

User input  
CNC Speed

Have G1 & G0 still  
be hard wired to  
delay but also go  
to the board.

Can't do this  
because when we  
tell machine to stop  
it could be in G1 still

G1 G0 Y  
000  
010  
101  
110

G1=0  
G0=1

While  
G1=0 +  
G0=1

G1=1  
G0=0

Stop  
CNC Movement

30  
seconds?

While  
G1=0 +  
G0=1

G1=0  
G0=1

Stop weld

else if  
IRQ from  
G1=0 + G0=1

Wait  
2min

Stop weld  
Stop CNC

IF IRQ  
from timer

Break  
if timer  
> 130 or G1=0  
+ G0=1

IRQ

return  
where we last

IF  
base  
temp < thresh

Torch Routine

Start  
Torch

base  
temp < thresh

stop  
torch

Set WS  
Start  
welder  
Start Timer  
Get welder  
checked

Start CNC  
Movement

Do while  
temp guard  
current guard  
WS guard

Get new welder I  
Get new temp  
Get wire speed

If weld  
I < thresh  
else

adjust weld  
I ++

Wait some  
ms

IF temp  
< thresh

WS WS  
OK?

Change  
So it's

yes

Torch  
Routine

Stop  
machine

0/50