

APPLICATION SOLUTION CUB5 #03

DAILY / WEEKLY PART COUNTER APPLICATION

An engine manufacturer wants a cost effective solution to keep a daily and a running weekly tally of the number of engines produced on their assembly lines. The operators will record their tally and reset their counter at the end of each day. The supervisor will compare the operators' weekly total against the total on the counter. The supervisor will be the only one that can reset the weekly counter total. This should keep the operators' daily records in agreement with the supervisors' weekly figures.

PRODUCTS USED: CUB5B000, MLPS1000, RRDC 0000, PKS1000

The CUB5B000 was chosen for the low cost and dual counter feature. The MLPS1000 power supply can be attached to the back of the CUB5, if no DC power is available. Also, included in the system are the RRDC0000 photo-electric sensor and the PKS1000 key switch.

HOW IT WORKS

The photo-electric sensor, located at the end of the assembly line, increments the CUB5 as the assembled engines pass. The CUB5 is programmed for dual count; Count A is for the daily count and Count B is for the weekly total. At the end of each shift, the daily count is recorded from Counter A display and reset via the front panel push-button. Weekly totals are recorded from Counter B display at the end of Friday's shift. An external key-switch is utilized to reset Counter B via the user input, which prevents reset by the operators.

DESIGN ADVANTAGES

Having both counts on the same counter has resolved the difference between what the operators are reporting and what the supervisors are reporting. This has improved personnel relationships, productivity and inventory accuracy. The key switch and the programming security code keep the weekly tally and counter program safe.

ADDITIONAL CAPABILITIES

The CUB5 could be programmed to show engines per minute of each line. Option cards could be added to the CUB5 for serial communications to a data collection system, large display or PC configuring software. A relay card could be added to turn on a light to indicate that the day's goal has been exceeded.

DIP SWITCH OR JUMPER SETTINGS

All are at factory settings.

PROGRAMMING (Only nonfactory settings shown)

1-INPUT

INP A-b : dUAL Cnt
USER INP : rESEt
USER ASN : Count b

2-rAtE

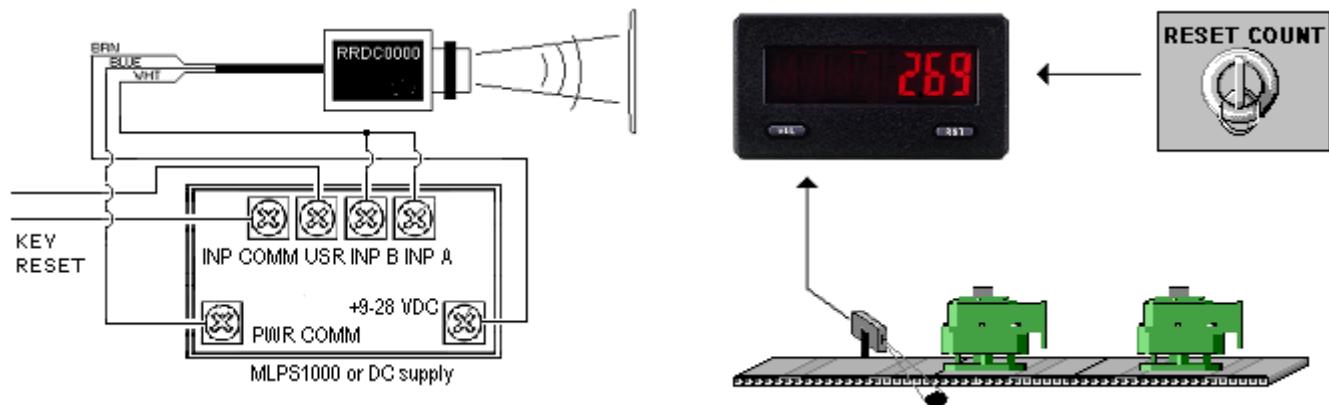
RAtE Enb : NO

3-dSPLAY

RSt Enb : Count A
Pro Code : xxxx

WIRING DIAGRAM

All wiring must be according to the installation guidelines listed in the product's specifications.



This application note is intended to be an example. Your specific application may require changes in products, programming and/or wiring. For specific assistance, you may contact your local Red Lion products supplier or Red Lion Controls Technical Support at 717-767-9511.