Example 5.7 - Cell part counter

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0000

Part into cell
PART_IN
I:0/10

Cell part counter
PART_CTR
CTU
Count Up
Counter C5:4
Preset 25<
Accum 0<
CU
DN

0001

Part out of workcell
PART_OUT
I:0/11

Cell part counter
PART_CTR
CTD
Count Down
Counter C5:4
Preset 25<
Accum 0<
CD
DN

0002

Cell part counter
PART_CTR/DN
C5:4/DN

Cell has 25 parts
CELL_25P
O:0/10

0003

Reset cell counter
RESET_CTR
B3/111

Cell part counter
PART_CTR
C5:4
RES

0004

Cell part counter
PART_CTR.ACC
EQU
Equal
Source A C5:4.ACC
0<
Source B 0
0<

Cell has zero parts
CELL_ZRP
O:0/11

0005

END

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