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Parts Transfer Station Control

Additional internal memory:

Tag	Data Type	
Step_1 to Step_4	BOOL	Step-in-progress bits
Motor1_Tmr	TIMER	Turntable turn timer
Parts_Ctr	COUNTER	Parts counter

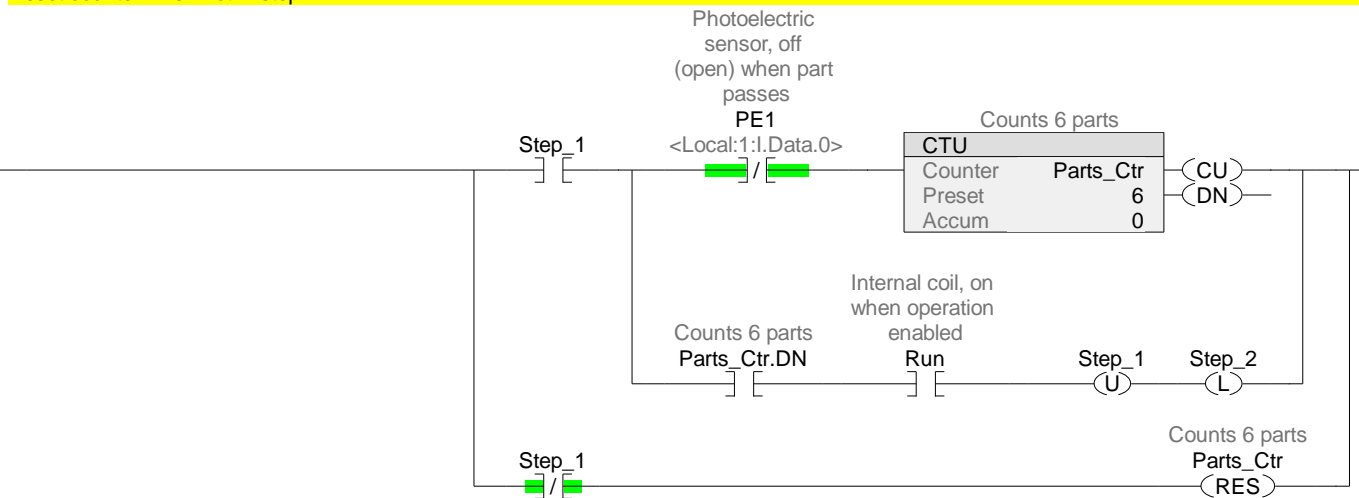
Initial Start

Internal coil, on
when operation
enabled

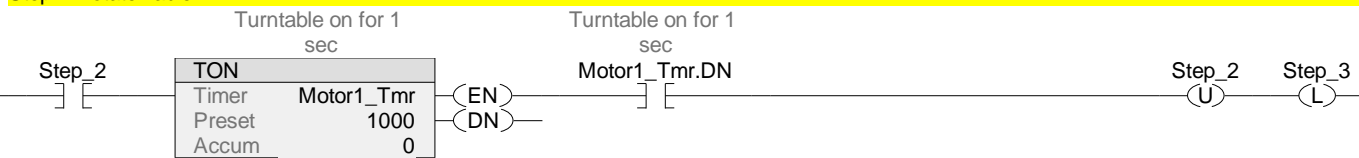


Step 1 Count parts

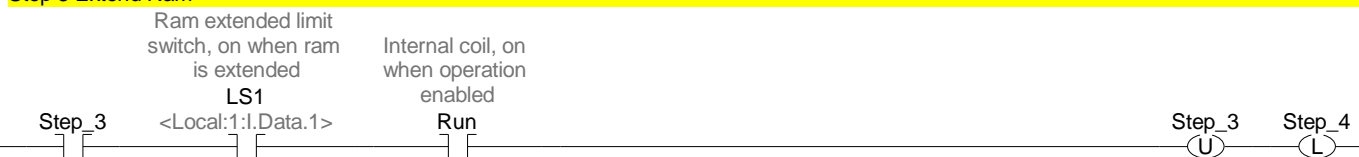
Reset counter when not in step 1



Step 2 Rotate Table



Step 3 Extend Ram



Step 4 Retract Ram



