

Program

Init Variables

BeforeStart

cnt_1:=0

cnt_2:=0

In_tray_empty:= False

out_tray_full:= False

m1_done:= False

m2_done:= False

m3_done:= False

activate_m1:= False

activate_m2:= False

activate_m3:= False

m1_loaded:= False

m2_loaded:= False

m3_loaded:= False

pulse_m1:= False

pulse_m2:= False

pulse_m3:= False

m1_inprogres:= False

m2_inprogres:= False

m3_inprogres:= False

Set DO[0]=Off

Set DO[1]=Off

Set DO[2]=Off

Set DO[3]=Off

Set DO[4]=Off

Set DO[5]=Off

Set DO[6]=Off

Set DO[7]=On

MoveJ

Waypoint_1

Robot Program

complete:=0

Wait: 0.01

MoveJ

If (cnt_1 \neq 0) and (out_tray_full \neq False)

out_tray_full:= True

Popup

If (cnt_2 \neq 0) and (In_tray_empty \neq False)

In_tray_empty:= True

Popup

If complete \neq 0

If (m1_done \neq True) and (m1_loaded \neq False)

open:= True

In_tray_empty:= False

Call go_btw_1001

Call pick_pl_in_intr

Call go_btw_1001

Call go_btw_1002

Call go_btw_1003

Call go_btw_1004

Call go_btw_1005

Call go_btw_1006

Call place_pallet_m1

Call pull_lever_m1

Call go_btw_1005

Call go_btw_1003

activate_m1:= True

m1_loaded:= True

m1_inprogres:= False

Call go_btw_1002

If (m2_done \neq True) and (m2_loaded \neq False)

open:= True

In_tray_empty:= False

Call go_btw_1001

Call pick_pl_in_intr

Call go_btw_1002

Call go_btw_1003

Call go_btw_1004

Call place_pallet_m2

Call pull_lever_2

activate_m2:= True

m2_loaded:= True

m2_inprogres:= False

Call go_btw_1002

If (m3_done \neq True) and (m3_loaded \neq False)

open:= True

In_tray_empty:= False

Call go_btw_1001

Call pick_pl_in_intr

Call go_btw_1002

Call place_pallet_m3

Call pull_lever_m3

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activate_m3:= True
m3_loaded:= True
m3_inprogres:= False
Call go_bt看_1002
If (m1_done≠ True ) and (m1_loaded≠ True )
open:= True
out_tray_full:= False
m1_inprogres:= True
m2_done:= False
pulse_m2:= False
m3_done:= False
pulse_m3:= False
Call go_bt看_1002
Call go_bt看_1003
Call go_bt看_1004
Call push_lever_m1
Call pick_pl_in_m1
Call go_bt看_1005
Call go_bt看_1004
Call go_bt看_1003
Call go_bt看_1002
Call place_pl_in_out
Call go_bt看_1001
m1_loaded:= False
If (m2_done≠ True ) and (m2_loaded≠ True )
open:= True
out_tray_full:= False
m2_inprogres:= True
m1_done:= False
pulse_m1:= False
m3_done:= False
pulse_m3:= False
Call go_bt看_1002
Call go_bt看_1003
Call go_bt看_1004
Call push_lever_m2
Call pick_pl_in_m2
Call go_bt看_1003
Call go_bt看_1002
Call place_pl_in_out
Call go_bt看_1001
m2_loaded:= False
If (m3_done≠ True ) and (m3_loaded≠ True )
open:= True
out_tray_full:= False
m3_inprogres:= True
m1_done:= False
pulse_m1:= False
m2_done:= False
pulse_m2:= False
Call go_bt看_1002
Call push_lever_m3
Call pick_pl_in_m3
Call go_bt看_1002
Call place_pl_in_out
Call go_bt看_1001
m3_loaded:= False
Thread_1
Wait: 0.01
If open≠ True
Set DO[7]=Off
Wait: 0.2
Set DO[6]=On
Wait: 0.3
open:= False
Thread_2
Wait: 0.01
If (m1_inprogres≠ True ) and (digital_in[1]≠ False )
m1_done:= False
m1_inprogres:= False
If (m2_inprogres≠ True ) and (digital_in[2]≠ False )
m2_done:= False
m2_inprogres:= False
If (m3_inprogres≠ True ) and (digital_in[3]≠ False )
m3_done:= False
m3_inprogres:= False
Thread_3
Wait: 0.01
If (digital_in[1]≠ True ) and (activate_m1≠ True )
m1_done:= False
If (activate_m1≠ True ) and (m1_done≠ True )
m1_done:= False
Set DO[1]=On
Wait: 2.0

