

Weigh Scale Station Control

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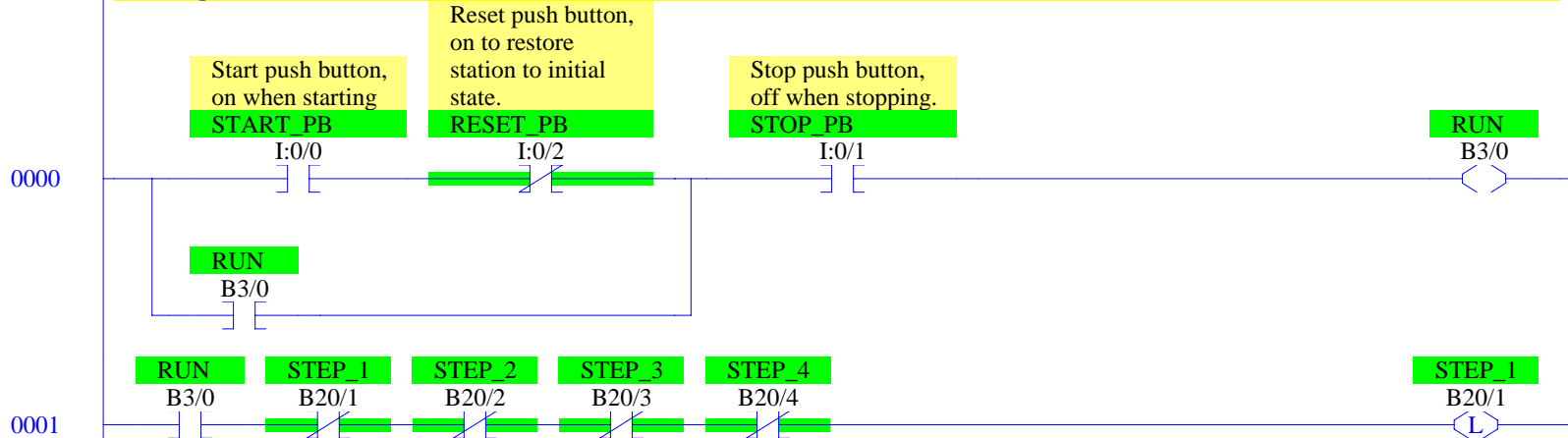
Additional internal memory:

Symbol	Address	
RUN	B3/0	On while station running
STEP_1 to STEP_4	B20/1 to B20/4	Step-in-progress bits
STAB_TMR	T4:1	Delay for weight to stabilize
MOVEOUT_TMR	T4:2	Delay for detecting pallet gone

