

FST

CONVEYOR

Name	Number	Uses	Description
ASI	7	-	AS-Interface

Options for 'ASI'

IPC Drive: C

Operand	Symbol	Comment
O0.0	L_I	Led: I
O0.1	L_O	Led: O
O0.3	L_Red	Led: Red Light
O0.6	BELT_FWD	Output: Makes the conveyor belt move
O0.7	BELT_ON	Output: Turn on the conveyor belt
O10.12	P1_BUMP	Output: Activates P1 stop bump
O11.3	P1_Q3	
O11.8	P2_BUMP	Output: Activates P2 stop bump
O11.15	P2_I6	Output:
O12.4	P3_BUMP	Output: Activates P3 stop bump
O12.8	P2_I5	Output:
O12.9	P3_WORK	Output: NEW PIECE / START
O12.10	P3_Q2	
O12.11	P3_Q3	
O13.12	P4_BUMP	Output: Activates p4 stop bump
O14.3	P4_Q3	
I0.0	B_I	Button: I
I0.1	B_O	Button: O
I10.8	P1_PULSE	Input: Tray pulses sensor
I10.9	P1_RDY	Input: Detects if a tray is at P1
I10.10	P1_PIECE	Input: Detects if there is a piece
I11.2	P1_Q4	Input:
I11.3	P1_Q7	Input
I11.4	P2_PULSE	Input: Tray pulses sensor
I11.5	P2_RDY	Input: Detects if a tray is at P2
I11.6	P2_PIECE	Input: Detects if there is a piece
I11.14	P2_Q6	Input: P2 Done Signal
I11.15	P2_Q7	Input: P2 Piece return signal
I12.0	P3_PULSE	Input: Tray pulses sensor
I12.1	P3_RDY	Input: Detects if a tray is at P3
I12.8	P3_IN0	
I12.9	P3_IN1	
I12.10	P3_Q7	Input: P3 Done Signal
I12.11	P3_IN3	
I13.8	P4_PULSE	Input: Tray pulses sensor
I13.9	P4_RDY	Input: Detects if a tray is at P4
I13.10	P4_PIECE	Input: Detects if there is a piece
I14.2	P4_Q4	Input:
I14.3	P4_IN3	
F1.3	F_P4_W	Flag: Position 4 Working
F2.1	F_P2_D	Flag: Position 2 Done
F2.2	F_P3_D	Flag: Position 3 Done
F3.0	Mode1	
F3.1	Mode2	
F3.2	Mode3	
F3.3	debounc1	Create a delay for debouncing
F3.4	debounc2	Create a delay for debouncing
F4.0	p3_piece	Flag: Tells position 3 if there is p
F4.1	F_inProg	Flag: Station with work in progress
F63.0	S_RUN	State: Run
FW5 (U)	F_Type	Flag: Piece Type 1 --> 2
FW10 (U)	C_P1	Counter: Position 1 current tray
FW11 (U)	C_P2	Counter: Position 2 current tray
FW12 (U)	C_P3	Counter: Position 3 current tray
FW13 (U)	C_P4	Counter: Position 4 current tray

0001

P5

(S)

P1

(S)

