	<h1>Operating Manual Information Sheet</h1>		
<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend	
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	



## Automation & Electrical Design

Unit 5 Hoel Ty Gwyn Industrial Estate, Maesteg, Bridgend. CF34 0BE

Tel: 01792 326350 Web: [www.platcon.biz](http://www.platcon.biz)

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### File Index

Section No	Section Description
Section 1	<u>Customer/Machine Information</u>



# Operating Manual Information Sheet

<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079

Section 2	<u>General Information</u> 2.1 Using this manual 2.2 Equipment overview 2.3 Electrical and automation overview 2.4 Operator Interaction
Section 3	<u>Installation/Services</u> 3.1 Installation 3.2 Machine Dimensions 3.3 Services Required 3.4 Environmental Conditions
Section 4	<u>Operation</u> 4.1 Plant Layout Drawing 4.2 Operation Screens
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Section No	1	Description	Customer/Project Information
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## Customer/Product/Project Information

Customer	WEPA (Bridgend)
Platinum Serial No	W1079
Customer Site	Maesteg (Northwood and Wepa Site)



# Operating Manual Information Sheet

<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079

Project Description	Hall 2 OCME SCADA
End User	Northwood and Wepa (N & W)
Scope of Work	Design and installation of a SCADA system for Hall 2 OCMEs
Customer	WEPA UK
Customer Site	Bridgend
Project Description	Design and installation of a SCADA system for Hall 2 OCMEs
Job No	W1079

WEPA UK	
Contract Number	
Project	Hall 2
Plant	Hall 2 OCMEs
Area	Hall 2
Equipment	OCME SCADA System


Section No	2	Description	General Information
------------	---	-------------	---------------------

WEPA (UK) Ltd has contracted PLATCON to supply, install and commission a SCADA system for the OCME robot systems in Hall 2.

This manual contains information relating to the operation and interaction with the Movicon SCADA system.

## **2.1 Using this Manual:**

This manual describes the operation and technical aspects relating to the OCME SCADA system in Hall 2. Contained in this manual are detailed operating instructions and relevant technical information.

		<h1>Operating Manual Information Sheet</h1>		
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## **2.2 Equipment Overview:**

The Movicon SCADA system has been designed by PLATCON Ltd. to provide a database of programs referenced by JCode which contain all of the relevant parameters required for stacking and filling pallets for a particular product on the OCME robots in Hall 2.

## **2.3 Electrical and Automation Overview.**

The SCADA system is supplied electrically from the main electrical control panel. The SCADA system is controlled by Movicon 11 software and a PC which is located in the main electrical control panel. The operator interacts with the system via a keyboard and a touch screen 21 inch monitor mounted on the control panel.

## **2.4 Operator Interaction**

The owner of the plant must ensure that the personnel who operate, maintain and repair the plant are competent and trained for their particular function.

Section No	3	Description	Installation/Services
------------	---	-------------	-----------------------

## **3.1 Installation:**

The loading and transportation of the control panel must only be carried out by personnel authorised by PLATCON Ltd. These personnel must ensure that the control panel is unloaded and unpacked in the correct way, as specified by PLATCON Ltd.

The control panel has been designed to operate in a shop floor environment, i.e.: a clean, dry atmosphere, with a temperature range of +10C to +30C.


## **3.2 Machine Dimensions**

N/A

## **3.3 Services Required**

Air: N/A

Power: 110Vac single phase, and earth, 16 amps.

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### **3.4 Environmental Conditions**

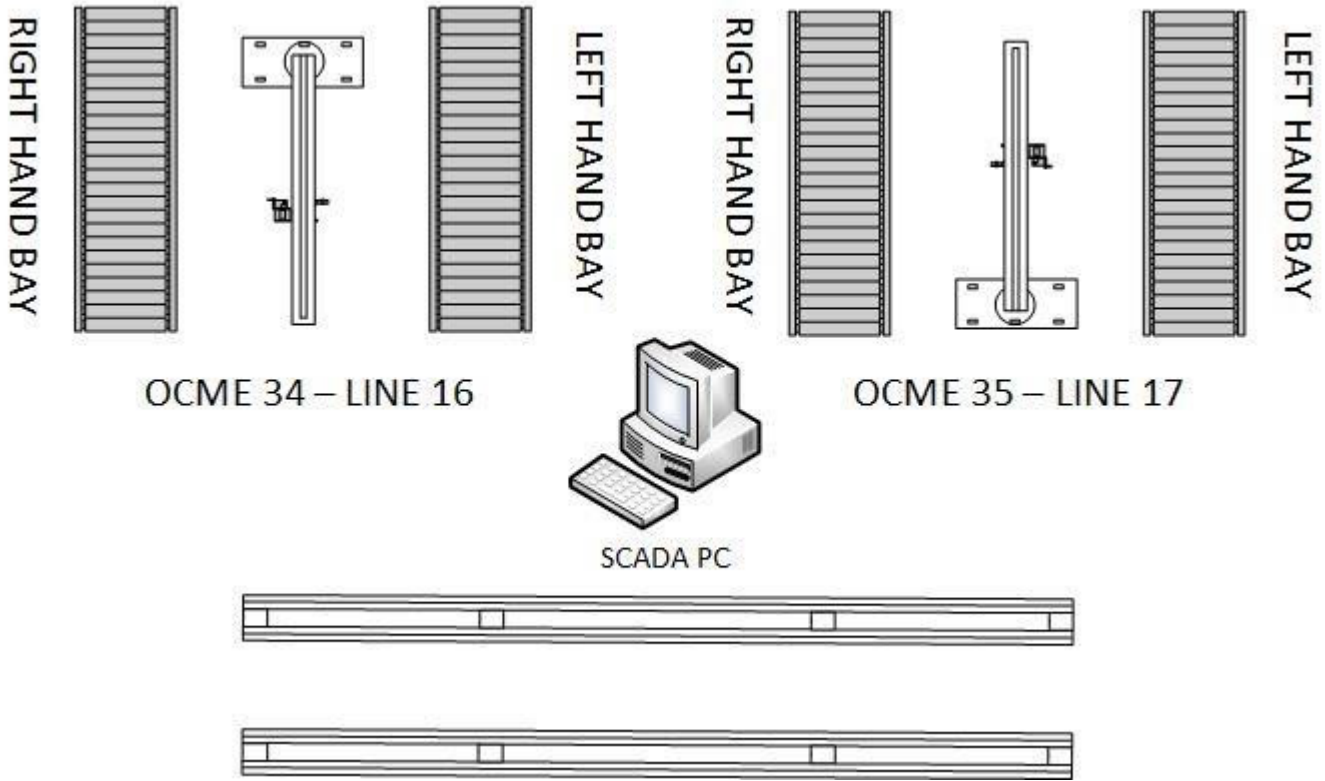
In normal operating conditions, this unit does not emit any substances considered harmful to the environment.

Noise emissions: within Health and Safety guidelines.

Section No	4	Description	Operation
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### **4.1 Plant Layout Drawing**


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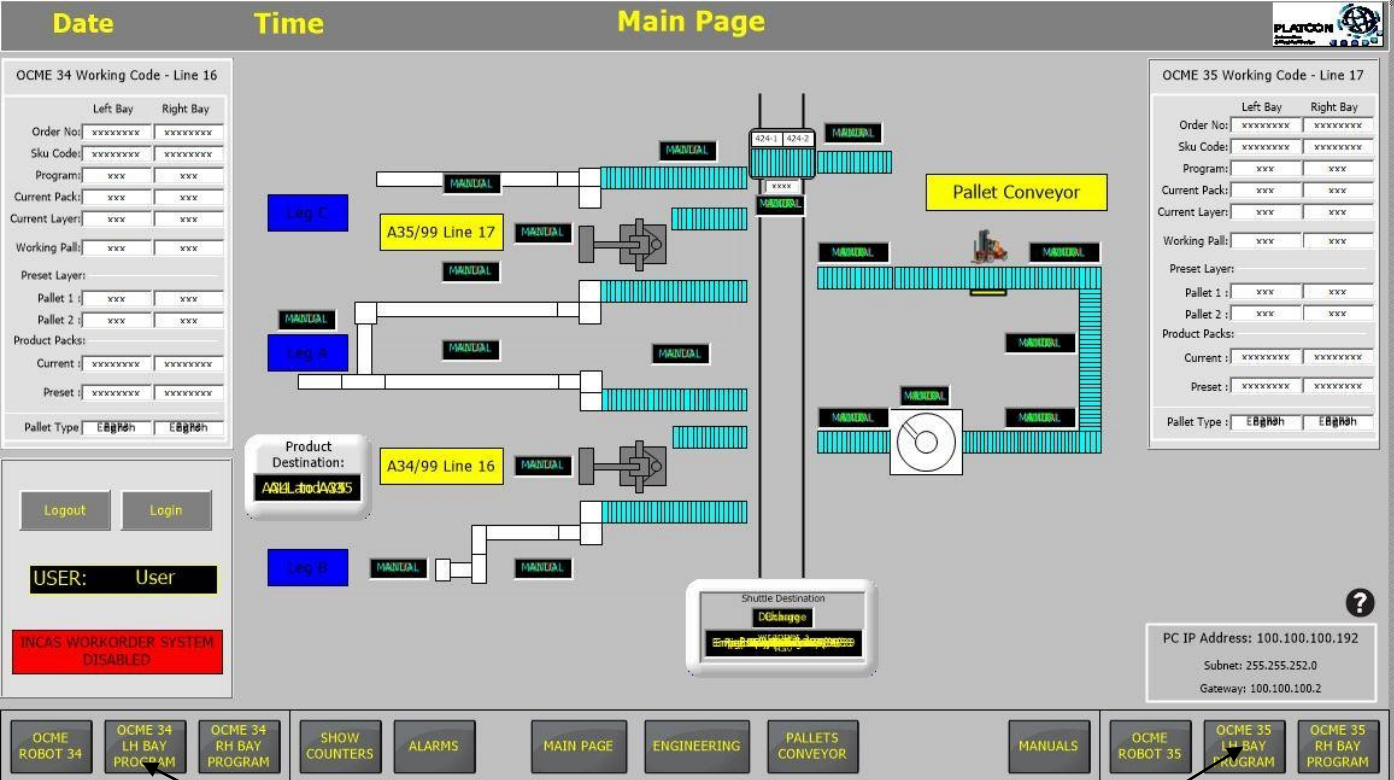


## 4.2 Operation Screens

### Main Overview Page

When the system is started for the very first time the Main Overview page will be the first screen opened and presented to the operator. This page displays the current OCME 25 and 33 Working Code information and the current user logged into the system. All other screens are accessed from this screen.

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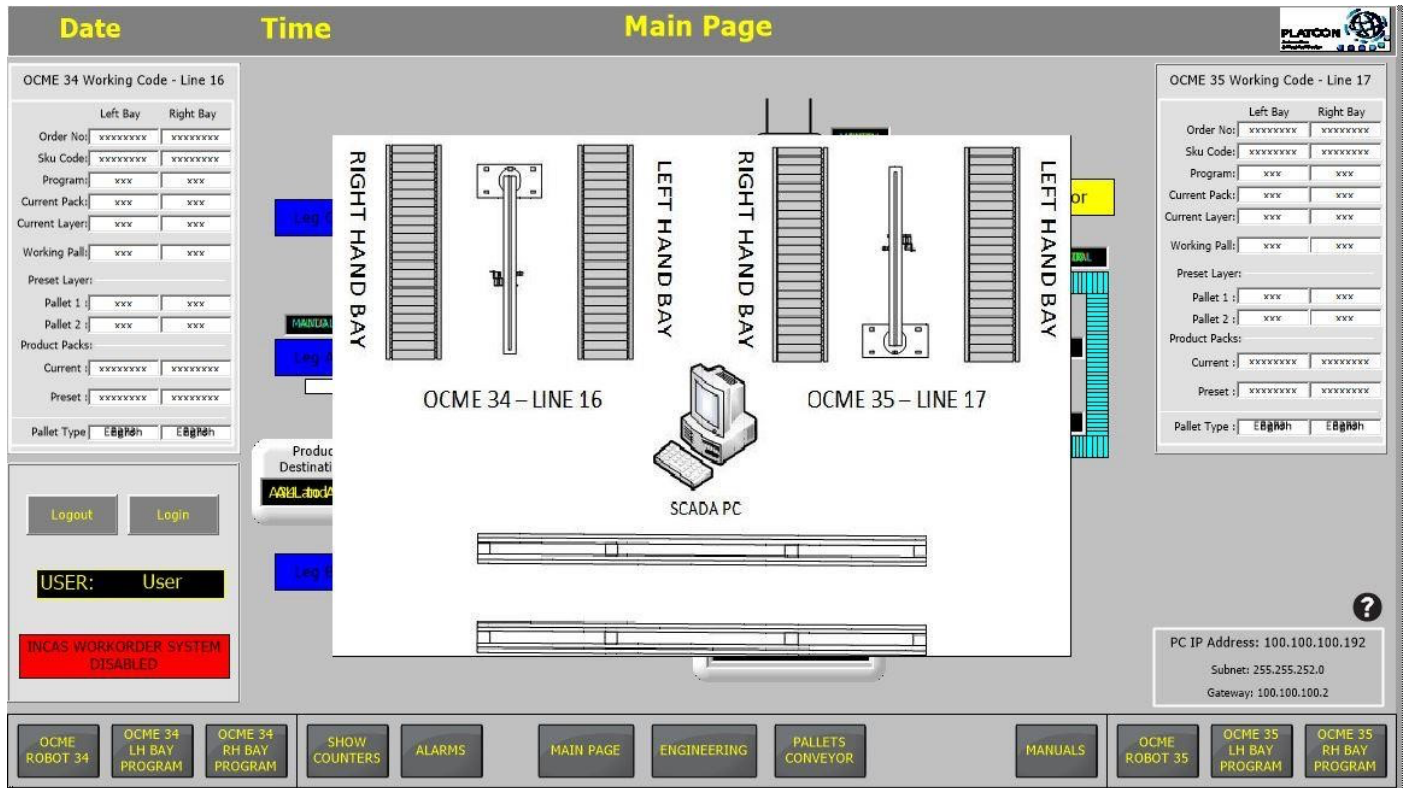
The screenshot displays the 'Main Page' of the SCADA system. At the top, it shows 'Date', 'Time', and 'Main Page' labels. The central area features a detailed plant layout with conveyor belts, pallet conveyors, and various control points. On the left and right sides, there are data entry forms for 'OCME 34 Working Code - Line 16' and 'OCME 35 Working Code - Line 17', each with fields for Order No, Sku Code, Program, Current Pack, Current Layer, Working Pallet, Preset Layer, Pallet 1, Pallet 2, Product Packs, Current, Preset, and Pallet Type. Below these forms are 'Logout' and 'Login' buttons, a 'USER: User' field, and a red 'INCAS WORKORDER SYSTEM DISABLED' banner. At the bottom, a navigation bar contains buttons for 'OCME ROBOT 34', 'OCME 34 LH BAY PROGRAM', 'OCME 34 RH BAY PROGRAM', 'SHOW COUNTERS', 'ALARMS', 'MAIN PAGE', 'ENGINEERING', 'PALLETS CONVEYOR', 'MANUALS', 'OCME ROBOT 35', 'OCME 35 LH BAY PROGRAM', and 'OCME 35 RH BAY PROGRAM'. A 'Shuttle Destination' display shows 'DChirage'. In the bottom right corner, there is a question mark icon and network information: 'PC IP Address: 100.100.100.192', 'Subnet: 255.255.252.0', and 'Gateway: 100.100.100.2'.