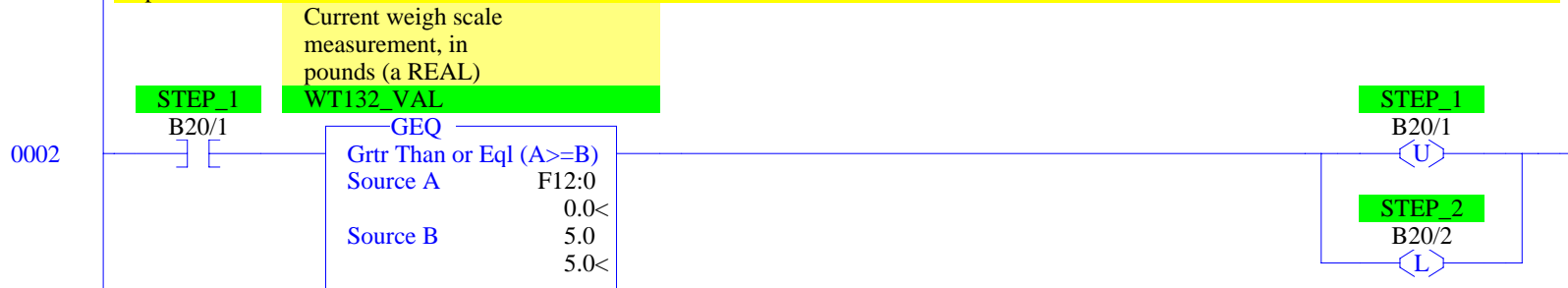
Conversion formula

$$WT132_VAL = ((WT132_MEAS - 6241) / 24965) * (900)$$

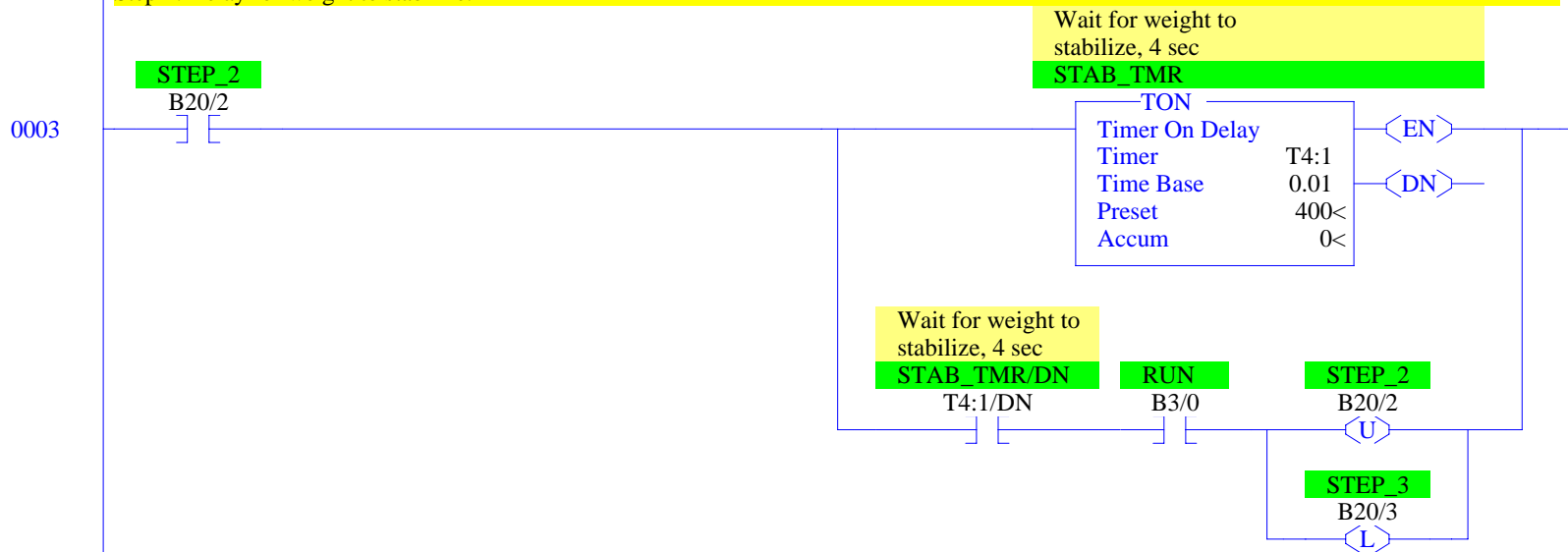
Start/Stop. Initial start

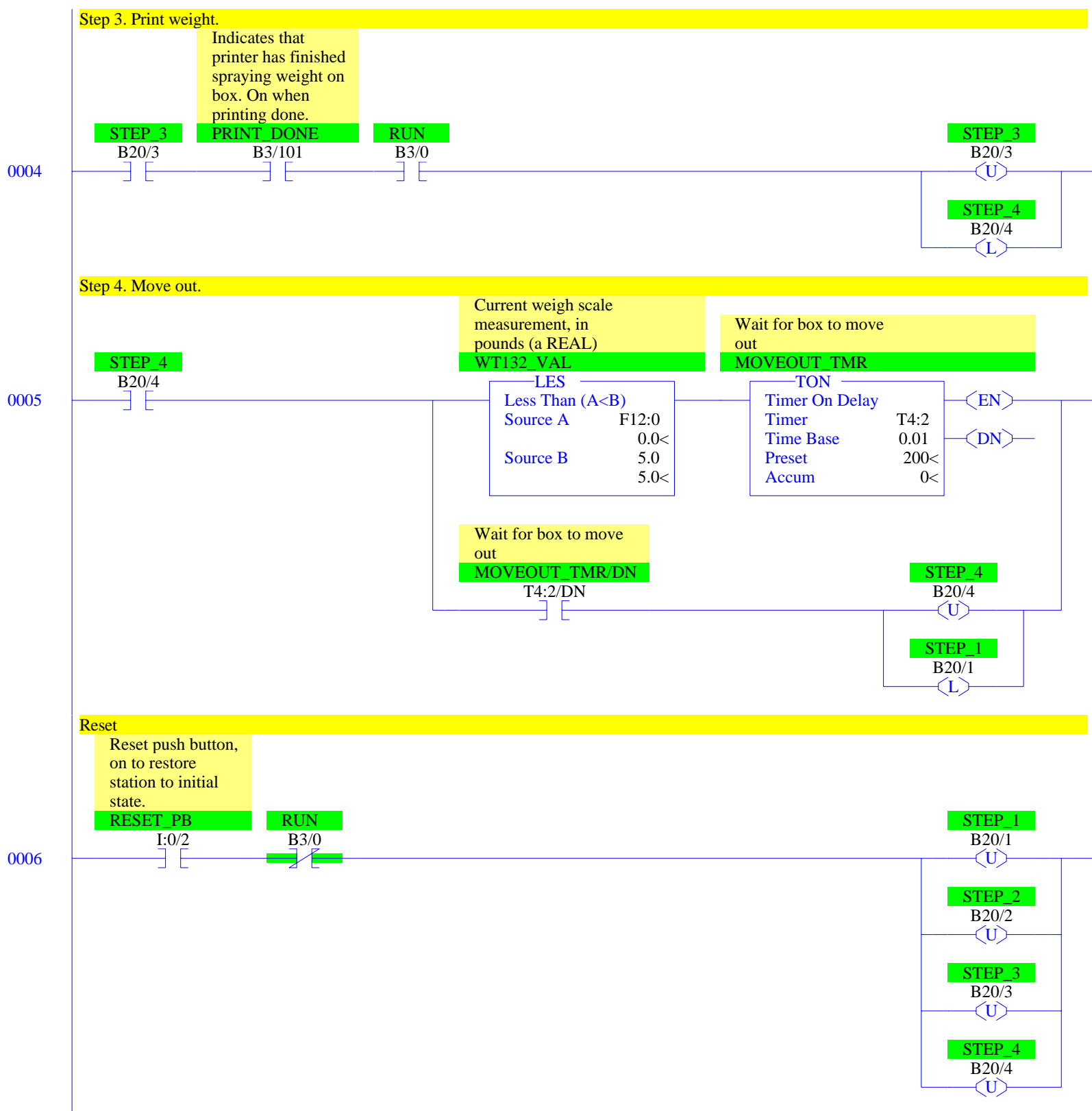


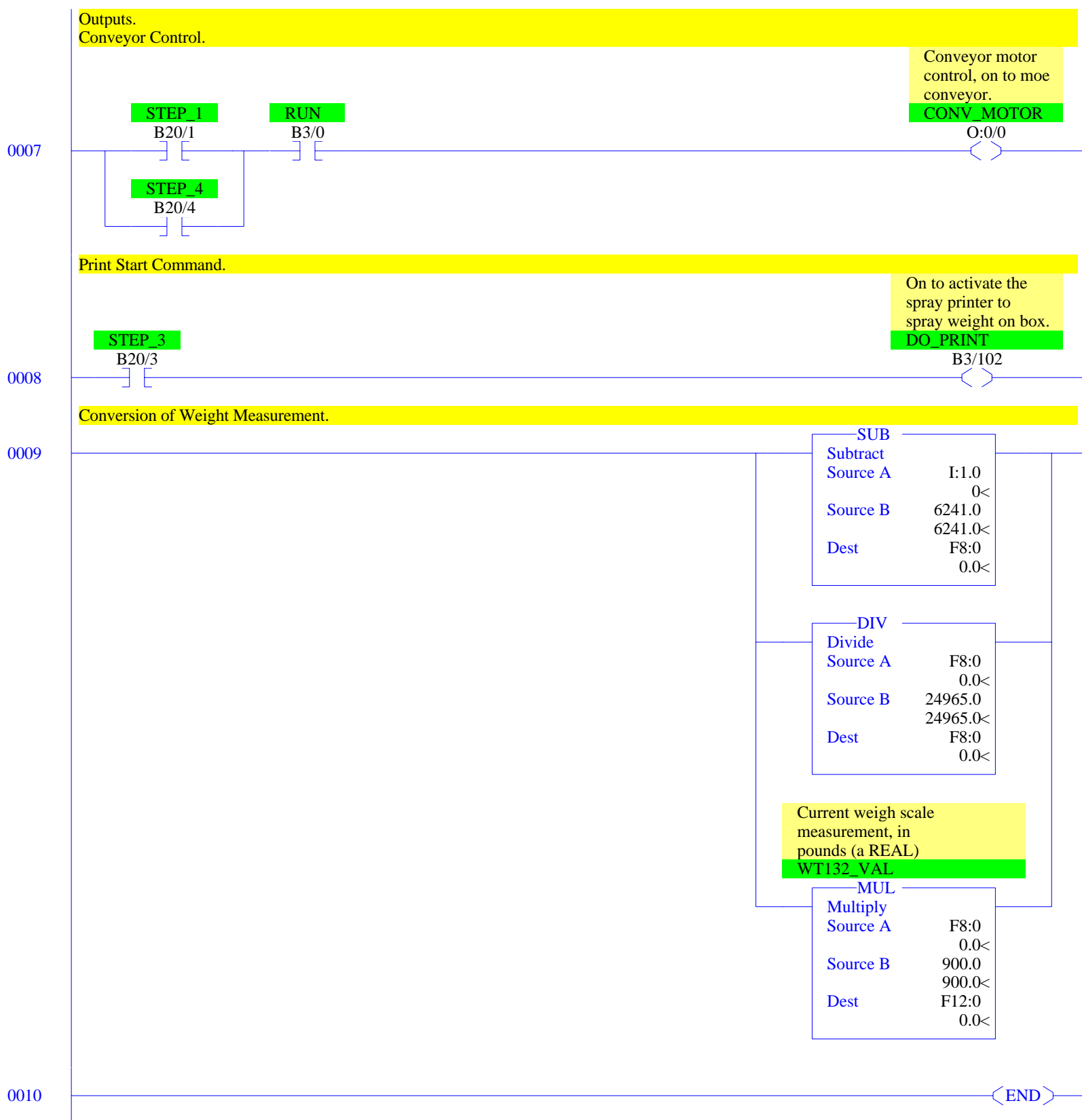
Step 1. Move in.



Step 2. Delay for weight to stabilize.







RSLogix 500 Cross Reference Report - Sorted by Address

O:0/0	- {CONV_MOTOR} Conveyor motor control, on to moe conveyor. OTE - File #2 - 7
I:0/0	- {START_PB} Start push button, on when starting XIC - File #2 - 0
I:0/1	- {STOP_PB} Stop push button, off when stopping. XIC - File #2 - 0
