FB112 - <offline>

"FB_VerticaalConveyor" Verticaal conveyor
Name: **Family:**
Author: JA **Version:** 0.1
Block version: 2
Time stamp Code: 04/07/2014 09:12:25 AM
Interface: 04/07/2014 09:12:25 AM
Lengths (block/logic/data): 01852 01364 00014

Name	Data Type	Address	Initial Value	Comment
IN		0.0		
iInit	Bool	0.0	FALSE	Initialising the Prorunner
iEnableAutomatic	Bool	0.1	FALSE	Enable mode automatic
iEnableElevator	Bool	0.2	FALSE	Enable clearence emercengystop, thermical etc.
iDischargeConveyorReady	Bool	0.3	FALSE	input Discharge conveyor is running an ready for product
iEnableManual	Bool	0.4	FALSE	FALSE = Mode manual, TRUE = Mode automatic
iManualForward	Bool	0.5	FALSE	Pushbutton Manual forward (normal run)
iManualReverse	Bool	0.6	FALSE	Pushbutton Manual reverse
iProductReadyForInfeed	Bool	0.7	FALSE	Photocel in front of infeed
iReset	Bool	1.0	FALSE	Pushbutton Reset
iProductRelease_B1	Bool	1.1	FALSE	Sensor infeedproduct
iEndInfeedConveyor_B7	Bool	1.2	FALSE	Photocell on infeedconveyor
iStartTimeFrame_B3	Bool	1.3	FALSE	Sensor Forksecurity for outfeed
iProductOnOutfeed_B8	Bool	1.4	FALSE	Dropoff position diagonial occupied
iProductLeftOutfeed_B9	Bool	1.5	FALSE	Dropoff position straight occupied
iMonitorRotation	Bool	1.6	FALSE	Sensor on bottom sprocket(Not standard)
iSupplyEmpty	Bool	1.7	FALSE	Supply is empty for a amount off time
iEmptyTimeEnabled	Time	2.0	T#0MS	Empty time enabled
iTimeInfeedAllowed	Time	6.0	T#0MS	Time of window infeed allowed
iTimeProductOnInfeed	Time	10.0	T#0MS	Time for delay on B7
iTimeCheckSensors	Time	14.0	T#0MS	Delay check sensors in 0,1 sec.
iTimeMonitorInfeed	Time	18.0	T#0MS	Time monitoring of product infeed
iTimeCheckOutfeed	Time	22.0	T#0MS	Time off delay on B3, when time is past outfeed must be empty, if not lift stop
iTimeMonitorRotation	Time	26.0	T#0MS	Time for monitoring of rotation bottom sprocket(0 = disabled)
iTimeDelayMonitorRotatio	Time	30.0	T#0MS	Time to delay monitor rotation at startup
OUT		0.0		
oProrunnerForward	Bool	34.0	FALSE	Forward vertical conveyor
oProrunnerReverse	Bool	34.1	FALSE	Reverse vertical conveyor
oSupplyConveyor	Bool	34.2	FALSE	Supply conveyor before Prorunner
oInfeedConveyor	Bool	34.3	FALSE	Infeed conveyor in Prorunner
oOutfeedConveyor	Bool	34.4	FALSE	Outfeed conveyor in Prorunner
oProrunnerIsEmpty	Bool	34.5	FALSE	Vertical conveyor is empty
oFaultTimeFrameSensor	Bool	34.6	FALSE	Fault Time frame sensor (sensor not triggered)