Pressing these buttons toggles the OCME 34 or 35 left and right hand bay overview layout pop up screen.

## Main Overview Page

When the question mark is pressed at the bottom right hand corner of the SCADA Screen, a pop up display will appear of the plant layout for Line 16 and 17.


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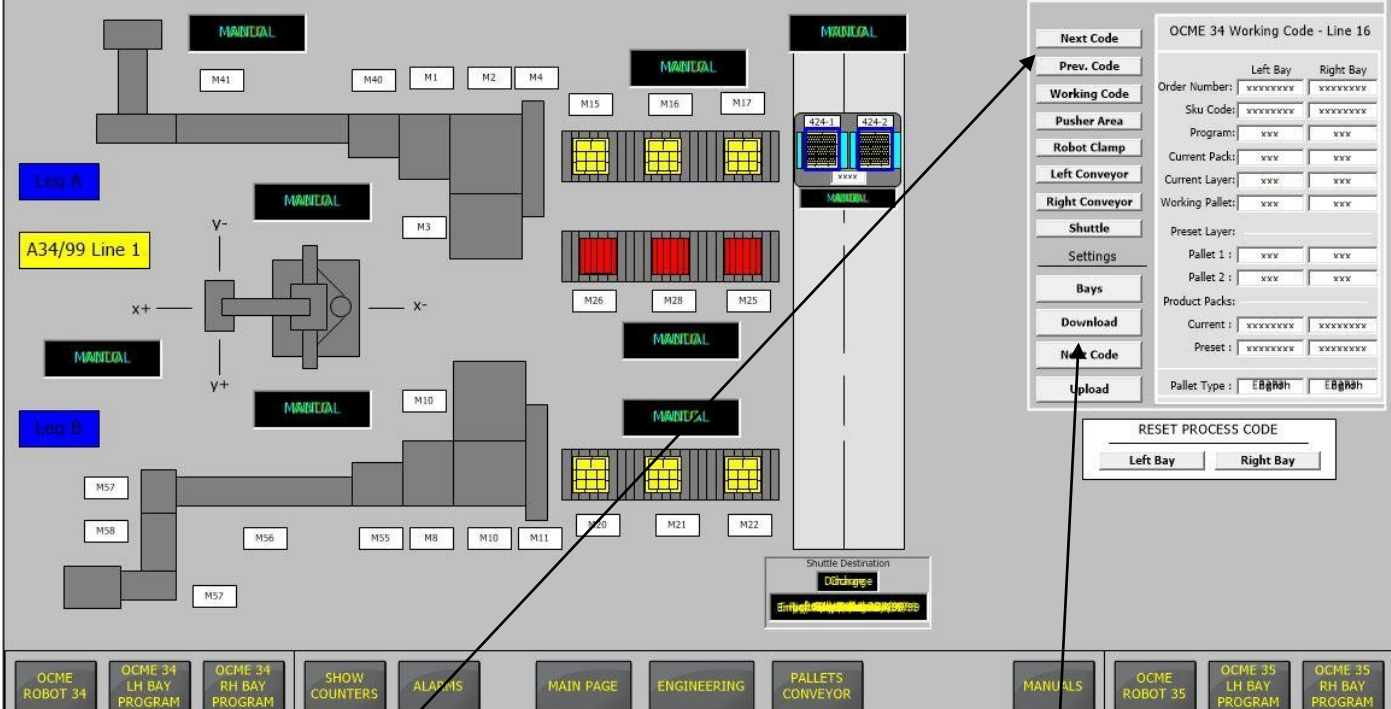
## OCME Robot 34 - Line 16 Robot Conveyors

By pressing the Line 16 conveyors on the Main Page, the following OCME 34 (Line 16) Working Code screen will open.



	<h1>Operating Manual Information Sheet</h1>		
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Date
Time
OCME 34 - Robot Conveyor Line 16




Next Code – Opens Next Code Screen  
 Working Code – Opens Working Code Screen  
 Prev. Code – Opens Previous Working Code Screen  
 Pusher Area – Opens Pusher Area Screen  
 Robot Clamp – Opens Robot Clamp Screen  
 Left Conv – Opens Left Conveyor Screen  
 Right Conv – Opens Right Conveyor Screen  
 Shuttle – Opens the Shuttle Screen

Bay Settings – Opens the Bay Settings Screen (Not Password Protected)  
 Download – Opens the Download Programs Screen (Password Protected)  
 Upload - Opens the Upload Programs Screen (Password Protected)  
 Next Code Settings – Opens the Next Code Settings Data Entry Screen

## OCME Robot 35 - Line 17 Robot Conveyors

By pressing the Line 17 conveyors on the Main Page, the following OCME 35 (Line 17) Working Code screen will open. (Same as OCME 34)


<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079


Next Code – Opens Next Code Screen  
 Working Code – Opens Working Code Screen  
 Prev. Code – Opens Previous Working Code Screen  
 Pusher Area – Opens Pusher Area Screen  
 Robot Clamp – Opens Robot Clamp Screen  
 Left Conv – Opens Left Conveyor Screen  
 Right Conv – Opens Right Conveyor Screen  
 Shuttle – Opens the Shuttle Screen

Bay Settings – Opens the Bay Settings Screen (Not Password Protected)  
 Download – Opens the Download Programs Screen (Password Protected)  
 Upload - Opens the Upload Programs Screen (Password Protected)  
 Next Code Settings – Opens the Next Code Settings Data Entry Screen

## OCME 34 Program Download Screen Sequence

Step 1: Select Required Bay i.e. Left or Right

	<h1>Operating Manual Information Sheet</h1>		
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<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	

**Date**
**Time**
**Program Download To OCME 34**


**Working Program** XXX

OCME 34 LEFT STORAGE LOCATIONS

1	P xxx	11	P xxx
2	P xxx	12	P xxx
3	P xxx	13	P xxx
4	P xxx	14	P xxx
5	P xxx	15	P xxx
6	P xxx	16	P xxx
7	P xxx	17	P xxx
8	P xxx	18	P xxx
9	P xxx	19	P xxx
10	P xxx	20	P xxx

Step 1: Select Required Bay i.e. Left or Right  
Step 2: Select Program To Download From The Program List  
Step 3: Activate The Selected Program For The Relevant Bay  
Step 4: Download Activated Program To OCME Storage Location  
Step 5: Quit and Return

LH Bay Programs

RH Bay Programs

**Working Program** XXX

OCME 34 RIGHT STORAGE LOCATIONS

1	P xxx	11	P xxx
2	P xxx	12	P xxx
3	P xxx	13	P xxx
4	P xxx	14	P xxx
5	P xxx	15	P xxx
6	P xxx	16	P xxx
7	P xxx	17	P xxx
8	P xxx	18	P xxx
9	P xxx	19	P xxx
10	P xxx	20	P xxx

**Download Program:** xxxxxxxxxx

Download Active Program To LHS OCME 34

**Selected Program:** xxxxxxxxxx

.... REQUEST IN PROGRESS ....

Left Hand Bay For OCME 34

Activate Selected Program For LH Bay

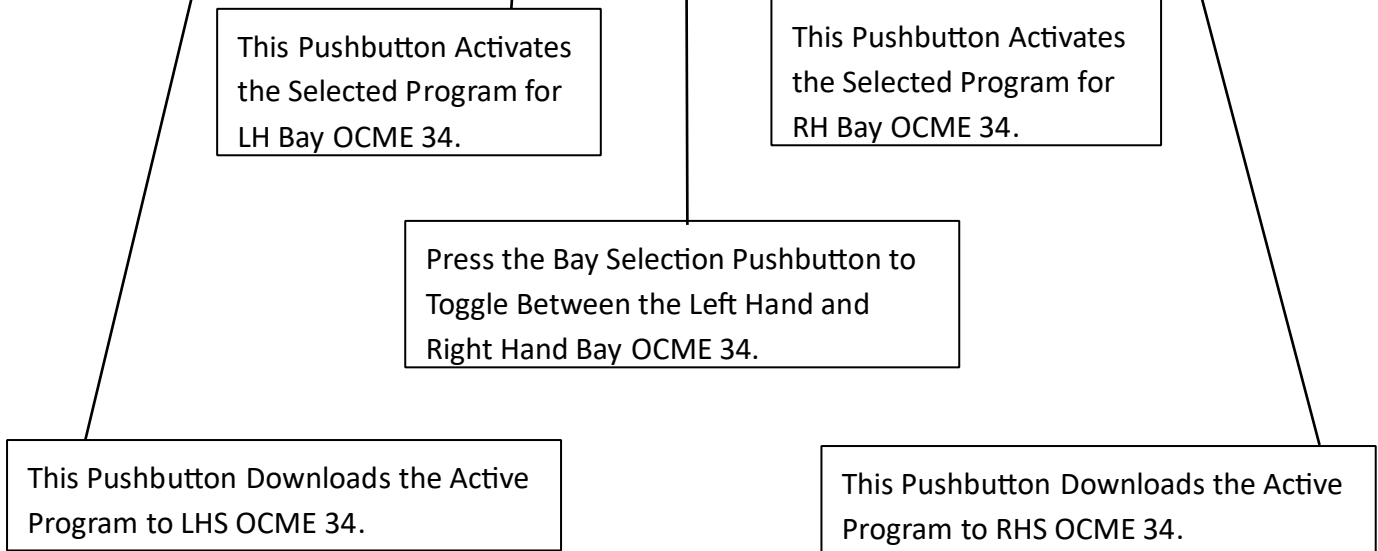
Bay Selection

Activate Selected Program For RH Bay

Quit And Return


**Download Program:** xxxxxxxxxx


Download Active Program To RHS OCME 34



### OCME 35 Program Download Screen Sequence

Step 1: Select Required Bay i.e. Left or Right

	<h1>Operating Manual Information Sheet</h1>		
<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend	
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	

**Date**
**Time**
**Program Download To OCME 35**


**Working Program** XXX

OCME 35 LEFT STORAGE LOCATIONS

1	P xxx	11	P xxx
2	P xxx	12	P xxx
3	P xxx	13	P xxx
4	P xxx	14	P xxx
5	P xxx	15	P xxx
6	P xxx	16	P xxx
7	P xxx	17	P xxx
8	P xxx	18	P xxx
9	P xxx	19	P xxx
10	P xxx	20	P xxx

Step 1: Select Required Bay i.e. Left or Right  
 Step 2: Select Program To Download From The Program List  
 Step 3: Activate The Selected Program For The Relevant Bay  
 Step 4: Download Activated Program To OCME Storage Location  
 Step 5: Quit and Return

LH Bay Programs

RH Bay Programs

**Working Program** XXX

OCME 35 RIGHT STORAGE LOCATIONS

1	P xxx	11	P xxx
2	P xxx	12	P xxx
3	P xxx	13	P xxx
4	P xxx	14	P xxx
5	P xxx	15	P xxx
6	P xxx	16	P xxx
7	P xxx	17	P xxx
8	P xxx	18	P xxx
9	P xxx	19	P xxx
10	P xxx	20	P xxx

Download Program: xxxxxxxxxx

Download Active Program To LHS OCME 35

Selected Program: xxxxxxxxxx

Activate Selected Program For LH Bay

Bay Selection

Activate Selected Program For RH Bay

Download Active Program To RHS OCME 35

Download Program: xxxxxxxxxx

Download Active Program To RHS OCME 35

.... REQUEST IN PROGRESS ....

Left Hand Bay For OCME 35

Quit And Return

This Pushbutton Activates the Selected Program for LH Bay OCME 35.


This Pushbutton Activates the Selected Program for RH Bay OCME 35.


Press the Bay Selection Pushbutton to Toggle Between the Left Hand and Right Hand Bay OCME 35.

This Pushbutton Downloads the Active Program to LHS OCME 35.

This Pushbutton Downloads the Active Program to RHS OCME 35.

Step 2: Select Program to Download From the Program List for your selected Bay.

	<h1>Operating Manual Information Sheet</h1>		
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<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	

Date
Time
Program Download To OCME 34


**Working Program** XXX

OCME 34 LEFT STORAGE

LOCATIONS

1	P xxx	11	P xxx
2	P xxx	12	P xxx
3	P xxx	13	P xxx
4	P xxx	14	P xxx
5	P xxx	15	P xxx
6	P xxx	16	P xxx
7	P xxx	17	P xxx
8	P xxx	18	P xxx
9	P xxx	19	P xxx
10	P xxx	20	P xxx

LH Bay Programs

m

RH Bay Programs

Pl

**Working Program** XXX

OCME 34 RIGHT STORAGE

LOCATIONS

1	P xxx	11	P xxx
2	P xxx	12	P xxx
3	P xxx	13	P xxx
4	P xxx	14	P xxx
5	P xxx	15	P xxx
6	P xxx	16	P xxx
7	P xxx	17	P xxx
8	P xxx	18	P xxx
9	P xxx	19	P xxx
10	P xxx	20	P xxx

**Download Program:** xxxxxxxxxxxx

Download Active Program To LHS OCME 34

**Selected Program:** xxxxxxxxxxxx

Activate Selected Program For LH Bay

Bay Selection

Activate Selected Program For RH Bay

.... REQUEST IN PROGRESS ....

