Packaging Line 1

When Start Button is pressed the box conveyor moves. Upon detection of box present, the box conveyor stops and the apple conveyor starts. Part sensor will count for 10 apples. Apple conveyor stops and box conveyor starts again. Counter will be reset and operation repeats until Stop Button is pressed.

Apple Present Sensor

Apple Conveyor

Box Present Sensor

Box Conveyor

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1 *Start condition*

```
StartButton    StopButton                                              LineRun
   ┤ ├           ┤/├                                                    ( )

 LineRun
   ┤ ├
```

2 *Apple conveyor*

```
 LineRun      BoxConveyorRun                                      AppleConveyorRun
   ┤ ├            ┤/├                                                  ( )
```

3 *Count parts(apples). Counter preset at 10*

```
                        ctuParts
 ApplePresent            CTU
    ┤ ├          CU      123      Q
                          ↑       CV ─
 BoxPresent
    ┤/├          RESET
         10 ─    PV
```

4 *Box conveyor*

```
 ctuParts.Q    LineRun                                            BoxConveyorRun
    ┤ ├          ┤ ├                                                   ( )

 BoxPresent
    ┤/├
```