



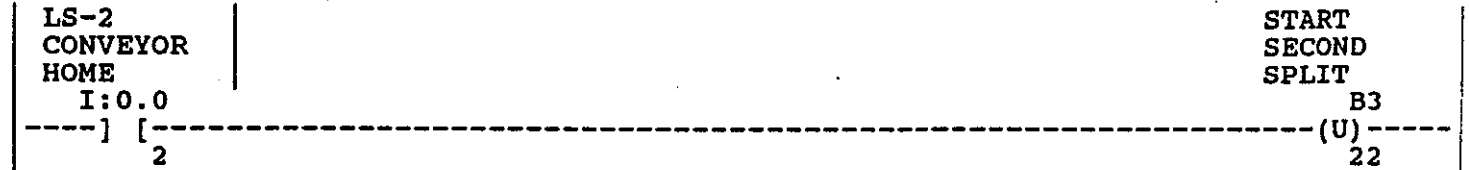


# BESSER VERTICAL-HORIZONTAL SPLITTER

HVSPLITTER LOGIC:453242 ELEM:453243 REV - 5/26/93  
 Program Listing Processor File: HVSPLIT.ACH

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 Rung 2:38

Rung 2:38  
 START SECOND SPLIT

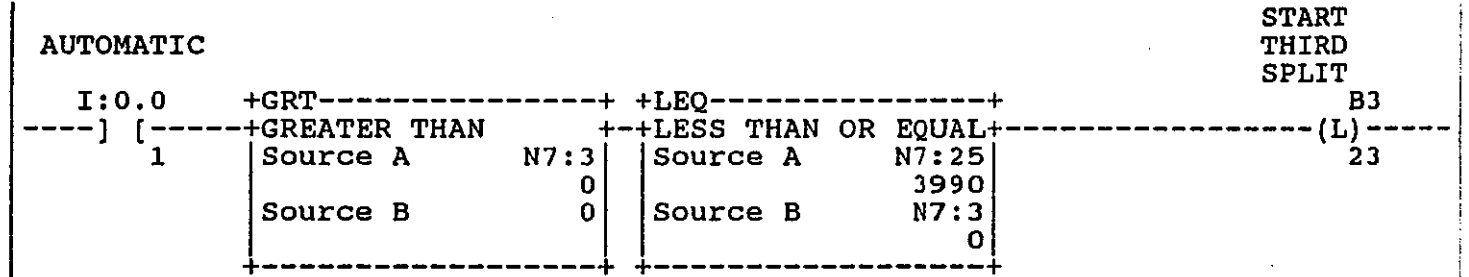


B3/22

```

-] [- 2:20 2:34 2:47 2:66
-(L)- 2:37
-(U)- 2:38
  
```

Rung 2:39  
 START THIRD SPLIT

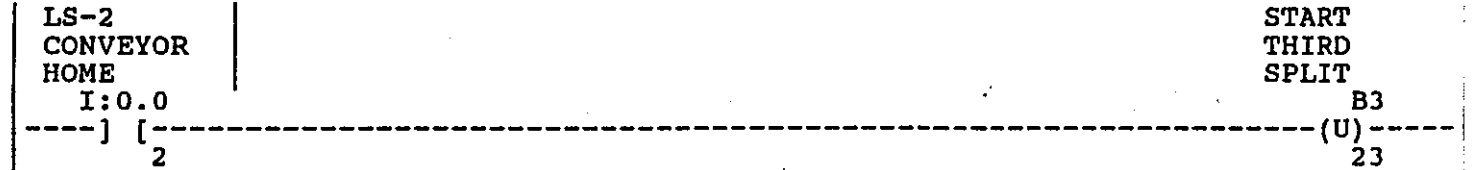


B3/23

```

-] [- 2:47 2:68
-(L)- 2:39
-(U)- 2:40
  
```

Rung 2:40  
 START THIRD SPLIT



B3/23

```

-] [- 2:47 2:68
-(L)- 2:39
-(U)- 2:40
  
```

# BESSER VERTICAL-HORIZONTAL SPLITTER

HVSPLITTER LOGIC:453242 ELEM:453243 REV - 5/26/93  
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 Rung 2:41