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Set DO[1]=Off
activate_m1:= False
If (activate_m1≠ True ) and (m1_done≠ False )
  m1_done:= False
  Set DO[1]=On
  Wait: 2.0
  Set DO[1]=Off
  activate_m1:= False
If (digital_in[1]≠ False )
  pulse_m1:= False
If (digital_in[1]≠ True ) and (activate_m1≠ False ) and (pulse_m1≠ False ) and (m2_inprogres≠ False ) and (m3_inprogres≠ False )
  m1_done:= True
  pulse_m1:= True
If (digital_in[2]≠ True ) and (activate_m2≠ True )
  m2_done:= False
If (activate_m2≠ True ) and (m2_done≠ True )
  m2_done:= False
  Set DO[2]=On
  Wait: 1.0
  Set DO[2]=Off
  activate_m2:= False
If (activate_m2≠ True ) and (m2_done≠ False )
  m2_done:= False
  Set DO[2]=On
  Wait: 1.0
  Set DO[2]=Off
  activate_m2:= False
If (digital_in[2]≠ False )
  pulse_m2:= False
If (digital_in[2]≠ True ) and (activate_m2≠ False ) and (m1_inprogres≠ False ) and (m3_inprogres≠ False ) and (pulse_m2≠ False )
  m2_done:= True
  pulse_m2:= True
If (digital_in[3]≠ True ) and (activate_m3≠ True )
  m3_done:= False
If (activate_m3≠ True ) and (m3_done≠ True )
  m3_done:= False
  Set DO[3]=On
  Wait: 2.0
  Set DO[3]=Off
  activate_m3:= False
If (activate_m3≠ True ) and (m3_done≠ False )
  m3_done:= False
  Set DO[3]=On
  Wait: 2.0
  Set DO[3]=Off
  activate_m3:= False
If (digital_in[3]≠ False )
  pulse_m3:= False
If (digital_in[3]≠ True ) and (activate_m3≠ False ) and (m1_inprogres≠ False ) and (m2_inprogres≠ False ) and (pulse_m3≠ False )
  m3_done:= True
  pulse_m3:= True
pick_pl_in_intr
Pallet
  Pattern: Square
  a1st_Corner_1
  a2nd_Corner_1
  a3rd_Corner_1
  a4th_Corner_1
PalletSequence
  Waypoint_2
  Approach_1
  PatternPoint_1
  Set DO[6]=Off
  Wait: 0.2
  Set DO[7]=On
  Wait: 0.5
  Exit_1
place_pallet_m3
MoveJ
  Waypoint_121
  Waypoint_125
  Waypoint_127
  Waypoint_128
  Waypoint_128_1
  Set DO[7]=Off
  Wait: 0.2
  Set DO[6]=On
  Wait: 0.3
  Waypoint_127
pull_lever_m3
MoveJ
  Waypoint_131
  Waypoint_132
  Waypoint_133

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Waypoint_134
Waypoint_135
Waypoint_137
Waypoint_138
place_pallet_m2
MoveJ
Waypoint_222
Waypoint_225
Waypoint_226
Waypoint_226_1
Set DO[7]=Off
Wait: 0.2
Set DO[6]=On
Wait: 0.3
Waypoint_227
pull_lever_2
MoveJ
Waypoint_231
Waypoint_231_1
Waypoint_232
Waypoint_233
Waypoint_234
Waypoint_235
Waypoint_236
place_pallet_m1
MoveJ
Waypoint_310
Waypoint_311
Waypoint_312
Waypoint_313
Waypoint_314
Set DO[7]=Off
Wait: 0.2
Set DO[6]=On
Wait: 0.3
Waypoint_316
pull_lever_m1
MoveJ
Waypoint_321
Waypoint_322
Waypoint_323
Waypoint_324
Waypoint_325
Waypoint_326
Waypoint_327
place_pl_in_out
Pallet
Pattern: Square
a1st_Corner_2
a2nd_Corner_2
a3rd_Corner_2
a4th_Corner_2
PalletSequence
Comment
Approach_2
PatternPoint_2
Set DO[7]=Off
Wait: 0.2
Set DO[6]=On
Wait: 0.3
Exit_2
push_lever_m3
MoveJ
Waypoint_501
Waypoint_502
Waypoint_503
Waypoint_504
Waypoint_505
Waypoint_506
pick_pl_in_m3
MoveJ
Waypoint_511
Waypoint_514
Set DO[6]=Off
Wait: 0.2
Set DO[7]=On
Wait: 0.3
Waypoint_516_0
Waypoint_516
Waypoint_517
push_lever_m2
MoveJ
Waypoint_601
Waypoint_602
Waypoint_603

Waypoint_604
Waypoint_605
Waypoint_606
pick_pl_in_m2
MoveJ
Waypoint_611
Waypoint_611_1
Set DO[6]=Off
Wait: 0.2
Set DO[7]=On
Wait: 0.3
Waypoint_613_0
Waypoint_613
Waypoint_614
push_lever_m1
MoveJ
Waypoint_701
Waypoint_702
Waypoint_703
Waypoint_704
Waypoint_705
Waypoint_706
pick_pl_in_m1
MoveJ
Waypoint_711
Waypoint_712
Set DO[6]=Off
Wait: 0.2
Set DO[7]=On
Wait: 0.3
Waypoint_713_0
Waypoint_713
Waypoint_714
go_bt看_1001
MoveJ
Waypoint_1001
go_bt看_1002
MoveJ
Waypoint_1002
go_bt看_1003
MoveJ
Waypoint_1003
go_bt看_1004
MoveJ
Waypoint_1004
go_bt看_1005
MoveJ
Waypoint_1005
go_bt看_1006
MoveJ
Waypoint_1006