

clock Project

cut\_SEQ

Engrave\_SEQ

EngraveX

init

main

Pick\_SEQ

Place\_SEQ

Local variables

placeHeight

pushClearanceX

pushDistance

step0

step1

step2

step3

Push\_SEQ

Sched

Local variables

StepperSEQ

TimeGetter

Global\_vars

auto

cmplt

cnt

curSeq

cutBackX

cutDigit

cutFrontX

cutPositionsY

cutSeq

engraveSeq

hour0

hour1

laserSeq

manMode

min0

min1

moveSpeed

PBTimeOff

pickIndex

pickPositionsY

pickSeq

placeClearZ

placedCur

placeIndex

placePositionsY

placeSeq

pushSeq

Solenoids

timeRTC

XOFF

YOFF

ZOFF

ZTop

I\_O\_mappings\_AO

laserPWM

I\_O\_mappings\_DI

XHome

YHome

ZHome

I\_O\_mappings\_DIO

EnableA

EnableXYZ

Sol1

Sol2

Sol3

Sol4

I\_O\_mappings\_DO

home2

Ungrouped\_vars

SharedVars

INPUTS

hour

minute

second

XPosAct

YPosAct

ZPosAct

OUTPUTS

ADir

APos

ASpeed

Home

XDir

XPos

XSpeed

YDir

YPos

YSpeed

ZDir

ZPos

ZSpeed

Tasks

Fast

main

Sched

Engrave\_SEQ

cut\_SEQ

Pick\_SEQ

Place\_SEQ

Push\_SEQ

Slow

TimeGetter

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	step0	StepperSEQ	Auto	No		..	
5	step1	StepperSEQ	Auto	No		..	
6	step2	StepperSEQ	Auto	No		..	
7	step3	StepperSEQ	Auto	No		..	
8	placeOffsetY	INT	Auto	No	2100	CONSTANT	
9	placePositionX	INT	Auto	No	19400	CONSTANT	

0001

auto

placeSeq

EN

EQ

ENO

=

curSeq

10

placePositionX

XPOSIN

XPOSOUT

XPos

placePositionsY[placeIndex]

YPOSIN

YPOSOUT

YPos

placeClearZ

ZPOSIN

ZPOSOUT

ZPos

XPosAct

XPOSACT

YPosAct

YPOSACT

ZPosAct

ZPOSACT

step0

StepperSEQ

EN

ENO

0002

auto

placeSeq

EN

EQ

ENO

=

curSeq

20

placePositionX

XPOSIN

XPOSOUT

XPos

placePositionsY[placeIndex]

YPOSIN

YPOSOUT

YPos

placeHeight

ZPOSIN

ZPOSOUT

ZPos

XPosAct

XPOSACT

YPosAct

YPOSACT

ZPosAct

ZPOSACT

step1

StepperSEQ

EN

ENO

0003

auto

placeSeq

EN

EQ

ENO

=

curSeq

30

placePositionX

XPOSIN

XPOSOUT

XPos

placePositionsY[placeIndex] + placeOffsetY

YPOSIN

YPOSOUT

YPos

placeHeight

ZPOSIN

ZPOSOUT

ZPos

XPosAct

XPOSACT

YPosAct

YPOSACT

ZPosAct

ZPOSACT

step2

StepperSEQ

EN

ENO

0004

auto

placeSeq

EN

EQ

ENO

=

curSeq

40

placePositionX

XPOSIN

XPOSOUT

XPos

placePositionsY[placeIndex] + placeOffsetY

YPOSIN

YPOSOUT

YPos

placeClearZ

ZPOSIN

ZPOSOUT

ZPos

XPosAct

XPOSACT

YPosAct

YPOSACT

ZPosAct

ZPOSACT

step3

StepperSEQ

EN

ENO

0005

auto

placeSeq

EN

EQ

ENO

=

curSeq

50

cmplt

0006

auto

placeSeq

cmplt

placeSeq

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