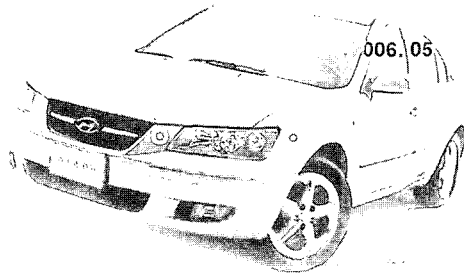


RFID 를 이용한 품질정보 사례발표 (PL법 대응)



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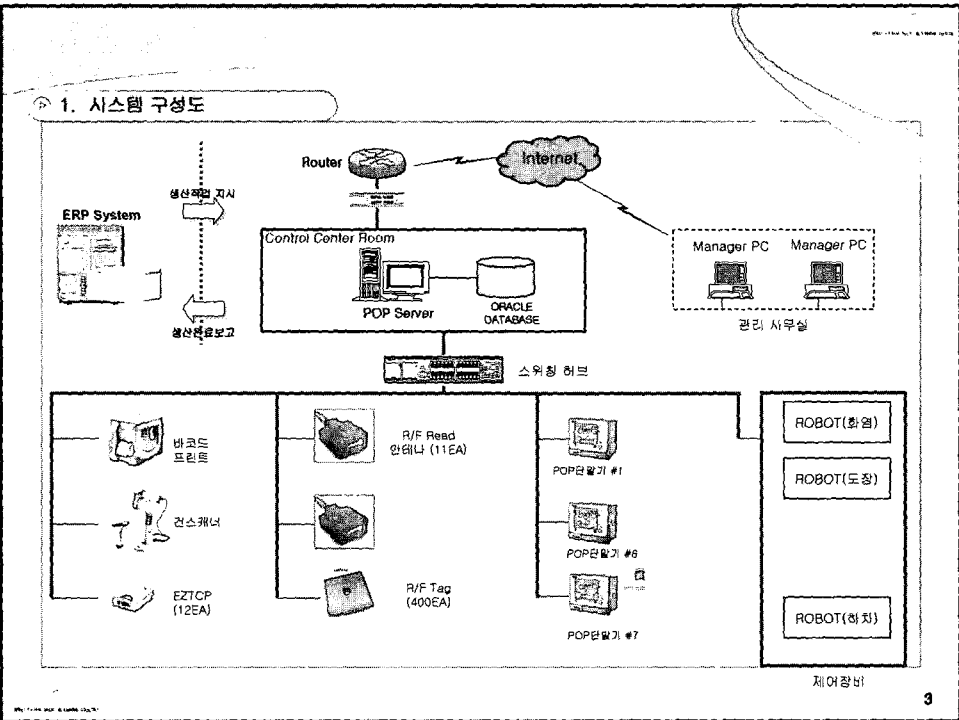
1. 시스템 구성도