Rung 2:41  
 START FOURTH SPLIT

AUTOMATIC		START FOURTH SPLIT
I:0.0	+GRT-----+ +LEQ-----+	B3
] [-	+GREATER THAN +LESS THAN OR EQUAL+	(L)
1	Source A N7:4 0	24
	Source B 0	
	Source A N7:25 3990	
	Source B N7:4 0	
	-----	

B3/24

-] [- 2:47 2:70  
 -(L)- 2:41  
 -(U)- 2:42

Rung 2:42  
 START FOURTH SPLIT

LS-2 CONVEYOR HOME		START FOURTH SPLIT
I:0.0		B3
] [-		(U)
2		24

B3/24

-] [- 2:47 2:70  
 -(L)- 2:41  
 -(U)- 2:42

Rung 2:43  
 START FIFTH SPLIT

AUTOMATIC		START FIFTH SPLIT
I:0.0	+GRT-----+ +LEQ-----+	B3
] [-	+GREATER THAN +LESS THAN OR EQUAL+	(L)
1	Source A N7:5 0	25
	Source B 0	
	Source A N7:25 3990	
	Source B N7:5 0	
	-----	

B3/25

-] [- 2:47 2:72  
 -(L)- 2:43  
 -(U)- 2:44

# BESSER VERTICAL-HORIZONTAL SPLITTER

HVSPLITTER LOGIC:453242 ELEM:453243 REV - 5/26/93  
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 Rung 2:44

