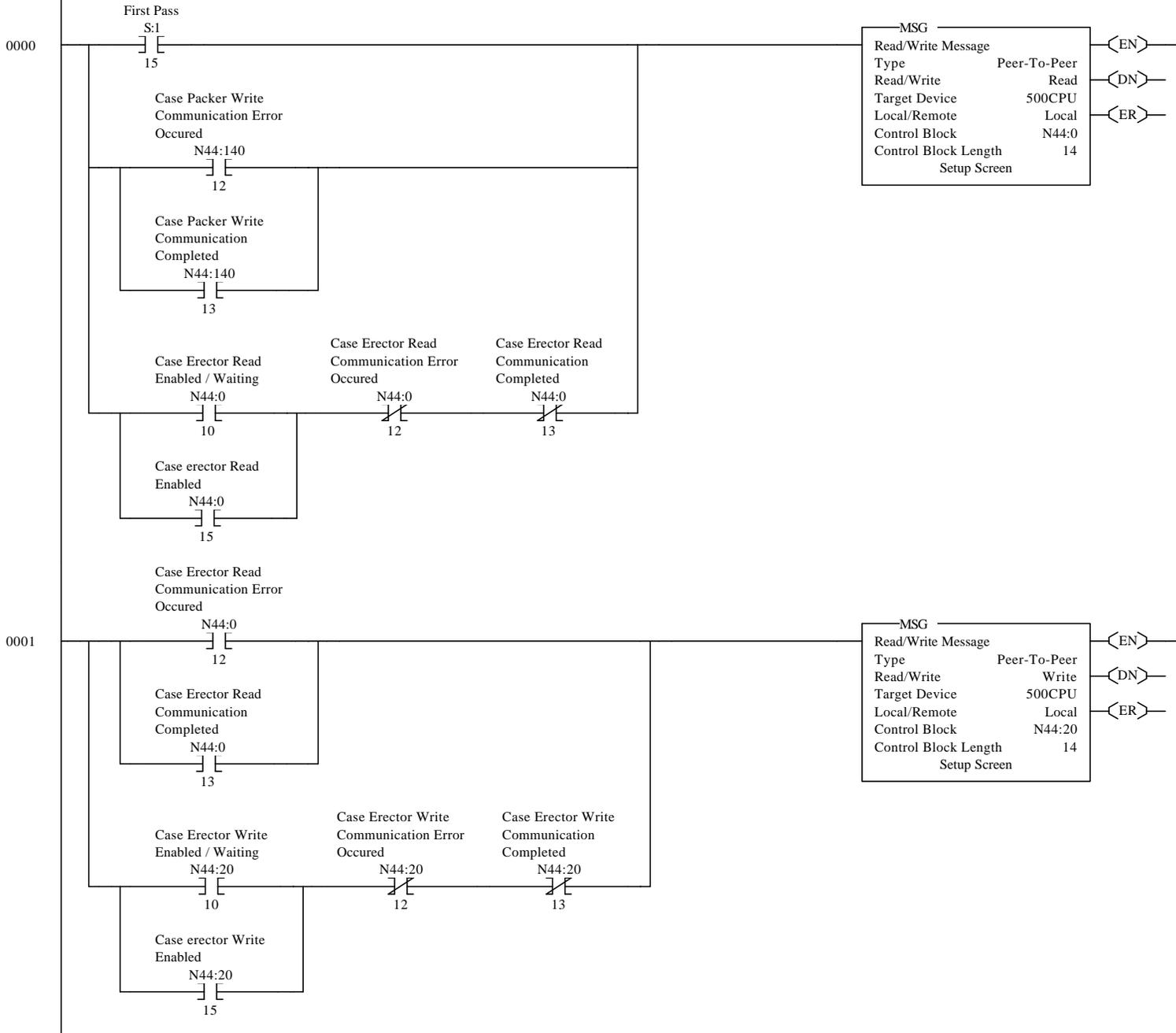


DH-485 Communications Control.

This file contains all of the processor to processor messaging instructions. Communications is cascaded, such that as one MSG instruction completes (or errors out) the next is triggered. The Error bits are monitored in ERR DETECT (File 15). Note that this does not include traffic that is initiated by the PV-550 or TCP screen.

