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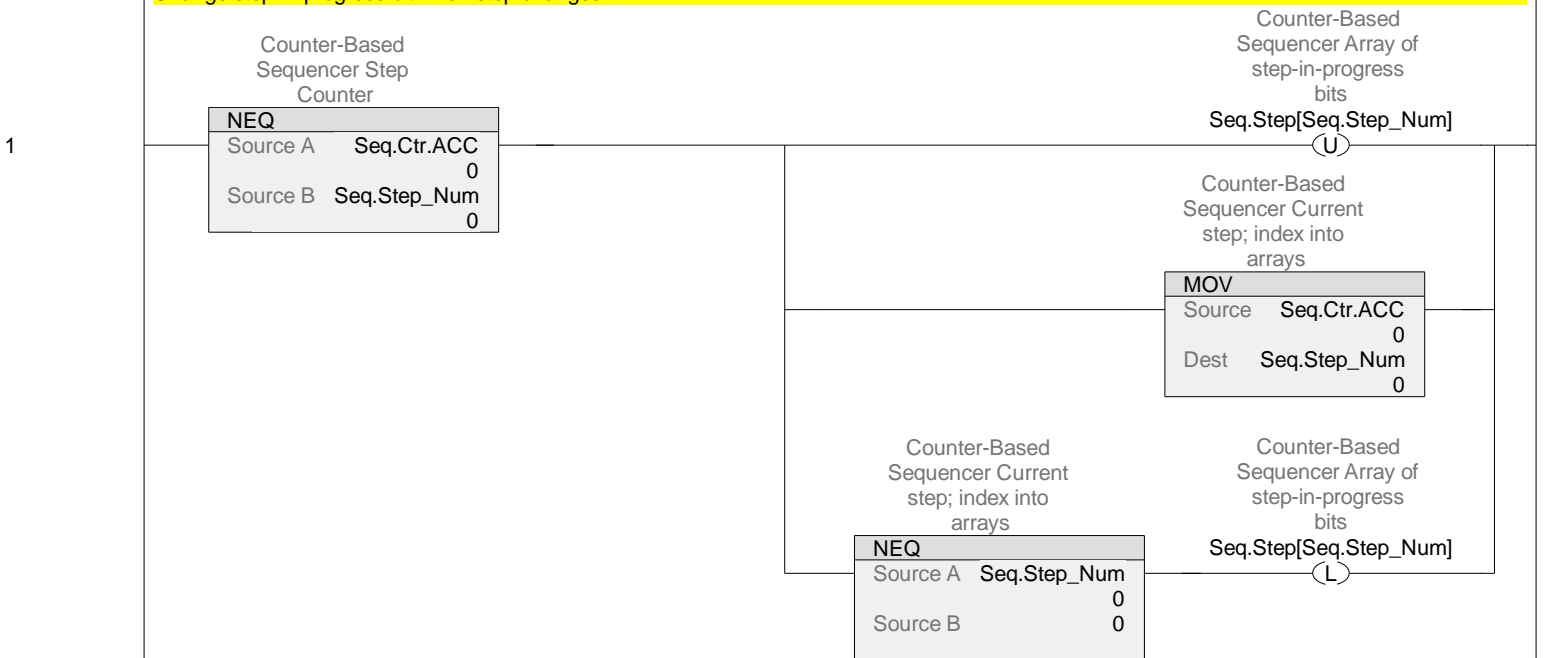
Pressure Check Station with Counter-based sequencer

Generate transition out of initial step

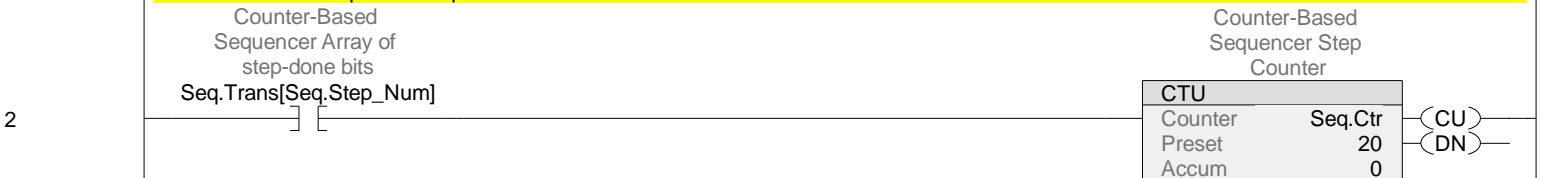


Pressure Check Station with Counter-based sequencer

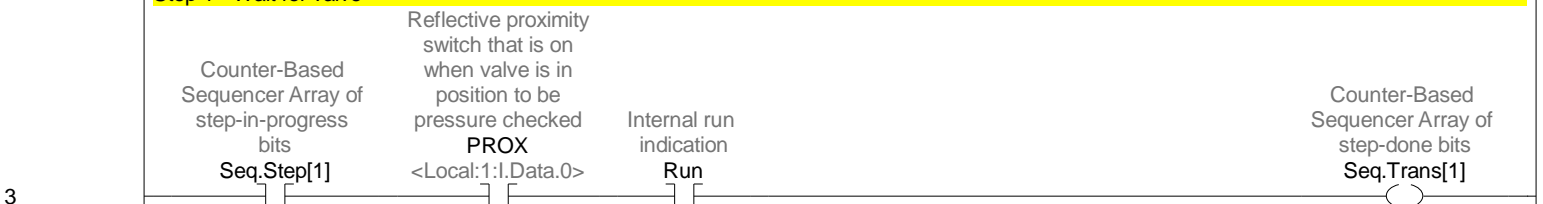
Change step-in-progress bit when step changes.