Left Hand Bay For OCME 34

Quit And Return


**Download Program:** xxxxxxxxxxxx


Download Active Program To RHS OCME 34

Select Required Program to Download From the List

Step 3: Activate the Selected Program for the Relevant Bay



	<h1>Operating Manual Information Sheet</h1>		
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Date
Time
**Program Download To OCME 34**


**Working Program** XXX

OCME 34 LEFT STORAGE

LOCATIONS

1 P xxx	11 P xxx
2 P xxx	12 P xxx
3 P xxx	13 P xxx
4 P xxx	14 P xxx
5 P xxx	15 P xxx
6 P xxx	16 P xxx
7 P xxx	17 P xxx
8 P xxx	18 P xxx
9 P xxx	19 P xxx
10 P xxx	20 P xxx

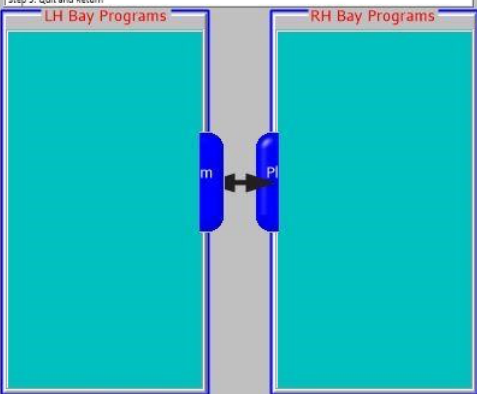
Download Program: xxxxxxxxxxxx

Download Active Program To LHS OCME 34

Step 1: Select Required Bay i.e. Left or Right  
Step 2: Select Program To Download From The Program List  
Step 3: Activate The Selected Program For The Relevant Bay  
Step 4: Download Activated Program To OCME Storage Location  
Step 5: Quit and Return

LH Bay Programs

RH Bay Programs



Selected Program: xxxxxxxxxxxx

Activate Selected Program For LH Bay

Bay Selection

Activate Selected Program For RH Bay

.... REQUEST IN PROGRESS ....

Left Hand Bay For OCME 34

Quit And Return

**Working Program** XXX

OCME 34 RIGHT STORAGE

LOCATIONS


1 P xxx	11 P xxx
2 P xxx	12 P xxx
3 P xxx	13 P xxx
4 P xxx	14 P xxx
5 P xxx	15 P xxx
6 P xxx	16 P xxx
7 P xxx	17 P xxx
8 P xxx	18 P xxx
9 P xxx	19 P xxx
10 P xxx	20 P xxx


Download Program: xxxxxxxxxxxx

Download Active Program To RHS OCME 34

Press the Activate Selected Program Pushbutton on the bay you wish to download too. This Will Activate the Program Ready for Downloading to the OCME PLC

Step 4: Download Activated Program to OCME Storage Location

	<h1>Operating Manual Information Sheet</h1>		
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<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	

**Date**
**Time**
**Program Download To OCME 34**


**Working Program** XXX

**OCME 34 LEFT STORAGE LOCATIONS**

1	P xxx	11	P xxx
2	P xxx	12	P xxx
3	P xxx	13	P xxx
4	P xxx	14	P xxx
5	P xxx	15	P xxx
6	P xxx	16	P xxx
7	P xxx	17	P xxx
8	P xxx	18	P xxx
9	P xxx	19	P xxx
10	P xxx	20	P xxx

Step 1: Select Required Bay i.e. Left or Right

Step 2: Select Program To Download From The Program List

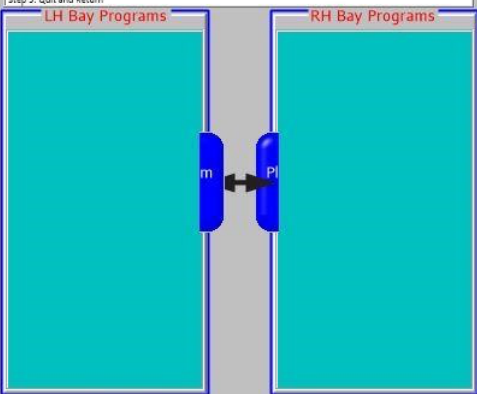
Step 3: Activate The Selected Program For The Relevant Bay

Step 4: Download Activated Program To OCME Storage Location

Step 5: Quit and Return

LH Bay Programs

RH Bay Programs



**Working Program** XXX

**OCME 34 RIGHT STORAGE LOCATIONS**

1	P xxx	11	P xxx
2	P xxx	12	P xxx
3	P xxx	13	P xxx
4	P xxx	14	P xxx
5	P xxx	15	P xxx
6	P xxx	16	P xxx
7	P xxx	17	P xxx
8	P xxx	18	P xxx
9	P xxx	19	P xxx
10	P xxx	20	P xxx

**Download Program:** xxxxxxxxxxxx

Download Active Program To LHS OCME 34

**Selected Program:** xxxxxxxxxxxx

Activate Selected Program For LH Bay

Bay Selection

Activate Selected Program For RH Bay

.... REQUEST IN PROGRESS ....

Left Hand Bay For OCME 34

Quit And Return

**Download Program:** xxxxxxxxxxxx

Download Active Program To RHS OCME 34


Press Download Active Program to Download the Activated Program to the OCME PLC

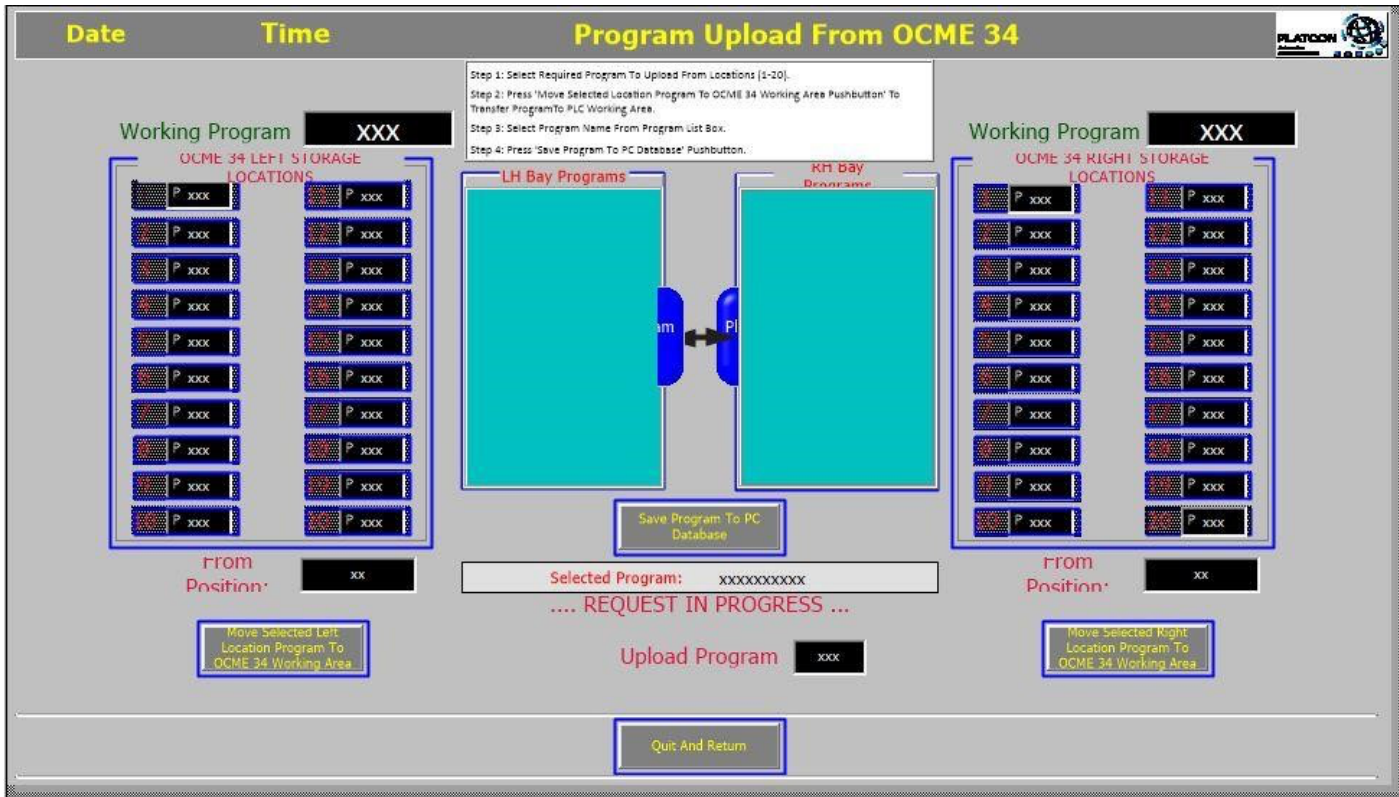
Quit and Return to Previous Screen

Press Download Active Program to Download the Activated Program to the OCME PLC

### OCME 34 Program Upload Screen Sequence

Step 1: Select Required Program to Upload From OCME PLC Storage Locations (1-20)


	<h1>Operating Manual Information Sheet</h1>		
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<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	




### OCME 35 Program Upload Screen Sequence

Step 1: Select Required Program to Upload From OCME PLC Storage Locations (1-20)



	<h1>Operating Manual Information Sheet</h1>		
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<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	

Date
Time
Program Upload From OCME 35


**Working Program** XXX

OCME 35 LEFT STORAGE LOCATIONS

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

From Position: xx

Move Selected Left Location Program To OCME 35 Working Area

LH Bay Programs

n

⇌

P

RH Bay Programs

Save Program To PC Database

Selected Program: xxxxxxxxxxxx

.... REQUEST IN PROGRESS ....

Upload Program: xxx

Quit And Return

**Working Program** XXX

OCME 35 RIGHT STORAGE LOCATIONS

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

P xxx

From Position: xx

Move Selected Right Location Program To OCME 35 Working Area

Step 1: Select Required Program To Upload From Locations (1-20).

Step 2: Press 'Move Selected Location Program To OCME 35 Working Area Pushbutton' To Transfer Program To PLC Working Area.

Step 3: Select Program Name From Program List Box.

Step 4: Press 'Save Program To PC Database' Pushbutton.

Step 2: Press 'Move Selected Location Program to Working Area Pushbutton' To Transfer Program to OCME PLC Working Area.

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<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079

Press Move Selected Program to Working Area Pushbutton once one of the 20 programs you require has been selected.

Press Move Selected Program to Working Area Pushbutton once one of the 20 programs you require has been selected.

Press any one of the 20 programs that you wish to upload to the PLC.

Press any one of the 20 programs that you wish to upload to the PLC.

Step 3: Select Program Name from Program List Box.

<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079

**Date**      **Time**      **Program Upload From OCME 34**

Step 1: Select Required Program To Upload From Locations [1-20].  
 Step 2: Press 'Move Selected Location Program To OCME 34 Working Area Pushbutton' To Transfer Program To PLC Working Area.  
 Step 3: Select Program Name From Program List Box.  
 Step 4: Press 'Save Program To PC Database' Pushbutton.

**Working Program**      **XXX**

**OCME 34 LEFT STORAGE LOCATIONS**

**LH Bay Programs**      **RH Bay Programs**

**OCME 34 RIGHT STORAGE LOCATIONS**

**FROM Position:**      **XXX**

**Selected Program:**      xxxxxxxxxxxx


**... REQUEST IN PROGRESS ...**

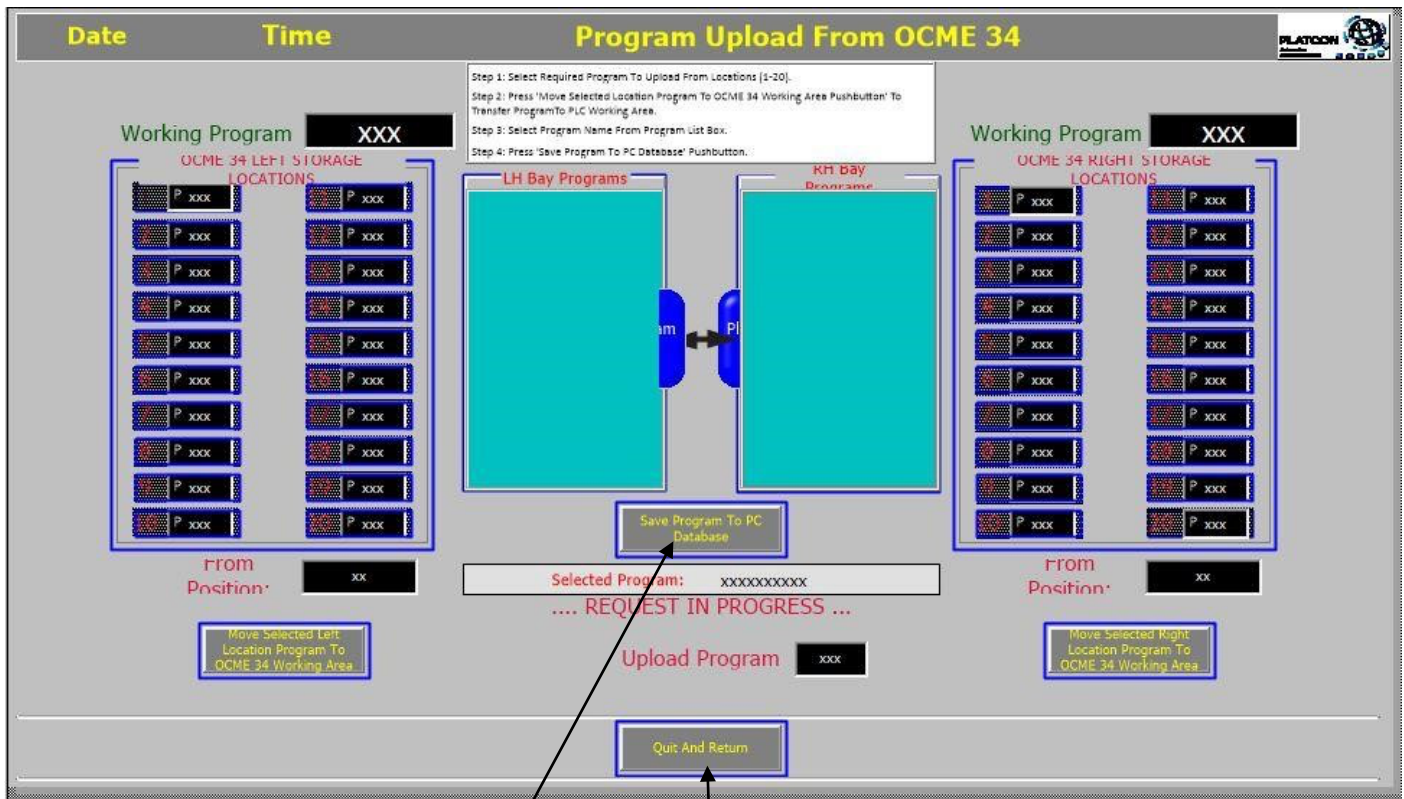
**Upload Program**      **xxx**

**Quit And Return**

Select Program from this program listed box.

Step 4: Press 'Save Program To PC Database' Pushbutton.


	<h1>Operating Manual Information Sheet</h1>		
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<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	




To Save program to the PC database, press this pushbutton.

