


Zagazig University, Faculty of Engineering,
Mechatronics Program

ZuKa

Deployment of industrial KUKA robot in CNC machining and visual servoing through Kinect interfacing on ROS

Graduation project for the degree Bachelor of Science (B.Sc.) submitted to Mechatronics Program, Faculty of Engineering, Zagazig University, Egypt

by

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July, 2017

Graduation Project Report submitted to
Zagazig University, faculty of Engineering, Mechatronics Program, Zagazig, Egypt
in partial fulfillment of the requirements for the degree
Bachelor of Science in Engineering (**B.Sc.**)
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Date of Presentation
16. July 2017

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Revision SVN.198.50.20170713

In memory of **Ahmed Emam**

Abstract

The first industrial revolution marked the transition to new manufacturing processes in eighteenth century, which is arguably similar to the transition introduced by the use of robotic manipulators in different industrial aspects in the late twentieth century. This project is motivated by the major developments in the industrial sector thanks to robots, especially in machining processes. Robots offer more flexibility, cost reduction and higher level of details, all of which are essential characteristics to any successful industry. Although these characteristics can be obtained by conventional CNC machines, however, the level and rate of production differ on larger scales, in favor of the robots.

The main problem can be summarized in Four points; accuracy, ease of use, flexibility and safety, and the solution to these problems defines the scope of our project. As for accuracy, it is obtained by implementing the robot itself, which offers multiple-axes movement, enabling the possibility for higher level of details than the conventional CNC machines. Ease of use is demonstrated in the user-friendly robot interface that enables the implementation of projects easily and without the need to multiple machines or tasks to deliver the final results. Flexibility is provided through the multiple programmable interfaces that offer multiple methods of control; Inline programming through KUKA's smartPAD, offline programming through converting G-codes from CAD files into KRL and ROS. Safety is increased in the work space of the robot by introducing a vision based safety system that reduces the robot's operating speed when someone enters this work space.

The results of the aforementioned methods and applications are diverse, offering milling in multiple dimensions and thus widening the scope of final products. In addition to introducing further control methods, which opens up new doors towards further developments and applications that were not applicable earlier.

Acknowledgements

We would like to express our deepest appreciation to all those who provided us the possibility to complete this project, most importantly, our deepest gratitude goes to KUKA AG, as without their Robots, our project would have never seen the light .

A special gratitude goes to our final year project supervisors, Prof. Ahmed Hamdy and prof. Mohamed Nour Abdelgawad, whose contributions in stimulating suggestions and encouragement, helped us to coordinate our project, especially in writing this report.

Furthermore I would also like to acknowledge with much appreciation the crucial role of the staff of Zagazig university's Mechanical Engineering department, who gave the permission to use all required equipment and the necessary materials to complete our project. We appreciate the guidance given by the supervisors as well as the panels especially in our project presentation that has improved our presentation skills thanks to their comment and advices.

This work was partially funded by Zagazig University. We would like to thank the funders. They had no role in study design, data collection and analysis, decision to publish, or preparation of this work.

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"There is nothing more difficult to take in hand, more perilous to conduct or more uncertain in its success than to take the lead in the introduction of a new order of things."

— Niccolo Machiavelli, (Italian writer and statesman, Florentine patriot, author of 'The Prince', 1469-1527)

Chapter 1
Introduction

Industrial robots are reshaping the present and future of most, and very soon all, industrial aspects. They are currently used in a broad spectrum of industries, some of which include car parts assembly as in BMW and Mercedes factories, industrial automation as in Yaskawa factories, metal industries that include welding and machining processes and many others. While there is a controversial part in replacing humans with robots in factories, it, nevertheless, offers more accuracy and higher production rate with more space for development. The growth of the Global Industrial Robotics Market is driven by many factors, of which the need to reduce manufacturing cost in industries is one of the main drivers. Industrial robotics aids companies in reducing the cost due to product failure and product wastage.

Some of the pioneering companies in the Industrial robotics market are ABB Ltd., Fanuc Corp., Yaskawa Electric Corp., Apex Automation and Robotics, Mistubishi Electric Corp. and KUKA AG. We had the opportunity to work with the latter, KUKA AG, on the implementation of our project (*ZuKa: Deployment of the industrial KUKA robotic manipulator in CNC machining and visual servoing through Kinect interfacing on ROS*). Over the course of our final year, this project helped increase our knowledge, not only on the main topic, machining and visual servoing, but also on the KUKA platform itself, which is considered an advanced platform widely used in today's industries.

The project is inspired by the aforementioned development in the industrial sector. The scope of the project can be summarized in the following three points; firstly, the commissioning and operation of the KUKA KR6 R900 sixx robotic manipulator, which included the installation of the related software and creating a network that facilitates communications with the robot. In addition to software commissioning, hands-on experience with the KUKA robot language (KRL) platform was achieved through learning the basic and advanced forms of KRL, which later helped in the development of software tools that facilitates the main objective of the project; the milling process.

Secondly, the design and manufacturing of a base to support the robot during heavy

duty operation, this included performing mathematical calculations based on the robot's weight and forces to obtain the optimal dimensions and weight for the base, besides performing CAD studies on the manipulator's body to support the results of the mathematical analysis.

Finally, the development of various software tools to achieve the purposes of remotely controlling the robot and milling. These tools include an Inkscape extension for converting 2D G-code to KRL, directly using sketches from Inkscape, an independent toolkit for converting 3 axis G-code to KRL. In addition to Python tools; one Python class for reading and writing system variables, and a Python library for controlling the arm motions from pc. The development also included editing openni_tracker for publishing uncalibrated person's depth and creating ROS nodes for safety operation distance and visual servoing (hand guiding) for the robot.

Initially, the project scope was limited to the milling process in addition to minor ideas in the smart development of the workspace, however, over the course of the semester we encountered many problems that required extended research in all the previously mentioned aspects, which eventually led to broadening the scope of the project to include these development tools, both relevant and irrelevant to milling.

1.1 Project Contributions

The results of the project studies and implementation include, but not limited to;

- The manufacturing of the robot's base, with mathematically calculated data endorsed by CAD studies, contributing in a stable, secure and robust base that can support the weight of the robot and tolerate the forces resulting from the robot's motion without major failure or errors.
- The attachment and operation of a pneumatic gripper, leading to the development and implementation of software tools for drawing and palletizing.
- The development of different software tools to obtain the appropriate KRL codes used in the milling process.
- The development of a safety system in the robot's workspace, similar to KUKA AG's own Collision detection, which stops thee robot from moving when it hits a solid surface. However, being more efficient and safe, in terms that it does not require actual contact or collision but significantly reduced the operation speed of the robot when someone enters a defined perimeter of the robot's workspace. This is achieved using a Microsoft Kinect device for obtaining visual input of the workspace.

The results of the work exceeded both the preset expectations and goals for the project, resulting in a wide variety of applications and an extension in our own knowledge base, which is the most important achievement.

just some text for text

1.2 overview

some data

1.2.1 Flower Power

Figure 1.1: This is a test figure. You can use it as a template for your figures

"It is impossible for us, who live in the latter ages of the world, to make observations in criticism, morality, or in any art or science, which have not been touched upon by others. We have little else left us but to represent the common sense of mankind in more strong, more beautiful, or more uncommon lights."

— Joseph Addison, (English essayist, poet, and politician, 1672–1719), Spectator, No. 253

Chapter 2
CAD Analysis Approach

For the purpose of our study, SolidWorks was used as a CAD software, as it contains solid modelling, Motion studies, Simulation PhotoView 360, e-drawing and many other features that were used to obtain a complete CAD model for KR6 r900 sixx KUKA arm. In Simulation and Analysis, you can test your designed product in real environment.In simulation process the model can be tested against parameters like static and dynamic response, fluid dynamic, heat transfer. It also supports thermal, fatigue, structural and motion analysis.
In our project, SolidWorks is used to obtain a CAD model for KR6 r900 sixx and to perform a motion analysis study on the model. In addition to designing a base to fix the robot arm, perform a stress analysis and creating an animation video of the model's motion.

2.0.1 Complete CAD model

2.0.1.1 Searching for a suitable model

All CAD models for KR6 r900 sixx on KUKA website or GrabCAD were step imported parts which are treated as a one body where joints can't rotate therefore, motion study can't be performed because it was impossible to add motors at the robot joints. The solution for this issue was obtained by converting step parts into assembly, which is done through several steps:

- Open the .stp file part in SOLIDWORKS. Select the file type to be .stp
- Click the OPTIONS tab, select Import multiple bodies as parts and click OK.
- Then click Open.

SolidWorks will create an assembly and create an individual part file for each multibody (Part1,Part2,Part3 etc.)

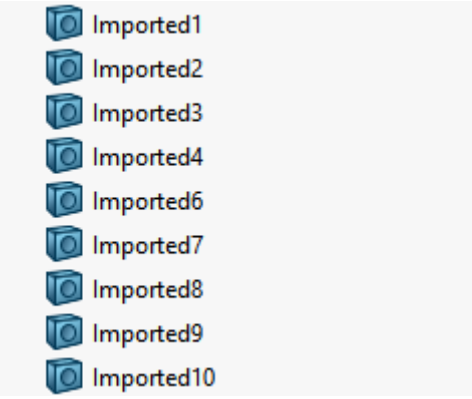


Figure 2.1: Step parts

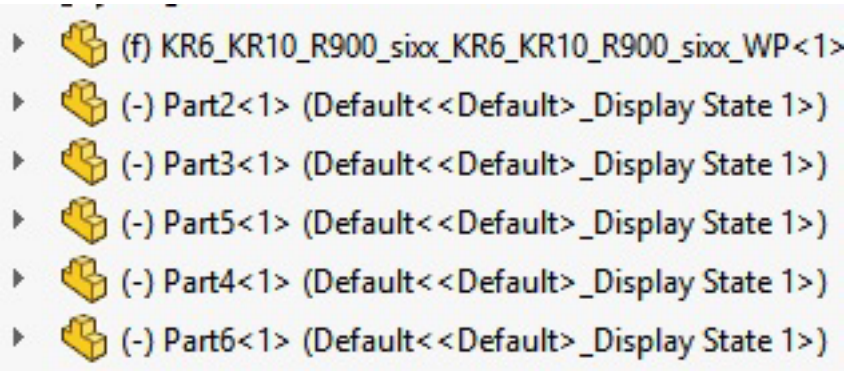


Figure 2.2: SolidWorks parts

2.0.1.2 Modifications on CAD model

Material and weights The robot material wasn't specified and the model was a whole body, and the total mass for the robot was 33.74 Kg, which was not accurate, because the actual mass of the robot, according to the KR6 R900 sixx dimensions manual, must be approximately equal to 52Kg. This is achieved by making the model hollow, using the shell feature and adding to joins point masses similar to the real motors with mass approximate equal to motors masses.

Spindle In order to have a complete model for our graduation project, a router spindle and its holder were sketched to complete the existing KUKA model.

Figure 2.3: KUKA motors

2.0.2 Motion studies

Motion studies are graphical simulations of motion for assembly models. They simulate and animate the prescribed motion for a model. SolidWorks offer three different types of motion study, Animation, Basic Motion and Motion Analysis. They also offer mate controller that show, save the positions of assembly components at various mate values and degrees of freedom and create simple animations between those positions.

Animation can be used to animate the motion of assembly. If you simply wish to create some nice visuals for presentation or marketing without consideration of mass and gravity effects, then animation is for you.

Basic Motion is an extra layer of complexity that takes into consideration the effects of mass, motors, springs, contact, and gravity on assemblies.

Motion Analysis is the top tier of motion study provides accurately simulation and analyze the motion of an assembly while incorporating the effects of Motion Study

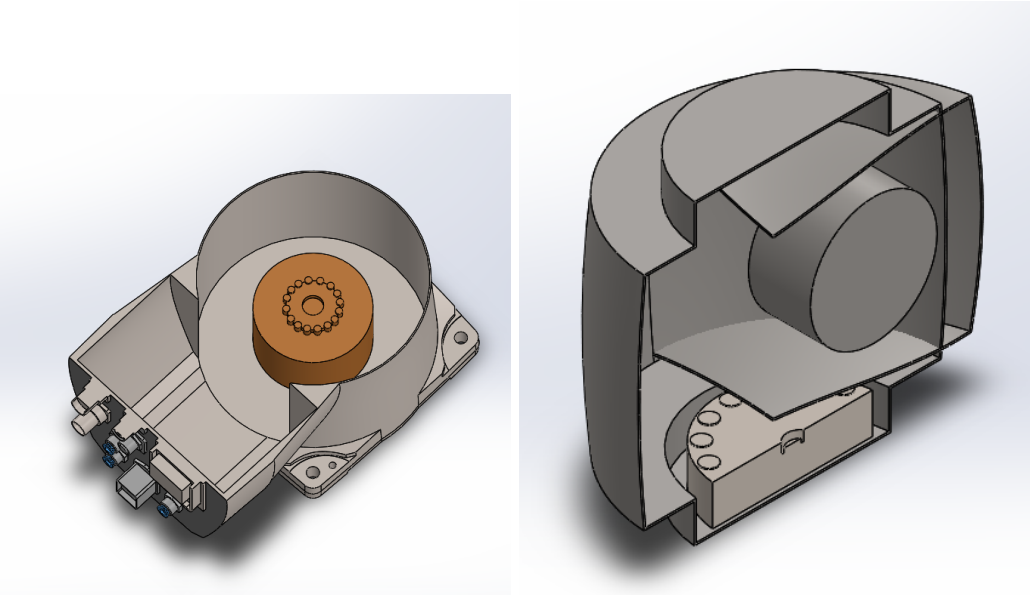


Figure 2.4: Motors 1,2 and 3 , 4,5 and 6 models

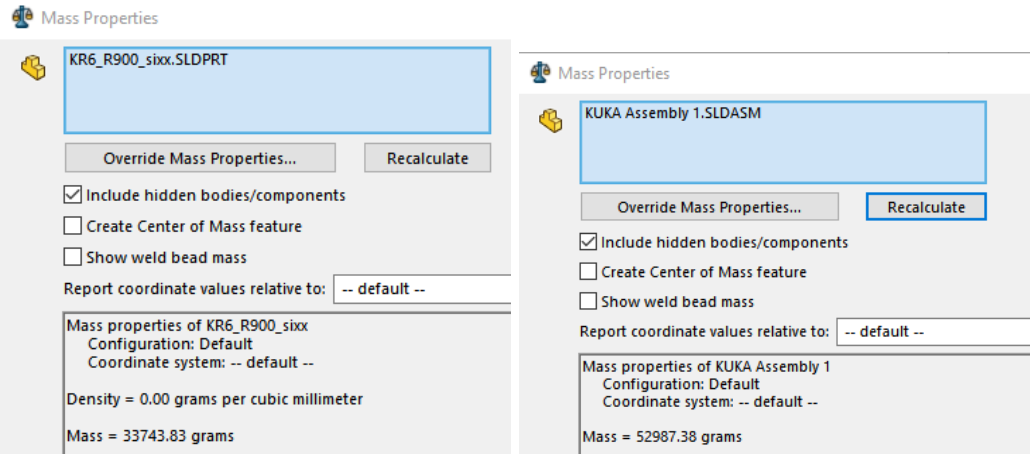


Figure 2.5: The model mass: Old mass and final mass

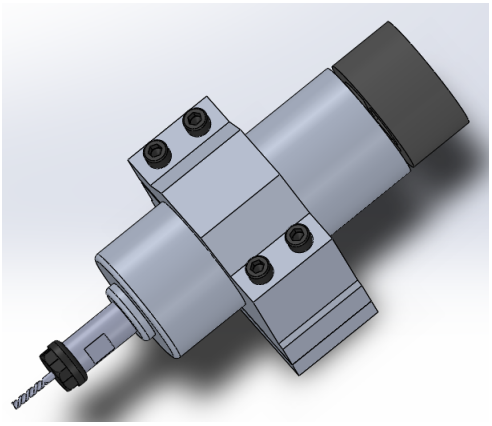


Figure 2.6: Spindle model

elements (including forces, springs, dampers, and friction). Motion Analysis can also be used to plot simulation results for further analysis.

