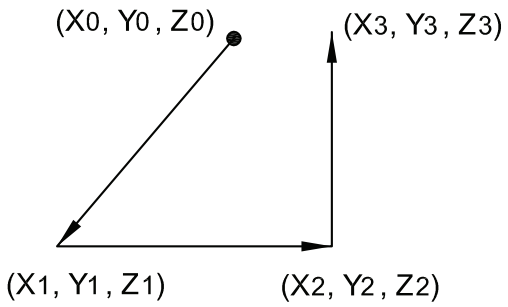


FIG. 5A

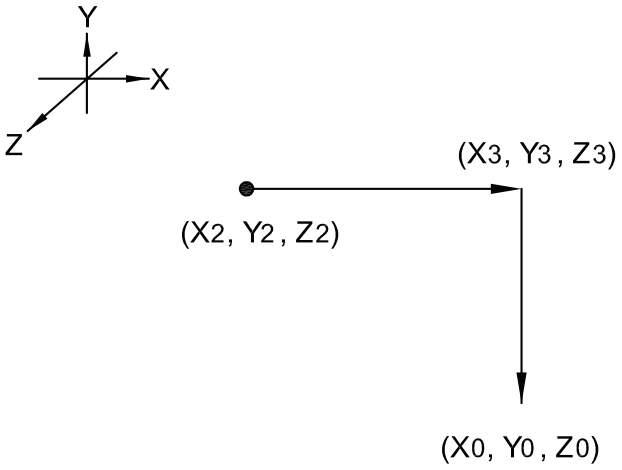


FIG. 5B

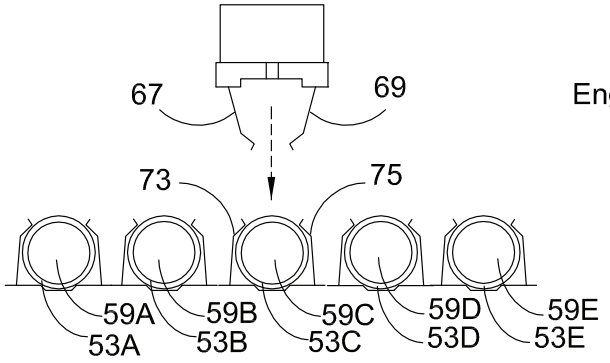


FIG. 6A

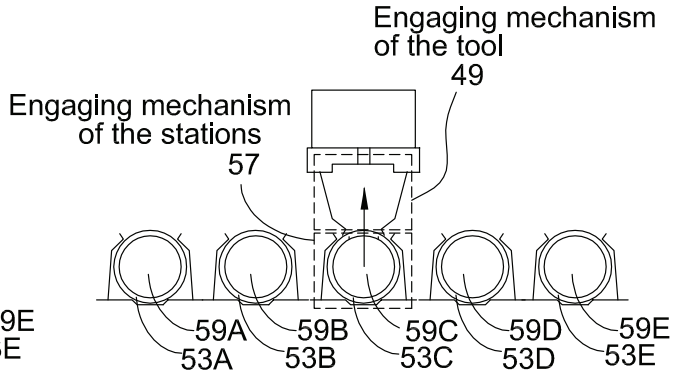


FIG. 6B

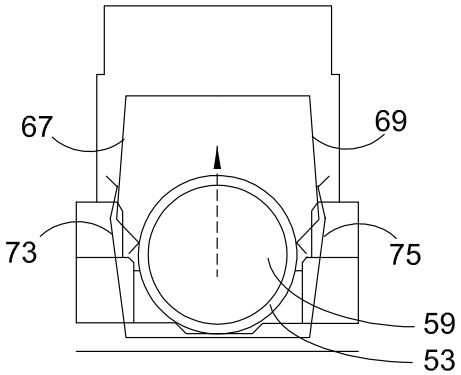


FIG. 6C

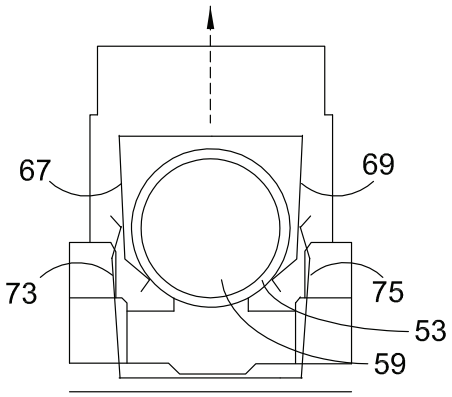


FIG. 6D

