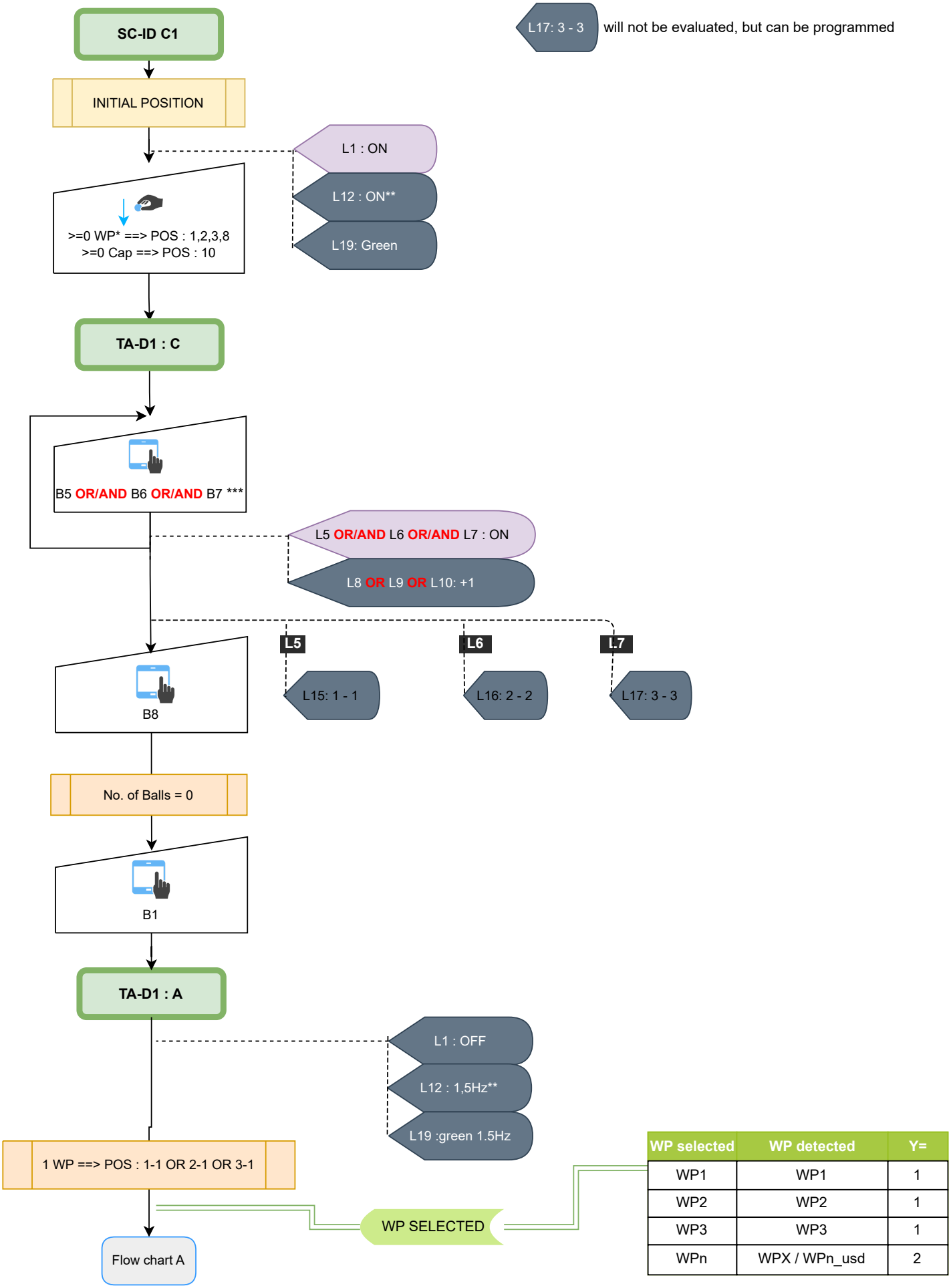
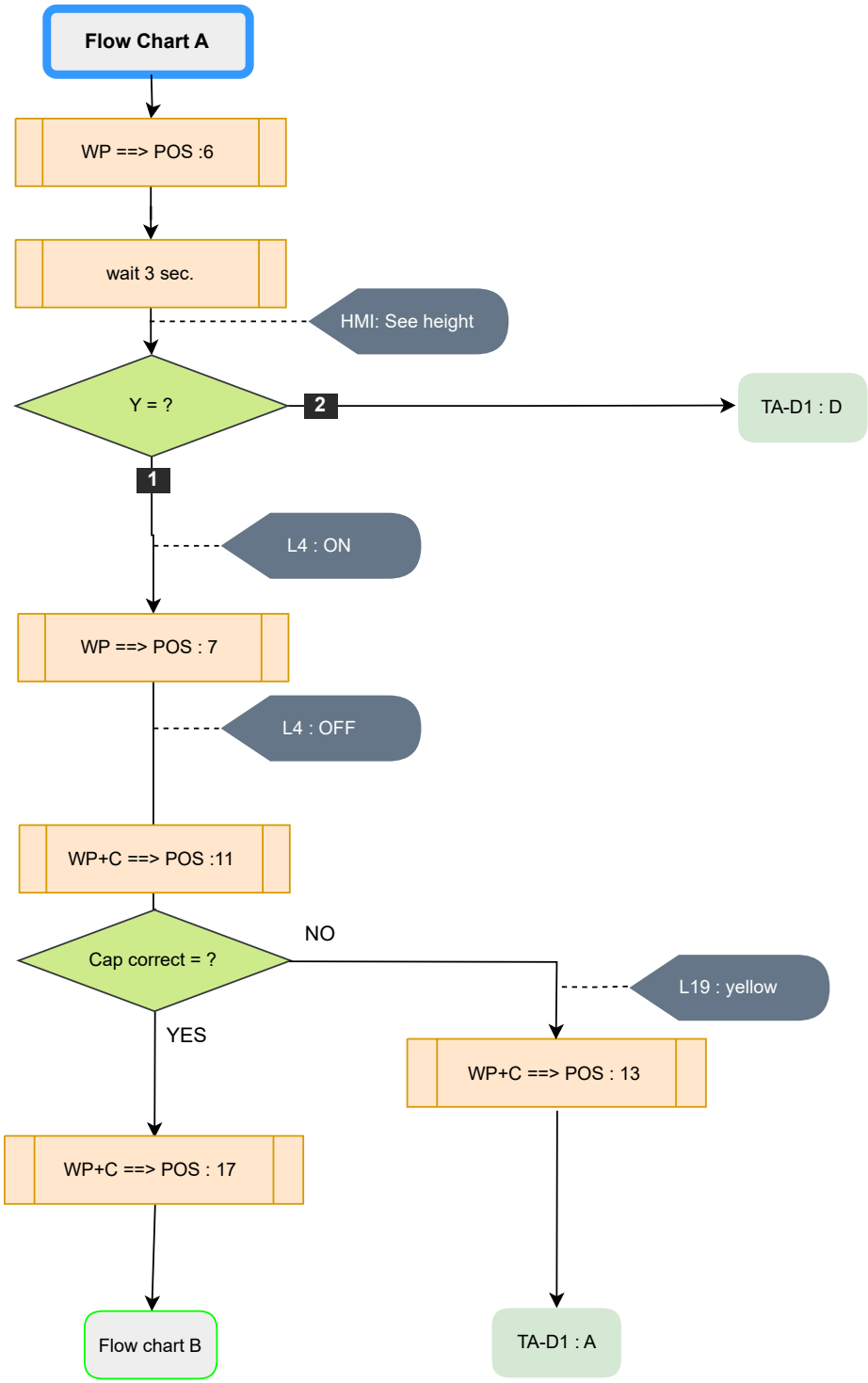
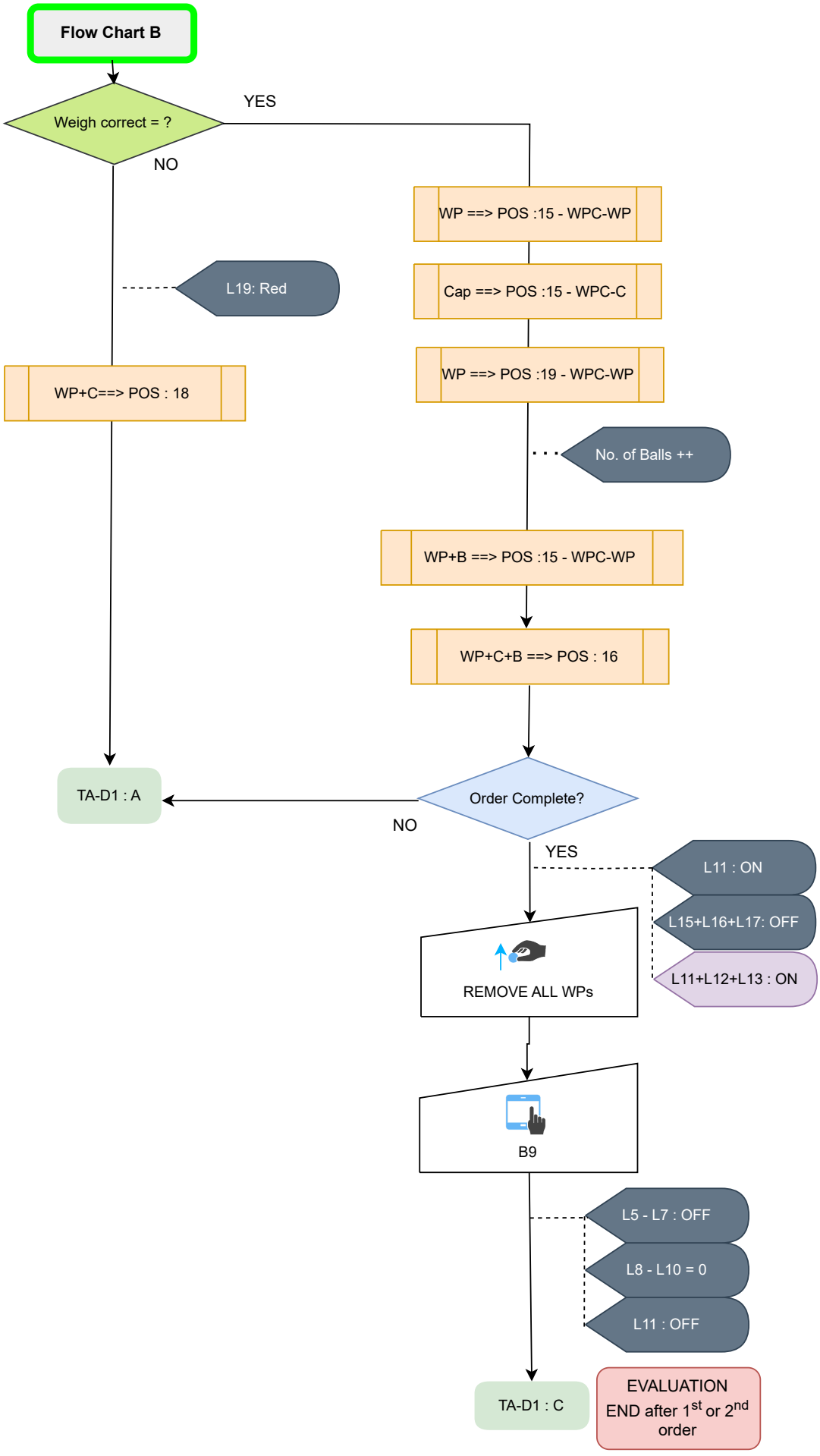
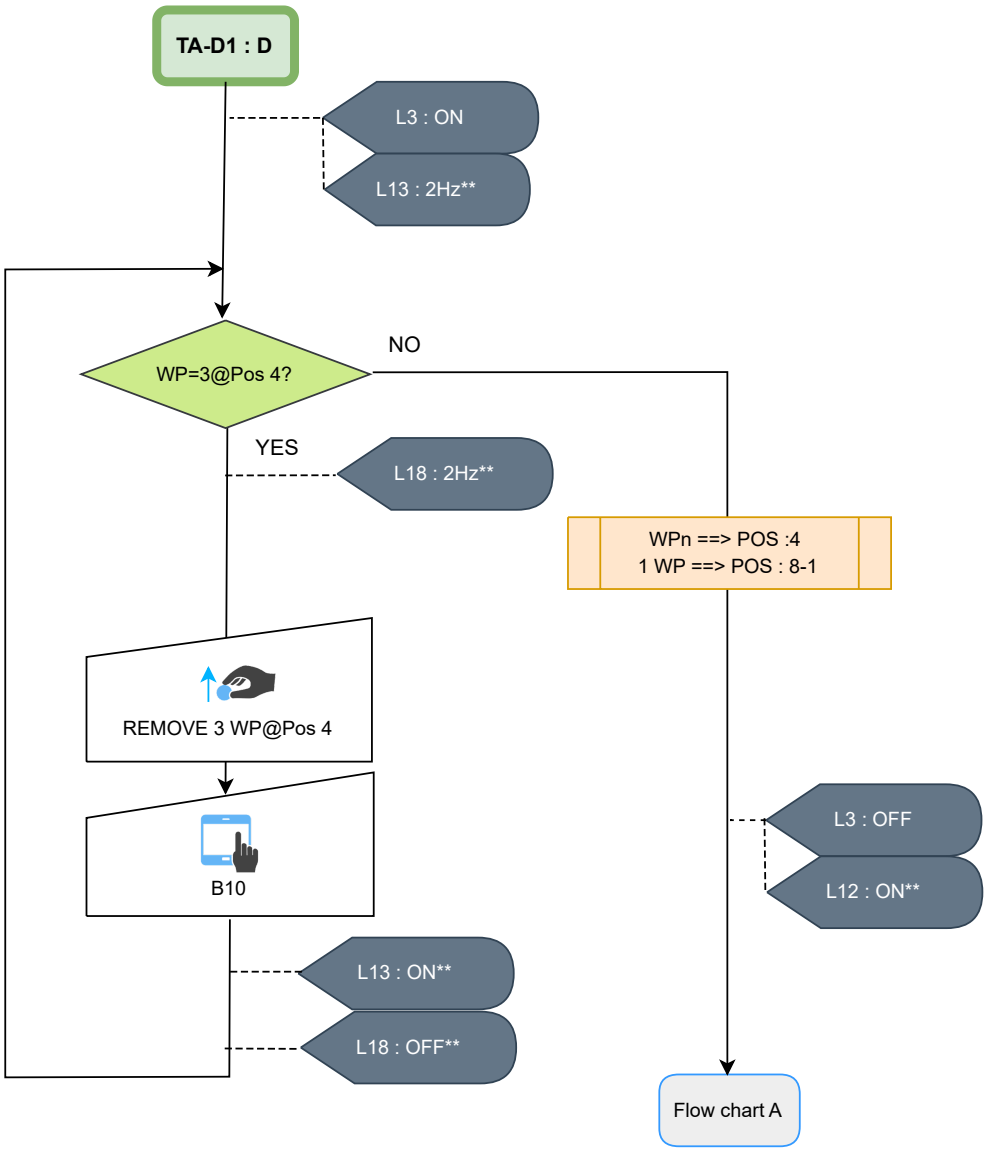
Task D, SC-ID D1 : Function Quality of production and signals 1/4



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


