Ovrd 15

Dly 0.5

Def Plt 1, PX1, PX2, PX4, PX3, 4,3,2 ‘INPUT PALLET (4\*3) 1ST LAYER

Def Plt 2, PY1, PY2, PY4, PY3, 4,3,2 ‘INPUT PALLET (4\*3) 2ND LAYER

Def Plt 3, PL11, PL12, PL14, PL13, 2,2,2 ‘OUTPUT PALLET1 (2\*2) 1ST LAYER

Def Plt 4, PL111, PL112, PL114, PL113, 2,2,2 ‘OUTPUT PALLET1 (2\*2) 2ND LAYER

Def Plt 5, PL21, PL22, PL23, PL24, 2,2,2 ‘OUTPUT PALLET2 (2\*2) 1ST LAYER

Def Plt 6, PL221, PL222, PL223, PL224, 2,2,2 ‘OUTPUT PALLET2 (2\*2) 2ND LAYER

Def Plt 7, PL31, PL32, PL33, PL34, 2,2,2 ‘OUTPUT PALLET3 (2\*2) 1ST LAYER

Def Plt 8, PL321, PL322, PL323, PL324, 2,2,2 ‘OUTPUT PALLET3 (2\*2) 2ND LAYER

A1= 0

B1=0

C1=0

D1=0

E1=0

F1=0

M1 = 0

N1 = 0

P10 = Plt 1, A1 ‘ P10 IS THE PRODUCT POSITION NAME A1 OF Plt1

P20 = Plt 2, B1 ‘ P20 IS THE PRODUCT POSITION NAME B1 OF Plt2

P30 = Plt 3, C1

P40 = Plt 4, D1

P50 = Plt 5, E1

P60 = Plt 6, F1

P70 = Plt 7, M1

P80 = Plt 8, N1

A1= A1+1

B1= B1+1

\*DECISION

END

\*DECISION

SELECT B1

CASE 1 TO 4

GOSUB \*LINE1

BREAK

CASE 5 TO 8

GOSUB \*LINE2

BREAK

CASE 9 TO 12

GOSUB \*LINE3

BREAK

END SELECT

SELECT A1

CASE 1 TO 4

GOSUB \*LINE4

BREAK

CASE 5 TO 8

GOSUB \*LINE5

BREAK

CASE 9 TO 12

GOSUB \*LINE6

BREAK

END SELECT

RETURN

IF B1 <5 THEN \*LINE1

IF B1 >= 5 THEN \*LINE2

IF B1 >= 9 THEN \* LINE3

IF A1 <5 THEN \* LINE4

IF A1 >= 5 THEN \* LINE5

IF A1 >= 9 THEN \* LINE6

Return

\* LINE1

FOR B1 = 1 TO 4

P20 = Plt 2, B1

MOV P20, -100

HOPEN 1

DLY 0.5

MVS P20

DLY 1.5

HCLOSE 1

DLY 1.5

MVS P20, -100 ‘HOLDING THE PRODUCT ON TOP

DLY 1.5

C1=C1+1

P30 = Plt 3, C1

MOV P30, -100

OVRD 20

DLY 1.5

MVS P30

DLY 1.5

HOPEN 1

DLY 1.5

OVRD 20

MVS 40, -100

Next B1

B1=5

GoSub \* DECISION

RETURN

/////////////////////////////////////

\*LINE2

WHILE B1<=8

P20 = Plt 2, B1

MOV P20, -100

HOPEN 1

DLY 0.5

MVS P20

DLY 1.5

HCLOSE 1

DLY 1.5

MVS P20, -100 ‘HOLDING THE PRODUCT ON TOP

DLY 1.5

D1=D1+1

P40 = Plt 4, D1

MOV P40, -100

OVRD 20

DLY 1.5

MVS P40

DLY 1.5

HOPEN 1

DLY 1.5

OVRD 20

MVS P40, -100

B1=B1+1

WEND

GOSUB \*DECISION

RETURN

/////////////////////////////////////

\* LINE3

E1=0

FOR B1 = 9 TO 12

P20 = Plt 2, B1

MOV P20, -100

HOPEN 1

DLY 0.5

MVS P20

DLY 1.5

HCLOSE 1

DLY 1.5

MVS P20, -100 ‘HOLDING THE PRODUCT ON TOP

DLY 1.5

E1=E1+1

P50 = Plt 5, E1

MOV P50, -100

OVRD 20

DLY 1.5

MVS P50

DLY 1.5

HOPEN 1

DLY 1.5

OVRD 20

MVS P50, -100

Next B1

B1=13

GoSub \* DECISION

RETURN

////////////////////////////

\* LINE4

F1=0

FOR A1 = 1 TO 4

P10 = Plt 1, A1

MOV P10, -100

HOPEN 1

DLY 0.5

MVS P10

DLY 1.5

HCLOSE 1

DLY 1.5

MVS P10, -100 ‘HOLDING THE PRODUCT ON TOP

DLY 1.5

F1=F1+1

P60 = Plt 6, E1

MOV P60, -100

OVRD 20

DLY 1.5

MVS P60

DLY 1.5

HOPEN 1

DLY 1.5

OVRD 20

MVS P60, -100

Next A1

A1=5

GoSub \* DECISION

RETURN

\* LINE5

M1=0

FOR A1 = 5 TO 8

P10 = Plt 1, A1

MOV P10, -100

HOPEN 1

DLY 0.5

MVS P10

DLY 1.5

HCLOSE 1

DLY 1.5

MVS P10, -100 ‘HOLDING THE PRODUCT ON TOP

DLY 1.5

M1=M1+1

P70 = Plt 7, M1

MOV P70, -100

OVRD 20

DLY 1.5

MVS P70

DLY 1.5

HOPEN 1

DLY 1.5

OVRD 20

MVS P70, -100

Next A1

A1=9

GoSub \* DECISION

RETURN

\* LINE6

N1=0

FOR A1 = 9 TO 12

P10 = Plt 1, A1

MOV P10, -100

HOPEN 1

DLY 0.5

MVS P10

DLY 1.5

HCLOSE 1

DLY 1.5

MVS P10, -100 ‘HOLDING THE PRODUCT ON TOP

DLY 1.5

N1=N1+1

P80 = Plt 8, N1

MOV P80, -100

