/PROG ALL

/ATTR

OWNER = MNEDITOR;

COMMENT = "";

PROG\_SIZE = 3689;

CREATE = DATE 14-05-13 TIME 17:03:06;

MODIFIED = DATE 14-05-13 TIME 17:21:44;

FILE\_NAME = ;

VERSION = 0;

LINE\_COUNT = 118;

MEMORY\_SIZE = 4365;

PROTECT = READ\_WRITE;

TCD: STACK\_SIZE = 0,

TASK\_PRIORITY = 50,

TIME\_SLICE = 0,

BUSY\_LAMP\_OFF = 0,

ABORT\_REQUEST = 0,

PAUSE\_REQUEST = 0;

DEFAULT\_GROUP = 1,\*,\*,\*,\*;

CONTROL\_CODE = 00000000 00000000;

/MN

! motion ;

J P[1:test point] 100% FINE ;

J P[1] 100.0sec CNT100 ;

J P[1] 100msec CNT R[1] ;

L P[1] 100/sec FINE ;

L P[1] 100cm/min CNT100 ;

L P[1] 100.0inch/min CNT100 ;

L P[1] 100deg/sec CNT100 ;

! indirect speed ;

L P[1] R[1]sec CNT100 ;

! indirect indirect ;

L PR[1] R[R[1]]msec CNT100 ;

! indirect destination ;

L PR[R[1]] max\_speed CNT100 ;

;

! assignment ;

R[1]=R[2] ;

! indirect assignment ;

R[R[1]]=R[2] ;

! system variables ;

$foo=$bar[100].$baz ;

R[1]=$FOO.$BAR ;

;

! various keyword assignments ;

PR[1]=LPOS ;

PR[1]=JPOS ;

PR[1]=UFRAME[1] ;

PR[1]=UTOOL[1] ;

PR[1]=P[1] ;

PR[1,1:component]=5 ;

SR[1:string reg]=SR[2]+AR[1] ;

R[1]=SO[1:Cycle start] DIV SI[2:Remote] ;

R[1]=UO[1:Cmd enabled] MOD UI[1:\*IMSTP] ;

! mixed logic ;

DO[1]=(DI[1] AND AR[1] AND F[1] OR TIMER[1]>TIMER\_OVERFLOW[1]) ;

F[1]=(ON) ;

JOINT\_MAX\_SPEED[1]=5 ;

LINEAR\_MAX\_SPEED=5 ;

SKIP CONDITION DI[1]=OFF- ;

PAYLOAD[R[1]] ;

OFFSET CONDITION PR[1] ;

UFRAME\_NUM=1 ;

UTOOL\_NUM=1 ;

UFRAME[1]=PR[1] ;

UTOOL[1]=PR[1] ;

RSR[1]=ENABLE ;

RSR[AR[1]]=DISABLE ;

UALM[1] ;

TIMER[1]=START ;

TIMER[1]=STOP ;

TIMER[1]=RESET ;

OVERRIDE=50% ;

TOOL\_OFFSET CONDITION PR[1] ;

LOCK PREG ;

UNLOCK PREG ;

COL DETECT ON ;

COL DETECT OFF ;

COL GUARD ADJUST R[1] ;

COL GUARD ADJUST 50 ;

MONITOR TEST ;

MONITOR END TEST ;

R[1]=STRLEN SR[1] ;

SR[1]=SUBSTR SR[2],R[3],R[4] ;

R[1]=FINDSTR SR[1],SR[2] ;

DIAG\_REC[1,5,2] ;

;

! program calls ;

CALL TEST ;

CALL TEST(1,'string',SR[1],AR[1]) ;

RUN TEST ;

RUN TEST(1,'string',SR[1],AR[1]) ;

;

! conditionals ;

IF R[1]=1,JMP LBL[5] ;

IF R[1]=AR[1],CALL TEST ;

IF (DI[1]),R[1]=(5) ;

SELECT R[1]=1,JMP LBL[5] ;

=2,CALL TEST ;

ELSE,JMP LBL[100] ;

FOR R[1]=1 TO R[2] ;

ENDFOR ;

;

! wait statement ;

WAIT 1.00(sec) ;

WAIT R[5] ;

WAIT DI[1]=ON ;

WAIT DI[1]=ON+ ;

WAIT ERR\_NUM=1 ;

WAIT (DI[1]=ON) ;

;

! jumps and labels ;

JMP LBL[1] ;

JMP LBL[R[1]] ;

LBL[100] ;

LBL[100:TEST] ;

;

! statements ;

PAUSE ;

ABORT ;

ERROR\_PROG=ALL ;

RESUME\_PROG[1]=TEST ;

END ;

MESSAGE[ASDF] ;

;

! comments ;

--eg:ASDFASDFASDF ;

// L P[9] 100mm/sec CNT100 ACC100 ;

;

! motion modifiers ;

L P[1] 100mm/sec CNT100 ACC100 ;

L P[1] 100mm/sec CNT100 ACC R[1] ;

L P[1] 100mm/sec CNT100 Skip,LBL[1] ;

L P[1] 100mm/sec CNT100 BREAK ;

L P[1] 100mm/sec CNT100 Offset ;

L P[1] 100mm/sec CNT100 PSPD50 ;

L P[1] 100mm/sec CNT100 Offset,PR[1] ;

L P[1] 100mm/sec CNT100 INC ;

L P[1] 100mm/sec CNT100 RT\_LDR[1] ;

L P[1] 100mm/sec CNT100 AP\_LD50 ;

L P[1] 100mm/sec CNT100 Tool\_Offset ;

L P[1] 100mm/sec CNT100 Tool\_Offset,PR[1] ;

L P[1] 100mm/sec CNT100 Skip,LBL[1],PR[1]=LPOS ;

L P[1] 100mm/sec CNT100 TB R[5]sec,CALL ALL ;

L P[1] 100mm/sec CNT100 TA 0.00sec,AO[1]=R[5] ;

L P[1] 100mm/sec CNT100 DB 0.0mm,CALL ALL ;

L P[1] 100mm/sec CNT100 PTH ;

L P[1] 100mm/sec CNT100 VOFFSET,VR[1] ;

/POS

P[1:"test"]{

GP1:

UF : 0, UT : 1, CONFIG : '',

X = 550.000 mm, Y = 0.000 mm, Z = -685.000 mm,

W = 180.000 deg, P = 0.000 deg, R = 0.000 deg

};

/END