P2

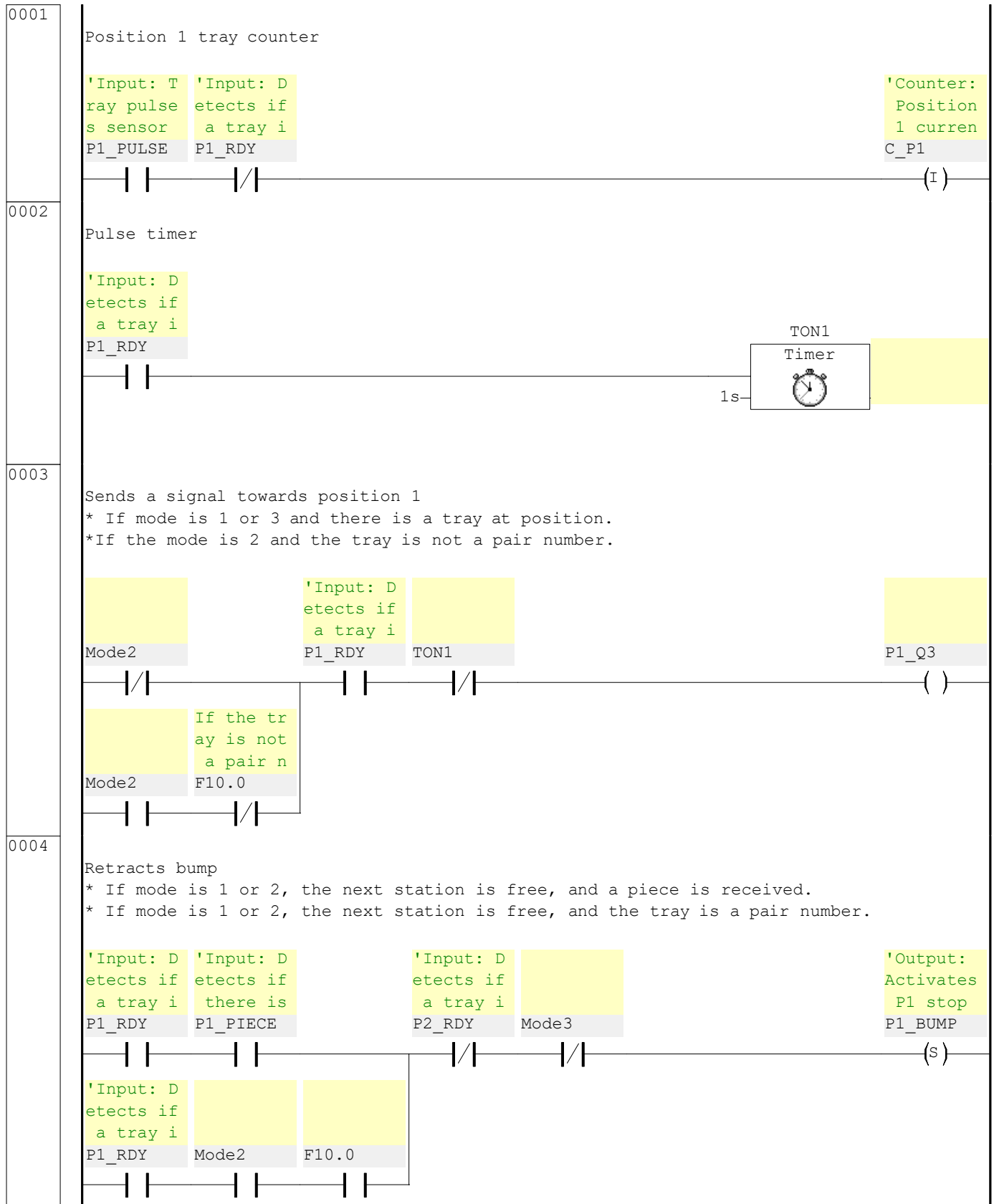
(S)

