1 Example 8.2. Part Tracking and Stacking.

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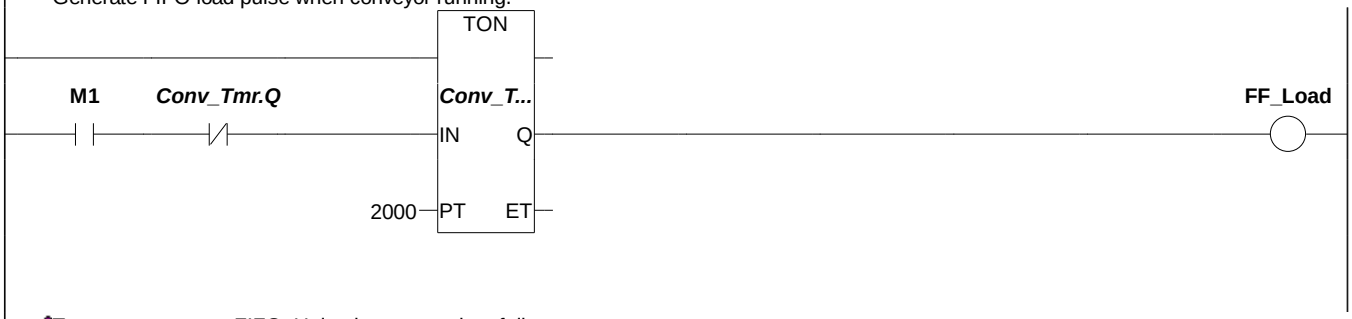
.

Generate FIFO load pulse when conveyor running.

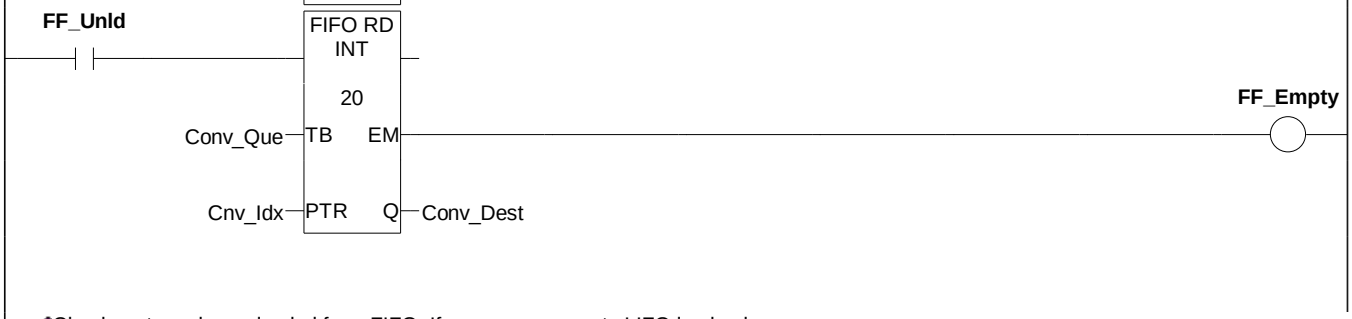
2



3 Transport conveyor FIFO. Unload one part when full.

4

5



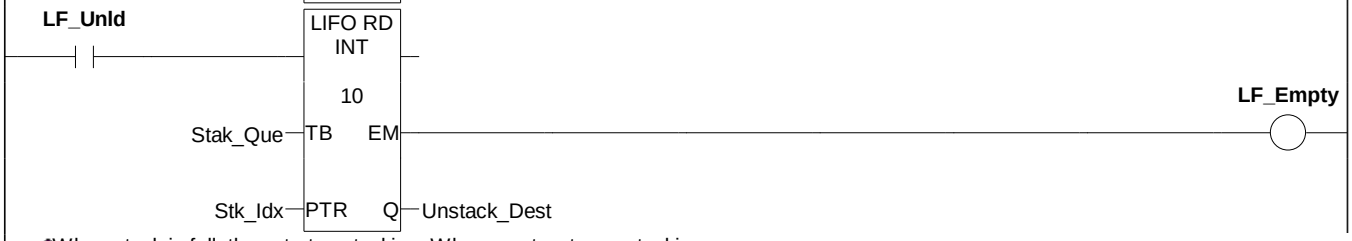
6 Check part number unloaded from FIFO. If non-zero, generate LIFO load pulse.

7

8 Stacking LIFO. Unload when full.

9

10



11 When stack is full, then start unstacking. When empty, stop unstacking.

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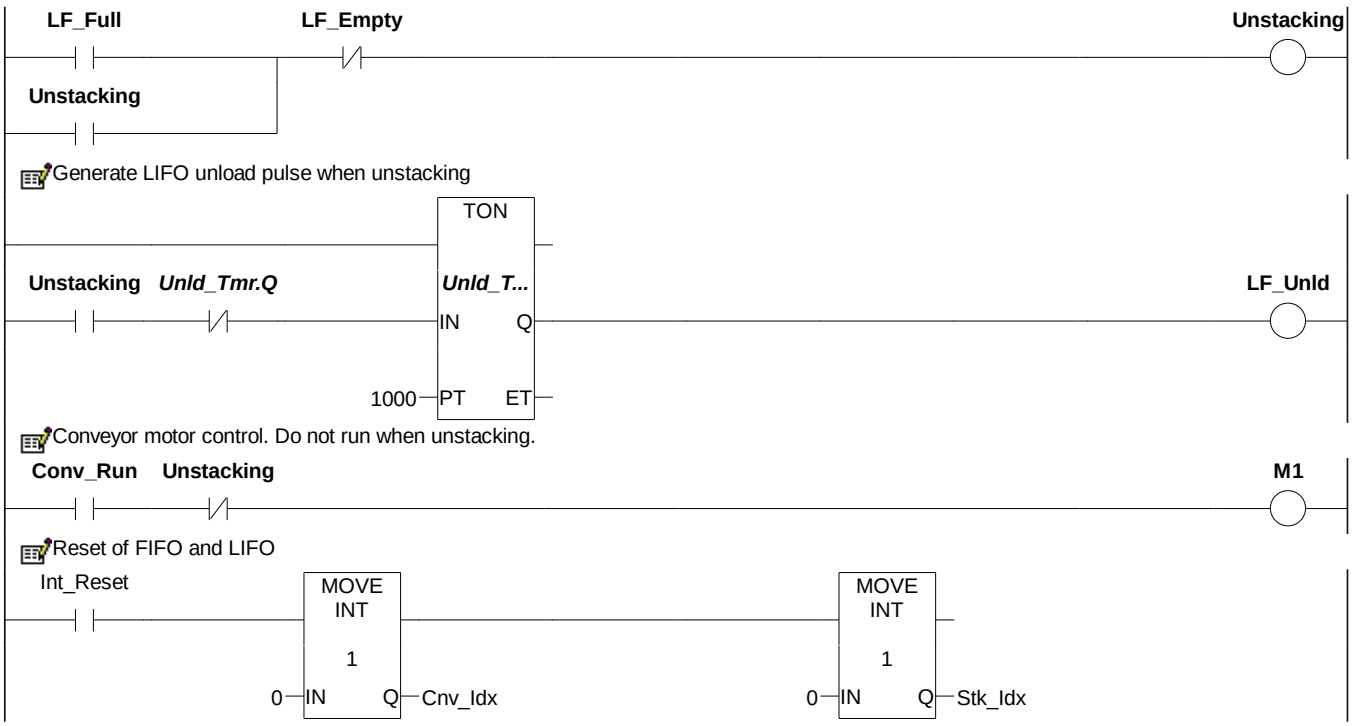

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