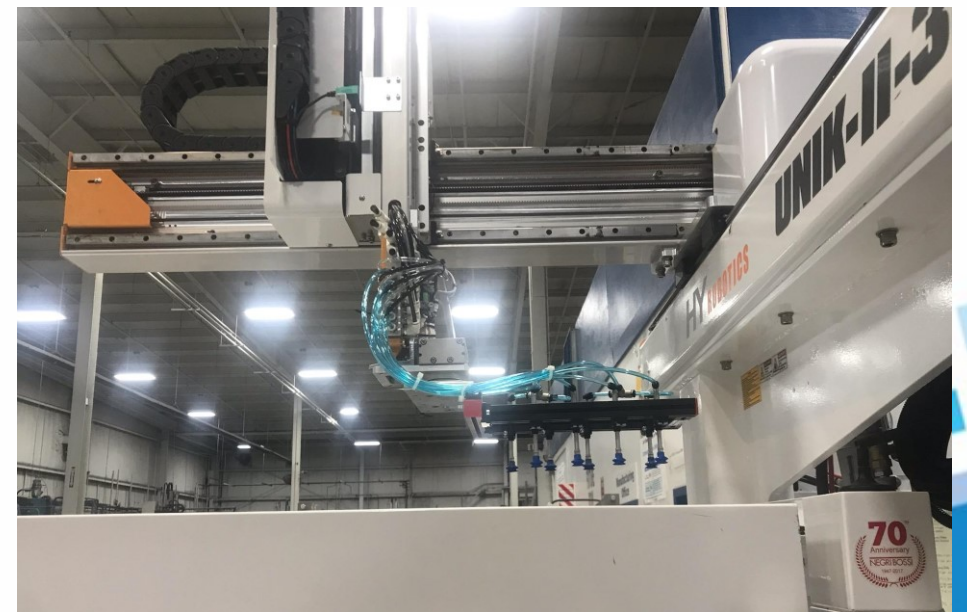
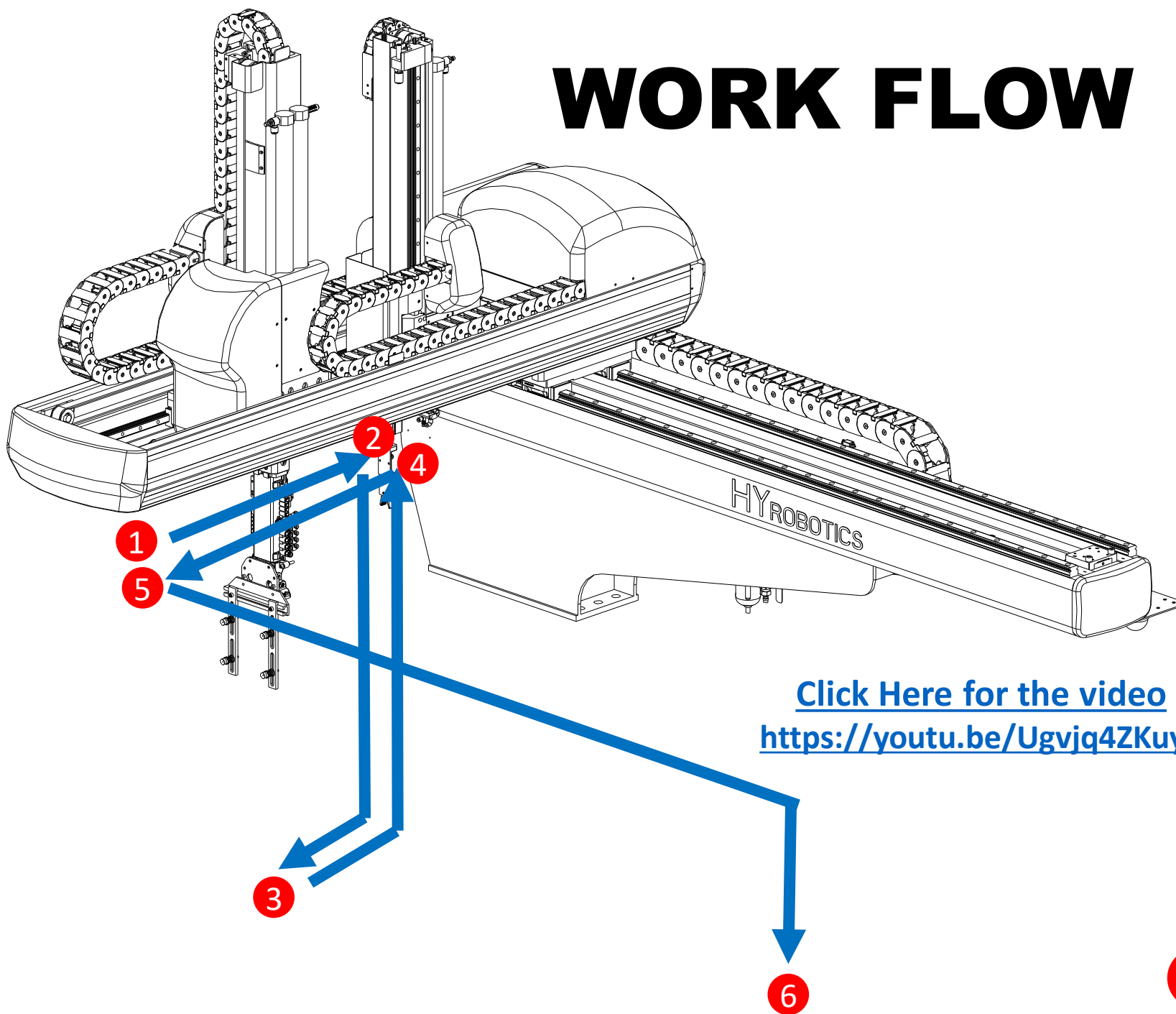


A CUSTOM PROGRAM FOR A LONG EOAT

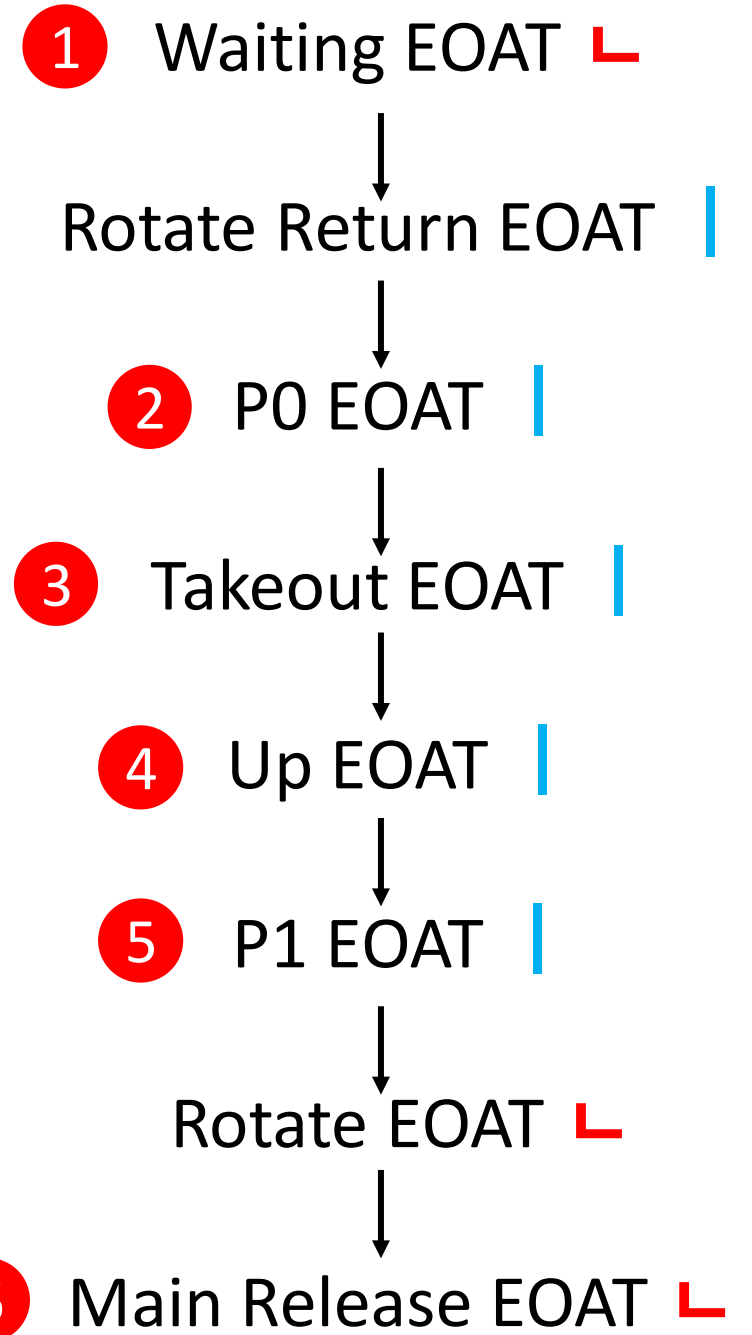
EPIK / UNIK



WORK FLOW



[Click Here for the video
https://youtu.be/Ugvjq4ZKuyg](https://youtu.be/Ugvjq4ZKuyg)

