

clock2 Project

Cut_Seq

Engrave_SEQ

EngraveX

Home

IndexA

init

main

Pick_SEQ

Place_SEQ

Local variables

placeHeight

pushClearance

pushDistance

Push_SEQ

Sched

StepperFC

TimGet

Global_vars

auto

cmplt

cnt

curSeq

cutBackX

cutDigit

cutFrontX

cutPositionsY

hour0

hour1

laserSeq

manMode

min0

min1

moveSpeed

PB_HOME

PB_START

PB_STOP

PBTimeOff

pickIndex

pickPositionsY

placeClearZ

placedCur

placeIndex

placePositionsY

seqCut

seqEngrave

seqHome

seqIndex

seqPick

seqPlace

seqPush

Solenoids

timeRTC

ZTop

I_O_mappings_AO

laserPWM

I_O_mappings_DIO

EnableA

EnableXYZ

laserFull

Sol1

Sol2

Sol3

Sol4

SharedVars

INPUTS

hour

minute

second

XHomeDN

XPosAct

YHomeDN

YPosAct

ZHomeDN

ZPosAct

OUTPUTS

ADir

APos

ASpeed

XDir

XHome

XPos

XSpeed

YDir

YHome

YPos

YSpeed

ZDir

ZHome

ZPos

ZSpeed

Tasks

Fast

Home

main

Sched

Engrave_SEQ

Cut_Seq

Pick_SEQ

Place_SEQ

Push_SEQ

IndexA

Slow

Background

Init

init

Local variables

| | Name | Type | Address | Array | Init value | Attribute | Description |
|---|----------------|------|---------|-------|------------|-----------|-------------|
| 1 | pushClearanceX | INT | Auto | No | 17000 | .. | |
| 2 | placeHeight | INT | Auto | No | 9500 | .. | |
| 3 | pushDistance | INT | Auto | No | 300 | .. | |
| 4 | placeOffsetY | INT | Auto | No | 2100 | CONSTANT | |
| 5 | placePositionX | INT | Auto | No | 19400 | CONSTANT | |

0001

auto

seqPlace

EN

ENO

EQ

=

curSeq

10

EN

ENO

StepperFC

placePositionX

placePositionsY[placeIndex]

placeClearZ

XPOSIN

YPOSIN

ZPOSIN

EN

ENO

ADD

+

curSeq

10

curSeq

0002

auto

seqPlace

EN

ENO

EQ

=

curSeq

20

EN

ENO

StepperFC

placePositionX

placePositionsY[placeIndex]

placeHeight

XPOSIN

YPOSIN

ZPOSIN

EN

ENO

ADD

+

curSeq

10

curSeq

0003

auto

seqPlace

EN

ENO

EQ

=

curSeq

30

EN

ENO

StepperFC

placePositionX

placePositionsY[placeIndex] + placeOffsetY

placeHeight

XPOSIN

YPOSIN

ZPOSIN

EN

ENO

ADD

+

curSeq

10

curSeq

0004

auto

seqPlace

EN

ENO

EQ

=

curSeq

40

EN

ENO

StepperFC

placePositionX

placePositionsY[placeIndex] + placeOffsetY

placeClearZ

XPOSIN

YPOSIN

ZPOSIN

EN

ENO

ADD

+

curSeq

10

curSeq

0005

auto

seqPlace

EN

ENO

EQ

=

curSeq

50

cmplt

0006

auto

seqPlace

cmplt

P

seqPlace

(R)