

Main

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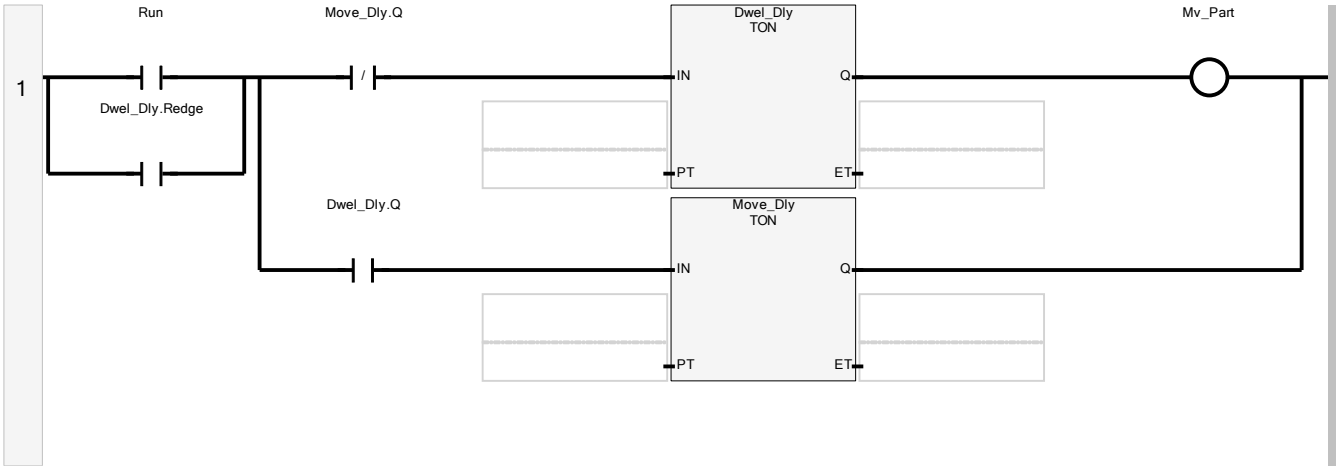
Main 3

Main

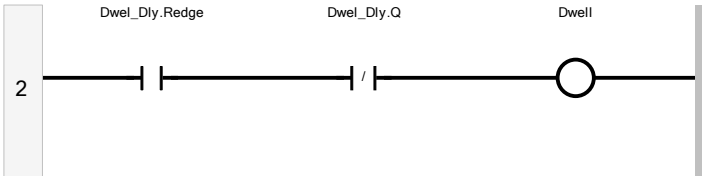
Rung1 Diagram

Example 8.1

Generate part dwell and part move indications. If Run turns off, finish cycle.

