Lower Cylinder

Engage Drawbar Release

Disengage Drawbar Release

No

No

Error

Remember Variable:   
Last Loaded

Check Tool In

Disengage Drawbar Release

Engage Drawbar Release

Check Tool Removed

Confirm Empty

Return ATC

Lower Cylinder

If not in Position

Move CNC

Move ATC

Raise Cylinder

Move ATC

Raise Cylinder

Move CNC

If not in Position

If Not Empty

Run Rotate Path

Check CNC

CNC has Tool

If not in Position

Check ATC

If Empty

Check CNC

Confirm Tool

Run Rotate Path

CNC is Empty

Enter Slot Number

Error

Set Variable:  
Last Loaded as 0

Check Stocktake

Run Homing

Initialise

Startup