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\*\*\*\*\* Hole Drilling Station Control \*\*\*\*\*

Additional internal memory:

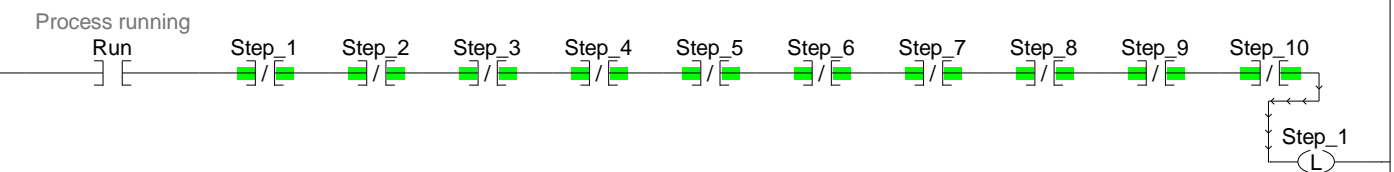
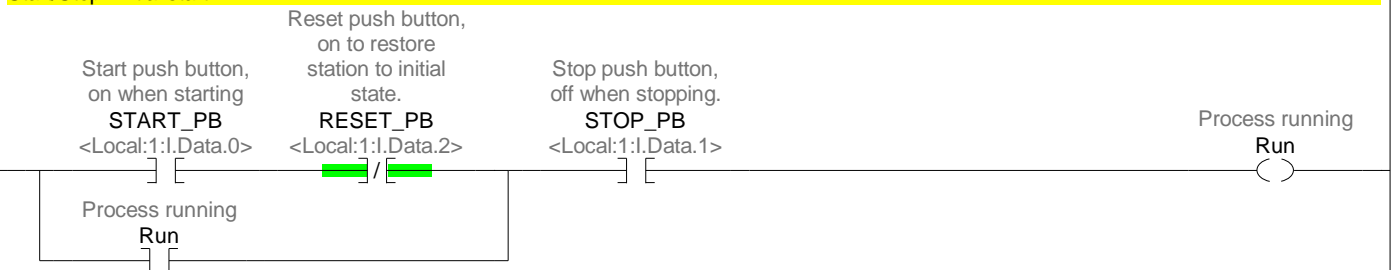
Tag	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Step_1 to Step_10	BOOL	Step-in-progress bits
Clamp_Tmr	TIMER	Times clamping
Pause_Tmr	TIMER	Times pause during drilling
Reset_Tmr	TIMER	Times retract of YCYL when reset

