

Example 5.7

Track parts in process in work cell

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0

[NOP]

1

Senses part entering
work cell
PART_IN
<Local:1:I.Data.11>

Counts workcell
parts

CTU	
Counter	Part_Ctr
Preset	25
Accum	0

(CU)
(DN)

2

Senses part exiting
work cell
PART_OUT
<Local:1:I.Data.12>

Counts workcell
parts

CTD	
Counter	Part_Ctr
Preset	25
Accum	0

(CD)
(DN)

3

Counts workcell
parts
Part_Ctr.DN

Indicates at least
25 parts in cell
CELL_25P
<Local:2:O.Data.8>

()

4

Clears part count
RESET_CTR

Counts workcell
parts

Part_Ctr
(RES)

5

CMP	
Expression	Part_Ctr.ACC=0

Indicates no parts
in cell
CELL_ZRP
<Local:2:O.Data.9>

()

(End)