

# Net Fill with Pause-Restore-Reset Example

ProAction PCEE - [Net Fill with Pause-Restore-Reset]

File Communications Tools View Help

Step List

Step #	Name
1	Enter Setpoint Value
2	Finished with Entry ?
3	Wait for Start Key Press
4	Check for Container/Tare
5	Net Fill Setpoint
6	Delay to Display Net
7	Capture Setpoint Value
8	Capture Weight
9	Capture Time & Date
10	Print Weight
11	Pause
12	Restore
13	Reset

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

☒ Enabled ☐ Pausable

Conditions "True" Actions "False" Actions Pause Actions

Conditions

◆ User Key Compare

**STEP 1: Enter Setpoint Value (Enabled, Not Pausable)**

**CONDITIONS**

User Key Compare, Key Number: 2  
Comment: Setpoint Key Pressed?

**TRUE ACTIONS**

Get Database Record, Slot: 0, Index: 2, MoveType: FIRST  
Comment: Find First Record in the Prompts Database  
DB Prompt, Slot: 0, Index: 2, Field: 5  
Comment: Put "Enter Setpoint" on the Display  
User Get Compare, Condition: 25, Compare Type: WEIGHT  
Comment: Get current Setpoint Value to Display  
User Get, Capture Type: REAL  
Comment: Get new Setpoint Value and Store in Real Variable  
Deactivate Step, Step Number: 1  
Comment: Deactivate this step when it is completed.  
Activate Step, Step Number: 2  
Comment: Activate the next step.

**FALSE ACTIONS**

**PAUSE ACTIONS**

**STEP 2: Finished with Entry ? (Not Enabled, Not Pausable)**

**CONDITIONS**

User Entry, Comment: Wait for User Entry of Setpoint Value

**TRUE ACTIONS**

User Set Compare, Condition: 25, Compare Type: WEIGHT  
Comment: Set New Setpoint Value  
Deactivate Step, Step Number: 2  
Comment: Deactivate this step when it is completed.  
Activate Step, Step Number: 3  
Comment: Activate the next step.  
Activate Step, Step Number: 1  
Comment:

**FALSE ACTIONS**

**PAUSE ACTIONS**

**STEP 3: Wait for Start Key Press (Enabled, Not Pausable)**

**CONDITIONS**

User Key Compare, Key Number: 1  
Comment: Wait for Start Key Press (1st Softkey)

**TRUE ACTIONS**

Deactivate Step, Step Number: 3  
Comment: Deactivate this step when it is completed.  
Activate Step, Step Number: 4

## Net Fill with Pause-Restore-Reset

---

Comment: Activate the next step.

### FALSE ACTIONS

Clear Tare, Scale Number: SCALE1

Comment: Remove any Previous Tare Value

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

Comment: Find First Record in the Prompts Database

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

Comment: Put "Press Start Key" on the Display

### PAUSE ACTIONS

#### **STEP 4: Check for Container/Tare (Not Enabled, Not Pausable)**

### CONDITIONS

Weight Compare, Source: SCALE1, Value: 10, Mode: GROSS, Trip: INBAND, Band Value: 2,

Preact Mode: OFF, Preact Value: 0

Comment: Check for a Container [10 Lbs (+ / - 2 Lbs)] on the Scale

Motion Compare, Source: SCALE1, Trip: STANDSTILL

Comment: Check that the Scale is also at Stand still

### TRUE ACTIONS

Tare Scale, Scale Number: SCALE1

Comment: Tare off Container / Switch to Net Mode

Deactivate Step, Step Number: 4

Comment: Deactivate this step when it is completed.

Activate Step, Step Number: 5

Comment: Activate the next step.

### FALSE ACTIONS

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

Comment: Display "Put Container On" message

### PAUSE ACTIONS

#### **STEP 5: Net Fill Setpoint (Not Enabled, Pausable)**

### CONDITIONS

Weight Compare, Source: SCALE1, Value: 150, Mode: NET, Trip: HIGHER, Band Value: 0,

Preact Mode: OFF, Preact Value: 0

Comment: Fill to a Net Value of 150 Lbs

### TRUE ACTIONS

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

Comment: Turn off the 1st Digital Output above 150 Lbs

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

Comment: Display "Done" message

Start Timer, Timer Number: 1, Duration: 3000

Comment: Display Net Weight for 3 Seconds

Deactivate Step, Step Number: 5

Comment: Deactivate this step when it is completed.

Activate Step, Step Number: 6

Comment: Activate the next step.

