

7/29/2025

250(-1)

queuingortingconveyorfinalized

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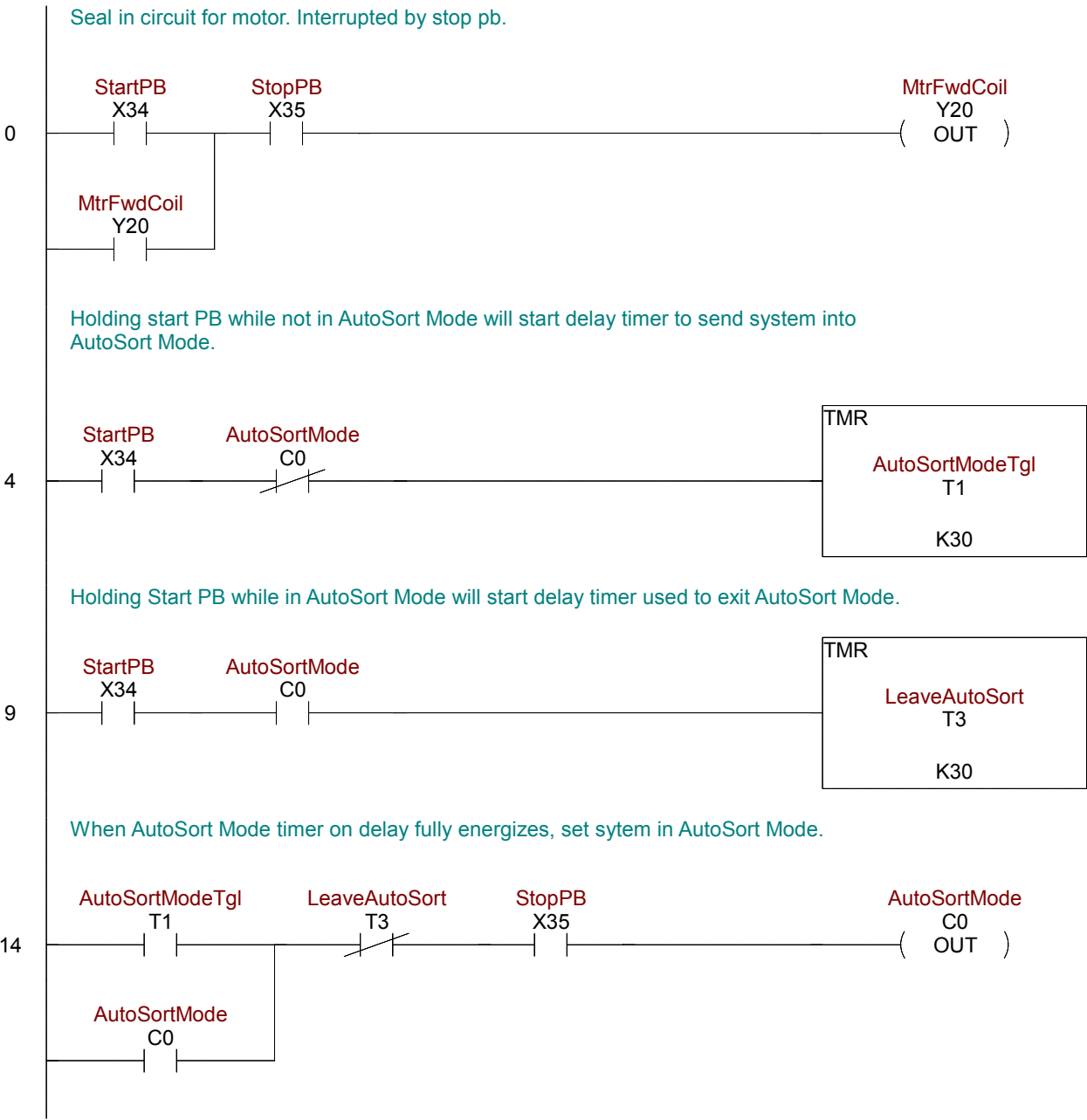
