

## Main

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Table of Contents

Main ..... 3

Main

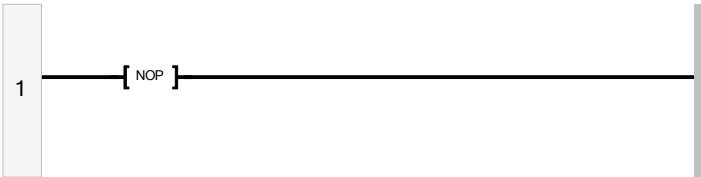
Rung1 Diagram

SP7-7 Width Check Station Control

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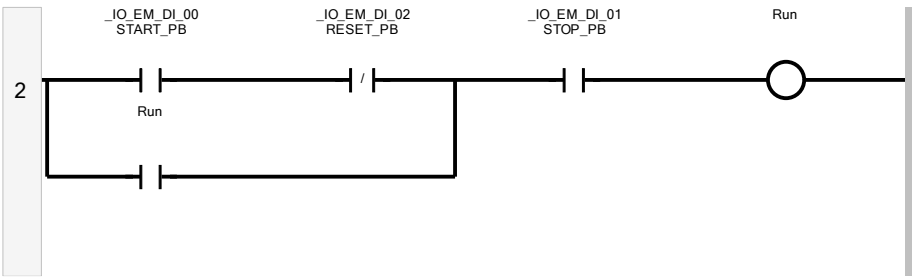
Additional internal memory:

Tag	Data Type	
Run	BOOL	On while station running
Step_1 to Step_3	BOOL	Step-in-progress bits
Clamp_Tmr	TON	Delay for measurement to stabilize
Release_Tmr	TON	Delay for allow part to move out
Part_Ctr	CTU	Counts parts
Temp	REAL	For measurement conversion