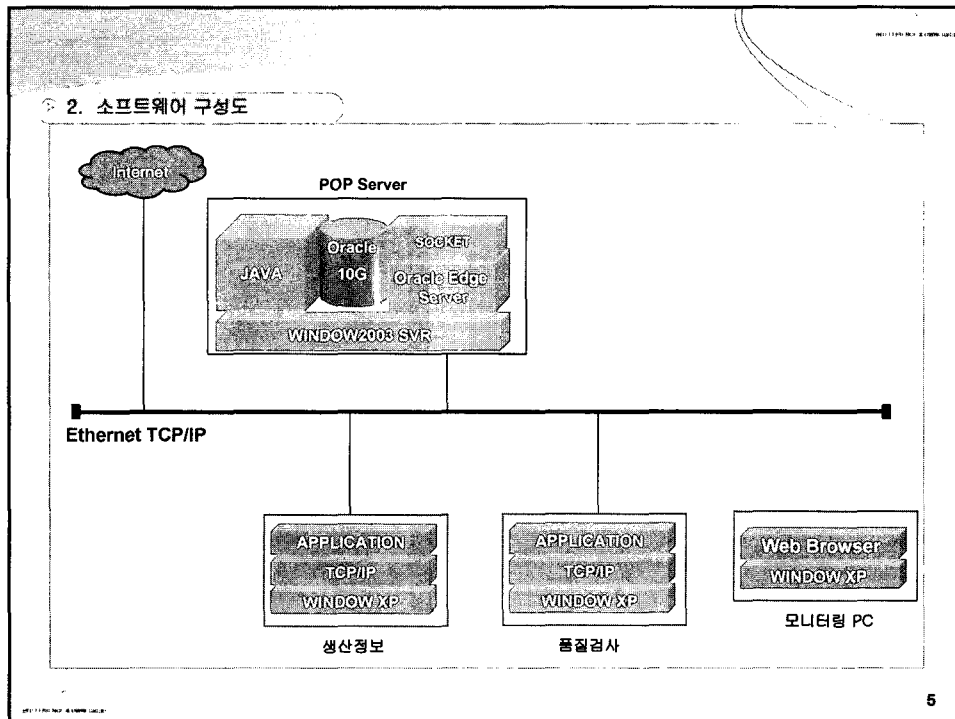
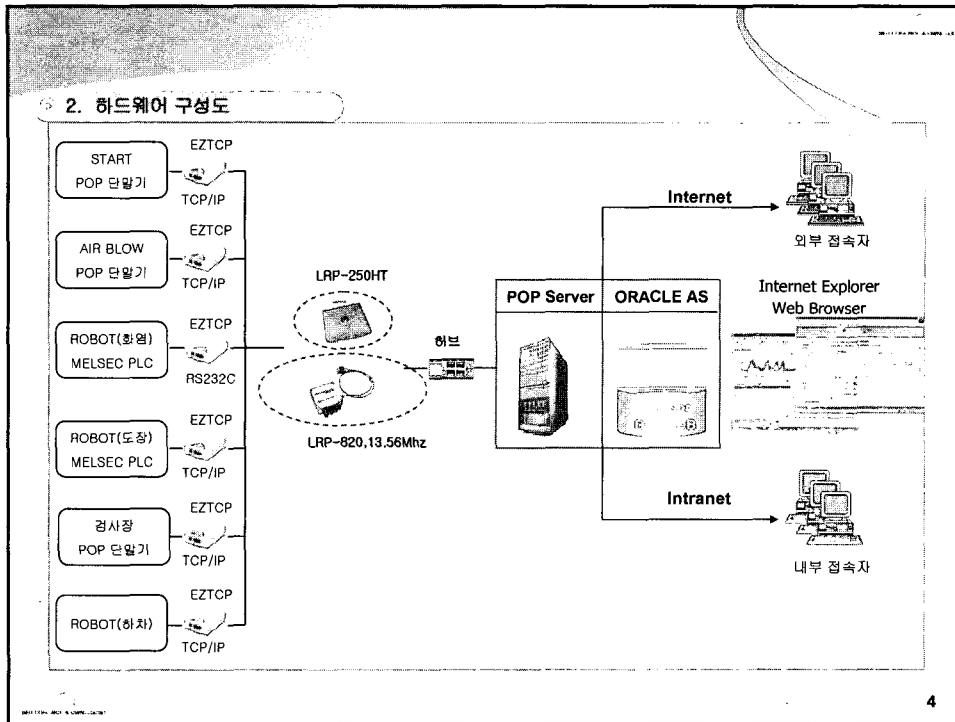
1. 시스템 구성도

