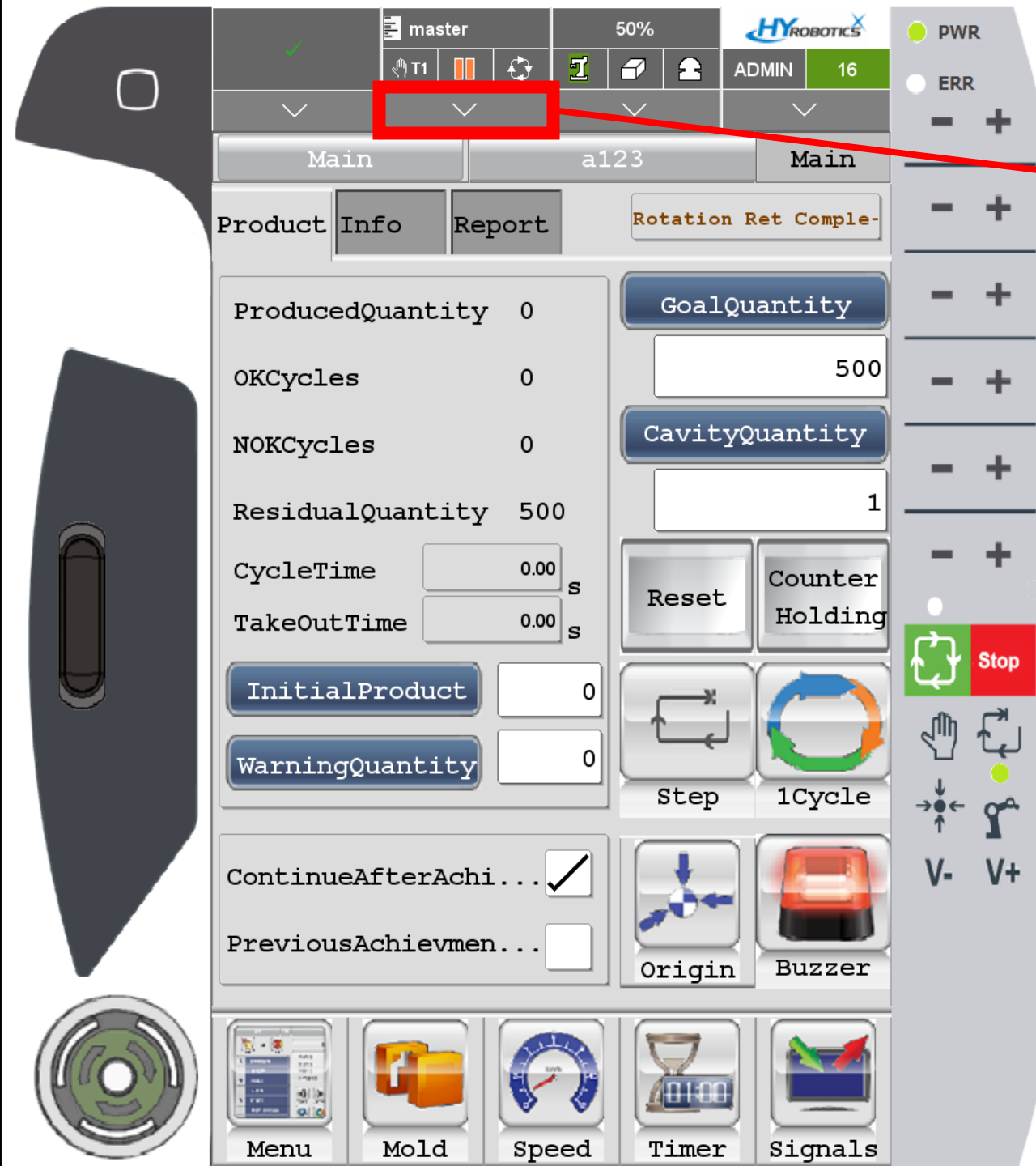


HOW TO ADD DIRECT OUTPUT AFTER PALLETIZING CYCLE





Log in level 16 Admin
PW: pass



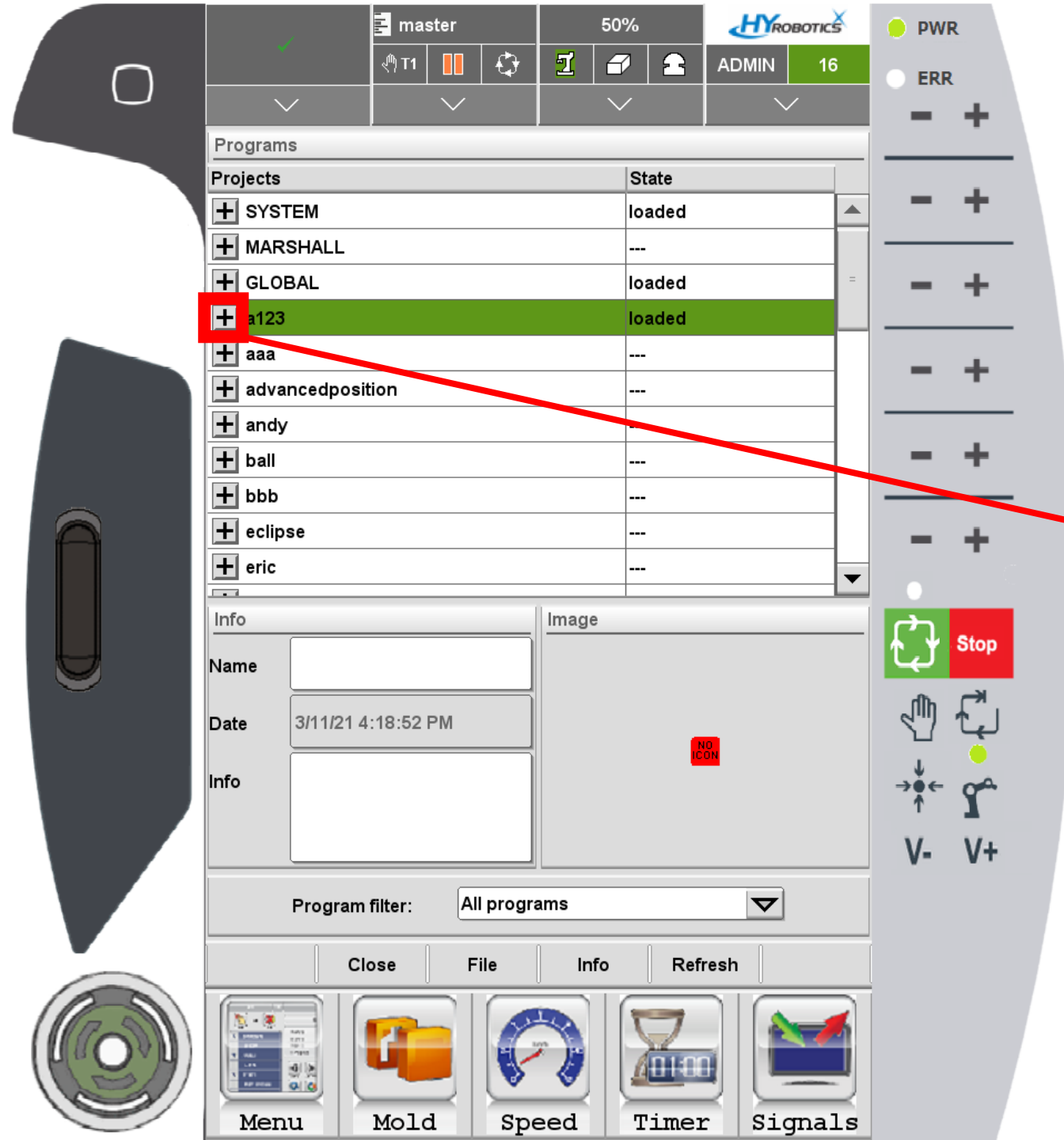
Press here



Press here



You will see
your mold
project files



Press **+** button and
Expand **currently loaded**
mold project file

master50%HY ROBOTICS

T1ADMIN16

Programs

Projects	State
ReadCurPos	---
Rotation	---
RotationReturn	---
RunnerRelease	---
RunnerReturnRelease	---
RunnerTraverseReturn	---
SecondPositionDown	---
SecondPositionUp	---
SubArmReleaseWhile Trav	---
Swivel	---
SwivelReturn	---

