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Rung 1

M200 — Stepper rotating bit

DPLSY	D474	D102	Y0
	Frequency pulse	Output pulses	move metallic bowl

14

Rung 2 Row 1

M1000 — Normally open contact (a contact). This

M224

DDIV	D442	D110	D102
	Pulse per revolution	No. of Poles	Output pulses

Rung 2 Row2

DDIVR	F360.000	F20100.000	D116
			Step angle

Rung 2 Row 3

FLT	D444	D106
	RPM	RPM in float

Rung 2 Row4

DMULR	D106	F6.000	D108
	RPM in float		

Rung 2 Row5

DEDIV	D108	D116	D112
		Step angle	Frequency pulse in float

Rung 2 Row 6

DINT	D112	D474
	Frequency pulse in float	Frequency pulse

Rung 2 Row 7

X5 — cylinder_2_up_read_sw

M122

X2 — cycle start

SET	Y5
	Cylinder

88

Rung 3 Row 1

Y5 — Cylinder

X6 — cylinder_2_down_read_sw

M200 — Stepper rotating bit

SET	Y6
	Dispenser

=	C0	K1

=	C0	K2

=	C0	K3

M224

112

Rung 4 Row1

Y5 — Cylinder

X6 — cylinder_2_down_read_sw

M200 — Stepper rotating bit

TMR	T5	D450

Rung 4 Row2

MUL	D454	K10	D450

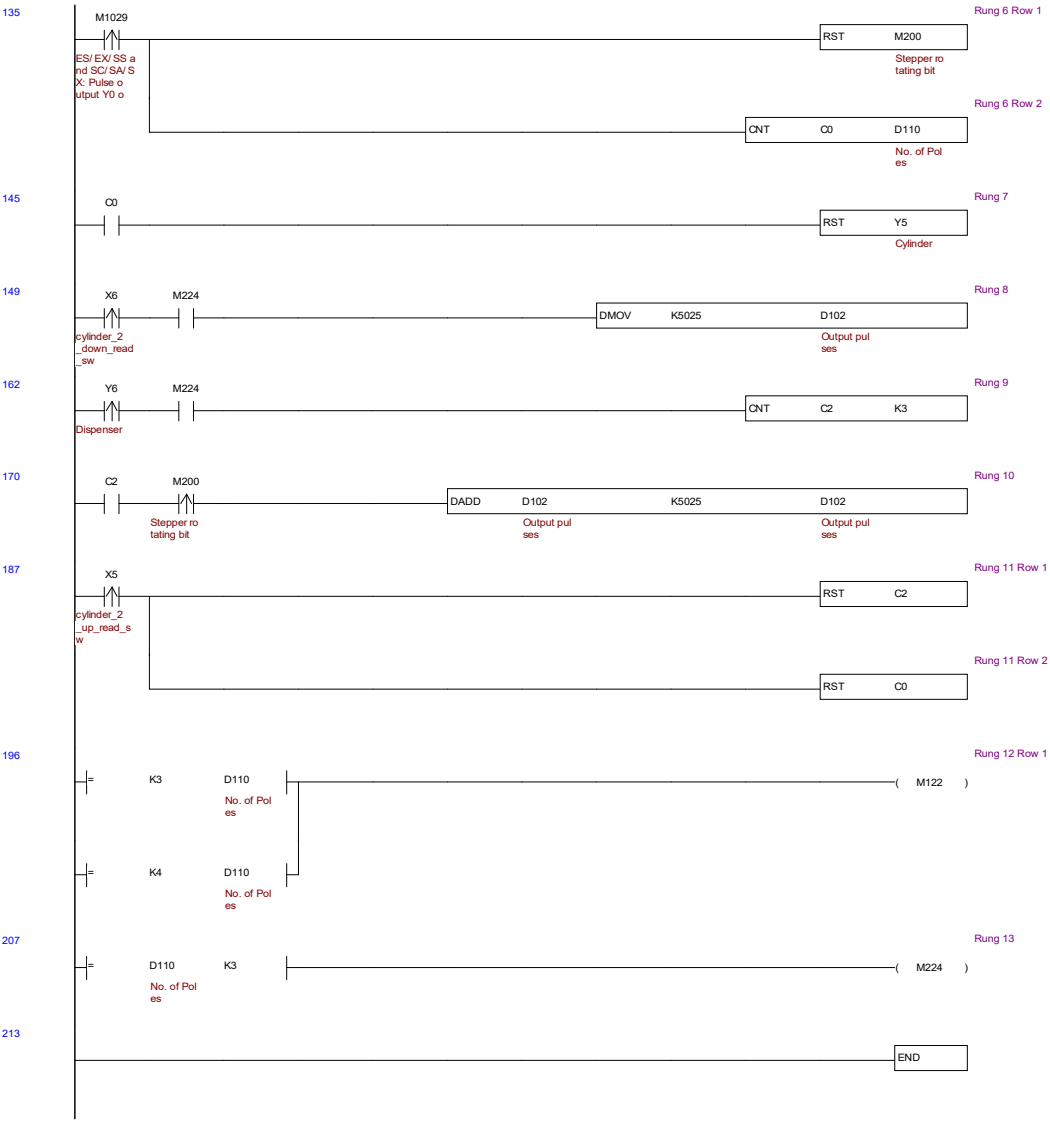
128

Rung 5 Row 1

T5

SET	M200
	Stepper rotating bit

Rung 5 Row 2

RST	Y6
	Dispenser

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