2. 하드웨어 구성도

3. 소프트웨어 구성도

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II. 시스템 구현방안

1. 시스템 장비 Layout 및 장비설치

2. 프로세스 구성도

3. Application 구성도

4. 도입 전.후 비교

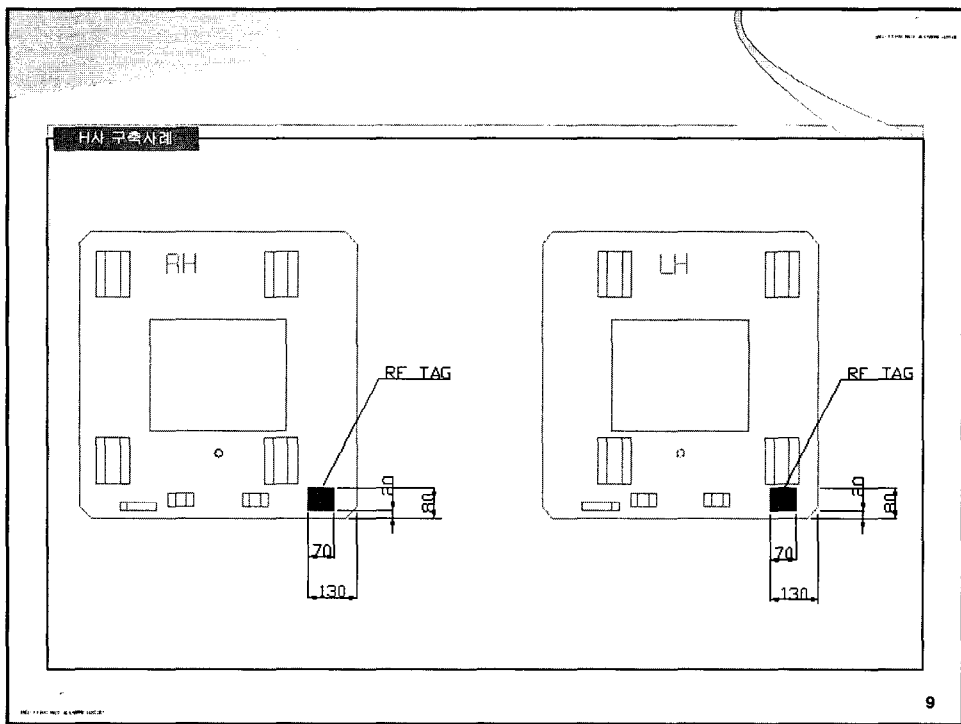
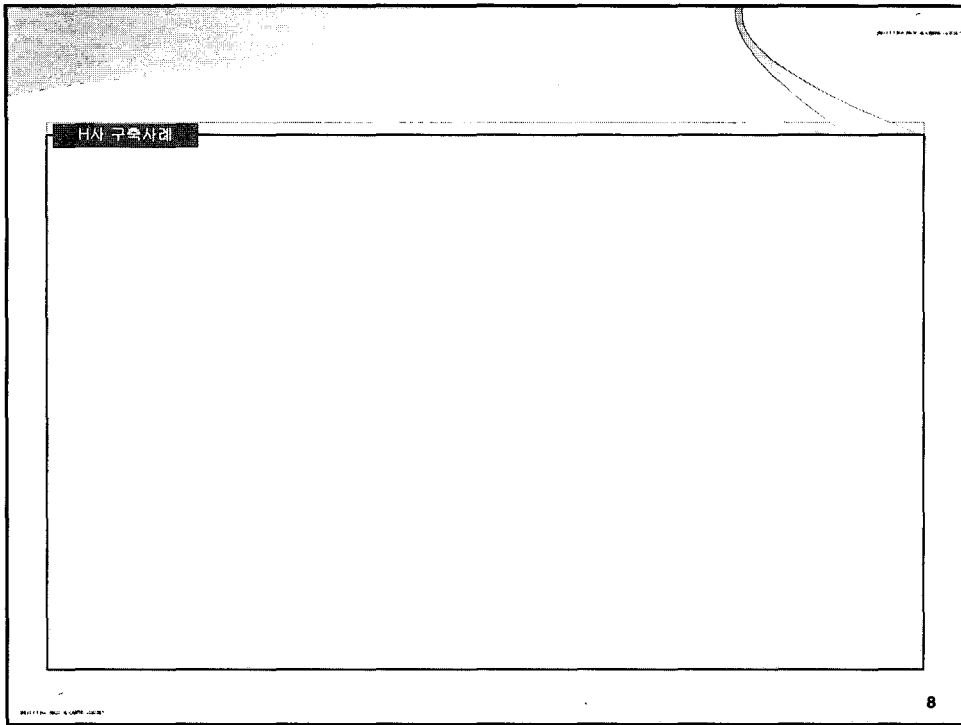
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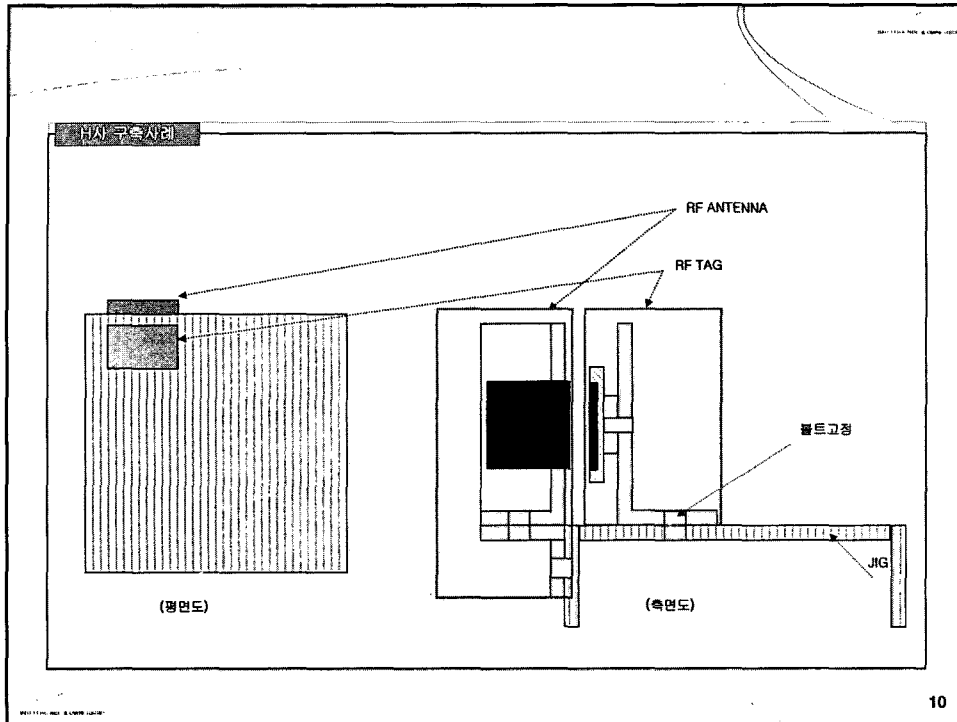
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1. 시스템 장비 Layout 및 장비 설치

