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***** Part Width Sorter Control *****

Additional internal memory:

Tag	Data Type	
Int_Reset	BOOL	Internal reset
Step_1 to Step_3	BOOL	Step-in-progress bits
Eject_Tmr	TIMER	Times eject pulse
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

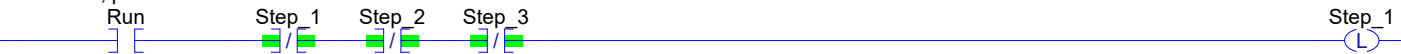
Conversion formulas

$$UXn_Inch = (UXn_MEAS/100) * (30-4) + 4$$

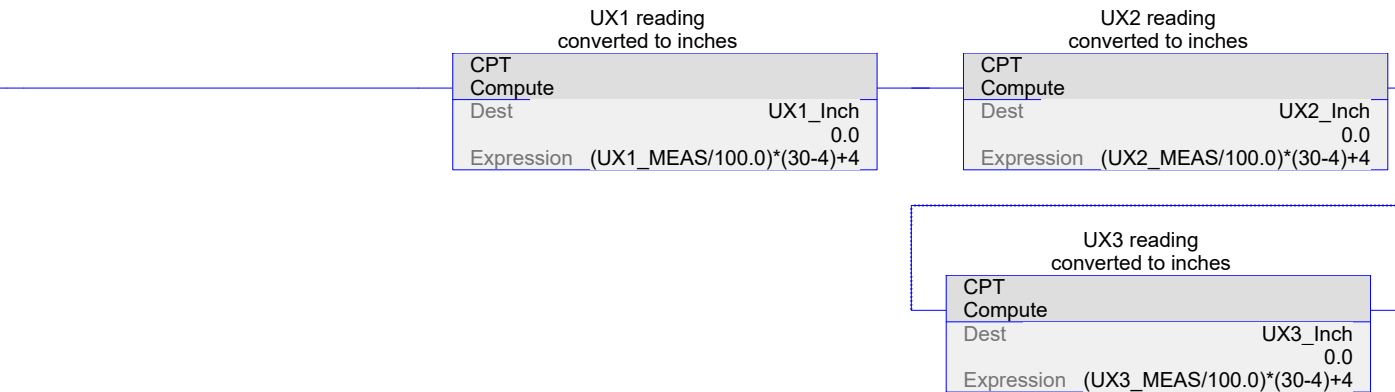
$$Part_Width = 16 - (UX1+UX2)$$

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>