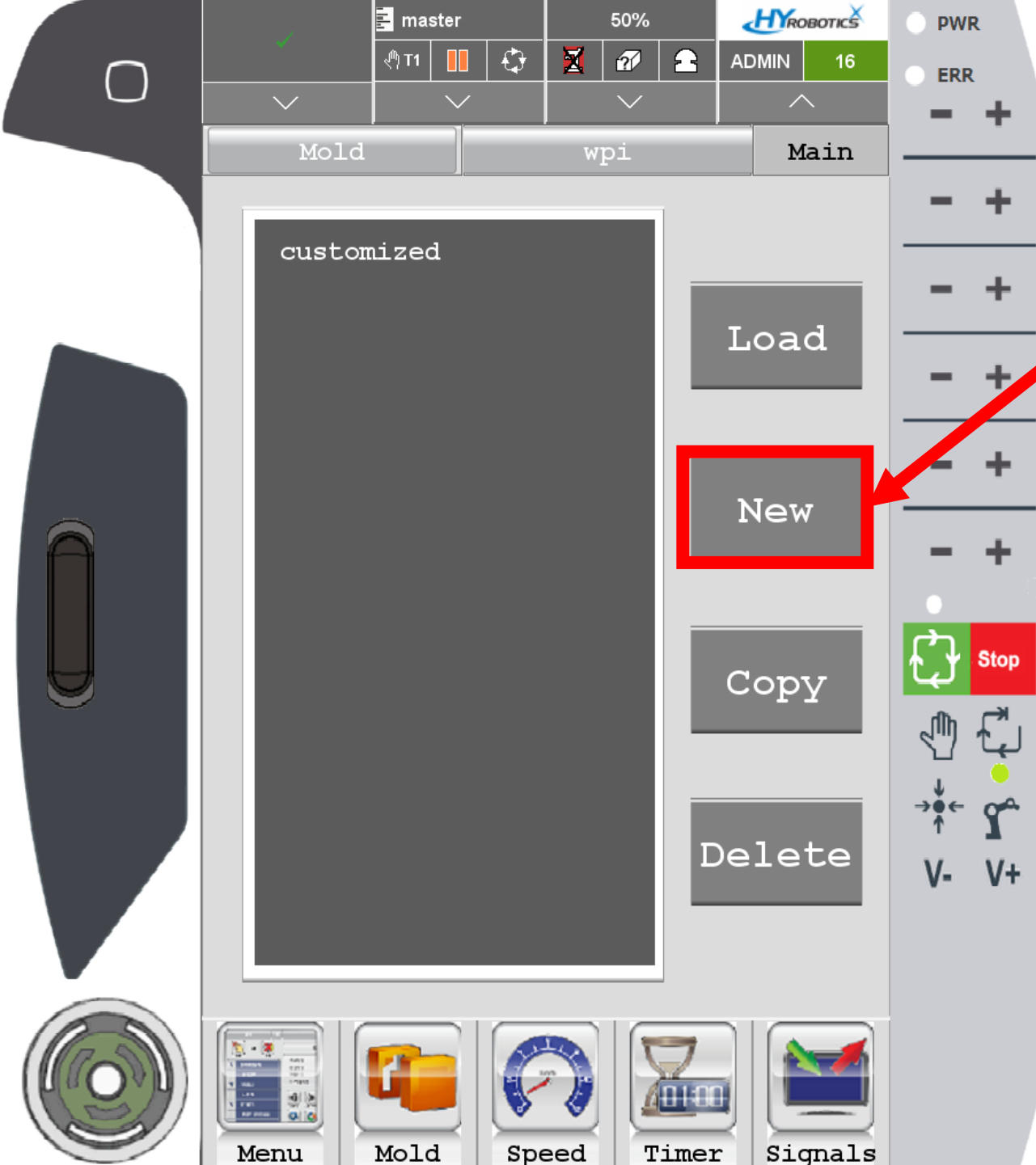




STEP 1

MAKING A NEW MOLD FILE





Make a new mold file.

**After the new mold file is created,
Power off the robot.**



STEP 2

**COPY & PASTE
CUSTOMIZED SUB-PROGRAMS**












**Power off the robot.
Take out SD card from the robot PLC
in the control box**



Connect it to the PC

Name	Date modified	Type
 application	5/25/2021 10:31 AM	File folder
 protocol	5/25/2021 10:31 AM	File folder
 system	5/25/2021 10:31 AM	File folder
 systemsettings	5/25/2021 10:31 AM	File folder
 terminal	5/25/2021 10:31 AM	File folder
 PmaData.bin	3/7/2018 10:54 AM	BIN File
 ProcessData.csv	5/25/2021 3:17 PM	Microsoft Excel C...

Before moving on to the next step,
PLEASE BACK UP these data
into your PC or another SD card.

Name	Date modified
application	12/10/2020 3:55 PM
protocol	12/10/2020 3:55 PM
system	12/10/2020 3:55 PM
systemsettings	12/10/2020 3:55 PM
terminal	12/10/2020 3:55 PM
PmaData.bin	3/7/2018
ProcessData.csv	12/3/2020

<Application>



> application

Name	Date modified	Type
control	12/10/2020 3:55 PM	File
view	12/10/2020 3:55 PM	File

<Control>



> application > control

Name

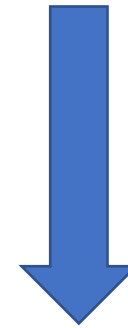
config
iecontrol
teachcontrol
text

> application > control > teachcontrol

Name

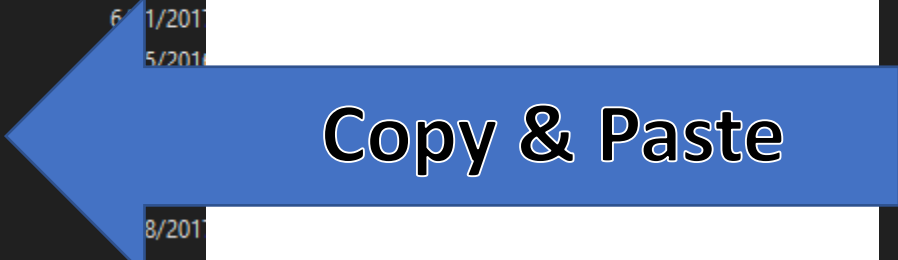
_global.tt
_system.tt
a1214.tt
aaa.tt
advancedposition.tt
andy.tt
ball.tt
bbb.tt
bbba.tt
eclipse.tt
eric.tt
escalade.tt

<teachcontrol>



You will see mold project file folders.
Find the mold file folder you created in step #1.

Name	Date modified
.nbattr	6/15/2019
_globalvars.tid	5/18/2020
Autolnit.tip	6/1/2019
autolnit_de.properties	5/2019
autolnit_en.properties	
autolnit_ko.properties	
autolnit_zh.properties	
CheckEachPos.tip	8/2019
Debug.tip	6/15/2019
Flowchart.ttu	6/15/2019
homing.tid	6/15/2019
homing.tip	1/7/2019
homing_de.properties	6/15/2019
homing_en.properties	6/15/2019
homing_ko.properties	6/15/2019
homing_zh.properties	6/15/2019
InitialPosition.tid	6/15/2019
InitialPosition.tip	1/9/2019
initialposition_de.properties	6/15/2019
initialposition_en.properties	6/15/2019
initialposition_ko.properties	6/15/2019
initialposition_zh.properties	6/15/2019
initlmm.tid	6/15/2019
initlmm.tip	1/3/2019
initlms.tip	1/3/2019
main.ttp	6/14/2019
MainArmRelease.tip	1/10/2019
mainarmrelease_de.properties	6/15/2019
mainarmrelease_en.properties	6/15/2019
mainarmrelease_ko.properties	6/15/2019
mainarmrelease_zh.properties	6/15/2019



Name
CheckEachPos.tip
MainArmRelease.tip
master.tid
master.tip
TakeOutMainNotJmotion.tip
TakeOutPosition.tip
WaitingPosition.tip

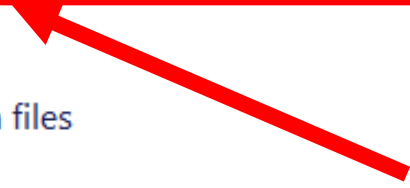
Copy and Paste provided 7 files into the mold file folder.

The destination already has a file named "WaitingPosition.tip"