○ 사

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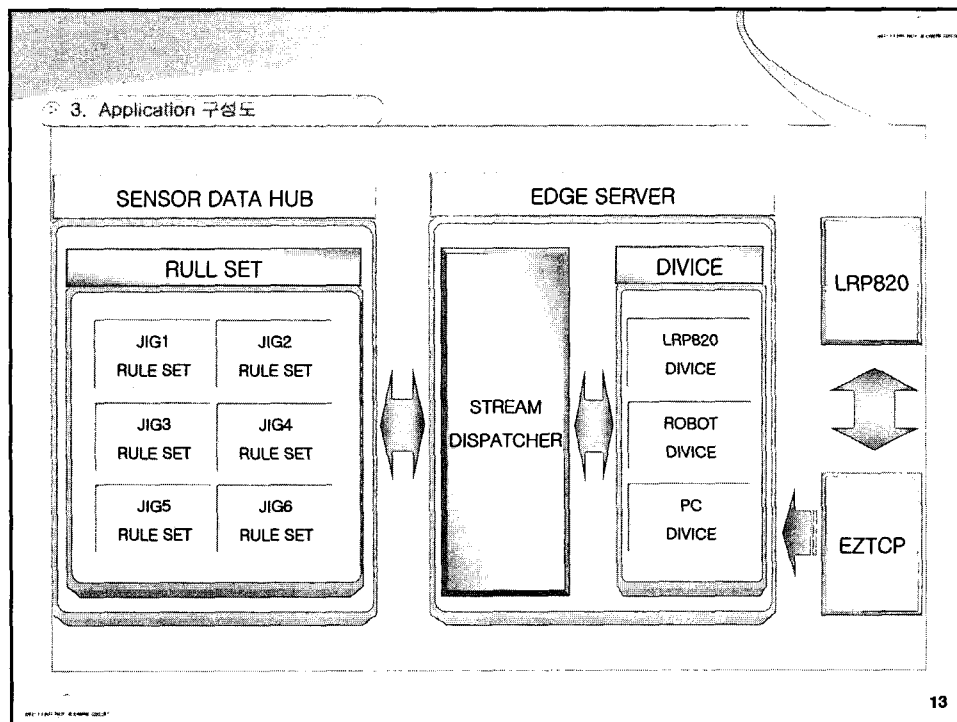
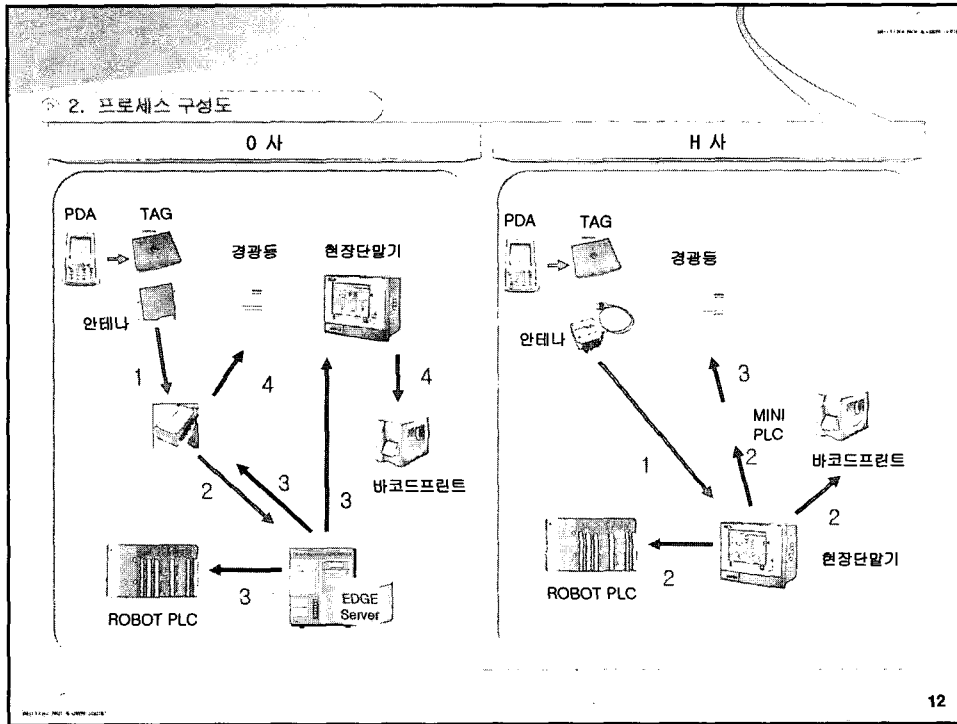




