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***** Hole Drilling Station Control *****

Additional internal memory:

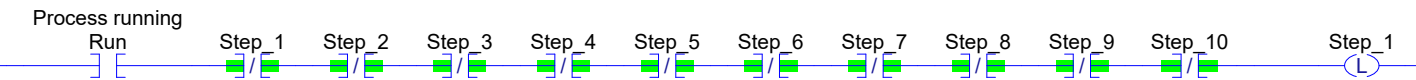
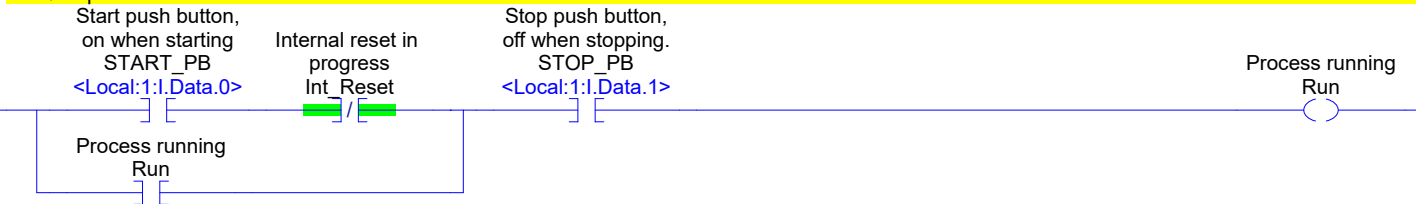
Tag	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Step_1 to Step_10	BOOL	Step-in-progress bits
Clamp_Tmr	TIMER	Times clamping
Pause_Tmr	TIMER	Times pause during drilling
Reset_Tmr	TIMER	Times retract of YCYL when reset

Conversion formulas

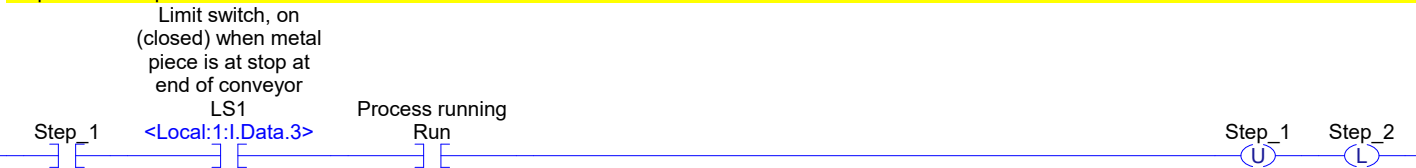
$$X_VAL = (X_MEAS/100) * (300-150) + 150$$

$$Y_VAL = (Y_MEAS/100) * (110-0) + 0$$

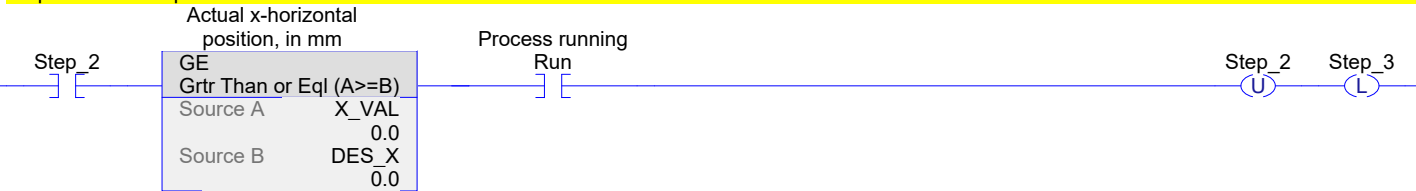
Start/Stop. Initial start



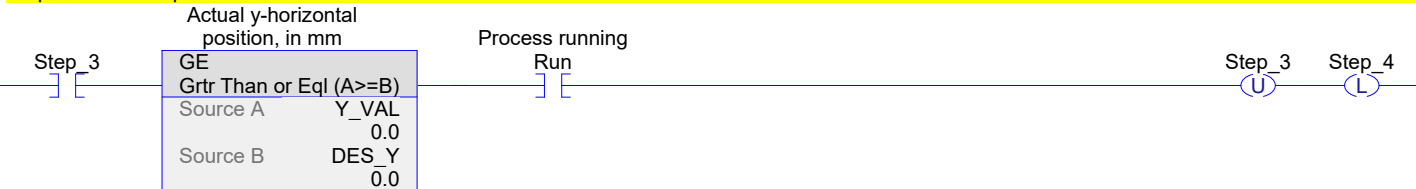
Step 1. Wait for piece.