✓ Replace the file in the destination

↶ Skip this file

📄 Compare info for both files



Select this

⬆ Fewer details

**When replacing the files is done,
Put the SD card back to PLC, and power on the robot.**



STEP 3

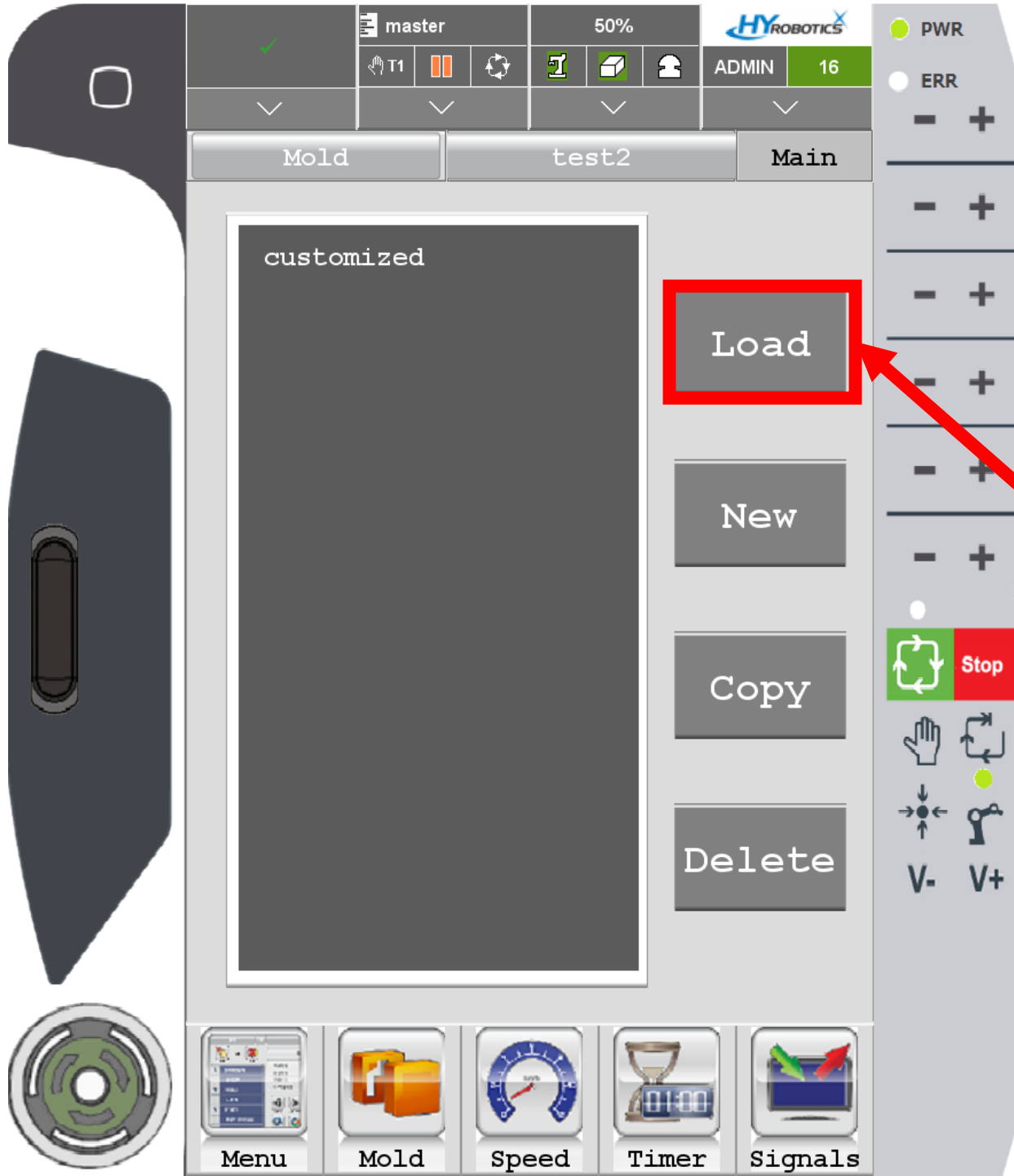
MODE SETTING



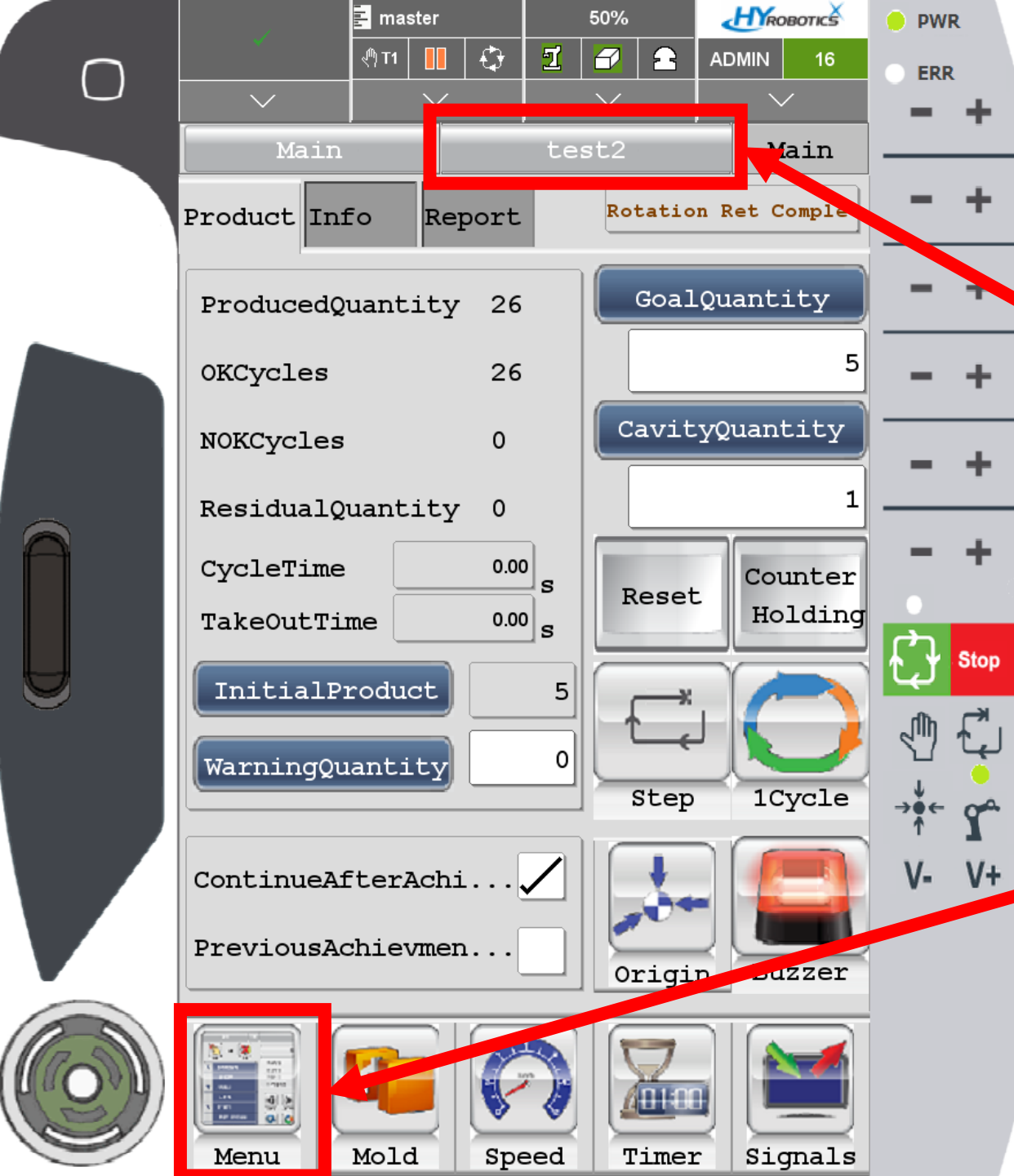


**After
referencing,

Log in as
Level 16
