&ACCESS RV

&PARAM DISKPATH =

DEF RoboDKsync35()

INT io\_id

INT j\_id

INT program\_id

BAS(#INITMOV,0)

PTP $AXIS\_ACT

$ORI\_TYPE = #VAR

$CIRC\_TYPE = #BASE

$VEL.ORI1 = 200

$VEL.ORI2 = 200

$ACC.ORI1 = 100

$ACC.ORI2 = 100

$VEL.CP=3

$ACC.CP=10

$BASE = {FRAME: X 0,Y 0,Z 0,A 0,B 0,C 0}

$TOOL = {FRAME: X 0,Y 0,Z 0,A 0,B 0,C 0}

$ADVANCE = 0

COM\_ROUNDM = -1

COM\_ACTION = 0

COM\_ACTCNT = 0

$APO.CPTP = 0

$APO.CDIS = 0

WHILE COM\_ACTION >= 0

SWITCH COM\_ACTION

CASE 1

; do nothing

COM\_ACTCNT = COM\_ACTCNT + 1

COM\_ACTION = 0

CASE 2

IF COM\_ROUNDM >= 0 THEN

PTP COM\_E6AXIS C\_PTP

ELSE

PTP COM\_E6AXIS

ENDIF

COM\_ACTION = 0

CASE 3

IF COM\_ROUNDM >= 0 THEN

LIN COM\_FRAME C\_DIS

ELSE

LIN COM\_FRAME

ENDIF

COM\_ACTION = 0

CASE 4

IF COM\_ROUNDM >= 0 THEN

CIRC COM\_POS,COM\_FRAME C\_DIS

ELSE

CIRC COM\_POS,COM\_FRAME

ENDIF

COM\_ACTION = 0

CASE 5

COM\_ACTCNT = COM\_ACTCNT + 1

$TOOL = COM\_FRAME

COM\_ACTION = 0

CASE 6

COM\_ACTCNT = COM\_ACTCNT + 1

$VEL.CP = COM\_VALUE1

COM\_ACTION = 0

CASE 7

COM\_ACTCNT = COM\_ACTCNT + 1

IF COM\_VALUE1 > 0 THEN

$VEL.CP = COM\_VALUE1

ENDIF

IF COM\_VALUE2 > 0 THEN

;$VEL.ORI1 = COM\_VALUE2

;$VEL.ORI2 = COM\_VALUE2

FOR j\_id=1 TO 6

IF COM\_VALUE2 > 100 THEN

$VEL\_AXIS[j\_id] = 100

ELSE

$VEL\_AXIS[j\_id] = COM\_VALUE2

ENDIF

ENDFOR

ENDIF

IF COM\_VALUE3 > 0 THEN

$ACC.CP = COM\_VALUE3

ENDIF

IF COM\_VALUE4 > 0 THEN

;$ACC.ORI1 = COM\_VALUE4

;$ACC.ORI2 = COM\_VALUE4

FOR j\_id=1 TO 6

IF COM\_VALUE4 > 100 THEN

$ACC\_AXIS[j\_id] = 100

ELSE

$ACC\_AXIS[j\_id] = COM\_VALUE4

ENDIF

ENDFOR

ENDIF

COM\_ACTION = 0

CASE 8

COM\_ACTCNT = COM\_ACTCNT + 1

IF COM\_ROUNDM >= 0 THEN

IF COM\_ROUNDM > 100 THEN

$APO.CPTP = 100

ELSE

$APO.CPTP = COM\_ROUNDM

ENDIF

$APO.CDIS = COM\_ROUNDM

$ADVANCE = 1

ELSE

$APO.CPTP = 0

$APO.CDIS = 0

$ADVANCE = 0

ENDIF

COM\_ACTION = 0

CASE 9

COM\_ACTCNT = COM\_ACTCNT + 1

WAIT SEC COM\_VALUE1

COM\_ACTION = 0

CASE 10

COM\_ACTCNT = COM\_ACTCNT + 1

io\_id = COM\_VALUE1

IF COM\_VALUE2 > 0.5 THEN

$OUT[io\_id] = TRUE

ELSE

$OUT[io\_id] = FALSE

ENDIF

COM\_ACTION = 0

CASE 11

PTP COM\_E6AXIS

LIN COM\_FRAME

WAIT SEC 0

COM\_ACTION = 0

CASE 12

COM\_ACTCNT = COM\_ACTCNT + 1

io\_id = COM\_VALUE1

IF COM\_VALUE2 > 0.5 THEN

WAIT FOR $IN[io\_id]==TRUE

ELSE

WAIT FOR $IN[io\_id]==FALSE

ENDIF

COM\_ACTION = 0

CASE 13

;----- Run program COM\_VALUE1 ---------

; (to trigger from RoboDK: use robot.RunCodeCustom("program id", INSTRUCTION\_CALL\_PROGRAM)

program\_id = COM\_VALUE1

SWITCH program\_id

CASE 1

; -- run program 1 --

; Drill()

; -------------------

CASE 2

; -- run program 2 --

; Cut()

; -------------------

ENDSWITCH

;--------------------------------------------

COM\_VALUE1 = 0

COM\_ACTION = 0

; DEFAULT

; COM\_ACTION = 0

ENDSWITCH

ENDWHILE

END