Comm's to Case Erector - DH-485 Node Address 3, MicroLogix 1000



Comm to case packer - Dh-485 Node Address 1, SLC 5/03

0002

Case Erector Write  
Communication Error  
Occured

N44:20  
12

Case Erector Write  
Communication  
Completed

N44:20  
13

Case Packer Read  
Enabled / Waiting

N44:40  
10

Case Packer Read  
Enabled

N44:40  
15

Case Packer Read  
Communication Error  
Occured

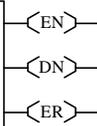
N44:40  
12

Case Packer Read  
Communication  
Completed

N44:40  
13

MSG

|                      |              |
|----------------------|--------------|
| Read/Write Message   | Peer-To-Peer |
| Type                 | Read         |
| Read/Write           | 500CPU       |
| Target Device        | Local        |
| Local/Remote         | N44:40       |
| Control Block        | 14           |
| Control Block Length | Setup Screen |



0003

Palletizer Write  
Communication Error  
Occured

N44:120  
12

Palletizer Write  
Communication  
Completed

N44:120  
13

Case Packer Write  
Enabled / Waiting

N44:140  
10

Case Packer Write  
Enabled

N44:140  
15

Case Packer Write  
Communication Error  
Occured

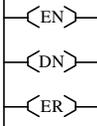
N44:140  
12

Case Packer Write  
Communication  
Completed

N44:140  
13

MSG

|                      |              |
|----------------------|--------------|
| Read/Write Message   | Peer-To-Peer |
| Type                 | Read         |
| Read/Write           | 500CPU       |
| Target Device        | Local        |
| Local/Remote         | N44:140      |
| Control Block        | 14           |
| Control Block Length | Setup Screen |



comm to case sealer - DH-485 Node Address 6, MicroLogix 1000

0004

Case Packer Read  
Communication Error  
Occured

N44:40  
] [ 12

Case Packer Read  
Communication  
Completed

N44:40  
] [ 13

Case Sealer Read  
Enabled / Waiting

N44:60  
] [ 10

Case Sealer Read  
Enabled

N44:60  
] [ 15

Case Sealer Read  
Communication Error  
Occured

N44:60  
] [ 12

Case Sealer Read  
Communication  
Completed

N44:60  
] [ 13

MSG

|                      |              |
|----------------------|--------------|
| Read/Write Message   |              |
| Type                 | Peer-To-Peer |
| Read/Write           | Read         |
| Target Device        | 500CPU       |
| Local/Remote         | Local        |
| Control Block        | N44:60       |
| Control Block Length | 14           |
| Setup Screen         |              |

(EN)  
(DN)  
(ER)

0005

Case Sealer Read  
Communication Error  
Occured

N44:60  
] [ 12

Case Sealer Read  
Communication  
Completed

N44:60  
] [ 13

Case Sealer Write  
Enabled / Waiting

N44:80  
] [ 10

Case Sealer Write  
Enabled

N44:80  
] [ 15

Case Sealer Write  
Communication Error  
Occured

N44:80  
] [ 12

Case Sealer Write  
Communication  
Completed

N44:80  
] [ 13

MSG

|                      |              |
|----------------------|--------------|
| Read/Write Message   |              |
| Type                 | Peer-To-Peer |
| Read/Write           | Write        |
| Target Device        | 500CPU       |
| Local/Remote         | Local        |
| Control Block        | N44:80       |
| Control Block Length | 14           |
| Setup Screen         |              |

(EN)  
(DN)  
(ER)

comms to palletizer - DH-485 Node Address 7 , SLC 5/03

0006

Case Sealer Write  
Communication Error  
Occured

N44:80  
] [ 12

Case Sealer Write  
Communication  
Completed

N44:80  
] [ 13

Palletizer Read  
Enabled / Waiting

N44:100  
] [ 10

Palletizer Read  
Enabled

N44:100  
] [ 15

Palletizer Read  
Communication Error  
Occured

N44:100  
] [ 12

Palletizer Read  
Communication  
Completed

N44:100  
] [ 13

Palletizer Read  
Communication Error  
Occured

N44:100  
] [ 12

Palletizer Read  
Communication  
Completed

N44:100  
] [ 13

Palletizer Write  
Enabled / Waiting

N44:120  
] [ 10

Palletizer Write  
Enabled

N44:120  
] [ 15

Palletizer Write  
Communication Error  
Occured

N44:120  
] [ 12

Palletizer Write  
Communication  
Completed

N44:120  
] [ 13

MSG

|                      |              |
|----------------------|--------------|
| Read/Write Message   |              |
| Type                 | Peer-To-Peer |
| Read/Write           | Read         |
| Target Device        | 500CPU       |
| Local/Remote         | Local        |
| Control Block        | N44:100      |
| Control Block Length | 14           |
|                      | Setup Screen |

(EN)  
(DN)  
(ER)

0007

MSG

|                      |              |
|----------------------|--------------|
| Read/Write Message   |              |
| Type                 | Peer-To-Peer |
| Read/Write           | Write        |
| Target Device        | 500CPU       |
| Local/Remote         | Local        |
| Control Block        | N44:120      |
| Control Block Length | 14           |
|                      | Setup Screen |

(EN)  
(DN)  
(ER)

0008

(END)