Rung 2:44  
 START FIFTH SPLIT

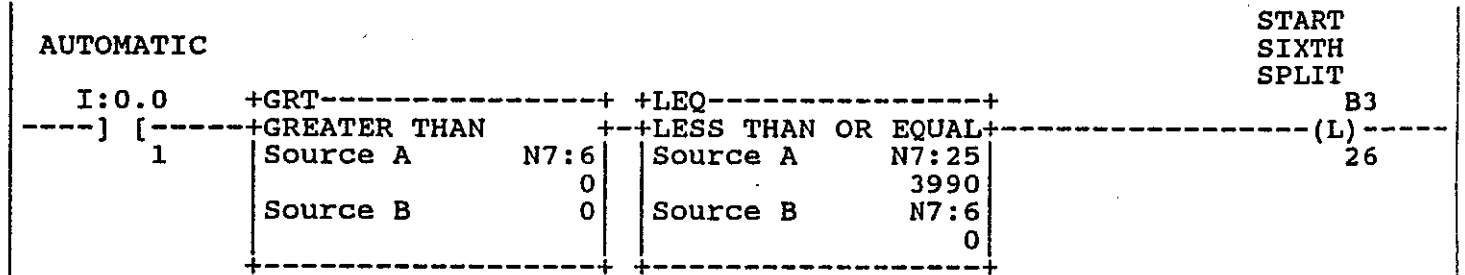


B3/25

```

-] [- 2:47 2:72
-(L)- 2:43
-(U)- 2:44
    
```

Rung 2:45  
 START SIXTH SPLIT

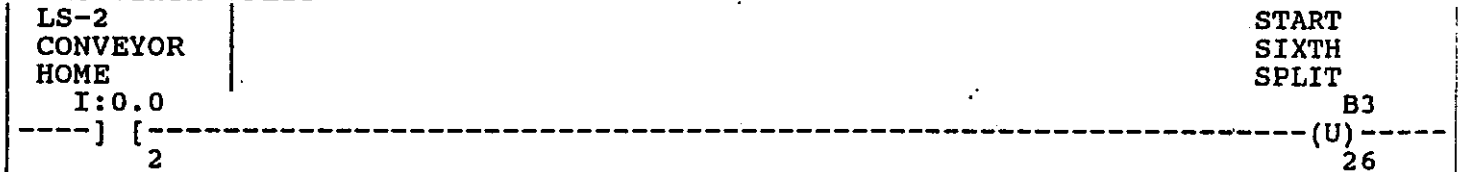


B3/26

```

-] [- 2:47 2:74
-(L)- 2:45
-(U)- 2:46
    
```

Rung 2:46  
 START SIXTH SPLIT



B3/26

```

-] [- 2:47 2:74
-(L)- 2:45
-(U)- 2:46
    
```

# BESSER VERTICAL-HORIZONTAL SPLITTER

HVSPLITTER LOGIC:453242 ELEM:453243 REV - 5/26/93  
 Program Listing Processor File: HVSPLIT.ACH

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 Rung 2:47

Rung 2:47

START SPLIT CYCLE - PUSHER BAR REVERSE ENABLE FOR VERTICAL SPLIT / START TABLE  
 UP FOR HORIZONTAL SPLIT

START FIRST SPLIT	FIRST SPLIT COMPLETE	B3	B3	B3	START SPLIT CYCLE
21	51				30
22	52				
23	53				
24	54				
25	55				
26	56				

B3/30

```

-] [- 2:48 2:50 2:52 2:53 2:54
-]/[- 2:20
-( )- 2:47
    
```

Rung 2:48

TABLE UP OUTPUT

START SPLIT CYCLE	HORIZONTAL SPLIT SELECTED	I:0.0	I:0.0	I:0.0	TABLE UP
30	11				5

O:0.0/5

```

-]/[- 2:49
-( )- 2:48
    
```

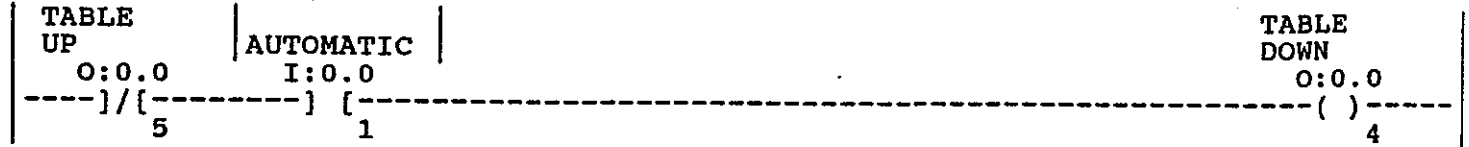
# BESSER VERTICAL-HORIZONTAL SPLITTER

HVSPLITTER LOGIC:453242 ELEM:453243 REV - 5/26/93  
 Program Listing Processor File: HVSPLIT.ACH

