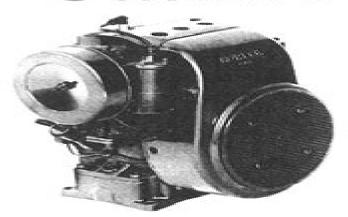


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double acting cylinder is used to perform maching operation pneumatic cylinder is advanced by pressing two push buttons simultaneously if any one of the push button is released cylinder comes back to start

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the physical contacts and coils are replaced with memory bits let s take a look for this program the relay logic s ladder diagram is duplicated with ladder logic no more hard wired logic but memory locations instead

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