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Pressure Checking Station with shift register-based sequence

Generate first start if run and no steps active

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

RUN

Normal operation  
steps

EQ	
Equal	
Source A	IStep[0]
	1048704
Source B	0

Initial kick-off of  
sequence  
First\_Start

All transition conditions. Any one causes shift.

Initial kick-off of  
sequence  
First\_Start

Do\_IShift

Normal operation  
steps

Step\_1  
<IStep[0].0>

Reflective proximity  
switch that is on  
when valve is in  
position to be  
pressure checked  
PROX

Normal operation  
steps

Step\_2  
<IStep[0].1>

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

Normal operation  
steps

Step\_3  
<IStep[0].2>

Pressure, in psi  
(REAL)

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

Normal operation  
steps

Step\_4  
<IStep[0].3>

Wait 30 sec to see  
if valve leaks

TON	
Timer On Delay	
Timer	Wait_Tmr
Preset	30000
Accum	0

(EN)

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

(DN)

Normal operation  
steps

Step\_5  
<IStep[0].4>

Limit switch that  
closes (on) when  
pressurizing head is  
fully up  
UP\_LS

When on, allow  
pressure check  
station to run. When  
off, pause.  
RUN

Normal operation  
steps

Step\_6  
<IStep[0].5>

Reflective proximity  
switch that is on  
when valve is in  
position to be  
pressure checked  
PROX

When on, allow  
pressure check  
station to run. When  
off, pause.  
RUN



