

Main

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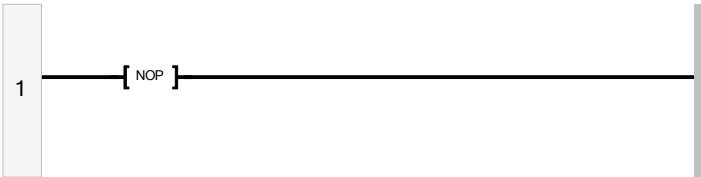
Rung1 Diagram

SP7-6 Weigh Scale Station Control

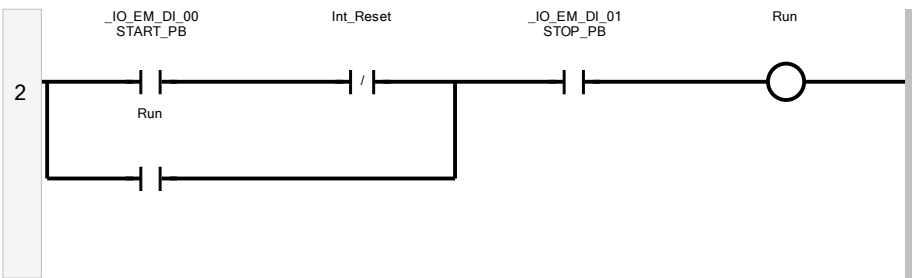
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Additional internal memory:

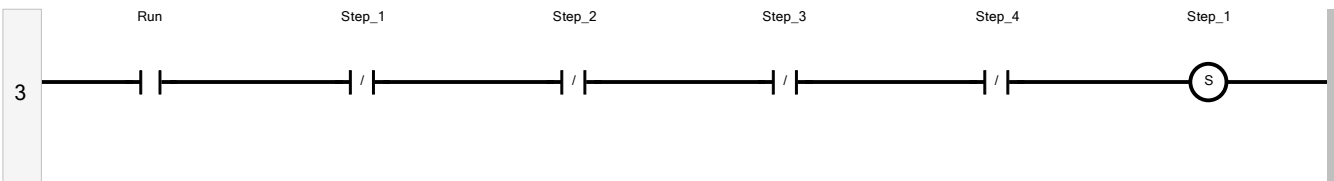
Tag	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Step_1 to Step_4	BOOL	Step-in-progress bits
Stab_Tmr	TON	Delay for weight to stabilize
MoveOut_Tmr	TON	Delay for detecting pallet gone
Temp	REAL	For measurement conversion



