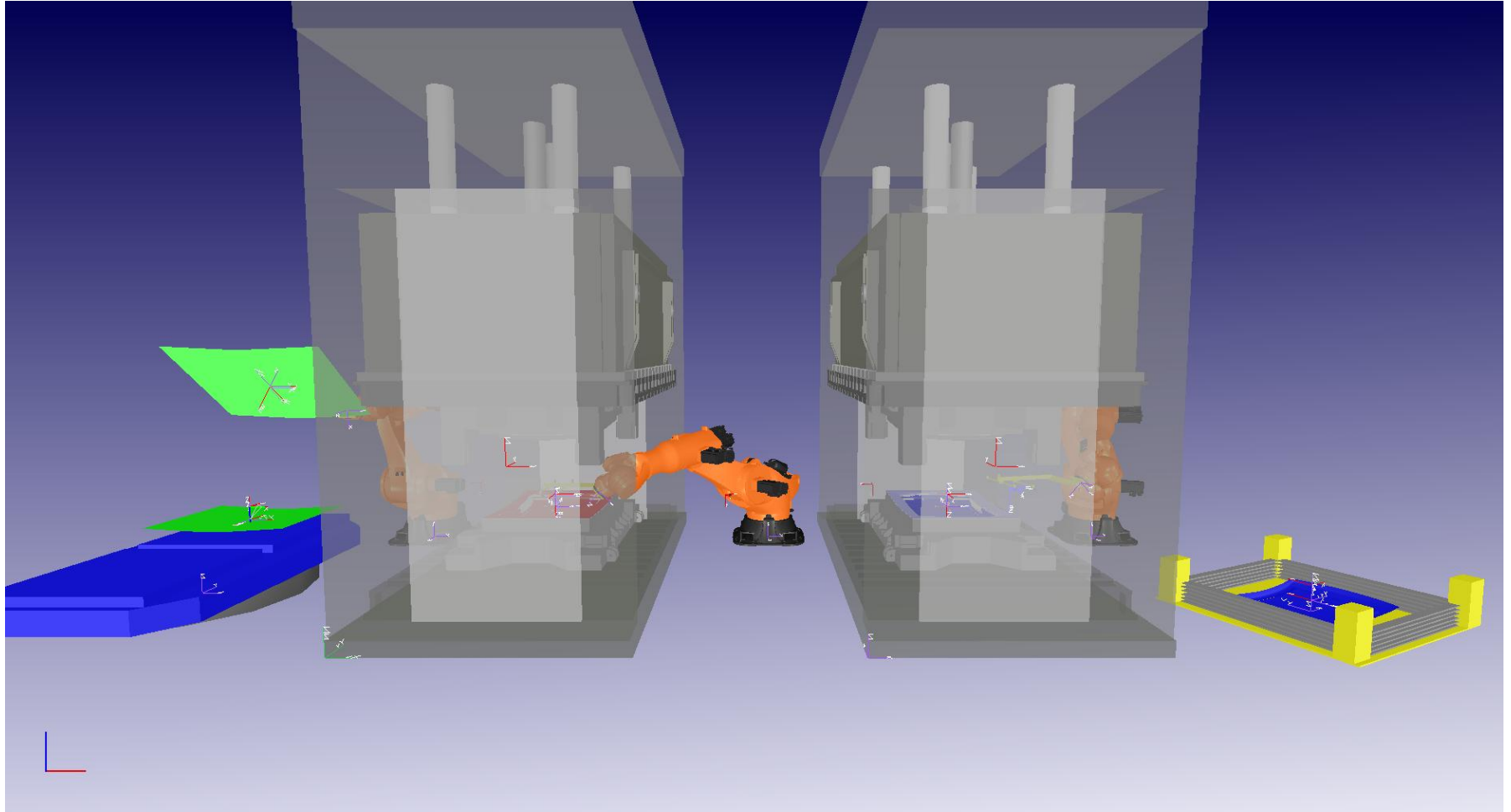
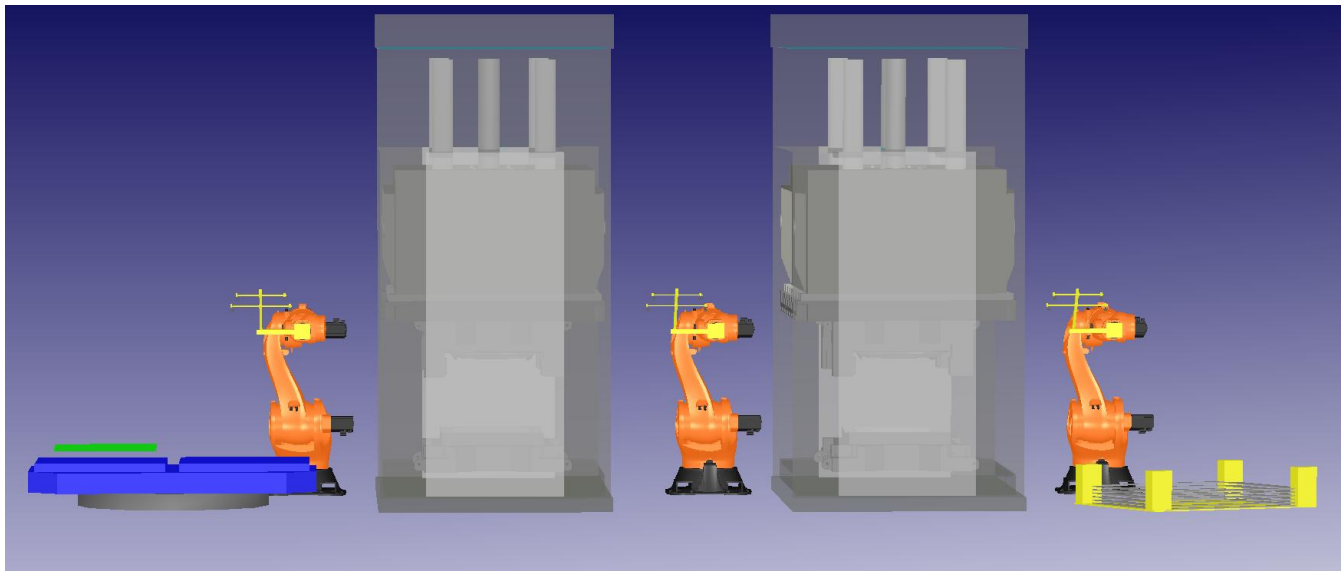