Info

Name

Date3/2/21 10:43:12 PM

Info

Image

NO ICON

Program filter: All programs

OpenFileInfoRefresh

Menu

Mold

Speed

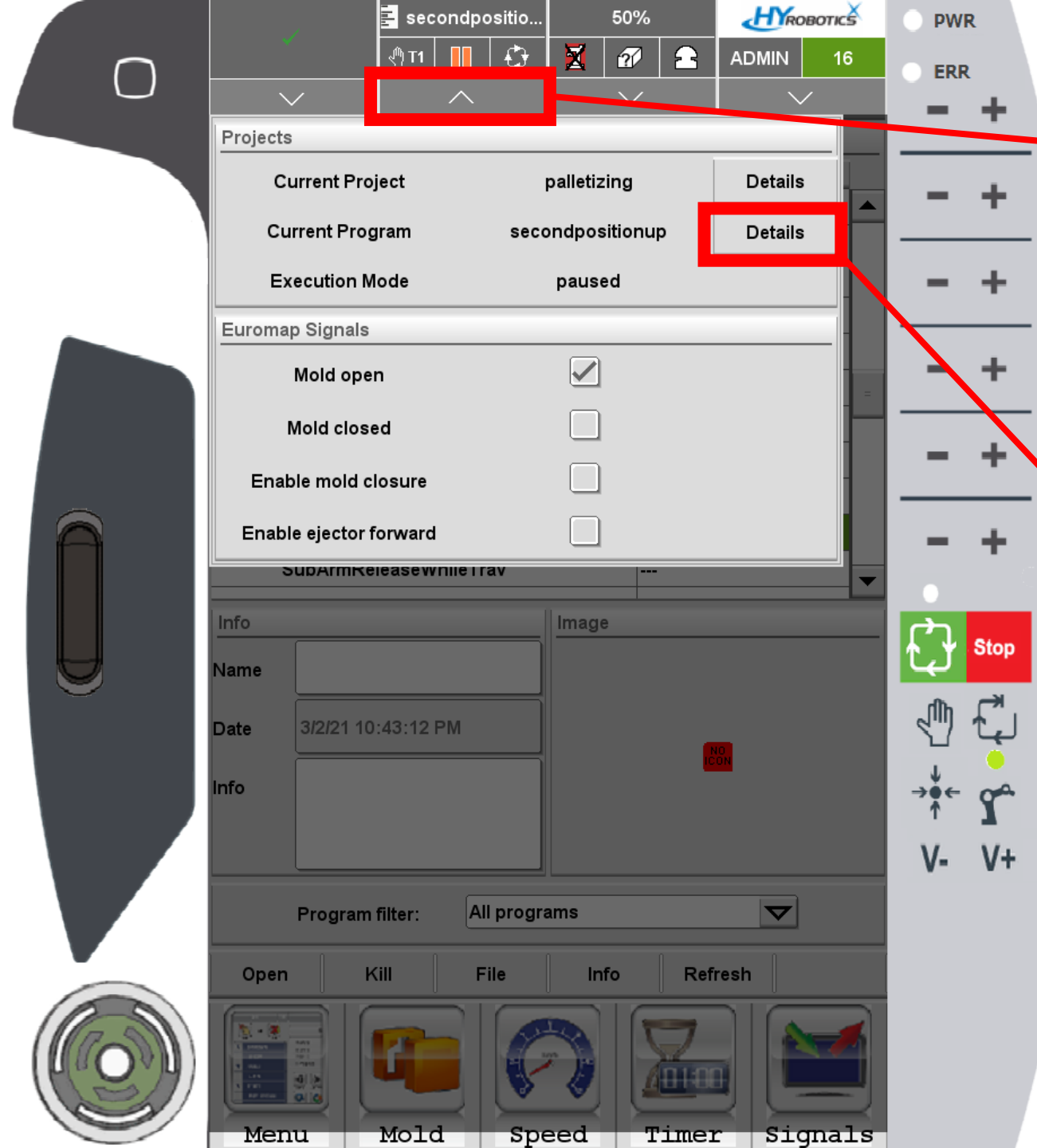
Timer

Signals

Find **SecondPositionUp**
And
OPEN it



Confirm
SecondPositionUp
is loaded



Click here

Click here

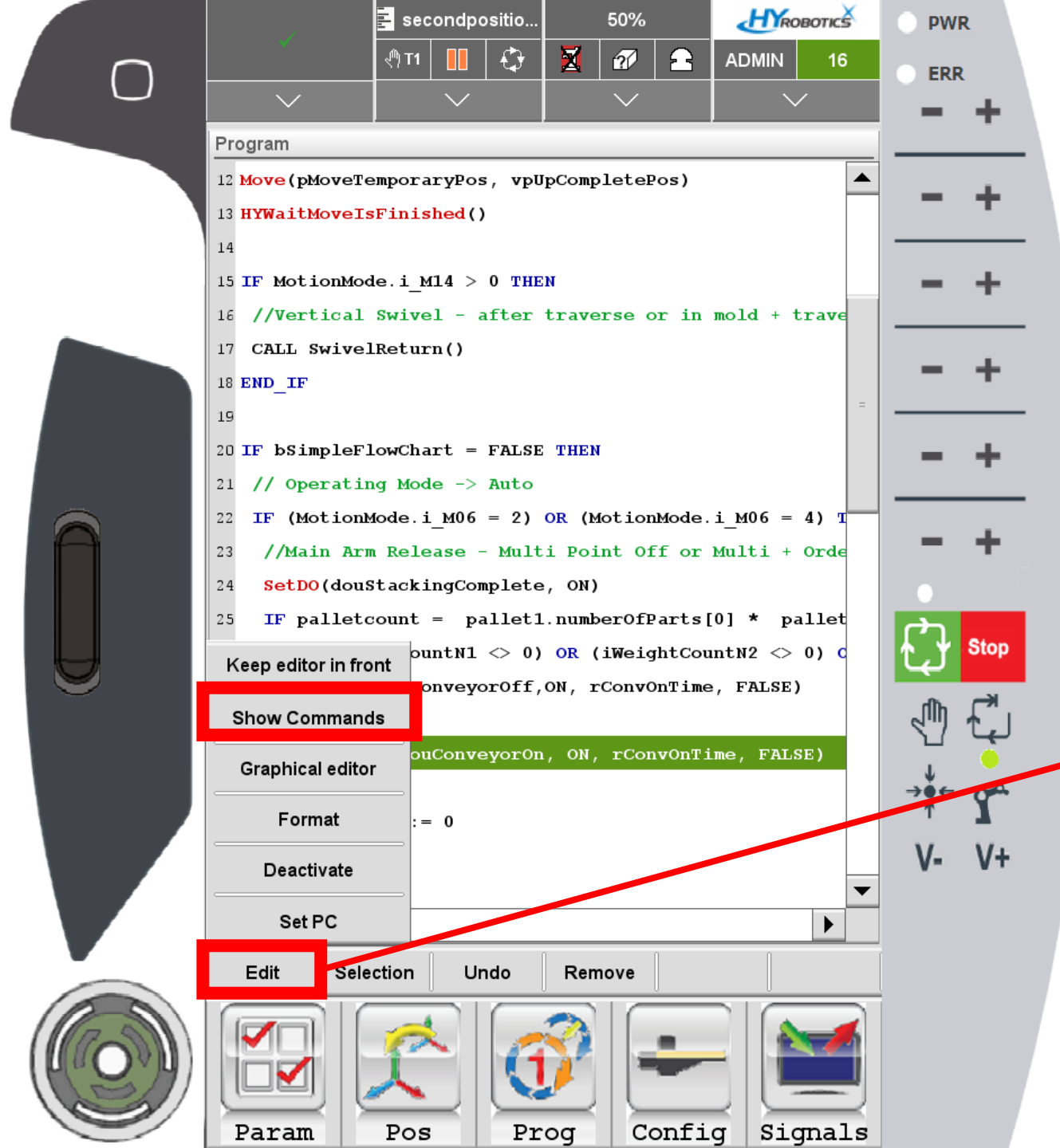
```

12 Move(pMoveTemporaryPos, vpUpCompletePos)
13 HYWaitMoveIsFinished()
14
15 IF MotionMode.i_M14 > 0 THEN
16 //Vertical Swivel - after traverse or in mold + trave
17 CALL SwivelReturn()
18 END_IF
19
20 IF bSimpleFlowChart = FALSE THEN
21 // Operating Mode -> Auto
22 IF (MotionMode.i_M06 = 2) OR (MotionMode.i_M06 = 4) T
23 //Main Arm Release - Multi Point Off or Multi + Orde
24 SetDO(douStackingComplete, ON)
25 IF palletcount = pallet1.numberOfParts[0] * pallet
26 IF (iWeightCountN1 <> 0) OR (iWeightCountN2 <> 0) c
27 PulseDO(douConveyorOff, ON, rConvOnTime, FALSE)
28 ELSE
29 PulseDO(douConveyorOn, ON, rConvOnTime, FALSE)
30 END_IF
31 palletcount := 0
32 END_IF
33 ELSE

