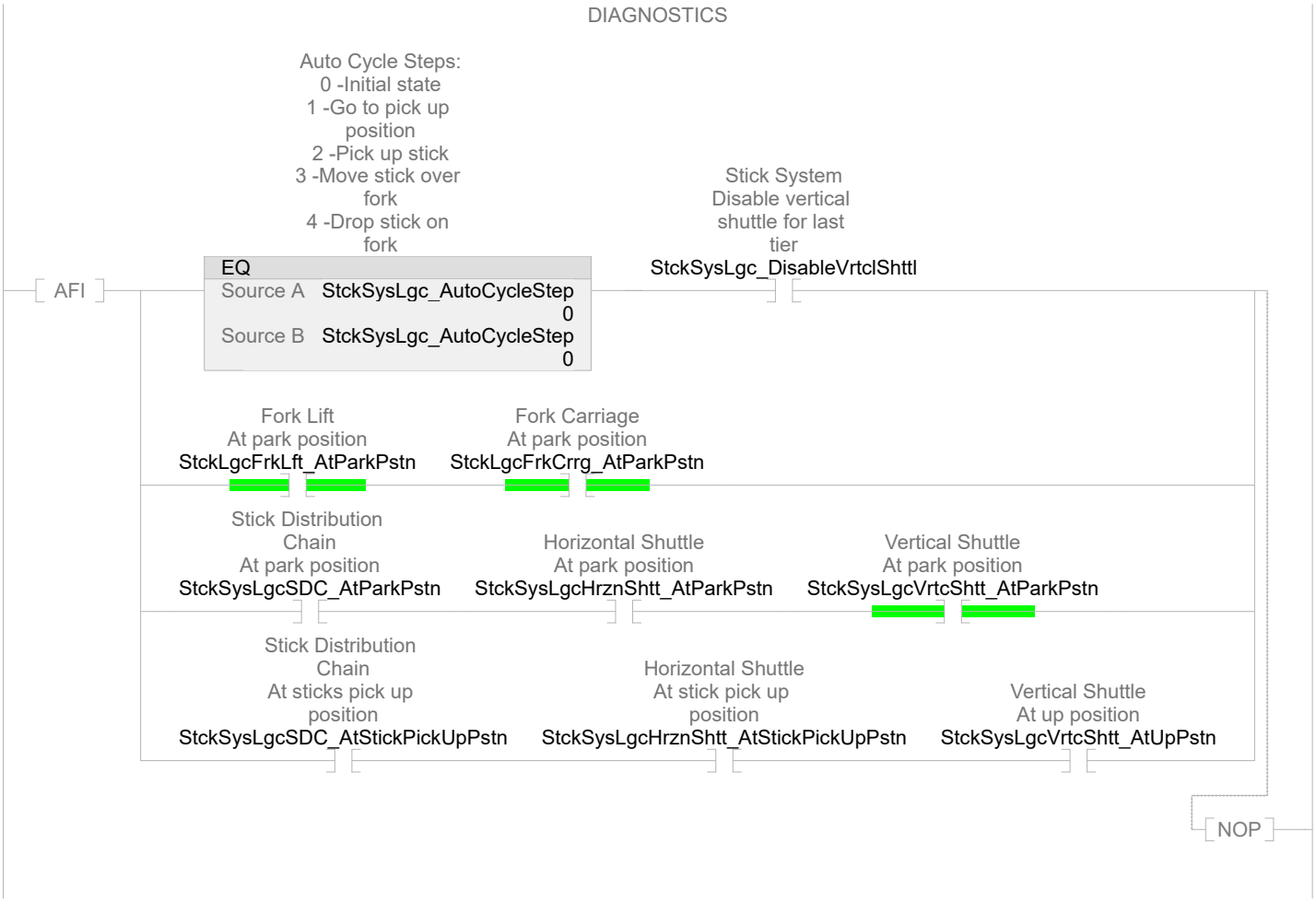

DIAGNOSTICS
Auto Cycle Steps:
0 -Initial state
1 -Go to pick up position
2 -Pick up stick
3 -Move stick over fork
4 -Drop stick on fork
Stick System Disable vertical shuttle for last tier
StckSysLgc_DisableVrtclShttl
0
AFI
EQ
Source A StckSysLgc_AutoCycleStep 0
Source B StckSysLgc_AutoCycleStep 0
Fork Lift At park position
StckLgcFrkLft_AtParkPstn
Fork Carriage At park position
StckLgcFrkCrrg_AtParkPstn
Stick Distribution Chain At park position
StckSysLgcSDC_AtParkPstn
Horizontal Shuttle At park position
StckSysLgcHrznShtt_AtParkPstn
Vertical Shuttle At park position
StckSysLgcVrtcShtt_AtParkPstn
Stick Distribution Chain At sticks pick up position
StckSysLgcSDC_AtStickPickUpPstn
Horizontal Shuttle At stick pick up position
StckSysLgcHrznShtt_AtStickPickUpPstn
Vertical Shuttle At up position
StckSysLgcVrtcShtt_AtUpPstn
NOP

CONFIGURATION

1

AFI

Parameter
Fork Carriage safe position to be loaded (deg)

EQ
Source A ZParam_ForkCrrgSafePstnToBeLoad 340.0
Source B ZParam_ForkCrrgSafePstnToBeLoad 340.0

Parameter
Vertical Shuttle Safe position to move toward forks (in)

EQ
Source A ZParam_VrtclShttlSafePstnLoadFork 8.0
Source B ZParam_VrtclShttlSafePstnLoadFork 8.0

Parameter
Horizontal Shuttle Safe position to drop sticks on forks (in)

EQ
Source A ZParam_HrzntlShttlSafePstnToDrop 0.25
Source B ZParam_HrzntlShttlSafePstnToDrop 0.25

Parameter
Vertical shuttle position safe to cycle master (in)

EQ
Source A Zparam_VrtclShttlSafePstnForkCycle 6.5
Source B Zparam_VrtclShttlSafePstnForkCycle 6.5

Parameter
Vertical Shutle Safe position for SDC (in)

EQ
Source A ZParam_VrtclShttlSafePstnSDC 1.0
Source B ZParam_VrtclShttlSafePstnSDC 1.0

NOP

Control power, Temporary stop & Auto selctor. It remains ON until control power is turned OFF.

2

Common Sector System ok (Control power On)
CmmnGnrlStckr.SysOk

SS 0140209 Stick System Auto C48A Operation Console Selector Switch
SS_StickSystemAutoC48A

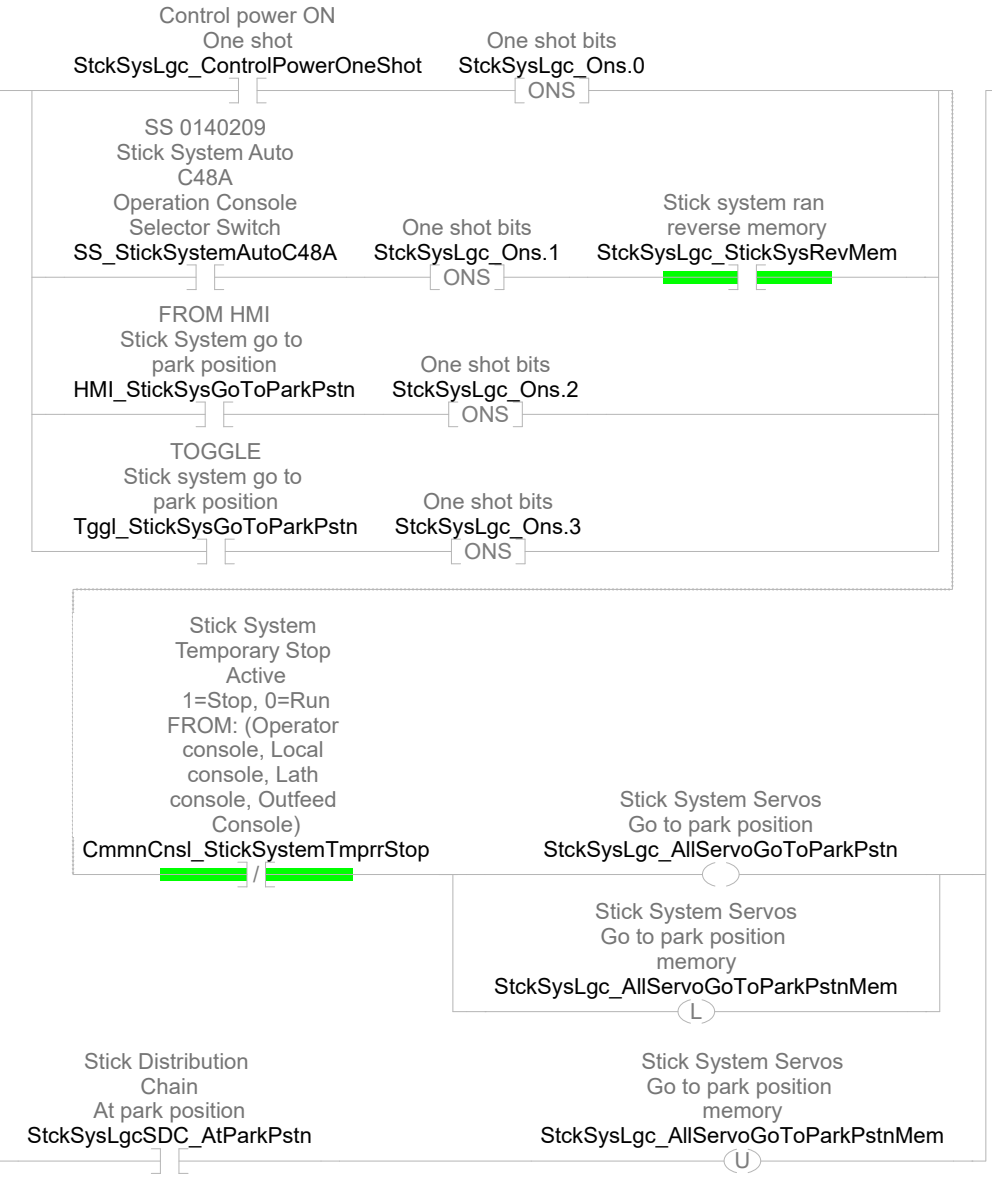
Stick System Temporary Stop Active 1=Stop, 0=Run FROM: (Operator console, Local console, Lath console, Outfeed Console)
CmmnCnsl_StickSystemTmprrStop

Control power ON One shot
StckSysLgc_ControlPowerOneShot

Control power ON One shot
StckSysLgc_ControlPowerOneShot

3

ALL SERVO OF STICK SYSTEM GO TO START POSITION



ALL SERVO OF STICK SYSTEM RESYNC

Go to recover position accordingly to the Auto Cycle Grafcet

4

SS 0140209
Stick System Auto
C48A
Operation Console
Selector Switch
SS_StickSystemAutoC48A

Stick System
Temporary Stop
Active
1=Stop, 0=Run
FROM: (Operator
console, Local
console, Lath
console, Outfeed
Console)
CmmnCnsl_StickSystemTmprrStop

One shot bits
StckSysLgc_Ons.4
ONS

Stick System Servos
Go to recovery
position
StckSysLgc_AllServoResync

TOGGLE
All stacker servo
Resync with master
Tggl_StckrAllServoResync

One shot bits
StckSysLgc_Ons.5
ONS

Stick System
Temporary Stop
Active
1=Stop, 0=Run
FROM: (Operator
console, Local
console, Lath
console, Outfeed
Console)
CmmnCnsl_StickSystemTmprrStop

ALL SERVO OF STICK SYSTEM, MOTION SERVO ON STATUS

5

Stick Feeder
Motion servo ON
status
Srv_StickFeeder.P.MotionServoOnStatus

Servo Position
Limited
Motion servo ON
status
Srv_StickDstrbtChain.P.MotionServoOnStatus

Servo Position
Limited
Motion servo ON
status
Srv_VrtclShttl.P.MotionServoOnStatus

Servo Position
Limited
Motion servo ON
status
Srv_HrzntlShttl.P.MotionServoOnStatus

Stick System Servos
ON and not faulted
StckSysLgc_AllServoOnStatus

6

FORK LOADED

Servo Position Limited Position actual input (unit)

LT
Source A Srv_VrtclShttl.P.In_PstnActual -0.00243
Source B Zparam_VrtclShttlSafePstnForkCycle 6.5

One shot bits
StckSysLgc_Ons.6
ONS

Auto Cycle Steps:
0 -Initial state
1 -Go to pick up position
2 -Pick up stick
3 -Move stick over fork
4 -Drop stick on fork

EQ
Source A StckSysLgc_AutoCycleStep 0
Source B 4

Fork loaded (stick in pan)
StckSysLgc_ForkLoaded
L

Tier count pulse
CmmnTrCntr_TierCountPulse

Fork loaded (stick in pan)
StckSysLgc_ForkLoaded
U

Stick System Logic Stick Inloaded
StckSysLgc_StickUnloaded

PB 0140226 Stick System Force Cycle C48A Operation Console
PB_StickSystemForceCycleC48A

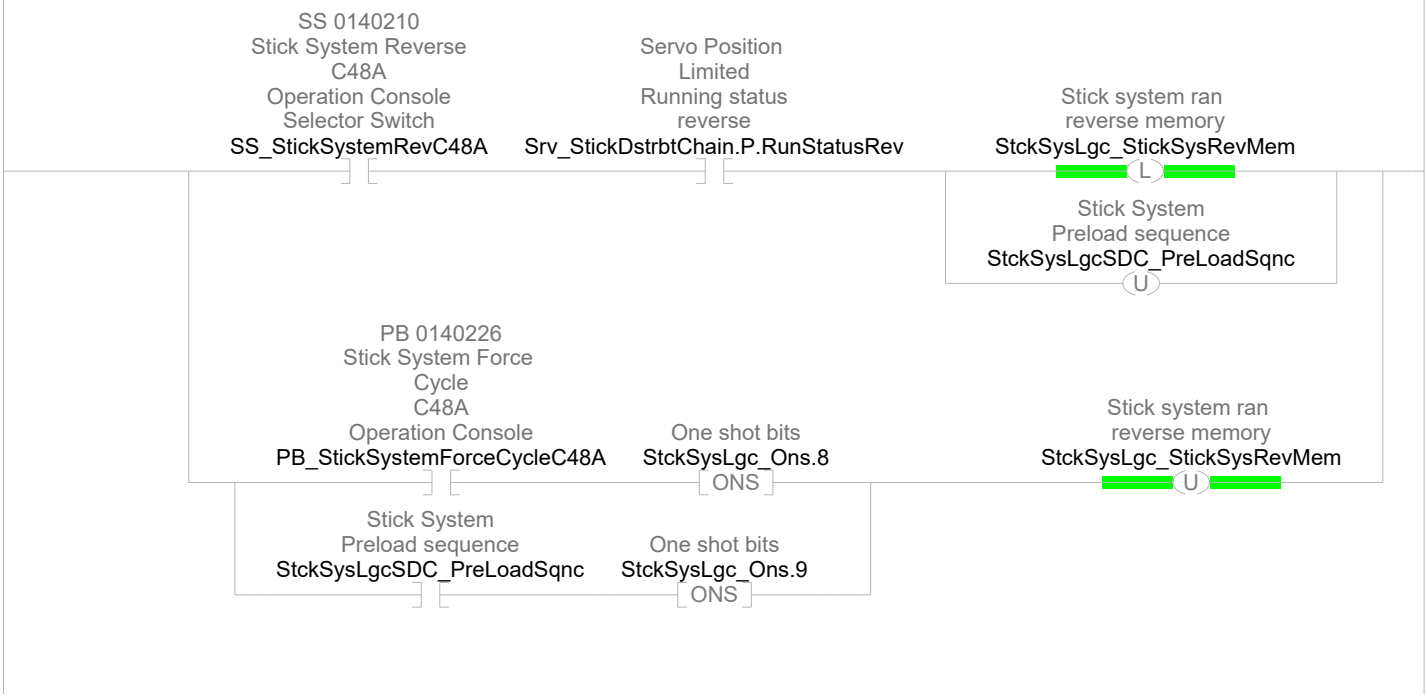
Stick System Paused midcyle
StckSysLgc_StickPausedMidCycle
/

Turn off "Fork Loaded" for auto loading at position
Hmi_AutoLoadSticks

One shot bits
StckSysLgc_Ons.7
ONS

STICK SYSTEM RAN REVERSE MEMORY

7



DISABLE VERTICAL SHUTTLE ON THE VERY LAST CYCLE OF THE BUNDLE
(First cycle of the next bundle doesn't need stick)

8

Actual Tier Count On Lift Decrement

EQ	
Source A	CmmnTrCntr_TierActualCountOnLiftDcrmnt 17
Source B	1

Actual Tier Count On The Main Lift Or The Auxiliary Lift

EQ	
Source A	CmmnTrCntr_TierActualCountOnLift 1
Source B	0

One shot bits
StckSysLgc_Ons.10
ONS

Stick System Disable vertical shuttle for last tier
StckSysLgc_DisableVrtclShttl
/

Fork loaded (stick in pan)
StckSysLgc_ForkLoaded

Stick System Disable vertical shuttle for last tier
StckSysLgc_DisableVrtclShttl
L

This machine cycle needs stick
StckSysLgcPttr_ThisCycleNeedStick
/

Actual Tier Count On Lift Decrement

GT	
Source A	CmmnTrCntr_TierActualCountOnLiftDcrmnt 17
Source B	1

Master Machine Auto cycle
StckLgc_MasterAutoCycle

PB 0140226 Stick System Force Cycle C48A Operation Console
PB_StickSystemForceCycleC48A

SS 0140223 Stick Preload C48A Operation Console Selector Switch
SS_StickPreloadC48A

Actual Tier Count On The Main Lift Or The Auxiliary Lift

NE	
Source A	CmmnTrCntr_TierActualCountOnLift 1
Source B	0

Stick System Disable vertical shuttle for last tier

StckSysLgc_DisableVrtclShttl
U

Auto cycle STEP 0

Initialization

Auto Cycle Steps:
0 -Initial state
1 -Go to pick up position
2 -Pick up stick
3 -Move stick over fork
4 -Drop stick on fork

9

Processor Flags
First Scan Pulse
_PrcssrFlag.FirstScanPulse

MOVE
Source 0
Dest StckSysLgc_AutoCycleStep 0

Stick System Servos
Go to park position
StckSysLgc_AllServoGoToParkPstn

Stick System
Unload sequence
active
StckSysLgc_UnloadSqncActive

SS 0140230
Vertical Shuttle
Lower
C48A
Operation Console
SS_VrtclShttlLowerC48A

10

Auto Cycle Steps:
0 -Initial state
1 -Go to pick up position
2 -Pick up stick
3 -Move stick over fork
4 -Drop stick on fork

EQ
Source A StckSysLgc_AutoCycleStep
0
Source B 0

Auto Cycle Steps:
0 -Initial state
1 -Go to pick up position
2 -Pick up stick
3 -Move stick over fork
4 -Drop stick on fork

EQ
Source A StckSysLgc_AutoCycleStep
0
Source B 4

SS 0140209
Stick System Auto
C48A
Operation Console
Selector Switch
SS_StickSystemAutoC48A

Stick system ran reverse memory
StckSysLgc_StickSysRevMem
/

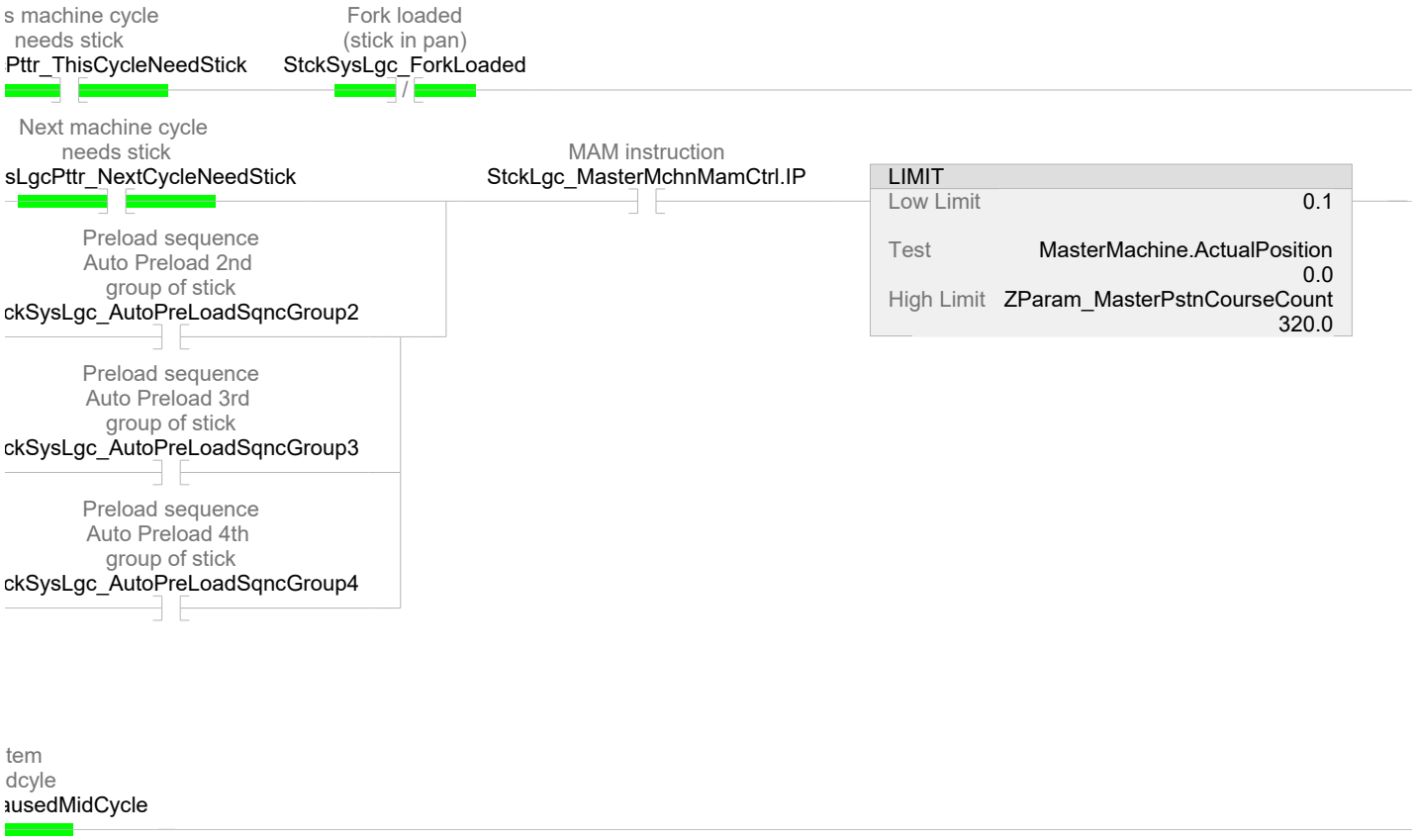
T
StckSysLg

StckS

PB 0140226
Stick System Force Cycle
C48A
Operation Console
PB_StickSystemForceCycleC48A

One shot bits
StckSysLgc_Ons.11
ONS

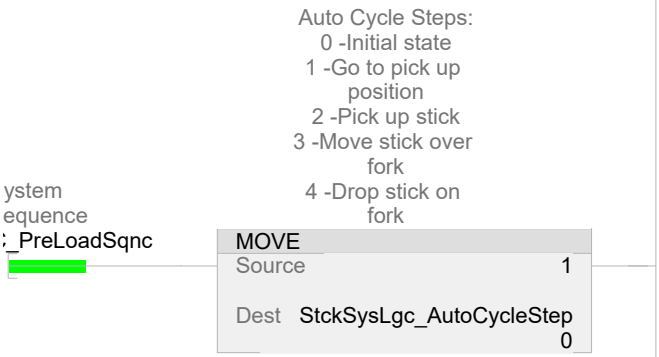
Stick Sy
Paused r
StckSysLgc_StickI
/


s machine cycle
needs stick
Pttr_ThisCycleNeedStick
Fork loaded
(stick in pan)
StckSysLgc_ForkLoaded
Next machine cycle
needs stick
sLgcPttr_NextCycleNeedStick
MAM instruction
StckLgc_MasterMchnMamCtrl.IP
LIMIT
Low Limit 0.1
Test MasterMachine.ActualPosition
0.0
High Limit ZParam_MasterPstnCourseCount
320.0
Preload sequence
Auto Preload 2nd
group of stick
ckSysLgc_AutoPreLoadSqncGroup2
Preload sequence
Auto Preload 3rd
group of stick
ckSysLgc_AutoPreLoadSqncGroup3
Preload sequence
Auto Preload 4th
group of stick
ckSysLgc_AutoPreLoadSqncGroup4
tem
dcyle
ausedMidCycle

Auto Cycle STEP 1

- Stick distribution chain moves to stick pick up position
- Horizontal shuttle moves to stick pick up position

Horizontal Shuttle
At park position
sLgcHrznShtt_AtParkPstn
Vertical Shuttle
At park position
StckSysLgcVrtcShtt_AtParkPstn
Stick
Preload
StckSysLgcSD
Servo Position
Limited
Position actual
input
(unit)
LE
Source A
Srv_VrtclShttl.P.In_PstnActual
-0.00243
Source B
ZParam_VrtclShttlSafePstnSDC
1.0
Servo Position
Limited
Running status
reverse
Srv_VrtclShttl.P.RunStatusRev


Auto Cycle Steps:
0 -Initial state
1 -Go to pick up position
2 -Pick up stick
3 -Move stick over fork
4 -Drop stick on fork
ystem
equence
_PreLoadSqnc
MOVE
Source
1
Dest
StckSysLgc_AutoCycleStep
0

11

Auto Cycle STEP 2

- Vertical shuttle moves up to pick and raise stick

Auto Cycle Steps:
0 -Initial state
1 -Go to pick up position
2 -Pick up stick
3 -Move stick over fork
4 -Drop stick on fork

EQ
Source A StckSysLgc_AutoCycleStep 0
Source B 1

Stick System Automatic cycle interlock
StckSysLgc_AutoCycleIntlck

Stick Distribution Chain At sticks pick up position
StckSysLgcSDC_AtStickPickUpPstn

Horizontal Shuttle At stick pick up position
StckSysLgcHrznShtt_AtStickPickUpPstn

Auto Cycle Steps:
0 -Initial state
1 -Go to pick up position
2 -Pick up stick
3 -Move stick over fork
4 -Drop stick on fork

MOVE
Source 2
Dest StckSysLgc_AutoCycleStep 0

12

Auto Cycle Steps:
0 -Initial state
1 -Go to pick up position
2 -Pick up stick
3 -Move stick over fork
4 -Drop stick on fork

EQ
Source A StckSysLgc_AutoCycleStep
0
Source B
2

Stick System
Automatic cycle
interlock
StckSysLgc_AutoCycleIntlck

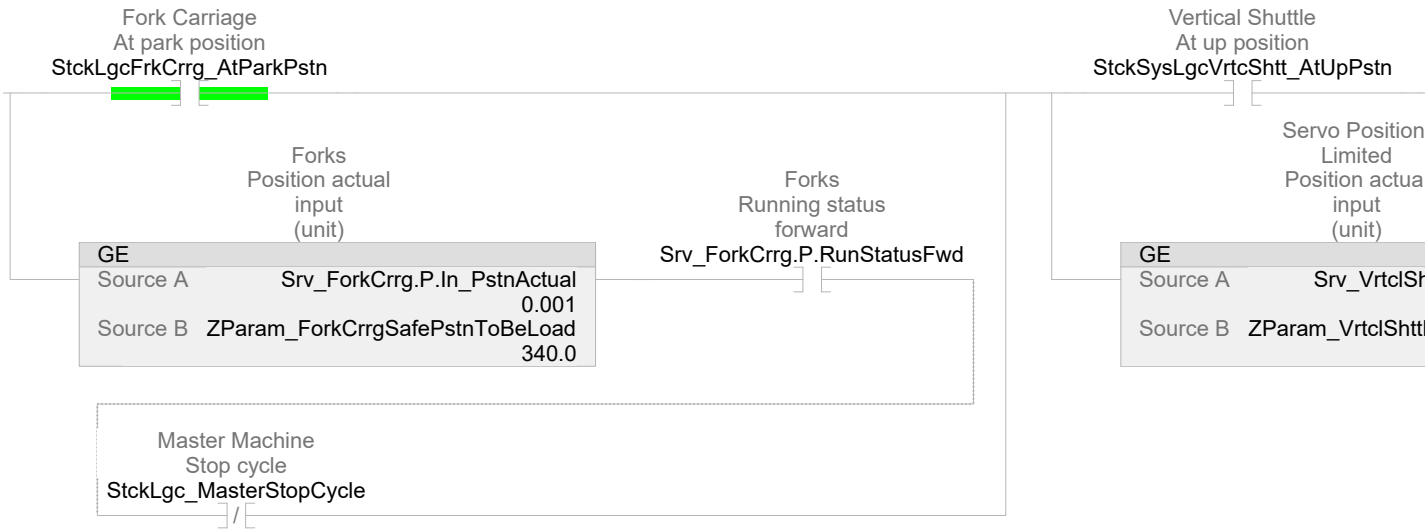
Fork loaded
(stick in pan)
StckSysLgc_ForkLoaded
/

Fork Lift
At park position
StckLgcFrkLft_AtParkPstn

Stick System
Disable vertical
shuttle for last
tier
StckSysLgc_DisableVrtclSh

Auto Cycle STEP 3

- Horizontal shuttle moves toward the fork to bring stick over the pan
- Stick distribution chain moves to park position position, so the shuttle doesn't touch sticks on the chain



Auto Cycle Steps:
0 -Initial state
1 -Go to pick up position
2 -Pick up stick
3 -Move stick over fork
4 -Drop stick on fork
MOVE
Source 3
Dest StckSysLgc_AutoCycleStep 0
Servo Position Limited
Running status forward
Srv_VrtclShttl.P.RunStatusFwd
l.P.In_PstnActual
-0.00243
afePstnLoadFork
8.0

Auto Cycle STEP 4

- Vertical shuttle moves down to drop the sticks on fork's pan

13

Auto Cycle Steps:
0 -Initial state
1 -Go to pick up position
2 -Pick up stick
3 -Move stick over fork
4 -Drop stick on fork

EQ
Source A StckSysLgc_AutoCycleStep
0
Source B 3

Stick System
Automatic cycle
interlock
StckSysLgc_AutoCycleIntlck

Fork Carriage
At park position
StckLgcFrkCrrg_AtParkPstn

Forks
Position actual
input
(unit)

GE
Source A Srv_ForkCrrg.P.In_PstnActual
0.001
Source B ZParam_ForkCrrgSafePstnToDrop
350.0

Forks
Running status
forward
Srv_ForkCrrg.P.RunStatusFwd

Master Machine
Stop cycle
StckLgc_MasterStopCycle

Horizontal Shuttle
At park position
StckSysLgcHrznShtt_AtParkPstn

Servo Position
Limited
Position actual
input
(unit)

LE
Source A Srv_HrzntlShttl.P.In_PstnActual
5.12825
Source B ZParam_HrzntlShttlSafePstnToDrop
0.25

Servo Position
Limited
Running status
reverse
Srv_HrzntlShttl.P.RunStatusRev

Auto Cycle Steps:
0 -Initial state
1 -Go to pick up position
2 -Pick up stick
3 -Move stick over fork
4 -Drop stick on fork

MOVE
Source 4
Dest StckSysLgc_AutoCycleStep
0

**** AUTO CYCLE GRAFCET ****

Auto cycle interlock

14

Stick System Temporary Stop Active 1=Stop, 0=Run FROM: (Operator console, Local console, Lath console, Outfeed Console)
CmmnCnsl_StickSystemTmprrStop

Stick System Servos ON and not faulted
StckSysLgc_AllServoOnStatus

Stick System Paused midcyle
StckSysLgc_StickPausedMidCycle

Stick System Unload sequence active
StckSysLgc_UnloadSqncActive

Stick System Automatic cycle interlock
StckSysLgc_AutoCycleIntlck

Stick System Temporary Stop Active 1=Stop, 0=Run FROM: (Operator console, Local console, Lath console, Outfeed Console)
CmmnCnsl_StickSystemTmprrStop

Stick Distribution Chain At park position
StckSysLgcSDC_AtParkPstn

Stick System Paused midcyle
StckSysLgc_StickPausedMidCycle
L

Stick System Servos ON and not faulted
StckSysLgc_AllServoOnStatus

PB 0140226 Stick System Force Cycle C48A Operation Console
PB_StickSystemForceCycleC48A

One shot bits
StckSysLgc_Ons.12
ONS

Stick System Temporary Stop Active 1=Stop, 0=Run FROM: (Operator console, Local console, Lath console, Outfeed Console)
CmmnCnsl_StickSystemTmprrStop

Stick System Servos ON and not faulted
StckSysLgc_AllServoOnStatus

Stick System Servos Go to park position
StckSysLgc_AllServoGoToParkPstn

Stick System Unload sequence active
StckSysLgc_UnloadSqncActive

SS 0140223 Stick Preload C48A Operation Console Selector Switch
SS_StickPreloadC48A

PB 0140103 Alarm Reset C48A

Operation Console
Push Button
PB_AlarmResetC48A

One shot bits
StckSysLgc_Ons.13
ONS

SS 0140210
Stick System Reverse
C48A
Operation Console
Selector Switch
SS_StickSystemRevC48A

One shot bits
StckSysLgc_Ons.21
ONS

Stick System
Paused midcyle
StckSysLgc_StickPausedMidCycle
U

**** UNLOAD GRAFCET ****

Unload interlock

15

Stick System
Temporary Stop
Active
1=Stop, 0=Run
FROM: (Operator
console, Local
console, Lath
console, Outfeed
Console)
CmmnCnsl_StickSystemTmprrStop
/

Stick System Servos
ON and not faulted
StckSysLgc_AllServoOnStatus

Fork Carriage
At park position
StckLgcFrkCrrg_AtParkPstn

Servo Position
Limited
At zero speed
Srv_HrzntlShttl.P.ZeroSpeed

Servo Position
Limited
At zero speed
Srv_VrtclShttl.P.ZeroSpeed

Unload interlock
StckSysLgc_UnloadIntlck

Unload Steps:
0 -Initial state
1 -Vertical go to
park position
2 -Horizontal go to
park position
3 -Vertical go to up
position
4 -Horizontal go to
pick up position
5 -Vertical go to
park position
6 -Horizontal go to
park position

