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;*****POSITION READING (8050 rotary axis)*****
;The following example will utilize the position variable to set an output. We want to set an
;output when the axis reads 45 degrees. We want to reset it when the axis reads other than 45 degrees
;References in the book which will help you are Chapter 10, 10.3, 10.6
;*****
;
CY1 ; initial cycle
() = CNCRD(MPB19,R150,M150) ; () always means logic high
; on power up, read machine parameter 19 for the B axis. The
; parameter is for the inposition zone.
;
= ADS 4500000 R150 R151 ; add 45 degrees plus the inposition zone. this will allow the plc
; to know when to set the output. the units for the position variables
; are in .00001 degrees. We want to make sure the units are the same
= SBS 4500000 R150 R152 ; subtract the inposition zone from 45 degrees. We are subtracting
; the the value in R150 from 45 degrees and place the result in R152
;
END
;
PRG ; main program
;
() = CNCRD ( POSB, R153, M150)
; read the real B axis position. Store the value in R153
;
(CPS R153 LT R151 AND
CPS R153 GT R152) = SET O7 ;compare the real position in R153 and check to see if it is less than
; R151 and compare the real position and check to see if is greater
; than R152. R151 and R152 have the 45 degrees position which
; we are comparing the real position to
;
(CPS R153 GT R151 AND
CPS R153 LT R152) = RES O7 ;compare the real position in R153 and check to see if it is greater
; than R151 and compare the real position and check to see if is less
; than R152. If the real position is other than 45 degrees, reset the
; output
END ; end of the main program

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