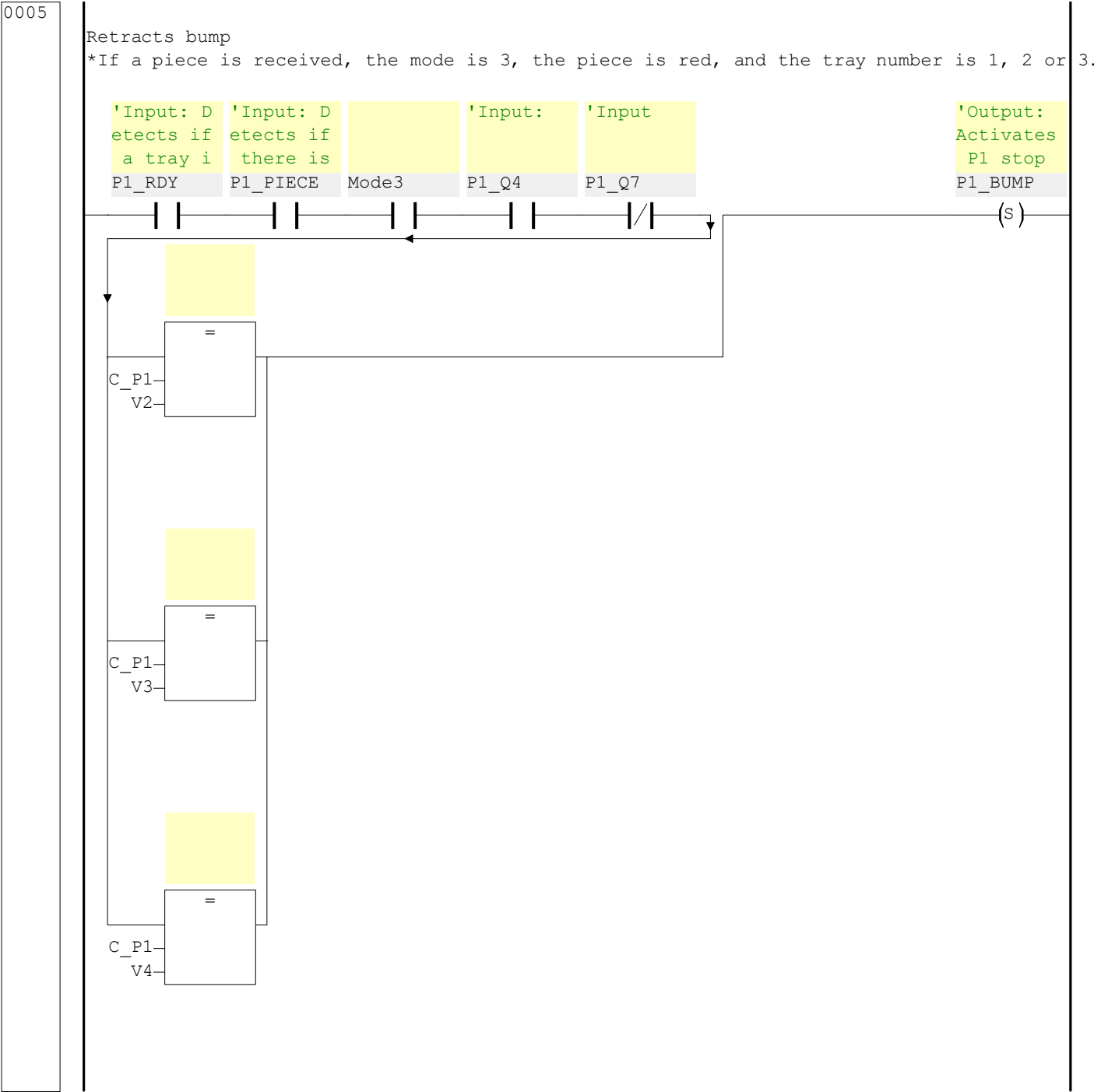
P3

(S)

P4

(S)