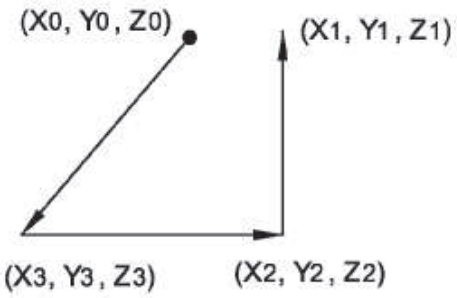


FIG. 5A

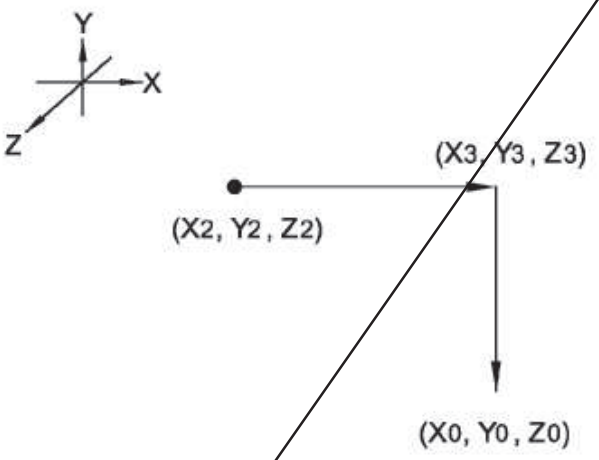


FIG. 5B

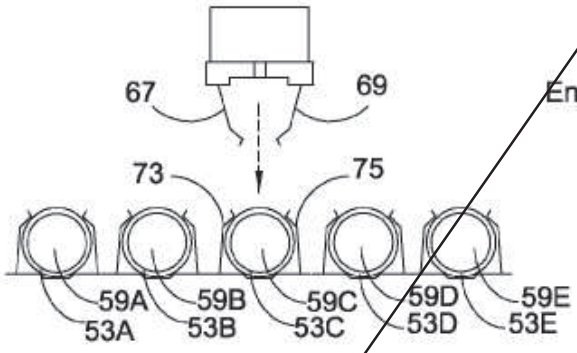


FIG. 6A

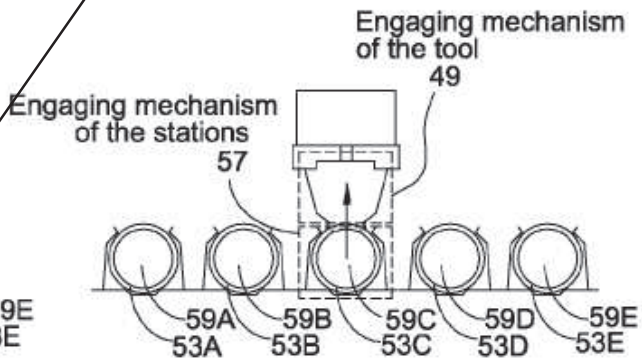


FIG. 6C

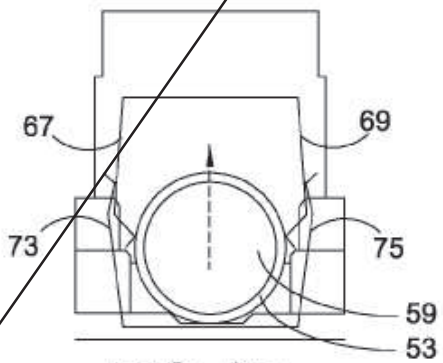


FIG. 6B

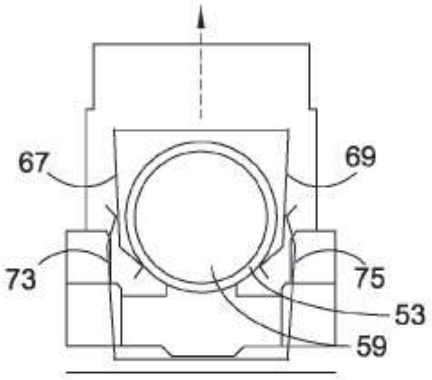


FIG. 6D

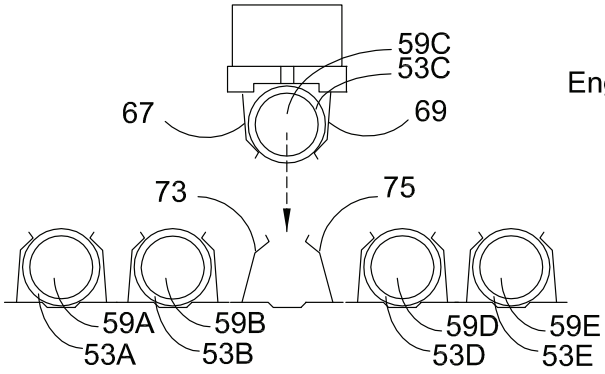