Name	Data Type	Address	Initial Value	Comment
oFaultProdReleaseSensor	Bool	34.7	FALSE	Fault sensor product release (sensor not triggered)
oFaultProductOnOutfeed	Bool	35.0	FALSE	Fault product on outfeed conveyor present
oFaultProductInfeedtime	Bool	35.1	FALSE	Fault Overtime box inserted
oFaultMonitorRotation	Bool	35.2	FALSE	
IN_OUT		0.0		
STAT		0.0		
sDelayForwardReverse	TON	36.0		
sDelayRelease	TOF	58.0		
sTimeDelayInfeed_B7	TON	80.0		
sTimeMonitorInfeed	TON	102.0		
sDelayProrunnerEmpty	TON	124.0		
sDelayCheckOutfeed	TOF	146.0		
sTimeCheckReleaseSensor	TON	168.0		
sTimeCheckTimeFrameSenso	TON	190.0		
sTimeMonitorRotation	TON	212.0		
sTimeDelayMonitotRotatio	TON	234.0		
sCounters	Struct	256.0		
CountedProducts	DInt	256.0	L#0	
sHM_FP	Struct	260.0		
Reset	Bool	260.0	FALSE	
ProductRelease	Bool	260.1	FALSE	
CheckRotation	Bool	260.2	FALSE	
CheckDropOffPosition	Bool	260.3	FALSE	
sHM_FN	Struct	262.0		
ProductReleased	Bool	262.0	FALSE	
ProductLeftOutfeed_B9	Bool	262.1	FALSE	
CheckRotation	Bool	262.2	FALSE	
TimeFrameOutfeed	Bool	262.3	FALSE	
sManualActive	Bool	264.0	FALSE	
sProductOnOutfeed	Bool	264.1	FALSE	
sStopLiftProdOnOutfeed	Bool	264.2	FALSE	
sEmptyVerticaalConveyor	Bool	264.3	FALSE	
sProductInserted	Bool	264.4	FALSE	
sExtendedRelease	Bool	264.5	FALSE	
TEMP		0.0		
tAutomaticTerms	Bool	0.0		
tAutomatic	Bool	0.1		
tManual	Bool	0.2		
tSignalToDelay	Bool	0.3		
tEnableMotorOn	Bool	0.4		
tEnableMotorForward	Bool	0.5		
tEnableMotorReverse	Bool	0.6		
tProrunnerRunning	Bool	0.7		
tProrunnerRotating	Bool	1.0		

Name	Data Type	Address	Initial Value	Comment
tMonitorRotatioEnabled	Bool	1.1		
tFP	Struct	2.0		
Reset	Bool	2.0		
Productrelease	Bool	2.1		
CheckDropOffPosition	Bool	2.2		
CheckRotation	Bool	2.3		
tFN	Struct	4.0		
ProductReleased	Bool	4.0		
ProductLeftOutfeed_B9	Bool	4.1		
CheckRotation	Bool	4.2		
TimeFrameOutfeed	Bool	4.3		

Block: FB112 Verticaal conveyor

When Init is activated, the prorunner must be empty.
all memory bits will be reset and the prorunner will start all over.

Network: 1 Init

```
      A     #iInit                    #iInit             -- Initialising the Prorunner
      JCN   NoIn

      SET
      R     #sProductOnOutfeed        #sProductOnOutfeed
      R     #sEmptyVerticaalConveyor  #sEmptyVerticaalConveyor
      R     #sProductInserted         #sProductInserted
      R     #sStopLiftProdOnOutfeed   #sStopLiftProdOnOutfeed

NoIn: NOP   0
```

Network: 2 Reset

```
      A     #iReset        #iReset            -- Pushbutton Reset
      FP    #sHM_FP.Reset  #sHM_FP.Reset
      =     #tFP.Reset     #tFP.Reset
```

