

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)	4AMES 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	SafePOS
				└─ Side 1	
				└─ Tool Reference 1	Setup
				└─ Frame Reference 1	Fixture
				└─ Park 1	SafeS1Weld
				└─ 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	LEFT
				└─ - side	RIGHT
				└─ centered	YMID
				└─ Return	
				└─ X-Axis welds	
				└─ + side	DOWN
				└─ - side	UP
				└─ centered	XMID
				└─ 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	