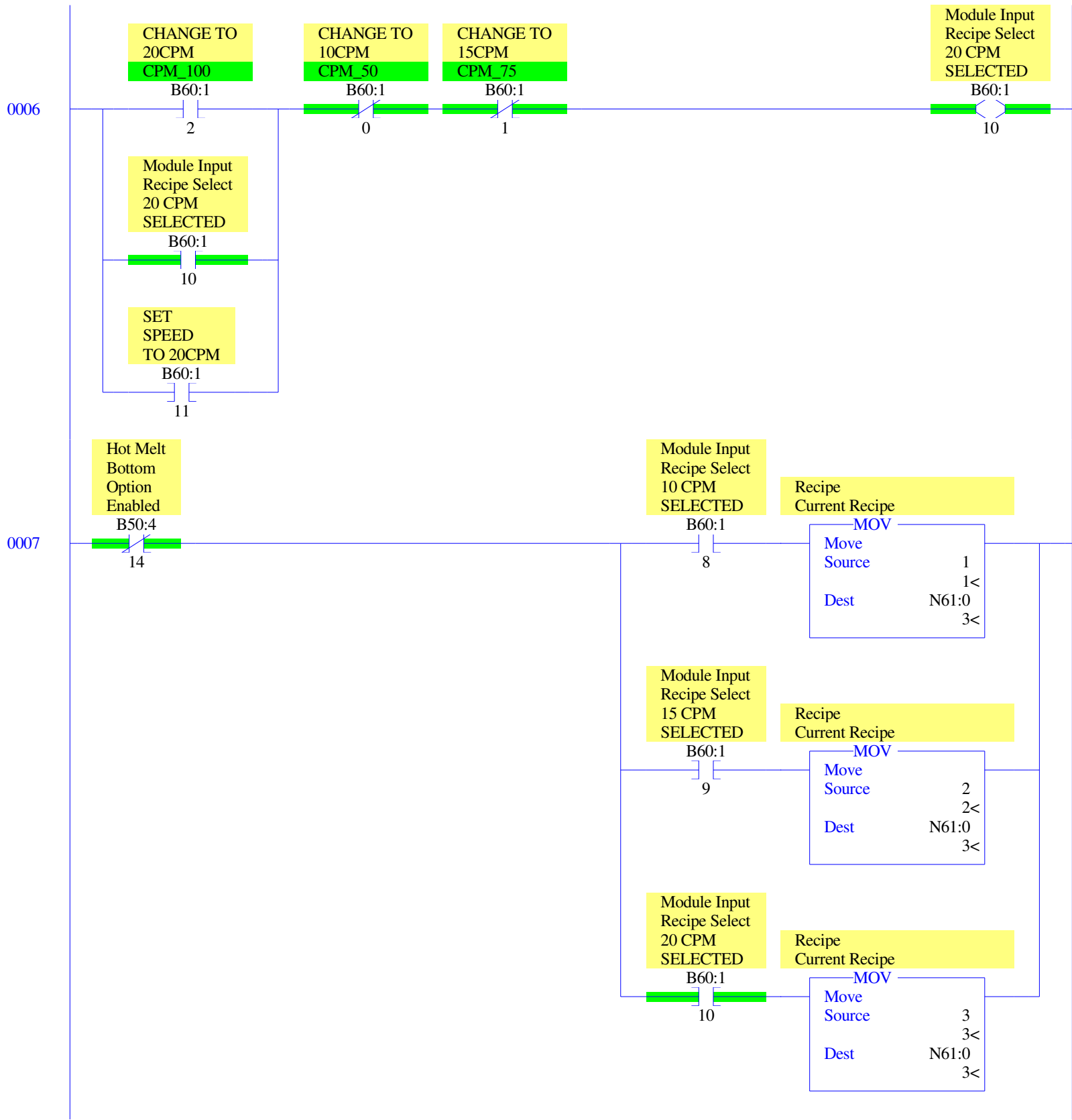
0054

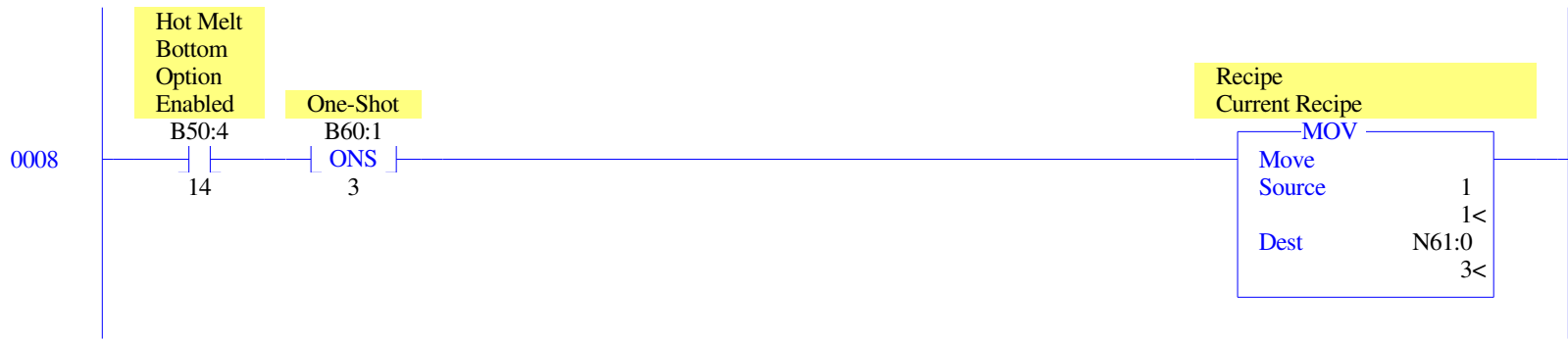


0055

END

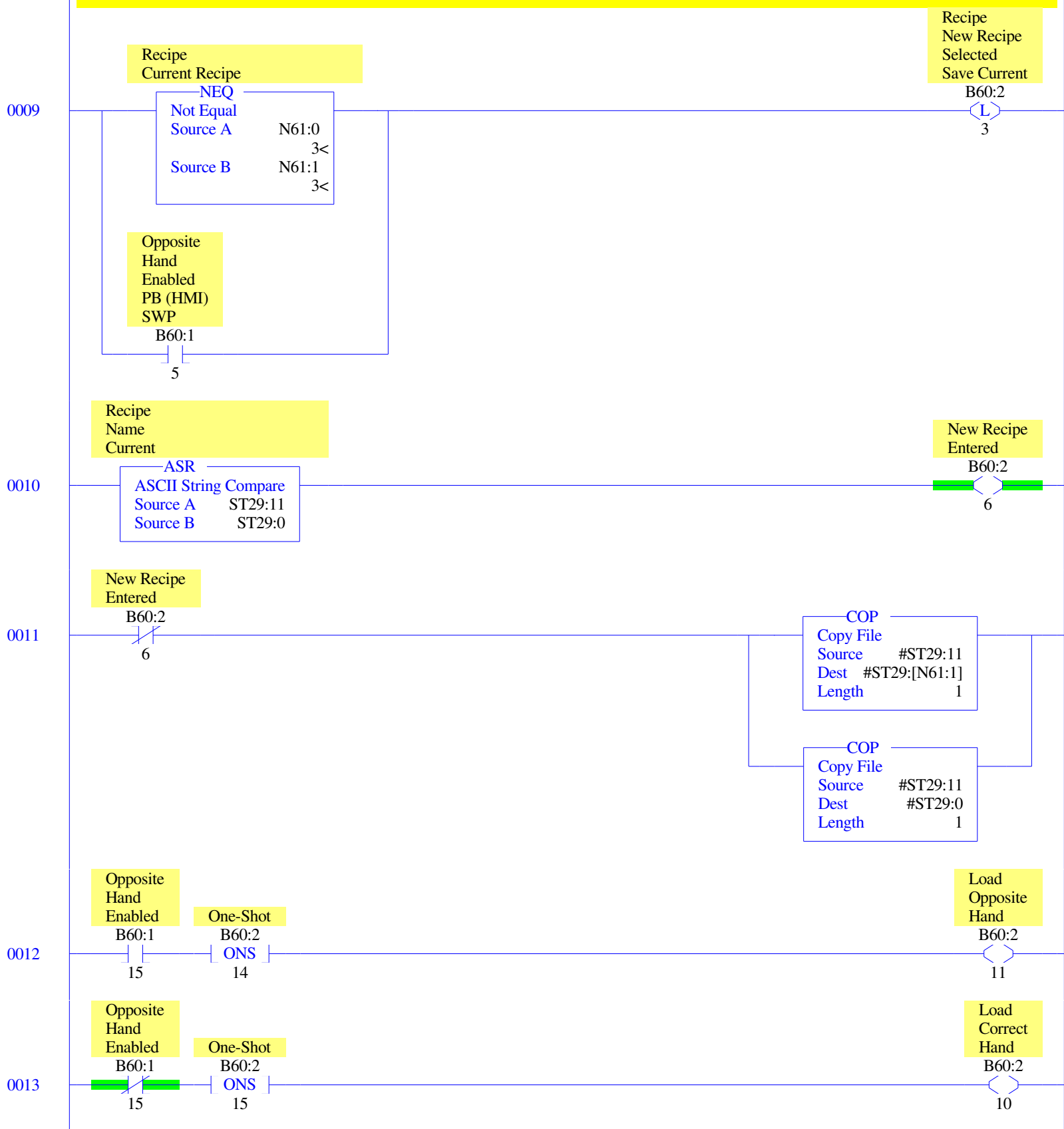






Recipe - Recipe Control

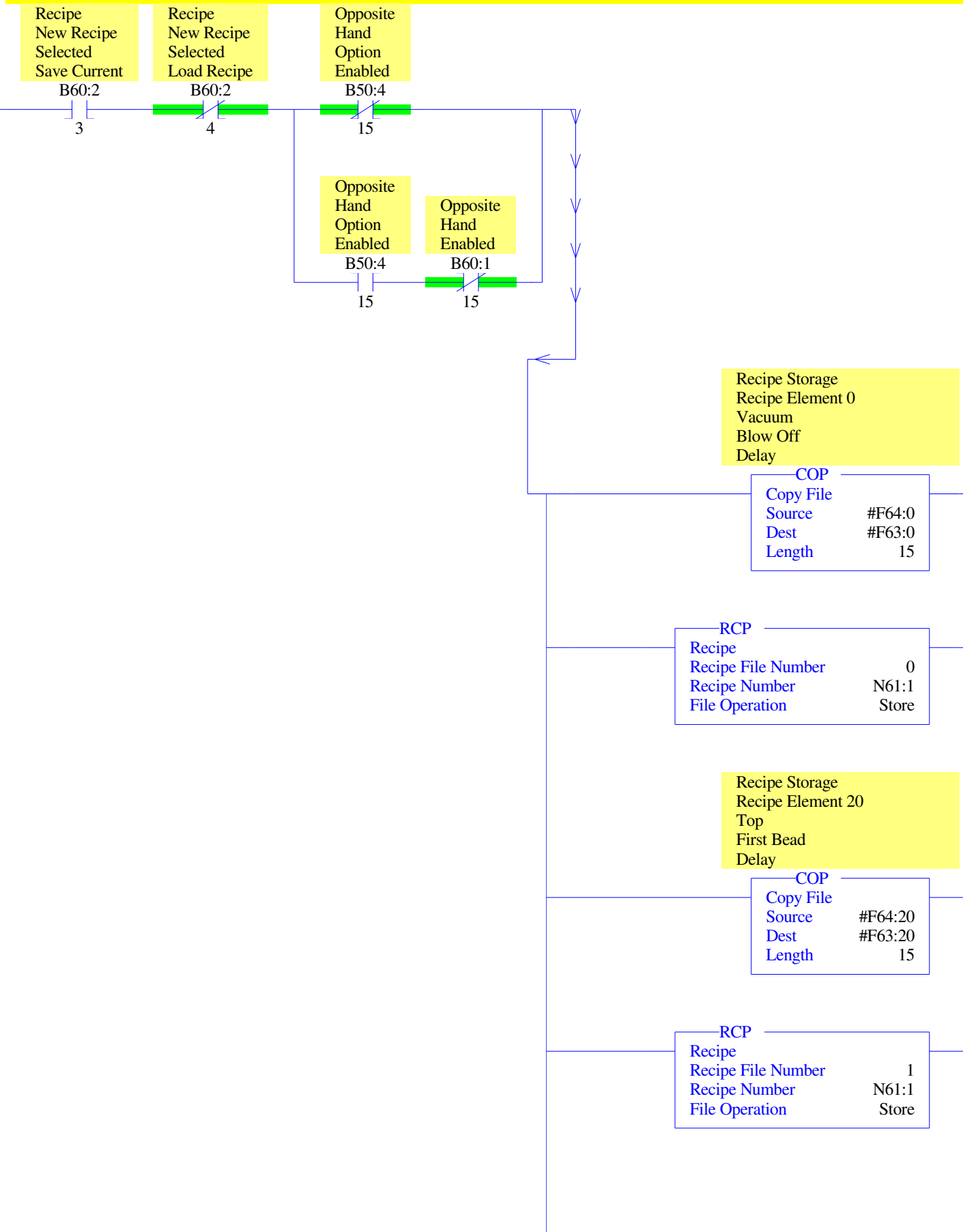
Every time the speed select is changed it will save a copy of the current settings and then Load a copy of the new recipe based on the speed select

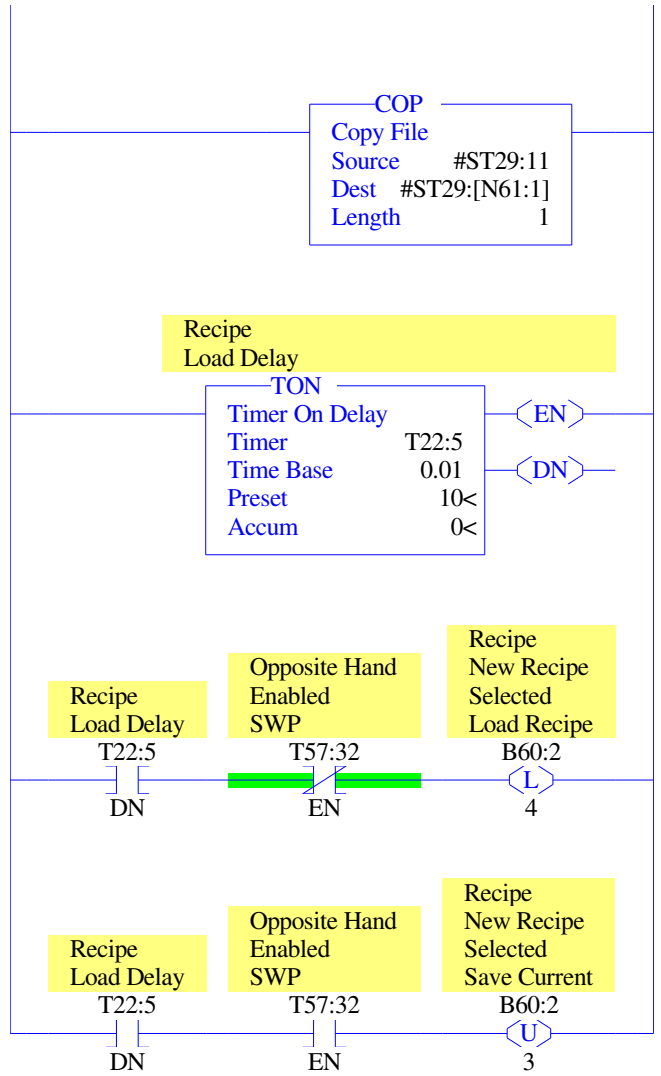


Recipe - Recipe Control

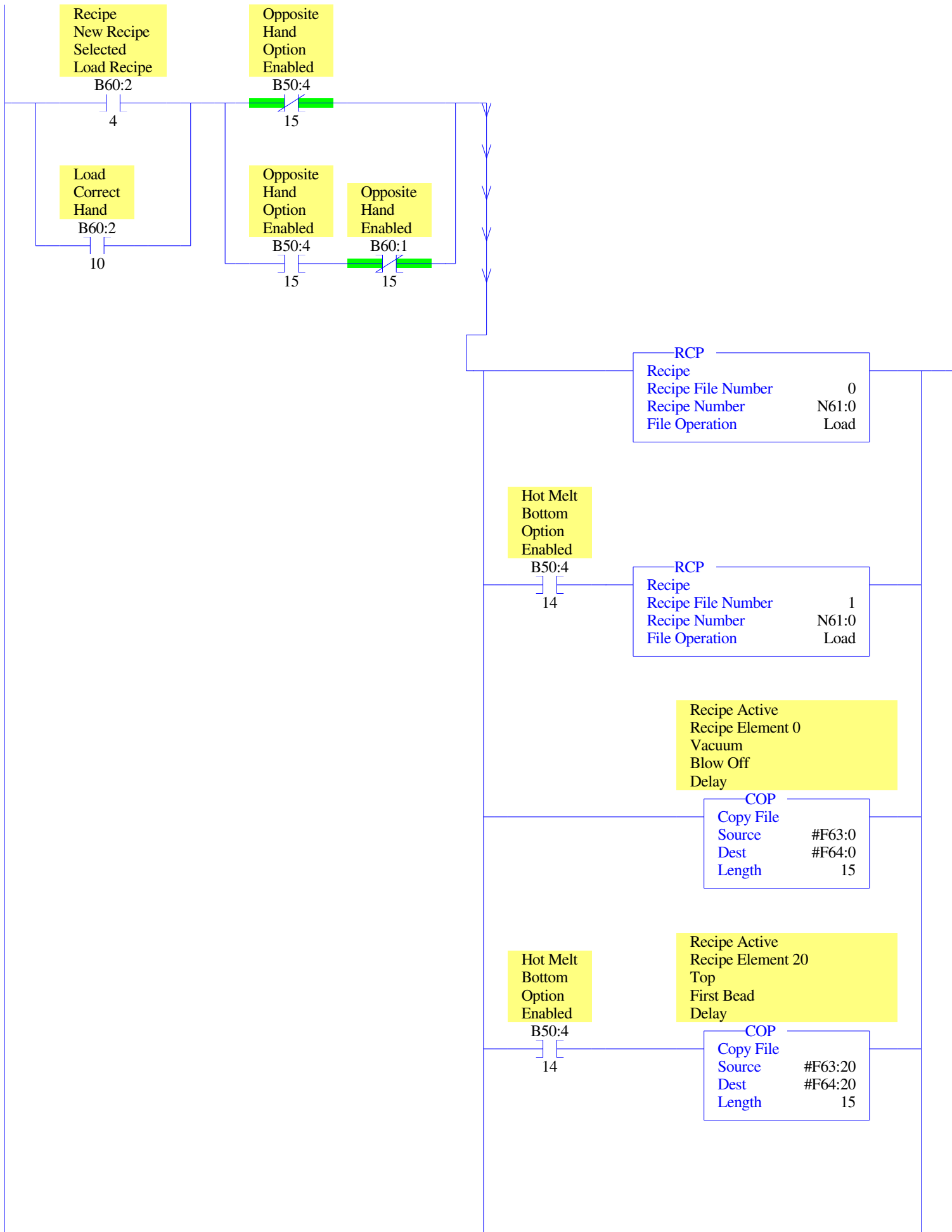
Every time the speed select is changed it will save a copy of the current settings and then Load a copy of the new recipe based on the speed select

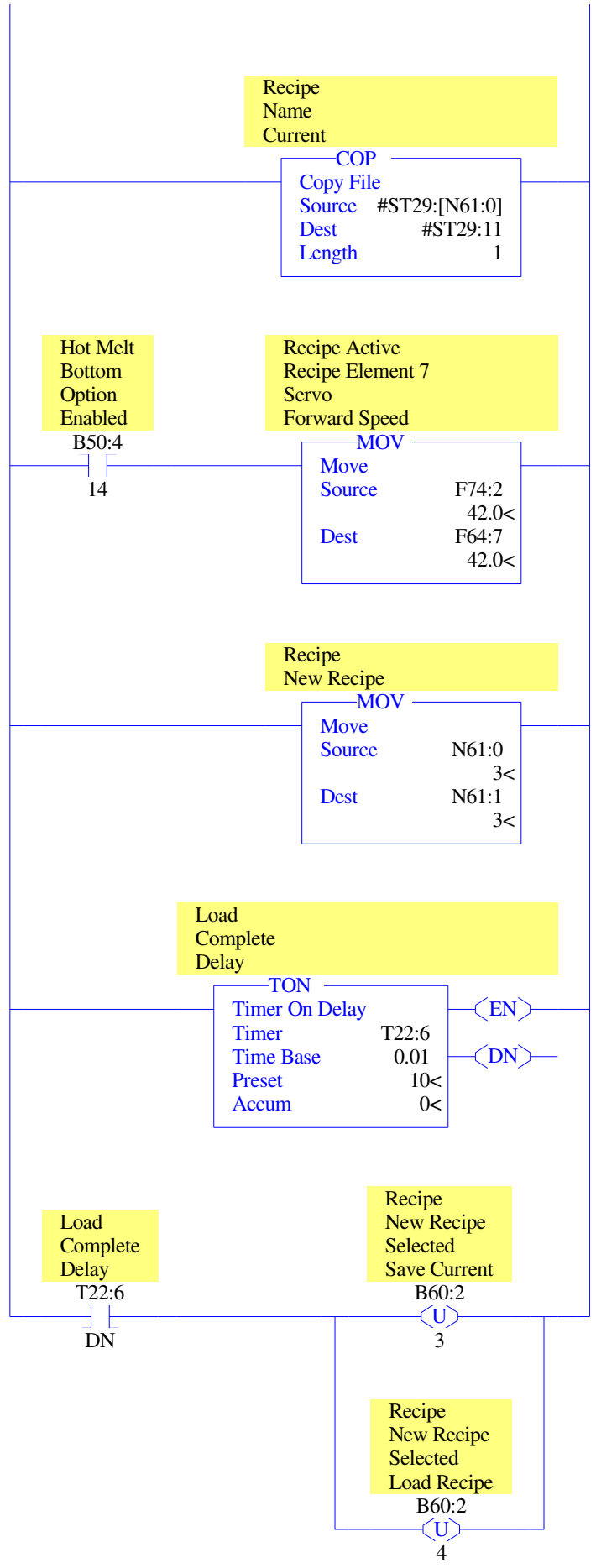
0014





0015





Recipe - Recipe Control

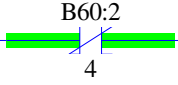
Every time the speed select is changed it will save a copy of the current settings and then Load a copy of the new recipe based on the speed select

0016

Recipe
New Recipe
Selected
Save Current



Recipe
New Recipe
Selected
Load Recipe



Opposite
Hand
Option
Enabled



Opposite
Hand
Enabled



Recipe Storage
Recipe Element 0
Vacuum
Blow Off
Delay

COP
Copy File
Source #F64:0
Dest #F63:0
Length 15

RCP
Recipe
Recipe File Number 1
Recipe Number N61:1
File Operation Store

Recipe Storage
Recipe Element 20
Top
First Bead
Delay

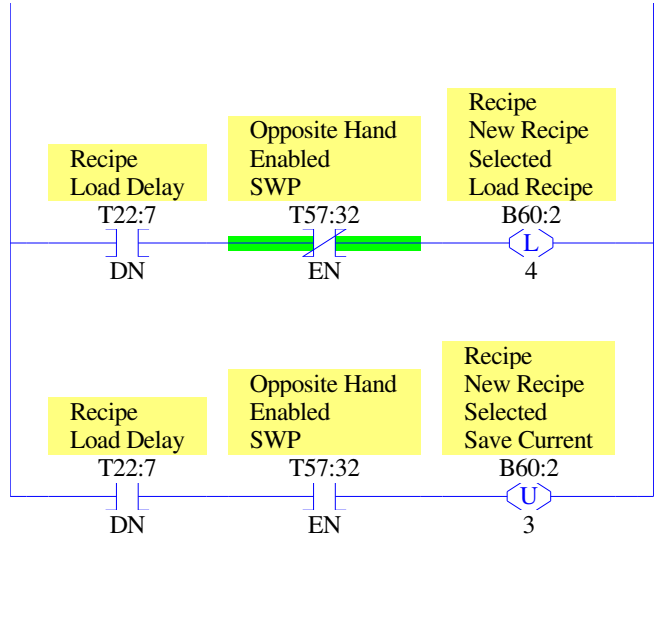
COP
Copy File
Source #F64:20
Dest #F63:20
Length 15

RCP
Recipe
Recipe File Number 2
Recipe Number N61:1
File Operation Store

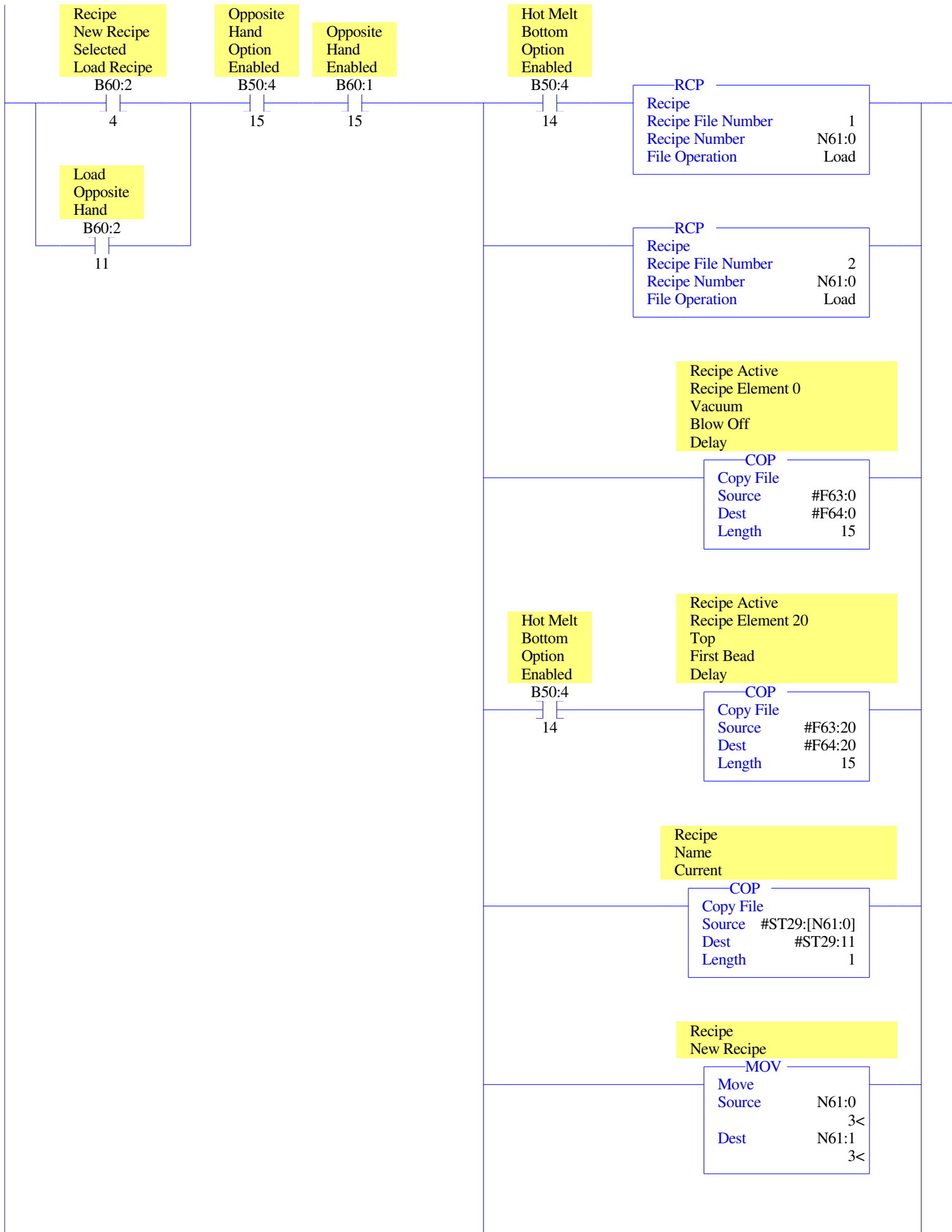
COP
Copy File
Source #ST29:11
Dest #ST29:[N61:1]
Length 1

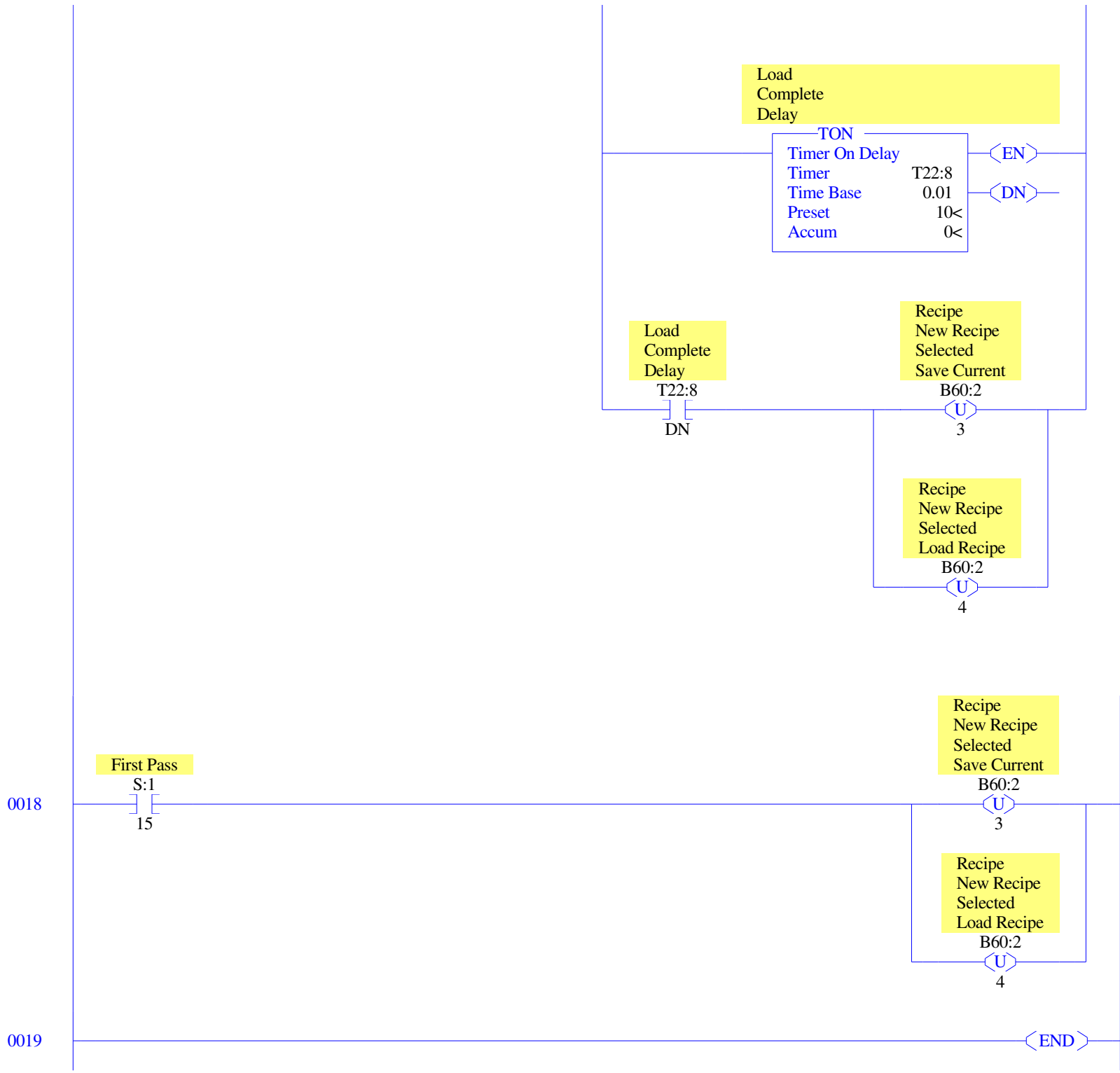
Recipe
Load Delay

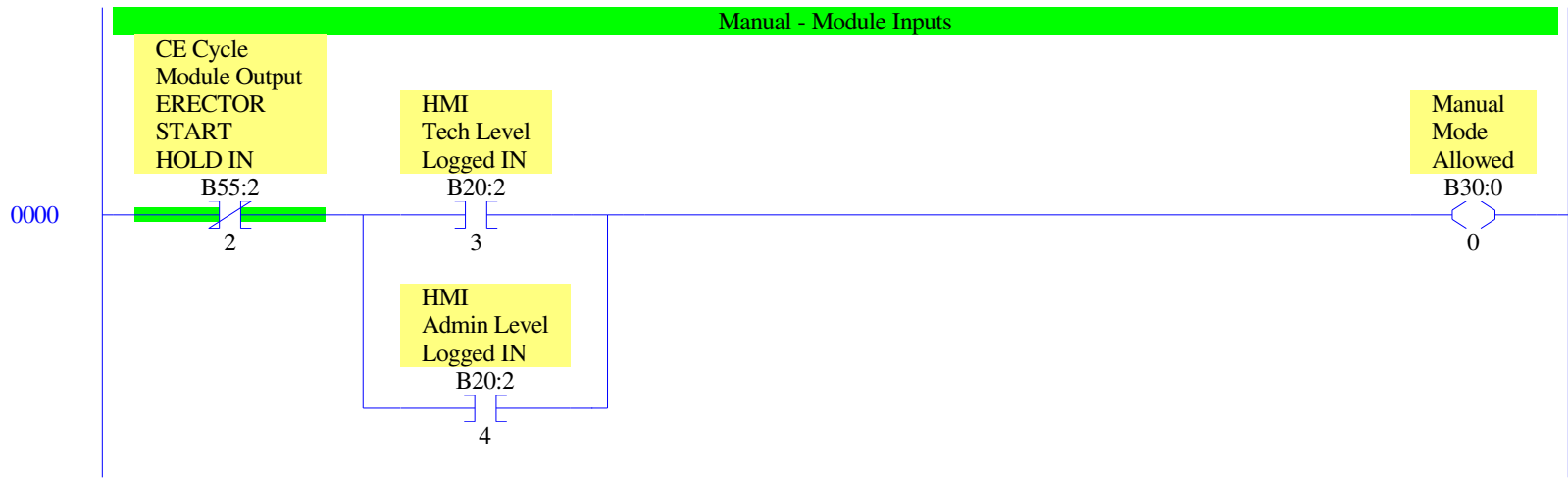
TON
Timer On Delay
Timer T22:7
Time Base 0.01
Preset 10<
Accum 0<

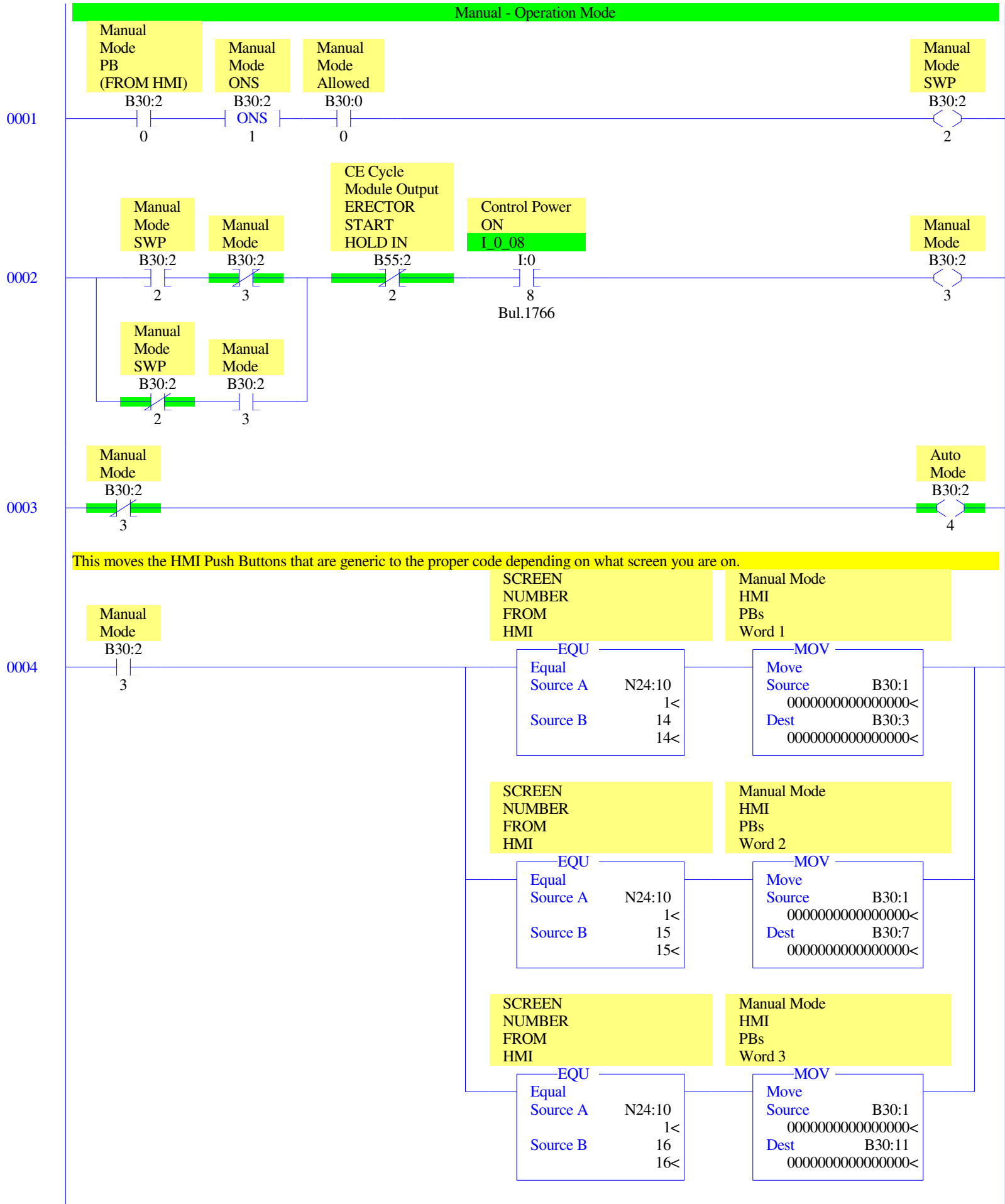


0017









This clears the HMI latched outputs if you are no longer in Manual Mode

0005

Manual Mode
B30:2
3

Manual Mode
Latched
Outputs
Word 1

MOV
Move
Source 0
0<
Dest B30:6
0000000000000000<

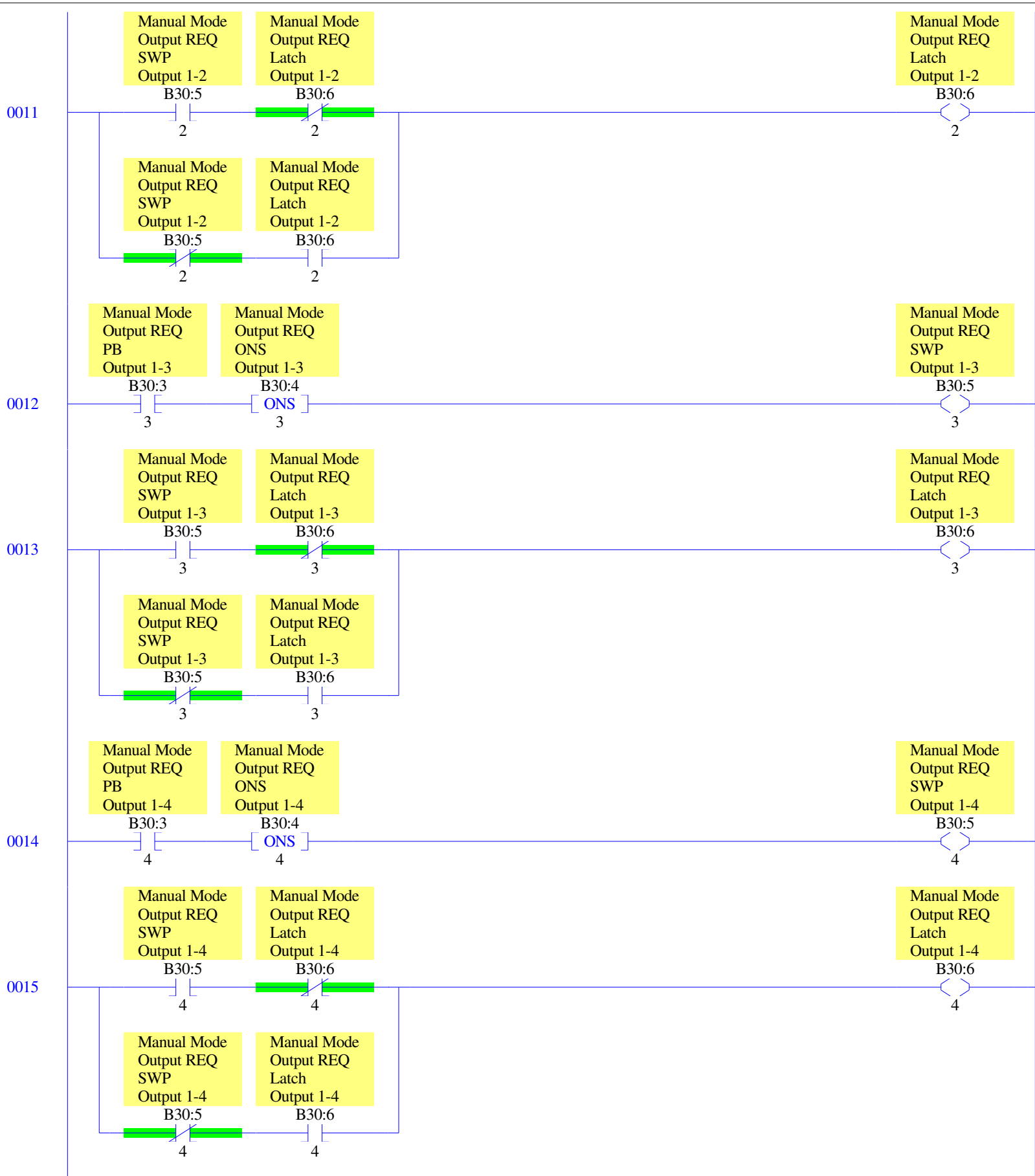
Manual Mode
Latched
Outputs
Word 2

MOV
Move
Source 0
0<
Dest B30:10
0000000000000000<

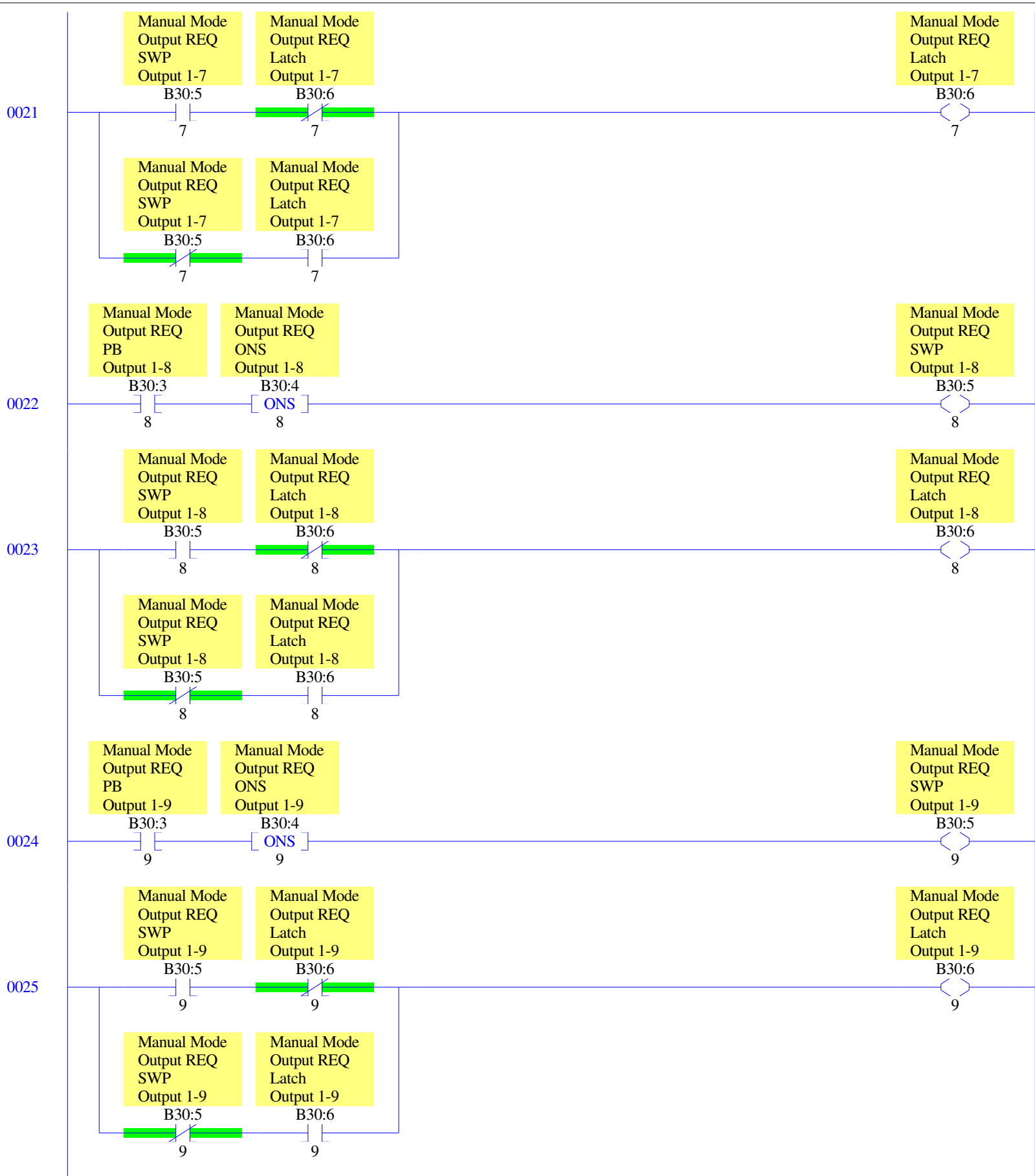
Manual Mode
Latched
Outputs
Word 3

MOV
Move
Source 0
0<
Dest B30:14
0000000000000000<

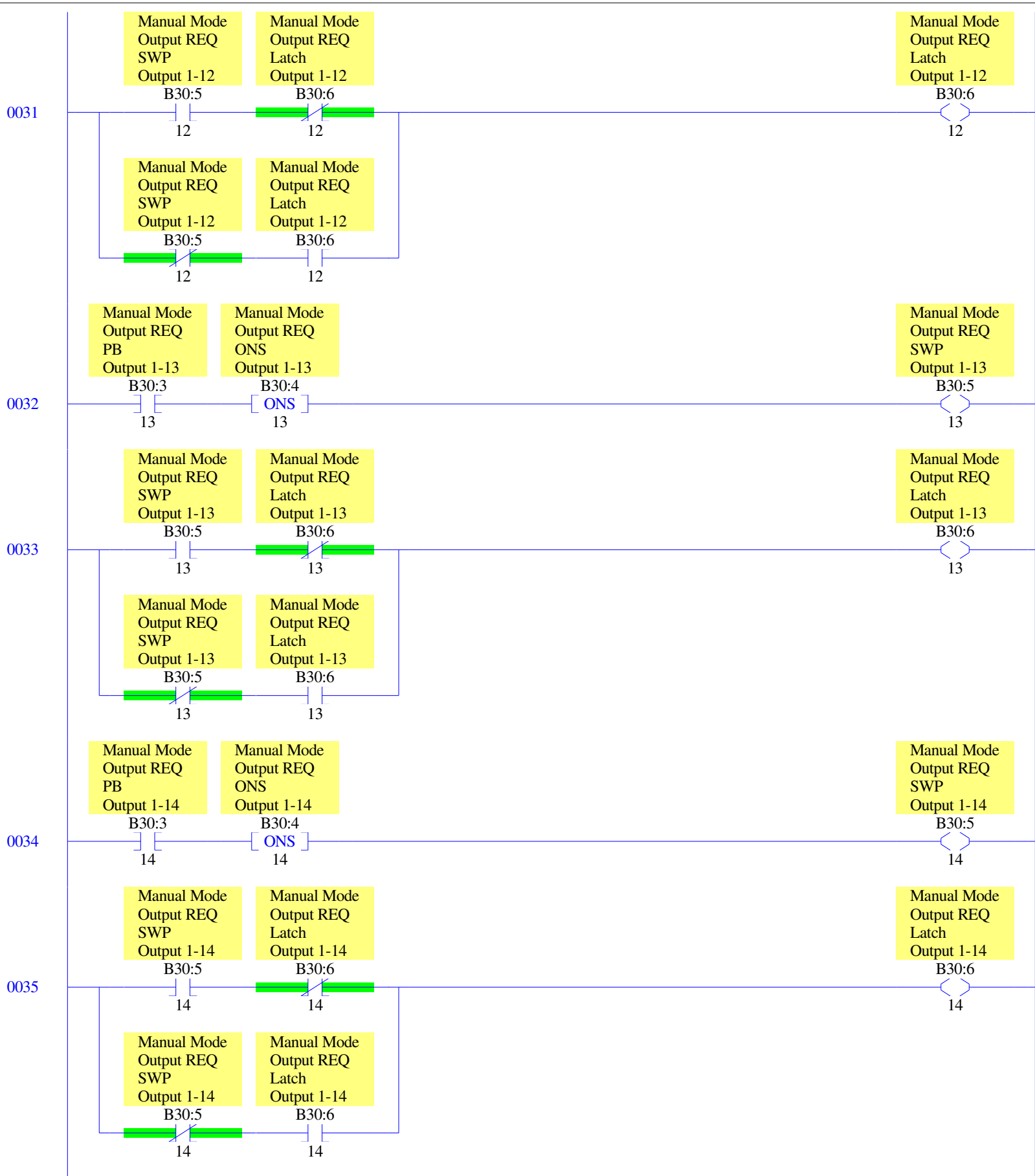


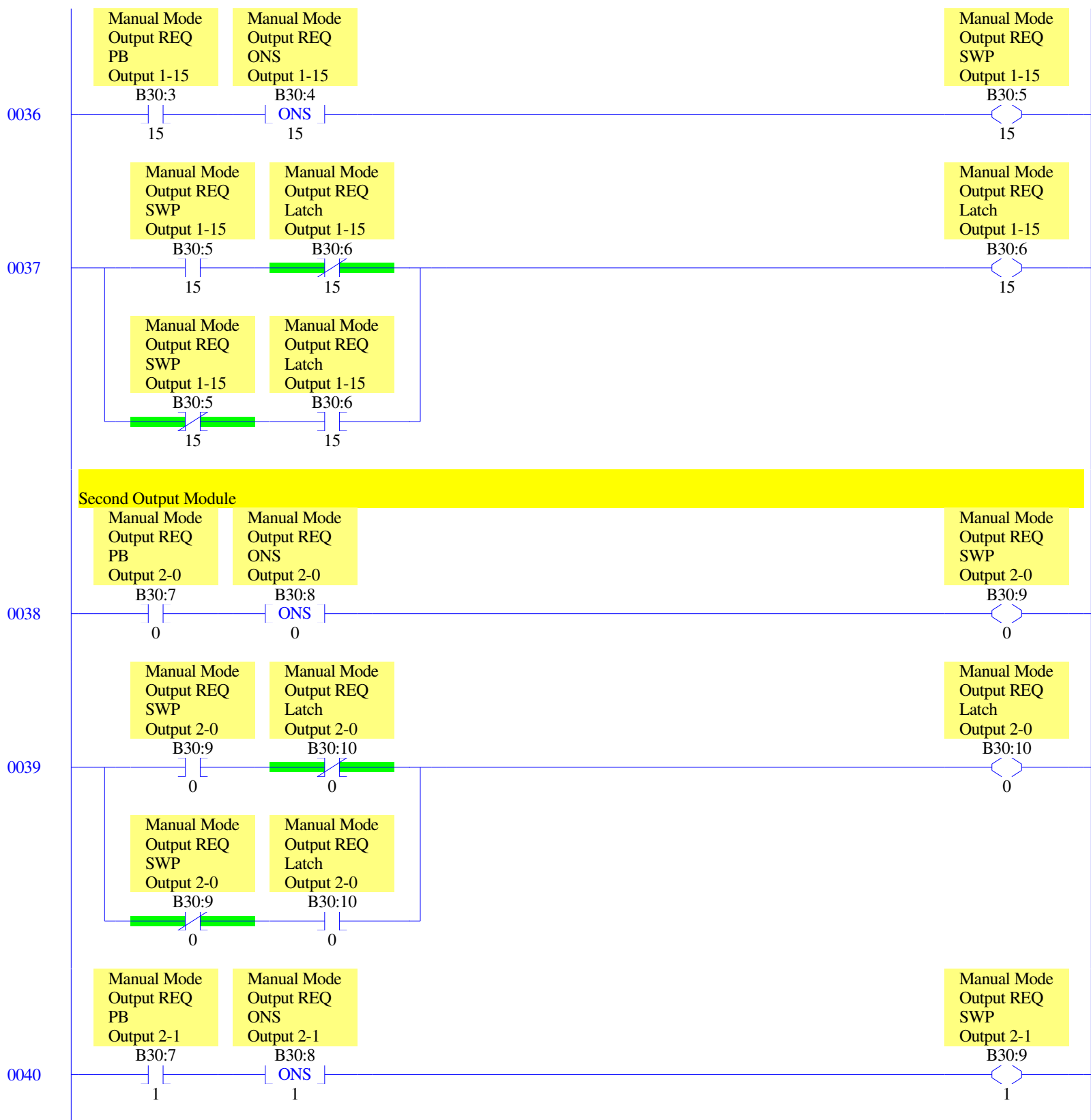


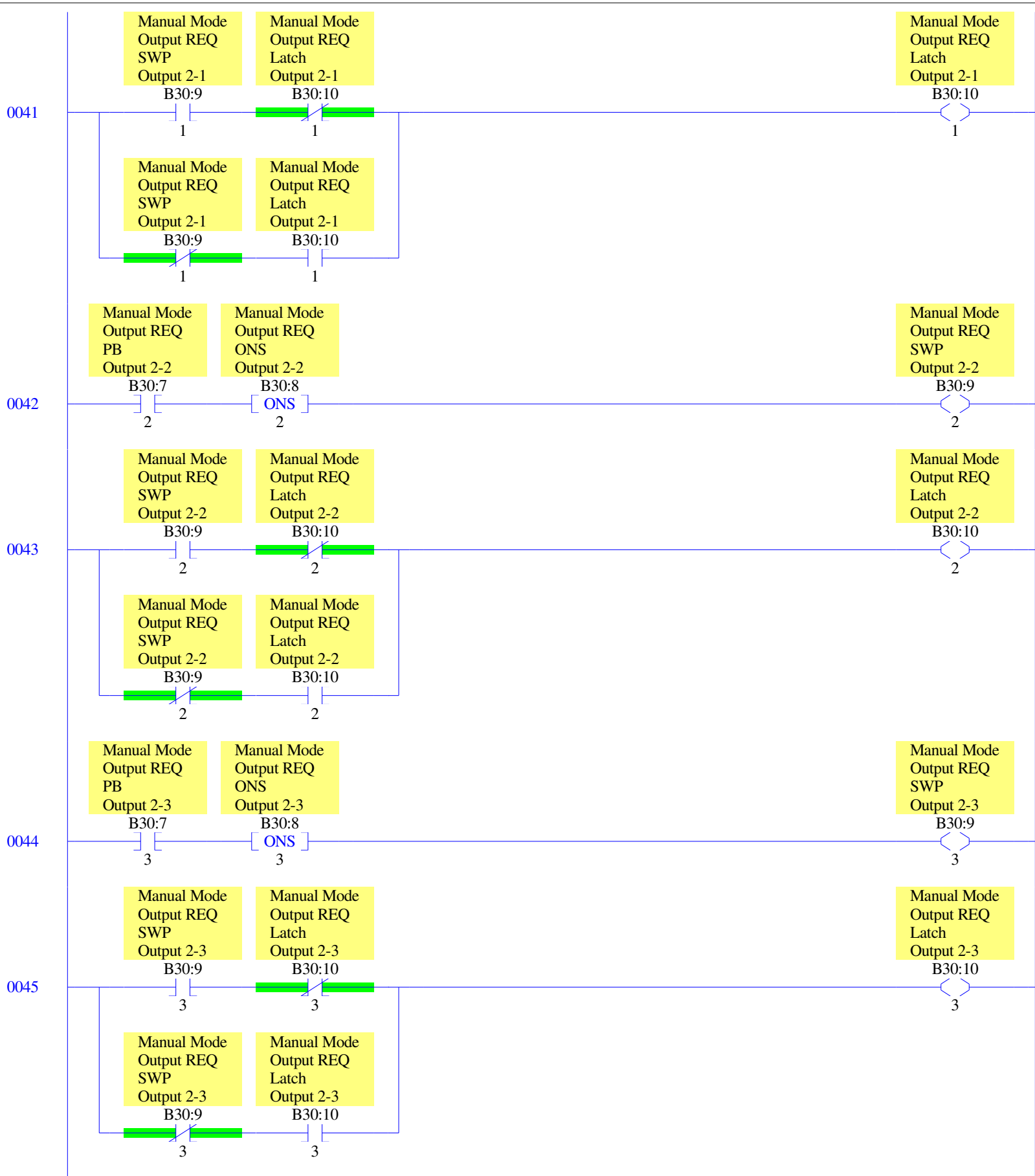




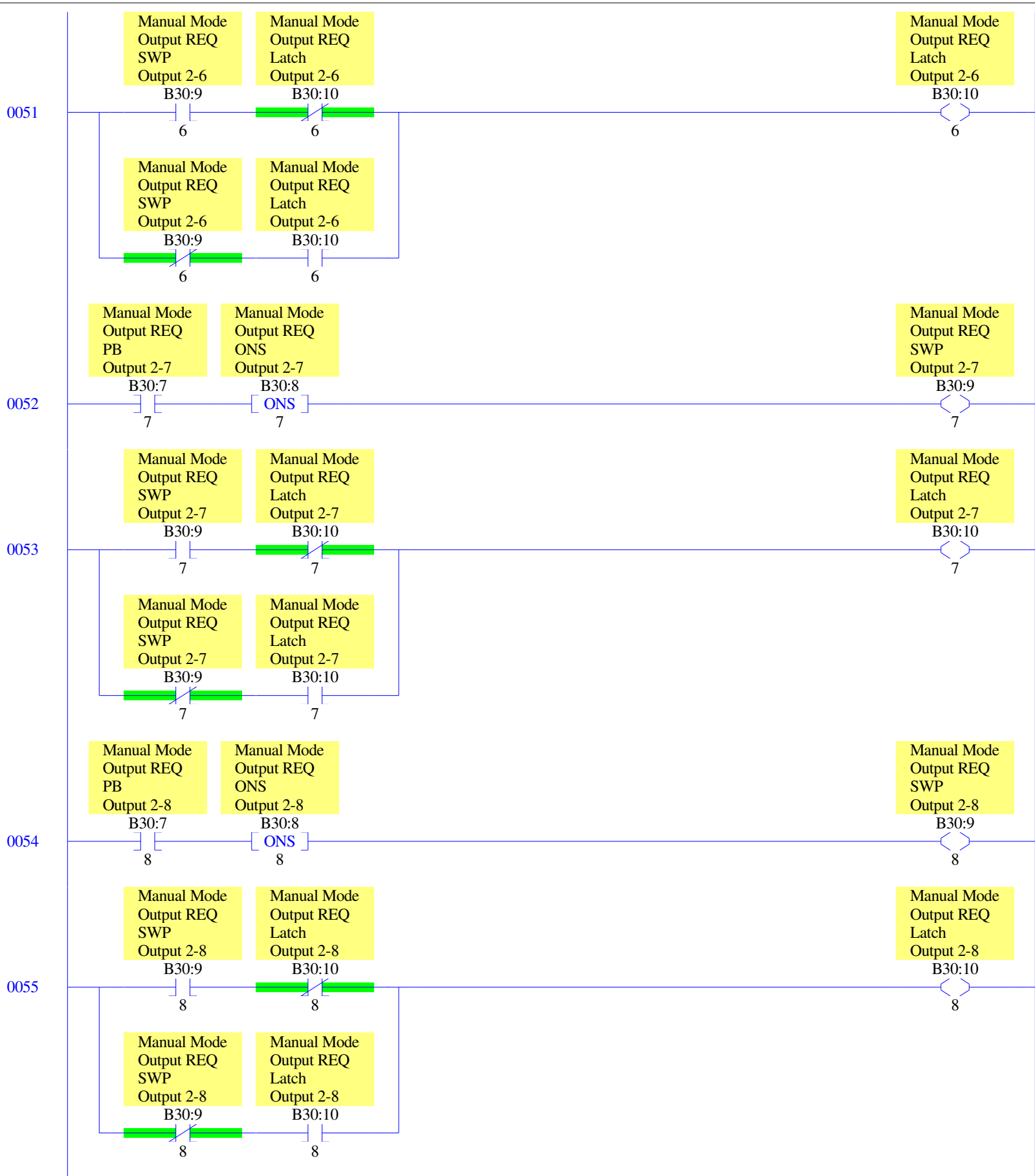




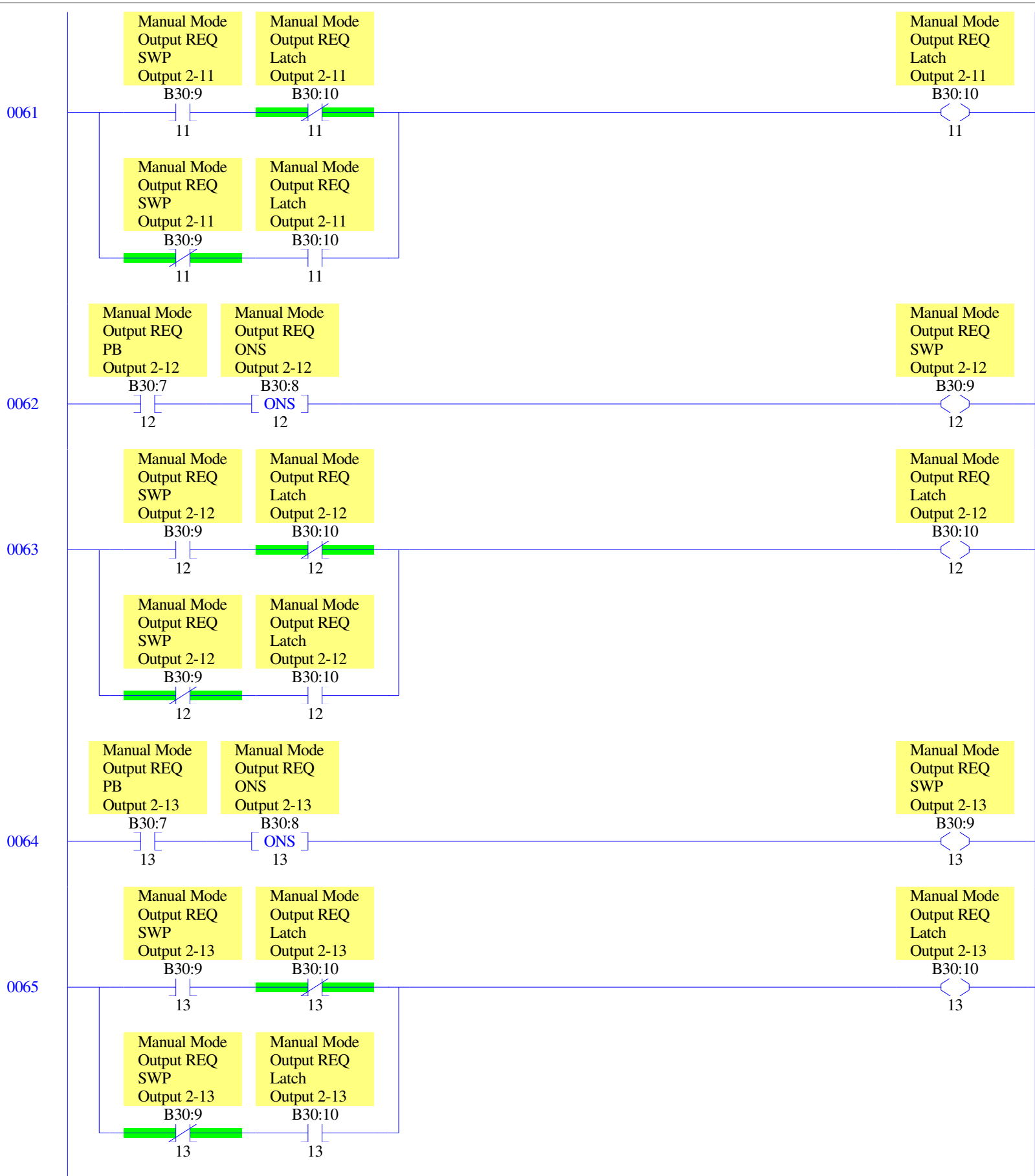


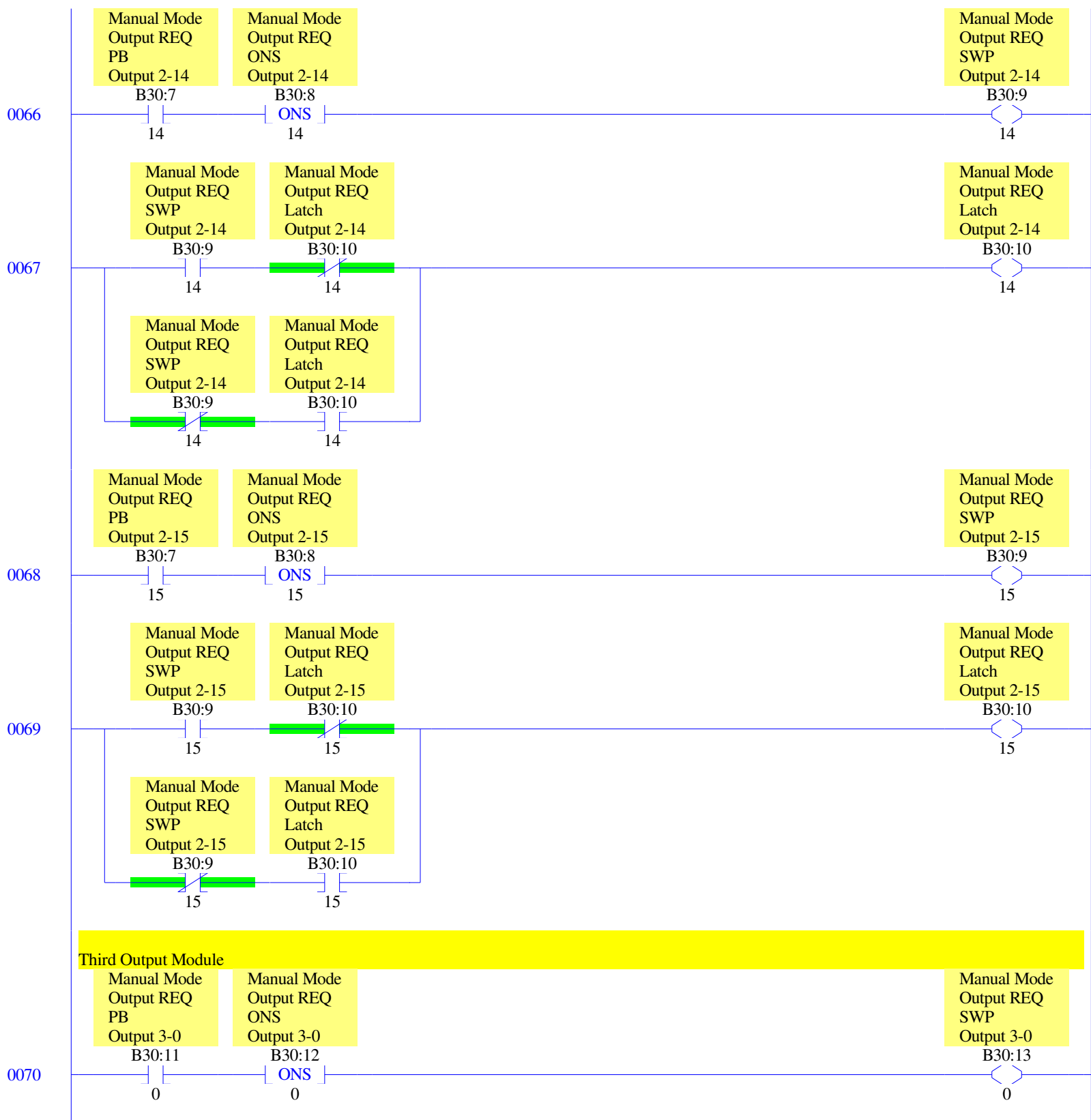


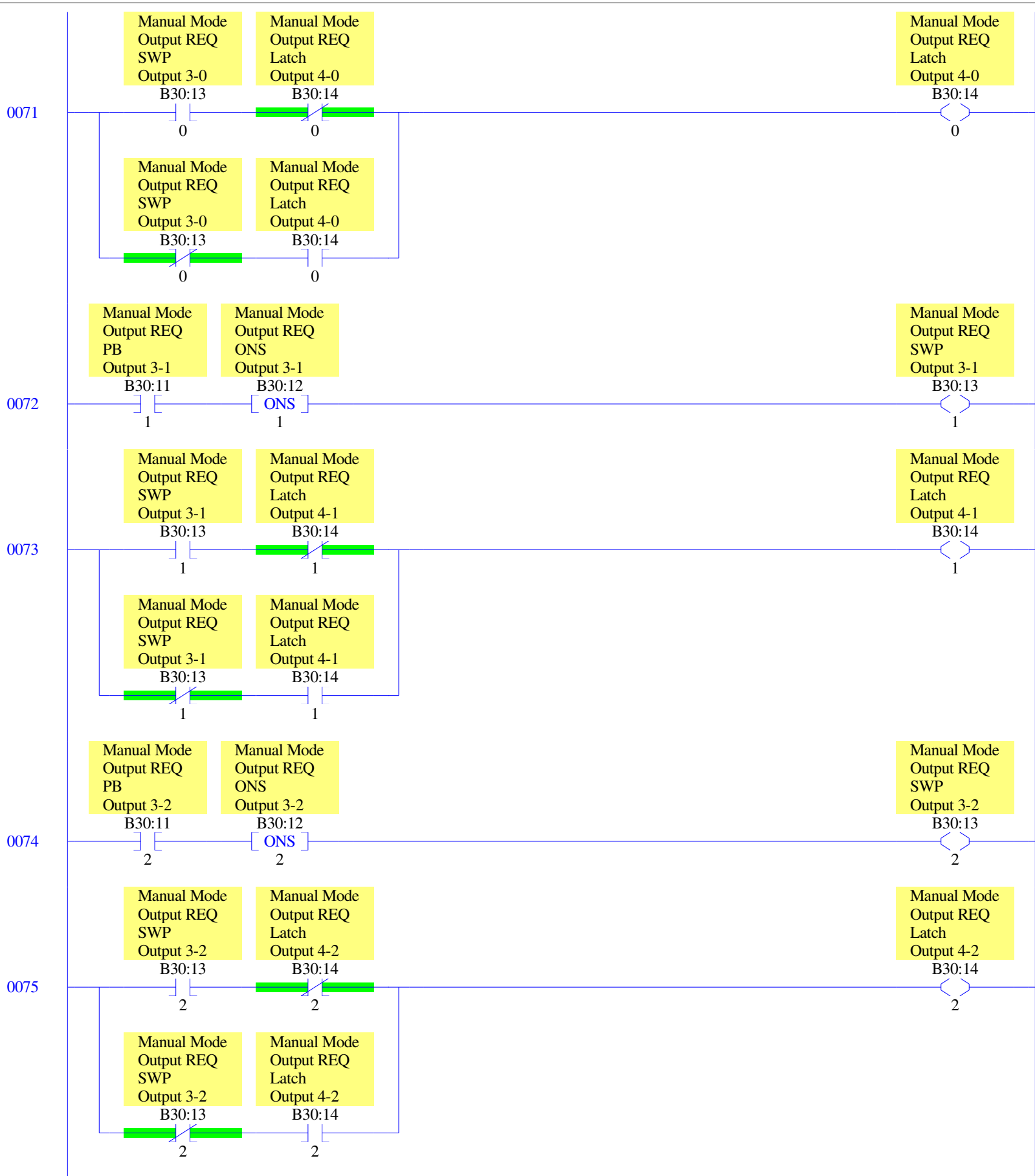




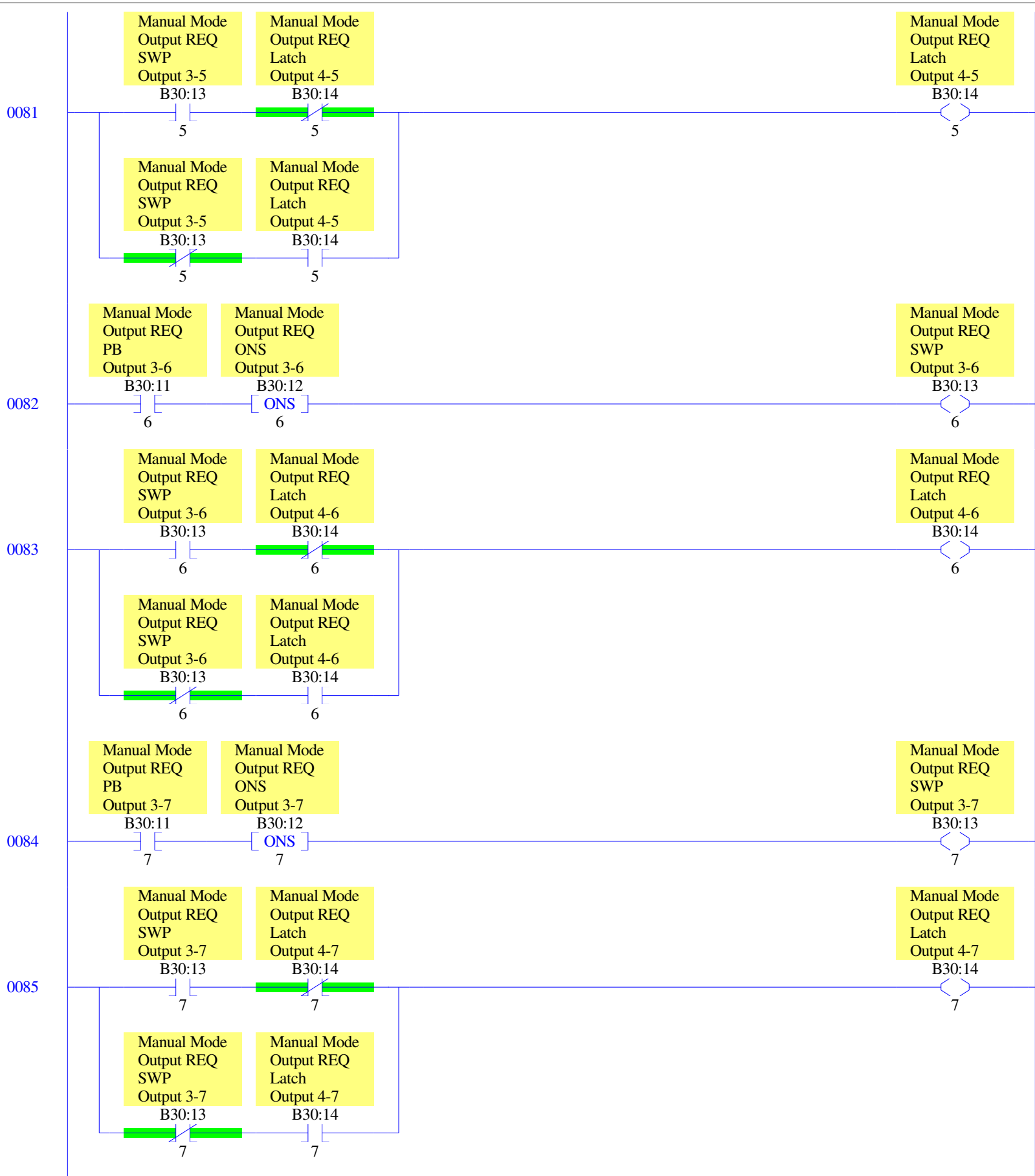




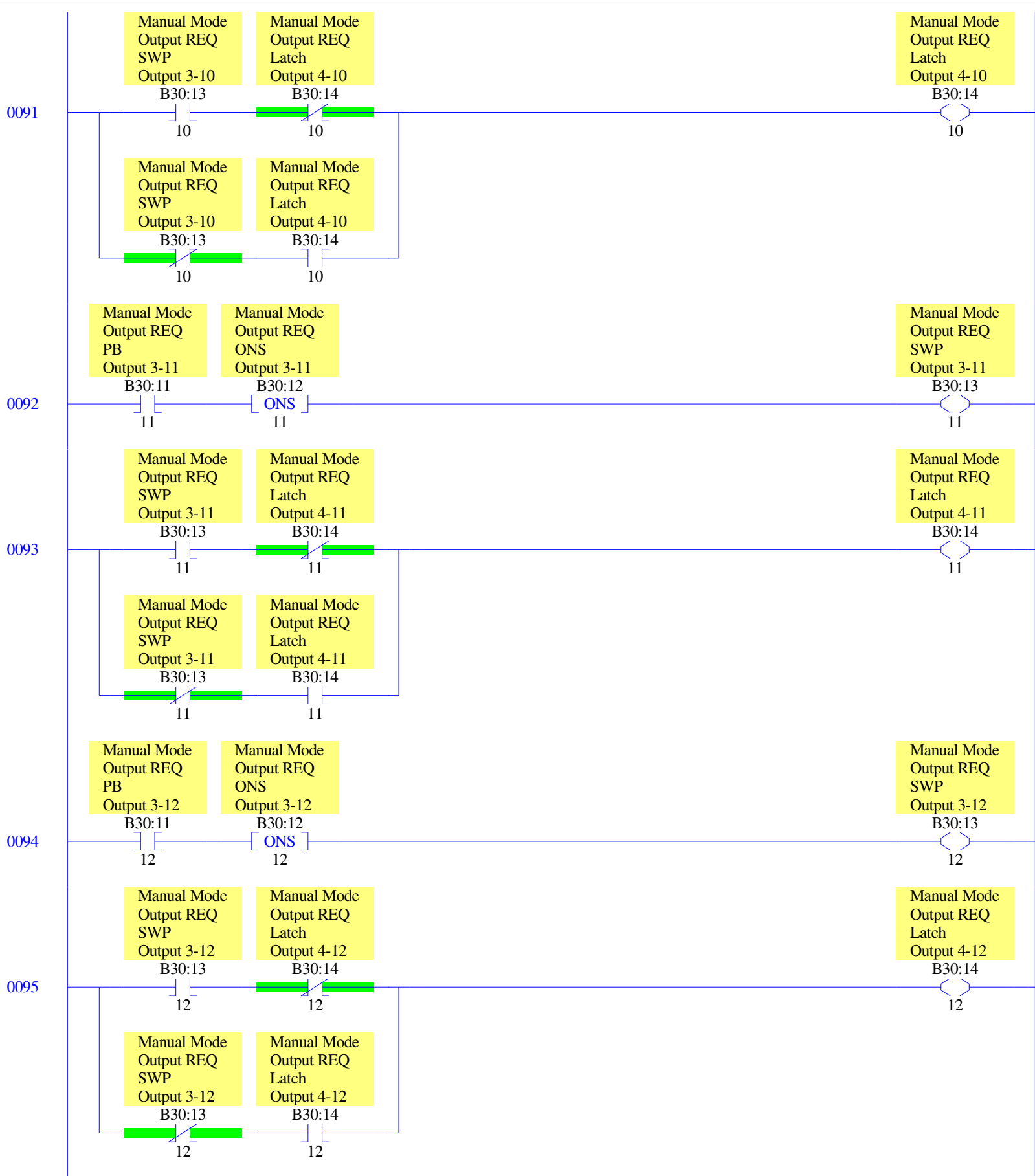




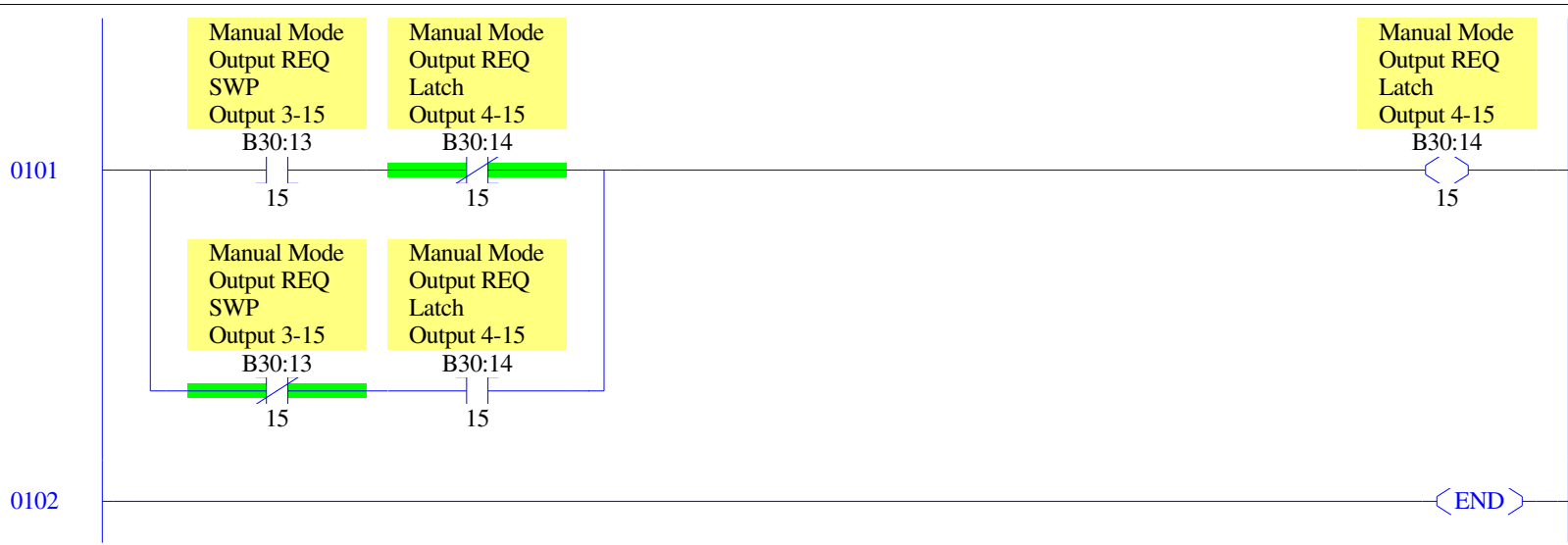


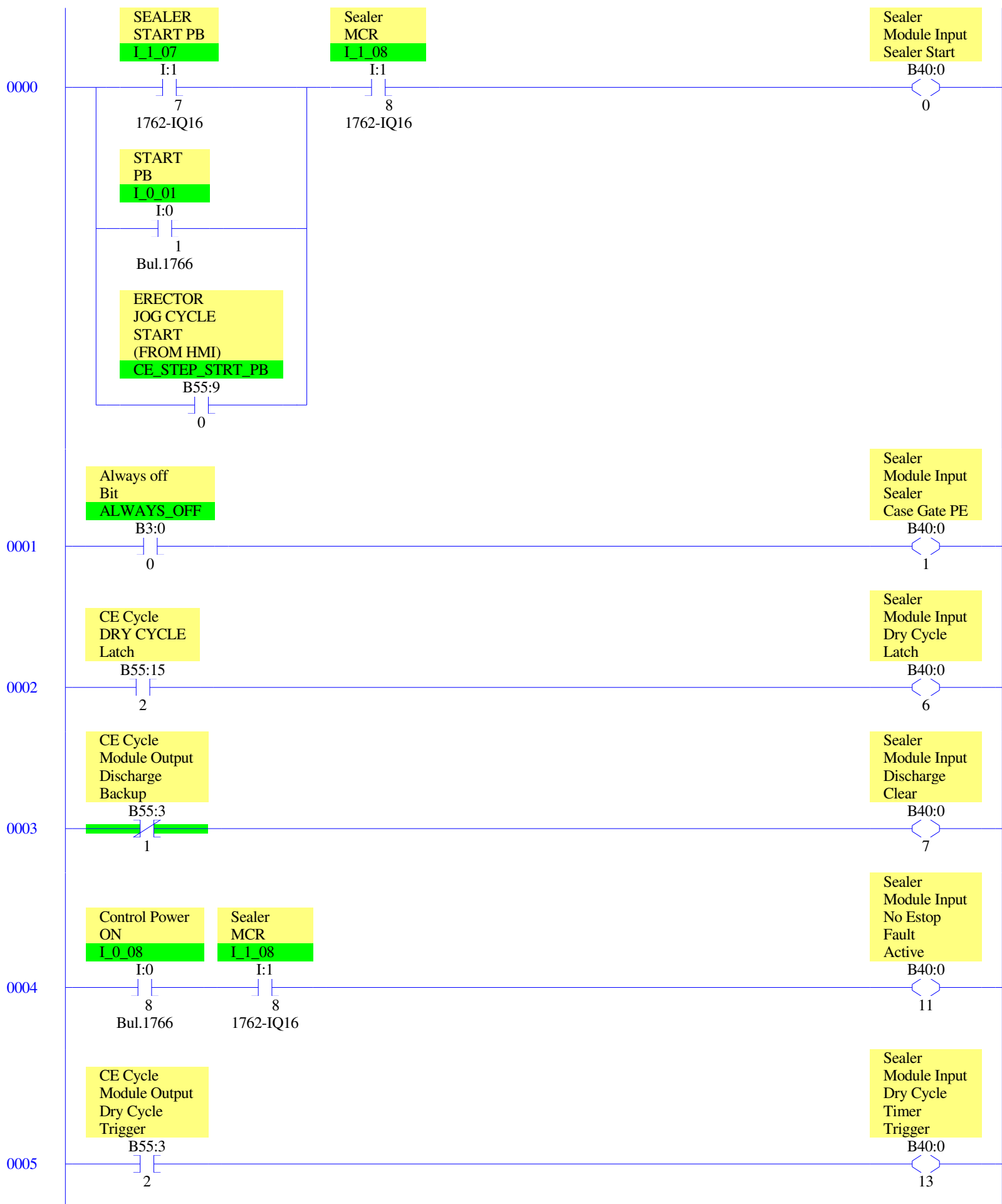


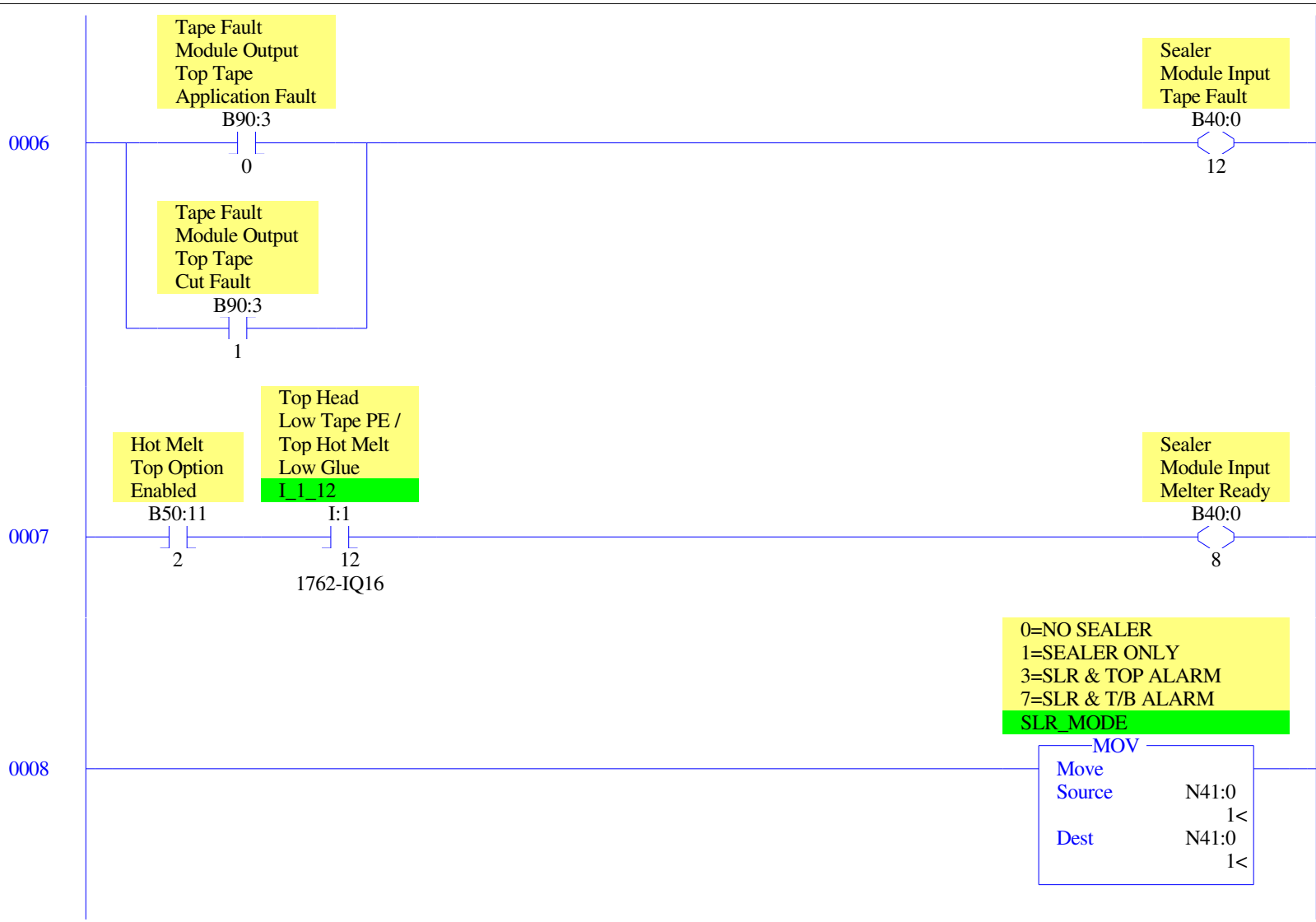












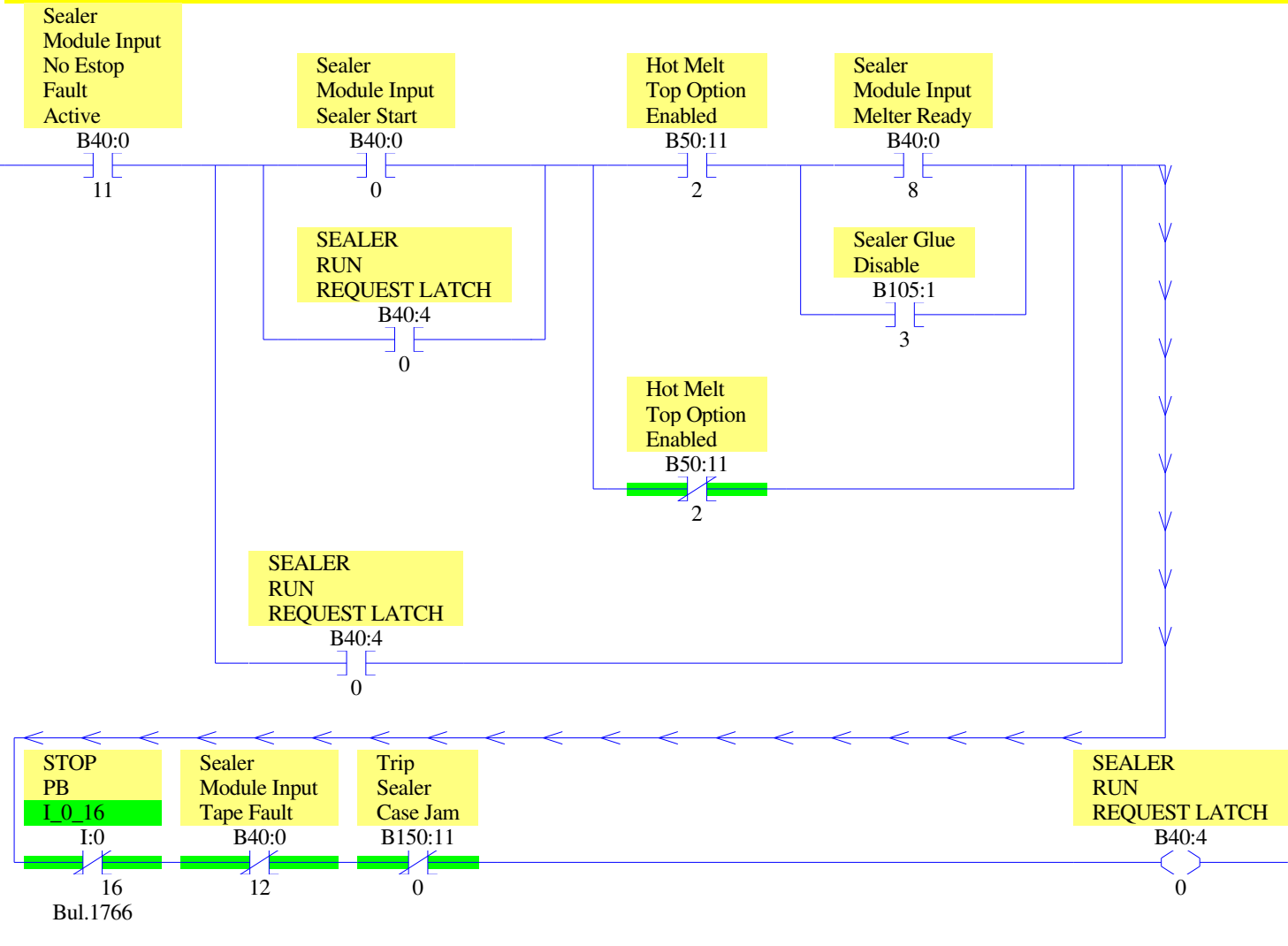
Sealer - Control

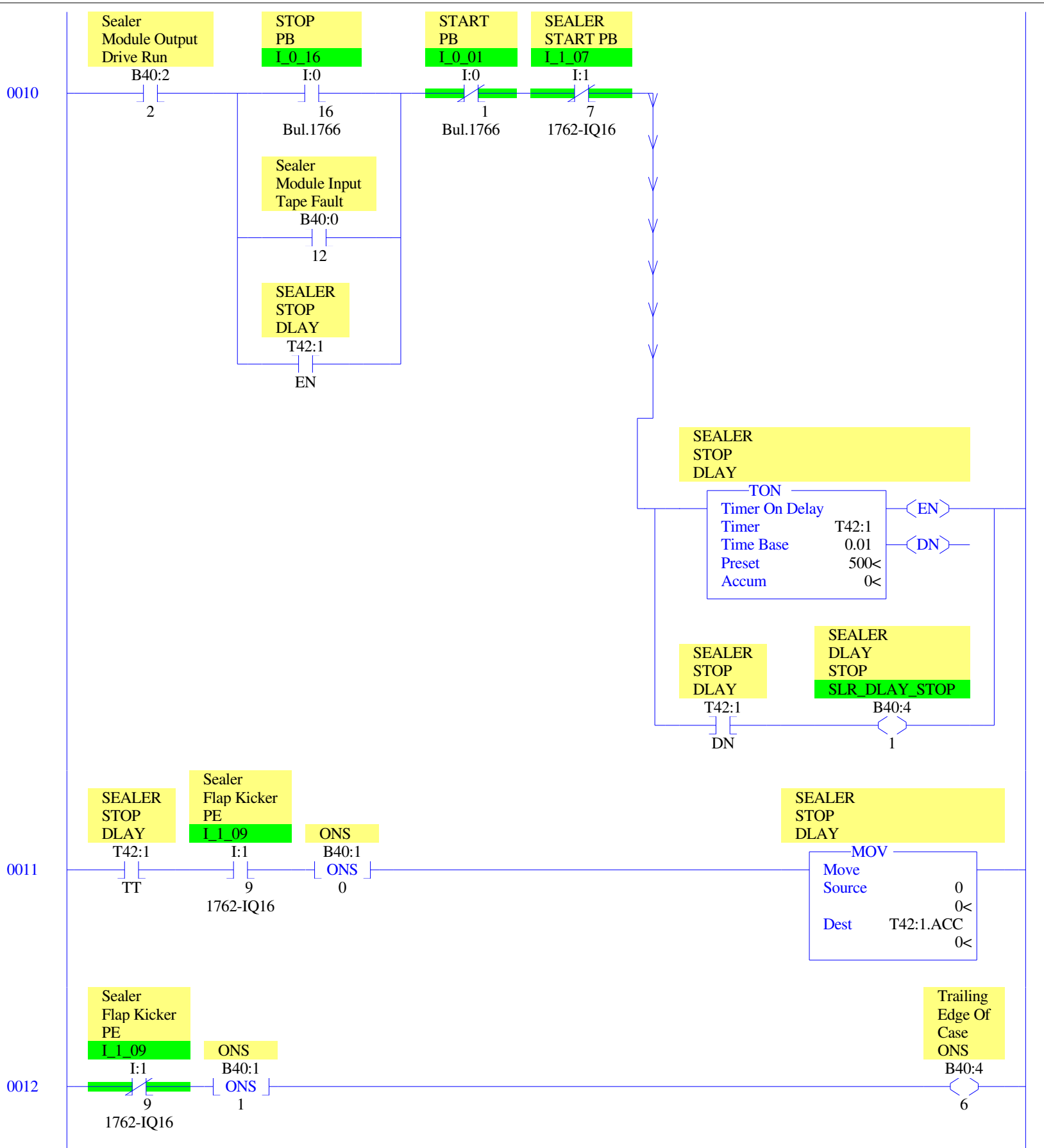
 This rung sets operation mode of the sealer. If the machine is equipped with no sealer, MOVE a zero (0) into the sealer mode register (D_SLR_MODE). If the machine is equipped with a sealer without tape monitoring options, MOVE a one (1) into the sealer mode register. If the machine is equipped with a sealer with top tape monitoring options only, MOVE a three (3) into the sealer mode register. If the machine is equipped with a sealer with top AND bottom tape monitoring options, MOVE a seven (7) into the sealer mode register.

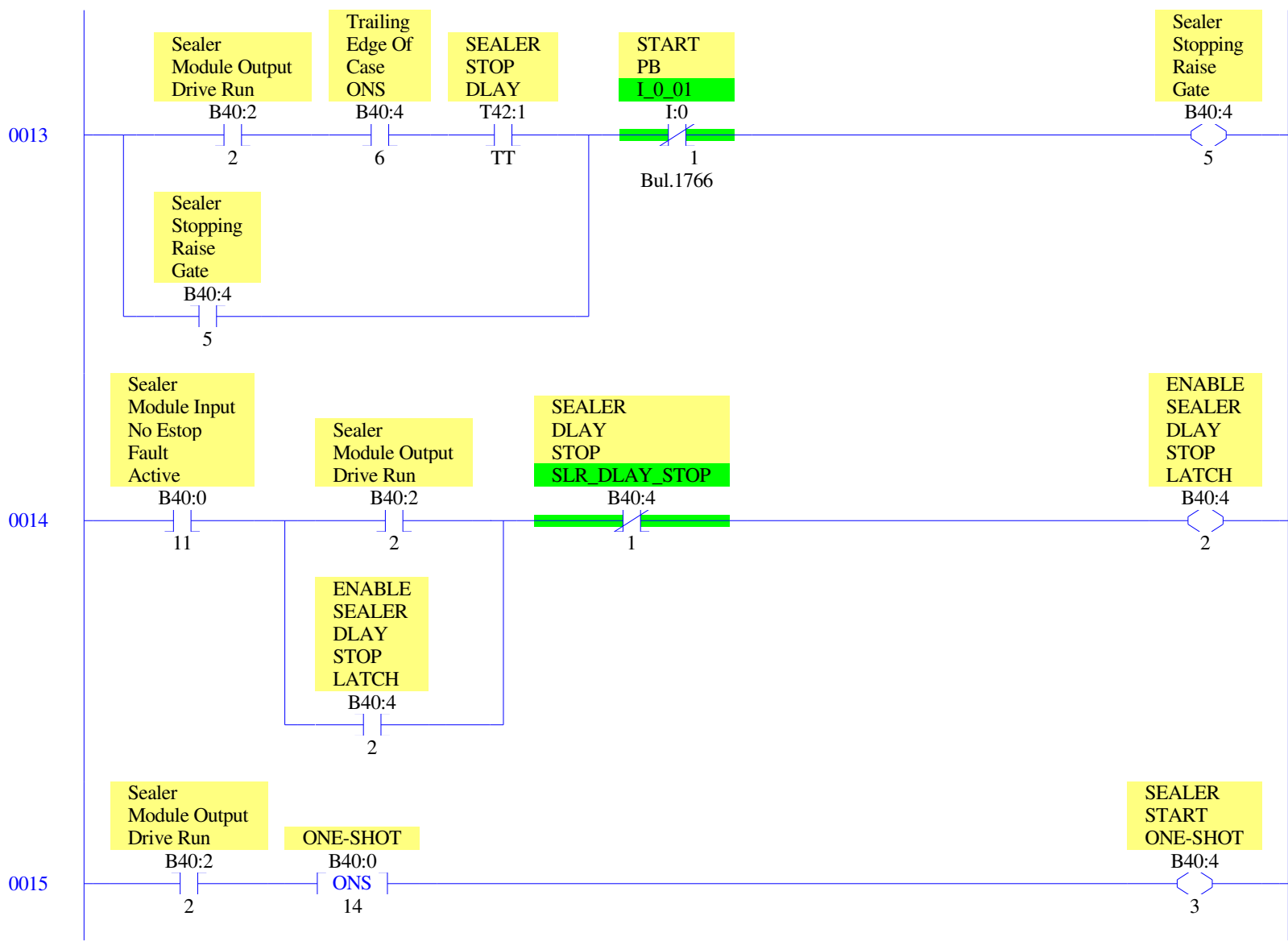
IF the machine is equipped with a discharge conveyor, move a one (1) into bit number 3 (value of 8).

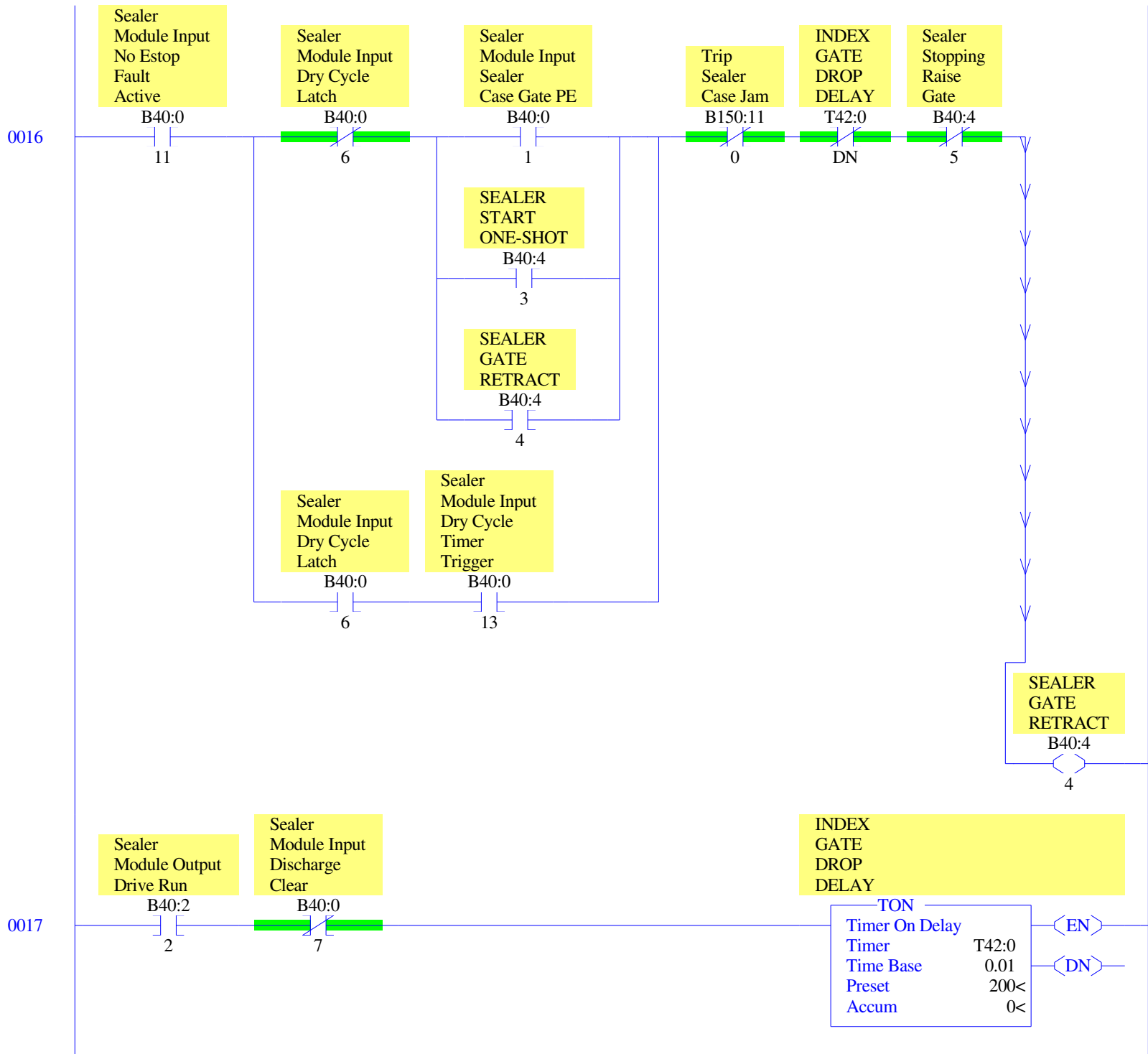
DO NOT LOAD WITH 2, 4, 5 OR 6.

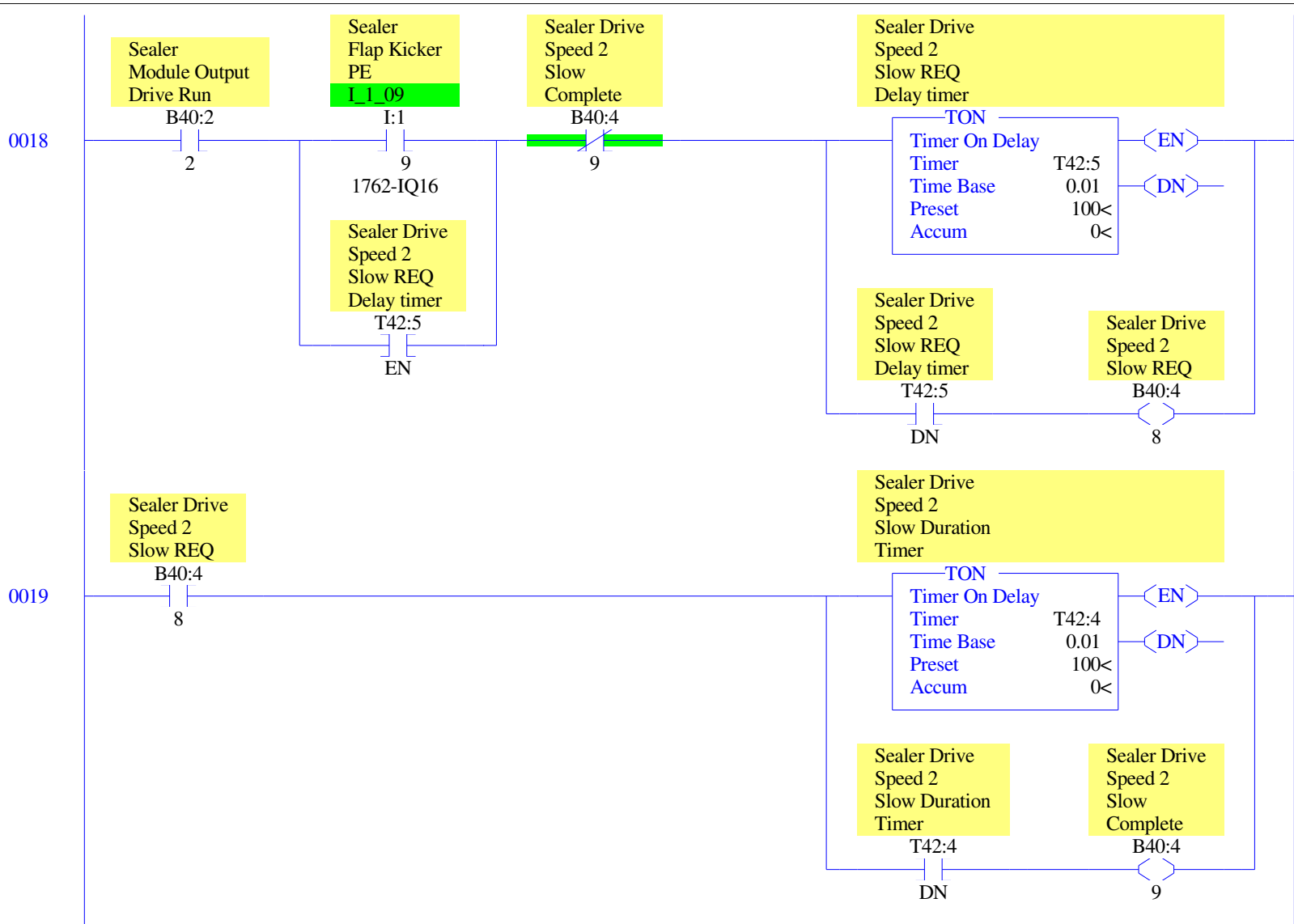
0009

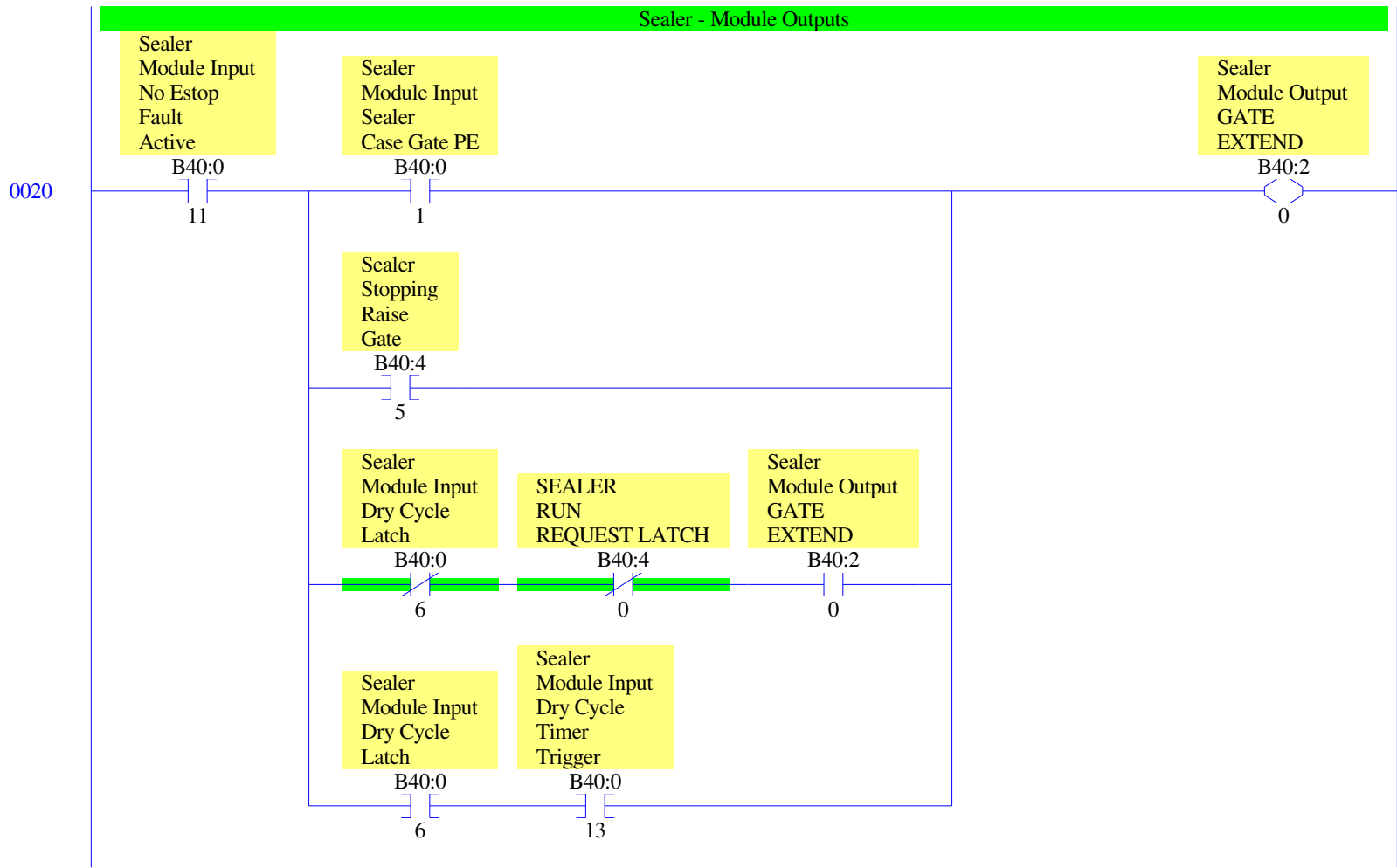




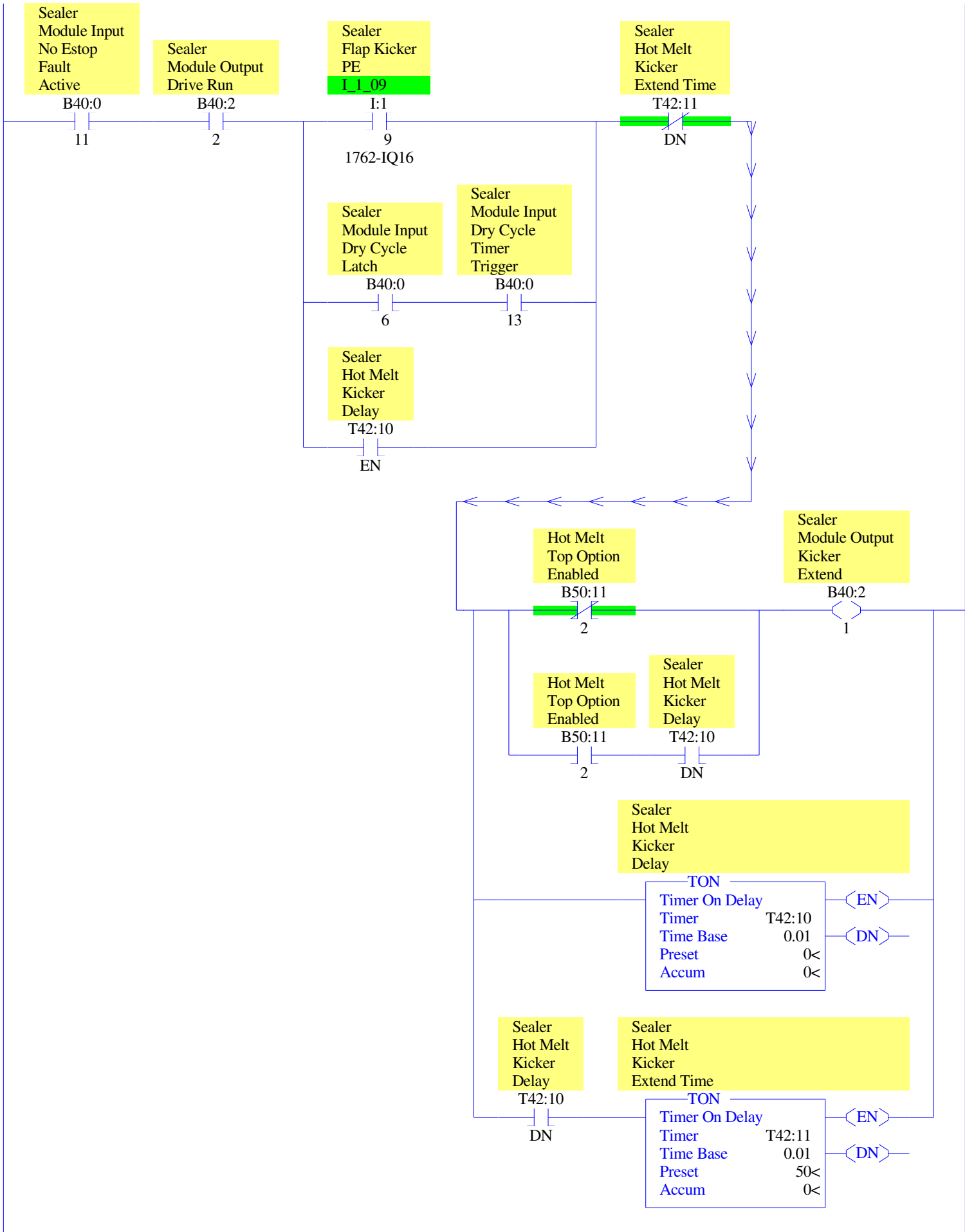


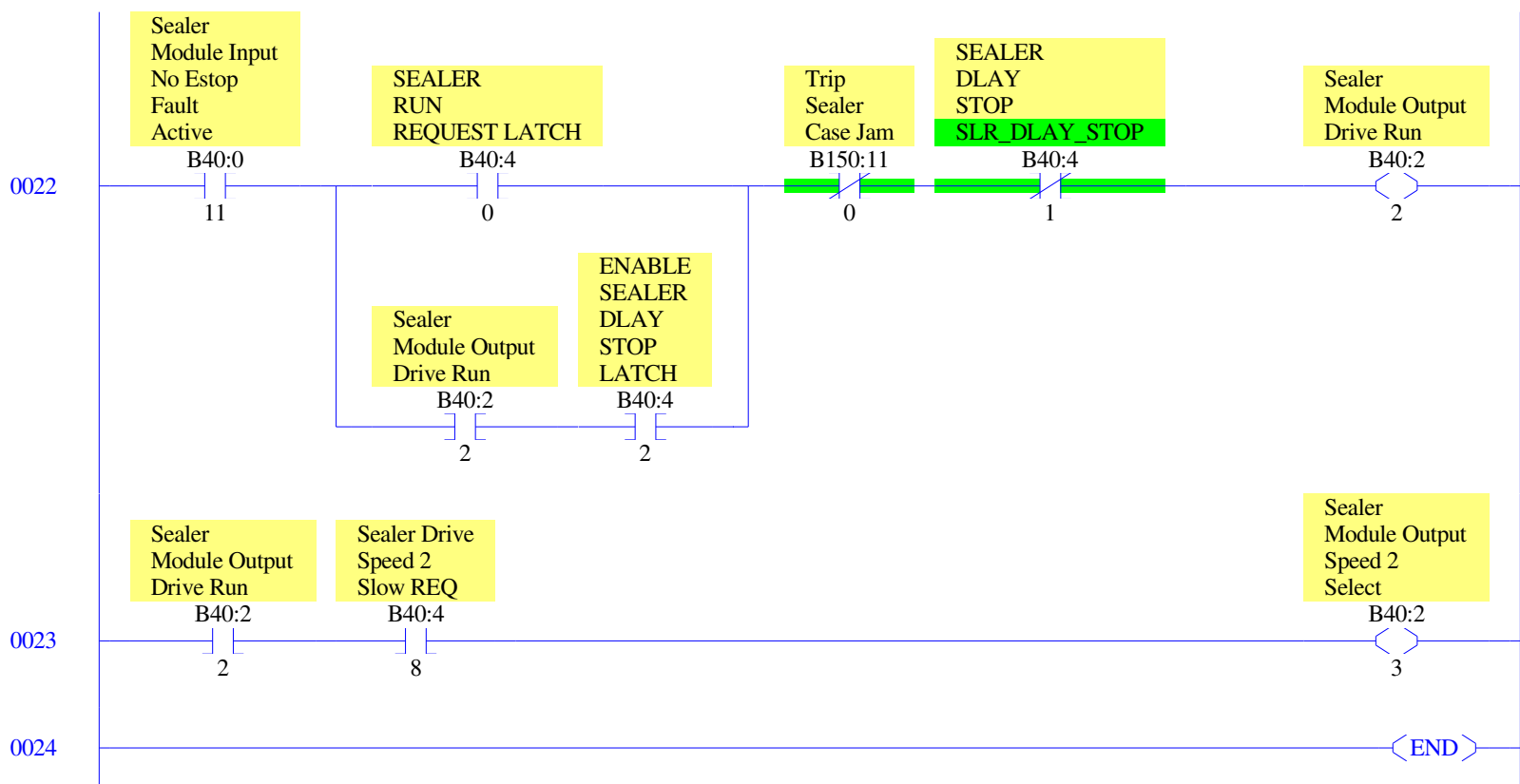






0021





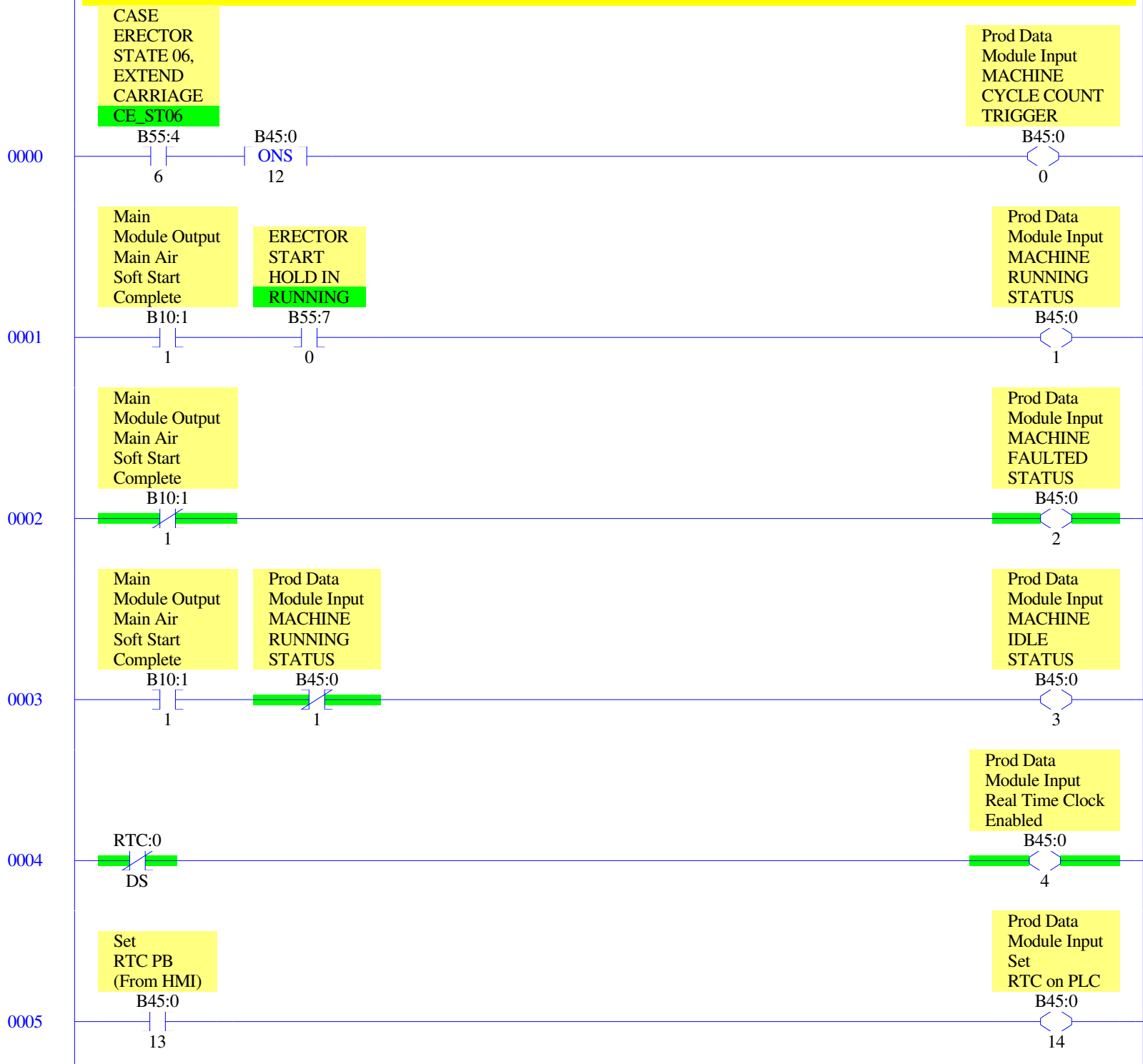
Prodata - Module Inputs

The following Module inputs require you to map the appropriate bits from the control program to allow the functions of production data to work. The Module inputs are the only items you need to supply to make this program work.

