

## Main

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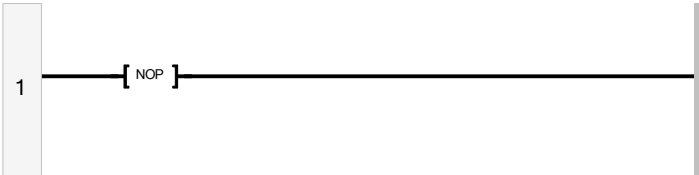
Main

Rung1 Diagram

SP7-8 Stamping Station Control Copyright (c) 2023, Dogwood Valley Press, LLC

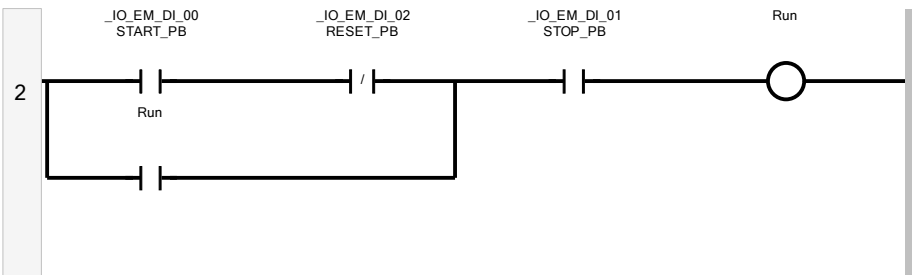
Additional internal memory:

Tag	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Step_1 to Step_8	BOOL	Step-in-progress bits
Ram_Up_Tmr	RTO	Times raising of stamp head
Retract_Tmr	TON	Times retract of PCYL2
Rst_Tmr	TON	Times raising of stamp head when reset
Temp	REAL	For measurement conversion