Network: 3 Release manual/automatic

```
      A     #iEnableAutomatic         #iEnableAutomatic  -- Enable mode automatic
      A     #iEnableElevator          #iEnableElevator   -- Enable clearence emercengystop, thermical etc.
      AN    #iEnableManual            #iEnableManual     -- FALSE = Mode manual, TRUE = Mode automatic
      =     #tAutomaticTerms          #tAutomaticTerms

      A     #tAutomaticTerms          #tAutomaticTerms
      AN    #oFaultMonitorRotation    #oFaultMonitorRotation
      AN    #oFaultProdReleaseSensor  #oFaultProdReleaseSensor -- Fault sensor product release (sensor not
                                      triggered)
      AN    #oFaultTimeFrameSensor    #oFaultTimeFrameSensor -- Fault Time frame sensor (sensor not trigger
                                      ed)
      AN    #sEmptyVerticaalConveyor  #sEmptyVerticaalConveyor
      =     #tAutomatic               #tAutomatic

      A     #iEnableElevator          #iEnableElevator   -- Enable clearence emercengystop, thermical etc.
      A     #iEnableManual            #iEnableManual     -- FALSE = Mode manual, TRUE = Mode automatic
      AN    #iManualForward           #iManualForward    -- Pushbutton Manual forward (normal run)
```

```
      AN    #iManualReverse           #iManualReverse    -- Pushbutton Manual reverse
      S     #sManualActive            #sManualActive

      ON    #iEnableElevator          #iEnableElevator   -- Enable clearence emercengystop, thermical etc.
      ON    #iEnableManual            #iEnableManual     -- FALSE = Mode manual, TRUE = Mode automatic
      R     #sManualActive            #sManualActive

      A     #sManualActive            #sManualActive
      AN    #oFaultMonitorRotation    #oFaultMonitorRotation
      =     #tManual                  #tManual
```

Network: 4 Empty verticaal conveyor

```
      AN    #iProductReadyForInfeed   #iProductReadyForInfeed -- Photocel in front of infeed
      AN    #iEndInfeedConveyor_B7    #iEndInfeedConveyor_B7 -- Photocell on infeedconveyor
      AN    #iProductOnOutfeed_B8     #iProductOnOutfeed_B8 -- Dropoff position diagonial occupied
      AN    #iProductLeftOutfeed_B9   #iProductLeftOutfeed_B9 -- Dropoff position straight occupied
      A     #oProrunnerForward        #oProrunnerForward -- Forward  vertical conveyor
      =     #tProrunnerRunning        #tProrunnerRunning

      CALL  #sDelayProrunnerEmpty     #sDelayProrunnerEmpty
       IN:=#tProrunnerRunning         #tProrunnerRunning
       PT:=#iEmptyTimeEnabled         #iEmptyTimeEnabled -- Empty time enabled
       Q :=#sEmptyVerticaalConveyor   #sEmptyVerticaalConveyor
       ET:=

      A     #sEmptyVerticaalConveyor  #sEmptyVerticaalConveyor
      S     #oProrunnerIsEmpty        #oProrunnerIsEmpty -- Vertical conveyor is empty

      A     #iProductReadyForInfeed   #iProductReadyForInfeed -- Photocel in front of infeed
      O     #iEndInfeedConveyor_B7    #iEndInfeedConveyor_B7 -- Photocell on infeedconveyor
      O     #iProductOnOutfeed_B8     #iProductOnOutfeed_B8 -- Dropoff position diagonial occupied
      O     #iProductLeftOutfeed_B9   #iProductLeftOutfeed_B9 -- Dropoff position straight occupied
      R     #oProrunnerIsEmpty        #oProrunnerIsEmpty -- Vertical conveyor is empty
```