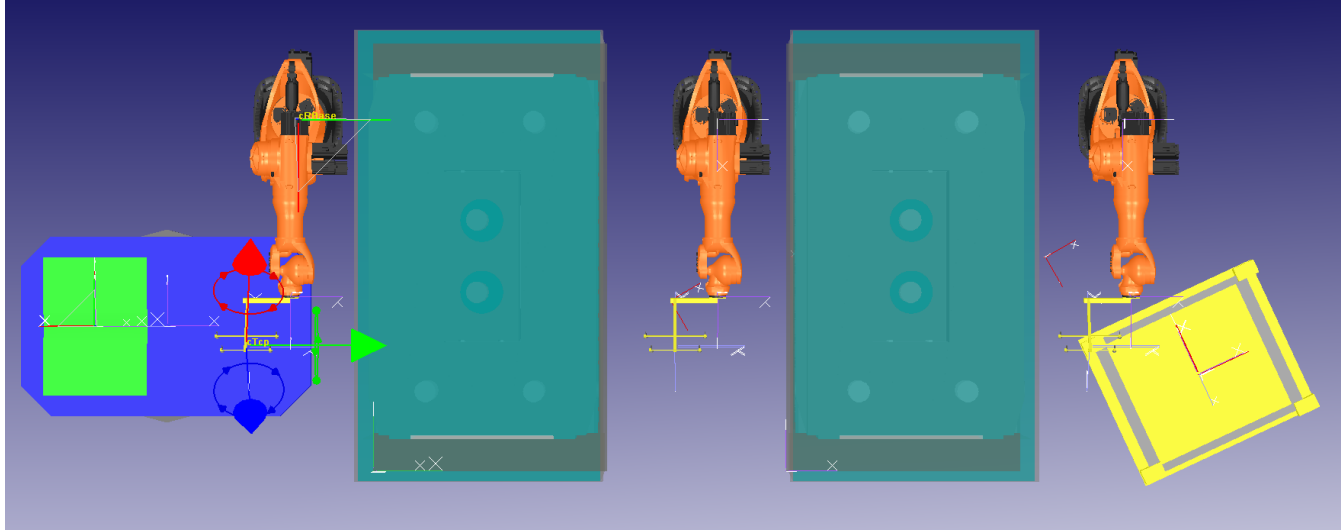