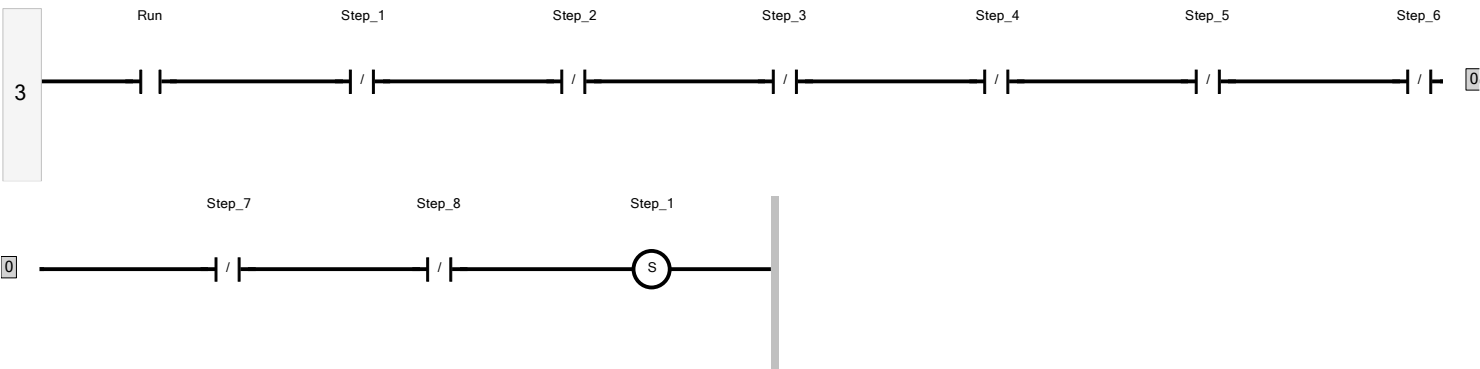


Rung2 Diagram

Start/stop and initial start

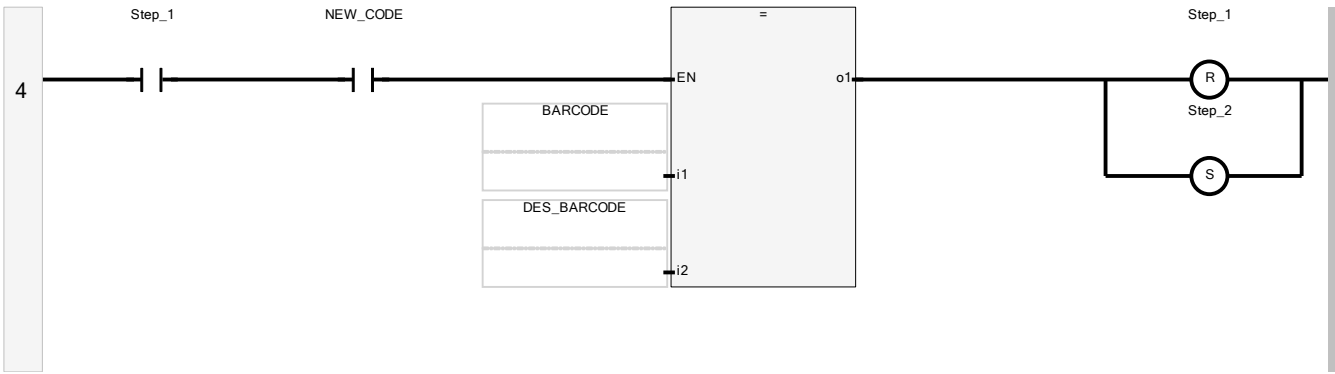


Rung3 Diagram



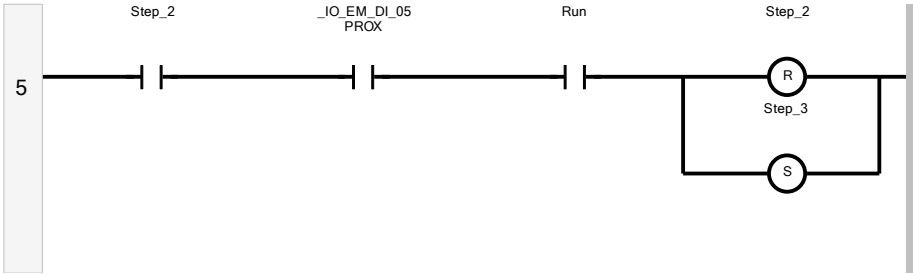
Rung4 Diagram

Step 1 - Wait for correct code



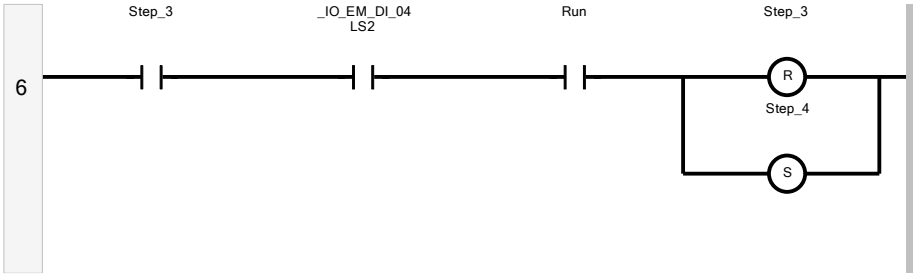
Rung5 Diagram

Step 2 - Wait for piece in position.



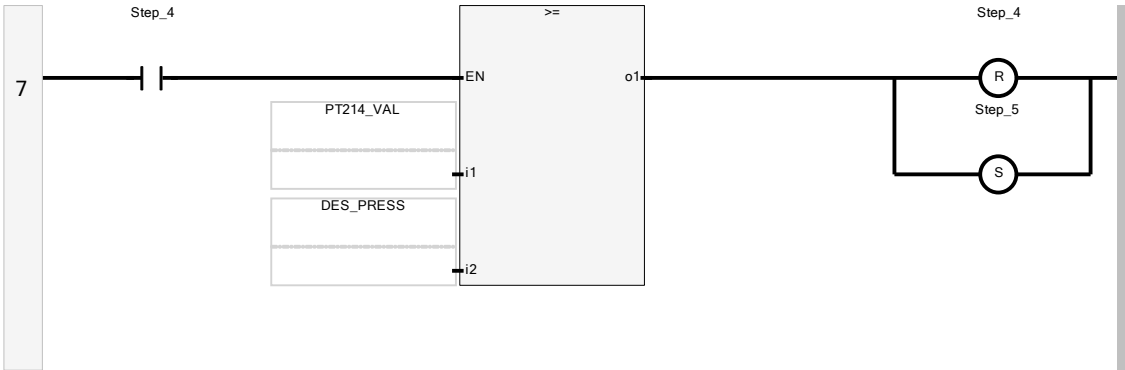
Rung6 Diagram

Step 3 - Push piece in.