Therefore, Motion Analysis is used to simulate the model, generating results and plots of the simulation and Animation is used to make a video for motion.

2.0.2.1 Animation study

Animation study is done to make an animation video of the moving parts with the use of limit mates. Limit angle mate is an advanced mate type that is performed by selecting two planes which rotate with respect to each other giving the desired range to mate and input a maximum and minimum value for the angle to specify the desired range of motion. Another advantage of limit angle is that it prevent collision between the moving parts.

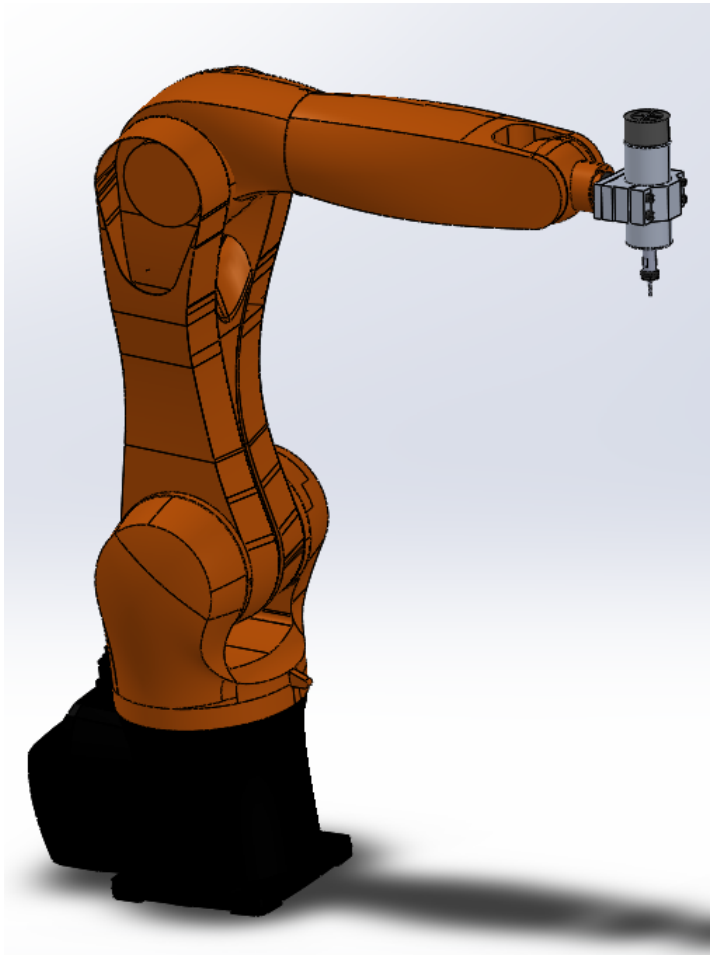


Figure 2.7: Final CAD model

2.0.2.2 Motion analysis

On implementing motion analysis by adding a motor at the required location to start simulating the robot, a problem arose; the model exploded on running the simulation where some of the parts were separated from each other. This happened because of redundancy constrains. For Motion Analysis studies, having redundant mates is the equivalent of over-defining the model.

Axis	Range of motion, software-limited	Speed with rated payload
1	+/-170°	360 °/s
2	+45° to -190°	300 °/s
3	+156° to -120°	360 °/s
4	+/-185°	381 °/s
5	+/-120°	388 °/s
6	+/-350°	615 °/s

Figure 2.8: Axes range of motion

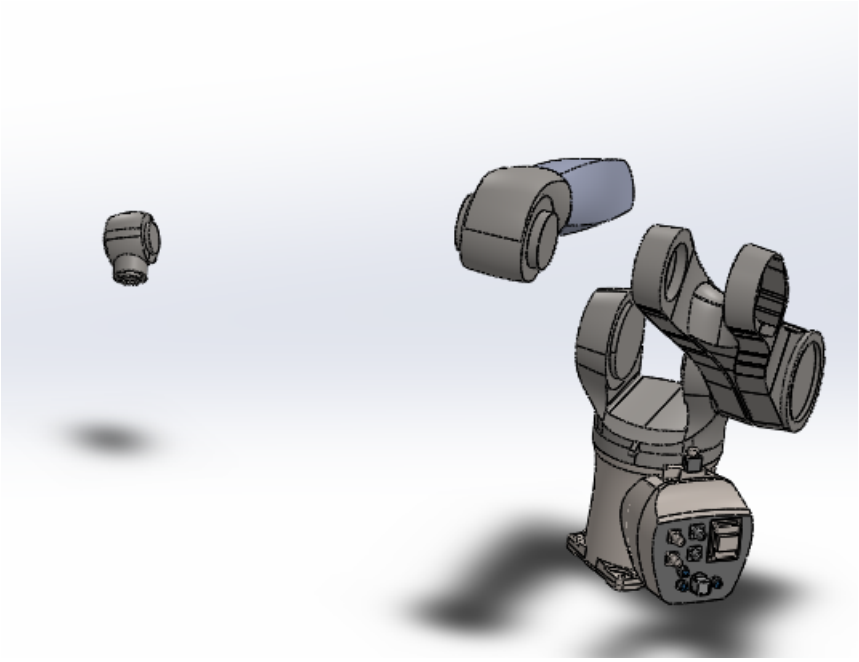


Figure 2.9: Redundancy constraint problem

This issue was solved by using mechanical mates of hinge type instead of standard mates. Hinge mate limits the movement between two components to one rotational degree of freedom. It has the same effect as adding a concentric mate plus a coincident mate and also limit the angular movement between the two components by adding limit angles. Reducing the negative effect of redundant mates on analysis.

Now motors can be added to the model to perform any motion and results as motor torque, velocity, acceleration and force are generated.

Results of motion analysis study] By assigning a motor to simulate the motion of axis and plotting the results to achieve this motion we found:

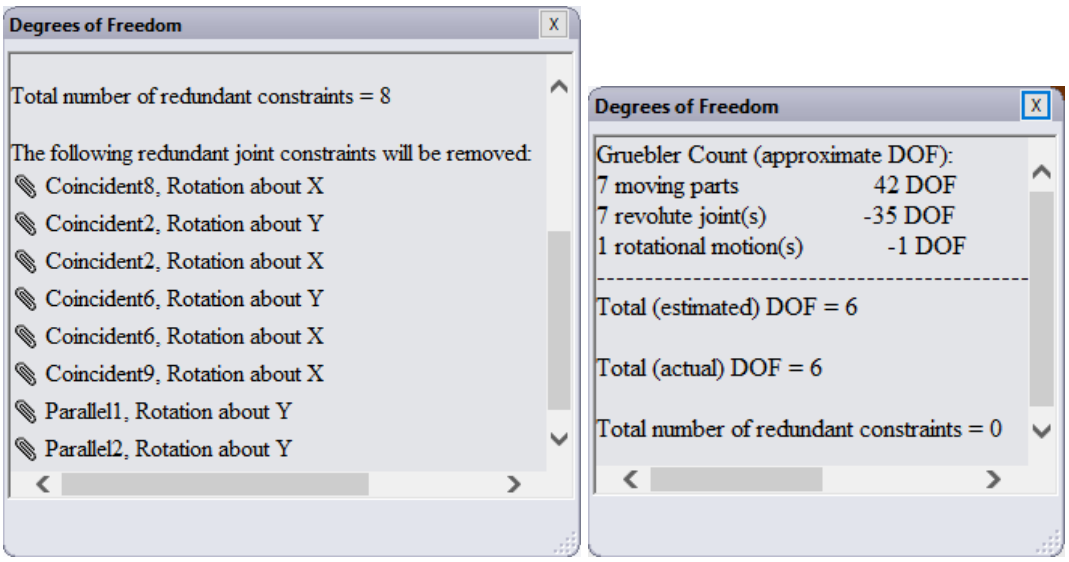


Figure 2.10: present of redundancy constrains and Zero redundant constraints

- Results of motor torque for axis 1 to move 100 degrees in 4 seconds:

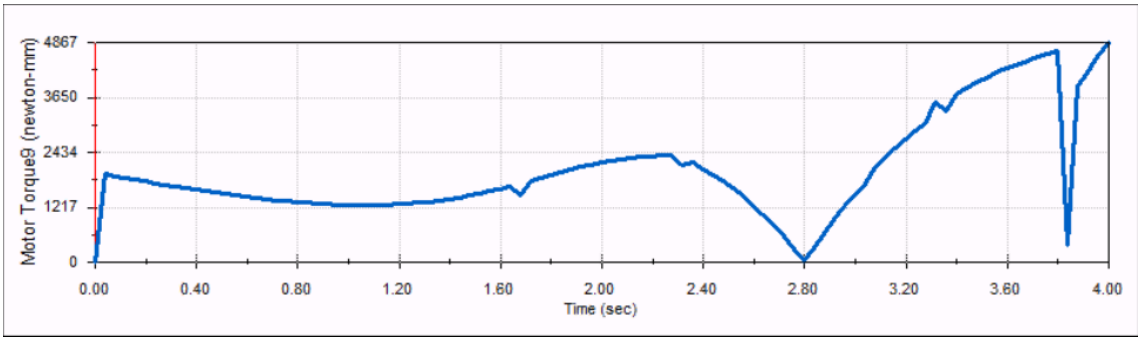


Figure 2.11: Motor 1 torque

Knowing that the actual motor torque for axis 1 is 4.5 N.m so the motion analysis result is approximate to actual torque.

Motor torque vary with time because of the motion of the links beyond the motor which has an effect on the torque by changing the loads carried by the motor.

- Motor 2 torque to move 60 degrees in 2 seconds:

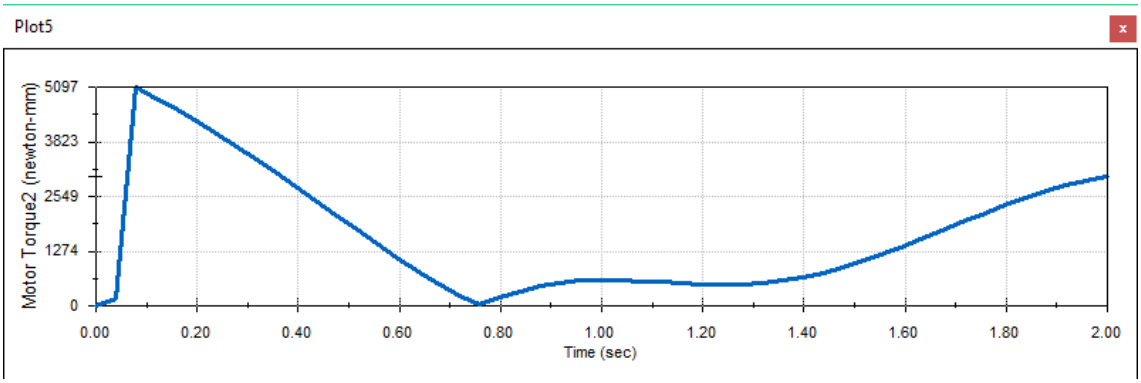


Figure 2.12: Motor 2 torque

Where the actual motor torque is 4 N.m

- Motor torque for axis 3 to move 75 degrees in 1.8 seconds:

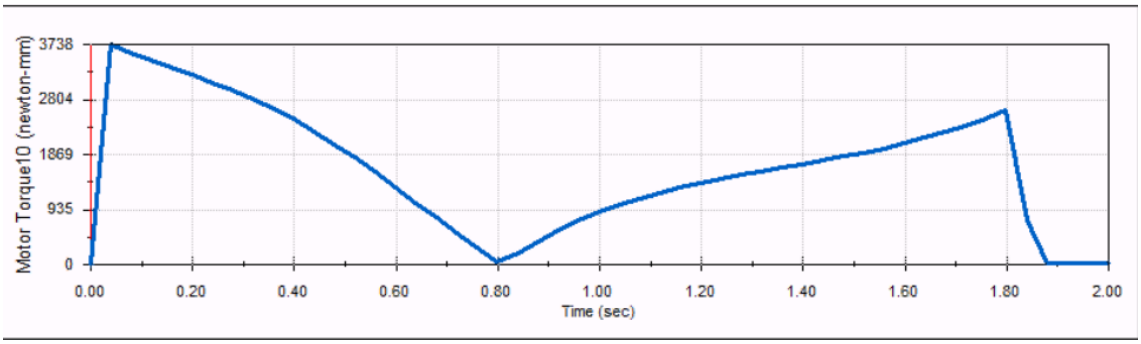


Figure 2.13: Motor 3 torque

Knowing that the actual motor torque for axis 3 is 3.5 N.m so the motion analysis result is approximate to actual torque.

Trace path Motion analysis results and plots have a trace path option that can trace the path of a point in the assembly. The selected point is end mill vertex to create the curve feature that represent the motion of the links. By assigning a data point motors to the joints whose data is imported from excel spreadsheet of file type .csv containing two columns, first represent time in seconds while other is degrees of rotation. The generated curve of adding this data to joints 1-5 is an arc shape.

	A	B
1	0	0
2	1	10
3	2	20
4	3	30
5	4	40
6	5	50
7	6	60
8	7	70
9	8	80
10	9	90

Figure 2.14: Used data point

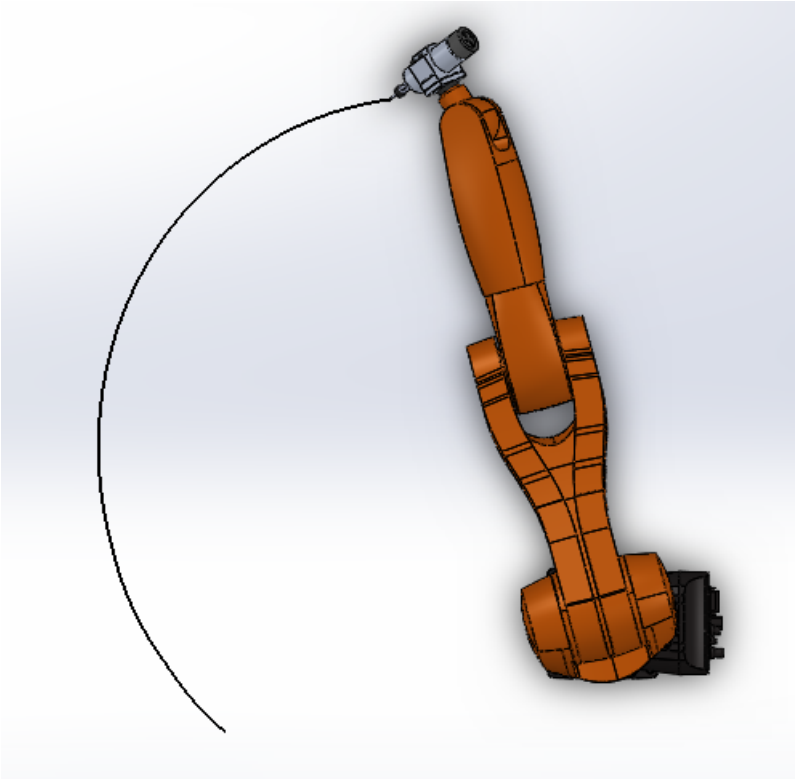


Figure 2.15: Created curve

2.1 Refrences

- `http://www.engineersrule.com/motion-studies-and-how-to-do-them`
- SolidWorks help
- SolidWorks forums

- Specification manual
- Dimensions manual
- https://robotics.stackexchange.com/questions/10256/dynamic-torque-simulation-for

"A computer would deserve to be called intelligent if it could deceive a human into believing that it was human."