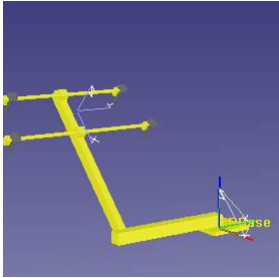
Press – Tending Robot



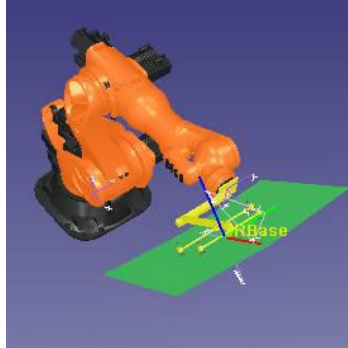
Press – Tending Robot



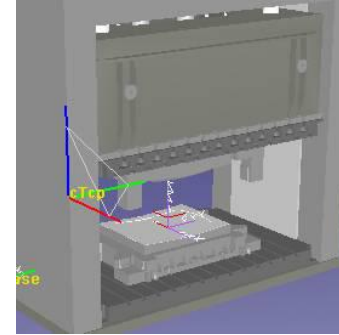
Press – Tending Robot



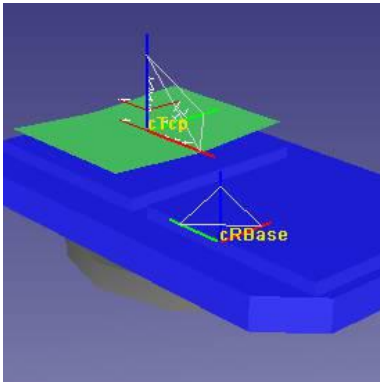
Gripper A, B, C



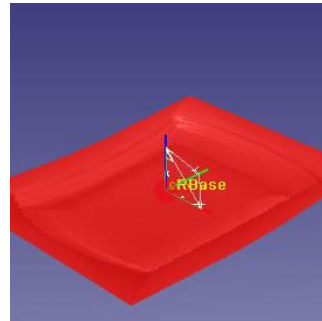
Robot A, B, C



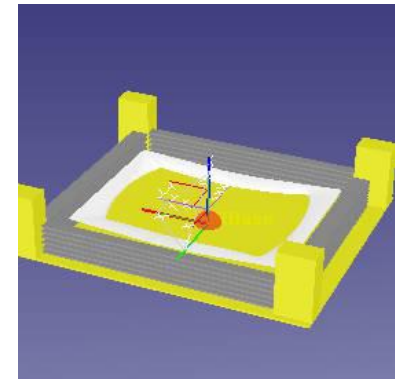
Press 1, 2



Turn Table 1

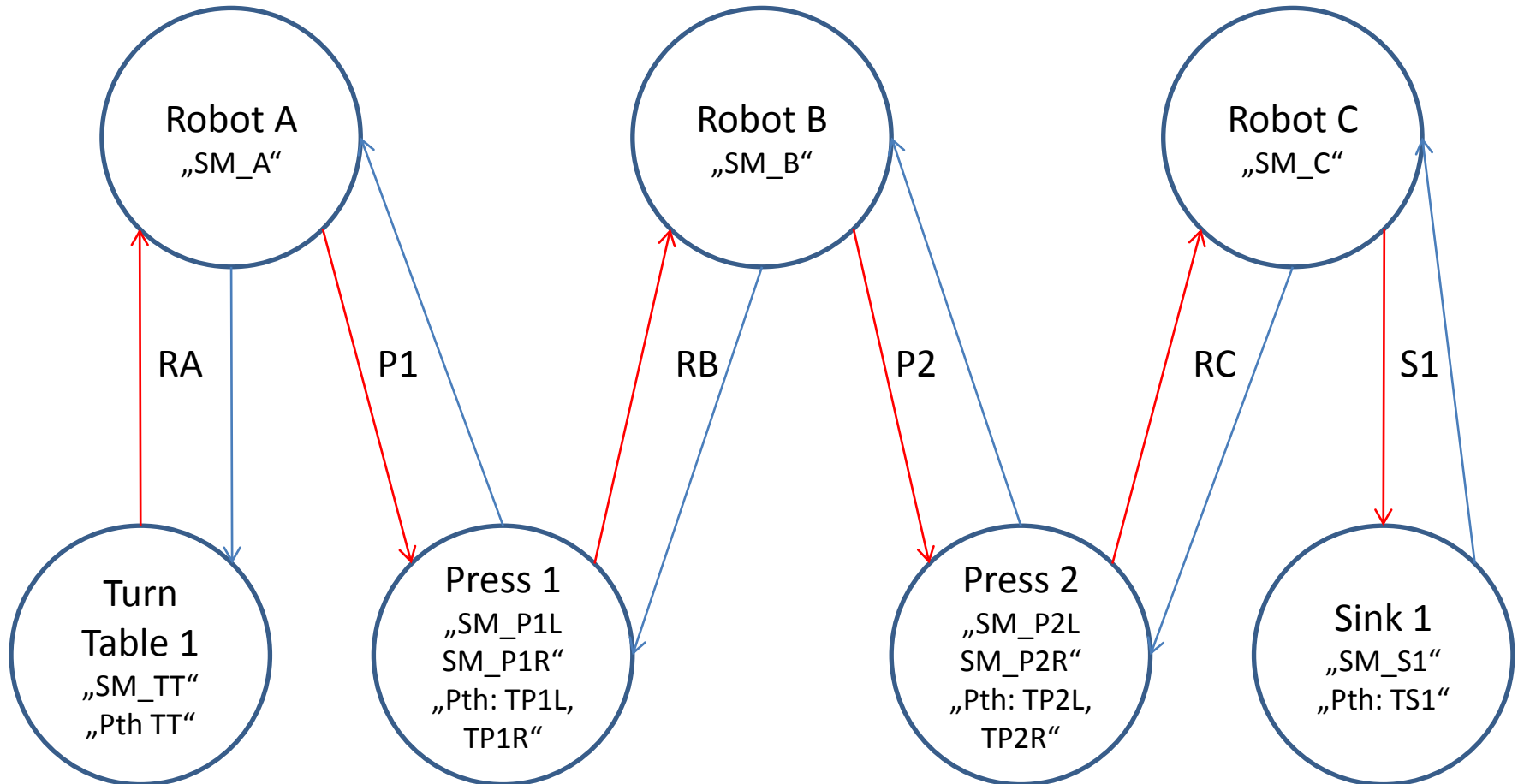


Sheet Metal_
TT, A, P1L,
P1R, B, P2L,
P2R, C, S1



Sink 1

Press – Tending Robot



→ Signal Set = 1
← Signal UnSet = 0



Press – Tending Robot

Turn Table 1

Initialization I/O Signals

RA=0

P1=0

RB=0

P2=0

RC=0

S1=0

WLOOP=5

EndInit

...

WHILE WLOOP

!-----

! Warte auf RA

!-----

WAIT_UNTIL_SIGNAL_UNSET RA

Home HOME_2

