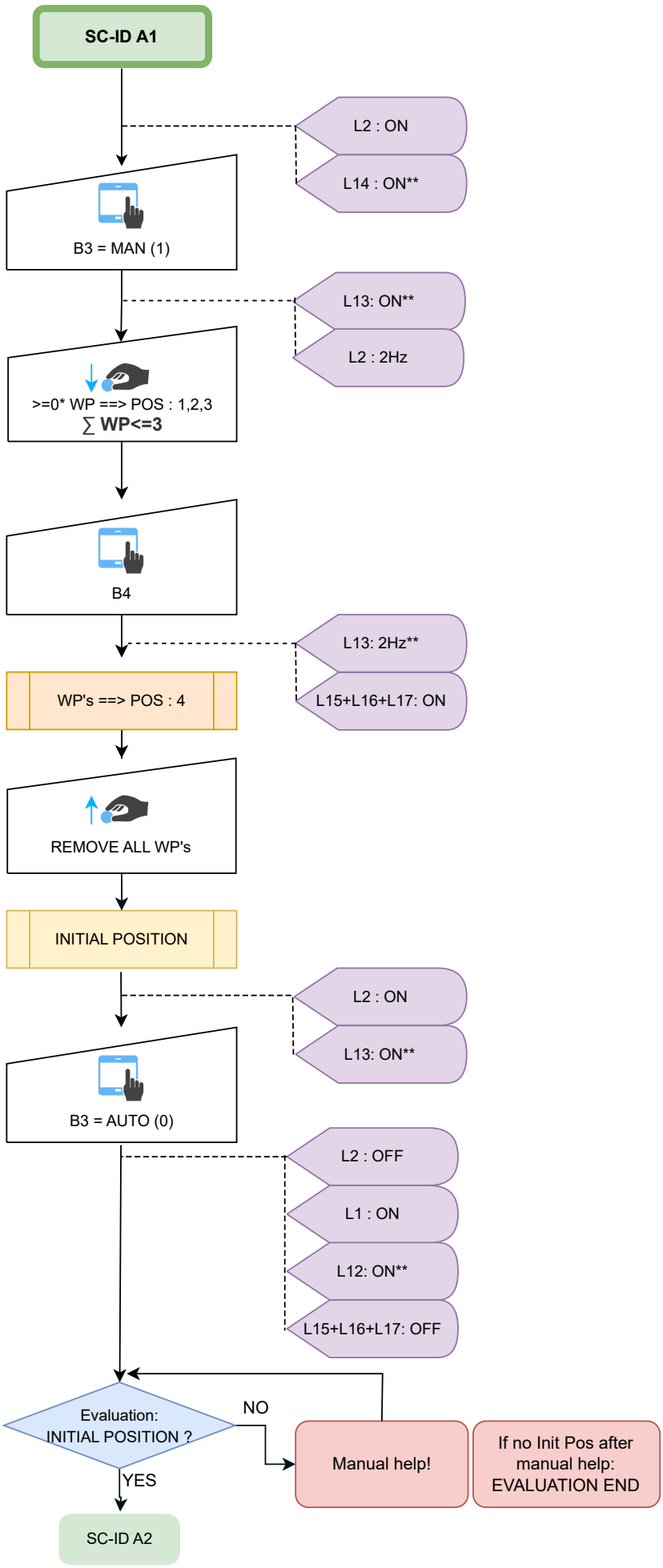
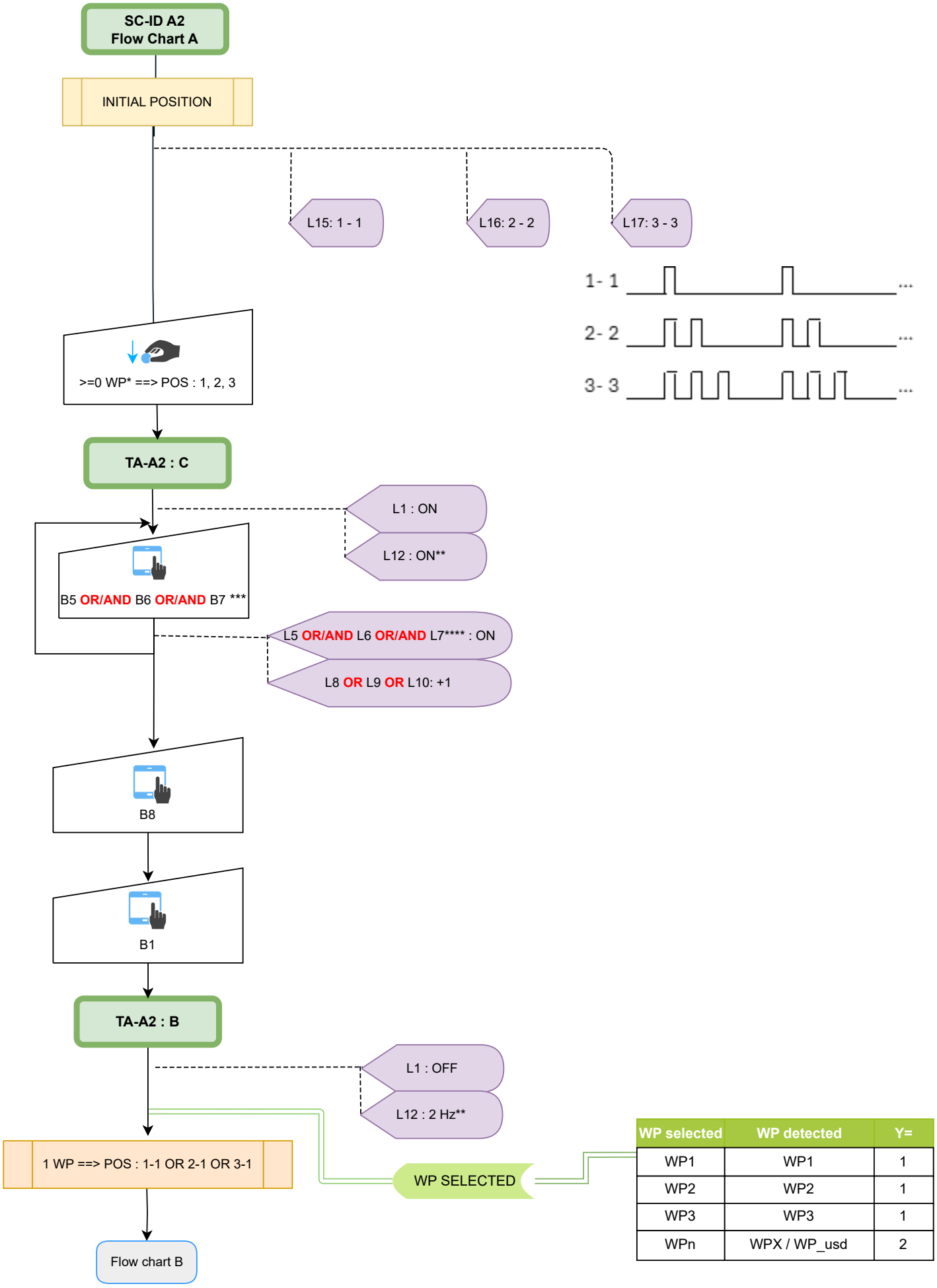
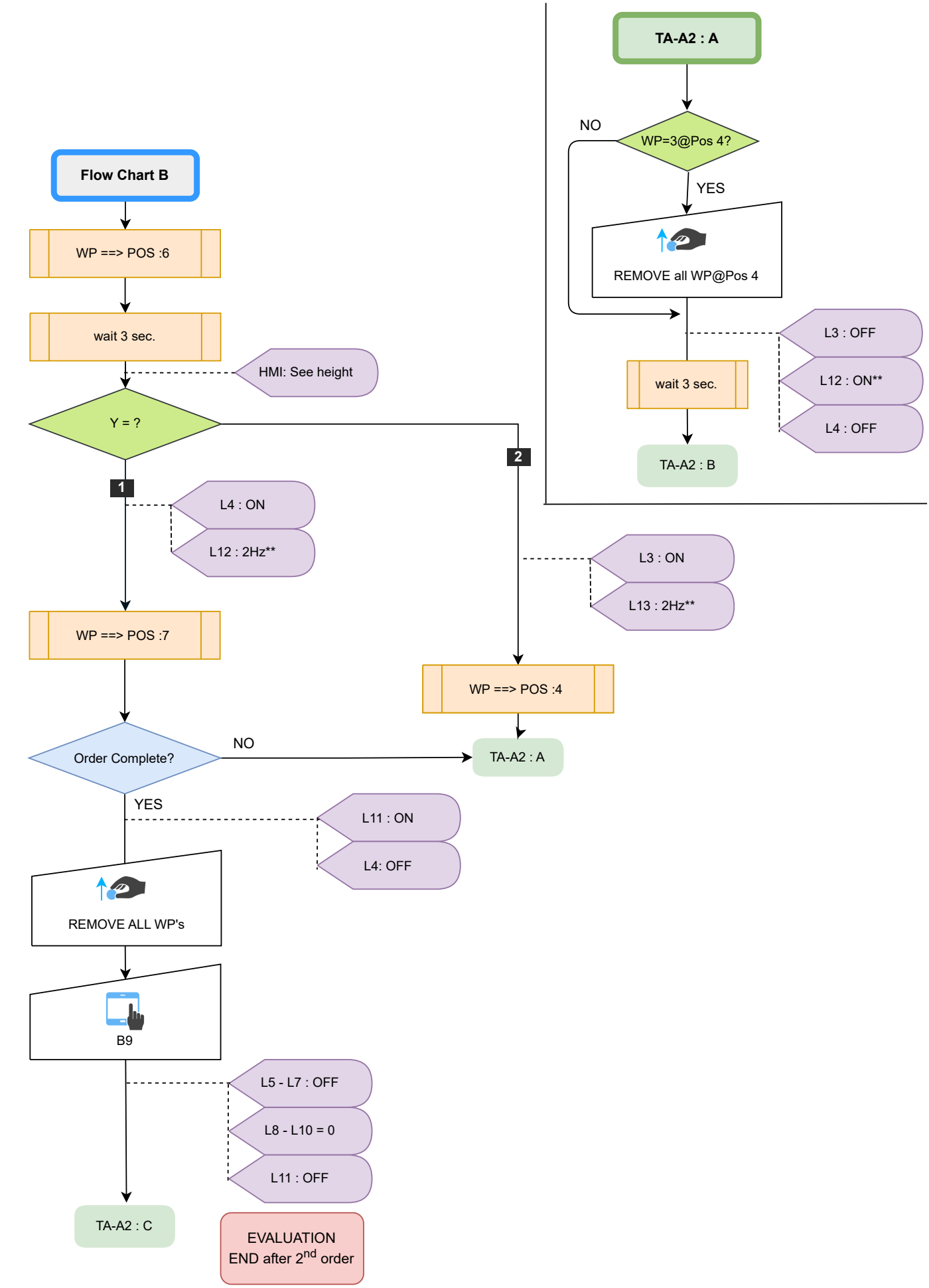

SC-ID A1
L2 : ON
L14 : ON**
B3 = MAN (1)
L13: ON**
L2 : 2Hz
>=0* WP ==> POS : 1,2,3
∑ WP<=3
B4
L13: 2Hz**
L15+L16+L17: ON
WP's ==> POS : 4
REMOVE ALL WP's
INITIAL POSITION
L2 : ON
L13: ON**
B3 = AUTO (0)
L2 : OFF
L1 : ON
L12: ON**
L15+L16+L17: OFF
Evaluation:
INITIAL POSITION ?
NO
YES
Manual help!
If no Init Pos after manual help: EVALUATION END
SC-ID A2

Task A, SC-ID A2 : Function Quality of production and signals 1/2



WP selected	WP detected	Y=
WP1	WP1	1
WP2	WP2	1
WP3	WP3	1
WPn	WPX / WP_usd	2


Flow Chart B
WP ==> POS :6
wait 3 sec.
HMI: See height
Y = ?
1
2
L4 : ON
L12 : 2Hz**
WP ==> POS :7
Order Complete?
NO
YES
L11 : ON
L4: OFF
REMOVE ALL WP's
B9
L5 - L7 : OFF
L8 - L10 = 0
L11 : OFF
TA-A2 : C
EVALUATION
END after 2nd order
L3 : ON
L13 : 2Hz**
WP ==> POS :4
TA-A2 : A
TA-A2 : A
NO
WP=3@Pos 4?
YES
REMOVE all WP@Pos 4
wait 3 sec.
L3 : OFF
L12 : ON**
L4 : OFF
TA-A2 : B