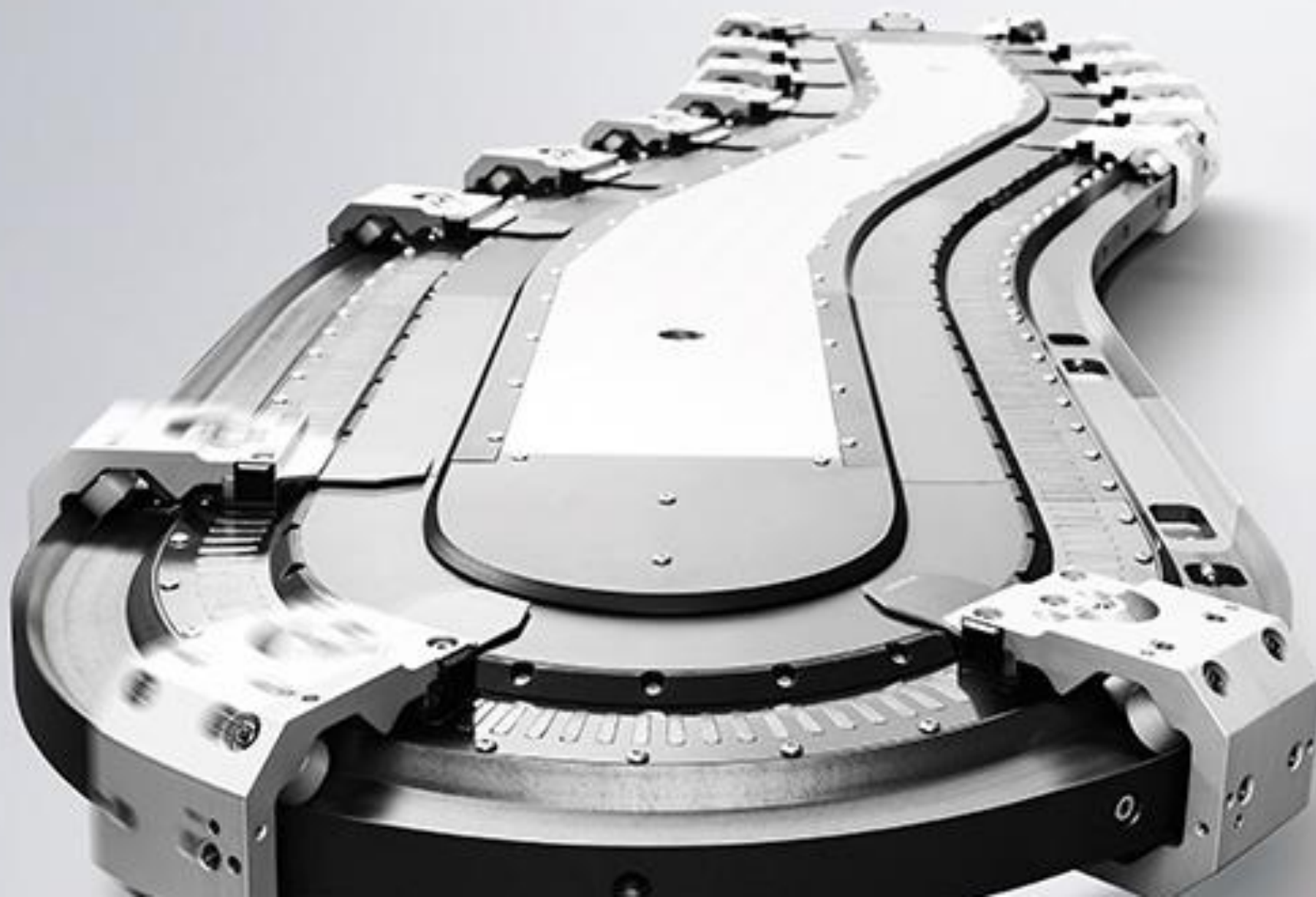


XTS TRANSPORT LAYER – a station based approach

BECKHOFF



1. Introduction
2. Requirements
 - XtsTransport (main control)
 - Xpu (XTS Processing Unit)
 - CaGroup (Collision Avoidance)
 - Mover (MC and CA)
 - Station (process handshake)
3. Design
 - use with any cyclic runtime
 - use with non cyclic software
4. License

1. Introduction

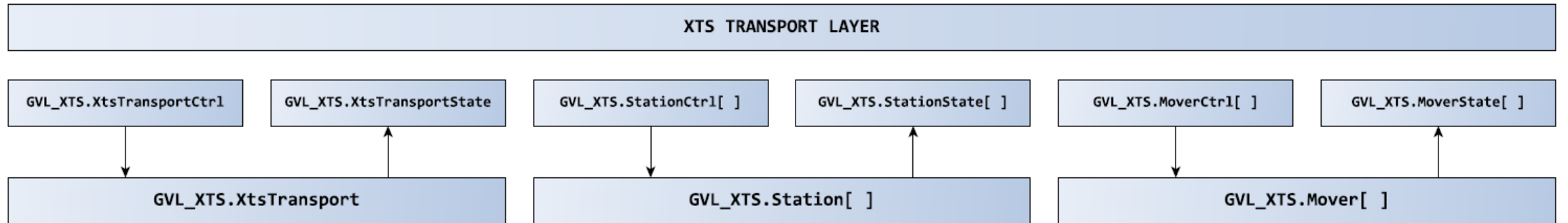
- This project collection is intended to convey the idea of a stand alone XTS transport layer to use in heterogen environments / applications.
- The main idea is that for every process a corresponding position on the xts exists.
- In order to reduce the amount of repetitive work when implementing a XTS into a machine, this project collection may help to put a transport layer in place
- A transport layer shall have an interface for guiding a mover through a process station
- A transport layer shall have an interface to manipulate a mover within a station or for a certain task
- A transport layer shall have an interface for setting-up or clearing the CollisionAvoidance Group

