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Pressure Check Station with Move-based sequencer

Generate transition out of initial step

Internal run  
indication

Run

EQ	Equal
Source A	Step_Num
	0
Source B	0

MOVE	Move
Source	1
Dest	Step_Num
	0

Step 1 - Wait for valve

Reflective proximity  
switch that is on  
when valve is in  
position to be  
pressure checked  
PROX  
<Local:1:I.Data.0>Internal run  
indication

Run

EQ	Equal
Source A	Step_Num
	0
Source B	1

MOVE	Move
Source	2
Dest	Step_Num
	0

Step 2 - Head down

Pressurizing head  
height, in mm (REAL)

LE	Less Than or Eql (A<=B)
Source A	HD_HGT
	0.0
Source B	VLV_HGT
	0.0

MOVE	Move
Source	3
Dest	Step_Num
	0

Step 3 - Pressurize

Pressure, in psi  
(REAL)

GE	Grtr Than or Eql (A>=B)
Source A	VLV_PRES
	0.0
Source B	DES_PRES
	0.0

MOVE	Move
Source	4
Dest	Step_Num
	0

Step 4 -Wait for pressure check

Wait 30 sec to see  
if valve leaksWait 30 sec to see  
if valve leaks  
Wait\_Tmr.DN

EQ	Equal
Source A	Step_Num
	0
Source B	4

TON	Timer On Delay
Timer	Wait_Tmr
Preset	30000
Accum	0

(EN)

(DN)

MOVE	Move
Source	5
Dest	Step_Num
	0

Step 5 - Head up

5

EQ	
Equal	
Source A	Step_Num
	0
Source B	5

Limit switch that  
closes (on) when  
pressurizing head is  
fully up  
UP\_LS  
<Local:1:I.Data.1>

MOVE	
Move	
Source	6
Dest	Step_Num
	0

Step 6 - Allow to move out. Then jump to step 1

6

EQ	
Equal	
Source A	Step_Num
	0
Source B	6

Reflective proximity  
switch that is on  
when valve is in  
position to be  
pressure checked  
PROX  
<Local:1:I.Data.0>

MOVE	
Move	
Source	1
Dest	Step_Num
	0

Start/stop for reset operation. Reset pb starts, reset step 4 stops it.

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Reset to restore  
station to initial  
state.  
RESET

Internal run  
indication  
Run

NE	
Not Equal	
Source A	Step_Num
	0
Source B	4

Reset in progress  
Int\_Reset

MOVE	
Move	
Source	0
Dest	Step_Num
	0

Reset in progress  
Int\_Reset

Limit switch that  
closes (on) when  
pressurizing head is  
fully up  
UP\_LS  
<Local:1:I.Data.1>

\*\*\*\*\* Control of Physical Outputs \*\*\*\*\*

Head raise/lower. Off when paused. Raise when reset

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EQ	
Equal	
Source A	Step_Num
	0
Source B	2

Internal run  
indication  
Run

When on, moves  
pressurizing head  
down. When off, head  
does not change  
position.  
HD\_DOWN  
<Local:2:O.Data.0>