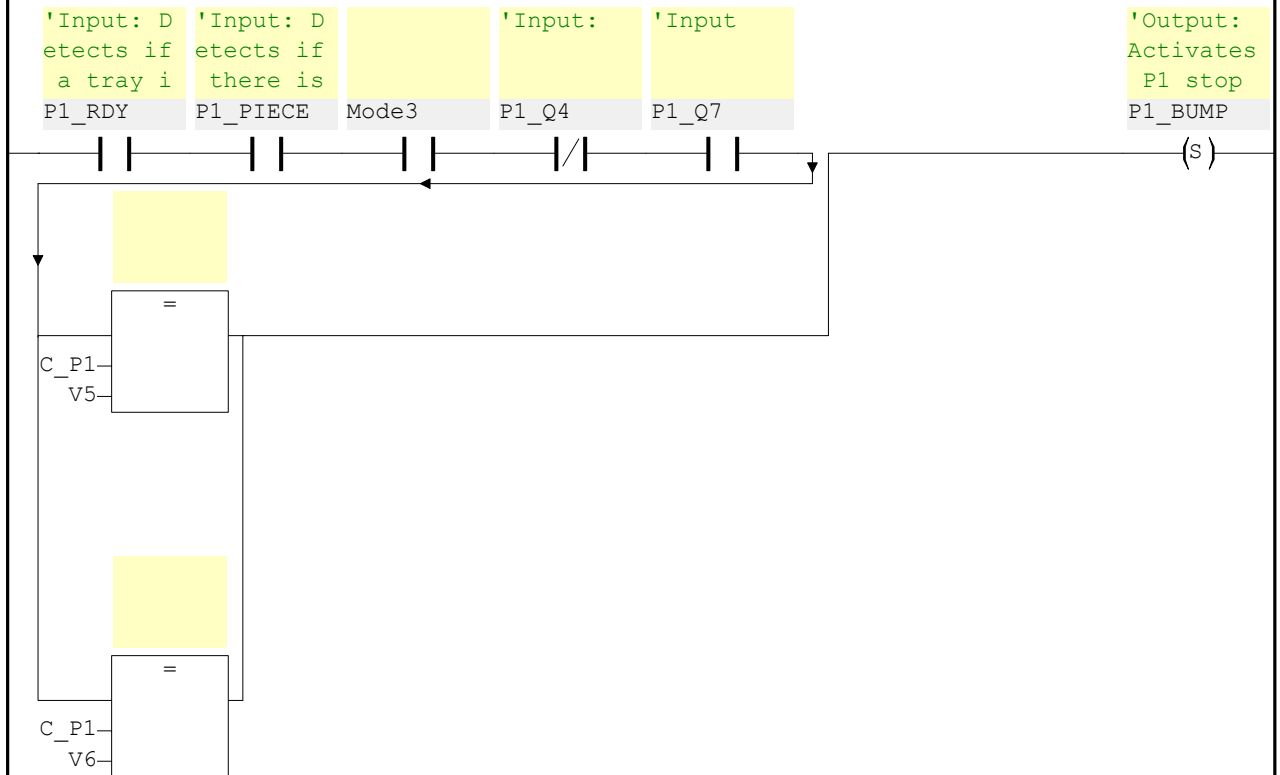


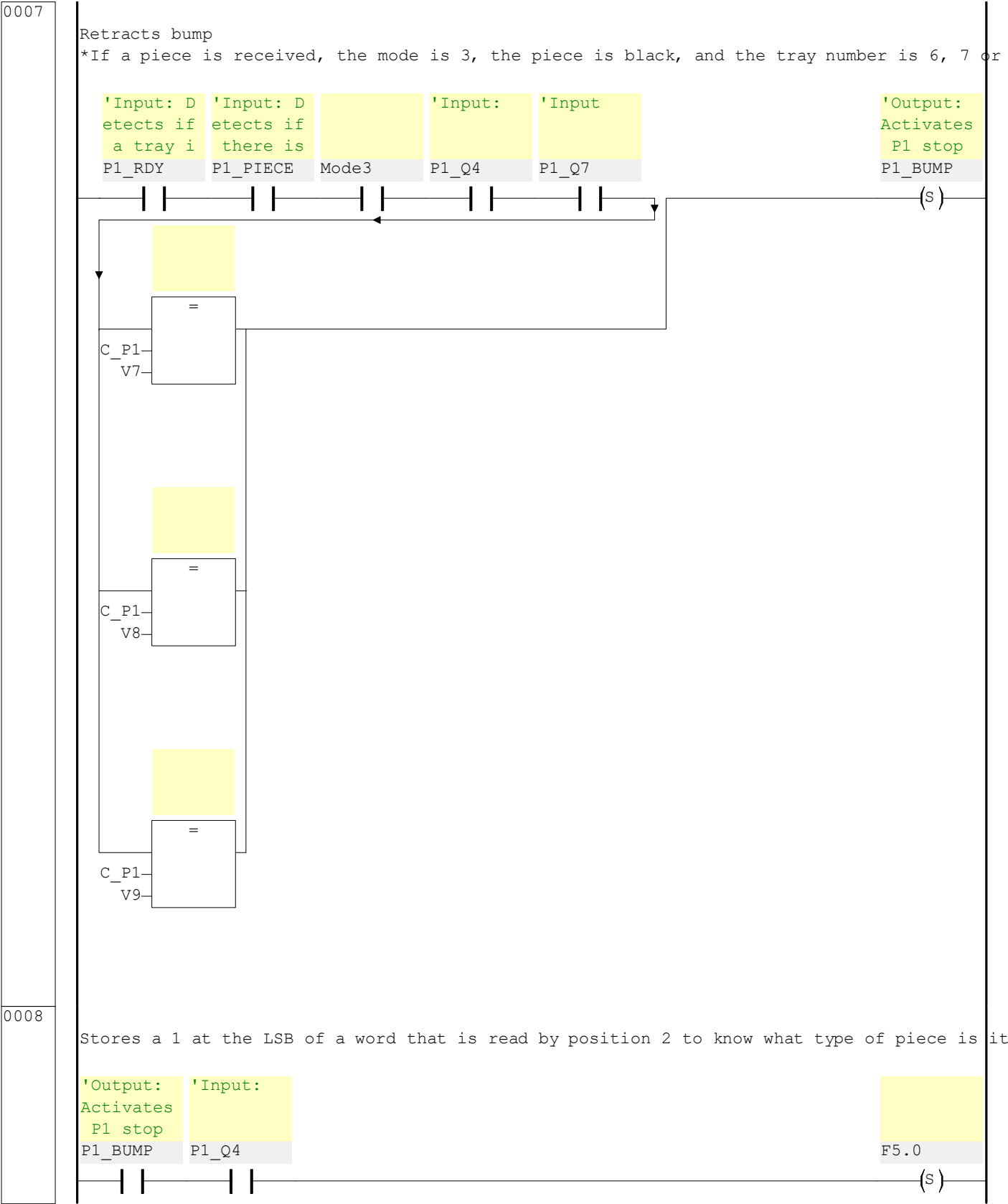


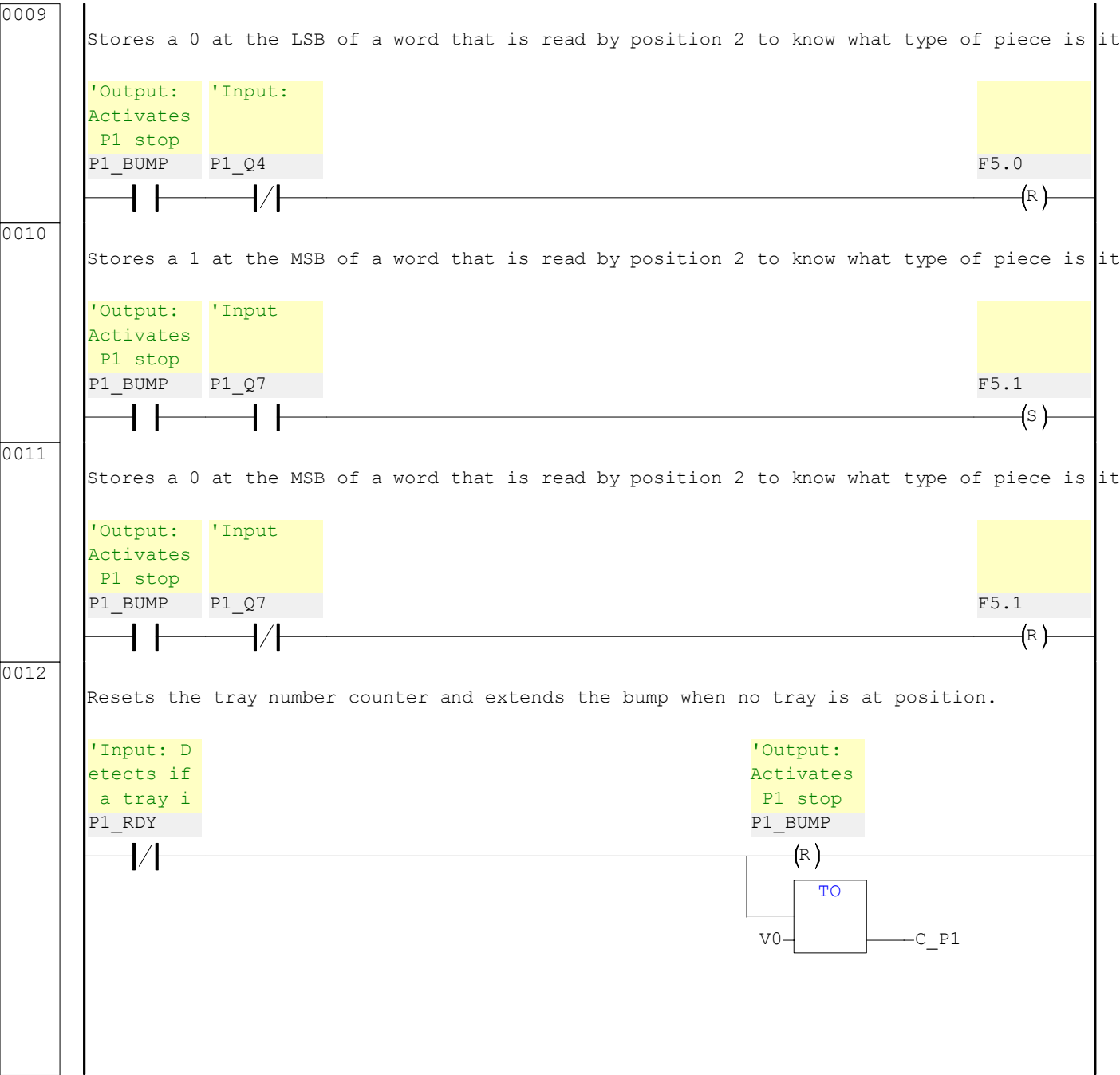
0006

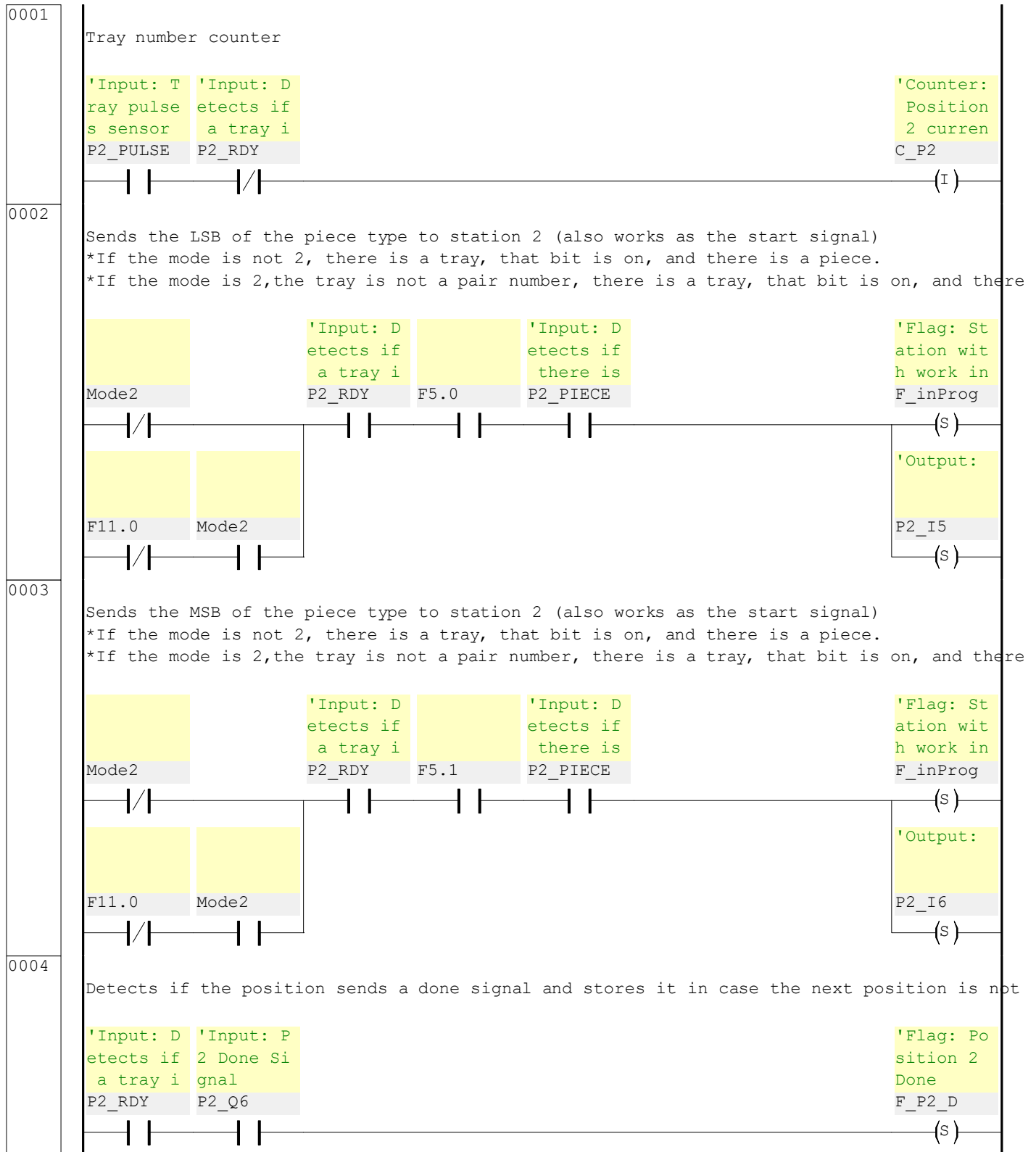
Retracts bump

*If a piece is received, the mode is 3, the