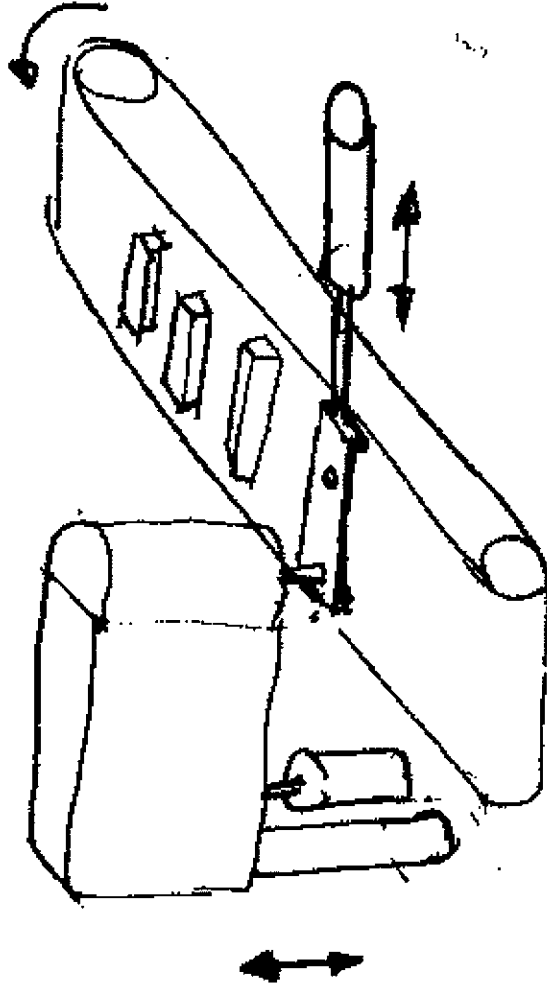
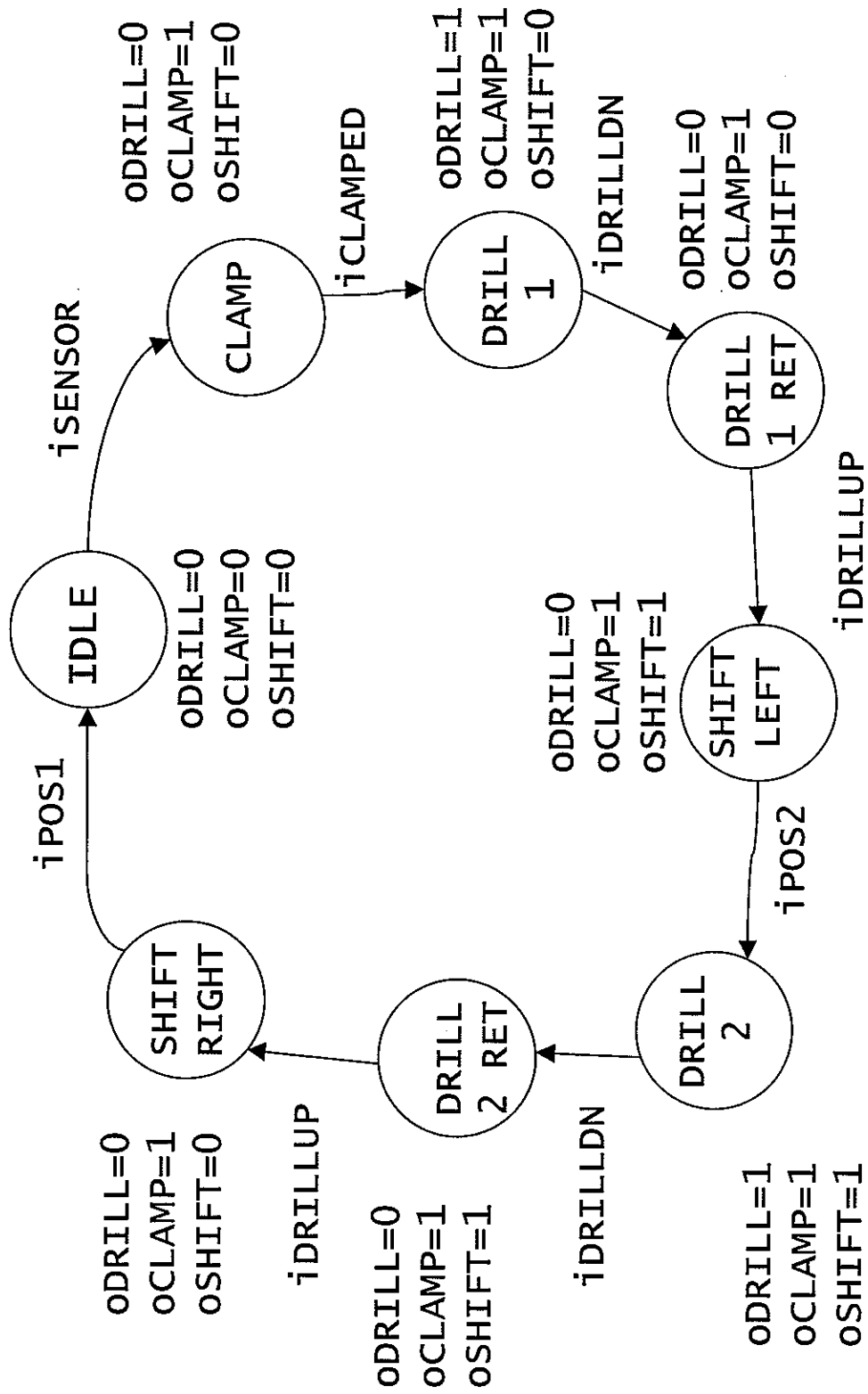


