Velocity = previous part

yes

Calculate velocity

Collect data

Beam broken?

Red LED on

Green LED off

Press select on LCD

Knob Turned for quantity

LCD displays “Select Quantity”

Green LED on

Red LED off

Sensor sees part

LCD display “LOAD”

Red LED on

Vibration Bowl on

Press Select

Select part

Start

Press Load

Next part

no

Rotate trough to discard

Adjust bowl velocity

Rotate trough to dispense

Dispense cup

Red Led change to Green

Gate open

no

wait

Dispense Parts

LCD message “Push dispense door “

Drop part

Access door opened ?

yes

Dispense chute

no

Start/ continue count

Counter = Input