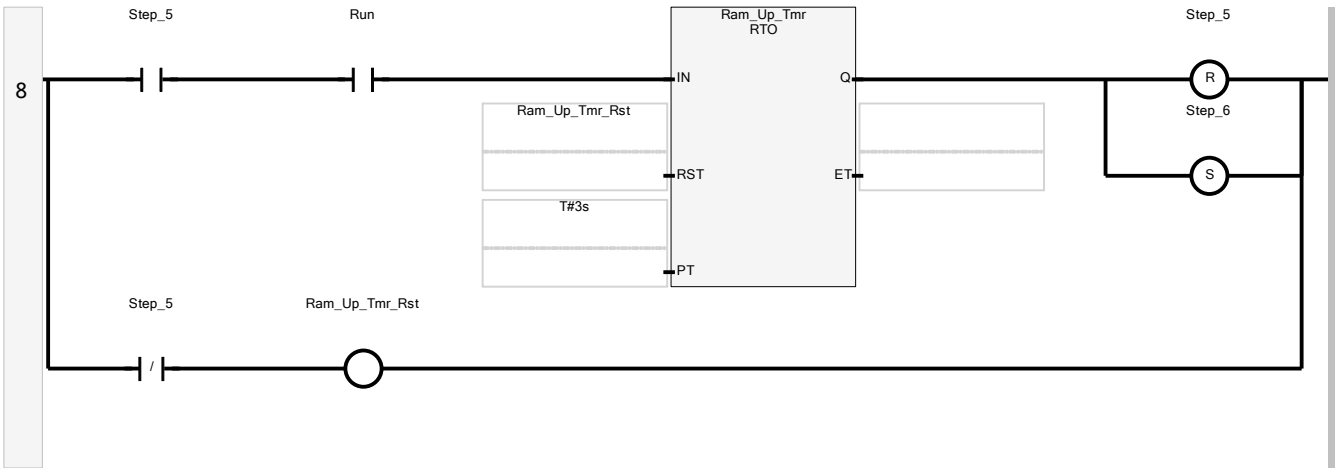
Rung7 Diagram

Step 4 - Stamp part.