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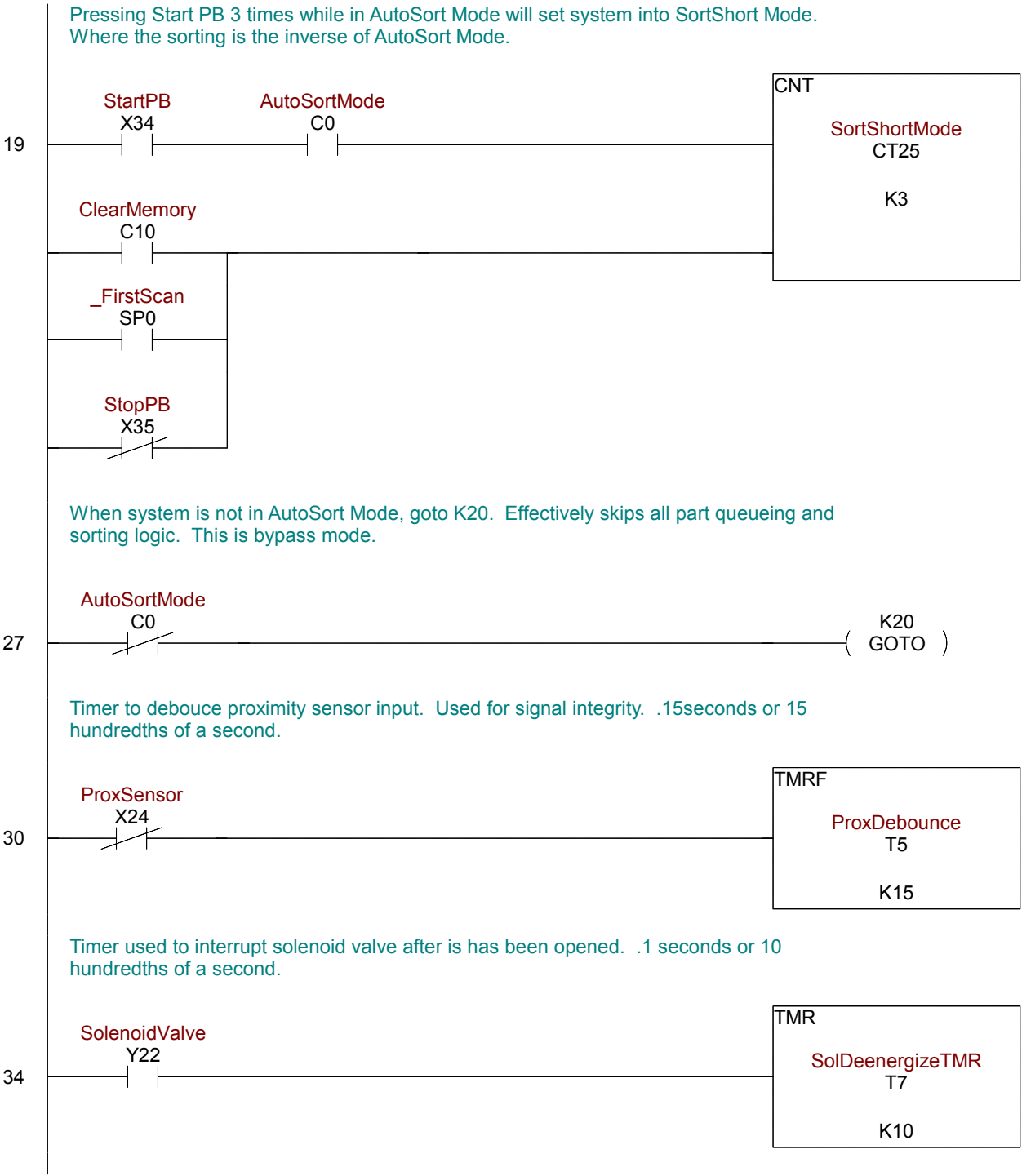
Creation Date: 07/28/25 10:12:44

PLC Type: 250(-1)

