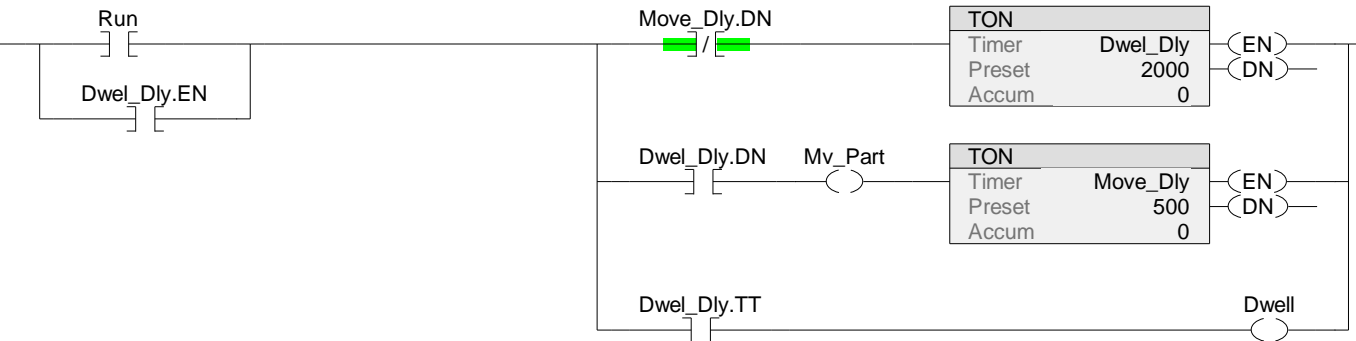


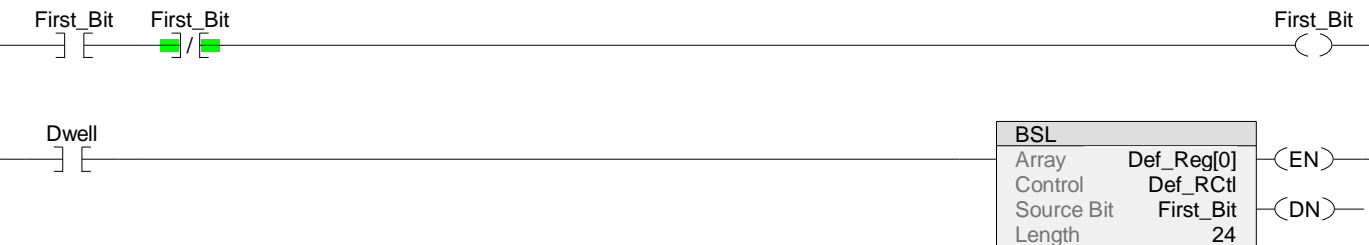
Example 8.1 - Defect Tracking

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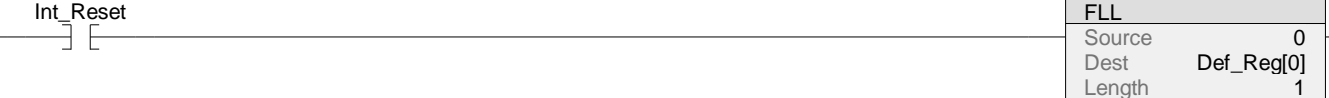
Generate part dwell and part move indications. If Run turns off, finish cycle.



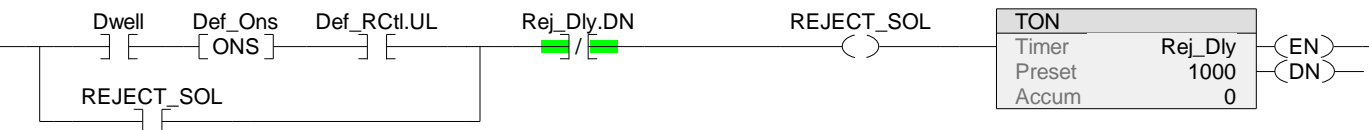
Shift defect indications left one position. Always shift in a zero.



Initialize shift register by clearing double integer.



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



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



(End)