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3 Part Width Sorter Control with Parallel Branches

4 Additional internal variable declarations:

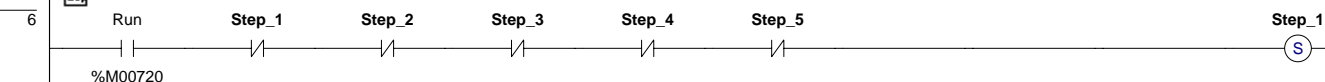
Variables	Data Type	Step-in-progress bits
Step_1 to Step_5	BOOL	Times eject pulse for Bin 1
Bin1_Tmr TON	TON	Times eject pulse for Bin 2
Bin2_Tmr TON	TON	Times eject pulse for Bin 3
Bin1	BOOL	Size for bin 1
Bin2	BOOL	Size for bin 2
Bin3	BOOL	Size for bin 3
UX1_INCH REAL		UX1 reading in inches
UX2_INCH REAL		UX2 reading in inches
UX3_INCH REAL		UX3 reading in inches
PART_WIDTH REAL		Part width in inches

5 Conversion formulas

6 $UXn_INCH = (UXn_MEAS / 32000) * (30 - 4) + 4$

7 $PART_WIDTH = 16 - (UX1 + UX_2)$

8 Initial start.



14 Convert UX1 reading to inches