1. Introduction

- The XTS transport system enables a flexible product transport for various processes.
- In combination with the Collision Avoidance library positioning of movers does not require extra monitoring of the axis
- Can be used for a station based approach, in which a station class is available for interaction with your process control
- Can be used for a mover based approach, so your process control has a direct connection to every mover
- Can be used as a combination of station based and mover based approach
- The use of predefined datafields enables you to control XTS Transport Layer through fieldbus or network.
- Use of interface pointers for cross communication between classes.

1. Introduction

- designed for use with extern cyclic or non cyclic flow control
- station based approach with individual targeting of mover
- handshake in station with extern process flow (ST_STATION_CTRL / ST_STATION_STATE)
- individual cyclic mover interface with given set of movement functionalities (ST_MOVER_CTRL / ST_MOVER_STATE)



1. Introduction

Planning requirements for use of fb_Station:

- Put the Modulo turn anywhere, **BUT NOT** within WaitPos, StopPos, ReleaseDistance of a station. The code does not support crossing the modulo turn within a station.
- The Use of LinkedList methods (AddTail, GetHead) requires thought about when the mover is entered into the target station.
- a. parallel stations for a process:
 - P1 uses XTS_STN[1] to XTS_STN[4] → rReleaseDistance of STN[4] shall be shortest, all other stations follow accordingly.
- b. using stations sparsely:
 - In this case it is easiest to always handshake the stations and use the forwarding command if a station shall be skipped: STATION_MOVER_SEND.
- c. deactivating stations:
 - Make sure the queue is empty before deactivating, since the waiting mover will hold up all the others in case of required deactivation while movers are in the queue:
 - handshake mover with E_STATION_CTRL.STATION_MOVER_SEND to new target station
 - Do not send any new mover to the station in question
 - disable station
 - preceeding stations continue workflow with changed ST_STATION_CTRL.nTargetStation

1. Introduction

Planning requirements for use of fb_Station:

- know thyself
 - all coordinates are modulo values, from station to station only forward, within station limits backward movement by use of negative nest offset or use of ST_MOVER_CTRL.
- IF move backwards you have to make sure that there is room for it
--> distance between PosWait and PosStop

- XtsTransport
 - Access to CA group function blocks (interface pointer)
 - Access to Stations (interface pointer)
 - Access to Movers (interface pointer)
 - Cyclic interface for access from extern control
 - Ctrl (write): command
 - State (read): response to command
 - information from Xpu
 - Information from CA Group

- Xpu (XTS Processing Unit)
 - Check Init Parameter
 - Check Online Parameter
 - Get Module Info Data
 - Connect TcCOM Objects to instances from XTS_Utility.lib function blocks
 - Cyclic plausibility checks
 - Mover ID detection after init
 - Cyclic interface for access from main control
 - Ctrl (write): command
 - State (read): response to command
 - Info (read): details from cyclic checks

- CaGroup
 - Access to group function blocks
 - Access to movers for group commands
 - Get Group Info Data
 - Implements interface pointer

- Mover
 - Access to MC function blocks
 - Access to CA function blocks
 - Cyclic interface for access from extern control
 - Ctrl (write): command
 - Data (write): command parameter
 - State (read): response to command
 - Interface pointer for access from:
 - TransportUnit
 - Station

- Station
 - Handshake mover transport with extern control
 - Close observation of movements with feedback to extern control
 - List for movers in queue
 - Cyclic interface for access from extern control
 - Ctrl (write): command and parameter
 - State (read): response to command and information about mover and queue
 - Uses Mover interface pointer

- Namespace GVL_XTS
 - **Station**
 - Handshake with Process for mover transport
 - **XtsTransport**
 - Main command interface to extern control
 - **XpuCtrl**
 - Access to TcCOM Objects
 - Cyclic plausibility checks
 - **CaGroup**
 - Access to CA library
 - **MoverCtrl**
 - Access to MC and CA library