Network: 5 Monitoring outfeed conveyor for next carrier

```
When a product is put on the outfeedconveyor, it must be put in photocel -B8.
this photocell sets a memory bit, so the software knows there is a product
present on the outfeed conveyor even if this product is not in the photcell -B8
anymore.
The product will travel in photocell -B9, and on a negative edge of this
photocell the memory bit is reset.
When the next carrier of the Prorunner activates sensor -B3 a time frame will
start. when this time is past and the memory bit ProductOnOutfeed is still
present, the Prorunner must stop until this memory bit is reset.
```

```
      A     #iStartTimeFrame_B3           #iStartTimeFrame_B3 -- Sensor Forksecurity for outfeed
      FP    #sHM_FP.CheckDropOffPosition  #sHM_FP.CheckDropOffPosition
      =     #tFP.CheckDropOffPosition     #tFP.CheckDropOffPosition

      CALL  #sDelayCheckOutfeed           #sDelayCheckOutfeed
       IN:=#tFP.CheckDropOffPosition      #tFP.CheckDropOffPosition
       PT:=#iTimeCheckOutfeed             #iTimeCheckOutfeed -- Time off delay on B3, when time is past ou
                                          tfeed must be empty, if not lift stop
       Q :=#sDelayCheckOutfeed.Q          #sDelayCheckOutfeed.Q
       ET:=

      A     #sDelayCheckOutfeed.Q         #sDelayCheckOutfeed.Q
      FN    #sHM_FN.TimeFrameOutfeed      #sHM_FN.TimeFrameOutfeed
      =     #tFN.TimeFrameOutfeed         #tFN.TimeFrameOutfeed


      A     #iProductLeftOutfeed_B9       #iProductLeftOutfeed_B9 -- Dropoff position straight occupied
      FN    #sHM_FN.ProductLeftOutfeed_B9 #sHM_FN.ProductLeftOutfeed_B9
      =     #tFN.ProductLeftOutfeed_B9    #tFN.ProductLeftOutfeed_B9

      A     #iProductOnOutfeed_B8         #iProductOnOutfeed_B8 -- Dropoff position diagonial occupied
      O     #iProductLeftOutfeed_B9       #iProductLeftOutfeed_B9 -- Dropoff position straight occupied
```

```
      S     #sProductOnOutfeed              #sProductOnOutfeed

      AN    #iProductOnOutfeed_B8           #iProductOnOutfeed_B8 -- Dropoff position diagonial occupied
      A     #tFN.ProductLeftOutfeed_B9      #tFN.ProductLeftOutfeed_B9
      R     #sProductOnOutfeed              #sProductOnOutfeed

      A     #sProductOnOutfeed              #sProductOnOutfeed
      A     #tFN.TimeFrameOutfeed           #tFN.TimeFrameOutfeed
      S     #sStopLiftProdOnOutfeed         #sStopLiftProdOnOutfeed

      AN    #sProductOnOutfeed              #sProductOnOutfeed
      R     #sStopLiftProdOnOutfeed         #sStopLiftProdOnOutfeed

      AN    #sEmptyVerticaalConveyor        #sEmptyVerticaalConveyor
      A     #oOutfeedConveyor               #oOutfeedConveyor  -- Outfeed conveyor in Prorunner
      A     #sProductOnOutfeed              #sProductOnOutfeed
      A     #tFN.TimeFrameOutfeed           #tFN.TimeFrameOutfeed
      S     #oFaultProductOnOutfeed         #oFaultProductOnOutfeed -- Fault product on outfeed conveyor pre
                                            sent

      A     #iReset                         #iReset            -- Pushbutton Reset
      O(
      AN    #sProductOnOutfeed              #sProductOnOutfeed
      AN    #iProductOnOutfeed_B8           #iProductOnOutfeed_B8 -- Dropoff position diagonial occupied
      AN    #iProductLeftOutfeed_B9         #iProductLeftOutfeed_B9 -- Dropoff position straight occupied
      )
      R     #oFaultProductOnOutfeed         #oFaultProductOnOutfeed -- Fault product on outfeed conveyor pre
                                            sent

Network: 6      Delay rotation when changing rotation CW or CCW

      AN    #oProrunnerForward      #oProrunnerForward -- Forward  vertical conveyor
      AN    #oProrunnerReverse      #oProrunnerReverse -- Reverse vertical conveyor
      =     #tSignalToDelay         #tSignalToDelay

      CALL  #sDelayForwardReverse   #sDelayForwardReverse
       IN:=#tSignalToDelay          #tSignalToDelay
       PT:=T#1S
       Q :=#tEnableMotorOn          #tEnableMotorOn
       ET:=

      O     #tEnableMotorOn         #tEnableMotorOn
      O     #oProrunnerForward      #oProrunnerForward -- Forward  vertical conveyor
      =     #tEnableMotorForward    #tEnableMotorForward

      O     #tEnableMotorOn         #tEnableMotorOn
      O     #oProrunnerReverse      #oProrunnerReverse -- Reverse vertical conveyor
      =     #tEnableMotorReverse    #tEnableMotorReverse

Network: 7      Motor verticaal conveyor

      A     #tAutomatic               #tAutomatic
      AN    #oFaultProductInfeedtime  #oFaultProductInfeedtime -- Fault Overtime box inserted
      AN    #sStopLiftProdOnOutfeed   #sStopLiftProdOnOutfeed
      A     #tEnableMotorForward      #tEnableMotorForward
      O
      A     #tManual                  #tManual
      A     #tEnableMotorForward      #tEnableMotorForward
      A     #iManualForward           #iManualForward    -- Pushbutton Manual forward (normal run)
      =     #oProrunnerForward        #oProrunnerForward -- Forward  vertical conveyor

      A     #tManual                  #tManual
      A     #tEnableMotorReverse      #tEnableMotorReverse
      A     #iManualReverse           #iManualReverse    -- Pushbutton Manual reverse
      =     #oProrunnerReverse        #oProrunnerReverse -- Reverse vertical conveyor
```