Rung2 Diagram

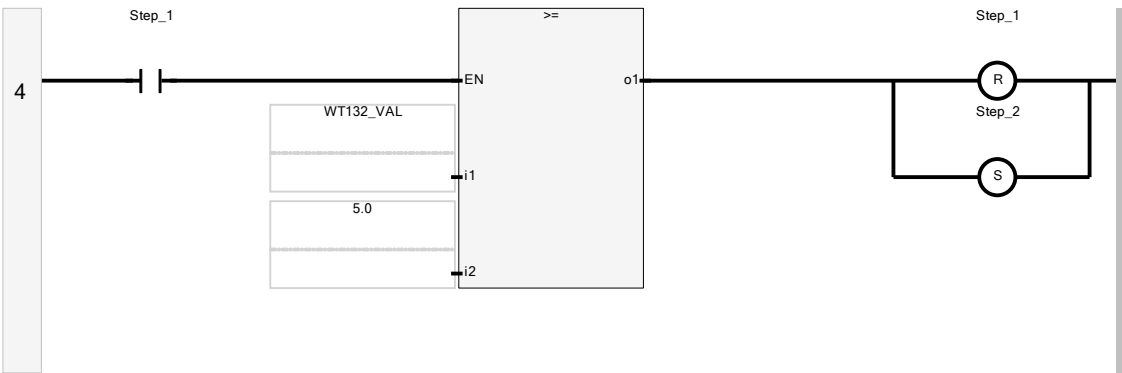


Rung3 Diagram



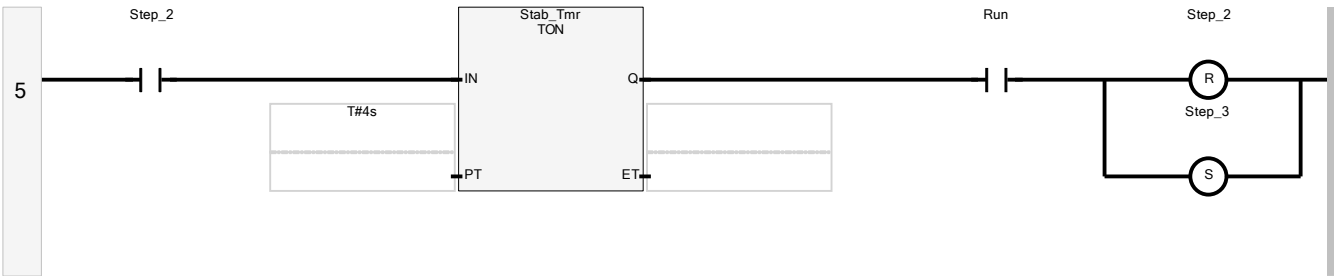
Rung4 Diagram

Step 1 - Move in.