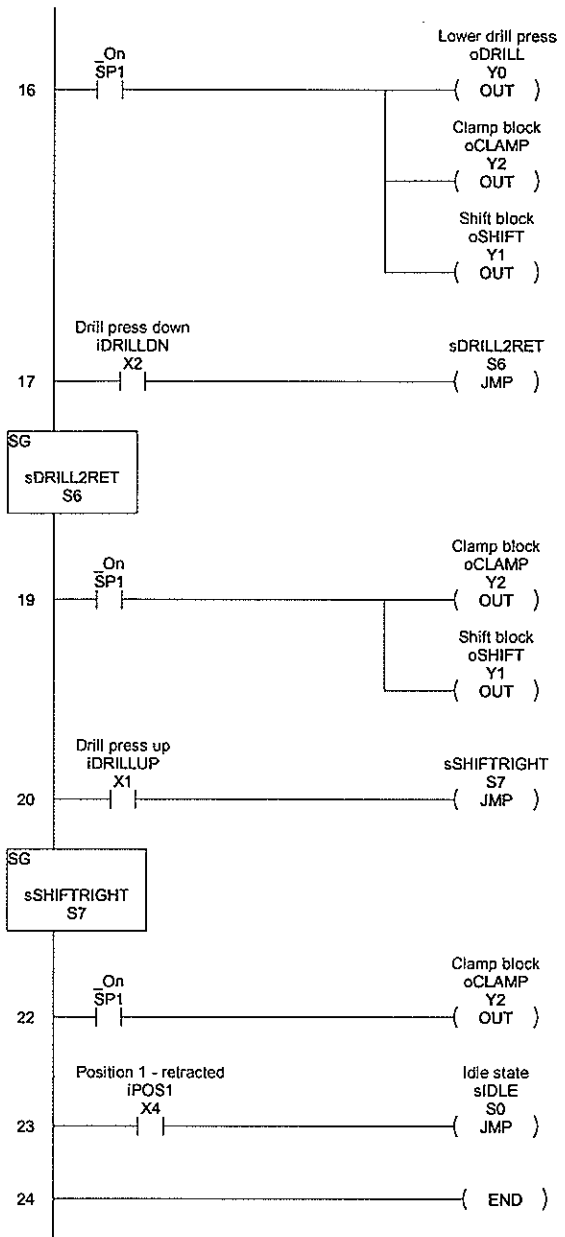
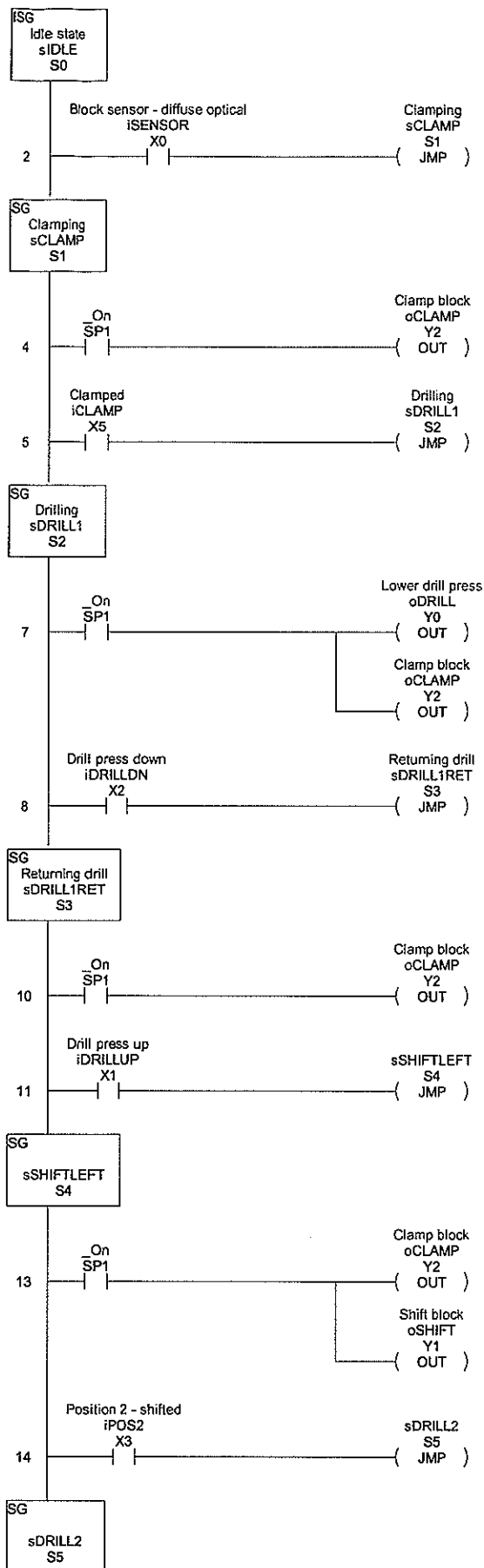
MULTI-STATE EXAMPLE



