

Main

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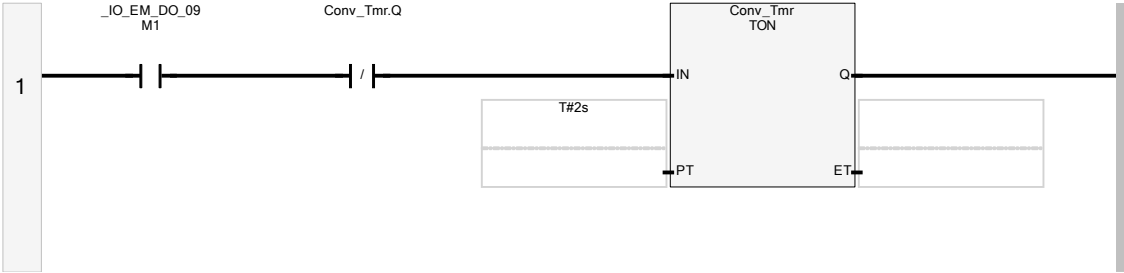
Main

Rung1 Diagram

Example 8.2

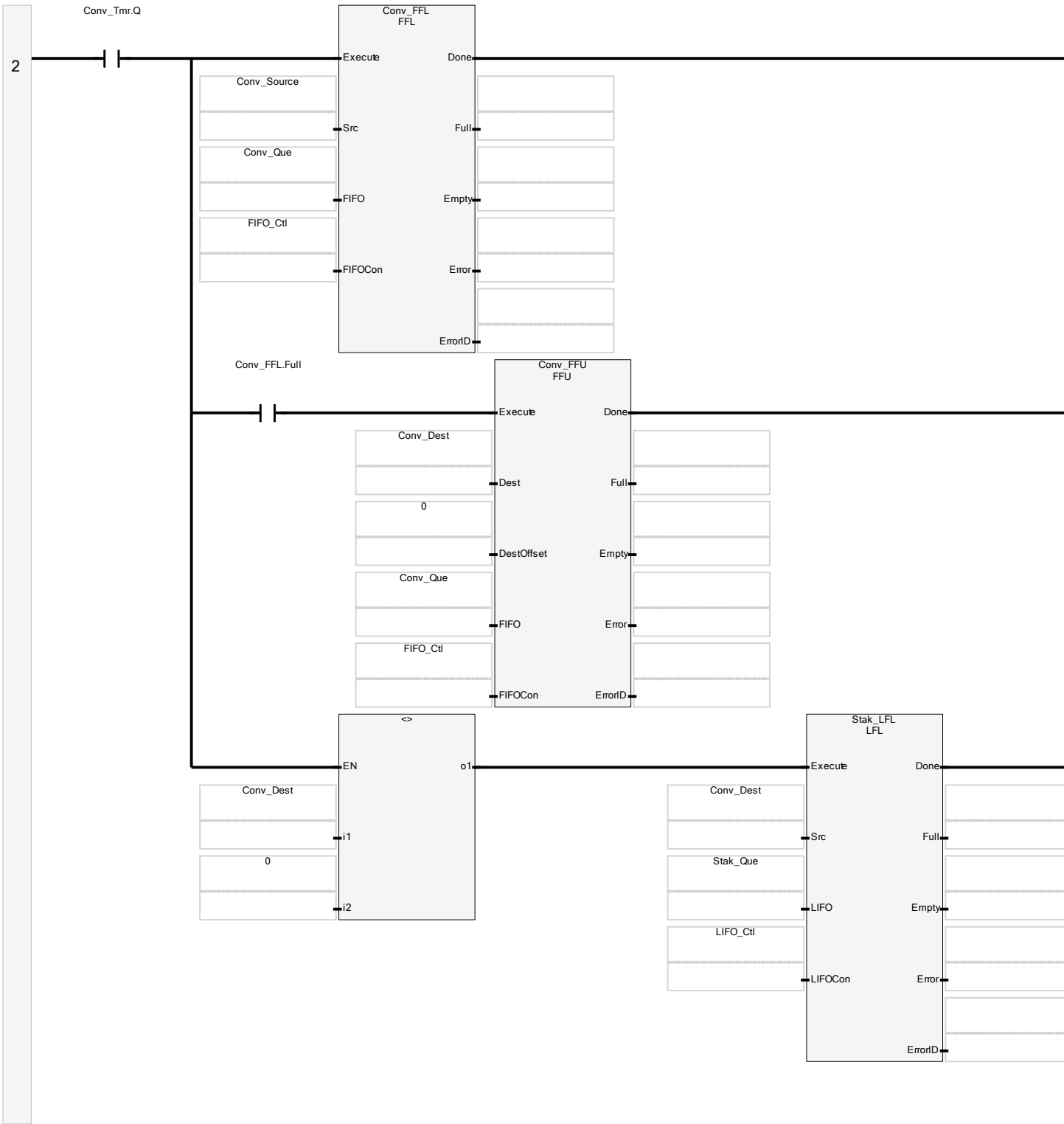
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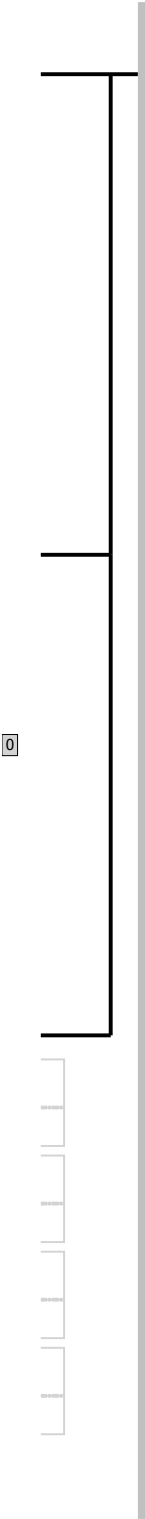
Generate FIFO shift pulse.