The only data files are:

- B45
- N46
- T47
- C48
- F49

R6 ***** Make sure R6 is open and available before copying this program into an existing program *****



This moves the Time / Cal Data from the HMI Customer Config Screen to the PLC to Set the Processors Time Clock.
 The RTC must be enabled before you can set the time in the PLC from the HMI. If the RTC:0/DS bit is on then the clock is disabled and if you try to write to the RTC with the clock disabled it will fault the processor.
 There is no way thru logic to enable the RTC. This is a Read Only Bit!

SCREEN
 NUMBER
 FROM
 HMI

Prod Data
 Module Input
 Real Time Clock
 Enabled

0006

EQU
 Equal
 Source A N24:10
 1<
 Source B 97
 97<

NEQ
 Not Equal
 Source A RTC:0.HR
 0<
 Source B N46:200
 8<

NEQ
 Not Equal
 Source A RTC:0.MIN
 0<
 Source B N46:202
 43<

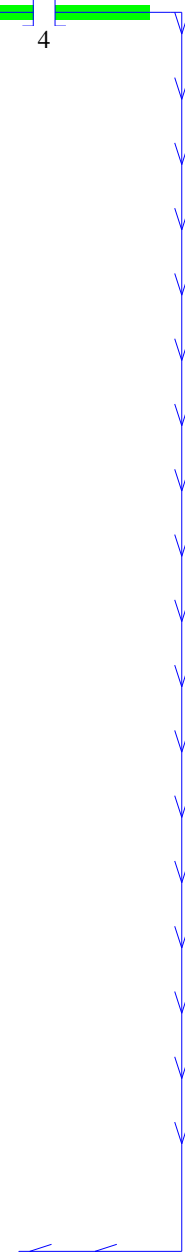
NEQ
 Not Equal
 Source A RTC:0.YR
 0<
 Source B N46:206
 2016<

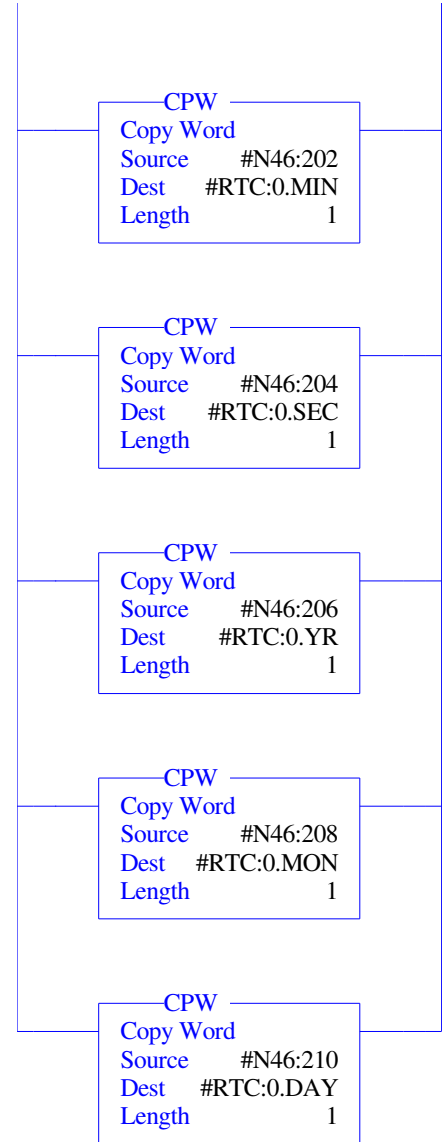
NEQ
 Not Equal
 Source A RTC:0.MON
 0<
 Source B N46:208
 9<

NEQ
 Not Equal
 Source A RTC:0.DAY
 0<
 Source B N46:210
 29<

B45:0
 4

CPW
 Copy Word
 Source #N46:200
 Dest #RTC:0.HR
 Length 1





0007

SCREEN
NUMBER
FROM
HMI

NEQ
Not Equal

Source A	N24:10
	1<
Source B	97
	97<

Real Time Clock
Hour Value
Set from
(HMI)

MOV
Move

Source	RTC:0.HR
	0<
Dest	N46:200
	8<

Real Time Clock
Min Value
Set from
(HMI)

MOV
Move

Source	RTC:0.MIN
	0<
Dest	N46:202
	43<

Real Time Clock
Year Value
Set from
(HMI)

MOV
Move

Source	RTC:0.YR
	0<
Dest	N46:206
	2016<

Real Time Clock
Month Value
Set from
(HMI)

MOV
Move

Source	RTC:0.MON
	0<
Dest	N46:208
	9<

Real Time Clock
Day Value
Set from
(HMI)

MOV
Move

Source	RTC:0.DAY
	0<
Dest	N46:210
	29<

Prodata - Shift Control

These rungs determine the active shift.

0008

EQU
 Equal
 Source A RTC:0.HR
 0<
 Source B N46:2
 7<

GEQ
 Grtr Than or Eql (A>=B)
 Source A RTC:0.MIN
 0<
 Source B N46:3
 0<

FIRST
 SHIFT
 ACTIVE
 DLAY TMR

TON
 Timer On Delay
 Timer T47:5
 Time Base 0.01
 Preset 500<
 Accum 0<

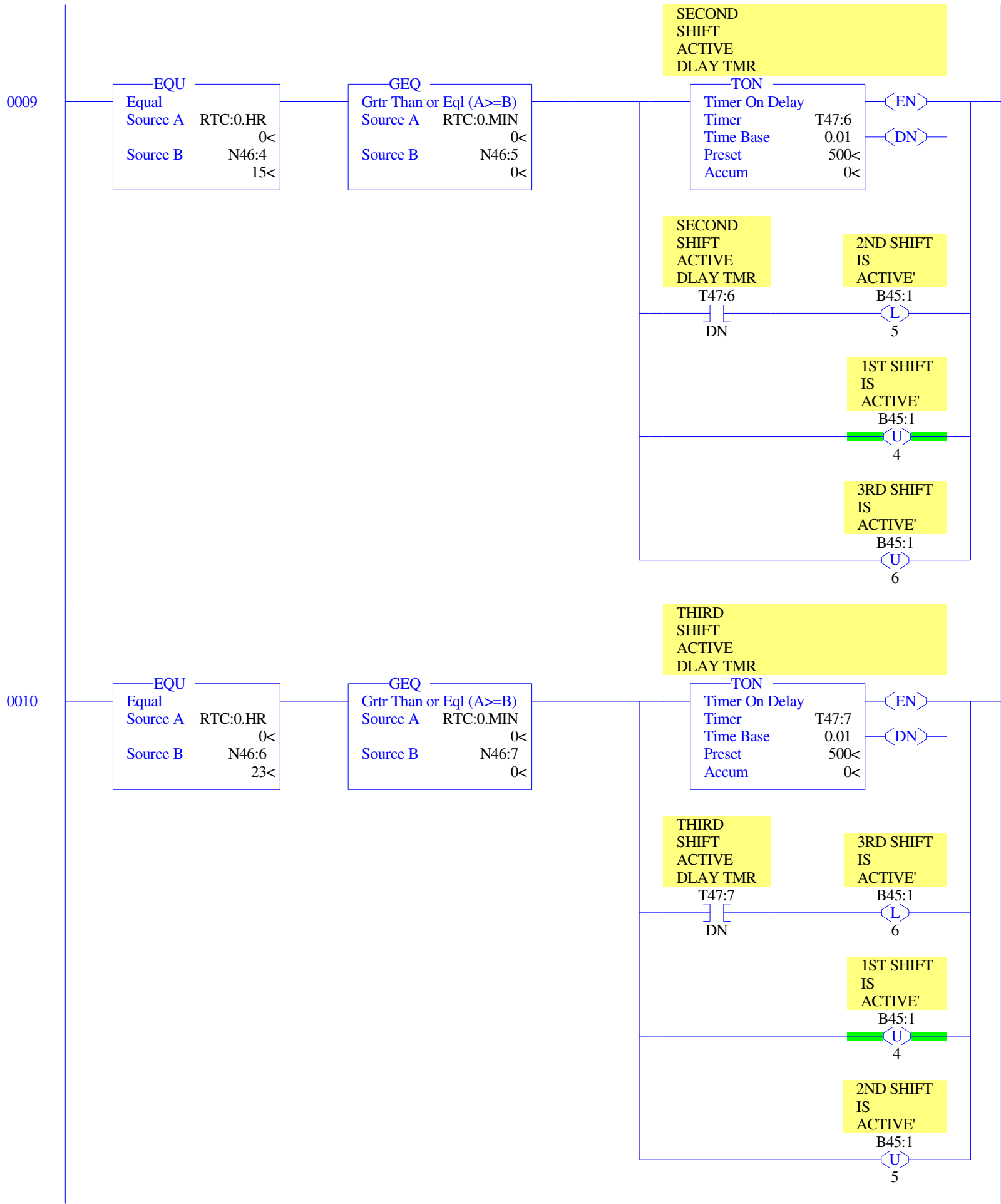
(EN)
 (DN)

FIRST
 SHIFT
 ACTIVE
 DLAY TMR
 T47:5
 DN

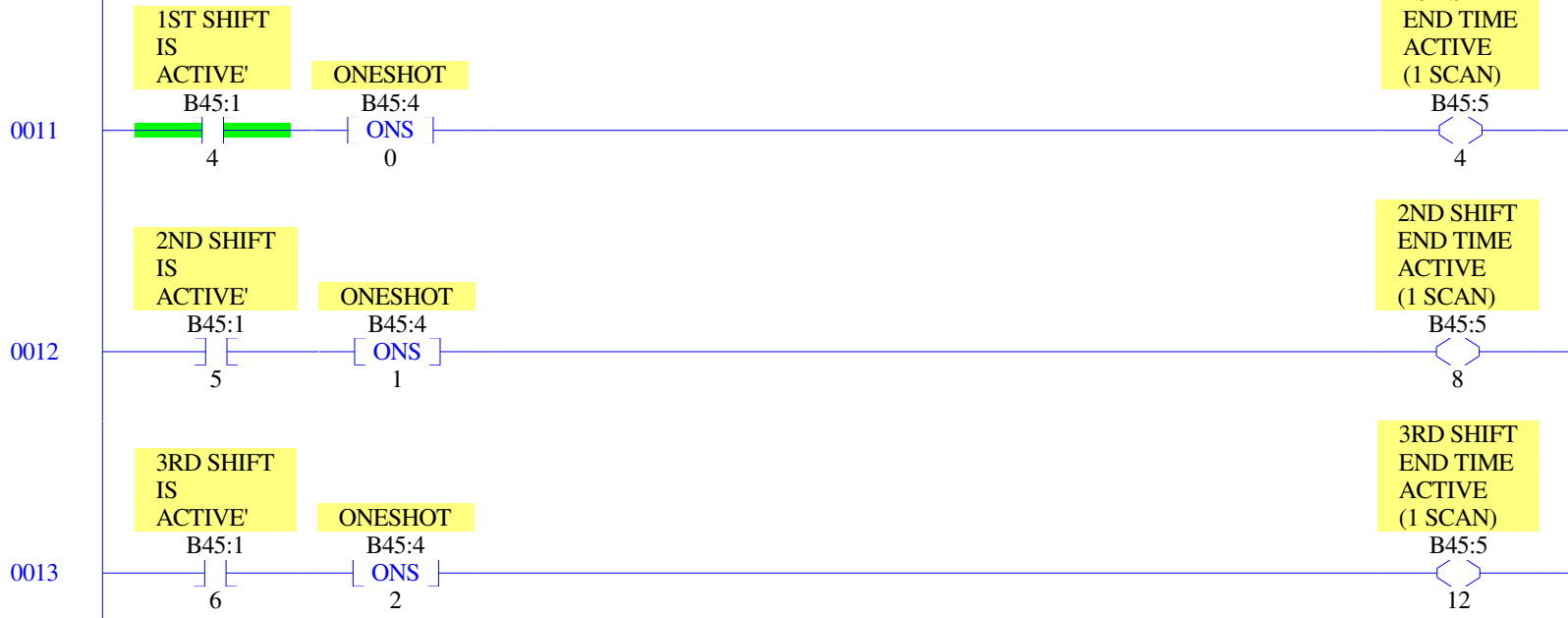
1ST SHIFT
 IS
 ACTIVE'
 B45:1
 (L)
 4

2ND SHIFT
 IS
 ACTIVE'
 B45:1
 (U)
 5

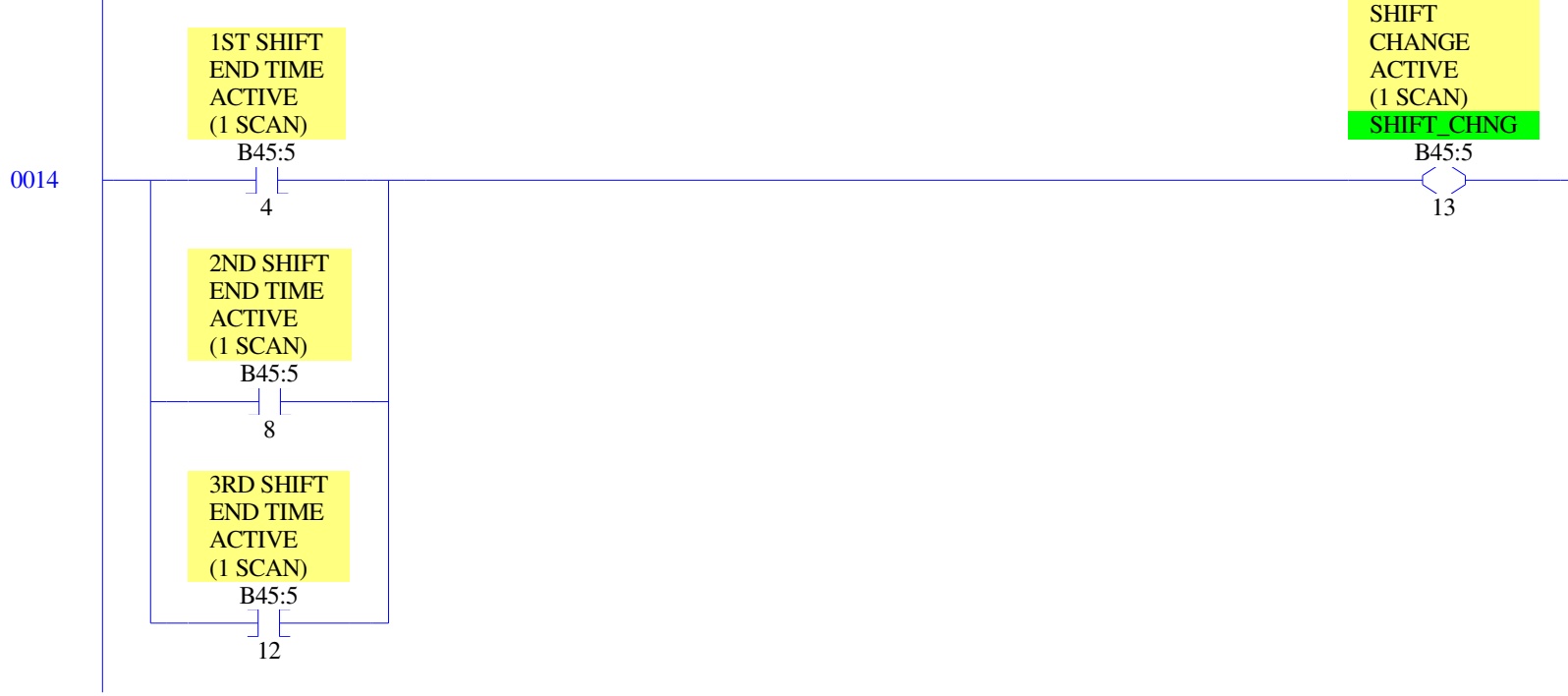
3RD SHIFT
 IS
 ACTIVE'
 B45:1
 (U)
 6



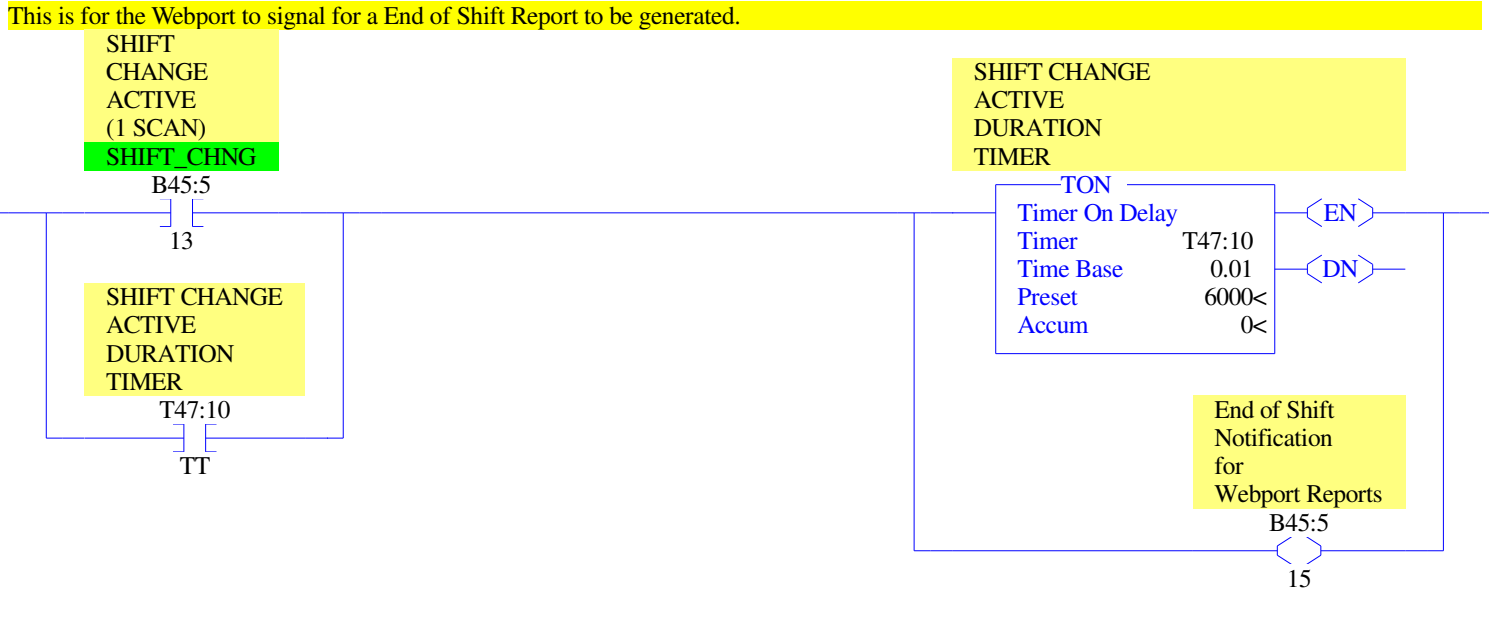
This rungs provides a single scan output at the end of EACH SHIFT



This rung summarizes the end of each shift.
At the end of each shift the data is logged into the FIFOs at this time.

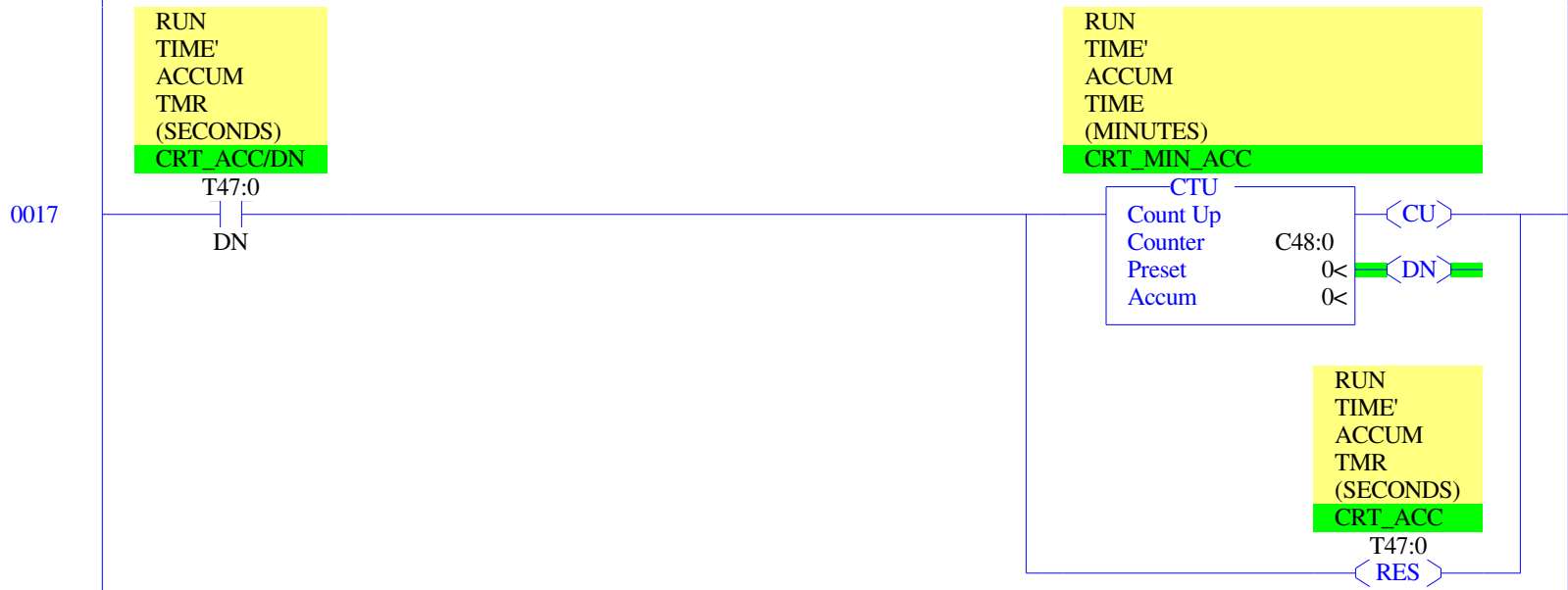


0015

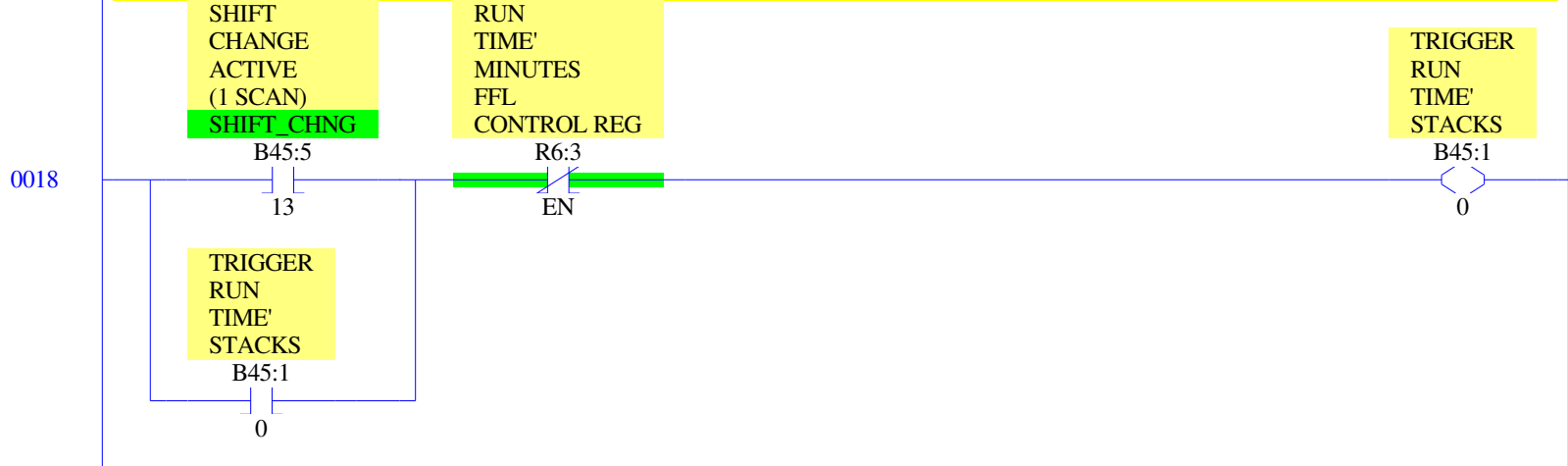


Prodata - Run Time Tracking

 These rungs track the 'RUN TIME' data.



This rung latches the 'SHIFT CHANGE' signal for 'RUN TIME' logging.



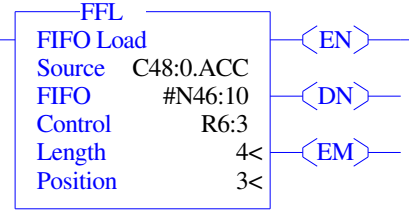
These rungs control data logging for 'RUN TIME'. The FFL's load new data into the stack, the FFU's unload old data from the stack.

0019

TRIGGER
RUN
TIME'
STACKS



RUN
TIME'
MINUTES
FFL
CONTROL REG

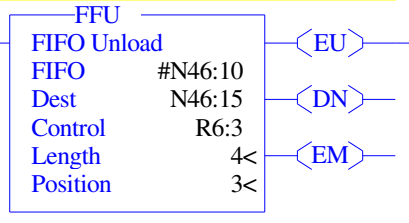


0020

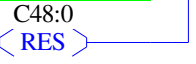
RUN
TIME'
MINUTES
FFL
CONTROL REG



RUN
TIME'
MINUTES
FFL
CONTROL REG

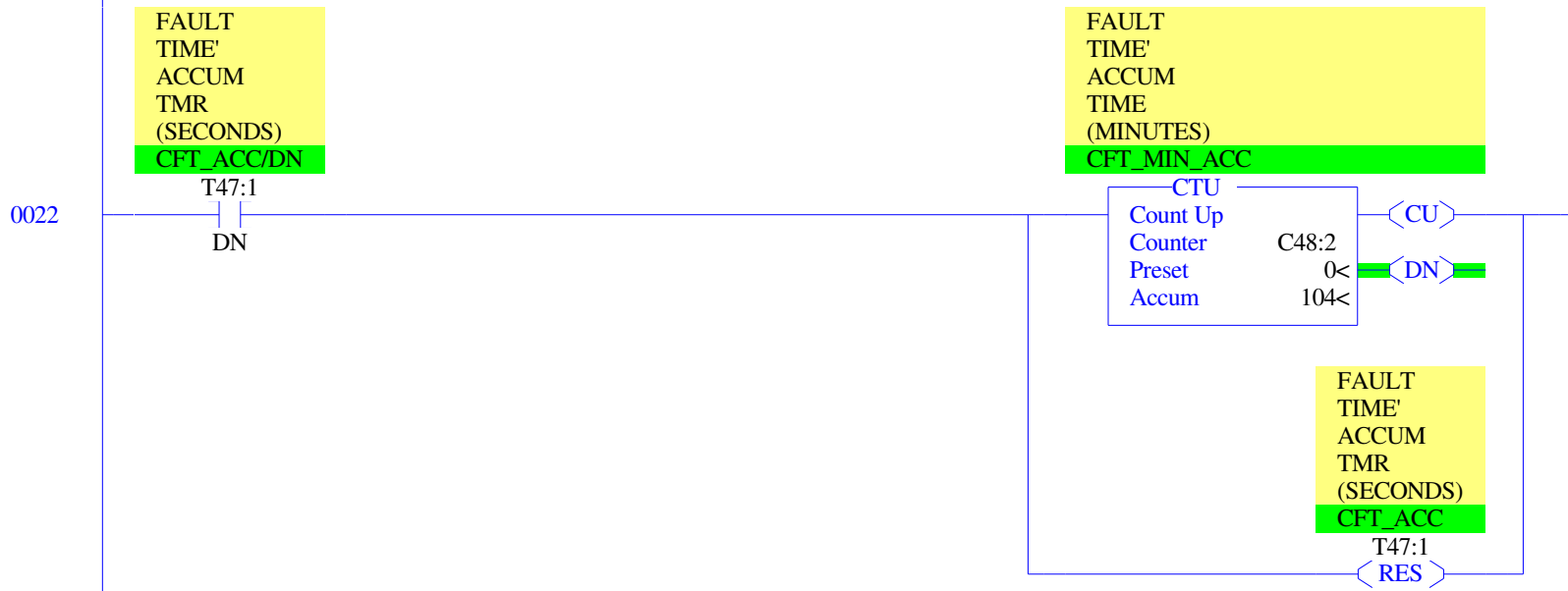


RUN
TIME'
ACCUM
TIME
(MINUTES)
CRT_MIN_ACC

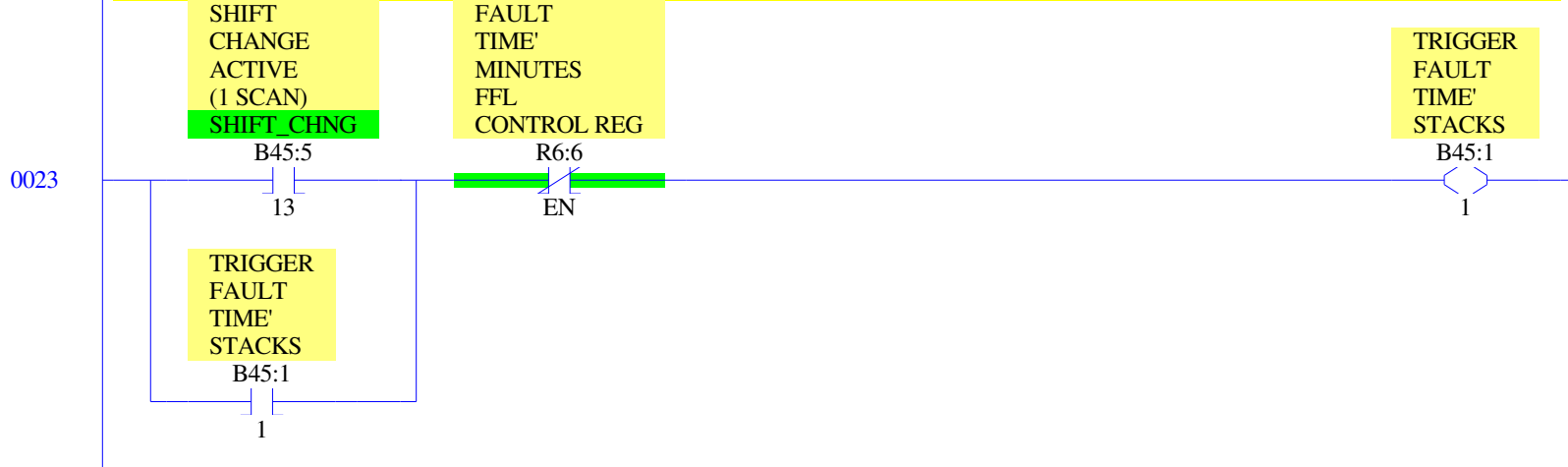


Prodata - Fault Time Tracking

 These rungs track the 'FAULT TIME' data.



This rung latches the 'SHIFT CHANGE' signal for 'FAULT TIME' logging.



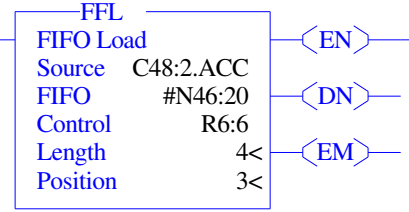
These rungs control data logging for 'FAULT TIME'. The FFL's load new data into the stack, the FFU's unload old data from the stack.

0024

TRIGGER
FAULT
TIME'
STACKS



FAULT
TIME'
MINUTES
FFL
CONTROL REG

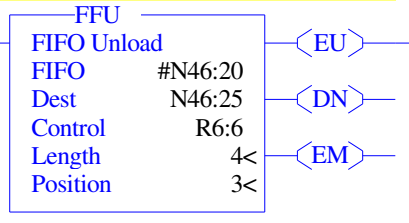


0025

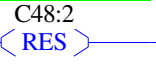
FAULT
TIME'
MINUTES
FFL
CONTROL REG



FAULT
TIME'
MINUTES
FFL
CONTROL REG

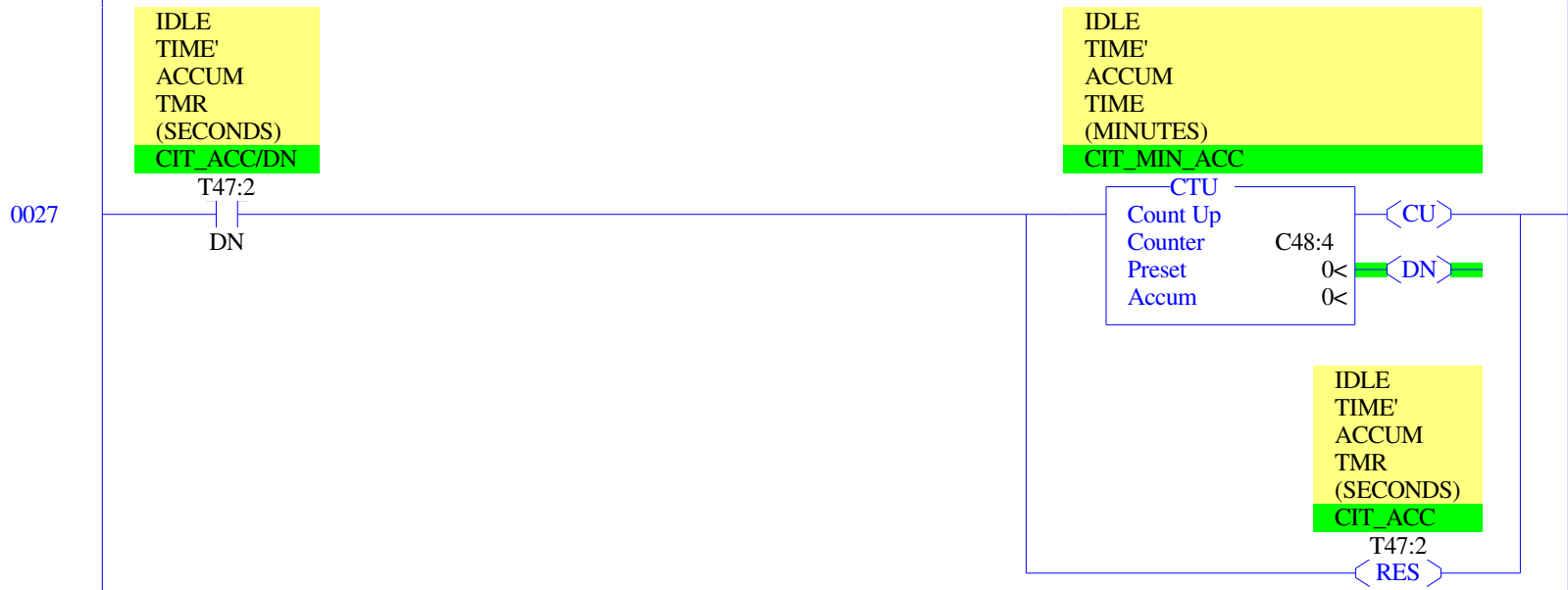


FAULT
TIME'
ACCUM
TIME
CFT_MIN_ACC

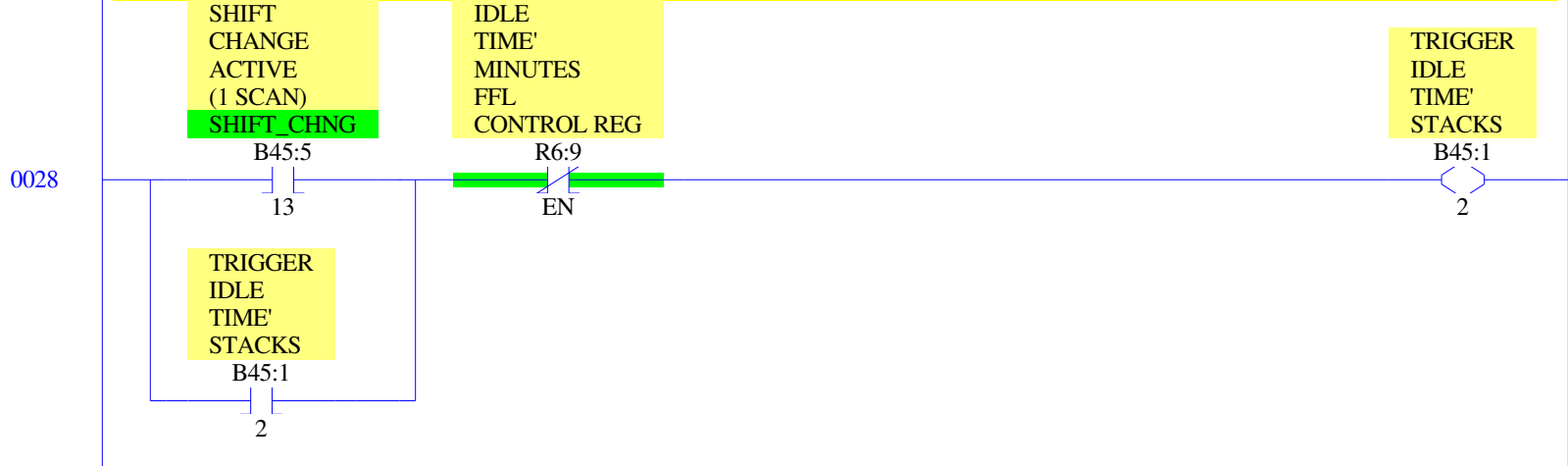


Prodata - Idle Time Tracking

These rungs track the 'IDLE TIME' data.



This rung latches the 'SHIFT CHANGE' signal for 'IDLE TIME' logging.



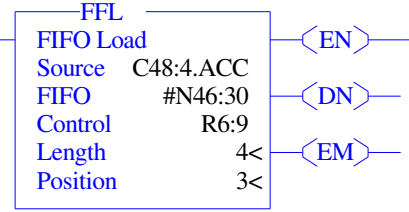
These rungs control data logging for 'IDLE TIME'. The FFL's load new data into the stack, the FFU's unload old data from the stack.

0029

TRIGGER
IDLE
TIME'
STACKS



IDLE
TIME'
MINUTES
FFL
CONTROL REG

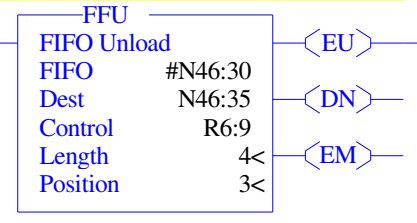


0030

IDLE
TIME'
MINUTES
FFL
CONTROL REG

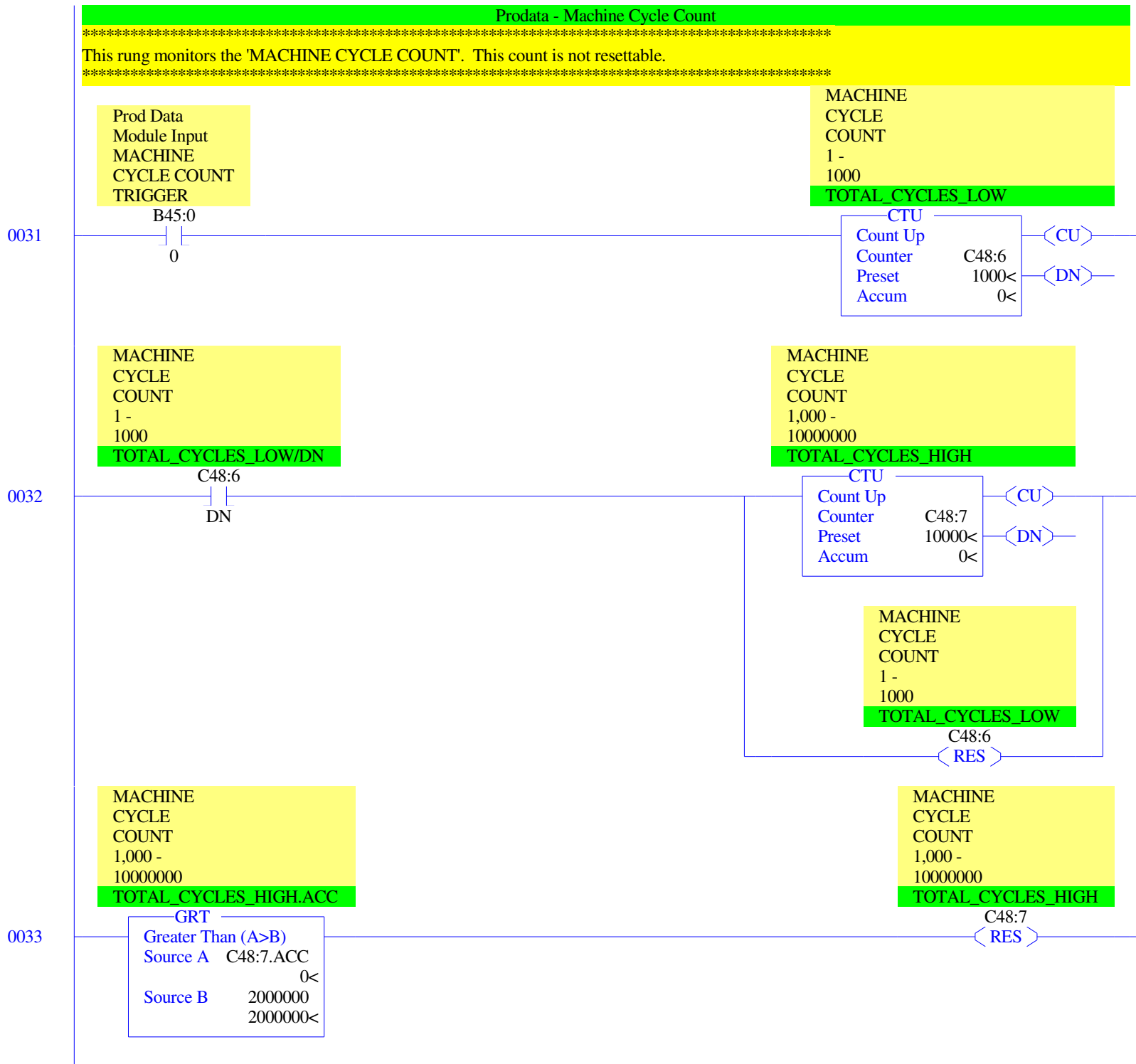


IDLE
TIME'
MINUTES
FFL
CONTROL REG



IDLE
TIME'
ACCUM
TIME
(MINUTES)
CIT_MIN_ACC





0034

Machine
Total
Cycle
Count

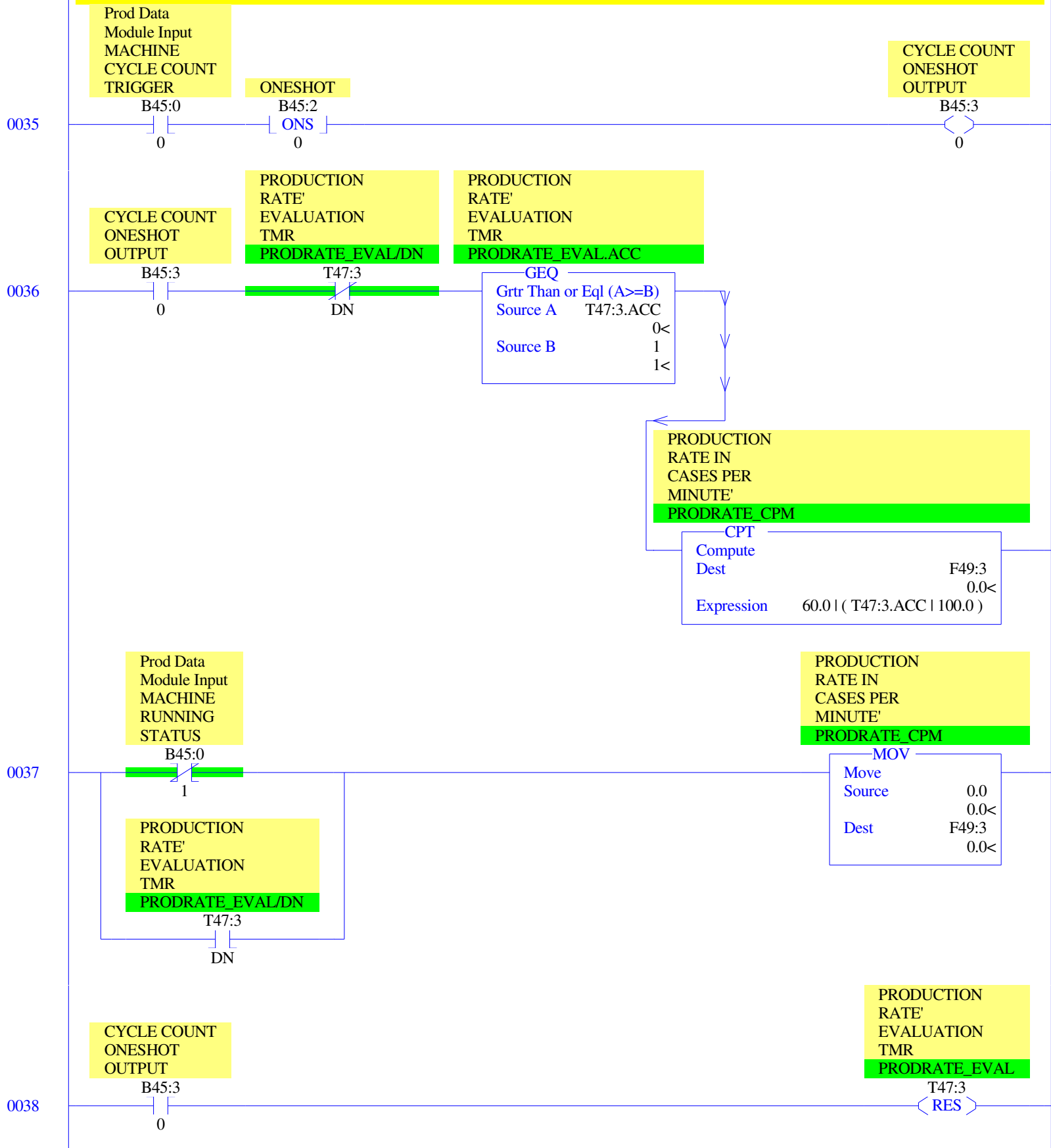
MUL
Multiply
Source A C48:7.ACC
0<
Source B C48:7.PRE
10000<
Dest F49:2
0.0<

Machine
Total
Cycle
Count

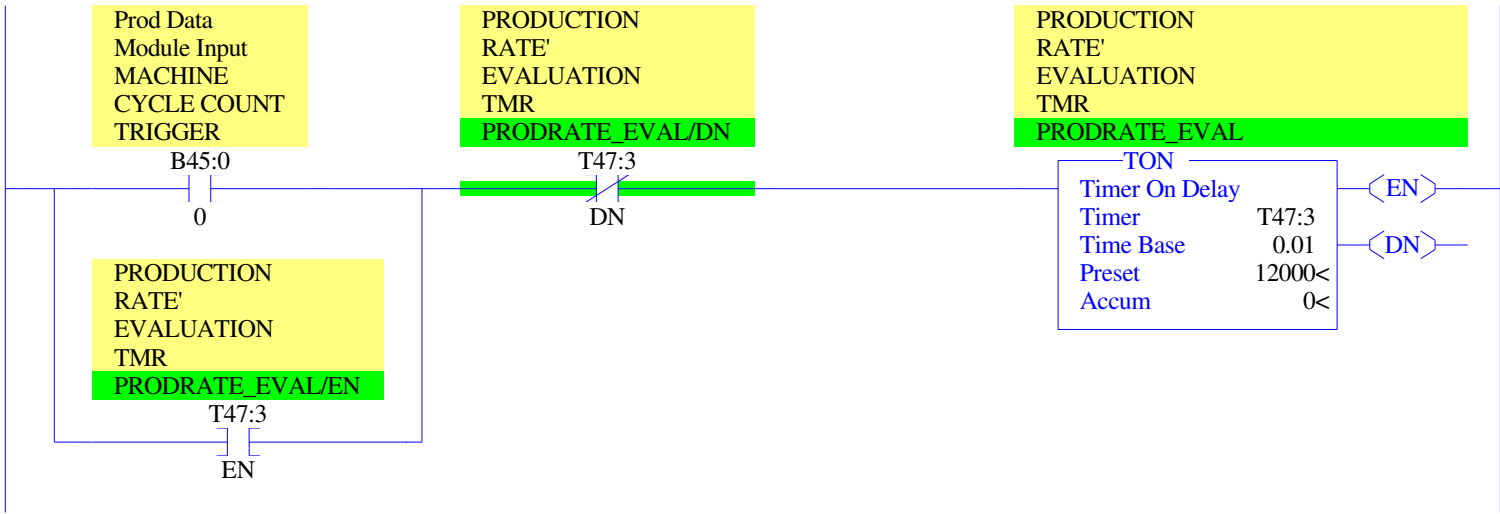
ADD
Add
Source A F49:2
0.0<
Source B C48:6.ACC
0<
Dest F49:2
0.0<

Prodata - Cases Per Minute

 These rungs monitor 'PRODUCTION RATE IN CASES PER MINUTE'.

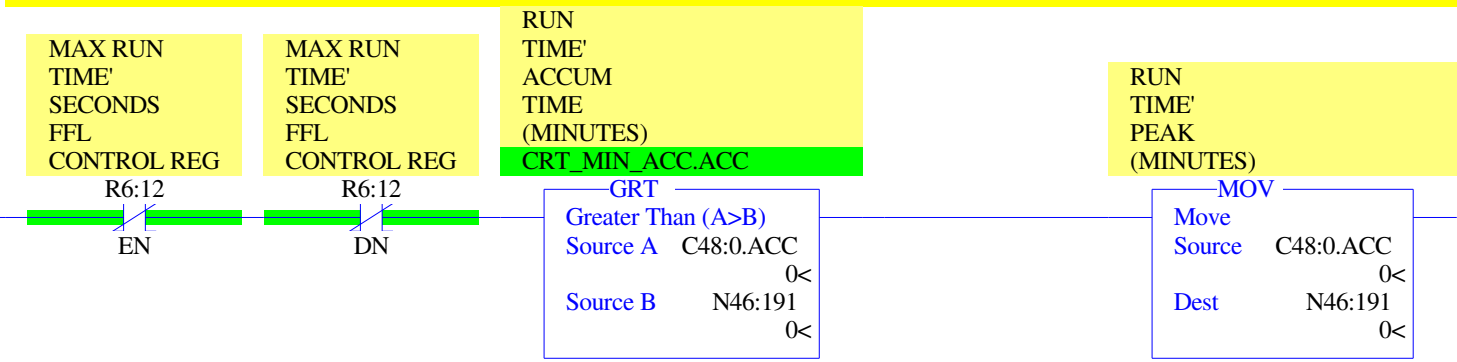


0039

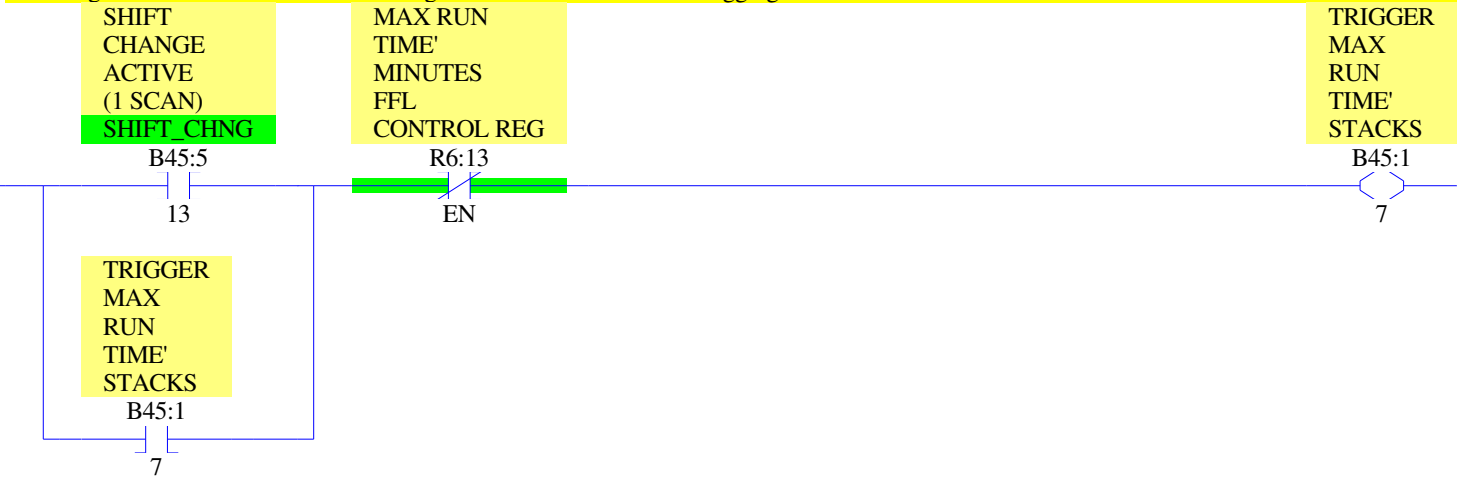


Prodata - Peak Run Time

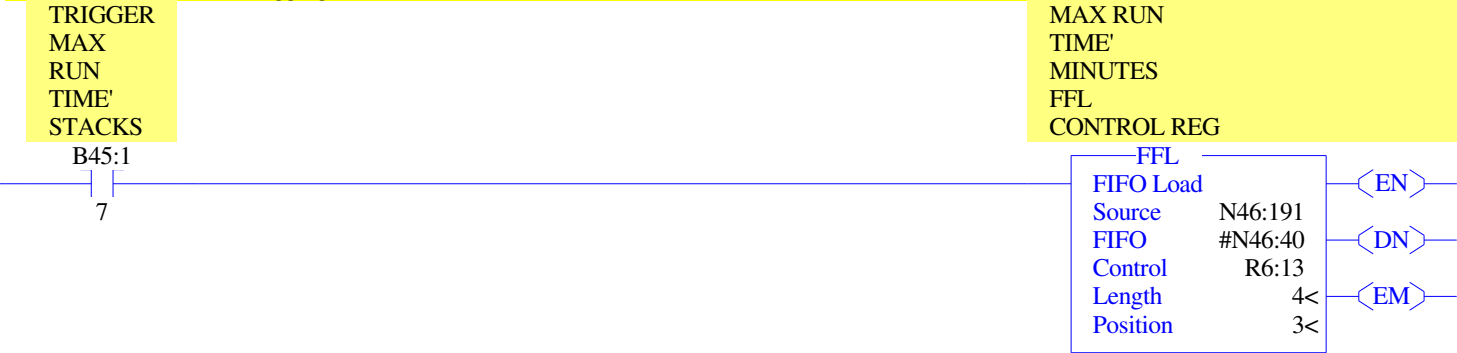
This rung monitors and logs 'PEAK RUN TIME' values.



This rung latches the 'SHIFT CHANGE' signal for 'MAX RUN TIME' logging.



These rungs control data logging for 'MAX RUN TIME'. The FFL's load new data into the stack, the FFU's unload old data from the stack.



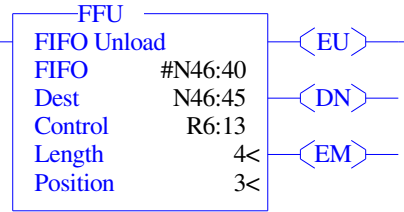
These rungs control data logging for 'MAX RUN TIME'. The FFL's load new data into the stack, the FFU's unload old data from the stack.

0043

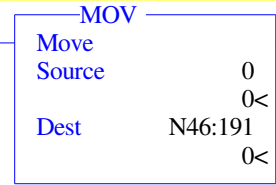
MAX RUN
TIME'
MINUTES
FFL
CONTROL REG



MAX RUN
TIME'
MINUTES
FFL
CONTROL REG

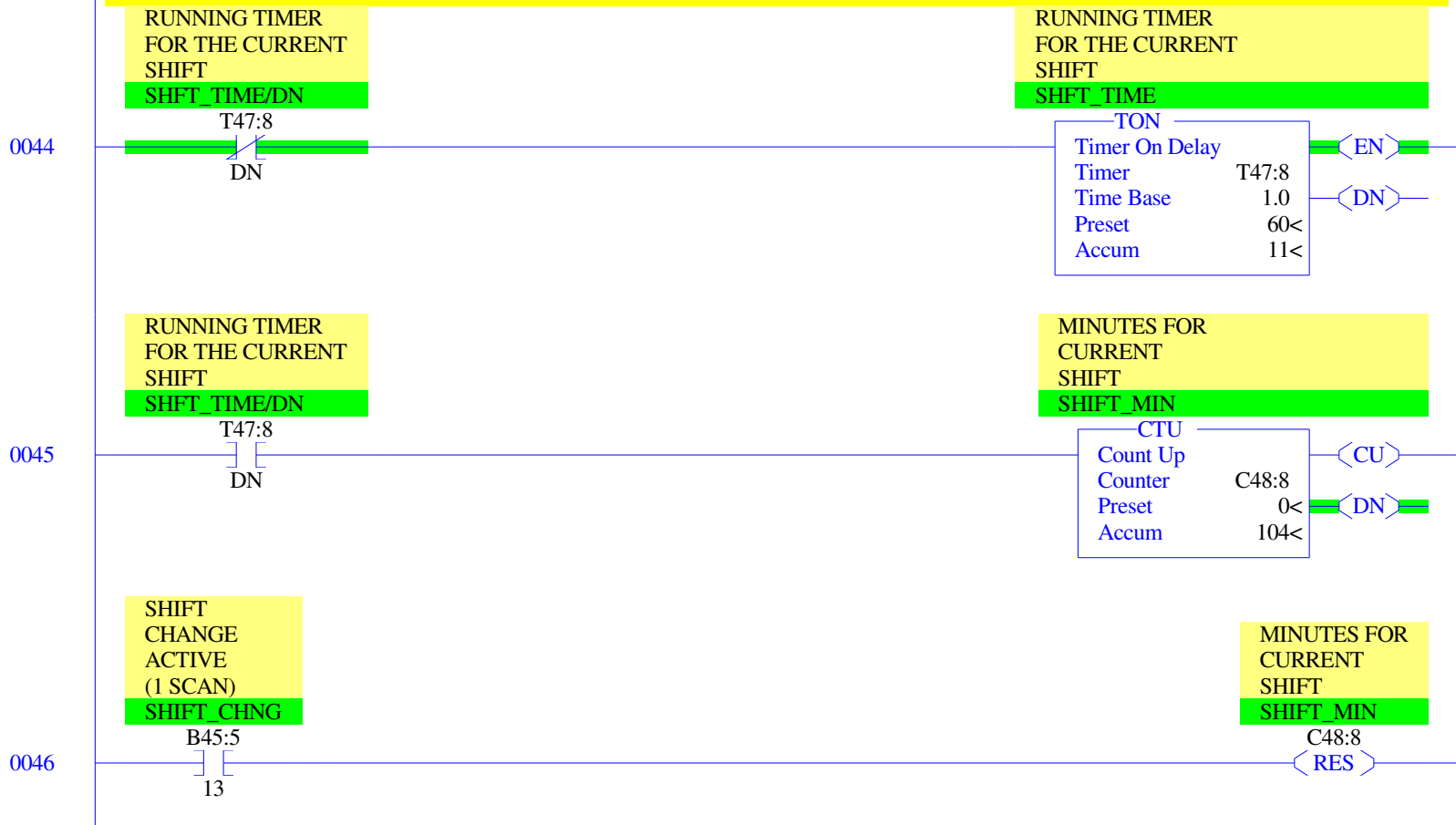


RUN
TIME'
PEAK
(MINUTES)



Prodata - Current Shift Running Minutes

These rungs track the 'CURRENT SHIFT RUNNING MINUTES' data.



Prodata - Efficiency Calculations

 This rung converts total run time to minutes for use in machine efficiency.

RUN TIME'
 TOTAL
 ACCUM
 IN MINUTES
 FORMAT

0047

MOV

Move	
Source	C48:0.ACC
	0<
Dest	N46:190
	0<

These rungs calculate efficiency based on shift duration (in minutes) and run time.

0048

MINUTES FOR
 CURRENT
 SHIFT
 SHIFT_MIN/CU

C48:8
 CU

ONESHOT
 B45:4
 ONS
 4

MINUTES FOR
 CURRENT
 SHIFT
 SHIFT_MIN.ACC

GRT

Greater Than (A>B)	
Source A	C48:8.ACC
	104<
Source B	0
	0<

ACTIVE
 RUN TIME
 DIVIDED
 BY SHIFT
 DURATION
 SHIFT_EFF

DIV

Divide	
Source A	N46:190
	0<
Source B	C48:8.ACC
	104<
Dest	F49:0
	0.0<

CURRENT SHIFT
 EFFICIENCY
 PERCENT
 (FLOAT POINT)
 SHIFT_EFF_PERCENT

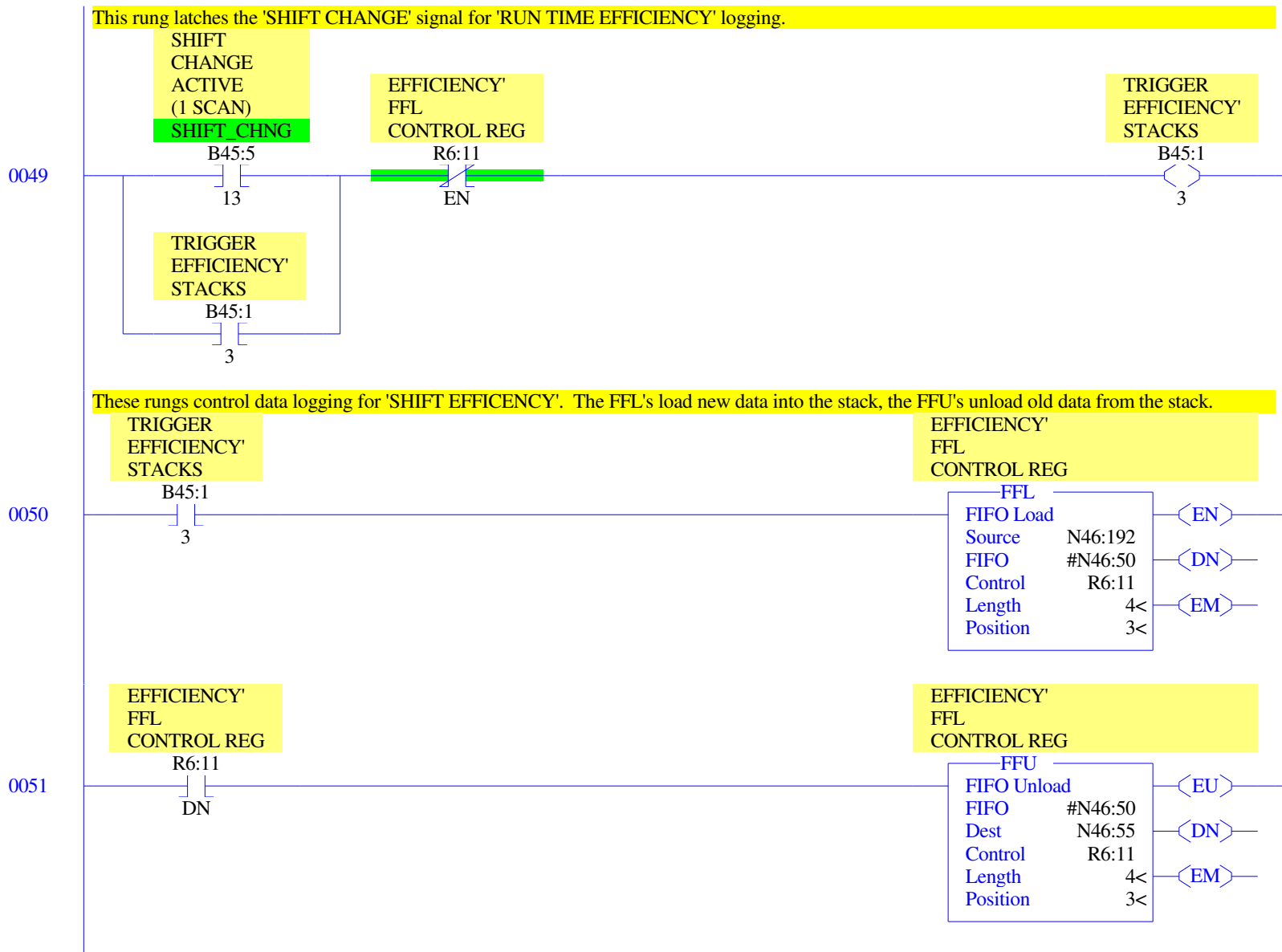
MUL

Multiply	
Source A	F49:0
	0.0<
Source B	100.0
	100.0<
Dest	F49:1
	0.0<

CURRENT SHIFT
 EFFICIENCY
 PERCENT
 (INTEGER)

MOV

Move	
Source	F49:1
	0.0<
Dest	N46:192
	0<



Prodata - Shift Cycle Count

This rung monitors the 'SHIFT CYCLE COUNT'.

Prod Data
Module Input
MACHINE
CYCLE COUNT
TRIGGER

ONESHOT

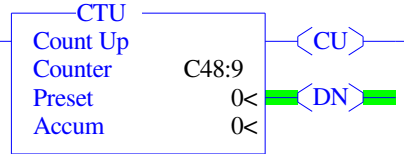
SHIFT
CYCLE
COUNT'
CNTR

SHIFT_CYCLE

0052

B45:0
0

B45:2
ONS
1



This rung latches the 'SHIFT CHANGE' signal for 'SHIFT CYCLE COUNT' logging.

SHIFT
CHANGE
ACTIVE
(1 SCAN)
SHIFT_CHNG

SHIFT
COUNT'
FFL
CONTROL REG

TRIGGER
SHIFT
COUNT'
STACKS

0053

B45:5
13

R6:15
EN

B45:1
8

TRIGGER
SHIFT
COUNT'
STACKS

B45:1
8

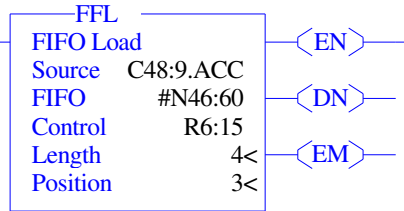
These rungs control data logging for 'SHIFT CYCLE COUNT'. The FFL's load new data into the stack, the FFU's unload old data from the stack.

TRIGGER
SHIFT
COUNT'
STACKS

SHIFT
COUNT'
FFL
CONTROL REG

0054

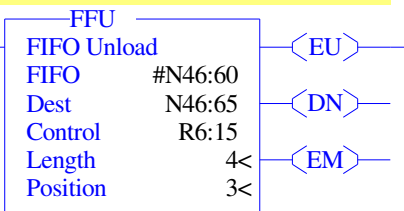
B45:1
8



SHIFT
COUNT'
FFL
CONTROL REG

R6:15
DN

SHIFT
COUNT'
FFL
CONTROL REG



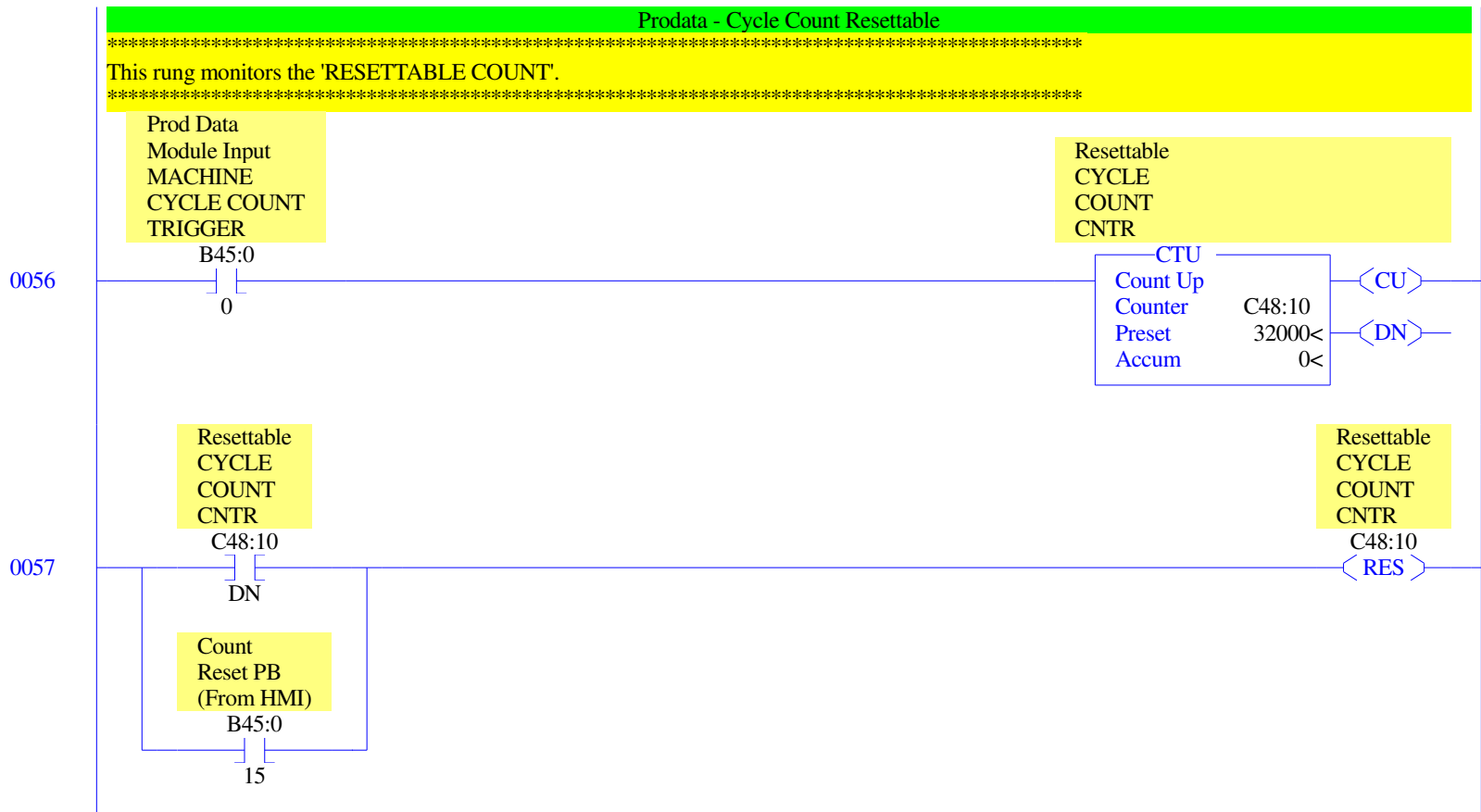
0055

SHIFT
CYCLE
COUNT'
CNTR

SHIFT_CYCLE

C48:9

RES



Prod Data - Machine Total Run Time

This is like a cars odometer and will continue to count up the hours of run time of the machine.

Prod Data
Module Input
MACHINE
RUNNING
STATUS

B45:0

1

Total
Machine
Run Time
Seconds

RTO

Retentive Timer On	
Timer	T47:20
Time Base	0.01
Preset	6000<
Accum	4039<

EN

DN

Total
Machine
Run Time
Seconds

T47:20

DN

Total
Machine
Run Time
Minutes

ADD

Add	
Source A	F49:10 0.0<
Source B	1.0 1.0<
Dest	F49:10 0.0<

Total
Machine
Run Time
Seconds

T47:20

RES

Total
Machine
Run Time
Minutes

GEQ

Grtr Than or Eql (A>=B)

Source A	F49:10 0.0<
Source B	60.0 60.0<

Total
Machine
Run Time
Minutes

MOV

Move

Source	0.0 0.0<
Dest	F49:10 0.0<

Total
Machine
Run Time
Hours

ADD

Add

Source A	F49:11 0.0<
Source B	1.0 1.0<
Dest	F49:11 0.0<

0058

Prod Data - Reset Production Information for Shipping

This resets all critical Production and time data.

Combi
Reset
Data
PB
(From HMI)

Combi
Reset
Data
ONS

Total
Machine
Run Time
Minutes

B45:0
10

B45:0
11

MOV

Move Source	0.0
	0.0<
Dest	F49:10
	0.0<

Total
Machine
Run Time
Hours

MOV

Move Source	0.0
	0.0<
Dest	F49:11
	0.0<

RUN
TIME'
ACCUM
TMR
(SECONDS)
CRT_ACC
T47:0
<RES>

FAULT
TIME'
ACCUM
TMR
(SECONDS)
CFT_ACC
T47:1
<RES>

IDLE
TIME'
ACCUM
TMR
(SECONDS)
CIT_ACC
T47:2
<RES>

RUN
TIME'
ACCUM
TIME
(MINUTES)
CRT_MIN_ACC
C48:0
<RES>

0059

FAULT
TIME'
ACCUM
TIME
(MINUTES)
CFT_MIN_ACC

C48:2

RES

IDLE
TIME'
ACCUM
TIME
(MINUTES)
CIT_MIN_ACC

C48:4

RES

MACHINE
CYCLE
COUNT
1 -
1000
TOTAL_CYCLES_LOW

C48:6

RES

MACHINE
CYCLE
COUNT
1,000 -
10000000
TOTAL_CYCLES_HIGH

C48:7

RES

MINUTES FOR
CURRENT
SHIFT
SHIFT_MIN

C48:8

RES

SHIFT
CYCLE
COUNT'
CNTR
SHIFT_CYCLE

C48:9

RES

Resettable
CYCLE
COUNT
CNTR

C48:10

RES

Production Data
Runtime Minutes
Storage 3

FLL
Fill File
Source 0
Dest #N46:10
Length 60

0060

Combi
Reset
Data
PB
(From HMI)

Combi
Reset
FFL
ONS

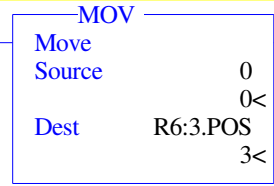
B45:0

B45:0

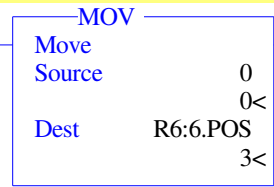
10

9

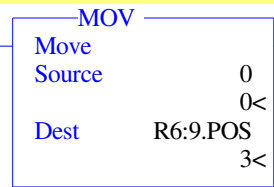
RUN
TIME'
MINUTES
FFL
CONTROL REG



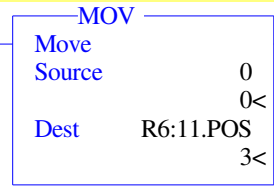
FAULT
TIME'
MINUTES
FFL
CONTROL REG



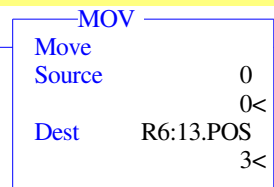
IDLE
TIME'
MINUTES
FFL
CONTROL REG



EFFICIENCY'
FFL
CONTROL REG



MAX RUN
TIME'
MINUTES
FFL
CONTROL REG



SHIFT
COUNT
FFL
CONTROL REG

MOV

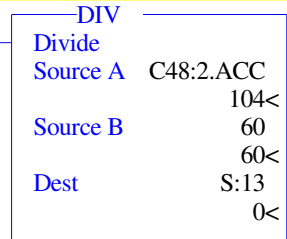
Move	
Source	0 0<
Dest	R6:15.POS 3<

Prod Data - Total Minutes Formatted for Hours and Minutes

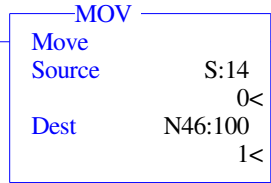
The Production Data is collected in total minutes but needs to be reformatted into Hours and Minuts just for the HMI Display. The following lines does this conversion for the HMI variables.

0061

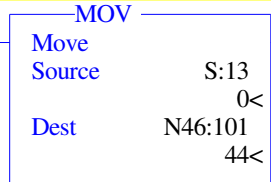
Math Register



HMI Display Current Faulttime Hours



HMI Display Current Faulttime Minutes



0062

Math Register

DIV
 Divide
 Source A C48:4.ACC
 0<
 Source B 60
 60<
 Dest S:13
 0<

HMI Display Current Idletime Hours

MOV
 Move
 Source S:14
 0<
 Dest N46:110
 0<

HMI Display Current Idletime Minutes

MOV
 Move
 Source S:13
 0<
 Dest N46:111
 0<

0063

Math Register

DIV
 Divide
 Source A C48:0.ACC
 0<
 Source B 60
 60<
 Dest S:13
 0<

HMI Display Current Runtime Hours

MOV
 Move
 Source S:14
 0<
 Dest N46:120
 0<

HMI Display Current Runtime Minutes

MOV
 Move
 Source S:13
 0<
 Dest N46:121
 0<

0064

Math Register

DIV
Divide
Source A N46:22
479<
Source B 60
60<
Dest S:13
0<

HMI Display Faulttime 1 History Hours

MOV
Move
Source S:14
0<
Dest N46:130
7<

HMI Display Faulttime 1 History Minutes

MOV
Move
Source S:13
0<
Dest N46:131
59<

Math Register

DIV
Divide
Source A N46:21
480<
Source B 60
60<
Dest S:13
0<

HMI Display Faulttime 2 History Hours

MOV
Move
Source S:14
0<
Dest N46:132
8<

HMI Display Faulttime 2 History Minutes

MOV
Move
Source S:13
0<
Dest N46:133
0<

0065

0066

Math Register

DIV
 Divide
 Source A N46:20
 2096<
 Source B 60
 60<
 Dest S:13
 0<

HMI Display Faulttime 3 History Hours

MOV
 Move
 Source S:14
 0<
 Dest N46:134
 34<

HMI Display Faulttime 3 History Minutes

MOV
 Move
 Source S:13
 0<
 Dest N46:135
 56<

Math Register

DIV
 Divide
 Source A N46:32
 0<
 Source B 60
 60<
 Dest S:13
 0<

HMI Display Idletime 1 History Hours

MOV
 Move
 Source S:14
 0<
 Dest N46:140
 0<

HMI Display Idletime 1 History Minutes

MOV
 Move
 Source S:13
 0<
 Dest N46:141
 0<

0067

0068

Math Register

DIV
 Divide
 Source A N46:31
 0<
 Source B 60
 60<
 Dest S:13
 0<

HMI Display
 Idletime 2 History
 Hours

MOV
 Move
 Source S:14
 0<
 Dest N46:142
 0<

HMI Display
 Idletime 2 History
 Minutes

MOV
 Move
 Source S:13
 0<
 Dest N46:143
 0<

0069

Math Register

DIV
 Divide
 Source A N46:30
 0<
 Source B 60
 60<
 Dest S:13
 0<

HMI Display
 Idletime 3 History
 Hours

MOV
 Move
 Source S:14
 0<
 Dest N46:144
 0<

HMI Display
 Idletime 3 History
 Minutes

MOV
 Move
 Source S:13
 0<
 Dest N46:145
 0<

0070

Math Register

DIV
Divide
Source A N46:42
0<
Source B 60
60<
Dest S:13
0<

HMI Display
MAX Runtime 1
History
Hours

MOV
Move
Source S:14
0<
Dest N46:150
0<

HMI Display
MAX Runtime 1
History
Minutes

MOV
Move
Source S:13
0<
Dest N46:151
0<

0071

Math Register

DIV
Divide
Source A N46:41
0<
Source B 60
60<
Dest S:13
0<

HMI Display
MAX Runtime 2
History
Hours

MOV
Move
Source S:14
0<
Dest N46:152
0<

HMI Display
MAX Runtime 2
History
Minutes

MOV
Move
Source S:13
0<
Dest N46:153
0<

0072

Math Register

DIV
Divide
Source A N46:40
0<
Source B 60
60<
Dest S:13
0<

HMI Display
MAX Runtime 3
History
Hours

MOV
Move
Source S:14
0<
Dest N46:154
0<

HMI Display
MAX Runtime 3
History
Minutes

MOV
Move
Source S:13
0<
Dest N46:155
0<

0073

Math Register

DIV
Divide
Source A N46:12
0<
Source B 60
60<
Dest S:13
0<

HMI Display Runtime 1 History Hours

MOV
Move
Source S:14
0<
Dest N46:160
0<

HMI Display Runtime 1 History Minutes

MOV
Move
Source S:13
0<
Dest N46:161
0<

0074

Math Register

DIV
Divide
Source A N46:11
0<
Source B 60
60<
Dest S:13
0<

HMI Display Runtime 2 History Hours

MOV
Move
Source S:14
0<
Dest N46:162
0<

HMI Display Runtime 2 History Minutes

MOV
Move
Source S:13
0<
Dest N46:163
0<

0075

Math Register

DIV
Divide
Source A N46:10
0<
Source B 60
60<
Dest S:13
0<

HMI Display Runtime 3 History Hours

MOV
Move
Source S:14
0<
Dest N46:164
0<

HMI Display Runtime 3 History Minutes

MOV
Move
Source S:13
0<
Dest N46:165
0<

0076

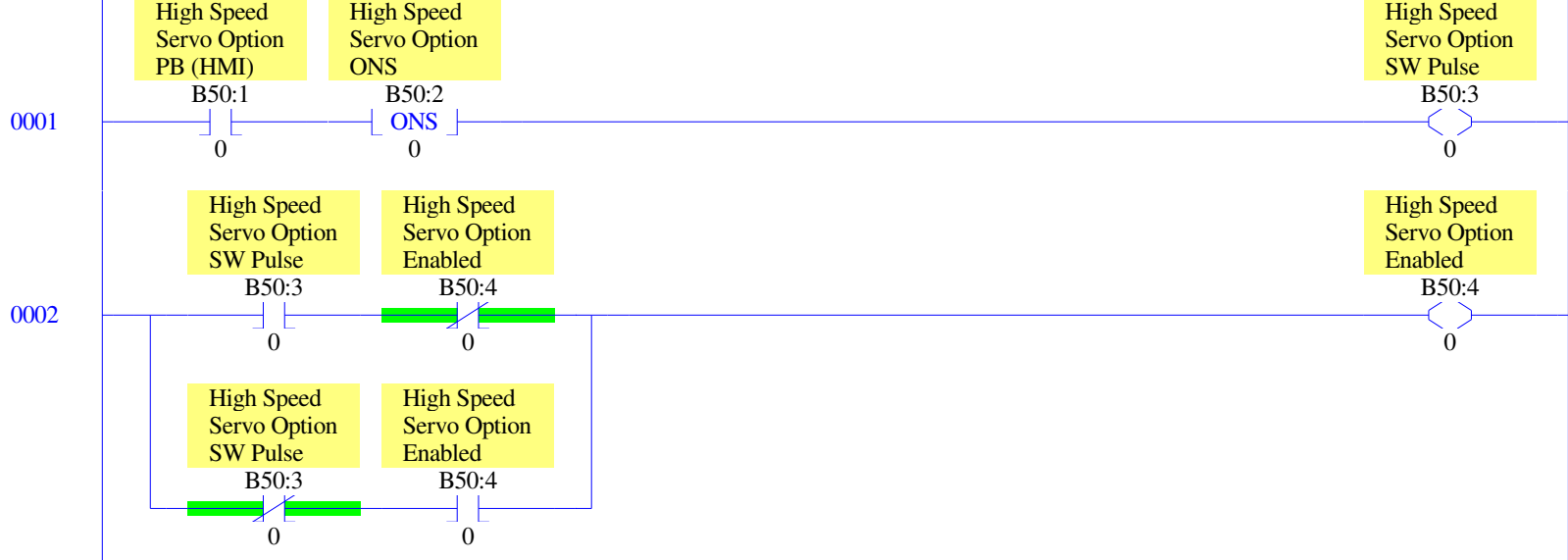
END

CE Main - Machine Option Selections

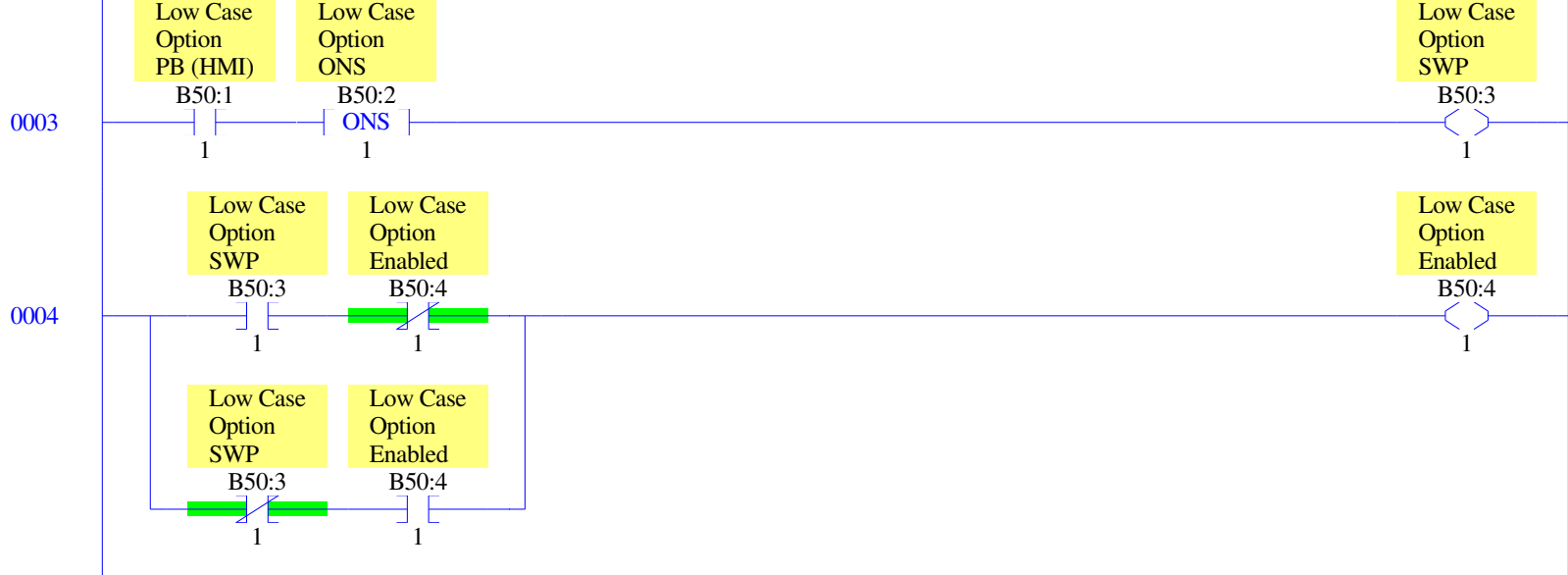
This Rung Restores last option settings from non-volatile memory