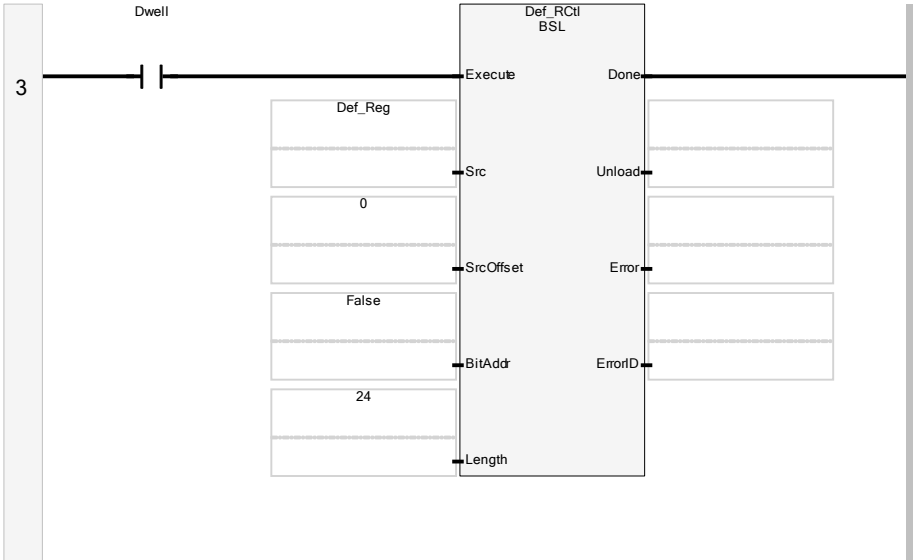


Rung2 Diagram



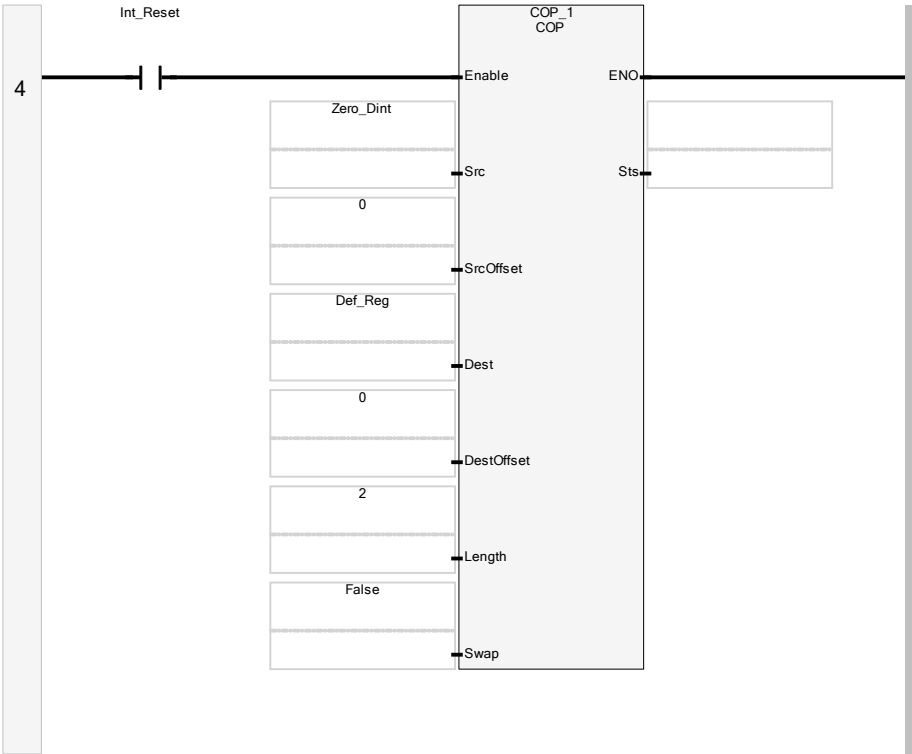
Rung3 Diagram

Shift defect indications left one position. Always shift in a false.



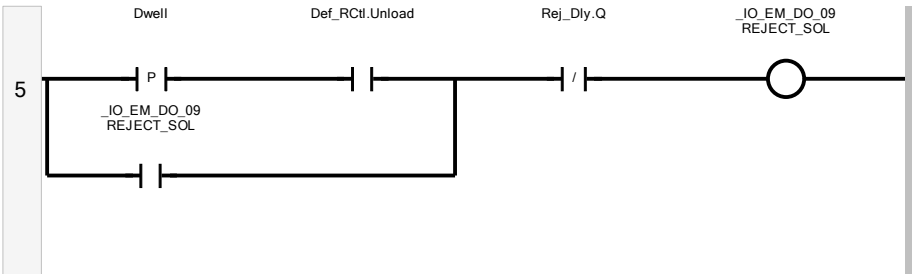
Rung4 Diagram

Initialize shift register by clearing both words.

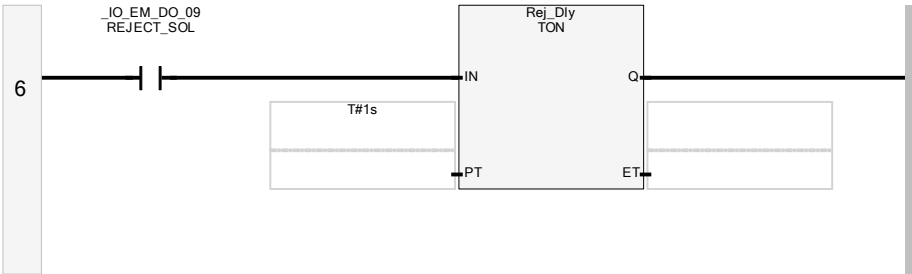


Rung5 Diagram

If defective at station 25 (shift reg .UL bit), hold sol. for 1 sec. to kick it off.



Rung6 Diagram



Rung7 Diagram

Set station 10 defect on rising edge of when part is moved.

