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Additional internal memory:

Tag	Data Type	Counts items
COUNT1	COUNTER	

Count 100 items. When 100 items have been counted, latch CYL410.  
When PB421 is activated, unlatch CYL410.

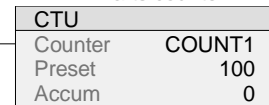
Counter resets itself after reaching 100 items so that more items can be counted while CYL410 is on.

Proximity switch, on  
when part passes

PROX412

<Local:1:I.Data.3>

Parts counter



(CU)

(DN)

Push button switch  
that is on when  
pressed

PB421

<Local:1:I.Data.5>

Pneumatic cylinder  
control

CYL410

<Local:2:O.Data.7>

Parts counter

COUNT1.DN

Pneumatic cylinder  
control

CYL410

<Local:2:O.Data.7>

Must wait to reset counter until after the DN bit used to latch CYL410

Parts counter

COUNT1.DN

Parts counter

COUNT1

(RES)

(End)