FIG. 7A

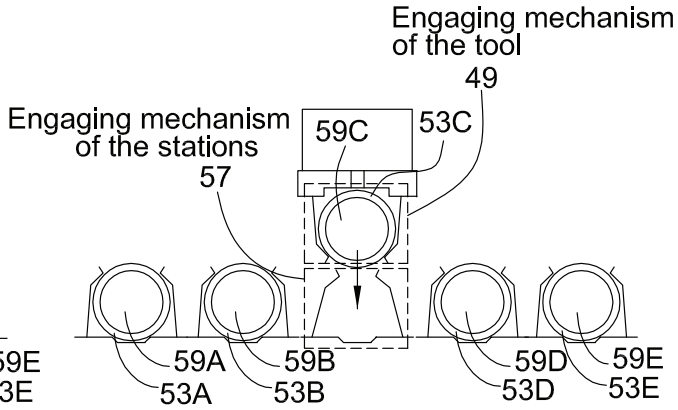


FIG. 7B

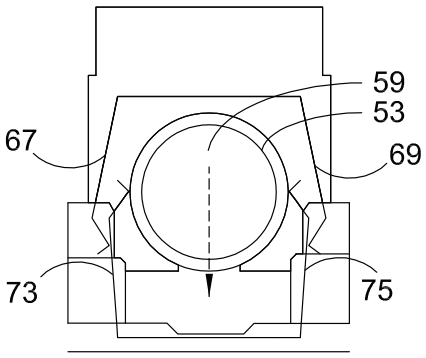


FIG. 7C

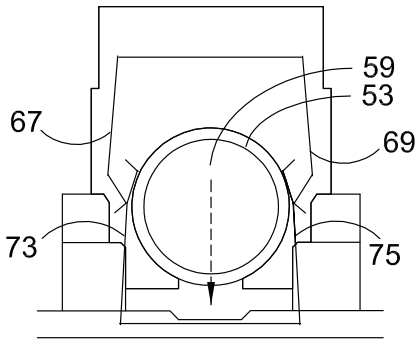


FIG. 7D

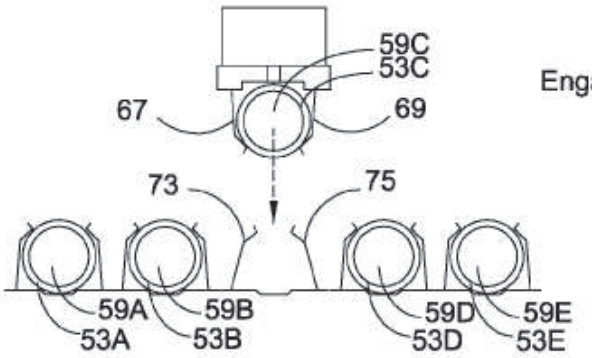


FIG. 7A

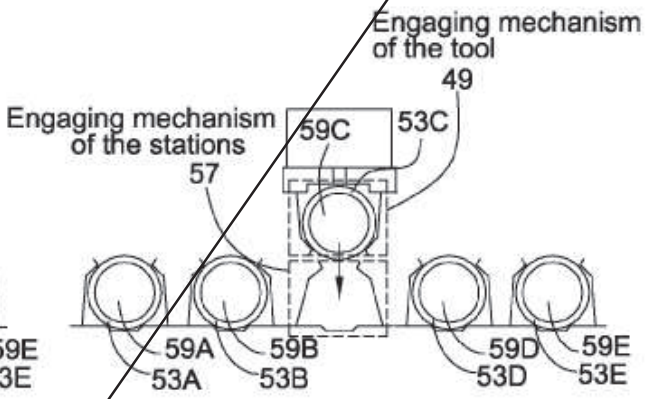


FIG. 7C

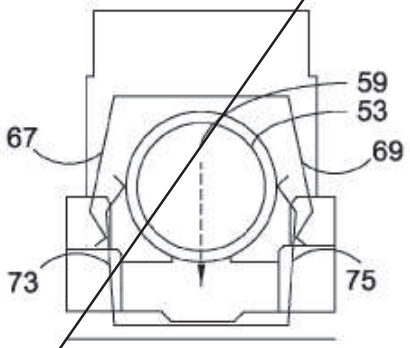


FIG. 7B

