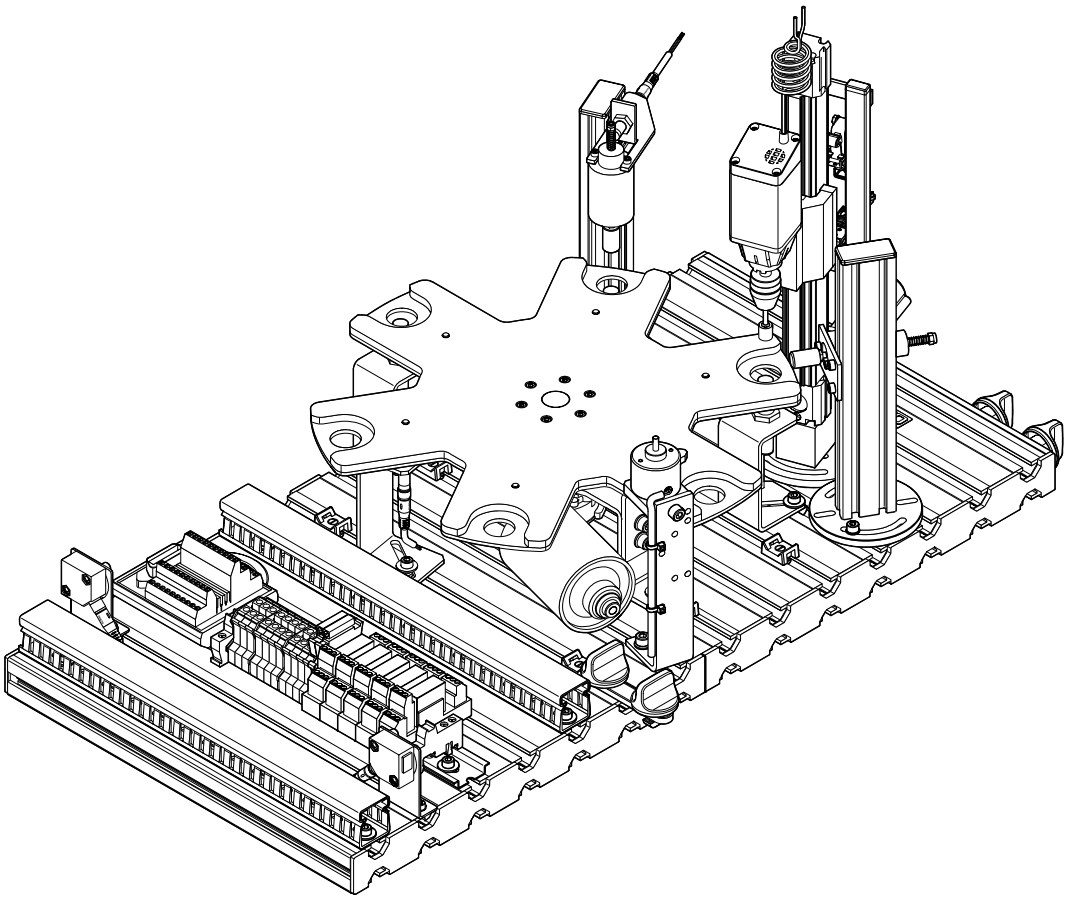
FESTO

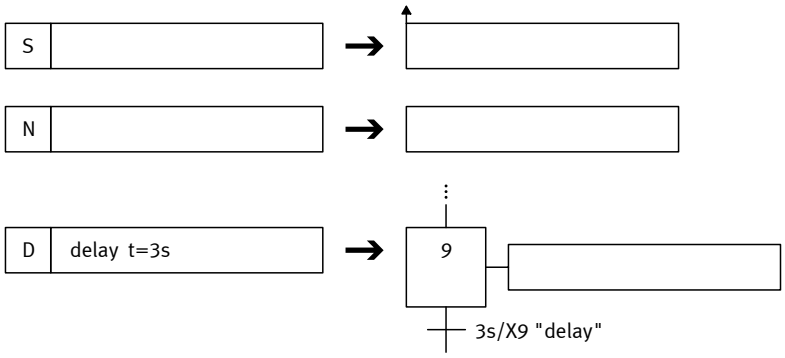
Processing station
Function chart



DE
01/04

Function chart according to DIN EN 60848

The following figure displays a comparison of symbols of DIN 40719-6 (1992-02) and symbols of DIN EN 60848 (2002-12).



