

DB600 - <offline> - Declaration view

"PMS_VK1_REQ_INPUT" input requests (wheel allowance) from PLC
Global data block DB 600

Name:

Author:

Time stamp Code:

Lengths (block/logic/data):

Family:

Version: 0.1

Block version: 2

03/04/2024 02:27:11 PM

Interface: 03/04/2024 02:27:11 PM

00948 00520 00000

Object properties:
S7_language 7(1) Deutsch (Deutschland) 08/03/2011 04:44:24 PM

Block: DB600

Address	Name	Type	Initial value	Comment
0.0		STRUCT		
+0.0	REQUEST_INPUT_Conv1	STRUCT		VK1 (Input Conveyor/Scanner) get wheel production allowan ce request
+0.0	oi_on	BYTE	B#16#0	PLC->1, PMS->0 after setting i_variables
+2.0	o_wp_id	ARRAY[1..20]		the scanned workpiece ID
*1.0		CHAR		
+22.0	o_wp_type	DINT	L#0	current wp setup type (database TypeID for TYHI WheelType (chars))
+26.0	i_status	BYTE	B#16#0	1 - OK, machining allowed, 2- NOK not in list, 3- NOK no job for wheel type
+28.0	i_job_id	ARRAY[1..20]		
*1.0		CHAR		
+48.0	i_drawing_id	ARRAY[1..20]		
*1.0		CHAR		
+68.0	i_heat_id	ARRAY[1..20]		
*1.0		CHAR		
+88.0	i_sourceheat	ARRAY[1..20]		
*1.0		CHAR		
+108.0	i_batch_id	ARRAY[1..20]		
*1.0		CHAR		
+128.0	i_skip_op	"UDT_WP_SKIP"		0 - use, 1 - skip (idx 1=InspectA,2=InspectB,3=Oil,...15)
=130.0		END_STRUCT		
+130.0	REQUEST_INPUT_Conv2	STRUCT		VK1 (Input Conveyor/Scanner) get wheel production allowan ce request
+0.0	oi_on	BYTE	B#16#0	PLC->1, PMS->0 after setting i_variables
+2.0	o_wp_id	ARRAY[1..20]		the scanned workpiece ID
*1.0		CHAR		
+22.0	o_wp_type	DINT	L#0	current wp setup type (database TypeID for TYHI WheelType (chars))
+26.0	i_status	BYTE	B#16#0	1 - OK, machining allowed, 2- NOK not in list, 3- NOK no job for wheel type
+28.0	i_job_id	ARRAY[1..20]		
*1.0		CHAR		
+48.0	i_drawing_id	ARRAY[1..20]		
*1.0		CHAR		
+68.0	i_heat_id	ARRAY[1..20]		
*1.0		CHAR		
+88.0	i_sourceheat	ARRAY[1..20]		
*1.0		CHAR		
+108.0	i_batch_id	ARRAY[1..20]		
*1.0		CHAR		
+128.0	i_skip_op	"UDT_WP_SKIP"		0 - use, 1 - skip (idx 1=InspectA,2=InspectB,3=Oil,...15)
=130.0		END_STRUCT		
+260.0	REQUEST_INPUT_Conv3	STRUCT		VK1 (Input Conveyor/Scanner) get wheel production allowan ce request
+0.0	oi_on	BYTE	B#16#0	PLC->1, PMS->0 after setting i_variables
+2.0	o_wp_id	ARRAY[1..20]		the scanned workpiece ID
*1.0		CHAR		
+22.0	o_wp_type	DINT	L#0	current wp setup type (database TypeID for TYHI WheelType (chars))
+26.0	i_status	BYTE	B#16#0	1 - OK, machining allowed, 2- NOK not in list, 3- NOK no job for wheel type
+28.0	i_job_id	ARRAY[1..20]		
*1.0		CHAR		
+48.0	i_drawing_id	ARRAY[1..20]		
*1.0		CHAR		
+68.0	i_heat_id	ARRAY[1..20]		
*1.0		CHAR		
+88.0	i_sourceheat	ARRAY[1..20]		
*1.0		CHAR		
+108.0	i_batch_id	ARRAY[1..20]		

Address	Name	Type	Initial value	Comment
*1.0		CHAR		
+128.0	i_skip_op	"UDT_WP_SKIP"		0 - use, 1 - skip (idx 1=InspectA,2=InspectB,3=Oil,...15)
=130.0		END_STRUCT		
+390.0	REQUEST_INPUT_ST_Feed	STRUCT		VK1 (Input Conveyor/Scanner) get wheel production allowance request
+0.0	oi_on	BYTE	B#16#0	PLC->1, PMS->0 after setting i_variables
+2.0	o_wp_id	ARRAY[1..20]		the scanned workpiece ID
*1.0		CHAR		
+22.0	o_wp_type	DINT	L#0	current wp setup type (databaseTypeID for TYHI WheelType (chars))
+26.0	i_status	BYTE	B#16#0	1 - OK, machining allowed, 2- NOK not in list, 3- NOK no job for wheel type
+28.0	i_job_id	ARRAY[1..20]		
*1.0		CHAR		
+48.0	i_drawing_id	ARRAY[1..20]		
*1.0		CHAR		
+68.0	i_heat_id	ARRAY[1..20]		
*1.0		CHAR		
+88.0	i_sourceheat	ARRAY[1..20]		
*1.0		CHAR		
+108.0	i_batch_id	ARRAY[1..20]		
*1.0		CHAR		
+128.0	i_skip_op	"UDT_WP_SKIP"		0 - use, 1 - skip (idx 1=InspectA,2=InspectB,3=Oil,...15)
=130.0		END_STRUCT		
=520.0		END_STRUCT		