Network: 8 Release new product in Prorunner

```
      A     #iProductRelease_B1         #iProductRelease_B1 -- Sensor infeedproduct
      FP    #sHM_FP.ProductRelease      #sHM_FP.ProductRelease
      =     #tFP.Productrelease         #tFP.Productrelease

      A     #iProductReadyForInfeed     #iProductReadyForInfeed -- Photocel in front of infeed
      FN    #sHM_FN.ProductReleased     #sHM_FN.ProductReleased
      =     #tFN.ProductReleased        #tFN.ProductReleased

      CALL  #sDelayRelease              #sDelayRelease
       IN:=#tFP.Productrelease          #tFP.Productrelease
       PT:=#iTimeInfeedAllowed          #iTimeInfeedAllowed -- Time of window infeed allowed
       Q :=#sExtendedRelease            #sExtendedRelease
       ET:=

      A     #tFN.ProductReleased        #tFN.ProductReleased
      JCN   pkvp

      L     #sCounters.CountedProducts  #sCounters.CountedProducts
      +     L#1
      T     #sCounters.CountedProducts  #sCounters.CountedProducts

pkvp: NOP   0
```

Network: 9 Motor supply conveyor

```
      A     #sExtendedRelease        #sExtendedRelease
      A     #tAutomatic              #tAutomatic
      A     #oInfeedConveyor         #oInfeedConveyor   -- Infeed conveyor in Prorunner
      AN    #sProductInserted        #sProductInserted
      AN    #iEndInfeedConveyor_B7   #iEndInfeedConveyor_B7 -- Photocell on infeedconveyor
      O
      A     #tAutomatic              #tAutomatic
      AN    #iProductReadyForInfeed  #iProductReadyForInfeed -- Photocel in front of infeed
      =     #oSupplyConveyor         #oSupplyConveyor   -- Supply conveyor before Prorunner
```

Network: 10 Motor infeed conveyor

```
      CALL  #sTimeDelayInfeed_B7      #sTimeDelayInfeed_B7
       IN:=#iEndInfeedConveyor_B7     #iEndInfeedConveyor_B7 -- Photocell on infeedconveyor
       PT:=#iTimeProductOnInfeed      #iTimeProductOnInfeed -- Time for delay on B7
       Q :=#sTimeDelayInfeed_B7.Q     #sTimeDelayInfeed_B7.Q
       ET:=

      A     #tAutomatic              #tAutomatic
      AN    #oProrunnerIsEmpty       #oProrunnerIsEmpty -- Vertical conveyor is empty
      AN    #sTimeDelayInfeed_B7.Q   #sTimeDelayInfeed_B7.Q
      AN    #oFaultProductInfeedtime #oFaultProductInfeedtime -- Fault Overtime box inserted
      =     #oInfeedConveyor         #oInfeedConveyor   -- Infeed conveyor in Prorunner
```

