



External Manifest Programming Update

Effectivity: Dual Carrier Stacker W/ External Manifest - Firmware 062-00016B HPS Stacker Controller SPEC 009 - Software 062-00020 Version 1.03

1. Recent changes to External Manifest Programming on the HPS Stacker Controlling have been made and are outlined below.

User Interface

- Changed format of the error message window that appears at bottom of screen. For improved readability the message remains on the screen until user presses key, or function is completed.

System Startup

- Polling process changed. Once the controller is activated, it will attempt to communicate with as many Stackers as were entered at startup. Stackers which have not responded to 10 consecutive transmissions of the same message are taken out of the poll loop for 30 seconds. It is important to only queue trucks to Stackers that are present and communicating. This can be verified by the Mode column of the Stackers Status display.

Help Function

- Corrected operation of Help items.

Manifest Functions

- Added block copy and delete commands to the Manifest Change function.
- Added support for the inkjet interface with addition of carrier name and comment fields to Manifest Change function.
- Corrected several problems with draw records in Manifest Change function including permitting entry of draw copies from Manifest Change dialog box.

Build Functions

- Shortcut added. When searching for trucks in the Build Trucks and Build Partial Trucks lists boxes, you can now cursor through the list or you can incrementally search it by pressing letter from the keyboard. The operator can type in the entire truck name if desired.
- Added information columns. Status and Stacker columns added to Build Trucks and Build Partial Trucks list boxes to display status of truck and associated Stacker.
 - queued = waiting to be built
 - complete = build complete
 - blank = no activity for this truck

Halt Functions

- Removed Halt Single command. Use Delete Single command to stop building a truck that is currently being built or delete a truck that is not currently being built.

Delete Functions

- Expanded Delete Single command. Use Delete Single command to stop building a truck that is currently being built or delete a truck that is not currently being built.

Report Functions

- Added a download message to the truck report.

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2. Recent changes to External Manifest Programming on the Dual Carrier Stacker have been made and are outlined below.

Stacking Functions

- Corrected handling of Delete All and Delete Single commands when stacker is stacking and when stacker is idle.
- Added line feed to display output to allow use of VDT to see record of bundles built.

Communications Functions

Added transmission of Truck Begin and Truck Stop message as System Messages to Exception Report.

- Added option to allow null check sum.

Machine Control Functions

- Added option to handle downstream interlock input.

Touch Terminal Functions

- Added system messages concerning:
 - Halt Right Trucks
 - Halt Left Trucks
 - Force Left Discharge
 - Force Right Discharge
 - Resume Normal Discharge