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2

3 Part Width Sorter Control

4 Additional internal variable declarations:

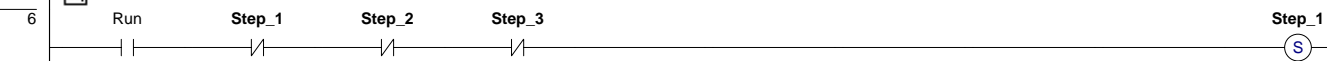
Variables	Data Type	
Step_1 to Step_3	BOOL	Step-in-progress bits
Eject_Tmr	TON	Times eject pulse
Bin1	BOOL	Size for bin 1
Bin2	BOOL	Size for bin 2
Bin3	BOOL	Size for bin 3
UX1_INCH	REAL	UX1 reading in inches
UX2_INCH	REAL	UX2 reading in inches
UX3_INCH	REAL	UX3 reading in inches
PART_WIDTH	REAL	Part width in inches

Conversion formulas

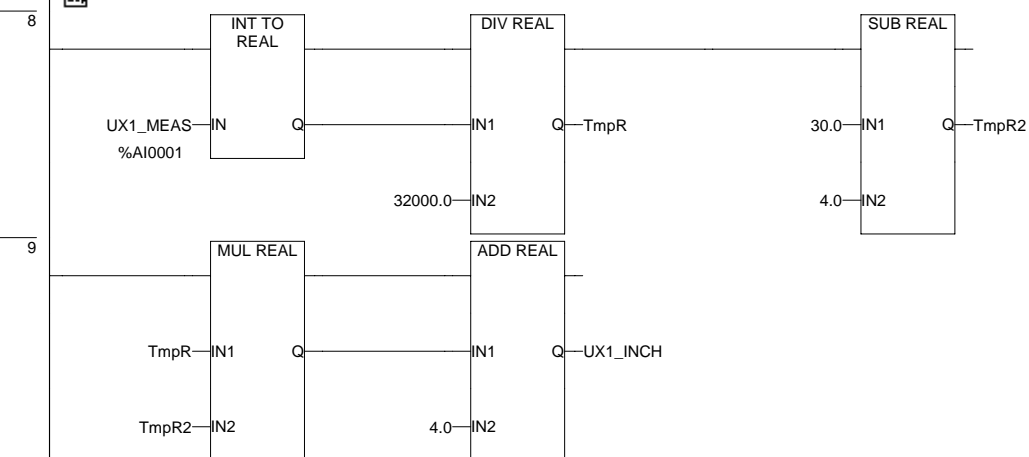
$UXn_INCH = (UXn_MEAS / 32000) * (30 - 4) + 4$

$PART_WIDTH = 16 - (UX1 + UX2)$

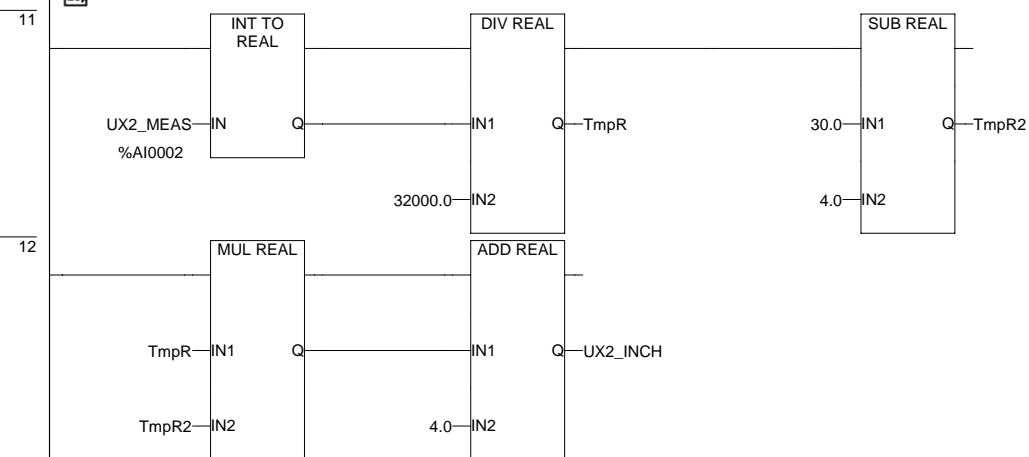
5 Initial start.



7 Convert UX1 reading to inches



10 Convert UX2 reading to inches



13 Convert UX3 reading to inches