— Alan Turing, (British pioneering computer scientist, cryptanalyst,···, and philosopher, 1912–1954)

Chapter 3
Robotic Operating System (ROS)

Recently, robotics community witnesses excessive progress. In Spite of this progress, It still undergo complexity and significant challenges to the software developers; One of the main reasons for this issue is handling the wide variation in tasks and environments of robot systems by an individual. ROS -Robot Operating System- is the flexible framework that makes robot software developing is more robust and accessible by robotics community. The official description of ROS is: "ROS is an open-source, meta-operating system for your robot. It provides the services you would expect from an operating system, including hardware ab- straction, low-level device control, implementation of commonly-used func- tionality, message-passing between processes, and package management. It also provides tools and libraries for obtaining, building, writing, and running code across multiple computers."

3.1 Modularity

The core of successive software algorithm is the ability to reuse in different projects without reimplementing. Modularity is an important Software principle. It divides complex systems into manageable and simpler modules ROS adds value to the most robotics projects and applications because of it Modularity, so you can use ROS as much as you desire and still implement your own parts.

3.2 Distributed Nature

Communication between multiple process is the key to powerful system. ROS provides an integration point that able to manage hardware, drives, development tools, useful libraries, simulators and much more. A ROS distribution is a set of ROS software packages that can be downloaded to your computer.

3.3 Road Map to ROS development

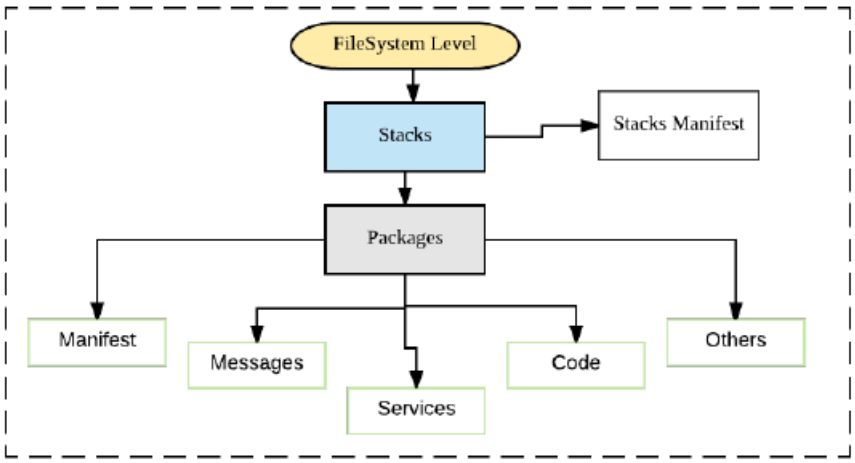
3.3.1 Filesystem Level

The filesystem level explains how ROS files are organized on the hard disk.ROS program is divided into folders, and these Folders has some files that describe their functionality

label description

Packages A package might contain ROS nodes, a ROS-independent library, a dataset, configuration files, a third-party piece of software, or anything else that logically constitutes a useful module.

Figure 3.1: Filesystem level representation



ROS Package tools To create, modify, or work with packages, ROS gives us some tools for assistance

Command	Function
`rospack`	This command is used to get information or find packages in the system
`roscreate-pkg`	creating new package with your own dependencies
`rosmake`	This command is used to compile package
`rosdep`	This command installs system dependencies of a package
`rxdeps`	This command is used if you want to see the package dependencies as a graph

Table 3.1: ROS Package commands

Stacks Packages in ROS are organized into ROS stacks.the main goal of stacks is to ease the process of sharing codes.

Messages Nodes communicate with each other by publishing messages to topics. A message is a simple data structure, comprising typed fields. Standard primitive types (integer, floating point, boolean, etc.)

Services ROS uses simplified service description language for describing ROS service types. This builds directly upon the ROS msg format to enable request/response communication between nodes. Service descriptions are stored in .srv files.

3.3.2 Computaional Graph Level

The basic Computation Graph concepts of ROS are: nodes, Master, Parameter Server, messages, services, topics, and bags, all of which provide data to the Graph in different ways.

- Nodes: Nodes are processes where computation is done. A system better has many nodes to control different functions. Nodes are written with ROS client library; roscpp, or rospy.
- Master: ROS Master is the part that facilitates all the communication between nodes.You should allow the master to continue running for the entire time that you're using ROS.
- Parameter Server: The Parameter Server gives us the possibility to have data stored using keys in a central location.
- Messages: The Parameter Server gives us the possibility to have data stored using keys in a central location.
- Topics: Messages are organized into topics. Nodes that need to listen to certain messages will **subscribe** to the topics that it is interested in, or if the node wants to share it is information, the node will **publish**to an appropriate topic.

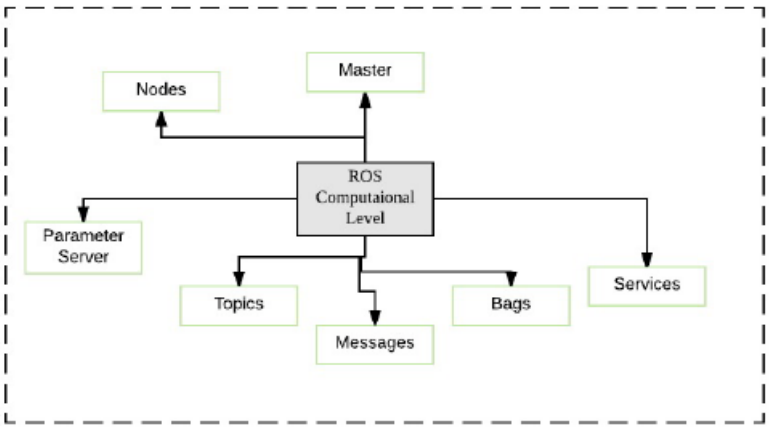


Figure 3.2: Filesystem level representation

3.3.3 Community Level

The third level is the Community level where you can find useful resources and interact with different developers to exchange knowledge, algorithms, and softwares. The official description of ROS Community level resources:

- *Distributions: ROS Distributions are collections of versioned stacks that you can install. Distributions play a similar role to Linux distributions: they make it easier to install a collection of software, and they also maintain consistent versions across a set of software.*
- *Repositories: ROS relies on a federated network of code repositories, where different institutions can develop and release their own robot software components.*
- *The ROS Wiki: The ROS community Wiki is the main forum for documenting information about ROS. Anyone can sign up for an account and contribute their own documentation, provide corrections or updates, write tutorials, and more.*
- *Bug Ticket System: Please see Tickets for information about file tickets.*
- *Mailing Lists: The ros-users mailing list is the primary communication channel about new updates to ROS, as well as a forum to ask questions about ROS software.*
- *ROS Answers: A Q and A site for answering your ROS-related questions.*
- *Blog: The Willow Garage Blog provides regular updates, including photos and videos.*

ROS tutorials `wiki.ros.org/ROS/Tutorials`

3.4 Using Sensors with ROS: Kinect

Figure 3.3: Kinect Xbox 360 with RGB Camera, Depth Camera, and Microphone array

3.4.1 Operation and Inferring body position

The process of inferring body position done by two main stages: analyzing a speckle pattern of infrared laser light to produce depth map; then transforms depth image to body part image from motion capture system and finally transforms the body part image into a skeleton.

Figure 3.4: Speckle Pattern

3.4.2 OpenNI: Natural Interaction

The term natural interaction refers to people communicating with devices through their human senses, such as audio, and vision. The most obvious applications uses this technology are: face/ voice recognition; body motion tracking; and control room electronics using hand gesture

Abstract Layered View The three layered view of OpenNI :

- **Top**: Represents the software that implements natural interaction applications on top of OpenNI.
- **Middle**: Represents OpenNI, providing communication interfaces that interact with both the sensors and the middleware components, that analyze the data from the sensor..
- **Bottom**: Shows the hardware devices that capture the visual and audio elements of the scene.

3.4.3 Skeleton Tracking: User segmentation

Skeleton tracker generate data of the users who exist in the scene; these data includes location of the skeletal joints, and ability to track skeleton position.

There are some consideration for accurate skeleton tracking:

- User considered to be lost if the user is not visible in the scene within 10 seconds
- Users get ID “user 1,2,...”. However the ID is recycled.
- Ideal distance for tracking around 2.5 m
- User should not wear very loose clothing, for better result.

Calibration To start tracking body, the user should do calibration position “psi pose” as shown in figure.

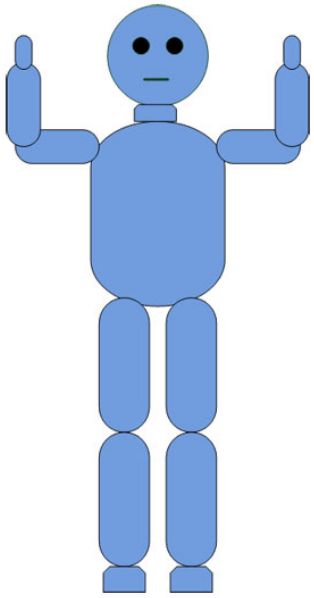


Figure 3.5: PSI pose

Limitations:

- User should not be sitting
- Most of the user body should be invisible
- User should be located 1 m away from kinect

Skeleton tracker output Skeleton tracker return the position, and quaternion of the joint.

Joint Transformation Joint positions and orientations are given in the real world coordinate system. The origin of the system is at the sensor. The positive direction of X-axis is to the right of origin “, The positive direction of Y-axis is up, and The positive direction of Z-axis is in the direction of increasing depth. The coordinate frame is shown in the figure above.

Keep in mind that representation of the skeleton in Rviz supposed to be in Mirror mode which indicates that the LEFT side labeled in Rviz window is actually your RIGHT side. Joint positions are measured in units of m and orientations are in radians.

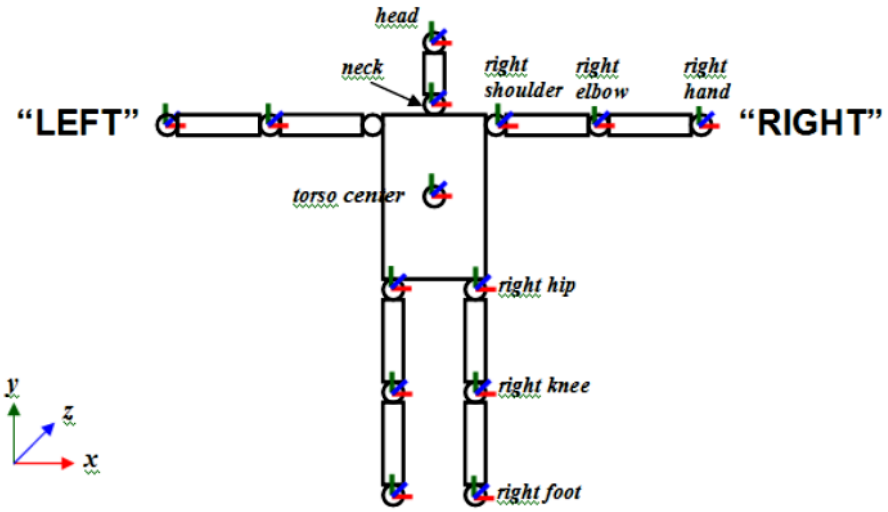


Figure 3.6: Skeleton joints Coordinate

3.4.4 Kinect Driver

Openni launch Package This package contains launch files for using OpenNI-compliant devices such as the Microsoft Kinect in ROS. from the device driver into point clouds, disparity images, and other products suitable for processing and visualization.

to open Kinect device and transform raw data to convenient data, run this command:

```
$ roslaunch openni_launch openni.lanuch
```

Openni tracker Package openni_tracker broadcasts the OpenNI skeleton frames using tf. this package allows you to track a person’s skeleton using a Kinect. It also gives you the positions, relative to the camera frame run this command:

```
$ rosrun openni_tracker penni_tracker
```

Stand in front of the Kinect. If the terminal window where you ran openni_tracker, you should see output like this:

```
[INFO]: New User 1
[INFO]: Calibration started for user 1

[INFO]: Calibration complete, start tracking user
```

3.4.5 3D Visualizing

As discussed in the previous sections, Kinect produced 3D data in form of point clouds.For this reason ROS has invented tool to visualize this type of data. these tools enable you to develop robotic system faster by visualizing your data and evaluate the quality of result for validation.

Visualizing 3D data using rviz With roscore running, we only have to execute the following code to start rviz:

```
$ rosrun rviz rviz
```

This command will open rviz interfac

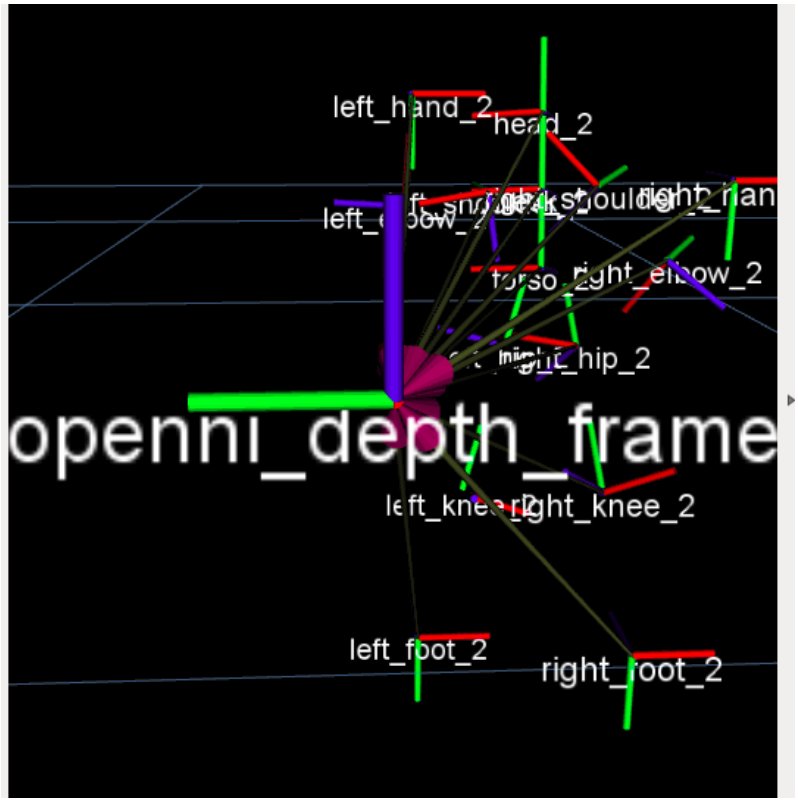


Figure 3.7: Visualizing skeleton joints using Rviz

"Be sure you put your feet in the right place, then stand firm."