**Next Code Settings Screen OCME 34**

Step 1: Select Left or Right Bay

		<h1>Operating Manual Information Sheet</h1>	
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<b>Project Description:</b> Hall 2 OCME SCADA		<b>Site:</b> Bridgend	
<b>Document No:</b> Op Man – W1079			

16/06/2015 11:26:19
Next Code Settings to OCME 34 Robot


Step 1: Select Left or Right Bay

Step 2: Press OK To Continue

Step 3: Enter Next Code Setting Data On Screen

Step 4: Press 'Send Sku & Program' To Download Settings Or Press Cancel To Re-Start Data Entry

Step 5: Press 'Quit' To Close The Screen And Return To Previous Screen


RESET PROCESS CODE

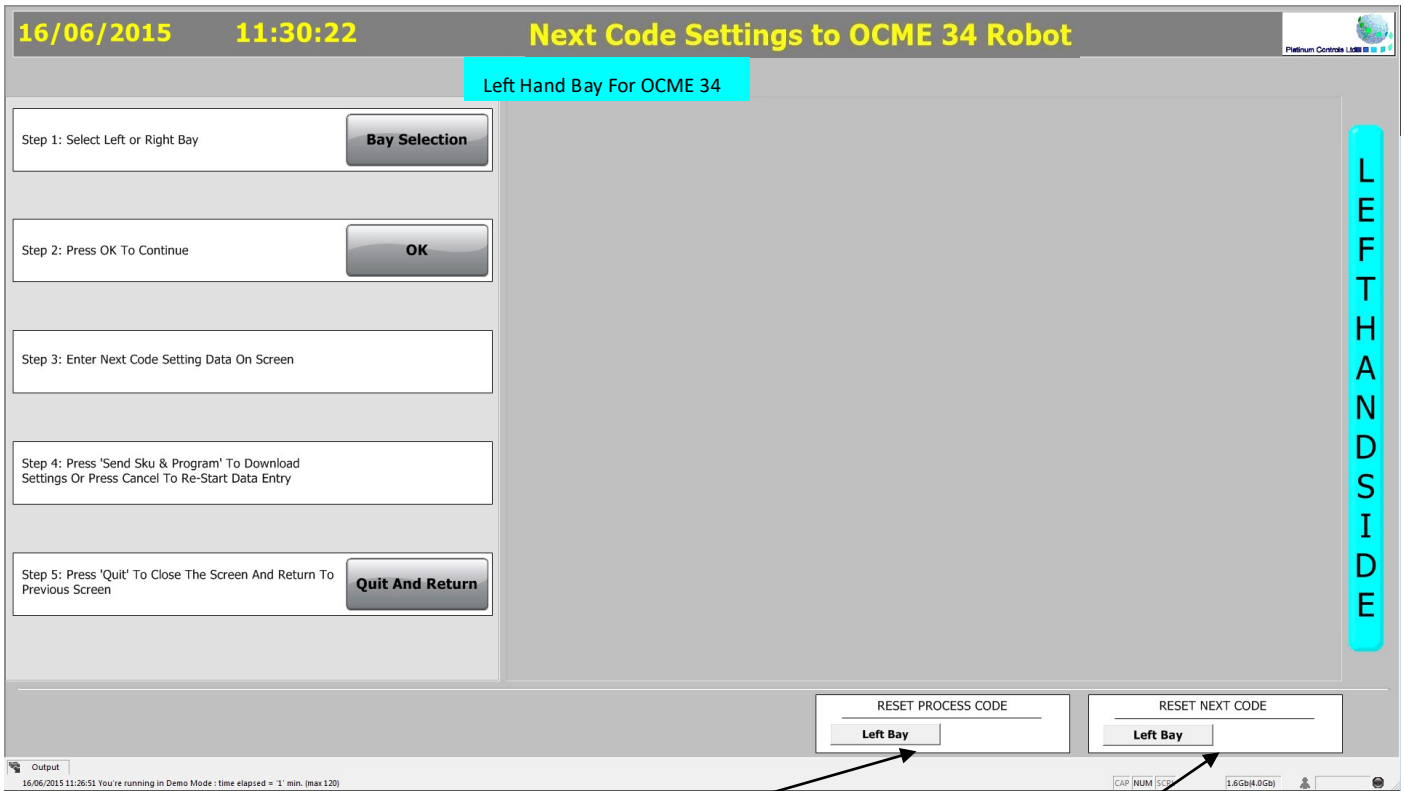
RESET NEXT CODE

Output | 16/06/2015 11:26:12 Com. Driver : Communication error : station OCME33, error A connection attempt failed because the connected party did not properly respond after a period of time, or established connection failed because connected host has failed to respond. | CAP NUM (SCR) | 1.6Gb(4.0Gb)

Step 2: Press OK To Continue



 <h1 style="text-align: center;">Operating Manual Information Sheet</h1>		
<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079




These Buttons Allow the User to Reset the Current Process Code in the Bay

These Buttons Allow the User to Reset the Next Code Values Set for the Bay

**Step 3: Enter Next Code Setting Data on Screen**

Select the Required Program with JCode Reference, the Relevant Data Will be Populated Automatically, the User Will Need to Enter the Order Number (8 Characters) and the Production Preset Packs Required.

		<h1>Operating Manual Information Sheet</h1>	
<b>Serial Number:</b> W1079		<b>Customer: WEPA</b> UK	
		<b>Site:</b> Bridgend	
<b>Project Description: Hall</b> 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	

16/06/2015 11:36:55
Next Code Settings to OCME 34 Robot

Step 1: Select Left or Right Bay

---

Step 2: Press OK To Continue OK

---

Step 3: Enter Next Code Setting Data On Screen

---

Step 4: Press 'Send Sku & Program' To Download Settings Or Press Cancel To Re-Start Data Entry Send Sku & Program

---

Step 5: Press 'Quit' To Close The Screen And Return To Previous Screen Quit And Return

Left Hand Bay For OCME 34

Programs

- AllBits
- Empty
- EveryOther
- OCME25LH-3002503
- OCME25LH-3002530
- OCME25LH-3002531
- OCME25LH-312345A
- OCME25LH-336726H
- OCME25LH-336727H
- OCME25LH-337023D
- OCME25LH-337026C
- OCME25LH-337030C
- OCME25LH-337131G
- OCME25LH-337131H
- OCME25LH-337166H
- OCME25LH-337247B
- OCME25LH-337247C
- OCME25LH-337248A
- OCME25LH-337250C
- OCME25LH-337258G
- OCME25LH-337258H
- OCME25LH-337258J
- OCME25LH-337261D
- OCME25LH-337309C
- OCME25LH-337727H
- OCME25LH-338015A
- OCME25LH-338017A
- OCME25LH-338023A
- OCME25LH-338026A
- OCME25LH-338036B
- OCME25LH-338037A

LEFT HAND SIDE

Sku Code:

Program:

Preset Layer 1:

Preset Layer 2:

Pallet Type:  Select

Wrap Program:

Pallet Stacker Setting :  Select

Order Number:

Production Preset Packs:


Cancel

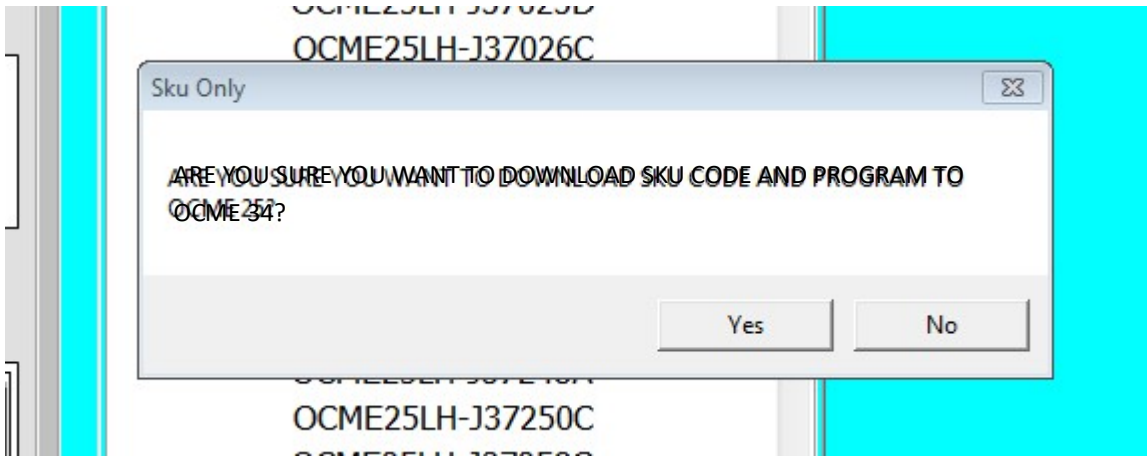
RESET PROCESS CODE  
Left Bay

RESET NEXT CODE  
Left Bay

Output
16/06/2015 11:35:54 You're running in Demo Mode: time elapsed = 10' min. (max 120)
CAP NUM (SCRL) 1.6GB(4.0GB)

Step 4: Press 'Send Sku & Program' to Download Settings or Press Cancel to Re-Start Data Entry The Following Message Box Will Appear:

	<h1>Operating Manual Information Sheet</h1>		
<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend	
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	




Click Yes to Continue With Download or Click No to Cancel and Abort the Sequence.

Step 5: Press 'Quit' to Close the Screen and Return to the Previous Screen.

### Left Hand Bay Program Editor – Odd Layer OCME 34 and 35

Press 'OCME 25 LH Bay Programs' Pushbutton to Open the First Odd Layer Screen




	<h1>Operating Manual Information Sheet</h1>		
<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend	
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	

These Buttons Will Open the Program Layer and Parameter Pages

### OCME 34 Left Hand Bay Program Editor – Odd Layer

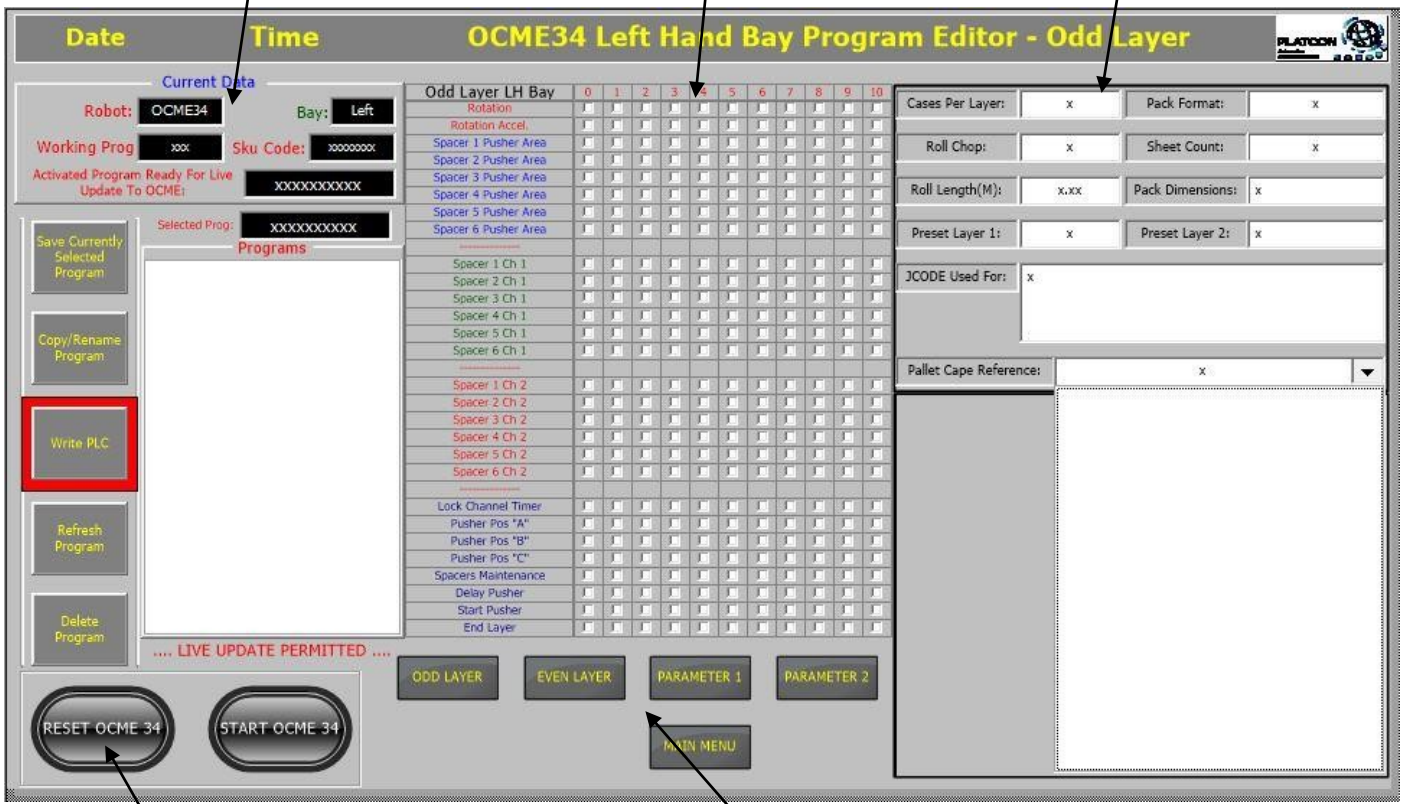
If a Program has been modified, you can either Save the currently selected Program or Refresh to revert back to the last saved state.  
 To either Copy or Rename a Program, first select the Program then press Copy/Rename Program pushbutton.  
 To Delete, select the Program and press the Delete pushbutton.