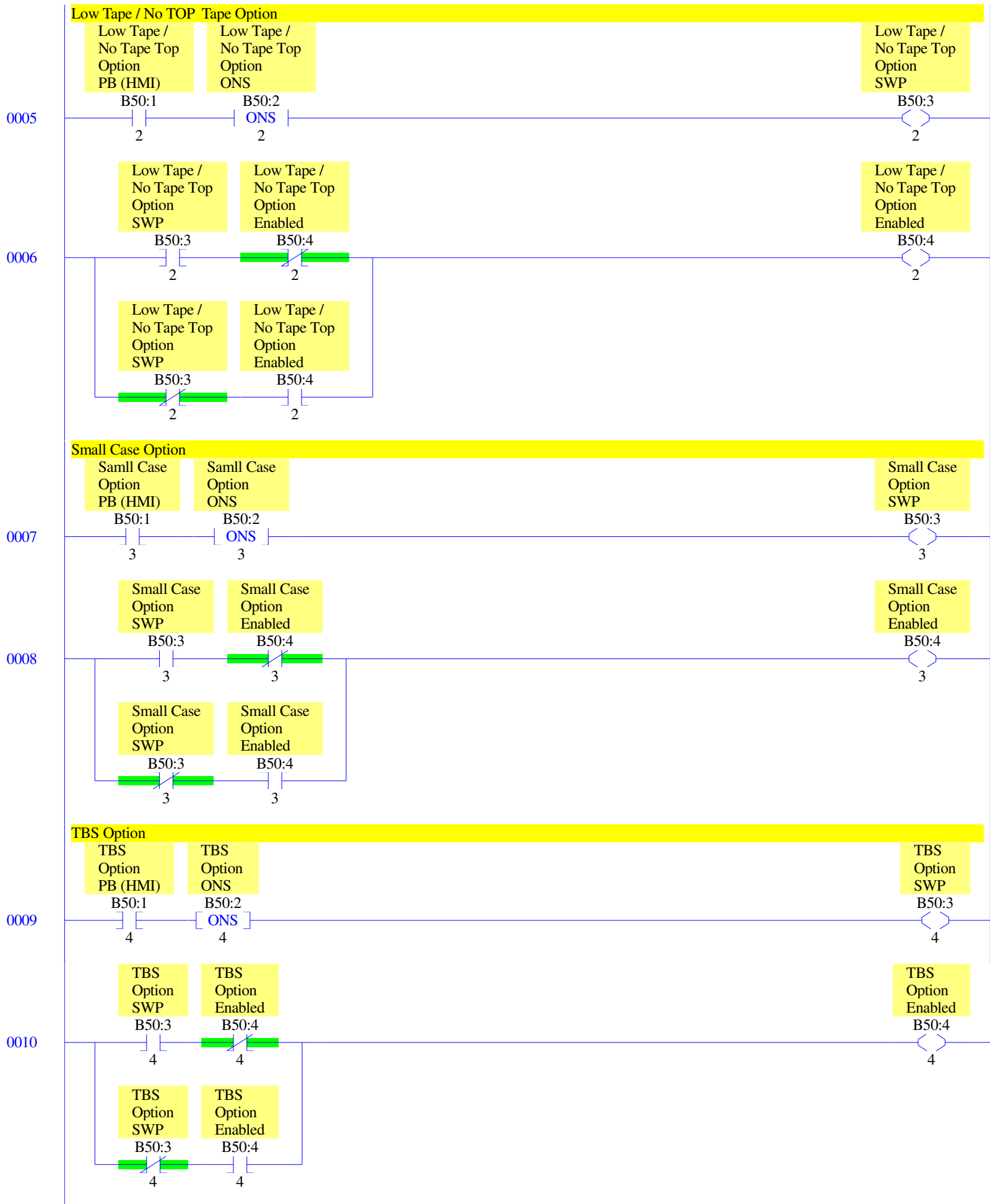


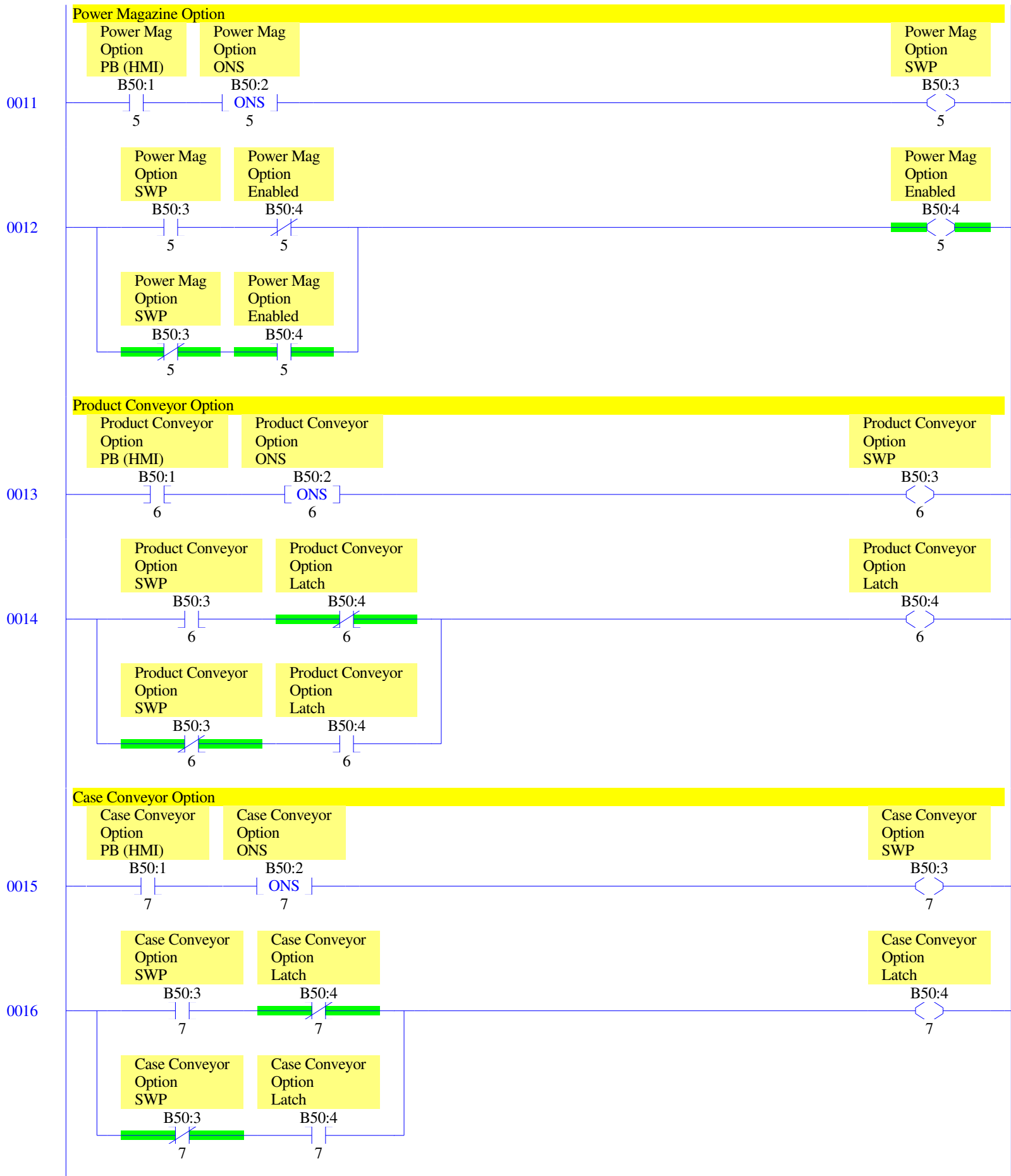
High Speed Servo Option

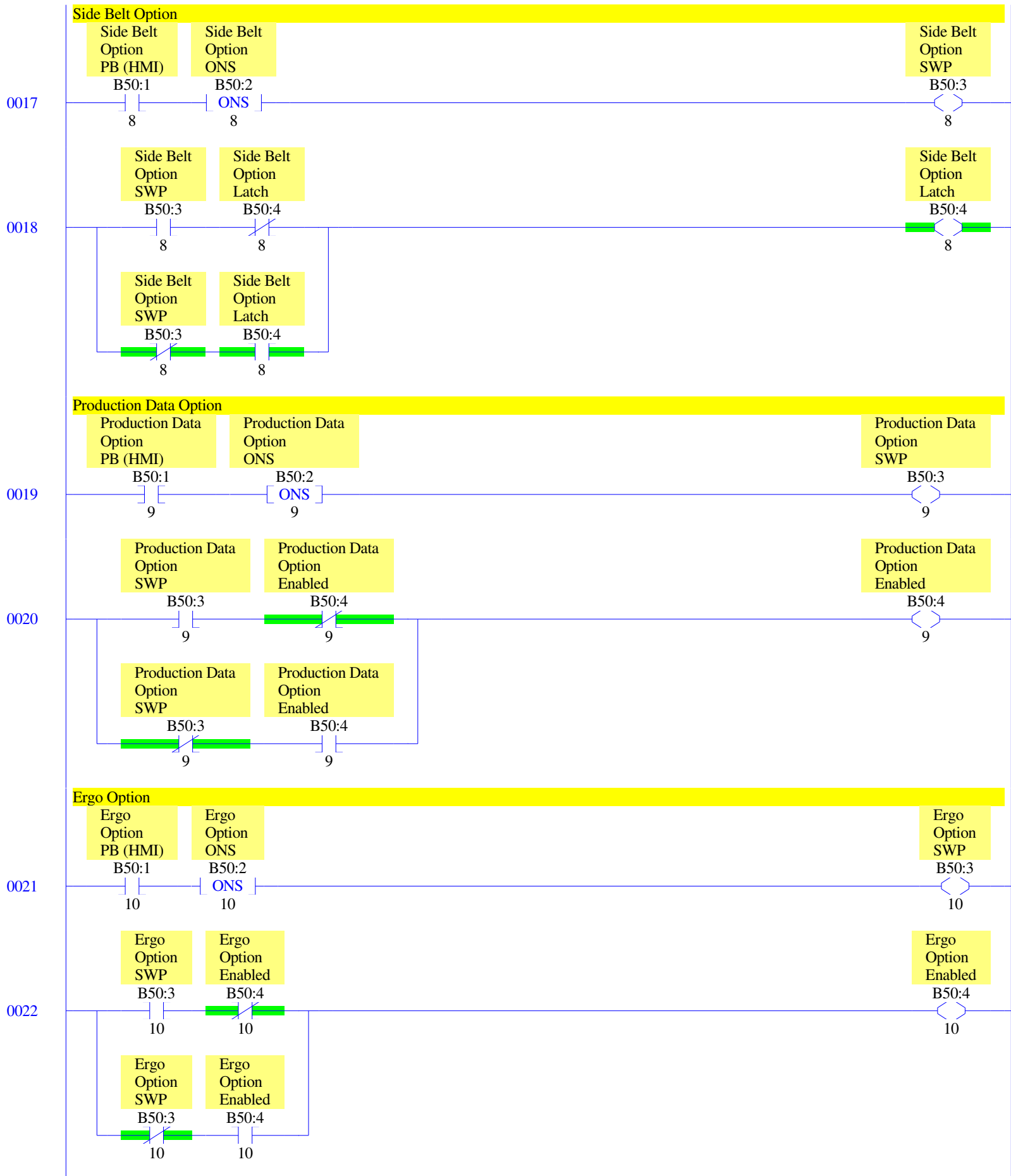


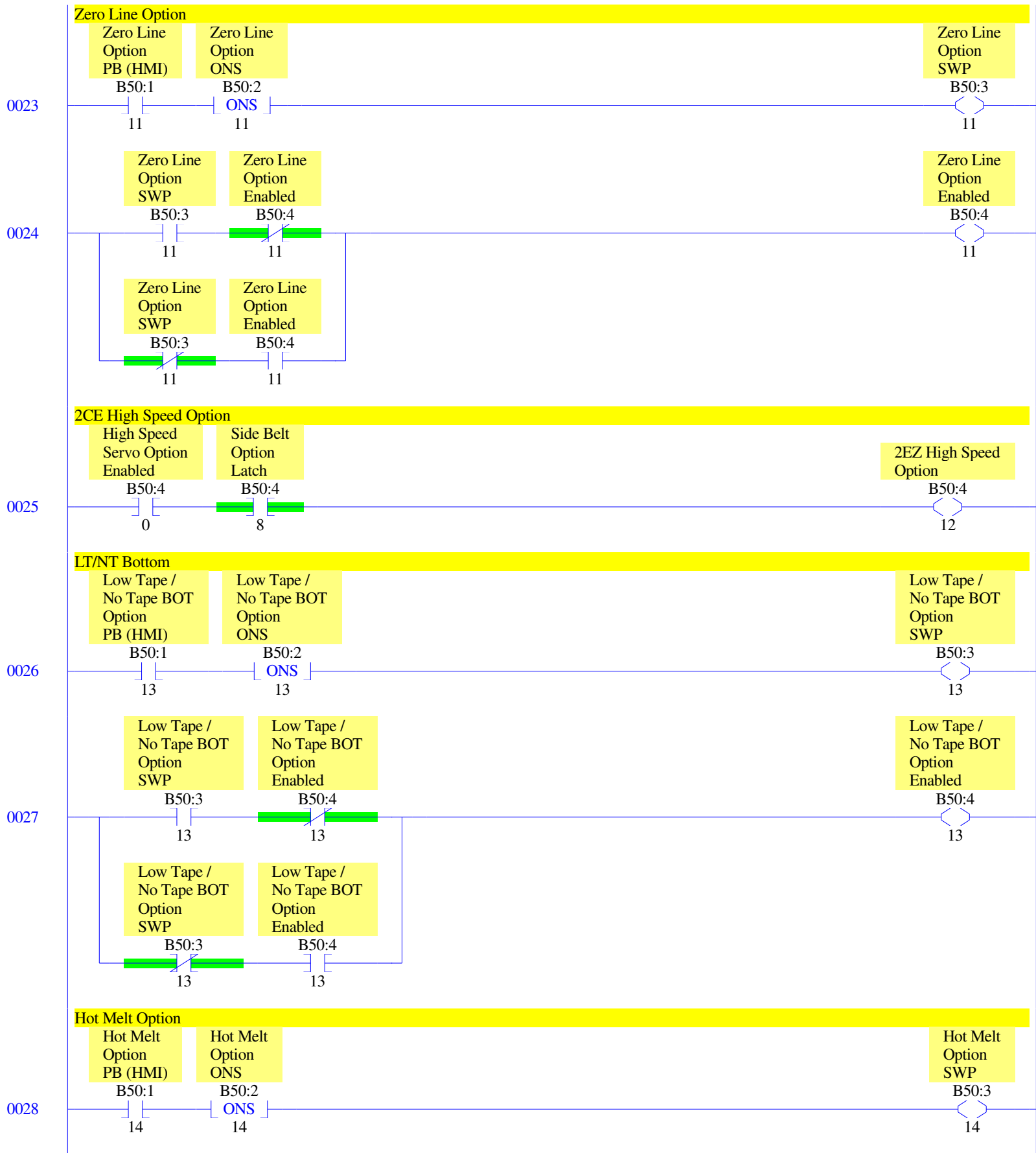
Low Case Option

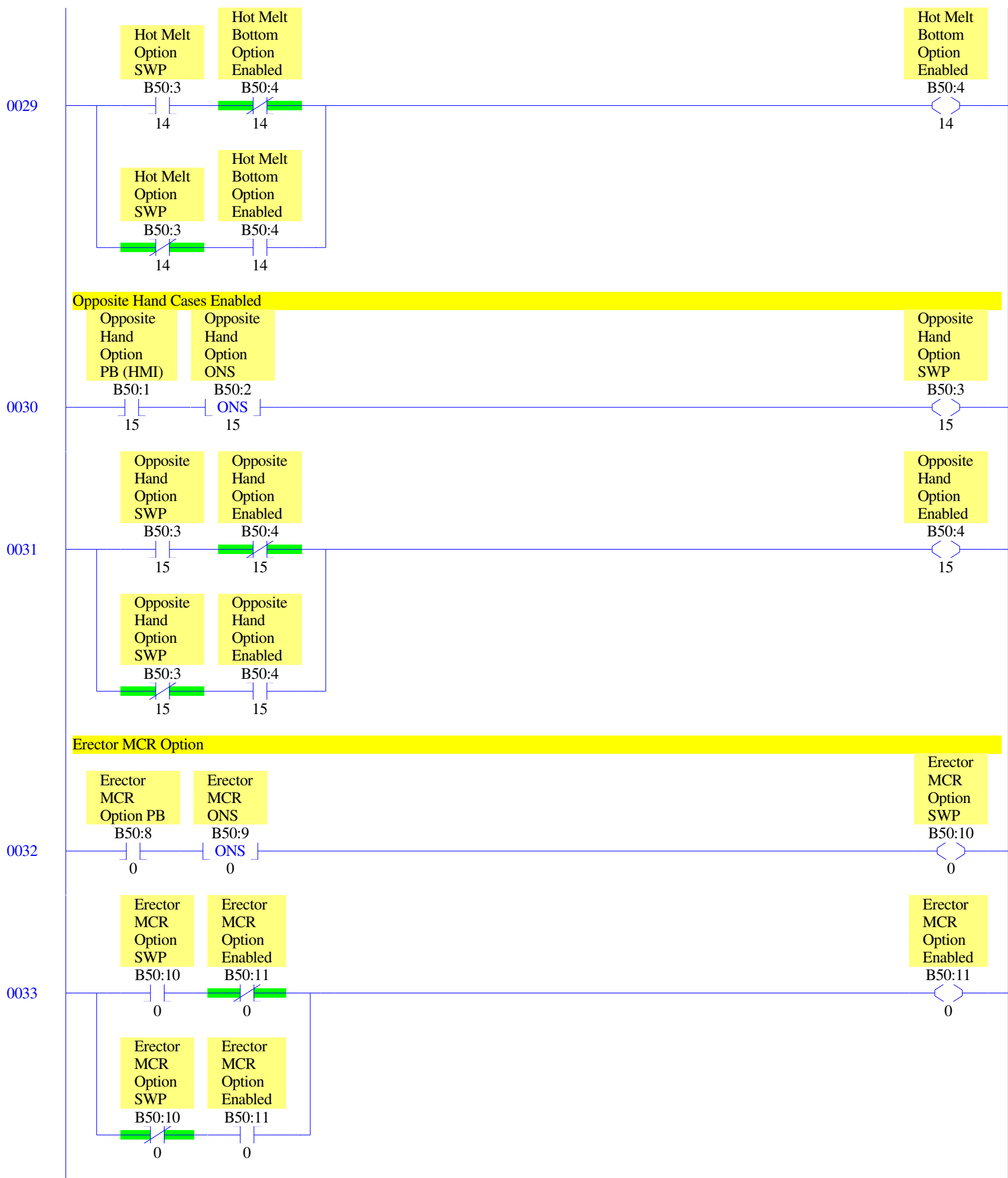


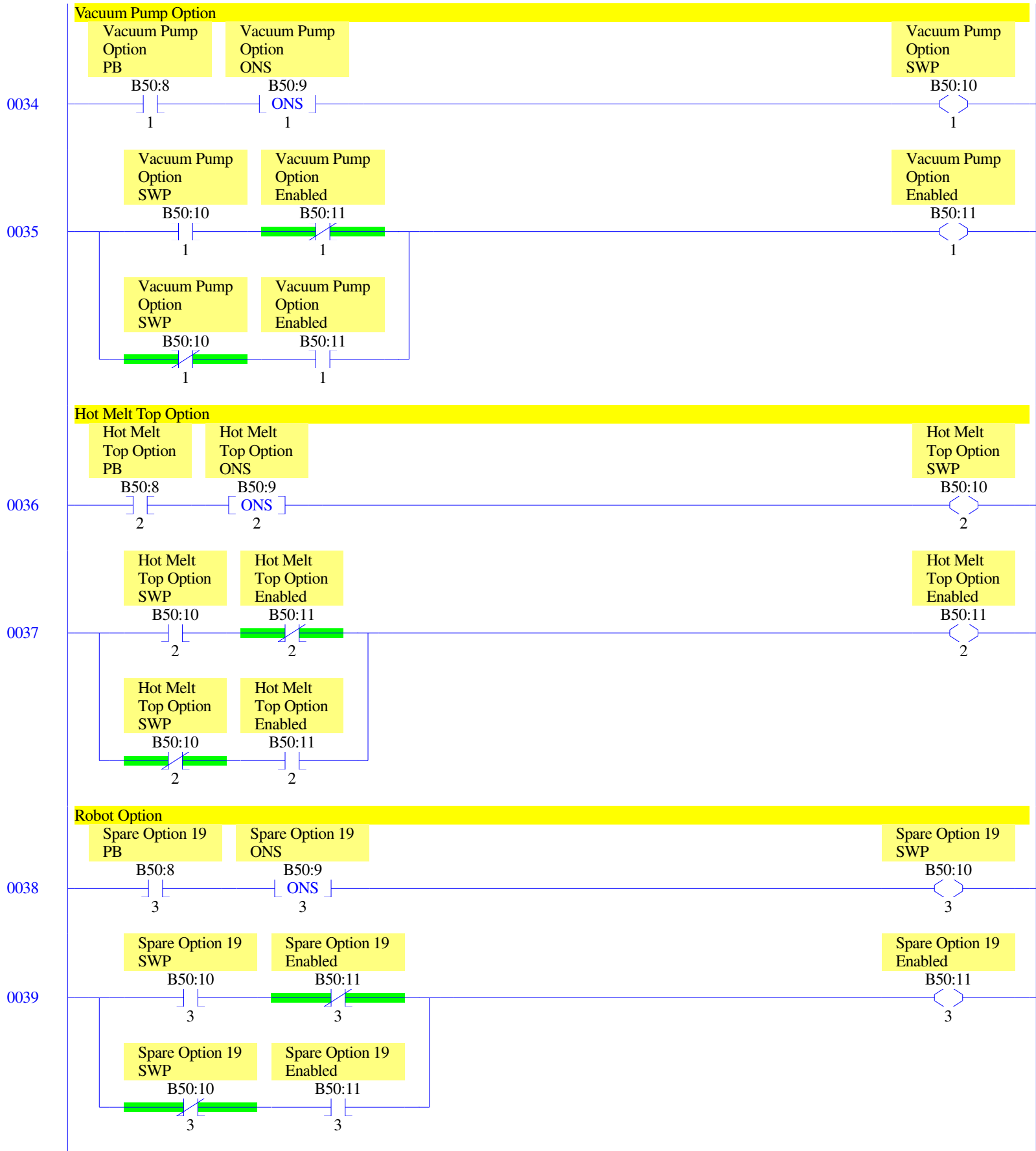


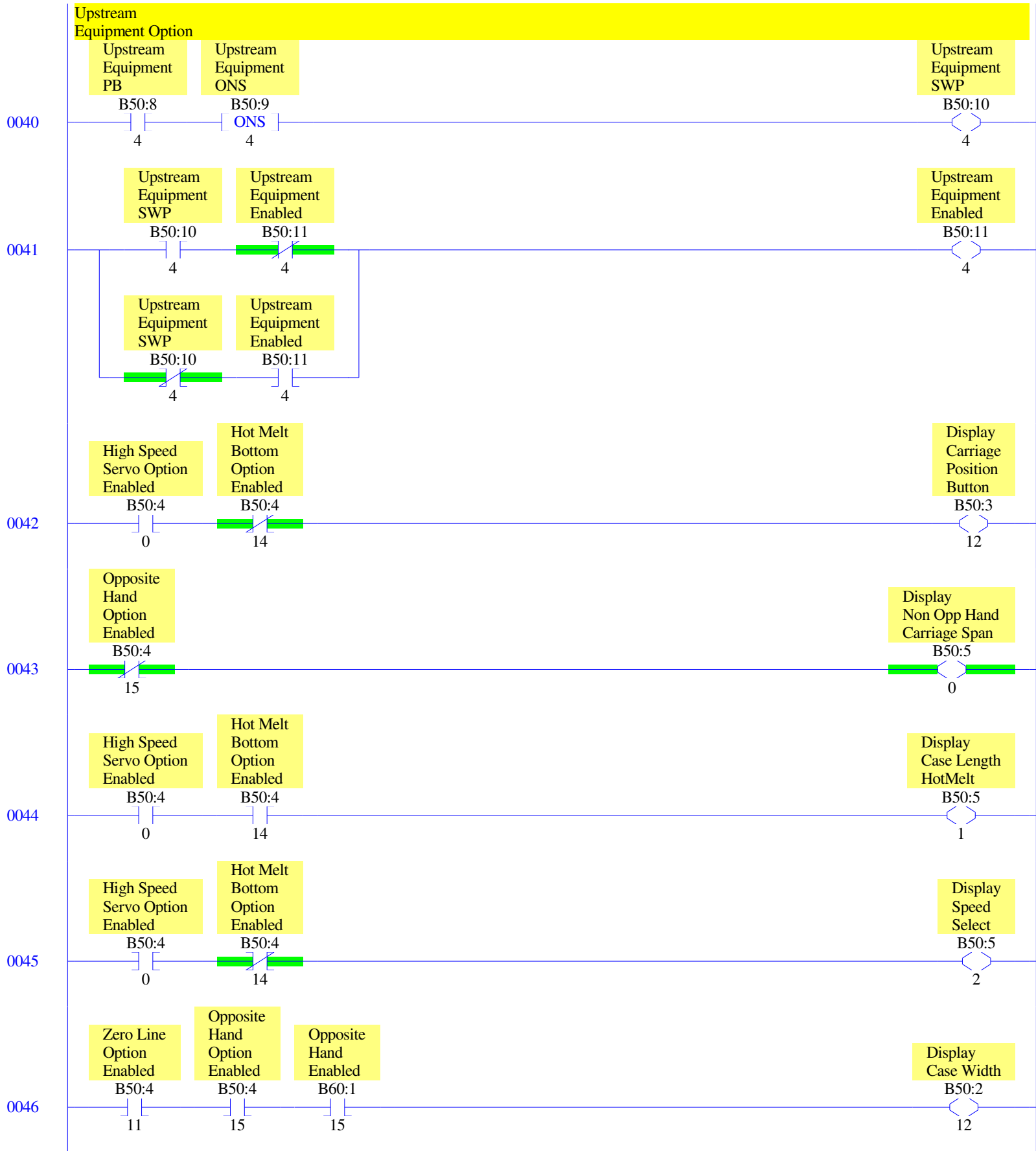


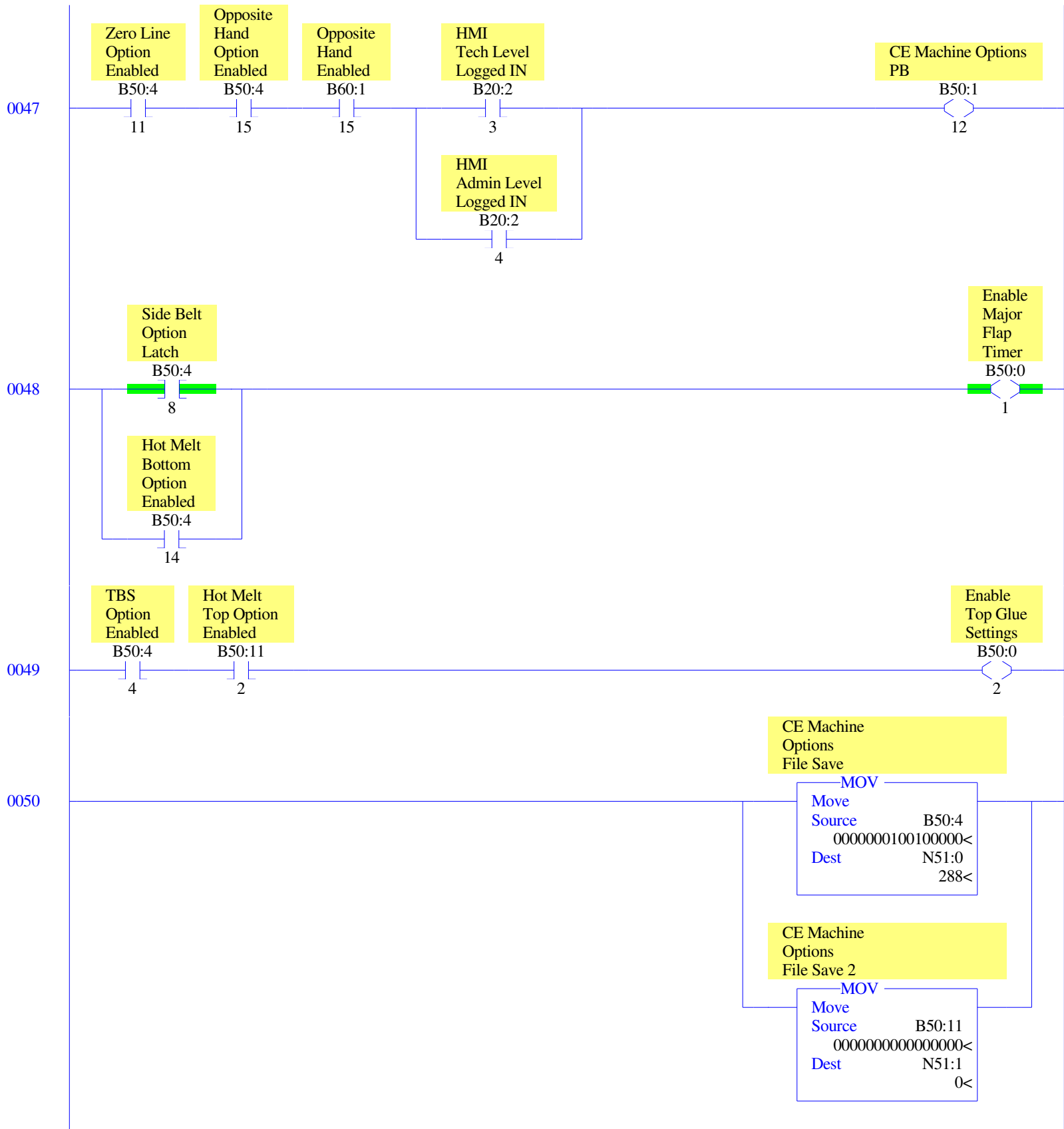


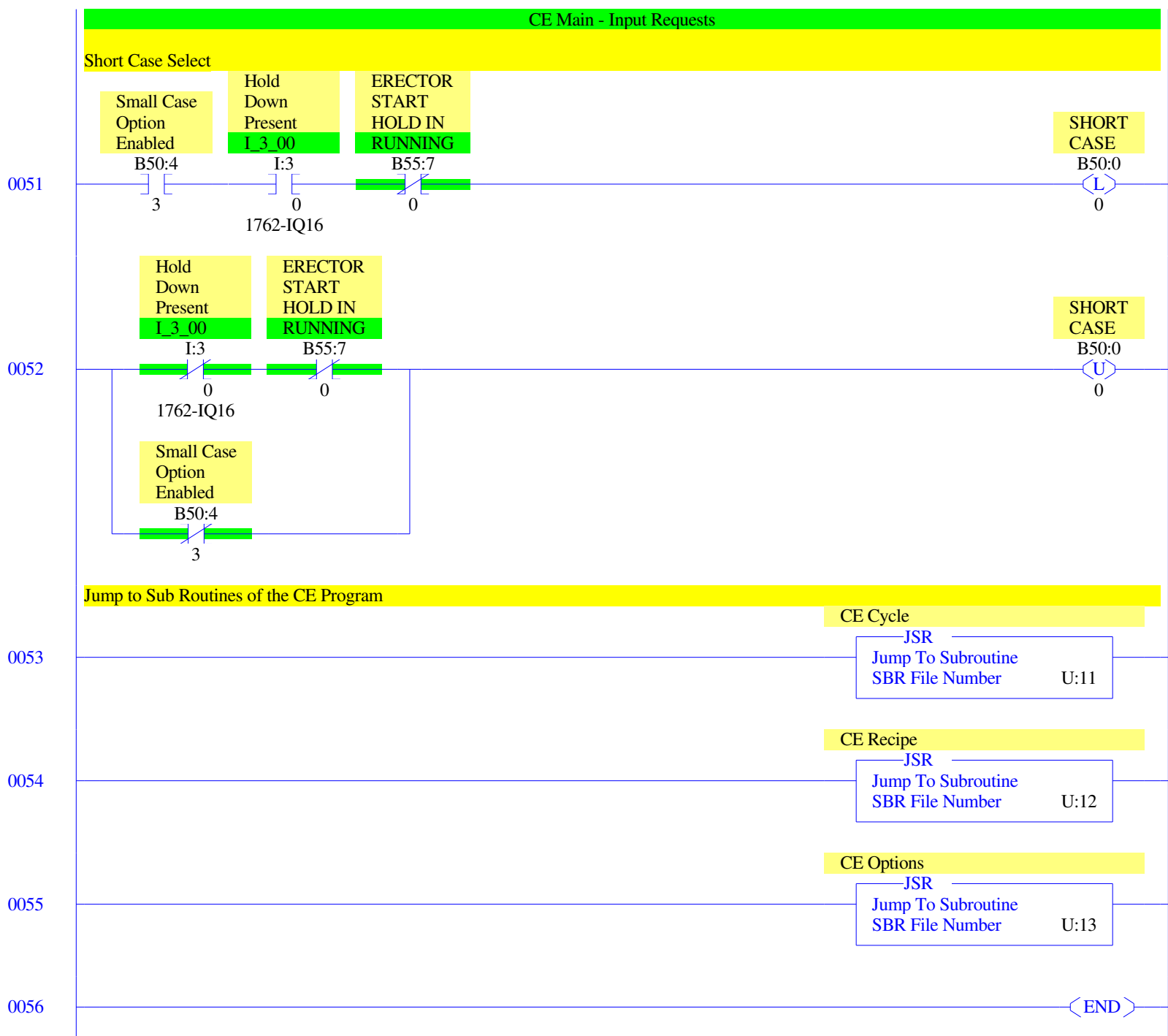


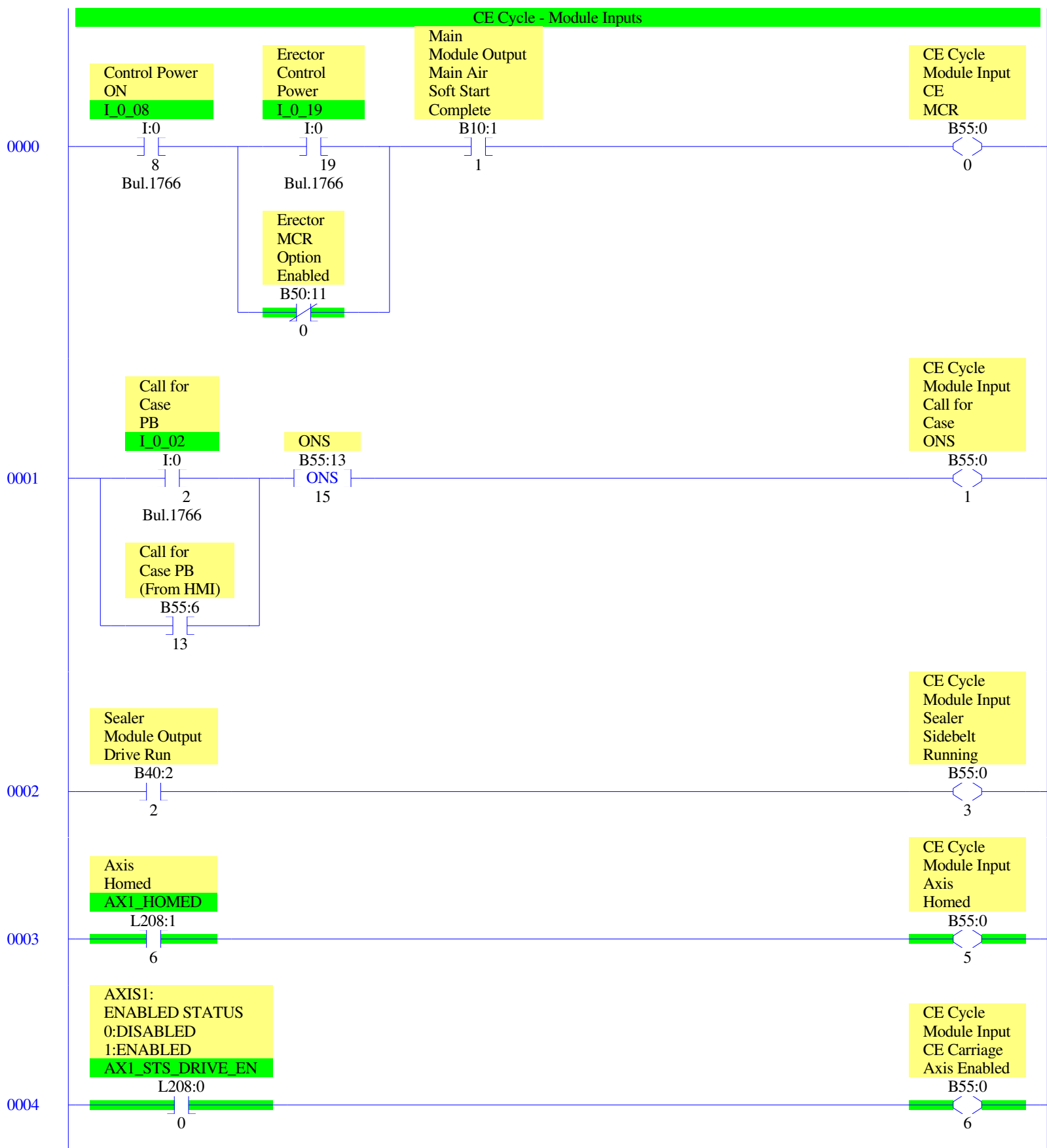


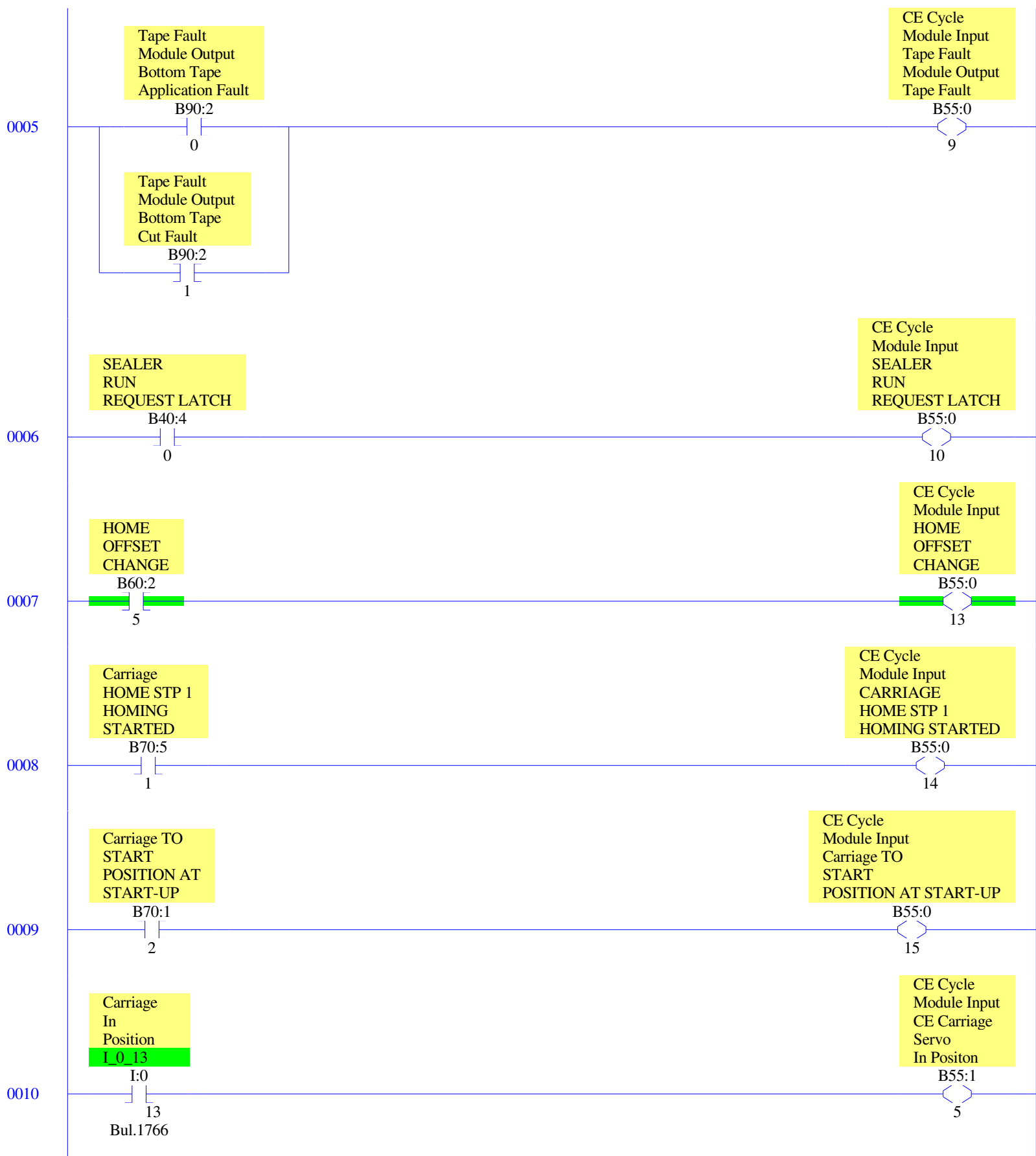


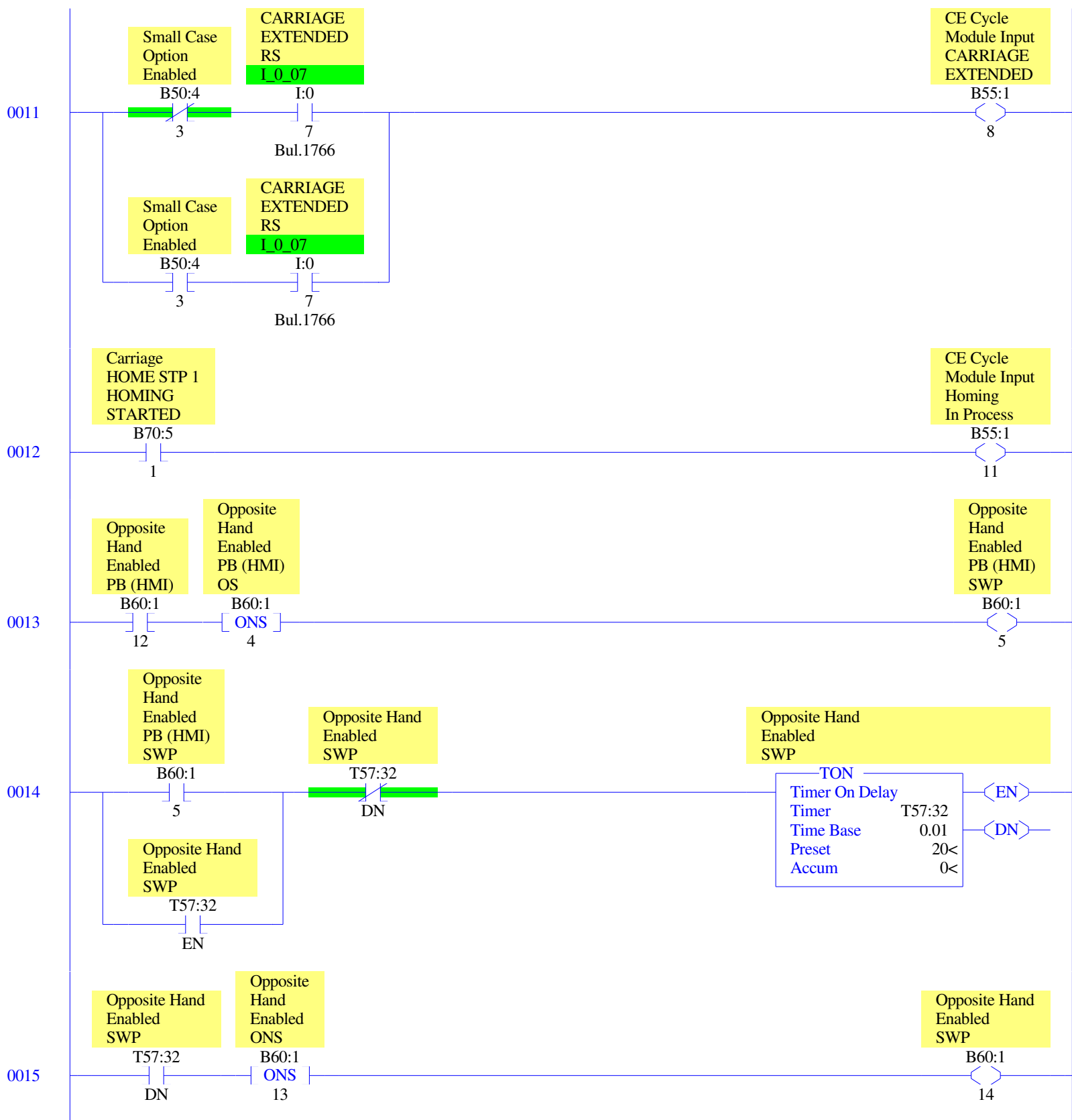


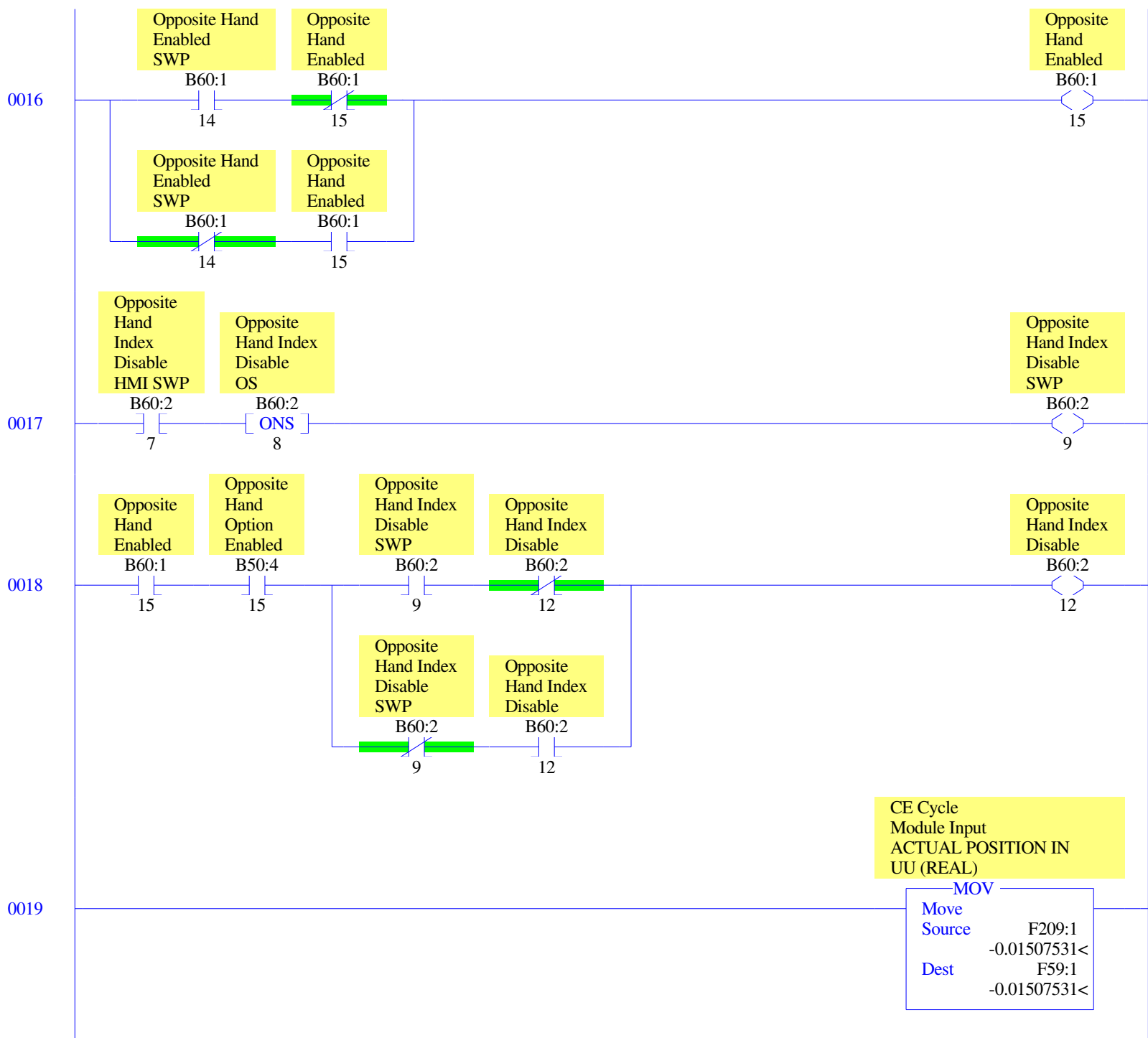








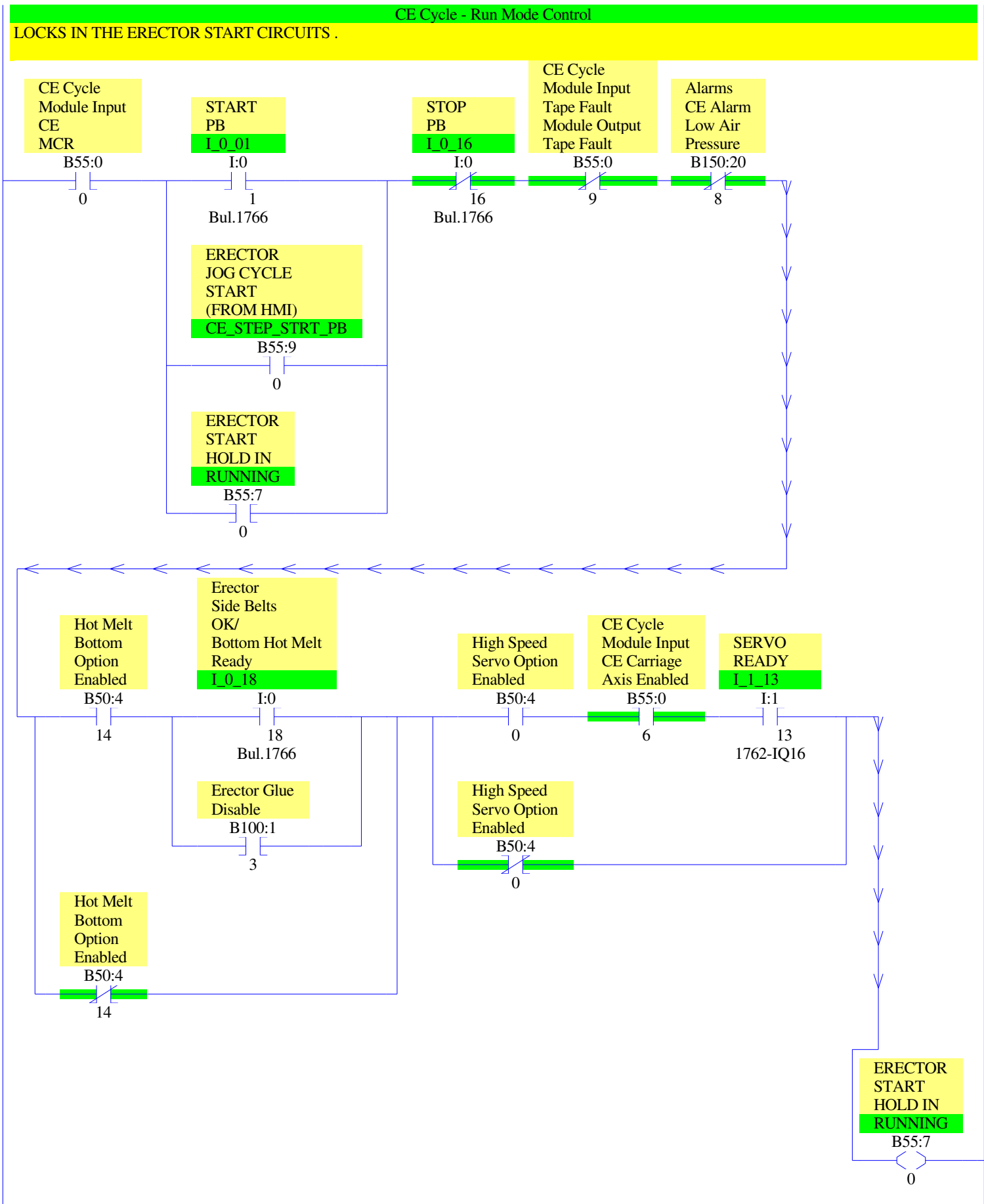


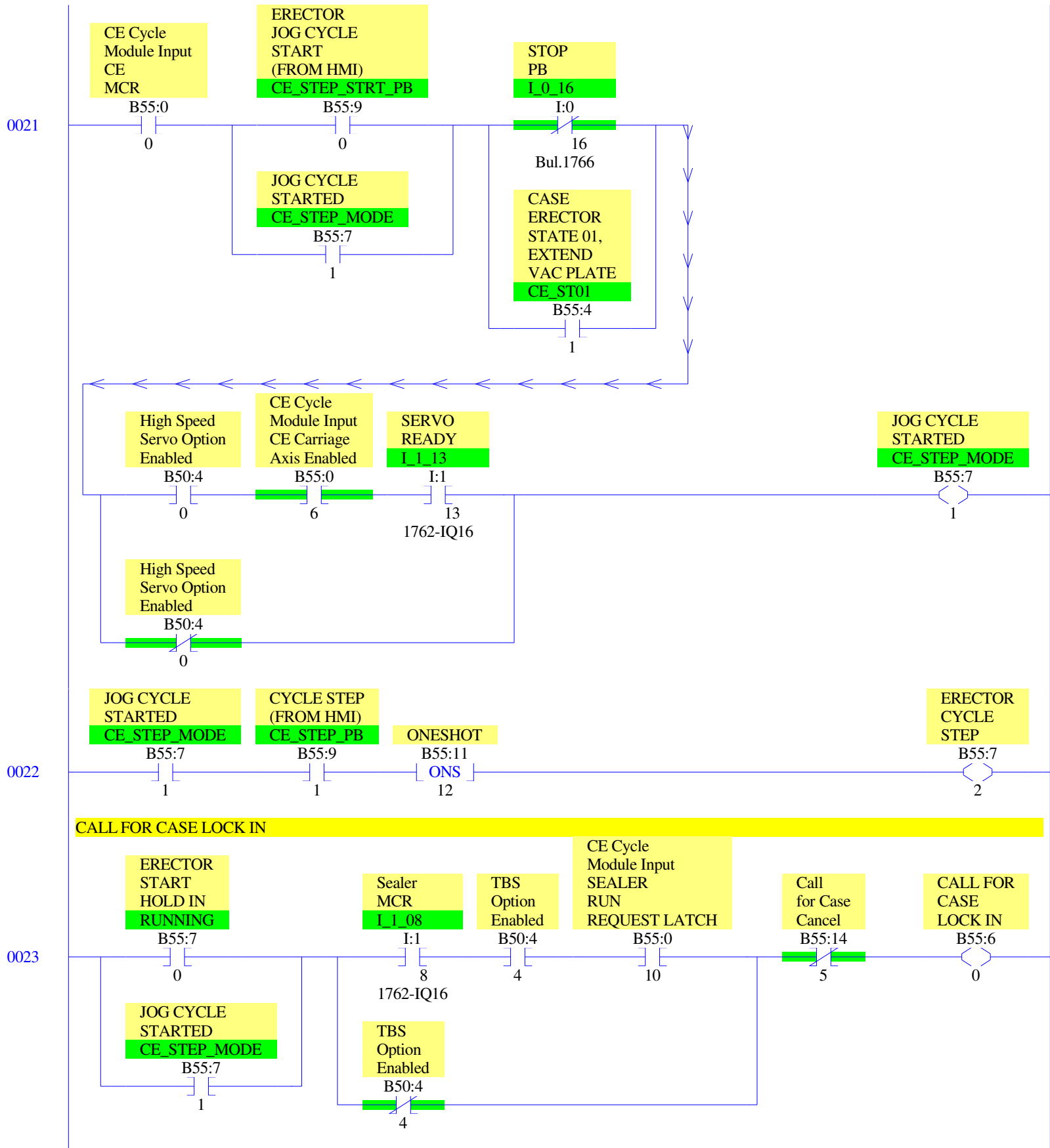


CE Cycle - Run Mode Control

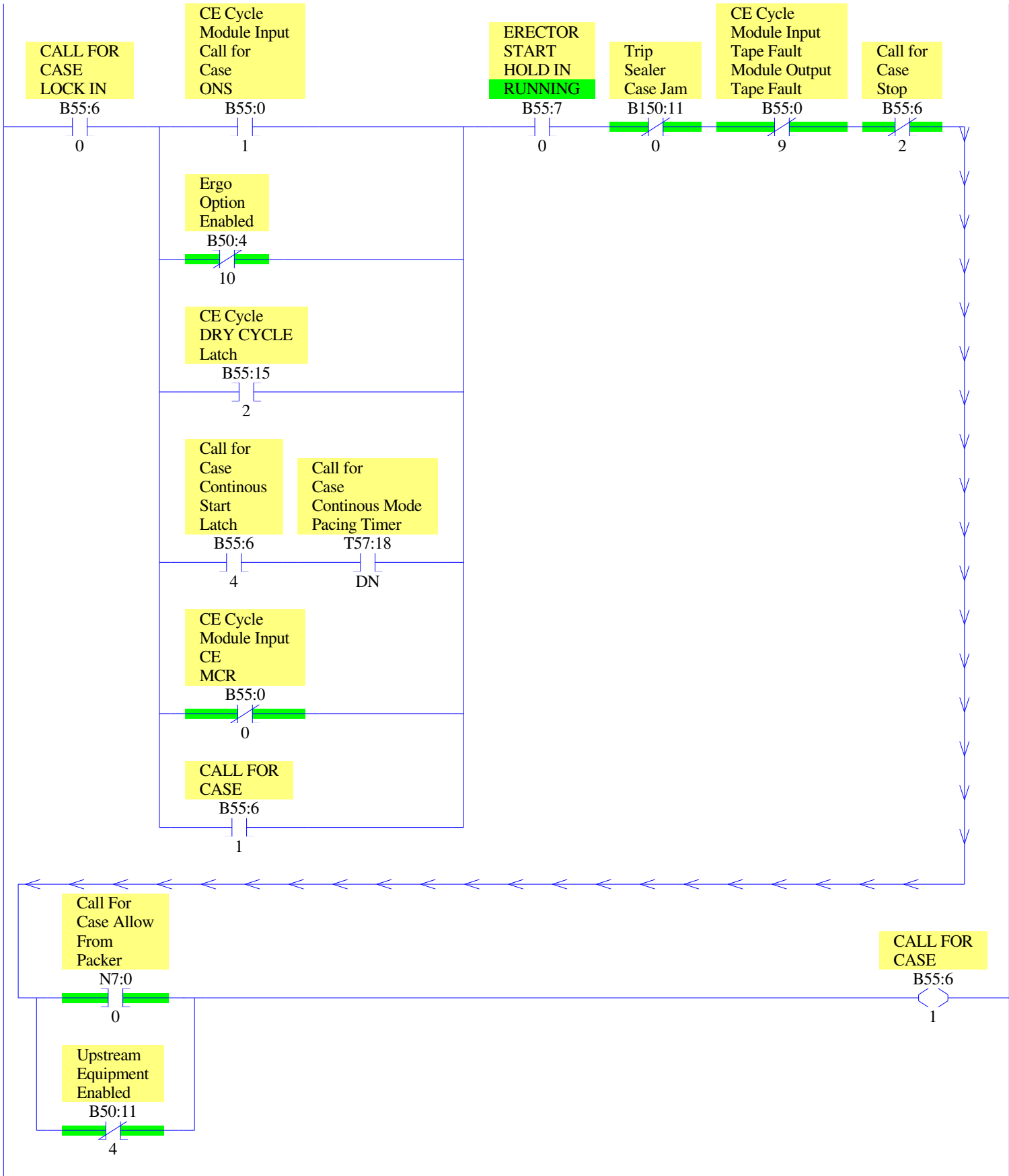
LOCKS IN THE ERECTOR START CIRCUITS .