<<global>> GVL_XTS	
StationStart	ST_STATION_PARAMETER
Station	ARRAY [1..MAX_STATION] OF fb_Station
StationList	ARRAY [1..MAX_STATION] OF fb_Station_LinkedListCtrl
StationQueue	ARRAY [1..MAX_STATION] OF ARRAY [1..MAX_LIST_NODES] OF ST_STATION_MOVER_DATA
StationListIf	ARRAY [1..MAX_STATION] OF I_Station_LinkedList
StationCtrlIf	ARRAY [1..MAX_STATION] OF I_XtsTransport_Station
StationCtrl	ARRAY [1..MAX_STATION] OF ST_STATION_CTRL
StationState	ARRAY [1..MAX_STATION] OF ST_STATION_STATE
StationParameter	ARRAY [1..MAX_STATION] OF ST_STATION_PARAMETER
PositionOffset	ARRAY [1..MAX_STATION] OF T_NEST_OFFSET
XtsTransport	fb_TransportUnit
XtsTransportCtrl	ST_XTS_TRANSPORT_CTRL
XtsTransportState	ST_XTS_TRANSPORT_STATE
Xpu	fb_XpuCtrl
XpuCtrl	ST_XPU_CTRL
XpuState	ST_XPU_STATE
XpuInfo	ST_XPU_INFO
XpuModules	ARRAY [1..MAX_MODULE] OF Tc3_XTS_Utility.ST_InfoDataView
CaGroup	FB_CaGroup
CaGroupIf	I_XtsTransport_CaGroup
CaGroupRef	Tc3_McCoordinatedMotion.AXES_GROUP_REF
CaGroupInfo	ST_GROUP_INFO
Mover	ARRAY [1..MAX_MOVER] OF fb_MoverCtrl
MoverCtrl	ARRAY [1..MAX_MOVER] OF ST_MOVER_CTRL
MoverState	ARRAY [1..MAX_MOVER] OF ST_MOVER_STATE
MoverIf	ARRAY [1..MAX_MOVER] OF I_XtsTransport_Mover
LastPosition	ARRAY [1..MAX_MOVER] OF LREAL
LastGap	ARRAY [1..MAX_MOVER] OF LREAL
MoverInfo	ARRAY [1..MAX_MOVER] OF ST_MOVER_INFO
MoveData	ARRAY [1..MAX_MOVER] OF ST_MOVE_DATA
GearData	ARRAY [1..MAX_MOVER] OF ST_GEAR_DATA
AxisRefMover	ARRAY [1..MAX_MOVER] OF Tc2_MC2.AXIS_REF

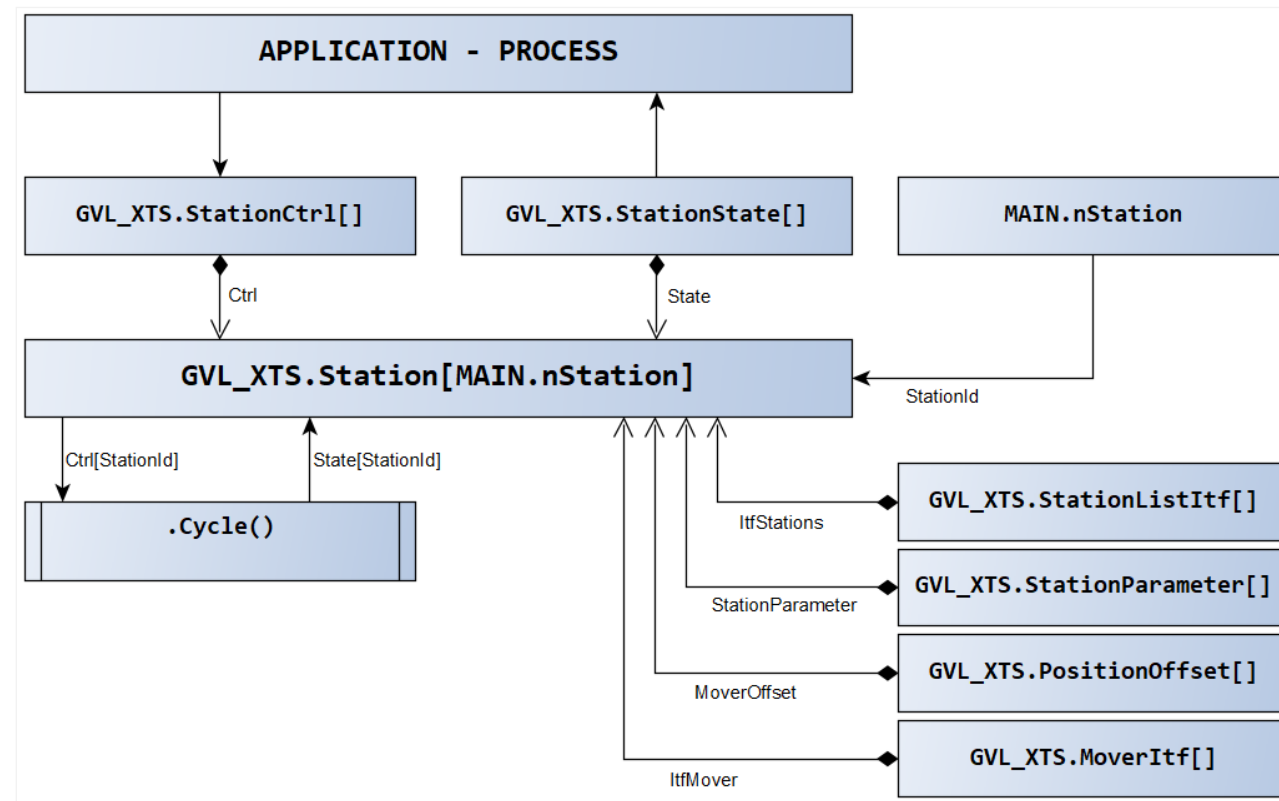
3. Design

- GVL_XTS.Station
 - fb_Station[].Cycle
 - State machine for handshaking with extern control
 - Init (clears everything in station)
 - Enable
 - Mover Enter
 - Stop Position(s)
 - Mover Out
 - Empty
 - Control writes ticket for mover
 - MoverId
 - TargetStation
 - Mask
 - Offset

