

000000  
(000000)

[Program Name : ClipInsertion]

[Section Name : Sequencer]

Initialize sequencer and check if valid

A200.11

P\_First\_Cycle  
First Cycle  
Flag

>  
(320)  
D100  
ClipInsertio  
n  
&3  
S\_WaitForPr  
essUp

[OP1]  
Sequencer for  
clip insertion  
[OP2]  
Wait for press  
to home

MOV  
(021)  
&0  
S\_Initialize  
D100  
ClipInsertio  
n

[OP1]  
Wait for part sensors off and press cylinder home  
[OP2]  
Sequencer for clip insertion  
<cD00100>  
c01 c03 c04 c06 c07 c09 c10 c12 c13

000001  
(000003)

State 0: Wait for part sensors off and press cylinder home

=  
(300)  
D100  
ClipInsertio  
n  
&0  
S\_Initialize

[OP1]  
Sequencer for  
clip insertion  
[OP2]  
Wait for part  
sensors off  
and press  
cylinder home

MOV  
(021)  
&1  
S\_WaitForP  
arts  
D100  
ClipInsertio  
n

[OP1]  
Wait for operator to load clip and substrate  
[OP2]  
Sequencer for clip insertion  
<cD00100>  
c01 c02 c03 c06 c07 c09 c10 c12 c13

100.01  
B\_Initialize

Wait for part sensors off and press cylinder home

000002  
(000006)

State 1: Wait for operator to load clip and substrate

=  
(300)  
D100  
ClipInsertio  
n  
&1  
S\_WaitForP  
arts

[OP1]  
Sequencer for  
clip insertion  
[OP2]  
Wait for  
operator to  
load clip and  
substrate

MOV  
(021)  
&2  
S\_WaitForPr  
essDown  
D100  
ClipInsertio  
n

[OP1]  
Wait for press to move down  
[OP2]  
Sequencer for clip insertion  
<cD00100>  
c01 c02 c03 c04 c06 c09 c10 c12 c13

100.02  
B\_WaitForPar  
ts

Wait for operator to load clip and substrate

Title	Clip Insertion Sample Program	Author	A. Zeeman	Step Number	
Number		Revision	1	Date	5/2/2010
					000000

000003  
(000009)

State 2: Wait for press to move down

=  
(300)  
D100  
ClipInsertion  
&2  
S\_WaitForPressDown

[OP1]  
Sequencer for clip insertion  
[OP2]  
Wait for press to move down

MOV  
(021)  
&3  
S\_WaitForPressUp  
D100  
ClipInsertion

[OP1]  
Wait for press to home  
[OP2]  
Sequencer for clip insertion  
<cD00100>  
c01 c02 c03 c04 c06 c07 c09 c12 c13

100.03  
○  
B\_WaitForPressDown

Wait for press to move down

000004  
(000012)

State 3: Wait for press to home

=  
(300)  
D100  
ClipInsertion  
&3  
S\_WaitForPressUp

[OP1]  
Sequencer for clip insertion  
[OP2]  
Wait for press to home

MOV  
(021)  
&0  
S\_Initialize  
D100  
ClipInsertion

[OP1]  
Wait for part sensors off and press cylinder home  
[OP2]  
Sequencer for clip insertion  
<cD00100>  
c01 c02 c03 c04 c06 c07 c09 c10 c12

100.04  
○  
B\_WaitForPressUp

Wait for press to home

Title	Clip Insertion Sample Program	Author	A. Zeeman	Step Number	000009
Number		Revision	1	Date	5/2/2010