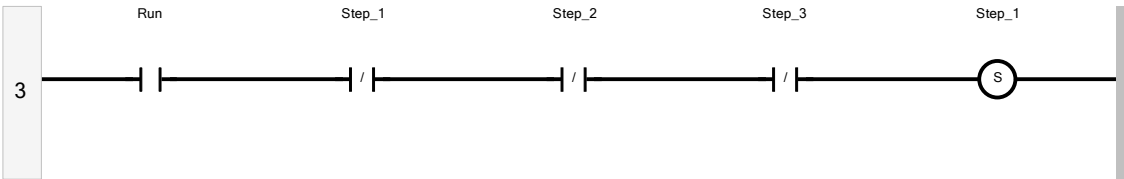


Rung2 Diagram

Start/stop and initial start

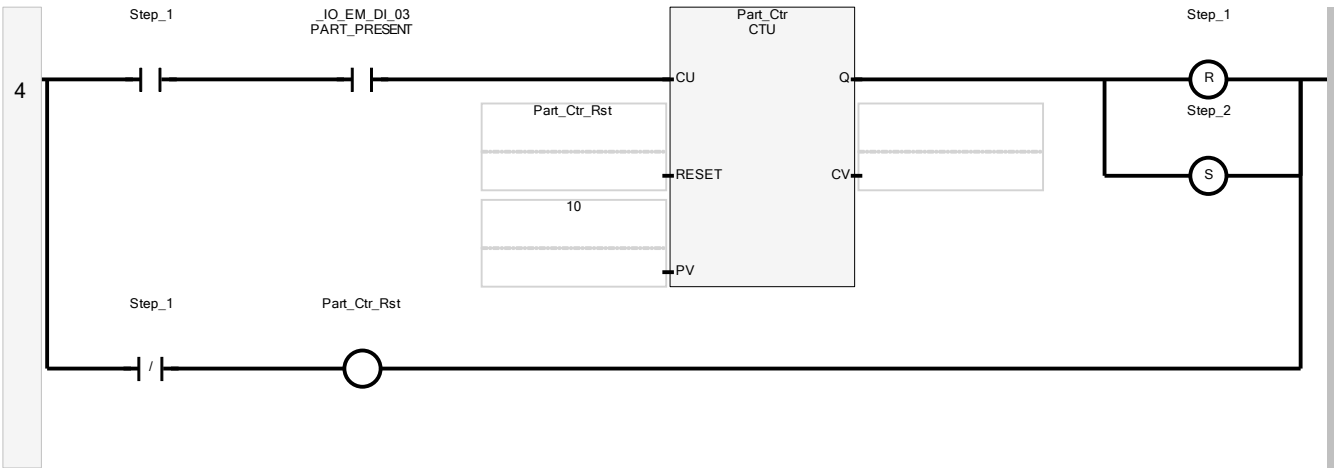


Rung3 Diagram



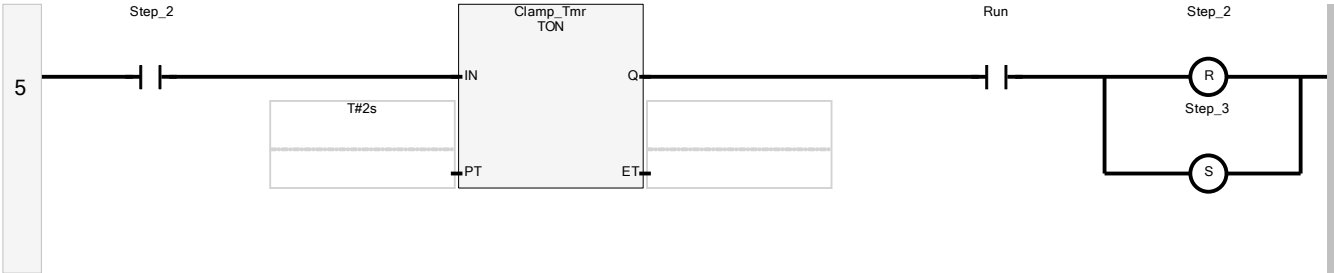
Rung4 Diagram

Step 1 - Wait for tenth part



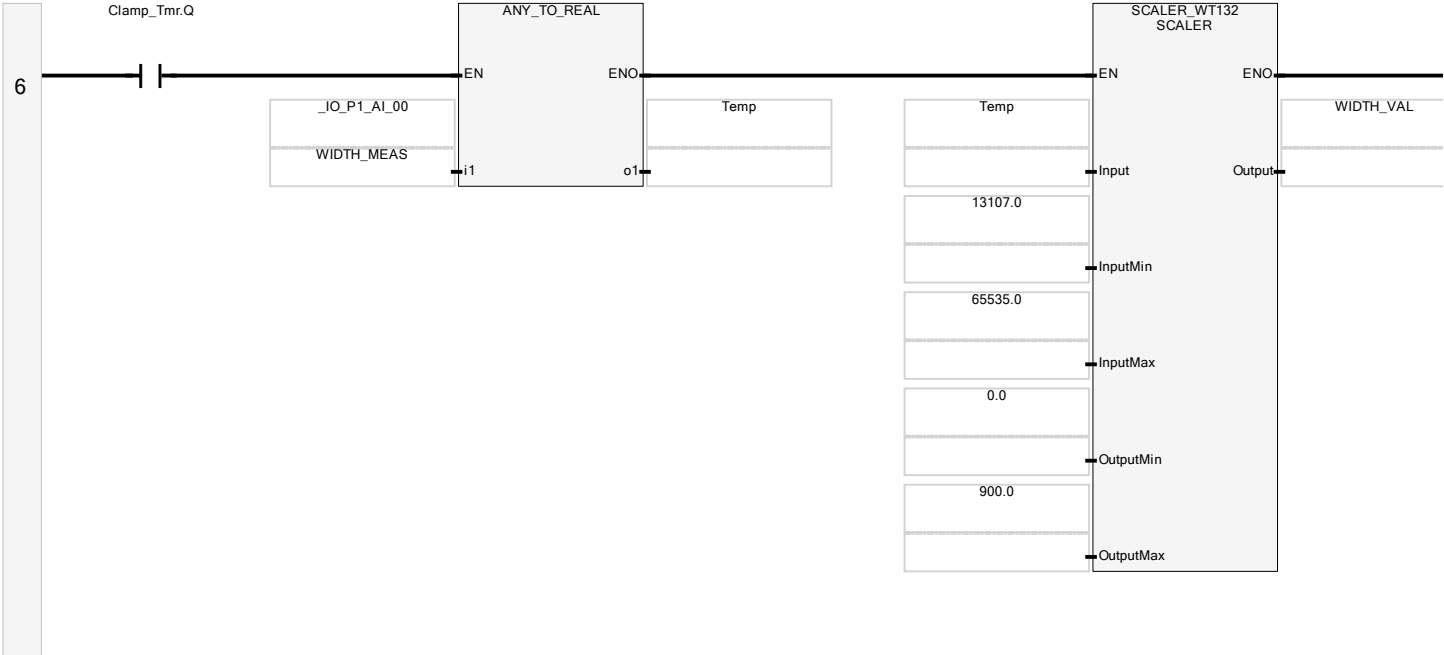
Rung5 Diagram

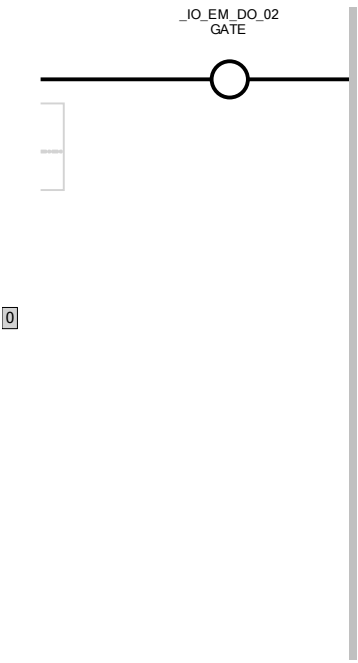
Step 2 - Wait 2 sec for width to stabilize. Convert width on transition.