Administrator**

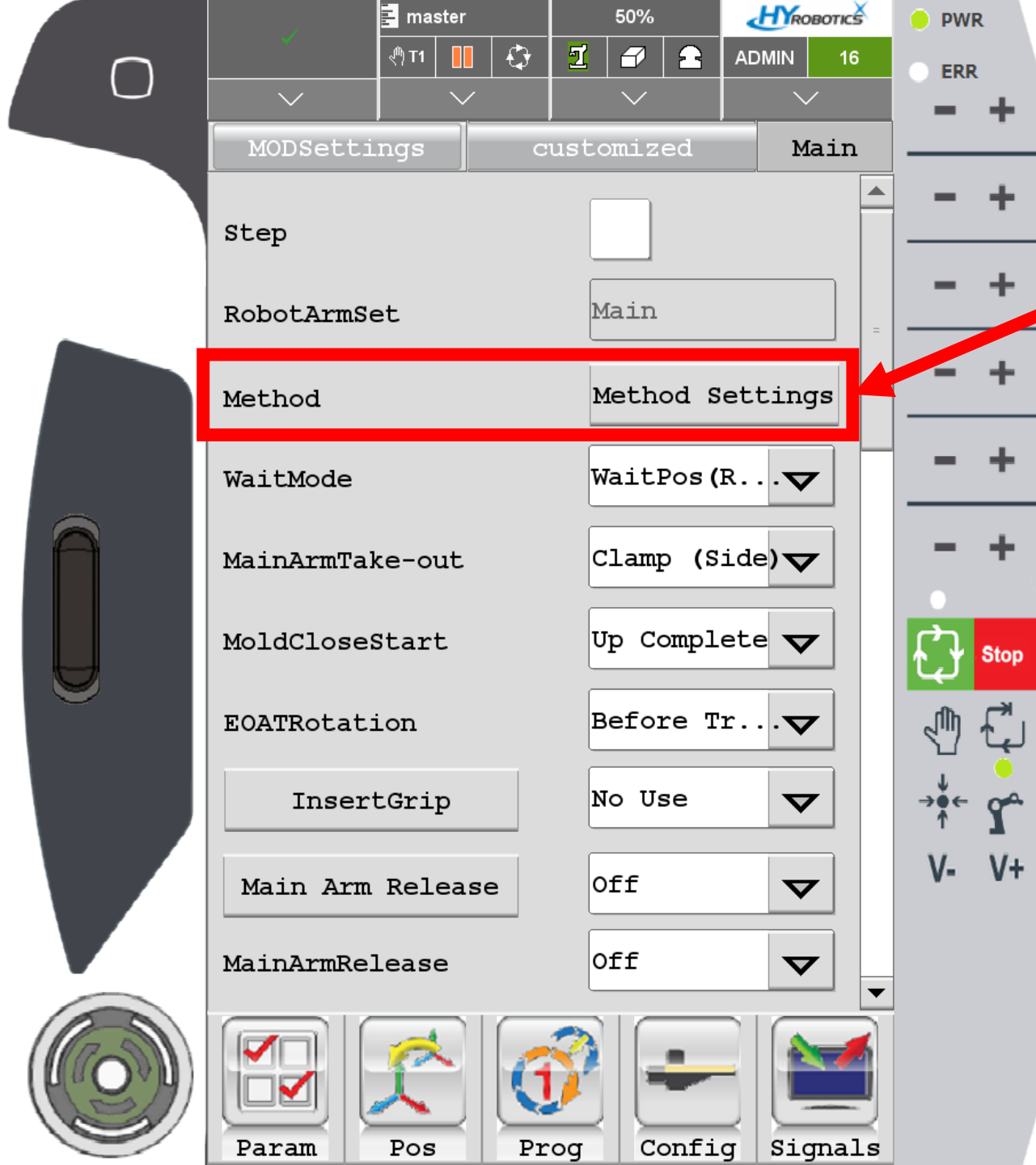


**Load the mold file
you created.**

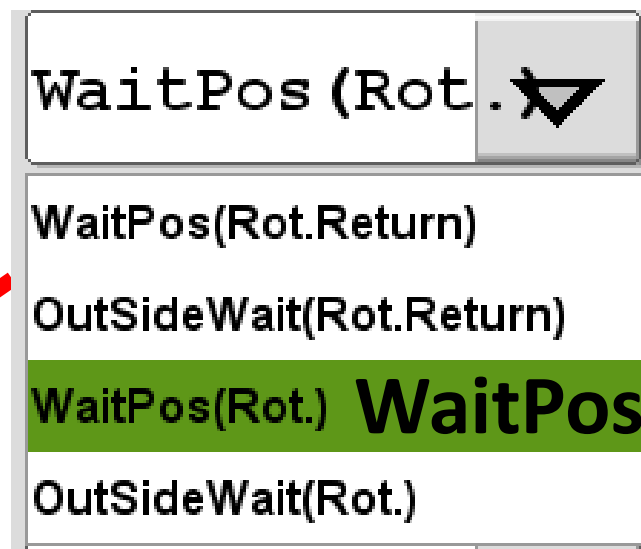
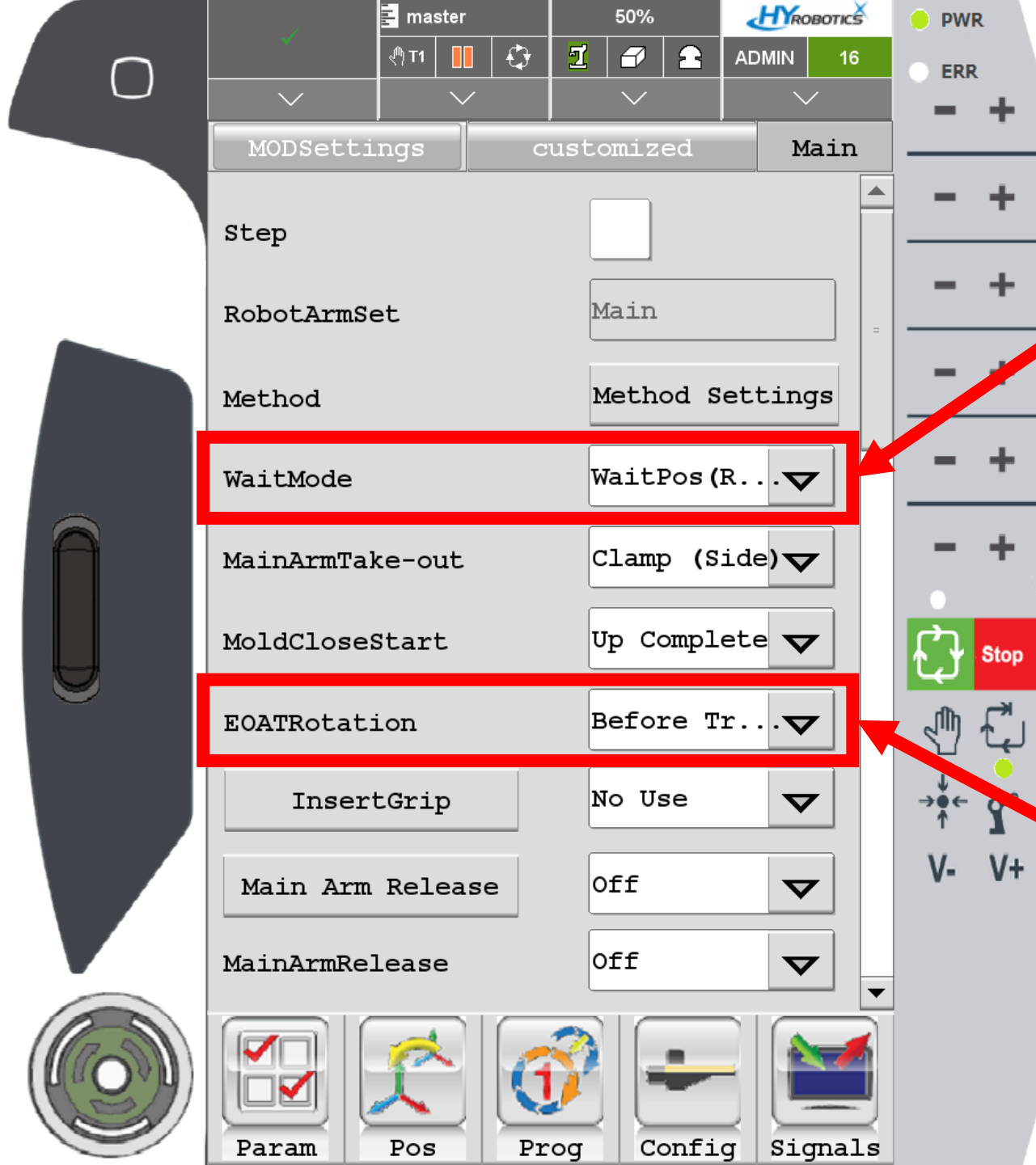


Check here if the right mold file is loaded.

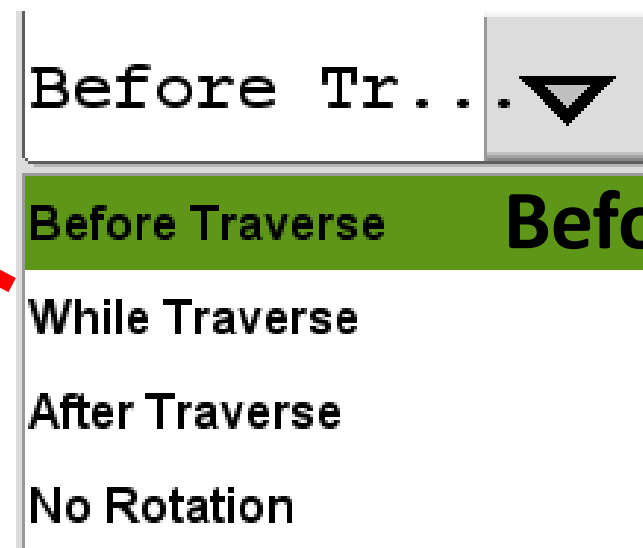
Go to mode setting.



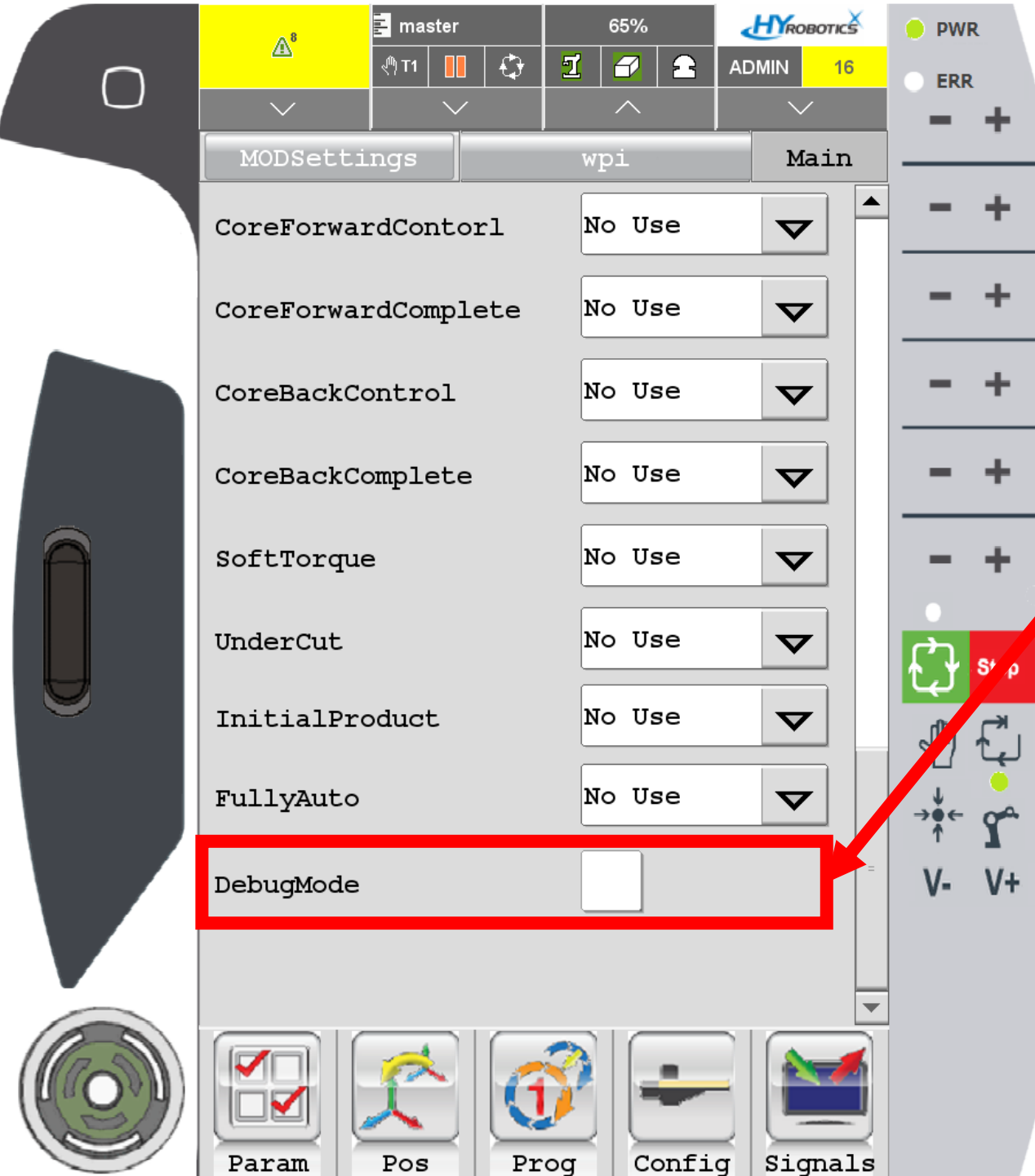
Select the method



WaitPos (Rotation)



