

Truck Weigh Example

ProAction PCEE - [TruckWeigh]

File Communications Tools View Help

Step List

Step #	Name
1	Truck Enters Scale
2	Prompt for ID
3	Accept ID
4	Prompt for Driver
5	Accept Driver
6	Tare Scale
7	Fill Truck
8	Print
9	Timer 1
10	Timer 2
11	Truck Exits
12	Pause
13	Restart
14	Abort

New Step
Rename Step
Remove Step
Move Step Up
Move Step Down

☒ Enabled ☐ Pausable

Conditions "True" Actions "False" Actions Pause Actions

Conditions

Weight Compare

720 PCEE Program Example SPECIFICATION

Truck Weigh Example

Objective

This program was written for the 720i to enter a truck ID and driver name and fill the truck to 100 lb net before printing a ticket. There are red/green traffic lights and a fill output.

Weighing Trucks

1. The green light will be on and the red light will be off before the truck enters the scale.
2. When the weight exceeds 500 lbs the light changes to red and the 720i prompts "Enter ID".
3. Enter the truck ID.
4. The 720i prompts "Enter Driver Name". Enter the driver name.
5. The scale will be tared off and the fill output will turn on until it reaches 100 net.
6. When 100 lb is reached the fill output will turn off.
7. It will wait for standstill before printing Auxillary Format #1 with the Truck ID, Driver Name and gross, tare and net weights, and time/date. It will then switch the traffic light back to green.

Databases

2) Prompts Database – 1 row

FIELD	TYPE	DESCRIPTION
1) EnterID	String	"Enter ID" prompt
2) Motlon	String	"In Motion" prompt
3) Printed	String	"Printed" prompt
4) Exit	String	"Exit Scale" prompt
5) Enter	String	"Enter Scale" prompt
6) Invalid	String	"Invalid ID" prompt
7) Filling	String	"Filling Truck" prompt
8) Paused	String	"Paused" prompt
9) Driver	String	"Enter Driver" prompt

720 PCEE Program Example SPECIFICATION

Truck Weigh Example

Databases

2) Trucks Database – 100 rows -- FOR FUTURE USE ONLY

FIELD	TYPE	DESCRIPTION
1) ID	Integer	Truck ID
2) Driver	String	Driver Name
3) Target	Real	Target weight to fill

Digital Inputs/Outputs

BIT	TYPE	DESCRIPTION
1	Output	Red traffic light
2	Output	Green traffic light
3	Output	Fill output
4	Off	Not used

Truck Weigh Example

STEP 1: Truck Enters Scale (Enabled, Not Pausable)

CONDITIONS

Weight Compare, Source: SCALE1, Value: 500, Mode: GROSS, Trip: HIGHER, Band Value: 0, Preact Mode: OFF, Preact Value: 0

Comment: When the weight exceeds 500, the truck entered

TRUE ACTIONS

Deactivate Step, Step Number: 1

Comment: Deactivate this step when it is completed.

Activate Step, Step Number: 2

Comment: Activate the next step.

Digital Output, Slot: 0, Relay Number: 1, State: ON

Comment: Turn the red light on when truck is on scale

Digital Output, Slot: 0, Relay Number: 2, State: OFF

Comment: Turn the green light off when truck enters

FALSE ACTIONS

Digital Output, Slot: 0, Relay Number: 1, State: OFF

Comment: Turn red light OFF before truck enters

Digital Output, Slot: 0, Relay Number: 2, State: ON

Comment: Turn green light on before truck enters.

Get Database Record, Slot: 0, Index: 2, MoveType: FIRST

Comment:

DB Prompt, Slot: 0, Index: 2, Field: 5

Comment: Prompts "Enter Scale"

Truck Weigh Example

STEP 2: Prompt for ID (Not Enabled, Not Pausable)

CONDITIONS

Always True

Comment:

TRUE ACTIONS

Deactivate Step, Step Number: 2

Comment: Deactivate this step when it is completed.

Activate Step, Step Number: 3

Comment: Activate the next step.

Get Database Record, Slot: 0, Index: 2, MoveType: FIRST

Comment:

DB Prompt, Slot: 0, Index: 2, Field: 1

Comment:

User Get, Capture Type: INTEGER

Comment:

STEP 3: Accept ID (Not Enabled, Not Pausable)

CONDITIONS

User Entry, Comment:

TRUE ACTIONS

Deactivate Step, Step Number: 3

Comment: Deactivate this step when it is completed. User Set Print Text, Tag: 1, Type: INTEGER

Comment: Puts Truck ID in user string 1

Activate Step, Step Number: 4

Comment: Activate the next step.

Activate Step, Step Number: 5

Comment: Activate the next step.

Truck Weigh Example

STEP 4: Prompt for Driver (Not Enabled, Not Pausable)

CONDITIONS

Always True

Comment:

TRUE ACTIONS

Deactivate Step, Step Number: 4

Comment:

Get Database Record, Slot: 0, Index: 2, MoveType: FIRST

Comment:

DB Prompt, Slot: 0, Index: 2, Field: 9

Comment:

User Get, Capture Type: STRING

Comment:

Activate Step, Step Number: 5

Comment: Activate the next step.

