|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| BLOK 0 | KET | M | BLOK 1 | KET | M |
|  | POS. GRIP FORWARD | 5 |  | POS. STOPPER UP | 4 |
|  | POS. GRIP BACKWARD |  | POS. STOPPER DOWN |
|  | POS. GRIP UP |  | WORK POINT |
|  | POS. GRIP DOWN |  | POS. DRILL UP |
|  | POS. FINGER OPEN |  | POS. DRILL DOWN |
|  | POS. FINGER CLOSE |  | AKHIR CONVEYOR 2 | 4/5 |
|  | SENSOR DI MAGAZINE | 2 |  | POS. ROT DI CONV 2 | 3 |
|  | PHOTO SENSOR |  | POS. ROT DI CONV 1 |

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
|  | IND.PROXIMITYSENSOR | 2 |  | POS. ROTARY UP | 3 |
|  | CAPACITIVE SENSOR |  | POS. ROTARY DOWN |
|  | POS. INSERT |  | POS. VACUUM ON |
|  | POS. INSERT RETURN |  | PB START | ALL |
|  | POS. EJECT |  |  |  |
|  | POS. EJECT RETURN |  |  |  |
|  | AKHIR CONVEYOR 1 | 2/3 |  |  |  |
|  |  |  |  |  |  |

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| BLOK 0 | KET | M | BLOK 1 | KET | M |
|  | POS. GRIP FORWARD | 5 |  | POS. STOPPER UP | 4 |
|  | POS. GRIP BACKWARD |  | POS. STOPPER DOWN |
|  | POS. GRIP UP |  | WORK POINT |
|  | POS. GRIP DOWN |  | POS. DRILL UP |
|  | POS. FINGER OPEN |  | POS. DRILL DOWN |
|  | POS. FINGER CLOSE |  | AKHIR CONVEYOR 2 | 4/5 |
|  | SENSOR DI MAGAZINE | 2 |  | POS. ROT DI CONV 2 | 3 |
|  | PHOTO SENSOR |  | POS. ROT DI CONV 1 |

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| --- | --- | --- | --- | --- | --- |
|  | IND.PROXIMITYSENSOR | 2 |  | POS. ROTARY UP | 3 |
|  | CAPACITIVE SENSOR |  | POS. ROTARY DOWN |
|  | POS. INSERT |  | POS. VACUUM ON |
|  | POS. INSERT RETURN |  | PB START | ALL |
|  | POS. EJECT |  |  |  |
|  | POS. EJECT RETURN |  |  |  |
|  | AKHIR CONVEYOR 1 | 2/3 |  |  |  |
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| --- | --- | --- | --- | --- | --- |
| BLOK 0 | KET | M | BLOK 1 | KET | M |
|  | POS. GRIP FORWARD | 5 |  | POS. STOPPER UP | 4 |
|  | POS. GRIP BACKWARD |  | POS. STOPPER DOWN |
|  | POS. GRIP UP |  | WORK POINT |
|  | POS. GRIP DOWN |  | POS. DRILL UP |
|  | POS. FINGER OPEN |  | POS. DRILL DOWN |
|  | POS. FINGER CLOSE |  | AKHIR CONVEYOR 2 | 4/5 |
|  | SENSOR DI MAGAZINE | 2 |  | POS. ROT DI CONV 2 | 3 |
|  | PHOTO SENSOR |  | POS. ROT DI CONV 1 |

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|  | IND.PROXIMITYSENSOR | 2 |  | POS. ROTARY UP | 3 |
|  | CAPACITIVE SENSOR |  | POS. ROTARY DOWN |
|  | POS. INSERT |  | POS. VACUUM ON |
|  | POS. INSERT RETURN |  | PB START | ALL |
|  | POS. EJECT |  |  |  |
|  | POS. EJECT RETURN |  |  |  |
|  | AKHIR CONVEYOR 1 | 2/3 |  |  |  |
|  |  |  |  |  |  |