**/PROG RSR0001**

LINE\_TRACK;

LINE\_TRACK\_SCHEDULE\_NUMBER : 0;

LINE\_TRACK\_BOUNDARY\_NUMBER : 0;

CONTINUE\_TRACK\_AT\_PROG\_END : TRUE;

/MN

1: ;

2: CALL MAIN\_PROGRAM\_SR6 ;

3: ;

/POS

/END

//

**/PROG MAIN\_PROGRAM\_SR6**

LINE\_TRACK;

LINE\_TRACK\_SCHEDULE\_NUMBER : 0;

LINE\_TRACK\_BOUNDARY\_NUMBER : 0;

CONTINUE\_TRACK\_AT\_PROG\_END : TRUE;

/MN

1: RUN FENCE\_OPEN ;

2: CALL MAIN\_VISION ;

3: ;

4: ;

/POS

/END

//

**/PROG FENCE\_OPEN**

LINE\_TRACK;

LINE\_TRACK\_SCHEDULE\_NUMBER : 0;

LINE\_TRACK\_BOUNDARY\_NUMBER : 0;

CONTINUE\_TRACK\_AT\_PROG\_END : TRUE;

/MN

1: LBL[1] ;

2: IF (DI[15:Fence Open DR3 Side] OR DI[16:Fence Open M3 Side]=ON),JMP LBL[2] ;

3: JMP LBL[1] ;

4: ;

5: LBL[2] ;

6: UALM[10] ;

/POS

/END

//

**/PROG MAIN\_VISION**

LINE\_TRACK;

LINE\_TRACK\_SCHEDULE\_NUMBER : 0;

LINE\_TRACK\_BOUNDARY\_NUMBER : 0;

CONTINUE\_TRACK\_AT\_PROG\_END : TRUE;

/MN

1: UFRAME\_NUM=1 ;

2: UTOOL\_NUM=1 ;

3: OVERRIDE=70% ;

4: ;

5:J PR[1:Home\_Position] 20% FINE ;

6: WAIT 1.00(sec) ;

7: ;

8: LBL[5] ;

9: VISION RUN\_FIND 'FIND\_OBJECT' ;

10: VISION GET\_NFOUND 'FIND\_OBJECT' R[10] ;

11: ;

12: IF R[10:Object\_Presence]=0,JMP LBL[2] ;

13: ;

14: LBL[1] ;

15: VISION GET\_OFFSET 'FIND\_OBJECT' VR[1] JMP LBL[2] ;

16: ;

17:L PR[2:Ref\_Position] 650mm/sec CNT25 Offset,PR[3:Z\_Offset] VOFFSET,VR[1] ;

18: ;

19:L PR[2:Ref\_Position] 245mm/sec FINE VOFFSET,VR[1] ;

20: ;

21: WAIT .25(sec) ;

22: CALL VACUUM\_ON ;

23: ;

24:L PR[2:Ref\_Position] 650mm/sec CNT25 Offset,PR[3:Z\_Offset] VOFFSET,VR[1] ;

25: ;

26:L PR[4:Place\_Position] 650mm/sec CNT25 Offset,PR[5:Place\_Z\_Offset] ;

27: ;

28:L PR[4:Place\_Position] 245mm/sec CNT50 ;

29: ;

30:L PR[6:Place\_Motion] 150mm/sec FINE DB 15.0mm,CALL VACUUM\_OFF ;

31: ;

32:L PR[6:Place\_Motion] 245mm/sec CNT25 Offset,PR[5:Place\_Z\_Offset] ;

33: ;

34: JMP LBL[5] ;

35: ;

36: LBL[2] ;

37: ;

38:J PR[1:Home\_Position] 20% FINE ;

39: ;

/POS

/END

//

**/PROG VACUUM\_ON**

LINE\_TRACK;

LINE\_TRACK\_SCHEDULE\_NUMBER : 0;

LINE\_TRACK\_BOUNDARY\_NUMBER : 0;

CONTINUE\_TRACK\_AT\_PROG\_END : TRUE;

/MN

1: ;

2: RO[2]=OFF ;

3: WAIT .10(sec) ;

4: RO[1]=ON ;

5: ;

/POS

/END

//

**/PROG VACUUM\_OFF**

LINE\_TRACK;

LINE\_TRACK\_SCHEDULE\_NUMBER : 0;

LINE\_TRACK\_BOUNDARY\_NUMBER : 0;

CONTINUE\_TRACK\_AT\_PROG\_END : TRUE;

/MN

1: ;

2: RO[1]=OFF ;

3: WAIT .10(sec) ;

4: RO[2]=ON ;

5: ;

/POS

/END

//

**IO STATUS::**

|  |  |
| --- | --- |
| DIN[ 1] OFF  DIN[ 2] OFF  DIN[ 3] OFF  DIN[ 4] OFF  DIN[ 5] OFF  DIN[ 6] OFF  DIN[ 7] OFF  DIN[ 8] OFF  DIN[ 9] OFF  DIN[ 10] OFF  DIN[ 11] OFF  DIN[ 12] OFF  DIN[ 13] OFF Restart  DIN[ 14] OFF Start  DIN[ 15] OFF Fence Open DR3 Side  DIN[ 16] OFF Fence Open M3 Side | UI[ 1] ON \*IMSTP  UI[ 2] ON \*Hold  UI[ 3] ON \*SFSPD  UI[ 4] OFF Cycle stop  UI[ 5] OFF Fault reset  UI[ 6] OFF Start  UI[ 7] OFF Home  UI[ 8] ON Enable  UI[ 9] OFF RSR1/PNS1/STYLE1 |
| SI[ 1] OFF Fault reset  SI[ 2] ON Remote  SI[ 3] ON Hold  SI[ 4] OFF  SI[ 5] OFF  SI[ 6] OFF Cycle start  SI[ 7] OFF  SI[ 8] ON CE/CR Select b0  SI[ 9] ON CE/CR Select b1  SI[ 10] OFF  SI[ 11] OFF  SI[ 12] OFF  SI[ 13] OFF  SI[ 14] OFF  SI[ 15] OFF  SI[ 16] ON | SO[ 1] OFF Cycle start  SO[ 2] OFF Hold  SO[ 3] OFF Fault LED  SO[ 4] OFF Batt alarm  SO[ 5] OFF  SO[ 6] OFF  SO[ 7] OFF TP enabled  SO[ 8] OFF  SO[ 9] OFF  SO[ 10] OFF  SO[ 11] OFF  SO[ 12] OFF  SO[ 13] OFF  SO[ 14] OFF  SO[ 15] OFF |