```

Find and select
PulseDO(douConveyorOn) line.

There is one more identical line.
Make sure you select the right one.



Edit – Show Commands

Program

```
17 HYWaitForIMM()  
18 // START_EDIT  
19 // 2.00a.12  
20 HYTakeOutPosition(TakeOutPos, vpTakeOutPos, rKickRetu  
21 HYUpPosition(UpPos, vpUpPos, rUpDelay)  
22 HYRunnerRelease(SubArmReleasePos, vpSubArmReleasePos,  
23 HYMainRelease(MainArmReleasePos, vpMainArmReleasePos,  
24 HYRunnerReturnRelease(SubArmReleasePos, vpSubArmRelea  
25 HYInsertGripWaiting(InsertGripWaitingPos, vpInsertGri  
26 HYInsertGrip(InsertGripPos, vpInsertGripPos, rInsertG  
27 HYToWaitingPos(home position, vpWaitingPos, rDownDela  
28 // END_EDIT  
29 IF bOnlyOneAutoRun THEN  
30 BREAK
```

Movement IMMIOActionAddToQueue
Homing IMMIOActionQueueSet
Settings IMMIOActionQueueClear
I/O-Control IMMStartup
Flow Control SetDO
Timing PulseDO
HanYang SetIMM

Edit Selection Remove

I/O Control – Pulse DO

secondpositio...50%HY ROBOTICS

T1

ADMIN16

Program

11 pMoveTemporaryPos.Aux2 := Aux2-axis home position

12 Move(pMoveTemporaryPos, vpUpCompletePos)

13 HYWaitMoveIsFinished()

14

15 IF MotionMode.i_M14 > 0 THEN

16 //Vertical Swivel - after traverse or in mold + trave

17 CALL SwivelReturn()

18 END_IF

19

20 IF bSimpleFlowChart = FALSE THEN

21 // Operating Mode -> Auto

22 IF (MotionMode.i_M06 = 2) OR (MotionMode.i_M06 = 4) T

23 //Main Arm Release - Multi Point Off or Multi + Orde

24 SetDO(douStackingComplete, ON)

25 IF palletcount = pallet1.numberOfParts[0] * pallet

26 IF (iWeightCountN1 <> 0) OR (iWeightCountN2 <> 0) C

27 PulseDO(douConveyorOff,ON, rConvOnTime, FALSE)

28 ELSE

29 PulseDO(douConveyorOn, ON, rConvOnTime, FALSE)

30 END_IF

PulseDO(douUserOutput1,0.0)