	<h1>Operating Manual Information Sheet</h1>		
<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend	
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	

Current Production Data and Activated Program

Selected Pack Dimensions and Format Area


Odd Layer Program Data



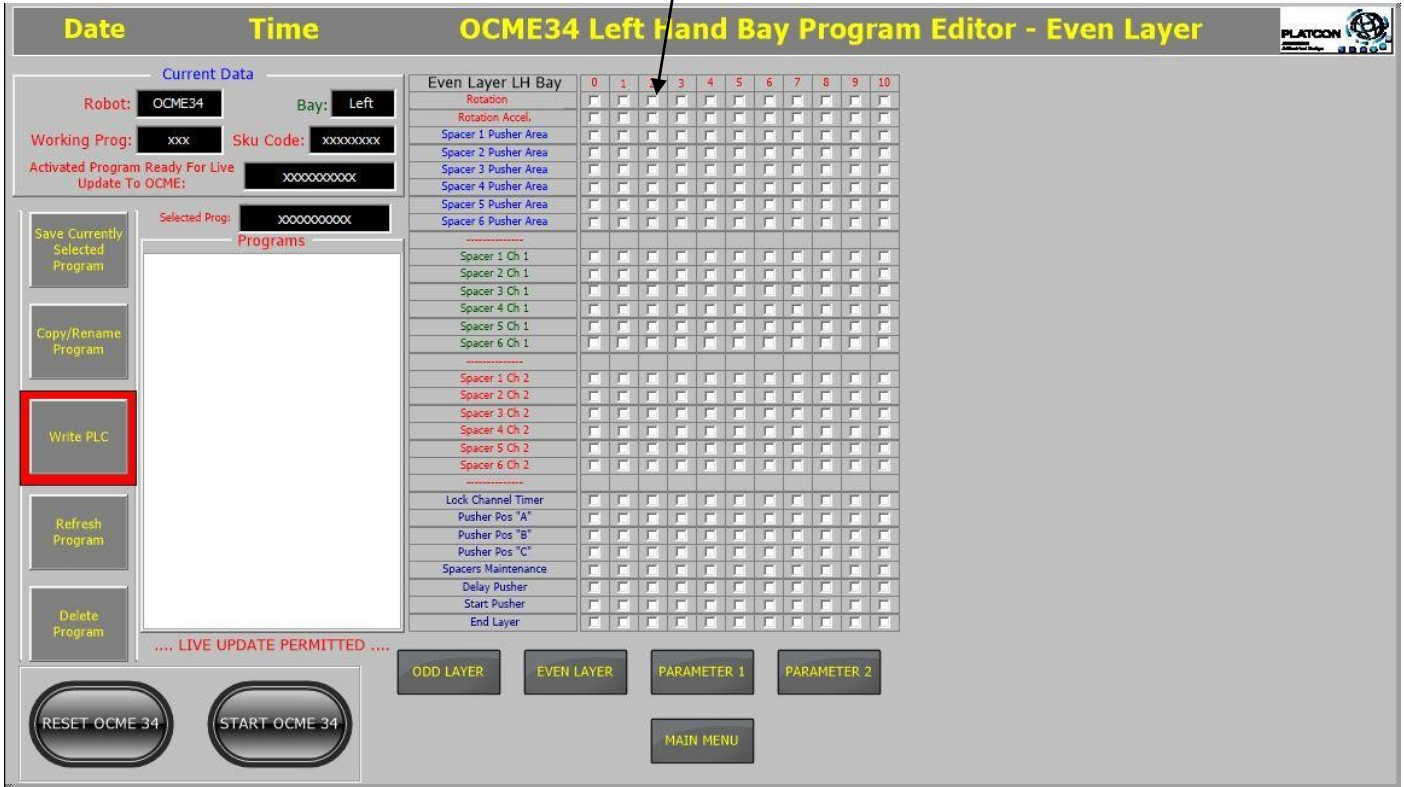
Remote Reset and Start Pushbuttons for the OCME Robot

Screen Change Buttons to Switch Between Odd, Even, Parameter 1 and Parameter 2 Screens

## OCME 34 Left Hand Bay Program Editor – Even Layer


	<h1>Operating Manual Information Sheet</h1>		
<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend	
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	

Even Layer Program Data



The screenshot displays the 'OCME34 Left Hand Bay Program Editor - Even Layer' interface. It features a top header with 'Date', 'Time', and the title. Below the header, there are sections for 'Current Data' (Robot: OCME34, Bay: Left), 'Working Prog', 'Sku Code', and 'Activated Program Ready For Live Update To OCME'. A 'Selected Prog' field is also present. On the left, there are buttons for 'Save Currently Selected Program', 'Copy/Rename Program', 'Write PLC' (highlighted with a red box), 'Refresh Program', and 'Delete Program'. The main area is a grid for programming data, with columns labeled 0 through 10 and rows for various parameters like 'Rotation', 'Spacer 1 Pusher Area', 'Spacer 2 Pusher Area', etc. At the bottom, there are buttons for 'ODD LAYER', 'EVEN LAYER', 'PARAMETER 1', 'PARAMETER 2', 'RESET OCME 34', 'START OCME 34', and 'MAIN MENU'. A status bar at the bottom indicates '.... LIVE UPDATE PERMITTED ....'.

## OCME 34 Left Hand Bay Program Editor – Parameters 1

	<h1>Operating Manual Information Sheet</h1>		
	<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	

**Date**
**Time**
**OCME34 Left Hand Bay Program Editor - Parameters 1**


**Current Data**

Robot: **OCME34** Bay: **Left**

Working Prog: **xxx** Sku Code: **xxxxxxxx**

Activated Program Ready For Live Update To OCME: **xxxxxxxxxxxx**

Selected Prog: **xxxxxxxxxxxx**

**Programs**

Program Number	x	Lateral Guide Open Odd Layer	x
Cases per layer	x	Rear Guide Open Odd Layer	x
Pusher encoder Pos "A"	x	Lateral Guide Close Approx. Odd Layer	x
Pusher encoder Pos "B"	x	Rear Guide Close Approx. Odd Layer	x
Pusher encoder Pos "C"	x	-----	x
Pusher encoder infreed start	x	En Reading 2nd Table Guides Even Layers	x
Delay Rotation Counter	x	Open Lateral Guide Delay Even Layer	x
Delay Acc. Rotation Counter	x	Open Rear Guide Delay Even Layer	x
Acc. Rotation Mainten. Counter	x	Close Lateral Guide Delay Even Layer	x
Spacer 1 Pusher Area	x	Close Rear Guide Delay Even Layer	x
Spacer 2 Pusher Area	x	Pos Value Open Lateral Guides Even Layer	x
Spacer 3 Pusher Area	x	Pos Value Open Rear Guides Even Layer	x
Spacer 4 Pusher Area	x	Pos Closed Lat Guides Even Lay Approach	x
Spacer 5 Pusher Area	x	Pos Closed Rear Guides Even Lay Approach	x
Spacer 6 Pusher Area	x	-----	x
Spacer 1 Ch 1	x	Following Pack Stopping Time	x
Spacer 2 Ch 1	x	-----	x
Spacer 3 Ch 1	x	-----	x
Spacer 4 Ch 1	x	LH Blade Pos. Value for Odd Lay Decent	x
Spacer 5 Ch 1	x	RH Blade Pos. Value for Odd Lay Decent	x
Spacer 6 Ch 1	x	LH Blade Pos. Value for Odd Lay Rise	x
Spacer 1 Ch 2	x	RH Blade Pos. Value for Odd Lay Rise	x
Spacer 2 Ch 2	x	LH Blade Pos. Value for Odd Lay Slipping Rise	x
Spacer 3 Ch 2	x	RH Blade Pos. Value for Odd Lay Slipping Rise	x
Spacer 4 Ch 2	x	-----	x
Spacer 5 Ch 2	x	-----	x
Spacer 6 Ch 2	x	Blade Enabled	x
-----	x	Enable Reading 2nd Table for Blades Even Layers	x
Open Lateral Guide odd layer delay	x	LH Blade Pos. Value for Even Lay Decent	x
Open Rear Guide odd layer delay	x	RH Blade Pos. Value for Even Lay Decent	x
Close Lateral Guide odd layer delay	x	LH Blade Pos. Value for Even Lay Rise	x
Close Rear Guide odd layer delay	x	RH Blade Pos. Value for Even Lay Rise	x

**Gripper Encoder Actual Values**

LAT	TRANS
LAT	TRANS

**Blade Encoder Actual Values**

LH(1)	RH(2)
LH(1)	RH(2)

**Pusher Encoder Actual Values**

LH(1)
LH(1)

Save Currently Selected Program

Copy/Rename Program

Write PLC


Refresh Program


Delete Program

.... LIVE UPDATE PERMITTED ....

## OCME 34 Left Hand Bay Program Editor – Parameters 2



	<h1>Operating Manual Information Sheet</h1>	
	<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079

**Date**
**Time**
**OCME34 Left Hand Bay Program Editor - Parameters 2**


**Current Data**

Robot: **OCME34** Bay: **Left**

Working Prog: **xxx** Sku Code: **xxxxxxxx**

Activated Program Ready For Live Update To OCME: **xxxxxxxx**

Selected Prog: **xxxxxxxx**

Programs

.... LIVE UPDATE PERMITTED ....

LH Blade Pos. Value For Even Lay, Slipping Rise	x	Pusher Speed For Approaching	x
RH Blade Pos. Value For Even Lay, Slipping Rise	x	Pusher Speed For Reaching Row	x
-----	x	Pusher Max Speed With Packs	x
-----	x	Advance Time For Pusher Slow Down Forwards	x
Guide Cams Opening Value For Pressing Over Travel Check	x		x
Closed Lateral Guides Positioning Odd Layer Pressing	x		x
Closed Rear Guides Positioning Odd Layer Pressing	x		x
-----	x		x
Closed Lateral Guides Positioning Even Layer Pressing	x		x
Closed Rear Guides Positioning Even Layer Pressing	x		x
Closing Gripper Delay On Bay and Ready To Lift	x		x
Robot Head Section Pos. For Picking Odd Layers	x		x
Robot Head Section Pos. For Placing Odd Layers	x		x
-----	x		x
En. Read 2nd Table Even Layer Robot Head Section Position	x		x
Robot Head Section Position For Picking Even Layer	x		x
Robot Head Section Position For Placing Even Layer	x		x
-----	x		x
-----	x		x
-----	x		x
Robot X Axis Value For Descent In Picking Odd Layers	x		x
Robot Y Axis Value For Descent In Picking Odd Layers	x		x
-----	x		x
-----	x		x
Enabling Reading 2nd Table For Even Layers Robot Axes Adjustment	x		x
Robot X Axis Value For Descent In Picking Even Layers	x		x
Robot Y Axis Value For Descent In Picking Even Layers	x		x
-----	x		x
-----	x		x
-----	x		x
Height Value Pack (mm)	x		x
Robot Speed (1..100)	x		x
Encoder Value For Pusher Approaching	x		x

Gripper Encoder Actual Values	
LAT	TRANS
LAT	TRANS
Blade Encoder Actual Values	
LH(1)	RH(2)
LH(1)	RH(2)
Pusher Encoder Actual Values	
LH(1)	
LH(1)	

Save Currently Selected Program

Copy/Rename Program

Write PLC

Refresh Program

Delete Program

RESET OCME 34

START OCME 34

ODD LAYER


EVEN LAYER

PARAMETER 1

PARAMETER 2

MAIN MENU


## Access to Counters Screen

	<h1>Operating Manual Information Sheet</h1>		
<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend	
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	

From the Main Overview Screen Press the 'Show Counters' Pushbutton to Open the Counters Pop Up Window.

## Counters Pop Up Window

This screen updates every 5 seconds and displays last 3 production run figures.

	<h1>Operating Manual Information Sheet</h1>		
<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend	
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	

27/03/2020 14:04:04 Main Page

OCME 34 Working Code - Line 16

Order No	Sku Code	Current Bundles	-1			-2			-3		
			Skus	Order	Packs	Skus	Order	Packs	Skus	Order	Packs
OCME 35 L	Robot 1	00000 R	00 000 0	00000	00 000 0	00000	00 000 0	00000	00 000 0	00000	
OCME 35 R	Robot 2	00000 R	00 000 0	00000	00 000 0	00000	00 000 0	00000	00 000 0	00000	
OCME 34 L	Robot 1	00000 R	00 000 0	00000	00 000 0	00000	00 000 0	00000	00 000 0	00000	
OCME 34 R	Robot 2	00000 R	00 000 0	00000	00 000 0	00000	00 000 0	00000	00 000 0	00000	

OCME 35 Working Code - Line 17

No:	Left Bay	Right Bay
ram:	000	000
pack:	000	000
layer:	000	000
Pall:	000	000
layer:		
st 1:	000	000
st 2:	000	000
Packs:		
ent:	00000000	00000000
Preset:	00000000	00000000
Pallet Type:	????	????

Please Quit This Screen To Continue Viewing Other Screens

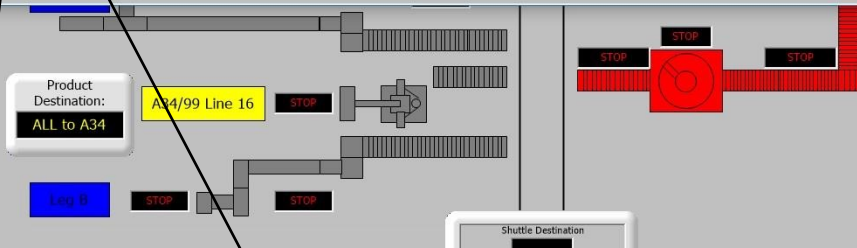
Quit

Product Destination: ALL to A34

A34/99 Line 16

Logout Login

USER: [ ]




Shuttle Destination

Press Here To Modify the Production Counts

Press Here to Reset the Production Counts to Zero

The Counters Screen Must Be Quit Before Being Able to Open Any Other Screens

## Counters Set Value

	<h1>Operating Manual Information Sheet</h1>		
<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend	
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	

27/03/2020 14:04:04 Main Page

OCME 34 Working Code - Line 16
OCME 35 Working Code - Line 17

Order No	Sku Code	Current Bundles	-1			-2			-3		
			Skus	Order	Packs	Skus	Order	Packs	Skus	Order	Packs
OCME 35 L Robot 1		00000 R		00 000 0	00000		00 000 0	00000		00 000 0	00000
OCME 35 R Robot 2		00000 R		00 000 0	00000		00 000 0	00000		00 000 0	00000
OCME 34 L Robot 2		00000 R		00 000 0	00000		00 000 0	00000		00 000 0	00000
OCME 34 R		00000 R		00 000 0	00000		00 000 0	00000		00 000 0	00000

MODIFY OCME 34 RIGHT BAY PACK COUNTER

CURRENT VALUE	NEW VALUE
00000313	00000313

Please Quit This Screen To Continue Viewing Other Screens

Product Destination: A34/99 Line 16

Shuttle Destination: [ ]

Logout Login


USER: [ ]

Counters Set Value Pop Up Box, Enter the New Value and Click Save or Quit to Exit with no Change