장비비교

비교	HMS820-05(HMS150)	LRP820-08(LRP250 HT)
제품		
전기	Supply Voltage : 18-30VDC Current : 270mA@24VDC	Supply Voltage : 18-30VDC Current : 31W (1.3A @ 24Vdc)
특징	<ul style="list-style-type: none"> Host Interface (COM1):RS232/RS422/Mux32 Auxiliary RS232 Serial Port 1000 Bytes/Second Data Transfer Speed Passive Tag, Requires No Batteries 	<ul style="list-style-type: none"> COM1 RS232 RS422 Mux32 Bus Interfaces: Mux32 Auxiliary RS232 Serial Port 1200 Bytes/Second Data Transfer Speed Passive Tag, Requires No Batteries
메모리	60KB Program Memory (System + User) 20KB Data Read/Write Memory (Flat) Tag Memory : 736 Bytes	60KB Program Memory (System) 16KB Data Read/Write Memory 96KB Paged Data Read/Write Memory (32KB x 3) Tag Memory : 48 Bytes
인식거리	(inches/mm) Typical Range : 1.38/35 Guaranteed Operating Range : 1.10/28	(inches/mm) Typical Range : 17.00/432 Guaranteed Operating Range : 15.00/381
운영환경	Operating Temperature : -20° to 49° C Storage Temperature : -40° to 85° C	-40° to 200° F (-40° to 93° C) -40° to 392° F (-40° to 200° C)

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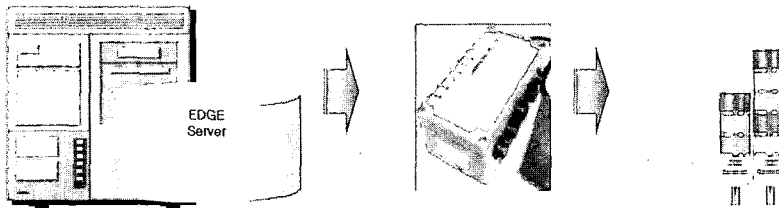


RULE SET - 경광등 예제

```

if edge_car <> w_popcar or edge_car <> '99' then ← 대차의 차종이 작업지시랑 틀린경우
myEvent := EDG_EVENT(200, 1, '01', 'MySite', 'JIG01', 'aa100001ffff', SYSDATE, NULL, 'SP_JIG01');
← JIG01이라는 Device를 이용하여 LRP820 컨트롤러에 SetOut A에 접점을 주는 명령어를 보냄
DBMS_AQ.ENQUEUE
(
  QUEUE_NAME => 'edge.edg_instr_in_q', ENQUEUE_OPTIONS => eopt,
  MESSAGE_PROPERTIES => mprop, PAYLOAD => myEvent,
  MSGID => queue_msg_id
);