RA=1

WAIT_UNTIL_SIGNAL_UNSET RA

Home HOME_1

ERC DISPLAY DEVICE SHEET_METAL_TT ON

ENDWHILE

Robot A

...

WHILE WLOOP

!-----

! Warte auf RA

!-----

WAIT_UNTIL_SIGNAL_SET RA

PTP TT_1

LIN TT_2

ERC DISPLAY DEVICE SHEET_METAL_A ON

ERC DISPLAY DEVICE SHEET_METAL_TT OFF

LIN TT_1

RA=0

Home HOME_1

!-----

! Warte auf P1

!-----

WAIT_UNTIL_SIGNAL_UNSET P1

PTP TP1L_3

LIN TP1L_2

LIN TP1L_1

ERC DISPLAY DEVICE SHEET_METAL_P1L ON

ERC DISPLAY DEVICE SHEET_METAL_A OFF

LIN TP1L_2

LIN TP1L_3

P1=1

Home HOME_1

ENDWHILE

Press 1

...

WHILE WLOOP

!-----

! Warte auf P1

!-----

WAIT_UNTIL_SIGNAL_SET P1

HOME HOME_1

HOME HOME_ZU

HOME HOME_PRESS

ERC DISPLAY DEVICE SHEET_METAL_P1L OFF

ERC DISPLAY DEVICE SHEET_METAL_P1R ON

HOME HOME_1

!

