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\*\*\*\*\* Part Width Sorter Control with Parallel Branches \*\*\*\*\*

Additional internal memory:

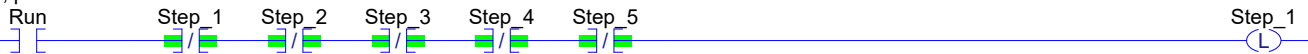
Tag	Data Type	
Int_Reset	BOOL	Internal reset
Step_1 to Step_5	BOOL	Step-in-progress bits
B1_Tmr	TIMER	Times eject pulse for bin 1
B2_Tmr	TIMER	Times eject pulse for bin 2
B3_Tmr	TIMER	Times eject pulse for bin 3
Bin1	BOOL	Size for bin 1
Bin2	BOOL	Size for bin 2
Bin3	BOOL	Size for bin 3
UX1_Inch	REAL	UX1 reading in inches
UX2_Inch	REAL	UX2 reading in inches
UX3_Inch	REAL	UX3 reading in inches
Part_Width	REAL	Part width in inches

Conversion formulas

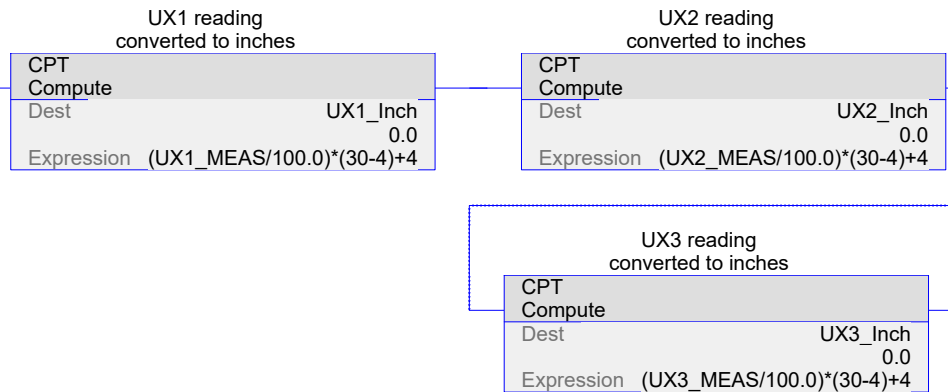
$UXn\_INCH = (UXn\_MEAS/100.0) * (30-4) + 4$

Initial start

When on, allow  
station to run. When  
off, pause.



Convert UX readings to inches.



Step 1. Wait for part in measure position. Calculate part width on transition.

Proximity sensor  
that is on when part  
is in position for  
width measurement

PROX

<Local:1:I.Data.0>