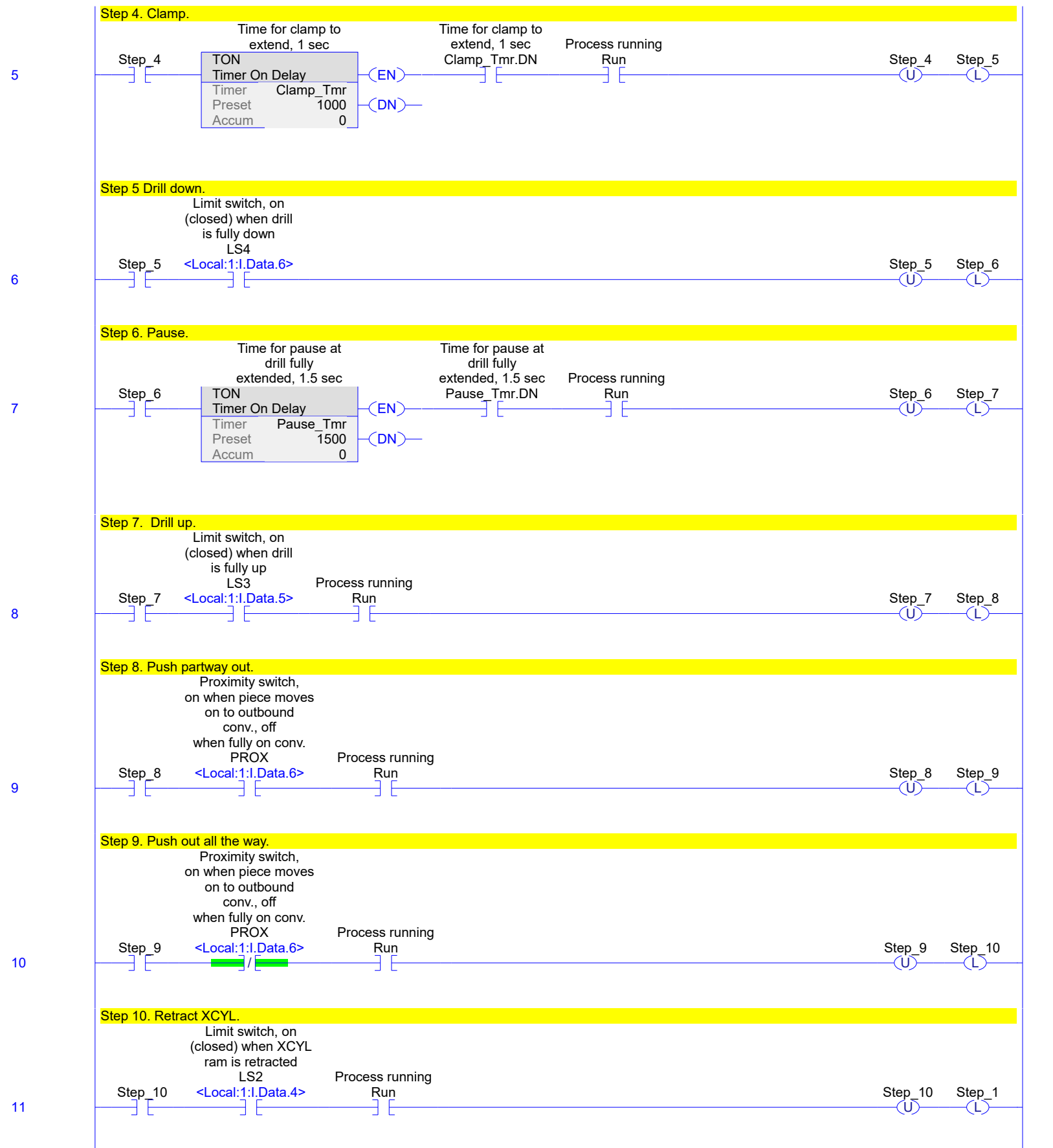


Step 2. Push to X position.