Rung6 Diagram

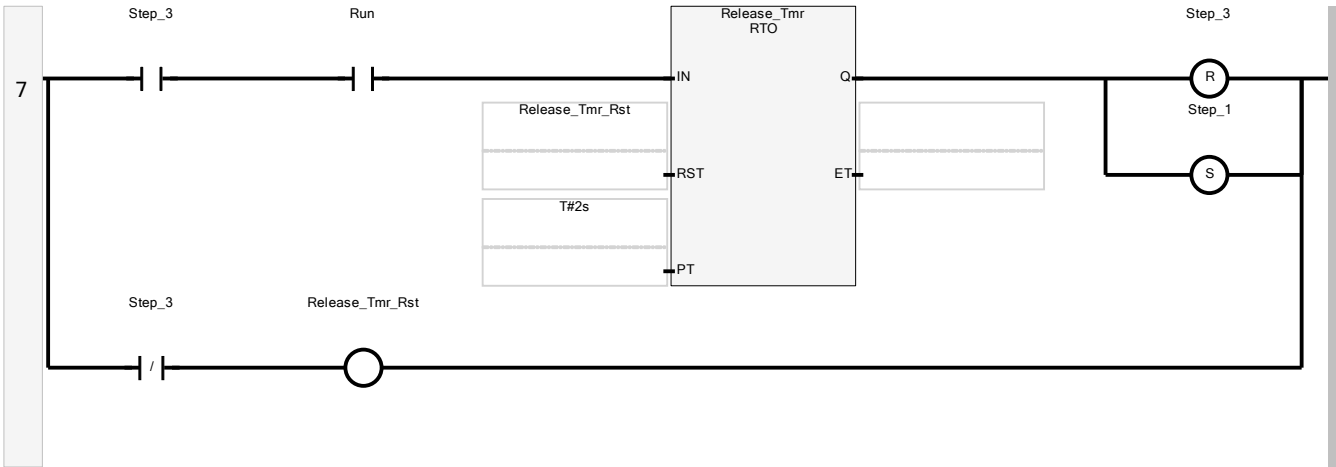
Conversion of Weight measurement





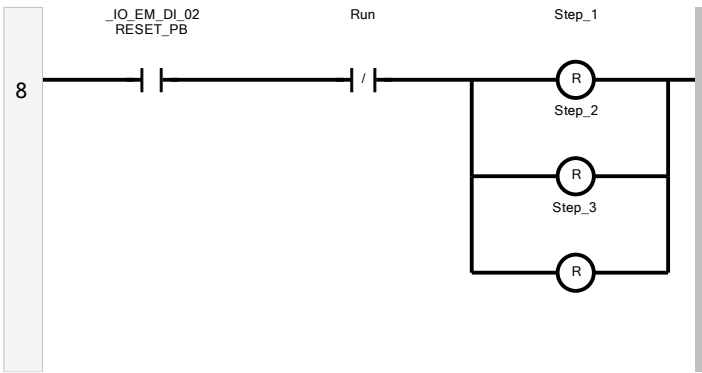
Rung7 Diagram

Step\_3 - Print weight



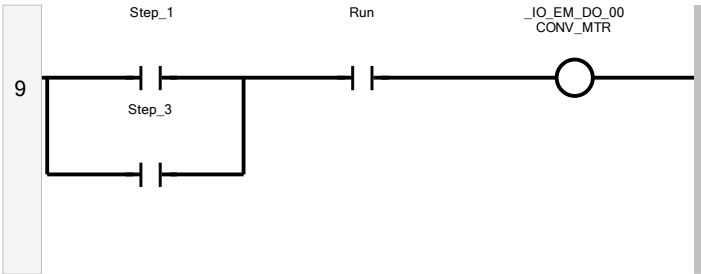
Rung8 Diagram

Reset



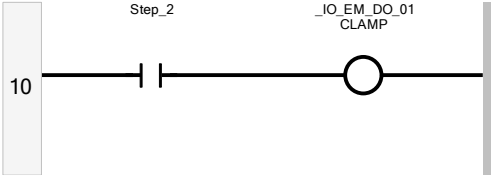
Rung9 Diagram

Physical Outputs



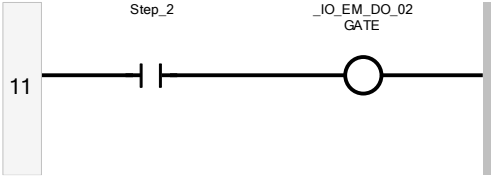
Rung10 Diagram

Clamp control



Rung11 Diagram

Gate control



Rung12 Diagram

Coil to let other part of program know there is a new width