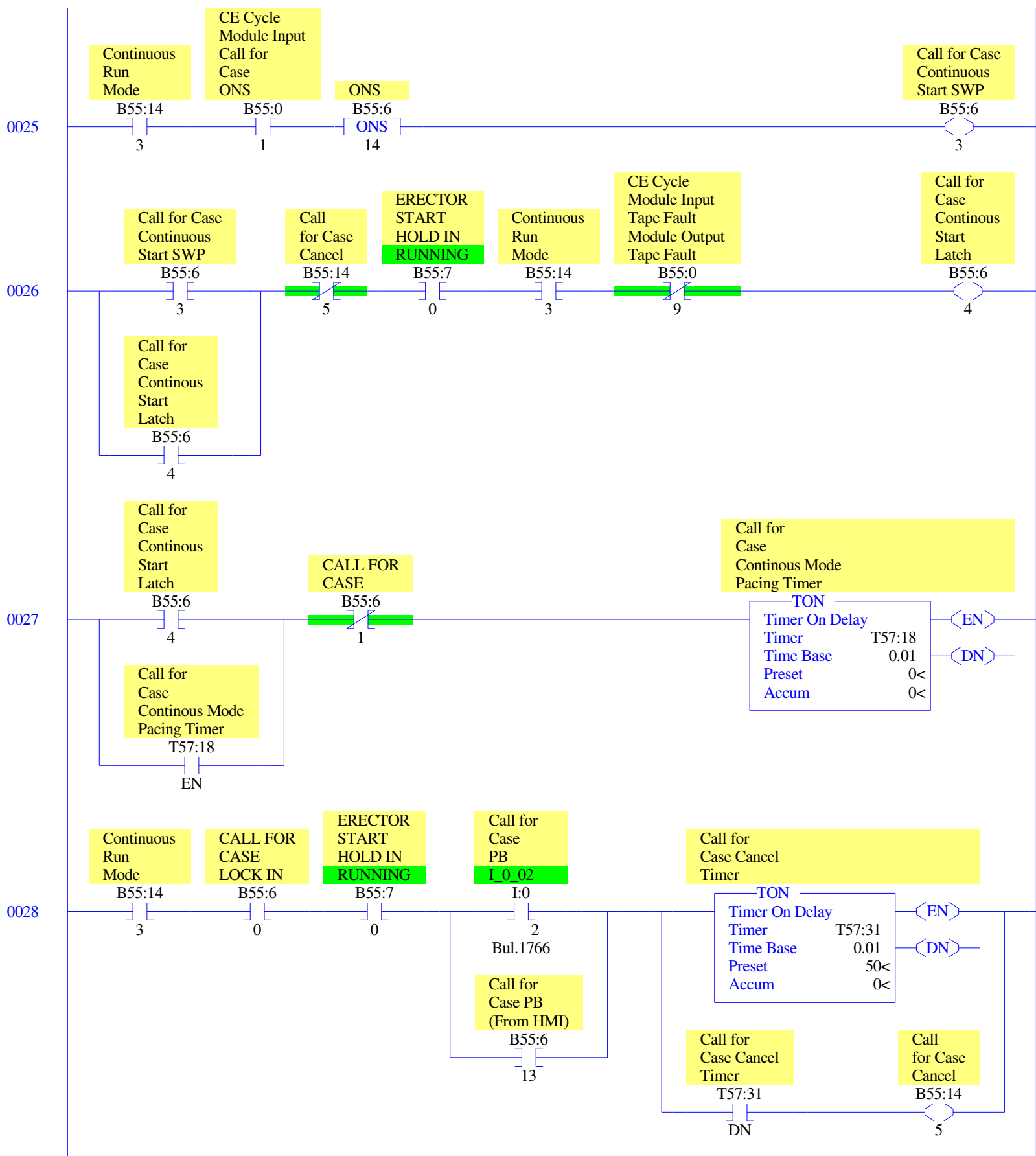
0020

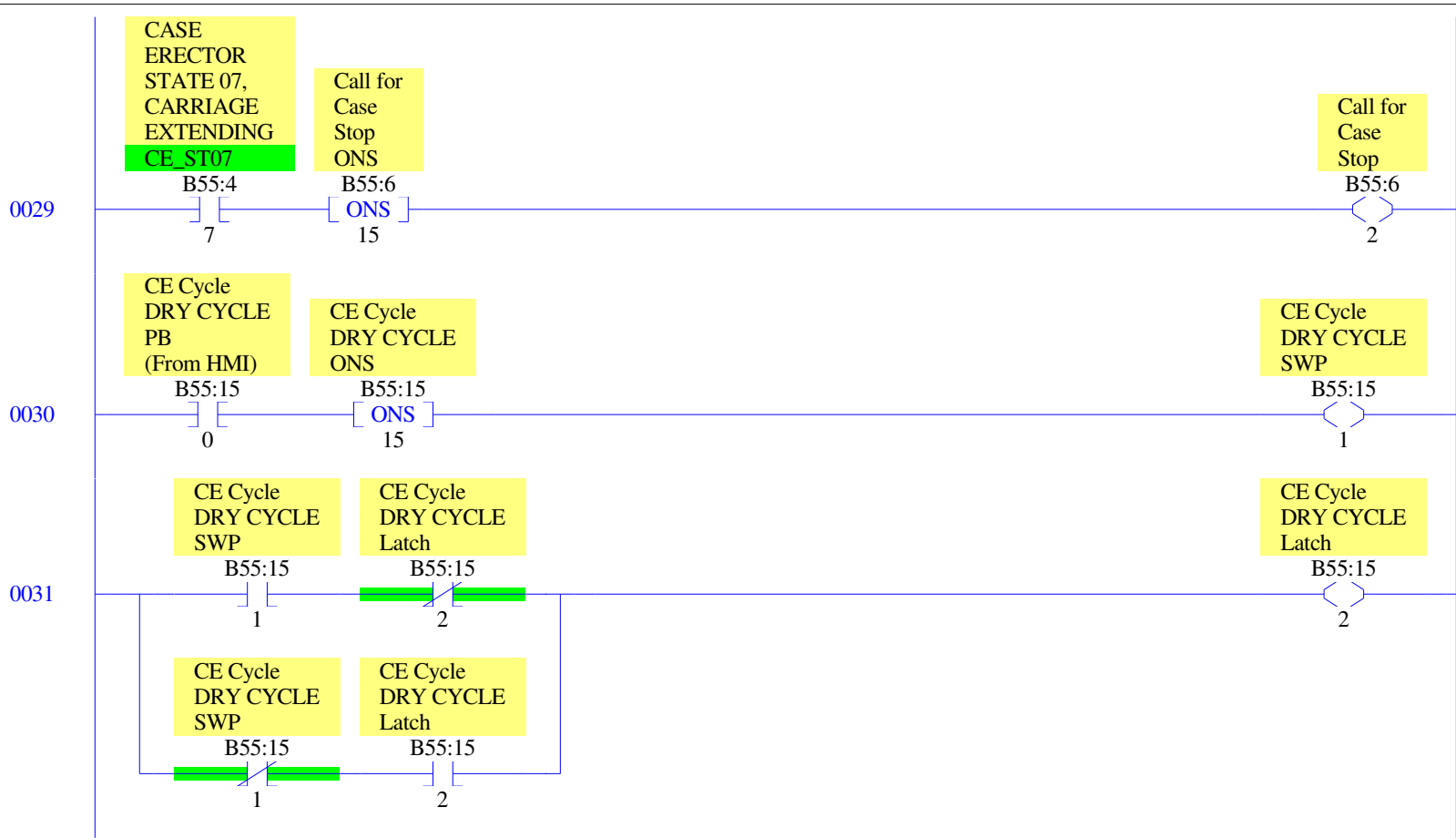


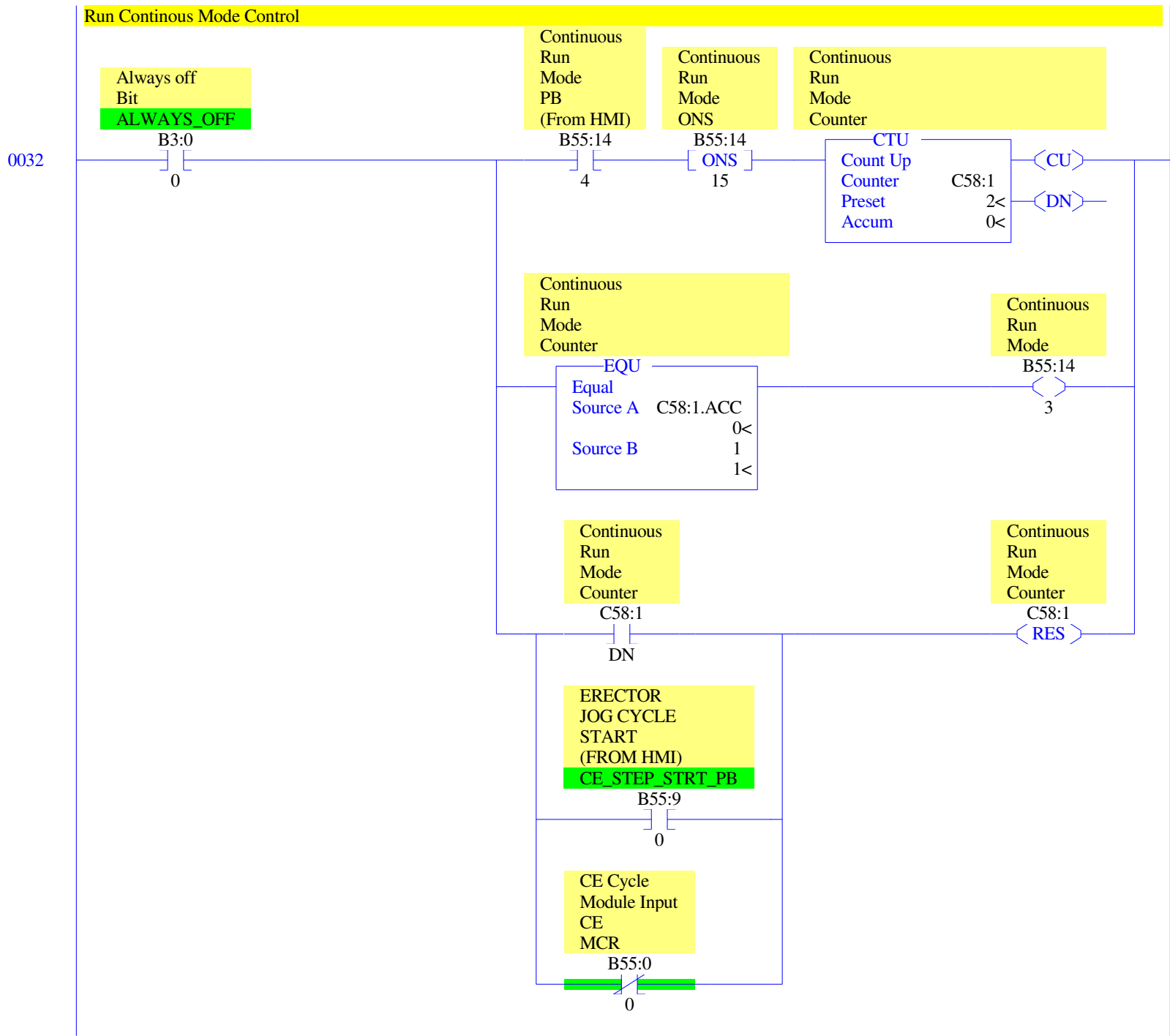


0024

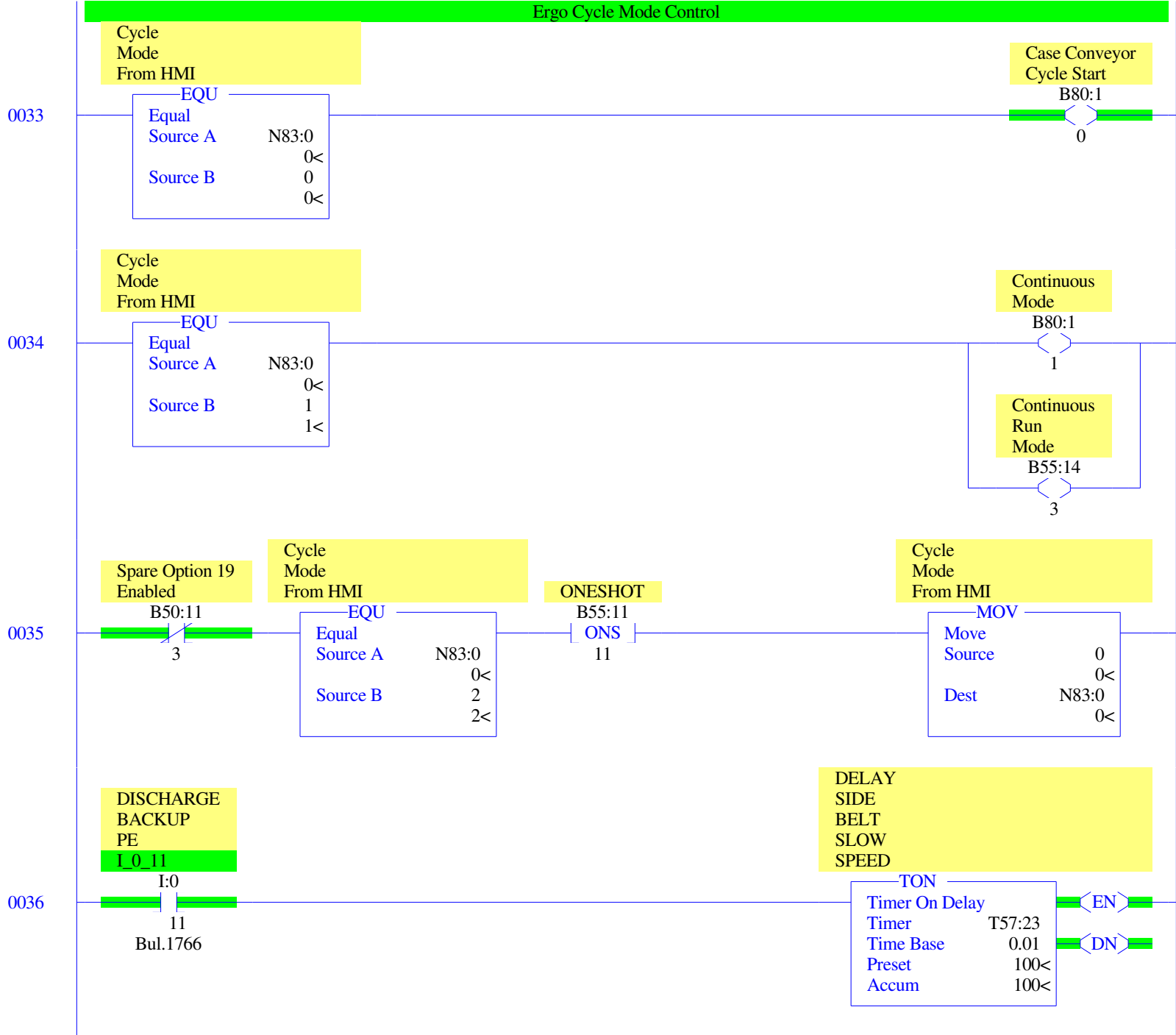


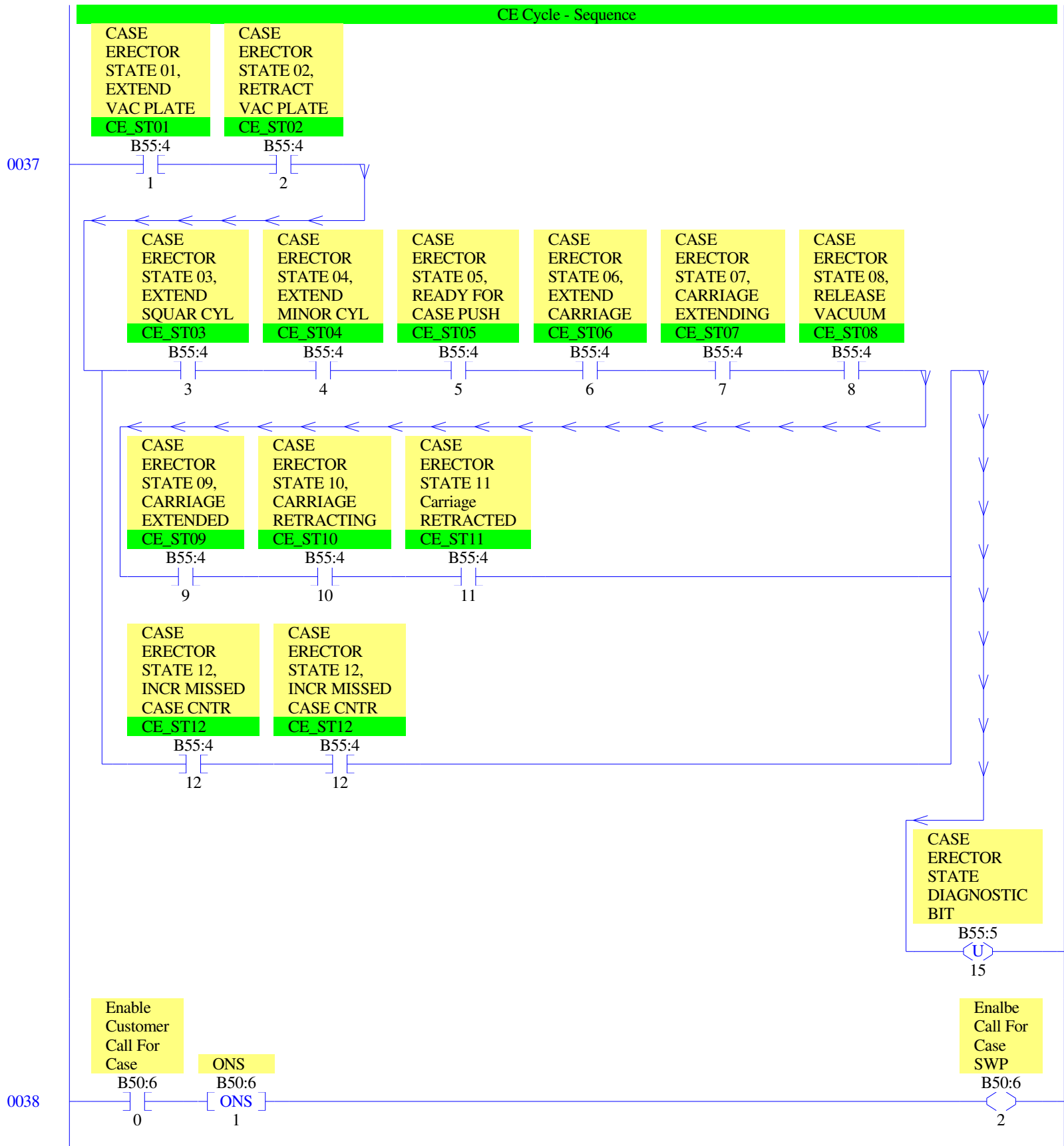


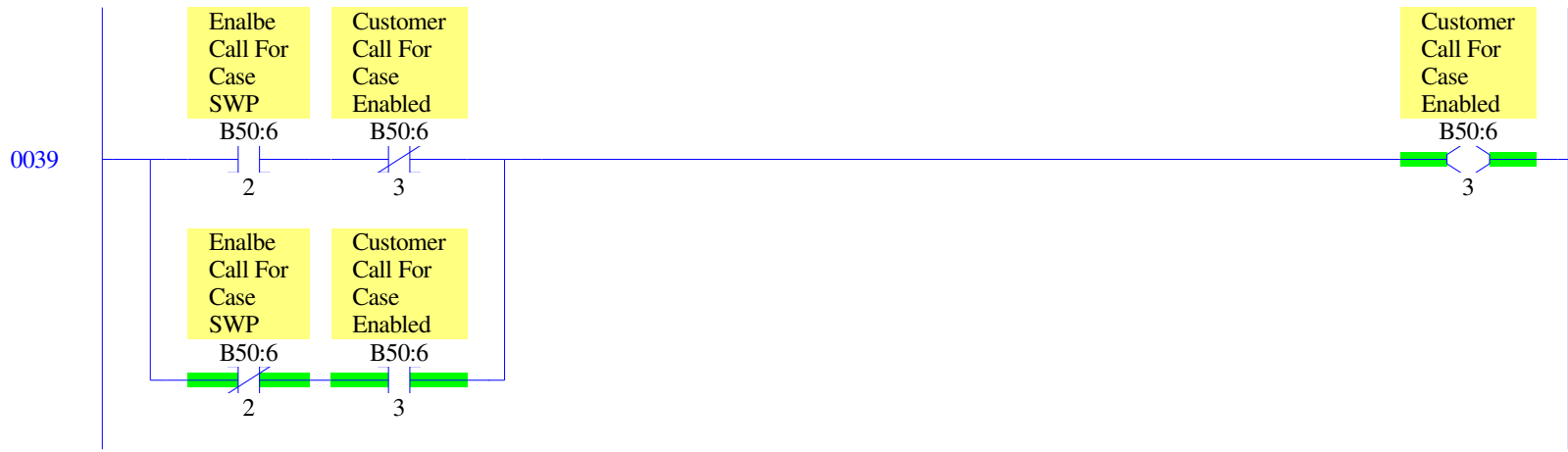




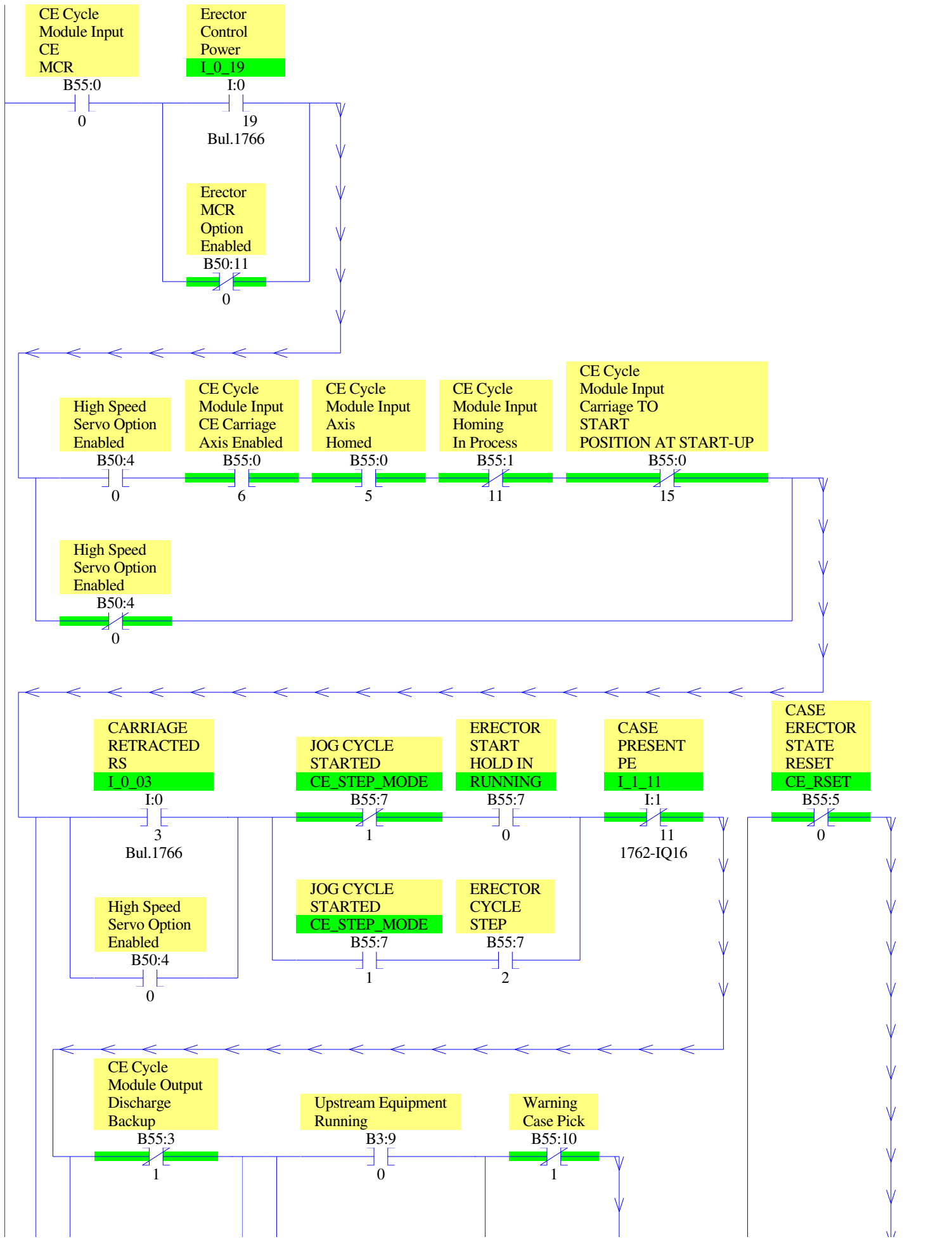
Ergo Cycle Mode Control

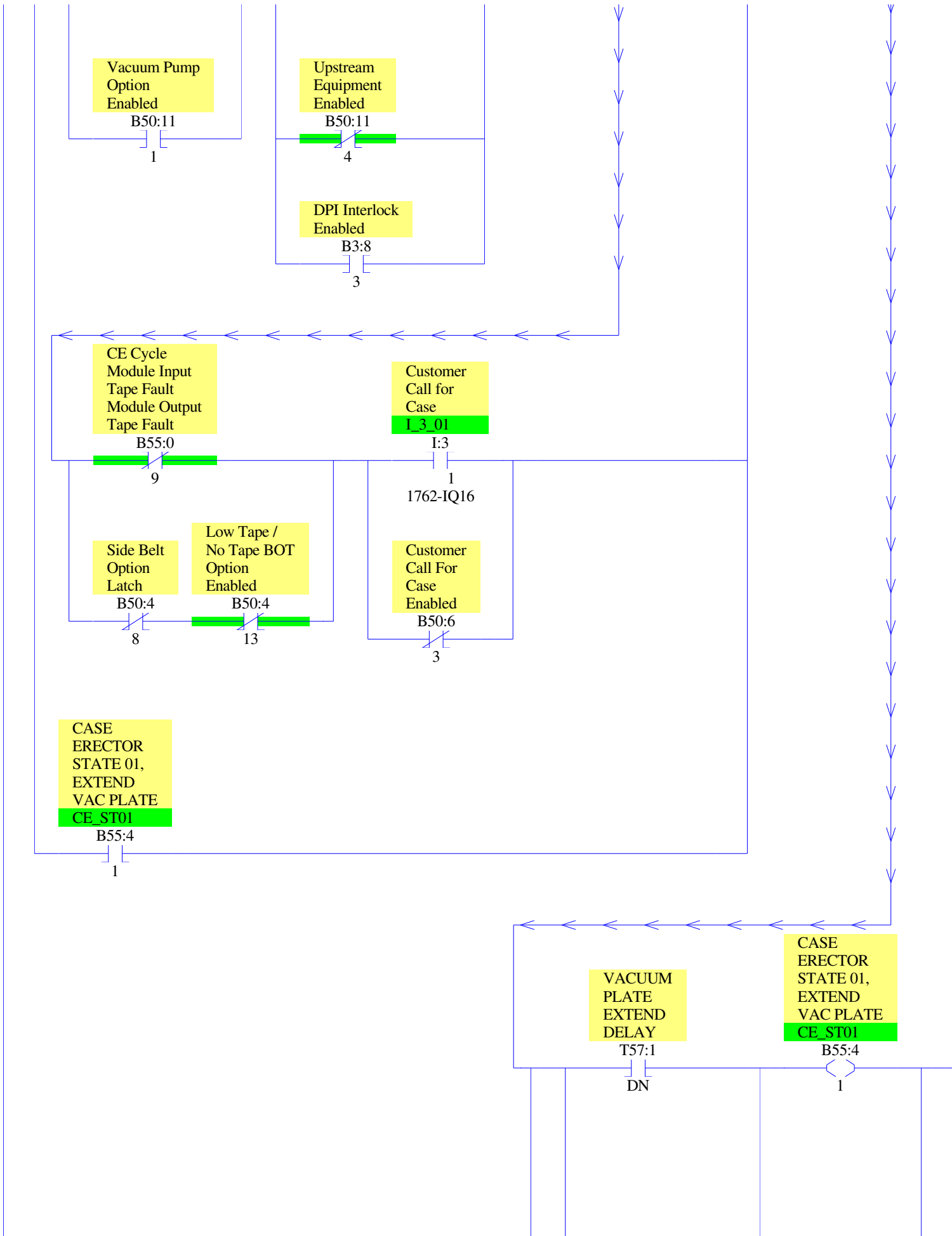


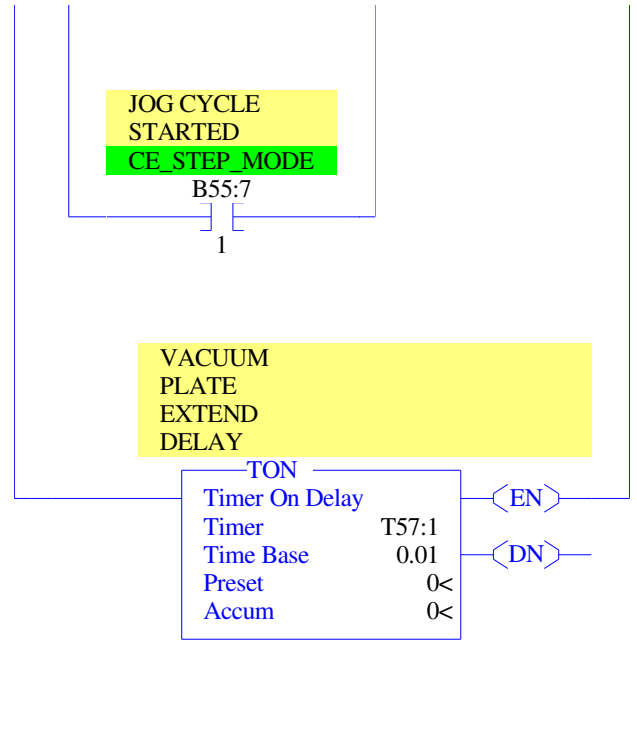




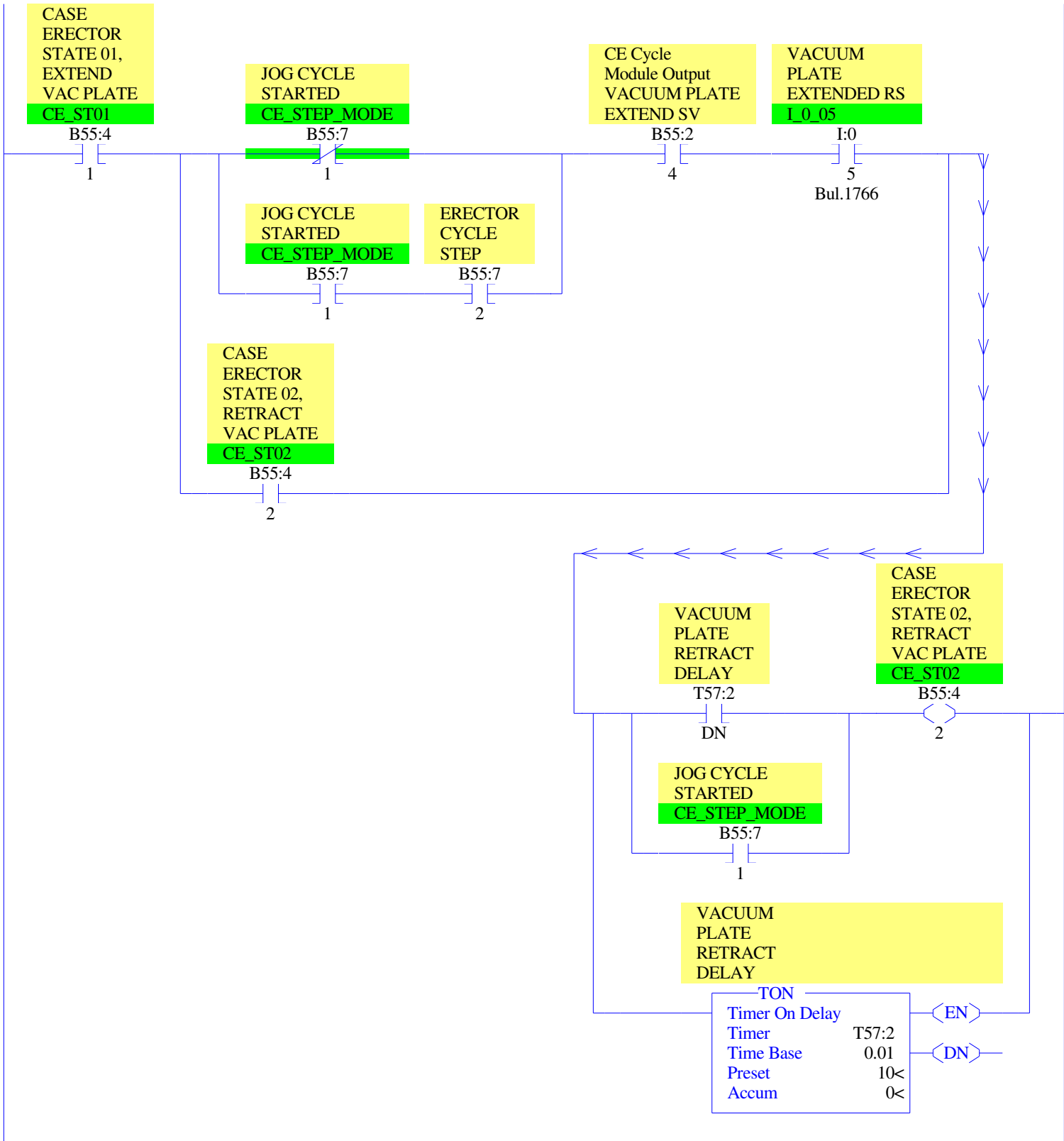
0040



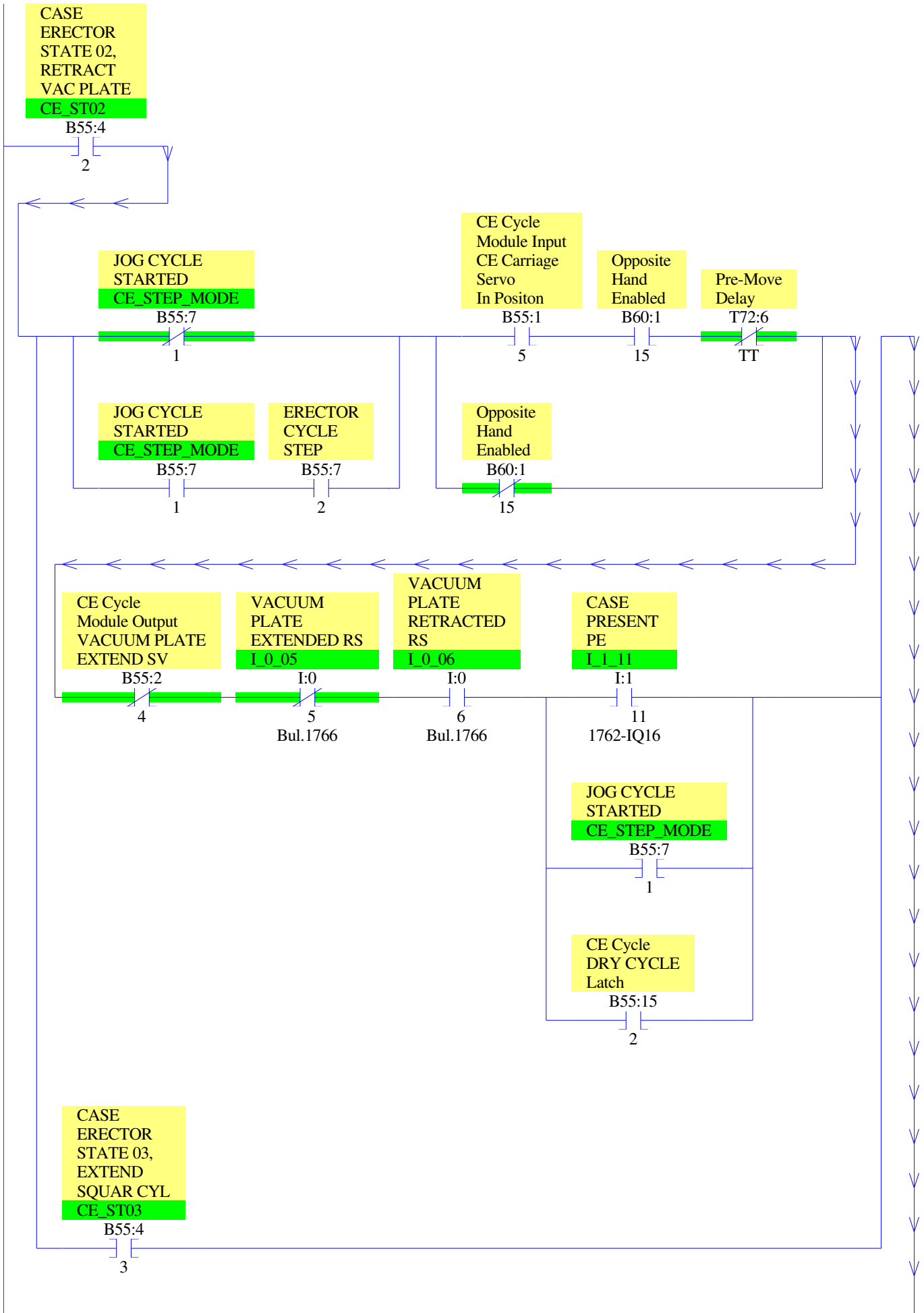


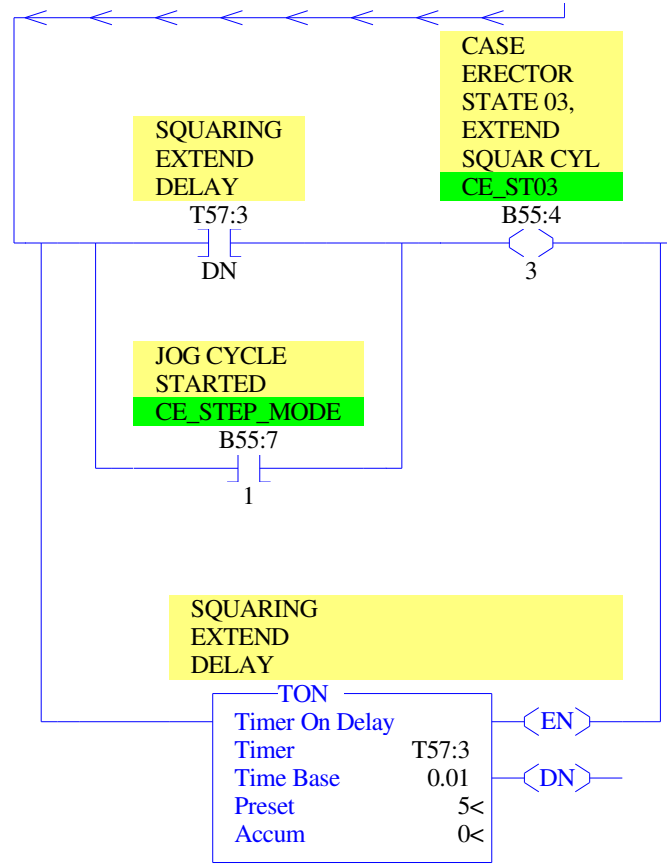


0041

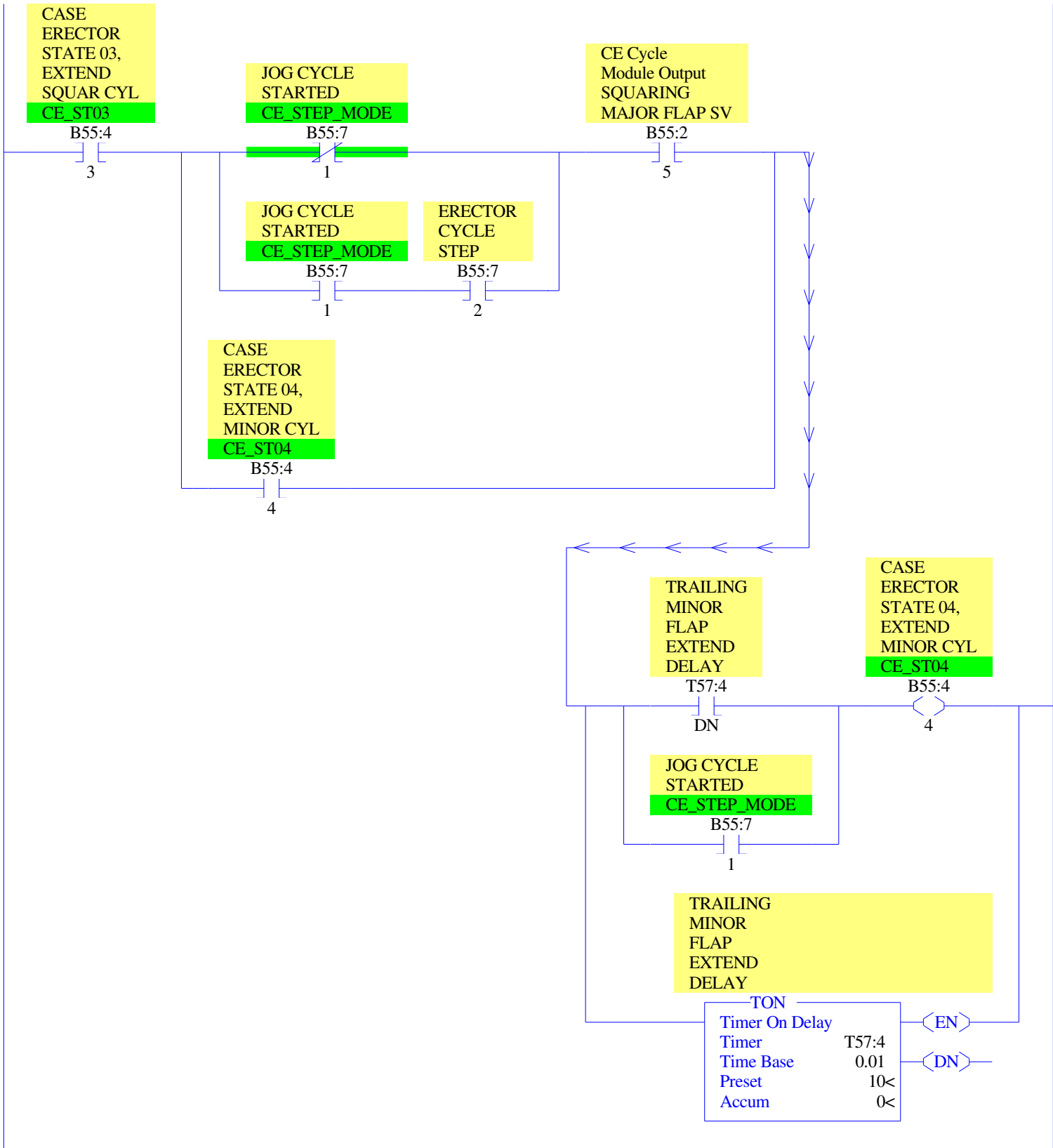


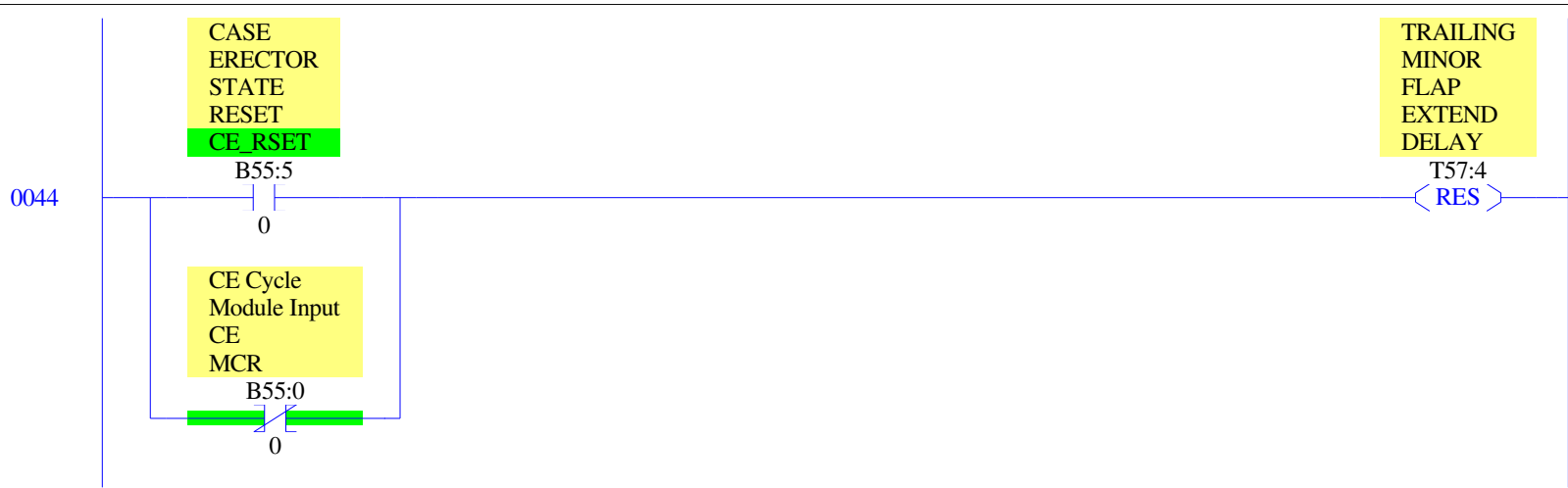
0042

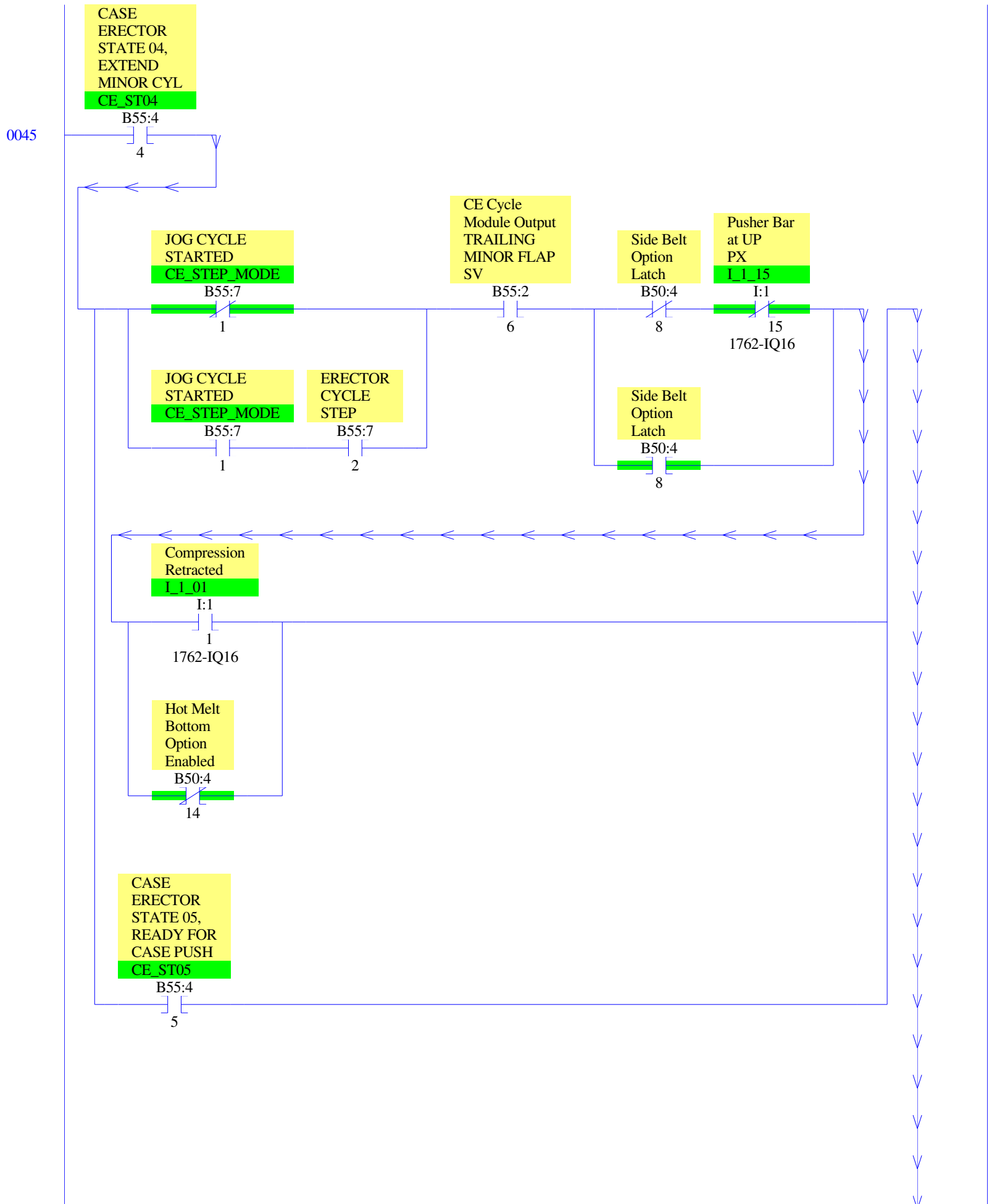


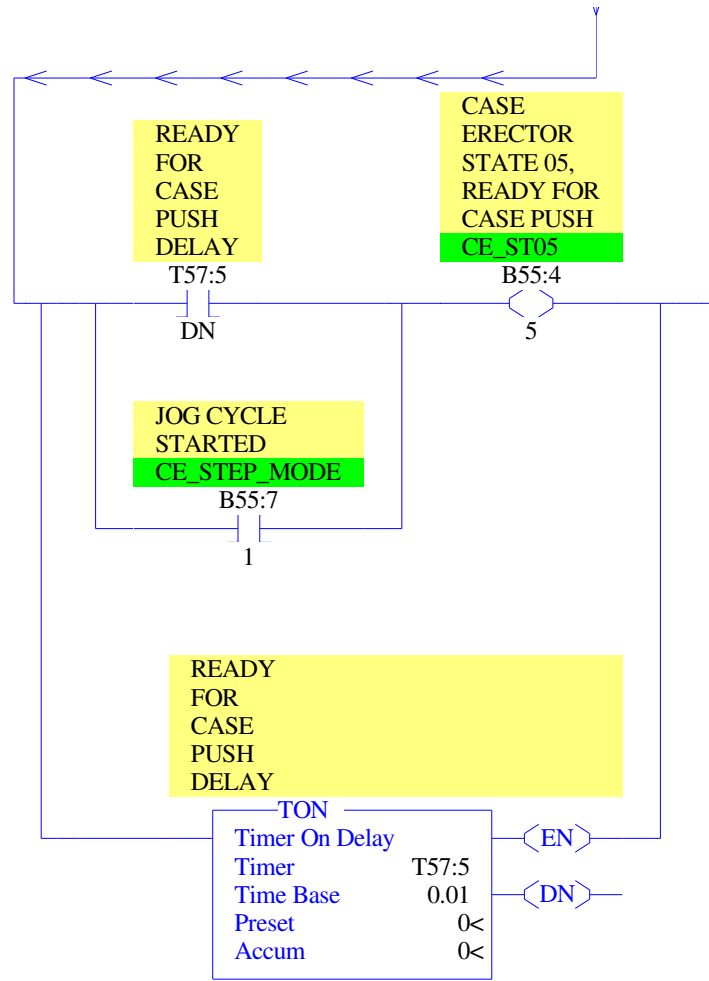


0043

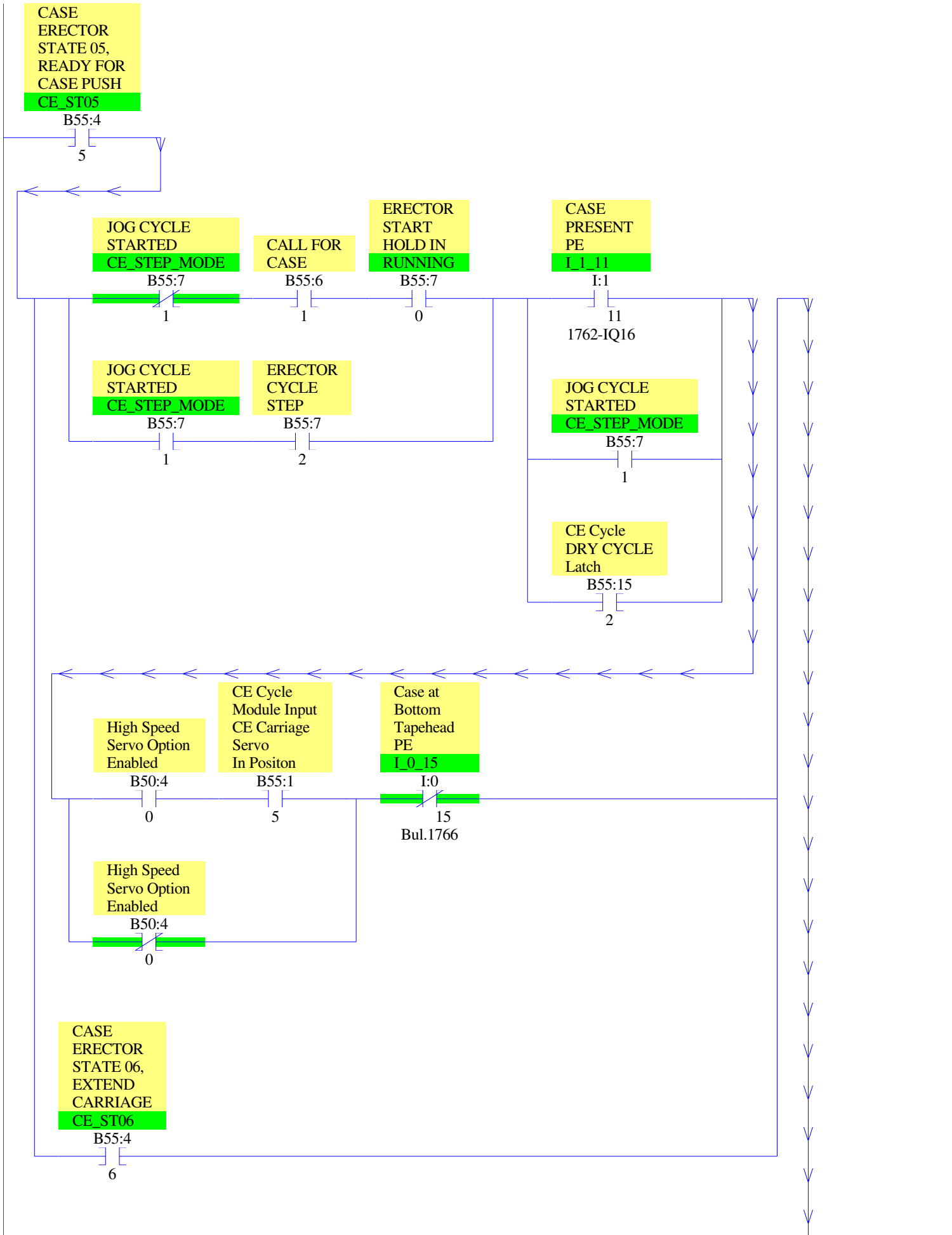


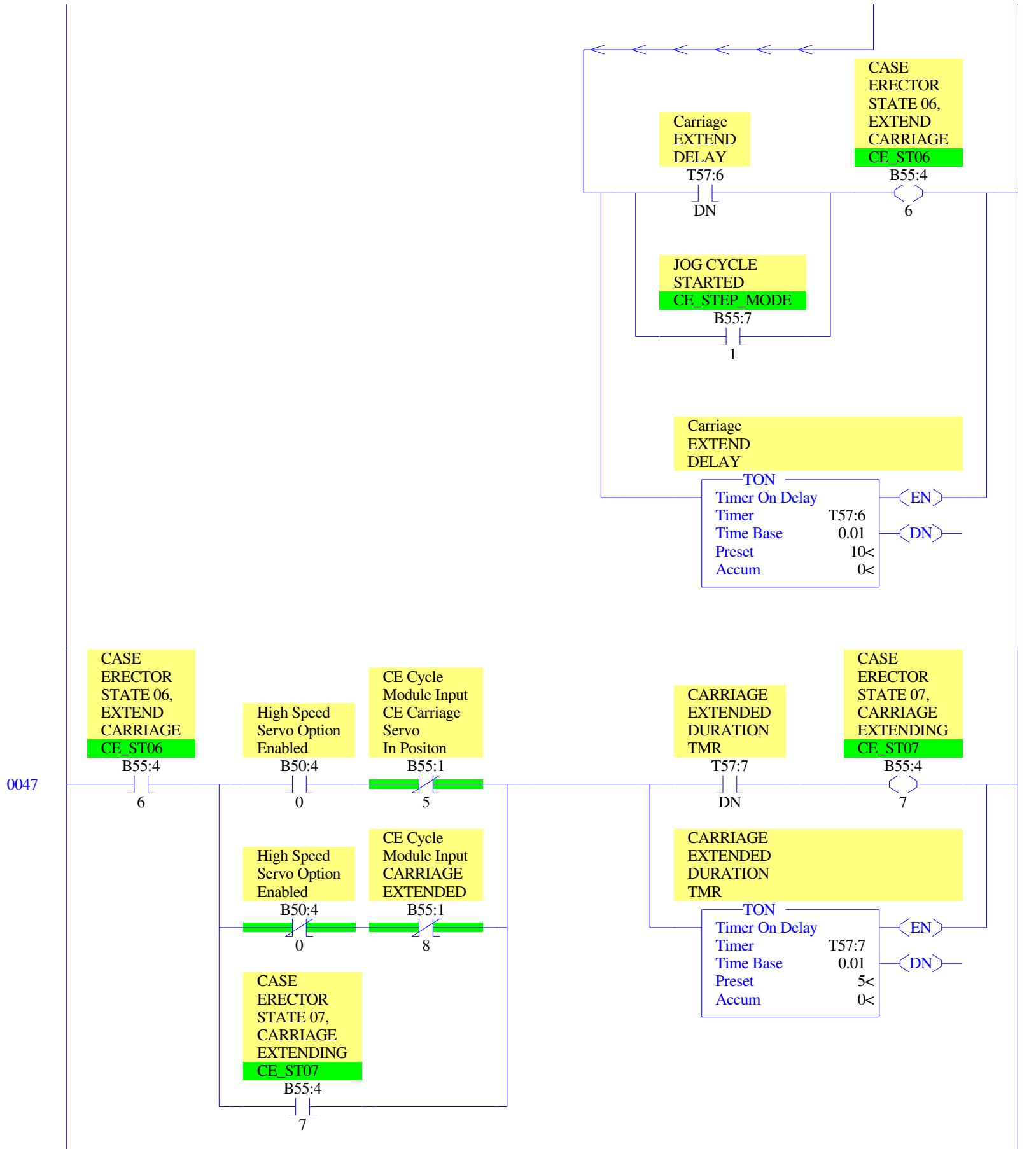






0046





DELAYS THE VACUUM BLOW SO THAT CASE DOES NOT FALL BEFORE FULLY INTO THE SIDE BELTS

CASE
ERECTOR
STATE 07,
CARRIAGE
EXTENDING
CE_ST07

B55:4
7

Side Belt
Option
Latch
B50:4

8

High Speed
Servo Option
Enabled
B50:4

0

SHORT
CASE
B50:0

0

Vacuum
Release
Position
PE
I_0_10

I:0
10

Bul.1766

SHORT
CASE
B50:0

0

CE Cycle
Module Input
CARRIAGE
EXTENDED
B55:1

B55:1
8

CE Cycle
DRY CYCLE
Latch
B55:15

2

JOG CYCLE
STARTED
CE_STEP_MODE

B55:7
1

ERECTOR
CYCLE
STEP
B55:7

B55:7
2

Side Belt
Option
Latch
B50:4

8

High Speed
Servo Option
Enabled
B50:4

0

SHORT
CASE
B50:0

0

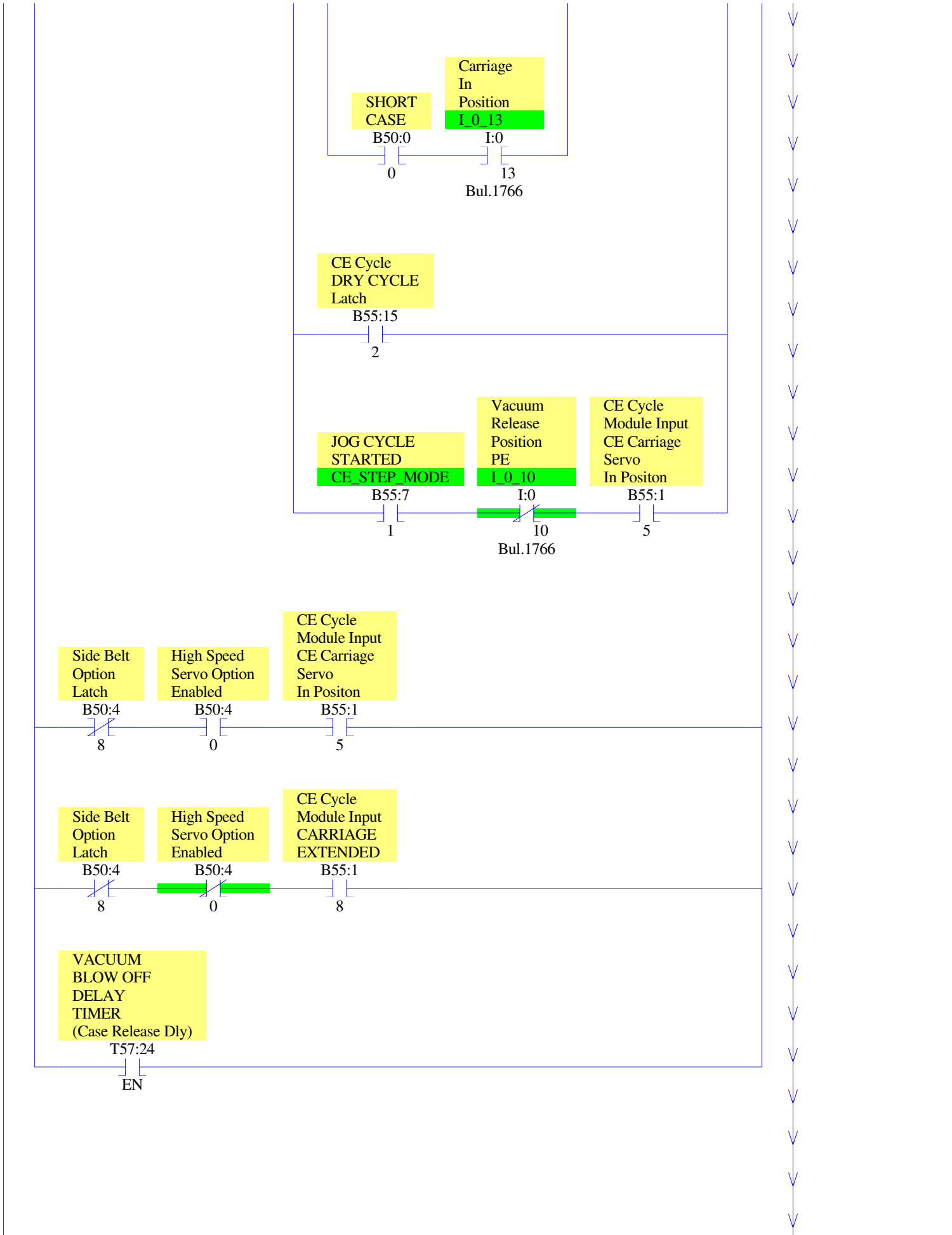
Vacuum
Release
Position
PE
I_0_10

I:0
10

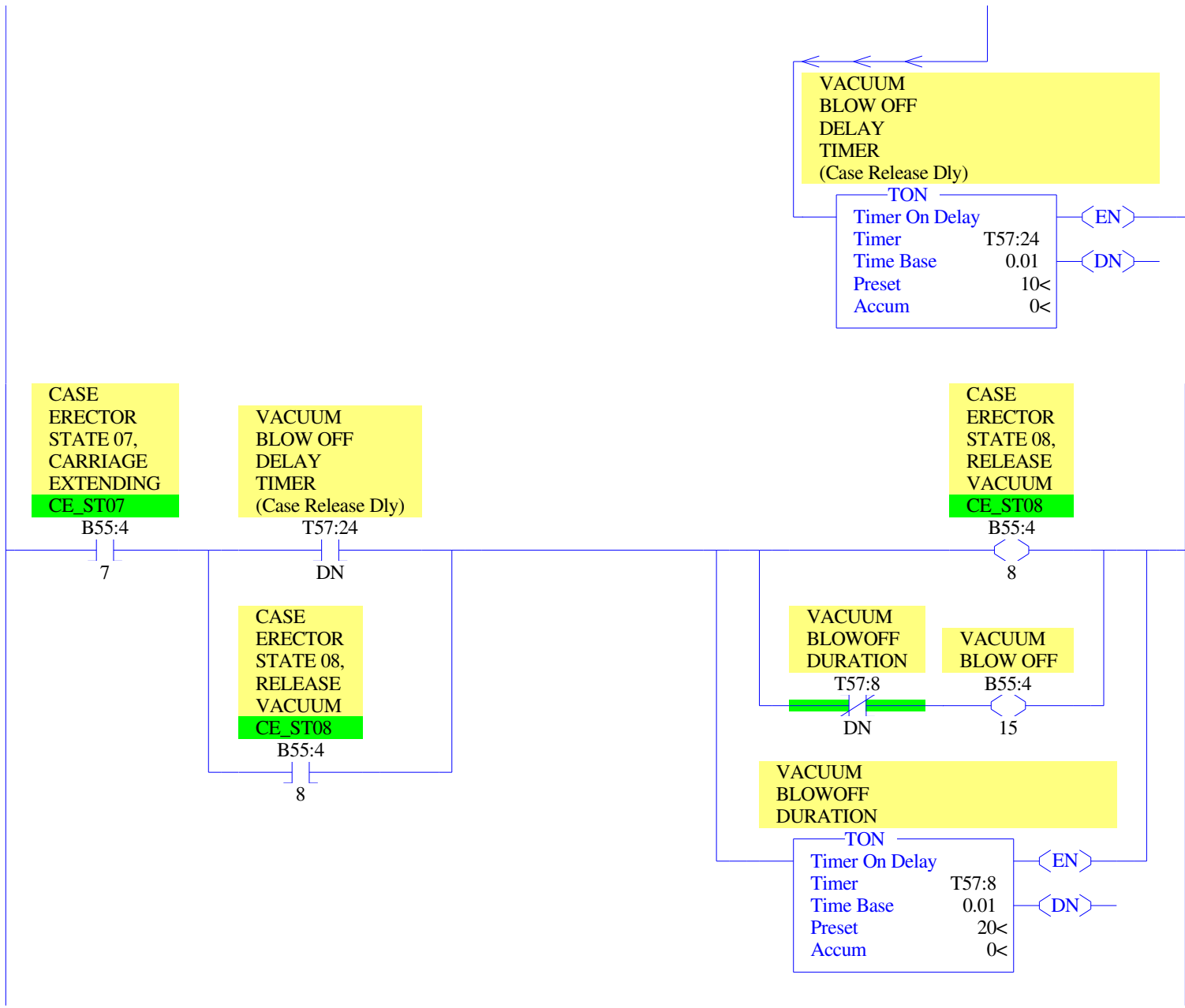
Bul.1766



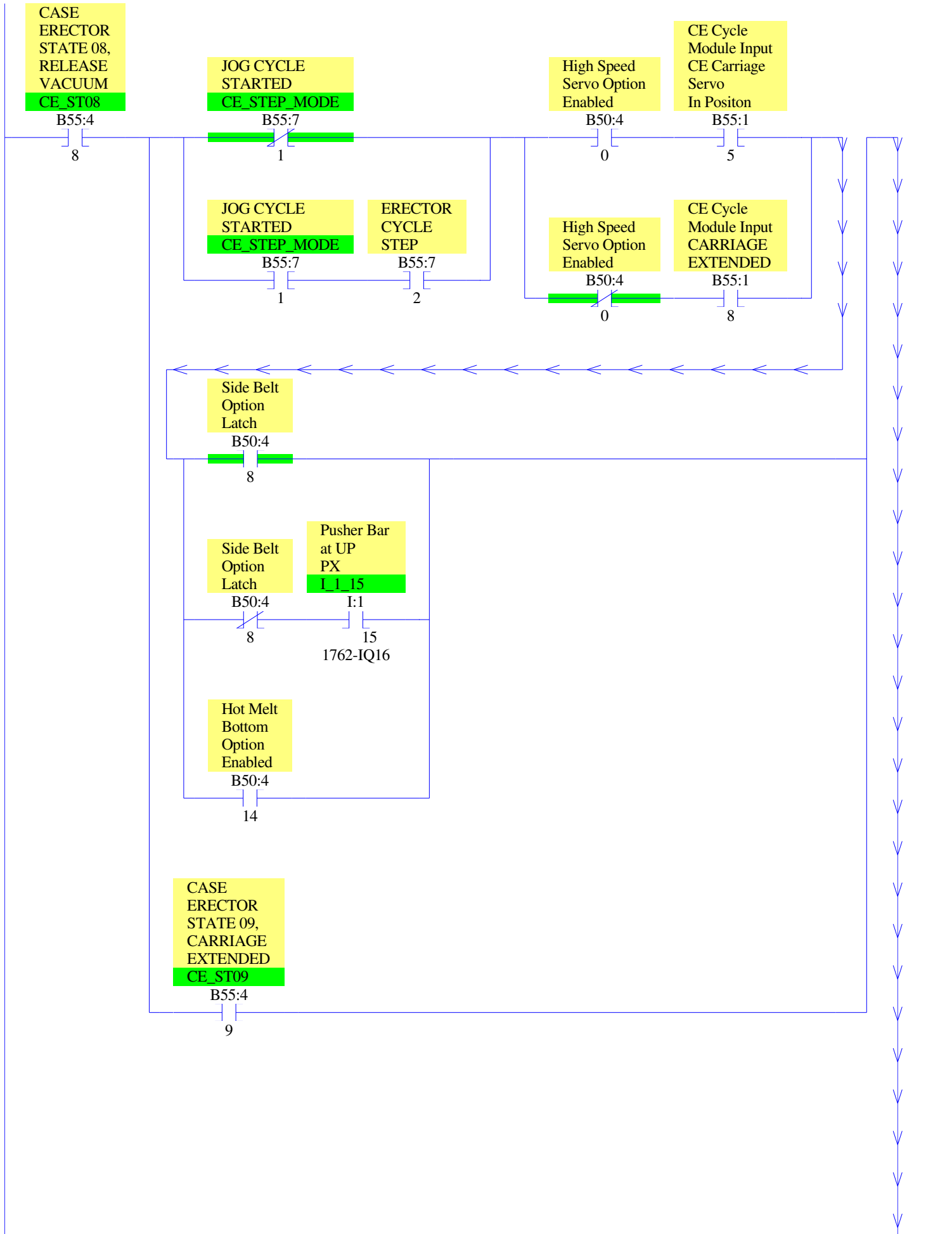
0048

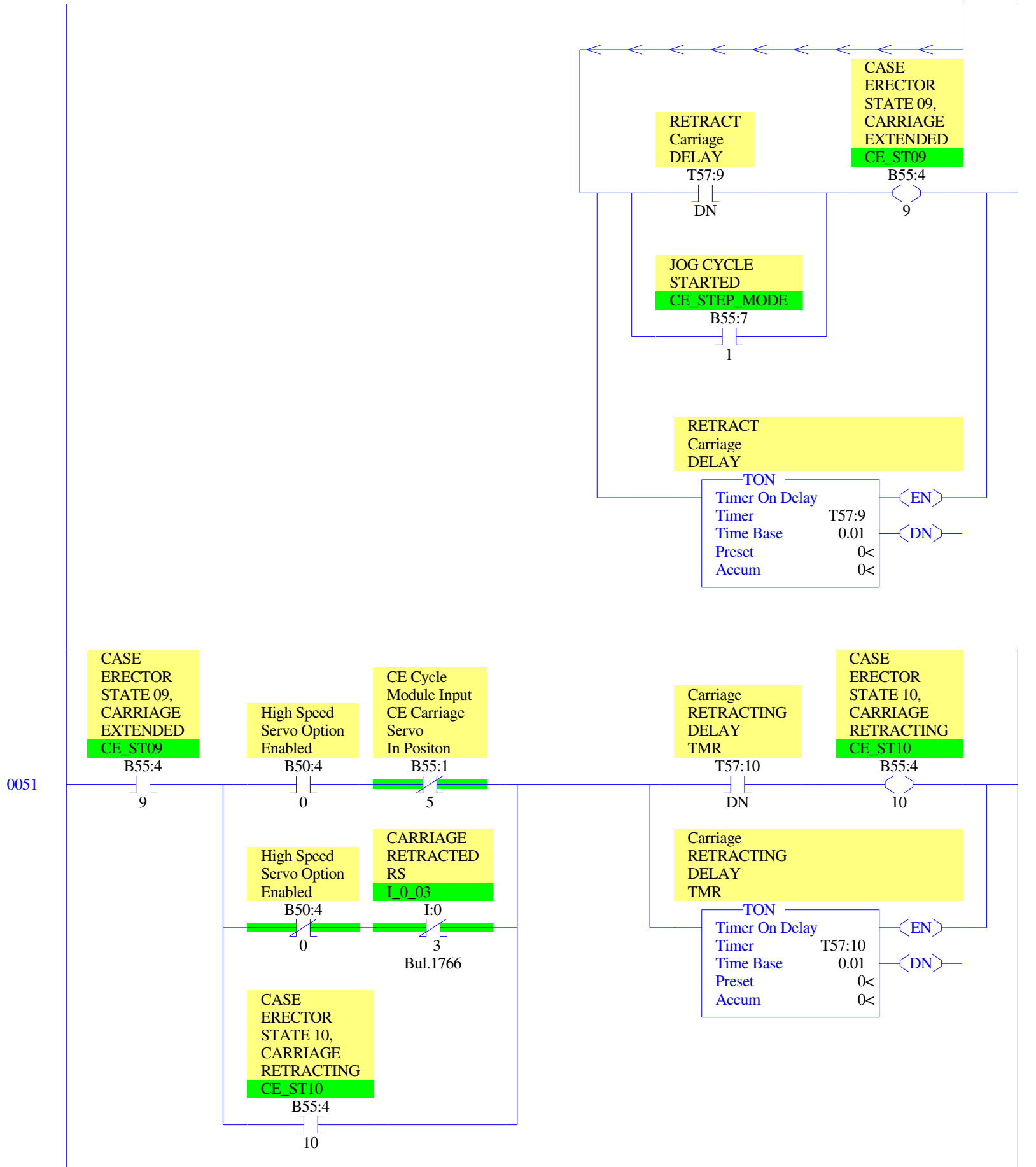


0049



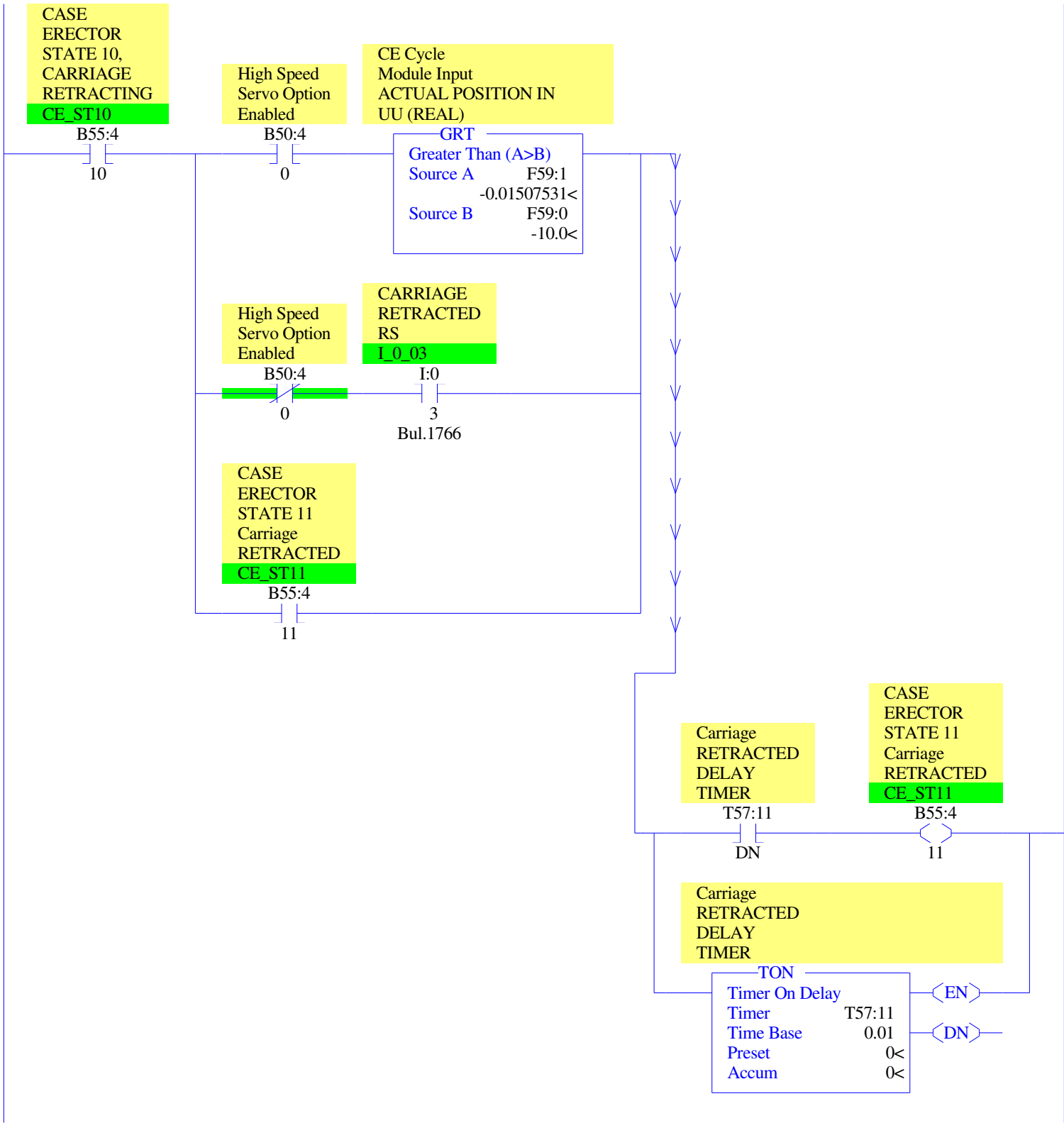
0050



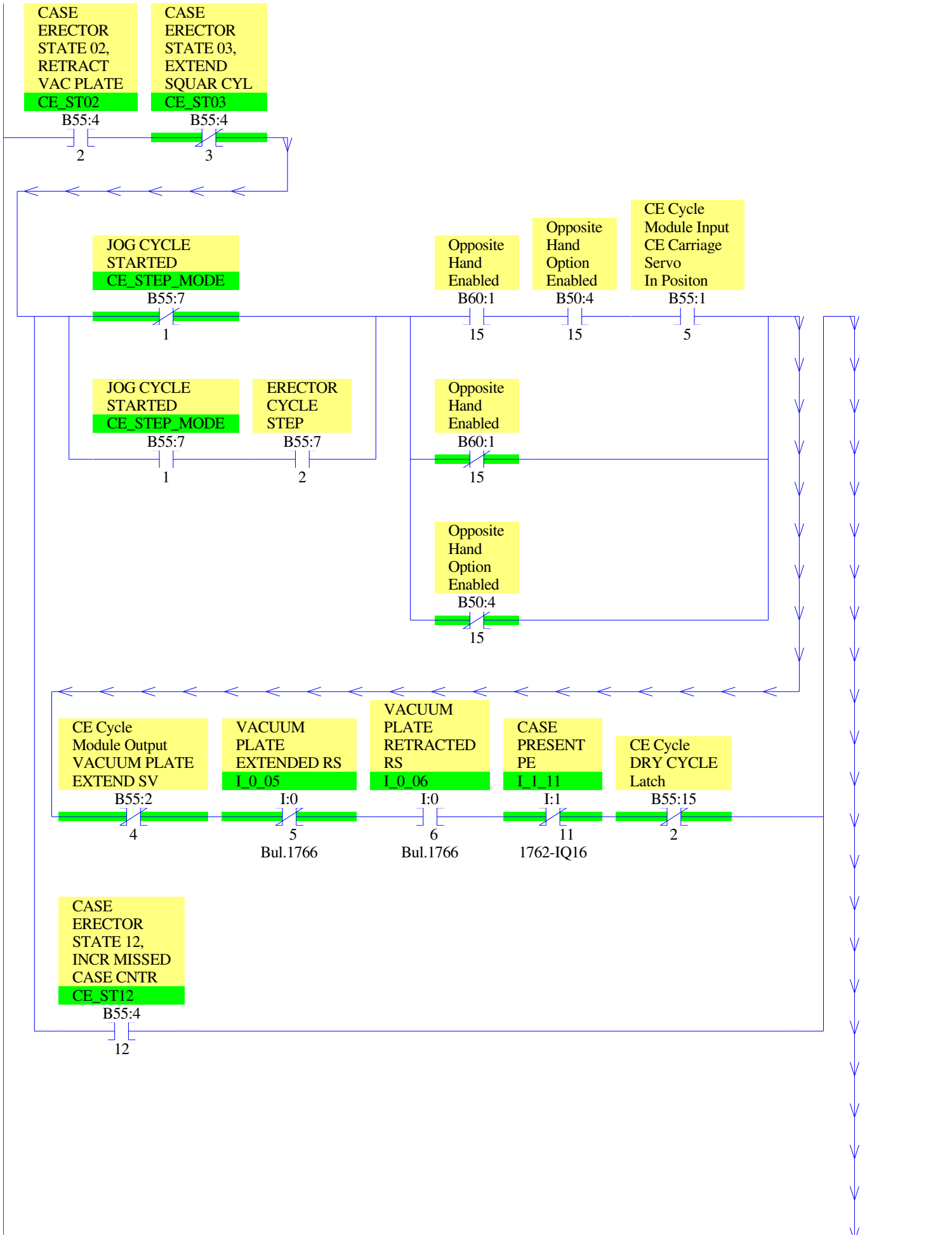


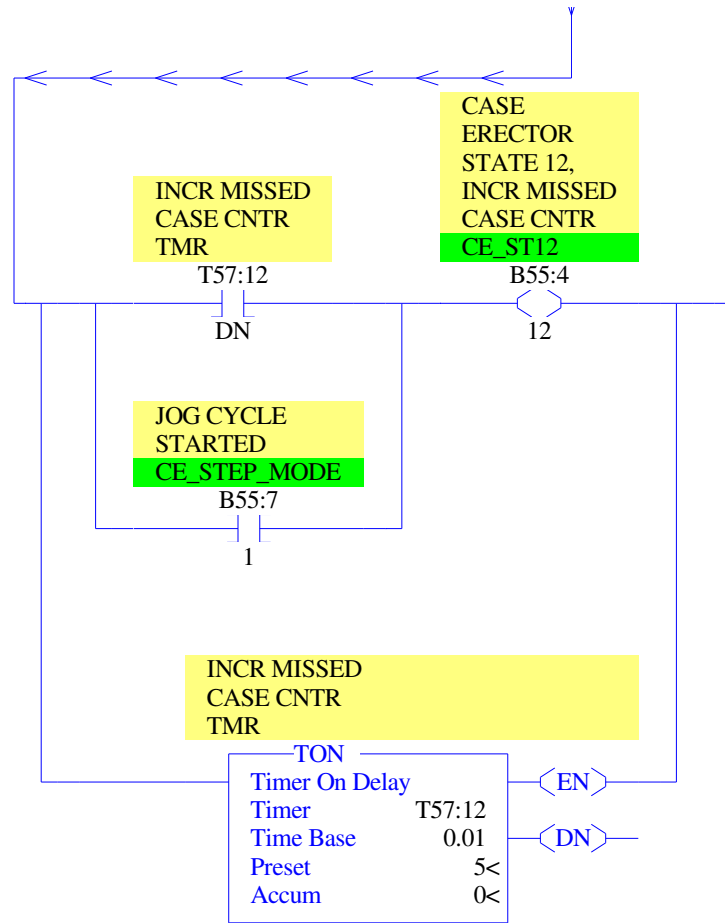
0051

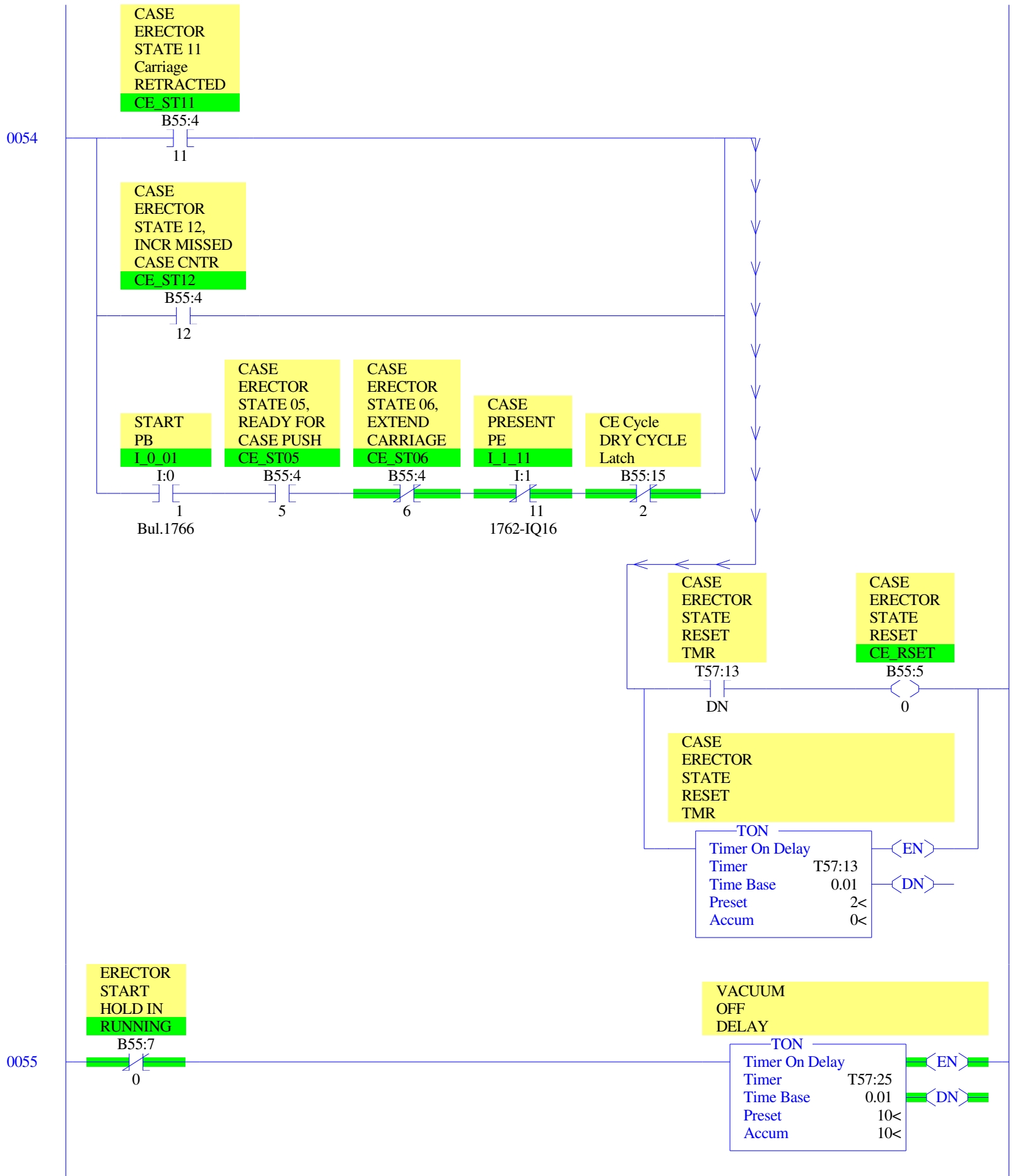
0052



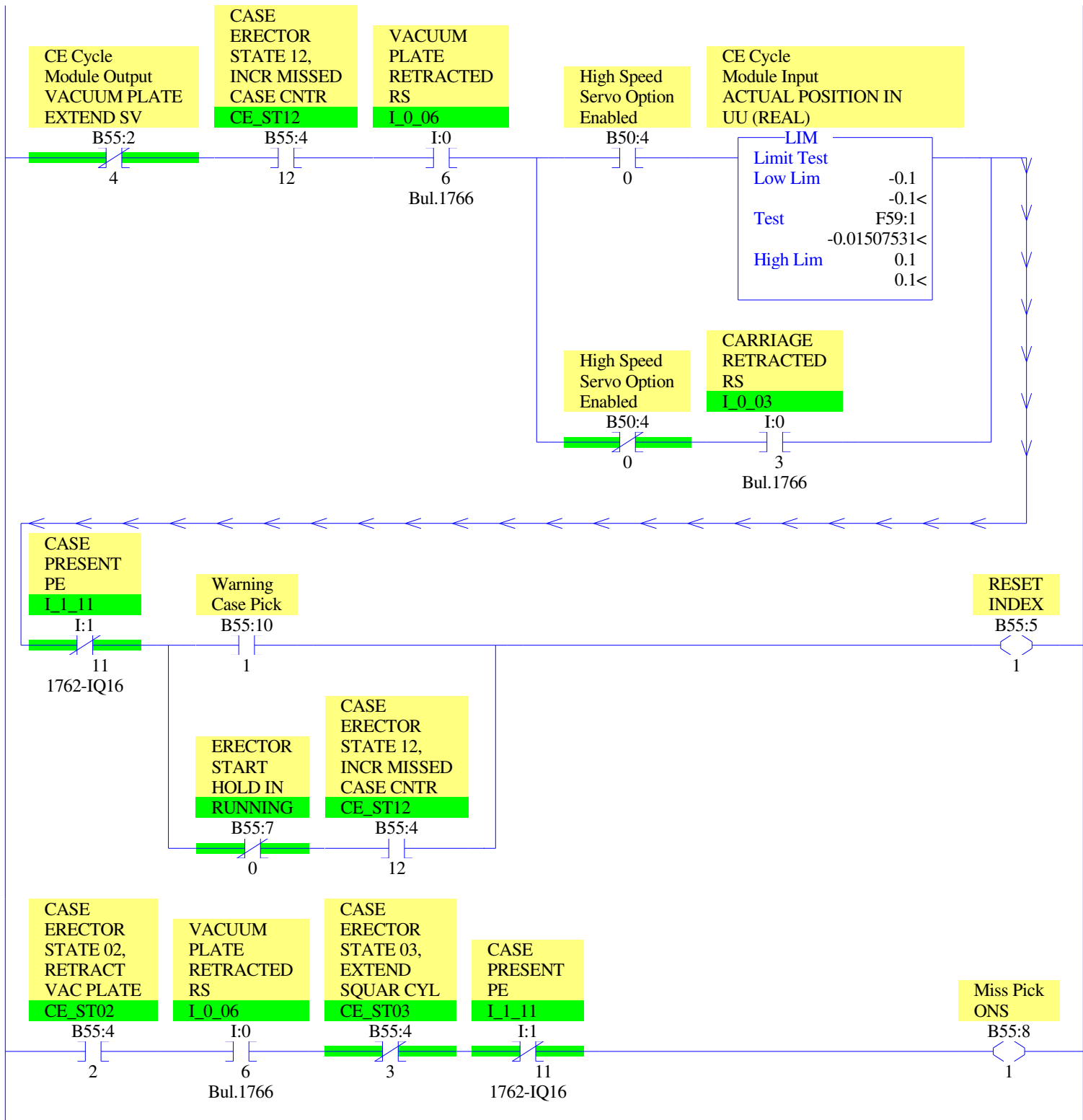
0053

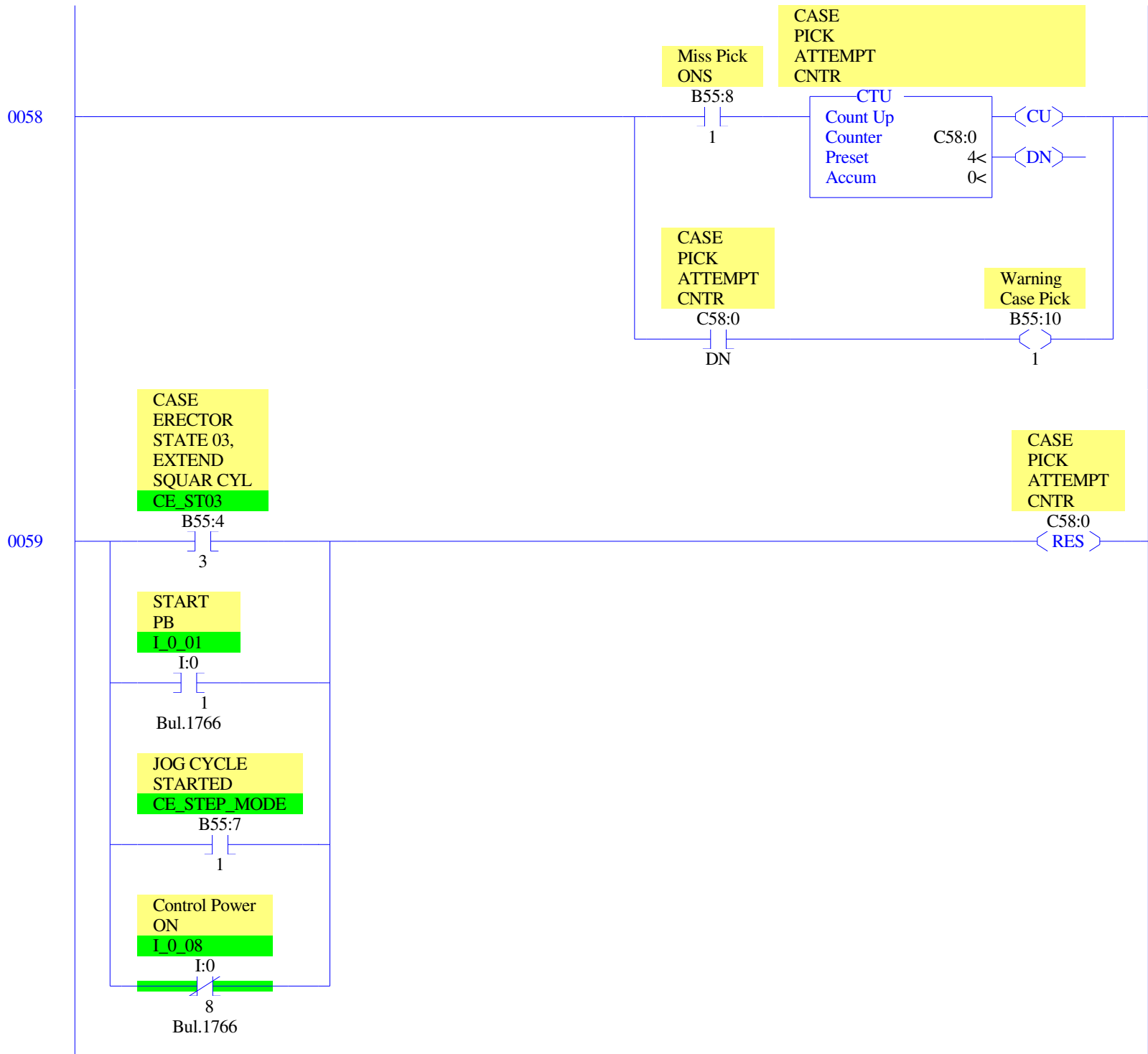


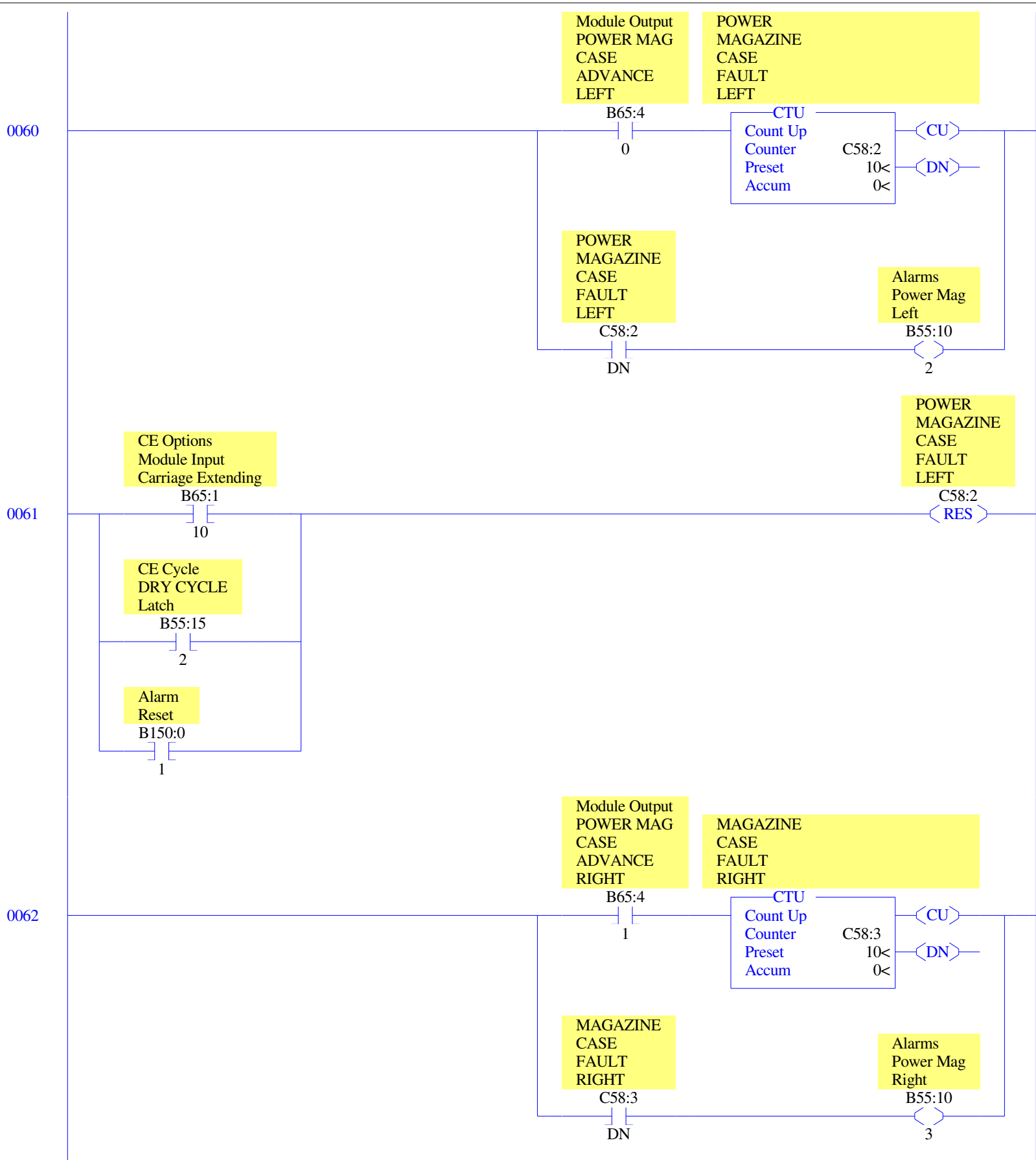


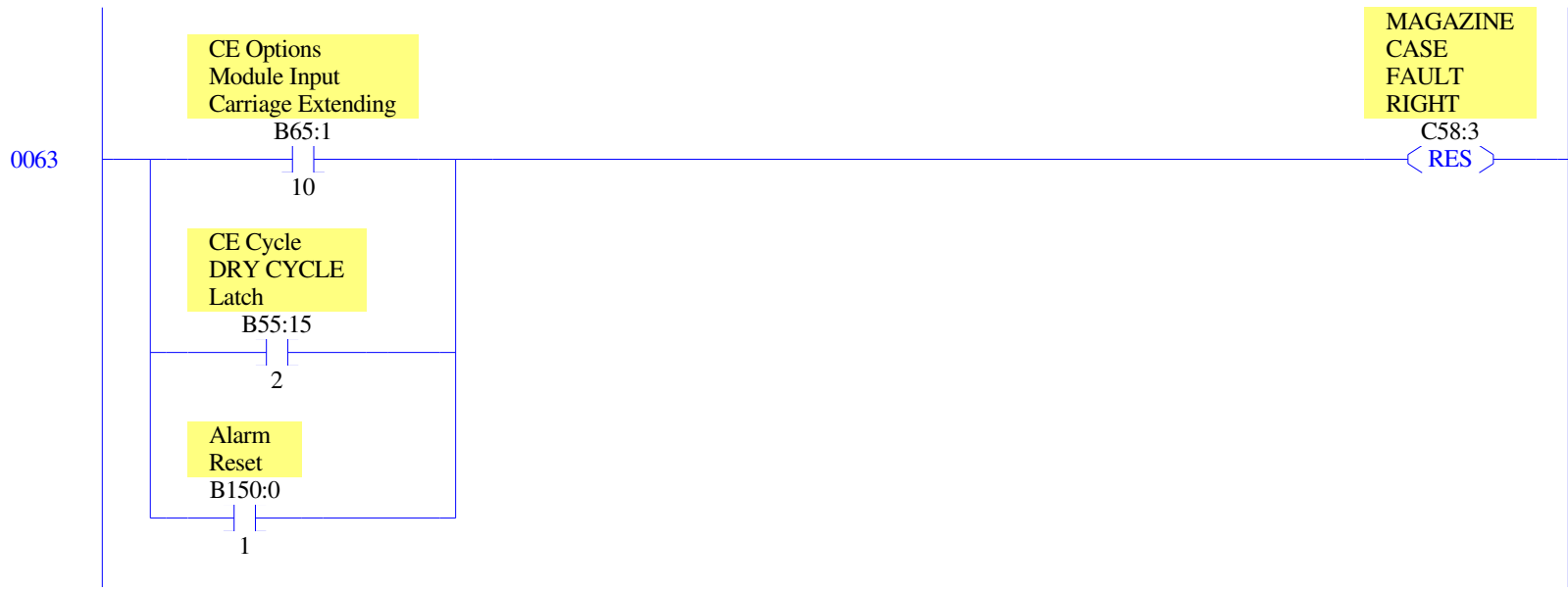


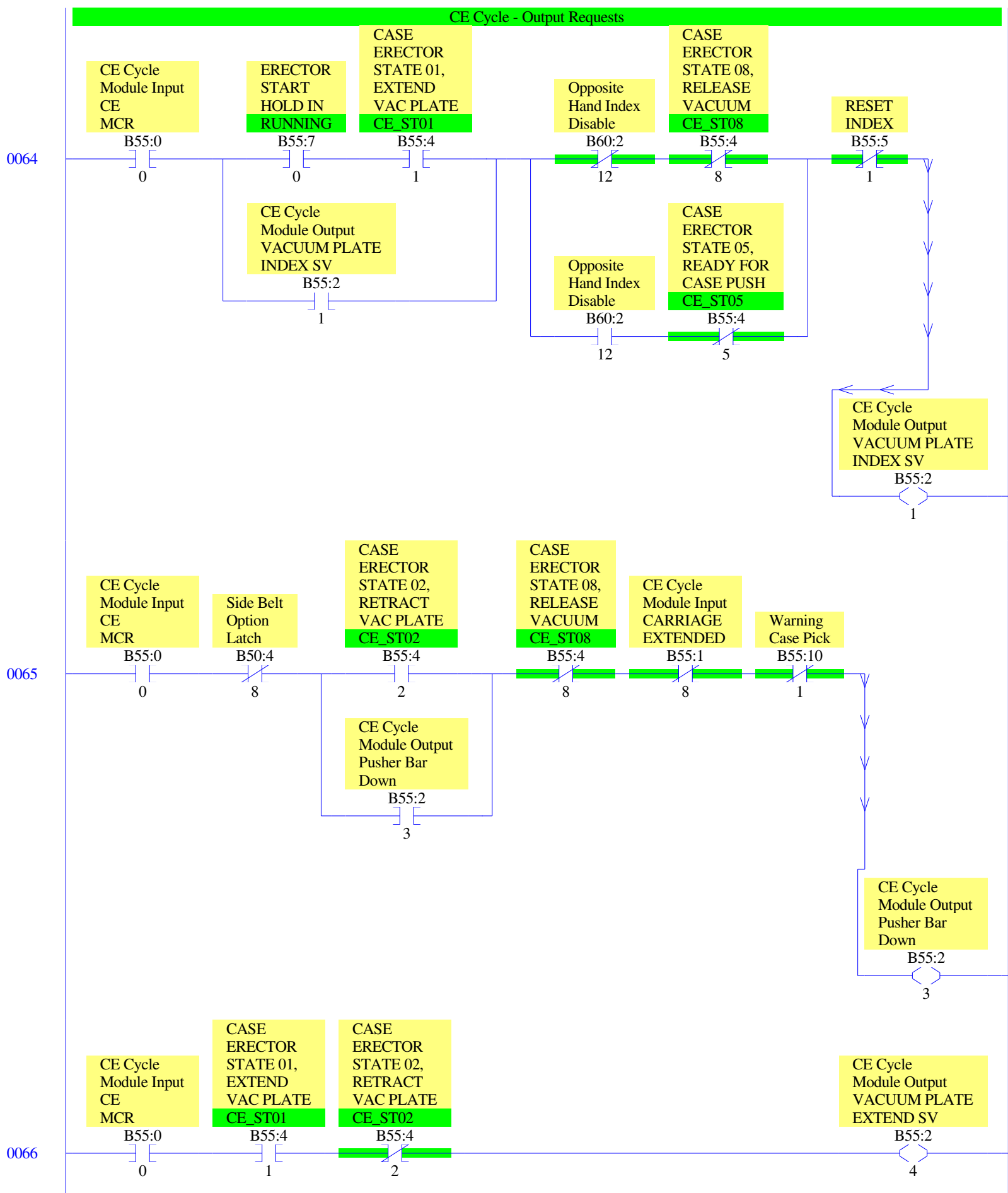
0056



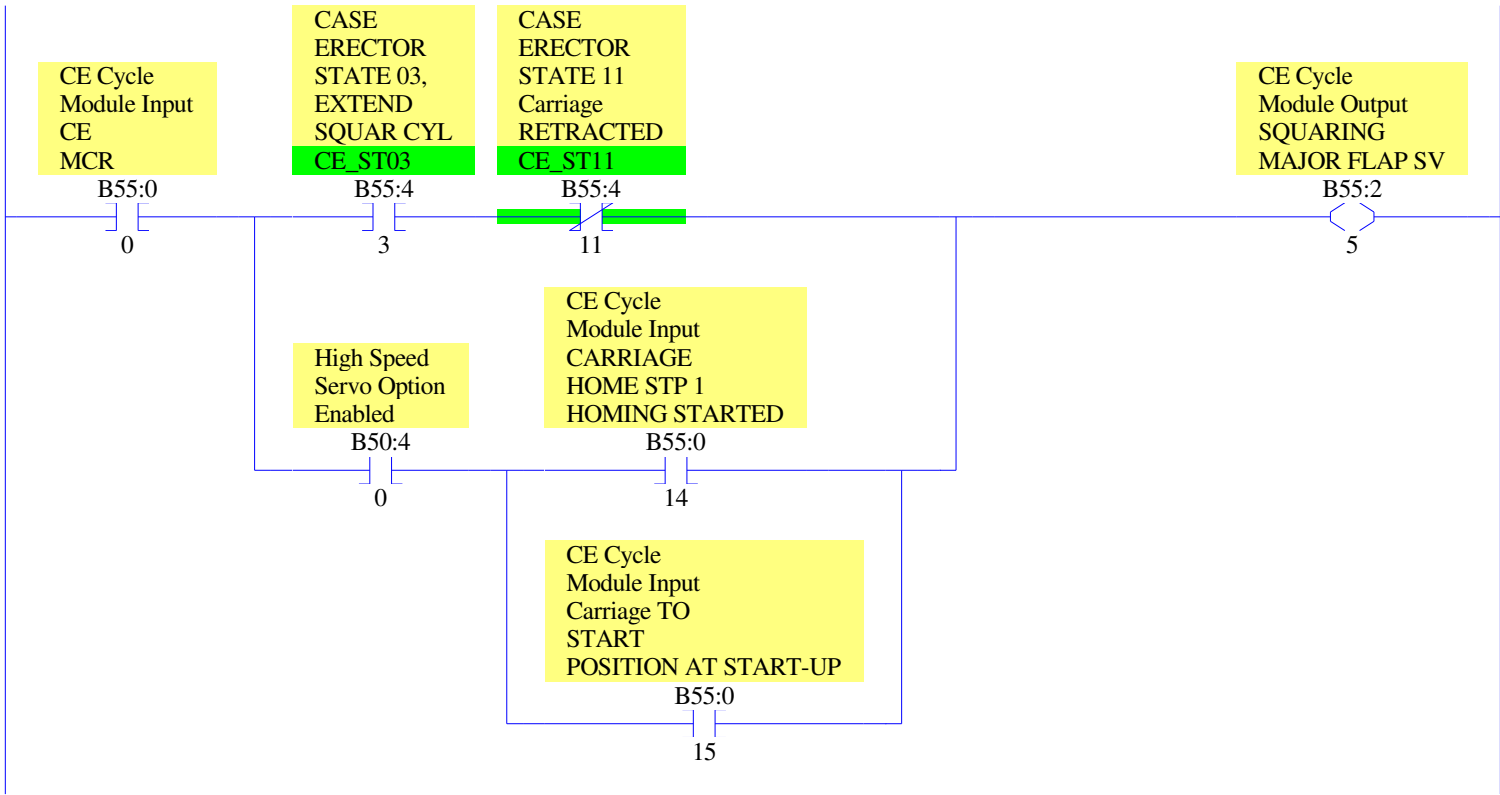


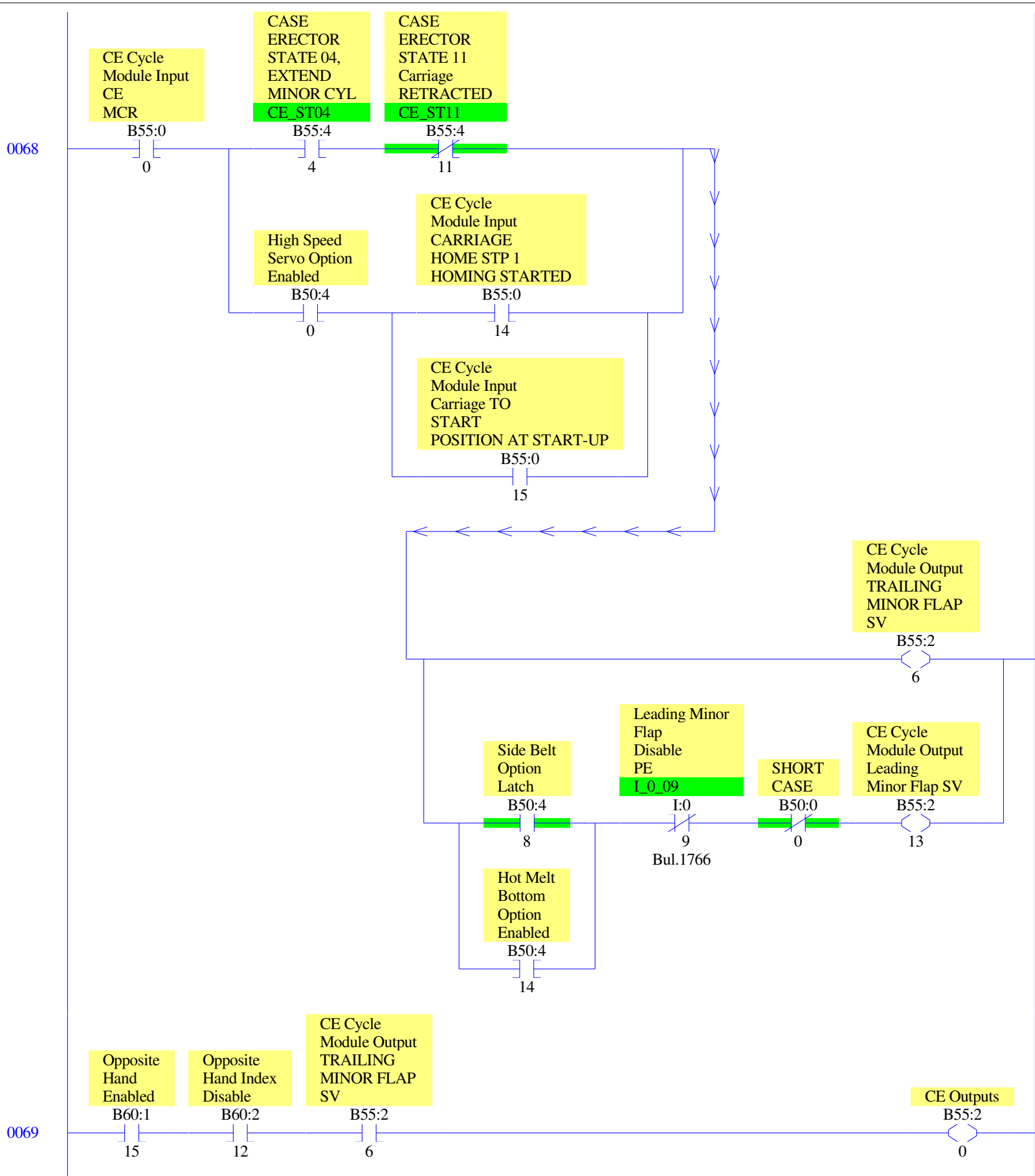


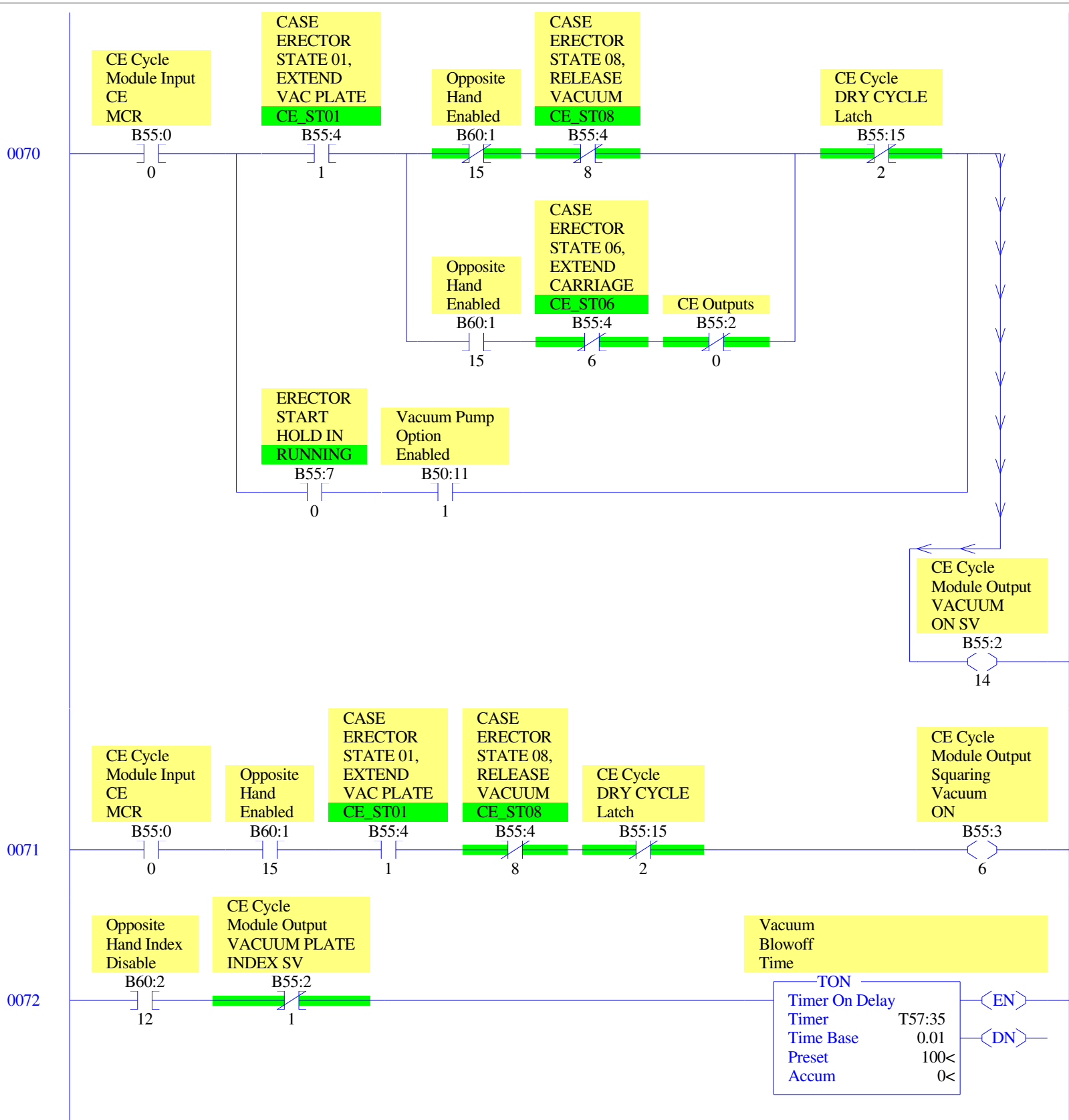


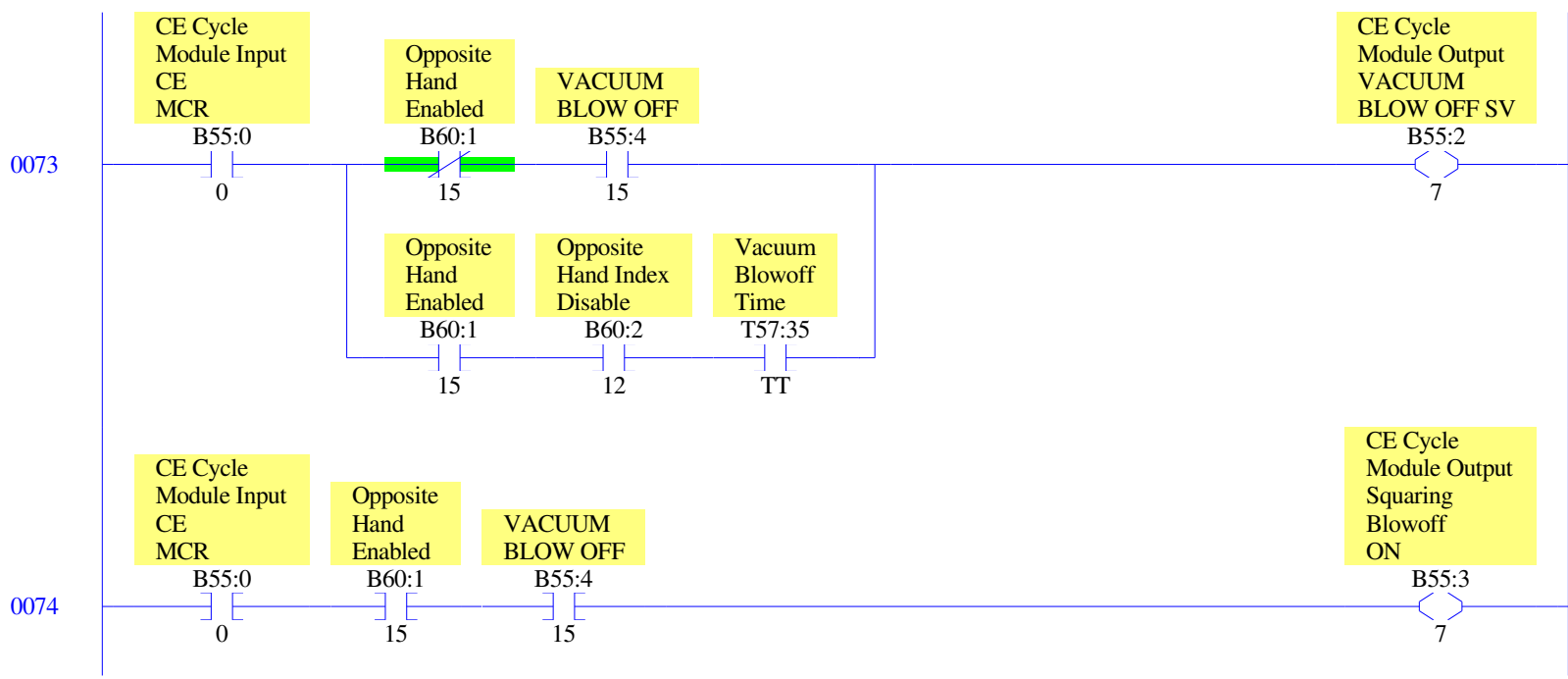


0067

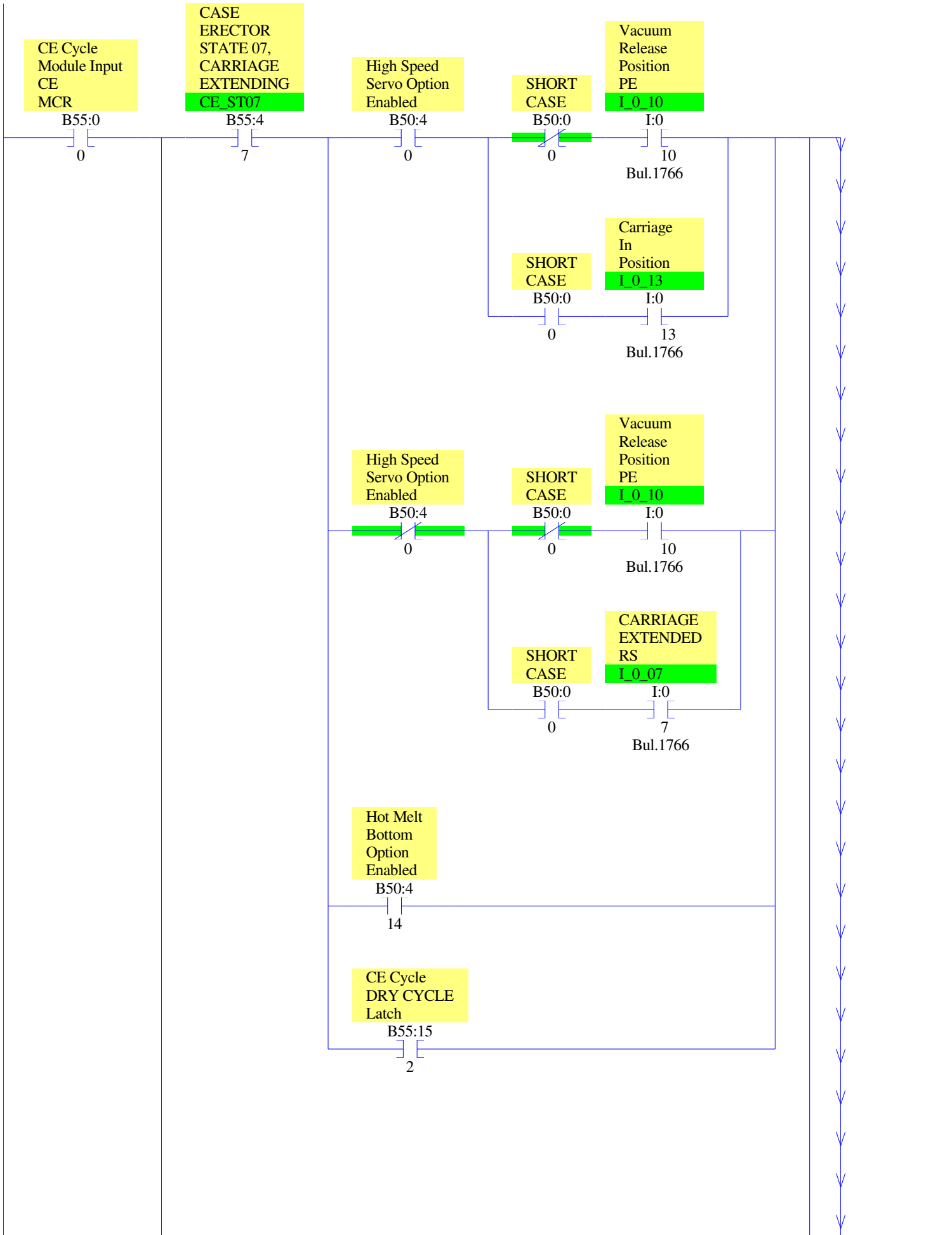


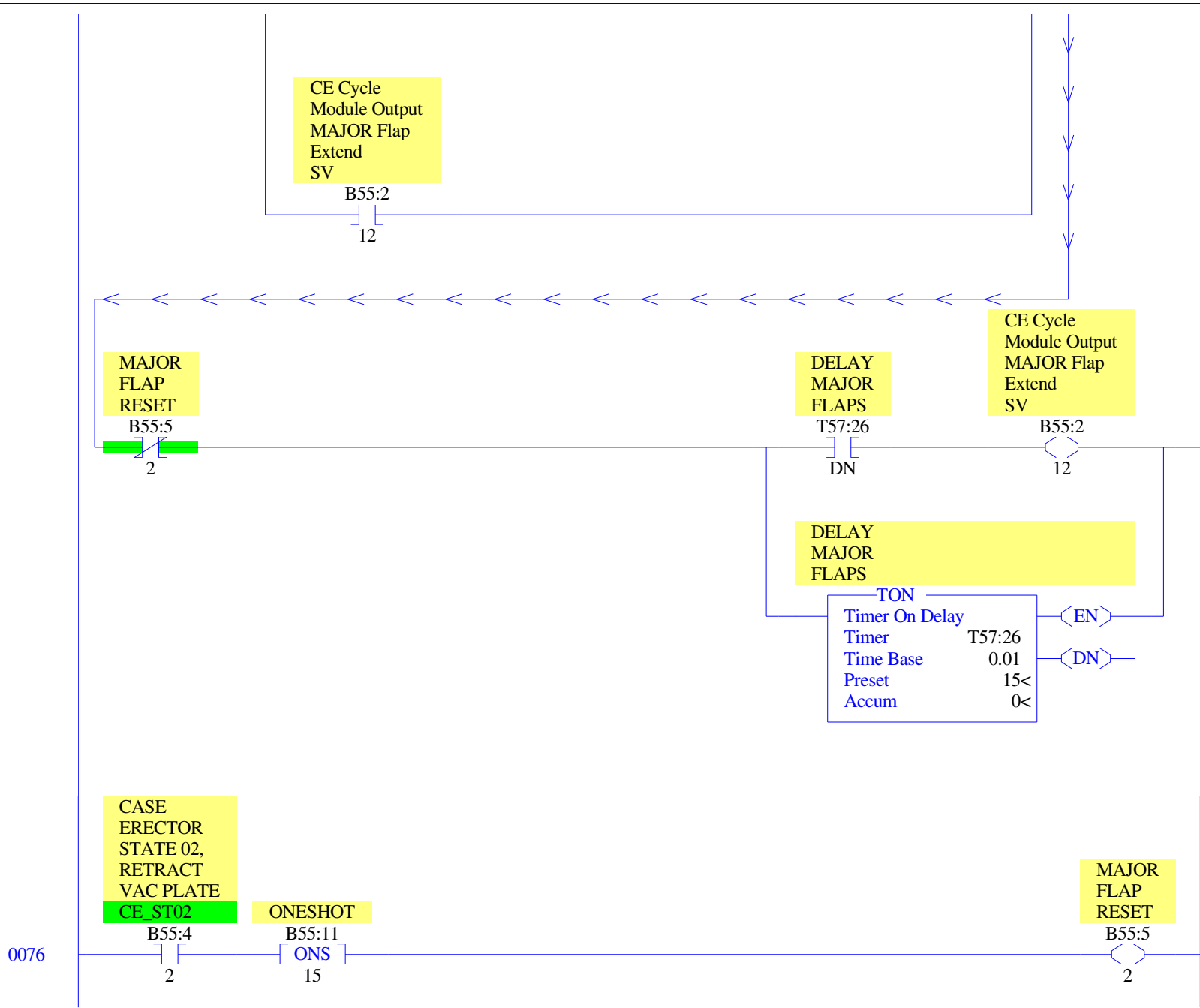




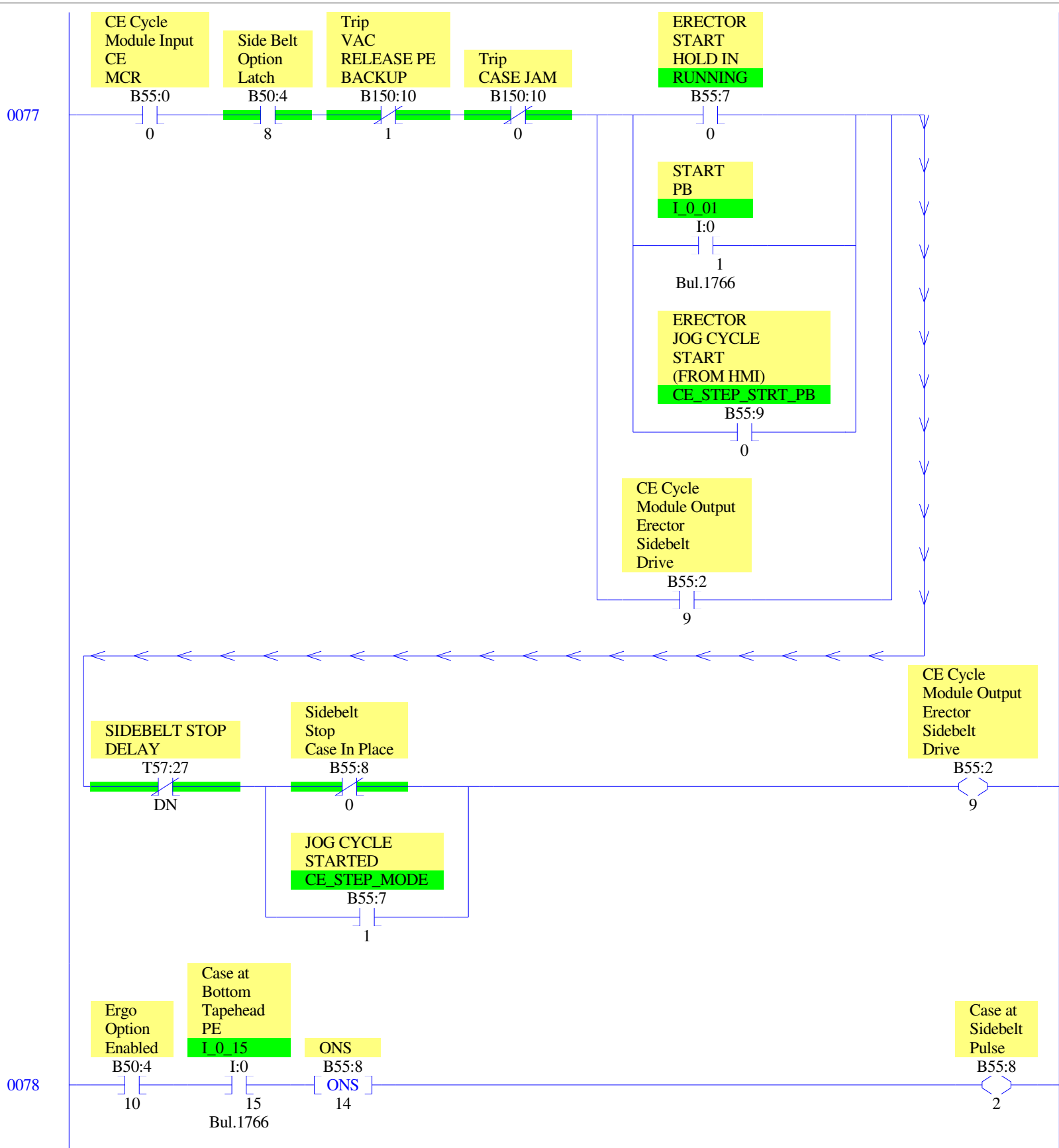


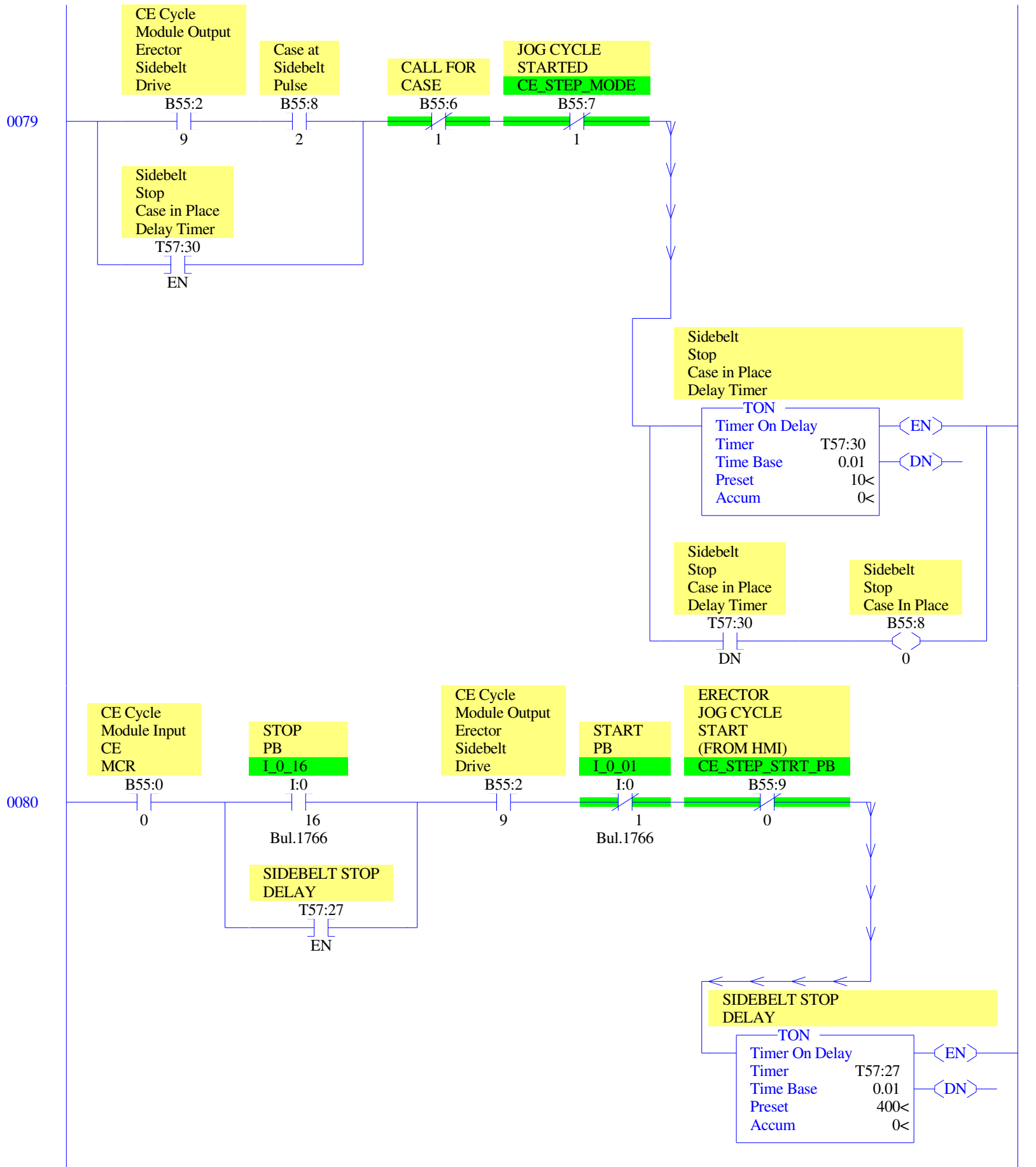
0075

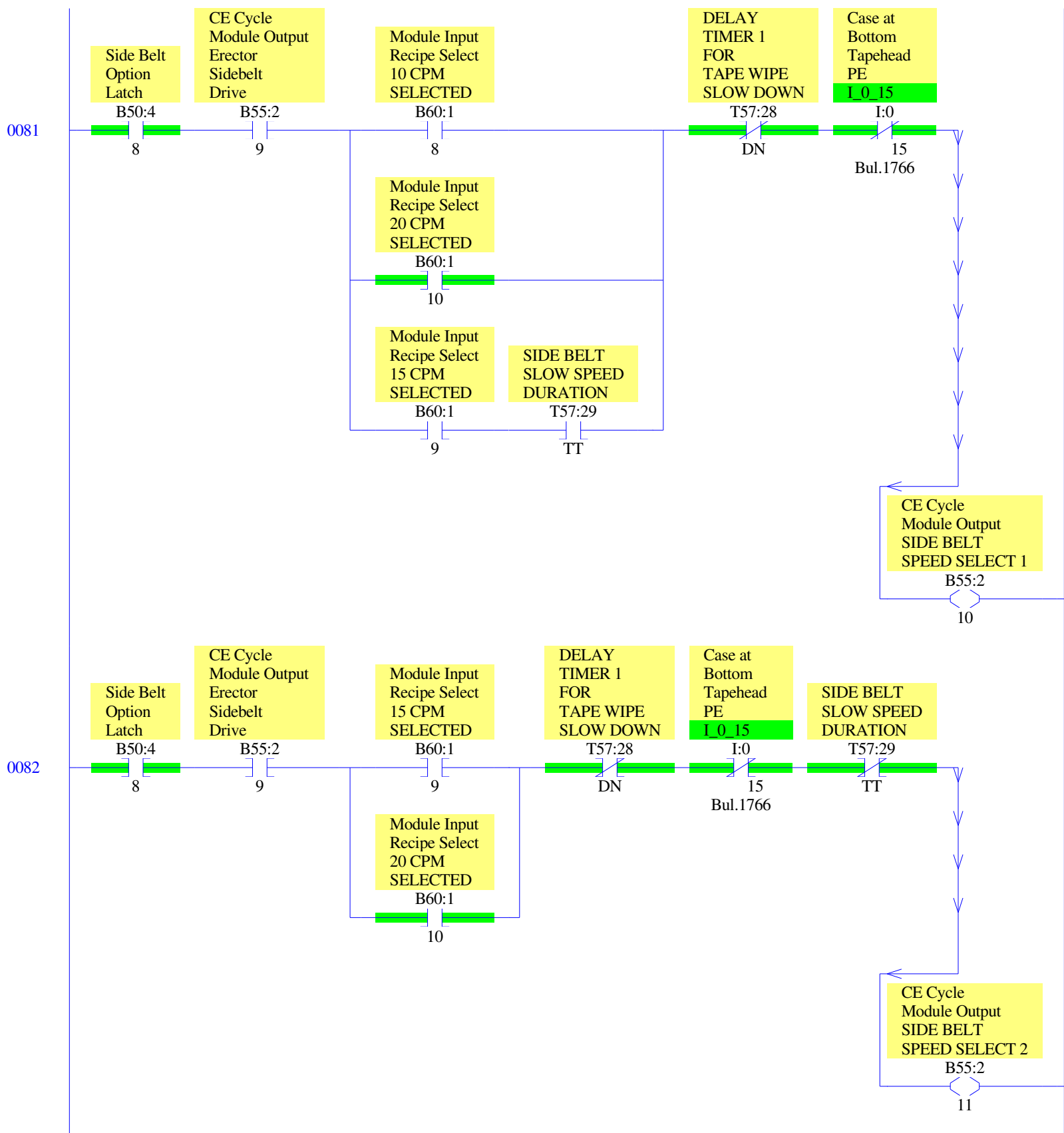


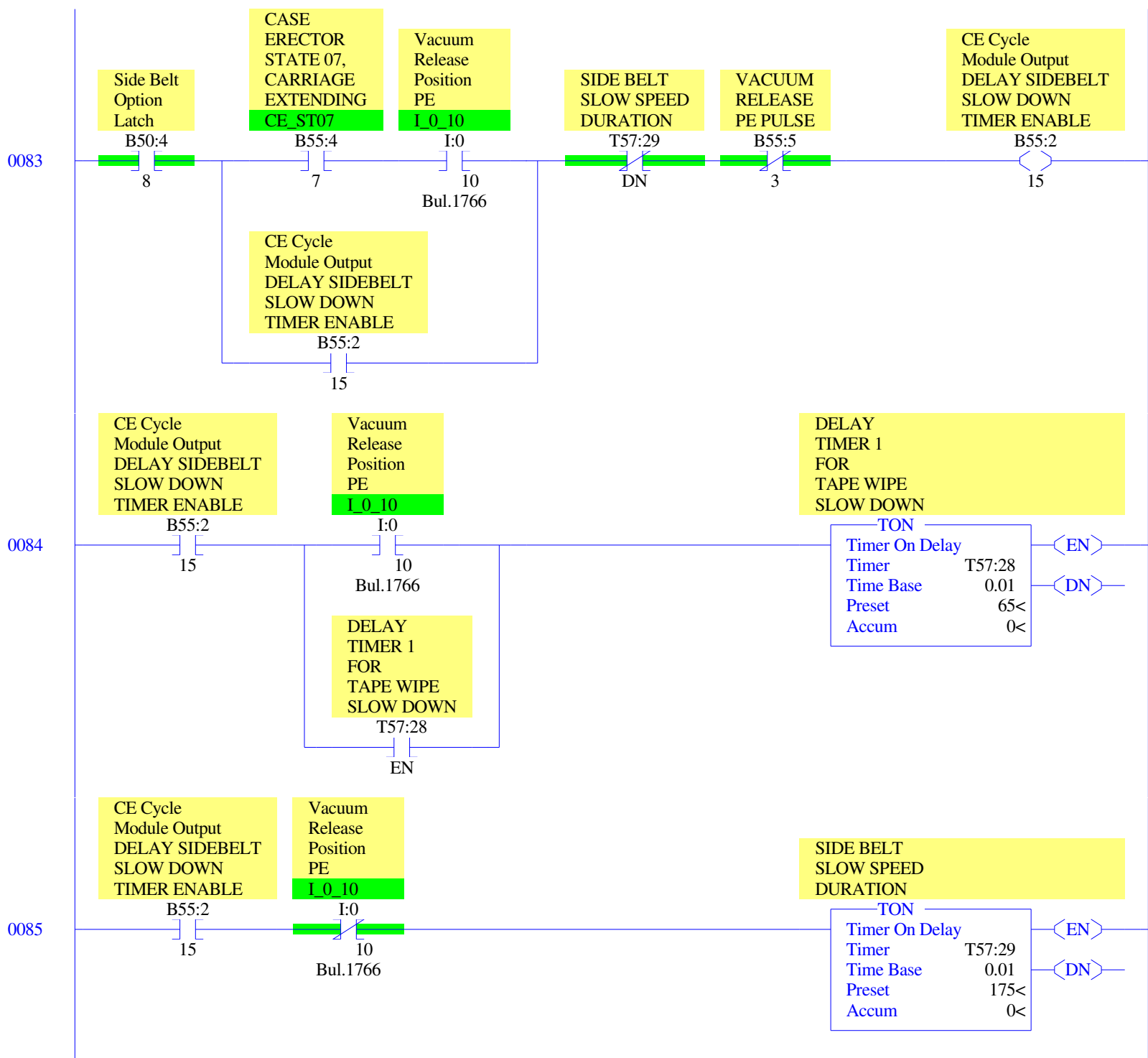


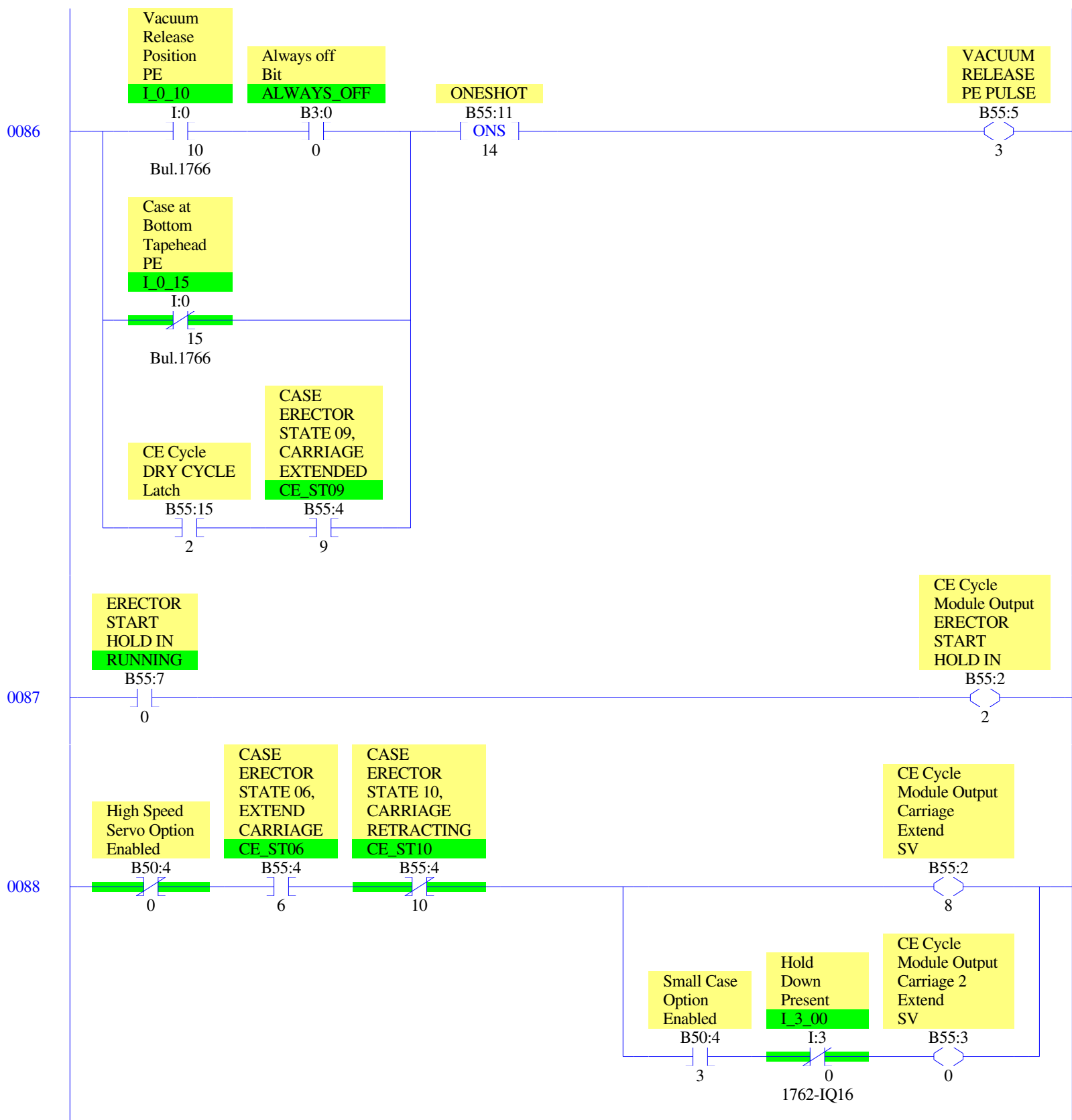
0076

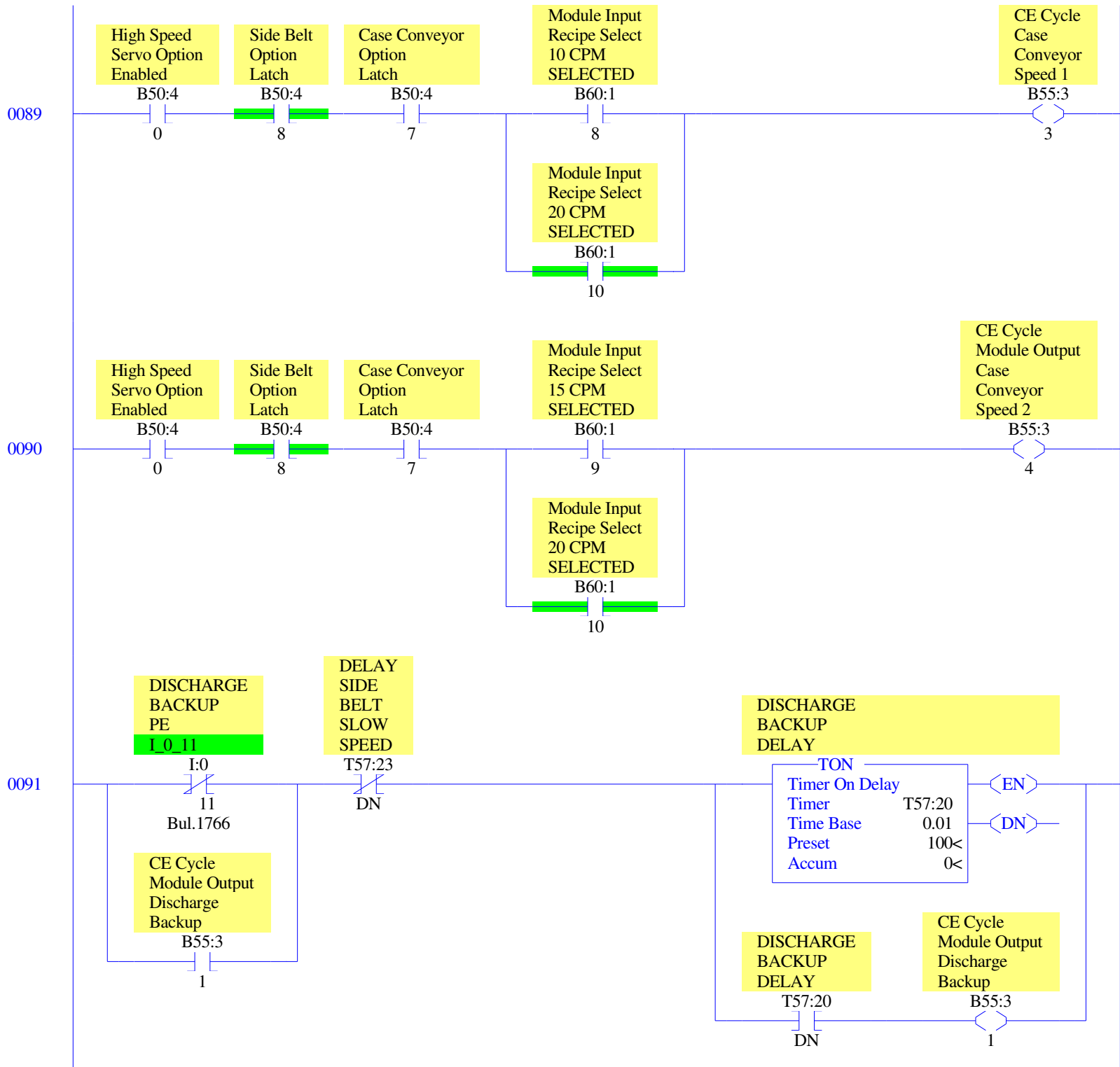


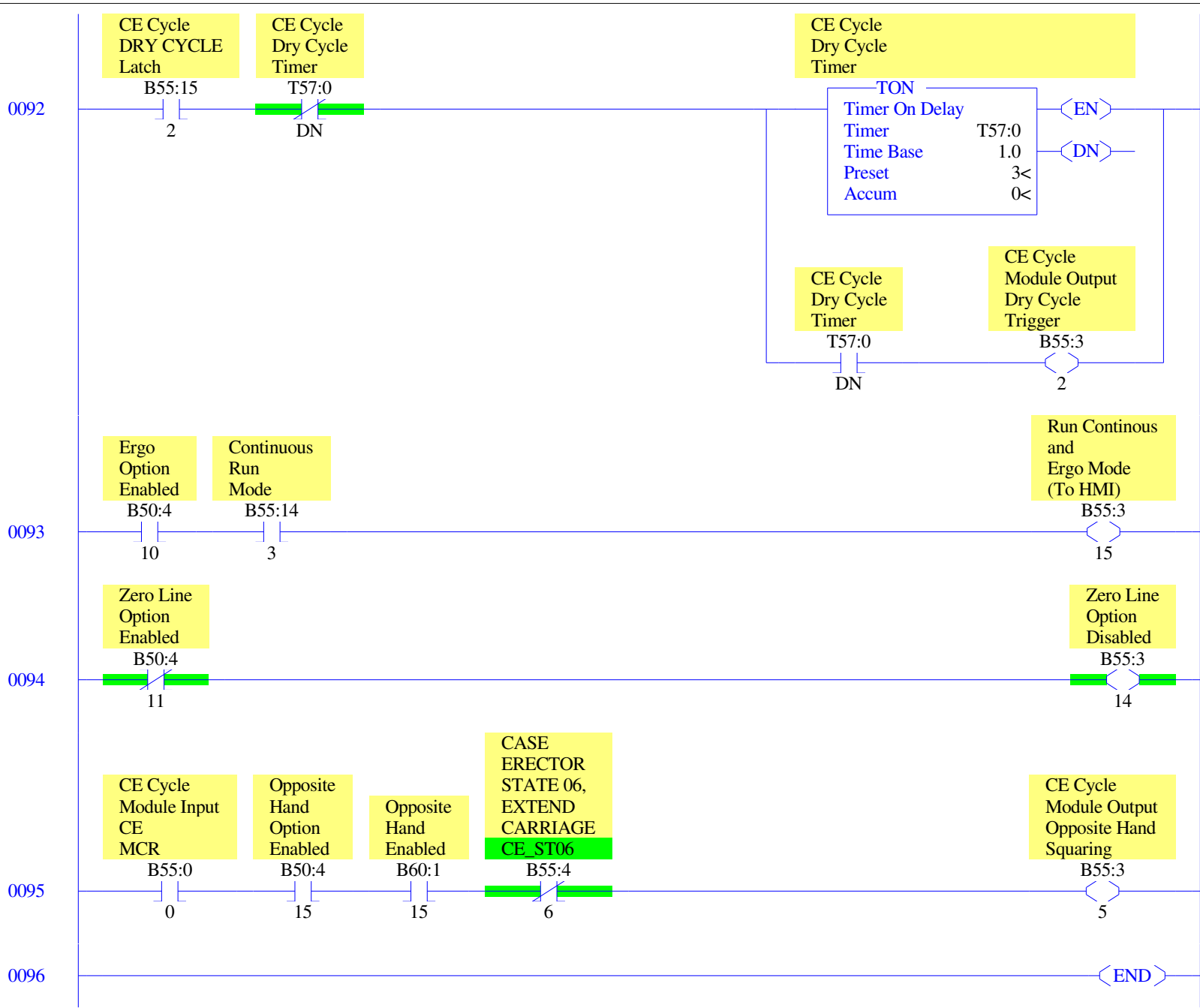












0000

VACUUM
BLOW OFF
DELAY
TIMER
(Case Release Dly)

—MUL—	
Multiply	
Source A	F64:0
	0.1<
Source B	100.0
	100.0<
Dest	T57:24.PRE
	10<

SQUARING
EXTEND
DELAY

—MUL—	
Multiply	
Source A	F64:1
	0.05<
Source B	100.0
	100.0<
Dest	T57:3.PRE
	5<

TRAILING
MINOR
FLAP
EXTEND
DELAY

—MUL—	
Multiply	
Source A	F64:2
	0.1<
Source B	100.0
	100.0<
Dest	T57:4.PRE
	10<

TRAILING
MINOR
FLAP
EXTEND
DELAY

TRAILING
MINOR
FLAP
EXTEND
DELAY

—LES—	
Less Than (A<B)	
Source A	T57:4.PRE
	10<
Source B	1
	1<

—MOV—	
Move	
Source	1
	1<
Dest	T57:4.PRE
	10<

VACUUM
PLATE
RETRACT
DELAY

—MUL—	
Multiply	
Source A	F64:3
	0.1<
Source B	100.0
	100.0<
Dest	T57:2.PRE
	10<

DELAY
TIMER 1
FOR
TAPE WIPE
SLOW DOWN

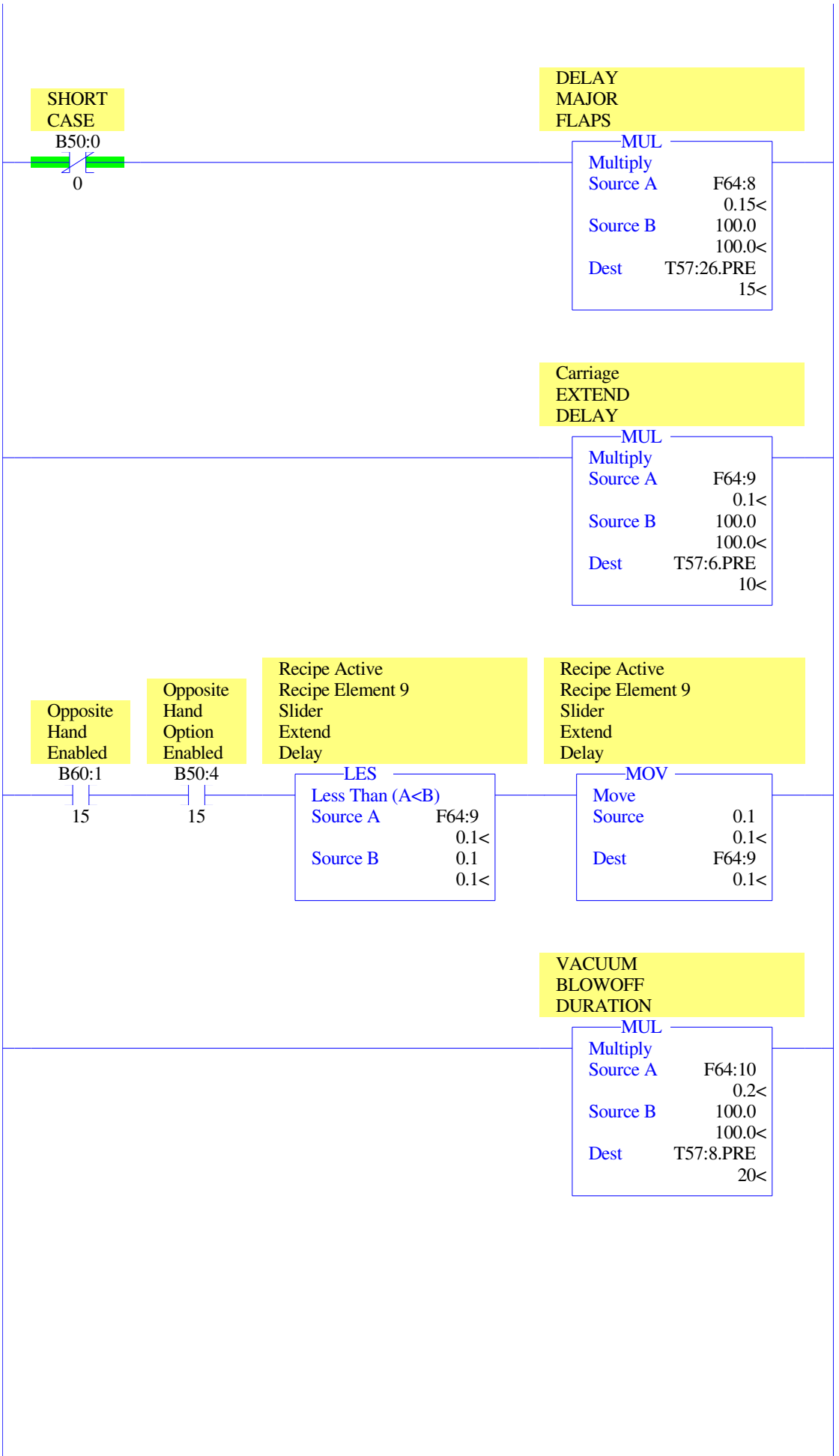
—MUL—	
Multiply	
Source A	F64:4
	0.65<
Source B	100.0
	100.0<
Dest	T57:28.PRE
	65<

SIDE BELT
SLOW SPEED
DURATION

—MUL—	
Multiply	
Source A	F64:5
	1.75<
Source B	100.0
	100.0<
Dest	T57:29.PRE
	175<

Forward
Speed

—MOV—	
Move	
Source	F64:7
	42.0<
Dest	F74:2
	42.0<



DISCHARGE
BACKUP
DELAY

MUL	
Multiply	
Source A	F64:11
	1.0<
Source B	100.0
	100.0<
Dest	T57:20.PRE
	100<

Case
Conveyor
START
DELAY

MUL	
Multiply	
Source A	F64:12
	0.05<
Source B	100.0
	100.0<
Dest	T67:1.PRE
	5<

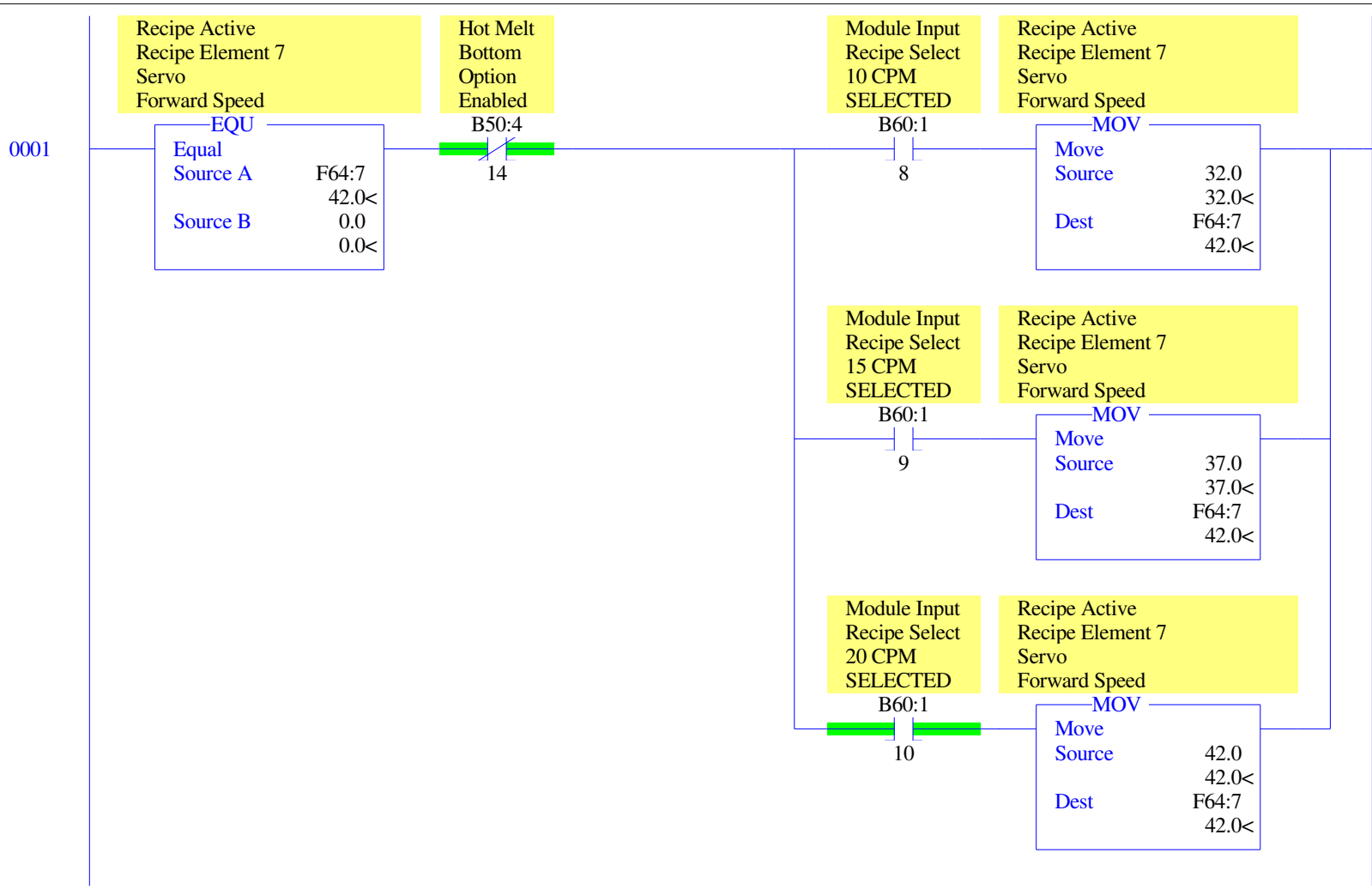
SHORT
CASE
B50:0
0

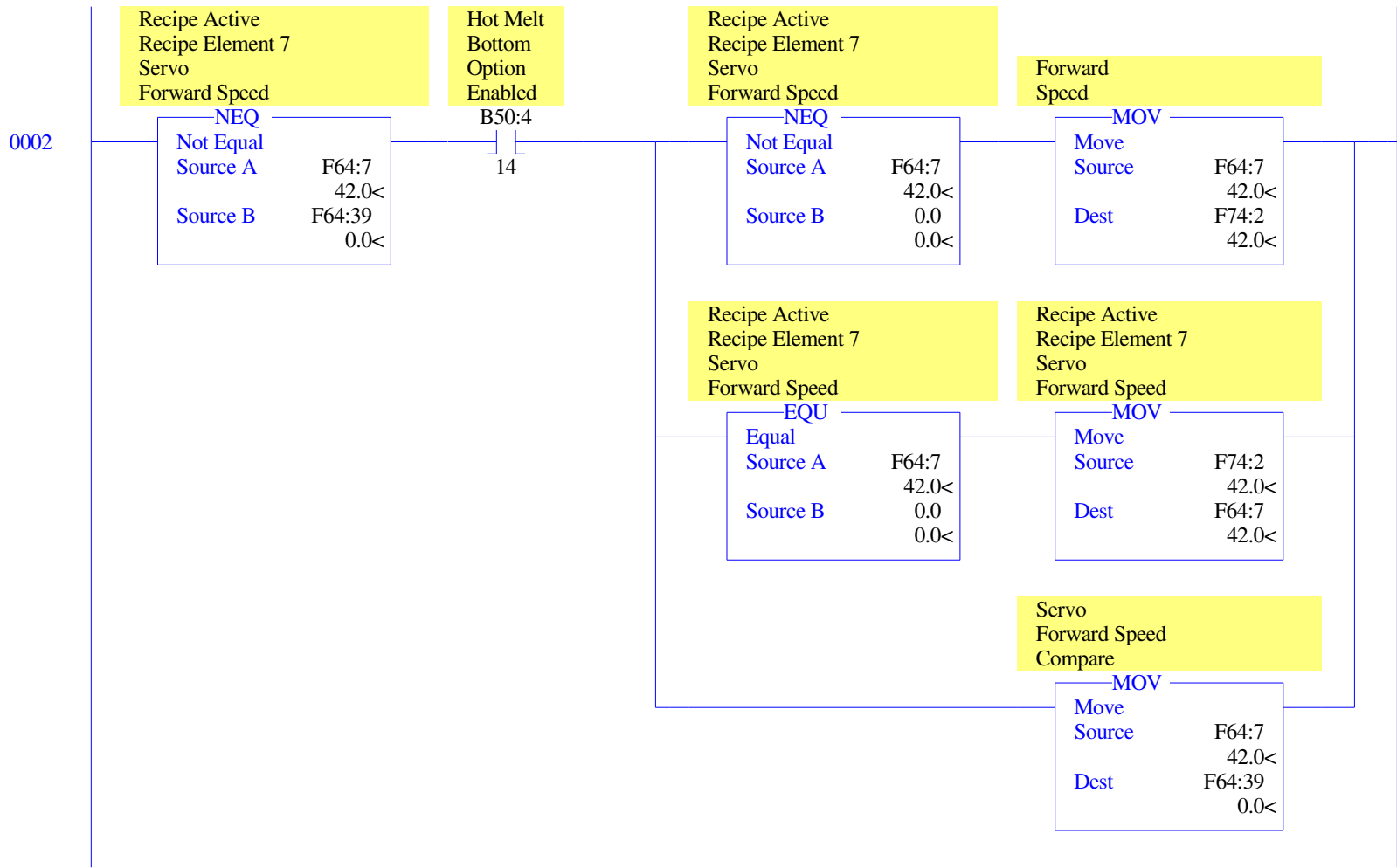
DELAY
MAJOR
FLAPS

MUL	
Multiply	
Source A	F64:13
	0.2<
Source B	100.0
	100.0<
Dest	T57:26.PRE
	15<

Call for
Case
Continous Mode
Pacing Timer

MUL	
Multiply	
Source A	F64:14
	0.0<
Source B	100.0
	100.0<
Dest	T57:18.PRE
	0<





0003

Top First
Bead
Delay

MUL
Multiply
Source A F64:20
0.0<
Source B 100.0
100.0<
Dest T107:0.PRE
0<

Top First
Bead
Duration

MUL
Multiply
Source A F64:21
0.0<
Source B 100.0
100.0<
Dest T107:1.PRE
0<

Top
Second
Bead
Delay

MUL
Multiply
Source A F64:22
0.0<
Source B 100.0
100.0<
Dest T107:2.PRE
0<

Top
Second
Bead
Duration

MUL
Multiply
Source A F64:23
0.0<
Source B 100.0
100.0<
Dest T107:3.PRE
0<

Bottom First
Bead Delay

MUL	
Multiply	
Source A	F64:24
	0.0<
Source B	100.0
	100.0<
Dest	T102:0.PRE
	0<

Bottom First
Bead
Duration

MUL	
Multiply	
Source A	F64:25
	0.0<
Source B	100.0
	100.0<
Dest	T102:1.PRE
	0<

Bottom
Second
Bead
Delay

MUL	
Multiply	
Source A	F64:26
	0.0<
Source B	100.0
	100.0<
Dest	T102:2.PRE
	0<

Bottom
Second
Bead
Duration

MUL	
Multiply	
Source A	F64:27
	0.0<
Source B	100.0
	100.0<
Dest	T102:3.PRE
	0<

Offset /
Case Length
SP

MOV

Move
Source F64:29
0.0<
Dest F74:4
0.0<

COMPRESSION
EXTEND
TIME

MUL

Multiply
Source A F64:30
0.0<
Source B 100.0
100.0<
Dest T102:15.PRE
0<

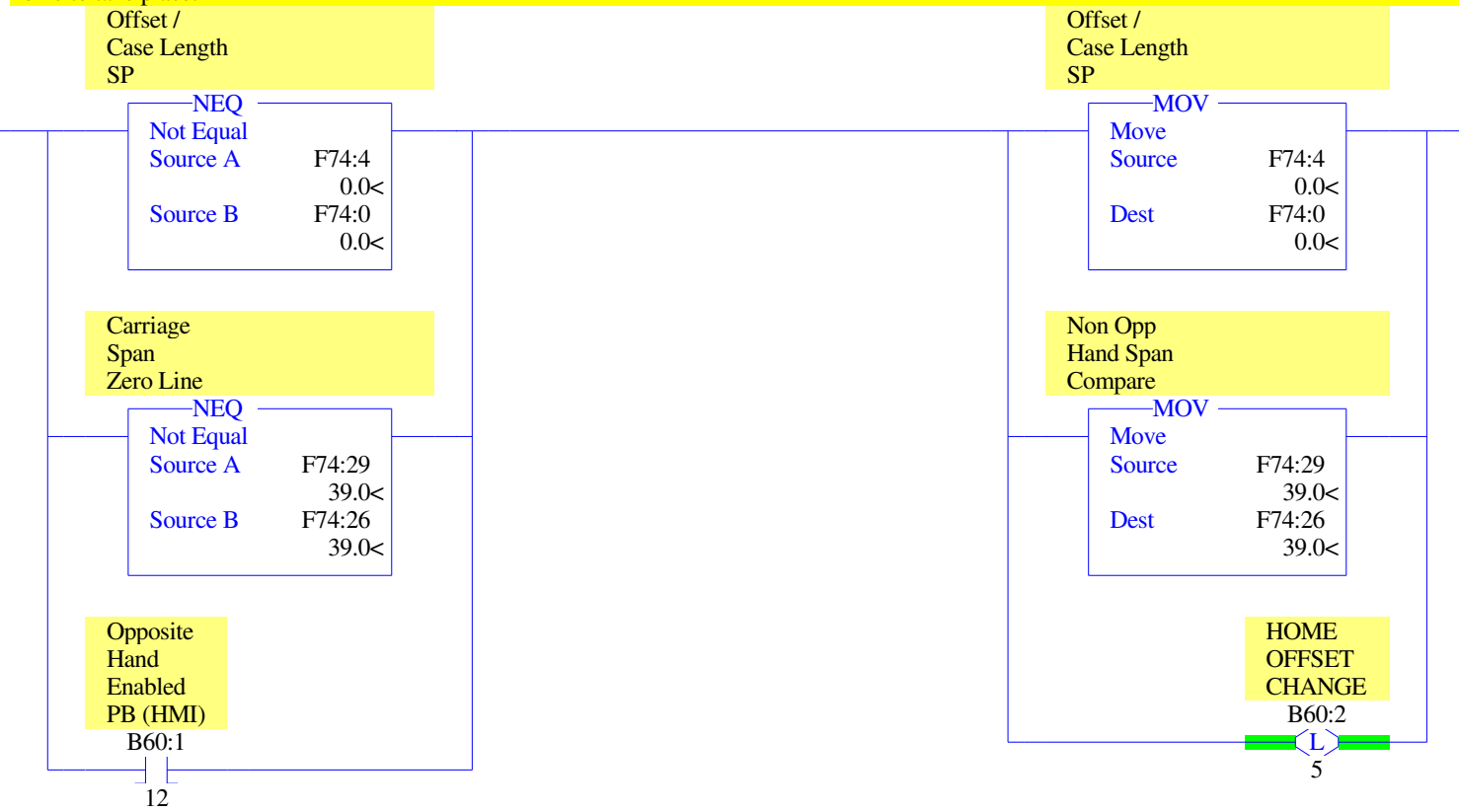
Sealer
Hot Melt
Kicker
Delay

MUL

Multiply
Source A F64:31
0.0<
Source B 100.0
100.0<
Dest T42:10.PRE
0<

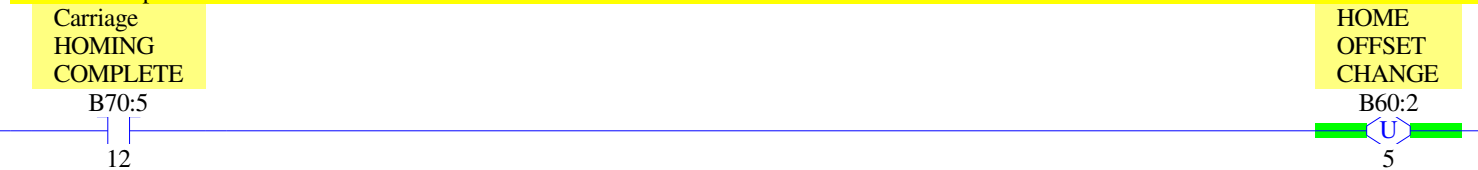
This rung Detects if there was a change in the Servo Offset Position. If there is then it will move the new setpoint and set the Flag to require a new home to take place.

0004

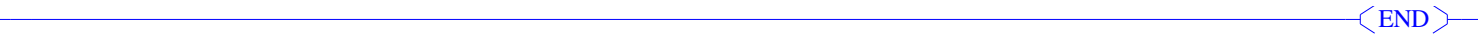


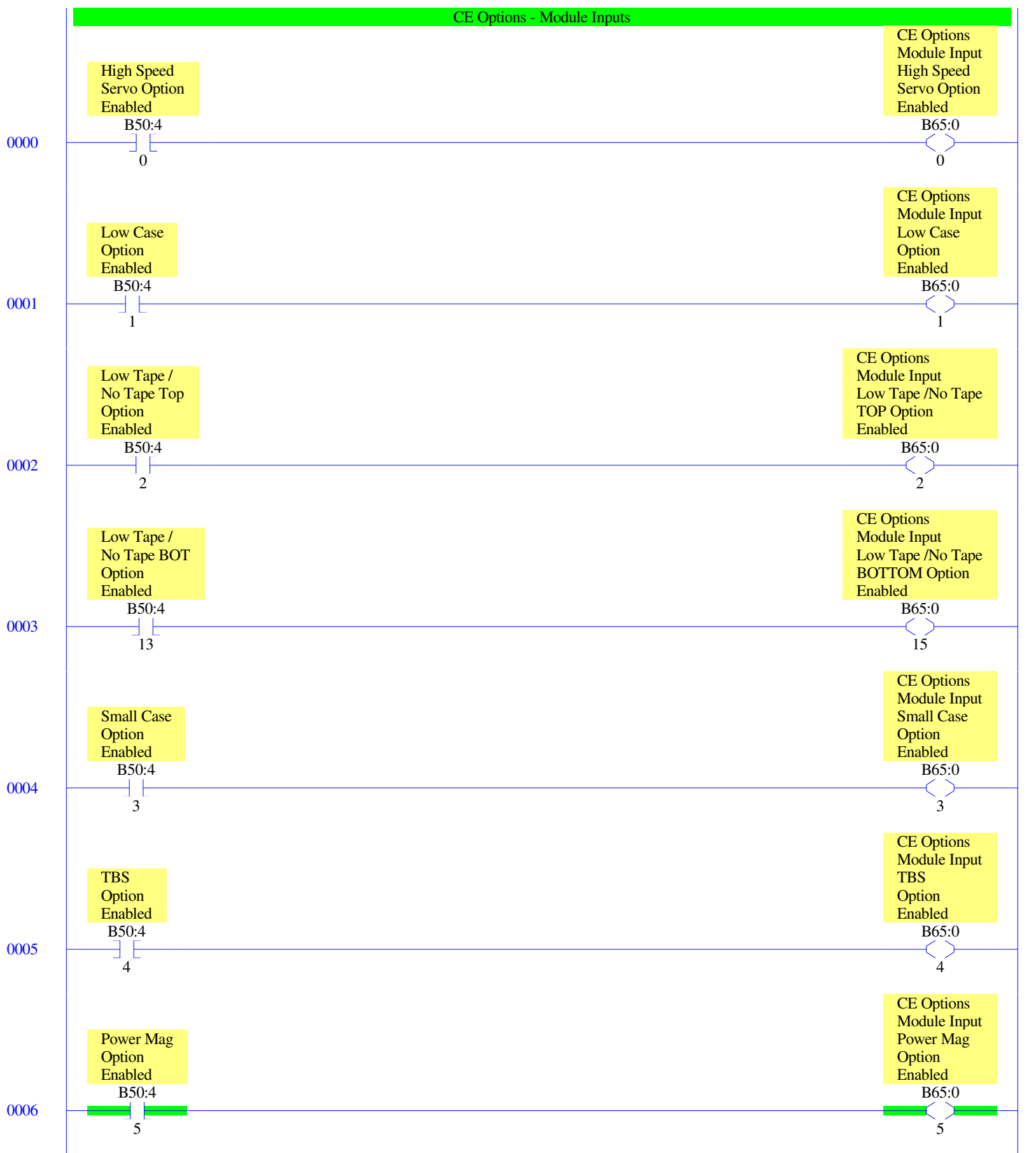
This rung Detects if there was a change in the Servo Offset Position. If there is then it will move the new setpoint and set the Flag to require a new home to take place.

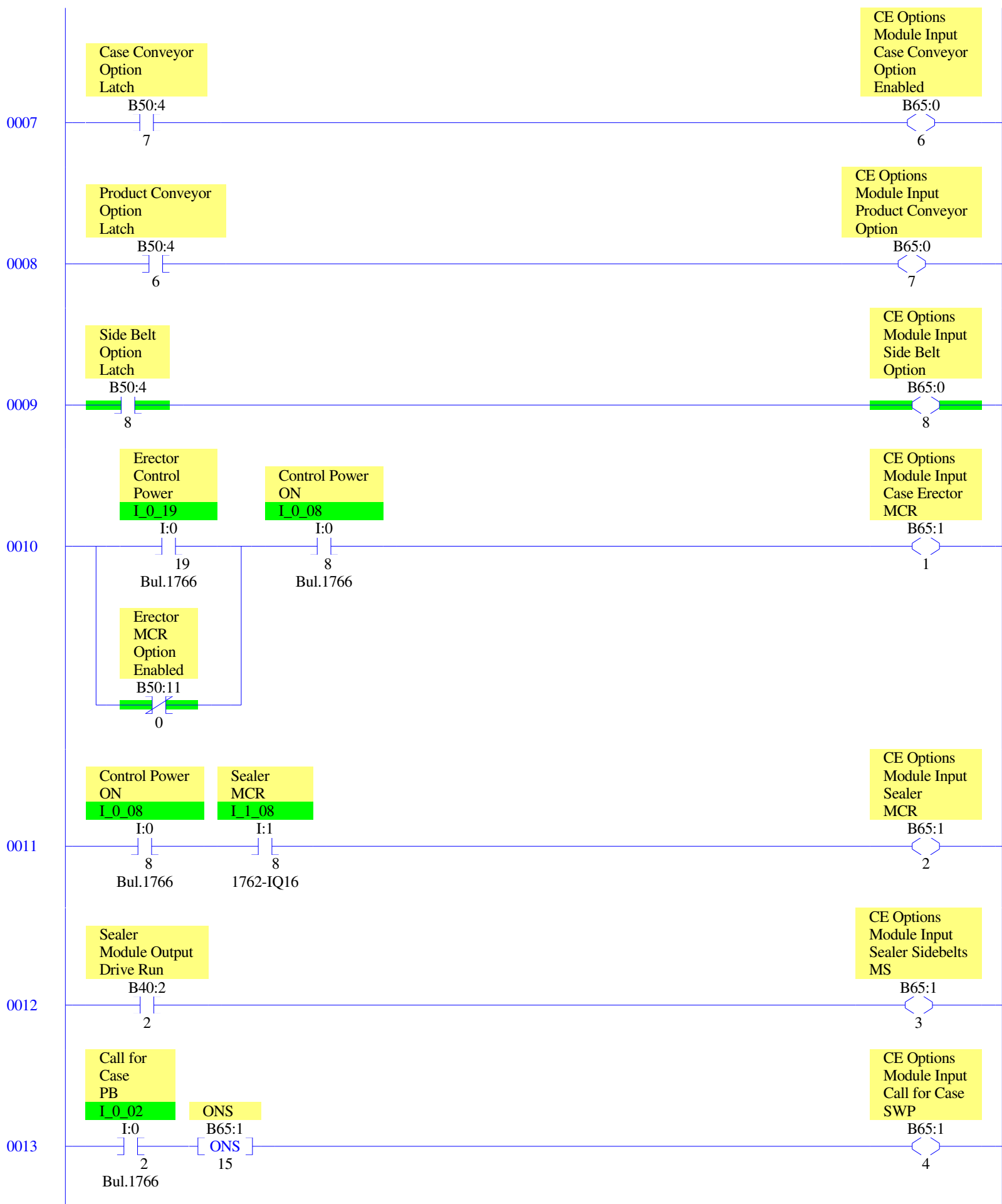
0005



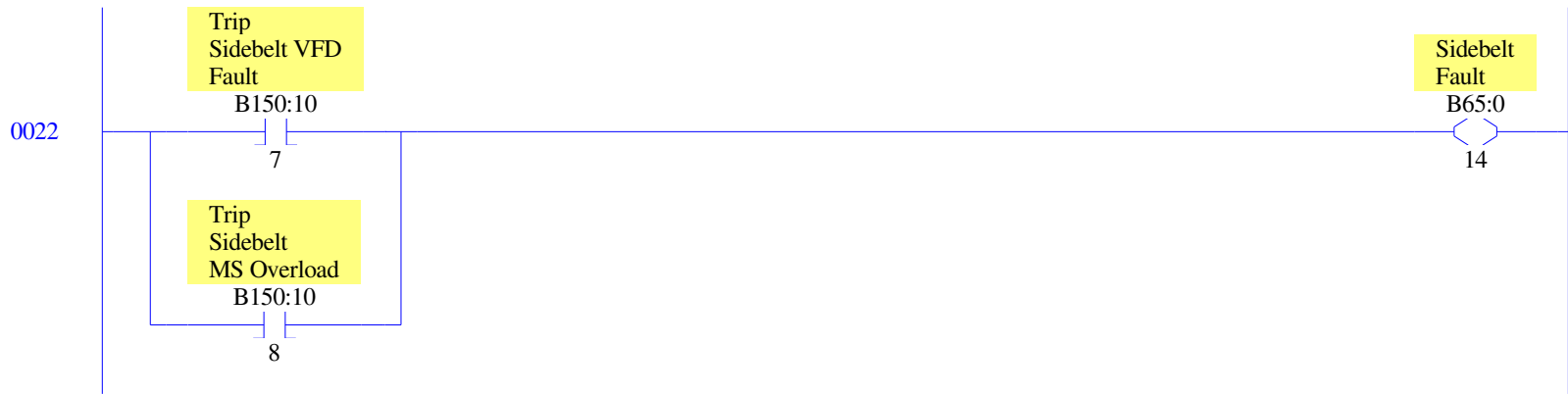
0006











CE Options - HS Servo Option

There is too much code for the servo system to place here so all of the servo code is located in the CE_Servo program file.