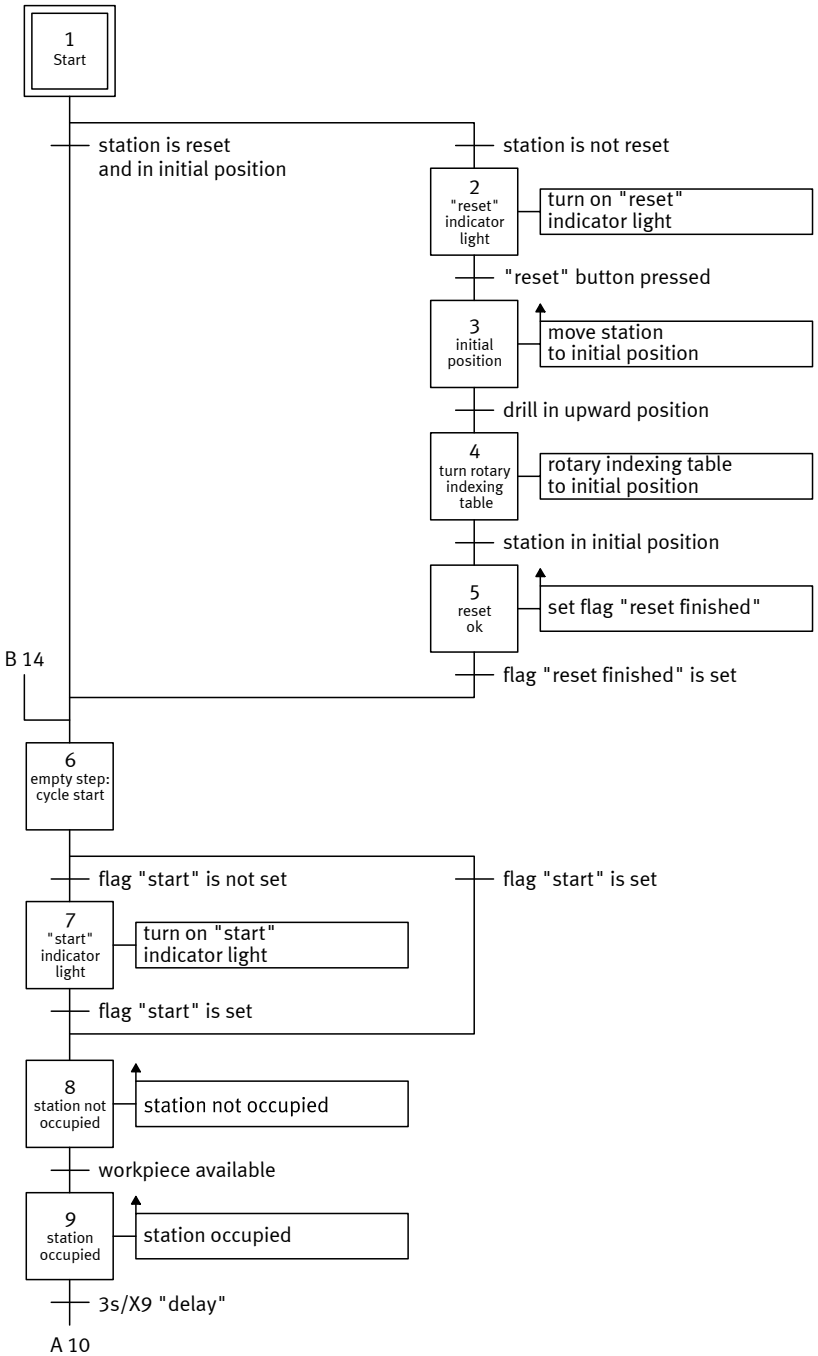
Left: DIN 40719-6; right: DIN EN 60848

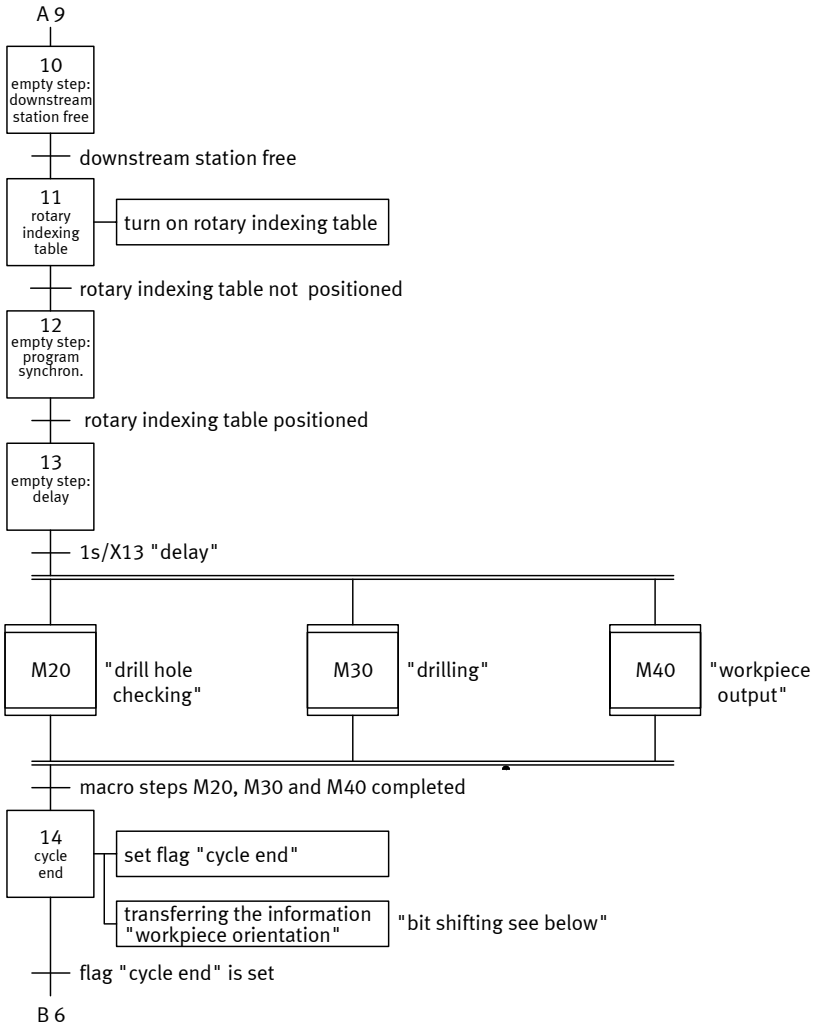
Note
The standard DIN 40719-6 is valid until 2005-04.

DIN 40719-6 1992-02	Diagrams, charts, tables; rules for function charts; (IEC 848 modified)
DIN EN 60848 2002-12	GRAFCET specification language for sequential function charts; (IEC 60848)

Function chart Processing station

sequential function chart according to DIN EN 60848 (IEC 60848) for the Processing station
