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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