

000000  
(000007)

[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>  
c08 c10 c14 c17 c21 c24 c27 c30 c33

000001  
(000010)

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

100.05      0.05  
PartSensorsCl      PressHome  
ear      Press cylinder  
All parts      in home  
sensors are      position  
off

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

[OP1]  
Wait for operator to load clip and substrate  
[OP2]  
Sequencer for clip insertion  
<cD00100>  
c08 c09 c10 c17 c21 c24 c27 c30 c33

100.01  
B\_Initialize

Wait for part sensors off and press cylinder home

000002  
(000017)

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

100.06      0.07  
AllPartsPrese      Start  
nt      Start button  
All parts are      pressed  
present

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

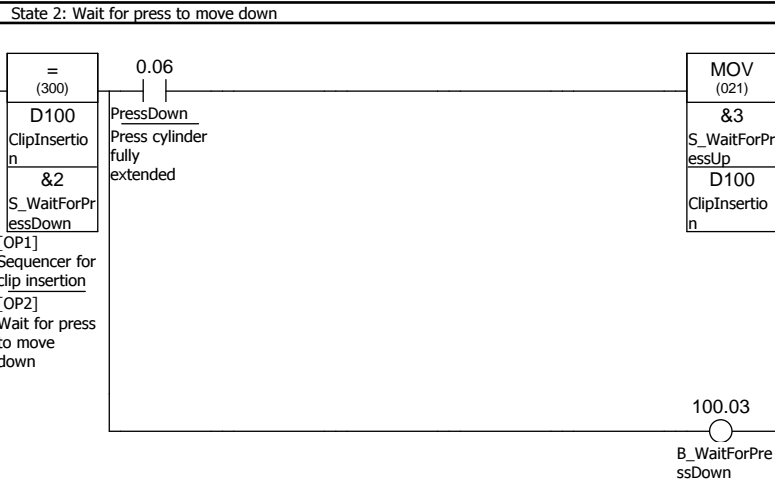
[OP1]  
Wait for press to move down  
[OP2]  
Sequencer for clip insertion  
<cD00100>  
c08 c09 c10 c14 c17 c24 c27 c30 c33

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	000007

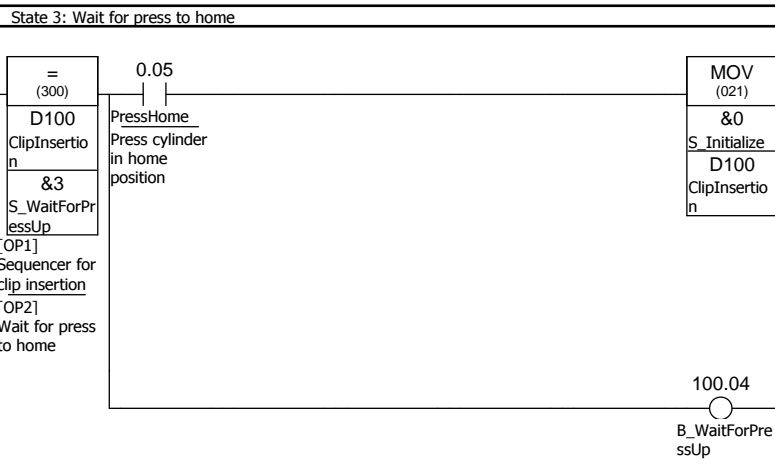
000003  
(000024)



[OP1]  
Wait for press to home  
[OP2]  
Sequencer for clip insertion  
<cD00100>  
c08 c09 c10 c14 c17 c21 c24 c30 c33

Wait for press to move down

000004  
(000030)



[OP1]  
Wait for part sensors off and press cylinder home  
[OP2]  
Sequencer for clip insertion  
<cD00100>  
c08 c09 c10 c14 c17 c21 c24 c27 c30

Wait for press to home

Title	Clip Insertion Sample Program	Author	A. Zeeman	Step Number	
Number		Revision	1	Date	5/2/2010
					000024