Class ID: DirectLogic 205 Series

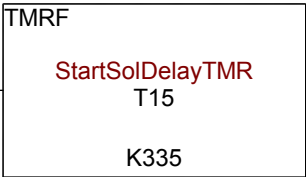
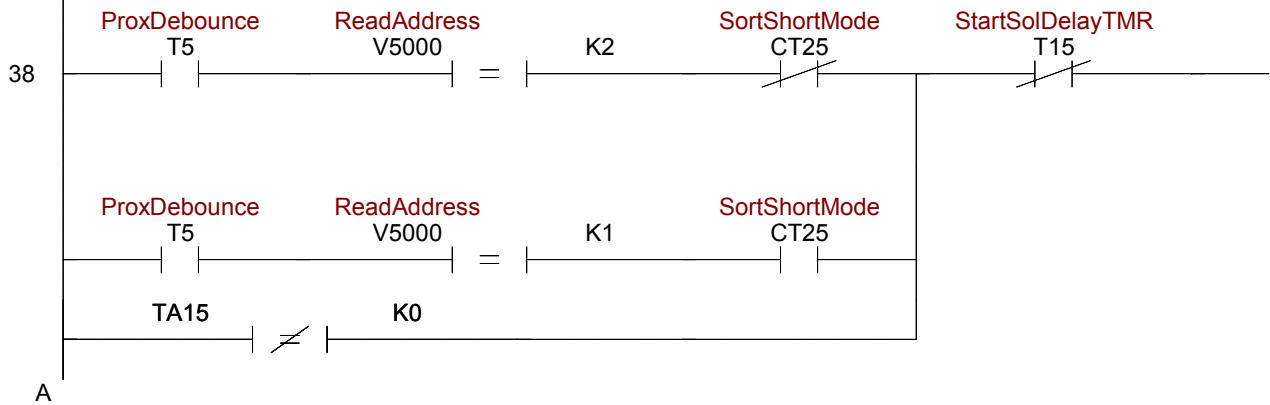
Link Name: dl_205_conn



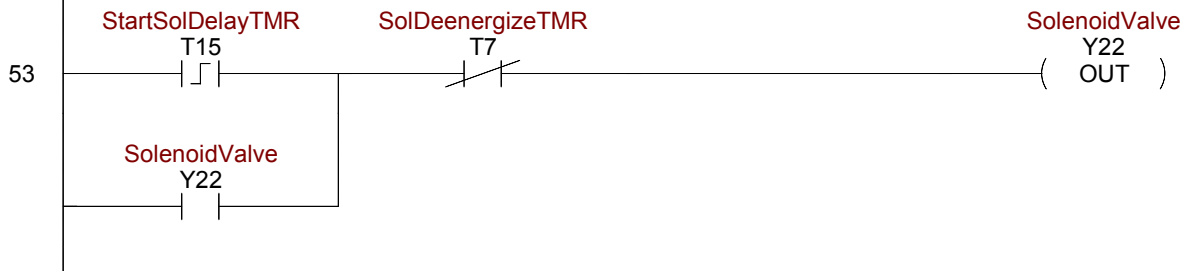


Conditions to delay start of solenoid energizing sequence. Once Prox signal detects part, if in AutoSort and top of queue has tall(2) part, start delay. If in SortShort Mode and top of queue has short(1) part, start delay.