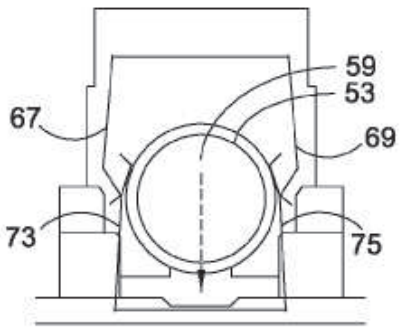


FIG. 7D

FIG. 8A

FIG. 8B

FIG. 8

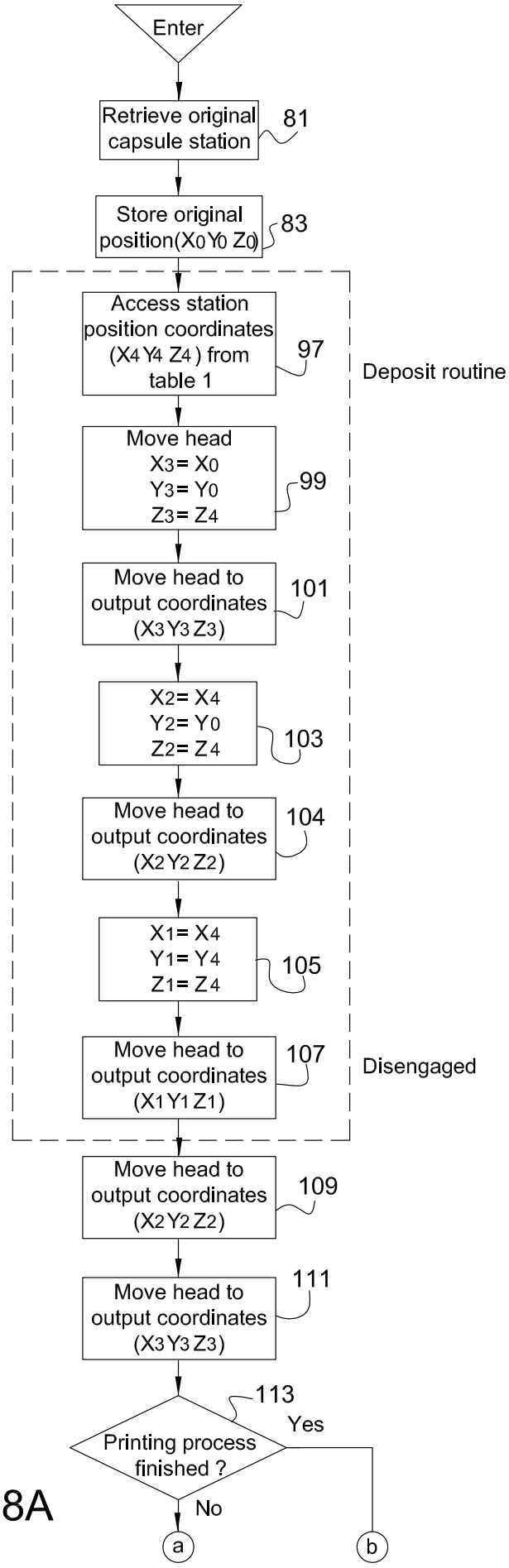


FIG. 8A

FIG. 8A

FIG. 8B

FIG. 8

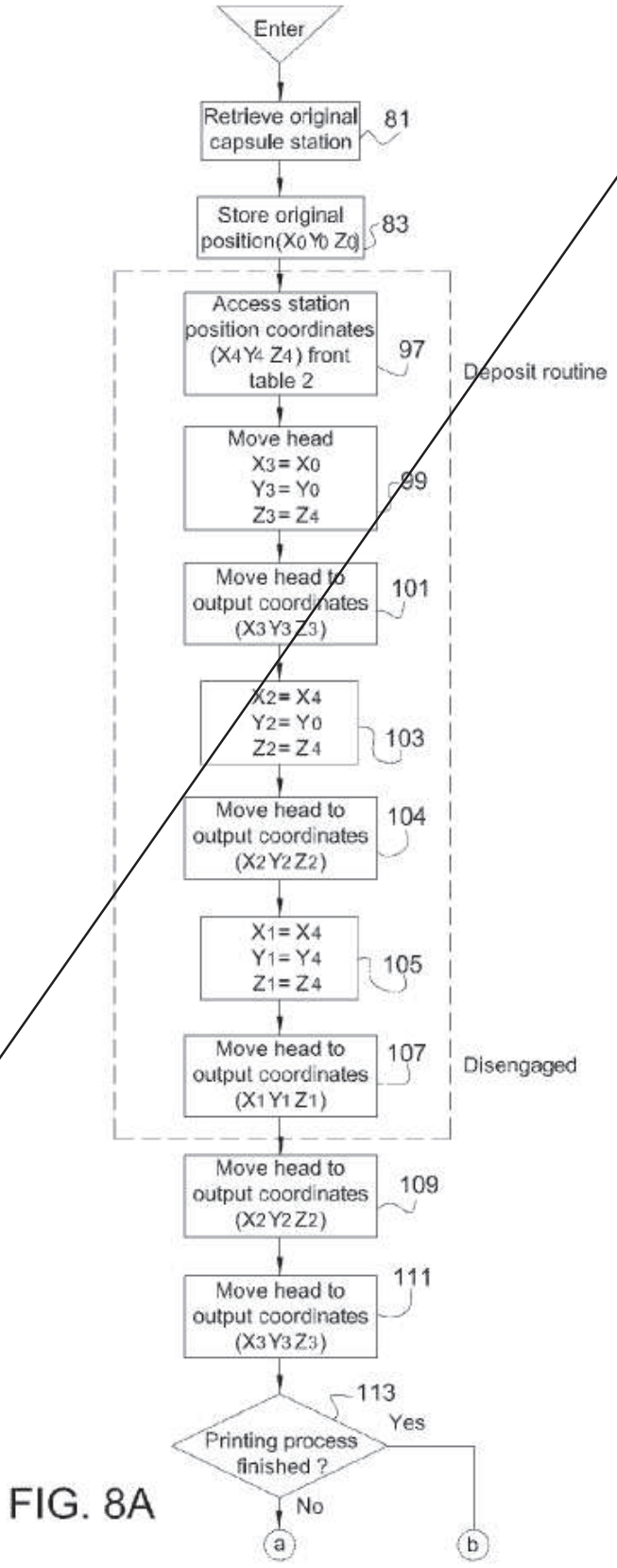


FIG. 8A

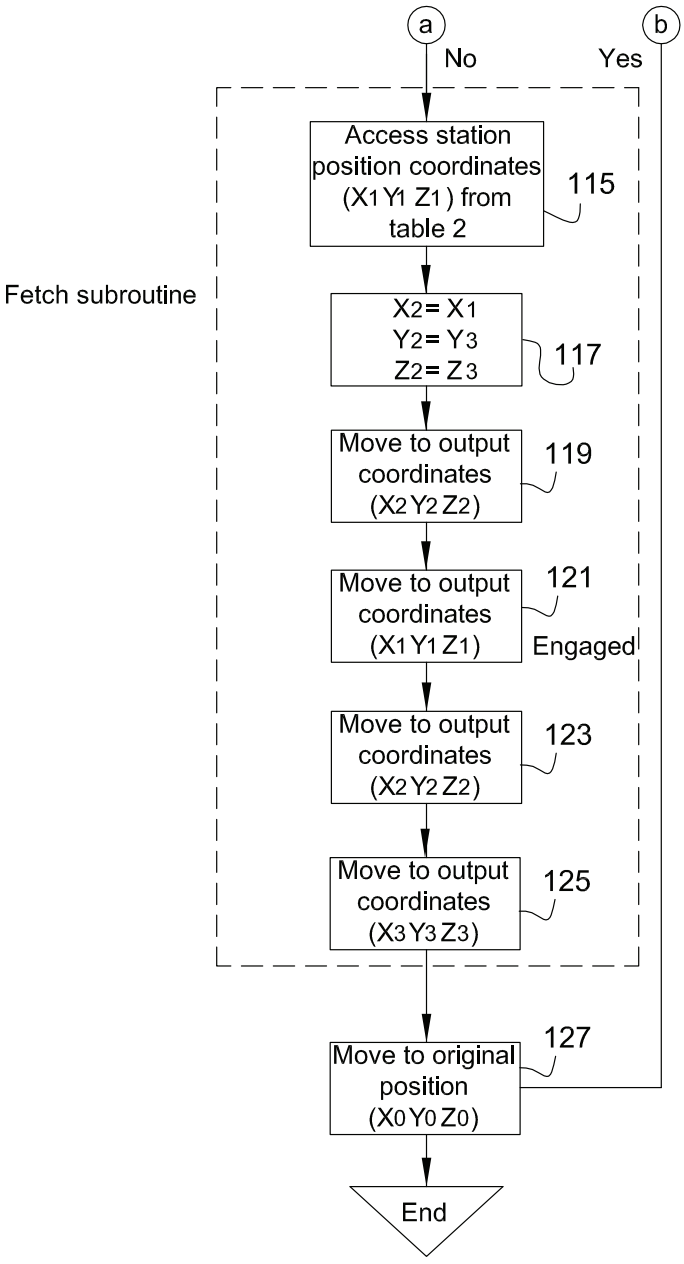

a
b
No
Yes
Fetch subroutine
Access station position coordinates (X1 Y1 Z1) from table 2