Before Traverse



Debug Mode OFF

J-Motion No Use

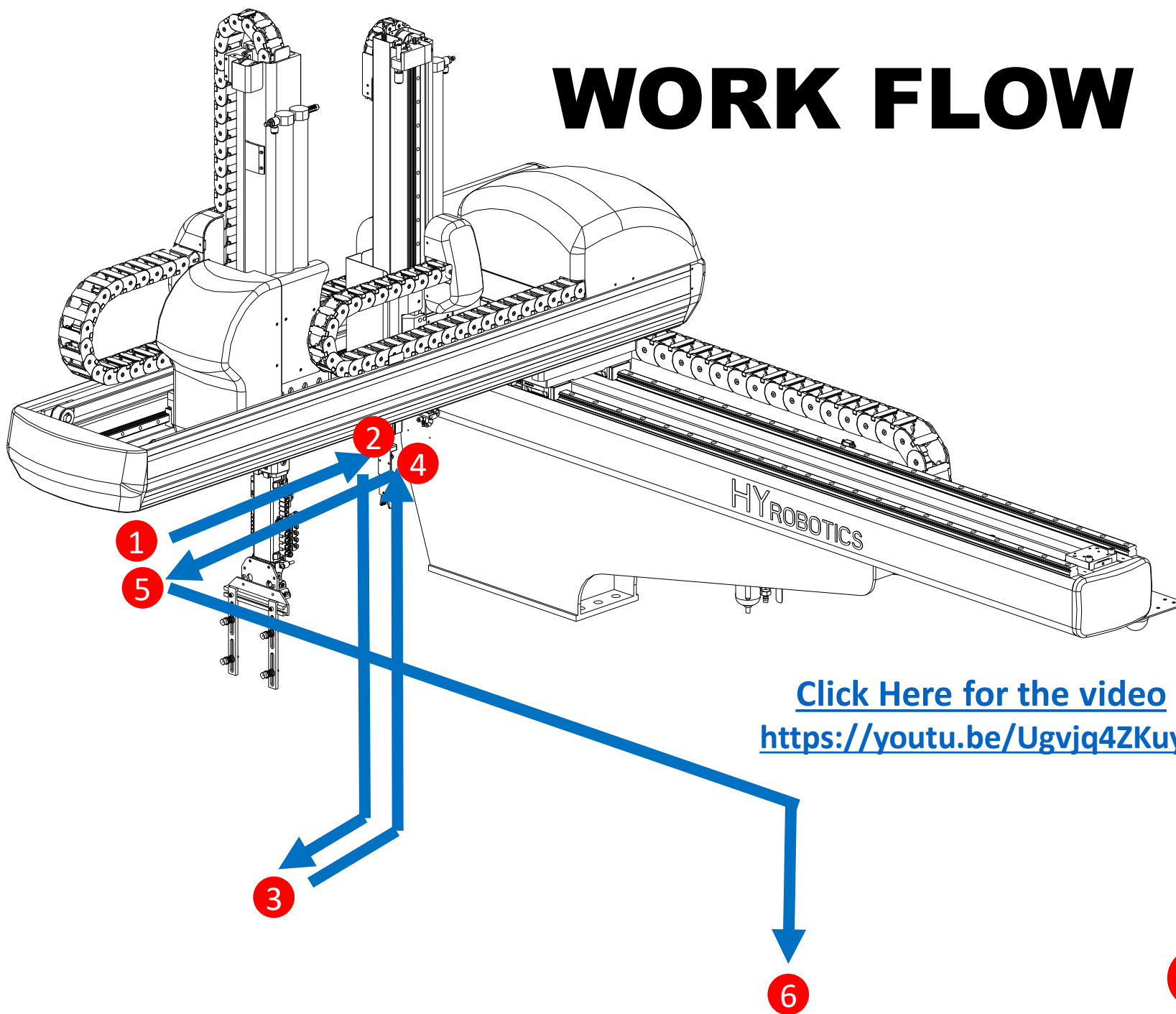


STEP 4

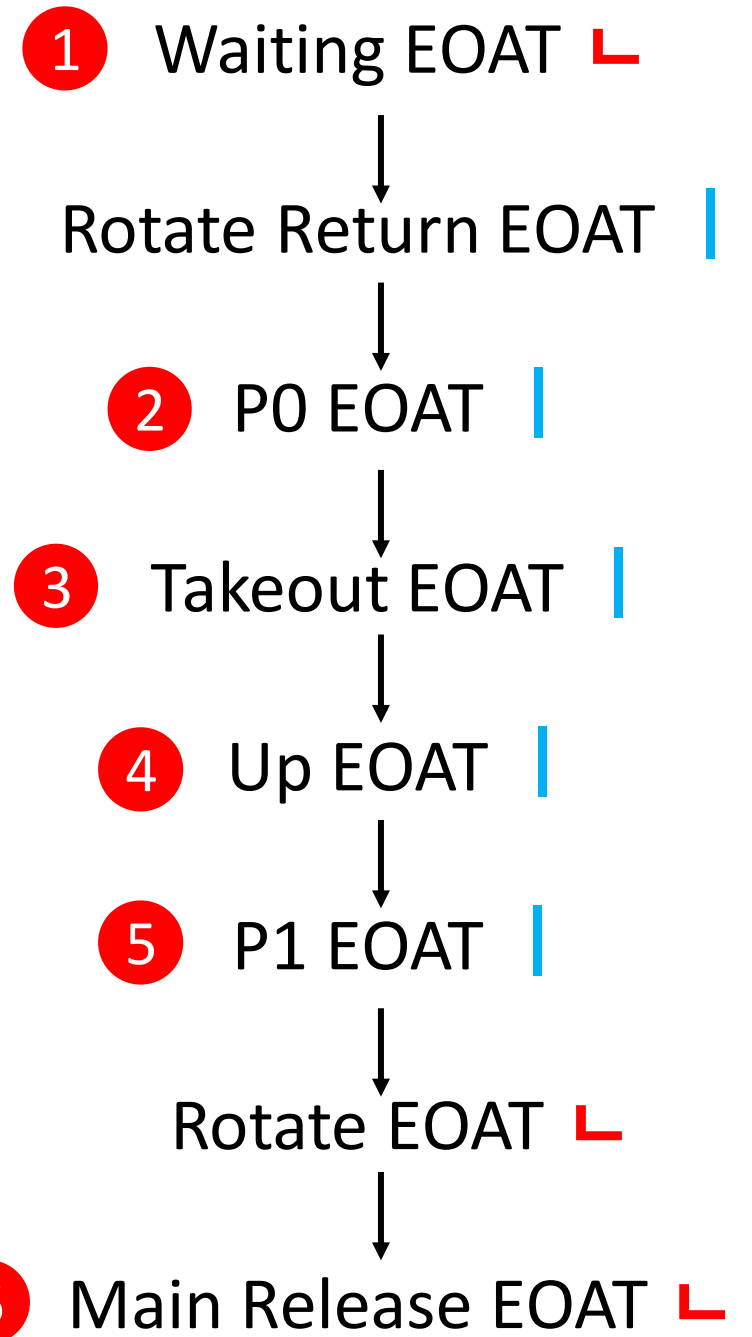
TEACHING POSITIONS

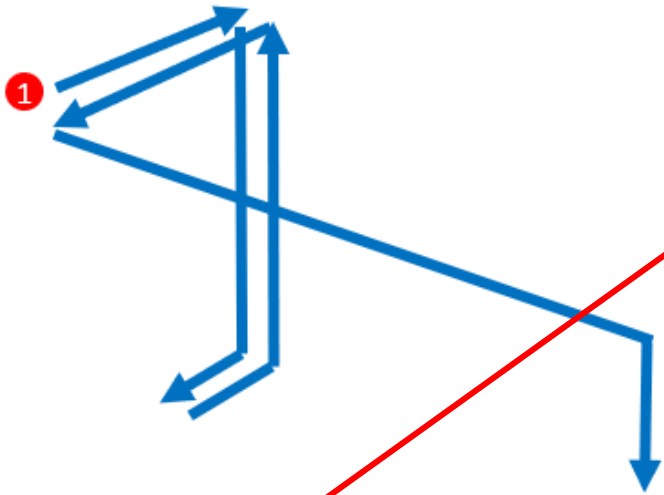


WORK FLOW



[Click Here for the video
https://youtu.be/Ugvjq4ZKuyg](https://youtu.be/Ugvjq4ZKuyg)





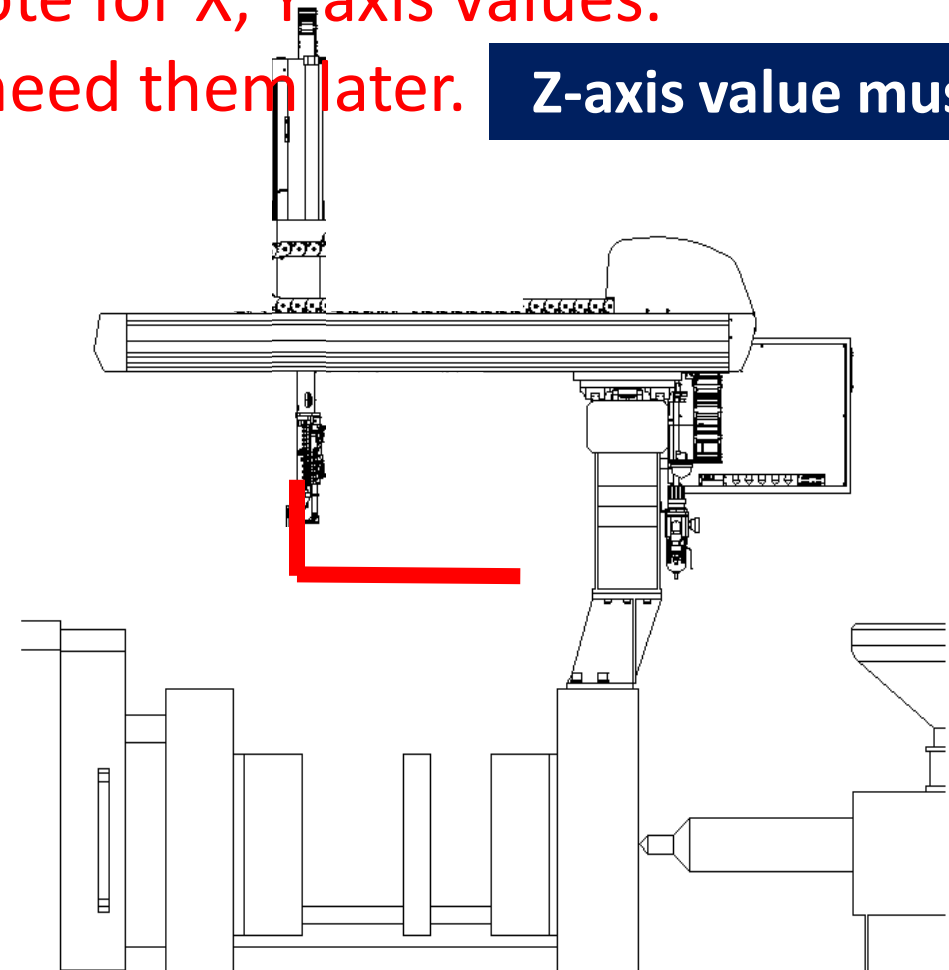
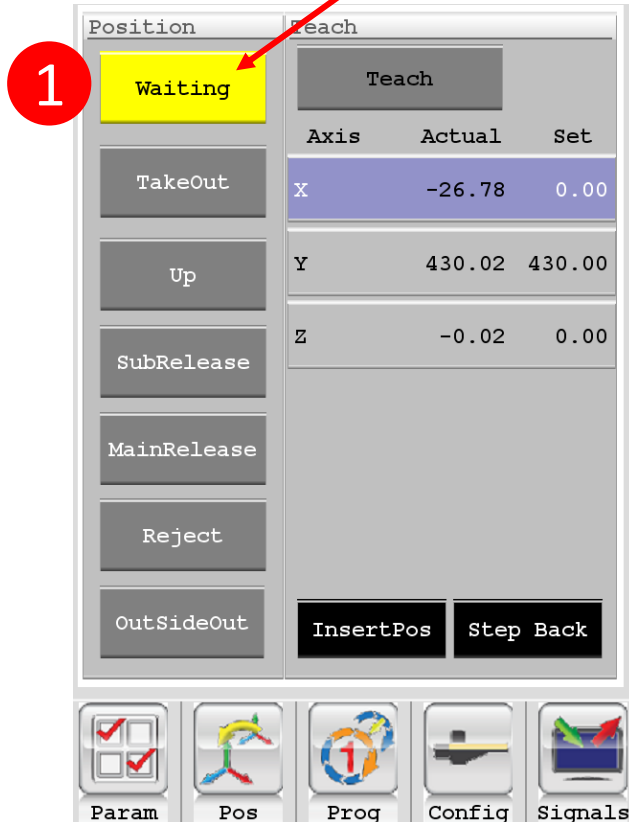
Select Waiting

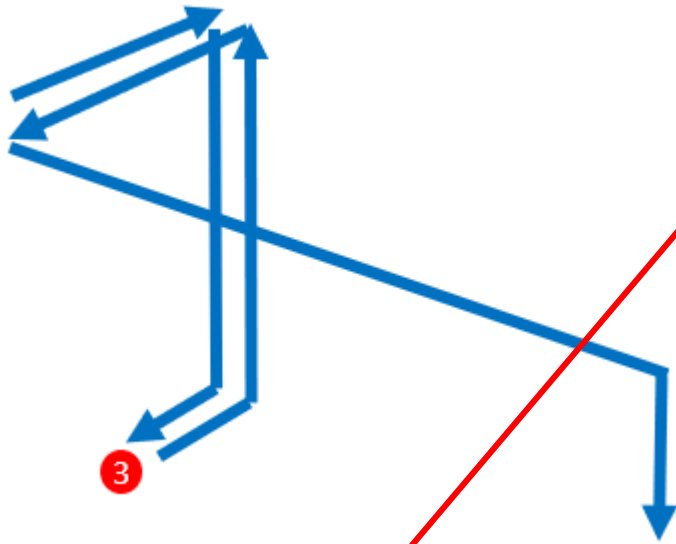
Rotate EOAT and move the robot manually to Waiting position. Press TEACH button.

