Lettering color

Grey- nothing

Red- write/source/input

Blue- read/destination/output

Opcode format

Green- code

Red- source

Blue- destination

Notes-

Number + h means hex aka an address ie 00h is mem address 00h

Blank means remove color

Empty means remove contents

Speeds-

Conveyor is approx 125 in long

Conveyor speed 65 fpm or 13 in per sec

Gantry to conveyor or vice versa always takes 0.5 sec