1-bit-link



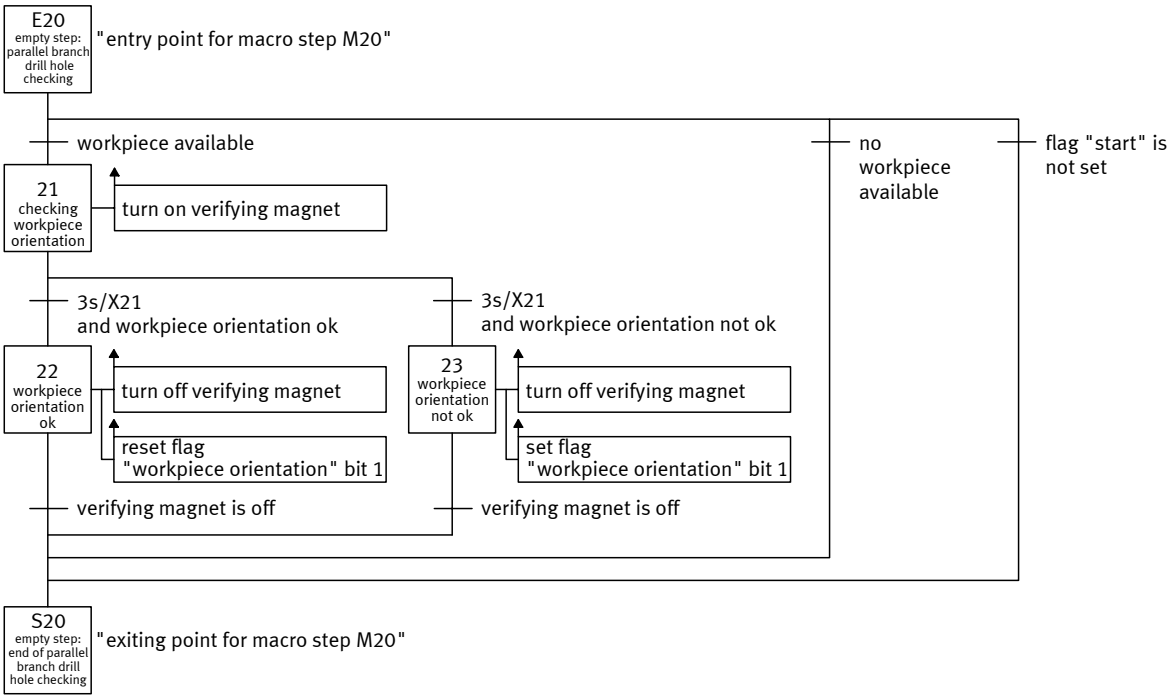


Sample of the bit shifting of flag "workpiece orientation"
After each process the bits and the rotary indexing table are shifted by one step. The information "workpiece orientation ok" (bit = 0) respectively "workpiece orientation not ok" (bit = 1) is acquired during the "dill hole checking" (M20) and is shifted to and used by "drilling" (M30) and "workpiece output" (M40).