fb_Station	
_nStationId	UINT
_sState	STRING(255)
_eInitList	E_PROGRESS
_eFatalError	E_STATION_STATE
_stCtrl	REFERENCE TO ARRAY [1..MAX_STATION] OF ST_STATION_CTRL
_stState	REFERENCE TO ARRAY [1..MAX_STATION] OF ST_STATION_STATE
_stStationCtrl	ST_STATION_CTRL
_stStationState	ST_STATION_STATE
_lItfStation	REFERENCE TO ARRAY [1..MAX_STATION] OF I_Station_LinkedList
_lItfMover	REFERENCE TO ARRAY [1..MAX_MOVER] OF I_XtsTransport_Mover
_rMoverOffset	REFERENCE TO ARRAY [1..MAX_STATION] OF T_NEST_OFFSET
_stParameter	REFERENCE TO ARRAY [1..MAX_STATION] OF ST_STATION_PARAMETER
_Mover	REFERENCE TO ARRAY [1..MAX_MOVER] OF AXIS_REF
_stListEnter	ST_STATION_LIST_RESULT
_stListTarget	ST_STATION_LIST_RESULT
_stListDelete	ST_STATION_LIST_RESULT
_stMoverDataSend	ST_STATION_MOVER_DATA
_stMoverData	ST_STATION_MOVER_DATA
_stMoveData	ST_MOVE_DATA
_Result	E_PROGRESS
_eState	E_PROGRESS
_nNest	UINT
_nMoverDetected	UINT
_nMoverInStation	UINT
_nTargetStation	UINT
_ix	UINT
_rModActPosFetch	LREAL
_stMsg	ST_Message
_eMessageLevel	E_MessageType
Ctrl	REFERENCE TO ARRAY [1..MAX_STATION] OF ST_STATION_CTRL {property}
lItfMover	REFERENCE TO ARRAY [1..MAX_MOVER] OF I_XtsTransport_Mover {property}
lItfStations	REFERENCE TO ARRAY [1..MAX_STATION] OF I_Station_LinkedList {property}
MessageLevel	e_messageType {property}
Mover	REFERENCE TO ARRAY [1..MAX_MOVER] OF AXIS_REF {property}
MoverOffset	REFERENCE TO ARRAY [1..MAX_STATION] OF T_NEST_OFFSET {property}
State	REFERENCE TO ARRAY [1..MAX_STATION] OF ST_STATION_STATE {property}
StationId	UINT {property}
StationParameter	REFERENCE TO ARRAY [1..MAX_STATION] OF ST_STATION_PARAMETER {property}
Check()	BOOL
Cycle()	
DelBitWord(...)	WORD
GetBitWord(...)	BOOL
Init()	e_progress
LogState(...)	
MoveData()	
MoverOut()	
SetBitWord(...)	WORD

3. Design

- GVL_XTS.Station
 - nStation index is passed as value from caller
 - Global datafields are passed as references (REF=) into fb_Station properties
 - Ctrl / State: handshakes
 - ItfStations: interface pointer to linked list methods for getting and setting of mover data
 - StationParameter: Coordinates and dynamic constraint of XtsStation
 - MoverOffset: correction values for every mover in every station with every nest (StopPos[])
 - ItfMover: interface pointer to CA movements



- GVL_XTS.Station
 - Ctrl[nStation] : ST_STATION_CTRL
 - eCmd :
 - enumeration for handshakes with State[nStation].eState
 - nMask :
 - bit mask to be used with multiple stop positions within a XtsStation.
This mask tells the target station which StopPos[] (nest) has to be worked.
 - nTargetStation :
 - target to send mover to GVL_XTS.Station[nTargetStation].WaitPos
 - rOffset :
 - Optional offset for mover, used in target station in addition to static offset

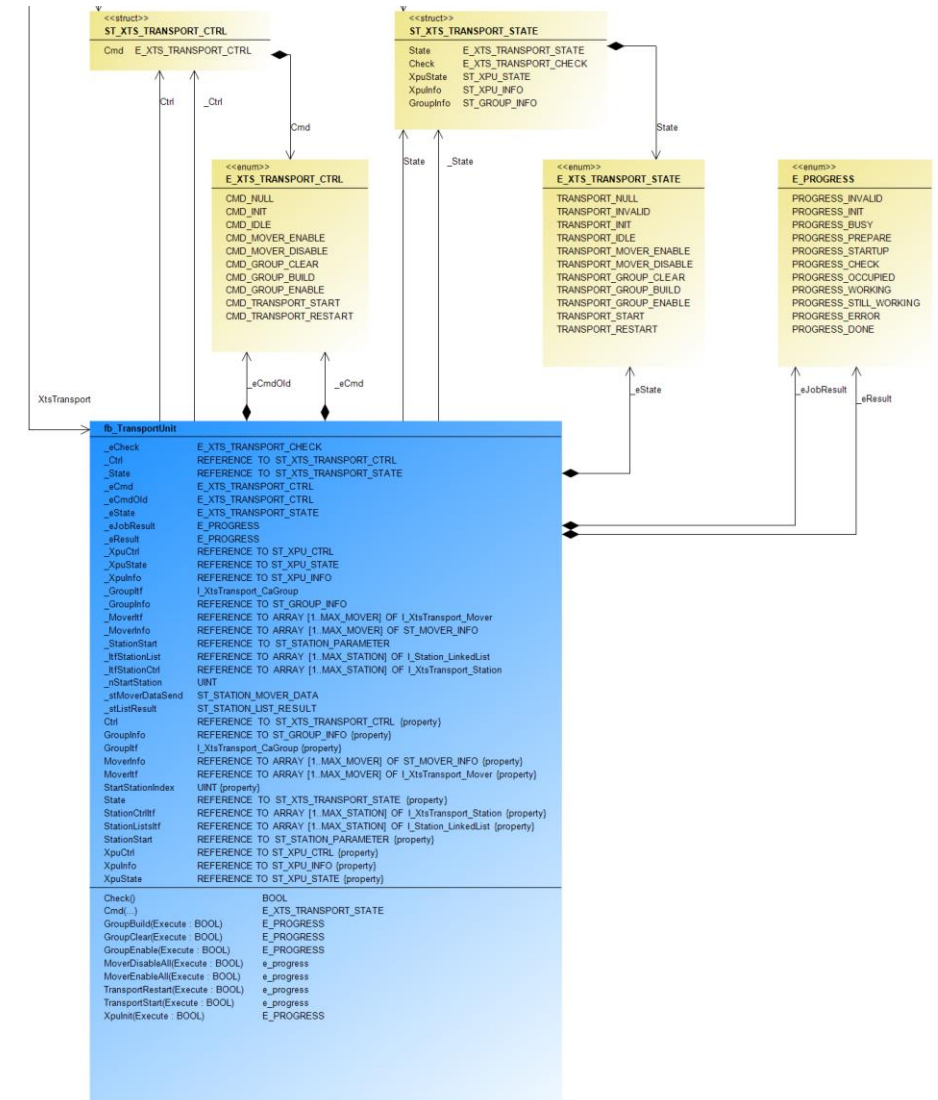
- GVL_XTS.Station
 - State[nStation] : ST_STATION_STATE
 - eState :
 - Enumeration for active station state, Ctrl has to react to
 - nMask :
 - Bitmask for active PosStop[] (nest)
 - nMoverId :
 - Active mover index in station
 - rMoverModPos :
 - Modulo position of active mover
 - nQueue :
 - Count of movers, which were sent to XtsStation