Flow Chart A
WP ==> POS :6
wait 3 sec.
HMI: See height
Y = ?
2
TA-D1 : D
1
L4 : ON
WP ==> POS : 7
L4 : OFF
WP+C ==> POS :11
Cap correct = ?
NO
L19 : yellow
YES
WP+C ==> POS : 13
WP+C ==> POS : 17
Flow chart B
TA-D1 : A


Flow Chart B
Weigh correct = ?
YES
NO
L19: Red
WP+C==> POS : 18
WP ==> POS :15 - WPC-WP
Cap ==> POS :15 - WPC-C
WP ==> POS :19 - WPC-WP
No. of Balls ++
WP+B ==> POS :15 - WPC-WP
WP+C+B ==> POS : 16
Order Complete?
NO
TA-D1 : A
YES
L11 : ON
L15+L16+L17: OFF
L11+L12+L13 : ON
REMOVE ALL WPs
B9
L5 - L7 : OFF
L8 - L10 = 0
L11 : OFF
TA-D1 : C
EVALUATION
END after 1st or 2nd order


TA-D1 : D
L3 : ON
L13 : 2Hz**
WP=3@Pos 4?
NO
YES
L18 : 2Hz**
WPn ==> POS :4
1 WP ==> POS : 8-1
REMOVE 3 WP@Pos 4
B10
L3 : OFF
L12 : ON**
L13 : ON**
L18 : OFF**
Flow chart A