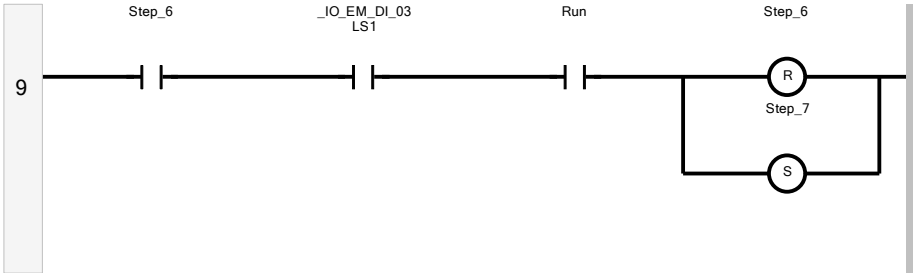


Rung8 Diagram

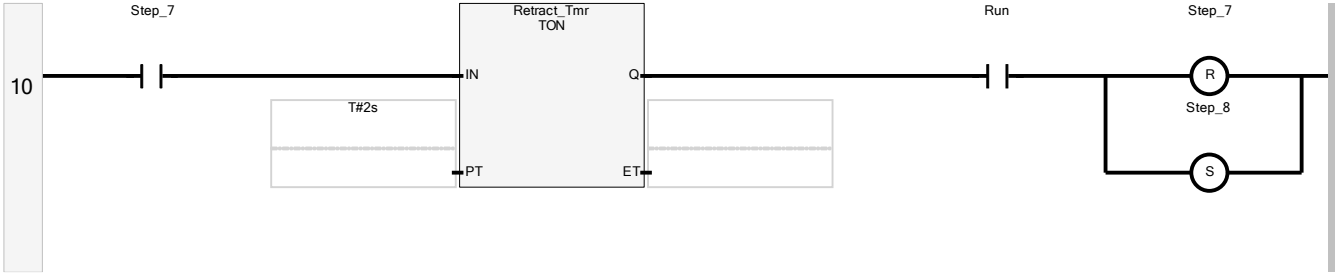
Step 5 - Move stamp up, retentive timer



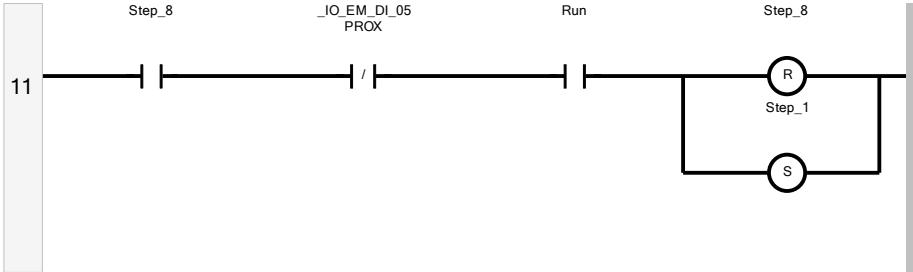
Rung9 Diagram  
Step 6 - Push to conveyor



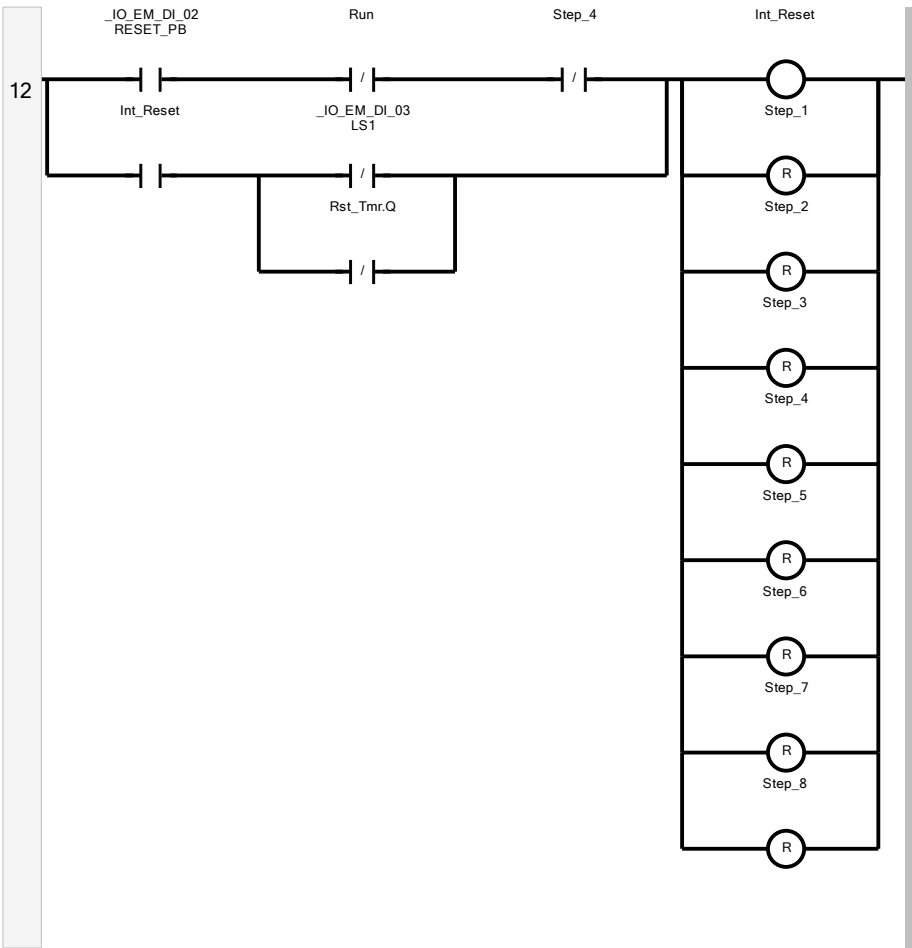
Rung10 Diagram  
Step 7 - Retract PCYL2.