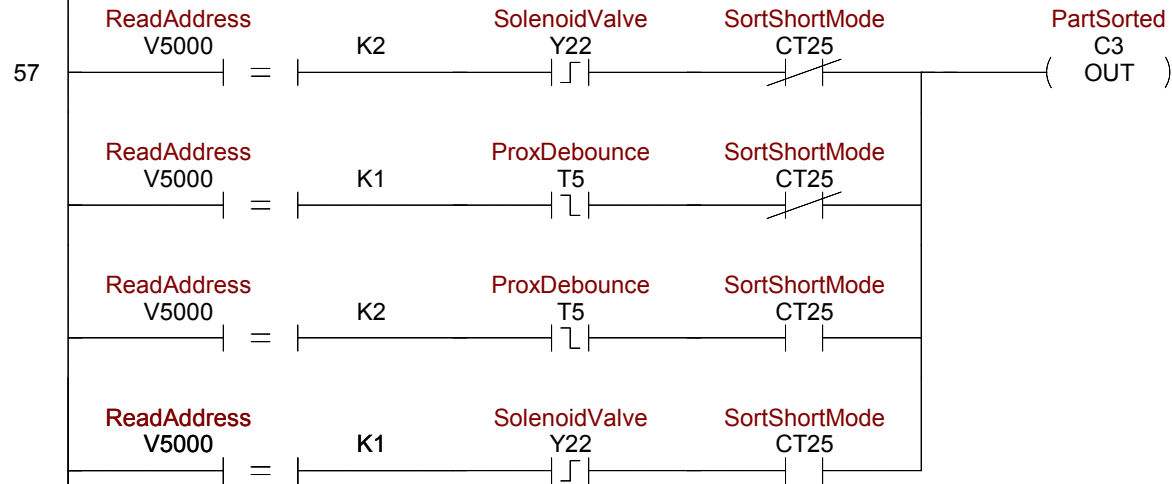
A



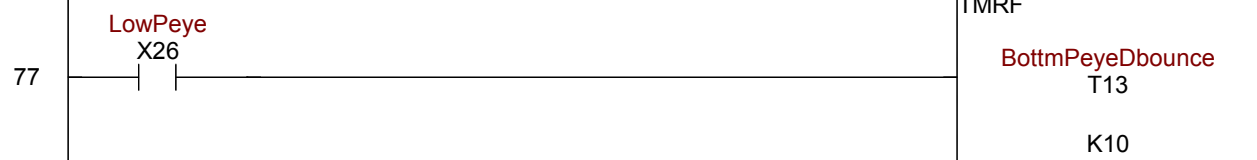
Once solenoid energize delay has completed, energize solenoid valve. Interrupted by SolDeenergizeTMR



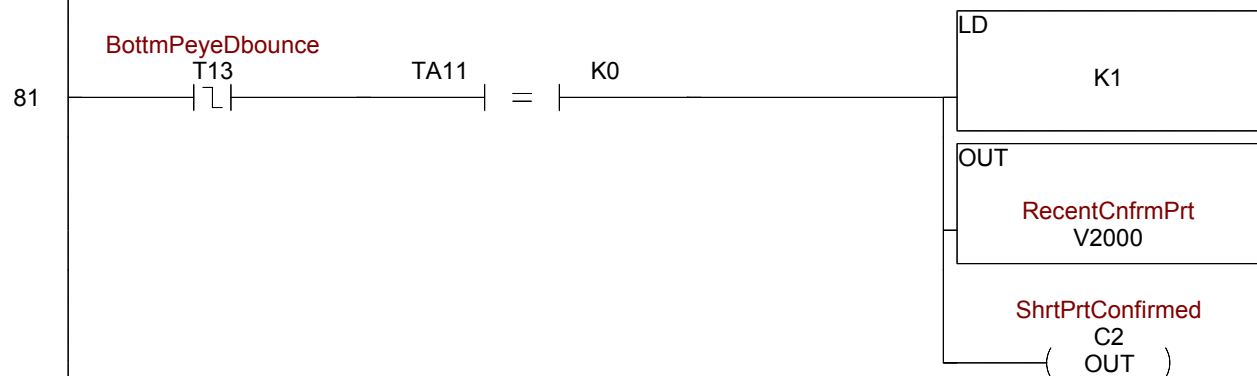
Conditions to generate part sorted bit. Conditions needed for each part type in each mode. In SortShort, generate part sorted when top of queue is 1 and sol valve has opened and closed. Generate bit when top of queue is 2 and prox sensor has detected then stop detecting part. Inverse for AutoSort Mode.



Timer to debounce lower photo eye signal. .1 seconds, 10 hundredths of a second.

