```
1   PROGRAM Load_Scale_Station
2   VAR
3       Ons3_At_Scale           : R_TRIG ;
4       Ons4_Timer_Out          : R_TRIG ;
5       Ons5_Box_At_Entry       : R_TRIG ;
6   END_VAR
7
```

```
1   (*
2   * File: Load Scale Station
3   * Author: Jaime Calvente Mieres
4   * Date: 13-08-2022
5   * Description: Program to control the box loading into the Scale.
6   *)
7
8
9   (*
10  * If system is active allow to load boxes into the scale
11  * and set the timer to allow weighing time.
12  *)
13  IF System_Active THEN
14      // One shot declarations
15      Ons3_At_Scale ( CLK := At_Scale ) ;
16      Ons4_Timer_Out ( CLK := Load_Timer . Q ) ;
17      Ons5_Box_At_Entry ( CLK := At_Scale_Entry ) ;
18
19      // Timer instantiation
20      Load_Timer ( IN := ( At_Scale AND NOT Soft_Stop_Active ) , PT :=
    Load_Time , ET => Time_Weighing_Elap ) ;
21
22      (* Load conveyor activation when not box at scale AND
23         at scale entry OR timer output is active *)
24      IF ( Ons5_Box_At_Entry . Q AND NOT At_Scale ) OR Ons4_Timer_Out . Q THEN
25          M_Load_Convey := TRUE ;
26      END_IF
27
28      // If box at Scale sensor deactivate conveyor and SET timer
29      IF Ons3_At_Scale . Q OR Soft_Stop_Active AND ( M_Load_Convey AND
    At_Scale ) THEN
30          M_Load_Convey := FALSE ;
31      END_IF
32
33  END_IF
34
35  (* Conditions to Re-Start the program after
36  a soft stop *)
37  IF Soft_Stop_Active AND M_Load_Convey AND At_Scale THEN
38      M_Load_Convey := FALSE ;
39  END_IF
40
41
42
```