Take a note for X, Y axis values.

We will need them later.

Z-axis value must be 0



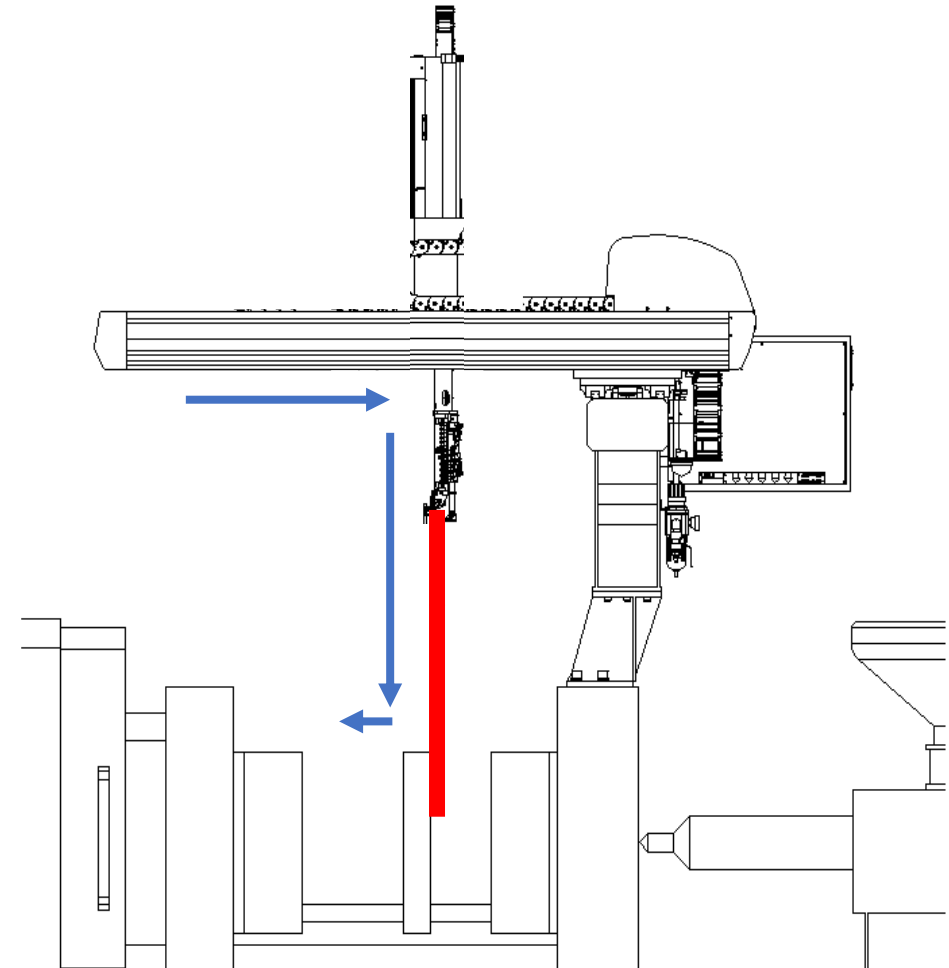
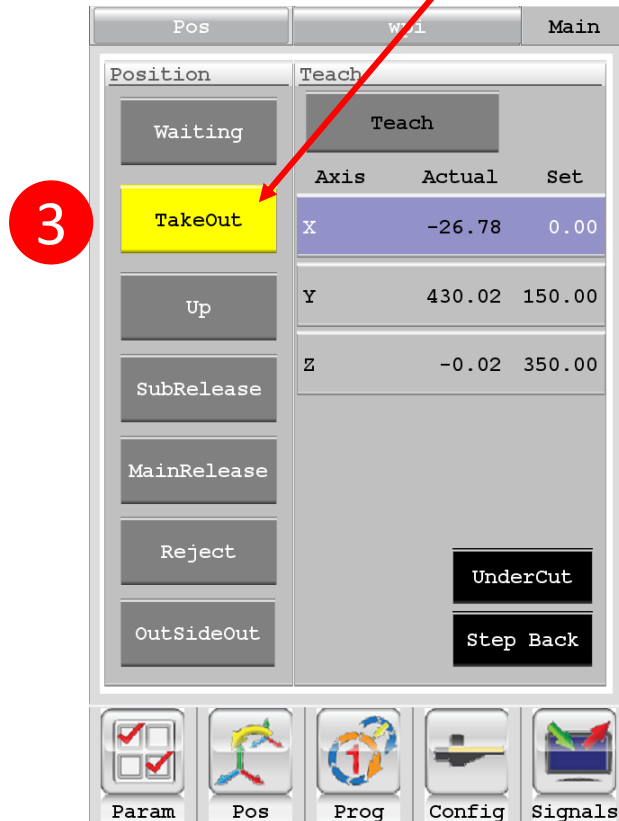


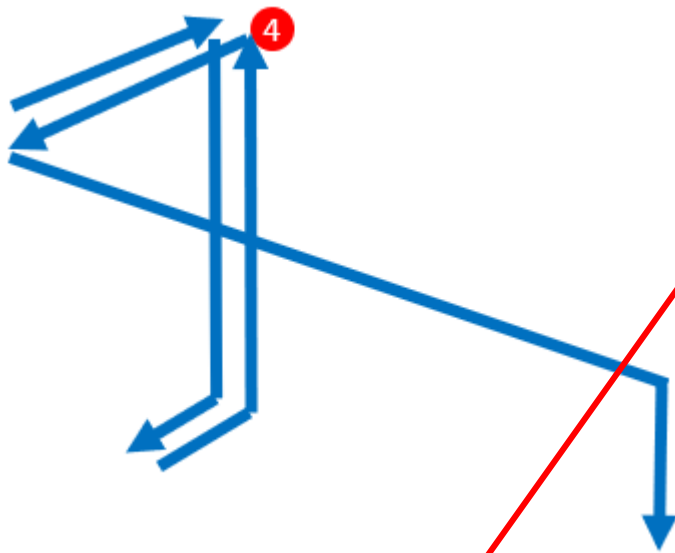
Select Takeout

Rotate return.

Move the robot manually to Takeout position.

Press TEACH button.





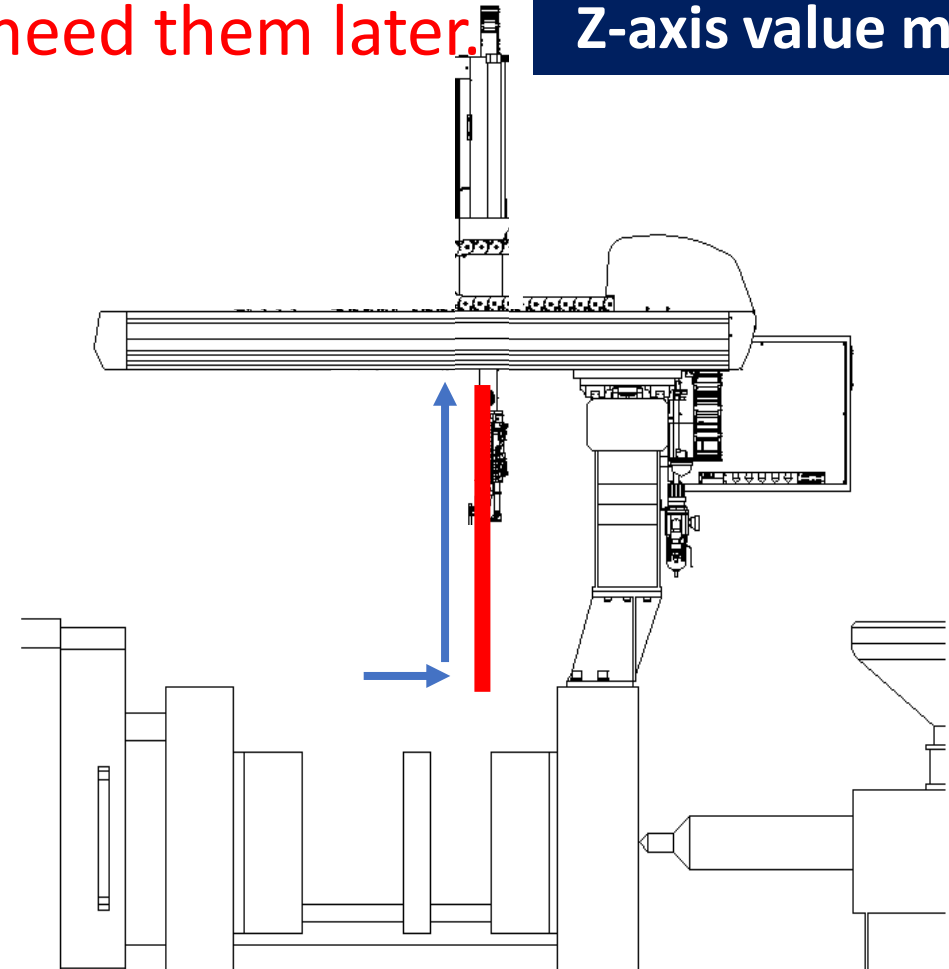
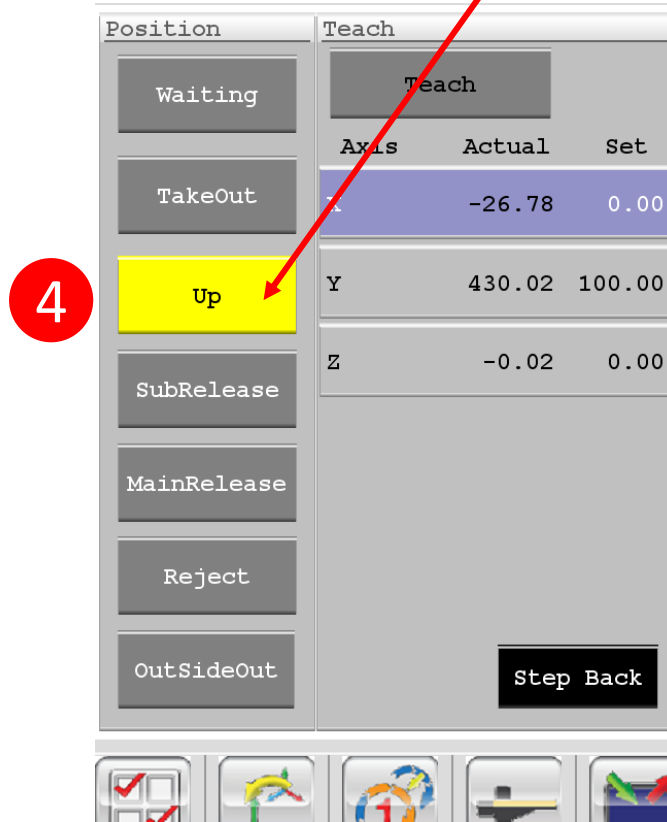
Select Up

Move the robot manually to up position.
Press TEACH button.