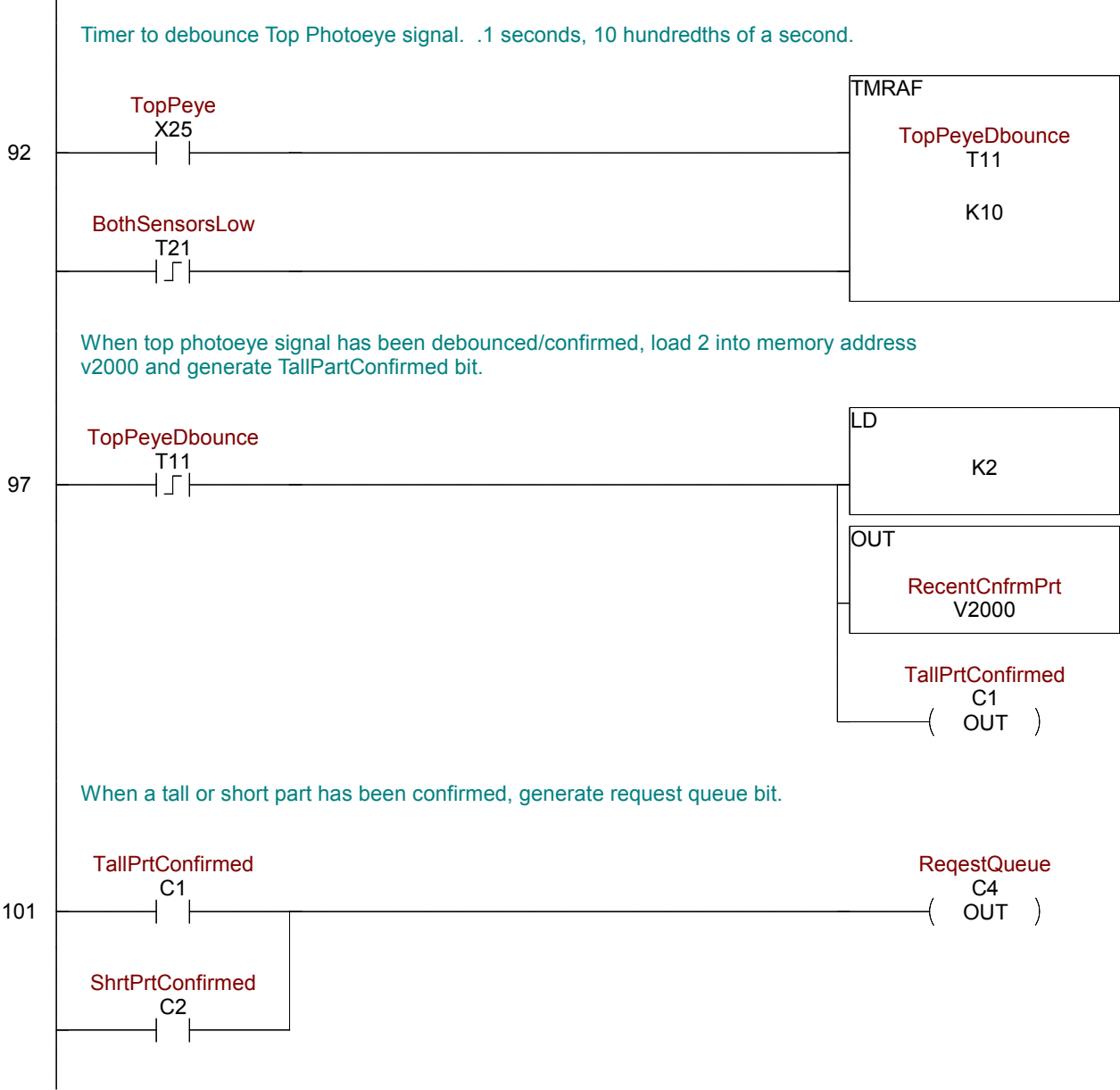


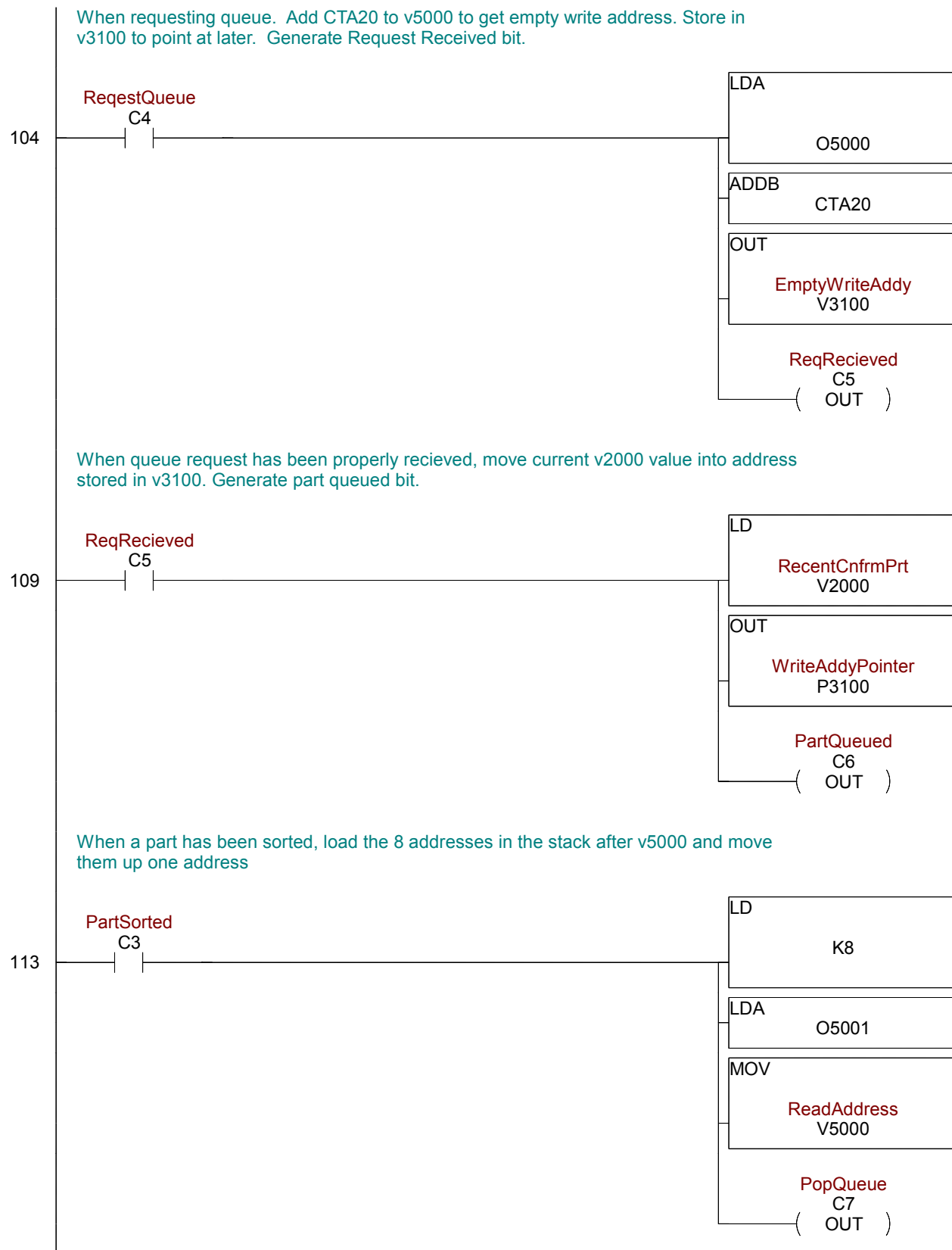
Once debounced low pEye signal has been received, move 1 into v2000 and generate ShortPartConfirmed bit.



Timer to denote when both photoeyes have been low for some time. .25 seconds, 25 hundredths of a second. Used to reset accumulating timer.