High Speed
Servo Option
Enabled

B50:4

0

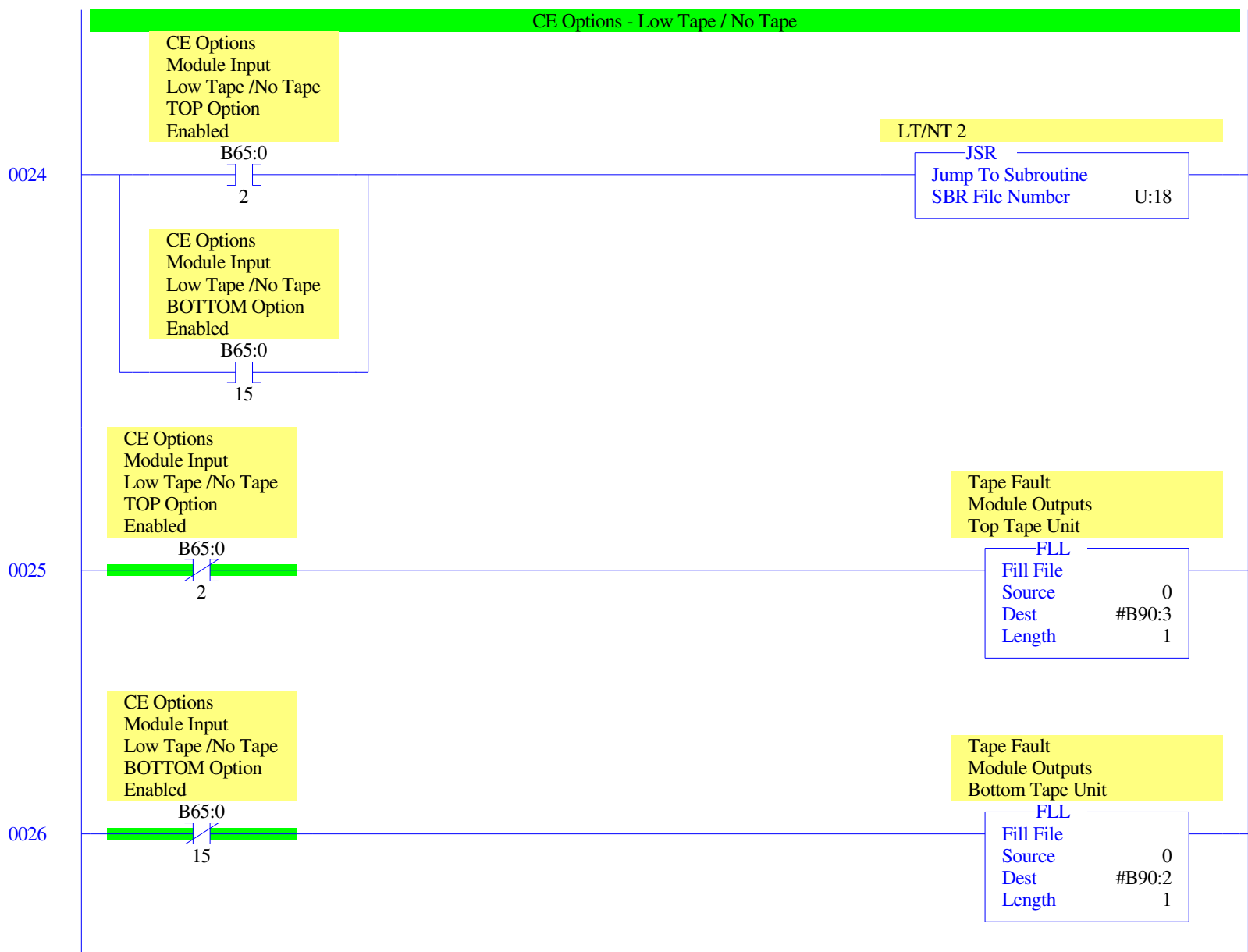
CE Servo Drive
Routine

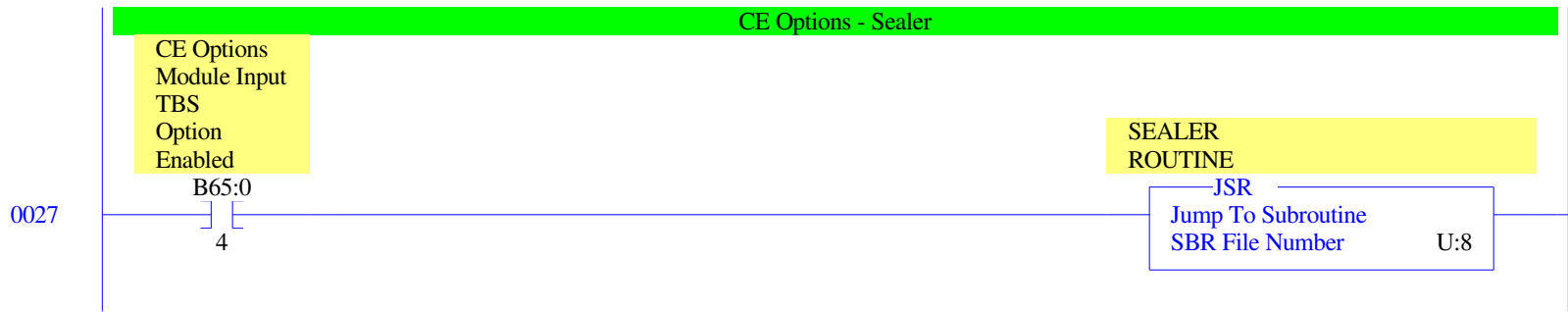
JSR

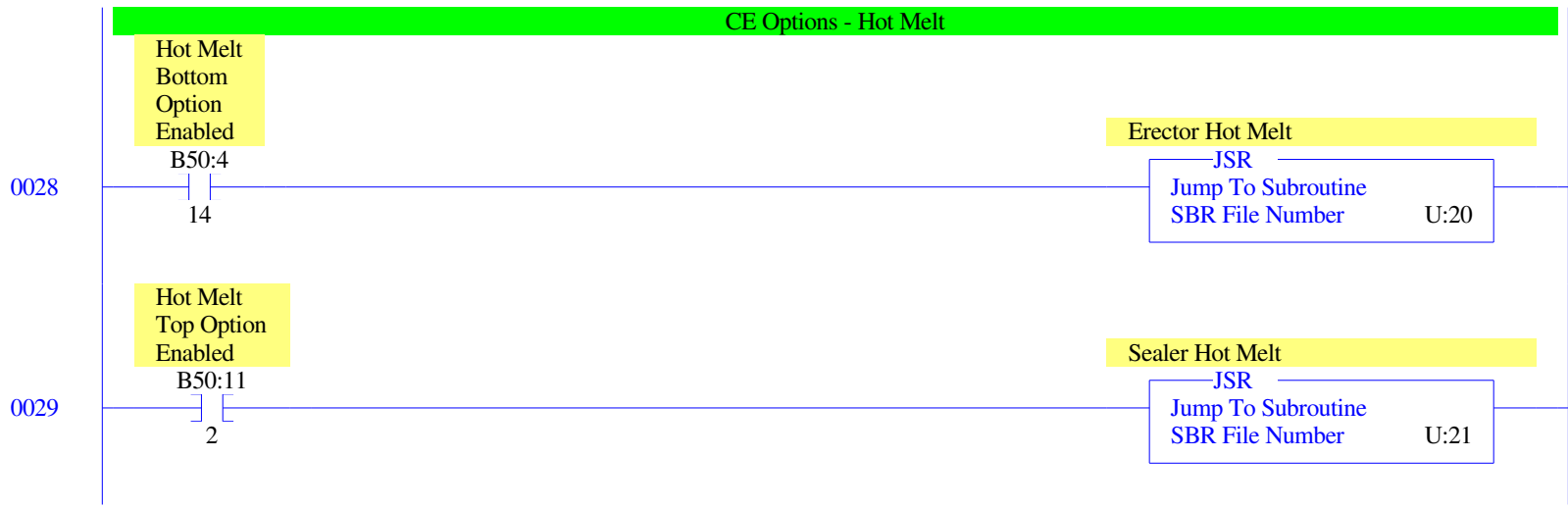
Jump To Subroutine
SBR File Number

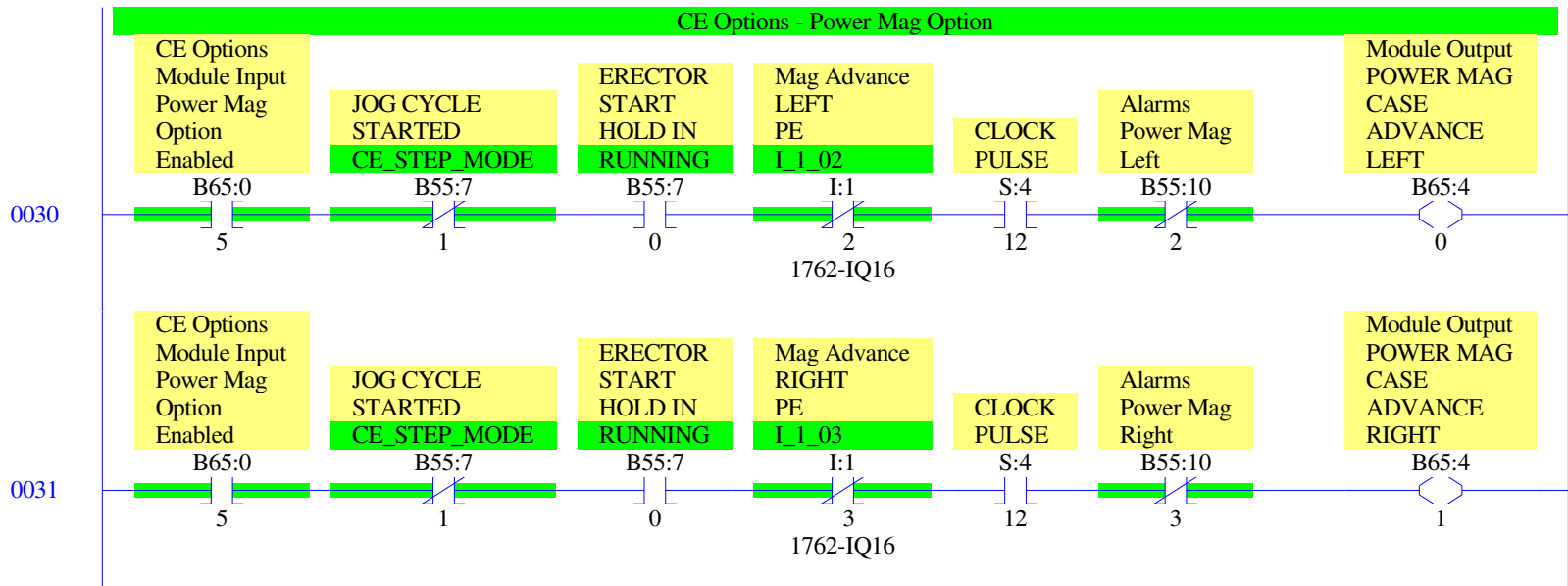
U:14

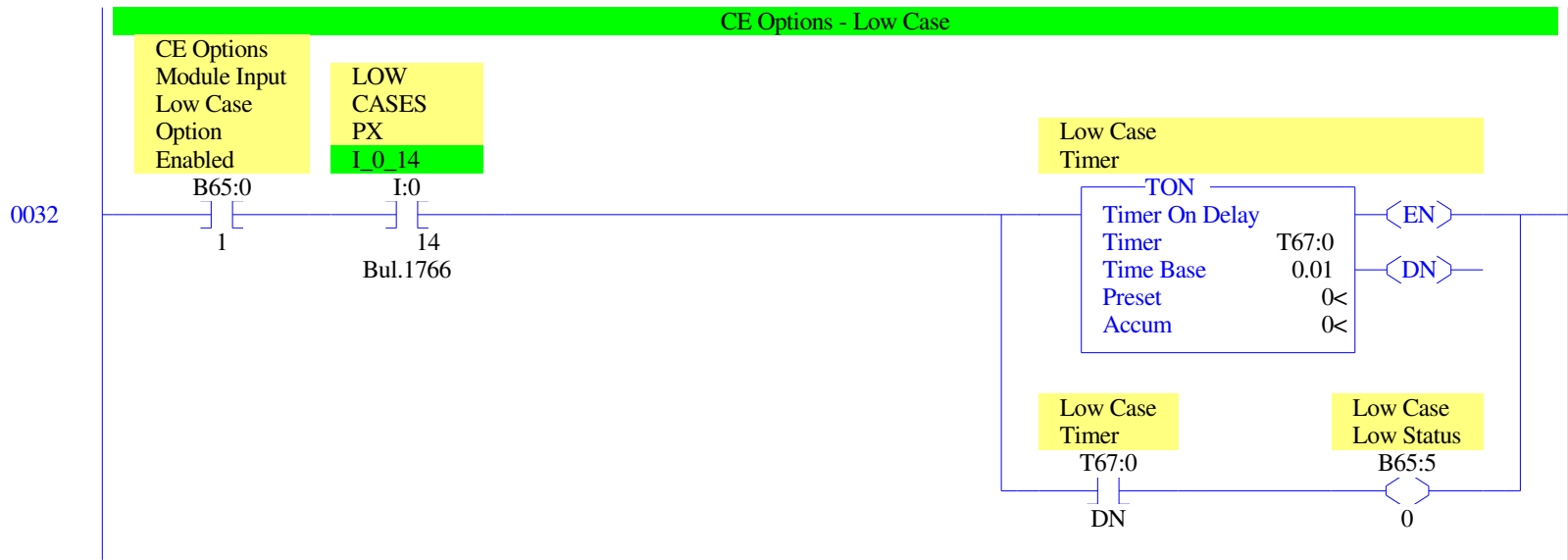
0023

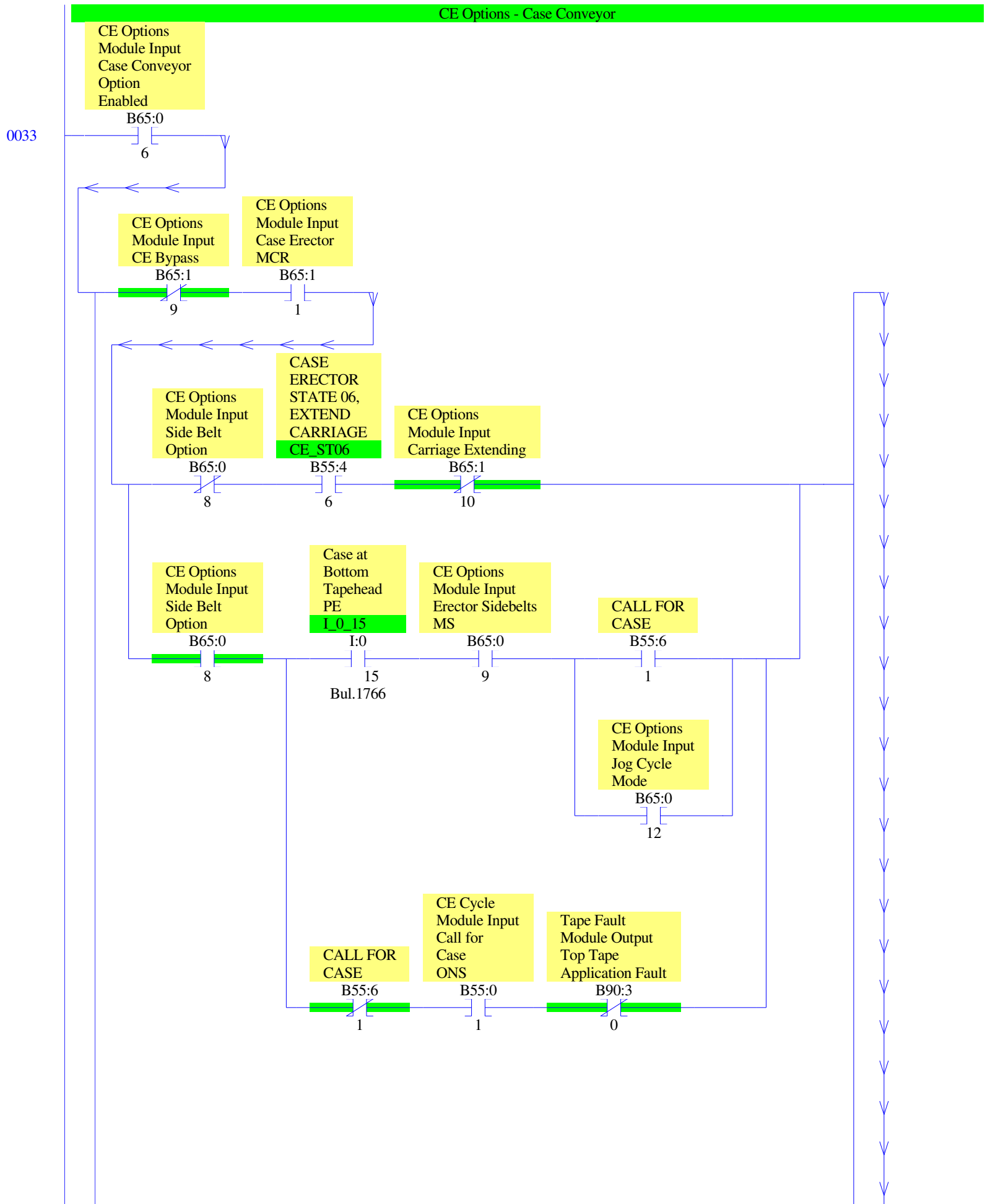


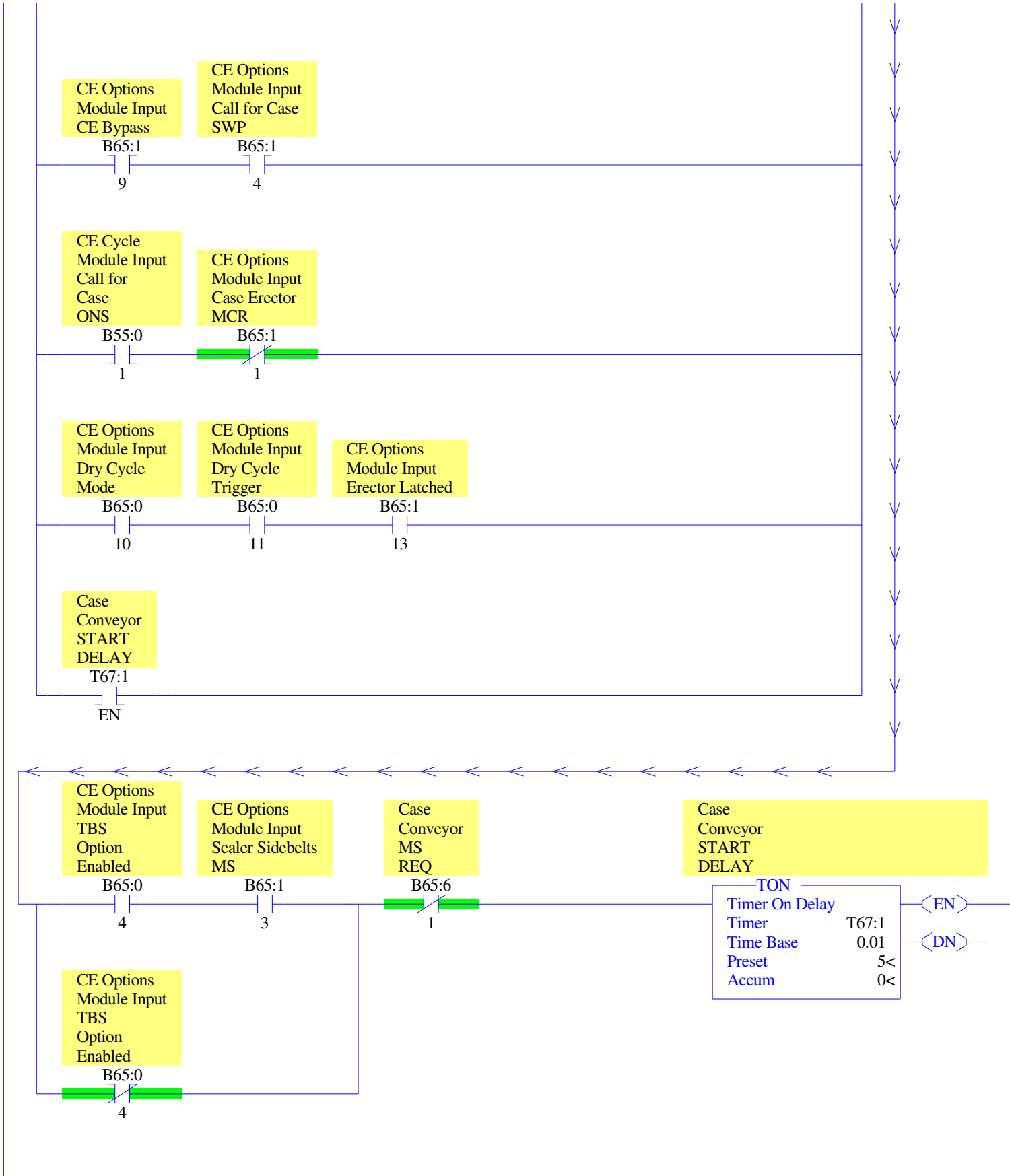


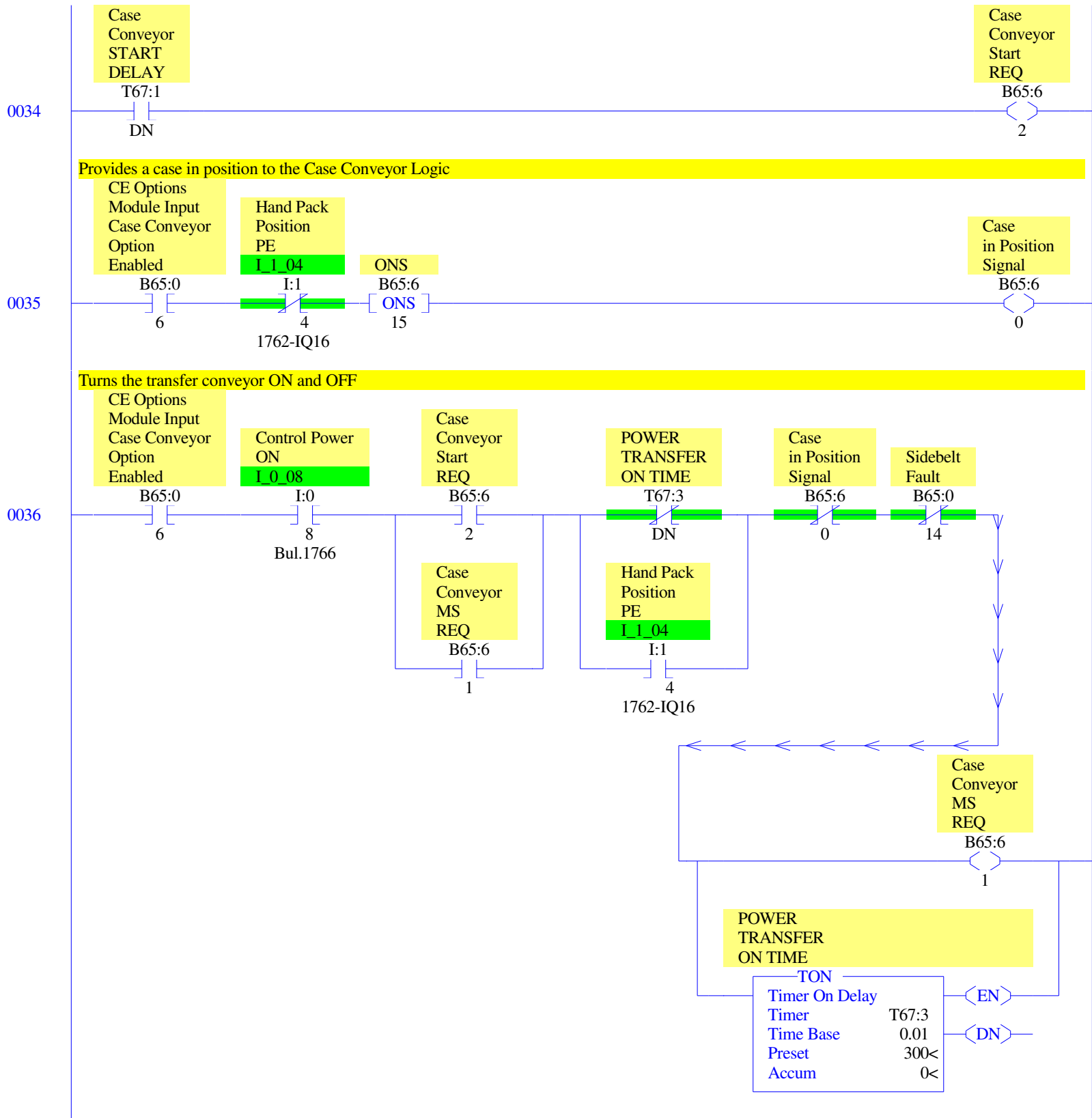


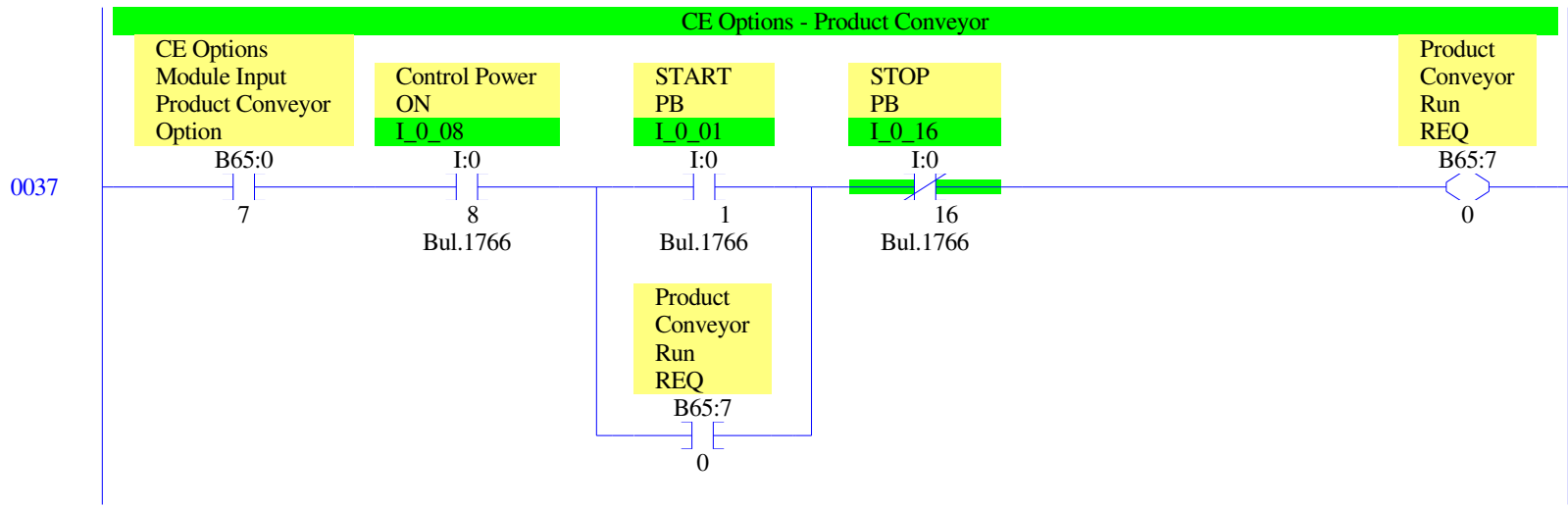


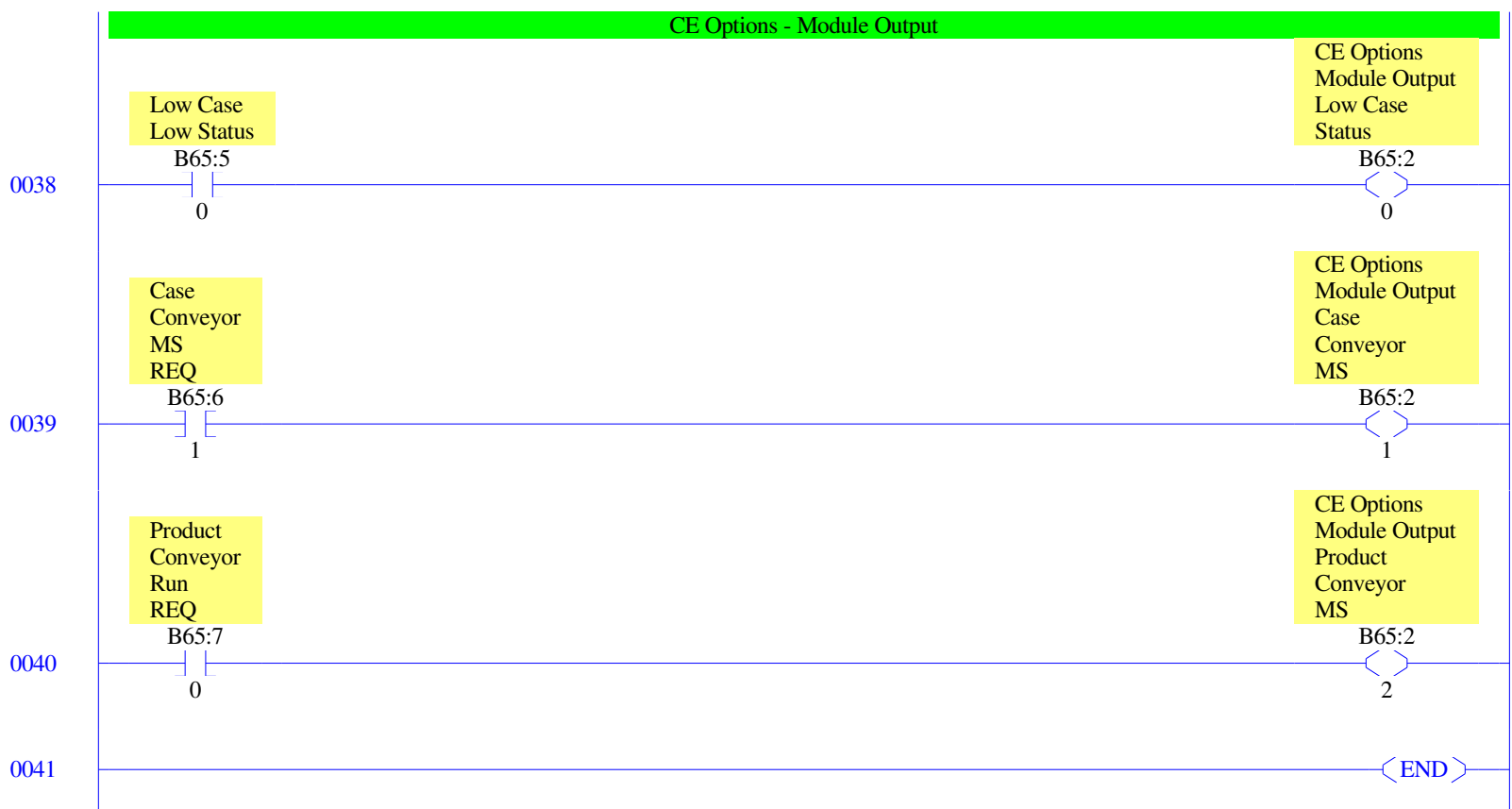


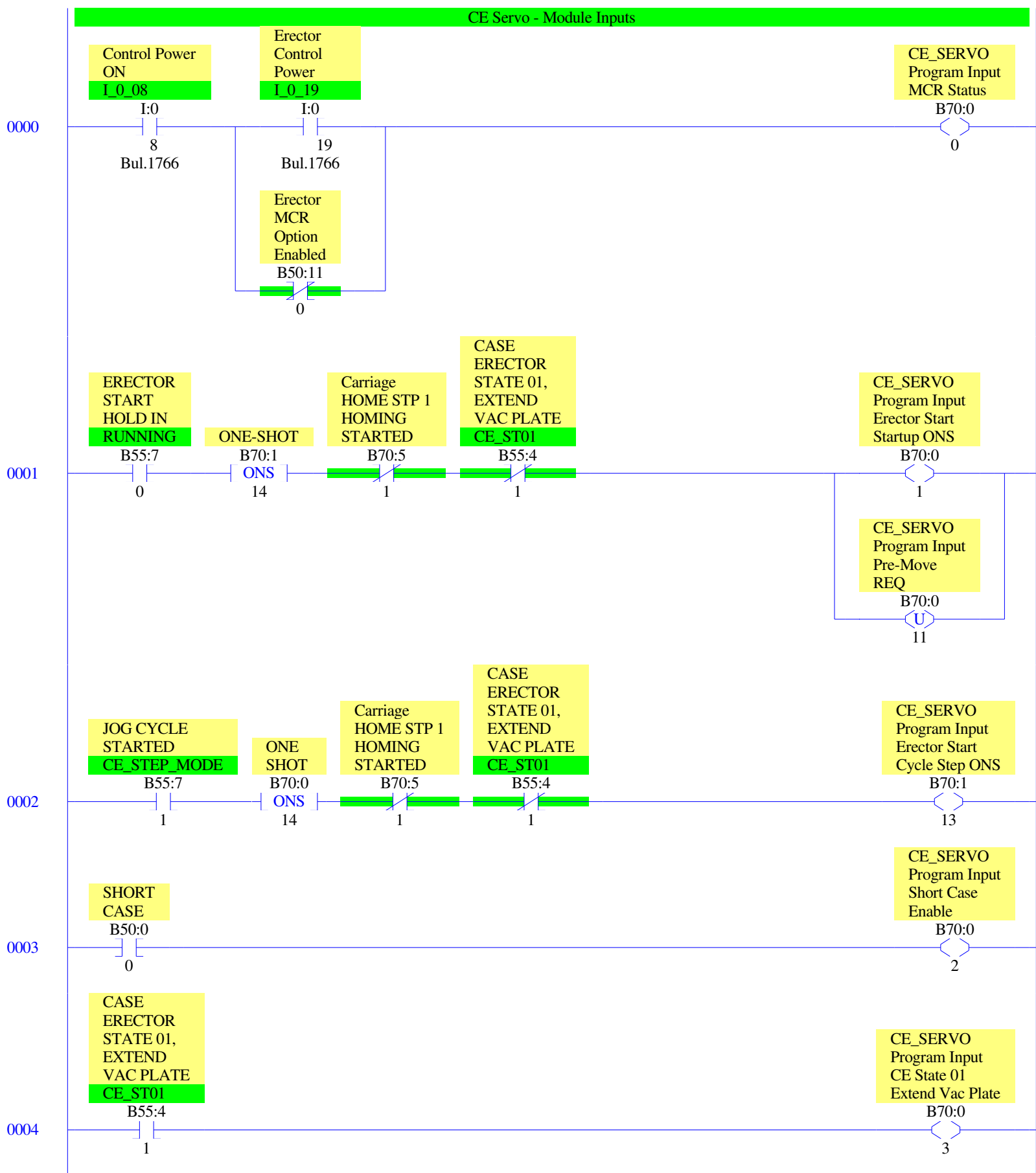


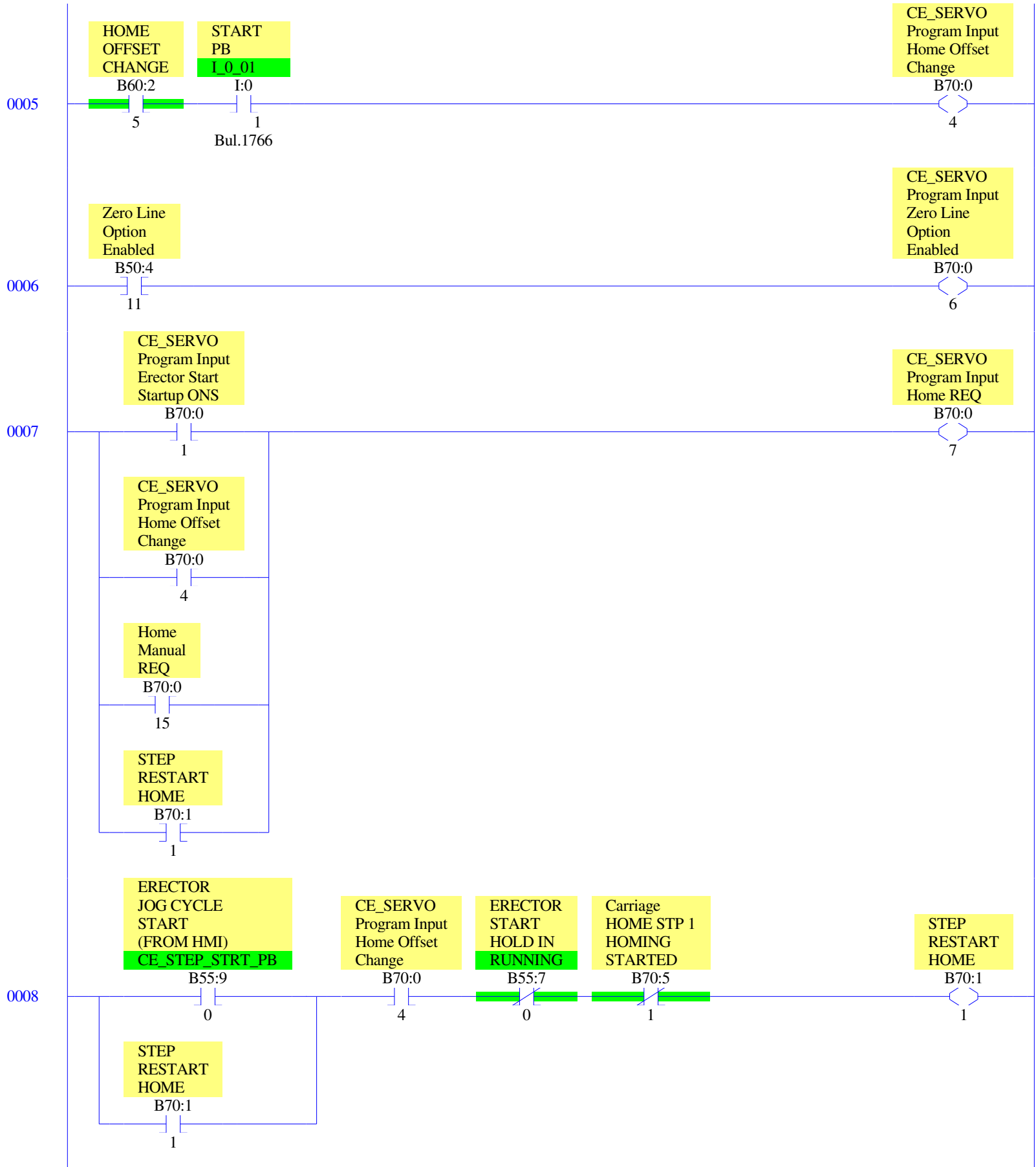


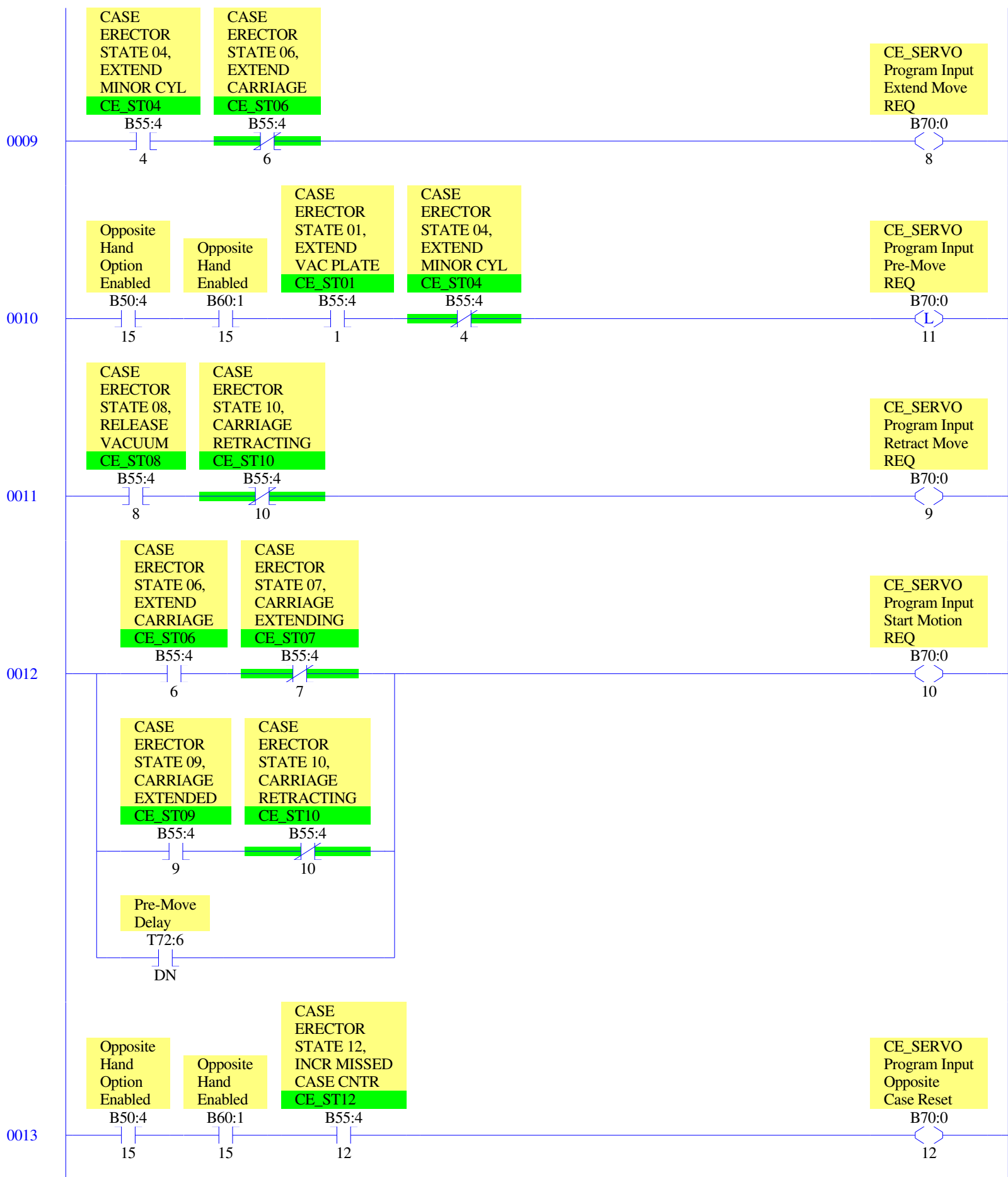


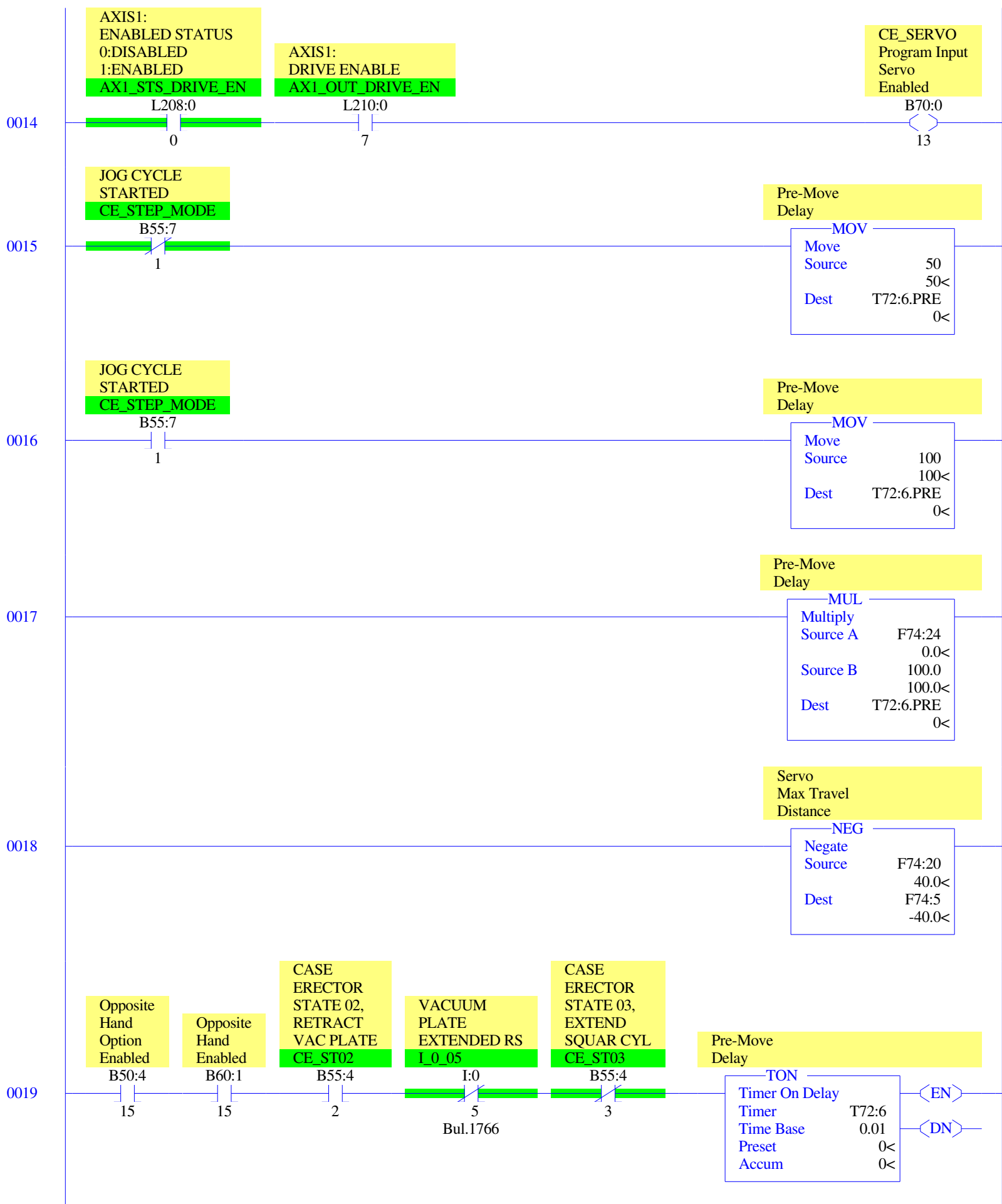






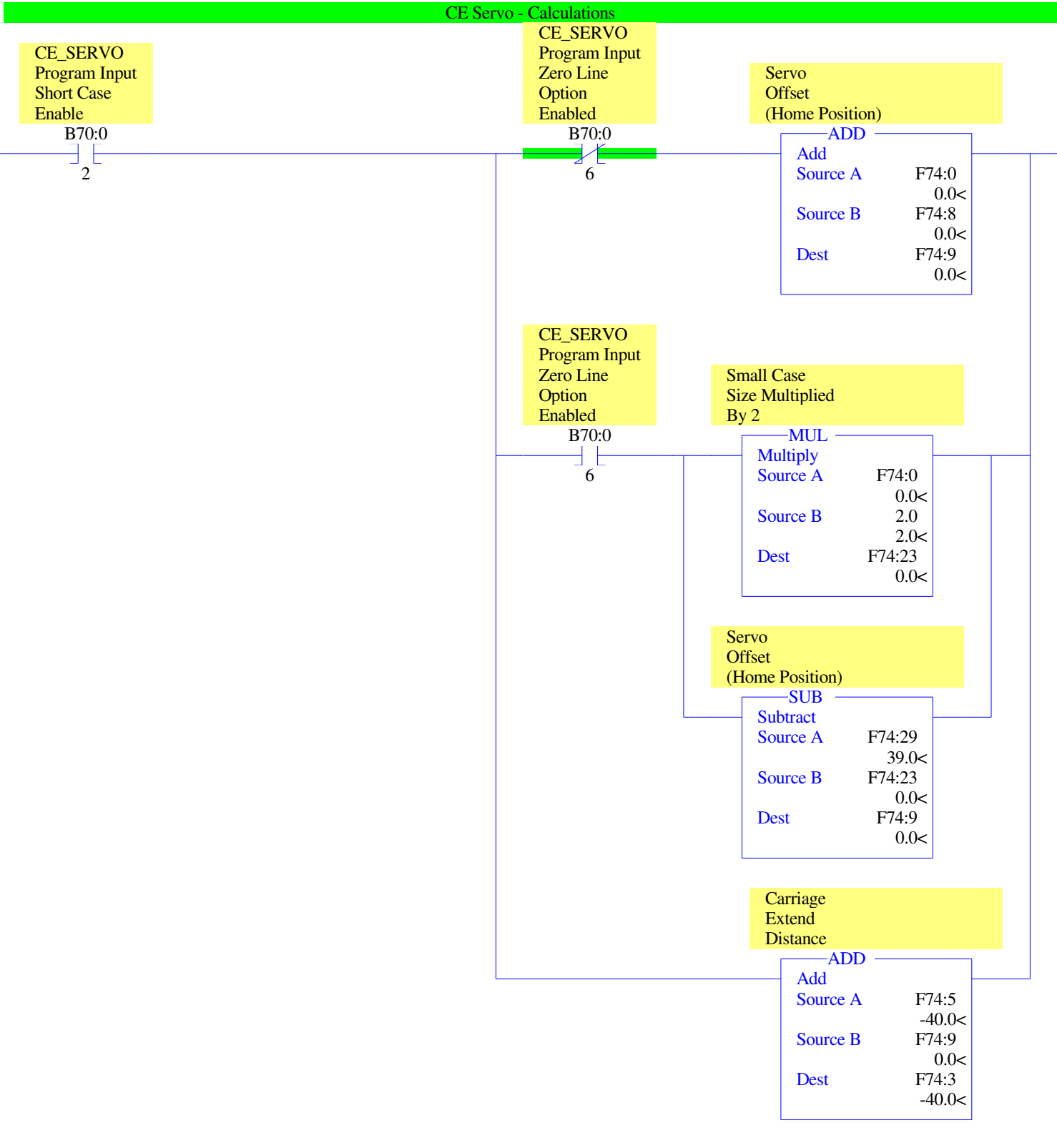




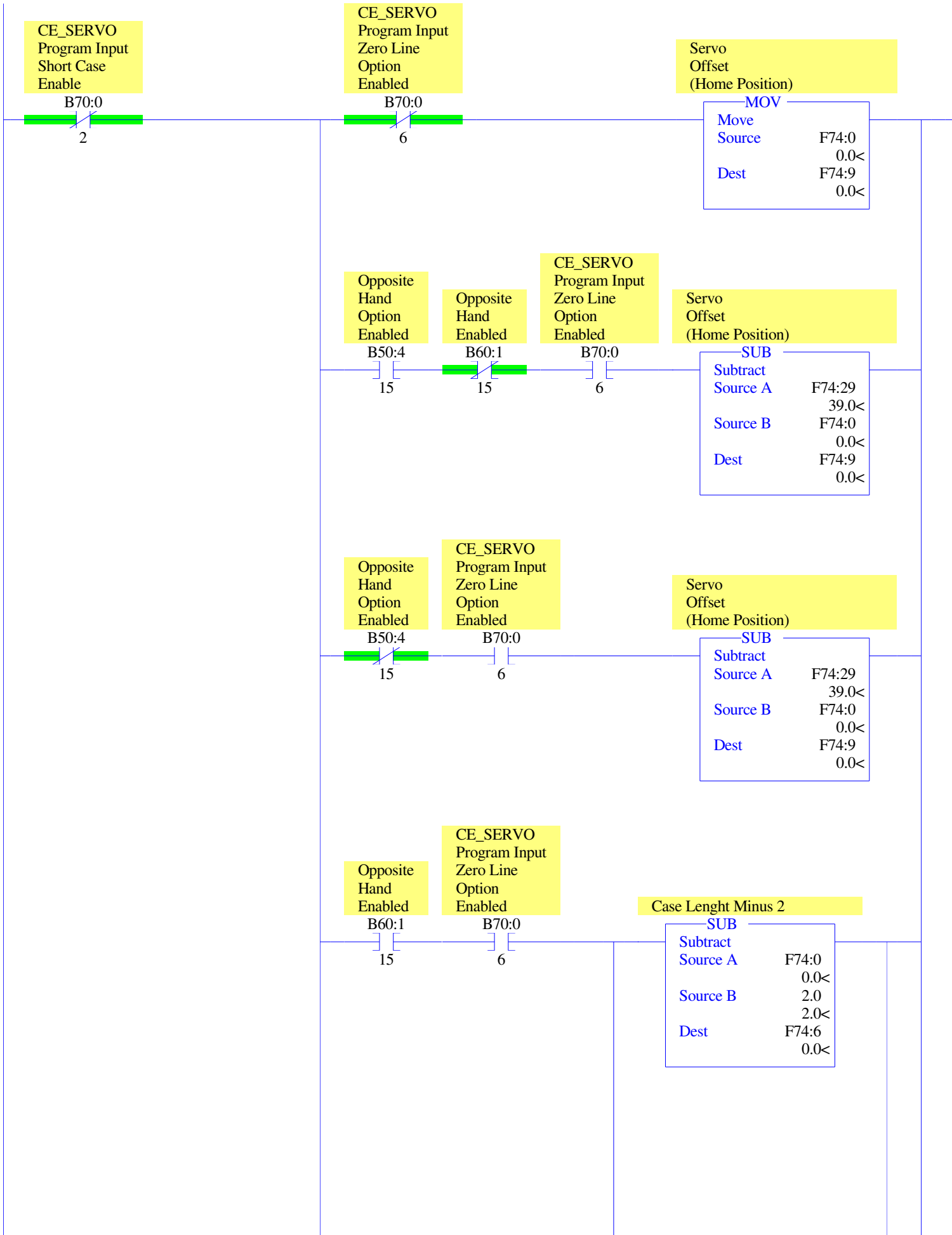




0021



0022



Servo
Offset
(Home Position)

SUB	
Subtract	
Source A	F74:29 39.0<
Source B	F74:0 0.0<
Dest	F74:9 0.0<

Case Width Plus 2

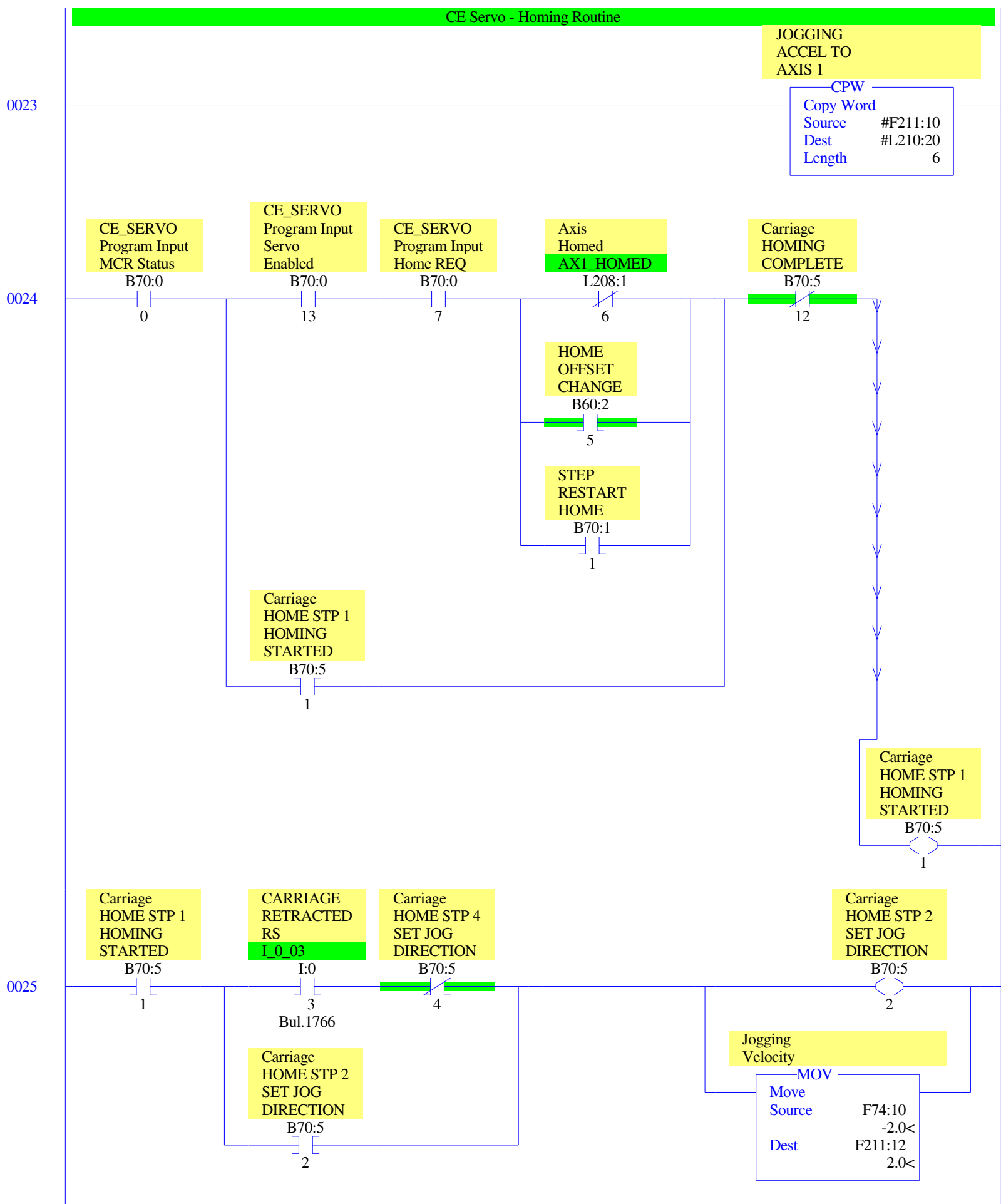
ADD	
Add	
Source A	2.0 2.0<
Source B	F74:15 9.0<
Dest	F74:17 0.0<

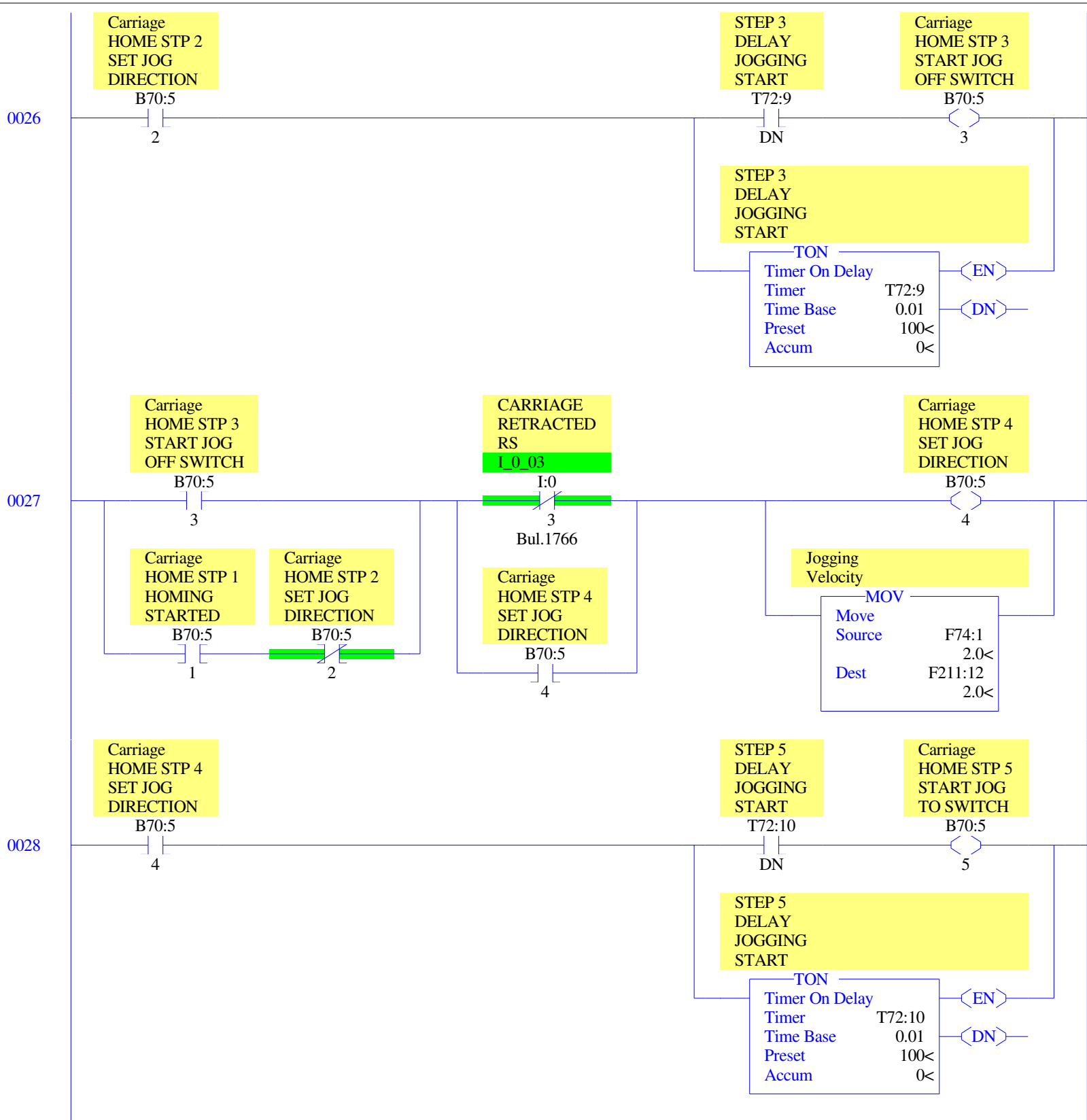
Servo
Offset
(Home Position)

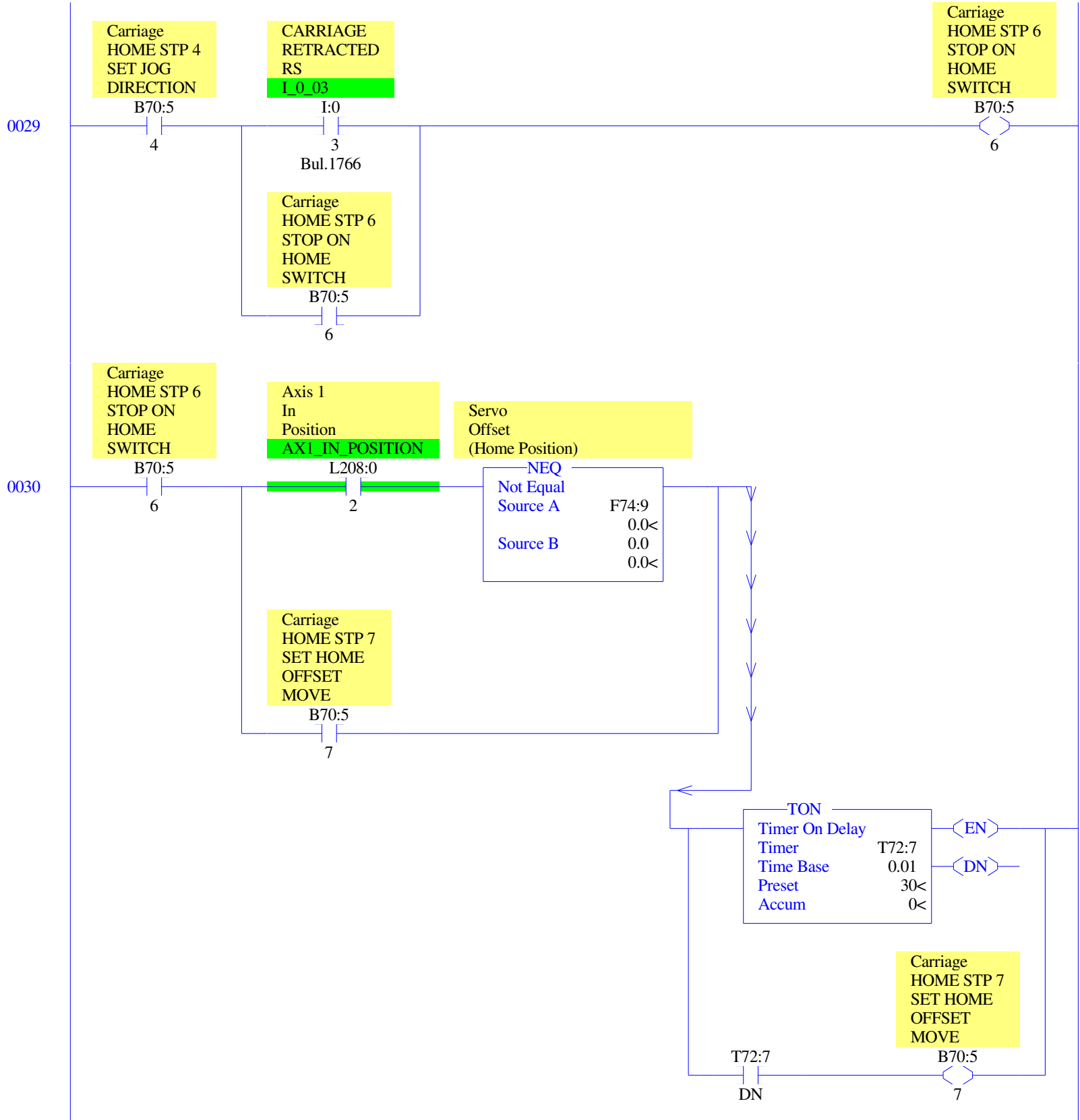
SUB	
Subtract	
Source A	F74:9 0.0<
Source B	F74:15 9.0<
Dest	F74:9 0.0<

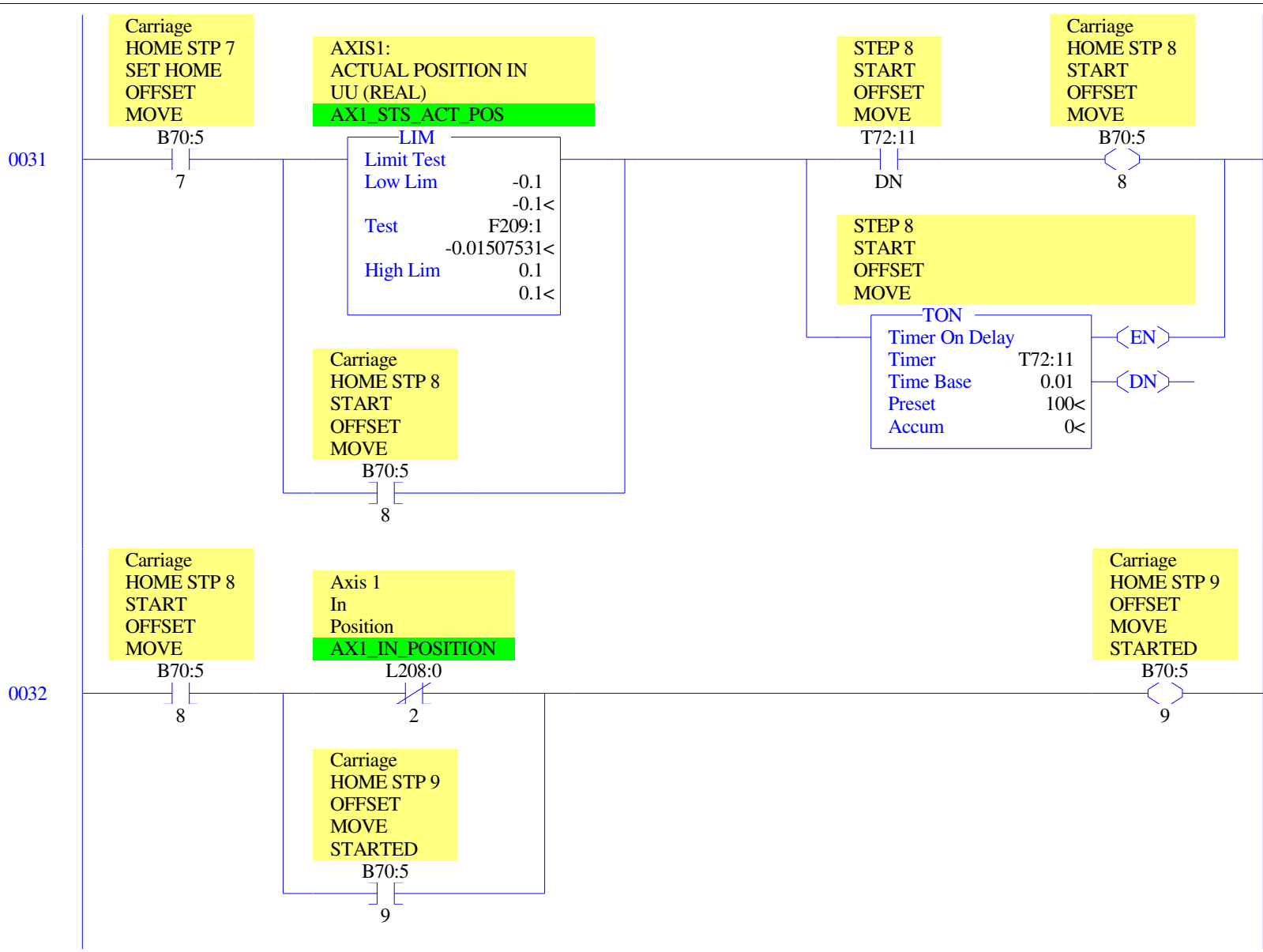
Carriage
Extend
Distance

ADD	
Add	
Source A	F74:5 -40.0<
Source B	F74:9 0.0<
Dest	F74:3 -40.0<

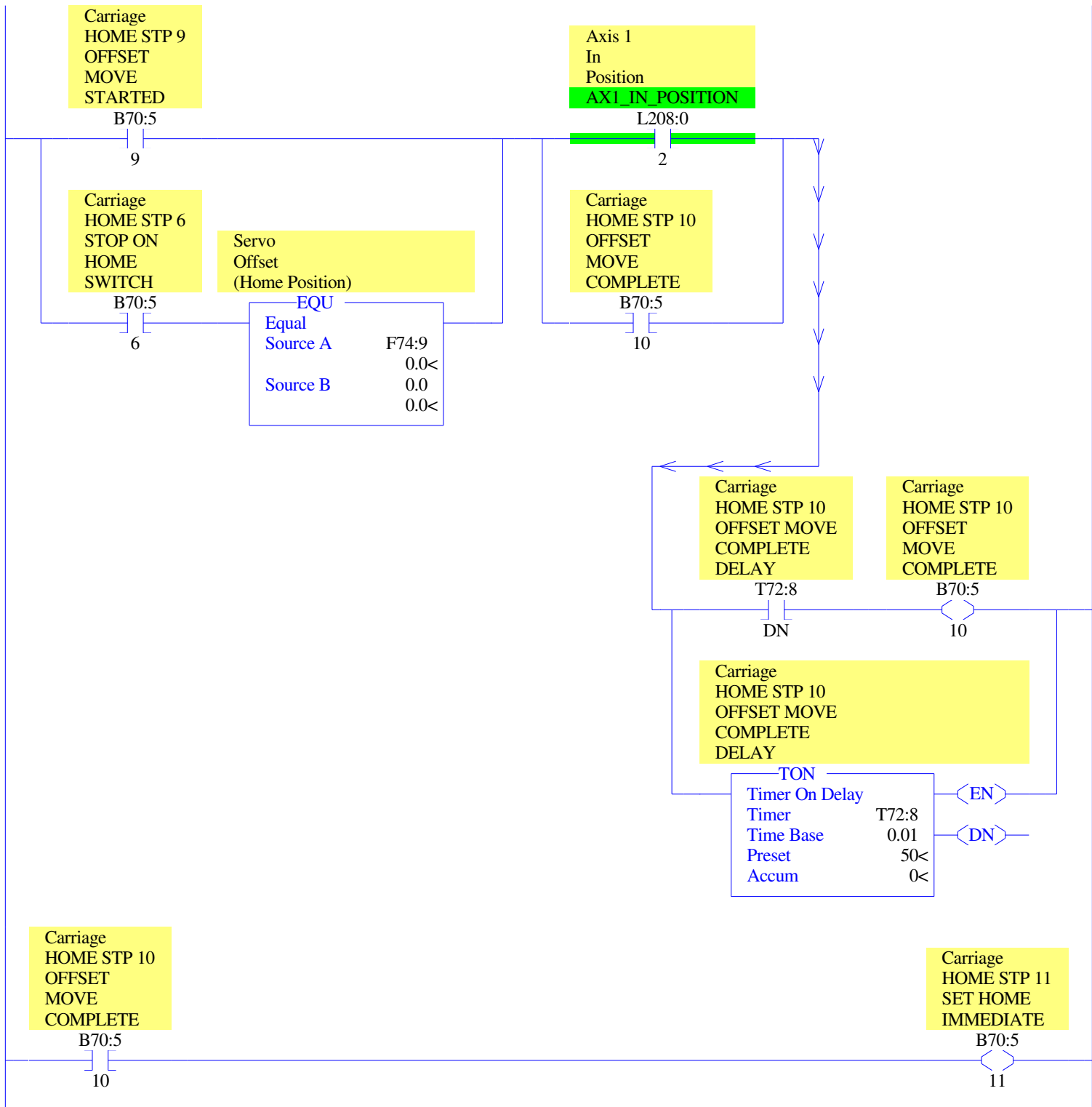








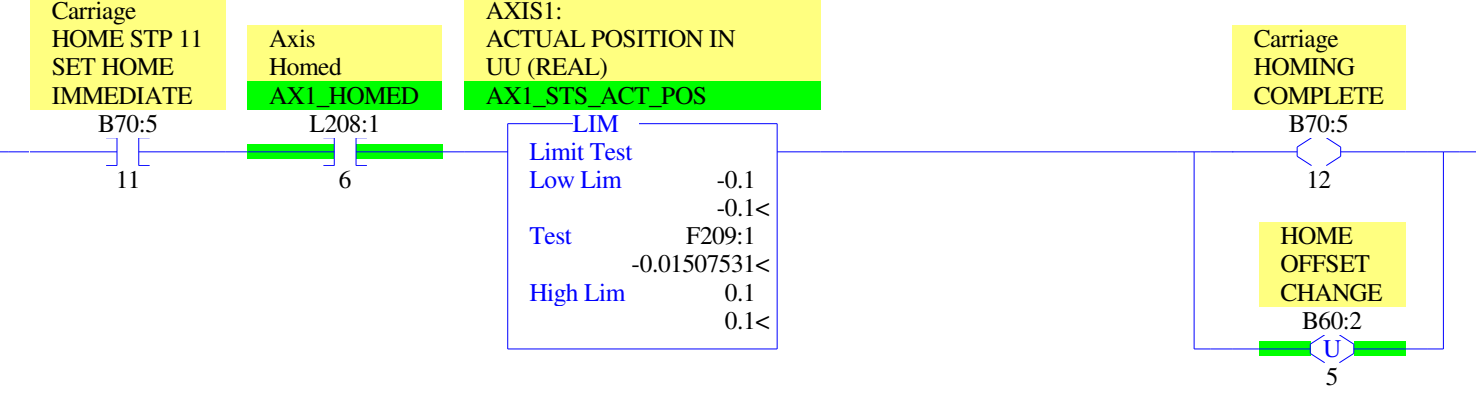
0033



0034

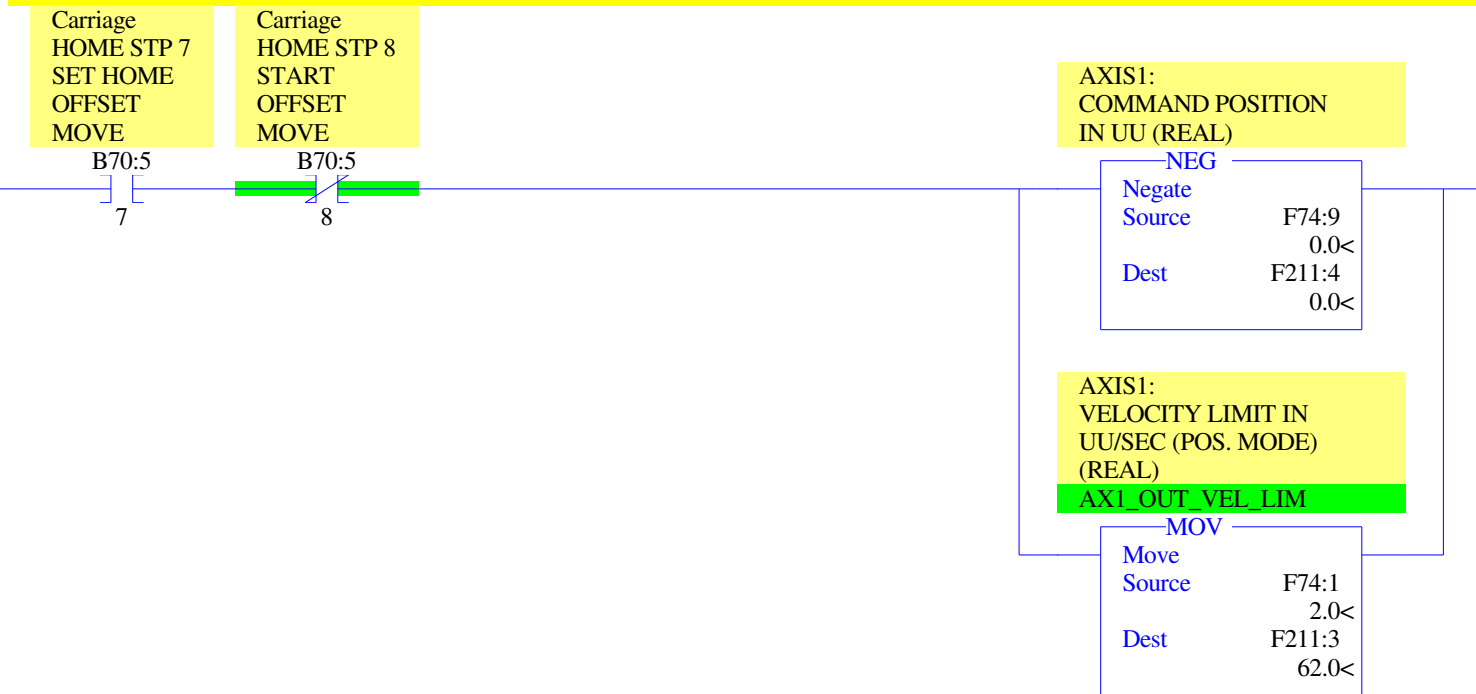
This rung Detects if there was a change in the Servo Offset Position. If there is then it will move the new setpoint and set the Flag to require a new home to take place.

0035

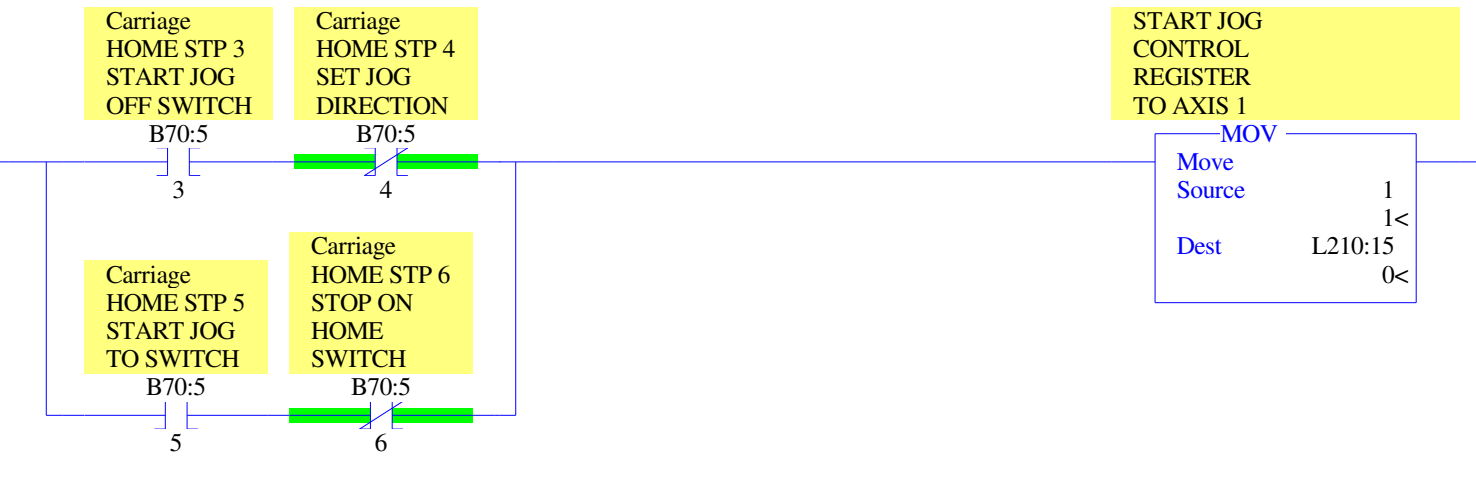


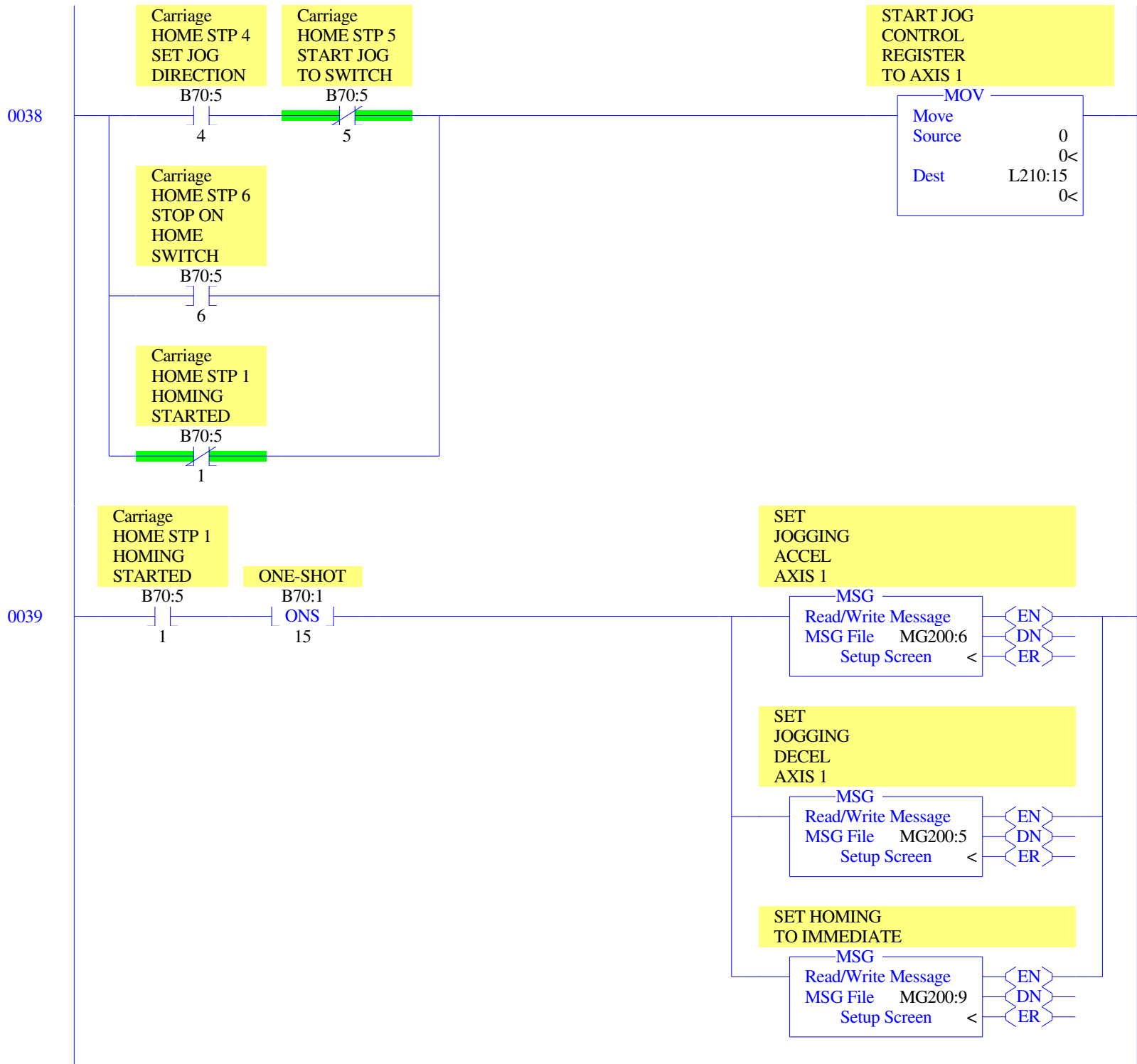
Homing - Output Requests

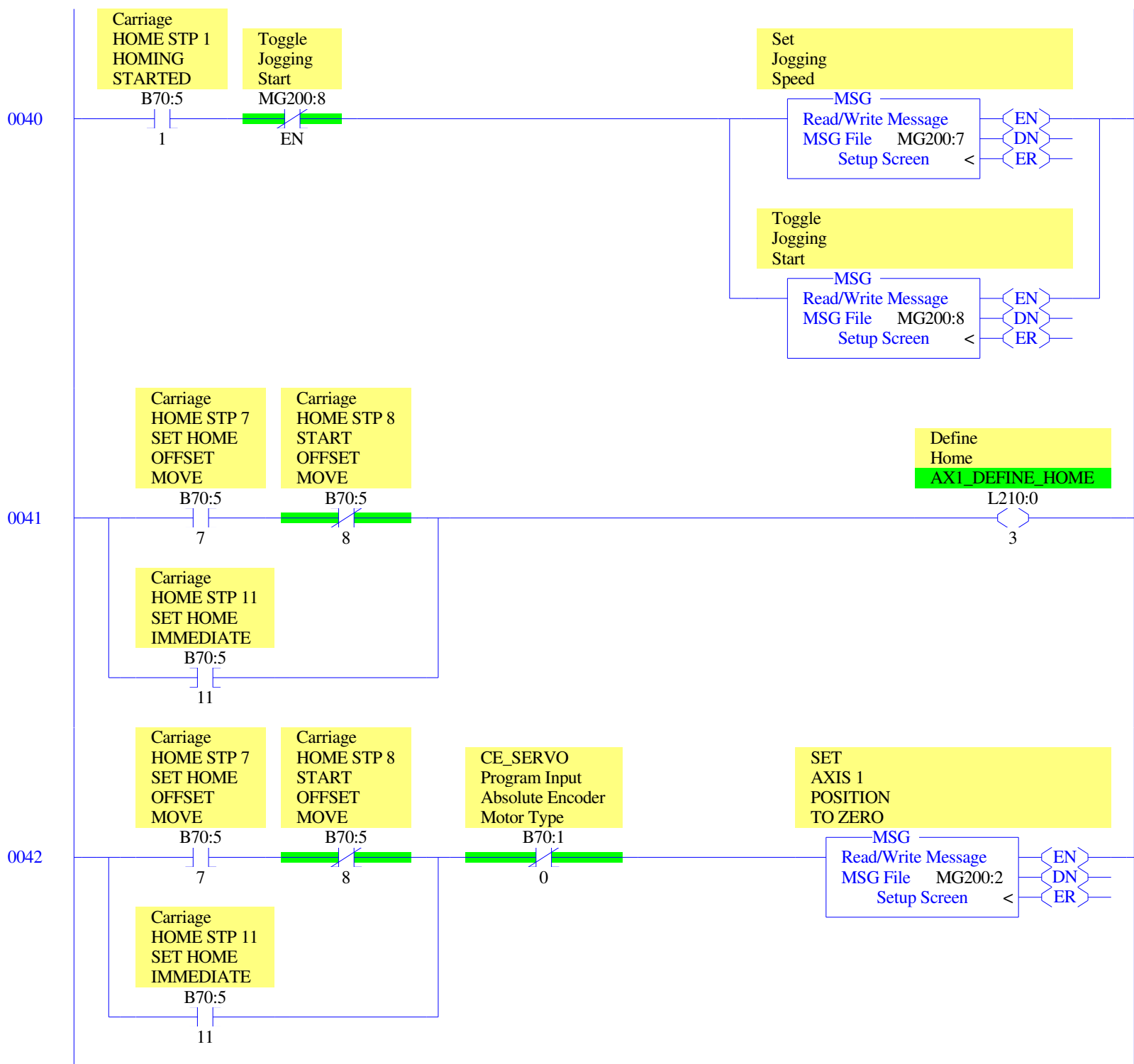
0036



0037







CE Servo - Motion Program

AXIS 1: DRIVE ENABLE

CE_SERVO
Program Input
MCR Status

B70:0

0

Software
Enable
Delay

T72:5

DN

AXIS1:
DRIVE ENABLE

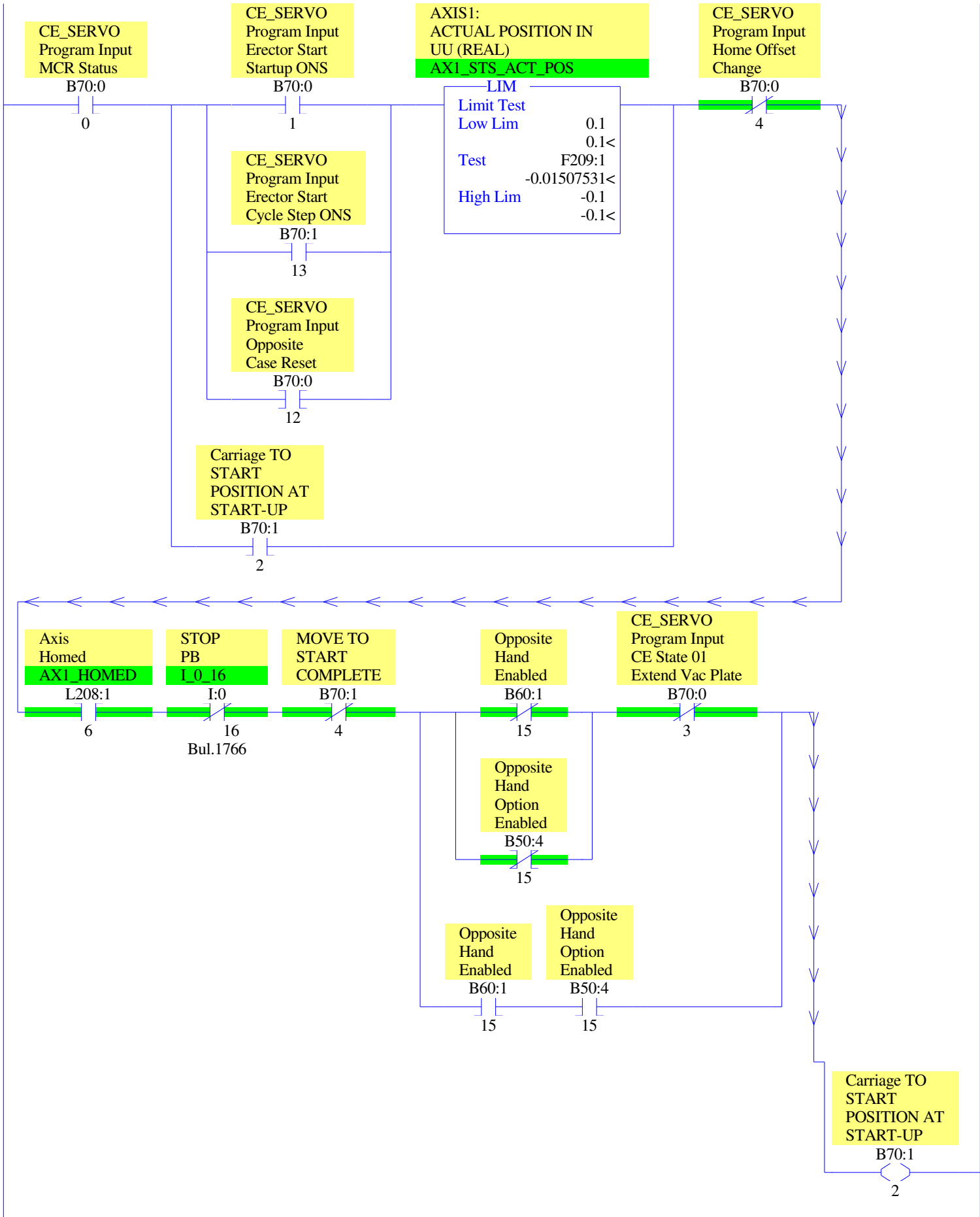
AXI_OUT_DRIVE_EN

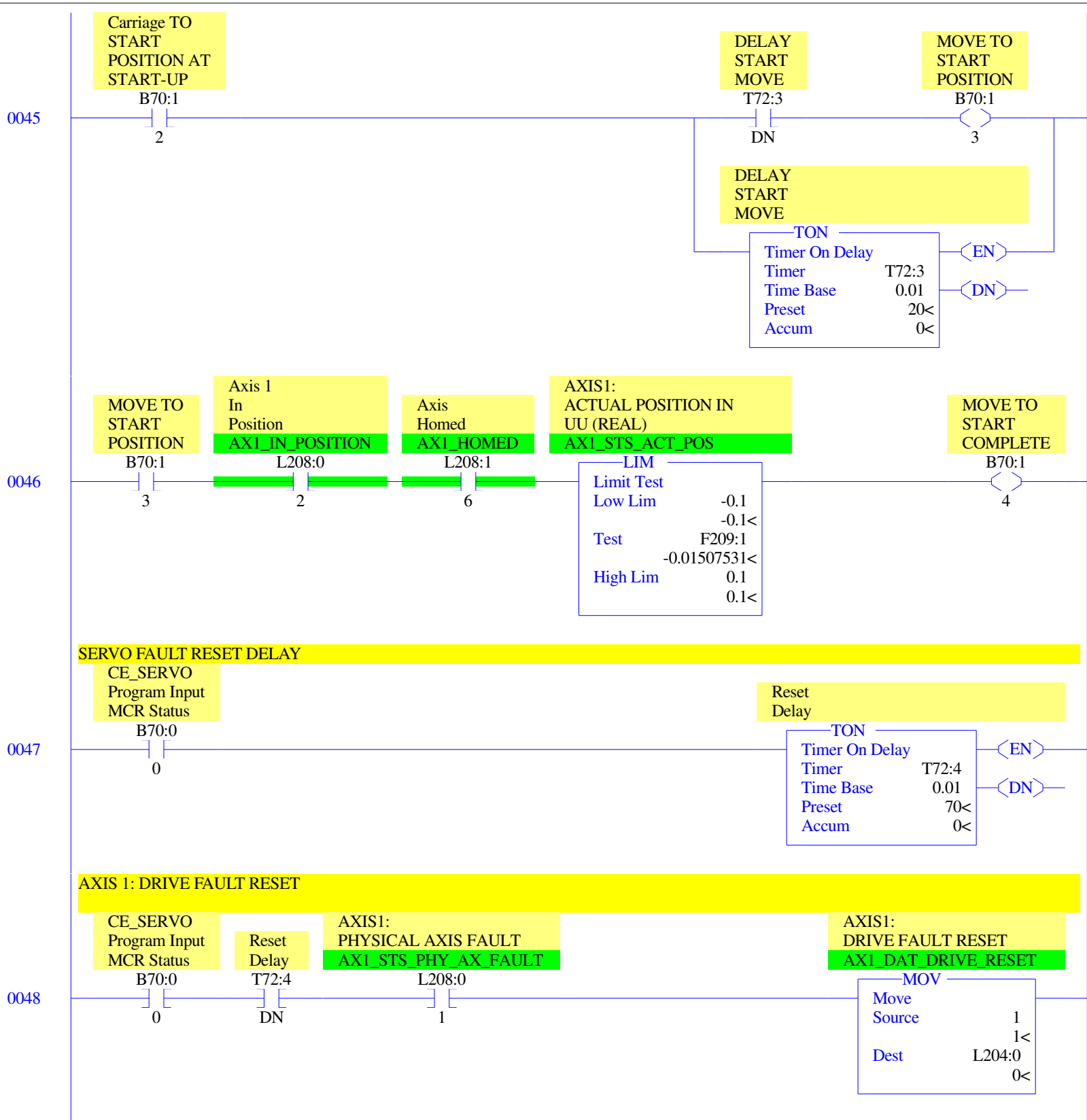
L210:0

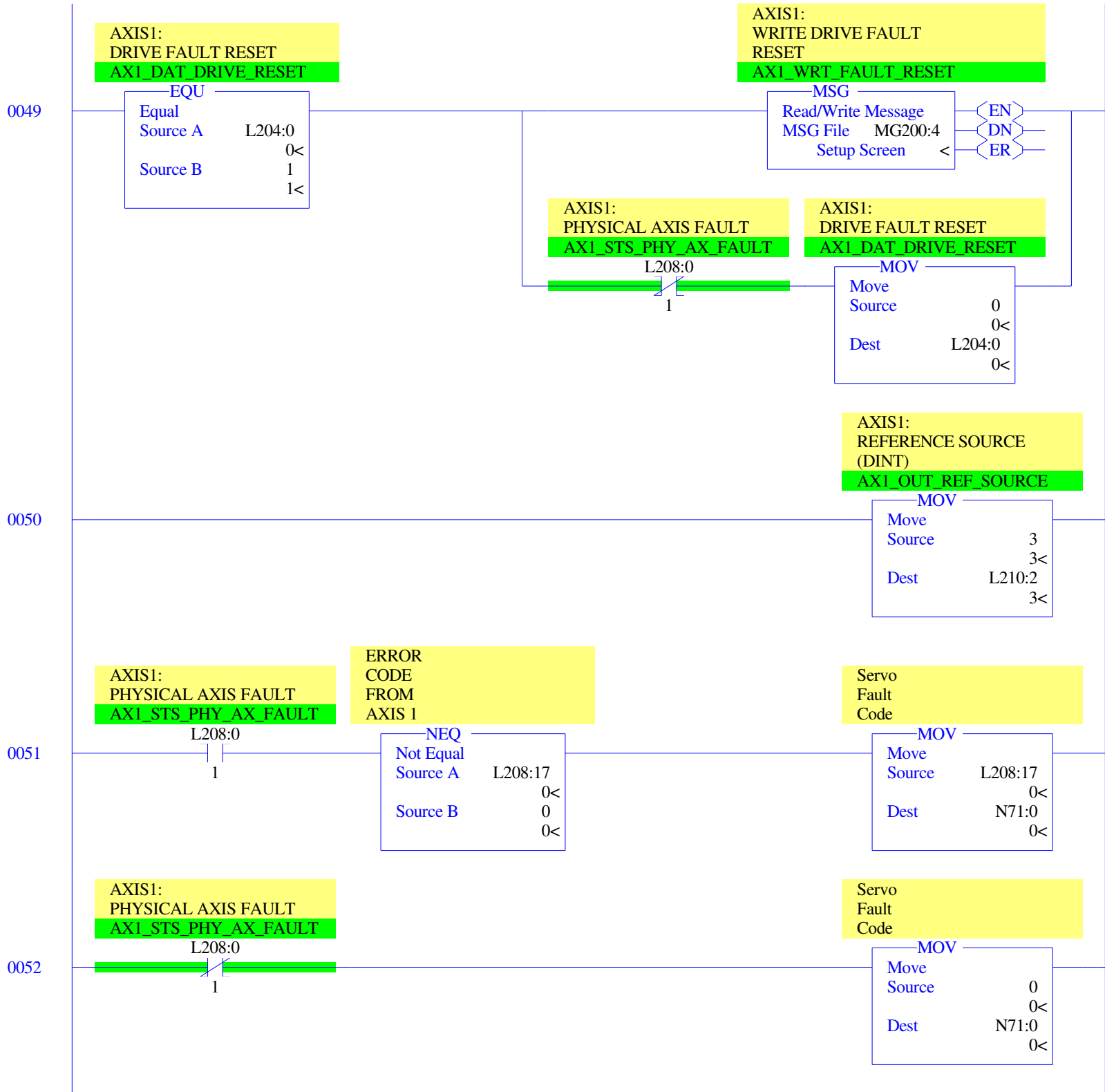
7

0043

0044







0053

CE_SERVO
Program Input
Pre-Move
REQ

B70:0

11

Opposite
Hand
Enabled

B60:1

15

AXIS1:
COMMAND POSITION
IN UU (REAL)

SUB

Subtract

Source A	1.75
	1.75<
Source B	F74:15
	9.0<
Dest	F211:4
	0.0<

Opposite
Hand
Enabled

B60:1

15

AXIS1:
COMMAND POSITION
IN UU (REAL)

SUB

Subtract

Source A	1.75
	1.75<
Source B	F74:17
	0.0<
Dest	F211:4
	0.0<

AXIS1:
VELOCITY LIMIT IN
UU/SEC (POS. MODE)
(REAL)

AX1_OUT_VEL_LIM

MOV

Move

Source	F74:16
	10.0<
Dest	F211:3
	62.0<

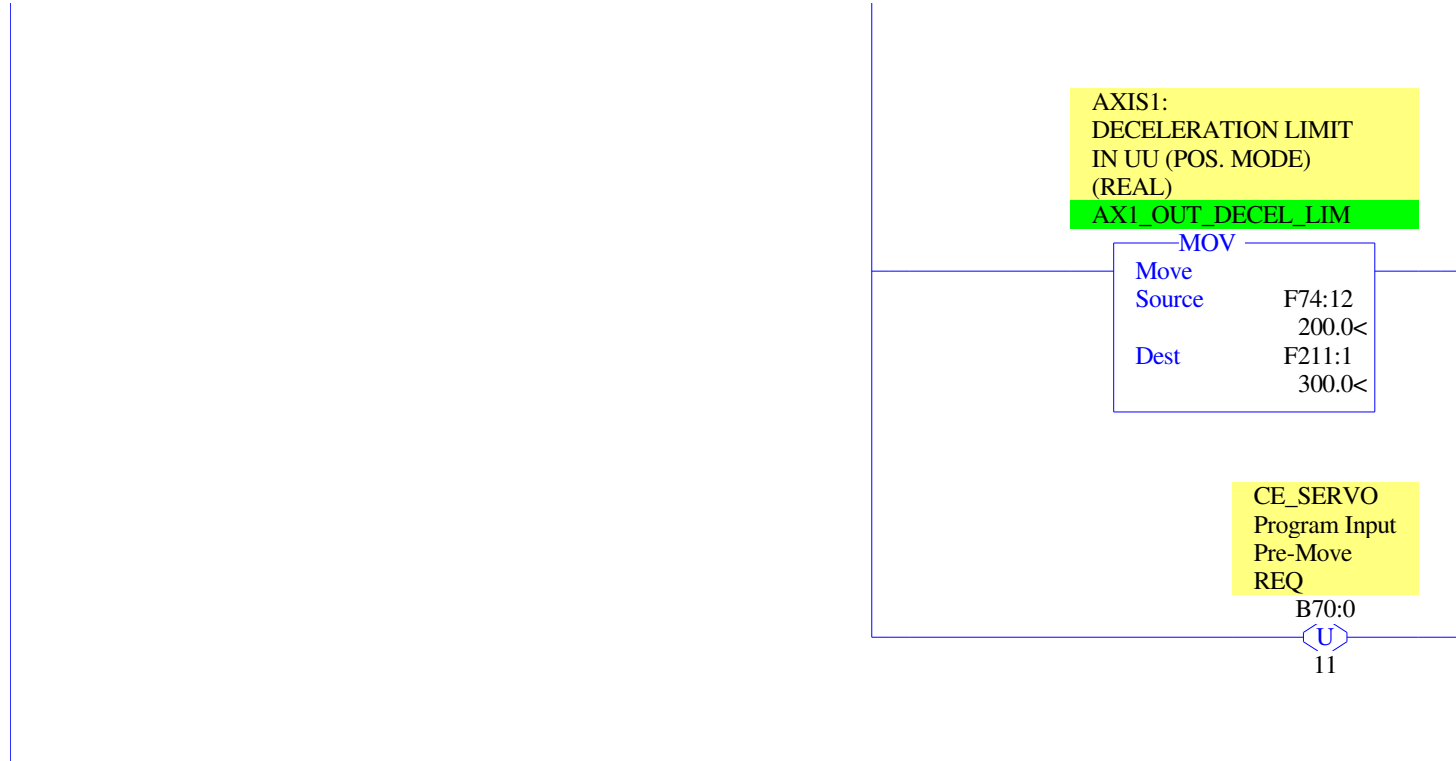
AXIS1:
ACCELERATION LIMIT
IN UU (POS. MODE)
(REAL)

AX1_OUT_ACCEL_LIM

MOV

Move

Source	F74:12
	200.0<
Dest	F211:0
	300.0<



0054

CE_SERVO
Program Input
Extend Move
REQ

B70:0

8

AXIS1:
COMMAND POSITION
IN UU (REAL)

MOV

Move
Source F74:3
-40.0<
Dest F211:4
0.0<

AXIS1:
VELOCITY LIMIT IN
UU/SEC (POS. MODE)
(REAL)

AXI_OUT_VEL_LIM

MOV

Move
Source F74:2
42.0<
Dest F211:3
62.0<

AXIS1:
ACCELERATION LIMIT
IN UU (POS. MODE)
(REAL)

AXI_OUT_ACCEL_LIM

MOV

Move
Source F74:12
200.0<
Dest F211:0
300.0<

AXIS1:
DECELERATION LIMIT
IN UU (POS. MODE)
(REAL)

AXI_OUT_DECEL_LIM

MOV

Move
Source F74:12
200.0<
Dest F211:1
300.0<

0055

Carriage TO
START
POSITION AT
START-UP

B70:1
2

MOVE TO
START
POSITION

B70:1
3

CE_SERVO
Program Input
Retract Move
REQ

B70:0
9

AXIS1:
COMMAND POSITION
IN UU (REAL)

MOV
Move
Source 0.0
0.0<
Dest F211:4
0.0<

AXIS1:
VELOCITY LIMIT IN
UU/SEC (POS. MODE)
(REAL)

AX1_OUT_VEL_LIM
MOV
Move
Source F74:11
62.0<
Dest F211:3
62.0<

AXIS1:
ACCELERATION LIMIT
IN UU (POS. MODE)
(REAL)

AX1_OUT_ACCEL_LIM
MOV
Move
Source F74:13
300.0<
Dest F211:0
300.0<

AXIS1:
DECELERATION LIMIT
IN UU (POS. MODE)
(REAL)

AX1_OUT_DECEL_LIM
MOV
Move
Source F74:13
300.0<
Dest F211:1
300.0<

CE Servo - Drive Communications and Monitoring

AXIS1: READ INPUT ASSEMBLY

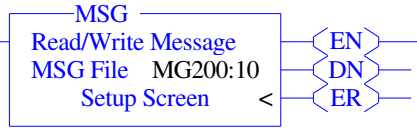
THE INPUT ASSEMBLY IS IDENTIFIED BY INSTANCE 113 AND CONSISTS OF 64 BYTES

AXIS1:
READ INPUT ASSEMBLY
OBJECT

AX1_READ_IN_ASSBLY



READ
AXIS 1
FAULT CODE



0056

AXIS1: READ INPUT ASSEMBLY

AFTER THE INPUT ASSEMBLY IS READ THE REAL VALUES ARE THEN COPIED TO A FLOAT DATA FILE.
ALSO, A TIMER (OPTIONAL) WAS ADDED TO CONTROL THE ASSEMBLY READ RATE (0 - CONTINUOUS READ, IS THE DEFAULT).

IF THE READ INPUT ASSEMBLY MESSAGE ERRORS OUT, CONTINUE TO TRY TO EXECUTE MESSAGE INSTRUCTION.

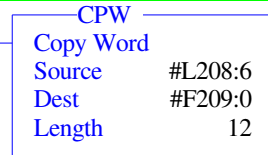
AXIS1:
READ INPUT ASSEMBLY
OBJECT
AXI_READ_IN_ASSBLY/DN



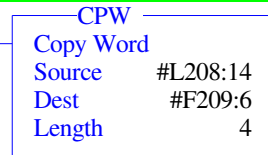
AXIS1:
READ INPUT ASSEMBLY
DELAY
TM_READ_INPUT_ASSBY/TT



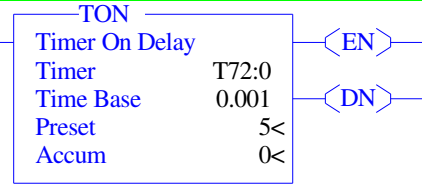
AXIS1:
ACTUAL VELOCITY IN
UU/MIN (REAL)
#AX1_STS_ACT_VEL



AXIS1:
DATA LINK C (REAL)
#AX1_STS_DATA_LINK_C



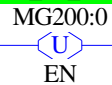
AXIS1:
READ INPUT ASSEMBLY
DELAY
TM_READ_INPUT_ASSBY



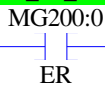
AXIS1:
READ INPUT ASSEMBLY
DELAY
TM_READ_INPUT_ASSBY/DN



AXIS1:
READ INPUT ASSEMBLY
OBJECT
AXI_READ_IN_ASSBLY/EN



AXIS1:
READ INPUT ASSEMBLY
OBJECT
AXI_READ_IN_ASSBLY/ER



READ
AXIS 1
FAULT CODE
MG200:10



0057

AXIS1: WRITE OUTPUT ASSEMBLY

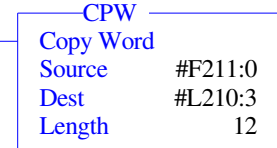
THE OUTPUT ASSEMBLY IS IDENTIFIED BY INSTANCE 114 AND CONSISTS OF 52 BYTES

BEFORE WRITING TO THE OUTPUT ASSEMBLY THE REAL VALUES ARE COPIED FROM A FLOAT DATA FILE TO THE LONG DATA FILE.

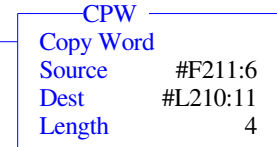
ALSO, A TIMER (OPTIONAL) WAS ADDED TO CONTROL THE ASSEMBLY WRITE RATE (0 - CONTINUOUS READ, IS THE DEFAULT)

IF THE WRITE OUTPUT ASSEMBLY MESSAGE ERRORS OUT, TRIGGER A COMMUNICATION LOSS FAULT, BUT CONTINUE TO TRY TO EXECUTE MESSAGE INSTRUCTION.

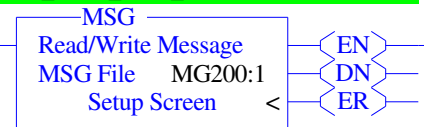
AXIS1:
ACCELERATION LIMIT
IN UU (POS. MODE)
(REAL)



AXIS1:
DATA LINK C (REAL)

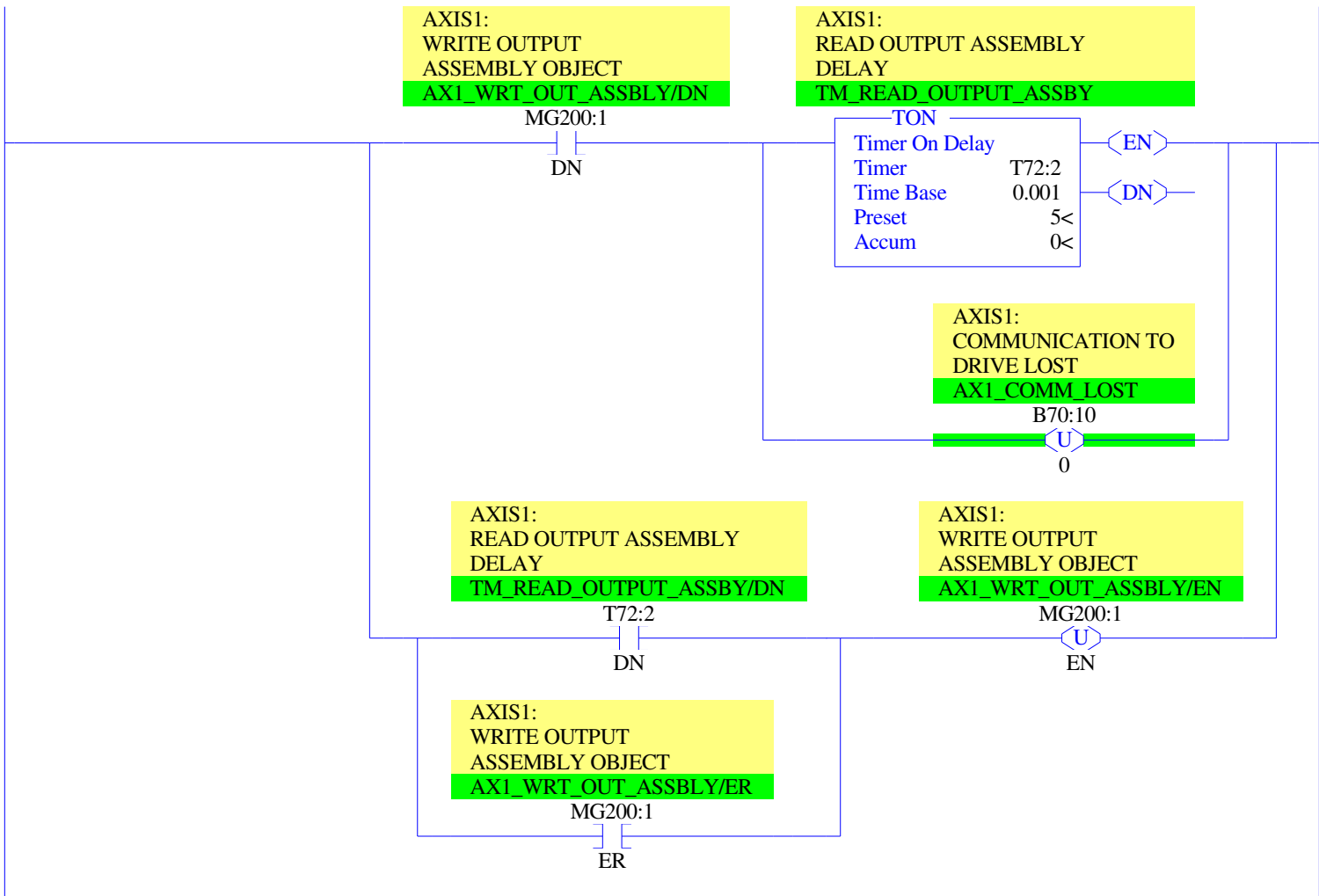


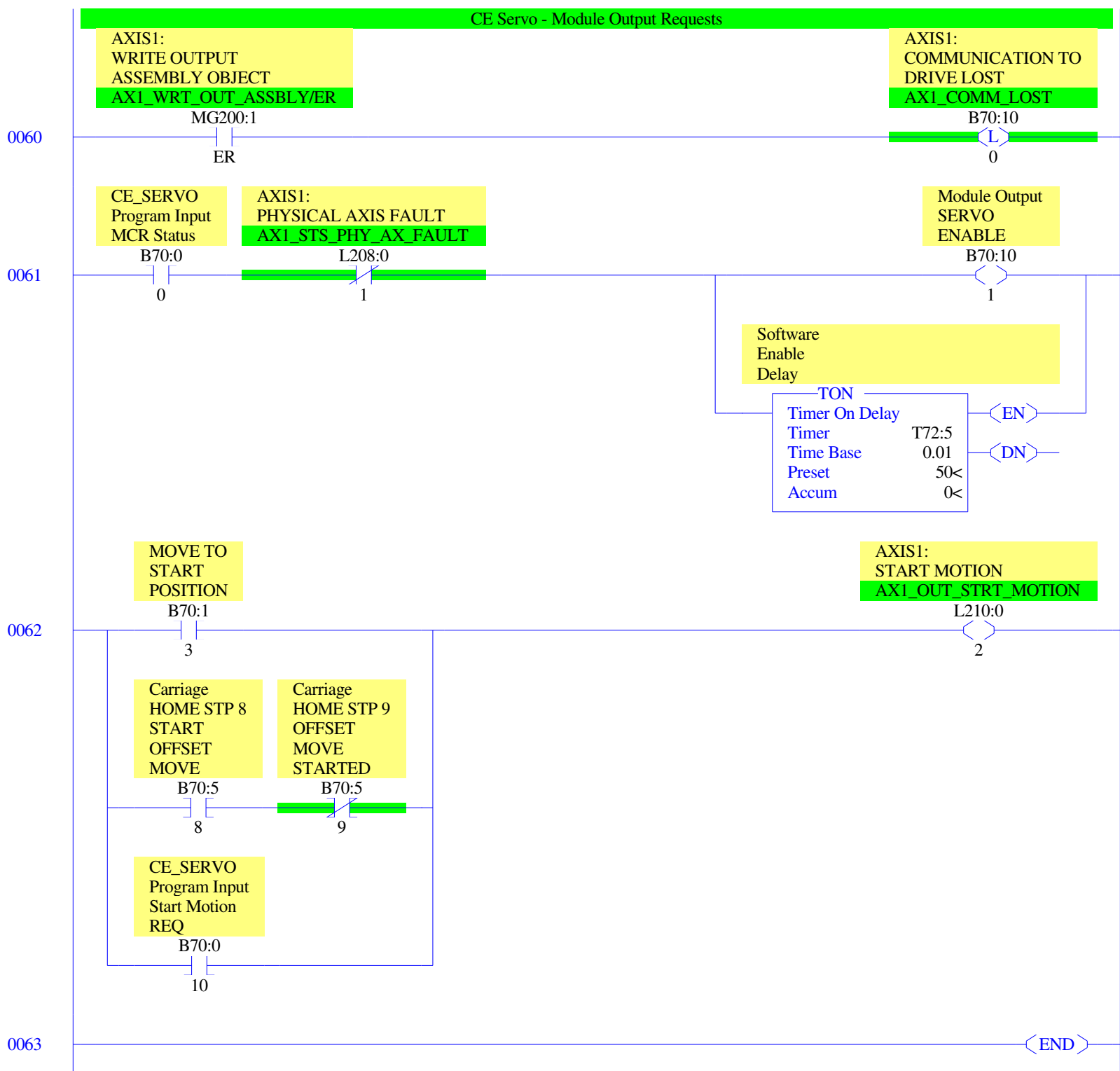
AXIS1:
WRITE OUTPUT
ASSEMBLY OBJECT
AX1_WRT_OUT_ASSBLY