piece is metallic, and the tray number is 4, or









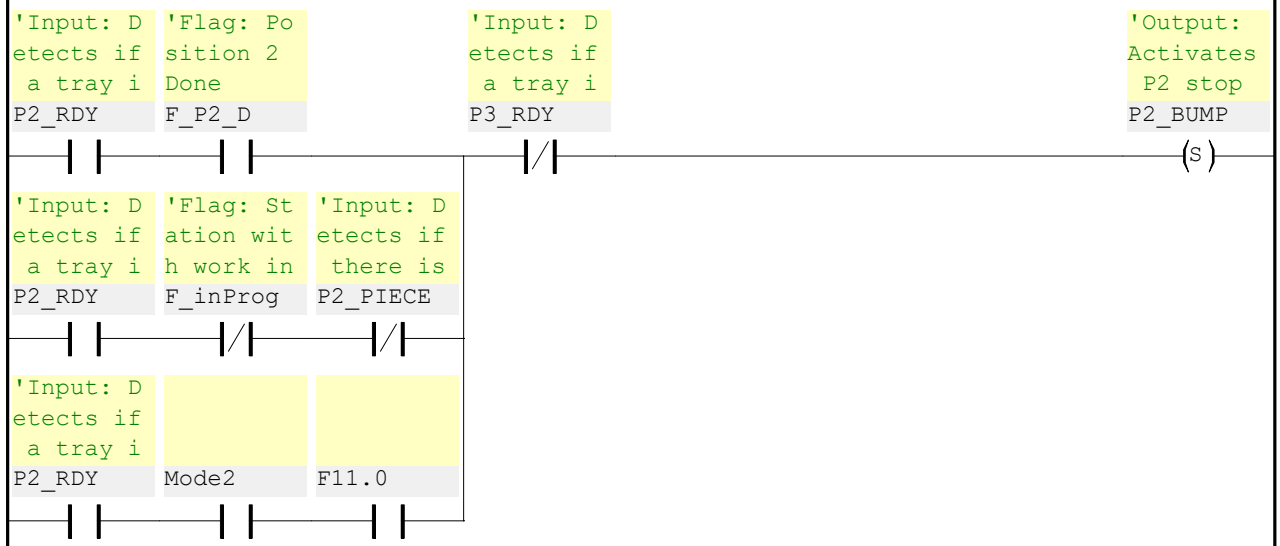
0005

Retracts the bump

* If there is a tray, the position is done, and the next position is free.

* If there is a tray, it is not in the middle of work with the piece, there is no piece, ar

* If there is a tray, it is the 2nd mode, the tray is an even number.



0006

When there is no tray at positon
Resets all flags, the position counter, and extends the bump.

'Input: Detects if a tray is present
P2_RDY



'Flag: Station with work in progress
F_inProg



'Output: P2_I5



'Output: P2_I6



'Create a delay for debounce
debounc1



'Flag: Position 2 Done
F_P2_D



'Output: Activates P2 stop
P2_BUMP

