



ISC PEM NETWORK COMMUNICATION DATA INTERFACE

COMMUNICATION PROTOCOL

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Address	Unit	ISC TO LINE	LINE TO ISC
0.0.0	Bit	Heartbeat	Heartbeat
0.0.1	Bit	System Ready	Motor running
0.0.2	Bit	Belt moving	Enable Transport mode
0.0.3	Bit	System error /fault	Fault Reset Command
0.0.4	Bit	System warning	Reset internal mode recipe
0.0.5	Bit	System ready for next product	Spare
0.0.6	Bit	System ready for next product destination	Run mode internal
0.0.7	Bit	Cleared products from system	Clear products from system
1.0.0	Bit	Induct successful	Next product destination (product control)
1.0.1	Bit	Divert successful	Product destination change (product control)
1.0.2	Bit	Gap too small	Spare
1.0.3	Bit	Product destination change successful	Spare
1.0.4	Bit	Spare	Spare
1.0.5	Bit	Spare	Spare
1.0.6	Bit	Spare	Spare
1.0.7	Bit	Spare	Spare
1.1.0	Bit	Spare	Reset destination (destination control)
1.1.1	Bit	Force destination ACK	Force destination (destination control)
1.1.2	Bit	Unforce destination ACK	Unforce destination (destination control)
1.1.3	Bit	Enable destination ACK	Enable destination (destination control)
1.1.4	Bit	Disable destination ACK	Disable destination (destination control)
1.1.5	Bit	Spare	Spare
1.1.6	Bit	Spare	Spare
1.1.7	Bit	Spare	Spare
2.0.0	Word	ProductID	ProductID
3.0.0	Word	DestinationID	DestinationID
4.0.0	Byte	Fault unique identifier	Spare
4.1.0	Byte	Subsystem at fault	Spare
5.0.0	Byte	Belt speed (Meters Per Minute)	Spare
5.1.0	Byte	Machine utilization (%)	Spare
6.0.0	Word	Throughput (Products Per Hour)	DestinationID (destination control)
7.0.0	DWord	Total Inducted Products	Spare
6.0.0	DWord	Total Sorted	Spare
11.0.0	DWord	Total Packages with Gap Error	Spare
13.0.0	Word	Total destination not Available	Spare
14.0.0	Word	Total Instructed to Off End	Spare
15.0.0	Byte	Spare	Spare
26.0.0	Byte	Spare	Spare
27.0.0	Byte	Parameter Group	Parameter Group
28.0.0	Bit	Parameter read ACK	Set parameter read
28.0.1	Bit	Parameter write ACK	Set parameter write
28.0.2	Bit	Parameter type ACK	Spare
28.0.3	Bit	Parameter value format ACK	Spare
28.0.4	Bit	Spare	Spare
28.0.5	Bit	Spare	Spare
28.0.6	Bit	Spare	Spare
28.0.7	Bit	Spare	Spare
29.0.0	Word	Parameter ID	Parameter ID
30.0.0	Word	Parameter value LSW	Parameter value LSW
31.0.0	Word	Parameter value MSW	Parameter value MSW