Increment to next step when step-done bit set.



Step 1 - Wait for valve



Step 2 - Head down

Counter-Based
Sequencer Array of
step-in-progress
bits

Seq.Step[2]

Pressurizing head
height, in mm (REAL)

LEQ	
Source A	HD_HGT 0.0
Source B	VLV_HGT 0.0

Counter-Based
Sequencer Array of
step-done bits

Seq.Trans[2]

Step 3 - Pressurize

Counter-Based
Sequencer Array of
step-in-progress
bits

Seq.Step[3]

Pressure, in psi
(REAL)

GEQ	
Source A	VLV_PRES 0.0
Source B	DES_PRES 0.0

Counter-Based
Sequencer Array of
step-done bits

Seq.Trans[3]

Step 4 -Wait for pressure check

Counter-Based
Sequencer Array of
step-in-progress
bits

Seq.Step[4]

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

Counter-Based
Sequencer Array of
step-done bits

Seq.Trans[4]

Step 5 - Head up

Counter-Based
Sequencer Array of
step-in-progress
bits

Seq.Step[5]

Limit switch that
closes (on) when
pressurizing head is
fully up
UP_LS

<Local:1:I.Data.1>

Counter-Based
Sequencer Array of
step-done bits

Seq.Trans[5]

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

Counter-Based
Sequencer Array of
step-in-progress
bits

Seq.Step[6]

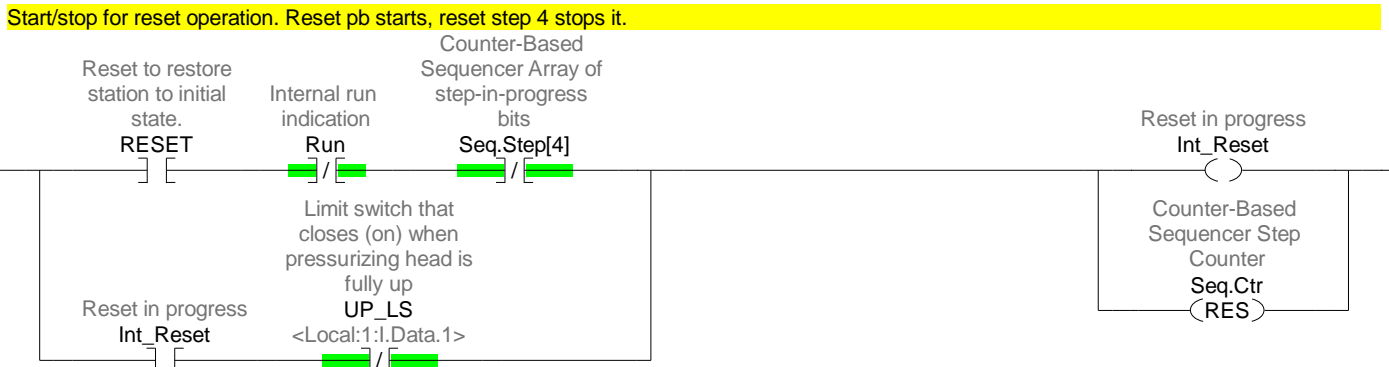
Reflective proximity
switch that is on
when valve is in
position to be
pressure checked
PROX

<Local:1:I.Data.0>

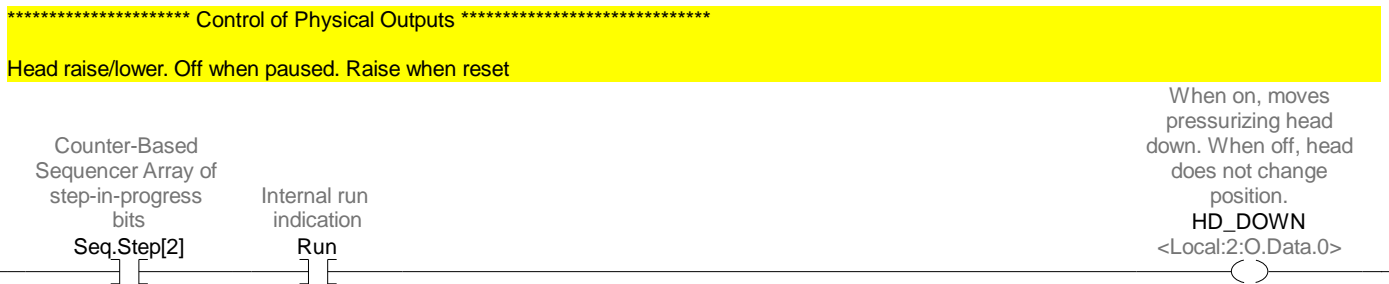
Counter-Based
Sequencer Step
Counter

MOV	
Source	1
Dest	Seq.Ctr.ACC 0

9



10



11



12



13