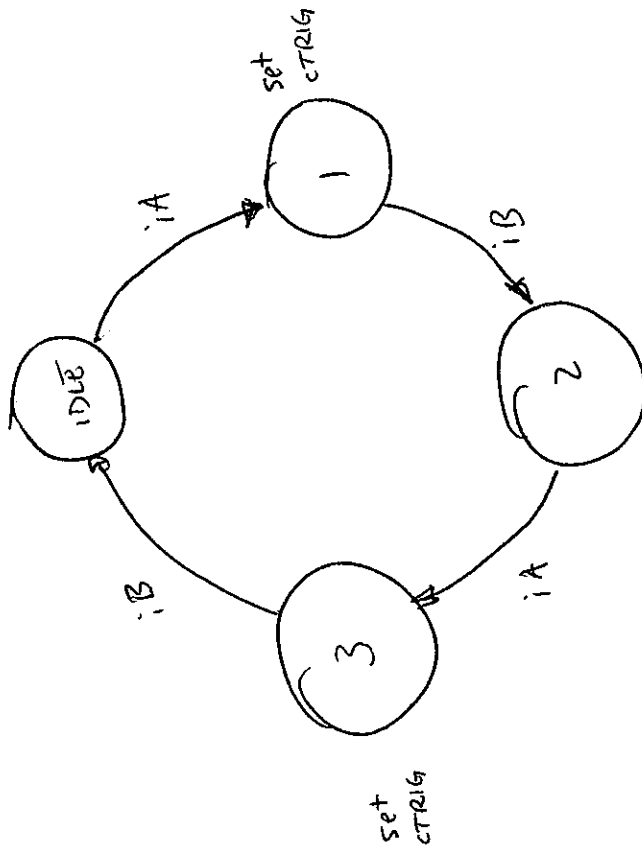
When sensor detects block; clamp block, drill hole, shift, drill 2nd hole, shift back, release clamp.

STATE DIAGRAM





STATE MACHINE #1



STATE MACHINE #2