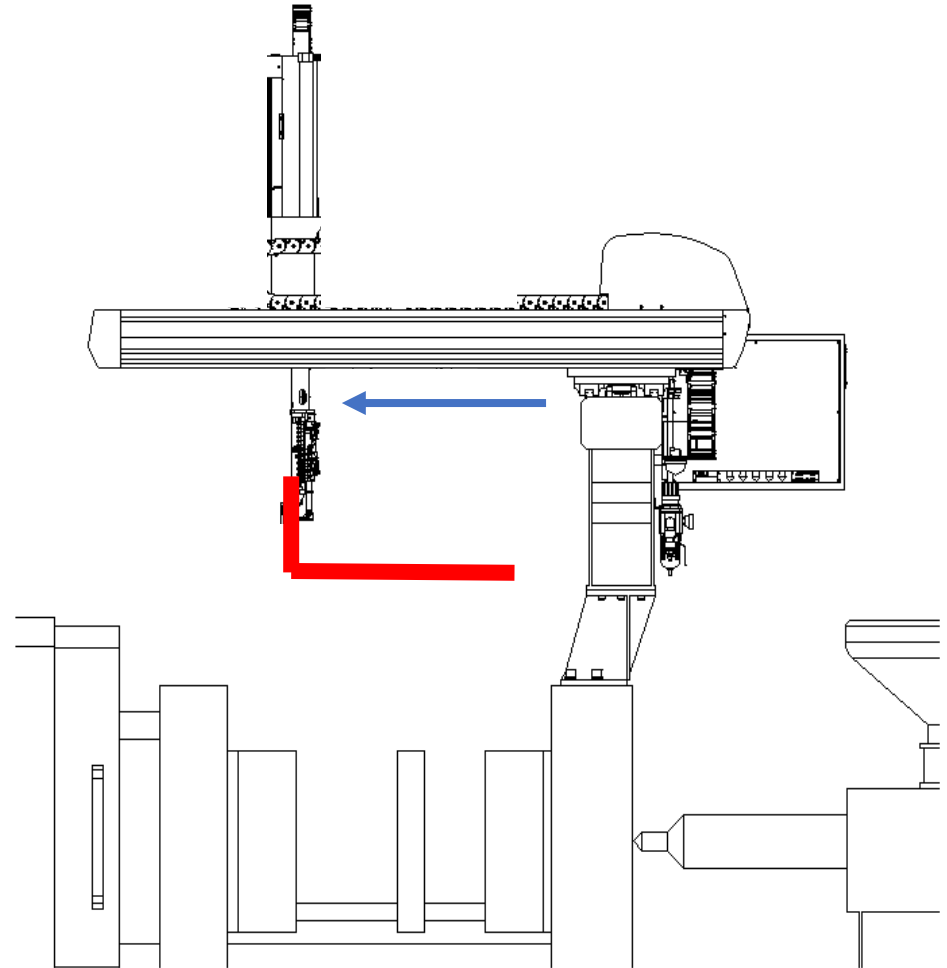
Take a note for X, Y axis values.

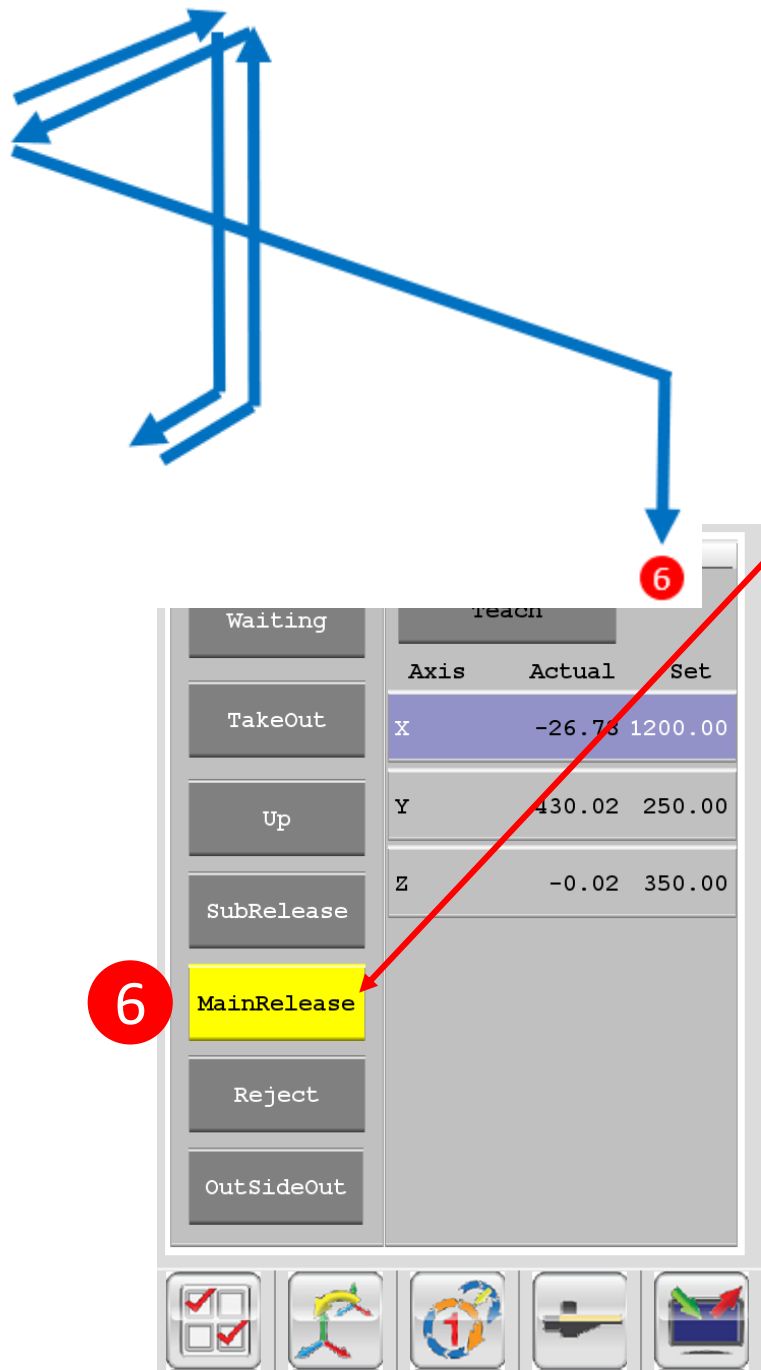
We will need them later.

Z-axis value must be 0



Move the robot forward,
And rotate EOAT





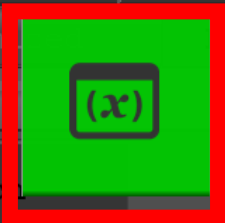
Select MainRelease

Traverse, down the robot to Release position.
Press TEACH button.

Be careful EOAT not to contact with the robot.



