Example 5.8 - Determine part production rate

Copyright (c) 2013 Dogwood Valley Press, LLC

0000

Hour timer
CHR_TMR/DN
T4:10/DN

Hour timer
CHR_TMR
TON
Timer On Delay
Timer T4:10
Time Base 1.0
Preset 3600<
Accum 0<
EN
DN

0001

Hour timer
CHR_TMR/DN
T4:10/DN

Total number of items passing on conv 1 and 2
CELL_PRATE
MOV
Move
Source C5:6.ACC
0<
Dest N7:50
0<

Counts parts produced in cell
CELL_PRATE_CTR
C5:6
RES

0002

Part out of machine
PART_OUT
I:1/14

Counts parts produced in cell
CELL_PRATE_CTR
CTU
Count Up
Counter C5:6
Preset 1000<
Accum 0<
CU
DN

0003

END

Copyright © 2013 Dogwood Valley Press, LLC.
Copying or posting without permission of the publisher is expressly prohibited.