

DATA REGISTERS

R[1] = NUMBER OF PARTS PICKED FROM THE X+ DIRECTION (ROWS)
R[2] = NUMBER OF PARTS PICKED FROM THE Y+ DIRECTION (COLUMNS)
R[50] = NUMBER OF ROWS IN THE X+ DIRECTION
R[51] = NUMBER OF COLUMNS IN THE Y+ DIRECTION
R[52] = OFFSET DISTANCE BETWEEN PARTS IN THE X+ DIRECTION
R[53] = OFFSET DISTANCE BETWEEN PARTS IN THE Y+ DIRECTION

PART_PICK

(NOTE: PR[10] IS THE FIRST PICK POSITION IN THE PALLET.)

```
J PR[10] 100% CNT60 Offset,PR[5]
L PR[10] 500mm/sec FINE
WAIT .05 SEC
GRIPPER_CLOSE
WAIT .05 SEC
L PR[10] 500mm/sec FINE Offset,PR[5]
```

CALL OFFSET_PART

OFFSET_PART

```
PR[10:Pick_Pos,1(x)]=PR[10:Pick_Pos,1(x)]+R[52:X_Offset Dis]
R[1:Parts in X+ Dir]=R[1:Parts in X+ Dir]+1
IF (R[1:Parts in X+ Dir]=R[50:Num of Rows(x)]) THEN
PR[10:Pick_Pos,1(x)]=(10:Pick_Pos,1(x))-(R[52:X_Offset
Dis]*(R[1:Num Picked in X]))
R[1:Num Picked in X]=0
ENDIF
```

```
IF (R[1:Num Picked in X]=0) THEN
PR[10:Pick_Pos,2(y)]=(PR[10:Pick_Pos,2(y)])+(R[51:Num of
Col(y)]*R[53:Y_Offset Dis])-(R[53:Y_Offset Dis]*(R[51:Num of
Col(y)]-1))
R[2:Parts in Y+ Dir]=R[2:Parts in Y+ Dir]+1
ENDIF
```

```
IF (R[2:Parts in Y+ Dir]=R[51:Num of Col(y)]) THEN
PR[10:Pick_Pos,2(y)]=(PR[10:Pick_Pos,2(y)]-(R[53:X_Offset
Dis]*(R[2:Parts in Y+ Dir]))
R[2:Parts in Y+ Dir]=0
ENDIF
```