### Counters Reset Value

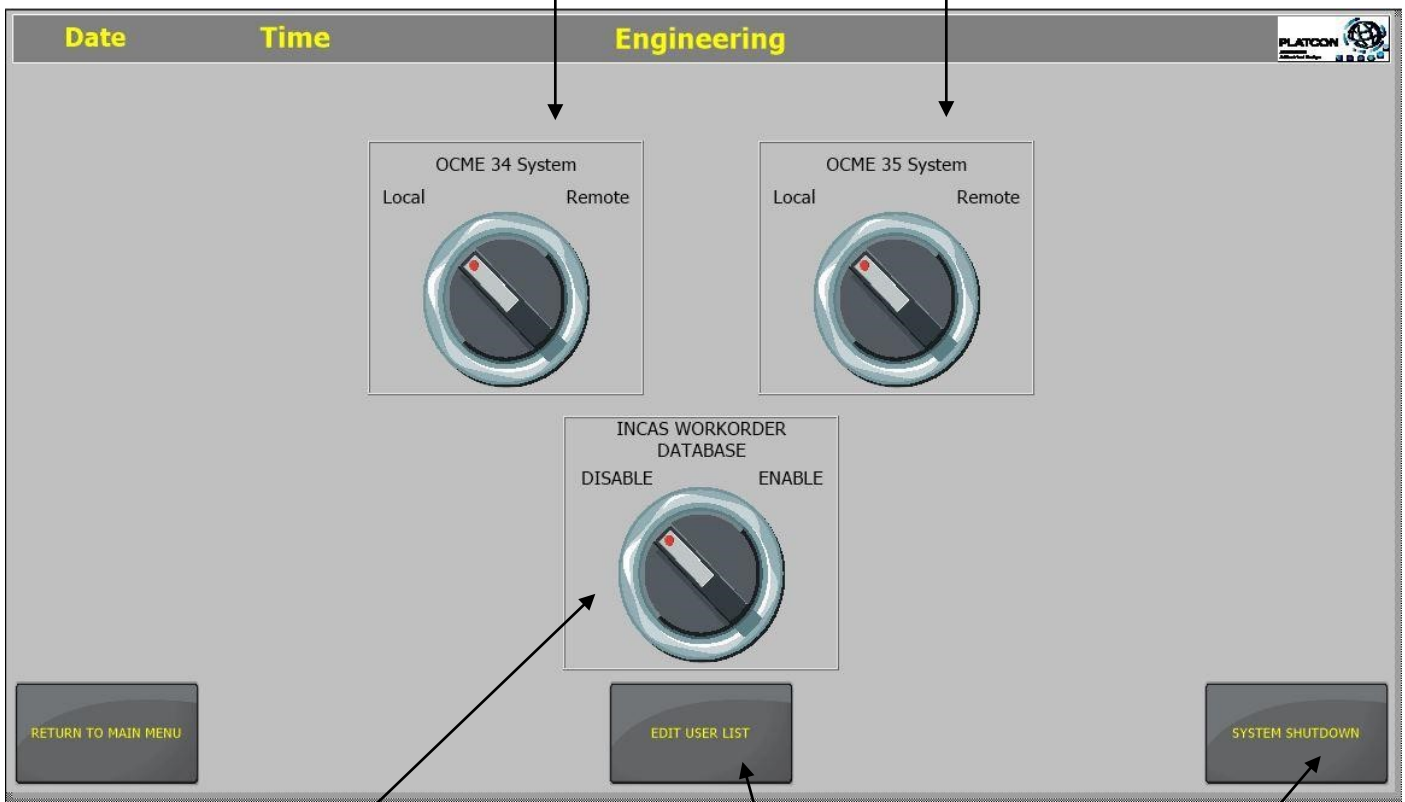




	<h1>Operating Manual Information Sheet</h1>		
<b>Serial Number:</b> W1079	<b>Customer:</b> WEPA UK	<b>Site:</b> Bridgend	
<b>Project Description:</b> Hall 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	

These Switches Place the OCME Systems into Either Local or Remote Mode.

When In Local Settings May be Entered from PanelView 550 HMI, When in Remote Mode Settings May be Entered From PC SCADA System




This toggle switch allows you to enable or disable the INCAS Workorder Database.

Allows Runtime Access to the Usernames and Passwords Set up on the System

System Shutdown Will Close Down the SCADA System and Revert Back to the Windows Desktop

<b>Section No</b>	<b>5</b>	<b>Description</b>	<b>Program Operation Scripts</b>
-------------------	----------	--------------------	----------------------------------

**5.1 Program Operation Scripts**

		<h1>Operating Manual Information Sheet</h1>	
<b>Serial Number:</b> W1079		<b>Customer: WEPA</b> UK	
		<b>Site:</b> Bridgend	
<b>Project Description: Hall</b> 2 OCME SCADA		<b>Document No:</b> Op Man – W1079	

## Next Code Calculations

Sub Main()

```

SKUR1L = Chr$((R1N92_0 And 65280)/256) + Chr$(R1N92_0 And 255) + Chr$((R1N92_1 And 65280)/256) + Chr$(R1N92_1 And 255) +
Chr$((R1N92_2 And 65280)/256) + Chr$(R1N92_2 And 255) + Chr$((R1N92_3 And 65280)/256) + Chr$(R1N92_3 And 255)
SKUR1R = Chr$((R1N98_0 And 65280)/256) + Chr$(R1N98_0 And 255) + Chr$((R1N98_1 And 65280)/256) + Chr$(R1N98_1 And 255) +
Chr$((R1N98_2 And 65280)/256) + Chr$(R1N98_2 And 255) + Chr$((R1N98_3 And 65280)/256) + Chr$(R1N98_3 And 255)
SKUR2L = Chr$((R2N92_0 And 65280)/256) + Chr$(R2N92_0 And 255) + Chr$((R2N92_1 And 65280)/256) + Chr$(R2N92_1 And 255) +
Chr$((R2N92_2 And 65280)/256) + Chr$(R2N92_2 And 255) + Chr$((R2N92_3 And 65280)/256) + Chr$(R2N92_3 And 255)
SKUR2R = Chr$((R2N98_0 And 65280)/256) + Chr$(R2N98_0 And 255) + Chr$((R2N98_1 And 65280)/256) + Chr$(R2N98_1 And 255) +
Chr$((R2N98_2 And 65280)/256) + Chr$(R2N98_2 And 255) + Chr$((R2N98_3 And 65280)/256) + Chr$(R2N98_3 And 255)
ORDER1L = Right$("0000" + Str(R1N92_4),4) + Right$("0000" + Str(R1N92_5),4)
ORDER1R = Right$("0000" + Str(R1N98_4),4) + Right$("0000" + Str(R1N98_5),4)
ORDER2L = Right$("0000" + Str(R2N92_4),4) + Right$("0000" + Str(R2N92_5),4)
ORDER2R = Right$("0000" + Str(R2N98_4),4) + Right$("0000" + Str(R2N98_5),4)

```

End Sub

## Counters Update

Option Explicit

' To run a script with a infinite loop is important that:

- ' 1) Enable the "Separate Thread" property
- ' 2) Set the "Sleep(msec)" property greater than 0 (10 msec or more)
- ' 3) Insert the "DoEvents" instruction inside each loop (Do..Loop, While..Wend, etc.)

Const CLOCK\_TIME As Single = 2      'value in seconds

Dim dOldDate As Date

Sub Main

    dOldDate = Now

    Do



# Operating Manual Information Sheet

<b>Serial Number:</b> W1079	<b>Customer: WEPA</b> UK	<b>Site:</b> Bridgend
<b>Project Description: Hall</b> 2 OCME SCADA		<b>Document No:</b> Op Man – W1079

```
'Call the subroutine every CLOCK_TIME
If DateDiff("s", dOldDate, Now) >= CLOCK_TIME Then
    Call CustomCode()
dOldDate = Now
End If
```

```
DoEvents
```

```
Loop Until IsInStoppingMode Or CounterScreenOpen = 0
```

```
End Sub
```

```
Sub CustomCode()
```

```
'Insert the code to execute
```

```
SKUR1L_P = Chr$(R1N9_20 And 65280)/256 & Chr$(R1N9_20 And 255) & Chr$(R1N9_21 And 65280)/256 & Chr$(R1N9_21 And 255) &
Chr$(R1N9_22 And 65280)/256 & Chr$(R1N9_22 And 255) & Chr$(R1N9_23 And 65280)/256 & Chr$(R1N9_23 And 255)
SKUR1R_P = Chr$(R1N9_40 And 65280)/256 & Chr$(R1N9_40 And 255) & Chr$(R1N9_41 And 65280)/256 & Chr$(R1N9_41 And 255) &
Chr$(R1N9_42 And 65280)/256 & Chr$(R1N9_42 And 255) & Chr$(R1N9_43 And 65280)/256 & Chr$(R1N9_43 And 255)
SKUR2L_P = Chr$(R2N9_20 And 65280)/256 & Chr$(R2N9_20 And 255) & Chr$(R2N9_21 And 65280)/256 & Chr$(R2N9_21 And 255) &
Chr$(R2N9_22 And 65280)/256 & Chr$(R2N9_22 And 255) & Chr$(R2N9_23 And 65280)/256 & Chr$(R2N9_23 And 255)
SKUR2R_P = Chr$(R2N9_40 And 65280)/256 & Chr$(R2N9_40 And 255) & Chr$(R2N9_41 And 65280)/256 & Chr$(R2N9_41 And 255) &
Chr$(R2N9_42 And 65280)/256 & Chr$(R2N9_42 And 255) & Chr$(R2N9_43 And 65280)/256 & Chr$(R2N9_43 And 255)
ORDR1L_P = Right$("0000" & Str$(R1N9_28),4) & Right$("0000" & Str$(R1N9_29),4)
ORDR1R_P = Right$("0000" & Str$(R1N9_44),4) & Right$("0000" & Str$(R1N9_45),4) ORDR2L_P
= Right$("0000" & Str$(R2N9_28),4) & Right$("0000" & Str$(R2N9_29),4)
ORDR2R_P = Right$("0000" & Str$(R2N9_44),4) & Right$("0000" & Str$(R2N9_45),4)
SKUR1L_P_2 = Chr$(R1N9_110 And 65280)/256 & Chr$(R1N9_110 And 255) & Chr$(R1N9_111 And 65280)/256 & Chr$(R1N9_111 And 255)
& Chr$(R1N9_112 And 65280)/256 & Chr$(R1N9_112 And 255) & Chr$(R1N9_113 And 65280)/256 & Chr$(R1N9_113 And 255)
SKUR1R_P_2 = Chr$(R1N9_130 And 65280)/256 & Chr$(R1N9_130 And 255) & Chr$(R1N9_131 And 65280)/256 & Chr$(R1N9_131 And 255)
& Chr$(R1N9_132 And 65280)/256 & Chr$(R1N9_132 And 255) & Chr$(R1N9_133 And 65280)/256 & Chr$(R1N9_133 And 255)
SKUR2L_P_2 = Chr$(R2N9_110 And 65280)/256 & Chr$(R2N9_110 And 255) & Chr$(R2N9_111 And 65280)/256 & Chr$(R2N9_111 And 255)
& Chr$(R2N9_112 And 65280)/256 & Chr$(R2N9_112 And 255) & Chr$(R2N9_113 And 65280)/256 & Chr$(R2N9_113 And 255)
SKUR2R_P_2 = Chr$(R2N9_130 And 65280)/256 & Chr$(R2N9_130 And 255) & Chr$(R2N9_131 And 65280)/256 & Chr$(R2N9_131 And 255)
& Chr$(R2N9_132 And 65280)/256 & Chr$(R2N9_132 And 255) & Chr$(R2N9_133 And 65280)/256 & Chr$(R2N9_133 And 255)
ORDR1L_P_2 = Right$("0000" & Str$(R1N9_114),4) & Right$("0000" & Str$(R1N9_115),4)
ORDR1R_P_2 = Right$("0000" & Str$(R1N9_134),4) & Right$("0000" & Str$(R1N9_135),4) ORDR2L_P_2
= Right$("0000" & Str$(R2N9_114),4) & Right$("0000" & Str$(R2N9_115),4)
ORDR2R_P_2 = Right$("0000" & Str$(R2N9_134),4) & Right$("0000" & Str$(R2N9_135),4)
SKUR1L_P_3 = Chr$(R1N9_120 And 65280)/256 & Chr$(R1N9_120 And 255) & Chr$(R1N9_121 And 65280)/256 & Chr$(R1N9_121 And 255)
& Chr$(R1N9_122 And 65280)/256 & Chr$(R1N9_122 And 255) & Chr$(R1N9_123 And 65280)/256 & Chr$(R1N9_123 And 255)
SKUR1R_P_3 = Chr$(R1N9_140 And 65280)/256 & Chr$(R1N9_140 And 255) & Chr$(R1N9_141 And 65280)/256 & Chr$(R1N9_141 And 255)
& Chr$(R1N9_142 And 65280)/256 & Chr$(R1N9_142 And 255) & Chr$(R1N9_143 And 65280)/256 & Chr$(R1N9_143 And 255)
SKUR2L_P_3 = Chr$(R2N9_120 And 65280)/256 & Chr$(R2N9_120 And 255) & Chr$(R2N9_121 And 65280)/256 & Chr$(R2N9_121 And 255)
& Chr$(R2N9_122 And 65280)/256 & Chr$(R2N9_122 And 255) & Chr$(R2N9_123 And 65280)/256 & Chr$(R2N9_123 And 255)
SKUR2R_P_3 = Chr$(R2N9_140 And 65280)/256 & Chr$(R2N9_140 And 255) & Chr$(R2N9_141 And 65280)/256 & Chr$(R2N9_141 And 255)
& Chr$(R2N9_142 And 65280)/256 & Chr$(R2N9_142 And 255) & Chr$(R2N9_143 And 65280)/256 & Chr$(R2N9_143 And 255)
ORDR1L_P_3 = Right$("0000" & Str$(R1N9_124),4) & Right$("0000" & Str$(R1N9_125),4)
ORDR1R_P_3 = Right$("0000" & Str$(R1N9_144),4) & Right$("0000" & Str$(R1N9_145),4) ORDR2L_P_3
= Right$("0000" & Str$(R2N9_124),4) & Right$("0000" & Str$(R2N9_125),4)
ORDR2R_P_3 = Right$("0000" & Str$(R2N9_144),4) & Right$("0000" & Str$(R2N9_145),4) Debug.Print
"Counters refresh routine executed!"
End Sub
```

## OCME 35 LH Filter

```
Sub Main()
```

```
Const RECIPE_NAME = "Params"
```

```
Dim IDX_RecipeCol As String
```

```
Dim RecipeCollist As String
```

```
Dim FilterText As String
```

```
Index_tmp = "OCME35LH"
```

```
FilterText = "OCME35LH"
```

```
RecipeCollist = GetDataLoggerRecipe(RECIPE_NAME).GetColumnNameList 'return string like: [ID Ricetta], Column1, Column2, ...
```

```
If RecipeCollist <> "" Then
```

```
    IDX_RecipeCol = Mid(RecipeCollist,1,InStr(RecipeCollist,",")-1)
```



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```
If Index_tmp <> "" Then
    [Params:Filter] = IDX_RecipeCol & " Like '%" & FilterText & "%"
Else
    [Params:Filter] = ""
End If
```

