:=

reg1+5*reg3

Data := Value

Data

All

Value

Same as Data

1
reg1 := 5;

reg1   5

2
reg1 := reg2 - reg3;

reg1   reg2-reg3

3
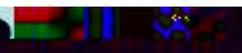counter := counter + 1;

counter

Comment

! Goto the position above pallet
MoveL p100, v500, z20, tool1;
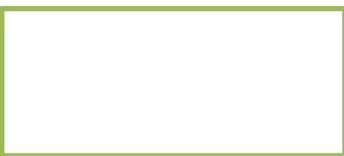
! Comment

Comment

WaitTime
WaitUntil
WaitDI
WaitDo

1 WaitTime

```
WaitTime [\Inpos,] Time;
      [\Inpos]                                              switch
      Time                            s        num


      [\InPOS]
```

```
WaitTime 3;
WaitTime\InPos,0.5;
WaitTime\InPos,0;

[\InPOS]
```

WaitTime [\InPos] Time

[\InPos]

In Position

switch

Time

num

0 s

0.001 s

2 WaitUntil

WaitUntil [\Inpos,]Cond[\MaxTime][\TimeFlag];

    [\Inpos]   switch

    Cond   bool

    [\MaxTime]   num

    [\TimeFlag]   bool

[\MaxTime]

num

ERR_WAIT_MAXTIME

[\TimeFlag]

Timeout Flag

bool

TRUE

MaxTime

[\lnPOS]

[\lnPOS]

WaitUntil 100
ms Pollrate

TimeFlag

TimeFlag

TRUE

WaitUntil di4 = 1;

di4

```
WaitUntil di1 = 1 AND di2 = 1 \MaxTime := 60 \Visualize;

..
        ERROR
            IF ERRNO = ERR_WAIT_MAX THEN
                RAISE;
            ELSE
                Stop;
            ENDIF
```

60

```
PROC PickPart()
        MoveJ pPrePick,vFastEmpty,zBig,tool1;
        bTimeout:=TRUE;
        nCounter:=0;
        WHILE bTimeout DO
                IF nCounter>3 THEN
                        TPWrite " ....." ;
                ENDIF
                IF nCounter>30 THEN
                        stop;
                ENDIF
                WaitUntil
bok=TRUE\MaxTime:=1\TimeFlag:=bTimeout:
                Incr nCounter;
        ENDWHILE
        …
ENDPROC
```

WaitDI Signal,Value [\MaxTime][\TimeFlag];

signal : signaldo

Value : dionum

[\MaxTime] : num

[\TimeFlag] : bool

```
PROC Pickpart()
        MoveJ pPrePick,vFastempty,zBig,tool1;
        WaitDI di_Ready,1;

        …
ENDPROC
PROC PickPart()
        MoveJ pPrepick,vFastEmpty,zBig,tool1;
        WaitDI di_Ready,1\WMaxTime:=5

        …
        IF ERRNO=ERR_WAIT_MAXTIME THEN
                TPWrite "……";
                RETRY;
        ELSE
                RAISE;
        ENDIF
ENDPROC
```
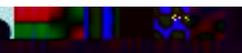
4 WaitDo

WaitDO Signal,Value [\MaxTime][\TimeFlag];

signal :   signaldo

Value :   dionum
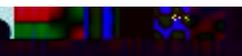
[\MaxTime] :   num

[\TimeFlag] :   bool

TryInt	
OpMode	
RunMode	
NonMotionMode	
Dim	
Present	
IsPers	
IsVar	

StrToByte	
ByteToStr	