- GVL_XTS.StationParameter
 - sText :
 - Description only
 - rPosWait :
 - start of station, a sending station is using this value to send mover to
 - rReleaseDistance :
 - distance mover has to travel (from ActPos) in order for station to go back to mover detection
 - rGap :
 - Active gap on infeed and outfeed of station
 - rVelo :
 - Active velocity on infeed and outfeed of station
 - rAccDec :
 - Active dyn constraint
 - rJerk :
 - Active dyn constraint
 - nConfiguredStopCount :
 - Count of PosStop (nests) a mover has to stop at in XtsStation
 - rPosStop[] :
 - Relative to rPosWait

3. Design

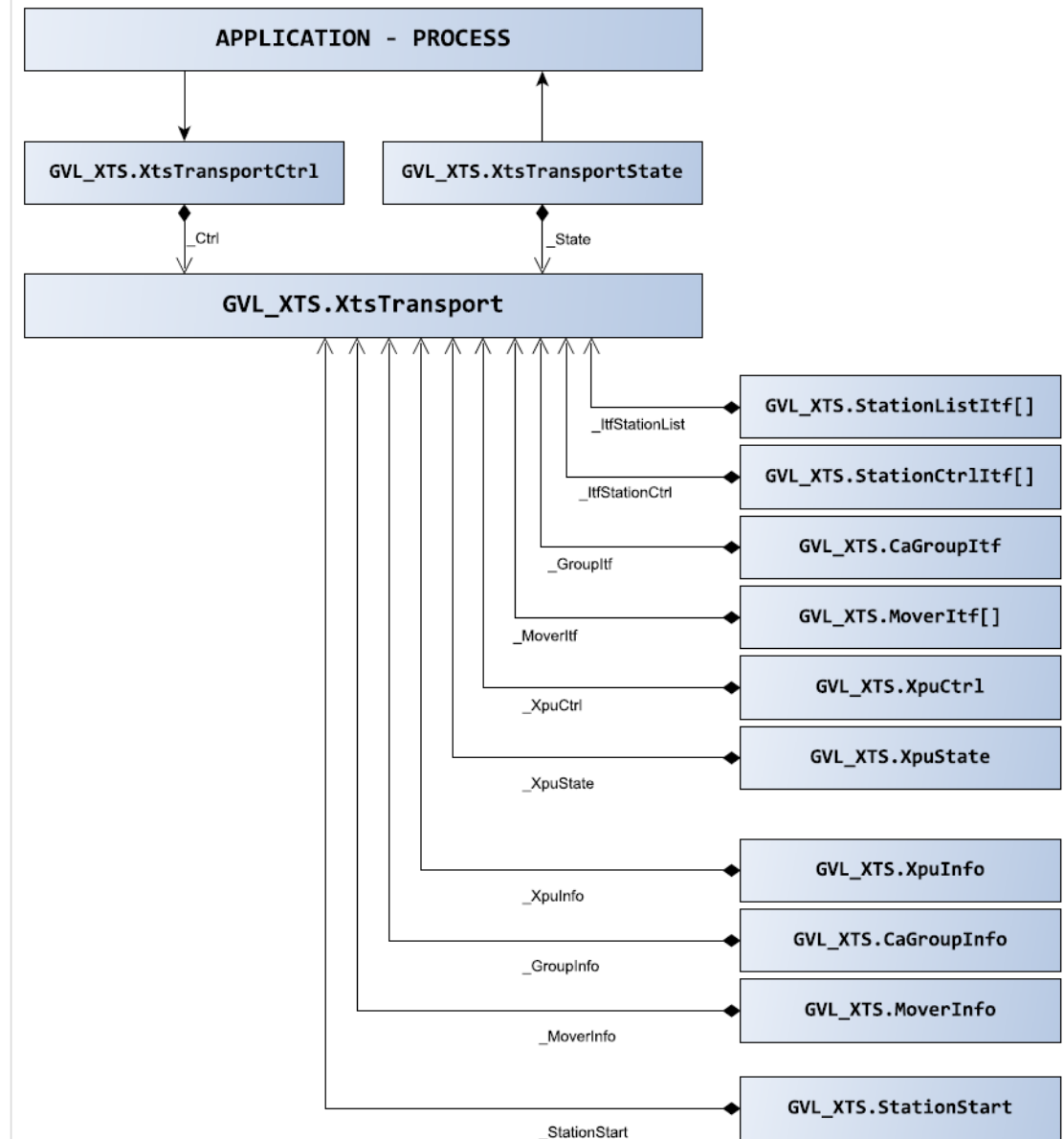