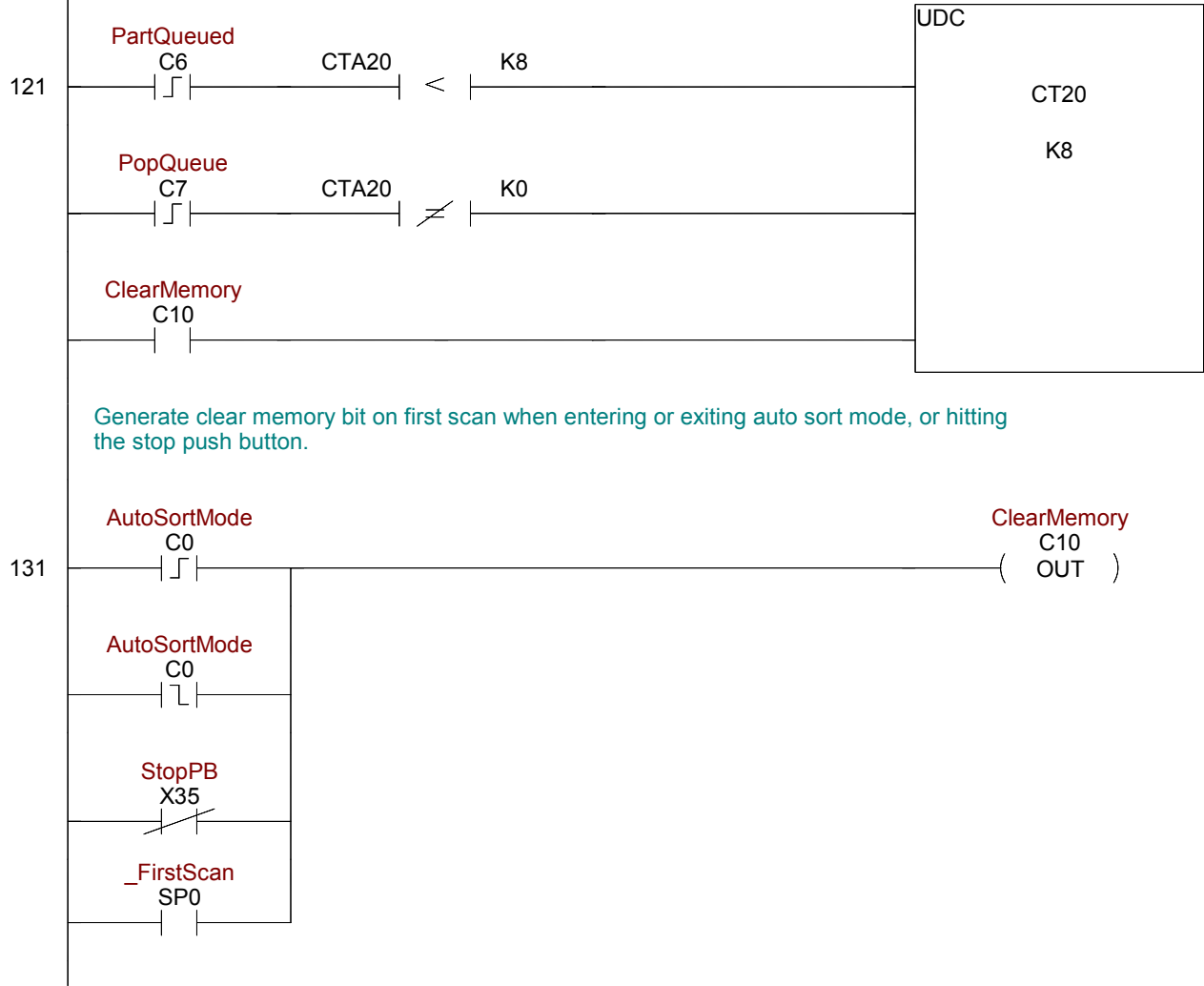






LBL
K20

Counter to help pointing towards empty write address. When a part is queued, count up, when the queue is popped, count down. Reset on multiple conditions.



Clearing memory will remove and reset all data related to queue logic.