— Abraham Lincoln, (American 16th President, 1809–1865)

Chapter 4
Robot Programming

4.1 Cartesian–Axis Specific Coordinate System

4.1.1 Coordinate systems in conjunction with robots

The following Cartesian coordinate systems are defined in the robot controller:

WORLDCoordinate System Fixed, rectangular coordinate system whose origin is located at the base of the robot. It is the root coordinate system for the ROBROOT and BASE coordinate systems. By default, the WORLD coordinate system is located at the robot base.

ROBROOT Coordinate System Fixed, rectangular coordinate system whose origin is located at the base of the robot. It is the root coordinate system for the ROBROOT and BASE coordinate systems. By default, the WORLD coordinate system is located at the robot base.

BASE Coordinate System Fixed, rectangular coordinate system whose origin is located at the base of the robot. It is the root coordinate system for the ROBROOT and BASE coordinate systems. By default, the WORLD coordinate system is located at the robot base.

TOOL Coordinate System a Cartesian coordinate system which is located at the tool center by default, the origin of the TOOL coordinate system is located at the flange center point. The TOOL coordinate system is offset to the tool center point by the user

4.2 KUKA Robot Language (KRL) Quick Guide

KRC 4 controller uses KRL KUKA programming language.

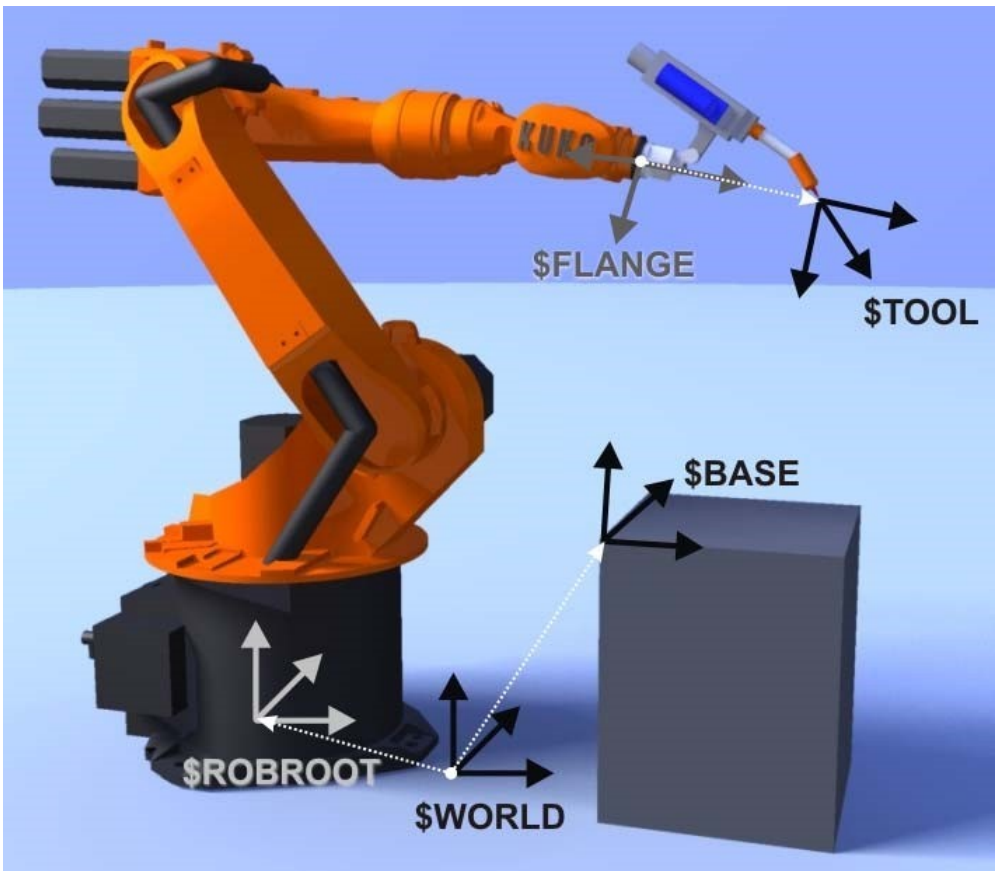


Figure 4.1: KUKA robot coordinate systems

4.2.1 Variables and Declarations

All system variables start with $ sign, mind not starting any "user-defined" name with this sign to avoid syntax errors.

Names in KRL

- Can have a maximum length of 24 characters
- Can consist of letters(A - Z), numbers(0 - 9) and the special characters '$'.
- Must not begin with a number.
- Must not be a keyword.

Declaration and initialization of variables

- Variables (simple and complex) must be declared in the SRC file before the INI line and initialized after the INI line
- Variables can optionally also be declared and initialized in a local or global data list.
- Every variable is linked to specific data type.

- The data type must be declared before use.
- The keyword for the declaration is DECL. It can be omitted in case of the four simple data type
  - In order to place syntax before the INI line, the DEF line must be activated:
    Open file >Edit >View >DEF line

```
DEF programName()
    DECL data type user defined variable
    ;declaration section of  variables
    INI
    ;Initialization section of user defined variables.
    ...
    ;Instruction Section
    ...
END
```

Simple Data types

Data Type	Keyword	Meaning	Range	Example
Integer	INT	integer number	$-2^31 \ldots 2^31-1$	2
Real	REAL	floating point number	$\pm 1.1E-38 \cdots \pm 3.4E+38$	4.23
Boolean	BOOL	logic state	TRUE, FALSE	TRUE
Character	CHAR	character	ASCII character	C

Table 4.1: KRL Data Types

Structure Types

- AXIS: A1 to A6 are angle values (rotational axes) or translation values (translational axes)

Axis: A1 .., A2 .., A3 .., A4, A5 .., A6 ..

- FRAME: X, Y, and Z are space coordinates, while A, B, and C are the orientation of the coordinate system.

FRAME: X .., Y .., Z .., A .., B .., C ..

- POS and E6POS: S (Status) and T (Turn) define axis positions unambiguously

POS: X .., Y .., Z .., A .., B .., C .., S ..., T

4.3 Motion Programming

4.3.1 Motion Types

The robot can move in various motion types. Paths are created according to the operation of each axis. Thus, the robot can be controlled to create either linear or circular path.

4.3.1.1 Axis-specific motion

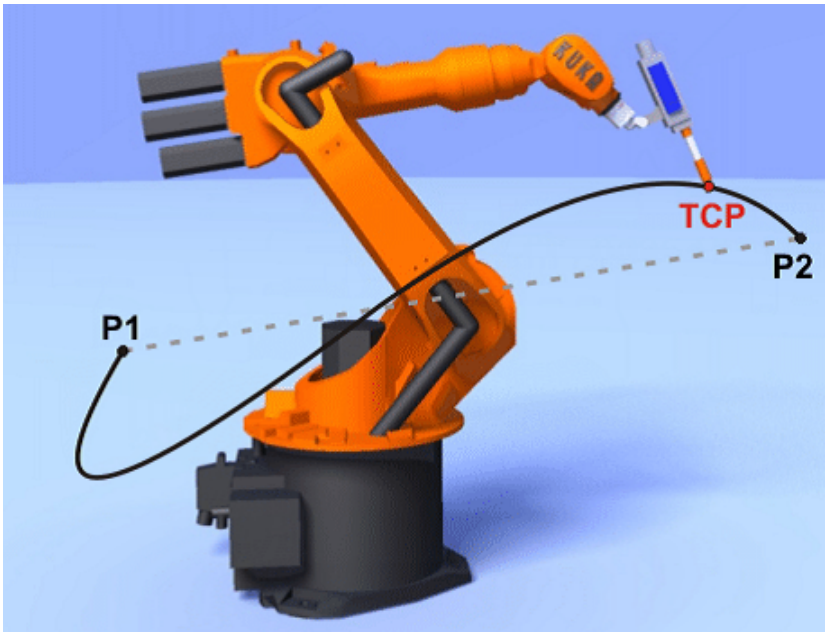
The robot guides the TCP along the fastest path to the end point. The fastest path is generally not the shortest path and is thus not a straight line. The first motion in the program must be PTP as status and turns are only evaluated here. The coordinates of the end point are absolute.

characteristics

- smooth motion

- Robot can move from start to end singularity free. As long as both the starting and ending points are in the working envelope, the robot will get to the end point without collision or sudden movement.
- Control is much simpler than continuous path control.

Figure 4.2: PTP Motion

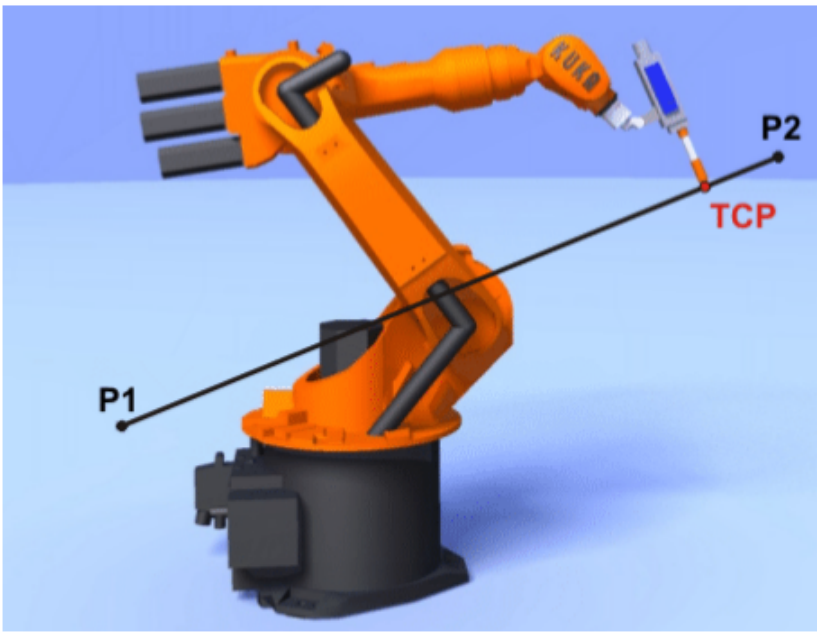


4.3.1.2 CP motion

LIN Motion Motion at a defined velocity and acceleration along a straight line. This motion requires the programmer to "teach" one point. The robot uses the point defined in the previous move as the start point and the point defined in the current command as the end point and interpolates a straight line in between the two points.

CIRC Motion Motion at a defined velocity and acceleration along a circular path or a portion of a circular path. This motion requires the programmer to "teach" two points, the mid-point and the end point. Using the start point of the robot (defined as the end point in the previous motion command) the robot interpolates a circular path through the mid-point and to the end point.

Figure 4.3: LIN Motion



4.3.2 Approximate Positioning

Approximate positioning of motion means that the next programmed point will not be exactly reached. This can help to shorten cycle times

4.3.2.1 PTP-PTP approximate positioning

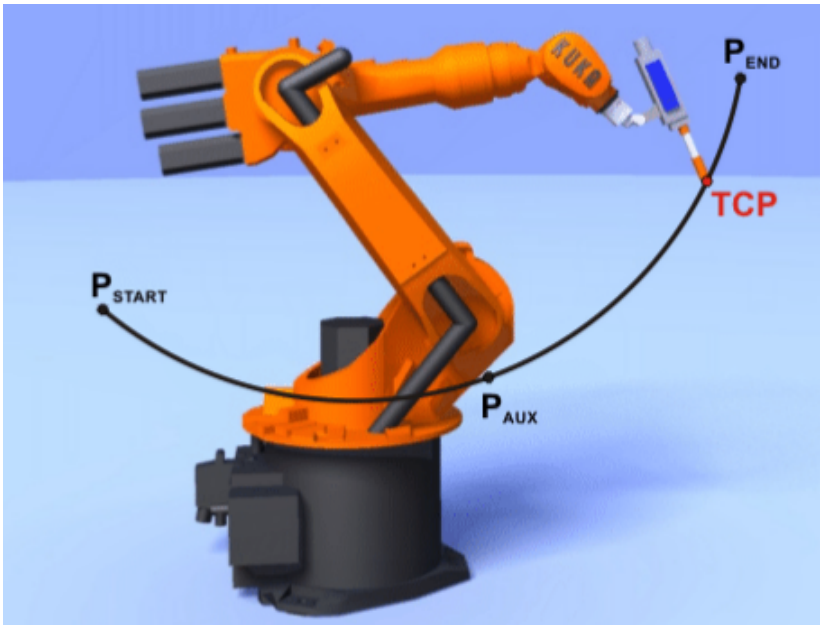
For the purposes of PTP approximate positioning,the controller calculates the distances the axes are to move in the approximate positioning range, and plans velocity profiles for each axis which ensure tangential transition from the individual instructions to the approximate positioning contour.

System Variable, $APO.CPTP enables the start of approximate positioning to be specified as a percentage of these maximum values. The approximate positioning of a point is displayed in the PTP command by adding the key word C_PTP:

```
$ APO.CPTP = 80
PTP HOME C_PTP
```

The greater this value the, the more path is rounded.

Figure 4.4: CIRC Motion



Status and Turns The position of x,y,z and orientation A,B,C values of TCP are not sufficient to define the robot position ,as different axis positioning are possible for the same TCP . Status and turns serve to define the position that can be achieved with different axis positions.

4.3.3 User Programming

Inline forms are available in the KSS for frequently used instruction. They simplify programming and facilitates user interface with controller without the need of knowing detail information about KUKA programming Language

4.3.4 Expert Programming

In the Expert interface, can achieve advanced programming using the KRL programming language and perform complex application programs including subprograms, interrupt programming, loops, and program branches.