!-----

! Warte auf RB

!-----

WAIT_UNTIL_SIGNAL_UNSET RB

! no move

RB=1

WAIT_UNTIL_SIGNAL_UNSET RB

ERC DISPLAY DEVICE SHEET_METAL_P1R OFF

!

P1=0

ENDWHILE



Press – Tending Robot

Press 1

```
...
WHILE WLOOP
!-----
! Warte auf P1
!-----
WAIT_UNTIL_SIGNAL_SET P1
HOME HOME_1
HOME HOME_ZU
HOME HOME_PRESS
ERC DISPLAY DEVICE SHEET_METAL_P1L OFF
ERC DISPLAY DEVICE SHEET_METAL_P1R ON
HOME HOME_1
!
!-----
! Warte auf RB
!-----
WAIT_UNTIL_SIGNAL_UNSET RB
! no move
RB=1
WAIT_UNTIL_SIGNAL_UNSET RB
ERC DISPLAY DEVICE SHEET_METAL_P1R OFF
!
P1=0

ENDWHILE
```

Robot B

```
...
WHILE WLOOP
!-----
! Warte auf RB
!-----
PTP TP1R_3
WAIT_UNTIL_SIGNAL_SET RB
LIN TP1R_2
LIN TP1R_1
ERC DISPLAY DEVICE SHEET_METAL_B ON
ERC DISPLAY DEVICE SHEET_METAL_P1R OFF
LIN TP1R_2
LIN TP1R_3
RB=0
Home HOME_1
!
!-----
! Warte auf P2
!-----
WAIT_UNTIL_SIGNAL_UNSET P2
PTP TP2L_3
LIN TP2L_2
LIN TP2L_1
ERC DISPLAY DEVICE SHEET_METAL_P2L ON
ERC DISPLAY DEVICE SHEET_METAL_B OFF
LIN TP2L_2
LIN TP2L_3
P2=1
Home HOME_1

ENDWHILE
```

Press 2

```
...
WHILE WLOOP
!-----
! Warte auf P2
!-----
WAIT_UNTIL_SIGNAL_SET P2
HOME HOME_1
HOME HOME_ZU
HOME HOME_PRESS
ERC DISPLAY DEVICE SHEET_METAL_P2L OFF
ERC DISPLAY DEVICE SHEET_METAL_P2R ON
HOME HOME_1
!
!-----
! Warte auf RC
!-----
WAIT_UNTIL_SIGNAL_UNSET RC
! no move
RC=1
WAIT_UNTIL_SIGNAL_UNSET RC
!
P2=0

ENDWHILE
```



Press – Tending Robot

Press 2

```
...
WHILE WLOOP
!-----
! Warte auf P2
!-----
WAIT_UNTIL_SIGNAL_SET P2
HOME HOME_1
HOME HOME_ZU
HOME HOME_PRESS
ERC DISPLAY DEVICE SHEET_METAL_P2L OFF
ERC DISPLAY DEVICE SHEET_METAL_P2R ON
HOME HOME_1
!
!-----
! Warte auf RC
!-----
WAIT_UNTIL_SIGNAL_UNSET RC
! no move
RC=1
WAIT_UNTIL_SIGNAL_UNSET RC
!
P2=0

ENDWHILE
```

Robot C

```
...
WHILE WLOOP
!-----
! Warte auf RC
!-----
PTP TP2R_3
WAIT_UNTIL_SIGNAL_SET RC
LIN TP2R_2
LIN TP2R_1
ERC DISPLAY DEVICE SHEET_METAL_C ON
ERC DISPLAY DEVICE SHEET_METAL_P2R OFF
LIN TP2R_2
LIN TP2R_3
RC=0
Home HOME_1
!
!-----
! Warte auf S1
!-----
WAIT_UNTIL_SIGNAL_UNSET S1
PTP TS1_1
LIN TS1_2
WAIT 1.5
ERC DISPLAY DEVICE SHEET_METAL_S1 ON
ERC DISPLAY DEVICE SHEET_METAL_C OFF
LIN TS1_1
S1=1
Home HOME_1

ENDWHILE
```

Sink 1

```
...
WHILE WLOOP
!-----
! Warte auf S1
!-----
WAIT_UNTIL_SIGNAL_SET S1
WAIT 0.5
ERC DISPLAY DEVICE SHEET_METAL_S1 ON
ERC DISPLAY DEVICE SHEET_METAL_C OFF
S1=0
!
WLOOP = WLOOP-1

ENDWHILE
```