Network: 11 Monitoring product infeed time

```
      A     #tFN.ProductReleased     #tFN.ProductReleased
      A     #tAutomatic              #tAutomatic
      S     #sProductInserted        #sProductInserted

      A     #sProductInserted        #sProductInserted
      A(
      O     #iEndInfeedConveyor_B7   #iEndInfeedConveyor_B7 -- Photocell on infeedconveyor
      O     #tFP.Reset               #tFP.Reset
      )
      R     #sProductInserted        #sProductInserted
```

```
CALL  #sTimeMonitorInfeed       #sTimeMonitorInfeed
 IN:=#sProductInserted          #sProductInserted
 PT:=#iTimeMonitorInfeed        #iTimeMonitorInfeed -- Time monitoring of product infeed
 Q :=#sTimeMonitorInfeed.Q      #sTimeMonitorInfeed.Q
 ET:=

A     #sTimeMonitorInfeed.Q     #sTimeMonitorInfeed.Q
S     #oFaultProductInfeedtime  #oFaultProductInfeedtime -- Fault Overtime box inserted

A     #tFP.Reset                #tFP.Reset
O     #iEndInfeedConveyor_B7    #iEndInfeedConveyor_B7 -- Photocell on infeedconveyor
R     #oFaultProductInfeedtime  #oFaultProductInfeedtime -- Fault Overtime box inserted
```

Network: 12 Motor outfeed conveyor

```
A     #tAutomatic               #tAutomatic
AN    #oProrunnerIsEmpty        #oProrunnerIsEmpty -- Vertical conveyor is empty
A     #iDischargeConveyorReady  #iDischargeConveyorReady -- input Discharge conveyor is running an re
                                ady for product
=     #oOutfeedConveyor         #oOutfeedConveyor  -- Outfeed conveyor in Prorunner
```

Network: 13 Monitoring product release and time frame sensor

```
A     #oProrunnerForward            #oProrunnerForward -- Forward  vertical conveyor
A     #tAutomatic                   #tAutomatic
AN    #iProductRelease_B1           #iProductRelease_B1 -- Sensor infeedproduct
AN    #oFaultProdReleaseSensor      #oFaultProdReleaseSensor -- Fault sensor product release (sensor
                                    not triggered)
=     #sTimeCheckReleaseSensor.IN   #sTimeCheckReleaseSensor.IN

CALL  #sTimeCheckReleaseSensor      #sTimeCheckReleaseSensor
 IN:=#sTimeCheckReleaseSensor.IN    #sTimeCheckReleaseSensor.IN
 PT:=#iTimeCheckSensors             #iTimeCheckSensors -- Delay check sensors in 0,1 sec.
 Q :=#sTimeCheckReleaseSensor.Q     #sTimeCheckReleaseSensor.Q
 ET:=

A     #sTimeCheckReleaseSensor.Q    #sTimeCheckReleaseSensor.Q
S     #oFaultProdReleaseSensor      #oFaultProdReleaseSensor -- Fault sensor product release (sensor
                                    not triggered)


A     #oProrunnerForward            #oProrunnerForward -- Forward  vertical conveyor
A     #tAutomatic                   #tAutomatic
AN    #iStartTimeFrame_B3           #iStartTimeFrame_B3 -- Sensor Forksecurity for outfeed
AN    #oFaultTimeFrameSensor        #oFaultTimeFrameSensor -- Fault Time frame sensor (sensor not tri
                                    ggered)
=     #sTimeCheckTimeFrameSenso.IN  #sTimeCheckTimeFrameSenso.IN

CALL  #sTimeCheckTimeFrameSenso     #sTimeCheckTimeFrameSenso
 IN:=#sTimeCheckTimeFrameSenso.IN   #sTimeCheckTimeFrameSenso.IN
 PT:=#iTimeCheckSensors             #iTimeCheckSensors -- Delay check sensors in 0,1 sec.
 Q :=#sTimeCheckTimeFrameSenso.Q    #sTimeCheckTimeFrameSenso.Q
 ET:=

A     #sTimeCheckTimeFrameSenso.Q   #sTimeCheckTimeFrameSenso.Q
S     #oFaultTimeFrameSensor        #oFaultTimeFrameSensor -- Fault Time frame sensor (sensor not tri
                                    ggered)
```