OVRD 20

DLY 1.5

MVS P80

DLY 1.5

HOPEN 1

DLY 1.5

OVRD 20

MVS P80, -100

Next A1

A1=13

GoSub \* DECISION

RETURN

// IF NEEDED THEN CHANGE THE POSITION OF (\*DECISION) ABOVE (RETURN). SO IT WILL COUNTE THE DECISION PATTERN.

PL11=(414.300,-89.200,201.340,178.830,1.850,-177.130)(7,0)

PL12=(410.490,-182.840,203.380,179.430,2.730,-177.340)(7,0)

PL13=(345.570,-91.160,201.460,179.120,1.660,-179.480)(7,0)

PL14=(343.580,-187.630,200.790,179.150,2.390,-178.310)(7,0)

PL21=(286.310,-81.660,201.880,-178.690,1.750,-174.850)(7,0)

PL22=(295.980,-168.040,202.990,-178.630,0.630,-173.480)(7,0)

PL23=(229.230,-83.560,202.580,-179.510,-0.180,-175.300)(7,0)

PL24=(224.350,-178.630,202.160,179.930,3.020,-173.710)(7,0)

PL31=(215.420,-318.240,205.290,-178.830,1.210,-173.460)(7,0)

PL32=(219.930,-243.630,201.550,-178.770,1.550,-177.320)(7,0)

PL33=(141.880,-304.480,204.070,-179.360,0.690,-173.670)(7,0)

PL34=(154.780,-229.380,201.590,-178.900,1.020,-175.690)(7,0)

PX1=(369.380,2.570,206.050,-179.330,0.550,-176.100)(7,0)

PX10=(184.910,76.410,201.180,-179.310,-0.440,-174.990)(7,0)

PX11=(175.360,156.710,199.940,-179.260,0.080,-179.500)(7,0)

PX12=(177.900,243.710,200.540,-178.180,0.720,-177.240)(7,0)

PX2=(368.900,79.200,205.450,-179.400,0.520,-174.630)(7,0)

PX3=(378.600,156.220,204.370,-179.650,-1.510,-176.980)(7,0)

PX4=(362.770,237.760,204.380,179.220,1.010,-176.660)(7,0)

PX5=(298.330,2.110,202.280,-179.490,0.410,-177.020)(7,0)

PX6=(295.270,80.120,201.250,-179.430,-0.190,-177.620)(7,0)

PX7=(293.150,158.900,201.460,-179.990,2.150,-176.660)(7,0)

PX8=(292.560,243.910,200.380,-179.650,0.630,-177.630)(7,0)

PX9=(198.500,4.320,202.670,-179.530,-1.570,-175.210)(7,0)

PL11=(414.300,-89.200,201.340,178.830,1.850,-177.130)(7,0)

PL12=(410.490,-182.840,203.380,179.430,2.730,-177.340)(7,0)

PL13=(345.570,-91.160,201.460,179.120,1.660,-179.480)(7,0)

PL14=(343.580,-187.630,200.790,179.150,2.390,-178.310)(7,0)

PX1=(369.380,2.570,206.050,-179.330,0.550,-176.100)(7,0)

PX2=(368.900,79.200,205.450,-179.400,0.520,-174.630)(7,0)

PX3=(378.600,156.220,204.370,-179.650,-1.510,-176.980)(7,0)

PX4=(362.770,237.760,204.380,179.220,1.010,-176.660)(7,0)

PX5=(293.120,2.060,208.990,-179.470,0.970,-177.020)(7,0)

PX6=(293.600,79.660,209.510,-179.680,0.900,-177.620)(7,0)

PX7=(288.850,151.350,209.000,179.730,1.720,-178.990)(7,0)

PX8=(289.480,241.330,209.290,-179.990,1.070,-177.640)(7,0)

PX9=(189.310,4.030,213.280,-179.440,-0.900,-175.490)(7,0)

PX10=(182.200,75.170,213.420,-179.320,-0.140,-175.020)(7,0)

PX11=(172.990,154.580,211.730,179.260,1.750,-179.520)(7,0)

PX12=(174.070,238.380,211.670,-179.050,1.410,-177.260)(7,0)

PBP101=(-36.760,94.930,6.440,1.510,73.540,-40.040)

PBP102=(-41.180,70.960,46.130,0.720,63.170,-44.700)

PBP103=(-45.510,60.720,65.530,-1.840,56.780,-44.700)

PBP104=(-53.800,48.760,86.360,-0.890,46.060,-54.940)

PBP111=(-28.340,78.020,34.960,-1.210,67.140,-30.860)

PBP112=(-35.740,55.740,77.480,2.470,45.100,-43.730)

PBP113=(-39.920,45.590,91.370,0.220,44.950,-45.000)

PBP114=(-46.570,35.870,107.560,-0.890,37.280,-49.060)

PBP121=(-20.140,65.970,56.440,-0.720,57.880,-22.950)

PBP122=(-24.120,43.480,95.240,-0.740,39.510,-26.050)

PBP123=(-29.120,35.380,108.680,-0.890,37.280,-31.670)

PBP124=(-36.120,29.440,119.240,1.990,34.100,-41.430)

PHOME=(230.710,-1.340,442.790,-179.780,-0.550,-177.790)(7,0)