■ TransportUnit

- Fb_TransportUnit():
 - Top level control of XtsTransport
 - Cycle check for change of command:
 - E_XTS_TRANSPORT_CTRL.
 - CMD_INIT
 - CMD_IDLE
 - CMD_MOVER_ENABLE
 - CMD_MOVER_DISABLE
 - CMD_GROUP_CLEAR
 - CMD_GROUP_BUILD
 - CMD_GROUP_ENABLE
 - CMD_TRANSPORT_START



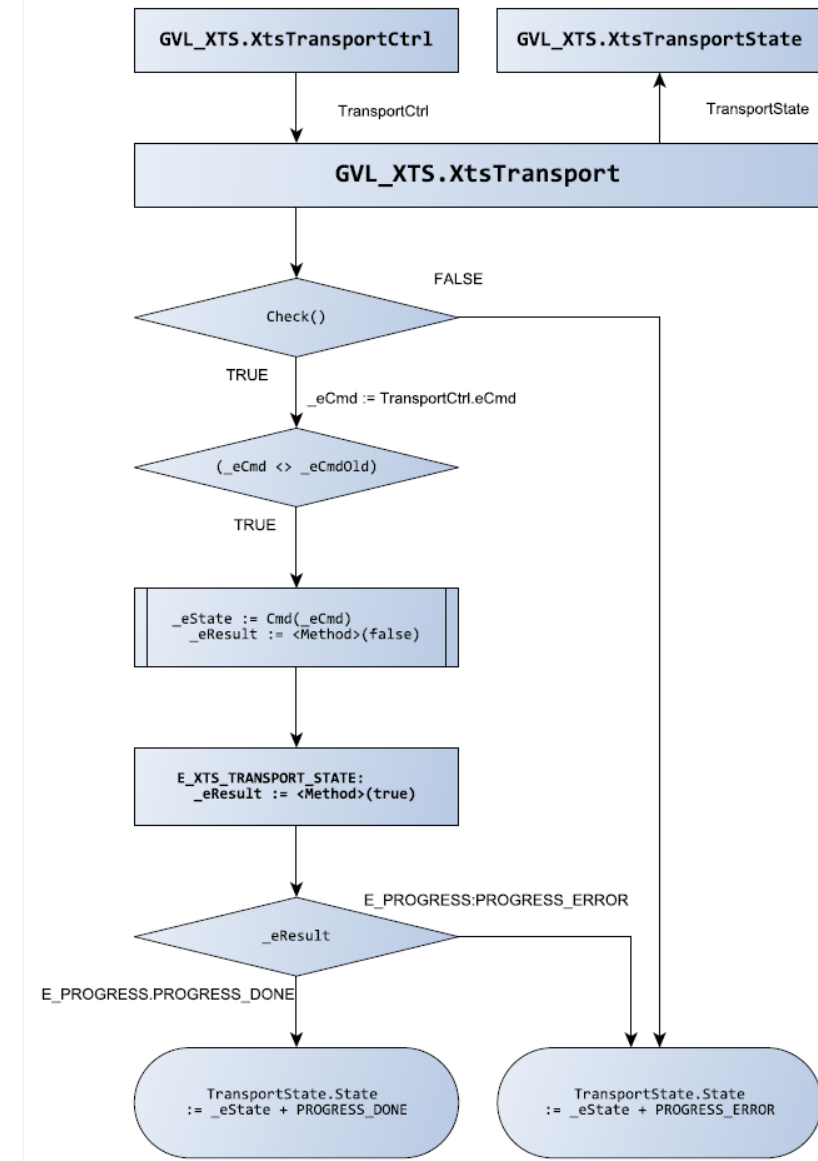
3. Design

- TransportUnit
 - Fb_TransportUnit():
 - Members:



3. Design

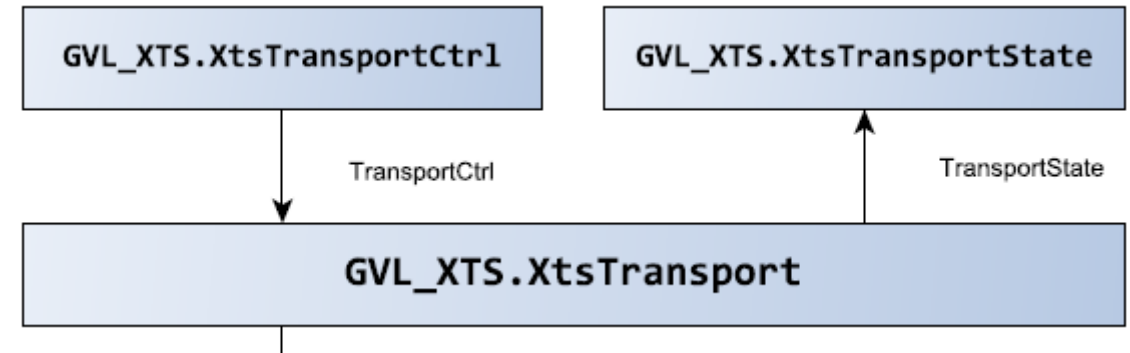
- TransportUnit
 - Fb_TransportUnit():
 - Change of command triggers execution
 - Execution result is added to state
 - Extern control needs to react to BUSY, DONE or ERROR



