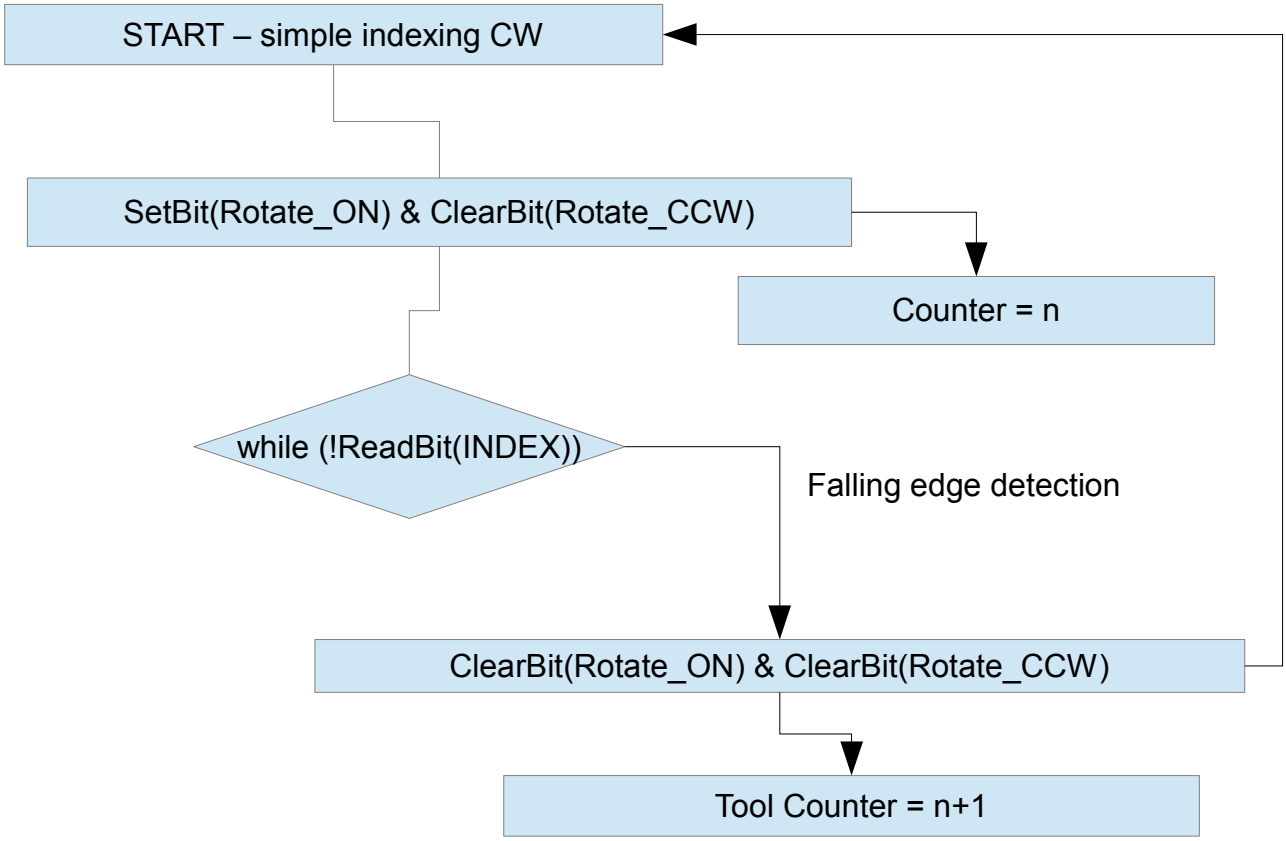
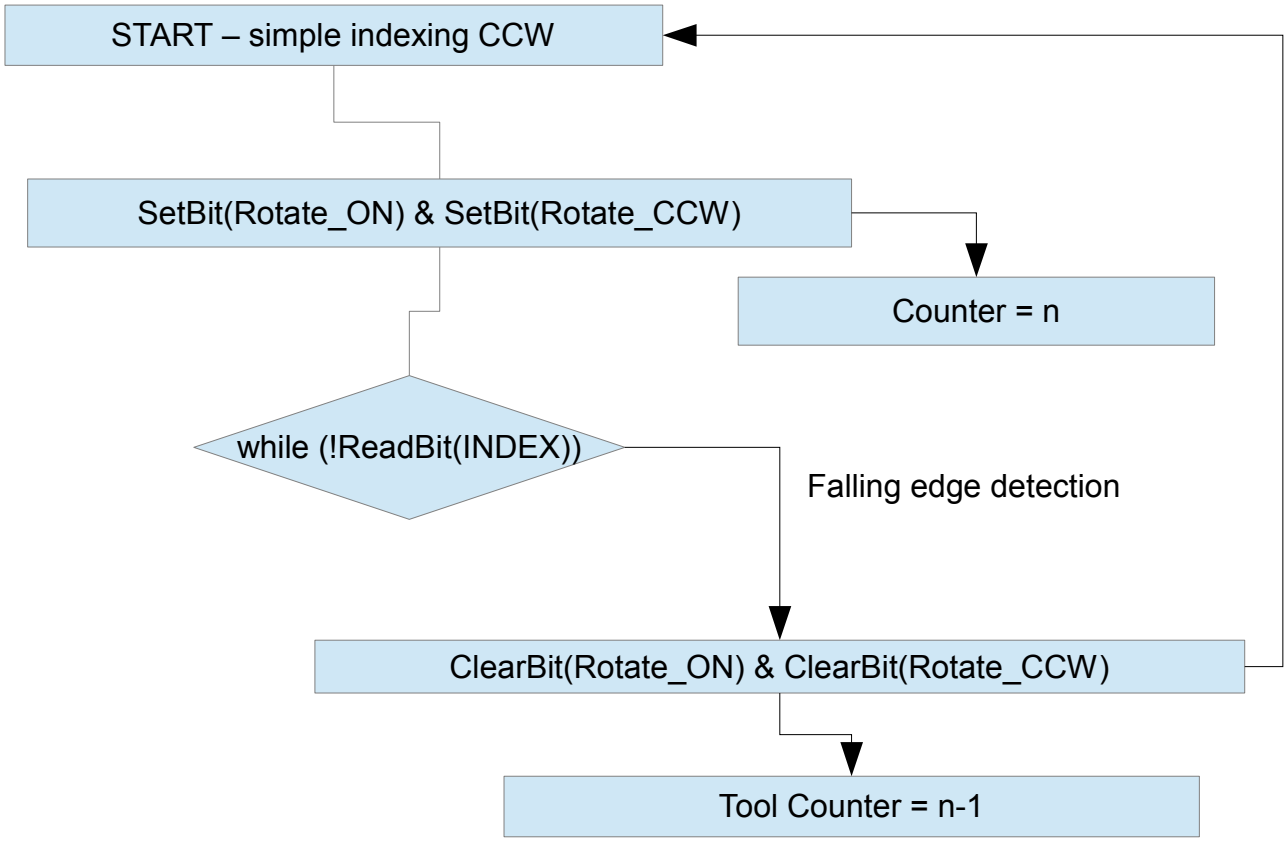
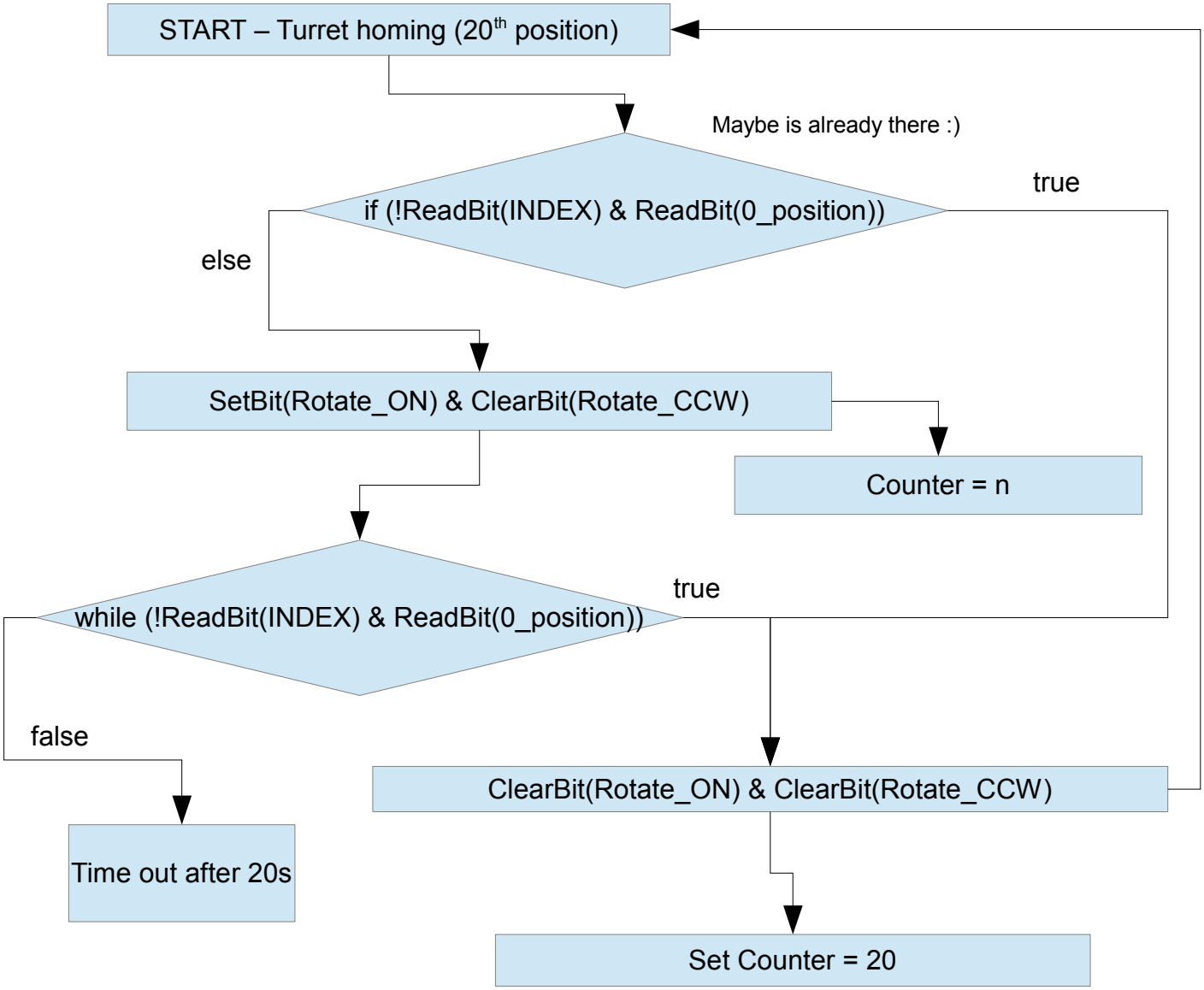
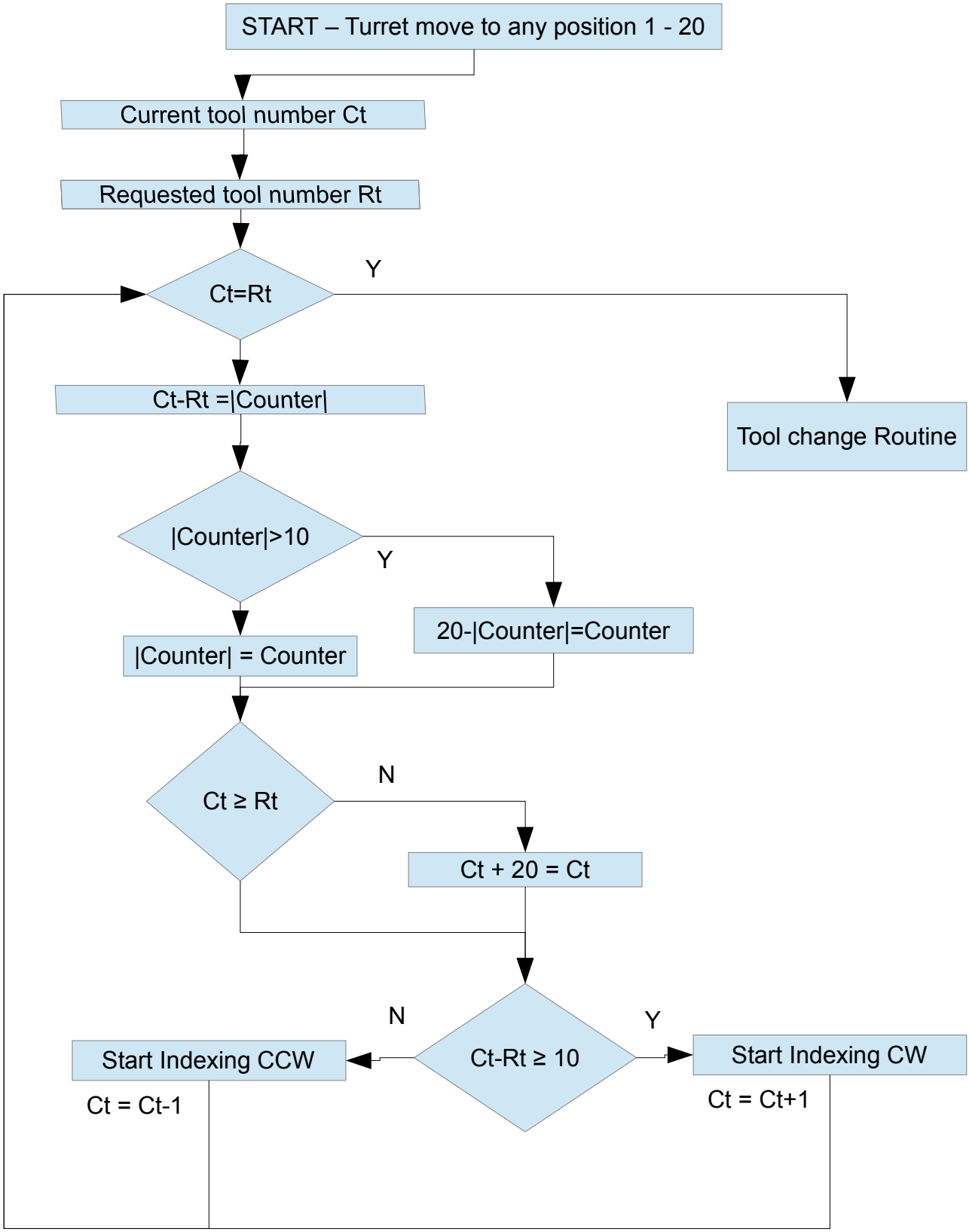

START – simple indexing CW
SetBit(Rotate_ON) & ClearBit(Rotate_CCW)
Counter = n
while (!ReadBit(INDEX))
Falling edge detection
ClearBit(Rotate_ON) & ClearBit(Rotate_CCW)
Tool Counter = n+1


START – simple indexing CCW
SetBit(Rotate_ON) & SetBit(Rotate_CCW)
Counter = n
while (!ReadBit(INDEX))
Falling edge detection
ClearBit(Rotate_ON) & ClearBit(Rotate_CCW)
Tool Counter = n-1


START – Turret homing (20th position)
Maybe is already there :)
if (!ReadBit(INDEX) & ReadBit(0_position))
true
else
SetBit(Rotate_ON) & ClearBit(Rotate_CCW)
Counter = n
while (!ReadBit(INDEX) & ReadBit(0_position))
true
false
ClearBit(Rotate_ON) & ClearBit(Rotate_CCW)
Time out after 20s
Set Counter = 20


START – Turret move to any position 1 - 20
Current tool number Ct
Requested tool number Rt
Ct=Rt
Y
Tool change Routine
Ct-Rt =|Counter|
|Counter|>10
Y
20-|Counter|=Counter
|Counter| = Counter
Ct ≥ Rt
N
Ct + 20 = Ct
N
Ct-Rt ≥ 10
Y
Start Indexing CCW
Ct = Ct-1
Start Indexing CW
Ct = Ct+1