Notcher_rev1

Main Program(Page 1 of 1)

Start Main Program

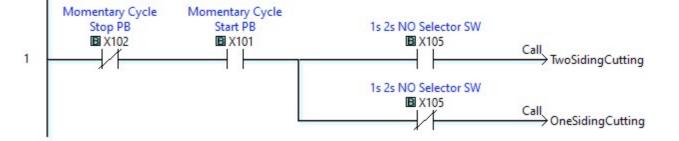
Momentary Cycle Start pushbutton is pressed (input X101)

The Momentary Cycle Stop pushbutton (input X102) will end the active cutting cycle and will not allow foot pedal operation until the momentary cycle start pushbutton is pressed.

X105 NO switch is closed = 2 sided cutting subroutine programm running

X105 NO switch is open = 1 sided cutting subroutine programm running

Not clear next item "This allows the PLC to process the momentary foot pedal when pressed by the operator (input X103)". Need to clarify



```
X105 NO switch is closed = 2 sided cutting subroutine programm running
     Set C1 bit as a 2 Sided cycle bit
                                          2 Sided cycle
                                             B C1
                                            ( SET )
     C1 NO contact closed and Y202 NC contact closed (checking if Y202 solenoid is not energized), T2 NC contact (checking is T2 is not turned ON) starts T1 timer (OFF Delay) for 750ms. T1 NC contact energized Y201 solenoid and open in 750ms when T1 turned
     T2 NO contact, Y202 NC contact and X104 NC contact - move cutter to the RIGHT until the Momentary NO Center Limit Switch is made
                                                                                                                               Right move 750 ms
                                                                                            Timer(ON Delay)
                                                                                                                                     BIT1
        2 Sided cycle
                             LEFT Solenoid
                                               Left move 1500 ms
                                                                                            Current Value
                                                                                                                 Not Retained
                               B Y202
            B C1
                                                     B T2
                                                                                            Unit
                                                                                       Enable SetPoint
                                                                                                             II 750
                                                                                                             TD1
                                                                                            Current
                                                Mom NO Center
      Left move 1500 ms
                             LEFT Solenoid
                                                   Limit SW
                                                                   Right move 750 ms
                                                                                                       RIGHT Solenoid
                                                                                                          B Y201
            B T2
                               B Y202
                                                    B X104
                                                                         B T1
                                                                                                          (OUT)
     T1 NO contact turned ON 750ms after C1 was turned ON and turns T2 LEFT move 1500 ms
                                                                                                                               Left move 1500 ms
                                                                                            Timer(ON Delay)
                                                                                                                                     B T2
      Right move 750 ms
                            RIGHT Solenoid
                                                                                            Current Value
                                                                                                                 Not Retained
                               B Y201
            B T1
                                                                                            Unit
3
                                                                                       Enable SetPoint
                                                                                                             1500
                                                                                                             Ⅲ TD2
                                                                                            Current
                                                                                                       LEFT Solenoid
                                                                    Left move 1500 ms
                                                                         B T2
                                                                                                          B Y202
                                                                                                          (OUT)
     When X104 Momentary NO Center Switch is made - cutting cycle is complete, C1 bit resets and subroutine program comes back to Main program
       Mom NO Center
          Limit SW
                                                     2 Sided cycle
           B X104
                                                        B C1
                                                        RST
                                              Return
```

```
X105 NO switch is opened = 1 sided cutting subroutine programm running
     Set C2 bit as a 1 Sided cycle bit
                                          1 Sided cycle
                                             B C2
                                            ( SET )
     C2 NO contact closed and Y202 NC contact closed (checking if Y202 solenoid is not energized) starts T1 timer (OFF Delay) for 750ms. T1 NC contact energized Y201 solenoid and open in 750ms when T1 turned ON
                                                                                                          Right move 750 ms
                                                                       Timer(ON Delay)
                                                                                                                B T1
        2 Sided cycle
                             LEFT Solenoid
                                                                       Current Value
                                                                                             Not Retained
            B C1
                                B Y202
                                                                       Unit
2
                                                                  Enable SetPoint
                                                                                         750
                                                                                         TD1
                                                                        Current
                                               Right move 750 ms
                                                                                  RIGHT Solenoid
                                                                                     B Y201
                                                                                     (OUT)
             Output coil Y201 is de-energized and Output coil Y202 is energized to activate the solenoid hydraulic valve to move the cutter to the LEFT until the momentary NO center switch is made
                                                Mom NO Center
      Right move 750 ms
                            RIGHT Solenoid
                                                   Limit SW
                                                                                  LEFT Solenoid
            B T1
                                B Y201
                                                    B X104
                                                                                     B Y202
3
                                                                                     (OUT)
             When the Momentary NO center switch X104 is made - Cutting cycle is complete
       Mom NO Center
          Limit SW
                                                     1 Sided cycle
                                                        B C2
           B X104
                                                        RST
                                              Return,
```