Flowchart for Moveable Clamp Motor

1. Power ON
2. Return “0”
3. “0”?
   - YES: Set direction bit to move away
   - NO: Material Cut?
4. Move proper # of pulses away
5. Wait
6. Material Cut?
   - YES: Open Clamp?
   - NO: Return to “0”

Note:
- “0”: Home Position
- “1”: Desired Position

Will always move away from home position