Network: 14 check bottom sprocket for rotation

Fist mak a positive and negative edge of the sensor on the bottom sprocket.
The monitoring can be delayed at the start of the motor for a variable time.
The monitoring can be disabled if time is 0 ms.
When the monitoring is enabled the sensor resets the timer at every edge.
When the time is past there is a fault warning and the Prorunner will stop
rotating.

```
A     #iMonitorRotation            #iMonitorRotation  -- Sensor on bottom sprocket(Not standard)
FP    #sHM_FP.CheckRotation        #sHM_FP.CheckRotation
=     #tFP.CheckRotation           #tFP.CheckRotation

A     #iMonitorRotation            #iMonitorRotation  -- Sensor on bottom sprocket(Not standard)
FN    #sHM_FN.CheckRotation        #sHM_FN.CheckRotation
=     #tFN.CheckRotation           #tFN.CheckRotation

O     #oProrunnerForward           #oProrunnerForward -- Forward  vertical conveyor
O     #oProrunnerReverse           #oProrunnerReverse -- Reverse vertical conveyor
=     #tProrunnerRotating          #tProrunnerRotating

CALL  #sTimeDelayMonitotRotatio    #sTimeDelayMonitotRotatio
 IN:=#tProrunnerRotating           #tProrunnerRotating
 PT:=#iTimeDelayMonitorRotatio     #iTimeDelayMonitorRotatio -- Time to delay monitor rotation at sta
                                   rtup
 Q :=#sTimeDelayMonitotRotatio.Q   #sTimeDelayMonitotRotatio.Q
 ET:=

A(
L     #iTimeMonitorRotation        #iTimeMonitorRotation -- Time for monitoring of rotation bottom sp
                                   rocket(0 = disabled)
L     T#0MS
<>I
)
A     #sTimeDelayMonitotRotatio.Q  #sTimeDelayMonitotRotatio.Q
=     #tMonitorRotatioEnabled      #tMonitorRotatioEnabled

A     #tProrunnerRotating          #tProrunnerRotating
A     #tMonitorRotatioEnabled      #tMonitorRotatioEnabled
A     #iEnableElevator             #iEnableElevator   -- Enable clearence emercengystop, thermical et
                                   c.
AN    #oFaultMonitorRotation       #oFaultMonitorRotation
AN    #iReset                      #iReset            -- Pushbutton Reset
AN    #tFP.CheckRotation           #tFP.CheckRotation
AN    #tFN.CheckRotation           #tFN.CheckRotation
=     #sTimeMonitorRotation.IN     #sTimeMonitorRotation.IN

CALL  #sTimeMonitorRotation        #sTimeMonitorRotation
 IN:=#sTimeMonitorRotation.IN      #sTimeMonitorRotation.IN
 PT:=#iTimeMonitorRotation         #iTimeMonitorRotation -- Time for monitoring of rotation bottom sp
                                   rocket(0 = disabled)
 Q :=#sTimeMonitorRotation.Q       #sTimeMonitorRotation.Q
 ET:=

A     #sTimeMonitorRotation.Q      #sTimeMonitorRotation.Q
S     #oFaultMonitorRotation       #oFaultMonitorRotation

A     #tFP.Reset                   #tFP.Reset
R     #oFaultMonitorRotation       #oFaultMonitorRotation
```

Network: 15 Reset failures

```
A     #tFP.Reset                #tFP.Reset
R     #oFaultProdReleaseSensor  #oFaultProdReleaseSensor -- Fault sensor product release (sensor not
                                triggered)
R     #oFaultTimeFrameSensor    #oFaultTimeFrameSensor -- Fault Time frame sensor (sensor not trigger
                                ed)
R     #oFaultProductOnOutfeed   #oFaultProductOnOutfeed -- Fault product on outfeed conveyor present
```

```
R     #oFaultProductInfeedtime  #oFaultProductInfeedtime -- Fault Overtime box inserted
```