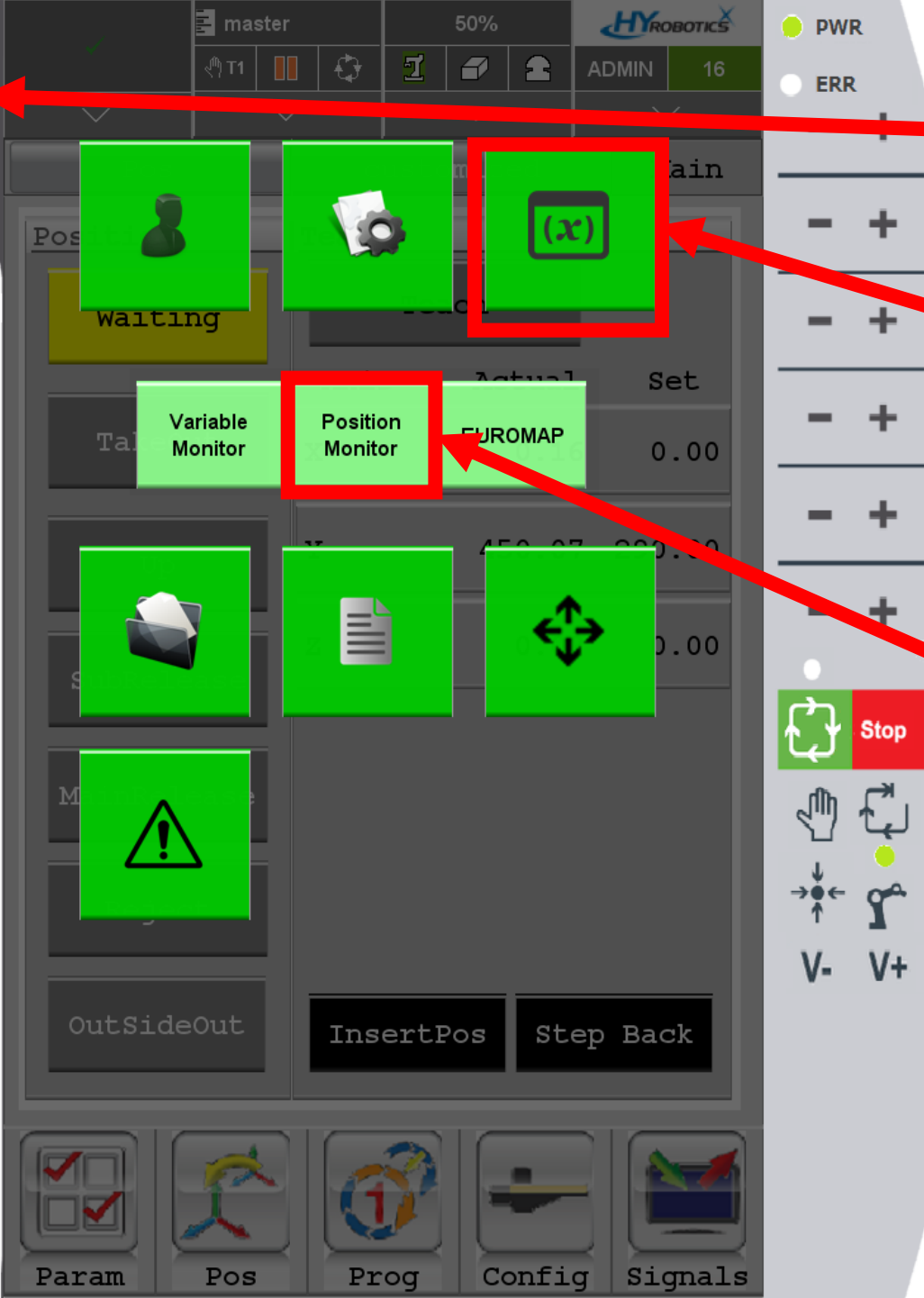
Double press



Press this button



**Open
Position Monitor**



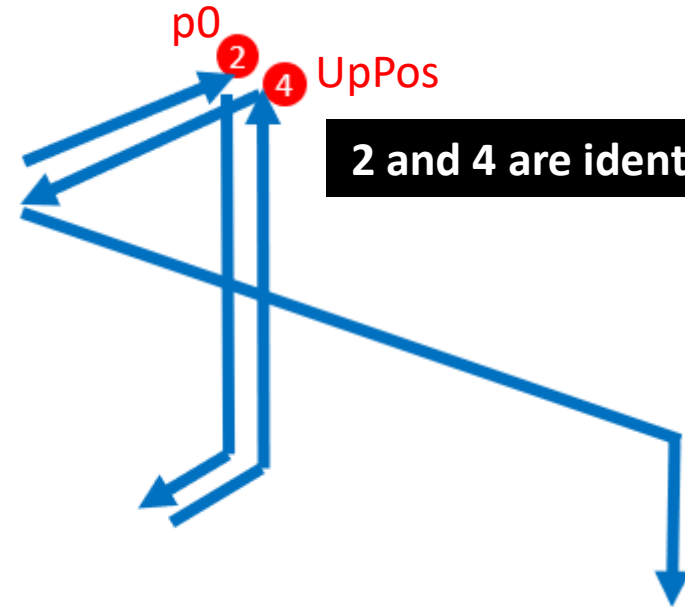
SETTING ²p0 POSITION

Enter same X, Y values
as ⁴UP position.

Press here to modify each axis value

Z-axis value must be 0

Variables	x	y
p0 ²	-26.80	112
p1	-26.80	430
OutSideWaitPos	830.61	499
home position	0.00	430
TakeOutPos	0.00	150
UpPos ⁴	0.00	100
SubArmReleasePos	800.00	300
MainArmReleasePos	1,200.00	250
RejectPos	1,550.00	150
InsertGripWaitingPos	1,400.00	500
InsertGripPos	1,400.00	500
EOATPos	2,000.00	900



2 and 4 are identical positions.

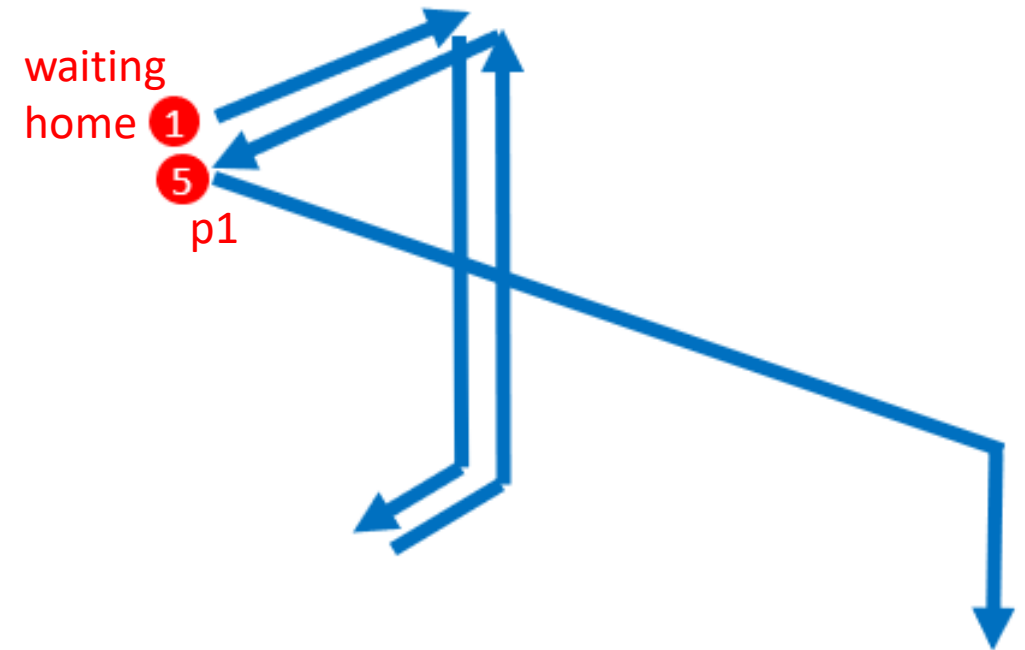
SETTING 5 p1 POSITION

Enter same X, Y values
as 1 Waiting position
(=home position).

Variables	x	y
p0	-30.00	100
p1 5	5.00	430
OutSideWaitPos	830.61	499
home position 1	-30.00	400
TakeOutPos	-30.00	183
UpPos	-30.00	100
SubArmReleasePos	1,250.00	600
MainArmReleasePos	995.72	387
RejectPos	1,550.00	150
InsertGripWaitingPos	1,400.00	500
InsertGripPos	1,400.00	500
EOATPos	2,000.00	900

Z-axis value must be 0

1 and 5 are identical positions.

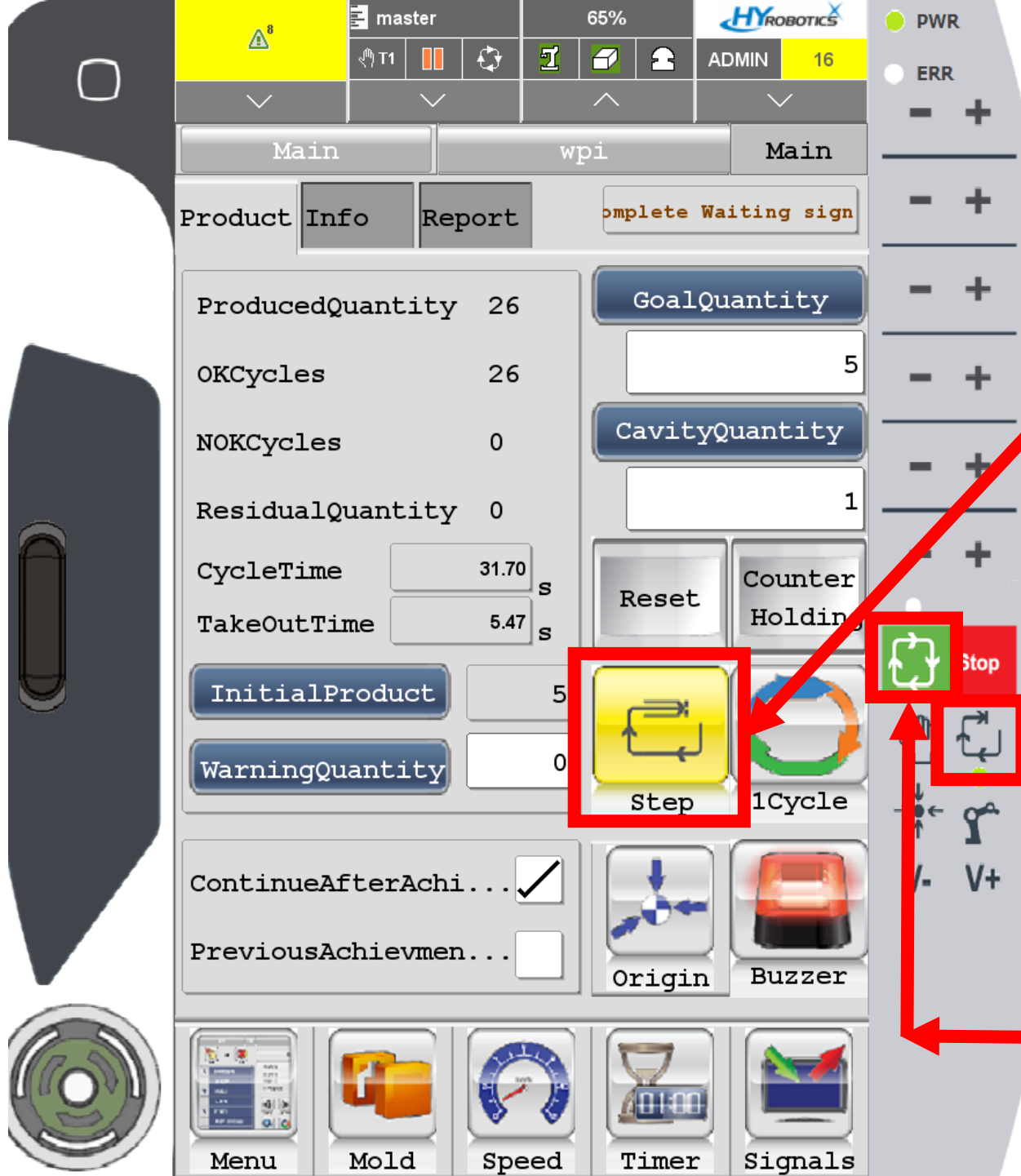




STEP 5

**RUN DRY CYCLE
(TEST DRIVE)**





Check the mold area is open

Turn on Step cycle

This function enables the robot runs automatic operation without mold signals with slower velocity

Step operation button to run the robot.

Press several times for the initial starting.

OR

Automatic operation button to run the robot.

Press twice for the initial starting.

