

Program

Init Variables

BeforeStart

Set E67[15]=Off

Set E67[8]=Off

Set E67[1]=Off

Wait: 0.5

Set E67[1]=On

Set E67[15]=On

Set E67[8]=On

Set DO[4]=Off

Set DO[6]=On

Set DO[7]=Off

Set TO[0]=Off

Set TO[1]=Off

Item\_man\_p\_f\_mo:= False

Item\_p\_f\_imm:= False

Item\_p\_f\_tray:= False

Item\_table\_pos:=0

unexpected\_forc:= False

measure\_force:= False

force\_measured:=0

highest\_force:=0

jig\_out\_pos\_1:= False

jig\_out\_pos\_2:= False

jig\_out\_pos\_3:= False

ejector:= False

Pre\_Program:= True

No\_mould:= False

MoveJ

Waypoint\_start

Set DO[0]=Off

Set DO[1]=On

Set DO[2]=Off

Set DO[3]=On

Set TO[1]=On

Wait: 0.5

Set TO[1]=Off

MoveJ

Waypoint\_1

MoveL

Waypoint\_repeat

Loop digital\_in[3]≠ False

Popup

Robot Program

If 1≠1

If Item\_p\_f\_tray≠ False

MoveJ

Waypoint\_repeat

If (digital\_in[4]≠ True ) and (tool\_in[0]≠ False )

Wait: 1.0

MoveJ

Set DO[0]=Off

Set DO[1]=On

Waypoint\_100

Waypoint\_110

WP\_pick\_1

Set DO[1]=Off

Set DO[0]=On

Wait: 0.9

Item\_p\_f\_tray:= True

Item\_tray\_pos:=2

Waypoint\_110

If tool\_in[0]≠ False

Set DO[0]=Off

Set DO[1]=On

Waypoint\_100

If (digital\_in[5]≠ True ) and (tool\_in[0]≠ False )

Wait: 1.0

MoveJ

Set DO[0]=Off

Set DO[1]=On

Waypoint\_200

Waypoint\_210

WP\_pick\_2

Set DO[1]=Off

Set DO[0]=On

Wait: 0.9

Item\_p\_f\_tray:= True

Waypoint\_210

If tool\_in[0]≠ False

Set DO[0]=Off

Set DO[1]=On

Item\_tray\_pos:=3

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Waypoint_200
If tool_in[0]≠ True
Wait: 0.01
MoveL
Waypoint_4
If tool_in[0]≠ False
Item_p_f_tray:= False
Loop digital_in[3]≠ False
Popup
If (E67 In: Mould Open Position≠ True ) and (digital_in[0]≠ True ) and (Item_p_f_tray≠ True )
MoveL
Set DO[6]=Off
WP_2_1_1
WP_2_1_3
Set TO[0]=On
WP_2_1_6
Wait: 0.1
WP_2_1_7
Wait: 0.1
Set DO[4]=On
Wait: 0.6
Set DO[3]=Off
Set DO[2]=On
Wait: 0.5
Set DO[4]=Off
WP_3_1_3
If (digital_in[2]≠ False ) and (Pre_Program≠ False ) and No_mould≠ False
Popup
Item_p_f_imm:= False
Item_man_p_f_mo:= True
If Pre_Program≠ True
Item_man_p_f_mo:= True
Pre_Program:= False
No_mould:= False
If Item_man_p_f_mo≠ True
Item_p_f_imm:= True
highest_force:=0
measure_force:= True
WP_load_1_1_4
WP_load_1_1_5
WP_load_1_1_6
Wait: 0.1
Set DO[0]=Off
Set DO[1]=On
Wait: 0.3
If digital_in[1]≠ False
jig_out_pos_1:= True
No_mould:= True
Item_p_f_tray:= False
measure_force:= False
WP_load_1_1_7
Wait: 0.1
If tool_in[0]≠ True
jig_out_pos_2:= True
No_mould:= True
WP_load_1_1_4
WP_load_1_1_1
Waypoint_4
If (jig_out_pos_1≠ False ) and (jig_out_pos_2≠ False ) and (jig_out_pos_3≠ False ) and (unexpected_forc≠ False )
Set DO[6]=On
Wait: 0.2
Set DO[7]=On
Wait: 0.5
Set DO[7]=Off
jig_out_pos_1:= False
jig_out_pos_2:= False
jig_out_pos_3:= False
unexpected_forc:= False
Waypoint_5
If (Item_table_pos≠0) and (Item_p_f_imm≠ True )
WP_table_up_1
Set DO[2]=Off
Set DO[3]=On
Wait: 0.2
Set TO[0]=Off
Set TO[1]=On
Wait: 0.6
WP_table_up_1_1
Set TO[1]=Off
Item_table_pos:=1
Item_p_f_imm:= False
If (Item_table_pos≠1) and (Item_p_f_imm≠ True )
WP_table_up_2
Set DO[2]=Off

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Set DO[3]=On
Wait: 0.2
Set TO[0]=Off
Set TO[1]=On
Wait: 0.6
WP_table_up_2_1
Set TO[1]=Off
Item_table_pos:=2
Item_p_f_imm:= False
If (Item_table_pos=2) and (Item_p_f_imm= True )
WP_table_up_3
Set DO[2]=Off
Set DO[3]=On
Wait: 0.2
Set TO[0]=Off
Set TO[1]=On
Wait: 0.6
WP_table_up_3_1
Set TO[1]=Off
Item_table_pos:=3
Item_p_f_imm:= False
If (Item_table_pos=3) and (Item_p_f_imm= True )
WP_table_up_4
Set DO[2]=Off
Set DO[3]=On
Set TO[0]=Off
Set TO[1]=On
Wait: 0.6
WP_table_up_4_1
Set TO[1]=Off
Item_table_pos:=0
Item_p_f_imm:= False
Wait: 0.01
Thread_3
Wait: 0.01
If measure_force= True
force_measured:=force()
If force_measured>highest_force
highest_force:=force_measured
If highest_force>120
unexpected_forc:= True
No_mould:= True
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