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2

3 Width Check Station Control

4 Additional internal variable declarations:

Variables	Data Type	
Run	BOOL	On while station running
Step_1 to Step_3	BOOL	Step-in-progress bits
Clmp_Tmr TON		Delay for measurement to stabilize
Release_Tmr	TON	Delay for parts to move out
Part_Ctr	CTU	Counts parts

Conversion formula
WIDTH_VAL = (WIDTH_MEAS/32000)*(70)

5 Start/stop and initial start. During reset prevent start.

6 START_PB %I00001 — RESET_PB %I00003 — STOP_PB %I00002 — Run %I00001 — Run M

7 Run — Step_1 — Step_2 — Step_3 — Step_1 S

8 Step 1 - Wait for tenth part.

9 Step_1 — PART_PRESENT %I00004 — UPCTR Part_Ctr (R, PV 10, CV) — Step_1 R — Step_2 S

10 Step 2 - Wait 2 sec for width to stabilize. Covert on transition.

11 TON Clamp_Tmr (IN, PT 2000, Q, ET) — Step_2 — Run — Step_2 R — Step_3 S

12 Clamp_Tmr.Q — INT TO REAL (IN, Q) — DIV REAL (IN1, IN2 32000.0, Q) — MUL REAL (IN1, IN2 70.0, Q) — WIDTH_VAL
WIDTH_MEAS

13 Step 3 - Release part and wait 2 sec

14 Step_3 — Run — ONDTR HUNDS Release_T... (R, PV 200, CV) — Step_3 R — Step_1 S

15 Physical Outputs - conveyor control

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