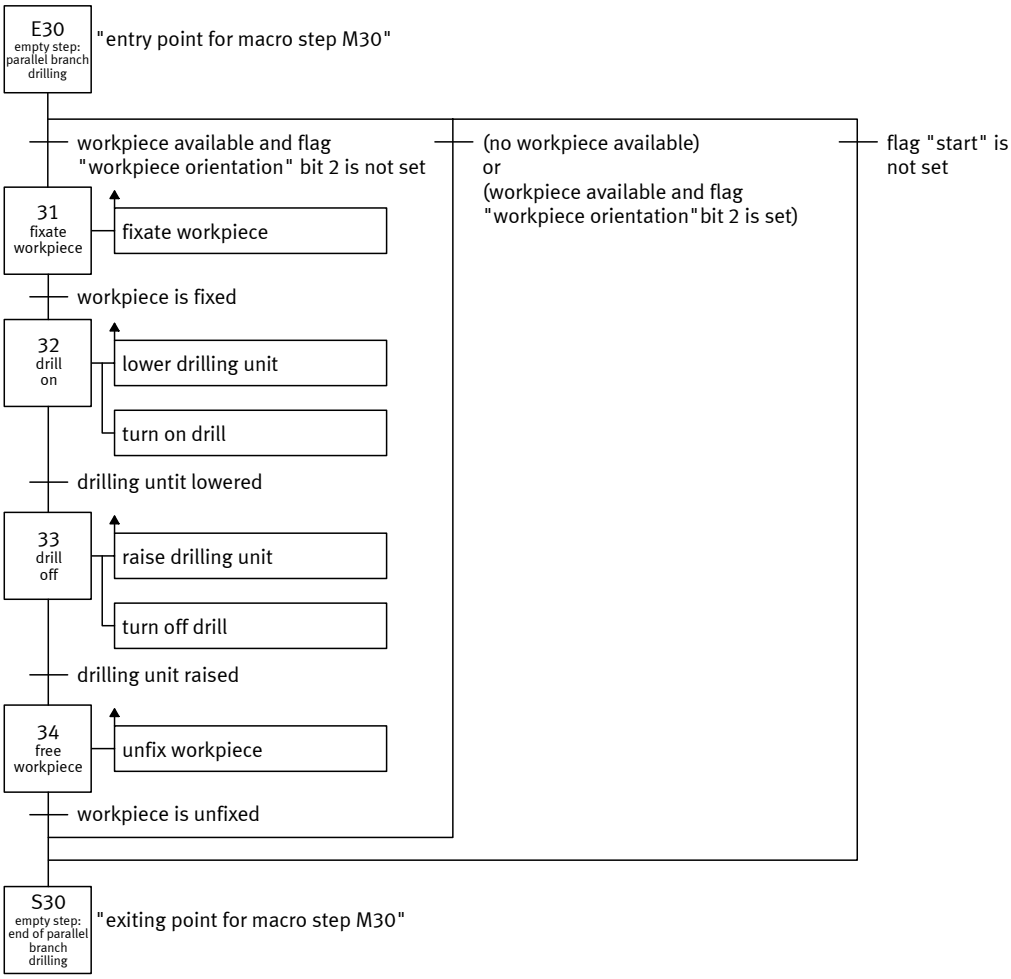
Sequence of inserted workpieces: "A", "B", "C", "D" ... whereas "B" is a bad part.

processing step	**position of the rotary indexing table**			**flag "workpiece orientation" (flag word)**		
	pos. 1 checking	pos. 2 drilling	pos. 3 output	BIT 1	BIT 2	BIT 3
1	–	–	–	–	–	–
2	A	–	–	0	–	–
3	B	A	–	1	0	–
4	C	B	A	0	1	0
5	D	C	B	0	0	1
•	•	•	•	•	•	•
•	•	•	•	•	•	•

macro step M20
"parallel branch drill hole checking"



macro step M30
"parallel branch drilling"



macro step M40
"parallel branch workpiece output"