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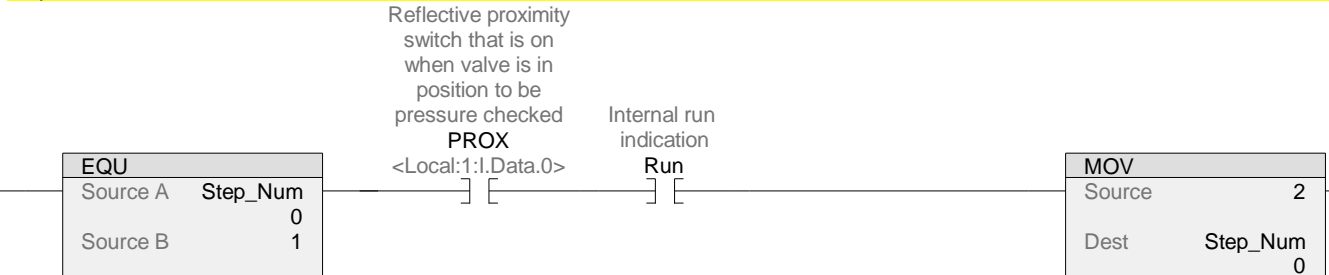
Pressure Check Station with Move-based sequencer

Generate transition out of initial step

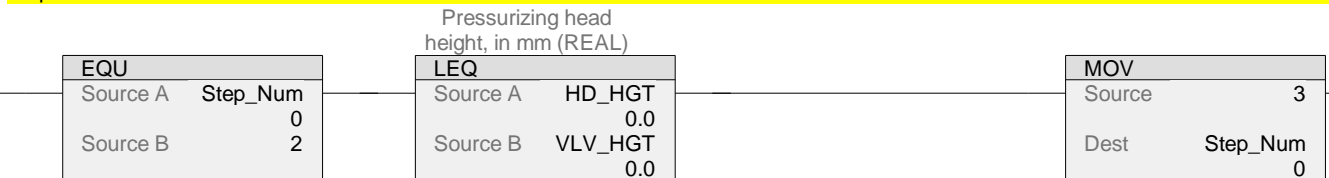
Internal run
indication



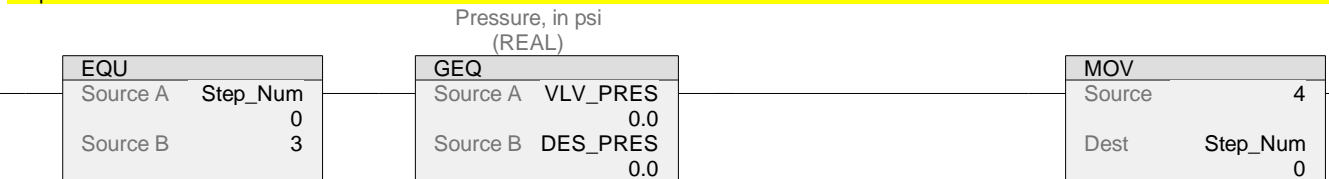
Step 1 - Wait for valve



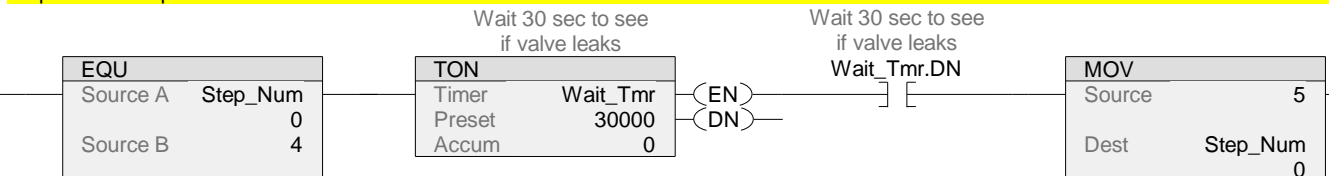
Step 2 - Head down



Step 3 - Pressurize



Step 4 -Wait for pressure check



Step 5 - Head up

5

EQU	
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>

MOV	
Source	6
Dest	Step_Num
	0

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

6

EQU	
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>

MOV	
Source	1
Dest	Step_Num
	0

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

7

Reset to restore
station to initial
state.

RESET

Internal run
indication

Run

NEQ	
Source A	Step_Num
	0
Source B	4

Reset in progress

Int_Reset

MOV	
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

8

EQU	
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>