I:0/2	- {RESET_PB} Reset push button, on to restore station to initial state. XIC - File #2 - 6 XIO - File #2 - 0
I:1.0	- SUB - File #2 - 9
B3/0	- {RUN} OTE - File #2 - 0 XIC - File #2 - 0, 1, 3, 4, 7 XIO - File #2 - 6
B3/101	- {PRINT_DONE} Indicates that printer has finished spraying weight on box. On when pri XIC - File #2 - 4
B3/102	- {DO_PRINT} On to activate the spray printer to spray weight on box. OTE - File #2 - 8
T4:1	- {STAB_TMR} Wait for weight to stabilize, 4 sec TON - File #2 - 3
T4:1/DN	- XIC - File #2 - 3
T4:2	- {MOVEOUT_TMR} Wait for box to move out TON - File #2 - 5
T4:2/DN	- XIC - File #2 - 5
F8:0	- SUB - File #2 - 9 MUL - File #2 - 9 DIV - File #2 - 9
F12:0	- {WT132_VAL} Current weigh scale measurement, in pounds (a REAL) MUL - File #2 - 9 GEQ - File #2 - 2 LES - File #2 - 5
B20/1	- {STEP_1} OTL - File #2 - 1, 5 OTU - File #2 - 2, 6 XIC - File #2 - 2, 7 XIO - File #2 - 1
B20/2	- {STEP_2} OTL - File #2 - 2 OTU - File #2 - 3, 6 XIC - File #2 - 3 XIO - File #2 - 1
B20/3	- {STEP_3} OTL - File #2 - 3 OTU - File #2 - 4, 6 XIC - File #2 - 4, 8 XIO - File #2 - 1
B20/4	- {STEP_4} OTL - File #2 - 4 OTU - File #2 - 5, 6 XIC - File #2 - 5, 7 XIO - File #2 - 1