## Net Fill with Pause-Restore-Reset

---

### FALSE ACTIONS

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

Comment: Turn on the 1st Digital Output below 150 Lbs

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

Comment: Display "Filling in Progress" message

### PAUSE ACTIONS

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

Comment:

### STEP 6: Delay to Display Net (Not Enabled, Not Pausable)

### CONDITIONS

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

Comment: Wait 3 Seconds before Looping Back

### TRUE ACTIONS

Deactivate Step, Step Number: 6

Comment: Deactivate this step when it is completed.

Activate Step, Step Number: 7

Comment: Activate the next step.

### FALSE ACTIONS

### PAUSE ACTIONS

### STEP 7: Capture Setpoint Value (Not Enabled, Not Pausable)

### CONDITIONS

Always True

Comment:

### TRUE ACTIONS

DB Add, Slot: 0, Database Index: 3

Comment: Add a new Record to the Database

User Get Compare, Condition: 25, Compare Type: WEIGHT

Comment: Read the Setpoint Target into the Database

DB Write, Field: 1

Comment: Write the Setpoint Value to the Database

User Set Print Text, Tag: 1, Type: REAL

Comment: Transfer the Setpoint to the Print String

Deactivate Step, Step Number: 7

Comment: Deactivate this step when it is completed.

Activate Step, Step Number: 8

Comment: Activate the next step.

### FALSE ACTIONS

### PAUSE ACTIONS

### STEP 8: Capture Weight (Not Enabled, Not Pausable)

## Net Fill with Pause-Restore-Reset

---

### CONDITIONS

Motion Compare, Source: SCALE1, Trip: STANDSTILL

Comment: Wait for Standstill Condition

### TRUE ACTIONS

DB Capture, Field: 2, Capture Type: LIVEWEIGHT, Scale: SCALE1, Index: 25, Slot: 1, Bit: 1

Comment: Store Final Weight in Database

DB Read, Field: 2

Comment: Read Final Weight into Variable

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

Comment: Transfer Final Weight to Print String

Deactivate Step, Step Number: 8

Comment: Deactivate this step when it is completed.

Activate Step, Step Number: 9

Comment: Activate the next step.

### FALSE ACTIONS

### PAUSE ACTIONS

### **STEP 9: Capture Time & Date (Not Enabled, Not Pausable)**

#### CONDITIONS

Always True

Comment:

#### TRUE ACTIONS

DB Capture, Field: 3, Capture Type: TIMEDATE, Scale: SCALE1, Index: 1, Slot: 1, Bit: 1

Comment: Store Time & Date in Database

DB Read, Field: 3

Comment: Read Time & Date into Variable

User Set Print Text, Tag: 3, Type: TIMEDATE

Comment: Transfer Time & Date to Print String

Deactivate Step, Step Number: 9

Comment: Deactivate this step when it is completed.

Activate Step, Step Number: 10

Comment: Activate the next step.

#### FALSE ACTIONS

#### PAUSE ACTIONS

### **STEP 10: Print Weight (Not Enabled, Not Pausable)**

#### CONDITIONS

Always True

Comment:

#### TRUE ACTIONS

Print, Format: 1

Comment: Print Auxiliary Format # 1

Deactivate Step, Step Number: 10

Comment: Deactivate this step when it is completed.

## Net Fill with Pause-Restore-Reset

---

Activate Step, Step Number: 3

Comment: Loop Back to Step 3 (Start)

### FALSE ACTIONS

### PAUSE ACTIONS

### **STEP 11: Pause (Enabled, Not Pausable)**

#### CONDITIONS

User Key Compare, Key Number: 3

Comment: Pause Key Pressed?

#### TRUE ACTIONS

DB Prompt, Slot: 0, Index: 2, Field: 6

Comment: Put "Paused" on the Display

Pause Process

Comment: Pause the Process

### FALSE ACTIONS

### PAUSE ACTIONS

### **STEP 12: Restore (Enabled, Not Pausable)**

#### CONDITIONS

User Key Compare, Key Number: 4

Comment: Restore Key Pressed?

#### TRUE ACTIONS

Restore Process

Comment: Restore the Process

### FALSE ACTIONS

### PAUSE ACTIONS

### **STEP 13: Reset (Enabled, Not Pausable)**

#### CONDITIONS

User Key Compare, Key Number: 5

Comment: Reset Key Pressed?

#### TRUE ACTIONS

Reset Process

Comment: Reset the Process

Activate Step, Step Number: 1

Comment:

Activate Step, Step Number: 3

Comment:

### FALSE ACTIONS

## Net Fill with Pause-Restore-Reset

---

### PAUSE ACTIONS