

FESTO MPS

Sensors – Actuators List¹

IPT-name	In-IPPs	Out-IPPs
Feeder	S1: sensor for back stop	A1: push-out cylinder move forward
	S2: sensor for front stop	A2: push-out cylinder move backward
		A3: stop
Converter	S3: workpiece sensor (position A)	
	S4: sensor for right stop (position A)	A4: pneumatic sucker move right
	S5: sensor for left stop (position B)	A5: pneumatic sucker move left
	S6: Piece sucked in	A6: vakuumOn()
		A7:vakuumOff()
		A8:stop
Detection Module	S7: workpiece sensor (position B)	
	S8: height sensor	
	S9: sensor for color	
	S10: sensor for material	
Shift out cylinder	S11: sensor for back stop	A9: shift out cylinder move backward
	S12: sensor for front stop	A10: shift out cylinder move forward
		A11: stop
Elevator	S13: sensor for lower stop	A12: elevating cylinder move down
	S14: sensor for upper stop	A13: elevating cylinder move up
		A14: stop
Rotating disc	S15: workpiece present in position 1	
	S16: workpiece present in position 2	
	S17: workpiece present in position 3	
	S18: workpiece present in position 4	A15: stop

¹ The list contains sensors and actuators that have been used for the development of the prototype IEC 61499 compliant FESTO MPS control application. This is part of the documentation of the FESTO MPS example application that was developed by SEG.

	S19: rotary indexing table has finished a 90 rotation	A16: rotate 90 clockwise
Drilling machine		A17:drill
	S20: workpiece bracked-in	A18: clamp cylinder brack-in
	S21: wokpiece bracked-out	A19: clamp cylinder brack-out
	S22: lifting cylinder up	A20: lifting cylinder move up
	S23: lifting cylinder down	A21: lifting cylinder move down
		A22:stop lifting cylinder
		A31: stop drilling
		A32: stop bracking
Checking machine	S24: checking cylinder up	A23: checking cylinder move-up
	S25: checking cylinder down	A24: checking cylinder move-down
		A25: stop checking machine
WarehouseCylinder	S26: cylinder returned to disc	A26: Warehouse Cylinder return2disc
	S27: piece removed from table	A27: Warehouse Cylinder removes piece from table
	S28: vakuum has been started	A28: start vakuum
		A29: stop vakuum
		A34: stop Cylinder

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