Second Position Down. TIP

```
329            SetDO(douMainArmGrip,OFF)
330        END_IF
331        IF bSimpleFlowChart = FALSE THEN
332            //170725 add WJM
333            Increment(palletcountY)
334            IF pallet1.numberOfParts[1] = palletcountY THEN
335                palletcountX := palletcountX + 1
336                palletcountY := 0
337            END_IF
338            IF pallet1.numberOfParts[0] = palletcountX THEN
339                palletcountZ := palletcountZ + 1
340                palletcountX := 0
341            END_IF
342            IF pallet1.numberOfParts[2] = palletcountZ THEN
343                palletcountZ := 0
344            END_IF
345            Increment(palletcount)
346        END_IF
347    END_IF
```

Line 331's IF statement represents a Simple Flow Chart, which indicates Dry Cycle Mode. In other words, when Dry Cycle is turned on, this condition is evaluated as false and skipped.

Therefore, it is recommended to change the condition to IF TRUE THEN to ensure that it is always evaluated as true. However, it is recommended to keep the existing Line 331 code commented out for future reference.

```
329            SetDO(douMainArmGrip,OFF)
330        END_IF
331        //IF bSimpleFlowChart = FALSE THEN
332        IF TRUE THEN
333            //170725 add WJM
334            Increment(palletcountY)
335            IF pallet1.numberOfParts[1] = palletcountY THEN
336                palletcountX := palletcountX + 1
337                palletcountY := 0
338            END_IF
339            IF pallet1.numberOfParts[0] = palletcountX THEN
340                palletcountZ := palletcountZ + 1
341                palletcountX := 0
342            END_IF
343            IF pallet1.numberOfParts[2] = palletcountZ THEN
344                palletcountZ := 0
345            END_IF
346            Increment(palletcount)
347        END_IF
348    END_IF
```