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 Rung 2:49

Rung 2:49

TABLE DOWN OUTPUT

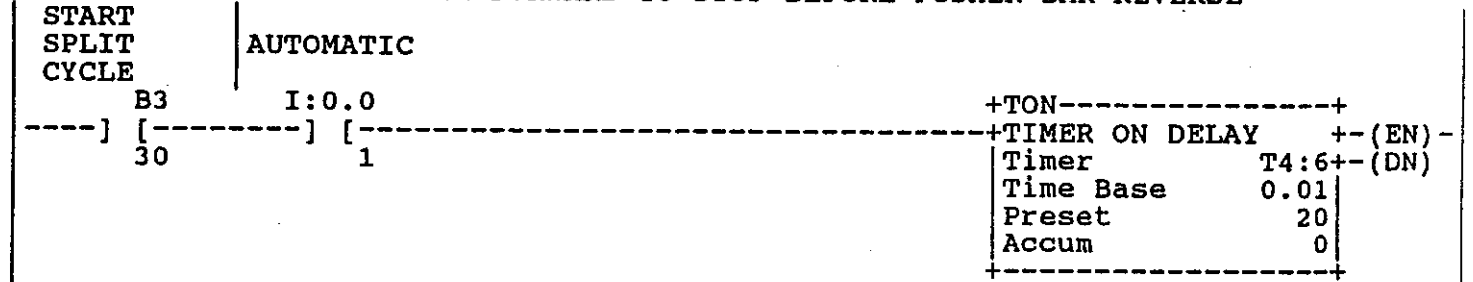


O:0.0/4

-( )- 2:49

Rung 2:50

TIME DELAY FOR PUSHER BAR FORWARD TO STOP BEFORE PUSHER BAR REVERSE

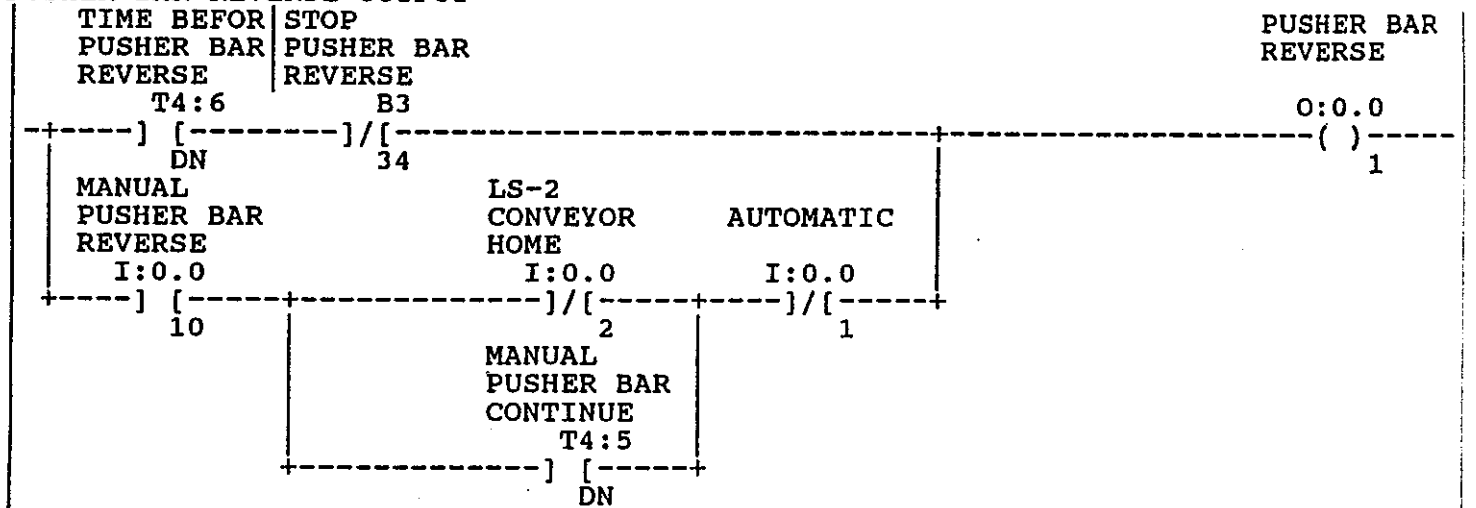


T4:6

-TON- 2:50

Rung 2:51

PUSHER BAR REVERSE OUTPUT



O:0.0/1

-] [- 2:1 2:2  
 -( )- 2:51





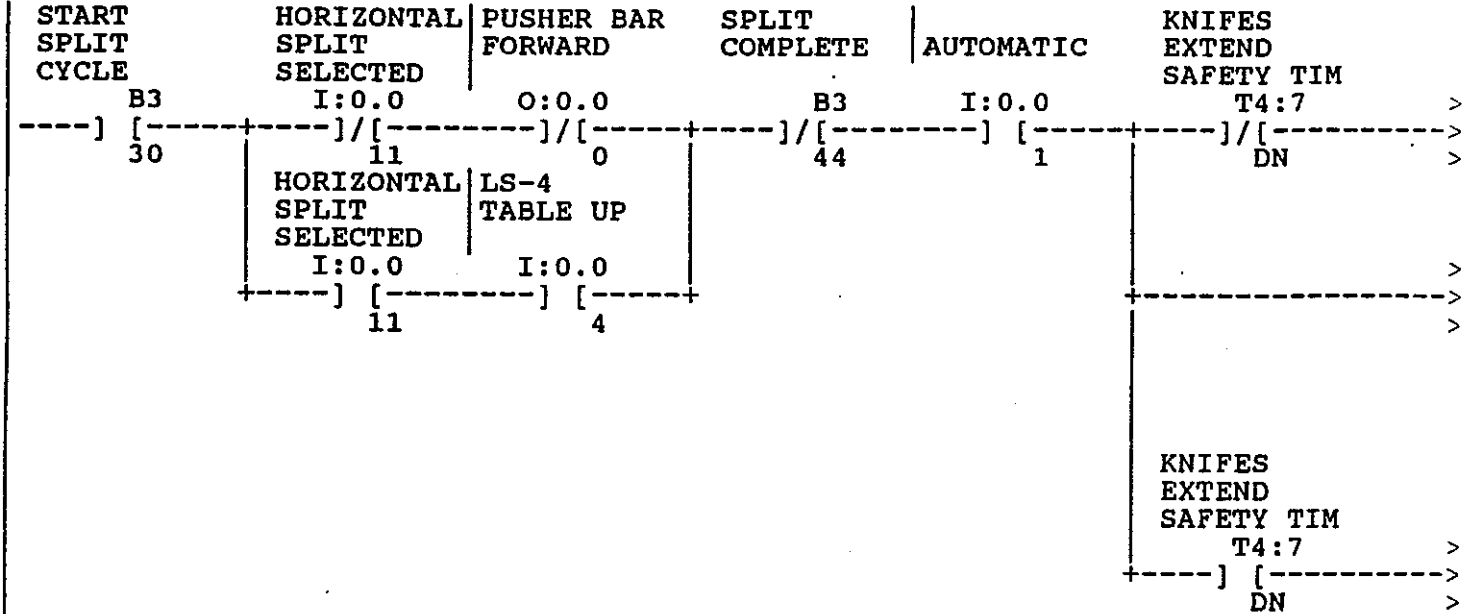
# BESSER VERTICAL-HORIZONTAL SPLITTER

HVSPLITTER LOGIC:453242 ELEM:453243 REV - 5/26/93  
 Program Listing Processor File: HVSPLIT.ACH

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 Rung 2:54

Rung 2:54

KNIFES EXTEND OUTPUT



KNIFES  
EXTEND

```

< 0:0.0
<----( )-----+
< 3
    
```

```

< +TON-----+
<+TIMER ON DELAY +- (EN) +-
< Timer T4:7+- (DN)
  Time Base 0.01
  Preset 300
  Accum 0
    
```

```

< +TON-----+
<+TIMER ON DELAY +- (EN) +-
< Timer T4:8+- (DN)
  Time Base 0.01
  Preset 100
  Accum 0
    
```

# BESSER VERTICAL-HORIZONTAL SPLITTER

HVSPLITTER LOGIC:453242 ELEM:453243 REV - 5/26/93  
 Program Listing Processor File: HVSPLIT.ACH

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 Rung 2:55

0:0.0/3  
     -] [- 2:12 2:13 2:55  
     -]/[- 2:20 2:61  
     -( )- 2:54

T4:7  
     -TON- 2:54

T4:8  
     -TON- 2:54

Rung 2:55  
 KNIFES HAVE LEFT HOME POSITION

KNIFES EXTEND	TIME BEFOR PRESSURE FWD OFF	T4:2			KNIFES HAVE LEFT HOME
0:0.0					B3
-----] [-----	-----] [-----	-----] [-----			(L)-----
3		DN			40

