live value setup

system variables

$SRC_GRP

%SCR_GPR_T

$MCH_POS_ENB = TRUE

Addressing :

$SCR_GRP[1].$MCG_POS_X
(last letter to be access data is
needed for)

Register List (copy for each axis)

tool position
(live x value at moment cal sensor activates

flag
(used to prevent multiple triggers of sensor

Diff
(difference in unit position and tool position)

unit position
(actual location of calibration sensor from base)

Other Data

Uframe (this must be at 0,0,0 for calibration program)

Utool (whatever Utool will be used for porgram)

RP (data written here from program then to utool)

BG setup instructions

Menue/setup/setup2/BGlogic

set Program you wish to run continuously

Main routine

Set
utool
uframe (0,0,0)
override speed

Home

move to Start point

Set Flag low

move to end point

calculate difference
between tool position
and unit position

at end of
X/Y

load difference into
PR(ex. PR[1,1])

load PR into Utool

Set utool to effect
changes

Home

Background logic (always running)

check for flag and di

Send live position to
cal position register

set flag high