State Machine Module
User Module written in PYTHON
Monitors inputs, tracks state, outputs control based on current state.

Running Torch Height Controller -- calculate position when torch is active, monitoring up/down pins

CHL (stop height changes when velocity is low, like on corners)

Pierce Height Position

Clear Off The Float Switch - Position Calculation

Position Command Selection

Velocity selection, based on motion state

Limit3 block limits position, velocity and acceleration

Clear Off The Float Switch - Position Calculation

Pierce position is an offset from where we came off the float switch

move to max-z, until float switch is released

move to min-z until float switch triggers

Calculation at an offset from last recorded cut height

CHL => Corner Height Lock

0.01

Users Module written in PYTHON

Monitors inputs, tracks state, outputs control based on current state

Limit3 block limits position, velocity and acceleration

Calculate Travel Position

based on an offset from last recorded cut height

State Machine Module

Monitors inputs, tracks state, outputs control based on current state.