



PCEE for 720i

PCEE Webinar Overview



- Part 1 – General 720i and PCEE Information
- Part 2 – Batching Example (Fill/Dump)
- Part 3 – Label Printing Example
- Part 4 – Laserlight Messaging Example
- Part 5 – Axle Weighing Example



Part 1

General 720i and PCEE information

Software



- Revolution III for 720i (sets up configuration, softkeys, digital inputs and outputs) file.rev extension
- Proaction PCEE (sets up conditions/actions) file.pcee extension
- Proaction DBE (database storage only) file.dbe extension
- There are up to three files that all need to be downloaded separately in the order above.

Conditions & Actions



- 720i constantly checks all the conditions of enabled steps
- True and False and Paused Actions for each condition
- Steps can be enabled or disabled
- See list of all Conditions and Actions ([link](#))

Definitions



- Integer, String, Real types
- Registers (1-128 store integers, 129-256 store reals)
- Databases



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Questions?

**Call Kristi Gay @ 715-234-9171 ext 5223
kgay@ricelake.com**



Part 2

Batching Example

Revolution III



- Add User Keys and name them
 - F1 = Target Wt
 - F2 = Start
 - F3 = Pause
 - F4 = Restart
 - F5 = Abort
- Set up Digital Outputs (1 = Fill, 2 = Dump)
- Set up Print Format (Auxillary Format #1)
 - User String 1 for Net Weight
- Download to 720i (Options to check COM/Baud)

DBE (Database Editor)



- Add Trans database
(Stored net weight after each fill)
 - Net field
 - TimeDate field
- Add Prompts database
(Stored strings to make program user-friendly)
 - One record
 - One field per prompt (Start or Target, Filling, Dumping, In Motion, Enter Target)
- Download Schema first, then data

PCEE (Adding Steps)



- Add Steps
 - Note if Auto-Sequence is checked
- Go back and set ID for Set User Compare Last
- Add comments
- Test

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Part 3

Label Printing Example

Revolution III



- Add User Keys and name them
 - F1= Data
- Set up Print Format (Auxillary Format #1)
 - Set up label with Labelview
 - User String 1 = Part Number
 - User String 2 = Product Name
 - User String 3 = Job Number
 - User String 4 = Gross weight for barcode
- Download to 720i (Options to check COM/Baud)

DBE (Database Editor)



- Add Prompts database
(Stored strings to make program user-friendly)
 - One record
 - One field per prompt (Enter Data to Print, Enter Part #, Enter Prod Name, Enter Job #)
- Download Schema first, then data

PCEE (Adding Steps)



- Add Steps
 - Note if Auto-Sequence is checked
- Add comments
- Test



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Part 4

Laserlight Messaging Example

Revolution III



- Add User Keys and name them
 - F1 = Drive On
 - F2 = Come In
 - F3 = Printed
 - F4 = Exit
 - F5 = Spare Msg
 - F6 = Enter Msg
- Set up Print Format (Auxillary Format #1)
 - User String 1 is the message (see pg 22 of Laserlight manual for format)
- Download to 720i (Options to check COM/Baud)

DBE (Database Editor)



- Add Prompts database
(Stored strings to make program user-friendly)
 - One record
 - One field per prompt (Drive On, Come In Office, Ticket Printed, Exit Scale, Enter Spare)
- Add Spare database
(Stored message that user can configure)
 - One record, one field
- Download Schema first, then data

PCEE (Adding Steps)



- Add Steps
 - Print Aux1 each time you change the message that scrolls the message 100 times (see pg 22 of laserlight manual)
 - Save User-Entered message in Spare database
- Add comments
- Test

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Part 5

Axle Weighing Example

Revolution III



- Add Traffic Lights (Green = Bit 1, Red = Bit 20)
- Set up Print Format (Auxillary Format #1)
 - User String 1 – 3 are axle weights, 4 is total
- Download to 720i (Options to check COM/Baud)

DBE (Database Editor)



- Add Total database
(Stored strings to make program user-friendly)
 - One record
 - One field for the total (total gross on the scale after each axle)
- Download Schema only

PCEE (Adding Steps)



- Add Steps
 - After threshold is met wait for standstill and store Axle 1
 - Wait for standstill again after increasing the weight 500 lbs or more before storing Axles 2 and 3
 - Print ticket
 - Wait for truck to leave scale
- Add comments
- Test



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