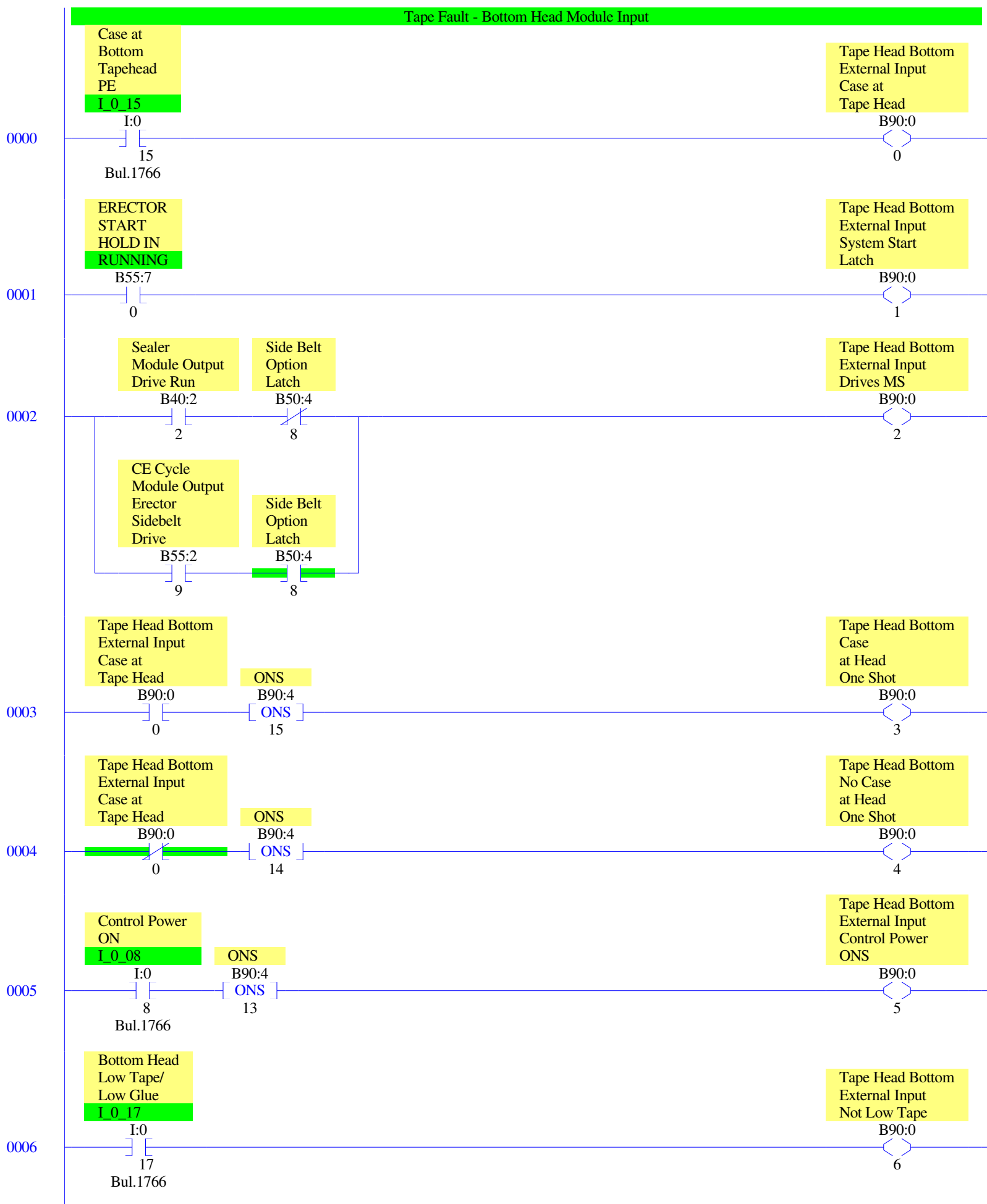


0058

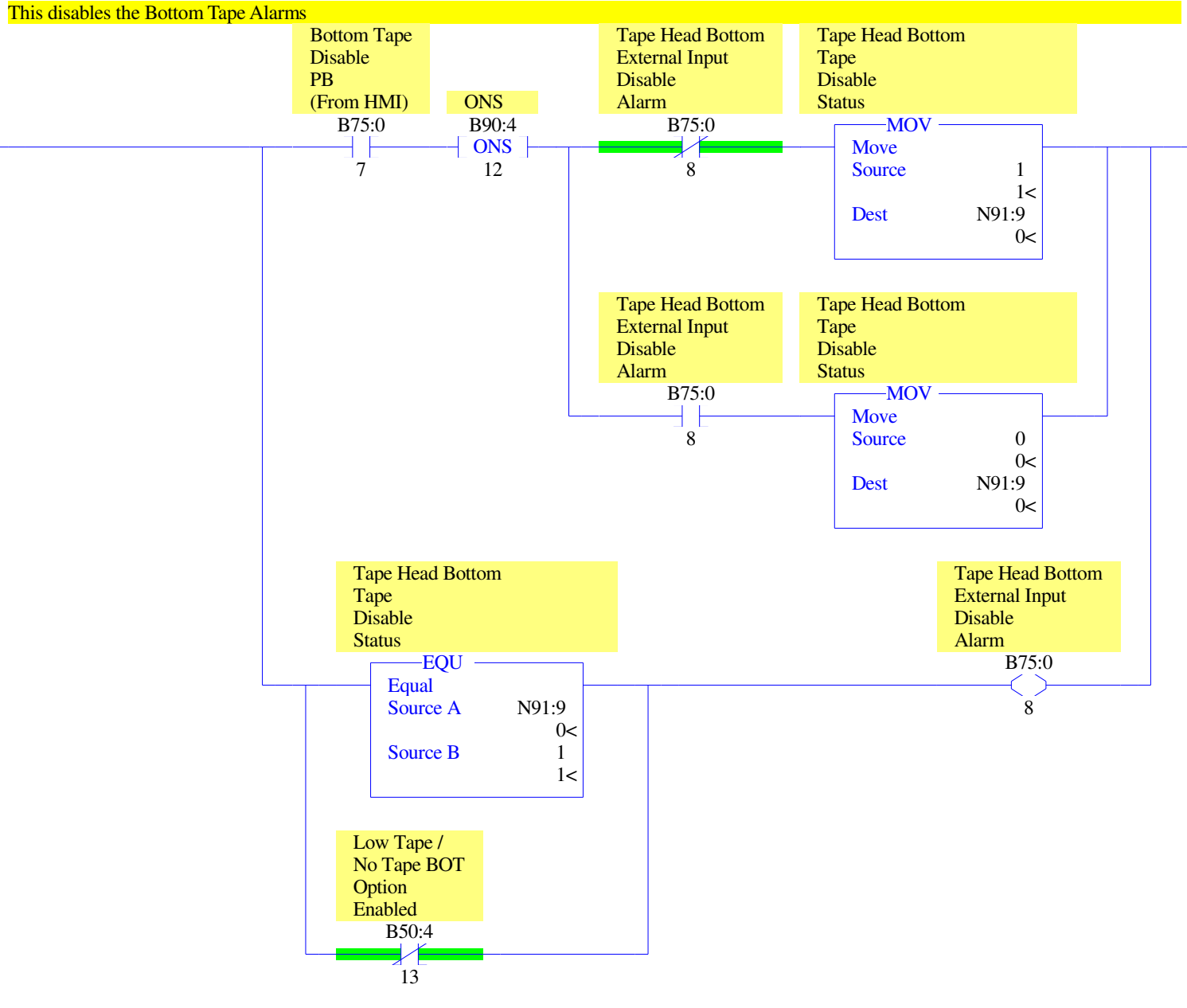
0059

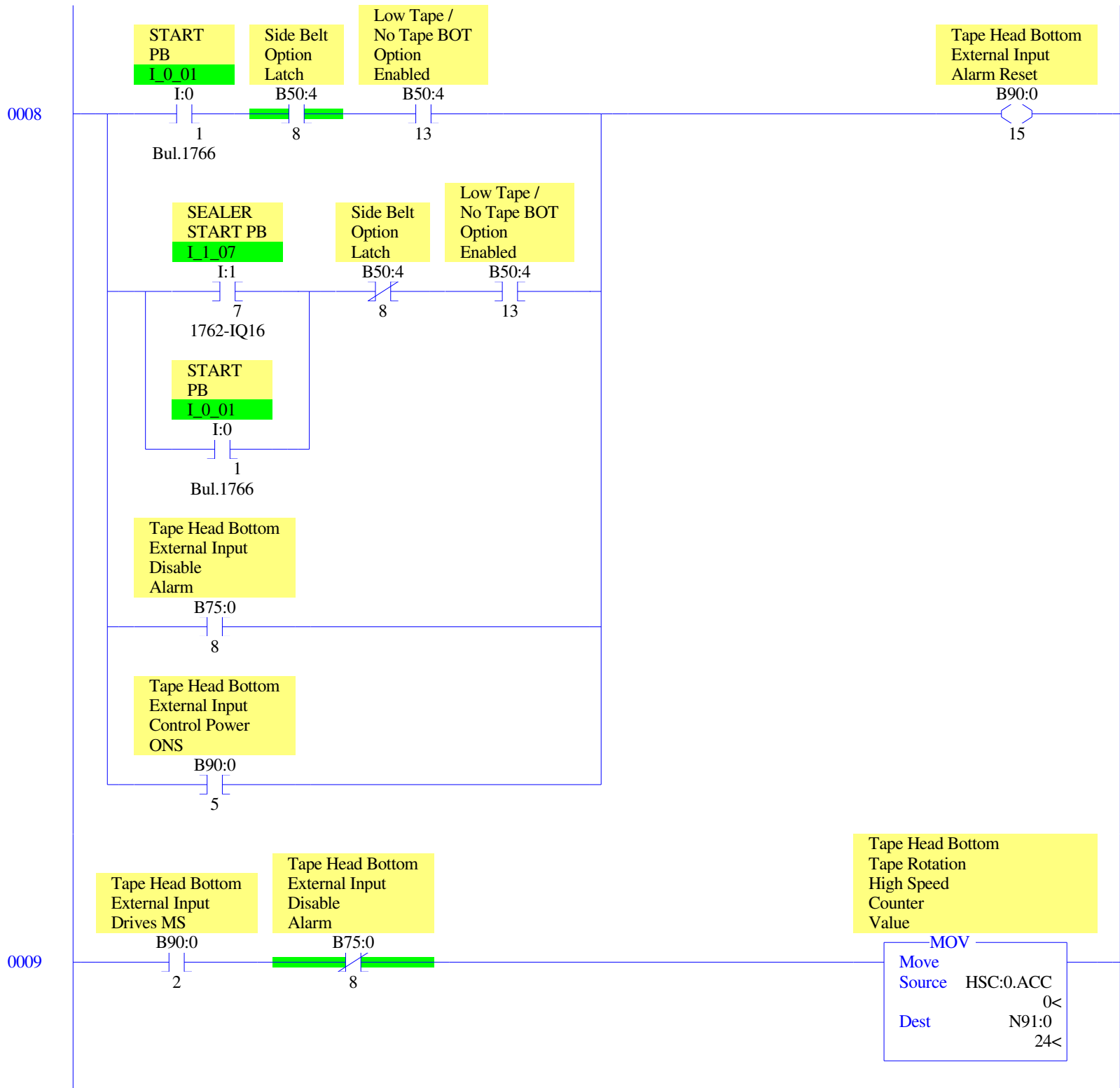






0007





0010

Tape Head Bottom
No Cut
Test
Duration Timer

T92:2

DN

Tape Head Bottom
External Input
Alarm Reset

B90:0

15

GRT

Greater Than (A>B)
Source A HSC:0.ACC 0<
Source B 32766 32766<

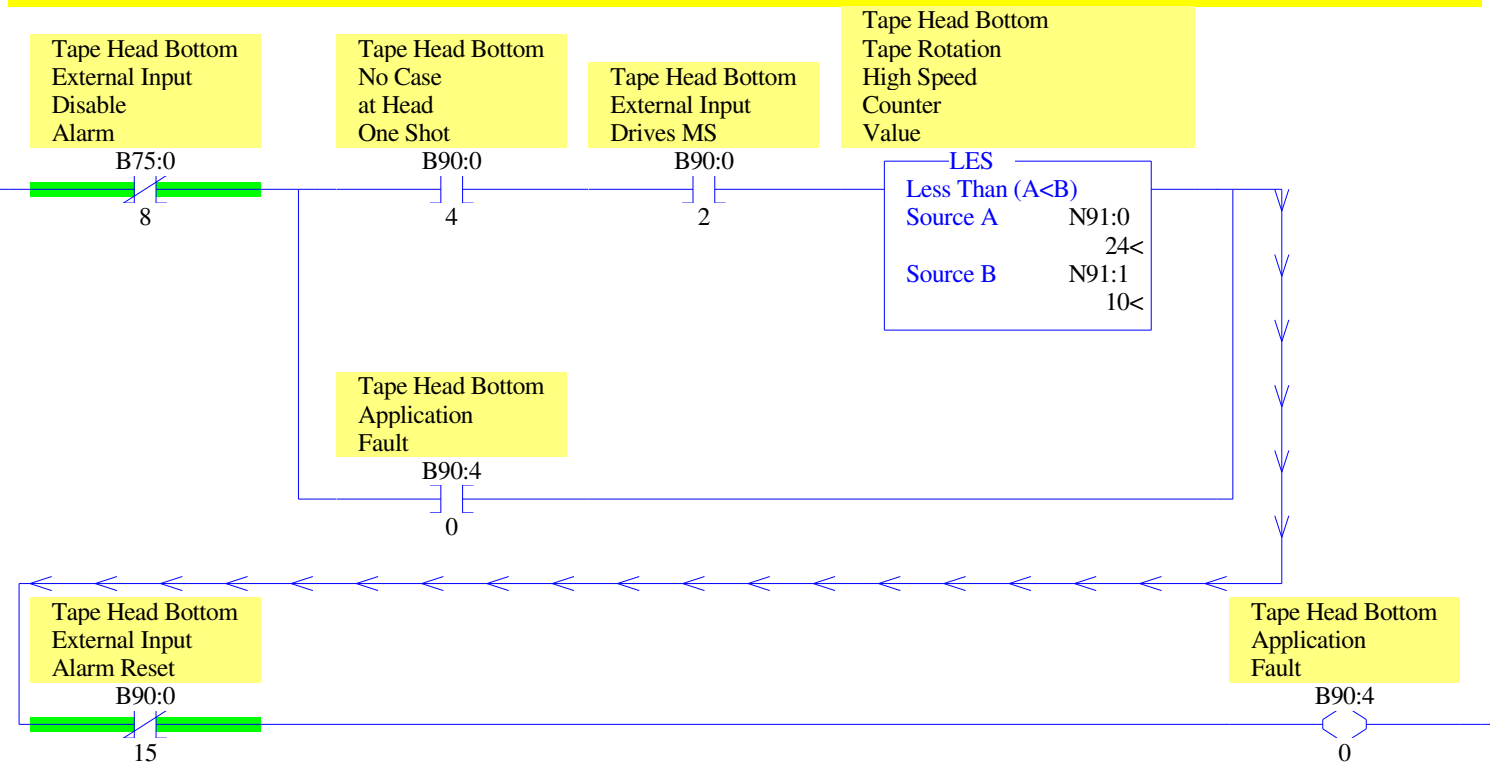
RAC

Reset Accumulated Value	HSC0
Counter	0
Source	

Tape Fault - Bottom Head Logic

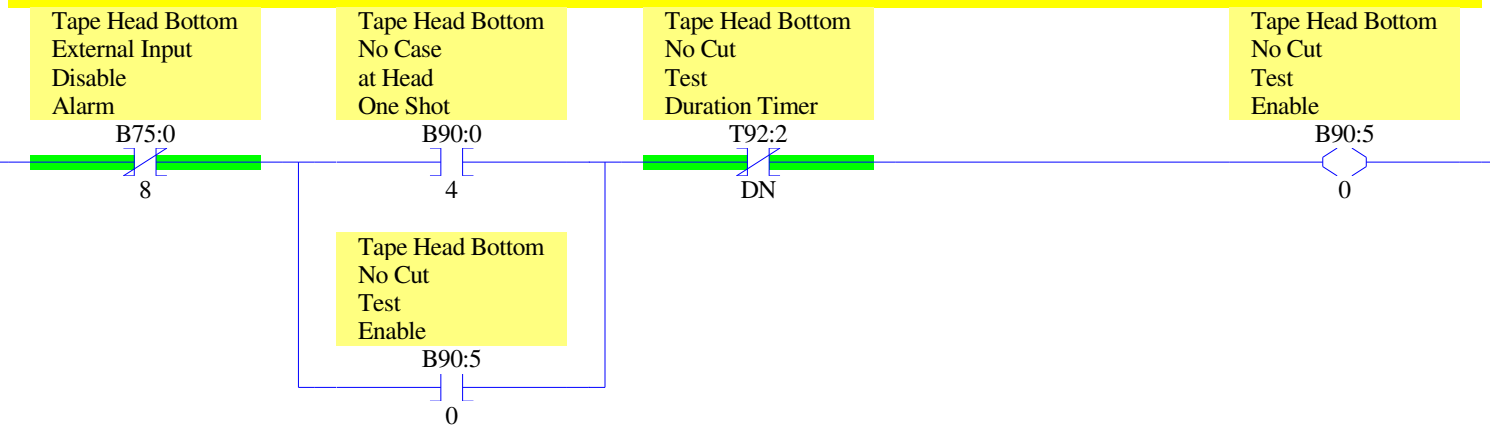
Tape Application Fault Logic

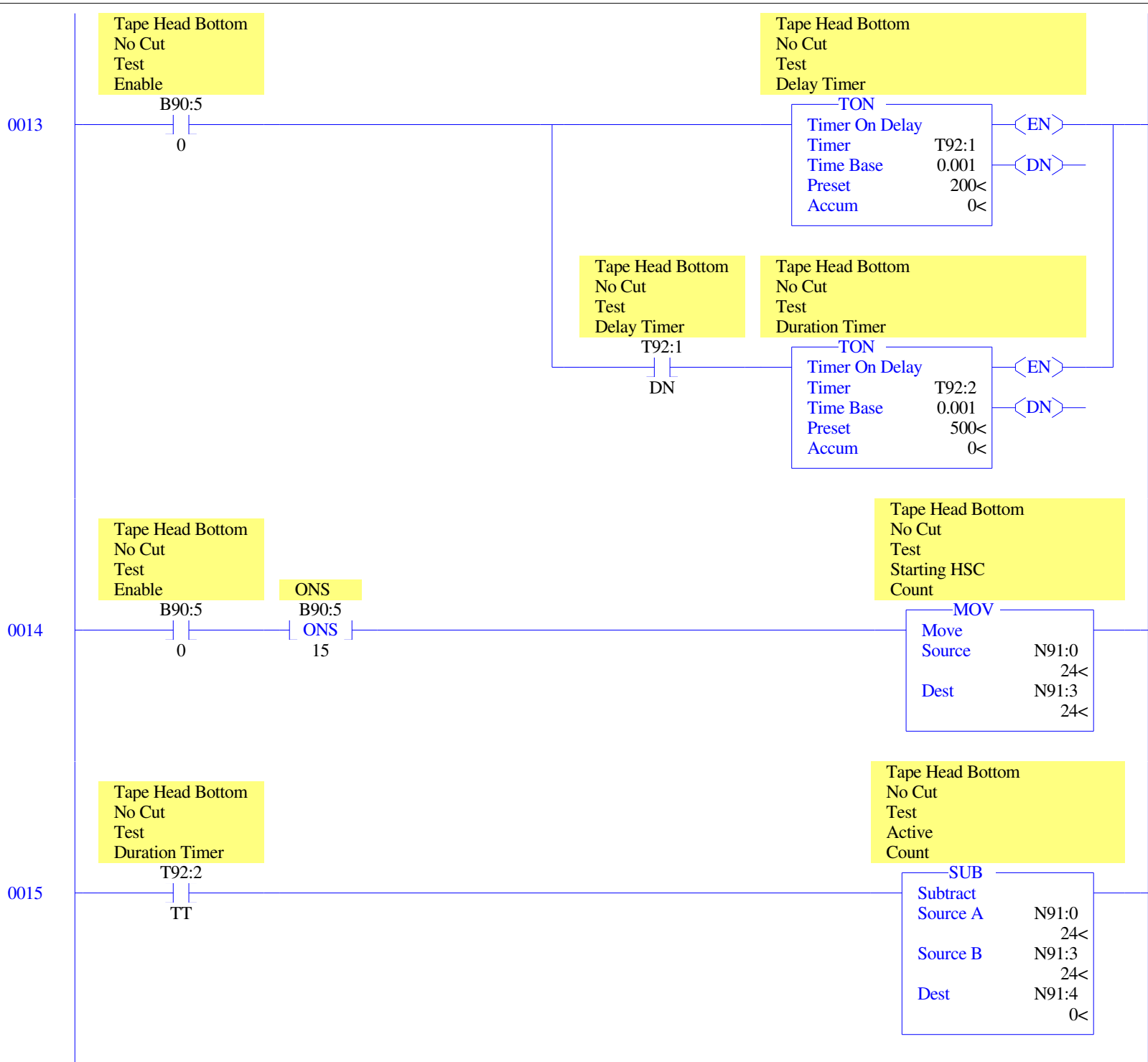
0011

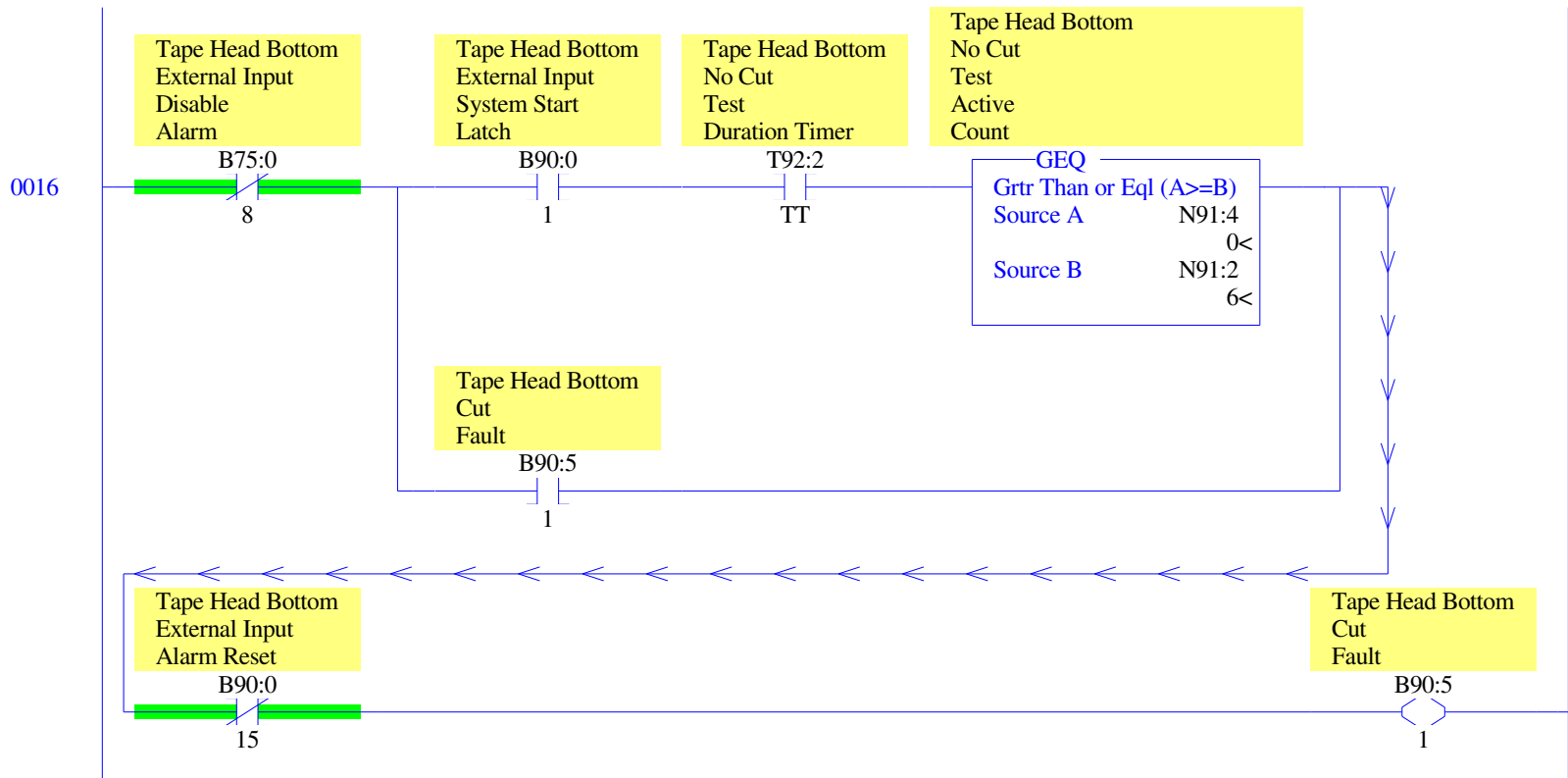


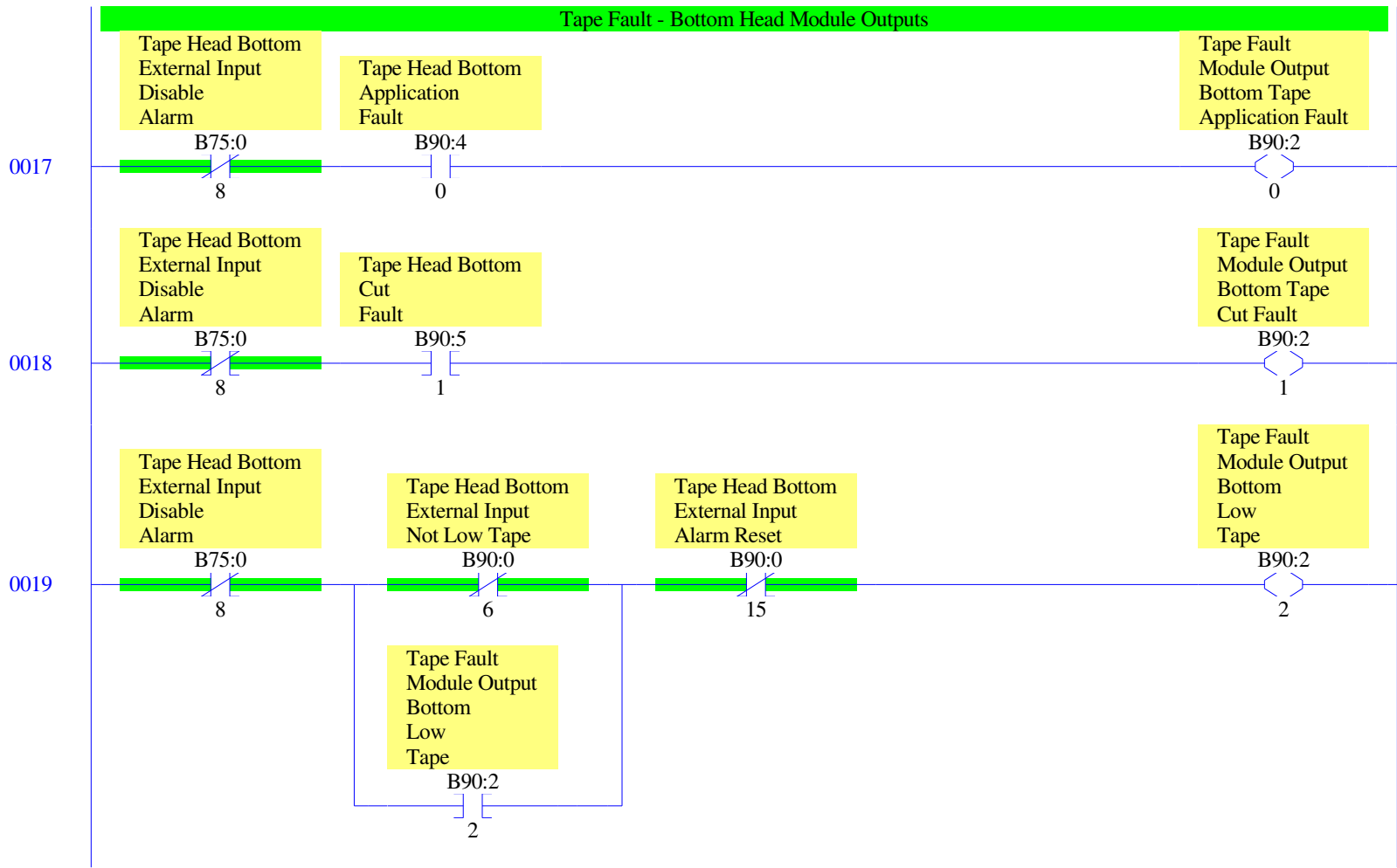
Tape Cut Fault Logic

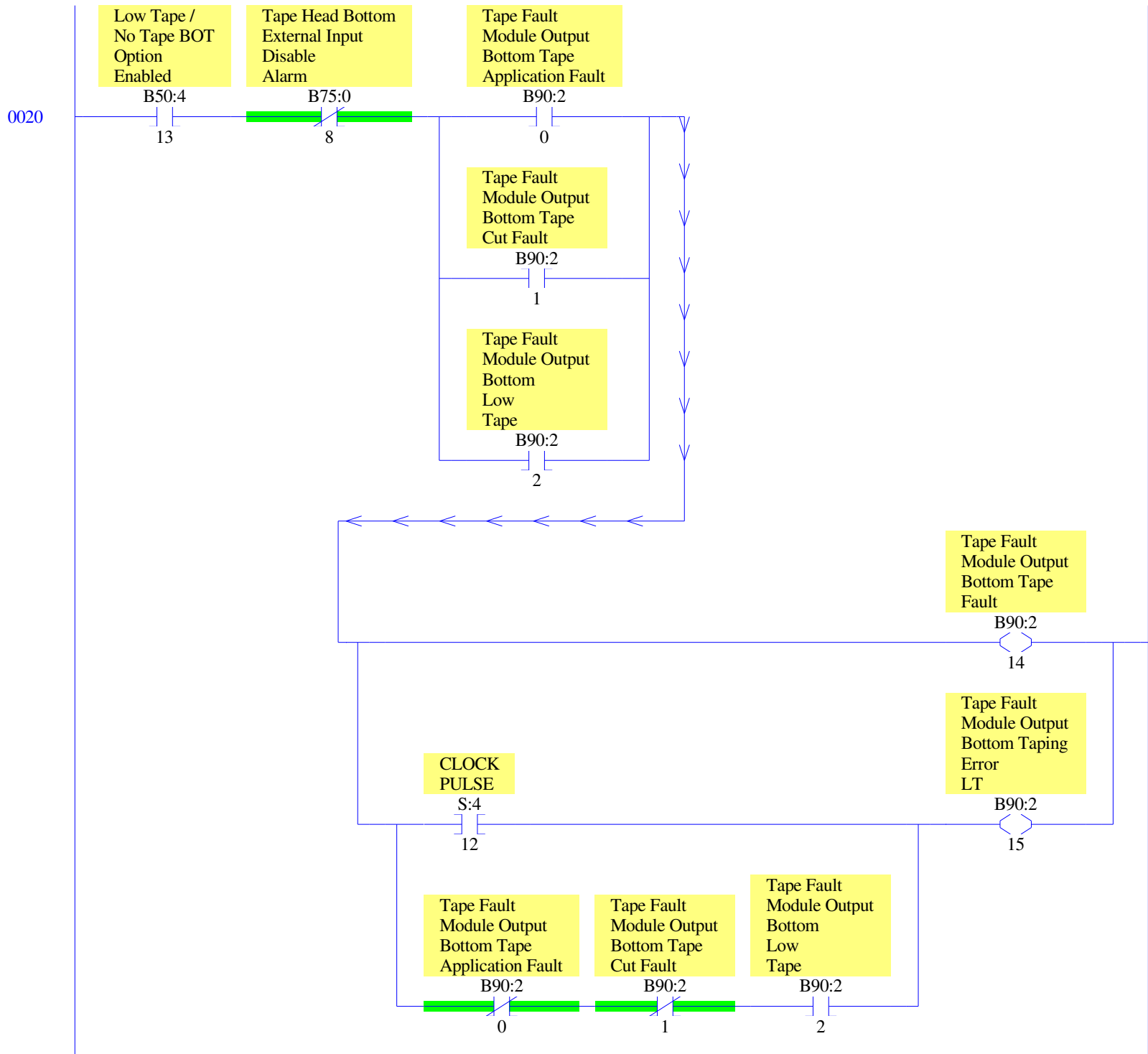
0012





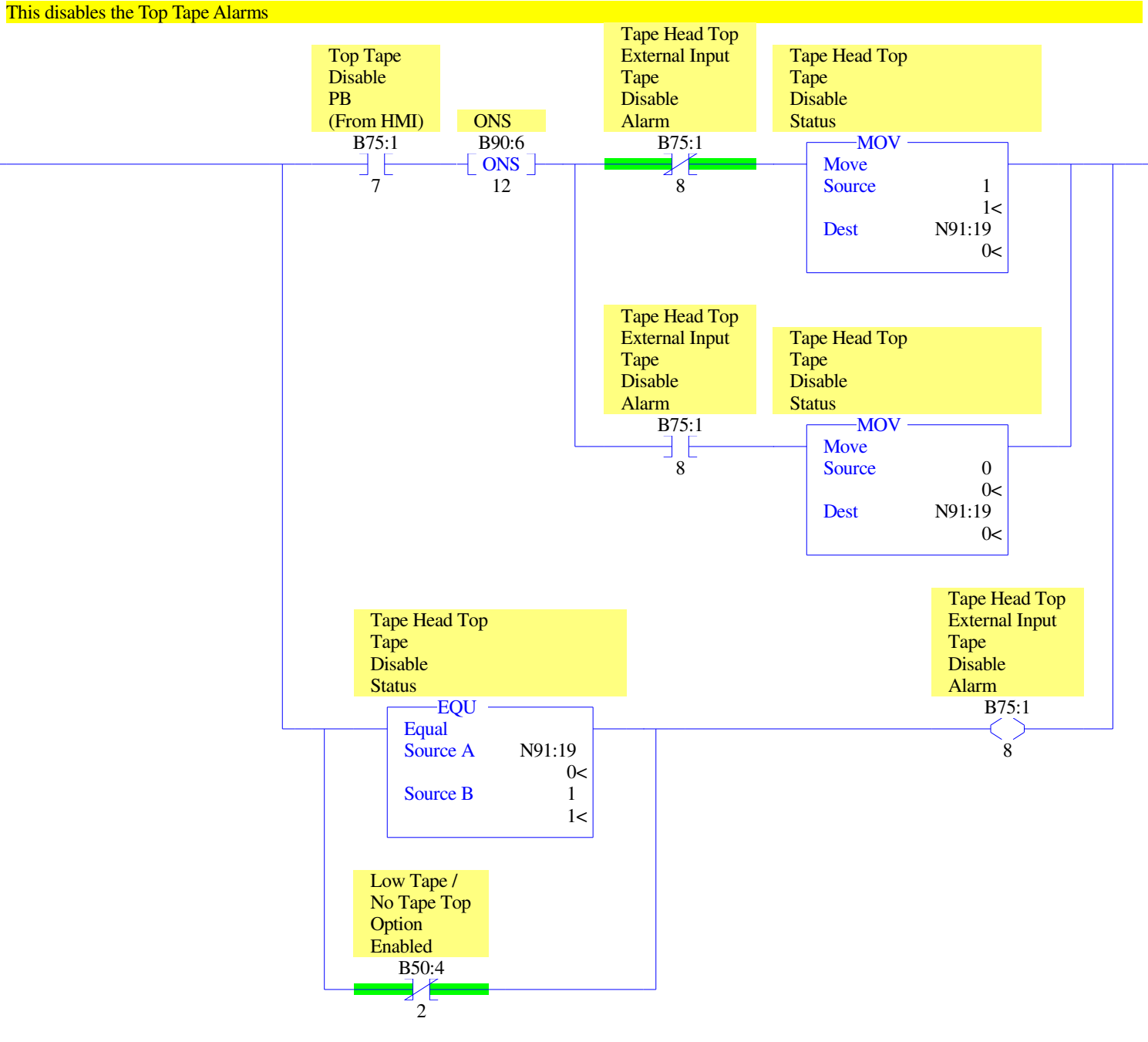


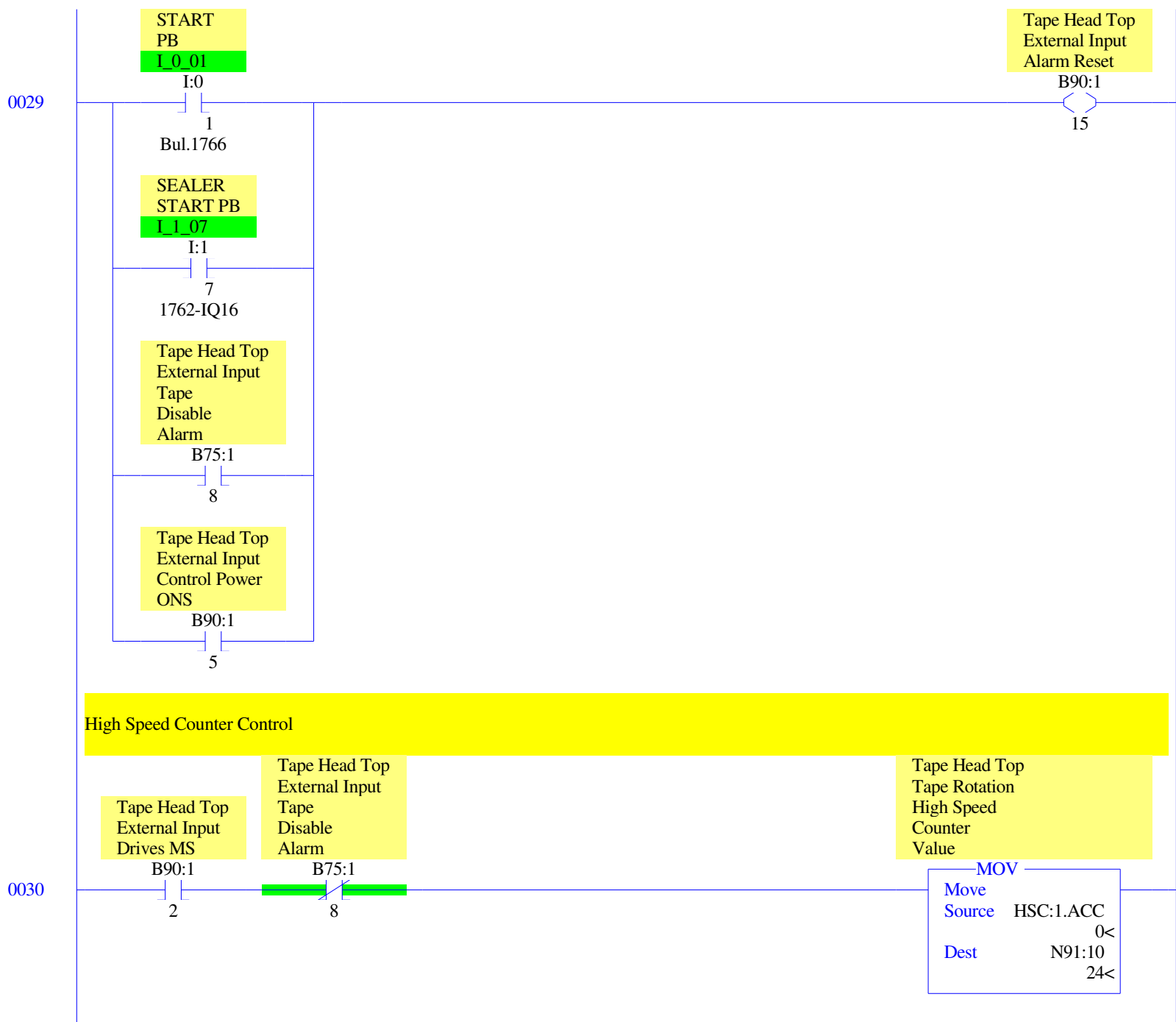


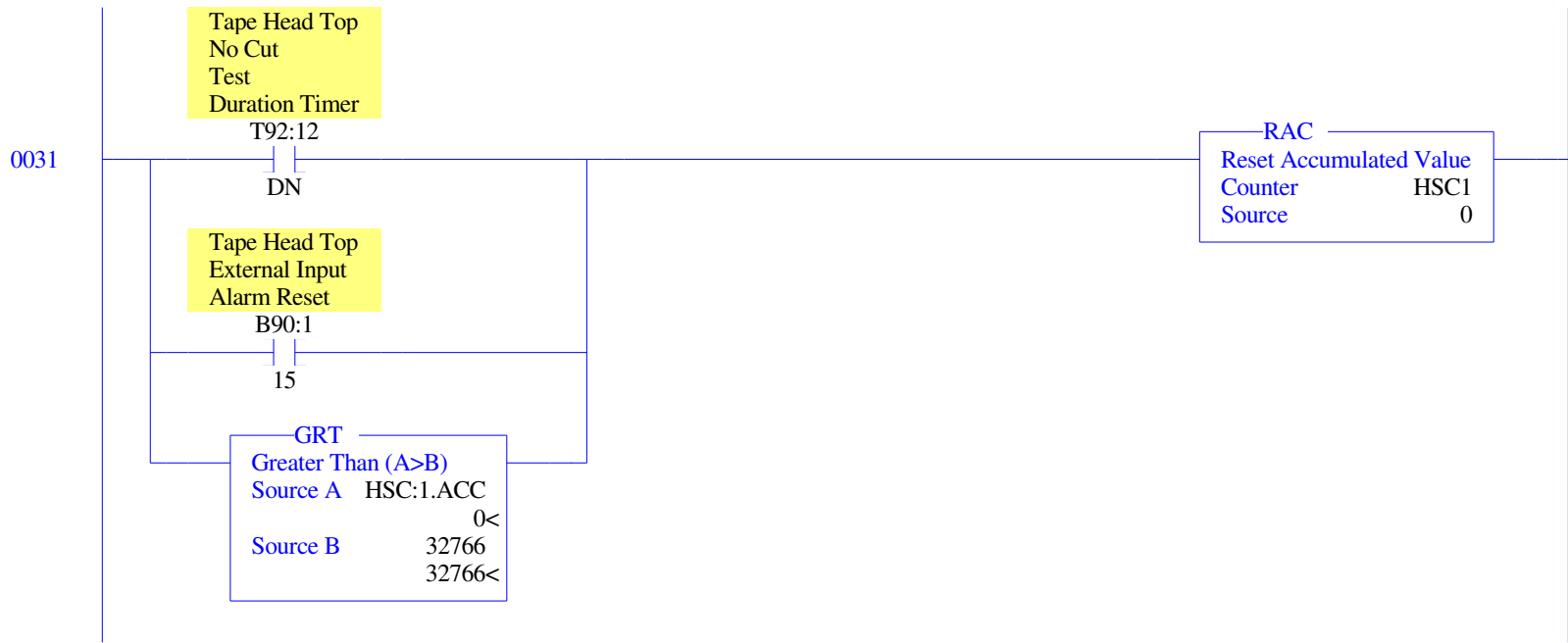




0028



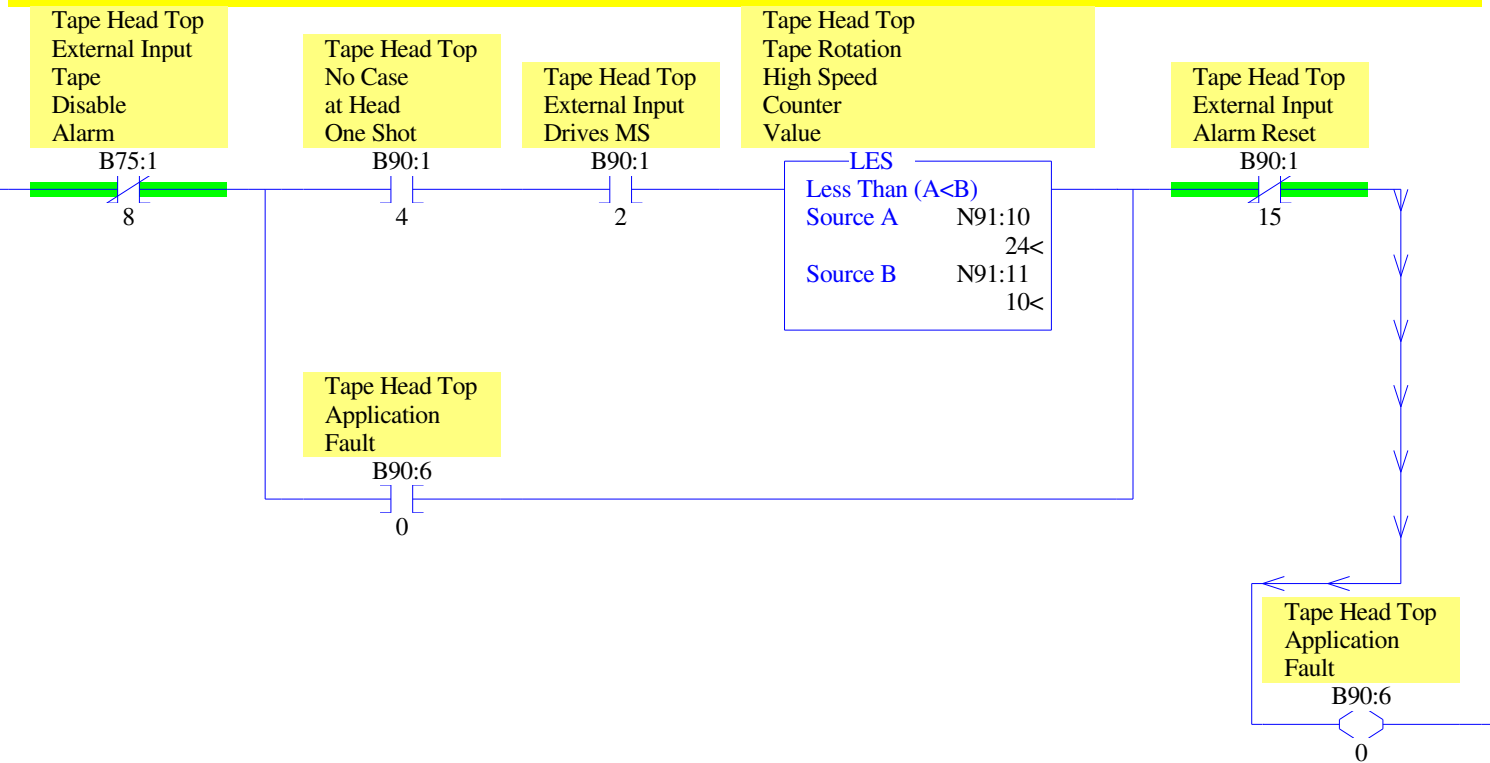




Tape Fault - Top Head Logic

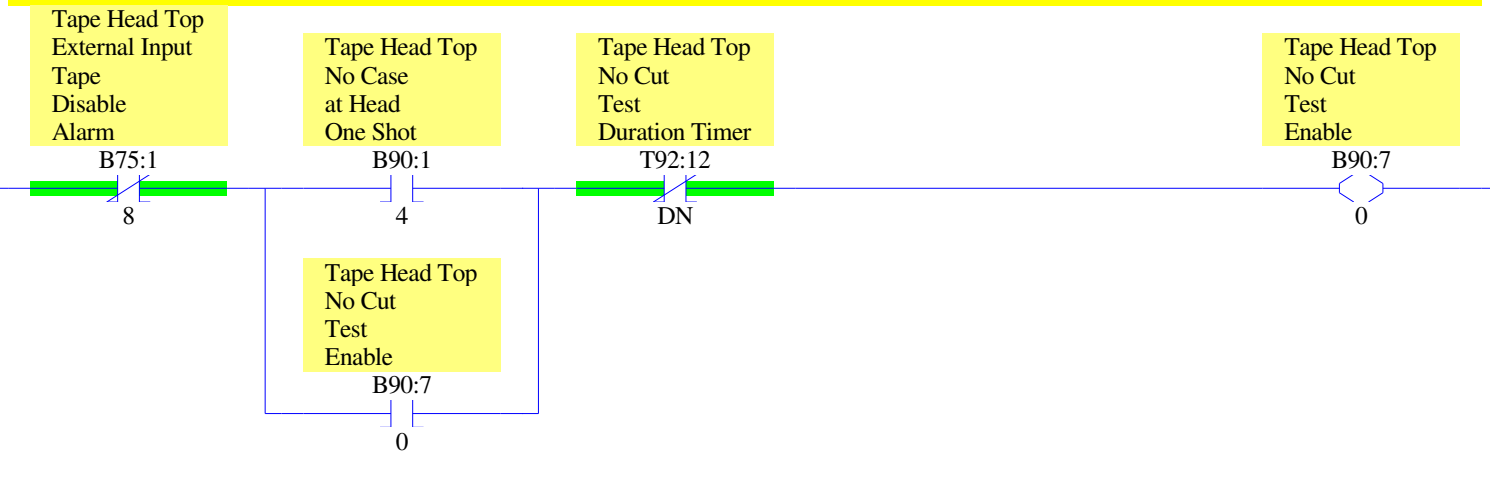
Tape Application Fault Logic

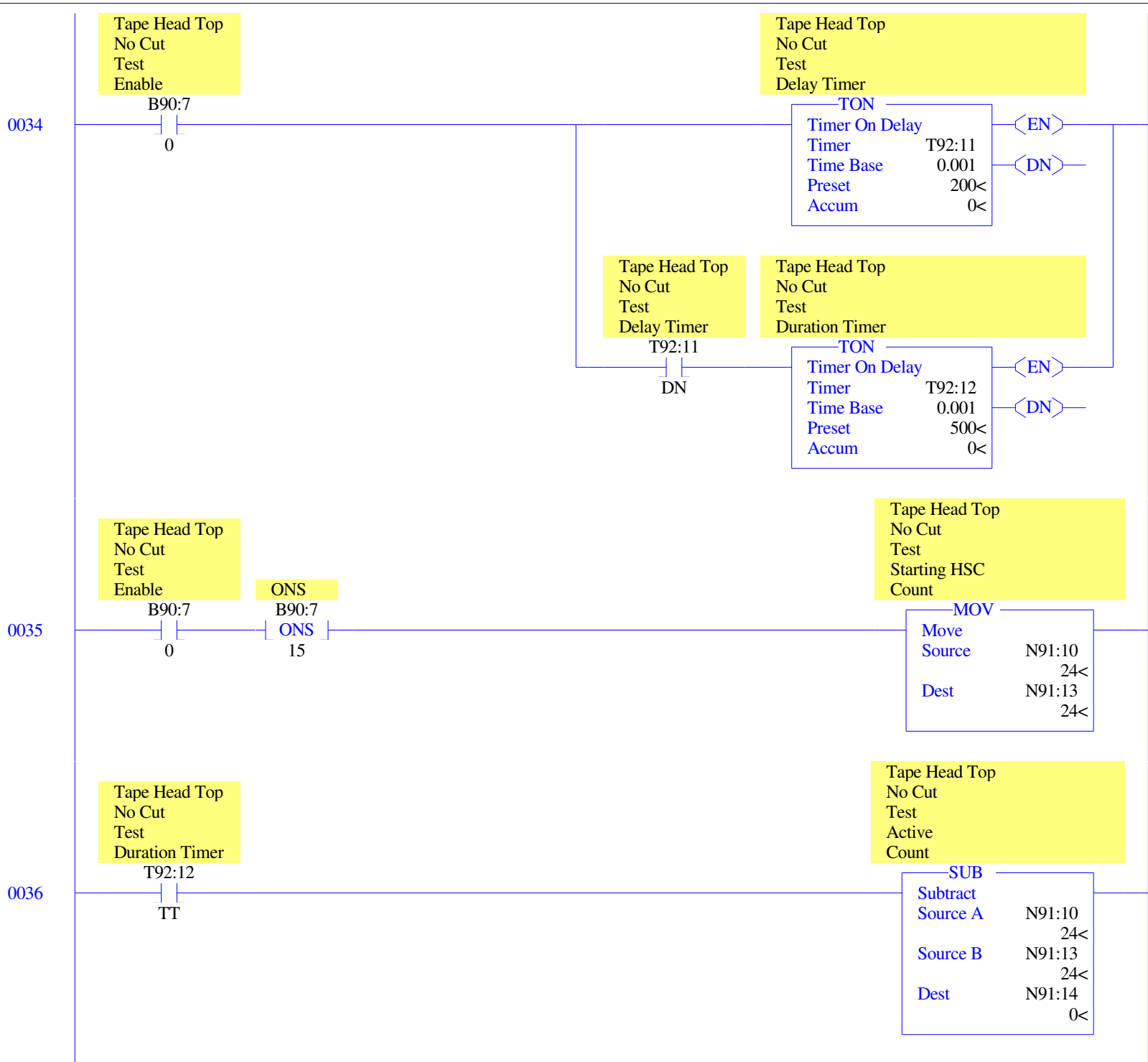
0032

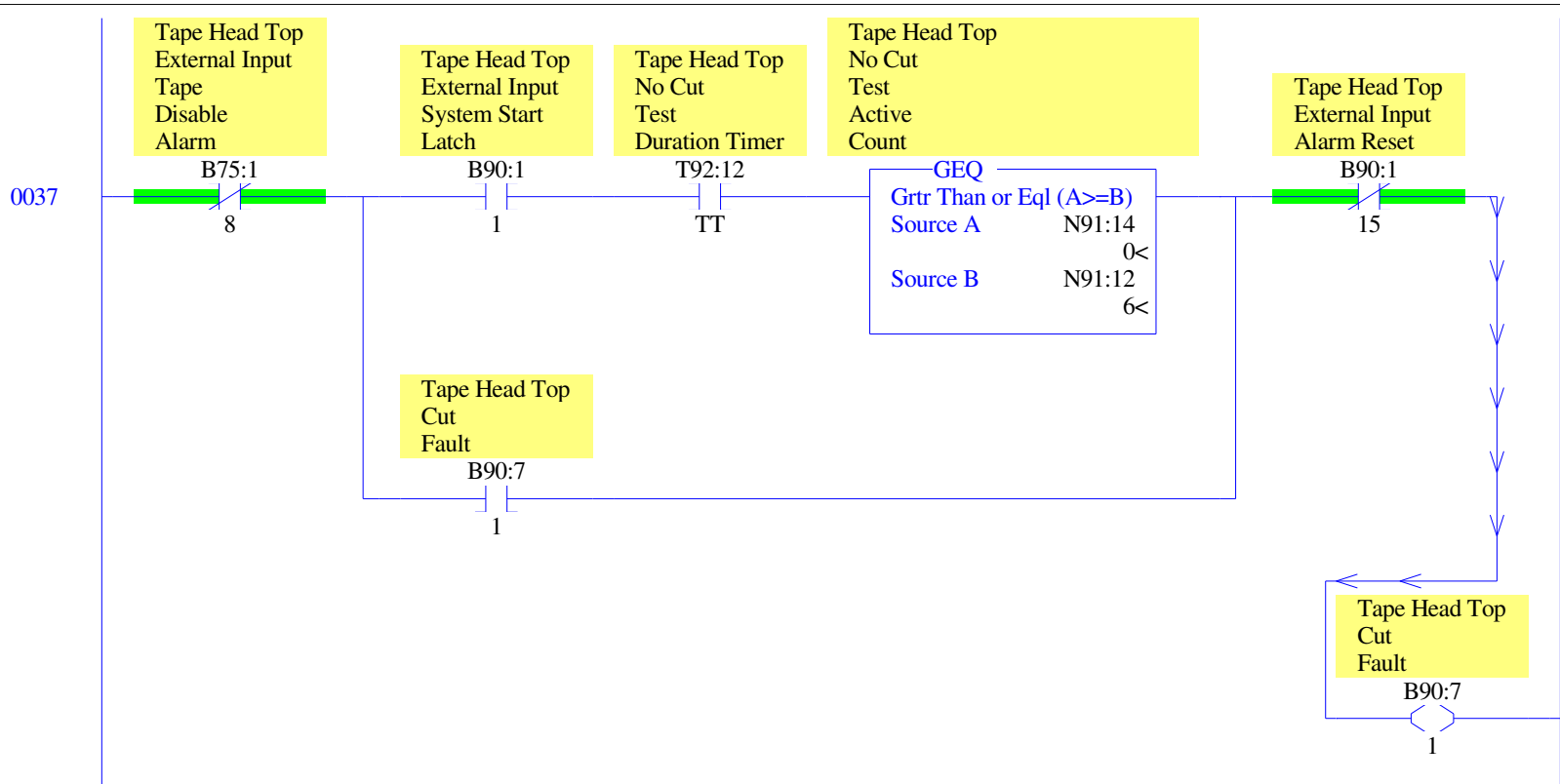


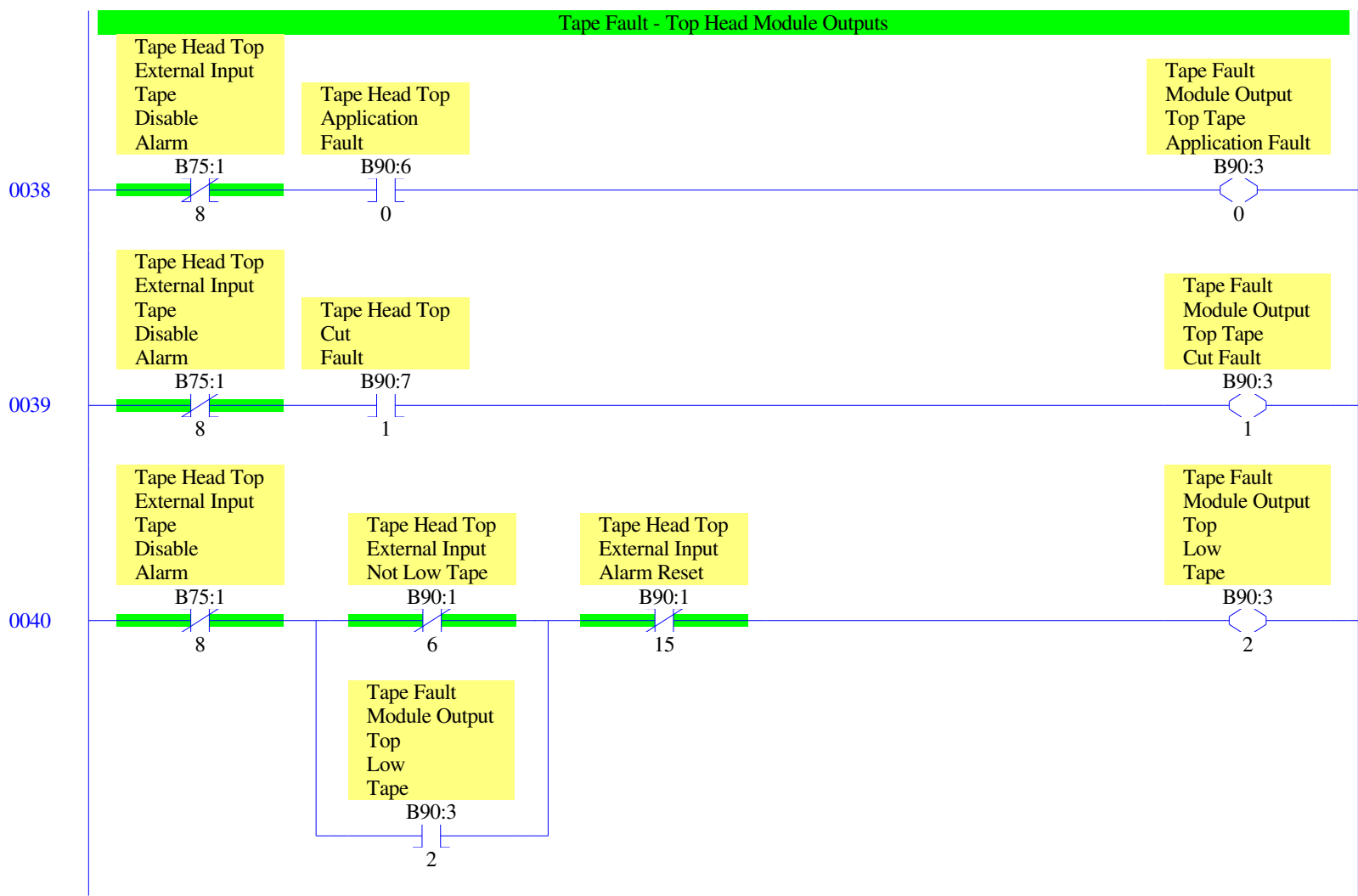
Tape Cut Fault Logic

0033

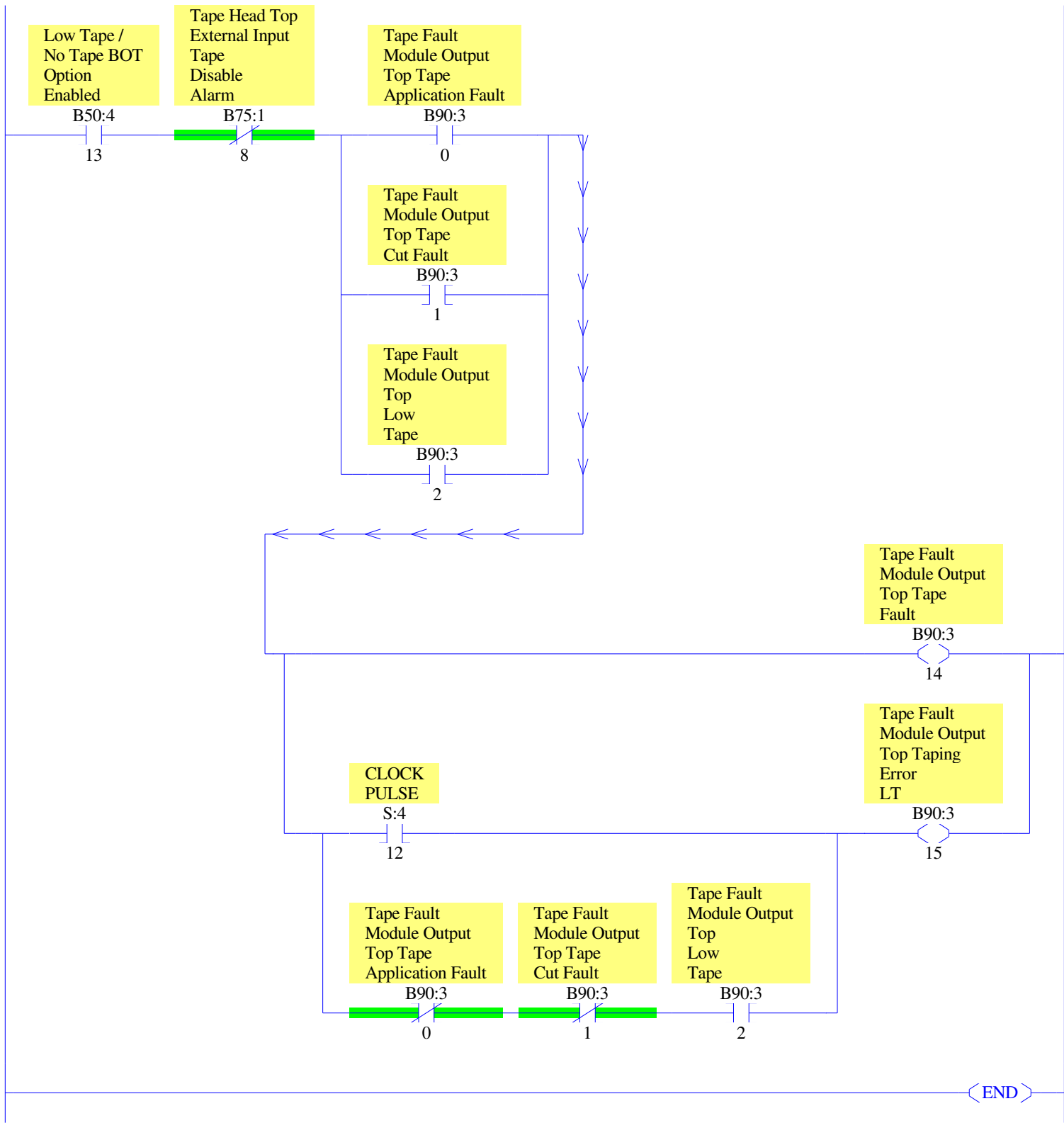




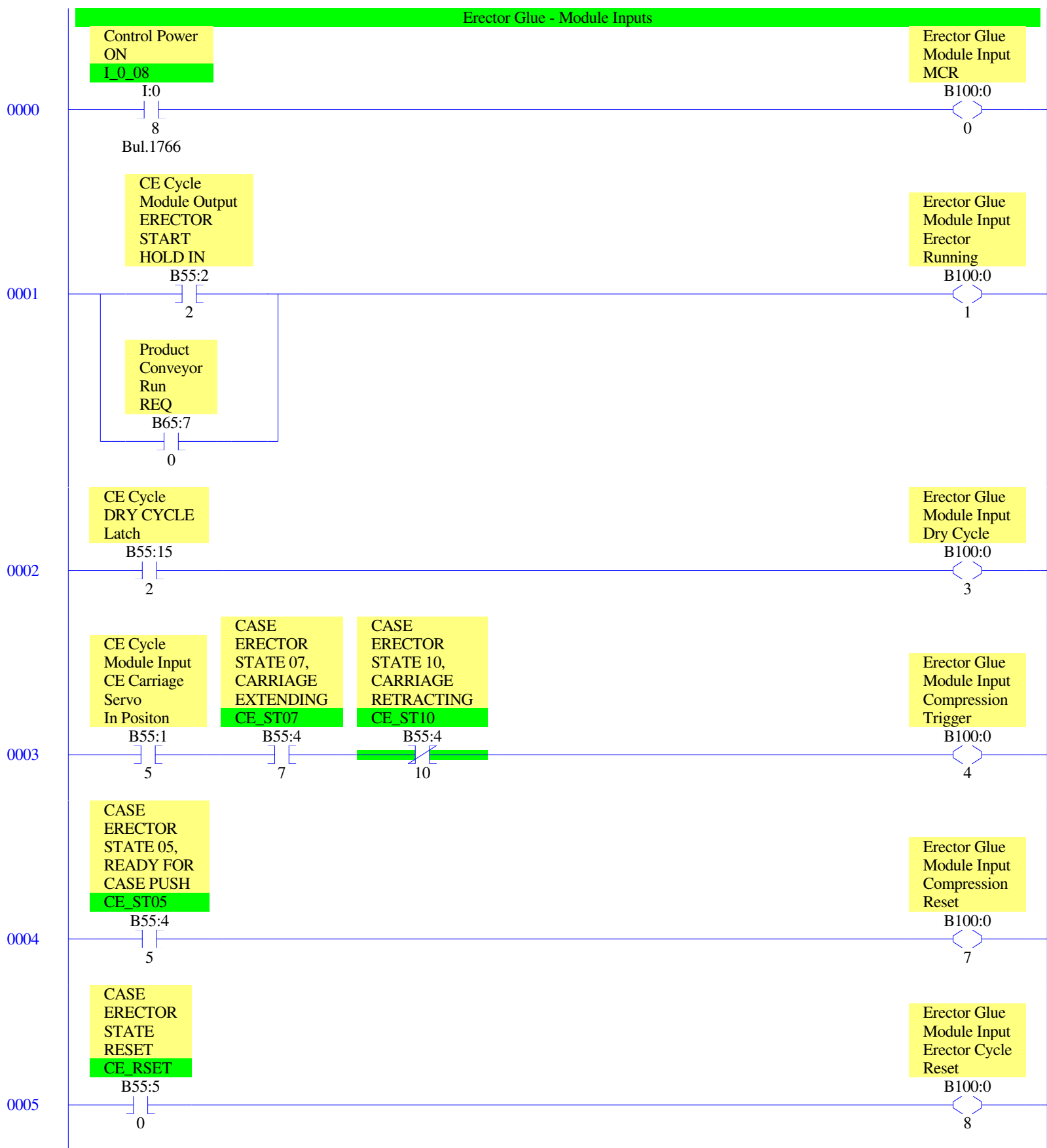


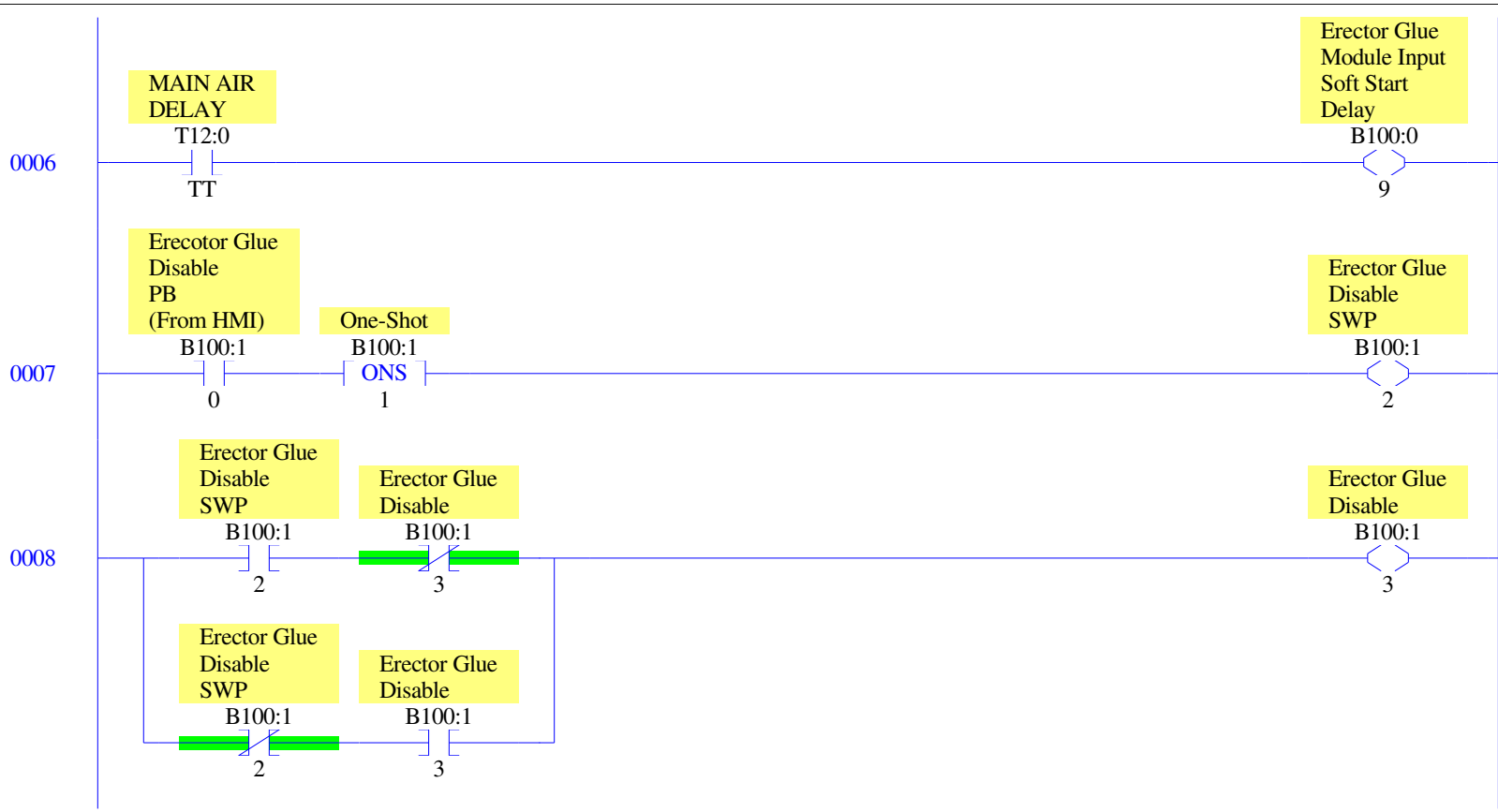


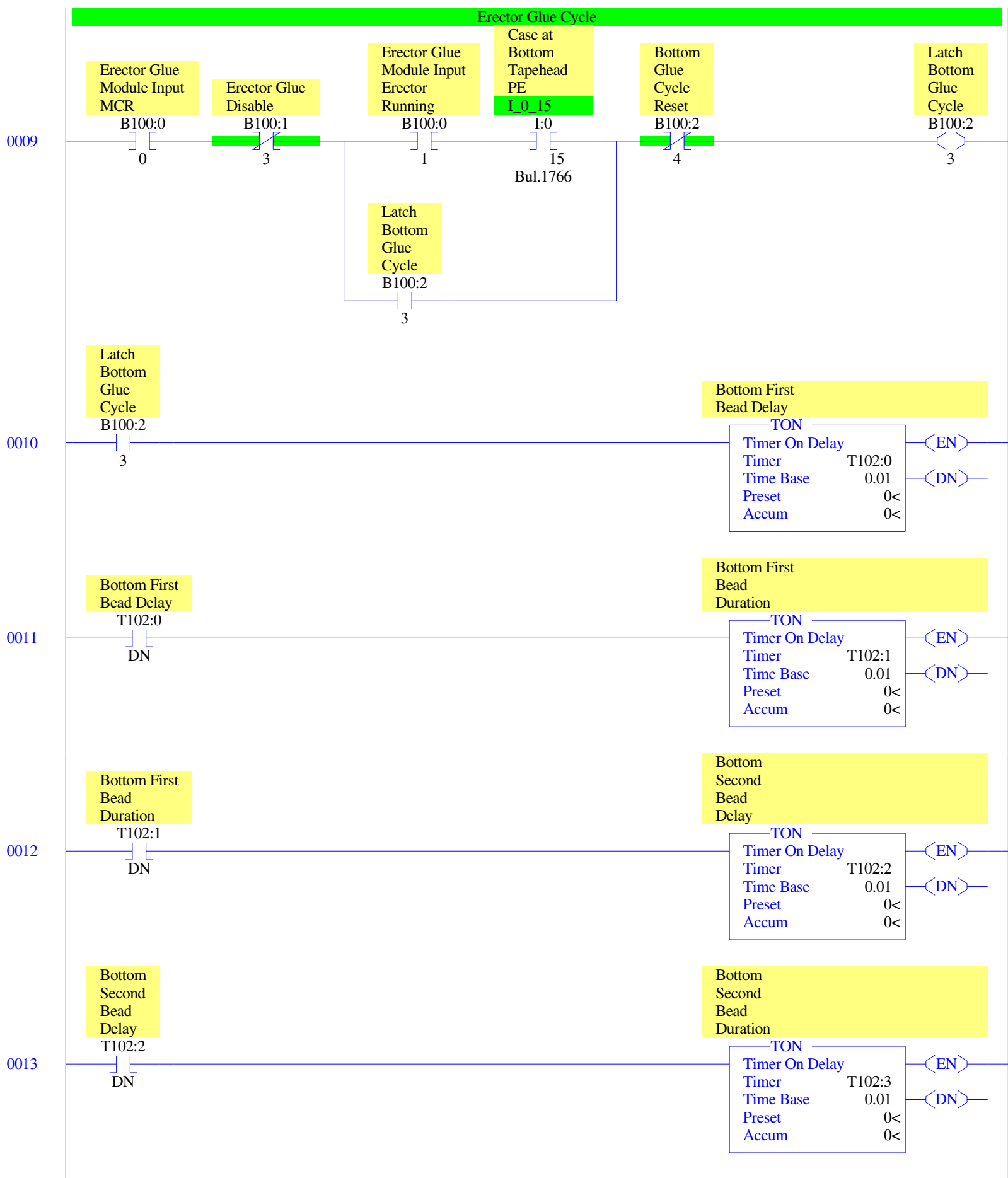
0041



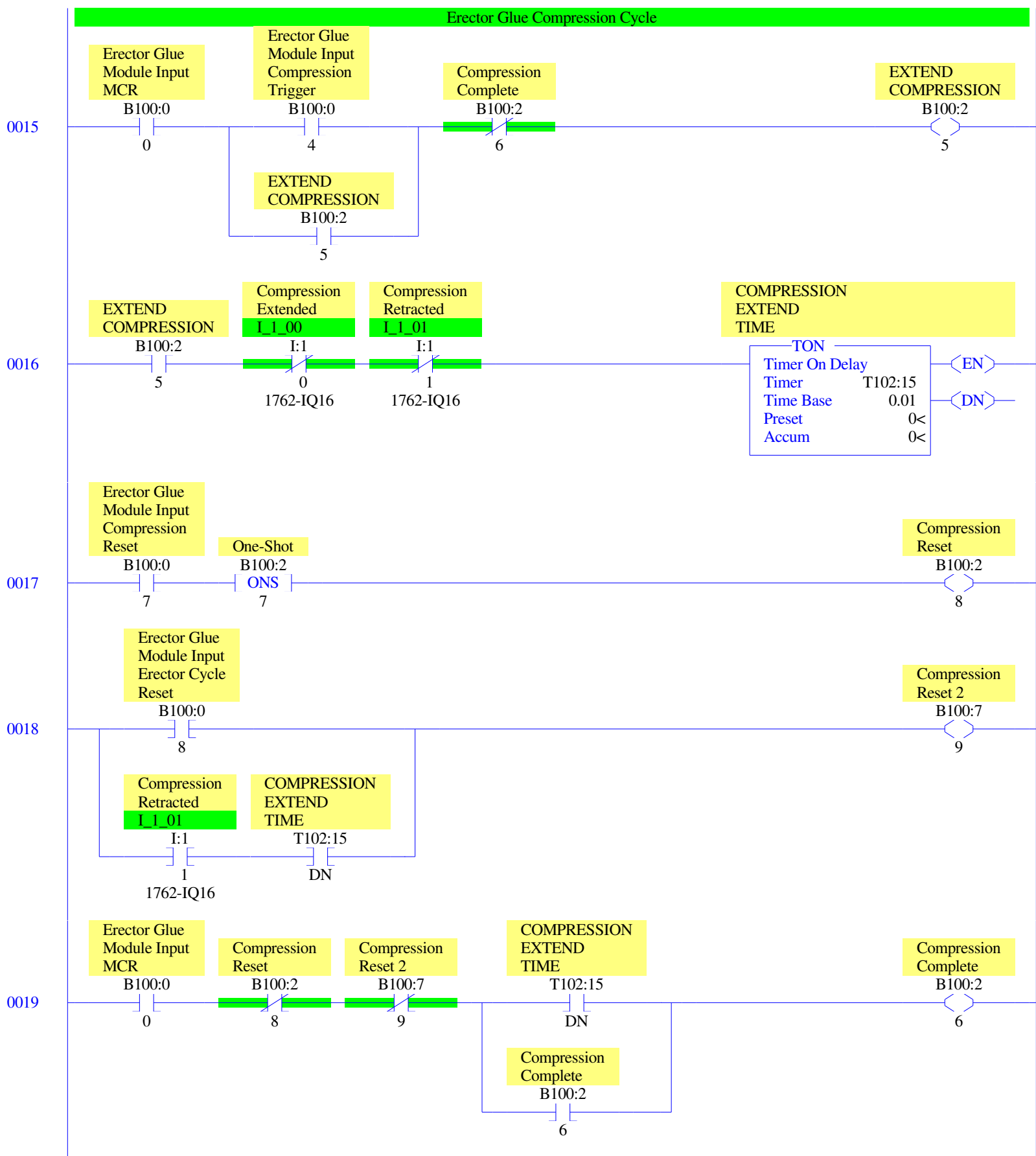
0042

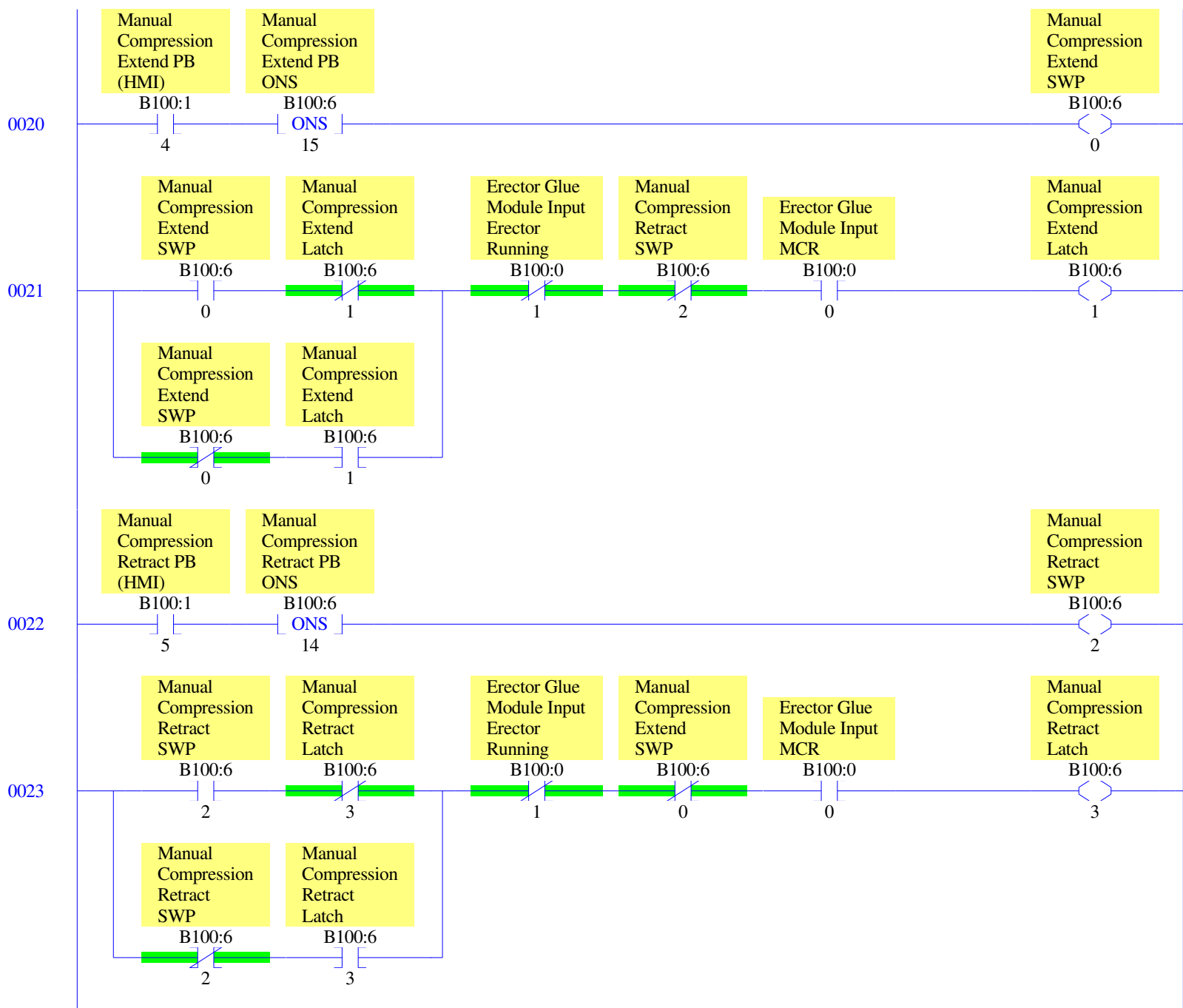


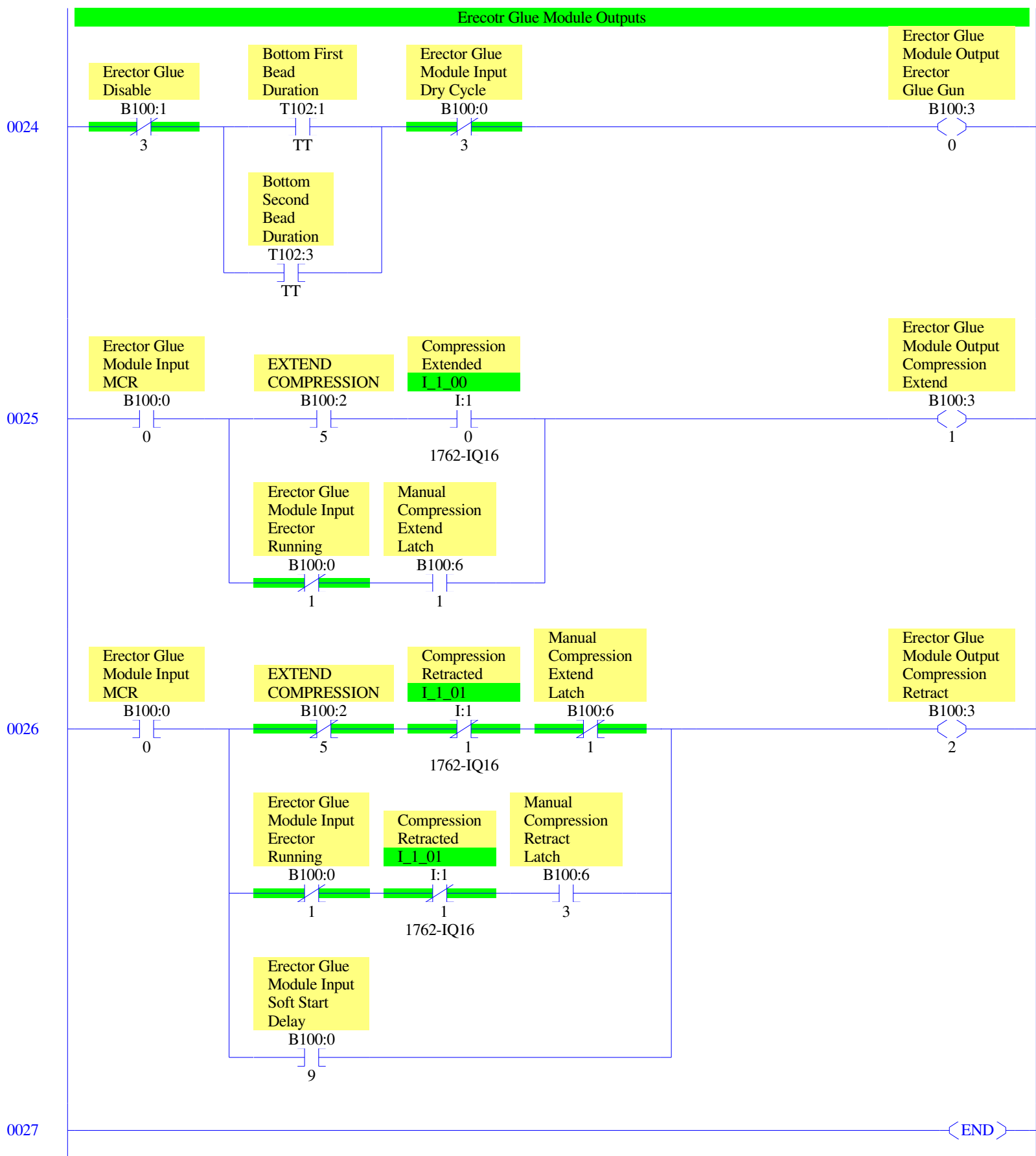


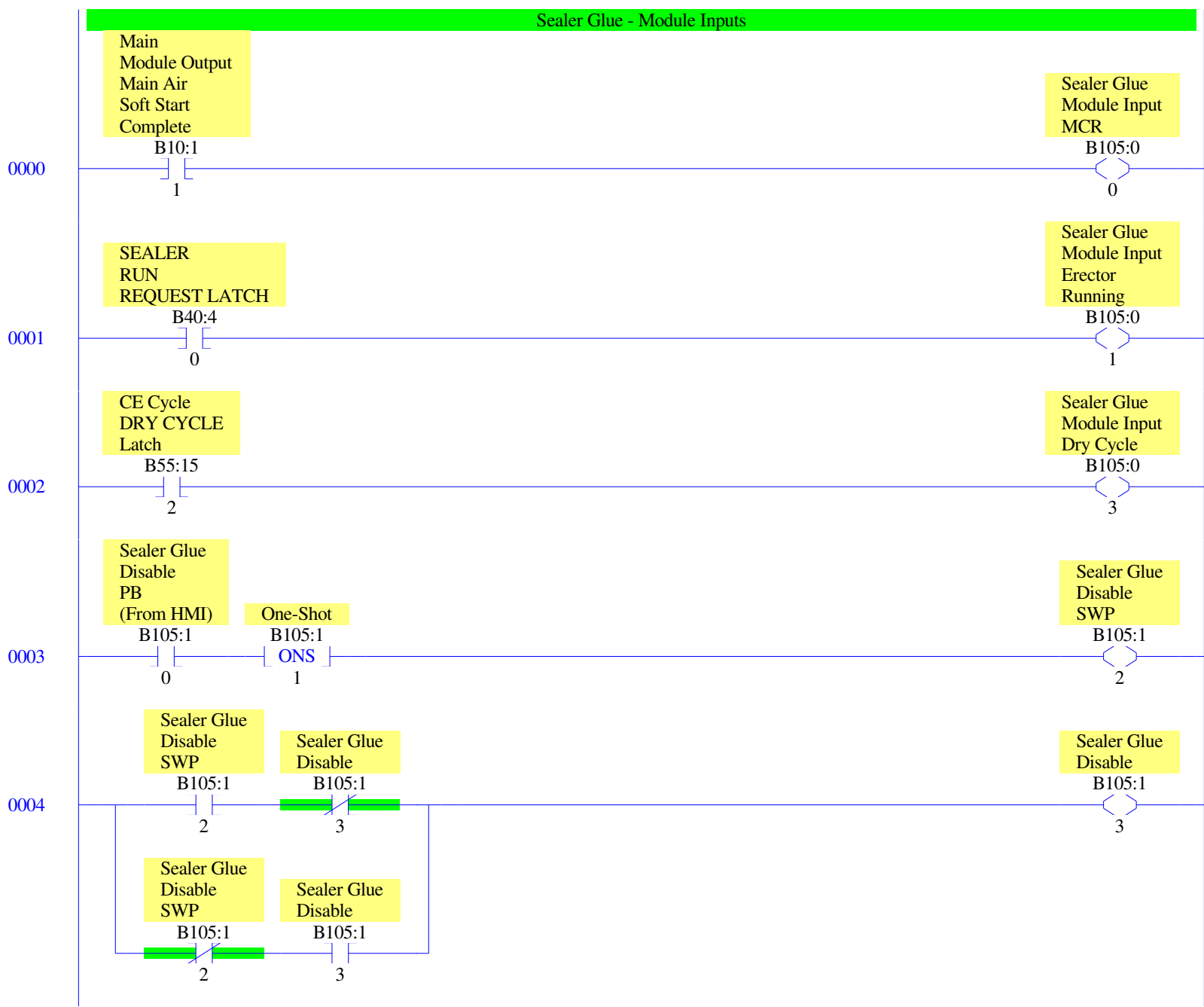


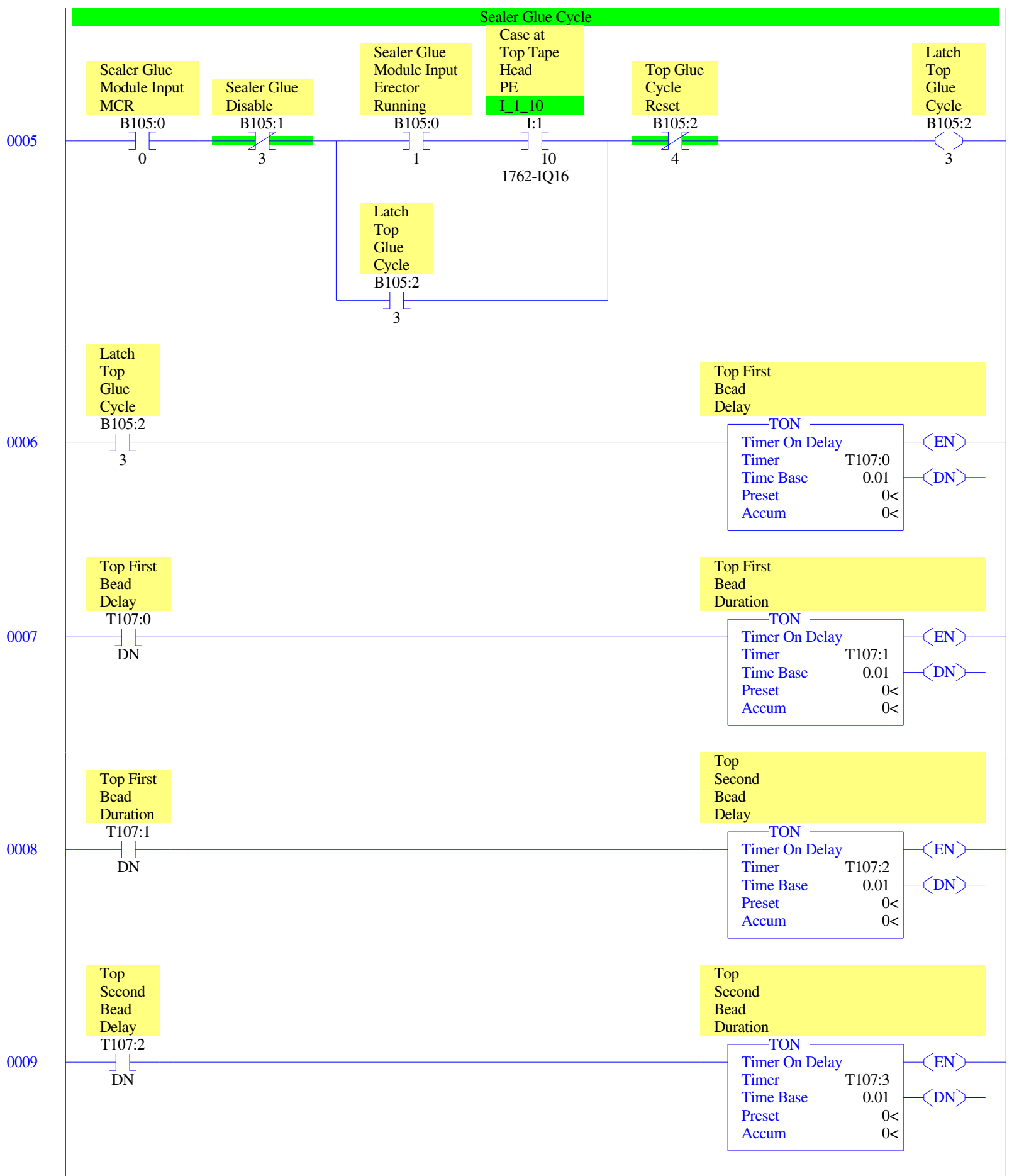


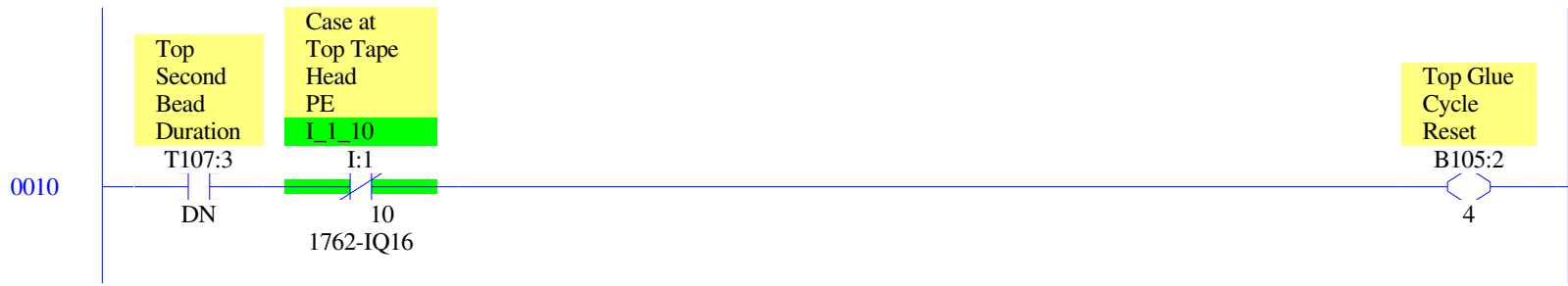


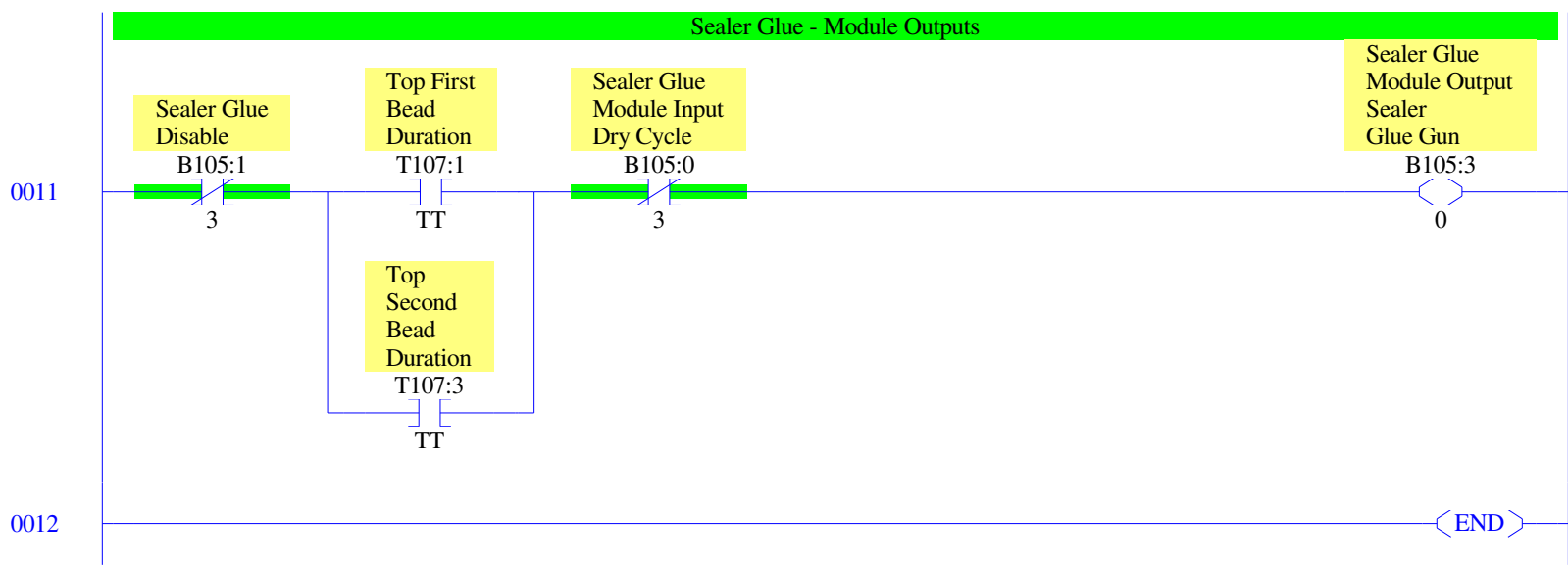








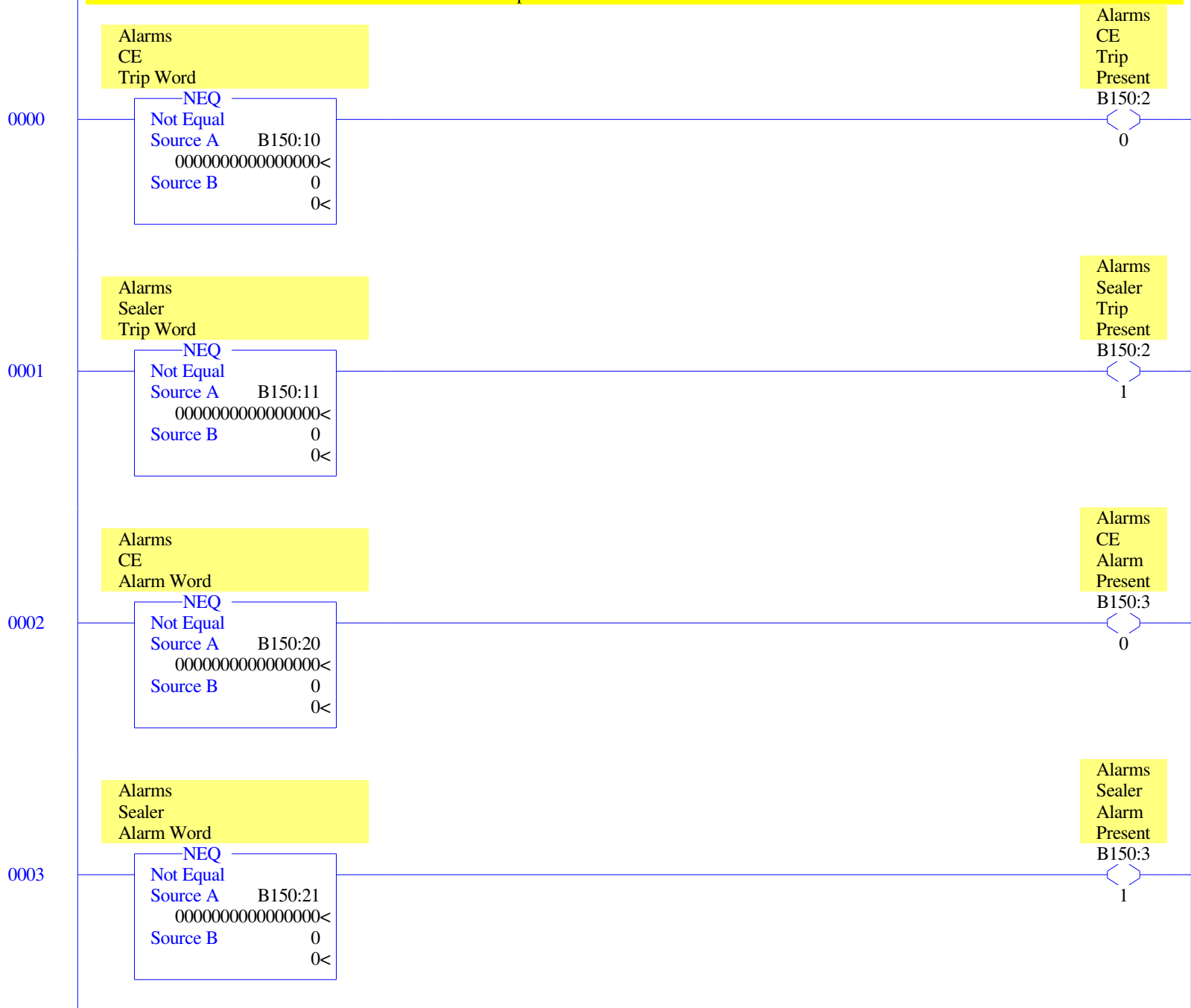




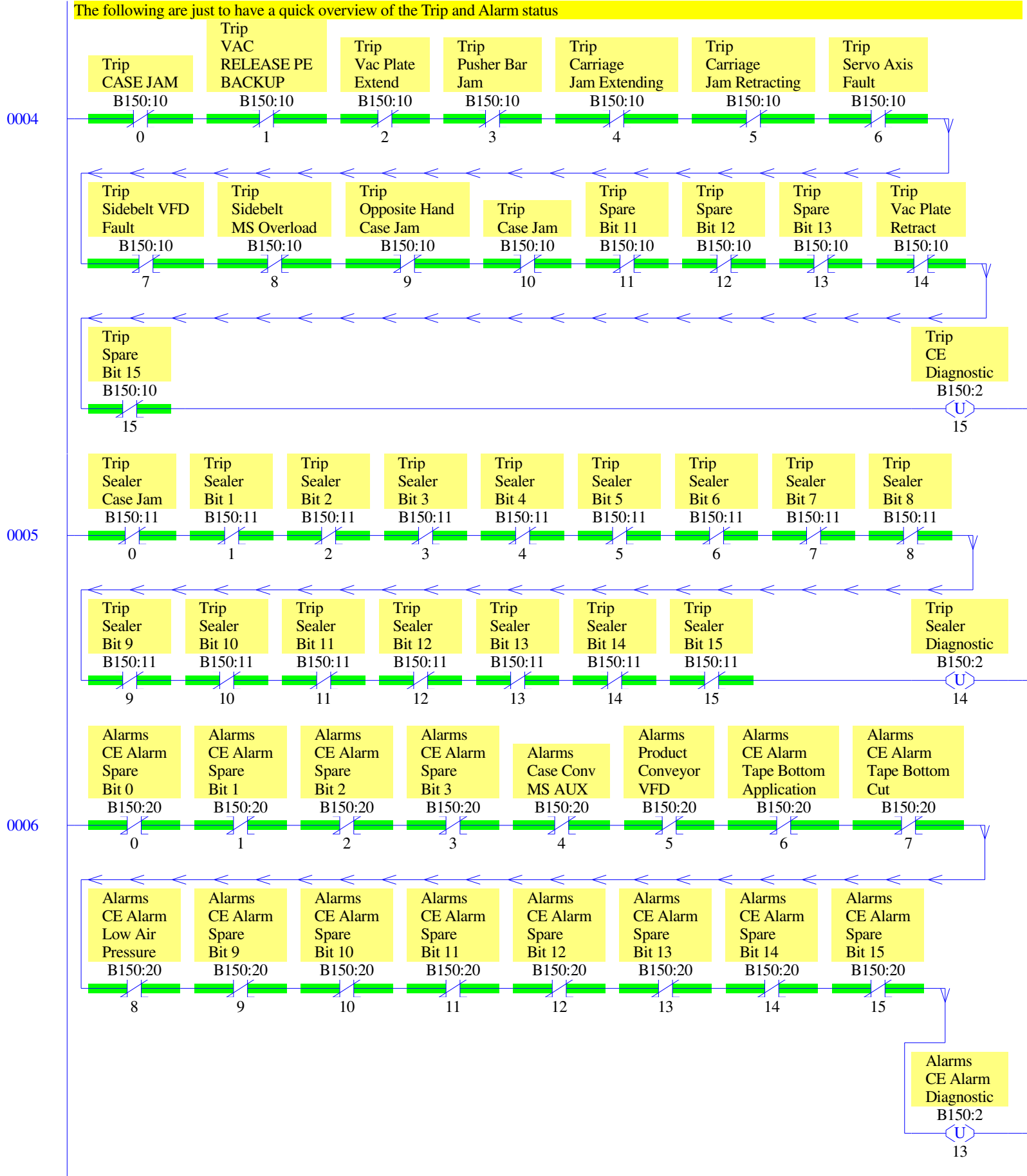
Alarms - Alarm Summary and Reset

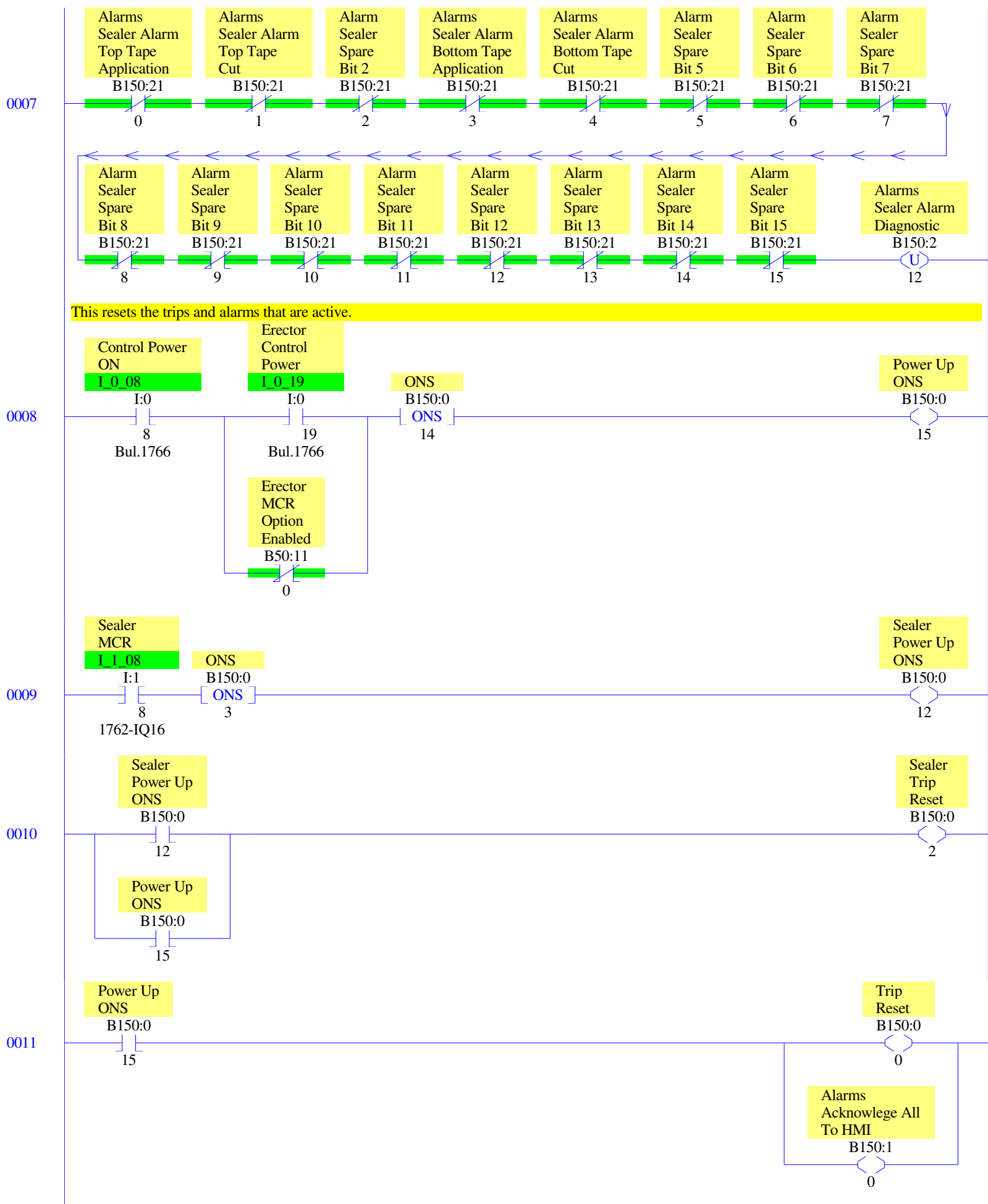
Trip Words are defined from B150:10 - 19
 Alarm Words are defined from B150:20 - 29

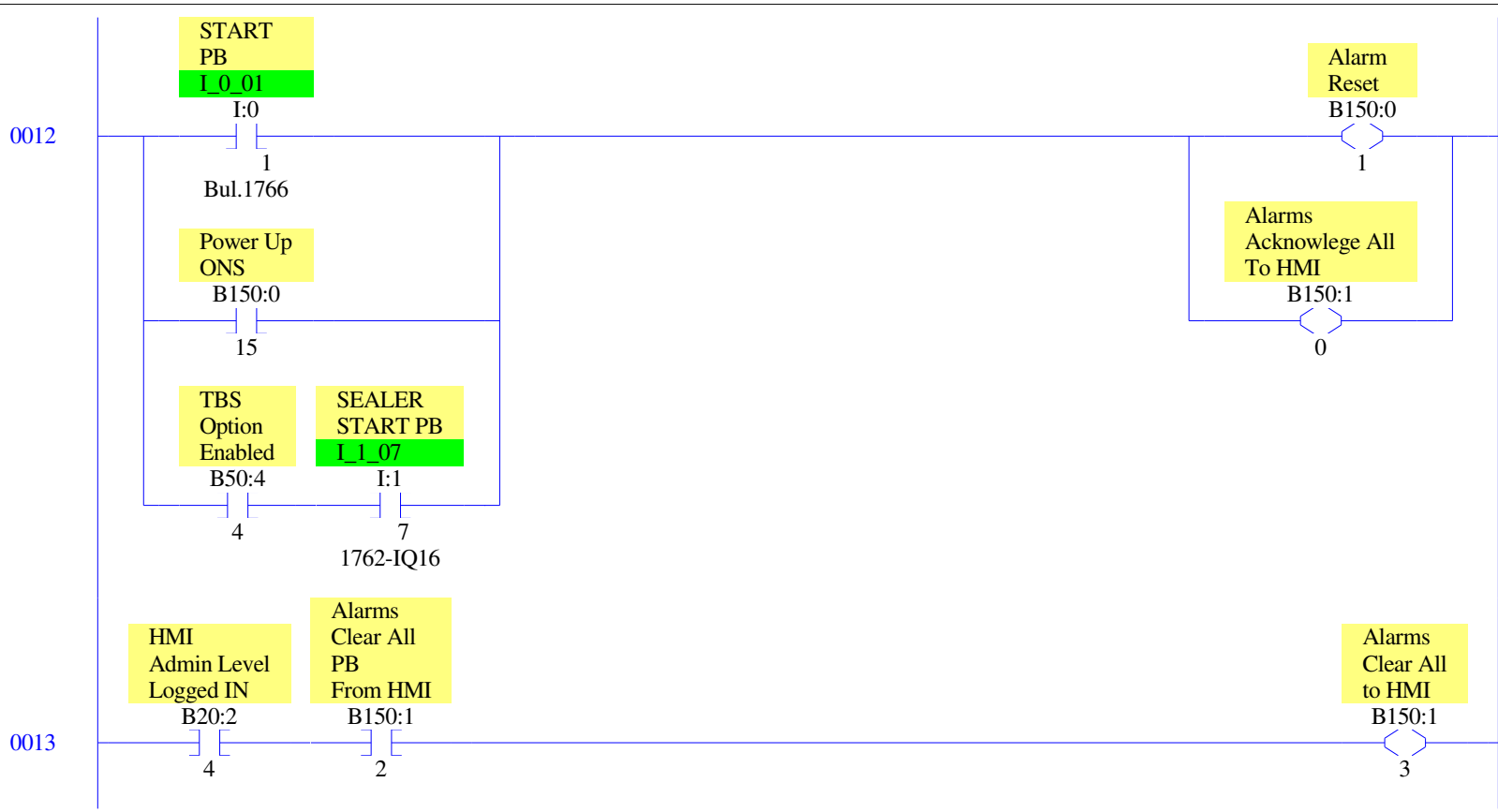
Each Section of the machine can have its own word for Trip and Alarm