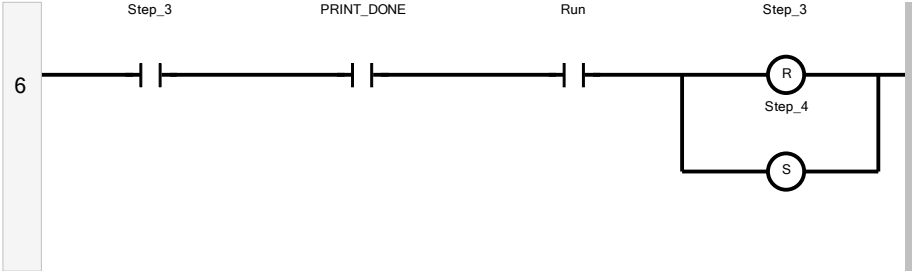


Rung5 Diagram

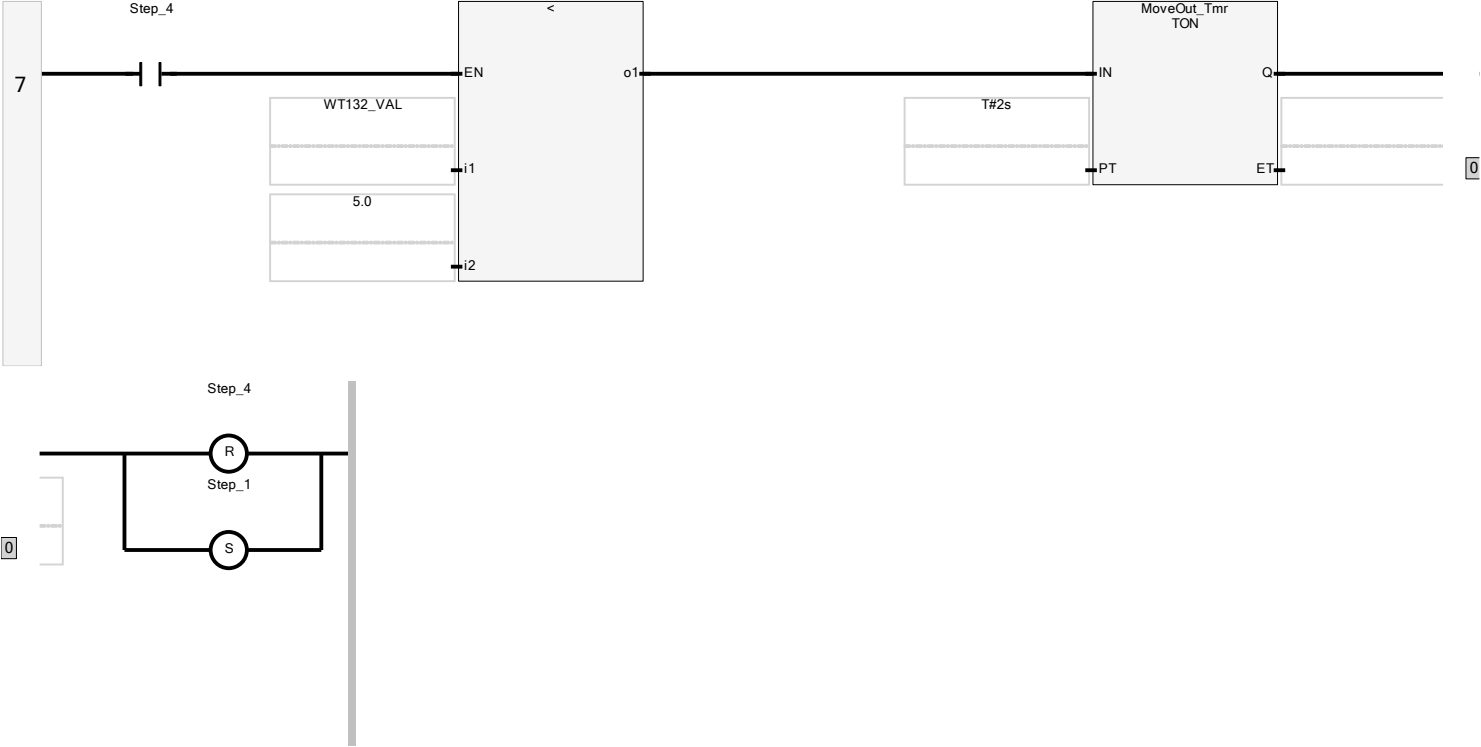
Step 2 - Delay for weight to stabilize



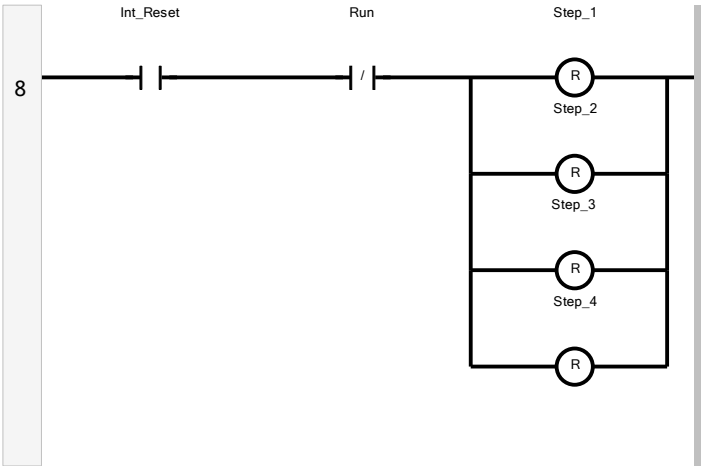
Rung6 Diagram
Step_3 - Print weight



Rung7 Diagram
Step 4 - Move out

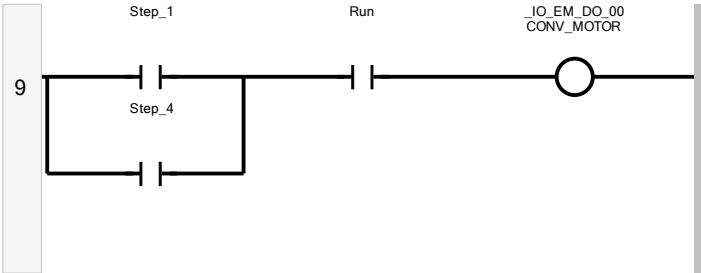


Rung8 Diagram
Reset



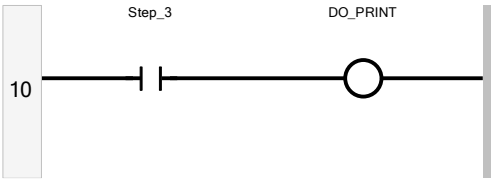
Rung9 Diagram

Physical Outputs



Rung10 Diagram

Print start command



Rung11 Diagram

Conversion of Weight measurement