```
[Params:Refresh] = Not [Params:Refresh]
End If
```

End Sub

## OCME 35 RH Filter

Sub Main()

Const RECIPE\_NAME = "Params"

Dim IDX\_RecipeCol As String  
Dim RecipeColList As String  
Dim FilterText As String

```
Index_tmp = "OCME35RH"
FilterText = "OCME35RH"
RecipeColList = GetDataLoggerRecipe(RECIPE_NAME).GetColumnNameList 'return string like: [ID Ricetta], Column1, Column2, ...
If RecipeColList <> "" Then
    IDX_RecipeCol = Mid(RecipeColList,1,InStr(RecipeColList,",")-1)

    If Index_tmp <> "" Then
        [Params:Filter] = IDX_RecipeCol & " Like '%" & FilterText & "%"
    Else
        [Params:Filter] = ""
    End If

    [Params:Refresh] = Not [Params:Refresh]
End If
```

End Sub

## OCME 34 LH Filter

Sub Main()

Const RECIPE\_NAME = "Params"

Dim IDX\_RecipeCol As String  
Dim RecipeColList As String  
Dim FilterText As String

```
Index_tmp = "OCME34LH"
FilterText = "OCME34LH"
RecipeColList = GetDataLoggerRecipe(RECIPE_NAME).GetColumnNameList 'return string like: [ID Ricetta], Column1, Column2, ...
If RecipeColList <> "" Then
```

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```
IDX_RecipeCol = Mid(RecipeColList,1,InStr(RecipeColList,"")-1)
```

```
If Index_tmp <> "" Then
    [Params:Filter] = IDX_RecipeCol & " Like '%" & FilterText & "%"
```

```
Else
    [Params:Filter] = ""
```

```
End If
```

```
[Params:Refresh] = Not [Params:Refresh]
```

```
End If
```

```
End Sub
```

## OCME 34 RH Filter

```
Sub Main()
```

```
Const RECIPE_NAME = "Params"
```

```
Dim IDX_RecipeCol As String
```

```
Dim RecipeColList As String
```

```
Dim FilterText As String
```

```
Index_tmp = "OCME34RH"
```

```
FilterText = "OCME34RH"
```

```
RecipeColList = GetDataLoggerRecipe(RECIPE_NAME).GetColumnNameList 'return string like: [ID Ricetta], Column1, Column2, ...
```

```
If RecipeColList <> "" Then
```

```
    IDX_RecipeCol = Mid(RecipeColList,1,InStr(RecipeColList,"")-1)
```

```
    If Index_tmp <> "" Then
```

```
        [Params:Filter] = IDX_RecipeCol & " Like '%" & FilterText & "%"
```

```
    Else
```

```
        [Params:Filter] = ""
```

```
    End If
```

```
[Params:Refresh] = Not [Params:Refresh]
```

```
End If
```

```
End Sub
```

## Pallet Cape Reference Image Selection

```
Sub Main()
```

```
    If PalletCapeRef_tmp = "" Or PalletCapeRef_tmp = "No Image" Then
        CapeRefImageNumber = 0
```

```
    End If
```

```
    If PalletCapeRef_tmp = "PF 8" Then
```

```
        CapeRefImageNumber = 1
```

```
End If
```

```
    If PalletCapeRef_tmp = "PF 77" Then
```

```
        CapeRefImageNumber = 2
```

```
End If
```

```
    If PalletCapeRef_tmp = "PF 71" Then
```



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```
CapeReflmageNumber = 3
End If
  If PalletCapeRef_tmp = "PF 68" Then
CapeReflmageNumber = 4  End If
  If PalletCapeRef_tmp = "PF 67" Then
    CapeReflmageNumber = 5
End If
  If PalletCapeRef_tmp = "PF 65" Then
    CapeReflmageNumber = 6
End If
  If PalletCapeRef_tmp = "PF 53" Then
    CapeReflmageNumber = 7
  End If
  If PalletCapeRef_tmp = "PF 235" Then
    CapeReflmageNumber = 8
  End If
  If PalletCapeRef_tmp = "PF 231" Then
    CapeReflmageNumber = 9
  End If
  If PalletCapeRef_tmp = "PF 197" Then
    CapeReflmageNumber = 10
  End If
  If PalletCapeRef_tmp = "PF 195" Then
    CapeReflmageNumber = 11
  End If
  If PalletCapeRef_tmp = "PF 175" Then
    CapeReflmageNumber = 12
  End If
  If PalletCapeRef_tmp = "PF 169" Then
    CapeReflmageNumber = 13
  End If
  If PalletCapeRef_tmp = "PF 168" Then
    CapeReflmageNumber = 14
  End If
  If PalletCapeRef_tmp = "PF 167" Then
    CapeReflmageNumber = 15
  End If
  If PalletCapeRef_tmp = "PF 231" Then
    CapeReflmageNumber = 16
  End If
  If PalletCapeRef_tmp = "PF 241" Then
    CapeReflmageNumber = 17
  End If
  If PalletCapeRef_tmp = "PF 238" Then
    CapeReflmageNumber = 18
  End If
  If PalletCapeRef_tmp = "PF 265" Then
    CapeReflmageNumber = 19
  End If
  If PalletCapeRef_tmp = "PF 217" Then
    CapeReflmageNumber = 20
  End If
  If PalletCapeRef_tmp = "PF 251" Then CapeReflmageNumber = 21 End
If
  If PalletCapeRef_tmp = "PF 252" Then
CapeReflmageNumber = 22  End If
  If PalletCapeRef_tmp = "PF 240" Then
CapeReflmageNumber = 23  End If
  If PalletCapeRef_tmp = "PF 245" Then
    CapeReflmageNumber = 24
  End If
  If PalletCapeRef_tmp = "PF 86" Then
CapeReflmageNumber = 25  End If
  If PalletCapeRef_tmp = "PF 247" Then
CapeReflmageNumber = 26  End If
  If PalletCapeRef_tmp = "PF 239" Then
    CapeReflmageNumber = 27
```



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End If

End Sub

## Send Sku and Program to OCME PLC System

Public Sub Click()

Dim I As Integer  
Dim C1 As String  
Dim C2 As String

OCME35NextCodeProgram = TABPRG\_tmp\_W200  
OCME35NextCodePresetL1 = PresetLayer1\_tmp  
OCME35NextCodePresetL2 = PresetLayer2\_tmp



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If MsgBox("ARE YOU SURE YOU WANT TO DOWNLOAD SKU CODE AND PROGRAM TO OCME 25?", vbYesNo, "Sku Only") = vbYes

Then

```

ExecuteCommand("<CommandType synoptic='IN PROGRESS' action='2' monitor='0' parameter=" x='600' y='400' width='400'
height='100' Caption='false' Border='true' Resizeable='false' SysMenu='false' MinimizeBox='false'
MaximizeBox='false'KeepPrintProportions='0' PageW='-1' PageH='-1' LMargin='-1' RMargin='-1' TMargin='-1'
BMargin='1'>Synoptic</CommandType>")
    R2N40_50 = OCME35NextCodeBay ' OCME Left Hand Bay Selected
    Wait 1
' If pc enabled by PanelView control sku code Is inserted
If Len(OCME35NextCodeOrder) <> 8 Then
    ExecuteCommand("<CommandType synoptic='IN PROGRESS' action='5' monitor='0' parameter=" x='800' y='500' width='200'
height='50' Caption='false' Border='true' Resizeable='false' SysMenu='false' MinimizeBox='false'
MaximizeBox='false'KeepPrintProportions='0' PageW='-1' PageH='-1' LMargin='-1' RMargin='-1' TMargin='-1'
BMargin='1'>Synoptic</CommandType>")
        OCME35NextCodeOrder = ""
    MsgBox("Incorrect Next Code Order Number - Parameters are NOT Downloaded!", vbOkOnly)
Else
    If OCME35NextCodeSku = "" Then
        MsgBox("No Sku Code Entered - Parameters are NOT Downloaded!", vbOkOnly)
    Else
        If OCME35NextCodePresetL1 = 0 Then
            MsgBox("Invalid Preset Number For Layer 1 Must Be Greater Than 0 - Parameters are NOT Downloaded!",
vbOkOnly)
        Else
            'Activate the currently selected program
            ExecuteCommand("<CommandType dlr='Params' action='8' x='-1' y='-1' width='0' height='0' Toolbar='0'
GroupTree='0' >Report</CommandType>")
            ExecuteCommand("<CommandType dlr='Params2' action='8' x='-1' y='-1' width='0' height='0' Toolbar='0'
GroupTree='0' >Report</CommandType>")
            Wait 2
            OCME35NextCodePacks10000 = Int(OCME35NextCodePacks / 10000)
            OCME35NextCodePacks1 = OCME35NextCodePacks - ( OCME35NextCodePacks10000 * 10000 )
            'Call the sub-routine to download the program to the PLC
            Call OCME35SendSkuAndProgram()
            R2N40_10 = OCME35NextCodeProgram
            R2N40_14 = OCME35NextCodePresetL1
            R2N40_19 = OCME35NextCodePresetL2
            R2N40_25 = OCME35NextCodePallet
            R2N40_26 = OCME35NextCodeWrap
            R2N40_29 = OCME35NextCodeProduct
            R2N40_44 = OCME35NextCodeStacker
            R2N40_48 = OCME35NextCodePad1
            R2N40_49 = OCME35NextCodePad2
            ' R2N40_104 = OCME35NextCodeOrder10000
            ' R2N40_105 = OCME35NextCodeOrder1
            R2N40_8 = OCME35NextCodePacks10000
            R2N40_9 = OCME35NextCodePacks1
            OCME35NextCodeSku = UCase(OCME35NextCodeSku)
            C1=Mid( OCME35NextCodeSku, 1, 1 )
            C2=Mid( OCME35NextCodeSku, 2, 1 )
            R2N40_100 = Asc( C1 )*256 + Asc( C2 )
            C1=Mid( OCME35NextCodeSku, 3, 1 )
            C2=Mid( OCME35NextCodeSku, 4, 1 )
            R2N40_101 = Asc( C1 )*256 + Asc( C2 )
            C1=Mid( OCME35NextCodeSku, 5, 1 )
            C2=Mid( OCME35NextCodeSku, 6, 1 )
            R2N40_102 = Asc( C1 )*256 + Asc( C2 )
            C1=Mid( OCME35NextCodeSku, 7, 1 )
            C2=Mid( OCME35NextCodeSku, 8, 1 )
            R2N40_103 = Asc( C1 )*256 + Asc( C2 )
            ' Convert OCME35 Next Code Order To Words To Transfer To OCME 25 PLC
            C1=Mid( OCME35NextCodeOrder, 1, 1 )
            C2=Mid( OCME35NextCodeOrder, 2, 1 )
            R2N40_110 = Asc( C1 )*256 + Asc( C2 )
            C1=Mid( OCME35NextCodeOrder, 3, 1 )

```



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```

C2=Mid( OCME35NextCodeOrder, 4, 1 )
R2N40_111 = Asc( C1 )*256 + Asc( C2 )
C1=Mid( OCME35NextCodeOrder, 5, 1 )
C2=Mid( OCME35NextCodeOrder, 6, 1 )
R2N40_112 = Asc( C1 )*256 + Asc( C2 )
C1=Mid( OCME35NextCodeOrder, 7, 1 )
C2=Mid( OCME35NextCodeOrder, 8, 1 )
R2N40_113 = Asc( C1 )*256 + Asc( C2 )
Wait 3
R2N40_52 = 1
ExecuteCommand("<CommandType synoptic='IN PROGRESS' action='5' monitor='0' parameter=" x='800'
y='500' width='200' height='50' Caption='false' Border='true' Resizeable='false' SysMenu='false'
MinimizeBox='false' MaximizeBox='false' KeepPrintProportions='0' PageW='-1' PageH='-1' LMargin='-1'
RMargin='-1' TMargin='-1' BMargin='-1'>Synoptic</CommandType>")
ExecuteCommand("<CommandType synoptic='DOWNLOAD COMPLETED' action='2' monitor='0'
parameter=" x='600' y='400' width='400' height='100' Caption='false' Border='true' Resizeable='false'
SysMenu='false' MinimizeBox='false' MaximizeBox='false' KeepPrintProportions='0' PageW='-1' PageH='-1'
LMargin='-1' RMargin='-1' TMargin='-1' BMargin='-1'>Synoptic</CommandType>")
Wait 3
ExecuteCommand("<CommandType synoptic='DOWNLOAD COMPLETED' action='5' monitor='0'
parameter=" x='800' y='500' width='200' height='50' Caption='false' Border='true' Resizeable='false'
SysMenu='false' MinimizeBox='false' MaximizeBox='false' KeepPrintProportions='0' PageW='-1' PageH='-1'
LMargin='-1' RMargin='-1' TMargin='-1' BMargin='-1'>Synoptic</CommandType>")
FinDatiNextCode=0
OCME35NextCodeBay = 0 ' No OCME Bay Selected flag
OCME35NextCodeSku = ""
OCME35NextCodeProgram = 0
OCME35NextCodePresetL1 = 0
OCME35NextCodePresetL2 = 0
OCME35NextCodePallet = 0
OCME35NextCodeWrap = 4
OCME35NextCodeProduct = 0
OCME35NextCodePad1 = 0
OCME35NextCodePad2 = 0
OCME35NextCodeOrder = ""
OCME35NextCodePacks = 0
OCME35NextCodePacks1 = 0
OCME35NextCodePacks10000 = 0
OCME35NextCodeStacker=0
R2N40_50=0
R2N40_60=0
R2N40_61=0
NEXTORDEROCME35LH = Chr$((R2N89_60 And 65280)/256) & Chr$(R2N89_60 And 255) &
Chr$((R2N89_61 And 65280)/256) & Chr$(R2N89_61 And 255) & Chr$(R2N89_62 And 65280)/256) &
Chr$(R2N89_62 And 255) & Chr$((R2N89_63 And 65280)/256) & Chr$(R2N89_63 And 255)
NEXTSKUOCME35LH = Chr$((R2N89_50 And 65280)/256) & Chr$(R2N89_50 And 255) &
Chr$((R2N89_51 And 65280)/256) & Chr$(R2N89_51 And 255) & Chr$((R2N89_52 And 65280)/256) &
Chr$(R2N89_52 And 255) & Chr$((R2N89_53 And 65280)/256) & Chr$(R2N89_53 And 255)
NEXTORDEROCME35RH = Chr$((R2N95_60 And 65280)/256) & Chr$(R2N95_60 And 255) &
Chr$((R2N95_61 And 65280)/256) & Chr$(R2N95_61 And 255) & Chr$((R2N95_62 And 65280)/256) &
Chr$(R2N95_62 And 255) & Chr$((R2N95_63 And 65280)/256) & Chr$(R2N95_63 And 255)
NEXTSKUOCME35RH = Chr$((R2N95_50 And 65280)/256) & Chr$(R2N95_50 And 255) &
Chr$((R2N95_51 And 65280)/256) & Chr$(R2N95_51 And 255) & Chr$((R2N95_52 And 65280)/256) &
Chr$(R2N95_52 And 255) & Chr$((R2N95_53 And 65280)/256) & Chr$(R2N95_53 And 255)
Wait 2
ExecuteCommand("<CommandType synoptic='OCME35 NEXT CODE SETTINGS' action='5' monitor='0'
parameter=" x='-1' y='-1' width='0' height='0' Caption='true' Border='true' Resizeable='false'
SysMenu='false' MinimizeBox='false' MaximizeBox='false' KeepPrintProportions='0' PageW='-1' PageH='-1'
LMargin='-1' RMargin='-1' TMargin='-1' BMargin='-1'>Synoptic</CommandType>")
ExecuteCommand("<CommandType synoptic='OCME35 ROBOT NEXT CODE' action='0' monitor='0'
parameter=" x='-1' y='-1' width='0' height='0' Caption='true' Border='true' Resizeable='false'
SysMenu='false' MinimizeBox='false' MaximizeBox='false' KeepPrintProportions='0' PageW='-1' PageH='-1'
LMargin='-1' RMargin='-1' TMargin='-1' BMargin='-1'>Synoptic</CommandType>")
End If
End If
End If
```