Rung11 Diagram  
Step 8 - Move out

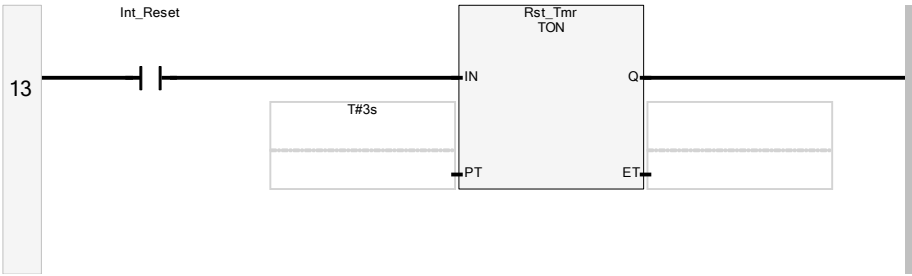


Rung12 Diagram  
Reset  
Do not allow when in step 4  
Maintain until stamp up and PCYL1 retracted



Rung13 Diagram

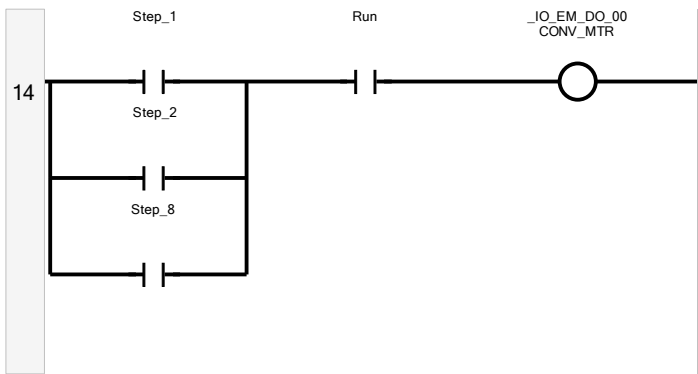
Timer for reset



Rung14 Diagram

Physical Outputs

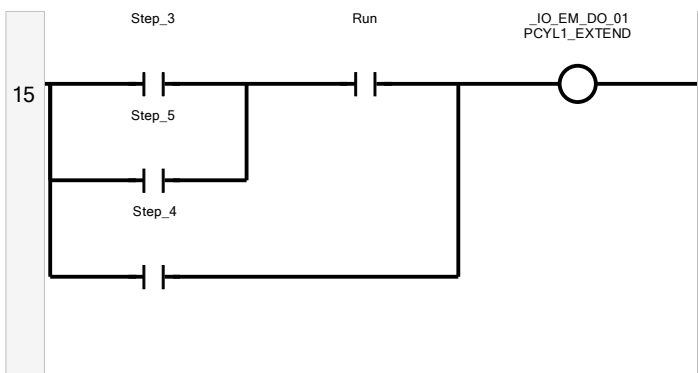
Conveyor control



**Rung15 Diagram**

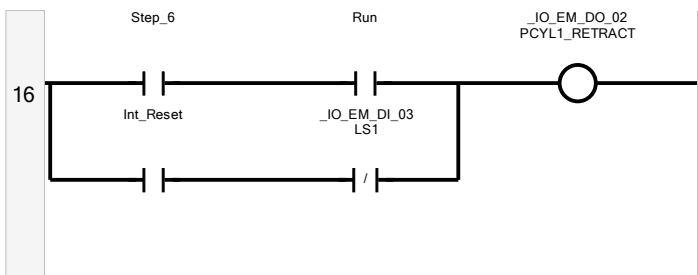
**PCYL1 control.**

**Extend must not be turned off if paused in step 4.**



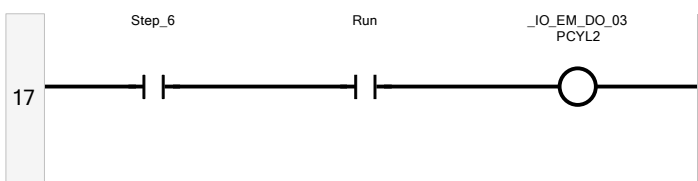
