

MainModule.main	
└ Production	
└ Production Menu	
└ Setup	
└ Setup Menu	
└ Teaching	
└ Teaching Menu	
└ Position	
└ Position Menu	
└ Load/Save	
└ Load/Save Module Menu	
└ Setup	
└ Setup Menu	
└ Work Origin	FRAMES
└ Select Origin # (1-6)	AMES SETUP SELECT
└ Origin 1	SetupP01
└ Base1	
└ Limit1	
└ Z-Plane 1	
└ Return	
└ Origin 2	SetupP02
└ Base 2	
└ Limit 2	
└ Z-Plane 2	
└ Return	
└ Origin 3	SetupP03
└ Base 3	
└ Limit 3	
└ Z-Plane 3	
└ Return	
└ Origin 4	SetupP04
└ Base 4	
└ Limit 4	
└ Z-Plane 4	
└ Return	
└ Origin 5	SetupP05
└ Base 5	
└ Limit 5	
└ Z-Plane 5	
└ Return	
└ Origin 6	SetupP06
└ Base 6	

	Limit 6	
	Z-Plane 6	
	Return	
	Preset Positions	<i>SafePOS</i>
	Side 1	
	Tool Reference 1	<i>Setup</i>
	Frame Reference 1	<i>Fixture</i>
	Park 1	<i>SafeS1Weld</i>
	Return	
	Side 2	
	Tool Reference 2	
	Frame Reference 2	
	Park 2	
	Return	
	Torch Station	
	Wire Cut	
	Reamer	
	Spray	
	Service	
	Return	
	BullsEye Station	
	Wire Touch Pt	
	Begin Calibration	
	Return	
	Return	
	Weld Config	
	Torch Angle	
	Y-Axis welds	
	+ side	<i>LEFT</i>
	- side	<i>RIGHT</i>
	centered	<i>YMID</i>
	Return	
	X-Axis welds	
	+ side	<i>DOWN</i>
	- side	<i>UP</i>
	centered	<i>XMID</i>
	Return	
	Return	
	Weld Presets	
	Select Weld Preset (1-9)	
	[DISPLAY CURRENT DATA]	
	[INPUT BOX FOR NEW DATA]	
	Update	

		└ Return	
	└ Weave Presets		
	└ Select Weave Preset (1-9)		
	└ [DISPLAY CURRENT DATA]		
	└ [INPUT BOX FOR NEW DATA]		
	└ Update		
	└ Return		
	└ Seam Presets		
	└ Select Seam Preset (1-9)		
	└ [DISPLAY CURRENT DATA]		
	└ [INPUT BOX FOR NEW DATA]		
	└ Update		
	└ Return		
	└ Speeds		
	└ Speeds Menu		
	└ Preview → EditSpeedMenu(Preview)		
	└ Arc		
	└ Approach		
	└ Retract		
	└ Transfer		
	└ Return		
	└ Production → EditSpeedMenu(Production)		
	└ Arc		
	└ Approach		
	└ Retract		
	└ Transfer		
	└ Return		
	└ Return		
	└ Return		
	└ Production		
	└ Run		
	└ Auto From Begining		
	└ Auto From Part# / Weld#		
	└ Opt Stop From Begining		
	└ Opt Stop From Part# / Weld#		
	└ Return		
	└ Preview		
	└ Fly/Dry From Begining		
	└ Fly/Dry From Part# / Weld#		
	└ Opt Stop From Begining		
	└ Opt Stop From Part# / Weld#		
	└ Return		

	└ Utilities Menu
	└ Align Torch
	└ Clean Torch
	└ BullsEye ck
	└ Fixture ck
	└ Return
	└ Teaching
	└ Edit Origin
	└ Select Origin # (1-6)
	└ Add Weld
	└ Select Weld # (1-30)
	Offers Default of next available
	└ Select Weld Type
	└ X Axis
	└ +Side
	└ - Side
	└ - Centered
	└ Return
	└ Y Axis
	└ +Side
	└ - Side
	└ - Centered
	└ Return
	└ Corner
	└ Y + AND X +
	└ Y + AND X -
	└ Y - AND X +
	└ Y - AND X -
	└ Return
	└ P 2 P WELD
	└ Return
	└ Delete Weld
	└ Select Weld # (1-30)
	└ View Weld
	└ Select Weld # (1-30)
	└ Return
	└ Wipe Origin
	└ Select Origin # (1-6)
	└ Return
	└ Position
	└ Side 1

		— Tool Reference 1	
		— Frame Reference 1	
		— Park 1	
		— Return	
	— Side 2		
		— Tool Reference 2	
		— Frame Reference 2	
		— Park 2	
		— Return	
		— Torch Station	
		— Wire Cut	
		— Reamer	
		— Spray	
		— Service	
		— Return	
		— BullsEye Station	
		— Wire Touch Pt	
		— Begin Calibration	
		— Return	
		— Return	
		— Load/Save	
		— Load Module	
		— Save Module	
		— Void Module	
		— Rename Module	
		— Return	