GVL_XTS.Station[StationId].Cycle() Example_2: handshake for a mover with NO required stop - init was already done at machine startup - default state after STATION_INIT is STATION_DISABLE check states are not displayed here only the states you have to handshake are displayed error handling, you find in other flow charts in the [doc] folder Ctrl[StationId].nTargetStation must be set by you before releasing the mover! RETURN; Check() **FALSE** TRUE State[nStationId].State E_STATION_STATE.STATION_DISABLE: Ctrl[nStationId].eCmd == E_STATION_CTRL.STATION_ENABLE TRUE State[nStationId].State When station is asking for a mover to enter, the Mover ID is copied onto State[nStationId].nMoverId E_STATION_STATE.STATION_MOVER_ENTER: Mover may still be on its way; IF you handshake early, the mover does not stop at WaitPos StationParameter[nStationId].ReleaseDistance may also be negative, this helps fetching the next mover only 4 PLC cycles later. Ctrl[nStationId].eCmd == E_STATION_CTRL.STATION_SEND E_STATION_STATE.STATION_MOVER_OUT: Ctrl[nStationId].eCmd == E_STATION_CTRL.STATION_MOVER_OUT **TRUE** E_STATION_STATE.STATION_MOVER_GONE: Ctrl[nStationId].eCmd == E_STATION_CTRL.STATION_MOVER_GONE State[nStationId].State := E_STATION_STATE.STATION_DISABLE