Flowchart of PLC Program

Wait for First 4 Pans
- Photo-Eye #1 Triggered?
  - YES
  - Triggered for 3 sec or more?
    - YES
    - Open Valve #1
    - Correct Amount Dispensed? (Timed)
      - YES
      - Close Valve #1
    - NO
  - NO
- NO

Fill First 4 Pans
- Open Valve #1
- Correct Amount Dispensed? (Timed)
  - YES
  - Close Valve #1
- NO

Wait for Last 4 Pans
- Photo-Eye #2 Triggered?
  - YES
  - Triggered for 3 sec or more?
    - YES
    - Open Valve #2
    - Correct Amount Dispensed? (Timed)
      - YES
      - Close Valve #2
    - NO
  - NO
- NO

Fill Last 4 Pans
- Open Valve #2
- Correct Amount Dispensed? (Timed)
  - YES
  - Close Valve #2
- NO

Release Pans
- Release Pans: (Drop Catch)
  - YES
  - Have The 8 Pans Cleared the Catch?
    - YES
    - Release Pneumatic Stop
  - NO
- NO

Wait 2 Sec
- Activate Pneumatic Stop
- YES
- Release Pneumatic Stop
- NO