STEP 5: Accept Driver (Not Enabled, Not Pausable)

CONDITIONS

User Entry, Comment:

TRUE ACTIONS

Deactivate Step, Step Number: 5

Comment:

User Set Print Text, Tag: 2, Type: STRING

Comment:

Activate Step, Step Number: 6

Comment:

Digital Output, Slot: 0, Relay Number: 3, State: OFF

Comment:

Get Database Record, Slot: 0, Index: 2, MoveType: FIRST

Comment: Points to Prompt DB

DB Prompt, Slot: 0, Index: 2, Field: 8

Comment: Prompts "Paused"

Truck Weigh Example

STEP 6: Tare Scale (Not Enabled. Not Pausable)

CONDITIONS

Always True

Comment:

TRUE ACTIONS

Deactivate Step, Step Number: 6

Comment:

Tare Scale, Scale Number: SCALE 1

Comment:

Activate Step, Step Number: 7

Comment:

Truck Weigh Example

STEP 7: Fill Truck (Not Enabled. Pausable)

CONDITIONS

Weight Compare, Source: SCALE1, Value: 100, Mode: NET, Trip: HIGHER, Band Value: 0, Preact Mode: OFF, Preact Value: 0
Comment:

TRUE ACTIONS

Digital Output, Slot: 0, Relay Number: 3, State: OFF

Comment:

Deactivate Step, Step Number: 7

Comment:

Activate Step, Step Number: 8

Comment:

Deactivate Step, Step Number: 12

Comment:

FALSE ACTIONS

Digital Output, Slot: 0, Relay Number: 3, State: ON

Comment:

Activate Step, Step Number: 12

Comment:

Get Database Record, Slot: 0, Index: 2, MoveType: FIRST

Comment:

DB Prompt, Slot: 0, Index: 2, Field: 7

Comment:

PAUSE ACTIONS

Digital Output, Slot: 0, Relay Number: 1, State: OFF

Comment:

Get Database Record, Slot: 0, Index: 2, MoveType: FIRST

Comment:

DB Prompt, Slot: 0, Index: 2, Field: 8

Comment:

Truck Weigh Example

STEP 8: Print (Not Enabled, Not Pausable)

CONDITIONS

Motion Compare, Source: SCALE1, Trip: STANDSTILL

Comment:

TRUE ACTIONS

Deactivate Step, Step Number: 8

Comment: Deactivate this step when it is completed.

Start Timer, Timer Number: 2, Duration: 2000

Comment: Displays "Printed" for 2 seconds before saying Exit Activate Step, Step Number: 10

Comment: Activate the next step.

Get Database Record, Slot: 0, Index: 2, MoveType: FIRST

Comment:

DB Prompt, Slot: 0, Index: 2, Field: 3

Comment: Prompts "Printed"

Print, Format: 1

Comment: Prints AuxFmt 1

Deactivate Step, Step Number: 11

Comment: Deactivates Pause key

Deactivate Step, Step Number: 12

Comment: Deactivates Restart key

Deactivate Step, Step Number: 13

Comment: Deactivates Abort key

STEP 9: Timer 1 (Not Enabled, Not Pausable)

CONDITIONS

Timer Compare, Timer Number: 1, Target State: STOPPED

Comment:

TRUE ACTIONS

Deactivate Step, Step Number: 7

Comment: Deactivate this step when it is completed.

Activate Step, Step Number: 2

Comment: Prompts "Invalid ID" for 2 seconds before reprompting

Truck Weigh Example

STEP 10: Timer 2 (Not Enabled, Not Pausable)

CONDITIONS

Timer Compare, Timer Number: 2, Target State: STOPPED

Comment:

TRUE ACTIONS

Deactivate Step, Step Number: 10

Comment: Deactivate this step when it is completed.

Activate Step, Step Number: 11

Comment: Prompts "Exit Scale" and waits for truck to leave

Get Database Record, Slot: 0, Index: 2, MoveType: FIRST

Comment:

DB Prompt, Slot: 0, Index: 2, Field: 4

Comment: Prompts Exit Scale and waits for truck to leave

Digital Output, Slot: 0, Relay Number: 1, State: OFF

Comment: Turns Red light off (so they exit)

Digital Output, Slot: 0, Relay Number: 2, State: ON

Comment: Turns green light on (so they exit)

Clear Tare, Scale Number: SCALE 1

Comment:

STEP 11: Truck Exits (Not Enabled, Not Pausable)

CONDITIONS

Weight Compare, Source: SCALE1, Value: 500, Mode: GROSS, Trip: LOWER, Band Value: 0, Preact Mode: OFF, Preact Value: 0

Comment: Waits for truck to leave scale before enabling step 1

TRUE ACTIONS

Deactivate Step, Step Number: 11

Comment: Deactivate this step when it is completed.

Activate Step, Step Number: 1

Comment: Reprompts "Enter" and switches lights

Truck Weigh Example

STEP 12: Pause (Not Enabled, Not Pausable)

CONDITIONS

User Key Compare, Key Number: 1

Comment: Pause key during filling of truck

TRUE ACTIONS

Pause Process

Comment:

Activate Step, Step Number: 13

Comment: Activates restart

Activate Step, Step Number: 14

Comment: Activates Abort

Deactivate Step, Step Number: 12

Comment:

STEP 13: Restart (Not Enabled, Not Pausable)

CONDITIONS

User Key Compare, Key Number: 2

Comment: Restart the process

TRUE ACTIONS

Restore Process

Comment:

Deactivate Step, Step Number: 13

Comment:

Deactivate Step, Step Number: 14

Comment:

Activate Step, Step Number: 12

Comment: When restarted, allow pause again

Truck Weigh Example

STEP 14: Abort (Not Enabled, Not Pausable)

CONDITIONS

User Key Compare, Key Number: 3

Comment:

TRUE ACTIONS

Reset Process

Comment:

Clear Tare, Scale Number: SCALE 1

Comment:

Deactivate Step, Step Number: 12

Comment:

Deactivate Step, Step Number: 13

Comment:

Deactivate Step, Step Number: 14

Comment: