LANGKAH VERIFIKASI PROGRAM LEWAT SIMULASI GMWIN 4

**TANTANGAN 2:**

|  |  |  |  |
| --- | --- | --- | --- |
| **No** | **MATIKAN INPUT** | **TEKAN INPUT** | **OUTPUT** |
| 1 |  | Posisi Pneumatic Insert Return dan RUN |  |
| 2 |  | PB Start | Conveyor ON |
| 3 |  | Sensor di Magazine | Pneumatic Insert |
| 4 | Sensor di Magazine dan Posisi Pneumatic Insert Return | Posisi Pneumatic Insert |  |
| 5 |  | +10 Detik | Pneumatic Insert Return |
| 6 | Posisi Pneumatic Insert | Posisi Pneumatic Insert Return |  |

**TANTANGAN 3:**

|  |  |  |  |
| --- | --- | --- | --- |
| **No** | **MATIKAN INPUT** | **TEKAN INPUT** | **OUTPUT** |
| 1 |  | Posisi Pneumatic Insert Return, Posisi Pneumatic Eject Return, dan RUN |  |
| 2 |  | PB Start | Conveyor ON |
| 3 |  | Sensor di Magazine | Pneumatic Insert |
| 4 | Sensor di Magazine dan Posisi Pneumatic Insert Return | Posisi Pneumatic Insert |  |
| 5 |  | +10 Detik | Pneumatic Insert Return |
| 6 | Posisi Pneumatic Insert | Posisi Pneumatic Insert Return |  |
| 7 |  | Inductive Proximity Sensor | Pneumatic Eject |
| 8 | Posisi Pneumatic Eject Return dan Inductive Proximity Sensor | Posisi Pneumatic Eject |  |
| 9 |  | + 3 Detik | Pneumatic Eject Return |
| 10 | Posisi Pneumatic Eject | Posisi Pneumatic Insert Return |  |

**MATERI 3:**

**Tantangan 1:**

|  |  |  |  |
| --- | --- | --- | --- |
| **No** | **MATIKAN INPUT** | **TEKAN INPUT** | **OUTPUT** |
| 1 |  | Posisi Rotary di Conveyor 2, Posisi Rotary Up, dan RUN |  |
| 2 |  | PB Start, end Conveyor1 dan Posisi Rotary Up | Rotary CW |
| 3 | Rotary di Conveyor 2 | Rotary di Conveyor 1 | Rotary Down |
| 4 | Posisi Rotary Up | Rotary Down |  |

**Tantangan 2:**

|  |  |  |  |
| --- | --- | --- | --- |
| **No** | **MATIKAN INPUT** | **TEKAN INPUT** | **OUTPUT** |
| 1 |  | Posisi Rotary di Conveyor 2, Posisi Rotary Up, dan RUN |  |
| 2 |  | PB Start dan Posisi Rotary Up | Rotary CW |
| 3 | Rotary di Conveyor 2 | Rotary di Conveyor 1 | Rotary Down |
| 4 | Posisi Rotary Up | Rotary Down | Vacuum ON |
| 5 |  | Posisi Vacuum ON | Rotary Up |
| 6 | Rotary Down | Posisi Rotary Up | Rotary CCW |
| 7 | Posisi Rotary di Conveyor 1 | Posisi Rotary di Conveyor 2 |  |

1. Tantangan 3:

|  |  |  |  |
| --- | --- | --- | --- |
| **No** | **MATIKAN INPUT** | **TEKAN INPUT** | **OUTPUT** |
| 1 |  | Posisi Rotary di Conveyor 2, Posisi Rotary Up, dan RUN |  |
| 2 |  | PB Start dan Posisi Rotary Up | Rotary CW |
| 3 | Rotary di Conveyor 2 | Rotary di Conveyor 1 | Rotary Down |
| 4 | Posisi Rotary Up | Rotary Down | Vacuum ON |
| 5 |  | Posisi Vacuum ON | Rotary Up, Vacuum ON |
| 6 | Posisi Rotary Down | Posisi Rotary Up | Rotary CCW, Vacuum ON |
| 7 | Posisi Rotary di Conveyor 1 | Posisi Rotary di Conveyor 2 | Rotary Down, Vacuum ON |
| 8 | Posisi Rotary Up | Rotary Down | Vacuum OFF |
| 9 | Posisi Vacuum OFF |  | Rotary Up |
| 10 | Posisi Rotary Down | Posisi Rotary Up |  |

MATERI 4:

1. Tekan Posisi Drill Up dan Stopper Down
2. Tekan START, maka Conveyor 2 ON
3. Tekan Work Point, maka Drill Down dan Conveyor 2 OFF
4. Matikan Posisi Drill Up dan Tekan Posisi Drill Down, maka Drill ON
5. Setelah 4 Detik, maka Drill OFF dan Drill Up
6. Matikan Posisi Drill Down dan Tekan Posisi Drill Up, maka Stopper UP
7. Matikan Posisi Stopper Down dan Tekan Posisi Stopper UP, maka Conveyor 2 ON dan Stopper UP
8. Tekan Akhir Conveyor 2, maka Stopper tidak UP
9. Matikan Posisi Stopper Up dan Tekan Posisi Stopper Down

|  |  |  |  |
| --- | --- | --- | --- |
| **No** | **MATIKAN INPUT** | **TEKAN INPUT** | **OUTPUT** |
| 1 |  | Posisi Drill Up, Stopper Down, dan RUN |  |
| 2 |  | PB Start | Conveyor 2 ON |
| 3 |  | Work Point | Conveyor 2 OFF |
| 4 | Posisi Drill Up | Posisi Drill Down | Drill ON |
| 5 |  | +4 Detik | Drill OFF dan Drill Up |
| 6 | Posisi Drill Down | Posisi Drill Up | Stopper UP |
| 7 | Posisi Stopper Down | Tekan Posisi Stopper UP | Conveyor 2 ON dan Stopper UP |
| 8 |  | Akhir Conveyor 2 | Stopper tidak UP |
| 9 | Posisi Stopper Up | Posisi Stopper Down |  |