16

NE
Source A StckSysLgc_UnloadStep
6
Source B 0

Stick System
Unload sequence
active
StckSysLgc_UnloadSqncActive

Unload STEP 0

Initialization

17

Processor Flags
First Scan Pulse
_PrcssrFlag.FirstScanPulse

Stick System Servos
Go to park position
StckSysLgc_AllServoGoToParkPstn

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

EQ
Source A StckSysLgc_UnloadStep 6
Source B 6

Horizontal Shuttle
At park position
StckSysLgcHrznShtt_AtParkPstn

Vertical Shuttle
At park position
StckSysLgcVrtcShtt_AtParkPstn

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

MOVE
Source 0
Dest StckSysLgc_UnloadStep 6

Unload STEP 1

- Vertical shuttle moves to park position (it moves down)

18

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

EQ
Source A StckSysLgc_UnloadStep 6
Source B 0

SS 0140222
Stick Unload
C48A
Operation Console
Selector Switch
SS_StickUnloadC48A

Unload interlock
StckSysLgc_UnloadIntlck

Horizontal Shuttle
At stick pick up position
StckSysLgcHrznShtt_AtStickPickUpPstn

Vertical Shuttle
At up position
StckSysLgcVrtcShtt_AtUpPstn

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

MOVE
Source 1
Dest StckSysLgc_UnloadStep 6

Unload STEP 2

- Horizontal shuttle go to park position (Under the fork pan)

19

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

EQ
Source A StckSysLgc_UnloadStep 6
Source B 0

SS 0140222
Stick Unload
C48A
Operation Console
Selector Switch
SS_StickUnloadC48A

Unload interlock
StckSysLgc_UnloadIntlck

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

EQ
Source A StckSysLgc_UnloadStep 6
Source B 1

Horizontal Shuttle
At stick pick up position
StckSysLgcHrznShtt_AtStickPickUpPstn

Vertical Shuttle
At park position
StckSysLgcVrtcShtt_AtParkPstn

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

MOVE
Source 2
Dest StckSysLgc_UnloadStep 6

Unload STEP 3

- Vertical shuttle moves up to pick stick from fork pan

20

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

EQ
Source A StckSysLgc_UnloadStep 6
Source B 0

SS 0140222
Stick Unload
C48A
Operation Console
Selector Switch
SS_StickUnloadC48A

Unload interlock
StckSysLgc_UnloadIntlck

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

EQ
Source A StckSysLgc_UnloadStep 6
Source B 2

Horizontal Shuttle
At park position
StckSysLgcHrznShtt_AtParkPstn

Vertical Shuttle
At park position
StckSysLgcVrtcShtt_AtParkPstn

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

MOVE
Source 3
Dest StckSysLgc_UnloadStep 6

Unload STEP 4

- Horizontal shuttle moves away from fork (moves to auto cycle "stick pick up position")

21

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

EQ
Source A StckSysLgc_UnloadStep 6
Source B 0

SS 0140222
Stick Unload
C48A
Operation Console
Selector Switch
SS_StickUnloadC48A

Unload interlock
StckSysLgc_UnloadIntlck

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

EQ
Source A StckSysLgc_UnloadStep 6
Source B 3

Horizontal Shuttle
At park position
StckSysLgcHrznShtt_AtParkPstn

Vertical Shuttle
At up position
StckSysLgcVrtcShtt_AtUpPstn

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

MOVE
Source 4
Dest StckSysLgc_UnloadStep 6

Unload STEP 5

- Vertical shuttle go back to park position, leaves the sticks on Stick Distribution Chain

22

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

EQ
Source A StckSysLgc_UnloadStep 6
Source B 4

Unload interlock
StckSysLgc_UnloadIntlck

Horizontal Shuttle
At stick pick up position
StckSysLgcHrznShtt_AtStickPickUpPstn

Vertical Shuttle
At up position
StckSysLgcVrtcShtt_AtUpPstn

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

MOVE
Source 5
Dest StckSysLgc_UnloadStep 6

Unload STEP 6

- Horizontal shuttle go back to park position (Under the fork pan)

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Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

EQ
Source A StckSysLgc_UnloadStep 6
Source B 5

Unload interlock
StckSysLgc_UnloadIntlck

Horizontal Shuttle
At stick pick up position
StckSysLgcHrznShtt_AtStickPickUpPstn

Vertical Shuttle
At park position
StckSysLgcVrtcShtt_AtParkPstn

Unload Steps:
0 -Initial state
1 -Vertical go to park position
2 -Horizontal go to park position
3 -Vertical go to up position
4 -Horizontal go to pick up position
5 -Vertical go to park position
6 -Horizontal go to park position

MOVE
Source 6
Dest StckSysLgc_UnloadStep 6

Stick System Logic
Stick Inloaded
StckSysLgc_StickUnloaded
L

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SS 0140209
Stick System Auto C48A
Operation Console
Selector Switch
SS_StickSystemAutoC48A

One shot bits
StckSysLgc_Ons.14
ONS

Stick System Logic
Stick Inloaded
StckSysLgc_StickUnloaded
U

25

Accumulated distance

Stick System Auto Preload sequence
StckSysLgcSDC_AutoPreLoadSqnc

One shot bits
StckSysLgcSDC_Ons.22
ONS

CLR
Dest StckSysLgc_Preloa

CPT
Dest StckSysLgc_Preload
Expression Srv_StickDstrbtChain.P.In_VlctActual/1000.0*CmmnGnrl_MainCntnScanTime.S

ADD
Source A StckSysLgc_PreloadSD
Source B StckSysLgc_Preload
Dest StckSysLgc_PreloadSD

ISDCAccmltdDstnc
175.9987

DCScanDstnc
0.00845886
hdldTaskIntrvl

CAccmltdDstnc
175.9987
DCScanDstnc
0.00845886
CAccmltdDstnc
175.9987

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Stick System Auto Preload sequence
StckSysLgcSDC_AutoPreLoadSqnc

