

Main

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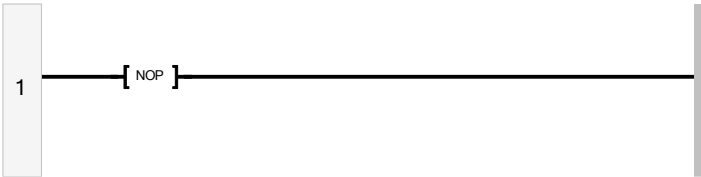
Rung1 Diagram

SP6-4 Bag Sealing Station

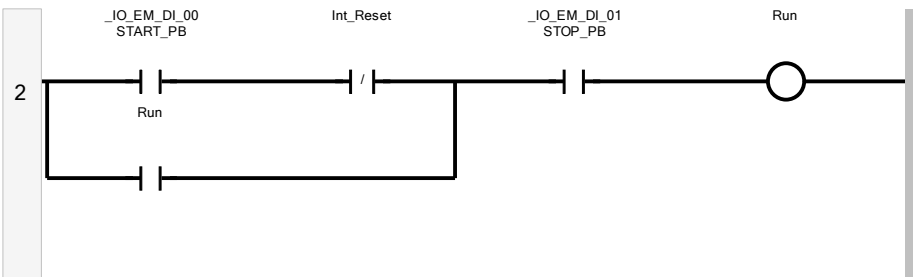
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Additional internal memory:

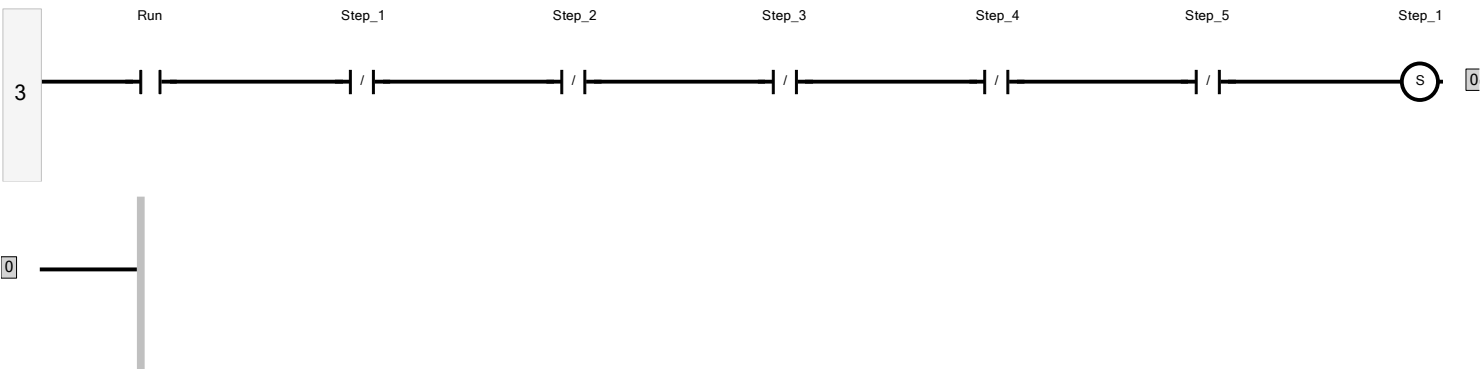
Tag	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Step_1 to Step_5	BOOL	Step-in-progress bits
Seal_Tmr	TON	Sealing bag timer