Figure 4.5: Speed Profile:
a) If all points approached exactly
b)In case of approximate positioning of the points

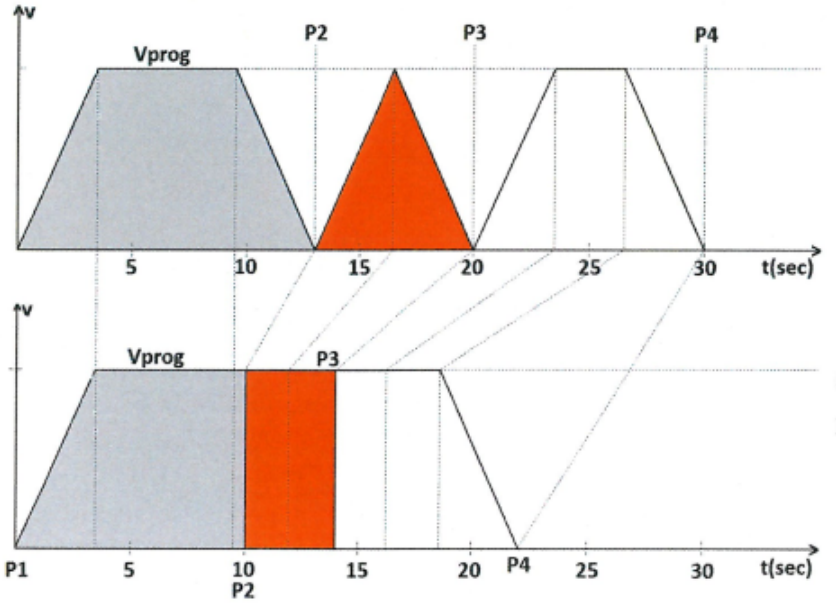
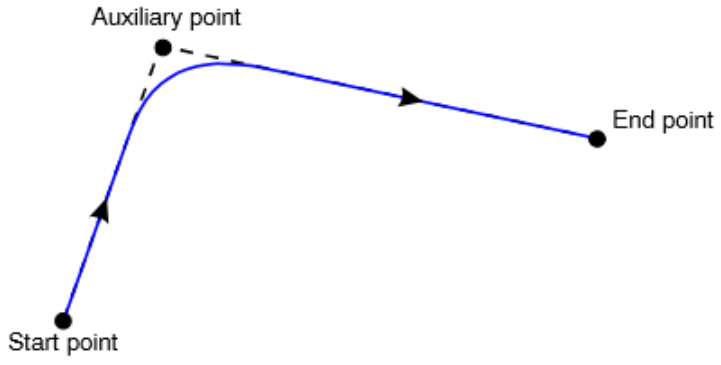


Figure 4.6: Approximate positioning of an auxiliary points



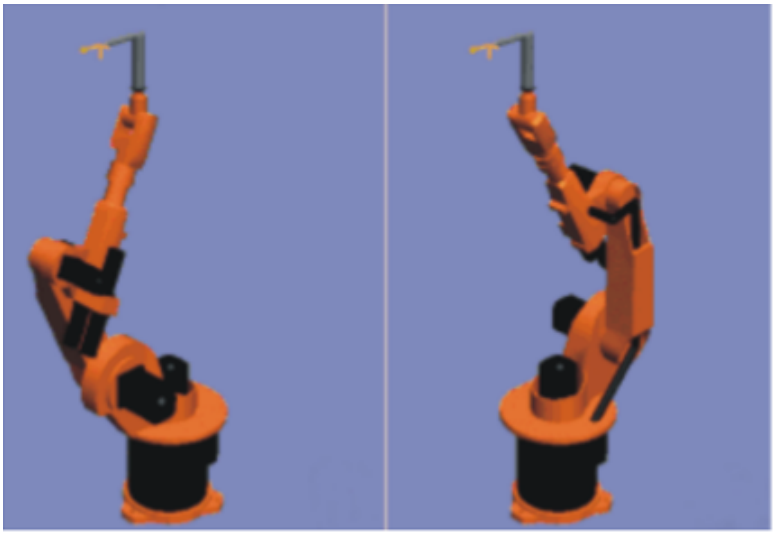


Figure 4.7: Same TCP, different axis position

Chapter 5
KUKA conditioning

5.1 Robot Mastering

The Mastering operation calibrates the relationship between the position sensor, attached to each axis motor, and each axis angle defined for each robot. Mastering axes enables the definition of geometric parameters used to describe the analytic parameters of a robot's geometric model. This helps in increasing the accuracy of the robot and correcting for discrepancies between design parameters and actual values.

Mastering the robot is performed by moving the each axis into a defined mechanical position, which is known as the "Mechanical zero position". The zero position, which is defined by a reference notch, is an assignment to the axis drive angle. Whenever the robot moves from the mechanical zero position, its deflection represents the change in corresponding axis angle (0 increments for 0 degrees).

To locate the mechanical zero position of a robot axis precisely, the axes must be aligned to their pre–mastering position. The protective cap of the gauge cartridge is then removed and a dial gauge, or the supplied EMD, is fitted to it.

Note: The robot must be mastered in the same temperature conditions (either always cold or at operating temperature) to avoid inaccuracies.

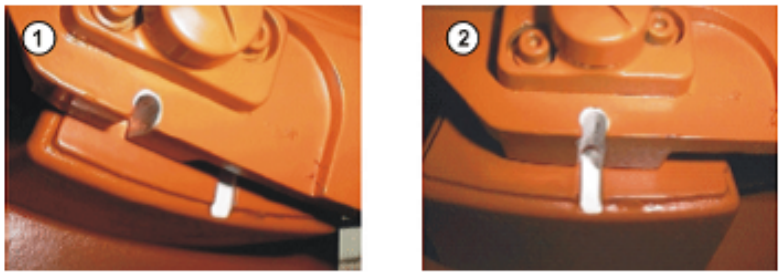


Figure 5.1: Moving an axis to pre-mastering position

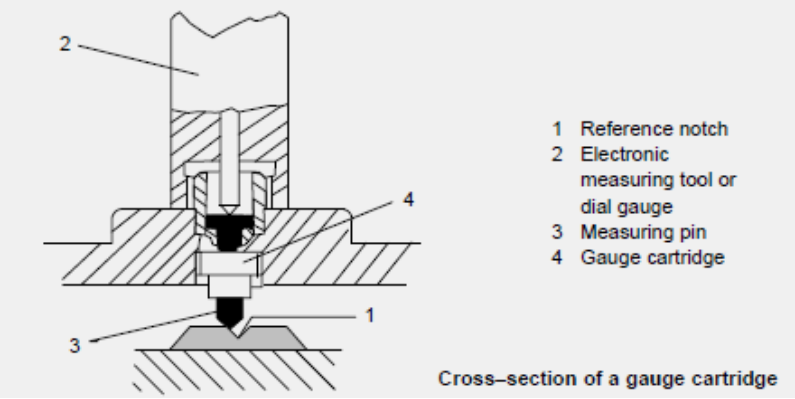


Figure 5.2: Moving an axis to pre-mastering position

On passing over the reference notch, the gauge pin reaches its lowest point, the mechanical zero position is reached. The electronic measuring tool sends an electronic signal to the controller.

Mastering can be performed through several methods; for older Robot versions it is performed using EMT, as for the KUKA AGILUS, mastering is done using one of these methods; EMD, dial gauge or MEMD. For our purpose, we used the MEMD supplied with the robot. The mastering positions are similar, but not identical, for all robots. Exact positions may vary between individual robots or single robot type.

5.1.1 Mastering using MEMD

Unlike Dial gauge mastering, which requires moving the robot manually to the mastering position, MEMD mastering offers automatic movement, done by the robot, to reach the mastering position. Mastering is per-

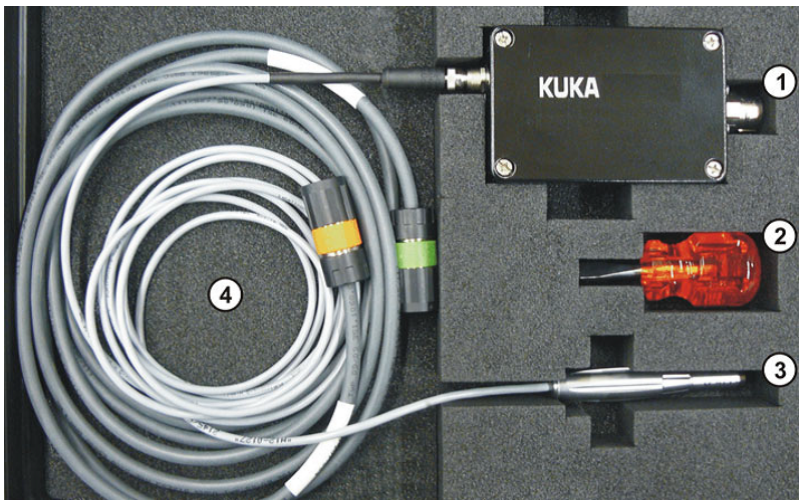


Figure 5.3: MEMD kit: 1. MEMD box, 2. Screwdriver, 3. MEMD, and 4. Cables.

formed first without a load then repeated using a load. The MEMD mastering tools are shown in the below picture.

Types of mastering

1. First mastering (without a load).
2. Tech offset (with a load and with saving the difference from first mastering being saved).
3. Master load with offset is based on saving an offset value that can be used to calculate first mastering in case it was lost (used when required, carried out with a load for which an offset has already been taught. This type is used to check first mastering or to restore it in case it was lost).

Precondition

- There is no load on the robot; i.e. there is no tool, workpiece or supplementary load mounted.
- A1 to A5 are in the pre-mastering position.
- No program is selected.
- Operating mode T1

Procedure

1. In the main menu, select Start-up > Master > EMD > With load correction > First mastering. A window opens. All axes to be mastered are displayed. The axis with the lowest number is highlighted.
2. Remove the cover from connection X32.
3. Connect the EtherCAT cable to X32 and to the MEMD box.
4. Remove the protective cap of the gauge cartridge on the axis highlighted in the window.
5. Screw the MEMD onto the gauge cartridge.
6. Press Master.
7. Press an enabling switch and the Start key.
8. When the MEMD has passed through the reference notch, the mastering position is calculated. The robot stops automatically. The values are saved. The axis is no longer displayed in the window.
9. Remove the MEMD from the gauge cartridge and replace the protective cap.
10. Repeat steps 4 to 8

Mastering of A6

1. Move A6 to the mastering position. A6 has very fine marks in the metal. Align these marks exactly with one another.
2. In the main menu, select Start-up > Master > Reference.
3. The option window Reference mastering is opened. A6 is displayed and is selected.
4. Press Master. A6 is mastered and removed from the option window.
5. Close the window.
6. Disconnect the EtherCAT cable from X32 and the MEMD box.

Note

For more information about the remaining mastering types (teach offset and mastering load with offset) and other mastering methods (using dial gauge and EMD), please refer to section: “5.9 Mastering” in the provided manual “07-KSS_82_Software programming_en”

5.2 Robot Calibration

Robot calibration is defined as identifying certain parameters in the robot’s kinematic structure, as an example; identifying relative position of robot links. Robot calibration can be performed through various methods, two of which are using a predefined and built-in calibration programs, or external methods (hardware and/or software) as RoboDK or advintec TCP. Calibration process differs in complexity from one method to another.

Calibration can be divided into three levels, depending on the type of modeled errors. The first of which models the differences between the actual and reported joint displacement values. This is also known as mastering. The second level, kinematic calibration, is related to the geometry of the robot and performing full geometric calibration, including angle offsets and joint lengths. The third level, non-kinematic calibration, models errors such as stiffness and friction.

Calibration offers higher positioning accuracy for offline programmed robots. Accuracy means that the real position of the robot end effector corresponds better to the actual position calculated from the robot’s mathematical model. In the case of offline programming, pose accuracy is considered an important performance criteria.

The calibration method used in out project is the first; using a predefined and built-in calibration program, which can be performed through different procedures in the KUKA platform, varying for tool and base calibration. For base calibration, these procedures are 3-point method, indirect method and Numeric input, and for tool calibration the procedures are

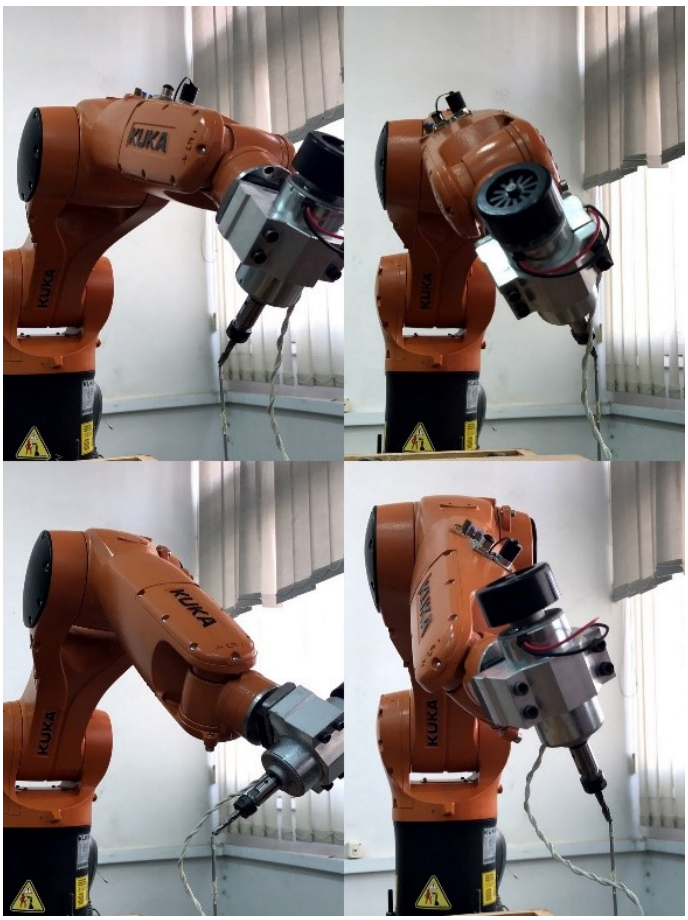


Figure 5.4: calibration

XYZ 4-point method and XYZ reference method, both for TCP, ABC 2-point method and Numeric input. For the purpose of our project, the applied calibration procedures for both tool and base calibration were XYZ 4-point method and 3-point method respectively.

5.2.1 Tool calibration using XYZ 4-point procedure

The TCP of the tool to be calibrated is moved to a reference point from four different directions. The reference point can be freely selected. The robot controller calculates the TCP from the different flange positions. These four directions must be sufficiently different from one another (similar to the positions shown in the provided pictures).

Precondition

- A previously calibrated tool is mounted on the mounting flange.
- Operating mode T1

Preparation Calculate the TCP data of the calibrated tool:

1. In the main menu, select Start-up > Calibrate > Tool > XYZ Reference.
2. Enter the number of the calibrated tool.
3. The tool data are displayed. Note the X, Y and Z values.
4. Close the window.

Procedure

1. In the main menu, select Start-up > Calibrate > Tool > XYZ Reference.
2. Assign a number and a name for the new tool. Confirm with Next.
3. Enter the TCP data of the calibrated tool. Confirm with Next.
4. Move the TCP to a reference point. Press Calibrate. Answer the request for confirmation with Yes.
5. Move the tool away and remove it. Mount the new tool.
6. Move the TCP of the new tool to the reference point. Press Calibrate. Answer the request for confirmation with Yes.
7. Enter the payload data. (This step can be skipped if the payload data are entered separately instead.) (>>> 5.12.3 "Entering payload data" Page 138)
8. Confirm with Next.
9. If required, coordinates and orientation of the calibrated points can be displayed in increments and degrees (relative to the FLANGE coordinate system).
10. For this, press Meas. points. Then return to the previous view by pressing Back.

11. Either: press Save and then close the window via the Close icon. Or: press ABC 2-point or ABC World. The previous data are automatically saved and a window is opened in which the orientation of the TOOL coordinate system can be defined.

5.2.2 Base calibration using 3-point method

During base calibration, the user assigns a Cartesian coordinate system (BASE coordinate system) to a work surface or the workpiece. The BASE coordinate system has its origin at a user-defined point. In 3-point calibration, the robot moves to the origin and 2 further points of the new base. These 3 points define the new base.

Advantages of base calibration

1. The TCP can be jogged along the edges of the work surface or workpiece.
2. Points can be taught relative to the base. If it is necessary to offset the base, e.g. because the work surface has been offset, the points move with it and do not need to be retaught.