3. Design

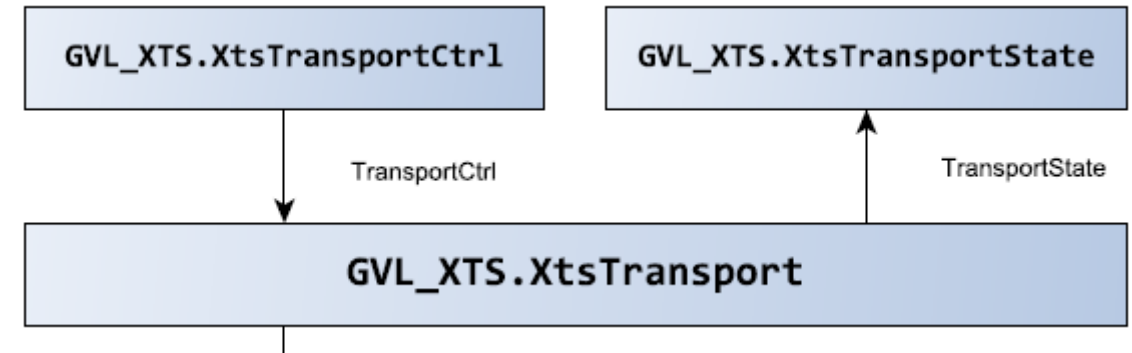
- TransportUnit
 - GVL_XTS.XtsTransportCtrl:
ST_TRANSPORT_UNIT_CTRL
 - Struct for commanding
FB_TransportUnit
 - eCmd : E_XTS_TRANSPORT_CTRL

```
ST_XTS_TRANSPORT_CTRL  ▢ ×  
1  TYPE ST_XTS_TRANSPORT_CTRL :  
2  STRUCT  
3      Cmd      : E_XTS_TRANSPORT_CTRL;  
4  END_STRUCT  
5  END_TYPE  
6
```



3. Design

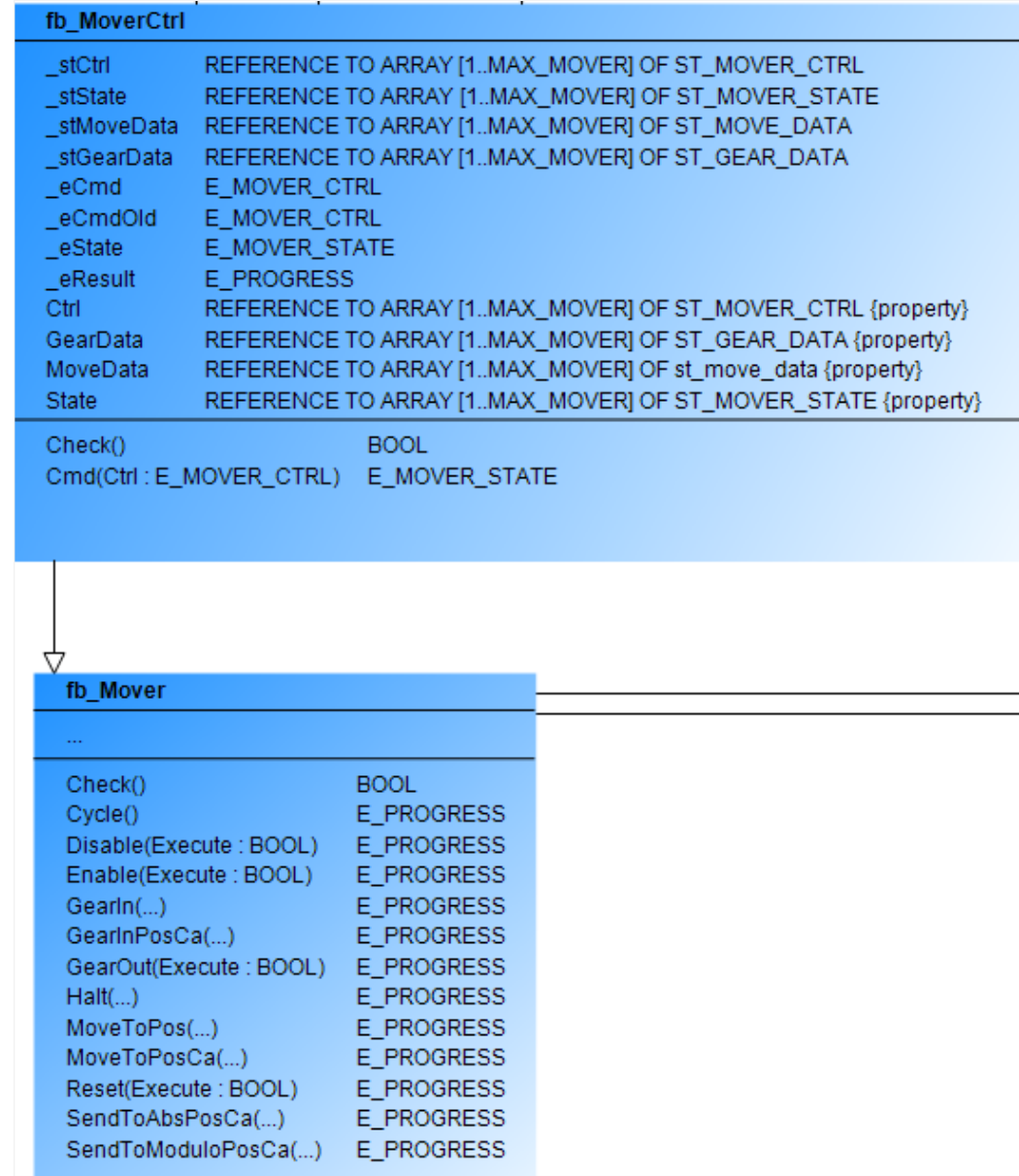
- TransportUnit
 - GVL_XTS.XtsTransportState:
ST_TRANSPORT_UNIT_STATE
 - State: combines active command and result
 - Check: cyclic pointer checks
 - XpuState: state from fb_Xpu
 - XpuInfo: cyclic plausibility checks to
TcCOM Objects
 - GroupInfo: cyclic information from
FB_CaGroup



```
ST_XTS_TRANSPORT_STATE -> X
1 {attribute 'pack_mode' := '2'}
2 TYPE ST_XTS_TRANSPORT_STATE :
3 STRUCT
4     State      : E_XTS_TRANSPORT_STATE;
5     Check      : E_XTS_TRANSPORT_CHECK;
6
7     XpuState    : ST_XPU_STATE;
8     XpuInfo     : ST_XPU_INFO;
9     GroupInfo   : ST_GROUP_INFO;
10 END_STRUCT
11 END_TYPE
12
```

