To calculate conveyor pulse per inch:

The goal is to calculate how many inches a roller travels for 20 pulses then divide the inch measurement by 20.

1. Lay a tape measure out starting where the roller comes out of the gate
2. Start the conveyor
3. Have a helper watch the TCS ready to count out pulses
4. Manually run a roller up,
5. When the roller passes up the ramp onto the conveyor, have the helper start counting pulses from 1 to 20 out the over the phone
6. Follow the roller while the helper is counting
7. When the pulse count reaches 20, take note of the amount in inches the roller has traveled
8. Divide the amount traveled in inches by 20 pulses to calculate the pulse distance per inch