Rung2 Diagram

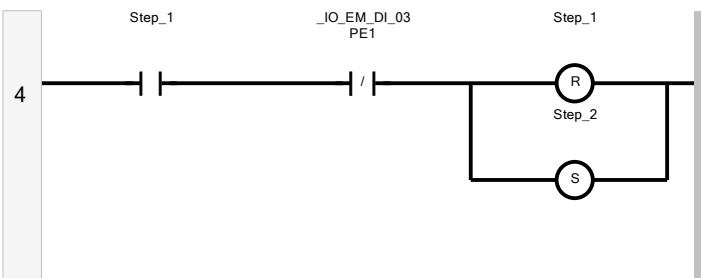


Rung3 Diagram



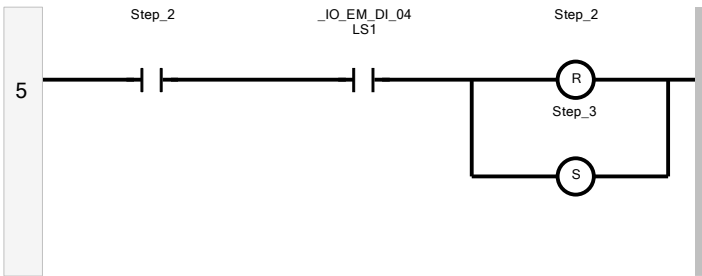
Rung4 Diagram

Step 1 - Move bag in



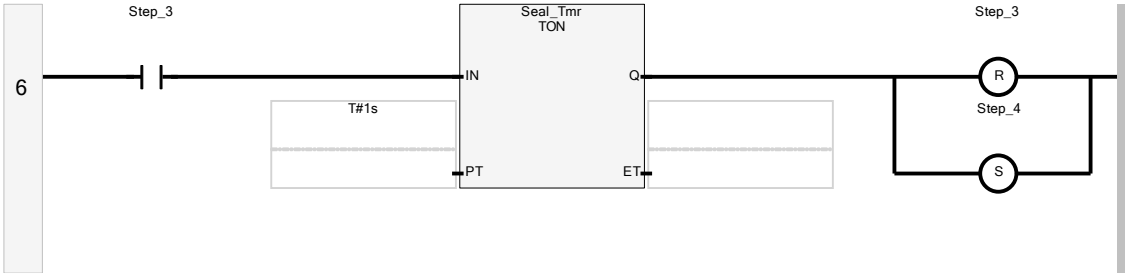
Rung5 Diagram

Step 2 - Move bars in



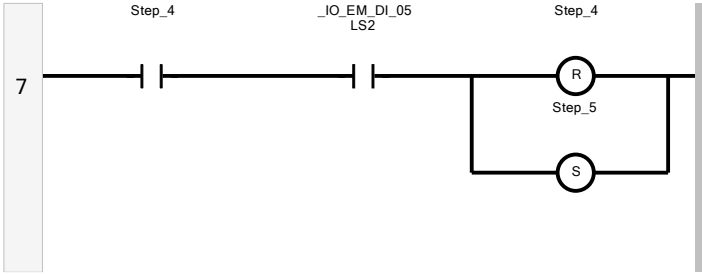
Rung6 Diagram

Step_3 - Extend Ram



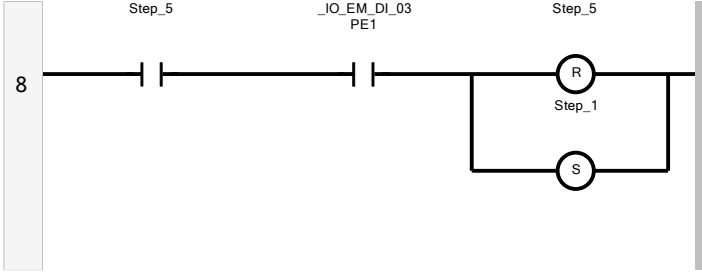
Rung7 Diagram

Step 4 - Move bars out



Rung8 Diagram

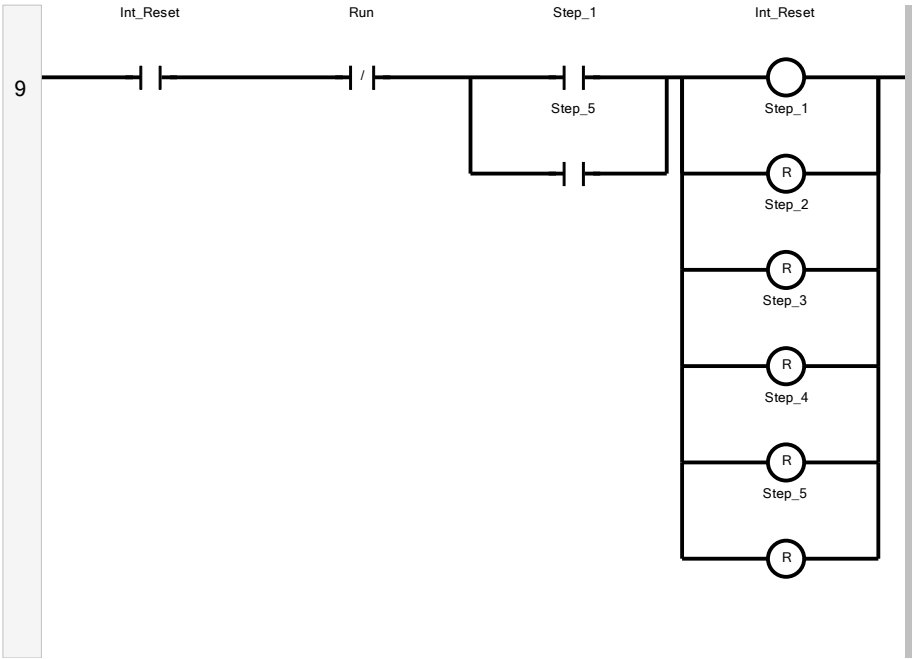
Step 5 - Move bag out



Rung9 Diagram

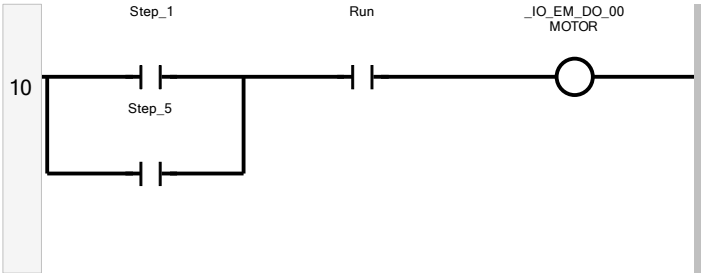
Reset

Only allowed in steps 1 and 5



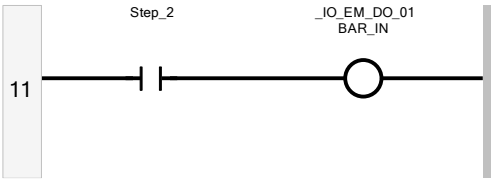
Rung10 Diagram

Physical Outputs



Rung11 Diagram

Roll conveyor control



Rung12 Diagram

Gate 1 cylinder control