115
X2= X1
Y2= Y3
Z2= Z3
117
Move to output coordinates (X2 Y2 Z2)
119
Move to output coordinates (X1 Y1 Z1)
121
Engaged
Move to output coordinates (X2 Y2 Z2)
123
Move to output coordinates (X3 Y3 Z3)
125
Move to original position (X0 Y0 Z0)
127
End

FIG. 8B

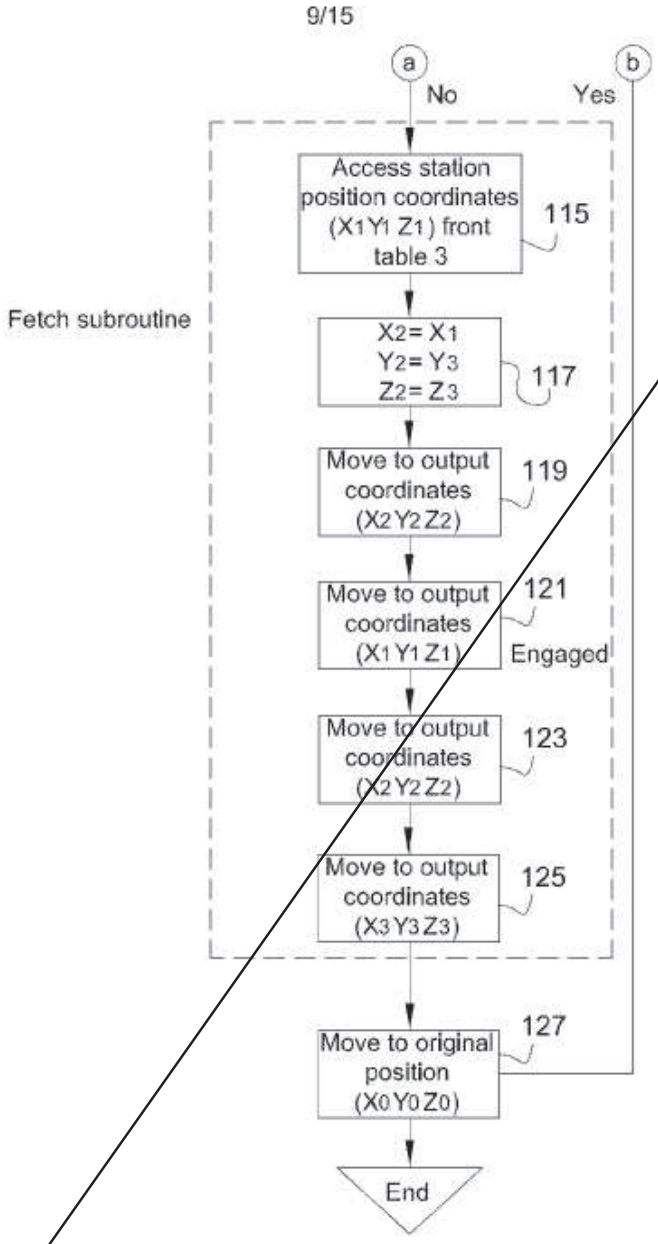

a
b
No
Yes
Fetch subroutine
Access station position coordinates (X1 Y1 Z1) front table 3
115
X2 = X1
Y2 = Y3
Z2 = Z3
117
Move to output coordinates (X2 Y2 Z2)
119
Move to output coordinates (X1 Y1 Z1)
121
Engaged
Move to output coordinates (X2 Y2 Z2)
123
Move to output coordinates (X3 Y3 Z3)
125
Move to original position (X0 Y0 Z0)
127
End

FIG. 8B