Precondition

- A previously calibrated tool is mounted on the mounting flange.
- Operating mode T1

Procedure

1. In the main menu, select Start-up > Calibrate > Base > ABC 3-point.
2. Assign a number and a name for the base. Confirm with Next.
3. Enter the number of the mounted tool. Confirm with Next.
4. Move the TCP to the origin of the new base. Press Calibrate. Answer the request for confirmation with Yes.
5. Move the TCP to a point on the positive X-axis of the new base. Press Calibrate. Answer the request for confirmation with Yes.

6. Move the TCP to a point in the XY plane with a positive Y value. Press Calibrate. Answer the request for confirmation with Yes.
7. If required, coordinates and orientation of the calibrated points can be displayed in increments and degrees (relative to the FLANGE coordinate system). For this, press Meas. points. Then return to the previous view by pressing Back.
8. Press Save.

Note

For more information about tool and base calibration, please refer to section “5.11 Calibration” in the provided manual “07-KSS_82_Software programming_en”.

5.3 WorkVisual and LAN connection

The WorkVisual software package is the engineering environment for KR C4 controlled robotic cells. It offers the following functionalities:

- Configuring and connecting field buses
- Programming robots offline
- Configuring machine data
- Configuring machine data
- Editing the safety configuration
- Transferring projects to the robot controller
- Loading projects from the robot controller
- Comparing a project with another project and accepting differences where necessary
- Managing long texts
- Managing option packages
- Diagnostic functionality
- Online display of system information about the robot controller

- Configuring traces, starting recordings, evaluating traces (with the oscilloscope)

Hardware requirements: Minimum requirements

- PC with Pentium IV processor, min. 1500 MHz
- 512 MB RAM
- DirectX8-compatible graphics card with a resolution of 1024x768 pixels

Recommended specifications

- PC with Pentium IV processor and 2500 MHz
- 1 GB RAM
- DirectX8-compatible graphics card with a resolution of 1280x1024 pixels

Software requirements:

- Windows 7 (Both the 32-bit version and the 64-bit version can be used).
- Or: Windows XP (32-bit version, with at least Service Pack 3, the 64-bit version cannot be used).

If the following software are not already installed on the PC, the installation wizard automatically starts their installation before preceding with the WorkVisual installation.

- .NET Framework 2.0, 3.0 and 3.5
- SQL Server Compact 3.5
- Visual C++ Runtime Libraries
- WinPcap

5.3.1 WorkVisual Installation

1. Start the program setup.exe.

2. If the following components are not yet installed on the PC, an installation wizard opens:
   - NET Framework 2.0, 3.0 and 3.5 Follow the instructions in the installation wizard. .NET Framework is installed.
3. If the following component is not yet installed on the PC, an installation wizard opens:
   - SQL Server Compact 3.5 Follow the instructions in the installation wizard. SQL Server Compact 3.5 is installed.
4. If the following components are not yet installed on the PC, an installation wizard opens:
   - Visual C++ Runtime Libraries
   - WinPcap Follow the instructions in the installation wizard. Visual C++ Runtime Libraries and/or WinPcap is installed.
5. The WorkVisual [...] Setup window opens. Click on Next.
6. Accept the license agreement and click on Next.
7. Click on the desired installation type.
8. Click on Install. WorkVisual is installed.
9. Once installation is completed, click on Finish to close the installation wizard.

Note

For more information about installation, uninstallation and GUI of the WorkVisual software, please refer to Manual "KST_WorkVisual_en".

5.3.2 LAN connection

In order to start file sharing process and to be able to use all functions of WorkVisual, a PC-Controller connection must be established. There are several ways to connect the KRC4 and KUKA-PC, one of which is setting up a local network for the connection of between several devices. This

can be done by either setting static IPs for the connected devices and connecting them physically using a specified Ethernet cable, or by using a network router and assign dynamic IPs starting from a specified value, with specified number of connected devices.

To obtain and/or change IP values for the PC

1. Open "Network and sharing center"
2. Choose "Change adapter settings"
3. Right click "Ethernet connections"
4. Choose "Internet protocol version 4 (TCP/IPv4)"
5. Choose "Properties"
6. Next you either set static IPs or choose dynamic IPs to be set, in our case by the router.

Note

The following address ranges are used by default by the robot controller for internal purposes. IP addresses from this range must not therefore be assigned by the user.

- 192.168.0.0···192.168.0.255
- 172.16.0.0···172.16.255.255
- 172.17.0.0···172.17.255.255

LAN Configuration steps

1. Connect the PC and the KRC4 to the router using regular Ethernet cables.
2. Access the router configuration page using the given data on the back of the router. (the router used in our case is TP-LINK, with username and password both being admin)
3. In the Interface setup change the LAN settings to your preferred values

4. It is preferred to set the starting IP address similar to that of the KRC4 (172.31.147) to avoid conflicts. Network gateway value is (172.31.1.1) and subnet mask (255.255.0.0), all other settings shall remain unchanged.

Figure 5.5: Network Configuration

5. After changing these values, the IP address used to access the router settings will change from (192.168.1.1) to the set gateway value (172.31.1.1) but with the same user name and password.

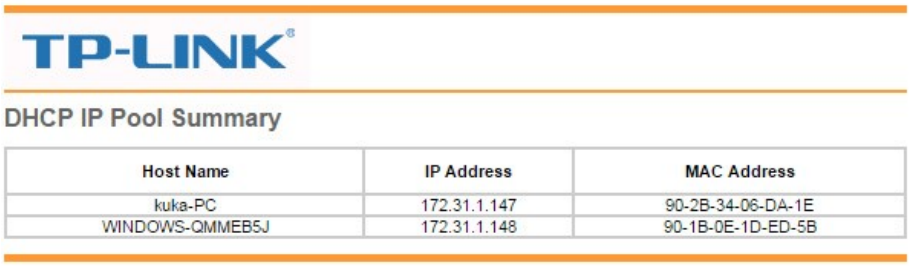


Figure 5.6: Network Configuration: IP address

6. The connection is now established and can be verified by checking the router LEDs

5.4 Installation of KUKA.Sim Pro

KUKA.Sim Pro is used for the complete offline programming of KUKA robots. This product allows the analysis of cycle times and the generation of robot programs. It also enables a real-time connection to the virtual KUKA robot controller (KUKA.OfficeLite). KUKA.Sim Pro is additionally used for building parametric components and defining kinematic systems, which can also be used in KUKA.Sim Layout and KUKA.Sim Tech. KUKA.OfficeLite is included in the KUKA.Sim Pro package. CAD importers are available as an option. This requires a purchasable license for each import interface.

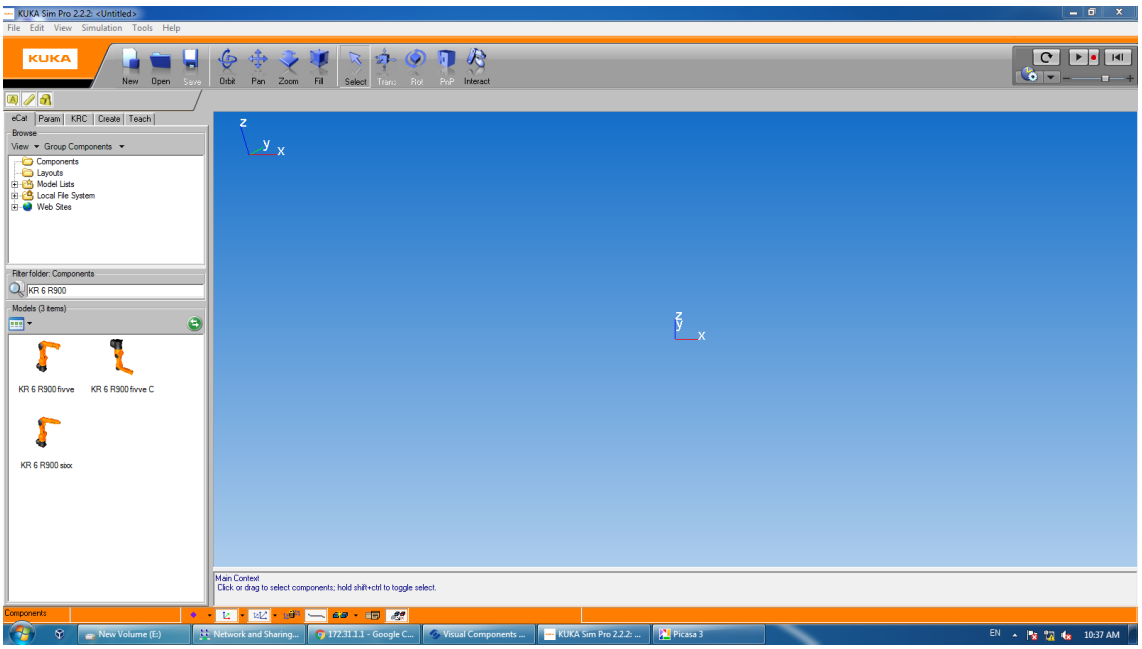


Figure 5.7: simpro

Requirements

- The minimum requirements for the computer are a 2 GHz CPU and 2 GB RAM, and an OpenGL-capable graphics card with at least 512 MB RAM and a resolution of 1024 x 768 pixels or a similarly specified notebook.
- Supported operating systems are WIN XP - 32-bit or WIN 7 - 32/64-bit.

5.4.1 Installation

1. Start the setup file ".exe"
2. Read the agreement and activate the check box "I accept ..."
3. Select "Install" to start installation.
4. Select "Install" to complete installation

Installing the component library

After installation of the KUKA.Sim software product, the component library is installed with the following program: SetupKUKASimLibrary_2.2.0_Buildx.exe The procedure is very similar to the installation of the software products. Simply follow the instructions given. The KUKA.Sim component library contains over 1,000 typical layout components (robots, grippers, fences, etc.), various demo layouts and tutorials for KUKA.Sim. Although the KUKA.Sim products still work without the component library installed, it is strongly recommended that the component library is installed in order to be able to create layouts quickly and easily.

5.4.2 License types

There are different types of licensing for the KUKA software. License types are determined and verified in accordance with the purchase

made from KUKA Roboter GmbH. The software licensing concerning the KUKA arm at Zagazig university is an educational bundle license. The serial number for the license is found in the booklet of the KUKA.Sim Pro CD. Information about different licensing bundles are obtained by contacting KUKA Roboter GmbH by email **simulation@kuka-roboter.de.** Further details about the steps of obtaining the serial key, for different commercial bundles, are found on page 13 of (KUKA.Sim 2.2- Installation-en) manual.

Note

The serial number associated with this purchase is: **K5P22-N174H-AW7KY-9**

Stand-alone License The license is on the PC on which KUKA.Sim is used. The license key is then valid for this PC only. It can also be transferred to a different PC, but cannot be used on a two different PCs at the same time, or when either of the two PCs is off.

Network License Network licenses provide a flexible way of using KUKA.Sim on more than one PC. When a license is requested by a PC, this license is then allocated to this PC. When KUKA.Sim is closed, the license becomes available again and can be accessed by other PCs. A license server is required to manage the network licenses. When KUKA.Sim Pro is started, the computer's identity (IP address, please refer to **LAN connection** in manual Section "WorkVisual & LAN connection") is required occasionally, however, KUKA.Sim Pro needs to check with the local license server to make sure that KUKA.Sim Pro and server are on the same PC, which is required in the network license configuration.

Requesting a license file manually

1. Start the installation of KUKA.Sim Pro
2. Enter the license key
3. Select "Activate manually" and save the request file

4. Go to the Visual components customer portal and use the given email and password, mentioned in the previous section, to login.
5. On the website, choose Manual Licensing, upload the request file and confirm.

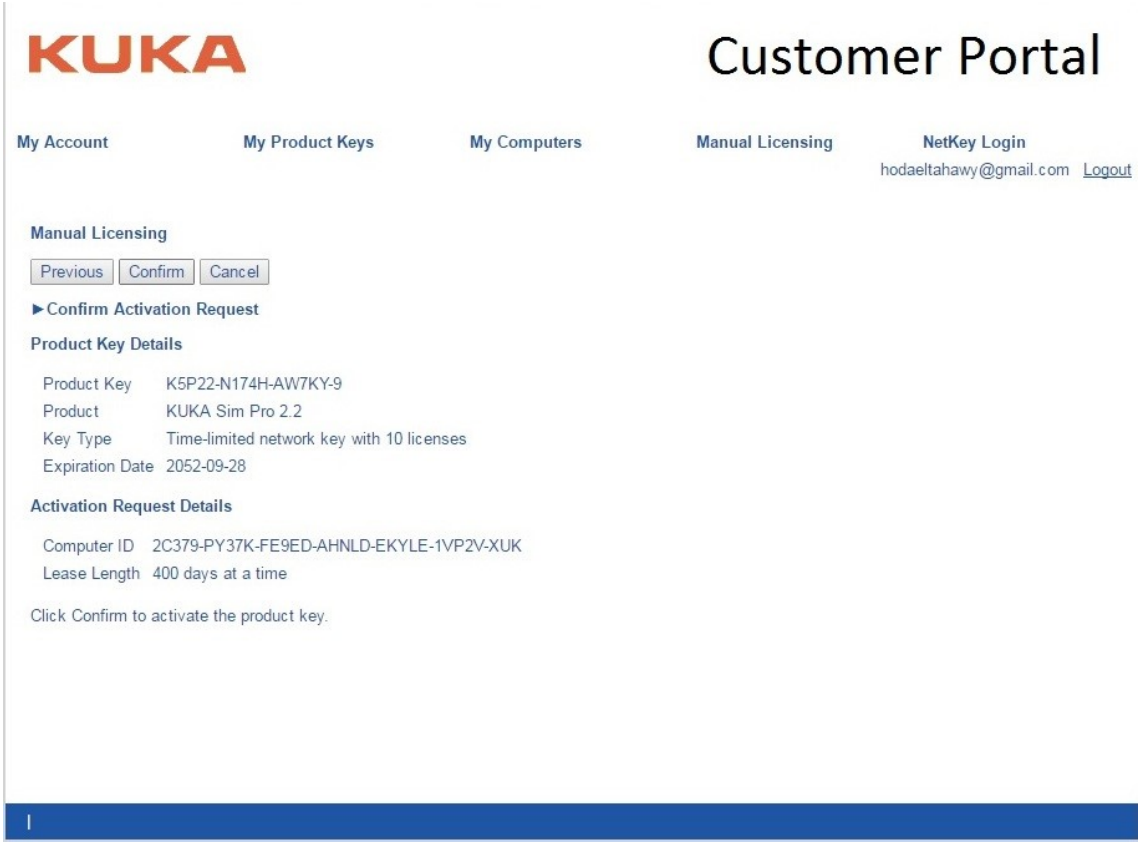


Figure 5.8: Requesting a license file manually

6. The license should be activated.
7. Download the license (.dat) file and click Finish. Please complete the installation steps of the license server before proceeding with the next steps.
8. The license (.dat) file should be loaded into the license server, not the KUKA.Sim Pro interface, in order to complete the activation process.