```



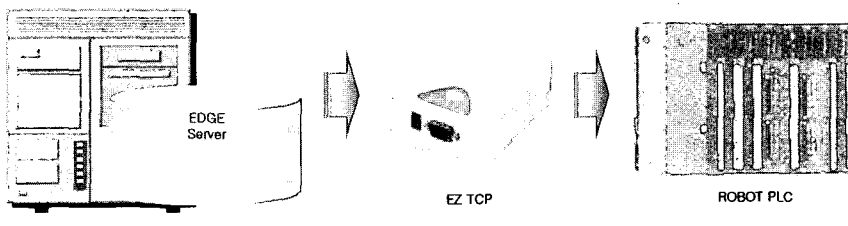
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DEVICE(로버트 예제)

```

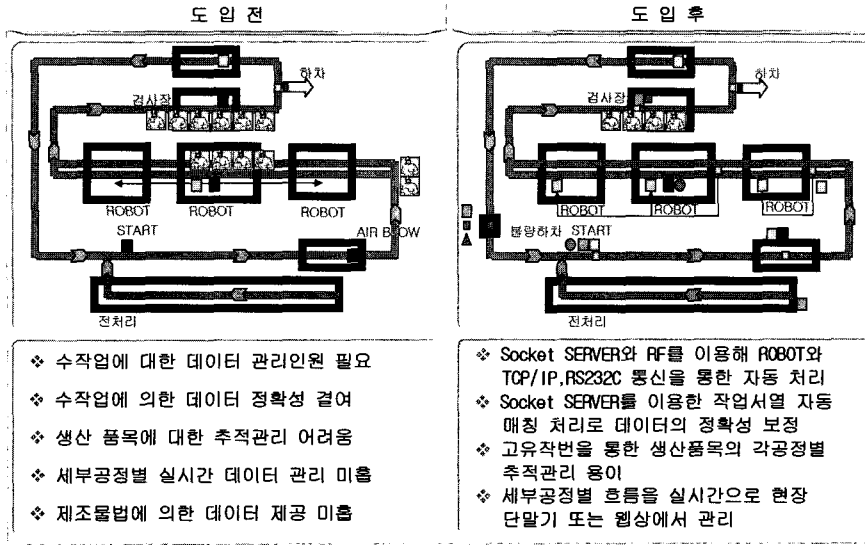
m_count = 0;
startSocket(); ←PLC 소켓서버에 접속을 하기 위해서 소켓 클라이언트 실행
m_count = m_count + 1;
System.out.println(m_DeviceName + " Send " + m_count + "회 시도 =>" + event.getData());
String cmd = event.getData();
out.println(cmd); ←PLC 소켓서버쪽으로 SDH에서 만들어진 Data를 전송
m_Send = true;

```

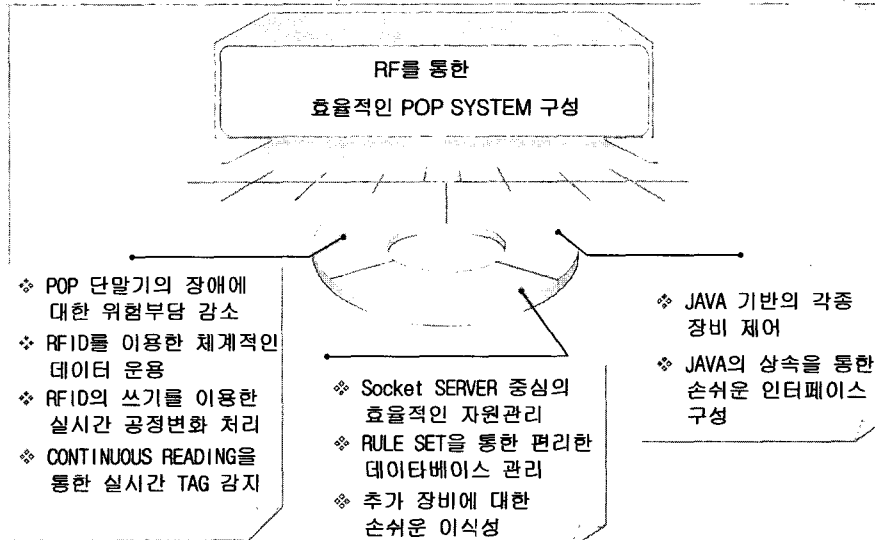


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4. 도입 전·후 비교



5. 도입효과



Q & A

감사합니다!

Question & Answer