**Rung16 Diagram**

**PCYL1 is retracted when reset.**



**Rung17 Diagram**

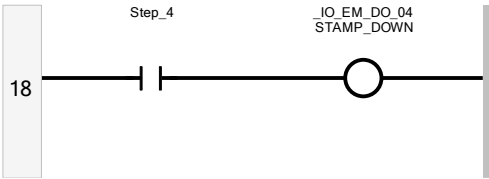
**PCYL2 control**



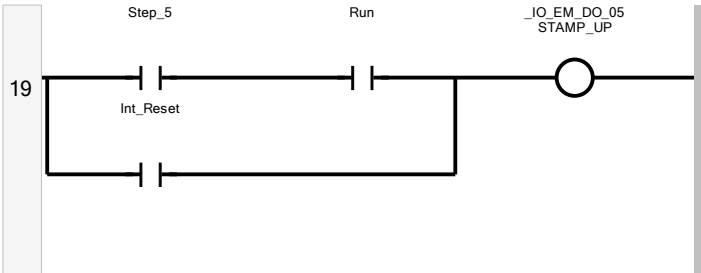
**Rung18 Diagram**

**Stamp Control**

**Not off if paused. Raises on reset.**

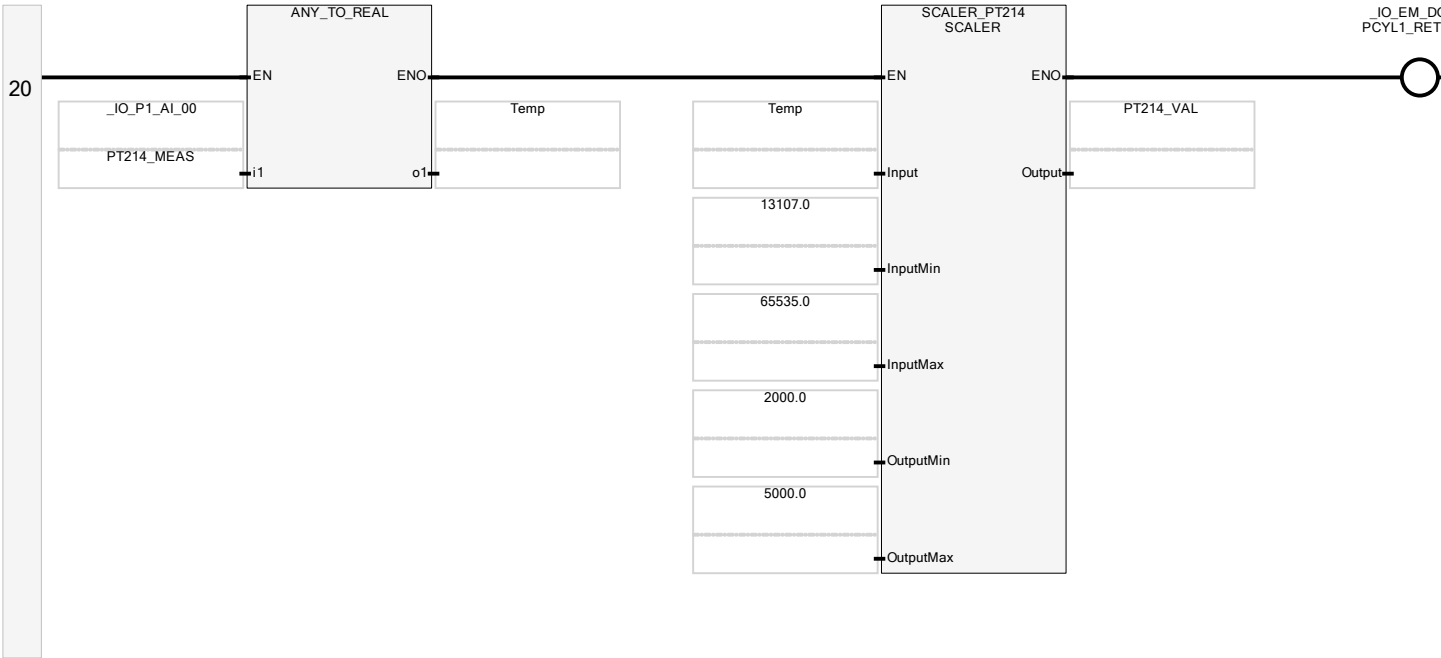


Rung19 Diagram



Rung20 Diagram

Conversion of measurement





0.02  
RACT

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