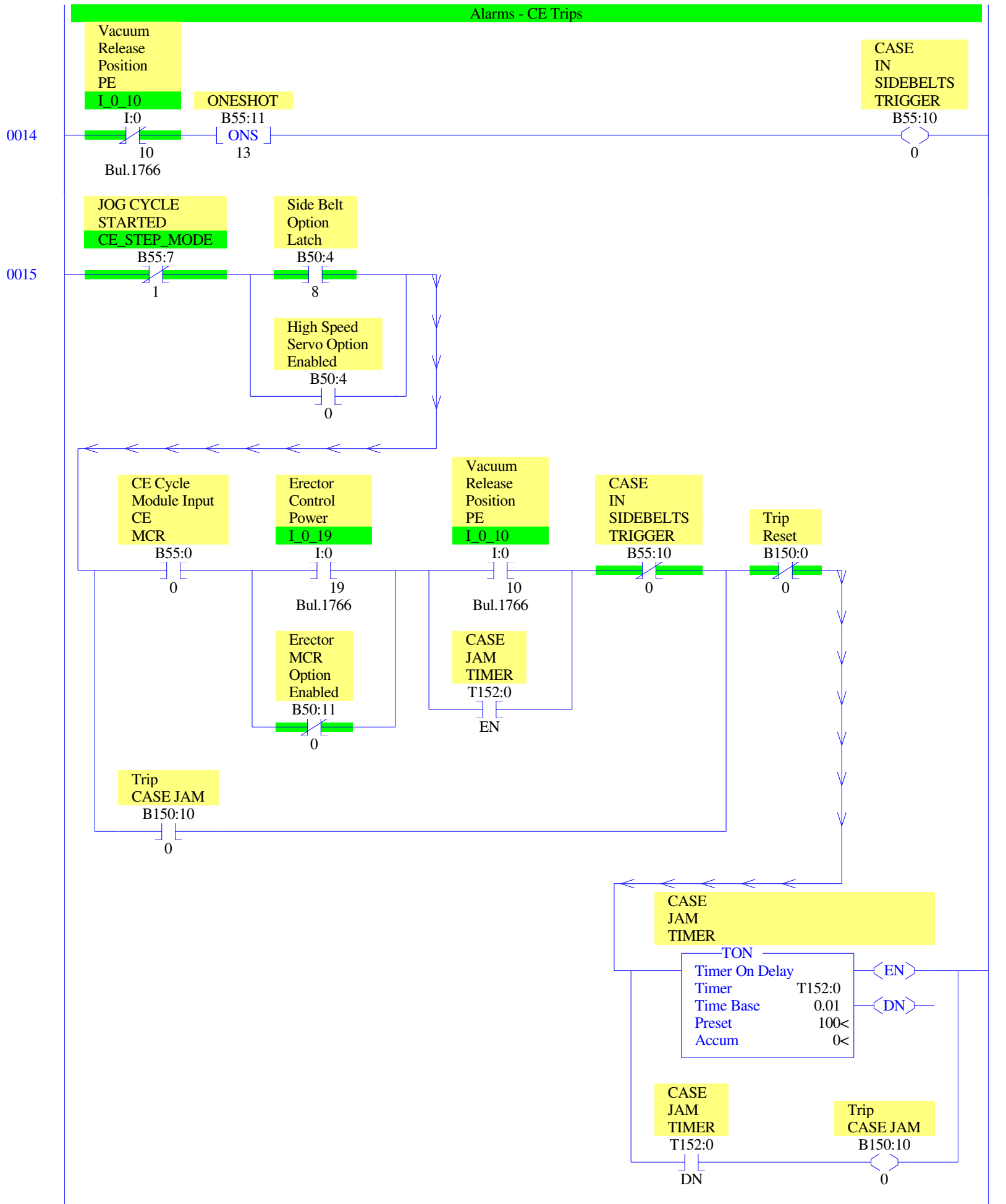


The following are just to have a quick overview of the Trip and Alarm status

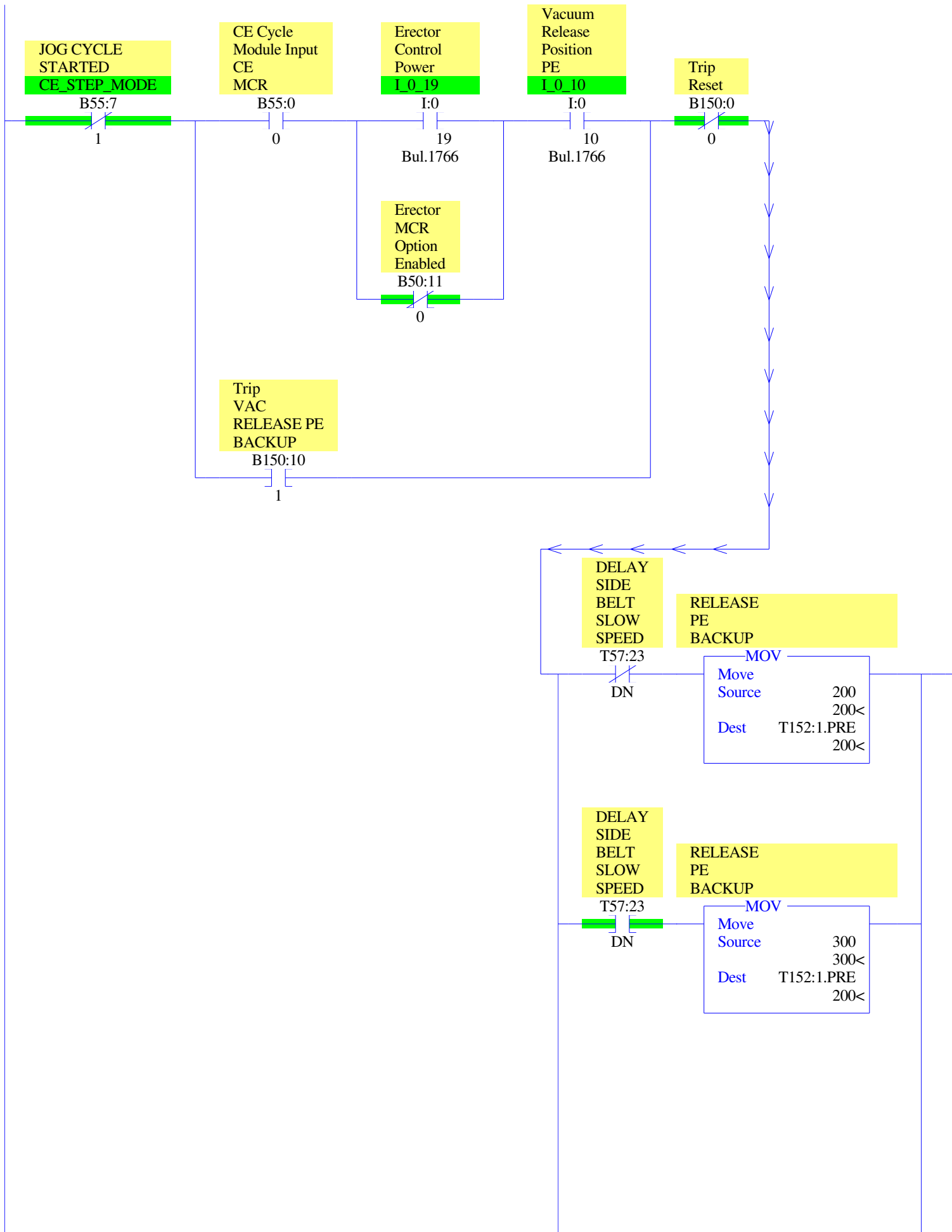


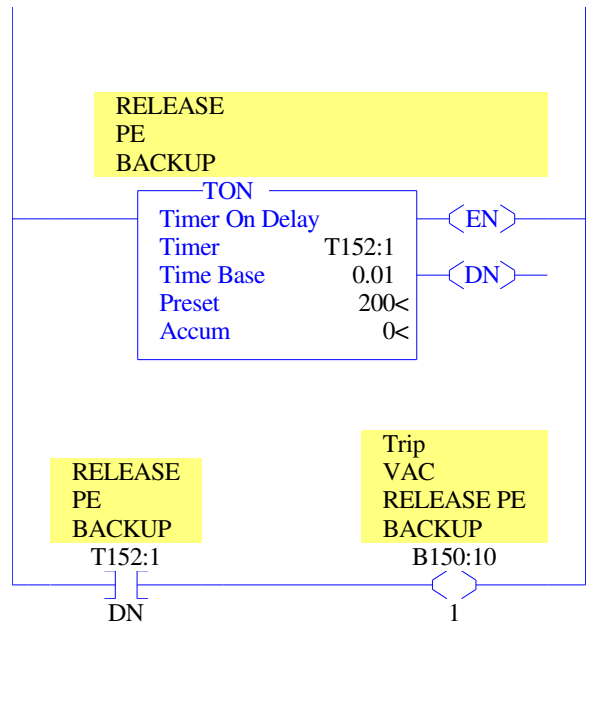


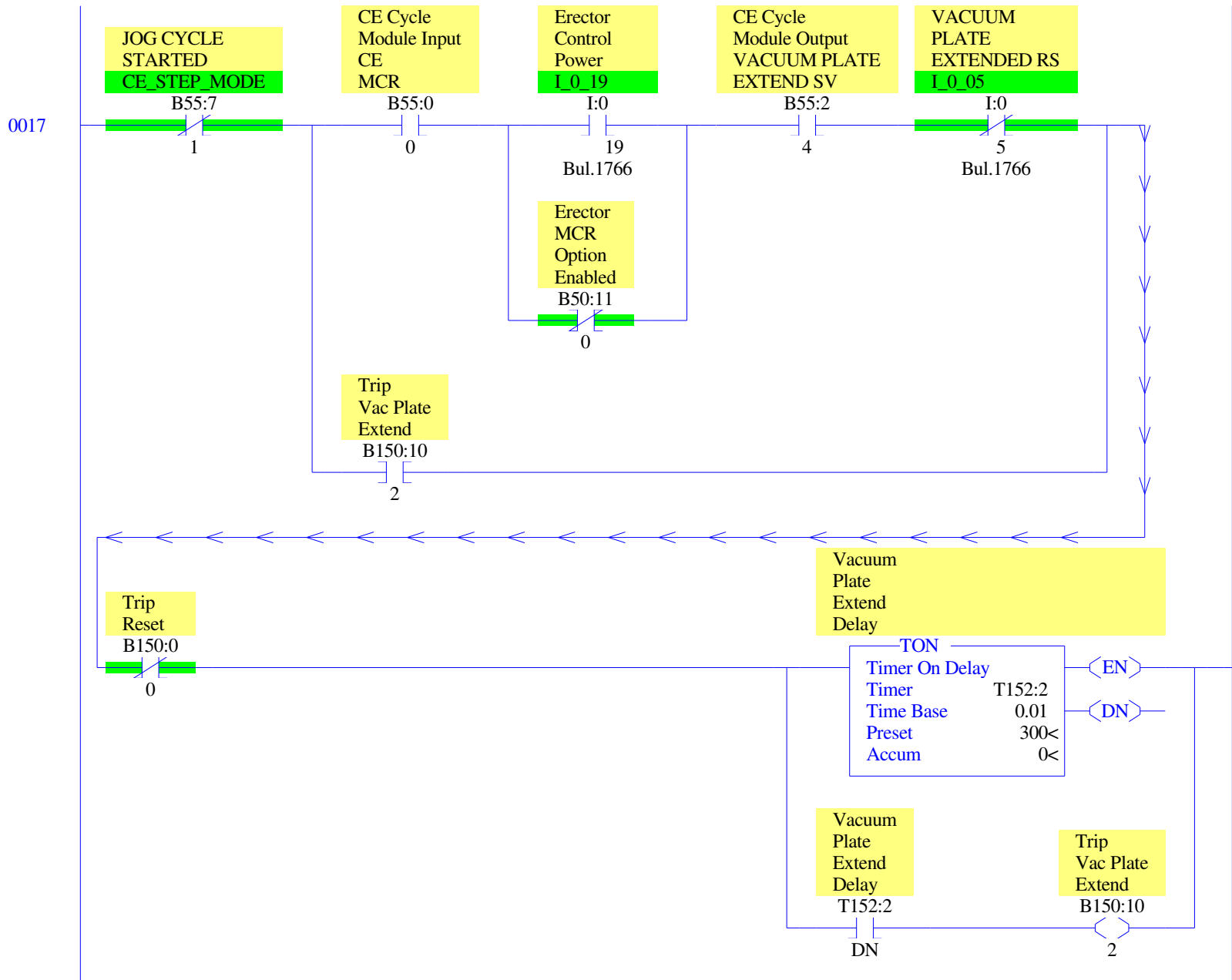




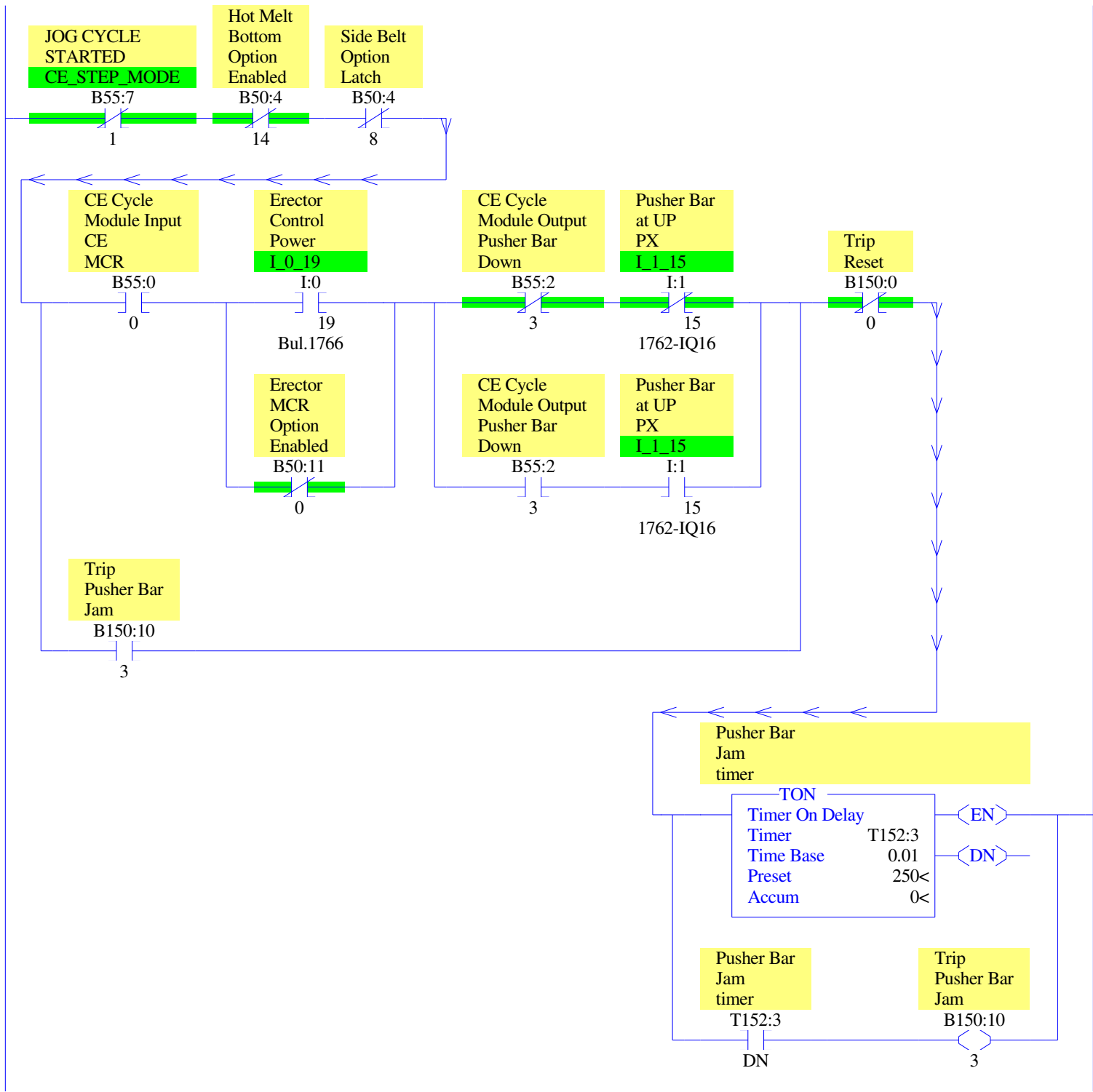
0016

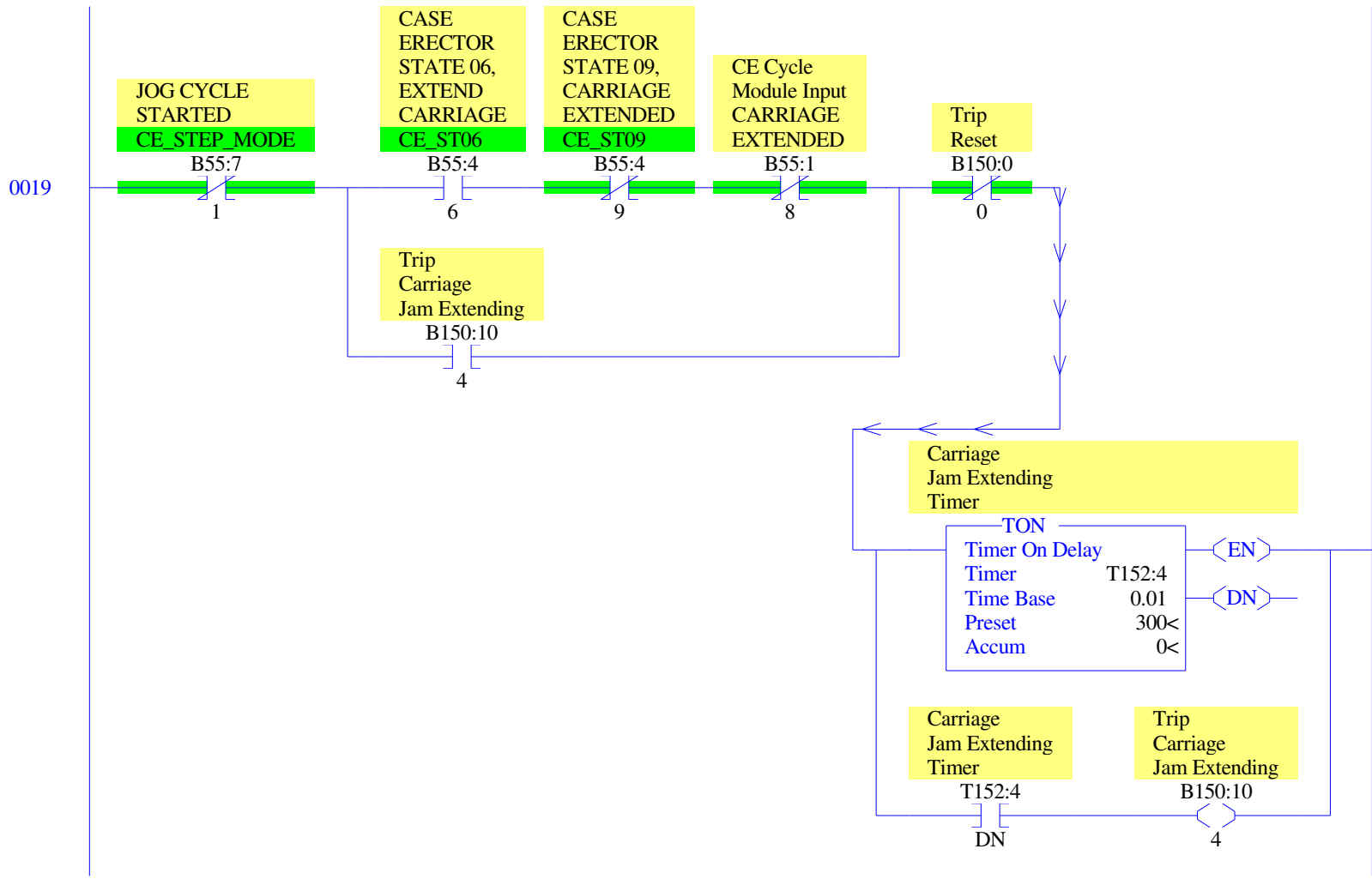


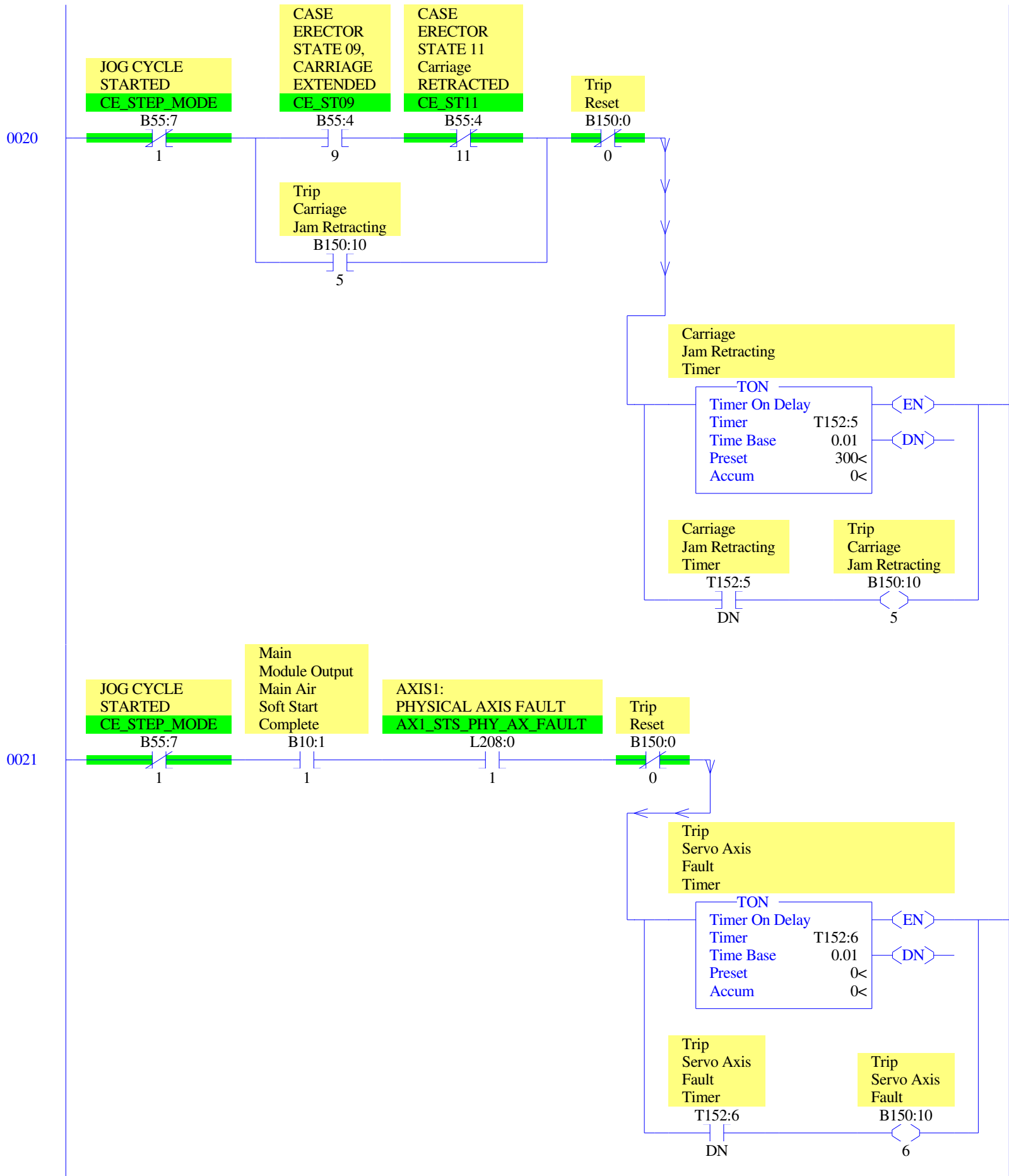




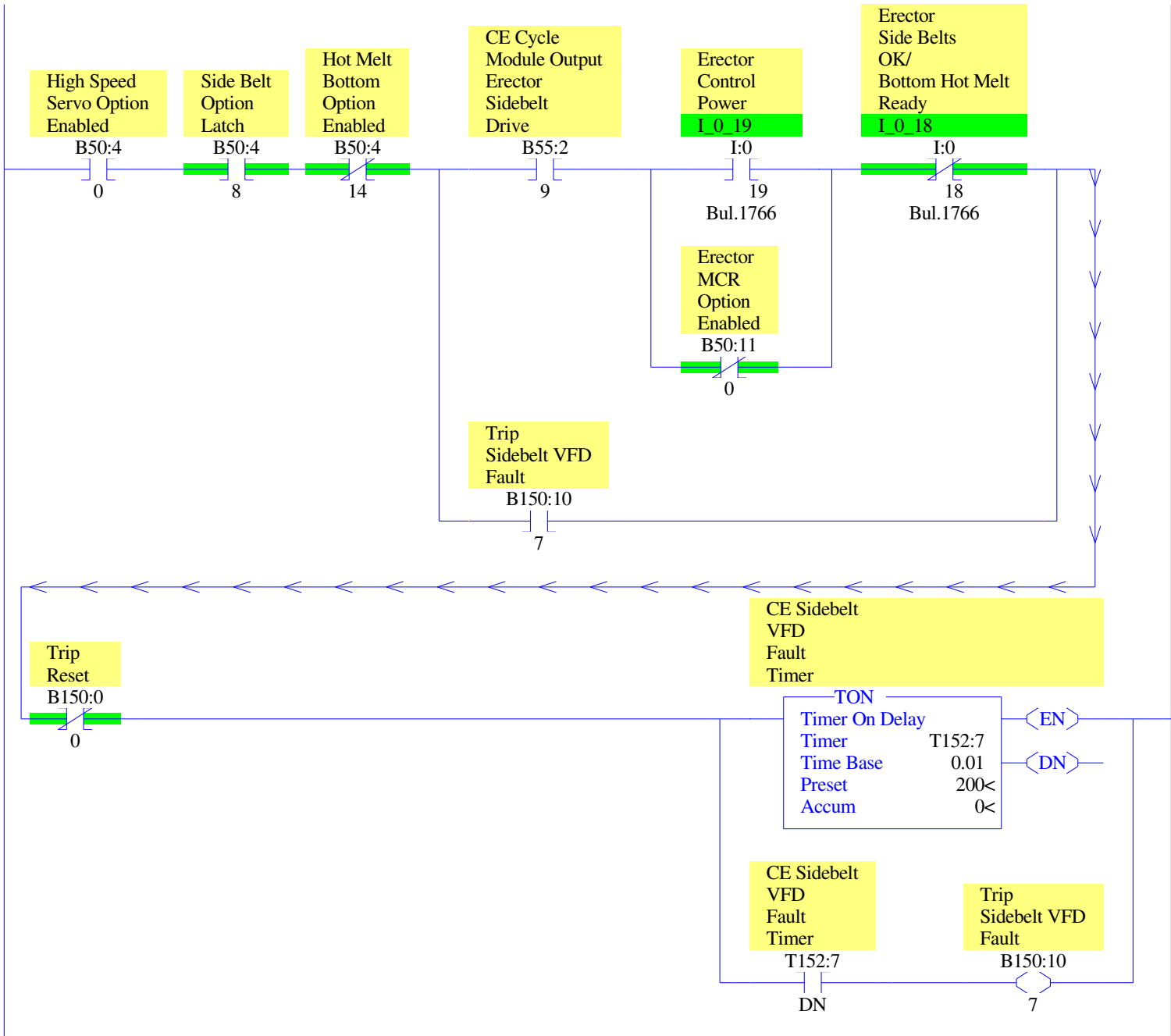
0018

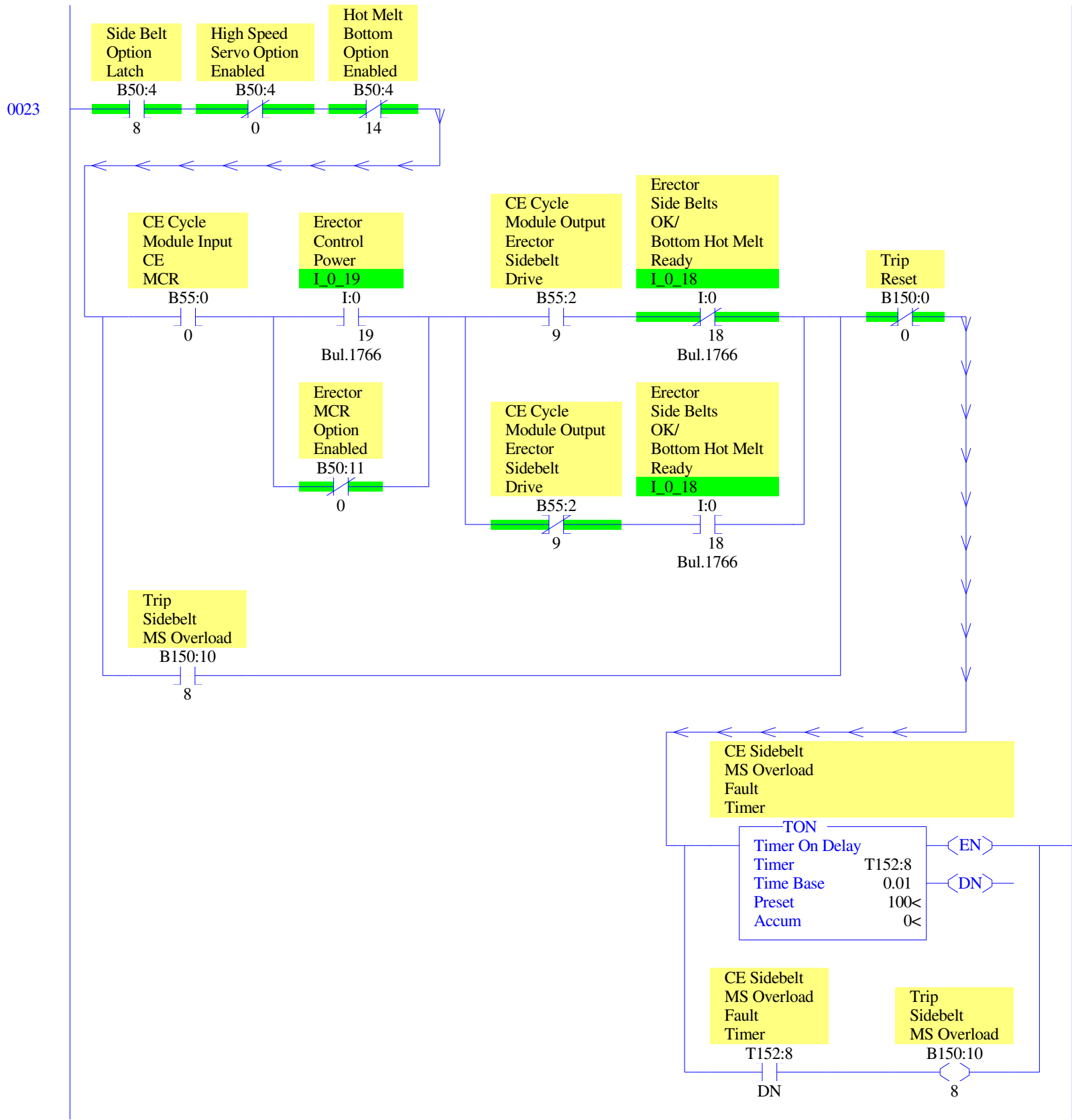


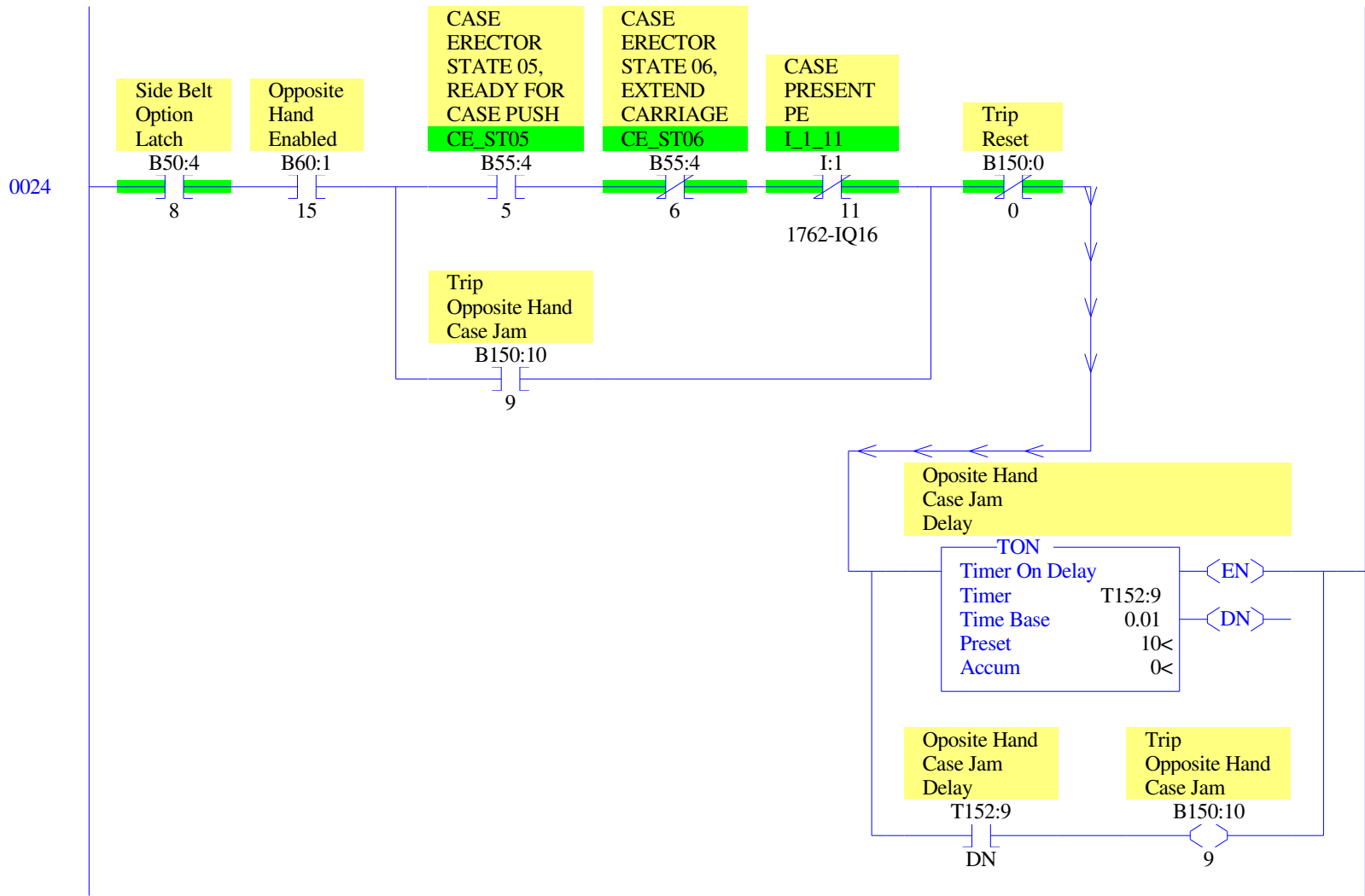


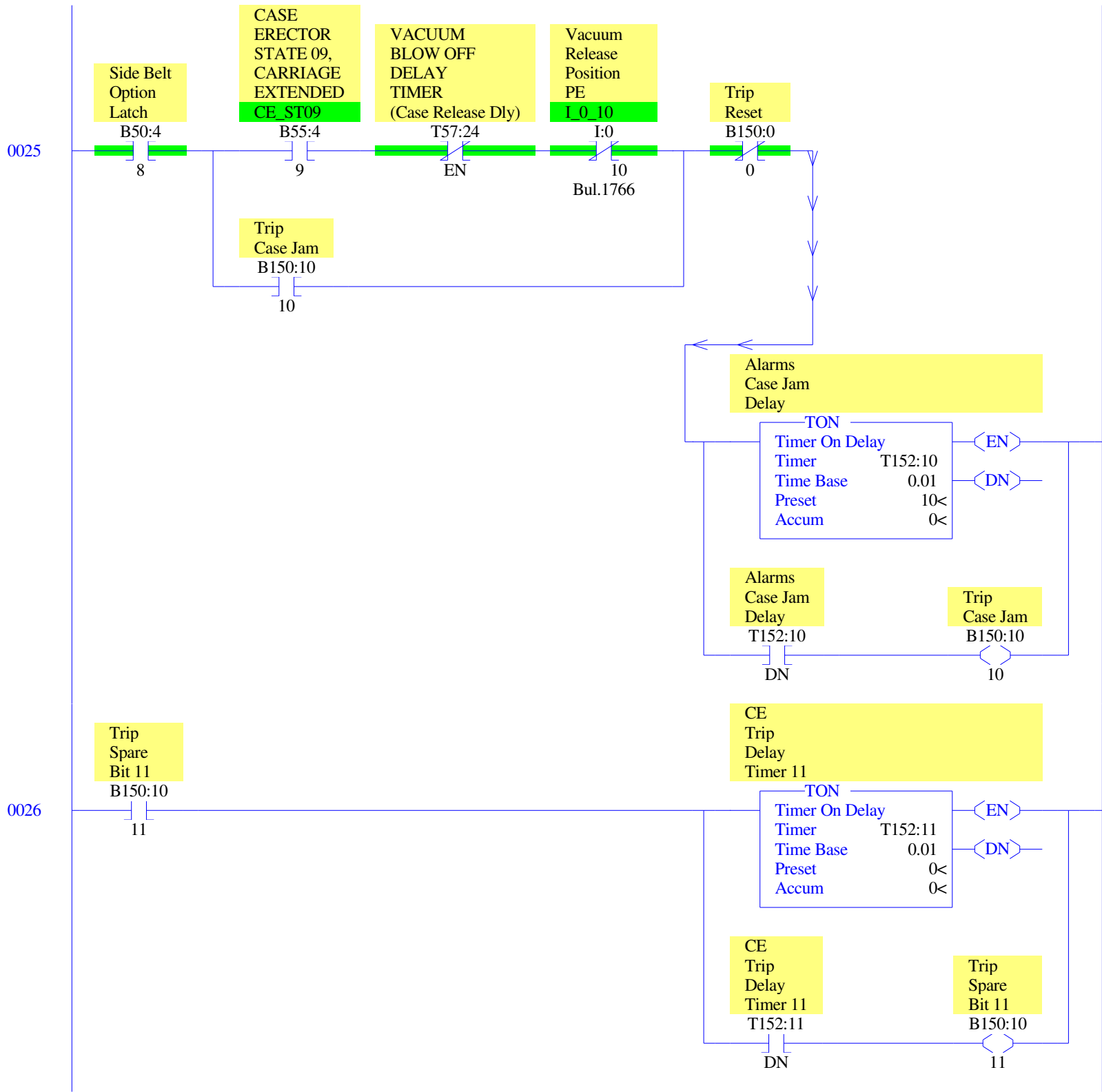


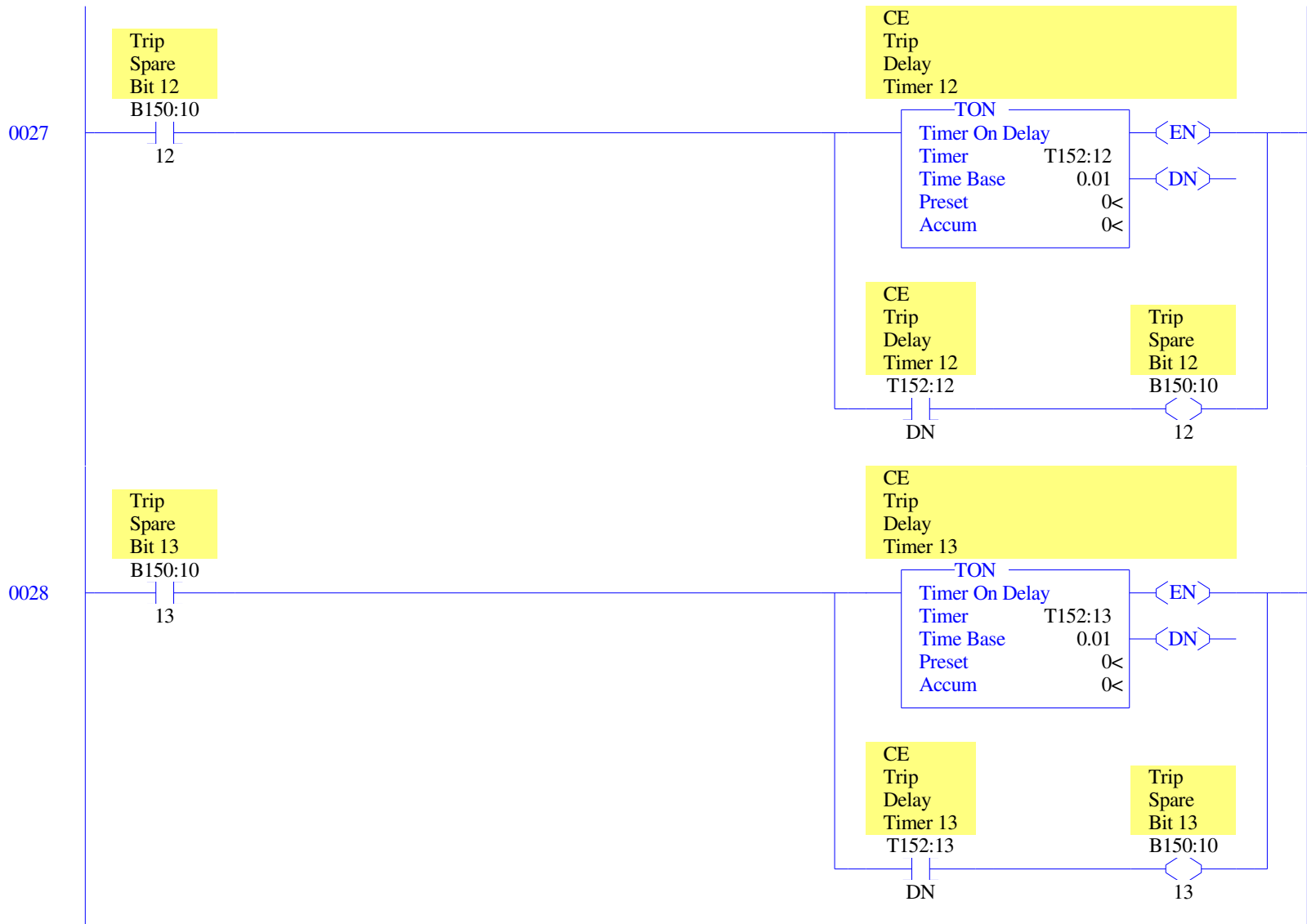
0022

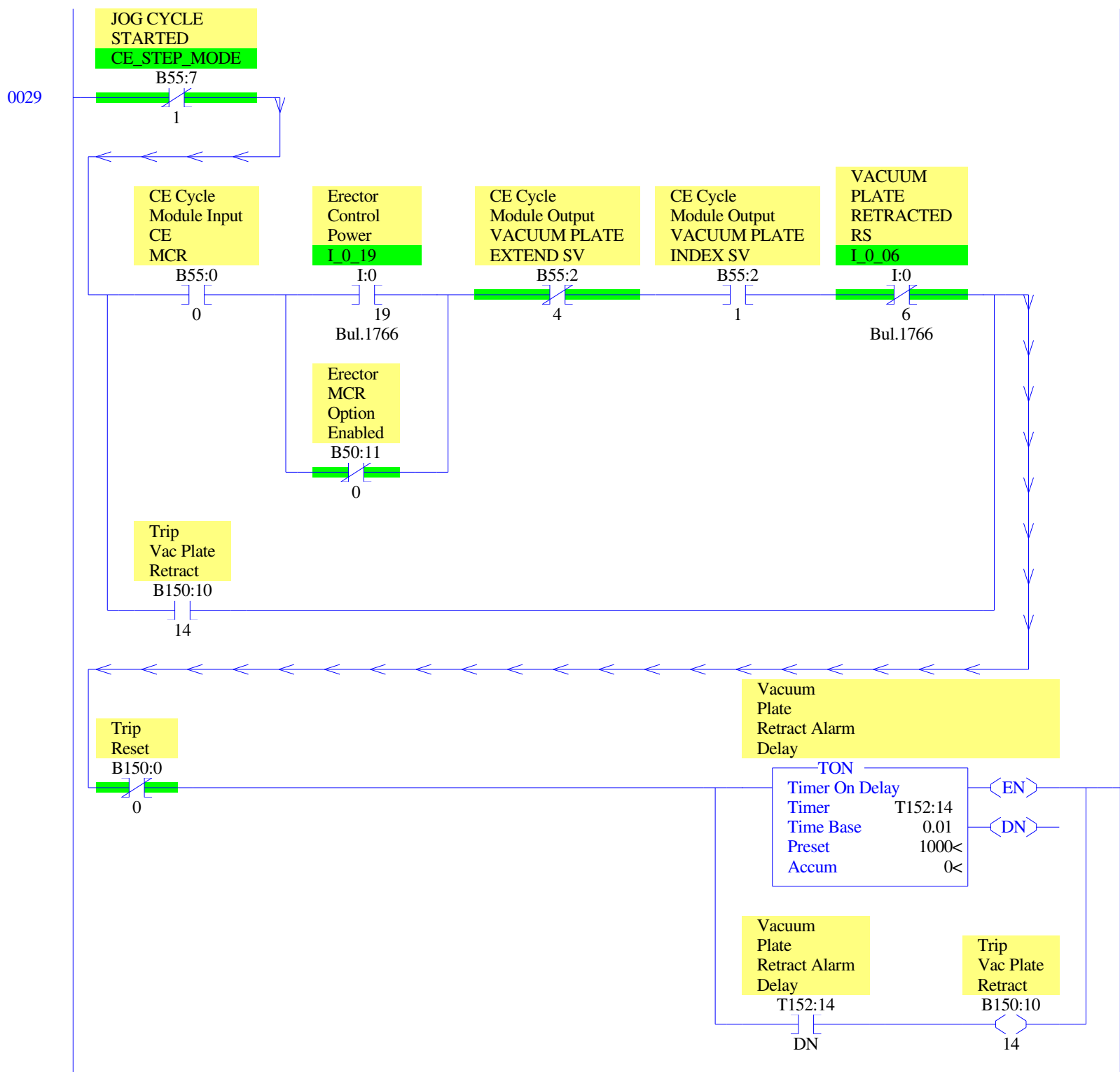


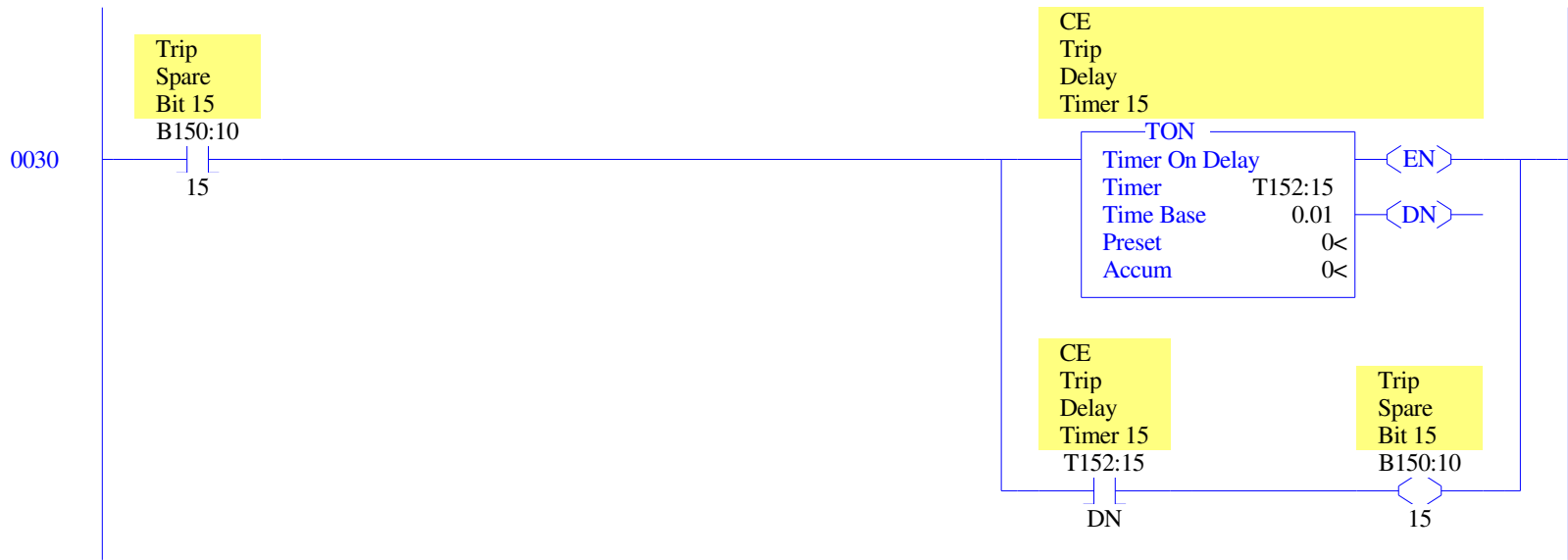






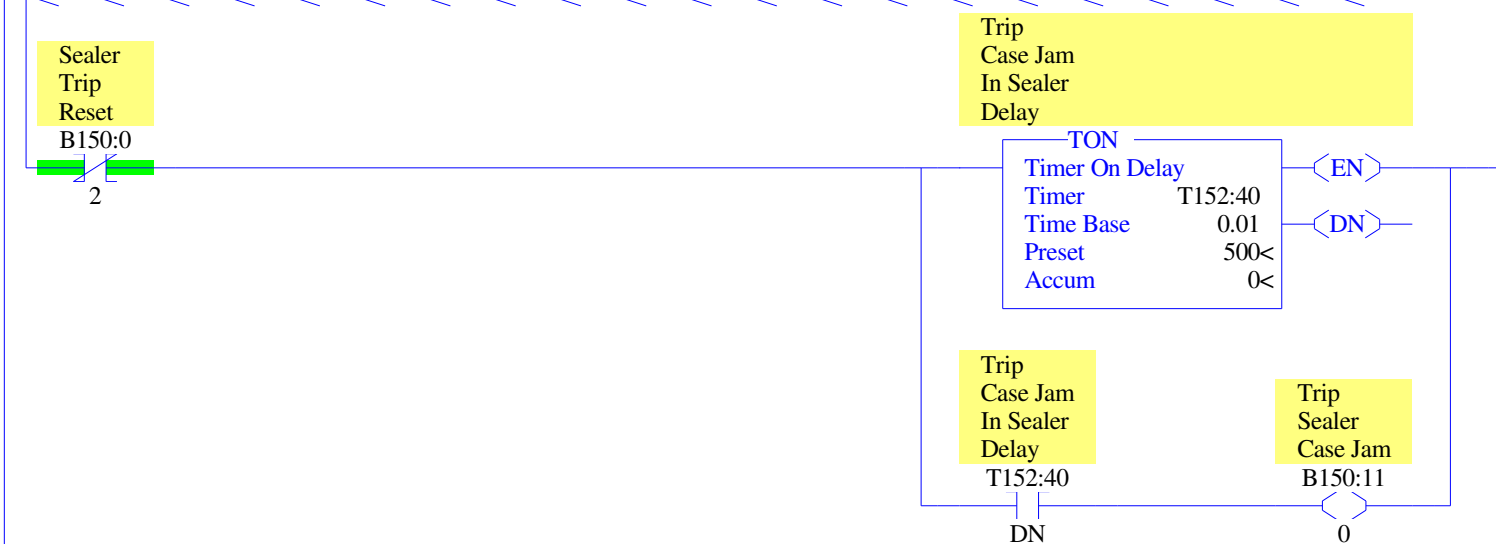
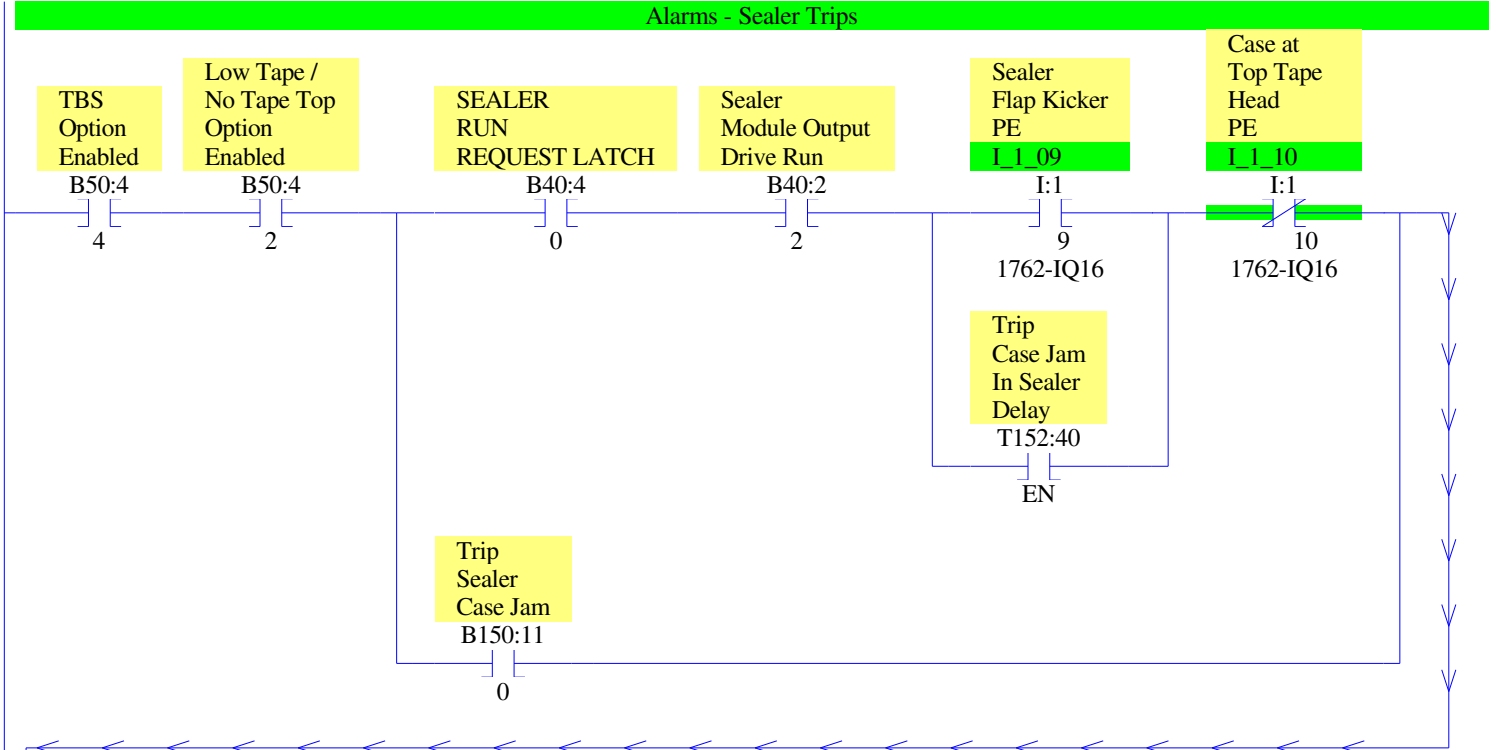




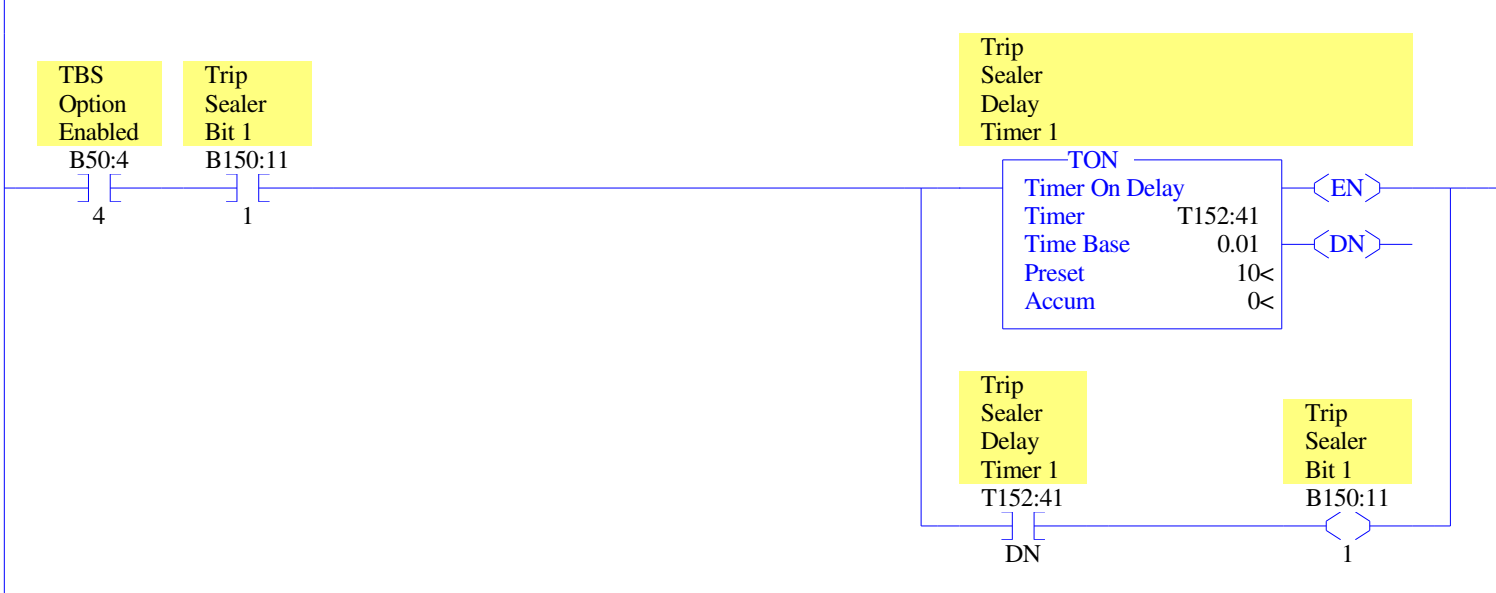


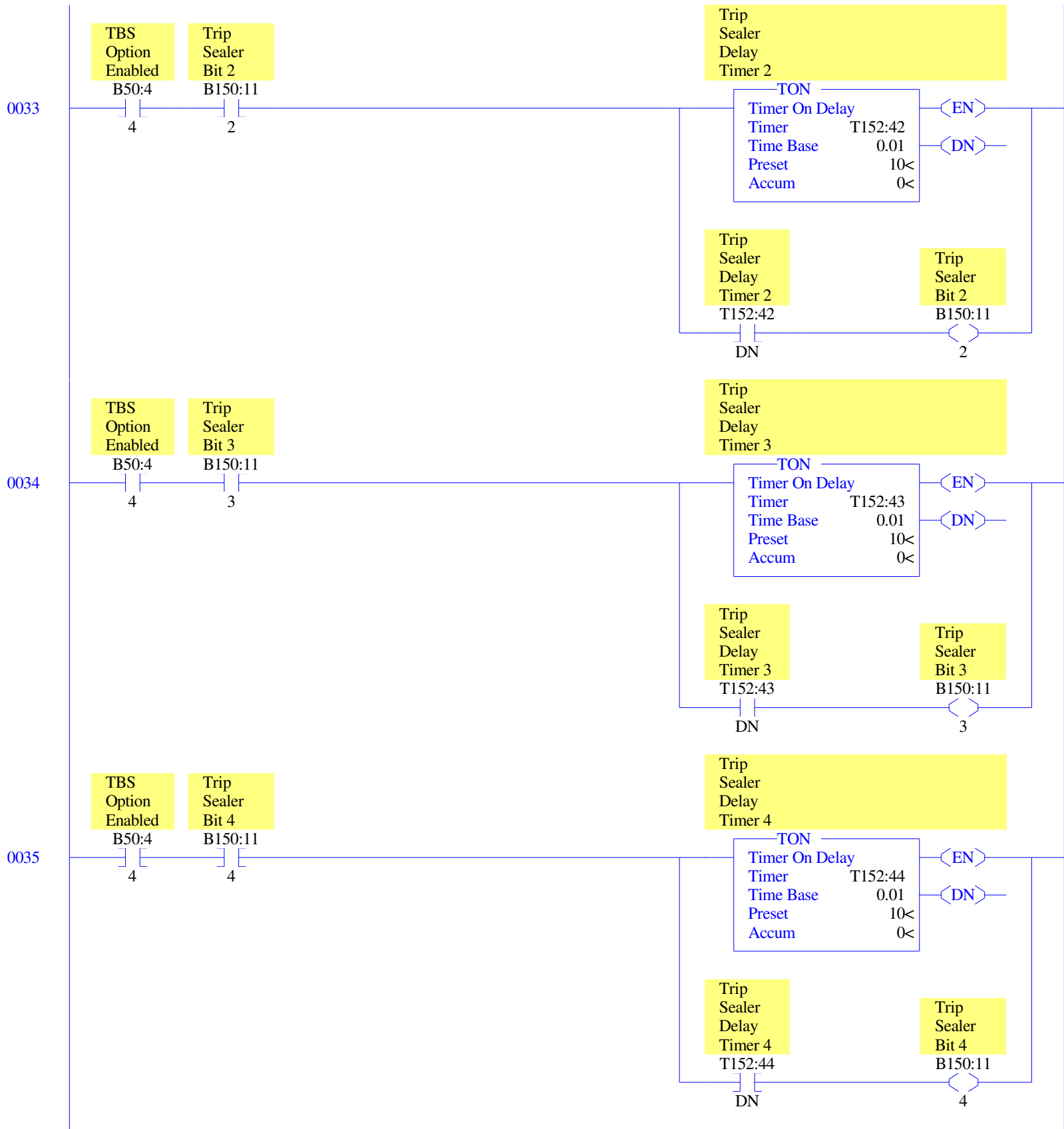
Alarms - Sealer Trips

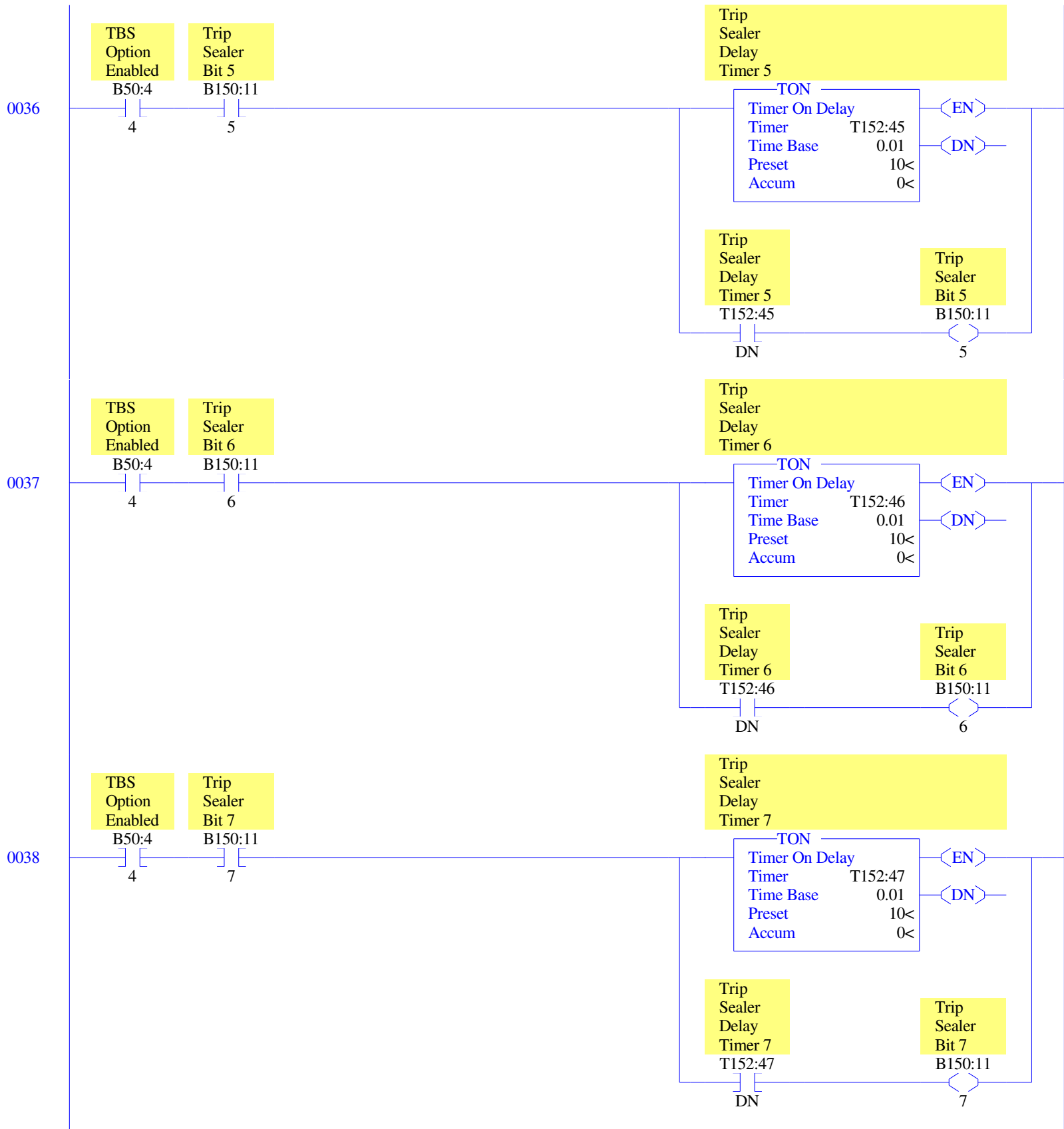
0031

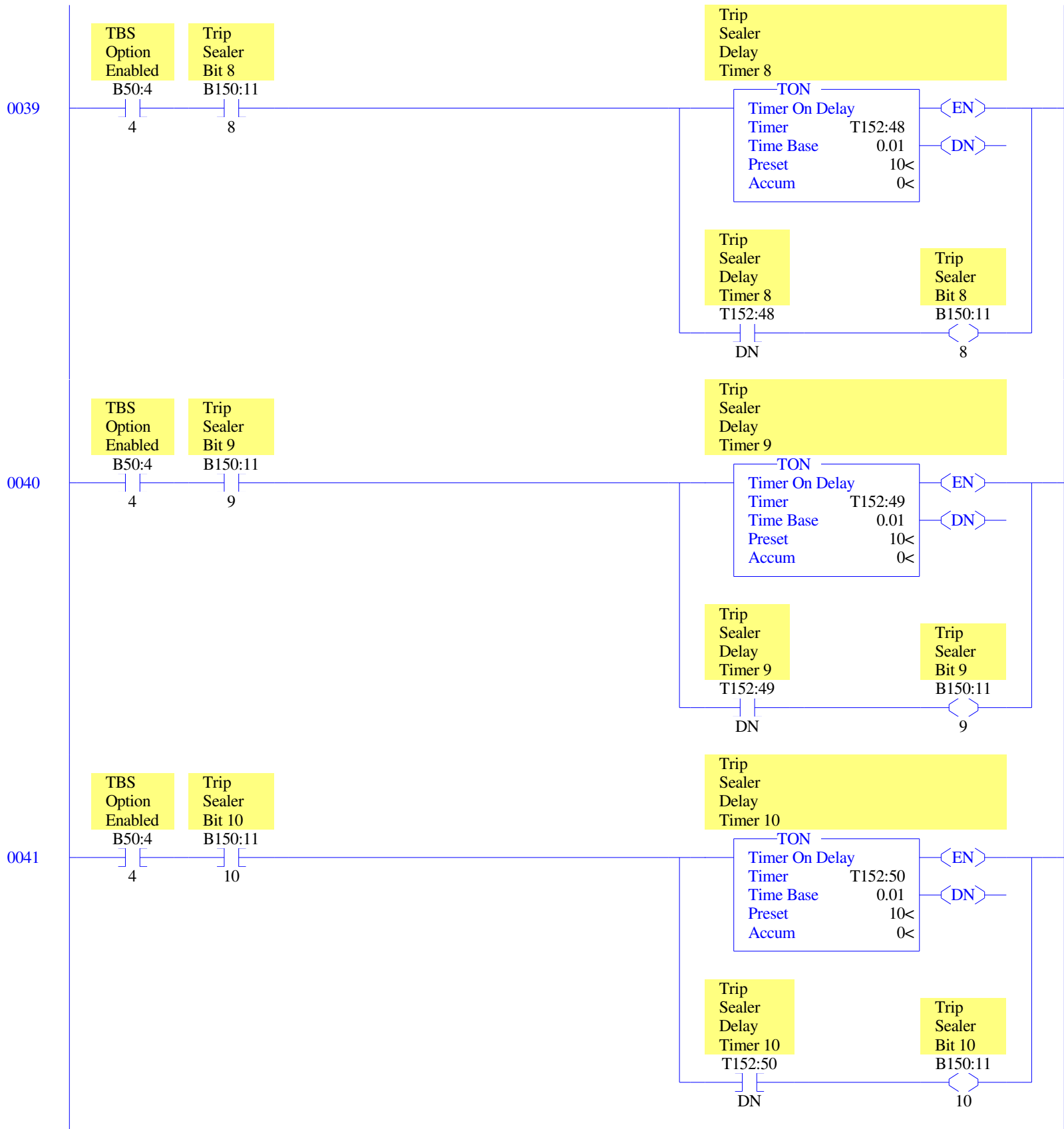


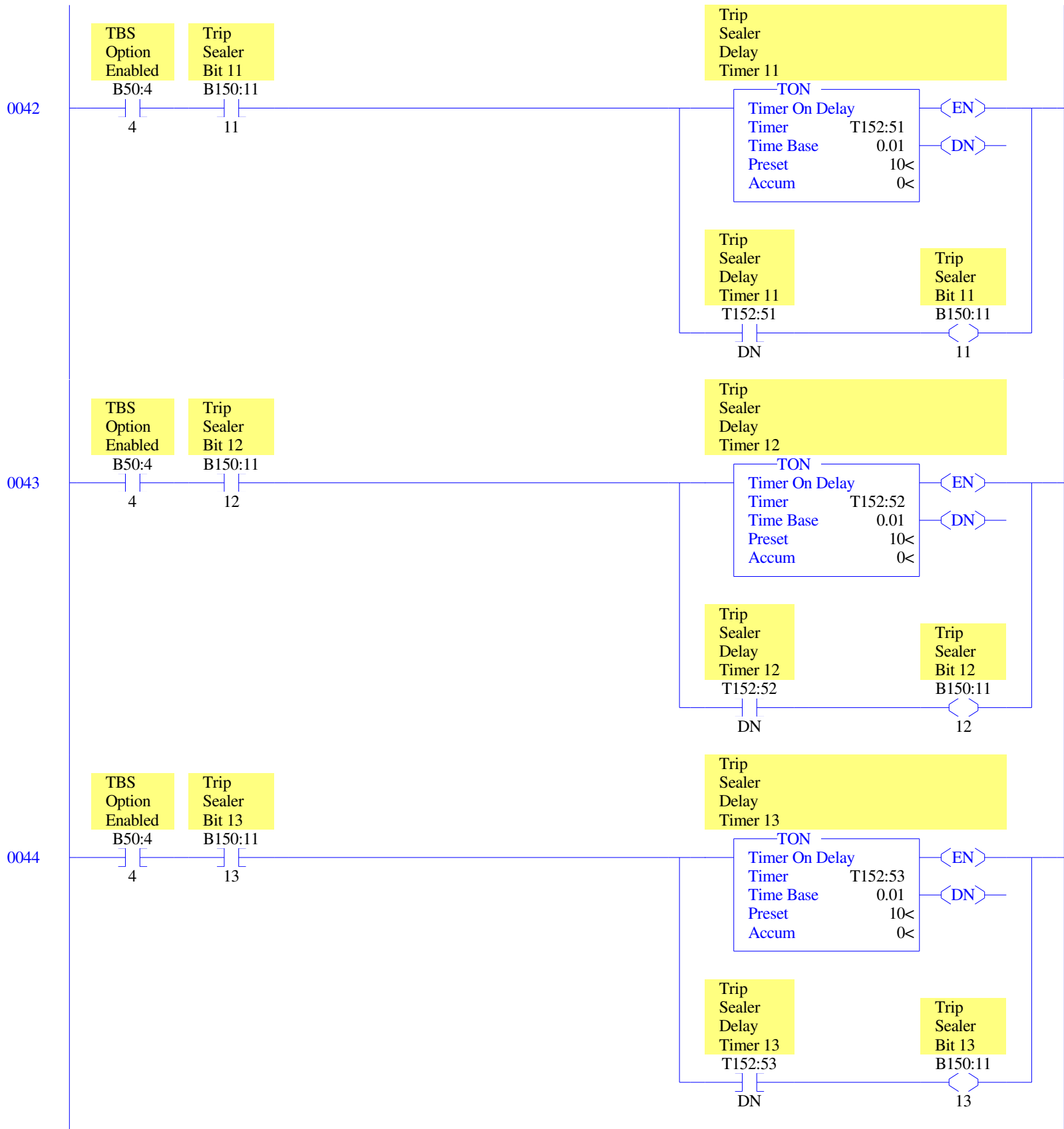
0032

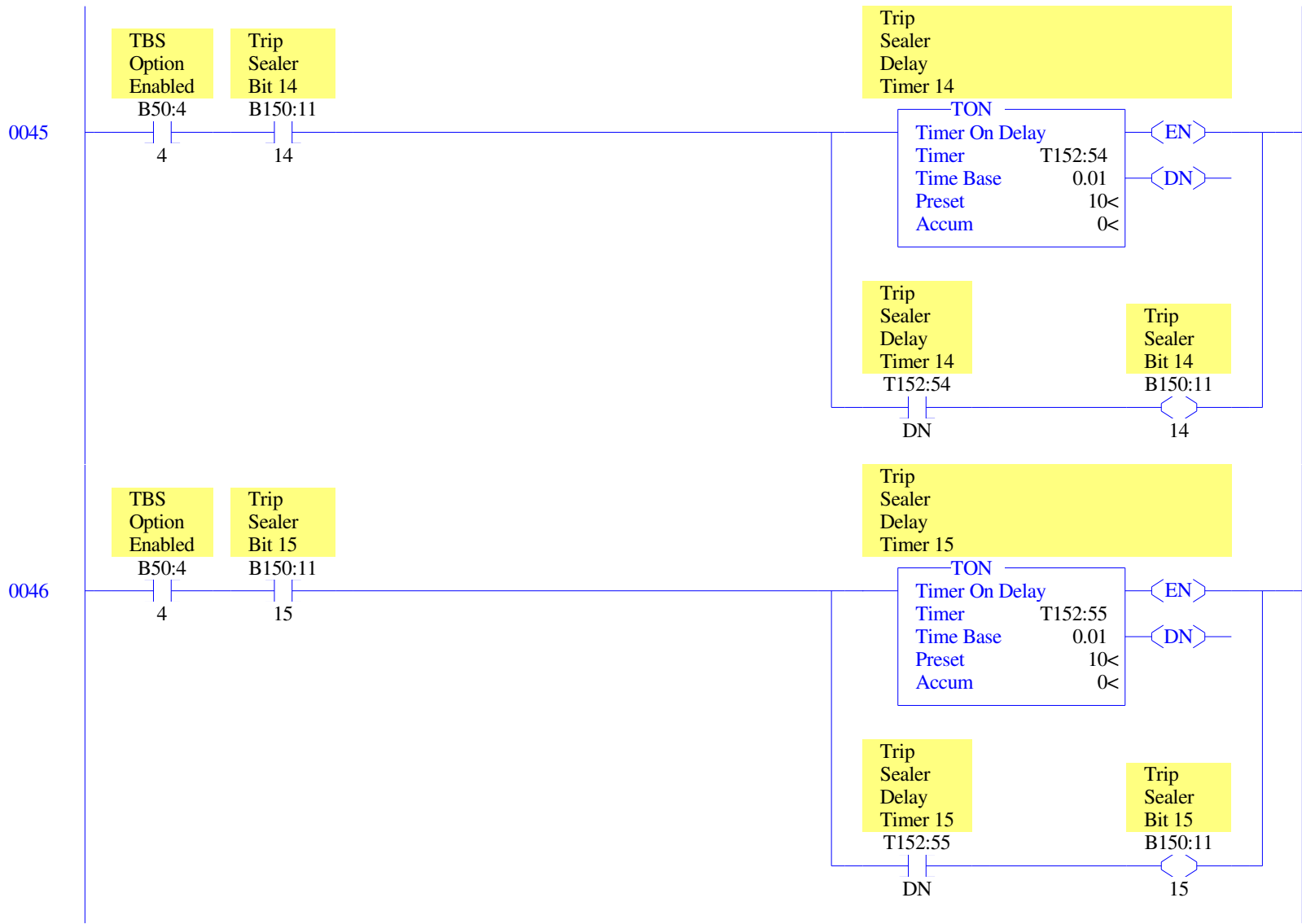




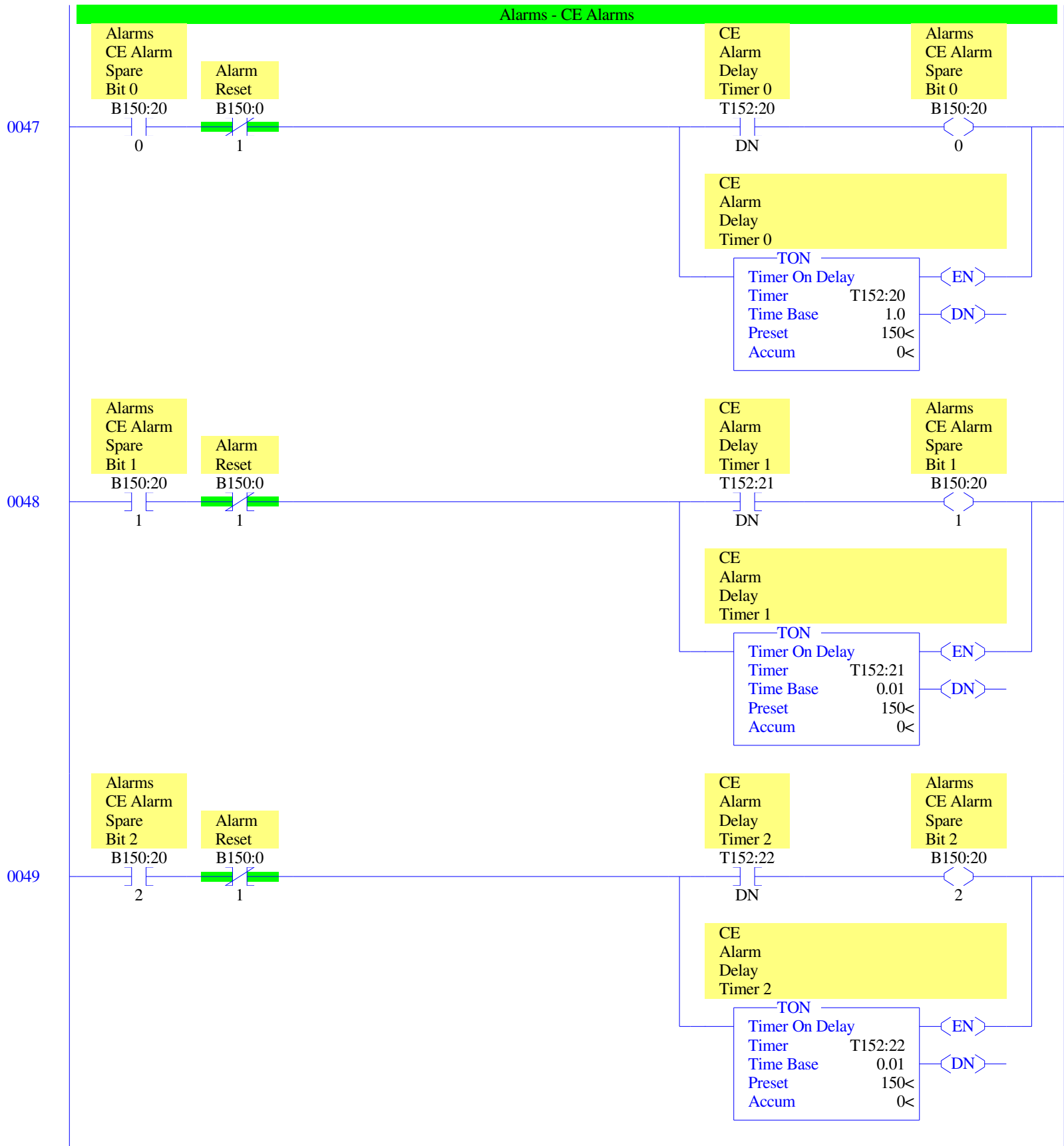


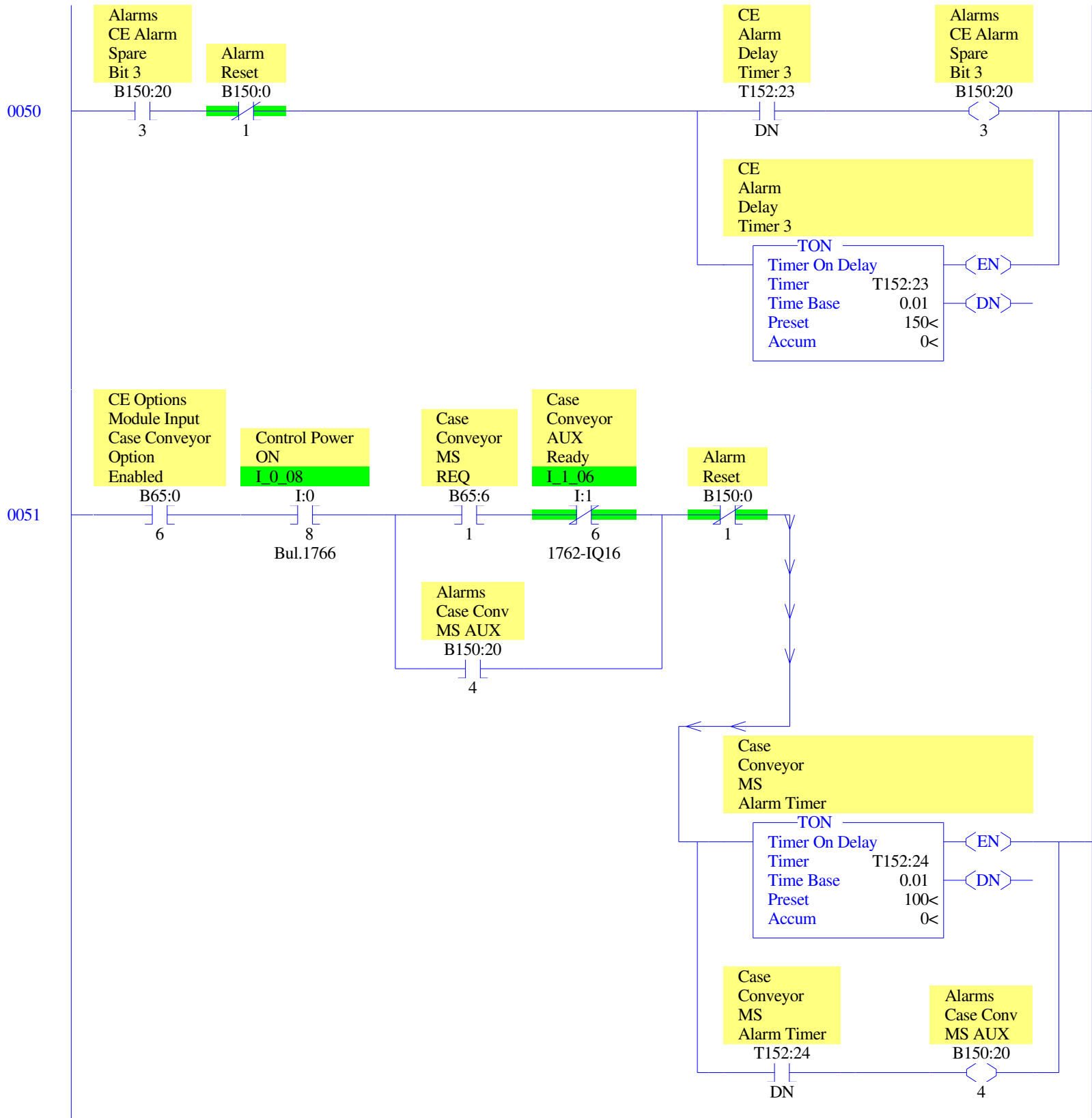


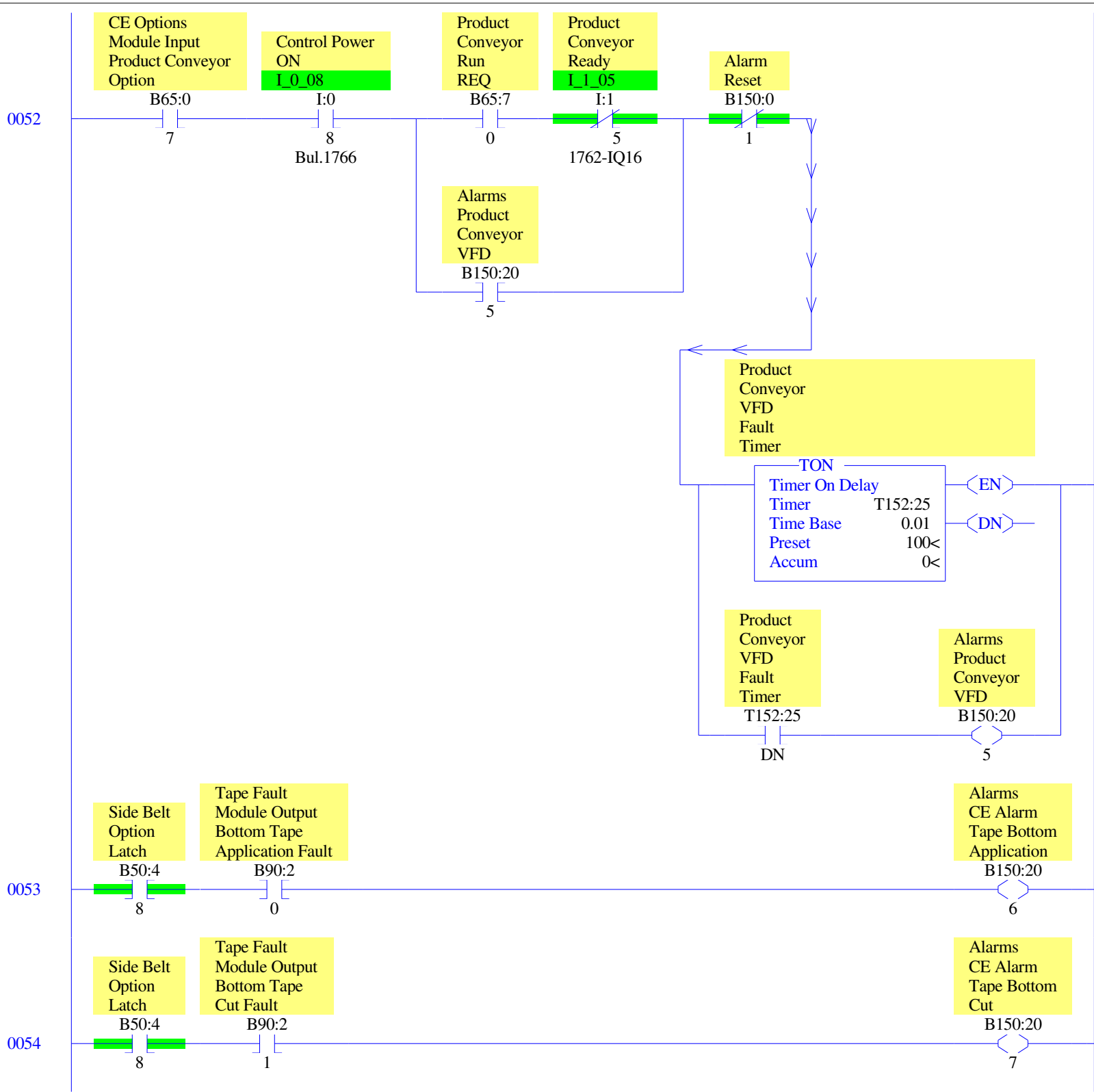


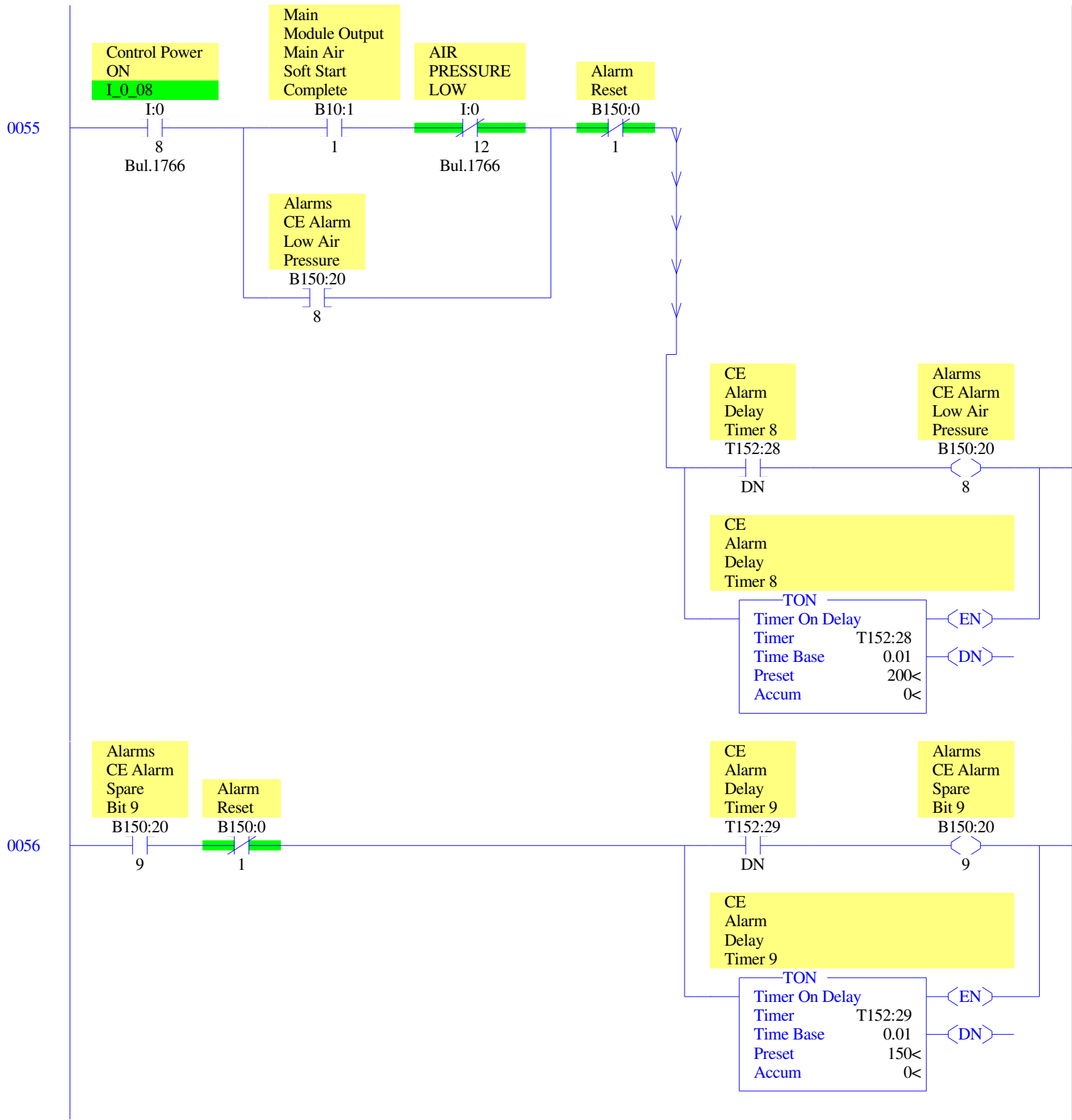


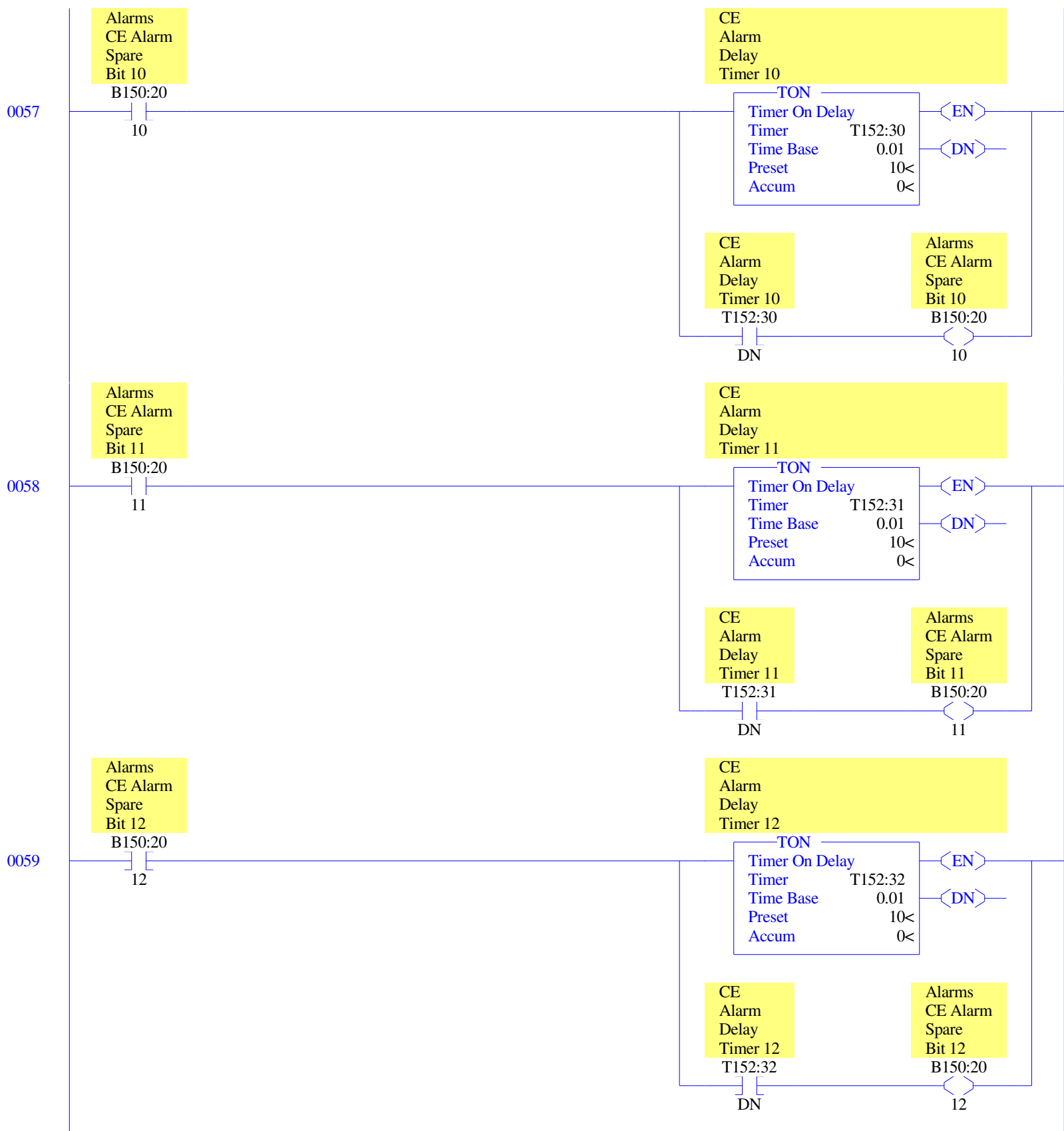
Alarms - CE Alarms

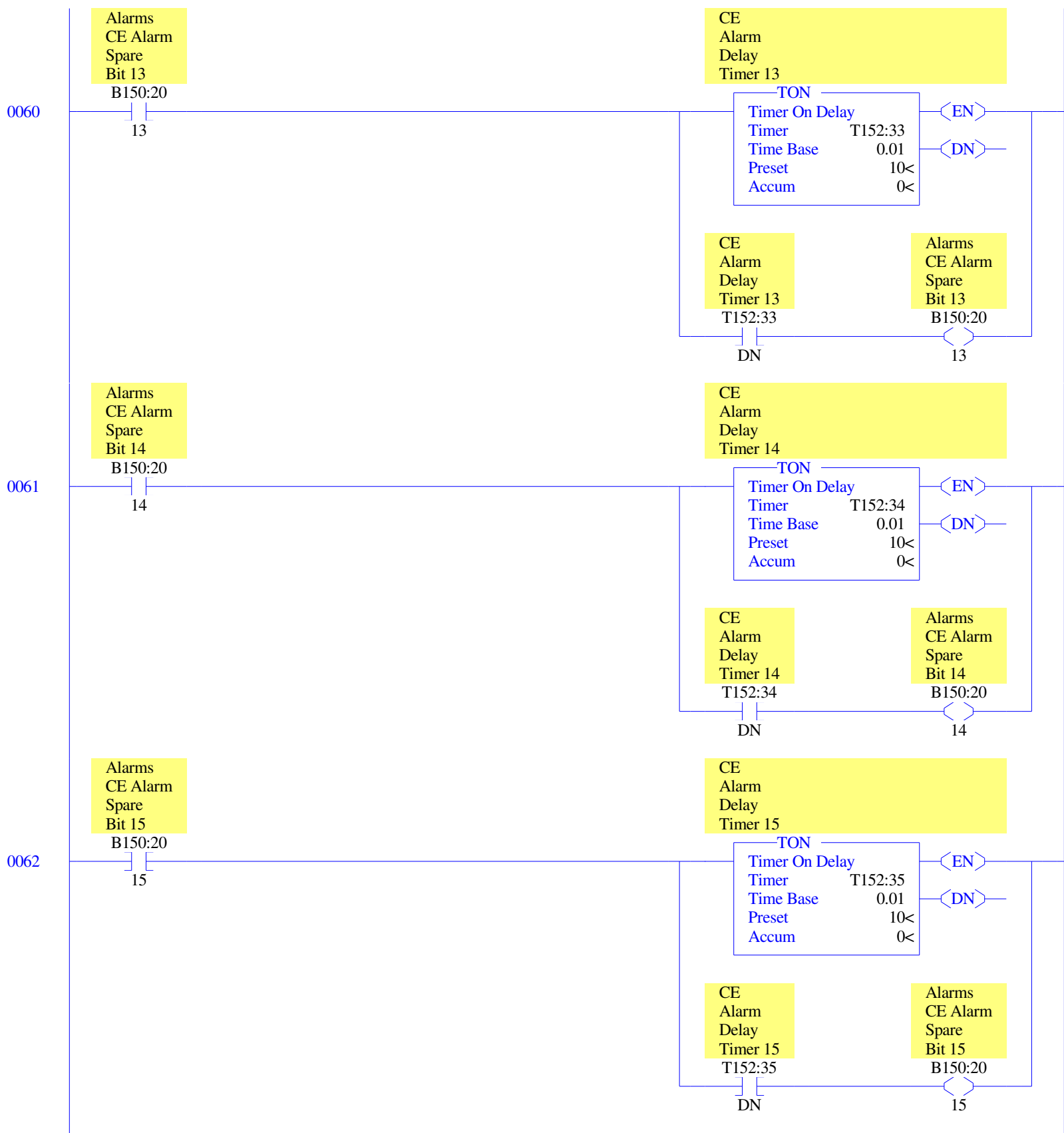


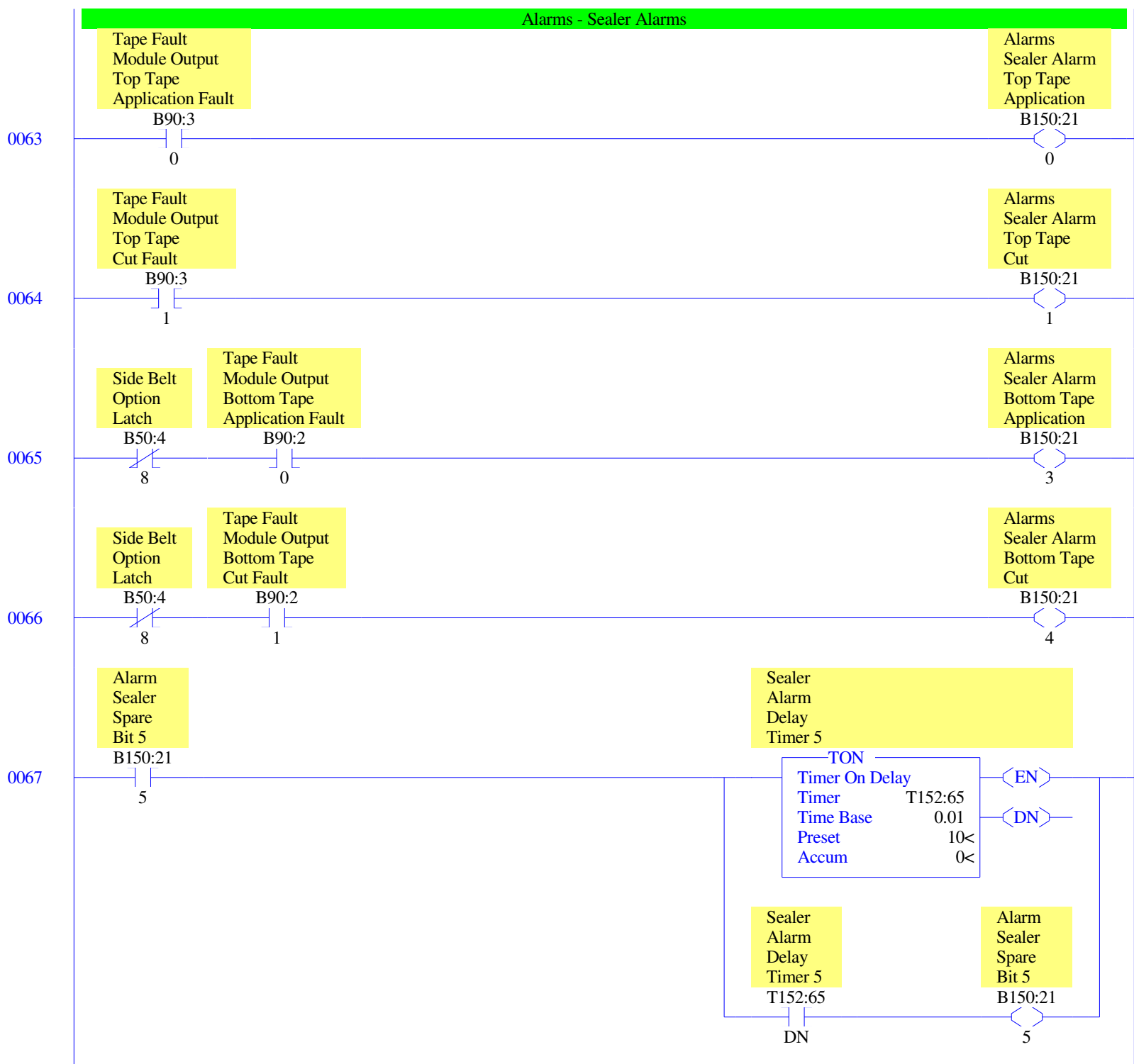


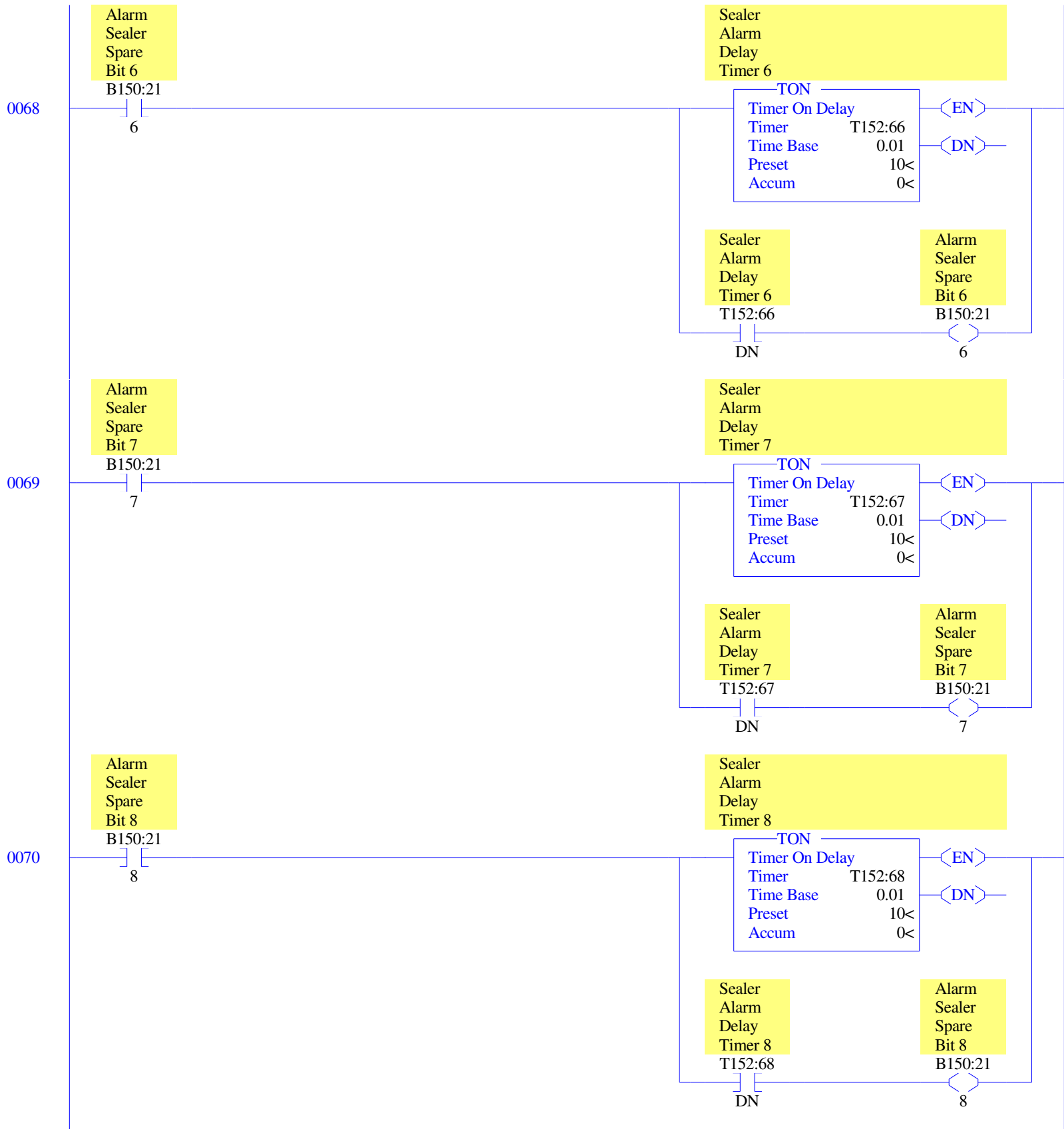


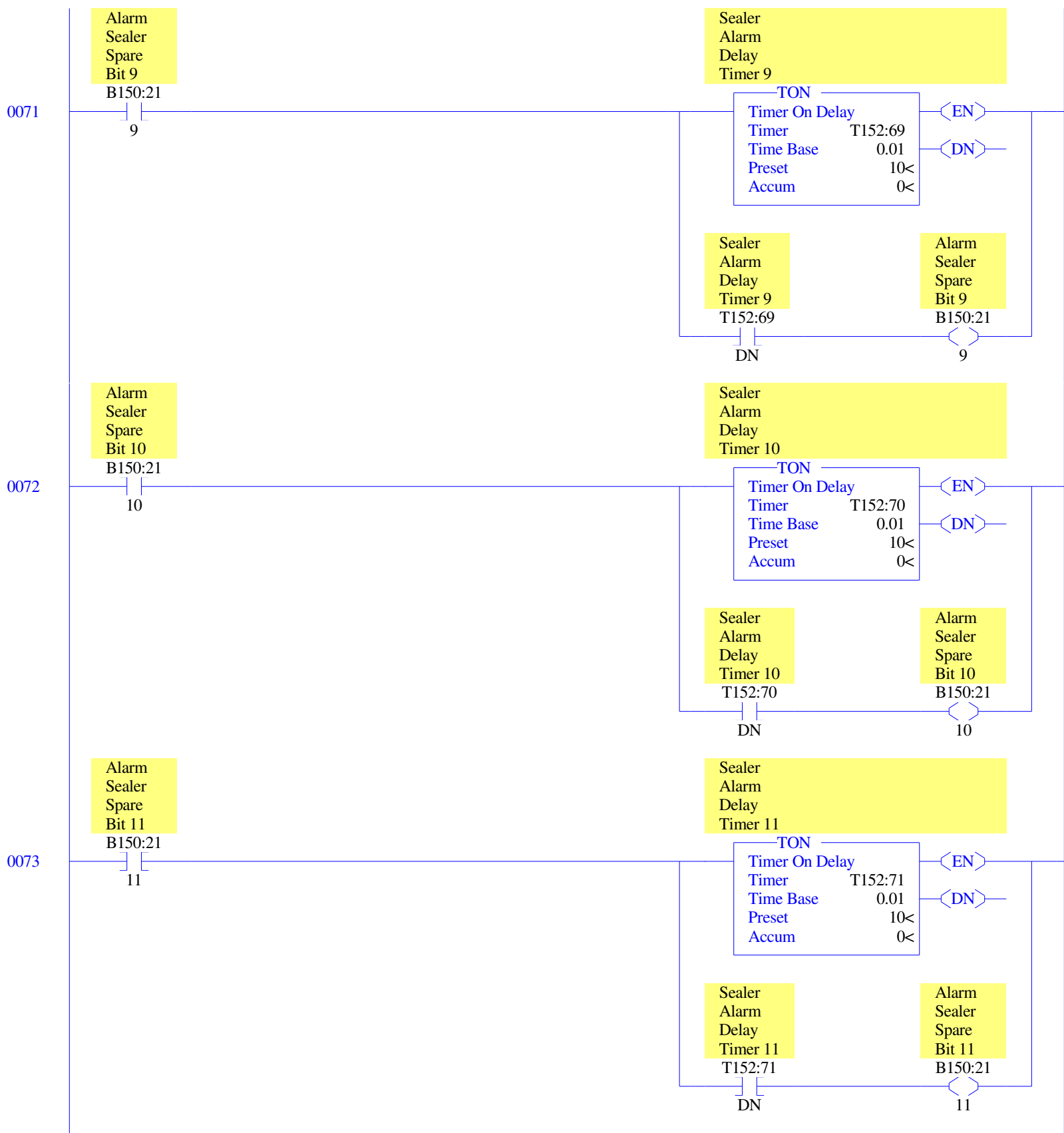


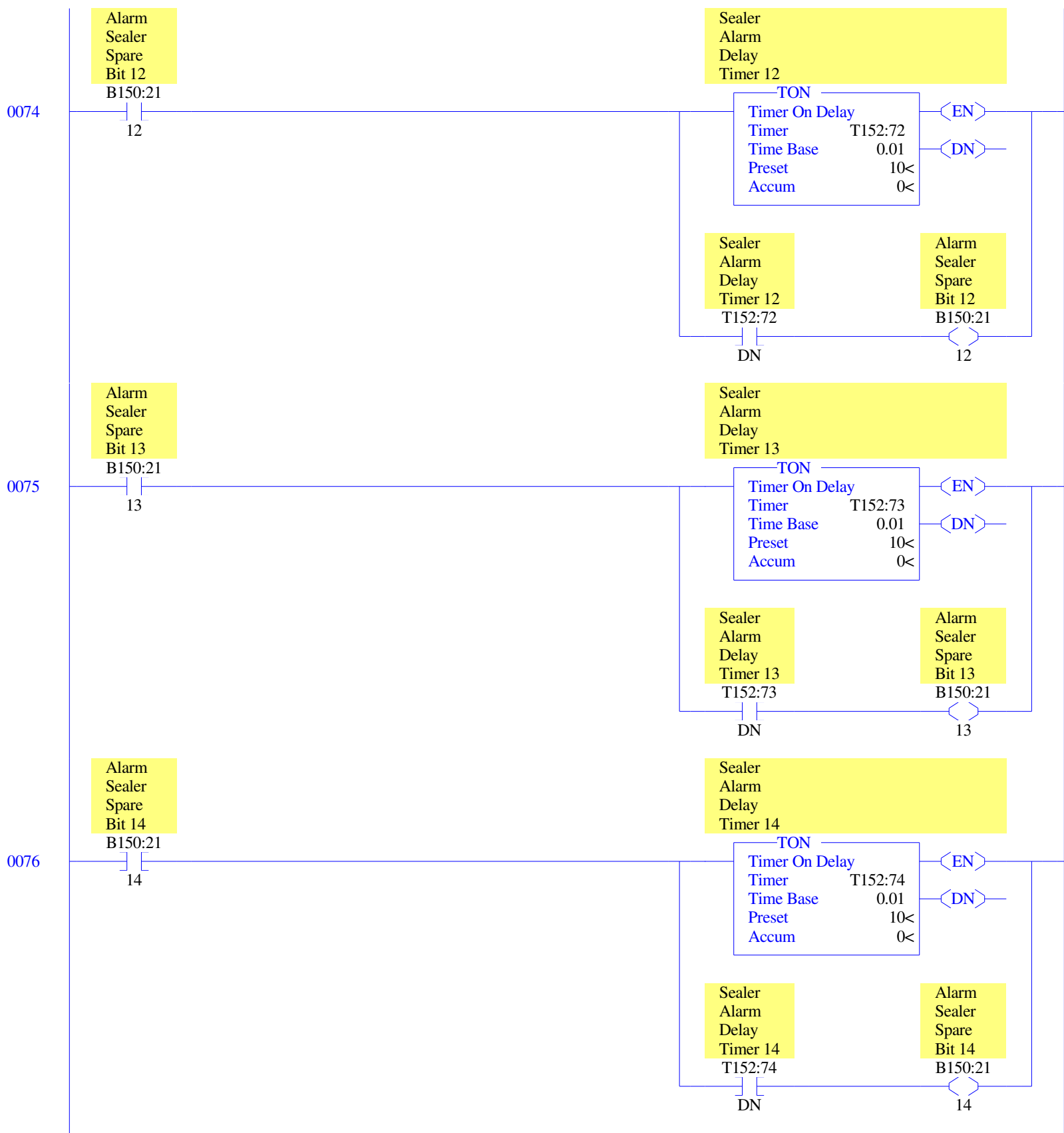


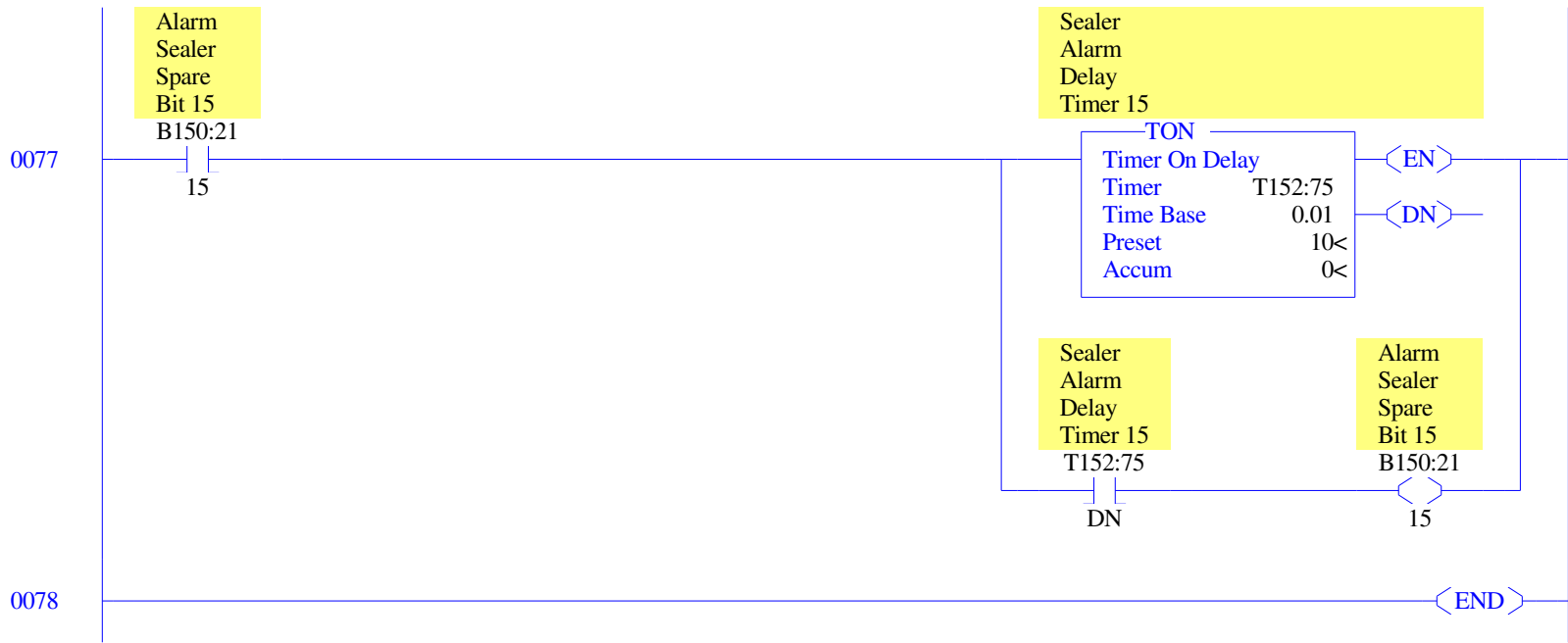


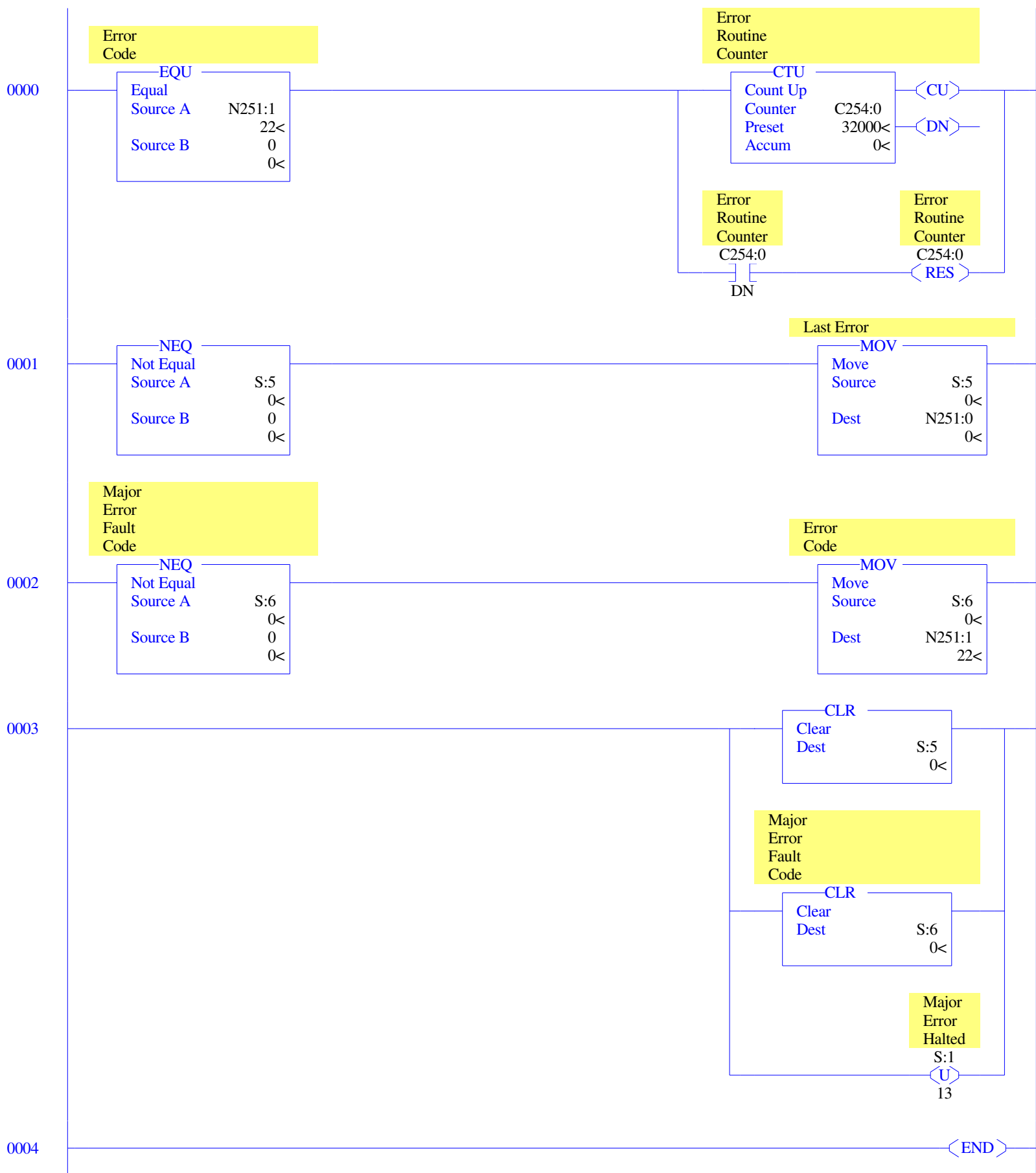












Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0		
O:0.0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Bul.1766	MicroLogix 1400 Series B
O:0.1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Bul.1766	MicroLogix 1400 Series B
O:0.2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Bul.1766	MicroLogix 1400 Series B
O:0.3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Bul.1766	MicroLogix 1400 Series B
O:0.4	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Bul.1766	MicroLogix 1400 Series B
O:0.5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Bul.1766	MicroLogix 1400 Series B
O:2.0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1762-OB16	- 16-Output (TRANS-SRC) 10/50 VDC
O:4.0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1762-OB16	- 16-Output (TRANS-SRC) 10/50 VDC

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0		
I:0.0	0	0	0	0	1	0	1	0	0	0	0	0	0	0	0	0	Bul.1766	MicroLogix 1400 Series B
I:0.1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Bul.1766	MicroLogix 1400 Series B
I:0.2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Bul.1766	MicroLogix 1400 Series B
I:0.3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Bul.1766	MicroLogix 1400 Series B
I:0.4	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Bul.1766	MicroLogix 1400 Series B
I:0.5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Bul.1766	MicroLogix 1400 Series B
I:0.6	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Bul.1766	MicroLogix 1400 Series B
I:0.7	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Bul.1766	MicroLogix 1400 Series B
I:1.0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1762-IQ16	- 16-Input 10/30 VDC
I:3.0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1762-IQ16	- 16-Input 10/30 VDC

Main

Processor Mode S:1/0 - S:1/4 = Remote Run
 On Power up Go To Run (Mode Behavior) S:1/12 = 1
 First Pass S:1/15 = No
 Free Running Clock S:4 = 1100-0000-0100-1011

Proc

OS Catalog Number S:57 = 1400 User Program Type S:63 = 9108h
 OS Series S:58 = B Compiler Revision Number S:64 =
 OS FRS S:59 =
 Processor Catalog Number S:60 =
 Processor Series S:61 = B
 Processor FRN S:62 =

Scan Times

Maximum (x10 ms) S:22 = 52
 Watchdog (x10 ms) S:3 (high byte) = 10
 Last 100 uSec Scan Time S:35 = 39
 Scan Toggle Bit S:33/9 = 1

Math

Math Overflow Selected S:2/14 = 0 Math Register (lo word) S:13 = 0
 Overflow Trap S:5/0 = 0 Math Register (high word) S:14-S:13 = 0
 Carry S:0/0 = 0 Math Register (32 Bit) S:14-S:13 = 0
 Overflow S:0/1 = 0
 Zero Bit S:0/2 = 1
 Sign Bit S:0/3 = 0

Chan 0

Processor Mode S:1/0- S:1/4 = Remote Run
 Node Address S:15 (low byte) = 0 Outgoing Msg Cmd Pending S:33/2 = 0
 Baud Rate S:15 (high byte) = ?
 Channel Mode S:33/3 = 0
 Comms Active S:33/4 = 0
 Incoming Cmd Pending S:33/0 = 0
 Msg Reply Pending S:33/1 = 0

Debug

Suspend Code S:7 = 0
 Suspend File S:8 = 0

Errors

Fault Override At Power Up S:1/8 = 1 Fault Routine S:29 = 50
 Startup Protection Fault S:1/9 = 1 Major Error S:6 = 0h
 Major Error Halt S:1/13 = 0
 Overflow Trap S:5/0 = 0 Error Description:
 Control Register Error S:5/2 = 0
 Major Error Executing User Fault Rtn. S:5/3 = 0
 Battery Low S:5/11 = 0
 Input Filter Selection Modified S:5/13 = 0
 ASCII String Manipulation error S:5/15 = 0

Protection

Deny Future Access S:1/14 = No
 Data File Overwrite Protection Lost S:36/10 = False

Mem Module

Memory Module Loaded On Boot S:5/8 = 0
 Password Mismatch S:5/9 = 0
 Load Memory Module On Memory Error S:1/10 = 1
 Load Memory Module Always S:1/11 = 1
 On Power up Go To Run (Mode Behavior) S:1/12 = 1
 Program Compare S:2/9 = 0
 Data File Overwrite Protection Lost S:36/10 = 0

Forces

Forces Enabled S:1/5 = Yes
Forces Installed S:1/6 = No

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B3:0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B3:1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B3:2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B3:3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B3:4	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B3:5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B3:6	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B3:7	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B3:8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B3:9	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B3:10	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	

Offset	EN	TT	DN	BASE	PRE	ACC	(Symbol)	Description
T4:0	0	0	0	.01 sec	200	0		

Offset	CU	CD	DN	OV	UN	UA	PRE	ACC	(Symbol)	Description
C5:0	0	0	1	1	0	0	32000	0		

Offset	EN	EU	DN	EM	ER	UL	IN	FD	LEN	POS	(Symbol) Description
R6:0	0	0	0	0	0	0	0	0	10	9	
R6:1	0	0	0	0	0	0	0	0	0	0	
R6:2	0	0	0	0	0	0	0	0	4	3	
R6:3	0	0	0	0	0	0	0	0	4	3	RUN TIME' MINUTES FFL CONTROL REG
R6:4	0	0	0	0	0	0	0	0	4	3	
R6:5	0	0	0	0	0	0	0	0	4	3	
R6:6	0	0	0	0	0	0	0	0	4	3	FAULT TIME' MINUTES FFL CONTROL REG
R6:7	0	0	0	0	0	0	0	0	4	3	
R6:8	0	0	0	0	0	0	0	0	4	3	
R6:9	0	0	0	0	0	0	0	0	4	3	IDLE TIME' MINUTES FFL CONTROL REG
R6:10	0	0	0	0	0	0	0	0	4	3	
R6:11	0	0	0	0	0	0	0	0	4	3	EFFICIENCY' FFL CONTROL REG
R6:12	0	0	0	0	0	0	0	0	4	3	MAX RUN TIME' SECONDS FFL CONTROL REG
R6:13	0	0	0	0	0	0	0	0	4	3	MAX RUN TIME' MINUTES FFL CONTROL REG
R6:14	0	0	0	0	0	0	0	0	4	3	
R6:15	0	0	0	0	0	0	0	0	4	3	SHIFT COUNT' FFL CONTROL REG

Offset	0	1	2	3	4	5	6	7	8	9
N7:0	1									

Offset	0	1	2	3	4
F8:0	3.3	501339			

Offset	LEN	String Text	(Symbol)	Description
ST9:0	3	DPI		

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B10:0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B10:1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B10:2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	

Offset	0	1	2	3	4	5	6	7	8	9
N11:0	0	0	0	0	0	0	0	0	0	0
N11:10	1033									

Offset	EN	TT	DN	BASE	PRE	ACC	(Symbol) Description
T12:0	0	0	0	.01 sec	400	0	MAIN AIR DELAY
T12:1	0	0	0	.01 sec	100	0	
T12:2	0	0	0	.01 sec	0	0	
T12:3	0	0	0	.01 sec	0	0	
T12:4	0	0	0	.01 sec	0	0	
T12:5	0	0	0	.01 sec	0	0	
T12:6	0	0	0	.01 sec	0	0	
T12:7	0	0	0	.01 sec	0	0	
T12:8	0	0	0	.01 sec	0	0	
T12:9	0	0	0	.01 sec	0	0	
T12:10	0	0	0	.01 sec	0	0	

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B20:0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	IO Status to HMI Word 0 Bits 0-15
B20:1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	IO Status to HMI Word 1 Bits 0-15
B20:2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	1	
B20:3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	
B20:4	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B20:5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B20:6	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	IO Enabled to HMI Word 0 Bits 0-15
B20:7	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	IO Enabled to HMI Word 1 Bits 0-15
B20:8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B20:9	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B20:10	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	

Data File N21 (dec) -- HMI_I -- HMI Integer File

Offset	0	1	2	3	4	5	6	7	8	9
N21:0	0	1	0	0	0	0	0	0	0	0
N21:10	0	0	0	0	0	0	0	0	0	0
N21:20	0	0	0	0	0	0	0	0	0	0
N21:30	0	0	0	0	0	0	0	0	0	0

Offset	EN	TT	DN	BASE	PRE	ACC	(Symbol) Description
T22:0	1	1	0	.01 sec	200	125	FAULT DISPLAY TIME
T22:1	0	0	0	.01 sec	100	0	FAULT CLEAR DELAY
T22:2	0	0	0	.01 sec	0	0	
T22:3	0	0	0	1.0 sec	32767	3609	Admin Logged In Time
T22:4	0	0	0	.01 sec	0	0	
T22:5	0	0	0	.01 sec	10	0	Recipe Load Delay
T22:6	0	0	0	.01 sec	10	0	Load Complete Delay
T22:7	0	0	0	.01 sec	10	0	Recipe Load Delay
T22:8	0	0	0	.01 sec	10	0	Load Complete Delay
T22:9	0	0	0	.01 sec	0	0	
T22:10	0	0	0	.01 sec	400	0	
T22:11	0	0	0	.01 sec	0	0	
T22:12	0	0	0	.01 sec	0	0	
T22:13	0	0	0	.01 sec	0	0	
T22:14	0	0	0	.01 sec	0	0	

Offset	LEN	String Text	(Symbol)	Description	
ST23:0	0				Current
ST23:1	0				Current
ST23:2	1	1			Current
ST23:3	1	2			Current
ST23:4	1	3			Current

Data File N24 (dec) -- HMI_I -- HMI Indirect Addressing Control File

Offset	0	1	2	3	4	5	6	7	8	9
N24:0	1	1	20	0	0	0	0	0	0	0
N24:10	1									

Offset	0	1	2	3	4
F25:0	350000	3600000			

Offset	LEN	String Text	(Symbol)	Description
ST29:0	1	3		
ST29:1	37	Blue stax case 11 3/4 x 7 1/2 x 6 5/8		
ST29:2	1	2		
ST29:3	1	3		
ST29:4	0			
ST29:5	0			
ST29:6	0			
ST29:7	0			
ST29:8	0			
ST29:9	0			
ST29:10	0			
ST29:11	1	3		

Recipe 1

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B30:0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B30:1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Manual Mode Generic HMI PB
B30:2	0	0	0	0	0	0	0	0	0	0	0	1	0	0	0	0	Manual Mode Operations
B30:3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Manual Mode HMI PBs Word 1
B30:4	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Manual Mode Output REQ ONS
B30:5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Manual Mode Output REQ SWP
B30:6	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Manual Mode Latched Outputs Word 1
B30:7	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Manual Mode HMI PBs Word 2
B30:8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Manual Mode Output REQ ONS
B30:9	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Manual Mode Output REQ SWP
B30:10	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Manual Mode Latched Outputs Word 2
B30:11	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Manual Mode HMI PBs Word 3
B30:12	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Manual Mode Output REQ ONS
B30:13	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Manual Mode Output REQ SWP
B30:14	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Manual Mode Latched Outputs Word 3

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B40:0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B40:1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B40:2	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B40:3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B40:4	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	

Offset	0	1	2	3	4	5	6	7	8	9
N41:0	1									

Offset	EN	TT	DN	BASE	PRE	ACC	(Symbol) Description
T42:0	0	0	0	.01 sec	200	0	INDEX GATE DROP DELAY
T42:1	0	0	0	.01 sec	500	0	SEALER STOP DLAY
T42:2	0	0	0	.01 sec	0	0	
T42:3	0	0	0	.01 sec	0	0	
T42:4	0	0	0	.01 sec	100	0	Sealer Drive Speed 2 Slow Duration Timer
T42:5	0	0	0	.01 sec	100	0	Sealer Drive Speed 2 Slow REQ Delay timer
T42:6	0	0	0	.01 sec	0	0	
T42:7	0	0	0	.01 sec	0	0	
T42:8	0	0	0	.01 sec	0	0	
T42:9	0	0	0	.01 sec	0	0	
T42:10	0	0	0	.01 sec	0	0	Sealer Hot Melt Kicker Delay
T42:11	0	0	0	.01 sec	50	0	Sealer Hot Melt Kicker Extend Time
T42:12	0	0	0	.01 sec	0	0	
T42:13	0	0	0	.01 sec	0	0	
T42:14	0	0	0	.01 sec	0	0	
T42:15	0	0	0	.01 sec	0	0	
T42:16	0	0	0	.01 sec	0	0	

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B45:0	0	0	0	0	0	0	0	0	0	0	0	1	0	1	0	0	
B45:1	0	0	0	0	0	0	0	0	0	0	0	1	0	0	0	0	
B45:2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B45:3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B45:4	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	
B45:5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	

Offset	0	1	2	3	4	5	6	7	8	9
N46:0	7	46	7	0	15	0	23	0	0	0
N46:10	0	0	0	0	0	0	0	0	0	0
N46:20	2096	480	479	0	0	1616	0	0	0	0
N46:30	0	0	0	0	0	0	0	0	0	0
N46:40	0	0	0	0	0	0	0	0	0	0
N46:50	0	0	0	0	0	0	0	0	0	0
N46:60	0	0	0	0	0	0	0	0	0	0
N46:70	0	0	0	0	0	0	0	0	0	0
N46:80	0	0	0	0	0	0	0	0	0	0
N46:90	0	0	0	0	0	0	0	0	0	0
N46:100	1	44	0	0	0	0	0	0	0	0
N46:110	0	0	0	0	0	0	0	0	0	0
N46:120	0	0	0	0	0	0	0	0	0	0
N46:130	7	59	8	0	34	56	0	0	0	0
N46:140	0	0	0	0	0	0	0	0	0	0
N46:150	0	0	0	0	0	0	0	0	0	0
N46:160	0	0	0	0	0	0	0	0	0	0
N46:170	0	0	0	0	0	0	0	0	0	0
N46:180	0	0	0	0	0	0	0	0	0	0
N46:190	0	0	0	0	0	0	0	0	0	0
N46:200	8	45	43	2013	11	5	2016	0	9	0
N46:210	29									

Offset	EN	TT	DN	BASE	PRE	ACC	(Symbol) Description
T47:0	0	0	0	1.0 sec	60	0	(CRT_ACC) RUN TIME' ACCUM TMR (SECONDS)
T47:1	1	1	0	1.0 sec	60	50	(CFT_ACC) FAULT TIME' ACCUM TMR (SECONDS)
T47:2	0	0	0	1.0 sec	60	0	(CIT_ACC) IDLE TIME' ACCUM TMR (SECONDS)
T47:3	0	0	0	.01 sec	12000	0	(PRODRATE_EVAL) PRODUCTION RATE' EVALUATION TMR
T47:4	0	0	0	.01 sec	0	0	
T47:5	0	0	0	.01 sec	500	0	FIRST SHIFT ACTIVE DLAY TMR
T47:6	0	0	0	.01 sec	500	0	SECOND SHIFT ACTIVE DLAY TMR
T47:7	0	0	0	.01 sec	500	0	THIRD SHIFT ACTIVE DLAY TMR
T47:8	1	1	0	1.0 sec	60	11	(SHFT_TIME) RUNNING TIMER FOR THE CURRENT SHIFT
T47:9	0	0	0	.01 sec	0	0	
T47:10	0	0	0	.01 sec	6000	0	SHIFT CHANGE ACTIVE DURATION TIMER
T47:11	0	0	0	.01 sec	0	0	
T47:12	0	0	0	.01 sec	0	0	
T47:13	0	0	0	.01 sec	0	0	
T47:14	0	0	0	.01 sec	0	0	
T47:15	0	0	0	.01 sec	0	0	
T47:16	0	0	0	.01 sec	0	0	
T47:17	0	0	0	.01 sec	0	0	
T47:18	0	0	0	.01 sec	0	0	
T47:19	0	0	0	.01 sec	0	0	
T47:20	0	0	0	.01 sec	6000	4039	Total Machine Run Time Seconds

Offset	CU	CD	DN	OV	UN	UA	PRE	ACC	(Symbol)	Description
C48:0	0	0	1	0	0	0	0	0	(CRT_MIN_ACC)	RUN TIME' ACCUM TIME (MINUTES)
C48:1	0	0	1	0	0	0	0	0		
C48:2	0	0	1	0	0	0	0	104	(CFT_MIN_ACC)	FAULT TIME' ACCUM TIME (MINUTES)
C48:3	0	0	1	0	0	0	0	1		
C48:4	0	0	1	0	0	0	0	0	(CIT_MIN_ACC)	IDLE TIME' ACCUM TIME (MINUTES)
C48:5	0	0	1	0	0	0	0	0		
C48:6	0	0	0	0	0	0	1000	0	(TOTAL_CYCLES_LOW)	MACHINE CYCLE COUNT 1 - 1000
C48:7	0	0	0	0	0	0	10000	0	(TOTAL_CYCLES_HIGH)	MACHINE CYCLE COUNT 1,000 - 10000000
C48:8	0	0	1	0	0	0	0	104	(SHIFT_MIN)	MINUTES FOR CURRENT SHIFT
C48:9	0	0	1	0	0	0	0	0	(SHIFT_CYCLE)	SHIFT CYCLE COUNT' CNTR
C48:10	0	0	0	0	0	0	32000	0		Resettable CYCLE COUNT CNTR

