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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

EQU
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)

LEQ

Source A	HD_HGT
	0.0
Source B	VLV_HGT
	0.0

Normal operation steps

Step_3

<IStep[0].2>

Pressure, in psi (REAL)

GEQ

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	Wait_Tmr
Preset	30000
Accum	0

Wait 30 sec to see if valve leaks

Wait_Tmr.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