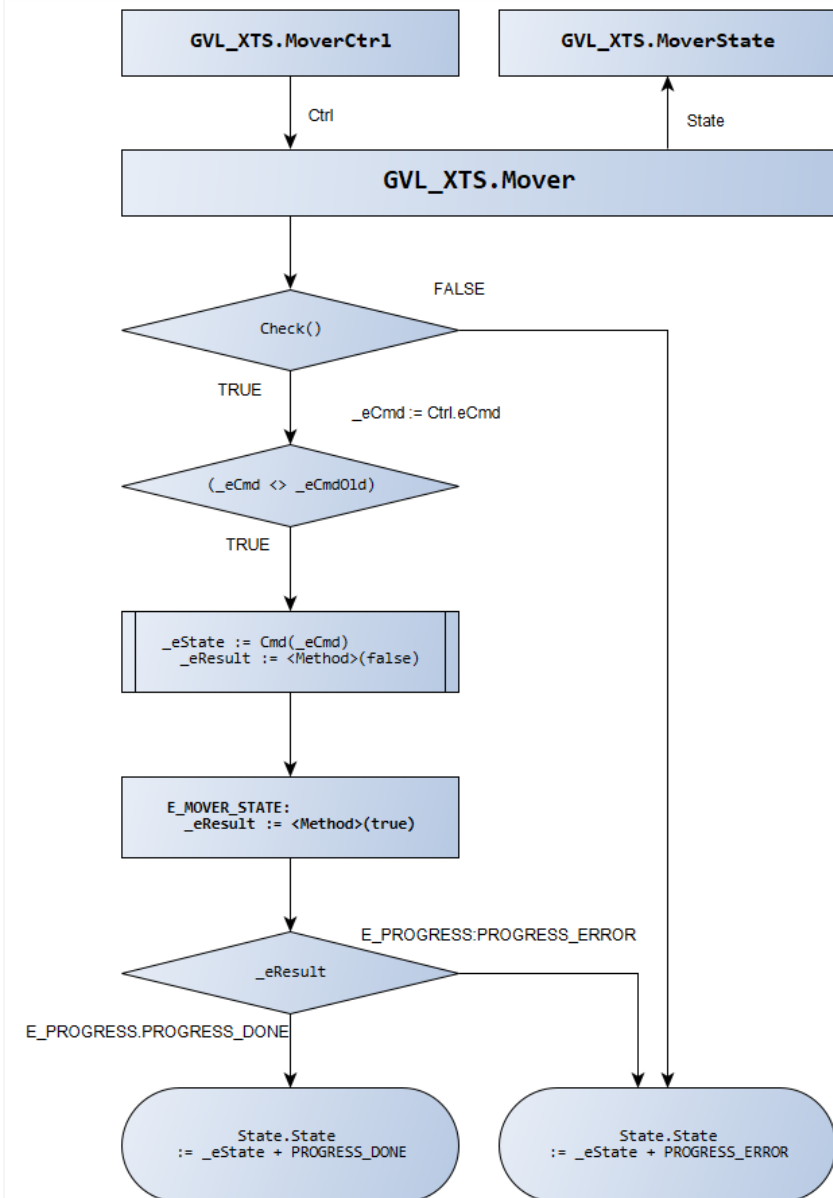
3. Design

- fb_MoverCtrl:
 - Inherits fb_Mover
 - Access to MC function blocks in library
 - Implements Interface for use in other classes
 - Contains cyclic interface
 - Ctrl datafield for setting commands
 - State data field for checking responses
 - Parameter datafields for using motion functions



3. Design

- fb_MoverCtrl:
 - Mover index is passed as value from caller
 - Global datafields are passed as references (REF=) into fb_MoverCtrl properties
 - Ctrl / State: handshakes
 - standard return value for method
 - Log LastPosition on CA/MC function execute
 - Log LastGap on CA function execute



XTS_TRANSPORT_LAYER project

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