Data File F49 -- PRODATA_F -- Production Data Floating Point File

Offset	0	1	2	3	4
F49:0	0	0	0	0	0
F49:5	1.000002	1.000002	0	0	0
F49:10	0	0			

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B50:0	0	0	0	0	0	0	0	0	0	1	0	0	0	0	1	0	
B50:1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	CE Machine Options PB
B50:2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	CE Machine Options ONS
B50:3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	CE Machine Options SWP
B50:4	0	0	0	0	0	0	0	1	0	0	1	0	0	0	0	0	CE Machine Options
B50:5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	
B50:6	0	0	0	0	0	0	0	0	0	0	0	0	1	0	0	0	
B50:7	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B50:8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	CE Machine Options PB 2
B50:9	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	CE Machine Options ONS 2
B50:10	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	CE Machine Options SWP 2
B50:11	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	CE Machine Options 2
B50:12	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B50:13	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B50:14	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	

Data File N51 (dec) -- CE_MAIN_I -- CE Main Integer File

Offset	0	1	2	3	4	5	6	7	8	9
N51:0	288	0								

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B55:0	0	0	1	1	0	0	0	0	0	1	1	0	0	1	0	0	CE Inputs
B55:1	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	CE Inputs
B55:2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	CE Outputs
B55:3	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	CE Outputs
B55:4	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	CE Step Bits
B55:5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	CE Reset Bits
B55:6	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Call for Case Control Bits
B55:7	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B55:8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B55:9	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B55:10	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	CE Cycle Alarm Bits
B55:11	0	1	1	0	0	0	0	0	0	0	0	0	0	0	0	0	
B55:12	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B55:13	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B55:14	0	0	0	0	0	0	0	0	1	0	0	0	0	0	0	0	
B55:15	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	

Offset	EN	TT	DN	BASE	PRE	ACC	(Symbol) Description
T57:0	0	0	0	1.0 sec	3	0	CE Cycle Dry Cycle Timer
T57:1	0	0	0	.01 sec	0	0	VACUUM PLATE EXTEND DELAY
T57:2	0	0	0	.01 sec	10	0	VACUUM PLATE RETRACT DELAY
T57:3	0	0	0	.01 sec	5	0	SQUARING EXTEND DELAY
T57:4	0	0	0	.01 sec	10	0	TRAILING MINOR FLAP EXTEND DELAY
T57:5	0	0	0	.01 sec	0	0	READY FOR CASE PUSH DELAY
T57:6	0	0	0	.01 sec	10	0	Carriage EXTEND DELAY
T57:7	0	0	0	.01 sec	5	0	CARRIAGE EXTENDED DURATION TMR
T57:8	0	0	0	.01 sec	20	0	VACUUM BLOWOFF DURATION
T57:9	0	0	0	.01 sec	0	0	RETRACT Carriage DELAY
T57:10	0	0	0	.01 sec	0	0	Carriage RETRACTING DELAY TMR
T57:11	0	0	0	.01 sec	0	0	Carriage RETRACTED DELAY TIMER
T57:12	0	0	0	.01 sec	5	0	INCR MISSED CASE CNTR TMR
T57:13	0	0	0	.01 sec	2	0	CASE ERECTOR STATE RESET TMR
T57:14	0	0	0	.01 sec	100	0	
T57:15	0	0	0	.01 sec	200	0	
T57:16	0	0	0	.01 sec	300	0	
T57:17	0	0	0	.01 sec	300	0	
T57:18	0	0	0	.01 sec	0	0	Call for Case Continuous Mode Pacing Timer
T57:19	0	0	0	.01 sec	250	0	
T57:20	0	0	0	.01 sec	100	0	DISCHARGE BACKUP DELAY
T57:21	0	0	0	.01 sec	300	0	
T57:22	0	0	0	.01 sec	100	0	
T57:23	1	0	1	.01 sec	100	100	DELAY SIDE BELT SLOW SPEED
T57:24	0	0	0	.01 sec	10	0	VACUUM BLOW OFF DELAY TIMER (Case Release Dly)
T57:25	1	0	1	.01 sec	10	10	VACUUM OFF DELAY
T57:26	0	0	0	.01 sec	15	0	DELAY MAJOR FLAPS
T57:27	0	0	0	.01 sec	400	0	SIDEBELT STOP DELAY
T57:28	0	0	0	.01 sec	65	0	DELAY TIMER 1 FOR TAPE WIPE SLOW DOWN
T57:29	0	0	0	.01 sec	175	0	SIDE BELT SLOW SPEED DURATION
T57:30	0	0	0	.01 sec	10	0	Sidebelt Stop Case in Place Delay Timer
T57:31	0	0	0	.01 sec	50	0	Call for Case Cancel Timer
T57:32	0	0	0	.01 sec	20	0	Opposite Hand Enabled SWP
T57:33	0	0	0	.01 sec	10	0	
T57:34	0	0	0	.01 sec	10	0	
T57:35	0	0	0	.01 sec	100	0	Vacuum Blowoff Time
T57:36	0	0	0	.01 sec	300	0	
T57:37	0	0	0	.01 sec	0	0	
T57:38	0	0	0	.01 sec	0	0	
T57:39	0	0	0	.01 sec	0	0	
T57:40	0	0	0	.01 sec	0	0	
T57:41	0	0	0	.01 sec	0	0	
T57:42	0	0	0	.01 sec	0	0	
T57:43	0	0	0	.01 sec	0	0	
T57:44	0	0	0	.01 sec	0	0	
T57:45	0	0	0	.01 sec	0	0	
T57:46	0	0	0	.01 sec	0	0	
T57:47	0	0	0	.01 sec	0	0	
T57:48	0	0	0	.01 sec	0	0	
T57:49	0	0	0	.01 sec	0	0	

Offset	CU	CD	DN	OV	UN	UA	PRE	ACC	(Symbol) Description
C58:0	0	0	0	0	0	0	4	0	CASE PICK ATTEMPT CNTR
C58:1	0	0	0	0	0	0	2	0	Continuous Run Mode Counter
C58:2	0	0	0	0	0	0	10	0	POWER MAGAZINE CASE FAULT LEFT
C58:3	0	0	0	0	0	0	10	0	MAGAZINE CASE FAULT RIGHT

Data File F59 -- CE_CYCLE_F -- CE Cycle Floating Point File

Offset	0	1	2	3	4
F59:0	-10	-0.01507531	-12		

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B60:0	0	0	0	0	0	0	0	0	0	0	0	0	1	0	0	0	
B60:1	0	0	0	0	0	1	0	0	0	0	0	0	0	0	0	0	
B60:2	1	0	0	0	0	0	0	0	0	1	1	0	0	0	0	0	

Data File N61 (dec) -- CE_RECIP_I -- CE REcipe Integer File

Offset	0	1	2	3	4	5	6	7	8	9
N61:0	3	3	0							

Offset	0	1	2	3	4
F63:0	0.03	0	0.4	0	1.5
F63:5	0.4	5	43.5	0.07	0.3
F63:10	0.2	1	0.05	0.2	0
F63:15	0	0	0	0	0
F63:20	0	0	0	0	0
F63:25	0	0	0	9	0
F63:30	0	0	0	0	0
F63:35	0	0	0	0	0
F63:40	2	0.5	7.2	60	4
F63:45	0	0	0	0	0
F63:50	0	0	0	0	0
F63:55	0	0	0	0	0

Offset	0	1	2	3	4
F64:0	0.1	0.05	0.1	0.1	0.65
F64:5	1.75	0.5	42	0.15	0.1
F64:10	0.2	1	0.05	0.2	0
F64:15	0	0	0	0	0
F64:20	0	0	0	0	0
F64:25	0	0	0	9	0
F64:30	0	0	0	0	0
F64:35	0	0	0	0	0

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B65:0	0	0	0	0	0	0	0	1	0	0	1	0	0	0	0	0	Module Inputs
B65:1	0	0	0	0	1	0	0	0	0	0	0	0	0	0	0	1	Module Inputs
B65:2	0	0	0	0	0	0	0	0	0	0	1	0	1	0	0	0	Module Outputs
B65:3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B65:4	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Power Mag Option Bits
B65:5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Low Case Option Bits
B65:6	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Transfer Conveyor Option Bits
B65:7	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	0	Product Conveyor Option Bits
B65:8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	

Data File N66 (dec) -- CE_OPT_I -- CE Option Integer File

Offset	0	1	2	3	4	5	6	7	8	9
N66:0	0									

Offset	EN	TT	DN	BASE	PRE	ACC	(Symbol) Description
T67:0	0	0	0	.01 sec	0	0	Low Case Timer
T67:1	0	0	0	.01 sec	5	0	Case Conveyor START DELAY
T67:2	0	0	0	.01 sec	0	0	
T67:3	0	0	0	.01 sec	300	0	POWER TRANSFER ON TIME
T67:4	0	0	0	.01 sec	100	0	
T67:5	1	0	1	.01 sec	100	100	
T67:6	1	1	0	.01 sec	200	191	
T67:7	0	0	0	.01 sec	200	0	
T67:8	0	0	0	.01 sec	50	0	Sheet Feeder Signal time
T67:9	0	0	0	.01 sec	300	300	Call Case Delay

Offset	CU	CD	DN	OV	UN	UA	PRE	ACC	(Symbol) Description
C68:0	0	0	0	0	0	0	0	0	
C68:1	0	0	0	0	0	0	1	0	
C68:2	0	0	0	0	0	0	0	0	
C68:3	0	0	0	0	0	0	0	0	
C68:4	0	0	0	0	0	0	0	0	
C68:5	0	0	0	0	0	0	10	0	
C68:6	0	0	0	0	0	0	10	1	

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B70:0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B70:1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B70:2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B70:3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B70:4	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B70:5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B70:6	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B70:7	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B70:8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B70:9	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B70:10	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	

Data File N71 (dec) -- CE_SERVO_I -- CE Servo Integer File

Offset	0	1	2	3	4	5	6	7	8	9
N71:0	0	0	0	0	0					

Offset	EN	TT	DN	BASE	PRE	ACC	(Symbol) Description
T72:0	0	0	0	.001 sec	5	0	(TM_READ_INPUT_ASSBY) AXIS1: READ INPUT ASSEMBLY DELAY
T72:1	0	0	0	1.0 sec	5	5	
T72:2	0	0	0	.001 sec	5	0	(TM_READ_OUTPUT_ASSBY) AXIS1: READ OUTPUT ASSEMBLY DELAY
T72:3	0	0	0	.01 sec	20	0	DELAY START MOVE
T72:4	0	0	0	.01 sec	70	0	Reset Delay
T72:5	0	0	0	.01 sec	50	0	Software Enable Delay
T72:6	0	0	0	.01 sec	0	0	Pre-Move Delay
T72:7	0	0	0	.01 sec	30	0	
T72:8	0	0	0	.01 sec	50	0	Carriage HOME STP 10 OFFSET MOVE COMPLETE DELAY
T72:9	0	0	0	.01 sec	100	0	STEP 3 DELAY JOGGING START
T72:10	0	0	0	.01 sec	100	0	STEP 5 DELAY JOGGING START
T72:11	0	0	0	.01 sec	100	0	STEP 8 START OFFSET MOVE

Offset	0	1	2	3	4
F74:0	0	2	42	-40	0
F74:5	-40	0	19	0	0
F74:10	-2	62	200	300	0
F74:15	9	10	0	0	0
F74:20	40	0	0	0	0
F74:25	0	39	0	0	39

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B75:0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Tape Fault Module Inputs Bottom Tape Unit
B75:1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Tape Fault Module Inputs Top Tape Unit
B75:2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Tape Fault Module Outputs Bottom Tape Unit
B75:3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Tape Fault Module Outputs Top Tape Unit
B75:4	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Tape Fault Bottom Unit Control Code
B75:5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Tape Fault Top Unit Control Code

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B80:0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B80:1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	
B80:2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B80:3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B80:4	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B80:5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B80:6	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B80:7	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B80:8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B80:9	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B80:10	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B80:11	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B80:12	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B80:13	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B80:14	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B80:15	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	** Temp Bits ** Enable Disable Test Cycles And

Offset	EN	TT	DN	BASE	PRE	ACC	(Symbol) Description
T81:0	0	0	0	.01 sec	50	0	Case in Position Delay Timer
T81:1	0	0	0	.01 sec	1	1	Case NOT in Position Delay Timer
T81:2	0	0	0	.01 sec	25	0	Case Complete Cylinder has Retracted Timer
T81:3	0	0	0	.01 sec	10	0	Case Complete Case Moved Out Delay Timer
T81:4	0	0	0	.01 sec	75	0	Delay Call For Case

Offset	0	1	2	3	4	5	6	7	8	9
N83:0	0									

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B90:0	0	0	0	0	0	0	0	1	0	0	0	0	0	0	0	0	
B90:1	0	1	0	0	0	0	0	1	0	0	0	0	0	0	0	0	
B90:2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Tape Fault Module Outputs Bottom Tape Unit
B90:3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Tape Fault Module Outputs Top Tape Unit
B90:4	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B90:5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B90:6	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B90:7	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	

Offset	0	1	2	3	4	5	6	7	8	9
N91:0	24	10	6	24	0	0	0	0	0	0
N91:10	24	10	6	24	0	0	0	0	0	0

Offset	EN	TT	DN	BASE	PRE	ACC	(Symbol) Description
T92:0	0	0	0	.01 sec	0	0	
T92:1	0	0	0	.001 sec	200	0	Tape Head Bottom No Cut Test Delay Timer
T92:2	0	0	0	.001 sec	500	0	Tape Head Bottom No Cut Test Duration Timer
T92:3	0	0	0	.01 sec	0	0	
T92:4	0	0	0	.01 sec	0	0	
T92:5	0	0	0	.01 sec	0	0	
T92:6	0	0	0	.01 sec	0	0	
T92:7	0	0	0	.01 sec	0	0	
T92:8	0	0	0	.01 sec	0	0	
T92:9	0	0	0	.01 sec	0	0	
T92:10	0	0	0	.01 sec	0	0	
T92:11	0	0	0	.001 sec	200	0	Tape Head Top No Cut Test Delay Timer
T92:12	0	0	0	.001 sec	500	0	Tape Head Top No Cut Test Duration Timer

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B100:0	0	0	0	0	0	0	0	0	0	1	1	0	0	0	0	0	
B100:1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B100:2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B100:3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B100:4	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B100:5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B100:6	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B100:7	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	

Offset	EN	TT	DN	BASE	PRE	ACC	(Symbol) Description
T102:0	0	0	0	.01 sec	0	0	Bottom First Bead Delay
T102:1	0	0	0	.01 sec	0	0	Bottom First Bead Duration
T102:2	0	0	0	.01 sec	0	0	Bottom Second Bead Delay
T102:3	0	0	0	.01 sec	0	0	Bottom Second Bead Duration
T102:4	0	0	0	.01 sec	0	0	
T102:5	0	0	0	.01 sec	0	0	
T102:6	0	0	0	.01 sec	0	0	
T102:7	0	0	0	.01 sec	0	0	
T102:8	0	0	0	.01 sec	0	0	
T102:9	0	0	0	.01 sec	0	0	
T102:10	0	0	0	.01 sec	0	0	
T102:11	0	0	0	.01 sec	0	0	
T102:12	0	0	0	.01 sec	0	0	
T102:13	0	0	0	.01 sec	0	0	
T102:14	0	0	0	.01 sec	0	0	
T102:15	0	0	0	.01 sec	0	0	COMPRESSION EXTEND TIME
T102:16	0	0	0	.01 sec	0	0	
T102:17	0	0	0	.01 sec	0	0	
T102:18	0	0	0	.01 sec	0	0	
T102:19	0	0	0	.01 sec	0	0	

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B105:0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B105:1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B105:2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B105:3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	

Offset	EN	TT	DN	BASE	PRE	ACC	(Symbol) Description
T107:0	0	0	0	.01 sec	0	0	Top First Bead Delay
T107:1	0	0	0	.01 sec	0	0	Top First Bead Duration
T107:2	0	0	0	.01 sec	0	0	Top Second Bead Delay
T107:3	0	0	0	.01 sec	0	0	Top Second Bead Duration
T107:4	0	0	0	.01 sec	0	0	
T107:5	0	0	0	.01 sec	0	0	
T107:6	0	0	0	.01 sec	0	0	
T107:7	0	0	0	.01 sec	0	0	
T107:8	0	0	0	.01 sec	0	0	
T107:9	0	0	0	.01 sec	0	0	
T107:10	0	0	0	.01 sec	0	0	
T107:11	0	0	0	.01 sec	0	0	
T107:12	0	0	0	.01 sec	0	0	
T107:13	0	0	0	.01 sec	0	0	
T107:14	0	0	0	.01 sec	0	0	
T107:15	0	0	0	.01 sec	0	0	
T107:16	0	0	0	.01 sec	0	0	
T107:17	0	0	0	.01 sec	0	0	
T107:18	0	0	0	.01 sec	0	0	
T107:19	0	0	0	.01 sec	0	0	

Offset	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0	(Symbol) Description
B150:0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:4	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:6	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:7	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:9	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:10	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Alarms CE Trip Word
B150:11	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Alarms Sealer Trip Word
B150:12	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:13	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:14	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:15	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:16	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:17	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:18	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:19	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
B150:20	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Alarms CE Alarm Word
B150:21	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	Alarms Sealer Alarm Word

Offset	EN	TT	DN	BASE	PRE	ACC	(Symbol) Description
T152:0	0	0	0	.01 sec	100	0	CASE JAM TIMER
T152:1	0	0	0	.01 sec	200	0	RELEASE PE BACKUP
T152:2	0	0	0	.01 sec	300	0	Vacuum Plate Extend Delay
T152:3	0	0	0	.01 sec	250	0	Pusher Bar Jam timer
T152:4	0	0	0	.01 sec	300	0	Carriage Jam Extending Timer
T152:5	0	0	0	.01 sec	300	0	Carriage Jam Retracting Timer
T152:6	0	0	0	.01 sec	0	0	Trip Servo Axis Fault Timer
T152:7	0	0	0	.01 sec	200	0	CE Sidebelt VFD Fault Timer
T152:8	0	0	0	.01 sec	100	0	CE Sidebelt MS Overload Fault Timer
T152:9	0	0	0	.01 sec	10	0	Oposite Hand Case Jam Delay
T152:10	0	0	0	.01 sec	10	0	Alarms Case Jam Delay
T152:11	0	0	0	.01 sec	0	0	CE Trip Delay Timer 11
T152:12	0	0	0	.01 sec	0	0	CE Trip Delay Timer 12
T152:13	0	0	0	.01 sec	0	0	CE Trip Delay Timer 13
T152:14	0	0	0	.01 sec	1000	0	Vacuum Plate Retract Alarm Delay
T152:15	0	0	0	.01 sec	0	0	CE Trip Delay Timer 15
T152:16	0	0	0	.01 sec	0	0	
T152:17	0	0	0	.01 sec	0	0	
T152:18	0	0	0	.01 sec	0	0	
T152:19	0	0	0	.01 sec	0	0	
T152:20	0	0	0	1.0 sec	150	0	CE Alarm Delay Timer 0
T152:21	0	0	0	.01 sec	150	0	CE Alarm Delay Timer 1
T152:22	0	0	0	.01 sec	150	0	CE Alarm Delay Timer 2
T152:23	0	0	0	.01 sec	150	0	CE Alarm Delay Timer 3
T152:24	0	0	0	.01 sec	100	0	Case Conveyor MS Alarm Timer
T152:25	0	0	0	.01 sec	100	0	Product Conveyor VFD Fault Timer
T152:26	0	0	0	.01 sec	0	0	
T152:27	0	0	0	.01 sec	0	0	
T152:28	0	0	0	.01 sec	200	0	CE Alarm Delay Timer 8
T152:29	0	0	0	.01 sec	150	0	CE Alarm Delay Timer 9
T152:30	0	0	0	.01 sec	10	0	CE Alarm Delay Timer 10
T152:31	0	0	0	.01 sec	10	0	CE Alarm Delay Timer 11
T152:32	0	0	0	.01 sec	10	0	CE Alarm Delay Timer 12
T152:33	0	0	0	.01 sec	10	0	CE Alarm Delay Timer 13
T152:34	0	0	0	.01 sec	10	0	CE Alarm Delay Timer 14
T152:35	0	0	0	.01 sec	10	0	CE Alarm Delay Timer 15
T152:36	0	0	0	.01 sec	0	0	
T152:37	0	0	0	.01 sec	0	0	
T152:38	0	0	0	.01 sec	0	0	
T152:39	0	0	0	.01 sec	0	0	
T152:40	0	0	0	.01 sec	500	0	Trip Case Jam In Sealer Delay
T152:41	0	0	0	.01 sec	10	0	Trip Sealer Delay Timer 1
T152:42	0	0	0	.01 sec	10	0	Trip Sealer Delay Timer 2
T152:43	0	0	0	.01 sec	10	0	Trip Sealer Delay Timer 3
T152:44	0	0	0	.01 sec	10	0	Trip Sealer Delay Timer 4
T152:45	0	0	0	.01 sec	10	0	Trip Sealer Delay Timer 5
T152:46	0	0	0	.01 sec	10	0	Trip Sealer Delay Timer 6
T152:47	0	0	0	.01 sec	10	0	Trip Sealer Delay Timer 7
T152:48	0	0	0	.01 sec	10	0	Trip Sealer Delay Timer 8
T152:49	0	0	0	.01 sec	10	0	Trip Sealer Delay Timer 9
T152:50	0	0	0	.01 sec	10	0	Trip Sealer Delay Timer 10
T152:51	0	0	0	.01 sec	10	0	Trip Sealer Delay Timer 11
T152:52	0	0	0	.01 sec	10	0	Trip Sealer Delay Timer 12
T152:53	0	0	0	.01 sec	10	0	Trip Sealer Delay Timer 13
T152:54	0	0	0	.01 sec	10	0	Trip Sealer Delay Timer 14
T152:55	0	0	0	.01 sec	10	0	Trip Sealer Delay Timer 15
T152:56	0	0	0	.01 sec	0	0	
T152:57	0	0	0	.01 sec	0	0	
T152:58	0	0	0	.01 sec	0	0	
T152:59	0	0	0	.01 sec	0	0	
T152:60	0	0	0	.01 sec	0	0	
T152:61	0	0	0	.01 sec	0	0	
T152:62	0	0	0	.01 sec	0	0	
T152:63	0	0	0	.01 sec	0	0	
T152:64	0	0	0	.01 sec	0	0	
T152:65	0	0	0	.01 sec	10	0	Sealer Alarm Delay Timer 5
T152:66	0	0	0	.01 sec	10	0	Sealer Alarm Delay Timer 6

Offset	EN	TT	DN	BASE	PRE	ACC	(Symbol)	Description
T152:67	0	0	0	.01 sec	10	0	Sealer Alarm Delay Timer	7
T152:68	0	0	0	.01 sec	10	0	Sealer Alarm Delay Timer	8
T152:69	0	0	0	.01 sec	10	0	Sealer Alarm Delay Timer	9
T152:70	0	0	0	.01 sec	10	0	Sealer Alarm Delay Timer	10
T152:71	0	0	0	.01 sec	10	0	Sealer Alarm Delay Timer	11
T152:72	0	0	0	.01 sec	10	0	Sealer Alarm Delay Timer	12
T152:73	0	0	0	.01 sec	10	0	Sealer Alarm Delay Timer	13
T152:74	0	0	0	.01 sec	10	0	Sealer Alarm Delay Timer	14
T152:75	0	0	0	.01 sec	10	0	Sealer Alarm Delay Timer	15

Offset	CU	CD	DN	OV	UN	UA	PRE	ACC	(Symbol)	Description
C153:0	0	0	0	0	0	0	0	0		
C153:1	0	0	0	0	0	0	0	0		
C153:2	0	0	0	0	0	0	10	0		
C153:3	0	0	0	0	0	0	10	0		
C153:4	0	0	0	0	0	0	0	0		
C153:5	0	0	0	0	0	0	0	0		
C153:6	0	0	0	0	0	0	0	0		
C153:7	0	0	0	0	0	0	0	0		
C153:8	0	0	0	0	0	0	0	0		
C153:9	0	0	0	0	0	0	0	0		

Data File MG200 -- AXIS DATA

Offset	IA	RBL	LBN	RBN	CHN	NOD	MTO	NB	TFT	TFN	ELE	SEL	BK	UC	TO	C
MG200:0	28340	816	-1	0	1	0	33	64	4	113	0	0	0	0	0	
MG200:1	0	816	-1	0	1	0	33	0	4	114	52	28444	0	0	0	
MG200:2	0	48	-1	0	1	0	33	0	884	185	4	28508	0	0	0	
MG200:3	0	48	-1	0	1	0	33	0	884	78	4	28366	0	0	0	
MG200:4	0	48	-1	0	1	0	33	0	884	53	4	28336	0	0	0	
MG200:5	0	816	-1	0	1	0	33	0	884	177	4	28528	0	0	0	
MG200:6	0	816	-1	0	1	0	33	0	884	176	4	28524	0	0	0	
MG200:7	0	816	-1	0	1	0	33	0	884	180	4	28532	0	0	0	
MG200:8	0	48	-1	0	1	0	33	0	884	138	4	28504	0	0	0	
MG200:9	0	48	-1	0	1	0	33	0	884	232	4	28500	0	0	0	
MG200:10	28408	48	-1	0	1	0	33	4	884	653	0	0	0	0	0	

Data File RIX201 -- AXIS DATA

Offset	STY	IP	IOIS	IOI0	IOI1	IOI2	IOI3	IOI4	ACPS	ACP0	ACP1	ACP2
RIX201:0	13	192.168.68.179	E03	2004	2471	3003	0	0	2	2002	2401	0
RIX201:1	13	192.168.68.179	1003	2004	2472	3003	0	0	2	2002	2401	0
RIX201:2	13	192.168.68.179	1003	2100	7403	24B9	3000	0	2	2002	2401	0
RIX201:3	13	200.1.0.179	1003	2100	7403	244E	3000	0	2	2002	2401	0
RIX201:4	13	192.168.68.179	1003	2100	7403	2435	3000	0	2	2002	2401	0
RIX201:5	13	192.168.68.179	1004	2100	7403	24B1	3003	0	2	2002	2401	0
RIX201:6	13	192.168.68.179	1004	2100	7403	24B0	3003	0	2	2002	2401	0
RIX201:7	13	192.168.68.179	1004	2100	7403	24B4	3003	0	2	2002	2401	0
RIX201:8	13	192.168.68.179	1003	2100	7403	248A	3000	0	2	2002	2401	0
RIX201:9	13	192.168.68.179	1003	2100	7403	24E8	3000	0	2	2002	2401	0
RIX201:10	13	192.168.68.179	E04	2100	7403	2500	8D02	3000	2	2002	2401	0

Offset	0	1	2	3	4
L204:0	0				

Offset	0	1	2	3	4
L208:0	827917	66	5	4	0
L208:5	0	0	-1133052307	-1133052307	0
L208:10	1019195656	0	0	0	0
L208:15	0	39	0		

Offset	0	1	2	3	4
F209:0	0	-0.01507531	-0.01507531	0	0.01269035
F209:5	0	0	0		

Offset	0	1	2	3	4
L210:0	0	0	3	1133903872	1133903872
L210:5	0	1115160576	0	0	0
L210:10	0	1058558444	0	1	35
L210:15	0	0	1	0	0
L210:20	1120403456	1120403456	1073741824		

Offset	0	1	2	3	4
F211:0	300	300	0	62	0
F211:5	0	0.595	0	0	0
F211:10	100	100	2	0	0

Offset	0	1	2	3	4	5	6	7	8	9
N251:0	0	22								

Offset	CU	CD	DN	OV	UN	UA	PRE	ACC	(Symbol)	Description
C254:0	0	0	0	0	0	0	32000	0	Error Routine Counter	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
B3:0/0	ALWAYS_OFF	Global	Always off Bit	
B3:0/1	SPARE_OUTPUT	Global	Spare Output	
B3:0/2			SPARE OUTPUT	
B3:0/15			ONE-SHOT	
B3:8/0			ByPass DPI Interlock PB	
B3:8/1			ByPass DPI Interlock ONS	
B3:8/2			ByPass DPI Interlock SWP	
B3:8/3			DPI Interlock Enabled	
B3:9/0			Upstream Equipment Running	
B3:10/0			CE Running Status To Upstream Equipment	
B10:0/0			PLC Not Properly Configured	
B10:1/0			Main Module Output Main Air	
B10:1/1			Main Module Output Main Air Soft Start Complete	
B10:1/2				
B10:2/0			Second Language Selection	
B10:2/1			Second Language Selection PB (From HMI)	
B10:2/2			Second Language Select ONS	
B20:0			IO Status to HMI Word 0 Bits 0-15	
B20:1			IO Status to HMI Word 1 Bits 0-15	
B20:2/0			DUMMY	
B20:2/1			HMI No User Logged IN	
B20:2/2			HMI User Level Logged IN	
B20:2/3			HMI Tech Level Logged IN	
B20:2/4			HMI Admin Level Logged IN	
B20:2/15			HMI Visability Based on User to Set Time on HMI	
B20:3/0			Hot Melt Option Not Selected	
B20:3/1			Sidebelt Option Not Selected	
B20:5/0			HMI Stay Logged In	
B20:5/1			Admin Locked In	
B20:6			IO Enabled to HMI Word 0 Bits 0-15	
B20:7			IO Enabled to HMI Word 1 Bits 0-15	
B20:8/0			Input Screen Base Selected	
B20:8/1			Input Screen 1 Selected	
B20:8/2			Output Screen Base Selected	
B20:8/3			Output Screen 2 Selected	
B20:8/4			Input Always Off Bit	
B30:0/0			Manual Mode Allowed	
B30:1			Manual Mode Generic HMI PB	
B30:2			Manual Mode Operations	
B30:2/0			Manual Mode PB (FROM HMI)	
B30:2/1			Manual Mode ONS	
B30:2/2			Manual Mode SWP	
B30:2/3			Manual Mode	
B30:2/4			Auto Mode	
B30:3			Manual Mode HMI PBs Word 1	
B30:3/0			Manual Mode Output REQ PB Output 1-0	
B30:3/1			Manual Mode Output REQ PB Output 1-1	
B30:3/2			Manual Mode Output REQ PB Output 1-2	
B30:3/3			Manual Mode Output REQ PB Output 1-3	
B30:3/4			Manual Mode Output REQ PB Output 1-4	
B30:3/5			Manual Mode Output REQ PB Output 1-5	
B30:3/6			Manual Mode Output REQ PB Output 1-6	
B30:3/7			Manual Mode Output REQ PB Output 1-7	
B30:3/8			Manual Mode Output REQ PB Output 1-8	
B30:3/9			Manual Mode Output REQ PB Output 1-9	
B30:3/10			Manual Mode Output REQ PB Output 1-10	
B30:3/11			Manual Mode Output REQ PB Output 1-11	
B30:3/12			Manual Mode Output REQ PB Output 1-12	
B30:3/13			Manual Mode Output REQ PB Output 1-13	
B30:3/14			Manual Mode Output REQ PB Output 1-14	
B30:3/15			Manual Mode Output REQ PB Output 1-15	
B30:4			Manual Mode Output REQ ONS	
B30:4/0			Manual Mode Output REQ ONS Output 1-0	
B30:4/1			Manual Mode Output REQ ONS Output 1-1	
B30:4/2			Manual Mode Output REQ ONS Output 1-2	
B30:4/3			Manual Mode Output REQ ONS Output 1-3	
B30:4/4			Manual Mode Output REQ ONS Output 1-4	
B30:4/5			Manual Mode Output REQ ONS Output 1-5	
B30:4/6			Manual Mode Output REQ ONS Output 1-6	
B30:4/7			Manual Mode Output REQ ONS Output 1-7	
B30:4/8			Manual Mode Output REQ ONS Output 1-8	
B30:4/9			Manual Mode Output REQ ONS Output 1-9	
B30:4/10			Manual Mode Output REQ ONS Output 1-10	
B30:4/11			Manual Mode Output REQ ONS Output 1-11	
B30:4/12			Manual Mode Output REQ ONS Output 1-12	
B30:4/13			Manual Mode Output REQ ONS Output 1-13	
B30:4/14			Manual Mode Output REQ ONS Output 1-14	
B30:4/15			Manual Mode Output REQ ONS Output 1-15	
B30:5			Manual Mode Output REQ SWP	
B30:5/0			Manual Mode Output REQ SWP Output 1-0	
B30:5/1			Manual Mode Output REQ SWP Output 1-1	
B30:5/2			Manual Mode Output REQ SWP Output 1-2	
B30:5/3			Manual Mode Output REQ SWP Output 1-3	
B30:5/4			Manual Mode Output REQ SWP Output 1-4	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
B30:5/5			Manual Mode Output REQ SWP Output 1-5	
B30:5/6			Manual Mode Output REQ SWP Output 1-6	
B30:5/7			Manual Mode Output REQ SWP Output 1-7	
B30:5/8			Manual Mode Output REQ SWP Output 1-8	
B30:5/9			Manual Mode Output REQ SWP Output 1-9	
B30:5/10			Manual Mode Output REQ SWP Output 1-10	
B30:5/11			Manual Mode Output REQ SWP Output 1-11	
B30:5/12			Manual Mode Output REQ SWP Output 1-12	
B30:5/13			Manual Mode Output REQ SWP Output 1-13	
B30:5/14			Manual Mode Output REQ SWP Output 1-14	
B30:5/15			Manual Mode Output REQ SWP Output 1-15	
B30:6			Manual Mode Latched Outputs Word 1	
B30:6/0			Manual Mode Output REQ Latch Output 1-0	
B30:6/1			Manual Mode Output REQ Latch Output 1-1	
B30:6/2			Manual Mode Output REQ Latch Output 1-2	
B30:6/3			Manual Mode Output REQ Latch Output 1-3	
B30:6/4			Manual Mode Output REQ Latch Output 1-4	
B30:6/5			Manual Mode Output REQ Latch Output 1-5	
B30:6/6			Manual Mode Output REQ Latch Output 1-6	
B30:6/7			Manual Mode Output REQ Latch Output 1-7	
B30:6/8			Manual Mode Output REQ Latch Output 1-8	
B30:6/9			Manual Mode Output REQ Latch Output 1-9	
B30:6/10			Manual Mode Output REQ Latch Output 1-10	
B30:6/11			Manual Mode Output REQ Latch Output 1-11	
B30:6/12			Manual Mode Output REQ Latch Output 1-12	
B30:6/13			Manual Mode Output REQ Latch Output 1-13	
B30:6/14			Manual Mode Output REQ Latch Output 1-14	
B30:6/15			Manual Mode Output REQ Latch Output 1-15	
B30:7			Manual Mode HMI PBs Word 2	
B30:7/0			Manual Mode Output REQ PB Output 2-0	
B30:7/1			Manual Mode Output REQ PB Output 2-1	
B30:7/2			Manual Mode Output REQ PB Output 2-2	
B30:7/3			Manual Mode Output REQ PB Output 2-3	
B30:7/4			Manual Mode Output REQ PB Output 2-4	
B30:7/5			Manual Mode Output REQ PB Output 2-5	
B30:7/6			Manual Mode Output REQ PB Output 2-6	
B30:7/7			Manual Mode Output REQ PB Output 2-7	
B30:7/8			Manual Mode Output REQ PB Output 2-8	
B30:7/9			Manual Mode Output REQ PB Output 2-9	
B30:7/10			Manual Mode Output REQ PB Output 2-10	
B30:7/11			Manual Mode Output REQ PB Output 2-11	
B30:7/12			Manual Mode Output REQ PB Output 2-12	
B30:7/13			Manual Mode Output REQ PB Output 2-13	
B30:7/14			Manual Mode Output REQ PB Output 2-14	
B30:7/15			Manual Mode Output REQ PB Output 2-15	
B30:8			Manual Mode Output REQ ONS	
B30:8/0			Manual Mode Output REQ ONS Output 2-0	
B30:8/1			Manual Mode Output REQ ONS Output 2-1	
B30:8/2			Manual Mode Output REQ ONS Output 2-2	
B30:8/3			Manual Mode Output REQ ONS Output 2-3	
B30:8/4			Manual Mode Output REQ ONS Output 2-4	
B30:8/5			Manual Mode Output REQ ONS Output 2-5	
B30:8/6			Manual Mode Output REQ ONS Output 2-6	
B30:8/7			Manual Mode Output REQ ONS Output 2-7	
B30:8/8			Manual Mode Output REQ ONS Output 2-8	
B30:8/9			Manual Mode Output REQ ONS Output 2-9	
B30:8/10			Manual Mode Output REQ ONS Output 2-10	
B30:8/11			Manual Mode Output REQ ONS Output 2-11	
B30:8/12			Manual Mode Output REQ ONS Output 2-12	
B30:8/13			Manual Mode Output REQ ONS Output 2-13	
B30:8/14			Manual Mode Output REQ ONS Output 2-14	
B30:8/15			Manual Mode Output REQ ONS Output 2-15	
B30:9			Manual Mode Output REQ SWP	
B30:9/0			Manual Mode Output REQ SWP Output 2-0	
B30:9/1			Manual Mode Output REQ SWP Output 2-1	
B30:9/2			Manual Mode Output REQ SWP Output 2-2	
B30:9/3			Manual Mode Output REQ SWP Output 2-3	
B30:9/4			Manual Mode Output REQ SWP Output 2-3	
B30:9/5			Manual Mode Output REQ SWP Output 2-5	
B30:9/6			Manual Mode Output REQ SWP Output 2-6	
B30:9/7			Manual Mode Output REQ SWP Output 2-7	
B30:9/8			Manual Mode Output REQ SWP Output 2-8	
B30:9/9			Manual Mode Output REQ SWP Output 2-9	
B30:9/10			Manual Mode Output REQ SWP Output 2-10	
B30:9/11			Manual Mode Output REQ SWP Output 2-11	
B30:9/12			Manual Mode Output REQ SWP Output 2-12	
B30:9/13			Manual Mode Output REQ SWP Output 2-13	
B30:9/14			Manual Mode Output REQ SWP Output 2-14	
B30:9/15			Manual Mode Output REQ SWP Output 2-15	
B30:10			Manual Mode Latched Outputs Word 2	
B30:10/0			Manual Mode Output REQ Latch Output 2-0	
B30:10/1			Manual Mode Output REQ Latch Output 2-1	
B30:10/2			Manual Mode Output REQ Latch Output 2-2	
B30:10/3			Manual Mode Output REQ Latch Output 2-3	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
B30:10/4			Manual Mode Output REQ Latch Output 2-4	
B30:10/5			Manual Mode Output REQ Latch Output 2-5	
B30:10/6			Manual Mode Output REQ Latch Output 2-6	
B30:10/7			Manual Mode Output REQ Latch Output 2-7	
B30:10/8			Manual Mode Output REQ Latch Output 2-8	
B30:10/9			Manual Mode Output REQ Latch Output 2-9	
B30:10/10			Manual Mode Output REQ Latch Output 2-10	
B30:10/11			Manual Mode Output REQ Latch Output 2-11	
B30:10/12			Manual Mode Output REQ Latch Output 2-12	
B30:10/13			Manual Mode Output REQ Latch Output 2-13	
B30:10/14			Manual Mode Output REQ Latch Output 2-14	
B30:10/15			Manual Mode Output REQ Latch Output 2-15	
B30:11			Manual Mode HMI PBs Word 3	
B30:11/0			Manual Mode Output REQ PB Output 3-0	
B30:11/1			Manual Mode Output REQ PB Output 3-1	
B30:11/2			Manual Mode Output REQ PB Output 3-2	
B30:11/3			Manual Mode Output REQ PB Output 3-3	
B30:11/4			Manual Mode Output REQ PB Output 3-4	
B30:11/5			Manual Mode Output REQ PB Output 3-5	
B30:11/6			Manual Mode Output REQ PB Output 3-6	
B30:11/7			Manual Mode Output REQ PB Output 3-7	
B30:11/8			Manual Mode Output REQ PB Output 3-8	
B30:11/9			Manual Mode Output REQ PB Output 3-9	
B30:11/10			Manual Mode Output REQ PB Output 3-10	
B30:11/11			Manual Mode Output REQ PB Output 3-11	
B30:11/12			Manual Mode Output REQ PB Output 3-12	
B30:11/13			Manual Mode Output REQ PB Output 3-13	
B30:11/14			Manual Mode Output REQ PB Output 3-14	
B30:11/15			Manual Mode Output REQ PB Output 3-15	
B30:12			Manual Mode Output REQ ONS	
B30:12/0			Manual Mode Output REQ ONS Output 3-0	
B30:12/1			Manual Mode Output REQ ONS Output 3-1	
B30:12/2			Manual Mode Output REQ ONS Output 3-2	
B30:12/3			Manual Mode Output REQ ONS Output 3-3	
B30:12/4			Manual Mode Output REQ ONS Output 3-4	
B30:12/5			Manual Mode Output REQ ONS Output 3-5	
B30:12/6			Manual Mode Output REQ ONS Output 3-6	
B30:12/7			Manual Mode Output REQ ONS Output 3-7	
B30:12/8			Manual Mode Output REQ ONS Output 3-8	
B30:12/9			Manual Mode Output REQ ONS Output 3-9	
B30:12/10			Manual Mode Output REQ ONS Output 3-10	
B30:12/11			Manual Mode Output REQ ONS Output 3-11	
B30:12/12			Manual Mode Output REQ ONS Output 3-12	
B30:12/13			Manual Mode Output REQ ONS Output 3-13	
B30:12/14			Manual Mode Output REQ ONS Output 3-14	
B30:12/15			Manual Mode Output REQ ONS Output 3-15	
B30:13			Manual Mode Output REQ SWP	
B30:13/0			Manual Mode Output REQ SWP Output 3-0	
B30:13/1			Manual Mode Output REQ SWP Output 3-1	
B30:13/2			Manual Mode Output REQ SWP Output 3-2	
B30:13/3			Manual Mode Output REQ SWP Output 3-3	
B30:13/4			Manual Mode Output REQ SWP Output 3-3	
B30:13/5			Manual Mode Output REQ SWP Output 3-5	
B30:13/6			Manual Mode Output REQ SWP Output 3-6	
B30:13/7			Manual Mode Output REQ SWP Output 3-7	
B30:13/8			Manual Mode Output REQ SWP Output 3-8	
B30:13/9			Manual Mode Output REQ SWP Output 3-9	
B30:13/10			Manual Mode Output REQ SWP Output 3-10	
B30:13/11			Manual Mode Output REQ SWP Output 3-11	
B30:13/12			Manual Mode Output REQ SWP Output 3-12	
B30:13/13			Manual Mode Output REQ SWP Output 3-13	
B30:13/14			Manual Mode Output REQ SWP Output 3-14	
B30:13/15			Manual Mode Output REQ SWP Output 3-15	
B30:14			Manual Mode Latched Outputs Word 3	
B30:14/0			Manual Mode Output REQ Latch Output 4-0	
B30:14/1			Manual Mode Output REQ Latch Output 4-1	
B30:14/2			Manual Mode Output REQ Latch Output 4-2	
B30:14/3			Manual Mode Output REQ Latch Output 4-3	
B30:14/4			Manual Mode Output REQ Latch Output 4-4	
B30:14/5			Manual Mode Output REQ Latch Output 4-5	
B30:14/6			Manual Mode Output REQ Latch Output 4-6	
B30:14/7			Manual Mode Output REQ Latch Output 4-7	
B30:14/8			Manual Mode Output REQ Latch Output 4-8	
B30:14/9			Manual Mode Output REQ Latch Output 4-9	
B30:14/10			Manual Mode Output REQ Latch Output 4-10	
B30:14/11			Manual Mode Output REQ Latch Output 4-11	
B30:14/12			Manual Mode Output REQ Latch Output 4-12	
B30:14/13			Manual Mode Output REQ Latch Output 4-13	
B30:14/14			Manual Mode Output REQ Latch Output 4-14	
B30:14/15			Manual Mode Output REQ Latch Output 4-15	
B40:0/0			Sealer Module Input Sealer Start	
B40:0/1			Sealer Module Input Sealer Case Gate PE	
B40:0/6			Sealer Module Input Dry Cycle Latch	
B40:0/7			Sealer Module Input Discharge Clear	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
B40:0/8			Sealer Module Input Melter Ready	
B40:0/9			ONS	
B40:0/11			Sealer Module Input No Estop Fault Active	
B40:0/12			Sealer Module Input Tape Fault	
B40:0/13			Sealer Module Input Dry Cycle Timer Trigger	
B40:0/14			ONE-SHOT	
B40:0/15			Erector Start Holdin ONS	
B40:1/0			ONS	
B40:1/1			ONS	
B40:2/0			Sealer Module Output GATE EXTEND	
B40:2/1			Sealer Module Output Kicker Extend	
B40:2/2			Sealer Module Output Drive Run	
B40:2/3			Sealer Module Output Speed 2 Select	
B40:4/0			SEALER RUN REQUEST LATCH	
B40:4/1	SLR_DLAY_STOP	Global	SEALER DLAY STOP	
B40:4/2			ENABLE SEALER DLAY STOP LATCH	
B40:4/3			SEALER START ONE-SHOT	
B40:4/4			SEALER GATE RETRACT	
B40:4/5			Sealer Stopping Raise Gate	
B40:4/6			Trailing Edge Of Case ONS	
B40:4/8			Sealer Drive Speed 2 Slow REQ	
B40:4/9			Sealer Drive Speed 2 Slow Complete	
B45:0/0			Prod Data Module Input MACHINE CYCLE COUNT TRIGGER	
B45:0/1			Prod Data Module Input MACHINE RUNNING STATUS	
B45:0/2			Prod Data Module Input MACHINE FAULTED STATUS	
B45:0/3			Prod Data Module Input MACHINE IDLE STATUS	
B45:0/4			Prod Data Module Input Real Time Clock Enabled	
B45:0/9			Combi Reset FFL ONS	
B45:0/10			Combi Reset Data PB (From HMI)	
B45:0/11			Combi Reset Data ONS	
B45:0/13			Set RTC PB (From HMI)	
B45:0/14			Prod Data Module Input Set RTC on PLC	
B45:0/15			Count Reset PB (From HMI)	
B45:1/0			TRIGGER RUN TIME' STACKS	
B45:1/1			TRIGGER FAULT TIME' STACKS	
B45:1/2			TRIGGER IDLE TIME' STACKS	
B45:1/3			TRIGGER EFFICIENCY' STACKS	
B45:1/4			1ST SHIFT IS ACTIVE'	
B45:1/5			2ND SHIFT IS ACTIVE'	
B45:1/6			3RD SHIFT IS ACTIVE'	
B45:1/7			TRIGGER MAX RUN TIME' STACKS	
B45:1/8			TRIGGER SHIFT COUNT' STACKS	
B45:2/0			ONESHOT	
B45:2/1			ONESHOT	
B45:3/0			CYCLE COUNT ONESHOT OUTPUT	
B45:4/0			ONESHOT	
B45:4/1			ONESHOT	
B45:4/2			ONESHOT	
B45:4/4			ONESHOT	
B45:5/4			1ST SHIFT END TIME ACTIVE (1 SCAN)	
B45:5/8			2ND SHIFT END TIME ACTIVE (1 SCAN)	
B45:5/12			3RD SHIFT END TIME ACTIVE (1 SCAN)	
B45:5/13	SHIFT_CHNG	Global	SHIFT CHANGE ACTIVE (1 SCAN)	
B45:5/15			End of Shift Notification for Webport Reports	
B50:0			SHORT CASE	
B50:0/0			Enable Major Flap Timer	
B50:0/1			Enable Top Glue Settings	
B50:0/2			CE Machine Options PB	
B50:1			High Speed Servo Option PB (HMI)	
B50:1/0			Low Case Option PB (HMI)	
B50:1/1			Low Tape / No Tape Top Option PB (HMI)	
B50:1/2			Samll Case Option PB (HMI)	
B50:1/3			TBS Option PB (HMI)	
B50:1/4			Power Mag Option PB (HMI)	
B50:1/5			Product Conveyor Option PB (HMI)	
B50:1/6			Case Conveyor Option PB (HMI)	
B50:1/7			Side Belt Option PB (HMI)	
B50:1/8			Production Data Option PB (HMI)	
B50:1/9			Ergo Option PB (HMI)	
B50:1/10			Zero Line Option PB (HMI)	
B50:1/11			Low Tape / No Tape BOT Option PB (HMI)	
B50:1/13			Hot Melt Option PB (HMI)	
B50:1/14			Opposite Hand Option PB (HMI)	
B50:1/15			CE Machine Options ONS	
B50:2			High Speed Servo Option ONS	
B50:2/0			Low Case Option ONS	
B50:2/1			Low Tape / No Tape Top Option ONS	
B50:2/2			Samll Case Option ONS	
B50:2/3			TBS Option ONS	
B50:2/4			Power Mag Option ONS	
B50:2/5			Product Conveyor Option ONS	
B50:2/6			Case Conveyor Option ONS	
B50:2/7			Side Belt Option ONS	
B50:2/8				

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
B50:2/9			Production Data Option ONS	
B50:2/10			Ergo Option ONS	
B50:2/11			Zero Line Option ONS	
B50:2/12			Display Case Width	
B50:2/13			Low Tape / No Tape BOT Option ONS	
B50:2/14			Hot Melt Option ONS	
B50:2/15			Opposite Hand Option ONS	
B50:3			CE Machine Options SWP	
B50:3/0			High Speed Servo Option SW Pulse	
B50:3/1			Low Case Option SWP	
B50:3/2			Low Tape / No Tape Top Option SWP	
B50:3/3			Small Case Option SWP	
B50:3/4			TBS Option SWP	
B50:3/5			Power Mag Option SWP	
B50:3/6			Product Conveyor Option SWP	
B50:3/7			Case Conveyor Option SWP	
B50:3/8			Side Belt Option SWP	
B50:3/9			Production Data Option SWP	
B50:3/10			Ergo Option SWP	
B50:3/11			Zero Line Option SWP	
B50:3/12			Display Carriage Position Button	
B50:3/13			Low Tape / No Tape BOT Option SWP	
B50:3/14			Hot Melt Option SWP	
B50:3/15			Opposite Hand Option SWP	
B50:4			CE Machine Options	
B50:4/0			High Speed Servo Option Enabled	
B50:4/1			Low Case Option Enabled	
B50:4/2			Low Tape / No Tape Top Option Enabled	
B50:4/3			Small Case Option Enabled	
B50:4/4			TBS Option Enabled	
B50:4/5			Power Mag Option Enabled	
B50:4/6			Product Conveyor Option Latch	
B50:4/7			Case Conveyor Option Latch	
B50:4/8			Side Belt Option Latch	
B50:4/9			Production Data Option Enabled	
B50:4/10			Ergo Option Enabled	
B50:4/11			Zero Line Option Enabled	
B50:4/12			2EZ High Speed Option	
B50:4/13			Low Tape / No Tape BOT Option Enabled	
B50:4/14			Hot Melt Bottom Option Enabled	
B50:4/15			Opposite Hand Option Enabled	
B50:5/0			Display Non Opp Hand Carriage Span	
B50:5/1			Display Case Length HotMelt	
B50:5/2			Display Speed Select	
B50:6/0			Enable Customer Call For Case	
B50:6/1			ONS	
B50:6/2			Enable Call For Case SWP	
B50:6/3			Customer Call For Case Enabled	
B50:8			CE Machine Options PB 2	
B50:8/0			Erector MCR Option PB	
B50:8/1			Vacuum Pump Option PB	
B50:8/2			Hot Melt Top Option PB	
B50:8/3			Spare Option 19 PB	
B50:8/4			Upstream Equipment PB	
B50:9			CE Machine Options ONS 2	
B50:9/0			Erector MCR ONS	
B50:9/1			Vacuum Pump Option ONS	
B50:9/2			Hot Melt Top Option ONS	
B50:9/3			Spare Option 19 ONS	
B50:9/4			Upstream Equipment ONS	
B50:10			CE Machine Options SWP 2	
B50:10/0			Erector MCR Option SWP	
B50:10/1			Vacuum Pump Option SWP	
B50:10/2			Hot Melt Top Option SWP	
B50:10/3			Spare Option 19 SWP	
B50:10/4			Upstream Equipment SWP	
B50:11			CE Machine Options 2	
B50:11/0			Erector MCR Option Enabled	
B50:11/1			Vacuum Pump Option Enabled	
B50:11/2			Hot Melt Top Option Enabled	
B50:11/3			Spare Option 19 Enabled	
B50:11/4			Upstream Equipment Enabled	
B55:0			CE Inputs	
B55:0/0			CE Cycle Module Input CE MCR	
B55:0/1			CE Cycle Module Input Call for Case ONS	
B55:0/3			CE Cycle Module Input Sealer Sidebelt Running	
B55:0/5			CE Cycle Module Input Axis Homed	
B55:0/6			CE Cycle Module Input CE Carriage Axis Enabled	
B55:0/9			CE Cycle Module Input Tape Fault Module Output Tape Fault	
B55:0/10			CE Cycle Module Input SEALER RUN REQUEST LATCH	
B55:0/13			CE Cycle Module Input HOME OFFSET CHANGE	
B55:0/14			CE Cycle Module Input CARRIAGE HOME STP 1 HOMING STARTED	
B55:0/15			CE Cycle Module Input Carriage TO START POSITION AT START-UP	
B55:1			CE Inputs	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
B55:1/5			CE Cycle Module Input CE Carriage Servo In Position	
B55:1/8			CE Cycle Module Input CARRIAGE EXTENDED	
B55:1/9				
B55:1/11			CE Cycle Module Input Homing In Process	
B55:2			CE Outputs	
B55:2/1			CE Cycle Module Output VACUUM PLATE INDEX SV	
B55:2/2			CE Cycle Module Output ERECTOR START HOLD IN	
B55:2/3			CE Cycle Module Output Pusher Bar Down	
B55:2/4			CE Cycle Module Output VACUUM PLATE EXTEND SV	
B55:2/5			CE Cycle Module Output SQUARING MAJOR FLAP SV	
B55:2/6			CE Cycle Module Output TRAILING MINOR FLAP SV	
B55:2/7			CE Cycle Module Output VACUUM BLOW OFF SV	
B55:2/8			CE Cycle Module Output Carriage Extend SV	
B55:2/9			CE Cycle Module Output Erector Sidebelt Drive	
B55:2/10			CE Cycle Module Output SIDE BELT SPEED SELECT 1	
B55:2/11			CE Cycle Module Output SIDE BELT SPEED SELECT 2	
B55:2/12			CE Cycle Module Output MAJOR Flap Extend SV	
B55:2/13			CE Cycle Module Output Leading Minor Flap SV	
B55:2/14			CE Cycle Module Output VACUUM ON SV	
B55:2/15			CE Cycle Module Output DELAY SIDEBELT SLOW DOWN TIMER ENABLE	
B55:3			CE Outputs	
B55:3/0			CE Cycle Module Output Carriage 2 Extend SV	
B55:3/1			CE Cycle Module Output Discharge Backup	
B55:3/2			CE Cycle Module Output Dry Cycle Trigger	
B55:3/3			CE Cycle Case Conveyor Speed 1	
B55:3/4			CE Cycle Module Output Case Conveyor Speed 2	
B55:3/5			CE Cycle Module Output Opposite Hand Squaring	
B55:3/6			CE Cycle Module Output Squaring Vacuum ON	
B55:3/7			CE Cycle Module Output Squaring Blowoff ON	
B55:3/8			CE Cycle Module Output Infeed Conveyor Run	
B55:3/14			Zero Line Option Disabled	
B55:3/15			Run Continuous and Ergo Mode (To HMI)	
B55:4			CE Step Bits	
B55:4/1	CE_ST01	Global	CASE ERECTOR STATE 01, EXTEND VAC PLATE	
B55:4/2	CE_ST02	Global	CASE ERECTOR STATE 02, RETRACT VAC PLATE	
B55:4/3	CE_ST03	Global	CASE ERECTOR STATE 03, EXTEND SQUAR CYL	
B55:4/4	CE_ST04	Global	CASE ERECTOR STATE 04, EXTEND MINOR CYL	
B55:4/5	CE_ST05	Global	CASE ERECTOR STATE 05, READY FOR CASE PUSH	
B55:4/6	CE_ST06	Global	CASE ERECTOR STATE 06, EXTEND CARRIAGE	
B55:4/7	CE_ST07	Global	CASE ERECTOR STATE 07, CARRIAGE EXTENDING	
B55:4/8	CE_ST08	Global	CASE ERECTOR STATE 08, RELEASE VACUUM	
B55:4/9	CE_ST09	Global	CASE ERECTOR STATE 09, CARRIAGE EXTENDED	
B55:4/10	CE_ST10	Global	CASE ERECTOR STATE 10, CARRIAGE RETRACTING	
B55:4/11	CE_ST11	Global	CASE ERECTOR STATE 11 Carriage RETRACTED	
B55:4/12	CE_ST12	Global	CASE ERECTOR STATE 12, INCR MISSED CASE CNTR	
B55:4/15			VACUUM BLOW OFF	
B55:5			CE Reset Bits	
B55:5/0	CE_RSET	Global	CASE ERECTOR STATE RESET	
B55:5/1			RESET INDEX	
B55:5/2			MAJOR FLAP RESET	
B55:5/3			VACUUM RELEASE PE PULSE	
B55:5/15			CASE ERECTOR STATE DIAGNOSTIC BIT	
B55:6			Call for Case Control Bits	
B55:6/0			CALL FOR CASE LOCK IN	
B55:6/1			CALL FOR CASE	
B55:6/2			Call for Case Stop	
B55:6/3			Call for Case Continuous Start SWP	
B55:6/4			Call for Case Continuous Start Latch	
B55:6/13			Call for Case PB (From HMI)	
B55:6/14			ONS	
B55:6/15			Call for Case Stop ONS	
B55:7/0	RUNNING	Global	ERECTOR START HOLD IN	
B55:7/1	CE_STEP_MODE	Global	JOG CYCLE STARTED	
B55:7/2			ERECTOR CYCLE STEP	
B55:8/0			Sidebelt Stop Case In Place	
B55:8/1			Miss Pick ONS	
B55:8/2			Case at Sidebelt Pulse	
B55:8/14			ONS	
B55:8/15				
B55:9/0	CE_STEP_STRT_PB	Global	ERECTOR JOG CYCLE START (FROM HMI)	
B55:9/1	CE_STEP_PB	Global	CYCLE STEP (FROM HMI)	
B55:10			CE Cycle Alarm Bits	
B55:10/0			CASE IN SIDEBELTS TRIGGER	
B55:10/1			Warning Case Pick	
B55:10/2			Alarms Power Mag Left	
B55:10/3			Alarms Power Mag Right	
B55:11				
B55:11/11			ONESHOT	
B55:11/12			ONESHOT	
B55:11/13			ONESHOT	
B55:11/14			ONESHOT	
B55:11/15			ONESHOT	
B55:13/15			ONS	
B55:14/3			Continuous Run Mode	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
B55:14/4			Continuous Run Mode PB (From HMI)	
B55:14/5			Call for Case Cancel	
B55:14/15			Continuous Run Mode ONS	
B55:15/0			CE Cycle DRY CYCLE PB (From HMI)	
B55:15/1			CE Cycle DRY CYCLE SWP	
B55:15/2			CE Cycle DRY CYCLE Latch	
B55:15/15			CE Cycle DRY CYCLE ONS	
B60:1/0	CPM_50	Global	CHANGE TO 10CPM	
B60:1/1	CPM_75	Global	CHANGE TO 15CPM	
B60:1/2	CPM_100	Global	CHANGE TO 20CPM	
B60:1/3			One-Shot	
B60:1/4			Opposite Hand Enabled PB (HMI) OS	
B60:1/5			Opposite Hand Enabled PB (HMI) SWP	
B60:1/6			ONS	
B60:1/8			Module Input Recipe Select 10 CPM SELECTED	
B60:1/9			Module Input Recipe Select 15 CPM SELECTED	
B60:1/10			Module Input Recipe Select 20 CPM SELECTED	
B60:1/11			SET SPEED TO 20CPM	
B60:1/12			Opposite Hand Enabled PB (HMI)	
B60:1/13			Opposite Hand Enabled ONS	
B60:1/14			Opposite Hand Enabled SWP	
B60:1/15			Opposite Hand Enabled	
B60:2/0	CPM_50_SELECT	Global	SPEED 10CPM SELECT (FROM HMI)	
B60:2/1	CPM_75_SELECT	Global	SPEED 15CPM SELECT (FROM HMI)	
B60:2/2	CPM_100_SELECT	Global	SPEED 20CPM SELECT (FROM HMI)	
B60:2/3			Recipe New Recipe Selected Save Current	
B60:2/4			Recipe New Recipe Selected Load Recipe	
B60:2/5			HOME OFFSET CHANGE	
B60:2/6			New Recipe Entered	
B60:2/7			Opposite Hand Index Disable HMI SWP	
B60:2/8			Opposite Hand Index Disable OS	
B60:2/9			Opposite Hand Index Disable SWP	
B60:2/10			Load Correct Hand	
B60:2/11			Load Opposite Hand	
B60:2/12			Opposite Hand Index Disable	
B60:2/14			One-Shot	
B60:2/15			One-Shot	
B65:0			Module Inputs	
B65:0/0			CE Options Module Input High Speed Servo Option Enabled	
B65:0/1			CE Options Module Input Low Case Option Enabled	
B65:0/2			CE Options Module Input Low Tape /No Tape TOP Option Enabled	
B65:0/3			CE Options Module Input Small Case Option Enabled	
B65:0/4			CE Options Module Input TBS Option Enabled	
B65:0/5			CE Options Module Input Power Mag Option Enabled	
B65:0/6			CE Options Module Input Case Conveyor Option Enabled	
B65:0/7			CE Options Module Input Product Conveyor Option	
B65:0/8			CE Options Module Input Side Belt Option	
B65:0/9			CE Options Module Input Erector Sidebelts MS	
B65:0/10			CE Options Module Input Dry Cycle Mode	
B65:0/11			CE Options Module Input Dry Cycle Trigger	
B65:0/12			CE Options Module Input Jog Cycle Mode	
B65:0/13			CE Options Module Input Case Conv Index Erector Door Open	
B65:0/14			Sidebelt Fault	
B65:0/15			CE Options Module Input Low Tape /No Tape BOTTOM Option Enabled	
B65:1			Module Inputs	
B65:1/1			CE Options Module Input Case Erector MCR	
B65:1/2			CE Options Module Input Sealer MCR	
B65:1/3			CE Options Module Input Sealer Sidebelts MS	
B65:1/4			CE Options Module Input Call for Case SWP	
B65:1/9			CE Options Module Input CE Bypass	
B65:1/10			CE Options Module Input Carriage Extending	
B65:1/13			CE Options Module Input Erector Latched	
B65:1/15			ONS	
B65:2			Module Outputs	
B65:2/0			CE Options Module Output Low Case Status	
B65:2/1			CE Options Module Output Case Conveyor MS	
B65:2/2			CE Options Module Output Product Conveyor MS	
B65:2/3				
B65:2/4				
B65:2/5				
B65:4			Power Mag Option Bits	
B65:4/0			Module Output POWER MAG CASE ADVANCE LEFT	
B65:4/1			Module Output POWER MAG CASE ADVANCE RIGHT	
B65:5			Low Case Option Bits	
B65:5/0			Low Case Low Status	
B65:5/1				
B65:6			Transfer Conveyor Option Bits	
B65:6/0			Case in Position Signal	
B65:6/1			Case Conveyor MS REQ	
B65:6/2			Case Conveyor Start REQ	
B65:6/3			ONS	
B65:6/5			One-Shot	
B65:6/6			Sheet Feeder OS	
B65:6/13			Stop Transfer Conveyor	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
B65:6/15			ONS	
B65:7			Product Conveyor Option Bits	
B65:7/0			Product Conveyor Run REQ	
B65:7/1				
B65:8/0			Cycle Sheet Feeder	
B70:0/0			CE_SERVO Program Input MCR Status	
B70:0/1			CE_SERVO Program Input Erector Start Startup ONS	
B70:0/2			CE_SERVO Program Input Short Case Enable	
B70:0/3			CE_SERVO Program Input CE State 01 Extend Vac Plate	
B70:0/4			CE_SERVO Program Input Home Offset Change	
B70:0/6			CE_SERVO Program Input Zero Line Option Enabled	
B70:0/7			CE_SERVO Program Input Home REQ	
B70:0/8			CE_SERVO Program Input Extend Move REQ	
B70:0/9			CE_SERVO Program Input Retract Move REQ	
B70:0/10			CE_SERVO Program Input Start Motion REQ	
B70:0/11			CE_SERVO Program Input Pre-Move REQ	
B70:0/12			CE_SERVO Program Input Opposite Case Reset	
B70:0/13			CE_SERVO Program Input Servo Enabled	
B70:0/14			ONE SHOT	
B70:0/15			Home Manual REQ	
B70:1/0			CE_SERVO Program Input Absolute Encoder Motor Type	
B70:1/1			STEP RESTART HOME	
B70:1/2			Carriage TO START POSITION AT START-UP	
B70:1/3			MOVE TO START POSITION	
B70:1/4			MOVE TO START COMPLETE	
B70:1/13			CE_SERVO Program Input Erector Start Cycle Step ONS	
B70:1/14			ONE-SHOT	
B70:1/15			ONE-SHOT	
B70:5/1			Carriage HOME STP 1 HOMING STARTED	
B70:5/2			Carriage HOME STP 2 SET JOG DIRECTION	
B70:5/3			Carriage HOME STP 3 START JOG OFF SWITCH	
B70:5/4			Carriage HOME STP 4 SET JOG DIRECTION	
B70:5/5			Carriage HOME STP 5 START JOG TO SWITCH	
B70:5/6			Carriage HOME STP 6 STOP ON HOME SWITCH	
B70:5/7			Carriage HOME STP 7 SET HOME OFFSET MOVE	
B70:5/8			Carriage HOME STP 8 START OFFSET MOVE	
B70:5/9			Carriage HOME STP 9 OFFSET MOVE STARTED	
B70:5/10			Carriage HOME STP 10 OFFSET MOVE COMPLETE	
B70:5/11			Carriage HOME STP 11 SET HOME IMMEDIATE	
B70:5/12			Carriage HOMING COMPLETE	
B70:10/0	AX1_COMM_LOST	Global	AXIS1: COMMUNICATION TO DRIVE LOST	
B70:10/1			Module Output SERVO ENABLE	
B75:0			Tape Fault Module Inputs Bottom Tape Unit	
B75:0/0			Tape Alarms External Input Bottom Tape Rotation Sensor	
B75:0/1			Tape Alarms External Input Box Present Sensor	
B75:0/2			Tape Alarms External Input Main Air ON	
B75:0/3			Tape Alarms External Input Control Power ONS	
B75:0/4			Tape Alarms External Input System Start Latch	
B75:0/5			Tape Alarms External Input Drives MS	
B75:0/6			Tape Alarms External Input Low Tape/No Tape BOT Option Enabled	
B75:0/7			Bottom Tape Disable PB (From HMI)	
B75:0/8			Tape Head Bottom External Input Disable Alarm	
B75:0/9			Tape Alarms External Input Low Tape/No Tape Bottom Option Enabled	
B75:0/10			Tape Alarms External Input Low Tape	
B75:0/11			Tape Alarms External Input Bottom Alarm Reset	
B75:0/13				
B75:0/14			ONS	
B75:0/15			Bottom Tape Disable PB ONS	
B75:1			Tape Fault Module Inputs Top Tape Unit	
B75:1/0			Tape Alarms External Input Top Tape Rotation Sensor	
B75:1/1			Tape Alarms External Input Box Present Sensor	
B75:1/2			Tape Alarms External Input Main Air ON	
B75:1/3			Tape Alarms External Input Control Power ONS	
B75:1/4			Tape Alarms External Input Sealer Start Latch	
B75:1/5			Tape Alarms External Input Taper Drives MS	
B75:1/6			Tape Alarms External Input Low Tape/No Tape TOP Option Enabled	
B75:1/7			Top Tape Disable PB (From HMI)	
B75:1/8			Tape Head Top External Input Tape Disable Alarm	
B75:1/9			Tape Alarms External Input Low Tape/No Tape Top Option Enabled	
B75:1/10			Tape Alarms External Input Low Tape Top	
B75:1/11			Tape Alarms External Input Top Alarm Reset	
B75:1/14			ONS	
B75:1/15			Top Tape Disable PB ONS	
B75:2			Tape Fault Module Outputs Bottom Tape Unit	
B75:2/2			Tape Fault Module Output Bottom Low Tape	
B75:3			Tape Fault Module Outputs Top Tape Unit	
B75:3/2			Tape Fault Module Output Top Low Tape	
B75:3/12			Taping Fault Module Output Taping Error LT	
B75:4			Tape Fault Bottom Unit Control Code	
B75:4/0			ERECTOR TAPE ROTATION ONESHOT	
B75:4/1			CASE IN BOTTOM TAPE HEAD BASED ON COUNT ACTIVITY LATCH	
B75:4/2			CASE IN BOTTOM TAPE HEAD BASED ON COUNT ACTIVITY ONESHOT	
B75:4/3			BOTTOM TAPE HEAD APPLICATION FAULT	
B75:4/4			BOTTOM TAPE HEAD CUT FAULT	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
B75:4/5			CASE AT BOTTOM HEAD ONESHOT	
B75:4/6			NO CASE AT BOTTOM HEAD ONESHOT	
B75:4/12			ONE-SHOT	
B75:4/13			ONE-SHOT	
B75:4/14			ONE-SHOT	
B75:4/15			ONE-SHOT	
B75:5			Tape Fault Top Unit Control Code	
B75:5/0			SEALER TAPE ROTATION ONESHOT	
B75:5/1			CASE IN TOP TAPE HEAD BASED ON COUNT ACTIVITY LATCH	
B75:5/2			CASE IN TOP TAPE HEAD BASED ON COUNT ACTIVITY ONESHOT	
B75:5/3			TOP TAPE HEAD APPLICATION FAULT	
B75:5/4			TOP TAPE HEAD CUT FAULT	
B75:5/5			NO CASE AT TOP HEAD ONESHOT	
B75:5/6			CASE AT TOP HEAD ONESHOT	
B75:5/7			Enable Tape Rotation Counter	
B75:5/8			Enable Tape Rotation Counter	
B75:5/12			ONE-SHOT	
B75:5/13			ONE-SHOT	
B75:5/14			ONE-SHOT	
B75:5/15			ONE-SHOT	
B80:0/0			Robot Running To HMI	
B80:0/1			Case at Pack Position Bit	
B80:0/2			Stop Infeed Conveyor from Robot	
B80:0/3				
B80:0/4			Case NOT at Pack Position Bit	
B80:0/5			Vision Trigger Bit	
B80:1/0			Case Conveyor Cycle Start	
B80:1/1			Continuous Mode	
B80:1/2				
B80:1/5			Case Conveyor Stop Cylinder Extend	
B80:1/7			Case Conveyor Move Case into Pack Position	
B80:1/11			Case Conveyor Cycle Complete	
B80:1/13			Case Conveyor Cycle Request	
B80:1/14			Case Conveyor Cycle Request	
B80:2/0			Case Complete Cycle Start	
B80:2/5			Case Complete Release Stop Cylinder	
B80:2/6			Case Complete Move Case Out	
B80:2/7			Case Complete Case has Moved Out	
B80:2/11			Case Complete Cycle Complete	
B80:2/14			Case Complete Cycle Request	
B80:2/15			Case Complete Cycle Enable	
B80:15			** Temp Bits ** Enable Disable Test Cycles And Operations	
B80:15/1			** Temp Bit ** Enable Move Case In Cycle	
B80:15/2			** Temp Bit ** Enable Move Case OUT Cycle	
B80:15/3			** Temp Bit ** Enable Move Out And In Cycle	
B80:15/10			** Temp Bit ** Turn On Vision Light	
B90:0/0			Tape Head Bottom External Input Case at Tape Head	
B90:0/1			Tape Head Bottom External Input System Start Latch	
B90:0/2			Tape Head Bottom External Input Drives MS	
B90:0/3			Tape Head Bottom Case at Head One Shot	
B90:0/4			Tape Head Bottom No Case at Head One Shot	
B90:0/5			Tape Head Bottom External Input Control Power ONS	
B90:0/6			Tape Head Bottom External Input Not Low Tape	
B90:0/15			Tape Head Bottom External Input Alarm Reset	
B90:1/0			Tape Head Top External Input Case at Tape Head	
B90:1/1			Tape Head Top External Input System Start Latch	
B90:1/2			Tape Head Top External Input Drives MS	
B90:1/3			Tape Head Top Case at Head One Shot	
B90:1/4			Tape Head Top No Case at Head One Shot	
B90:1/5			Tape Head Top External Input Control Power ONS	
B90:1/6			Tape Head Top External Input Not Low Tape	
B90:1/15			Tape Head Top External Input Alarm Reset	
B90:2			Tape Fault Module Outputs Bottom Tape Unit	
B90:2/0			Tape Fault Module Output Bottom Tape Application Fault	
B90:2/1			Tape Fault Module Output Bottom Tape Cut Fault	
B90:2/2			Tape Fault Module Output Bottom Low Tape	
B90:2/14			Tape Fault Module Output Bottom Tape Fault	
B90:2/15			Tape Fault Module Output Bottom Taping Error LT	
B90:3			Tape Fault Module Outputs Top Tape Unit	
B90:3/0			Tape Fault Module Output Top Tape Application Fault	
B90:3/1			Tape Fault Module Output Top Tape Cut Fault	
B90:3/2			Tape Fault Module Output Top Low Tape	
B90:3/14			Tape Fault Module Output Top Tape Fault	
B90:3/15			Tape Fault Module Output Top Taping Error LT	
B90:4/0			Tape Head Bottom Application Fault	
B90:4/12			ONS	
B90:4/13			ONS	
B90:4/14			ONS	
B90:4/15			ONS	
B90:5/0			Tape Head Bottom No Cut Test Enable	
B90:5/1			Tape Head Bottom Cut Fault	
B90:5/15			ONS	
B90:6/0			Tape Head Top Application Fault	
B90:6/12			ONS	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
B90:6/13			ONS	
B90:6/14			ONS	
B90:6/15			ONS	
B90:7/0			Tape Head Top No Cut Test Enable	
B90:7/1			Tape Head Top Cut Fault	
B90:7/15			ONS	
B100:0/0			Erector Glue Module Input MCR	
B100:0/1			Erector Glue Module Input Erector Running	
B100:0/3			Erector Glue Module Input Dry Cycle	
B100:0/4			Erector Glue Module Input Compression Trigger	
B100:0/7			Erector Glue Module Input Compression Reset	
B100:0/8			Erector Glue Module Input Erector Cycle Reset	
B100:0/9			Erector Glue Module Input Soft Start Delay	
B100:1/0			Erector Glue Disable PB (From HMI)	
B100:1/1			One-Shot	
B100:1/2			Erector Glue Disable SWP	
B100:1/3			Erector Glue Disable	
B100:1/4			Manual Compression Extend PB (HMI)	
B100:1/5			Manual Compression Retract PB (HMI)	
B100:2/3			Latch Bottom Glue Cycle	
B100:2/4			Bottom Glue Cycle Reset	
B100:2/5			EXTEND COMPRESSION	
B100:2/6			Compression Complete	
B100:2/7			One-Shot	
B100:2/8			Compression Reset	
B100:3/0			Erector Glue Module Output Erector Glue Gun	
B100:3/1			Erector Glue Module Output Compression Extend	
B100:3/2			Erector Glue Module Output Compression Retract	
B100:6/0			Manual Compression Extend SWP	
B100:6/1			Manual Compression Extend Latch	
B100:6/2			Manual Compression Retract SWP	
B100:6/3			Manual Compression Retract Latch	
B100:6/14			Manual Compression Retract PB ONS	
B100:6/15			Manual Compression Extend PB ONS	
B100:7/9			Compression Reset 2	
B105:0/0			Sealer Glue Module Input MCR	
B105:0/1			Sealer Glue Module Input Erector Running	
B105:0/3			Sealer Glue Module Input Dry Cycle	
B105:1/0			Sealer Glue Disable PB (From HMI)	
B105:1/1			One-Shot	
B105:1/2			Sealer Glue Disable SWP	
B105:1/3			Sealer Glue Disable	
B105:2/3			Latch Top Glue Cycle	
B105:2/4			Top Glue Cycle Reset	
B105:3/0			Sealer Glue Module Output Sealer Glue Gun	
B150:0/0			Trip Reset	
B150:0/1			Alarm Reset	
B150:0/2			Sealer Trip Reset	
B150:0/3			ONS	
B150:0/12			Sealer Power Up ONS	
B150:0/14			ONS	
B150:0/15			Power Up ONS	
B150:1/0			Alarms Acknowledge All To HMI	
B150:1/1			Alarms Acknowledge All PB From HMI	
B150:1/2			Alarms Clear All PB From HMI	
B150:1/3			Alarms Clear All to HMI	
B150:2/0			Alarms CE Trip Present	
B150:2/1			Alarms Sealer Trip Present	
B150:2/12			Alarms Sealer Alarm Diagnostic	
B150:2/13			Alarms CE Alarm Diagnostic	
B150:2/14			Trip Sealer Diagnostic	
B150:2/15			Trip CE Diagnostic	
B150:3/0			Alarms CE Alarm Present	
B150:3/1			Alarms Sealer Alarm Present	
B150:10			Alarms CE Trip Word	
B150:10/0			Trip CASE JAM	
B150:10/1			Trip VAC RELEASE PE BACKUP	
B150:10/2			Trip Vac Plate Extend	
B150:10/3			Trip Pusher Bar Jam	
B150:10/4			Trip Carriage Jam Extending	
B150:10/5			Trip Carriage Jam Retracting	
B150:10/6			Trip Servo Axis Fault	
B150:10/7			Trip Sidebelt VFD Fault	
B150:10/8			Trip Sidebelt MS Overload	
B150:10/9			Trip Opposite Hand Case Jam	
B150:10/10			Trip Case Jam	
B150:10/11			Trip Spare Bit 11	
B150:10/12			Trip Spare Bit 12	
B150:10/13			Trip Spare Bit 13	
B150:10/14			Trip Vac Plate Retract	
B150:10/15			Trip Spare Bit 15	
B150:11			Alarms Sealer Trip Word	
B150:11/0			Trip Sealer Case Jam	
B150:11/1			Trip Sealer Bit 1	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
B150:11/2			Trip Sealer Bit 2	
B150:11/3			Trip Sealer Bit 3	
B150:11/4			Trip Sealer Bit 4	
B150:11/5			Trip Sealer Bit 5	
B150:11/6			Trip Sealer Bit 6	
B150:11/7			Trip Sealer Bit 7	
B150:11/8			Trip Sealer Bit 8	
B150:11/9			Trip Sealer Bit 9	
B150:11/10			Trip Sealer Bit 10	
B150:11/11			Trip Sealer Bit 11	
B150:11/12			Trip Sealer Bit 12	
B150:11/13			Trip Sealer Bit 13	
B150:11/14			Trip Sealer Bit 14	
B150:11/15			Trip Sealer Bit 15	
B150:20			Alarms CE Alarm Word	
B150:20/0			Alarms CE Alarm Spare Bit 0	
B150:20/1			Alarms CE Alarm Spare Bit 1	
B150:20/2			Alarms CE Alarm Spare Bit 2	
B150:20/3			Alarms CE Alarm Spare Bit 3	
B150:20/4			Alarms Case Conv MS AUX	
B150:20/5			Alarms Product Conveyor VFD	
B150:20/6			Alarms CE Alarm Tape Bottom Application	
B150:20/7			Alarms CE Alarm Tape Bottom Cut	
B150:20/8			Alarms CE Alarm Low Air Pressure	
B150:20/9			Alarms CE Alarm Spare Bit 9	
B150:20/10			Alarms CE Alarm Spare Bit 10	
B150:20/11			Alarms CE Alarm Spare Bit 11	
B150:20/12			Alarms CE Alarm Spare Bit 12	
B150:20/13			Alarms CE Alarm Spare Bit 13	
B150:20/14			Alarms CE Alarm Spare Bit 14	
B150:20/15			Alarms CE Alarm Spare Bit 15	
B150:21			Alarms Sealer Alarm Word	
B150:21/0			Alarms Sealer Alarm Top Tape Application	
B150:21/1			Alarms Sealer Alarm Top Tape Cut	
B150:21/2			Alarm Sealer Spare Bit 2	
B150:21/3			Alarms Sealer Alarm Bottom Tape Application	
B150:21/4			Alarms Sealer Alarm Bottom Tape Cut	
B150:21/5			Alarm Sealer Spare Bit 5	
B150:21/6			Alarm Sealer Spare Bit 6	
B150:21/7			Alarm Sealer Spare Bit 7	
B150:21/8			Alarm Sealer Spare Bit 8	
B150:21/9			Alarm Sealer Spare Bit 9	
B150:21/10			Alarm Sealer Spare Bit 10	
B150:21/11			Alarm Sealer Spare Bit 11	
B150:21/12			Alarm Sealer Spare Bit 12	
B150:21/13			Alarm Sealer Spare Bit 13	
B150:21/14			Alarm Sealer Spare Bit 14	
B150:21/15			Alarm Sealer Spare Bit 15	
C48:0	CRT_MIN_ACC	Global	RUN TIME' ACCUM TIME (MINUTES)	
C48:2	CFT_MIN_ACC	Global	FAULT TIME' ACCUM TIME (MINUTES)	
C48:4	CIT_MIN_ACC	Global	IDLE TIME' ACCUM TIME (MINUTES)	
C48:6	TOTAL_CYCLES_LOW	Global	MACHINE CYCLE COUNT 1 - 1000	
C48:7	TOTAL_CYCLES_HIGH	Global	MACHINE CYCLE COUNT 1,000 - 10000000	
C48:8	SHIFT_MIN	Global	MINUTES FOR CURRENT SHIFT	
C48:9	SHIFT_CYCLE	Global	SHIFT CYCLE COUNT' CNTR	
C48:10			Resettable CYCLE COUNT CNTR	
C58:0			CASE PICK ATTEMPT CNTR	
C58:1			Continuous Run Mode Counter	
C58:2			POWER MAGAZINE CASE FAULT LEFT	
C58:3			MAGAZINE CASE FAULT RIGHT	
C78:0			Tape Rotation Counter No Apply	
C78:1			Tape Fault Count	
C78:2			No Tape Cut Fault Count	
C78:3			Tape Rotation Counter No Cut	
C78:3.ACC/0				
C78:4			Tape Alarms External Input Bottom Tape Disable Counter	
C78:5			TOP TAPE CASE COUNTER BEFORE NO CUT FAULT IS ACTIVE	
C78:10			Tape Rotation Counter No Apply	
C78:11			TOP TAPE CASE COUNTER BEFORE NO APPLY FAULT IS ACTIVE	
C78:12			No Tape Cut Fault Count	
C78:13			Tape Rotation Counter No Cut	
C78:14			Tape Alarms External Input Top Tape Disable Counter	
C153:2				
C153:3				
C153:3/DN			POWER MAGAZINE CASE FAULT(R)	
C254:0			Error Routine Counter	
F25:0			HMI System Timeout	
F25:1			Stored Password	
F49:0	SHIFT_EFF	Global	ACTIVE RUN TIME DIVIDED BY SHIFT DURATION	
F49:1	SHIFT_EFF_PERCENT	Global	CURRENT SHIFT EFFICIENCY PERCENT (FLOAT POINT)	
F49:2			Machine Total Cycle Count	
F49:3	PRODRATE_CPM	Global	PRODUCTION RATE IN CASES PER MINUTE'	
F49:10			Total Machine Run Time Minutes	
F49:11			Total Machine Run Time Hours	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
F59:0			Extend Vacuum Plate On Retract	
F59:1			CE Cycle Module Input ACTUAL POSITION IN UU (REAL)	
F63:0			Recipe Storage Recipe Element 0 Vacuum Blow Off Delay	
F63:1			Recipe Storage Recipe Element 1 Squaring Extend Delay	
F63:2			Recipe Storage Recipe Element 2 Trailing Minor Flap Delay	
F63:3			Recipe Storage Recipe Element 3 Vacuum Plate Retract Delay	
F63:4			Recipe Storage Recipe Element 4 Tape Wipe Slow Down Delay	
F63:5			Recipe Storage Recipe Element 5 Side Belt Slow Speed Reset	
F63:6			Recipe Storage Recipe Element 6 Servo Home Offset	
F63:7			Recipe Storage Recipe Element 7 Servo Forward Speed	
F63:8			Recipe Storage Recipe Element 8 Major Flaps Delay	
F63:9			Recipe Storage Recipe Element 9 Slider Extend Delay	
F63:10			Recipe Storage Recipe Element 10 Vacuum Blowoff Duration	
F63:11			Recipe Storage Recipe Element 11 Discharge Backup Delay	
F63:12			Recipe Storage Recipe Element 12 Transfer Conveyor Start Delay	
F63:13			Recipe Storage Recipe Element 13	
F63:14			Recipe Storage Recipe Element 14 Continous Mode Pacing Timer	
F63:20			Recipe Storage Recipe Element 20 Top First Bead Delay	
F63:21			Recipe Storage Recipe Element 21 Top First Bead Duration	
F63:22			Recipe Storage Recipe Element 22 Top Second Bead Delay	
F63:23			Recipe Storage Recipe Element 23 Top Second Bead Duration	
F63:24			Recipe Storage Recipe Element 24 Bottom First Bead Delay	
F63:25			Recipe Storage Recipe Element 25 Bottom First Bead Duration	
F63:26			Recipe Storage Recipe Element 26 Bottom Second Bead Delay	
F63:27			Recipe Storage Recipe Element 27 Bottom Second Bead Duration	
F63:28			Recipe Storage Recipe Element 28 Case Width	
F63:29			Recipe Storage Recipe Element 29 spare	
F63:30			Recipe Storage Recipe Element 30 Compression Extend Time	
F63:31			Recipe Storage Recipe Element 31 Hot Melt Sealer Kicker Delay	
F63:32			Recipe Storage Recipe Element 32 spare	
F63:33			Recipe Storage Recipe Element 33 spare	
F63:34			Recipe Storage Recipe Element 34 spare	
F64:0			Recipe Active Recipe Element 0 Vacuum Blow Off Delay	
F64:1			Recipe Active Recipe Element 1 Squaring Extend Delay	
F64:2			Recipe Active Recipe Element 2 Trailing Minor Flap Delay	
F64:3			Recipe Active Recipe Element 3 Vacuum Plate Retract Delay	
F64:4			Recipe Active Recipe Element 4 Tape Wipe Slow Down Delay	
F64:5			Recipe Active Recipe Element 5 Side Belt Slow Speed Reset	
F64:6			Recipe Active Recipe Element 6 Servo Home Offset	
F64:7			Recipe Active Recipe Element 7 Servo Forward Speed	
F64:8			Recipe Active Recipe Element 8 Major Flaps Delay	
F64:9			Recipe Active Recipe Element 9 Slider Extend Delay	
F64:10			Recipe Active Recipe Element 10 Vacuum Blowoff Duration	
F64:11			Recipe Active Recipe Element 11 Discharge Backup Delay	
F64:12			Recipe Active Recipe Element 12 Transfer Conveyor Start Delay	
F64:13			Recipe Active Recipe Element 13	
F64:14			Recipe Active Recipe Element 14 Continous Mode Pacing Timer	
F64:20			Recipe Active Recipe Element 20 Top First Bead Delay	
F64:21			Recipe Active Recipe Element 21 Top First Bead Duration	
F64:22			Recipe Active Recipe Element 22 Top Second Bead Delay	
F64:23			Recipe Active Recipe Element 23 Top Second Bead Duration	
F64:24			Recipe Active Recipe Element 24 Bottom First Bead Delay	
F64:25			Recipe Active Recipe Element 25 Bottom First Bead Duration	
F64:26			Recipe Active Recipe Element 26 Bottom Second Bead Delay	
F64:27			Recipe Active Recipe Element 27 Bottom Second Bead Duration	
F64:28			Recipe Active Recipe Element 28 Case Width	
F64:29			Recipe Active Recipe Element 29 spare	
F64:30			Recipe Active Recipe Element 30 Compression Extend Time	
F64:31			Recipe Active Recipe Element 31 Hot Melt Sealer Kicker Delay	
F64:32			Recipe Active Recipe Element 32 spare	
F64:33			Recipe Active Recipe Element 33 spare	
F64:34			Recipe Active Recipe Element 34 spare	
F64:39			Servo Forward Speed Compare	
F74:0			Offset / Case Length SP	
F74:1			Negative Jogging Velocity	
F74:2			Forward Speed	
F74:3			Carriage Extend Distance	
F74:4			Offset / Case Length SP	
F74:5			Servo Max Travel Distance	
F74:6			Case Length Minus 2	
F74:8			Servo Fixed Offset	
F74:9			Servo Offset (Home Position)	
F74:10			Positive Jogging Velocity	
F74:11			Retract Speed	
F74:12			Extend ACC/ DECEL	
F74:13			Retract ACC/DECEL	
F74:15			Opposite Hand Case Move	
F74:16			Forward Speed Pre-Move	
F74:17			Case Width Plus 2	
F74:20			Servo Max Travel Distance From HMI	
F74:23			Small Case Size Multiplied By 2	
F74:26			Non Opp Hand Span Compare	
F74:27			Opp Hand Span Compare	
F74:28				

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
F74:29			Carriage Span Zero Line	
F209:0	AX1_STS_ACT_VEL	Global	AXIS1: ACTUAL VELOCITY IN UU/MIN (REAL)	
F209:1	AX1_STS_ACT_POS	Global	AXIS1: ACTUAL POSITION IN UU (REAL)	
F209:2			AXIS1: COMMAND POSITION IN UU (REAL)	
F209:6	AX1_STS_DATA_LINK_C	Global	AXIS1: DATA LINK C (REAL)	
F211:0	AX1_OUT_ACCEL_LIM	Global	AXIS1: ACCELERATION LIMIT IN UU (POS. MODE) (REAL)	
F211:1	AX1_OUT_DECEL_LIM	Global	AXIS1: DECELERATION LIMIT IN UU (POS. MODE) (REAL)	
F211:3	AX1_OUT_VEL_LIM	Global	AXIS1: VELOCITY LIMIT IN UU/SEC (POS. MODE) (REAL)	
F211:4			AXIS1: COMMAND POSITION IN UU (REAL)	
F211:6	AX1_OUT_LINK_C	Global	AXIS1: DATA LINK C (REAL) USER UNITS PER REV	
F211:10			Jogging Accel Value	
F211:11			Jogging Decel Value	
F211:12			Jogging Velocity	
I:0:0			Input Module Base	
I:0/1	I_0_01	Global	START PB	
I:0/2	I_0_02	Global	Call for Case PB	
I:0/3	I_0_03	Global	CARRIAGE RETRACTED RS	
I:0/5	I_0_05	Global	VACUUM PLATE EXTENDED RS	
I:0/6	I_0_06	Global	VACUUM PLATE RETRACTED RS	
I:0/7	I_0_07	Global	CARRIAGE EXTENDED RS	
I:0/8	I_0_08	Global	Control Power ON	
I:0/9	I_0_09	Global	Leading Minor Flap Disable PE	
I:0/10	I_0_10	Global	Vacuum Release Position PE	
I:0/11	I_0_11	Global	DISCHARGE BACKUP PE	
I:0/12			AIR PRESSURE LOW	
I:0/13	I_0_13	Global	Carriage In Position	
I:0/14	I_0_14	Global	LOW CASES PX	
I:0/15	I_0_15	Global	Case at Bottom Tapehead PE	
I:0/16	I_0_16	Global	STOP PB	
I:0/17	I_0_17	Global	Bottom Head Low Tape/ Low Glue	
I:0/18	I_0_18	Global	Erector Side Belts OK/ Bottom Hot Melt Ready	
I:0/19	I_0_19	Global	Erector Control Power	
I:1:0			Input Module 1	
I:1/0	I_1_00	Global	Compression Extended	
I:1/1	I_1_01	Global	Compression Retracted	
I:1/2	I_1_02	Global	Mag Advance LEFT PE	
I:1/3	I_1_03	Global	Mag Advance RIGHT PE	
I:1/4	I_1_04	Global	Hand Pack Position PE	
I:1/5	I_1_05	Global	Product Conveyor Ready	
I:1/6	I_1_06	Global	Case Conveyor AUX Ready	
I:1/7	I_1_07	Global	SEALER START PB	
I:1/8	I_1_08	Global	Sealer MCR	
I:1/9	I_1_09	Global	Sealer Flap Kicker PE	
I:1/10	I_1_10	Global	Case at Top Tape Head PE	
I:1/11	I_1_11	Global	CASE PRESENT PE	
I:1/12	I_1_12	Global	Top Head Low Tape PE / Top Hot Melt Low Glue	
I:1/13	I_1_13	Global	SERVO READY	
I:1/15	I_1_15	Global	Pusher Bar at UP PX	
I:3/0	I_3_00	Global	Hold Down Present	
I:3/1	I_3_01	Global	Customer Call for Case	
I:3/2	I_3_02	Global	spare	
I:3/3	I_3_03	Global	spare	
I:3/4	I_3_04	Global	spare	
I:3/5	I_3_05	Global	spare	
I:3/6	I_3_06	Global	spare	
I:3/7	I_3_07	Global	spare	
I:3/8	I_3_08	Global	spare	
I:3/9	I_3_09	Global	spare	
I:3/10	I_3_10	Global	spare	
I:3/11	I_3_11	Global	spare	
I:3/12	I_3_12	Global	spare	
I:3/13	I_3_13	Global	spare	
I:3/14	I_3_14	Global	spare	
I:3/15	I_3_15	Global	spare	
I:5/1			Robot Running	
I:5/4	I_5_4	Global	Robot DO 104 Stop Infeed Conveyor	
I:5/5	I_5_5	Global	Case Complete From Robot DO 105	
I:5/13			Cycle Complete From Sheet Feeder	
I:5/15			Robot Safety Relay ON	
L204:0	AX1_DAT_DRIVE_RESET	Global	AXIS1: DRIVE FAULT RESET	
L208:0			AXIS1: INPUT ASSBLY BITS	
L208:0/0	AX1_STS_DRIVE_EN	Global	AXIS1: ENABLED STATUS 0:DISABLED 1:ENABLED	
L208:0/1	AX1_STS_PHY_AX_FAULT	Global	AXIS1: PHYSICAL AXIS FAULT	
L208:0/2	AX1_IN_POSITION	Global	Axis 1 In Position	
L208:1/6	AX1_HOMED	Global	Axis Homed	
L208:6			AXIS1: ACTUAL VELOCITY IN UU/MIN (REAL)	
L208:14			AXIS1: DATA LINK C (REAL)	
L208:16			ERROR CODE FROM AXIS 1	
L208:17			AXIS1: OUTPUT ASSBLY BITS	
L210:0			AXIS1: START MOTION	
L210:0/2	AX1_OUT_STRT_MOTION	Global	AXIS1: START MOTION	
L210:0/3	AX1_DEFINE_HOME	Global	Define Home	
L210:0/7	AX1_OUT_DRIVE_EN	Global	AXIS1: DRIVE ENABLE	
L210:2	AX1_OUT_REF_SOURCE	Global	AXIS1: REFERENCE SOURCE (DINT)	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
L210:3			AXIS1: ACCELERATION LIMIT IN UU (POS. MODE) (REAL)	
L210:7			Axis Command Position	
L210:11			AXIS1: DATA LINK C (REAL)	
L210:14			HOMING TYPE IMMEDIATE AXIS 1	
L210:15			START JOG CONTROL REGISTER TO AXIS 1	
L210:16			POSITION 0 REGISTER TO AXIS 1	
L210:20			JOGGING ACCEL TO AXIS 1	
L210:21			JOGGING DECEL TO AXIS 1	
L210:22			JOGGING SPEED TO AXIS 1	
MG200:0	AX1_READ_IN_ASSBLY	Global	AXIS1: READ INPUT ASSEMBLY OBJECT	
MG200:1	AX1_WRT_OUT_ASSBLY	Global	AXIS1: WRITE OUTPUT ASSEMBLY OBJECT	
MG200:2			SET AXIS 1 POSITION TO ZERO	
MG200:4	AX1_WRT_FAULT_RESET	Global	AXIS1: WRITE DRIVE FAULT RESET	
MG200:5			SET JOGGING DECEL AXIS 1	
MG200:6			SET JOGGING ACCEL AXIS 1	
MG200:7			Set Jogging Speed	
MG200:8			Toggle Jogging Start	
MG200:9			SET HOMING TO IMMEDIATE	
MG200:10			READ AXIS 1 FAULT CODE	
N7:0/0			Call For Case Allow From Packer	
N11:0			Second Language Selected Status Word	
N11:1			System Running Indication	
N11:10			Second Language HMI Reference Number	
N21:10				
N21:11				
N21:12				
N21:13				
N21:19				
N21:26				
N21:27				
N21:29				
N24:0			INDIRECT ADDRESS POINTER	
N24:1	FAULT_NUMBER	Global	FAULT REGISTER TO HMI	
N24:2			Max Number of Message to Display	
N24:10			SCREEN NUMBER FROM HMI	
N41:0	SLR_MODE	Global	0=NO SEALER 1=SEALER ONLY 3=SLR & TOP ALARM 7=SLR & T/B ALARM	
N46:2			FIRST SHIFT START TIME (HOURS) (FROM HMI)	
N46:3	FIRST_STRT_HRS	Global	FIRST SHIFT START TIME (MINUTES) (FROM HMI)	
N46:4	FIRST_STRT_MIN	Global	SECOND SHIFT START TIME (HOURS) (FROM HMI)	
N46:5			SECOND SHIFT START TIME (MINUTES) (FROM HMI)	
N46:6	SECOND_STRT_HRS	Global	THIRD SHIFT START TIME (HOURS) (FROM HMI)	
N46:7	SECOND_STRT_MIN	Global	THIRD SHIFT START TIME (MINUTES) (FROM HMI)	
N46:10			Production Data Runtime Minutes Storage 3	
N46:11			Production Data Runtime Minutes Storage 2	
N46:12			Production Data Runtime Minutes Storage 1	
N46:13			Runtime Total Minutes FIFO	
N46:14	RUNTIME_MIN_ACC	Global	Runtime Total Minutes FIFO	
N46:15			Runtime Total Minutes FIFO	
N46:16			Runtime Total Minutes FIFO	
N46:17			Runtime Total Minutes FIFO	
N46:18			Runtime Total Minutes FIFO	
N46:19			Runtime Total Minutes FIFO	
N46:20			Production Data Faulttime Minutes Storage 3	
N46:21			Production Data Faulttime Minutes Storage 2	
N46:22			Production Data Faulttime Minutes Storage 1	
N46:25			Production Data Faulttime Minutes FIFO Unload	
N46:30			Production Data Idletime Minutes Storage 3	
N46:31			Production Data Idletime Minutes Storage 2	
N46:32			Production Data Idletime Minutes Storage 1	
N46:35			Production Data Idletime Minutes FIFO Unload	
N46:40			Production Data Max Run Minutes Storage 3	
N46:41			Production Data Max Run Minutes Storage 2	
N46:42			Production Data Max Run Minutes Storage 1	
N46:45			Production Data Max Run Minutes FIFO Unload	
N46:50			Production Data Runtime Percent Storage 3	
N46:51			Production Data Runtime Percent Storage 2	
N46:52			Production Data Runtime Percent Storage 1	
N46:53			Production Data Runtime Percent FIFO	
N46:54			Production Data Runtime Percent FIFO	
N46:55			Production Data Runtime Percent FIFO Unload	
N46:56			Production Data Runtime Percent FIFO	
N46:57			Production Data Runtime Percent FIFO	
N46:58			Production Data Runtime Percent FIFO	
N46:59			Production Data Runtime Percent FIFO	
N46:60			Production Data Shift Cycle Count Storage 3	
N46:61			Production Data Shift Cycle Count Storage 2	
N46:62			Production Data Shift Cycle Count Storage 1	
N46:65			Production Data Shift Count FIFO Unload	
N46:100			HMI Display Current Faulttime Hours	
N46:101			HMI Display Current Faulttime Minutes	
N46:110			HMI Display Current Idletime Hours	
N46:111			HMI Display Current Idletime Minutes	
N46:120			HMI Display Current Runtime Hours	
N46:121			HMI Display Current Runtime Minutes	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
N46:130			HMI Display Faulttime 1 History Hours	
N46:131			HMI Display Faulttime 1 History Minutes	
N46:132			HMI Display Faulttime 2 History Hours	
N46:133			HMI Display Faulttime 2 History Minutes	
N46:134			HMI Display Faulttime 3 History Hours	
N46:135			HMI Display Faulttime 3 History Minutes	
N46:140			HMI Display Idletime 1 History Hours	
N46:141			HMI Display Idletime 1 History Minutes	
N46:142			HMI Display Idletime 2 History Hours	
N46:143			HMI Display Idletime 2 History Minutes	
N46:144			HMI Display Idletime 3 History Hours	
N46:145			HMI Display Idletime 3 History Minutes	
N46:150			HMI Display MAX Runtime 1 History Hours	
N46:151			HMI Display MAX Runtime 1 History Minutes	
N46:152			HMI Display MAX Runtime 2 History Hours	
N46:153			HMI Display MAX Runtime 2 History Minutes	
N46:154			HMI Display MAX Runtime 3 History Hours	
N46:155			HMI Display MAX Runtime 3 History Minutes	
N46:160			HMI Display Runtime 1 History Hours	
N46:161			HMI Display Runtime 1 History Minutes	
N46:162			HMI Display Runtime 2 History Hours	
N46:163			HMI Display Runtime 2 History Minutes	
N46:164			HMI Display Runtime 3 History Hours	
N46:165			HMI Display Runtime 3 History Minutes	
N46:190			RUN TIME' TOTAL ACCUM IN MINUTES FORMAT	
N46:191			RUN TIME' PEAK (MINUTES)	
N46:192			CURRENT SHIFT EFFICIENCY PERCENT (INTEGER)	
N46:200			Real Time Clock Hour Value Set from (HMI)	
N46:202			Real Time Clock Min Value Set from (HMI)	
N46:204			Real Time Clock Sec Value Set from (HMI)	
N46:206			Real Time Clock Year Value Set from (HMI)	
N46:208			Real Time Clock Month Value Set from (HMI)	
N46:210			Real Time Clock Day Value Set from (HMI)	
N51:0			CE Machine Options File Save	
N51:1			CE Machine Options File Save 2	
N61:0			Recipe Current Recipe	
N61:1			Recipe New Recipe	
N71:0			Servo Fault Code	
N76:0			BOTTOM HEAD PULSE-TO-PULSE TIME (mS)	
N76:1			CASE PRESENT ERECTOR TAPE ROTATION COUNTER BUFFER	
N76:10			TOP HEAD PULSE-TO-PULSE TIME (mS)	
N76:11			CASE PRESENT ERECTOR TAPE ROTATION COUNTER BUFFER	
N83:0			Cycle Mode From HMI	
N91:0			Tape Head Bottom Tape Rotation High Speed Counter Value	
N91:1			Tape Head Bottom Application Counts Minimum Setpoint	
N91:2			Tape Head Bottom Cut Counts Minimum Setpoint	
N91:3			Tape Head Bottom No Cut Test Starting HSC Count	
N91:4			Tape Head Bottom No Cut Test Active Count	
N91:9			Tape Head Bottom Tape Disable Status	
N91:10			Tape Head Top Tape Rotation High Speed Counter Value	
N91:11			Tape Head Top Application Counts Minimum Setpoint	
N91:12			Tape Head Top Cut Counts Minimum Setpoint	
N91:13			Tape Head Top No Cut Test Starting HSC Count	
N91:14			Tape Head Top No Cut Test Active Count	
N91:19			Tape Head Top Tape Disable Status	
N203:0				
N251:0			Last Error	
N251:1			Error Code	
O:0.0				
O:0/0			Output SIDE BELT SPEED SELECT 1 / Compression Extend SV	
O:0/1			Output SIDE BELT SPEED SELECT 2 / Compression Retract SV	
O:0/2			Output Product Conveyor MS	
O:0/3			Output Case Conveyor MS	
O:0/4			Output Case Conveyor Speed 1	
O:0/5			Output Case Conveyor Speed 2	
O:0/6			Output Sealer Glue Gun	
O:0/7			Output SPARE Output	
O:0/8			Output Bottom Taping / Low Cases Error LT	
O:0/9			Output Top Taping Error LT	
O:0/10			Output Kicker Extend	
O:0/11			Output Sealer Drive Run	
O:2.0			Output Module 2	
O:2/0			Output Main Air	
O:2/1			Output VACUUM PLATE INDEX SV	
O:2/2			Output VACUUM PLATE EXTEND SV	
O:2/3			Output SQUARING MAJOR FLAP SV	
O:2/4			Output TRAILING MINOR FLAP SV	
O:2/5			Output Leading Minor Flap SV	
O:2/6			Output MAJOR Flap Extend SV	
O:2/7			Output Pusher Bar Down	
O:2/8			Output Carriage Extend SV	
O:2/9			Output VACUUM ON SV	
O:2/10			Output VACUUM BLOW OFF SV	
O:2/11			Output Erector Sidebelt Drive/ Erector Glue Gun	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
O:2/12			Output SERVO ENABLE	
O:2/13			Output POWER MAG CASE ADVANCE LEFT	
O:2/14			Output POWER MAG CASE ADVANCE RIGHT	
O:2/15			Output Opp Hand Vacuum	
O:4/0			Spare Output 4/0	
O:4/1			Spare Output 4/1	
O:4/2			Spare Output 4/2	
O:4/3			Spare Output 4/3	
O:4/4			Spare Output 4/4	
O:4/5			Spare Output 4/5	
O:4/6			Spare Output 4/6	
O:4/7			Spare Output 4/7	
O:4/8			Spare Output 4/8	
O:4/9			Spare Output 4/9	
O:4/10			Spare Output 4/10	
O:4/11			Spare Output 4/11	
O:4/12			Spare Output 4/12	
O:4/13			Spare Output 4/13	
O:4/14			Spare Output 4/14	
O:4/15			Spare Output 4/15	
R6:3			RUN TIME' MINUTES FFL CONTROL REG	
R6:6			FAULT TIME' MINUTES FFL CONTROL REG	
R6:9			IDLE TIME' MINUTES FFL CONTROL REG	
R6:11			EFFICIENCY' FFL CONTROL REG	
R6:12			MAX RUN TIME' SECONDS FFL CONTROL REG	
R6:13			MAX RUN TIME' MINUTES FFL CONTROL REG	
R6:15			SHIFT COUNT' FFL CONTROL REG	
RTC:0.MIN				
RTC:0/DS				
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:1/5			Forces Enabled	
S:1/6			Forces Present	
S:1/7			Comms Active	
S:1/8			Fault Override at Powerup	
S:1/9			Startup Protection Fault	
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	
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:4/4			CLOCK PULSE	
S:4/5			CLOCK PULSE	
S:4/12			CLOCK PULSE	
S:5				
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			CLOCK PULSE	
S:13			Math Register	
S:14			Math Register	
S:15			Node Address/ Baud Rate	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
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 Register	
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 Disable,Fl	
S:35			Last 1 ms Scan Time	
S:36			Extended Minor Error Bits	
S:36/8			DII Lost	
S:36/9			STI Lost	
S:36/10			Memory Module Data File Overwrite Protection	
S:37			Clock Calendar Year	
S:38			Clock Calendar Month	
S:39			Clock Calendar Day	
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			DII 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 Number	
S:51			Discrete Input Interrupt- Return Number	
S:52			Discrete Input Interrupt- Accumulat	
S:53			Reserved/ Clock Calendar Day of the Week	
S:55			Last DII Scan Time	
S:56			Maximum Observed DII 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	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
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	
ST23:0			Current User (From HMI)	
ST23:1			Current User No User Logged IN	
ST23:2			Current User User Level	
ST23:3			Current User Tech Level	
ST23:4			Current User Admin Level	
ST29:11			Recipe Name Current	
ST29:[N26:0]				
T12:0			MAIN AIR DELAY	
T12:1				
T22:0			FAULT DISPLAY TIME	
T22:1			FAULT CLEAR DELAY	
T22:3			Admin Logged In Time	
T22:5			Recipe Load Delay	
T22:6			Load Complete Delay	
T22:7			Recipe Load Delay	
T22:8			Load Complete Delay	
T42:0			INDEX GATE DROP DELAY	
T42:1			SEALER STOP DLAY	
T42:1/EN				
T42:4			Sealer Drive Speed 2 Slow Duration Timer	
T42:5			Sealer Drive Speed 2 Slow REQ Delay timer	
T42:10			Sealer Hot Melt Kicker Delay	
T42:11			Sealer Hot Melt Kicker Extend Time	
T47:0	CRT_ACC	Global	RUN TIME' ACCUM TMR (SECONDS)	
T47:1	CFT_ACC	Global	FAULT TIME' ACCUM TMR (SECONDS)	
T47:2	CIT_ACC	Global	IDLE TIME' ACCUM TMR (SECONDS)	
T47:3	PRODRATE_EVAL	Global	PRODUCTION RATE' EVALUATION TMR	
T47:5			FIRST SHIFT ACTIVE DLAY TMR	
T47:6			SECOND SHIFT ACTIVE DLAY TMR	
T47:7			THIRD SHIFT ACTIVE DLAY TMR	
T47:8	SHFT_TIME	Global	RUNNING TIMER FOR THE CURRENT SHIFT	
T47:10			SHIFT CHANGE ACTIVE DURATION TIMER	
T47:20			Total Machine Run Time Seconds	
T57:0			CE Cycle Dry Cycle Timer	
T57:1			VACUUM PLATE EXTEND DELAY	
T57:2			VACUUM PLATE RETRACT DELAY	
T57:2/DN				
T57:3			SQUARING EXTEND DELAY	
T57:4			TRAILING MINOR FLAP EXTEND DELAY	
T57:5			READY FOR CASE PUSH DELAY	
T57:6			Carriage EXTEND DELAY	
T57:7			CARRIAGE EXTENDED DURATION TMR	
T57:8			VACUUM BLOWOFF DURATION	
T57:8.PRE				
T57:9			RETRACT Carriage DELAY	
T57:10			Carriage RETRACTING DELAY TMR	
T57:11			Carriage RETRACTED DELAY TIMER	
T57:12			INCR MISSED CASE CNTR TMR	
T57:13			CASE ERECTOR STATE RESET TMR	
T57:18			Call for Case Continuous Mode Pacing Timer	
T57:20			DISCHARGE BACKUP DELAY	
T57:20/DN			DISCHARGE BACKUP DELAY	
T57:23			DELAY SIDE BELT SLOW SPEED	
T57:24			VACUUM BLOW OFF DELAY TIMER (Case Release Dly)	
T57:24.PRE				
T57:25			VACUUM OFF DELAY	
T57:26			DELAY MAJOR FLAPS	
T57:26.PRE				
T57:26/DN				
T57:27			SIDEBELT STOP DELAY	
T57:28			DELAY TIMER 1 FOR TAPE WIPE SLOW DOWN	
T57:28/DN				
T57:28/EN				
T57:29			SIDE BELT SLOW SPEED DURATION	
T57:29.PRE				
T57:29/DN				
T57:29/TT				
T57:30			Sidebelt Stop Case in Place Delay Timer	
T57:31			Call for Case Cancel Timer	
T57:32			Opposite Hand Enabled SWP	
T57:32/DN				
T57:35			Vacuum Blowoff Time	
T67:0			Low Case Timer	
T67:1			Case Conveyor START DELAY	
T67:1/DN				
T67:1/EN				
T67:3			POWER TRANSFER ON TIME	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
T67:6				
T67:7				
T67:8			Sheet Feeder Signal time	
T67:9			Call Case Delay	
T72:0	TM_READ_INPUT_ASSBY	Global	AXIS1: READ INPUT ASSEMBLY DELAY	
T72:0/DN				
T72:2	TM_READ_OUTPUT_ASSBY	Global	AXIS1: READ OUTPUT ASSEMBLY DELAY	
T72:2/DN				
T72:3			DELAY START MOVE	
T72:4			Reset Delay	
T72:5			Software Enable Delay	
T72:6			Pre-Move Delay	
T72:8			Carriage HOME STP 10 OFFSET MOVE COMPLETE DELAY	
T72:9			STEP 3 DELAY JOGGING START	
T72:10			STEP 5 DELAY JOGGING START	
T72:11			STEP 8 START OFFSET MOVE	
T77:0			BOTTOM HEAD PULSE-TO-PULSE DUR TMR	
T77:1			BOTTOM HEAD TAPE CUT WINDOW DUR TMR	
T77:2			BOTTOM TAPE APPLICATION FAULT DLAY TMR	
T77:3			Tape Rotation Enable	
T77:10			TOP HEAD PULSE-TO-PULSE DUR TMR	
T77:11			TOP HEAD TAPE CUT WINDOW DUR TMR	
T77:12			TOP TAPE APPLICATION FAULT DLAY TMR	
T77:13			Reset Tape Count Enable	
T81:0			Case in Position Delay Timer	
T81:1			Case NOT in Position Delay Timer	
T81:2			Case Complete Cylinder has Retracted Timer	
T81:3			Case Complete Case Moved Out Delay Timer	
T81:3/DN				
T81:4			Delay Call For Case	
T92:1			Tape Head Bottom No Cut Test Delay Timer	
T92:2			Tape Head Bottom No Cut Test Duration Timer	
T92:11			Tape Head Top No Cut Test Delay Timer	
T92:12			Tape Head Top No Cut Test Duration Timer	
T102:0			Bottom First Bead Delay	
T102:1			Bottom First Bead Duration	
T102:2			Bottom Second Bead Delay	
T102:3			Bottom Second Bead Duration	
T102:15			COMPRESSION EXTEND TIME	
T107:0			Top First Bead Delay	
T107:1			Top First Bead Duration	
T107:2			Top Second Bead Delay	
T107:3			Top Second Bead Duration	
T152:0			CASE JAM TIMER	
T152:1			RELEASE PE BACKUP	
T152:2			Vacuum Plate Extend Delay	
T152:3			Pusher Bar Jam timer	
T152:4			Carriage Jam Extending Timer	
T152:5			Carriage Jam Retracting Timer	
T152:6			Trip Servo Axis Fault Timer	
T152:6/DN				
T152:7			CE Sidebelt VFD Fault Timer	
T152:8			CE Sidebelt MS Overload Fault Timer	
T152:8/DN				
T152:9			Oposite Hand Case Jam Delay	
T152:10			Alarms Case Jam Delay	
T152:11			CE Trip Delay Timer 11	
T152:11/DN				
T152:12			CE Trip Delay Timer 12	
T152:13			CE Trip Delay Timer 13	
T152:14			Vacuum Plate Retract Alarm Delay	
T152:15			CE Trip Delay Timer 15	
T152:20			CE Alarm Delay Timer 0	
T152:21			CE Alarm Delay Timer 1	
T152:22			CE Alarm Delay Timer 2	
T152:23			CE Alarm Delay Timer 3	
T152:24			Case Conveyor MS Alarm Timer	
T152:25			Product Conveyor VFD Fault Timer	
T152:28			CE Alarm Delay Timer 8	
T152:28/DN				
T152:29			CE Alarm Delay Timer 9	
T152:30			CE Alarm Delay Timer 10	
T152:31			CE Alarm Delay Timer 11	
T152:32			CE Alarm Delay Timer 12	
T152:33			CE Alarm Delay Timer 13	
T152:34			CE Alarm Delay Timer 14	
T152:35			CE Alarm Delay Timer 15	
T152:40			Trip Case Jam In Sealer Delay	
T152:41			Trip Sealer Delay Timer 1	
T152:41/DN				
T152:42			Trip Sealer Delay Timer 2	
T152:43			Trip Sealer Delay Timer 3	
T152:44			Trip Sealer Delay Timer 4	
T152:45			Trip Sealer Delay Timer 5	

Address/Symbol Database

Address	Symbol	Scope	Description	Sym Group
T152:46			Trip Sealer Delay Timer 6	
T152:47			Trip Sealer Delay Timer 7	
T152:48			Trip Sealer Delay Timer 8	
T152:49			Trip Sealer Delay Timer 9	
T152:50			Trip Sealer Delay Timer 10	
T152:51			Trip Sealer Delay Timer 11	
T152:52			Trip Sealer Delay Timer 12	
T152:53			Trip Sealer Delay Timer 13	
T152:54			Trip Sealer Delay Timer 14	
T152:55			Trip Sealer Delay Timer 15	
T152:55.ACC			Trip Sealer Delay Timer 15	
T152:65			Sealer Alarm Delay Timer 5	
T152:66			Sealer Alarm Delay Timer 6	
T152:67			Sealer Alarm Delay Timer 7	
T152:68			Sealer Alarm Delay Timer 8	
T152:69			Sealer Alarm Delay Timer 9	
T152:70			Sealer Alarm Delay Timer 10	
T152:71			Sealer Alarm Delay Timer 11	
T152:72			Sealer Alarm Delay Timer 12	
T152:73			Sealer Alarm Delay Timer 13	
T152:74			Sealer Alarm Delay Timer 14	
T152:75			Sealer Alarm Delay Timer 15	
T247:1				
T247:10				
T247:10/DN				
T247:10/EN				
T247:11			RELEASE PE BACKUP	
T247:13/DN	T152	Global		
U:3			IO Control	
U:4			HMI ROUTINE	
U:5			RECIPESSET ROUTINE	
U:6			MANUAL ROUTINE	
U:8			SEALER ROUTINE	
U:9			Production Data Control	
U:10			CE Control	
U:11			CE Cycle	
U:12			CE Recipe	
U:13			CE Options	
U:14			CE Servo Drive Routine	
U:15			TAPE FAULT ROUTINE	
U:16			MCRI ROBOT ROUTINE	
U:18			LT/NT 2	
U:20			Erector Hot Melt	
U:21			Sealer Hot Melt	
U:30			Alarm Control	

Address	Instruction	Description
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B45:4/24		
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Group_Name Description