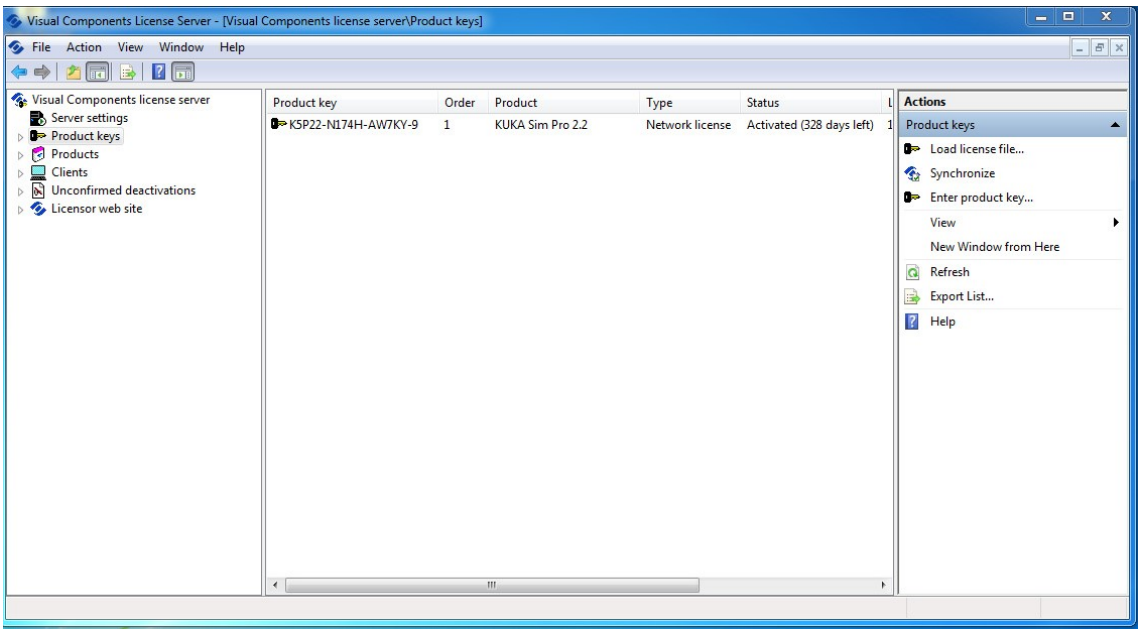


Figure 5.9: Requesting a license file manually

9. After this process is completed, the network server interface should appear as follows

Installing the license server

Requirements "Microsoft Management Console" (MMC) must be installed on the license server. The software can be downloaded from the Microsoft website. In addition, ".NET framework 3.5" or higher should be installed.

Installation

1. The license server is started via "Start > Programs > Visual Components > Visual Components License Server > Visual Components License Server Manager".
2. Choose "Server settings" from the left panel, make sure that the license server is started, if not, click Start to activate it. The port number value is 5093.

3. On the left-hand side, select “Product keys” in order to enter the license key.
    - The right-hand side changes and “Enter product key...” is offered. Click on this.
    - A window is opened in the center, in which the license key can be entered.
    - If manual licensing is being performed using a license file, this license file must be loaded with “Load license file...”.
4. Enter the license key and confirm with OK.

For network licensing, an account linked with the purchase is created on the Visual Components website (`http://www.visualcomponents.com`). In the specified customer portal (`https://portal.visualcomponents.net/website/Login.aspx`), sign in with the email `hodaeltahawy@gmail.com` and password quails@123 . In the “My Products keys” tab, you will find the product key for KUKA.Sim Pro on the KUKA-PC device, at the Mechatronics lab. The license is already activated and will only require renewal after a period of 400 days starting 3-12-2016, which is on 7-1-2018.

5.5 End-effector installation

5.5.1 Pneumatic gripper

The KUKA AGILUS offers numerous options for different end-effectors installations. One of the most common end effectors is a gripper, whether it be vacuum, pneumatic, hydraulic or servo-electric grippers. We are concerned with pneumatic grippers, which operate using air pressure. When air pressure is applied on the pistons, the gripper closes. When the pressure is released the gripper opens. The only way to manage the force in the gripper is to manage the air pressure in the air intake (or valve). The gripper used in our study is the SOMMER automatic GP 404 NC-C We also had the opportunity to work with one of KUKA Roboter's Application software; Gripper&SpotTech. These are ready-made software packages created for different industrial applications. Optional features can be installed on the controller easily and quickly and can also be tailored to the specific production environment.

These software include, and not limited to, KUKA.ArcTech, which enables implementation and programming of applications for arc welding and plasma cutting, KUKA.ConveyorTech, which automatically adapts the actions of the robot to the motion of an assembly line or conveyor belt and KUKA.CNC, which links the CNC and robot directly to each other. As a result, they can be operated like a conventional CNC controller.

Pneumatic grippers can be used in many applications, some of which include assembly purposes, Labs automation, and on mobile robots.

This software package offers numerous advantages, including:

- 16 freely configurable grippers
- 16 freely configurable grippers
- Gripper conditions statically and dynamically monitored
- Unlimited user-defined gripper icons
- Unlimited user-defined gripper icons
- Graphical user interface with indicator lamps, a status display and online adaptation

- Adaptation via WorkVisual 4.0 and on the smartPAD for production-relevant elements

5.5.1.1 Gripper connection

The gripper is connected to the air supply through the Air 1 port located on link 3 (The port is shown in the following picture). This port is connected internally to Air 1 port on the back of the robot arm, which in turn is connected with the air compressor.

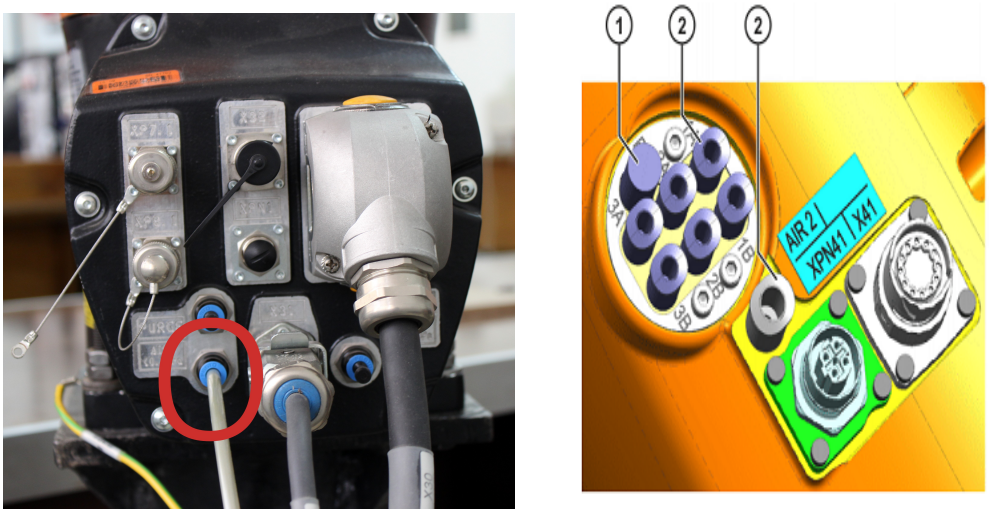


Figure 5.10: Grippers

In order for these ports to be operative, the connection between the ports and the controller must be activated, this is performed using mapping. Mapping can be simply described as the process of creating a link or a connection between ports on the robot arm and inner components in the controller in order to use them in control purposes, in our case operating the gripper. Mapping is performed through WorkVisual through the steps mentioned below.

1. get current project from robot using workvisual
2. save it as different file name
3. activate project in work visual (by double clicking on Controller<kss version>)

4. open I/O mapping
5. leave left pane on KRC (those are I/Os that robot programs can access), and click on inputs
6. move right pane to Fieldbus (those are physical I/O), then highlight EM8905 module (this is I/O card inside agilus arm)
7. map inputs of EM8905 to robot inputs of your choice
8. repeat steps 5.6.7 for outputs
9. on the robot login as Expert or higher (Expert will work in this case since we did not modify safety configuration)
10. deploy modified project to robot and activate it (on robot). You should have something like on image below.

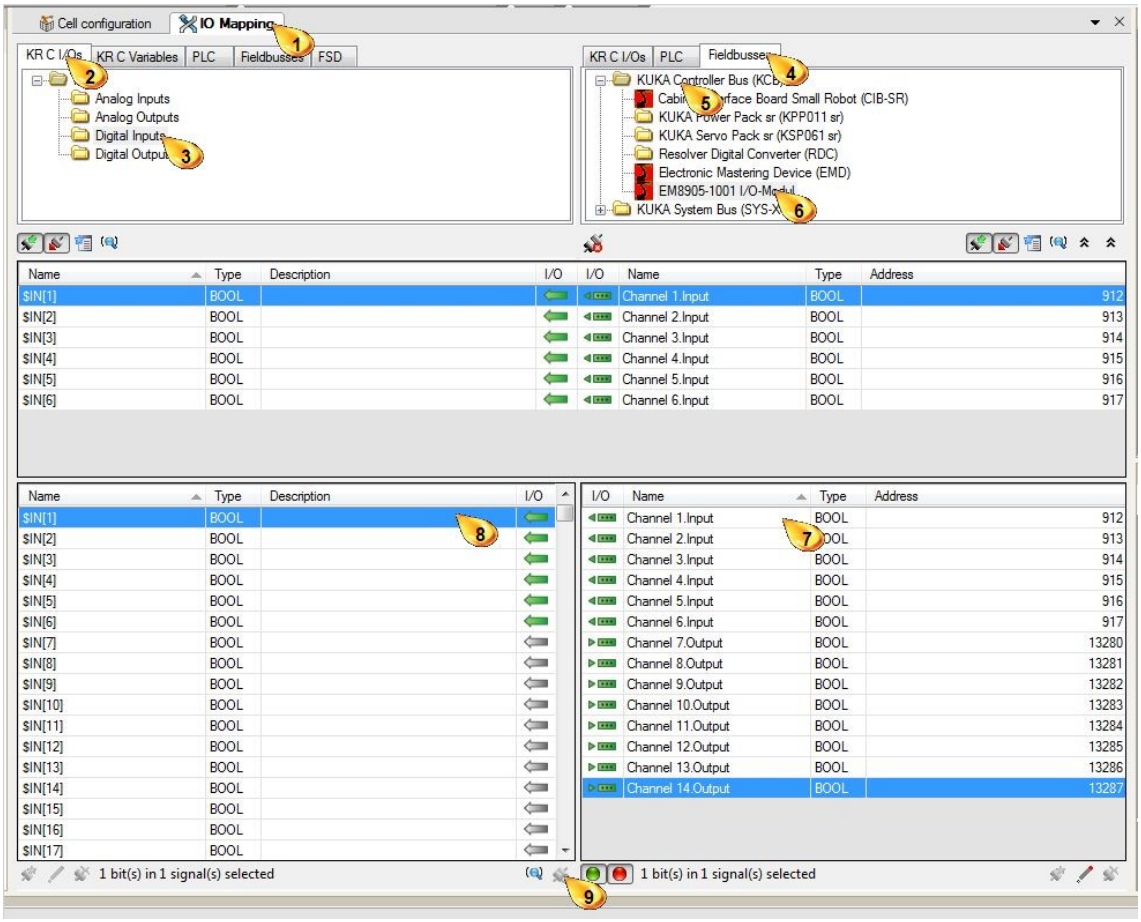
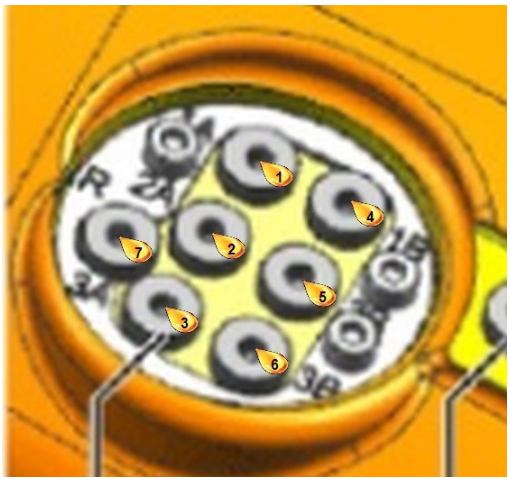


Figure 5.11: Gripper configuration

Six valves are mapped to ports:

1. 1A
2. 2A
3. 3A
4. 1B
5. 2B
6. 3B
7. R (relief/exhaust)



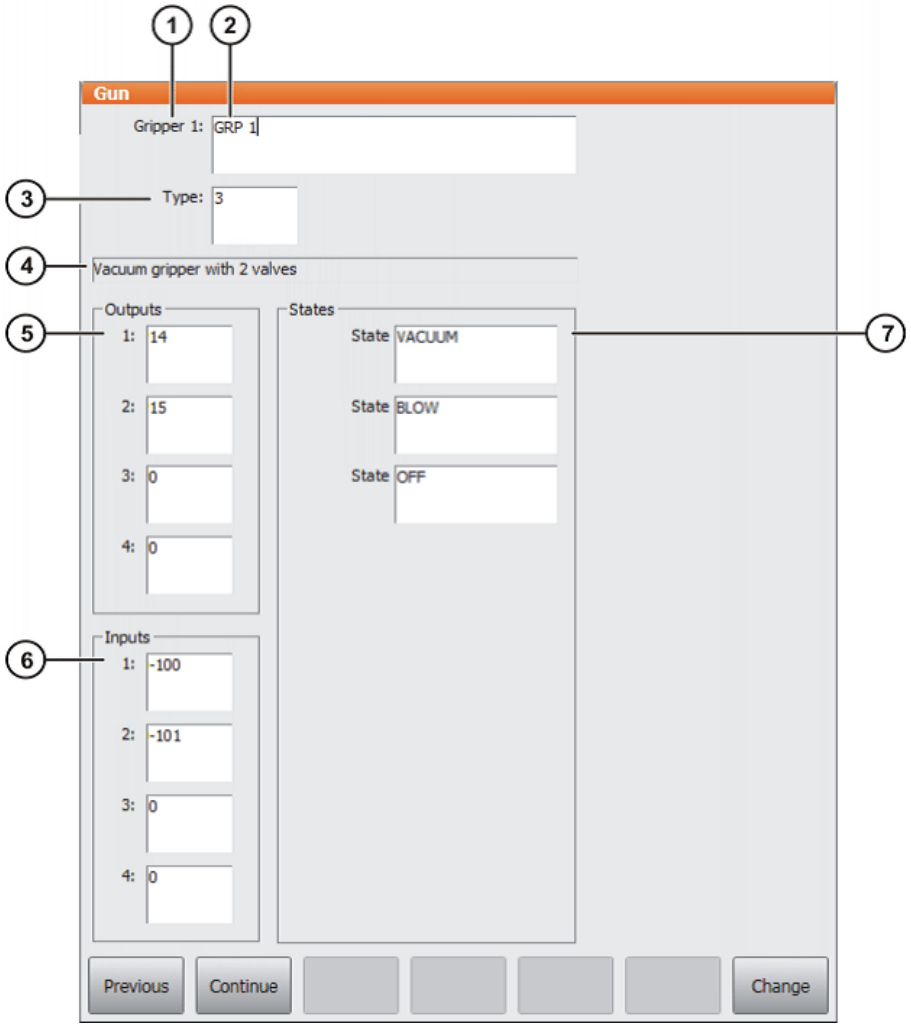


Figure 5.12: Configuring predefined grippers

Configuring predefined grippers

Gripper settings can be changed using smart pad. In the main menu, select Configure > I/O > Gripper. A window opens (shown in figure), inside it you'll find a list of the predefined grippers, select the desired gripper number with Next or Previous.