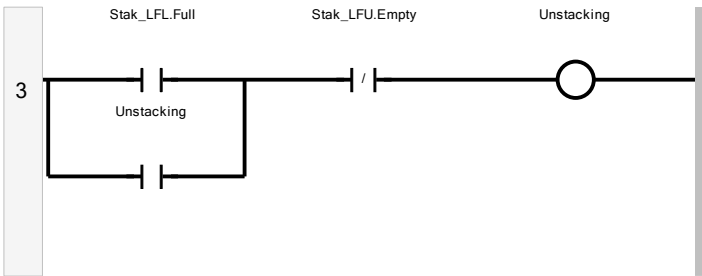
Rung2 Diagram

Shift conveyor position, loading FIFO. When FIFO full, unload. If non-zero part number comes out of FIFO, load in onto LIFO



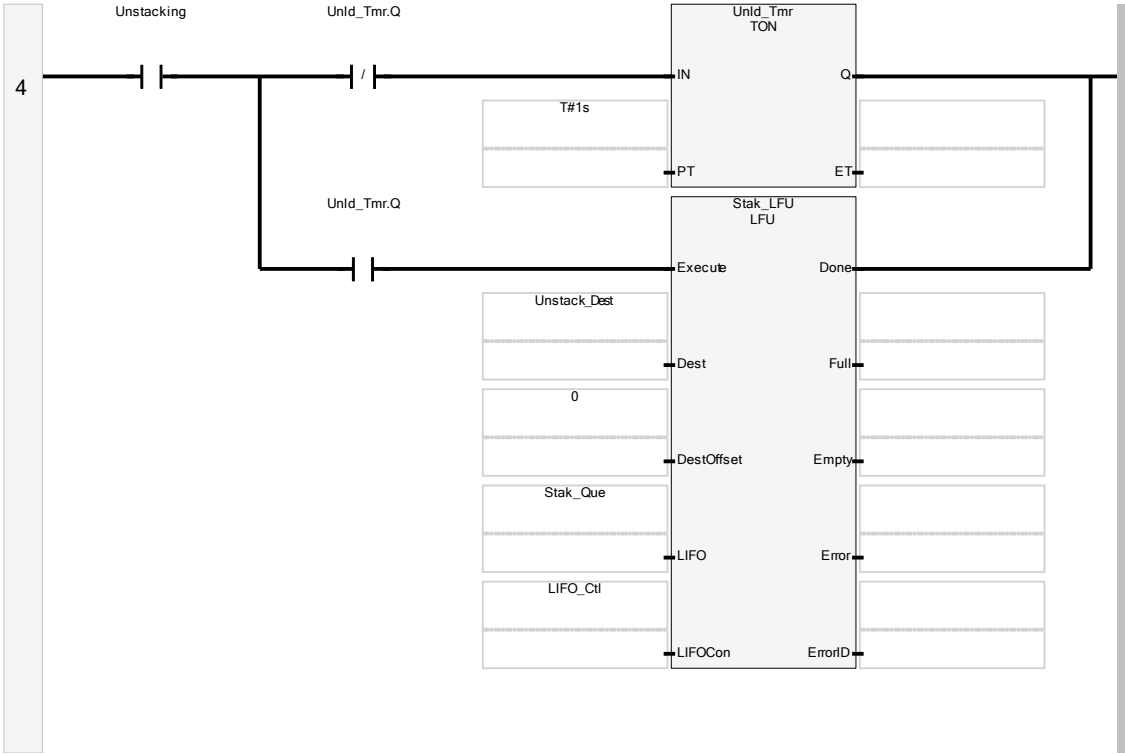


Rung3 Diagram
When stack is full, then start unstacking. When empty, stop unstacking.



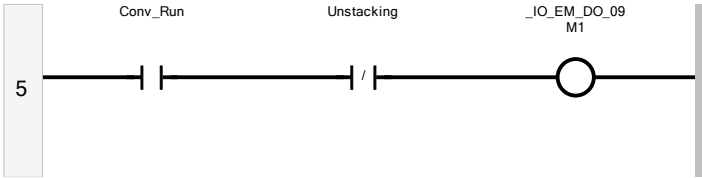
Rung4 Diagram

While unstacking, unload one item every second.



Rung5 Diagram

Conveyor motor control. Do not run when unstacking.



Rung6 Diagram

Initialize FIFO and LIFO by clearing position.

