

① SCAN BARCODE  
② PRESS **RUN** IN THE PROFACE HMI

③ PLC SENDS  
↳ POS = 102     102.1 → 1  
↳ BIT = 1  
↳ VALUE = 1

④ WHEN **BIT = 1**, PLC AUTO STARTS.  
CONVEYOR STARTS

⑤ PLC SENDS  
↳ POS = 102     102.0 → 1  
↳ BIT = 0  
↳ VALUE ≠ 1

⑥ WHEN **BIT = 0**, C# PROGRAM PRINTS

⑦ C# PROGRAM CHECKS CAM 1

⑧ C# PROGRAM COMPARES CAM 1 ↔ QR DATA

⑨ IF **NG**  
PROGRAM SENDS  
↳ POS = 0  
↳ BIT = 1  
↳ VALUE = 1

IF **OK**  
PROGRAM SENDS  
↳ POS = 0  
↳ BIT = 3  
↳ VALUE = 1

⑩ C# PROGRAM CHECKS CAM 2 ↔ BARCODE & QR CODE DATA

⑪ C# PROGRAM COMPARES CAM 2  
IF **NG**  
C# PROGRAM SENDS  
↳ POS = 1  
↳ BIT = 2  
↳ VALUE = 1

IF **OK**  
C# PROGRAM SENDS  
↳ POS = 1  
↳ BIT = 1  
↳ VALUE = 1

⑫ PROGRAM COUNTS UNTIL FINISH OF **LOT**  
END LOT.

↳ POS = 0  
↳ BIT = 10  
↳ VALUE = 1

⑬ SAVE REPORT