Conversion formulas

$X\_VAL = (X\_MEAS/100) * (300-150) + 150$

$Y\_VAL = (Y\_MEAS/100) * (110-0) + 0$

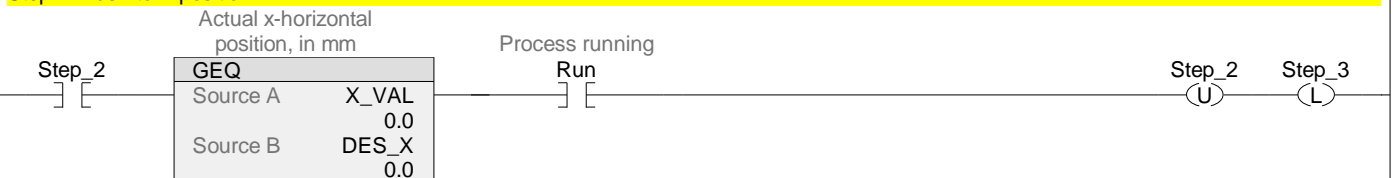
Start/Stop. Initial start

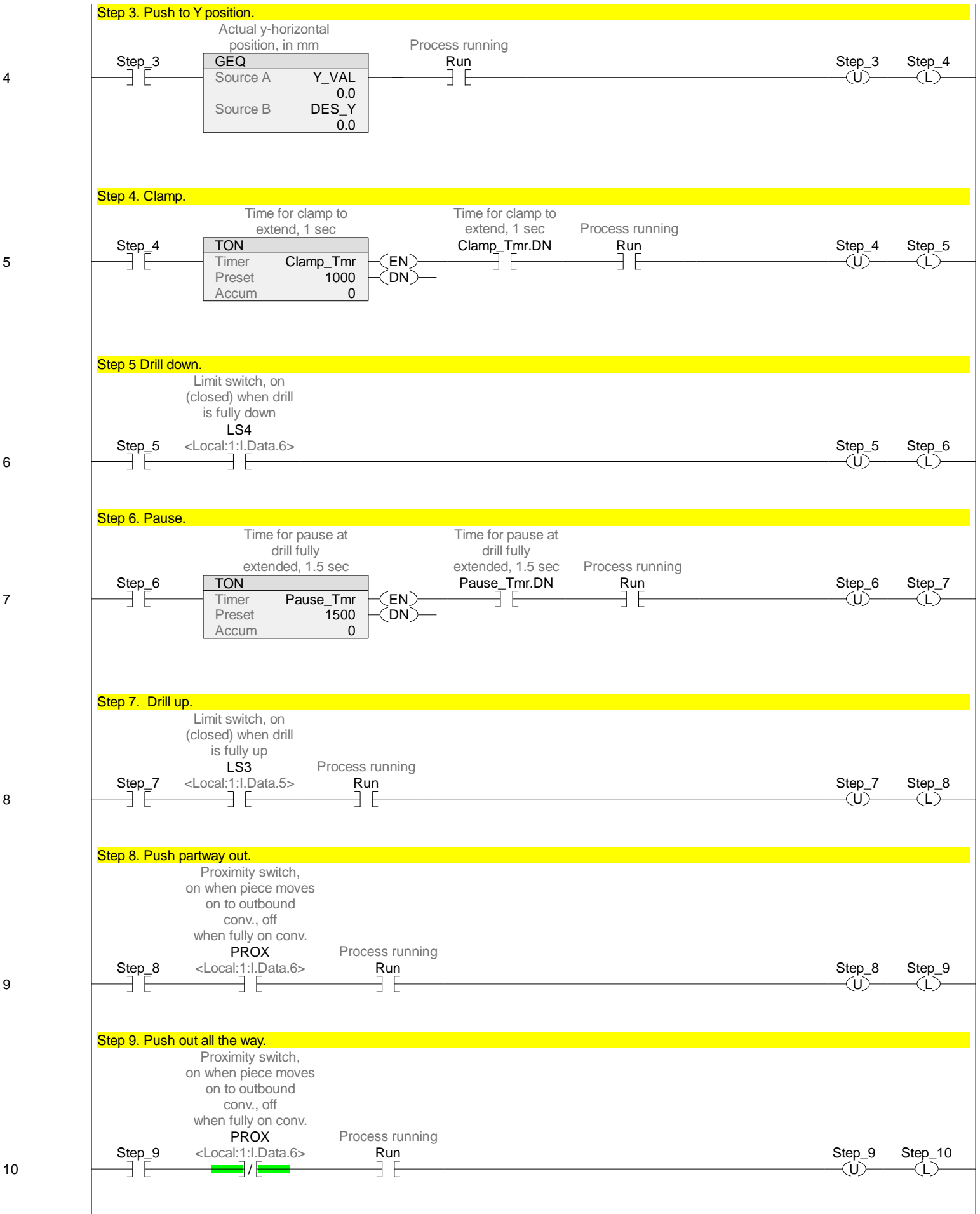


Step 1. Wait for piece.

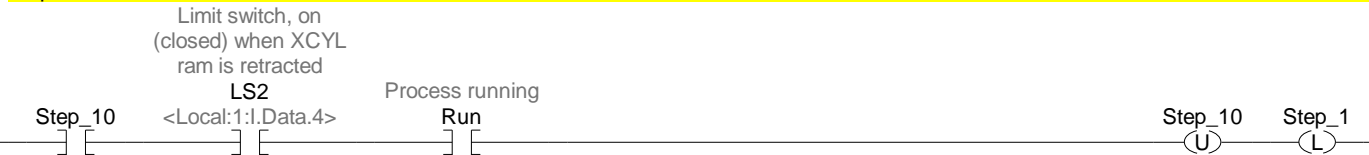


Step 2. Push to X position.