Stick System Auto Preload Sequence Group 4 Accumulated Distance

MUL
Source A Srv_StickDstrbtChain.P.AxisPrprtPstnUnwind 104.0
Source B 1
Dest StckSysLgc_AutoPreLoadSqncGroup4Dstnc 88.0

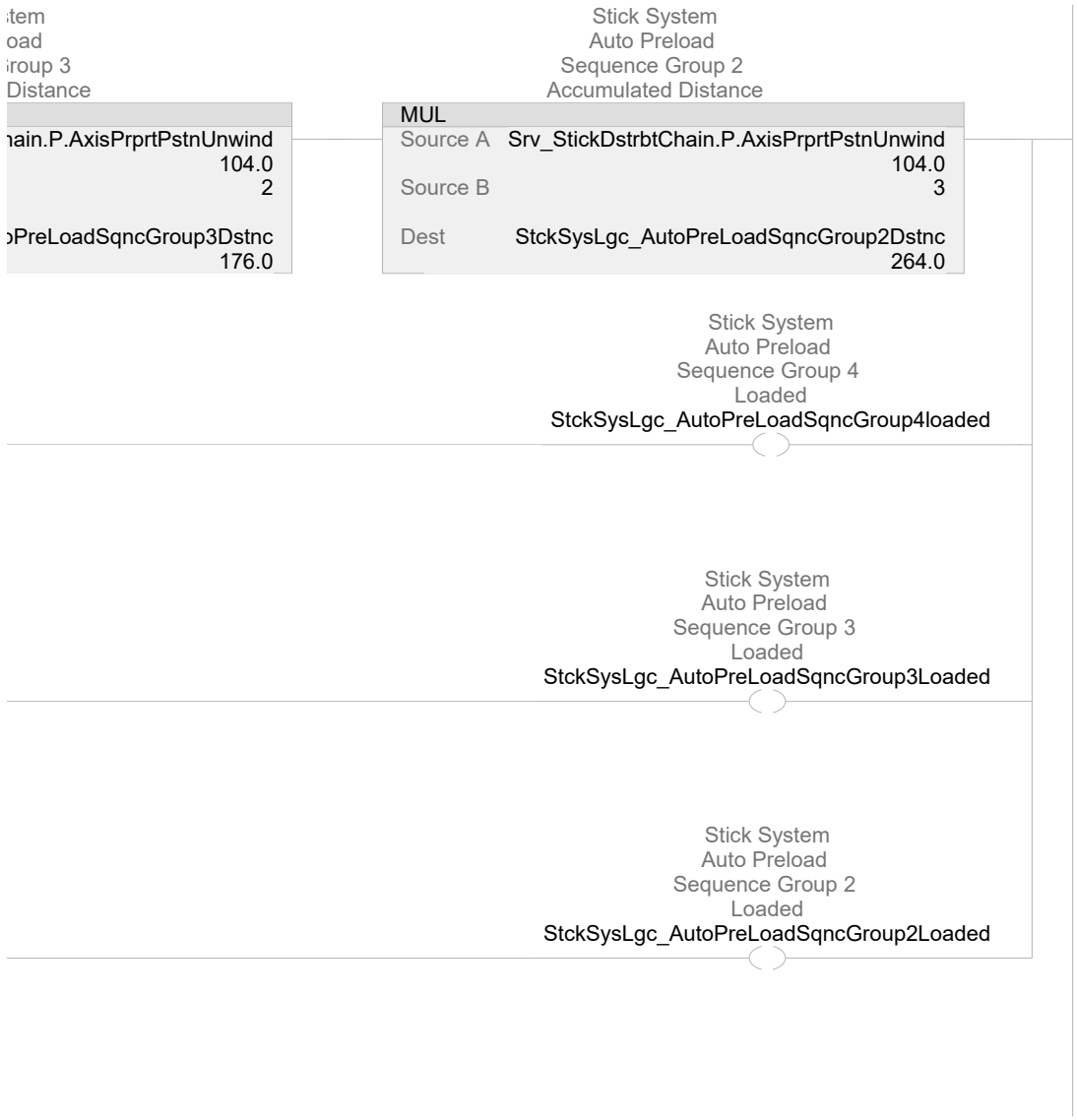
Stick S
Auto Pr
Sequence
Accumulate

MUL
Source A Srv_StickDstrbt
Source B
Dest StckSysLgc_Au

GT
Source A StckSysLgc_PreloadSDCAccmltdDstnc 175.9987
Source B StckSysLgc_AutoPreLoadSqncGroup4Dstnc 88.0

GT
Source A StckSysLgc_PreloadSDCAccmltdDstnc 175.9987
Source B StckSysLgc_AutoPreLoadSqncGroup3Dstnc 176.0

GT
Source A StckSysLgc_PreloadSDCAccmltdDstnc 175.9987
Source B StckSysLgc_AutoPreLoadSqncGroup2Dstnc 264.0


tem
oad
roup 3
Distance
hain.P.AxisPrprtPstnUnwind
104.0
2
oPreLoadSqncGroup3Dstnc
176.0
Stick System
Auto Preload
Sequence Group 2
Accumulated Distance
MUL
Source A
Srv_StickDstrbtChain.P.AxisPrprtPstnUnwind
104.0
Source B
3
Dest
StckSysLgc_AutoPreLoadSqncGroup2Dstnc
264.0
Stick System
Auto Preload
Sequence Group 4
Loaded
StckSysLgc_AutoPreLoadSqncGroup4loaded
Stick System
Auto Preload
Sequence Group 3
Loaded
StckSysLgc_AutoPreLoadSqncGroup3Loaded
Stick System
Auto Preload
Sequence Group 2
Loaded
StckSysLgc_AutoPreLoadSqncGroup2Loaded

(End)