

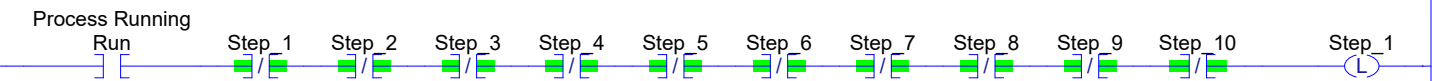
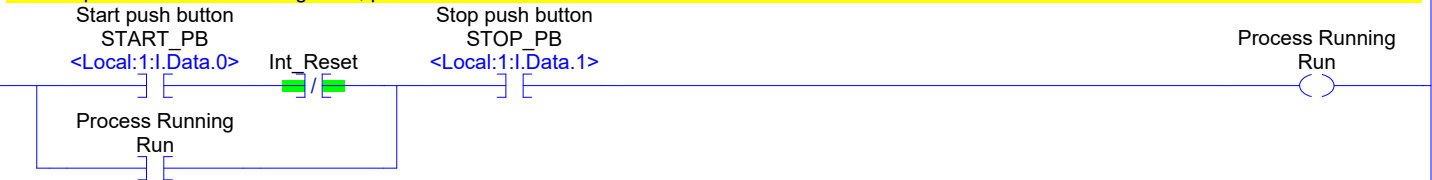
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Pick-and-Place Machine Control

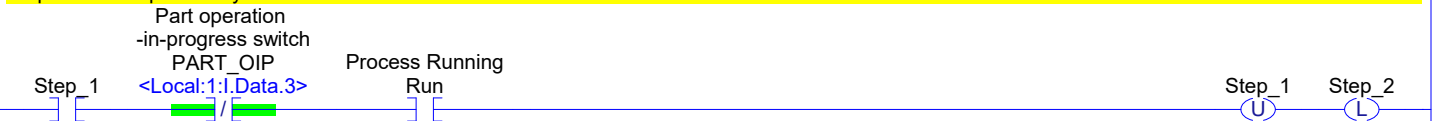
Additional internal memory:

Tag	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Step_1 to Step_10	BOOL	Step-in-progress bits
Clamp_Tmr	TIMER	Times clamp
Unclamp_Tmr	TIMER	Times unclamp
Reset_Tmr	TIMER	Times unclamp during reset

Start/stop and initial start. During reset, prevent start



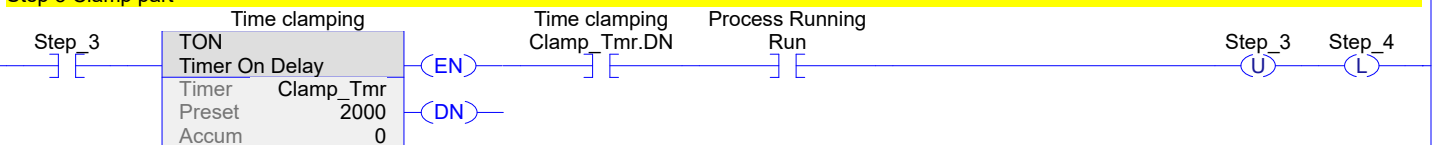
Step 1 Wait for part ready



Step 2 Lower to left table



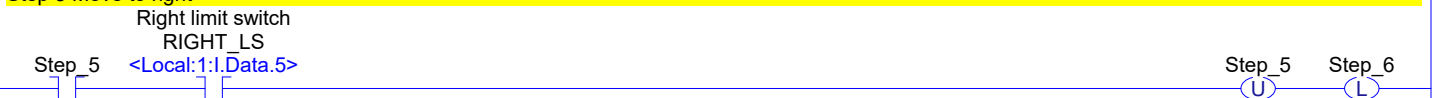
Step 3 Clamp part



Step 4 Raise to home



Step 5 Move to right



Step 6 Wait for part removed