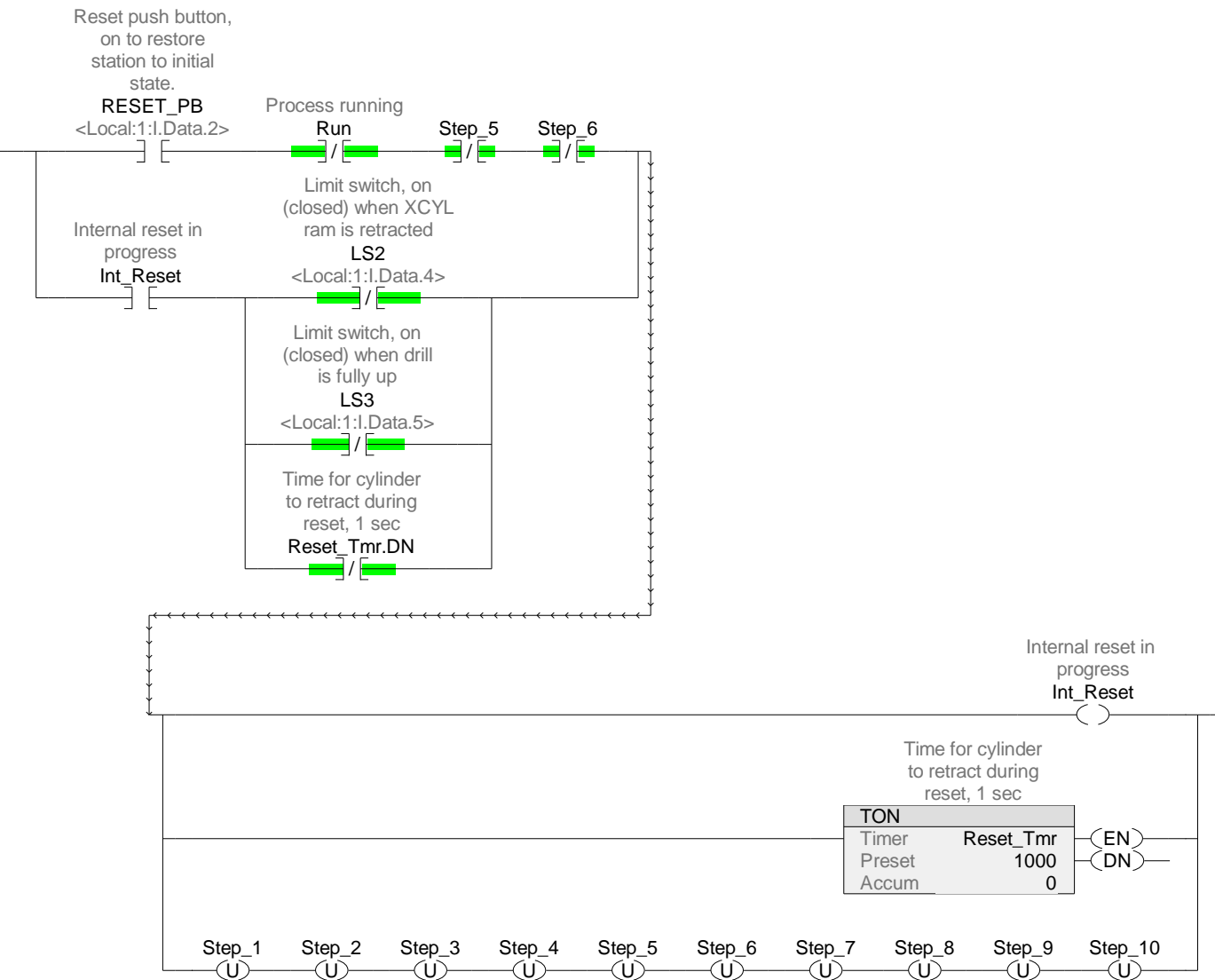


Step 10. Retract XCYL.



Reset

Ignore reset in steps 5 and 6  
Maintain until drill up and both cylinders retracted.



\*\*\*\*\* Outputs \*\*\*\*\*

Conveyor Control.