You can change number of grippers)1), Name of gripper (2), Type of gripper (3), designation of gripper type (4), Assignment of the output numbers (5), Assignment of the input numbers (6) and Switching states (7).

The third cell, designated for the type of gripper is explained in the following section, Predefined gripper types.

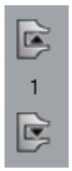
Predefined gripper types There are five predefined gripper types in Gripper&SpotTech. If these types are not sufficient, additional gripper functions can be programmed.

- Type 1: Single-element gripper, static, open/closed
- Type 2: With mid-position valve
- Type 3: Vacuum gripper with 2 valves
- Type 4: Vacuum gripper with 3 valves
- Type 5: Single-element gripper with pulse valves, open/close

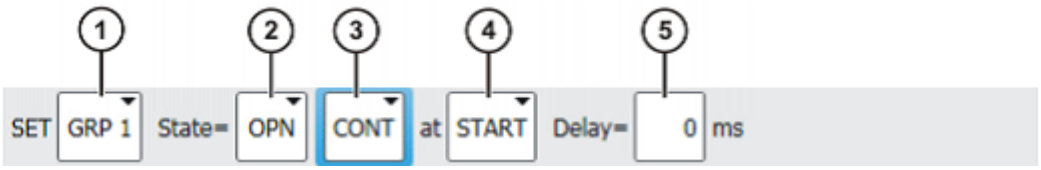
Note

More information about the specifications of each type and user specified grippers can be found in manual "KST_GripperSpotTech_32_en".

Gripper operation Manual gripper control can be performed using technology keys on smart pad. The settings for the technology keys are already set for this gripper and appear with the following icons on the smart pad screen, next to the assigned buttons.

Icon	Description
	Select gripper The number of the gripper is displayed. Pressing the upper key counts upwards. Pressing the lower key counts downwards.
	Toggle between the gripper states (e.g. open or close)

The gripper is opened or closed using these buttons, after pressing the enable buttons on the back of the smart pad. They can also controlled inside KRL programs in inline form through the following command



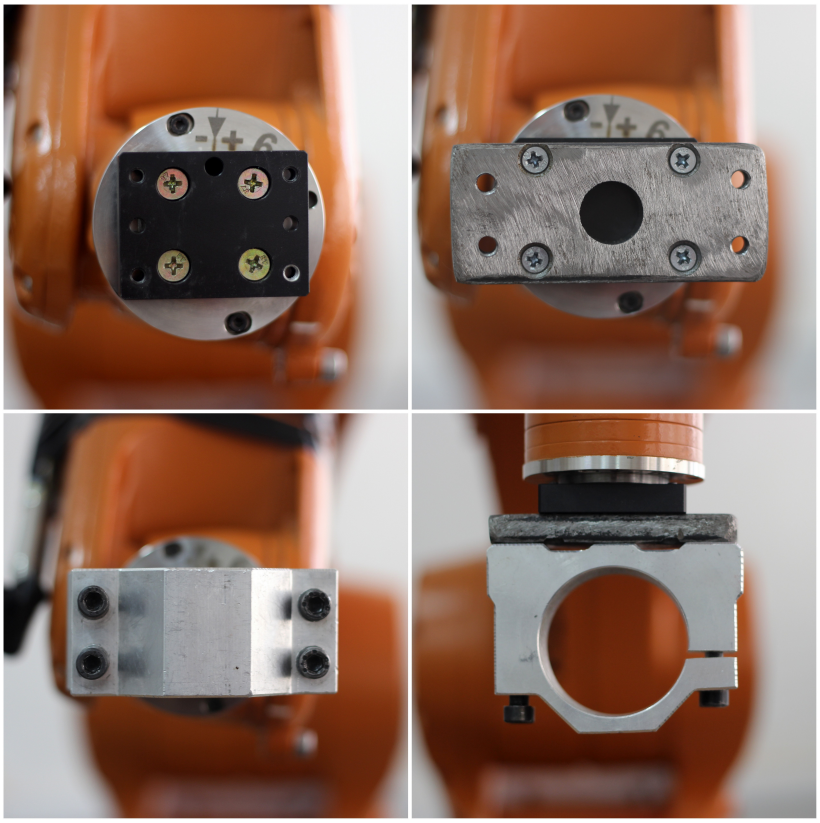
Where:

1. Choosing the desired gripper from a list of predefined grippers in settings
2. Set the state of the gripper, whether to open or close
3. CONT: Execution in the advance run
4. Box only available if CONT selected.
   - START: The gripper action is executed at the start point of the motion.
   - END: The gripper action is executed at the end point of the motion.
5. Box only available if CONT selected. Define a wait time (-200:200 ms), relative to the start or end point of the motion, for execution of the gripper action.
6. Box only available if [blank] selected. Data set with gripper parameters

5.5.2 Electric spindle

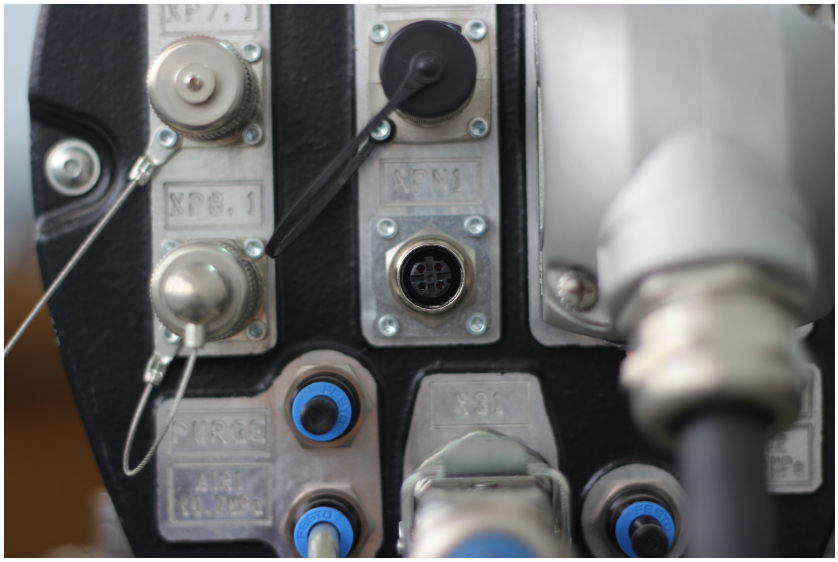
For the purpose of milling, a spindle was attached as an end effector to perform this process. The spindle used was a simple ON/OFF spindle, which required no control signals, so it merely needed to be attached to the end effector and to an external power supply.

Spindle attachment For the spindle to be attached to the sixth axis of the robot, a metal linkage was designed and manufactured to fit both the spindle and the mounting surface on the sixth axis. The first picture shows the mounting surface of the sixth axis of the robot. The second shows the metal linkage after being installed to the mounting surface. The Third and fourth pictures shows the spindle's metal holder.



Spindle connection The power supply of the spindle is connected to port XPN1 on the fourth axis, whose output is internally linked to a similar

port XPN1 on the back side of the robot. The port contains four openings or smaller ports; the positive wire is connected to the two right-hand side ports and the negative side to the left-hand side ports. The ports are shown in the picture below.



Spindle specifications The spindle used is an Air cooled spindle, with a 300W CNC Spindle Motor, supplied by a 220 voltage source, with adjustable speed through the attahced knob. The spindle must operate with full speed during the milling process. Further information about the spindle can be found in the resources in the references.

End mill used for machining The end mill used is a double blade 6 mm Carbide blade. A 6 mm collet was used to attach the end mill to the spindle. A collet is a subtype of chuck that forms a collar around an object to be held and exerts a strong clamping force on the object when it is tightened, usually by means of a tapered outer collar. Both the end mill and the collet can be changed for different milling purposes, as an example, a smaller end mill can be used to obtain a higher level of fine details that larger end mills can't offer, while larger end mills can be used to remove more material or perform faster in basic milling operations that does not require a high level of details.

"Look up at the stars and not down at your feet. Try to make sense of what you see, and wonder about what makes the universe exist. Be curious."

— Stephen Hawking, (British theoretical physicist, and cosmologist

Chapter 6
Safety

6.1 General

6.1.1 Terms used

- Work space: Space where the manipulator allowed to move.
- Danger zone: consist of workspace and stopping distance.
- Safety zone: Is outside the danger zone.
- KCP: KUKA control panel (teach pendant) has all operator control.
- Stop 0: Drivers are deactivated immediately and breaks are applied.
- Stop 1: Drivers are deactivated after 1s and breaks are applied.
- Axis range: Range of each axis, in degrees or millimeters, within which it may move.
- T1 Test mode: Manual Reduced Velocity (less than 250 mm/s)
- T2 Test mode: Manual High Velocity (more than 250 mm/s permissible)

6.1.2 Description of KUKA manipulator

components

- Manipulator
- smart PAD
- connecting cable from smart PAD to controller
- Controller
- Data connection cable
- Motors connecting cable

Axis

- In-line wrist (A4,A5,A6)
- Arm (A3)
- Link arm (A2)
- Rotational column (A1)

Figure 6.1: Description of KUKA arm

6.2 Warnings and notes

These warnings are relevant to safety and must be observed.

Figure 6.2: warning and notes

6.3 Workspace, safety and danger zone

Workspaces are to be restricted to the necessary minimum size it must be safeguarded using appropriate safeguards.The safeguard must be situated inside the safety zone. In the case of a stop, the manipulator and external axes are braked and come to a stop within the danger zone which consists of the workspace and the stopping distances of the manipulator.The maximum reach of the robot is 901mm

Figure 6.3: Working space

6.4 Safety function

- Emergency stop is the device must be pressed in the event of a hazardous situation or emergency, The manipulator and any external axes are stopped with a safety stop1.
- Enabling device of the industrial robot are the enabling switches on the KCP.There are 3 enabling switches installed on the KCP which have 3 positions
  - Not pressed
  - Center position
  - Panic position
- Jog mode is an additional protective equipment where the robot use operating modes T1 and T2 to execute the program.This means that it is necessary to hold down an enabling switch and the Start key in order to execute a program.
- operator safety is a signal used for interlocking physical safety gate in case of losing the signal during automating operation the manipulator will stop with stop 1.

6.5 Safe operating zone

Vision technology has become a critical component for many robot applications, enabling robots to be deployed into new areas. Over the years the technology has matured becoming very reliable, with higher performance and pricing has dropped dramatically. Giving robots eyes enables them to perform increasing complex operations in ways that dramatically improve their performance. For example, robots guided by vision can locate parts to be picked up, determine where to apply a weld, inspect parts that have been assembled, determine where to place a part. The possibilities are endless. The possibilities are not only limited to the industrial applications. For example, hand gestures can be used in teleoperation, navigation, or even to perform a surgery! [[[IEEE reference]]]. Computer vision libraries made it possible to detect human body and hence a safe operation zone can be provided. For more applications, you can have a look at this interesting IEEE article: `http://spectrum.ieee.org/automaton/robotics/diy/top-10-robotic-kinect-hacks`

6.6 State of the art

One of the most important piece of information that a normal camera misses is the depth of the image. The depth is important in recognizing the real world in a proper way. Researchers had found many solutions for this problem like the stereo camera installations, or even including depth sensors with the RGB camera itself, like in the Kinect. Kinect is a depth sensor which is able to return images like an ordinary camera, but instead of color, each pixel value represents the distance to the point. As such, the sensor can be seen as a range- or 3D-camera. For more technical details about Kinect, please refer to this website:

`https://ese.wustl.edu/ContentFiles/Research/UndergraduateResearch/CompletedProjects/WebPages/fl12/MattJohnson/kinect1.html`

Robotic grasping, object recognition, and human tracking became possible by interfacing Kinect camera to robots, especially robotic manipulators.

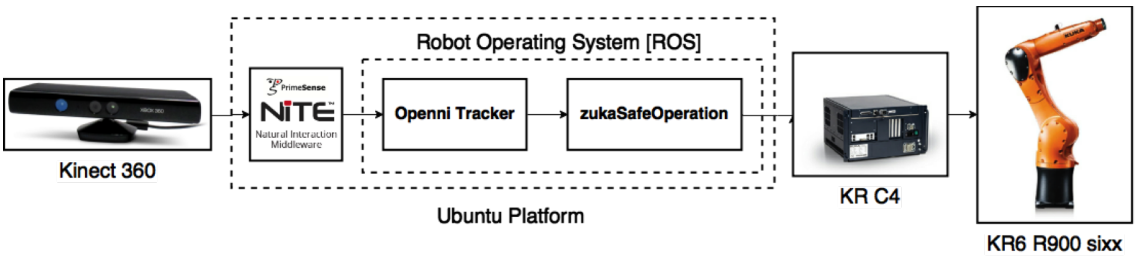


Figure 6.4: Safe Operating Zone

6.7 What we have done

We have used the Kinect and Robot Operating System (ROS) platform to implement two vision dependent systems on the KUKA robot:

- Visual Servoing System, that makes the robot moves according to the tracked person's hand position.
- Safe Operating Zone, where the robot slows down to 10

6.8 Safe Operating Zone

Human safety is the main concern which prevents performing some tasks requiring physical interaction between human and robot. Therefore, the safety concept was previously based on eliminating contact between human and robots. Using vision system, we've made it possible for the robot to detect and recognize human body, and its distance to the fixed camera, hence a safe operating zone can be acquired by sending a signal to the robot to change its speed when a human is in the safety zone. This is done by sending the RGB and depth data from the Kinect to the NiTE library, which is a middleware that provides body and skeleton detection, then reading this data by a ROS node to calculate the instantaneous distance of each human's center of mass, and the signal is sent by another ROS node that listens to the stream of the least user distance.

6.9 How to Use

- Install kukavarproxy as explained before, and make sure that everything is ok
- Install ROS, NiTE, and openni_tracker as explained before
- Launch the roscore, but don't launch the openni_tracker node
- Copy the our modified openni_tracker.cpp file to your catkin openni_tracker package. Our node publish and extra topic called /closestUser-Distance which gives the least detected distance of any tracked user without the need of standing in the psi calibration position
- Copy the zukaSafeOperation package to your catkin workspace, and run catkin_make to build the node. Don't forget to change node mode to executable if it hasn't.
- Use: rosrun zukaSafeOperation zukaSafeOperation to launch the package
- The package requires a proper internet connection through kukaproxvar, and changes the robot speed to 10% of it's speed when a user is detected within a range of 2 meters.

How to edit the detection data and the speed limits: In the source code you'll find variables to define the range, and the limited speed. Change these variables to your desired ones

Where to download:

- Edited openni_tracker: `https://github.com/mnourgwad/zuka/tree/master/codes/openni_tracker`
- zukaSafeOperation: `https://github.com/mnourgwad/zuka/tree/master/codes/zukaSafeOperation`

The true function of philosophy is to educate us in the principles of reasoning and not to put an end to further reasoning by the introduction of fixed conclusions.

— George Henry Lewes, (English philosopher and critic of literature, 1817–1878)

Chapter 7
Conclusions and Future Outlook

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