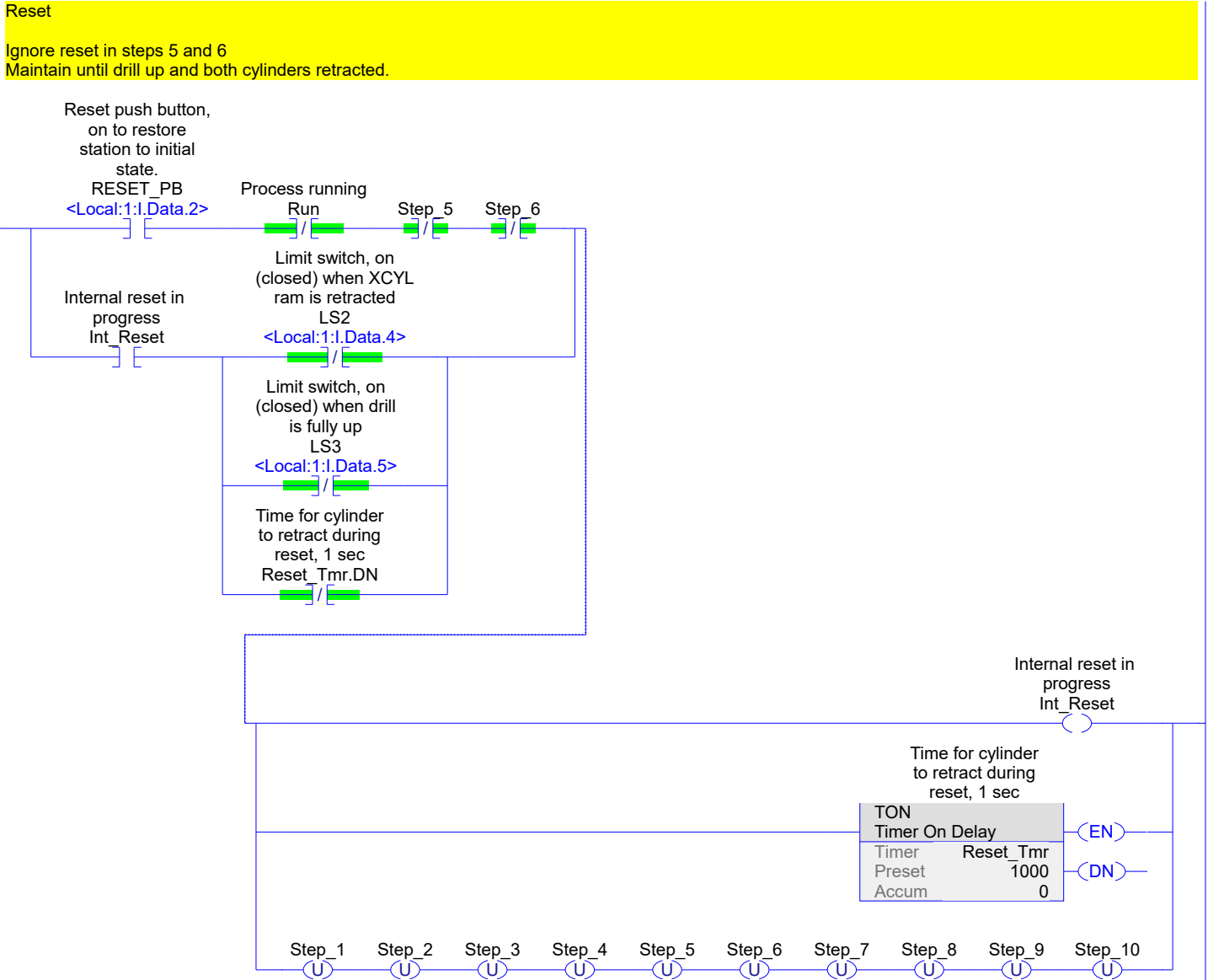


Step 3. Push to Y position.

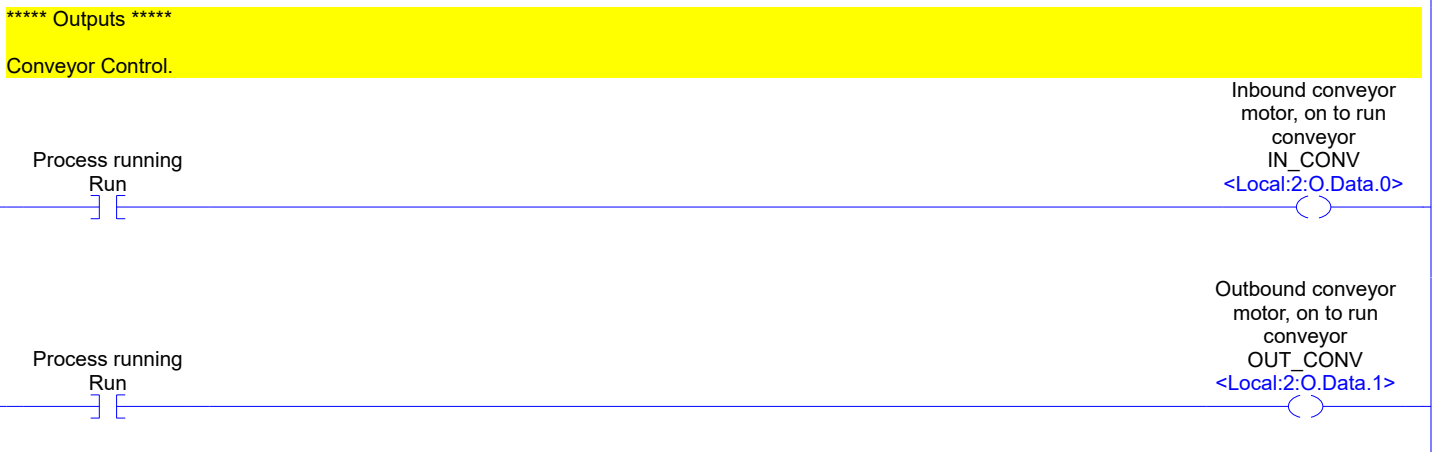




12



13



14