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End Sub  
Sub OCME35SendSkuAndProgram

' This Script Downloads the next working codes Program to OCME 34 LH Bay Dim  
n As Integer  
Dim s As String

Debug.Print "Download Next Working Codes Routine Executed!"

```
For n = 0 To 10 Step 1
    s = Str$(n)
    s = Replace(s, " ", "")
    PuntTagPlc = "R2N41_" & s
    PuntTag = "TABPRGW" & s
    If GetVariableValue(PuntTag) > 32767 Then
        SetVariableValue(PuntTagPlc,(GetVariableValue(PuntTag))-65536)
    Else
        SetVariableValue(PuntTagPlc,GetVariableValue(PuntTag))
    End If
Next n
```

```
For n = 50 To 60 Step 1
    s = Str$(n)
    s = Replace(s, " ", "")
    PuntTagPlc = "R2N41_" & s
    PuntTag = "TABPRGW" & s
    If GetVariableValue(PuntTag) > 32767 Then
        SetVariableValue(PuntTagPlc,(GetVariableValue(PuntTag)-65536))
    Else
        SetVariableValue(PuntTagPlc,GetVariableValue(PuntTag))
    End If
Next n
```

```
For n = 100 To 110 Step 1
    s = Str$(n)
    s = Replace(s, " ", "")
    PuntTagPlc = "R2N41_" & s
    PuntTag = "TABPRGW" & s
    If GetVariableValue(PuntTag) > 32767 Then
        SetVariableValue(PuntTagPlc,(GetVariableValue(PuntTag)-65536))
    Else
        SetVariableValue(PuntTagPlc,GetVariableValue(PuntTag))
    End If
Next n
```

```
For n = 150 To 160 Step 1
    s = Str$(n)
    s = Replace(s, " ", "")
    PuntTagPlc = "R2N41_" & s
    PuntTag = "TABPRGW" & s
    If GetVariableValue(PuntTag) > 32767 Then
        SetVariableValue(PuntTagPlc,(GetVariableValue(PuntTag)-65536))
    Else
        SetVariableValue(PuntTagPlc,GetVariableValue(PuntTag))
    End If
Next n
```

```
For n = 0 To 99 Step 1
    s = Str$(n)
    s = Replace(s, " ", "")
    PuntTagPlc = "R2N43_" & s s
    = Str$(n+200)
    s = Replace(s, " ", "")
    PuntTag = "TABPRGW" & s
    SetVariableValue(PuntTagPlc,GetVariableValue(PuntTag))
Next n
```



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```
Wait 2
If OCME35NextCodeBay = 1 Then

    R2B3_30_2 = 1

Else

    If OCME35NextCodeBay = 2 Then

        R2B3_30_5 = 1

    End If

End If

Wait 3
R2B3_30_2 = 0
R2B3_30_5 = 0
Debug.Print "Download Sku And Program Routine Completed!"

End Sub
```

## Program Download From SCADA System to OCME PLC System

' This Script Downloads the selected program to the working area of the OCME 25 LH Bay

```
Public Sub Click()
    Dim objVar As DBVarObjCmdTarget
    Dim n As Integer
    Dim s As String

    Set objVar = GetVariableObject("R2N43_0")
    If objVar.Quality = 192 Then

        If R2N40_55 = 2 Then ' Disable Pushbutton as per InTouch application
```

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Else

```
If MsgBox("ARE YOU SURE YOU WANT TO DOWNLOAD " & Index & " PROGRAM TO THE OCME 25 LHS PLC?",vbYesNo,"Activate Program") = vbYes Then
```

```
    Debug.Print "Download Selected Program To OCME 25 LH Working Area Executed!"
```

```
    For n = 0 To 10 Step 1
```

```
        s = Str$(n)
```

```
        s = Replace(s, " ", "")
```

```
PuntTagPlc = "R2N41_" & s
```

```
    PuntTag = "TABPRGW" & s
```

```
    If GetVariableValue(PuntTag) > 32767 Then
```

```
        SetVariableValue(PuntTagPlc,(GetVariableValue(PuntTag))-65536)
```

```
    Else
```

```
        SetVariableValue(PuntTagPlc,GetVariableValue(PuntTag))
```

```
    End If
```

```
Next n
```

```
For n = 50 To 60 Step 1
```

```
    s = Str$(n)
```

```
    s = Replace(s, " ", "")
```

```
PuntTagPlc = "R2N41_" & s
```

```
    PuntTag = "TABPRGW" & s
```

```
    If GetVariableValue(PuntTag) > 32767 Then
```

```
        SetVariableValue(PuntTagPlc,(GetVariableValue(PuntTag)-65536))
```

```
    Else
```

```
        SetVariableValue(PuntTagPlc,GetVariableValue(PuntTag))
```

```
    End If
```

```
Next n
```

```
For n = 100 To 110 Step 1
```

```
    s = Str$(n)
```

```
    s = Replace(s, " ", "")
```

```
PuntTagPlc = "R2N41_" & s
```

```
    PuntTag = "TABPRGW" & s
```

```
    If GetVariableValue(PuntTag) > 32767 Then
```

```
        SetVariableValue(PuntTagPlc,(GetVariableValue(PuntTag)-65536))
```

```
    Else
```

```
        SetVariableValue(PuntTagPlc,GetVariableValue(PuntTag))
```

```
    End If
```

```
Next n
```

```
For n = 150 To 160 Step 1
```

```
    s = Str$(n)
```

```
    s = Replace(s, " ", "")
```

```
PuntTagPlc = "R2N41_" & s
```

```
    PuntTag = "TABPRGW" & s
```

```
    If GetVariableValue(PuntTag) > 32767 Then
```

```
        SetVariableValue(PuntTagPlc,(GetVariableValue(PuntTag)-65536))
```

```
    Else
```

```
        SetVariableValue(PuntTagPlc,GetVariableValue(PuntTag))
```

```
    End If
```

```
Next n
```

```
For n = 0 To 99 Step 1
```

```
    s = Str$(n)
```

```
    s = Replace(s, " ", "")
```

```
PuntTagPlc = "R2N43_" & s
```

```
s = Str$(n+200)
```

```
    s = Replace(s, " ", "")
```

```
PuntTag = "TABPRGW" & s
```

```
    SetVariableValue(PuntTagPlc,GetVariableValue(PuntTag))
```

```
Next n
```

```
Wait 2
```

```
R2B3_30_2 = 1
```



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```
ExecuteCommand("<CommandType synoptic='DOWNLOAD COMPLETED' action='2' monitor='0'  
parameter=" x='600' y='400' width='400' height='100' Caption='false' Border='true' Resizeable='false'  
SysMenu='false' MinimizeBox='false' MaximizeBox='false'KeepPrintProportions='0' PageW='-1' PageH='-1'  
LMargin='-1' RMargin='-1' TMargin='-1' BMargin='-1'>Synoptic</CommandType>")  
Wait 3  
ExecuteCommand("<CommandType synoptic='DOWNLOAD COMPLETED' action='5' monitor='0'  
parameter=" x='800' y='500' width='200' height='50' Caption='false' Border='true' Resizeable='false'  
SysMenu='false' MinimizeBox='false' MaximizeBox='false'KeepPrintProportions='0' PageW='-1' PageH='-1'  
LMargin='-1' RMargin='-1' TMargin='-1' BMargin='-1'>Synoptic</CommandType>")  
R2B3_30_2 = 0  
Debug.Print "Download Selected Program To OCME 25 LH Working Area Completed!"
```

Else

End If

End If

Else

```
MsgBox("No Communications to OCME 35 Active, Please Check Communications",vbOkOnly,"No OCME35 Comms")
```

End If

```
Download25StepSeq = 0
```

End Sub

## Move Program From PLC Storage Location To Working Area

Public Sub Click()

```
Dim UpPos As String
```

```
Dim ProgStringTemp As String
```

```
If R2N40_54 >0 Then
```

Else

```
UpPos = Str$(120 + UpPositionSX)
```

```
UpPos = Replace(UpPos, " ", "")
```

```
PuntTagPlc = "R2N" & UpPos & "_0"
```

```
ProgStringTemp = Str$(GetVariableValue(PuntTagPlc))
```

```
ProgStringTemp = Replace(ProgStringTemp, " ", "")
```

```
Program = "P" & Right("000" & ProgStringTemp,3)
```

```
If Program = "P000" Then
```

```
MsgBox("Invalid Program Number.", vbOkOnly,"Data Error")
```



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```
Else
    Bay = "Left"
    R2N40_54 = GetVariableValue(PuntTagPlc)
    R2N40_55 = 11
    Wait 5
    Bay = "Left"
    R2N40_54 = GetVariableValue(PuntTagPlc)
    R2N40_55 = 11
    Upload25StepSeq = 2
```

```
End If
```

```
End Sub
```

## Live Update of Program Settings

' This Script Writes the selected program to the PLCs working area of the OCME 25 LH Bay

Option Explicit

Dim objVar As DBVarObjCmdTarget

Public Sub Click()

```
    Dim n As Integer
    Dim s As String
```

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```
Set objVar = GetVariableObject("R2N43_0")
If objVar.Quality = 192 Then
```

```
    If MsgBox("ARE YOU SURE YOU WANT TO WRITE " & Index & " PROGRAM TO THE OCME 25 LHS BAY?",vbYesNo,"Write Program") = vbYes Then
```

```
        Debug.Print "Selected Program Write To OCME 25 LH PLC Working Area Executed!"
```

```
For n = 0 To 10 Step 1  s = Str$(n)
                      s = Replace(s, " ", "")
    PuntTagPlc = "R2N41_" & s
    PuntTag = "TABPRGW" & s
    If GetVariableValue(PuntTag) > 32767 Then
        SetVariableValue(PuntTagPlc,(GetVariableValue(PuntTag)-65536)
    Else
        SetVariableValue(PuntTagPlc,GetVariableValue(PuntTag))
    End If
Next n
```

```
For n = 50 To 60 Step 1
    s = Str$(n)
    s = Replace(s, " ", "")
    PuntTagPlc = "R2N41_" & s
    PuntTag = "TABPRGW" & s
    If GetVariableValue(PuntTag) > 32767 Then
        SetVariableValue(PuntTagPlc,(GetVariableValue(PuntTag)-65536))
    Else
        SetVariableValue(PuntTagPlc,GetVariableValue(PuntTag))
    End If
Next n
```

```
For n = 100 To 110 Step 1  s = Str$(n)
                          s = Replace(s, " ", "")
    PuntTagPlc = "R2N41_" & s
    PuntTag = "TABPRGW" & s
    If GetVariableValue(PuntTag) > 32767 Then
        SetVariableValue(PuntTagPlc,(GetVariableValue(PuntTag)-65536))
    Else
        SetVariableValue(PuntTagPlc,GetVariableValue(PuntTag))
    End If
Next n
```

```
For n = 150 To 160 Step 1  s = Str$(n)
                          s = Replace(s, " ", "")
    PuntTagPlc = "R2N41_" & s
    PuntTag = "TABPRGW" & s
    If GetVariableValue(PuntTag) > 32767 Then
        SetVariableValue(PuntTagPlc,(GetVariableValue(PuntTag)-65536))
    Else
        SetVariableValue(PuntTagPlc,GetVariableValue(PuntTag))
    End If
Next n
```

```
For n = 0 To 99 Step 1
    s = Str$(n)
    s = Replace(s, " ", "")
    PuntTagPlc = "R2N43_" & s
    s = Str$(n+200)
    s = Replace(s, " ", "")
    PuntTag = "TABPRGW" & s
    SetVariableValue(PuntTagPlc,GetVariableValue(PuntTag))
Next n
R2N40_70 = R2N43_0 ' Set R2N40_70 to the program number of the current active program that has been
downloaded to the PLCs working area
R2N40_71 = 1 ' Data Written Confirmation From The PC to The PLC For The LH Processing Bay
```





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```
Wait 3
R2N40_70 = R2N43_0 ' Set R2N40_70 to the program number of the current active program that has been
downloaded to the PLCs working area
R2N40_71 = 1 ' Data Written Confirmation From The PC to The PLC For The LH Processing Bay
' Program_Saved = 0
ExecuteCommand("<CommandType synoptic='WRITE PLC COMPLETED' action='2' monitor='0' parameter=" x='580'
y='600' width='400' height='100' Caption='false' Border='true' Resizeable='false' SysMenu='false'
MinimizeBox='false' MaximizeBox='false'KeepPrintProportions=0' PageW='-1' PageH='-1' LMargin='-1' RMargin='-1'
TMargin='-1' BMargin='-1'>Synoptic</CommandType>")
Wait 2
ExecuteCommand("<CommandType synoptic='WRITE PLC COMPLETED' action='5' monitor='0' parameter="
x='580' y='600' width='400' height='100' Caption='false' Border='true' Resizeable='false' SysMenu='false'
MinimizeBox='false' MaximizeBox='false'KeepPrintProportions=0' PageW='-1' PageH='-1' LMargin='-1' RMargin='-1'
TMargin='-1' BMargin='-1'>Synoptic</CommandType>")
Debug.Print "Selected Program Write To OCME 25 LH PLC Working Area Completed!"
```

Else

End If

Else

```
MsgBox("No Communications to OCME 25 Active, Please Check Communications",vbOkOnly,"No OCME35 Comms")
```

End If

End Sub