Function diagram (GRAFCET acc. to EN 60848)

Control task: Gluing Device, Version B
Creator:
Class:

Step	Description
0	Initial step
	Starting conditions
1	Move press cylinder 1A1 out [Set solenoid coil 1M1]
	Press cylinder 1A1 extended
2	Move press cylinder 1A1 in, when step 2 is deactivated [Reset solenoid coil 1M1]
	P1 flashes and indicates the gluing process
	Step 0 will be activated 10 seconds after the activation of step 2