

Work Process

Start

1. Process is set to Manual.
2. Start is ON
3. Lid and Base emitter : ON
4. Lid and Base conveyor : ON
5. Lid and Base at place : FTRIG

Middle

1. Base and Lid Clamp : ON (Set Coil)
2. Move Z : ON (Set Coil)
 - a. Item Detected

IF False : Move Z: OFF, ERROR (RESet Coil)

(If there is an item , grab item,move back Z , move X , move Z , , grab off , move back Z,move back X)

IF True : Grab item : ON (Set Coil)

- i. MOVE X , MOVE Z : ON (Set Coil)
- ii. Grab : OFF , MOVE Z : OFF (RESet Coil)
- iii.

3. Base and Lid Clamp : OFF

END

- 1.Pos Raise Bases : ON
2. Base Conveyor : ON
- 3.Part Leaving : FTRIG
- 4.Pos Raise Bases: OFF
- 5.Run Conveyor : TOFF , Remove: ON