B3/40  
     -] [- 2:57  
     -(L)- 2:55  
     -(U)- 2:56

Rung 2:56  
 KNIFES HAVE LEFT HOME POSITION

SPLIT CYCLE COMPLETE					KNIFES HAVE LEFT HOME
B3					B3
-----] [-----	-----] [-----				(U)-----
50					40

B3/40  
     -] [- 2:57  
     -(L)- 2:55  
     -(U)- 2:56

Rung 2:57  
 KNIFES HAVE PRESSURE ON BLOCK

KNIFES HAVE LEFT HOME	LS-5 PRESSURE SWITCH	I:0.0			KNIFES HAVE PRESS ON BLOCK
B3					B3
-----] [-----	-----] [-----	-----] [-----			(L)-----
40		5			42

B3/42  
     -] [- 2:59  
     -(L)- 2:57  
     -(U)- 2:58

**BESSER VERTICAL-HORIZONTAL SPLITTER**

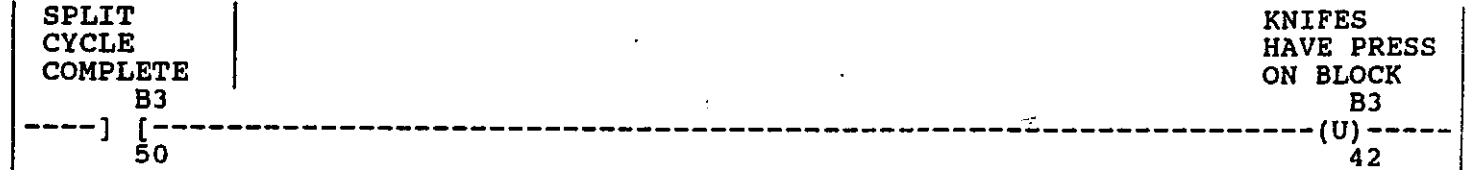
---

HVSPLITTER LOGIC:453242 ELEM:453243 REV - 5/26/93  
 Program Listing Processor File: HVSPLIT.ACH

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 Rung 2:58

Rung 2:58

KNIFES HAVE PRESSURE ON BLOCK

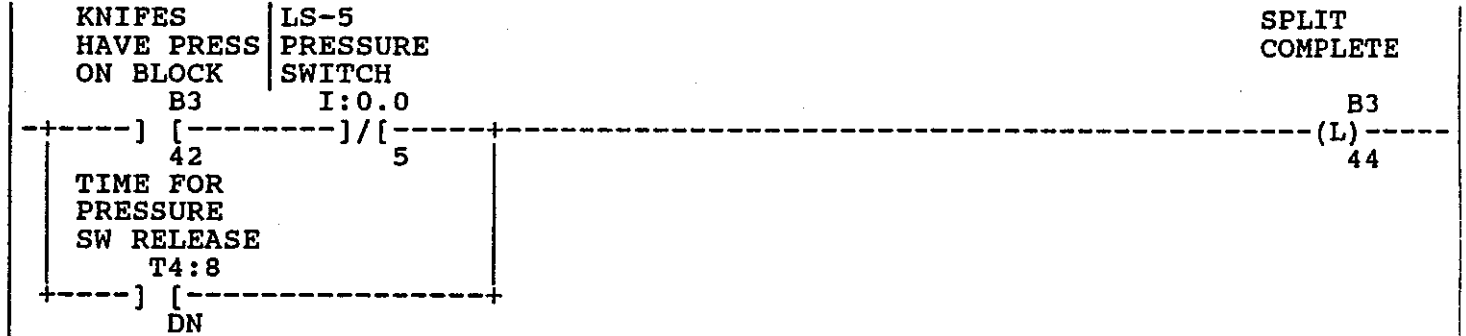


B3/42

-] [- 2:59  
 -(L)- 2:57  
 -(U)- 2:58

Rung 2:59

SPLIT COMPLETE



B3/44

-] [- 2:63  
 -] / [- 2:54  
 -(L)- 2:59  
 -(U)- 2:60

Rung 2:60

SPLIT COMPLETE



B3/44

-] [- 2:63  
 -] / [- 2:54  
 -(L)- 2:59  
 -(U)- 2:60