Modifykeyboardadd DOCancelOk

Param

Pos

Prog

Config

Signals

PWR

ERR

-+

-+

-+

-+

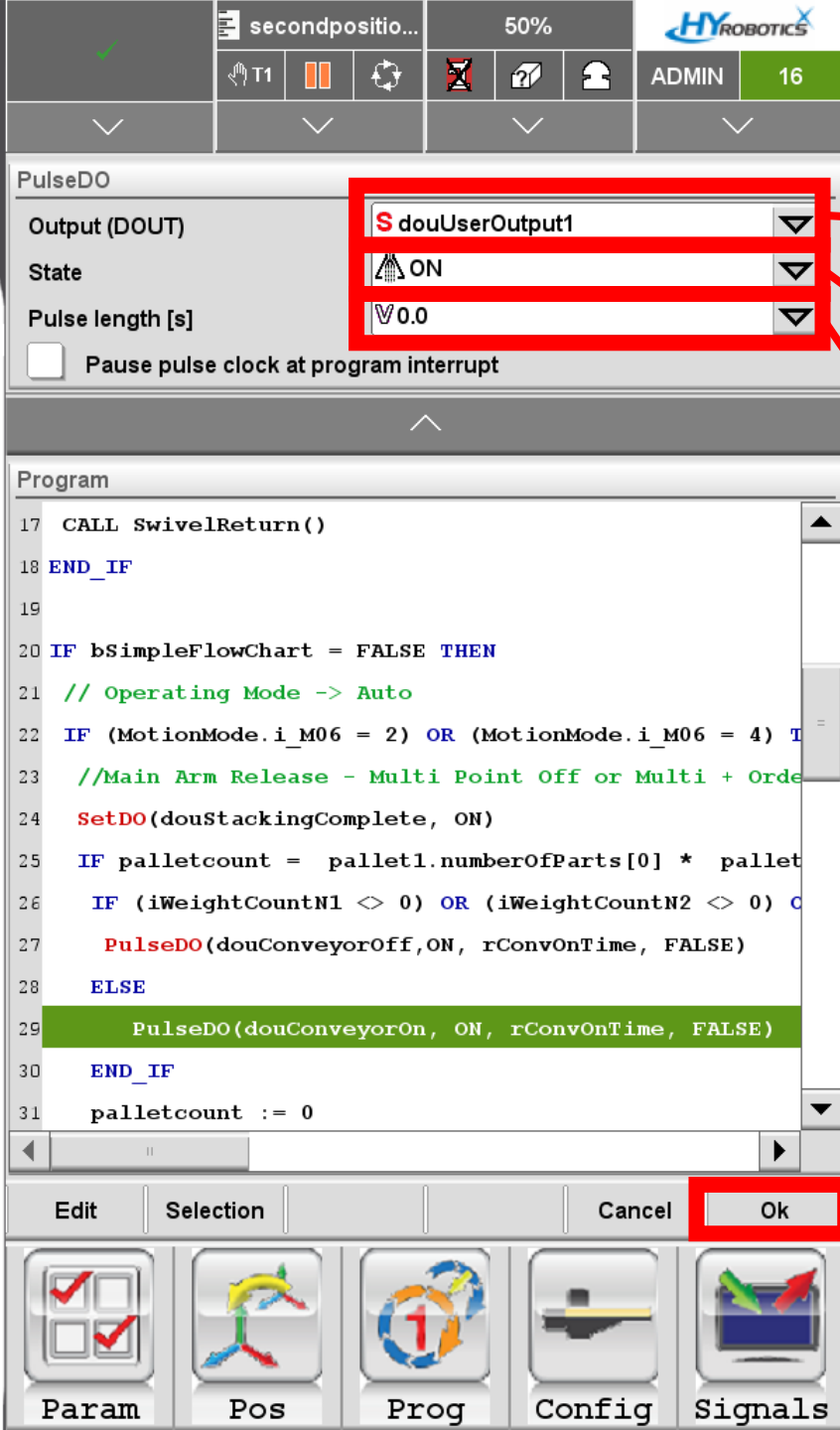
-+

-+

Stop

V-V+

Modify

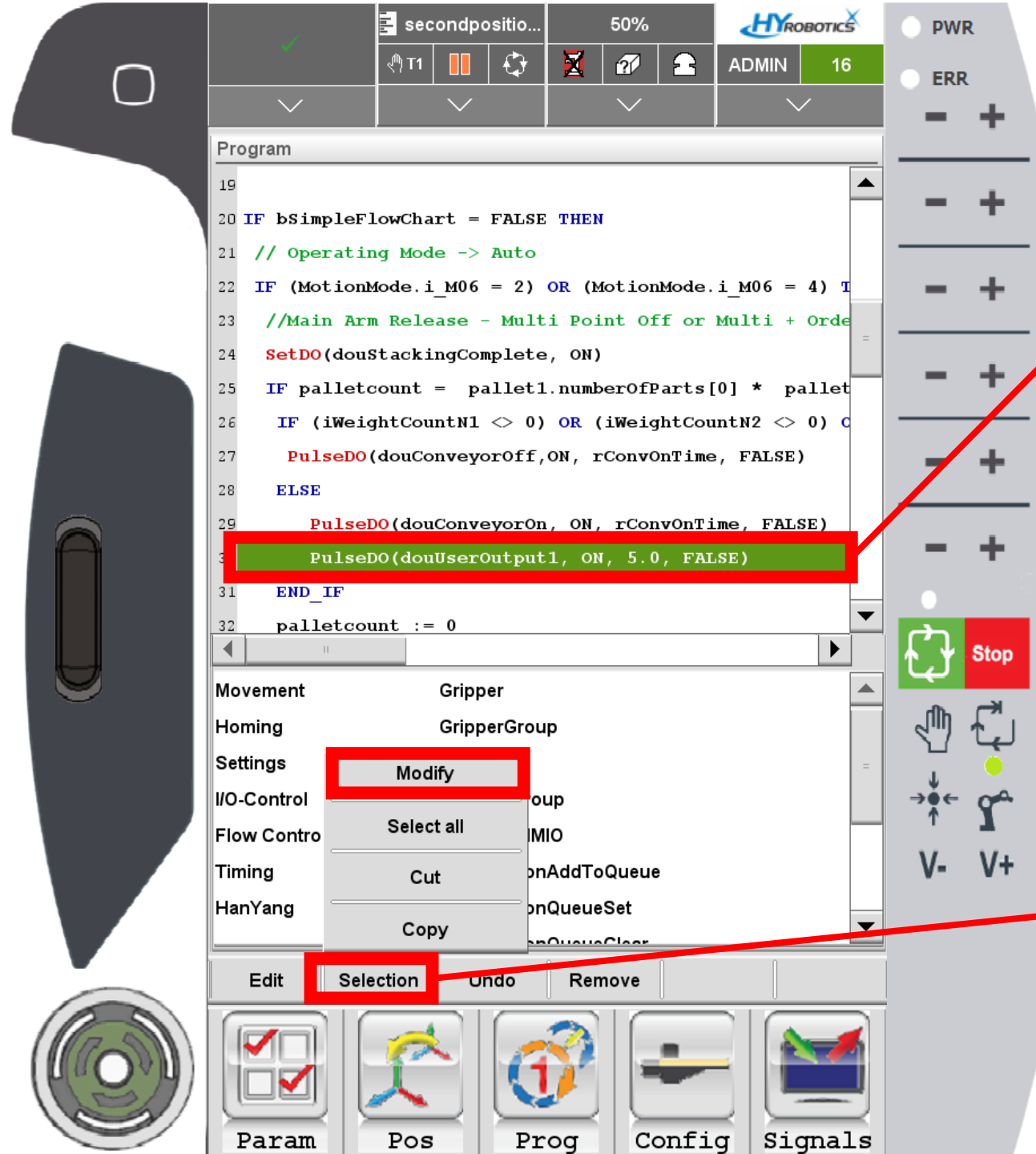


You can select which User output to use.

ON

Type pulse length.
It is seconds.

Hit OK



DO command added.

Robot will turn on DO1
for 5 seconds.

If you want to modify
the command,

Selection - Modify



Click here

Click here

secondpositio...

50%

HYROBOTICS

T1

ADMIN

16

Programs

Projects	State
MainRelease	---
OutSideWaitPosition	---
ReadCurPos	---
Rotation	---
RotationReturn	---
RunnerRelease	---
RunnerReturnRelease	---
RunnerTraverseReturn	---
SecondPositionDown	---
SecondPositionUp	stopped
SubArmReleaseWhileTrav	---

Info

Name

Date

Info

3/2/21 10:43:12 PM

Image

NO ICON

Program filter:

All programs

Open

Kill

File

Info

Refresh

Menu

Mold

Speed

Timer

Signals

PWR

ERR

-

+

-

+

-

+

-

+

-

+

-

+

Stop

V-

V+

Kill currently opened
secondpositionup



① Kill currently opened master

② Open master again

UserOutput1 is Y104

