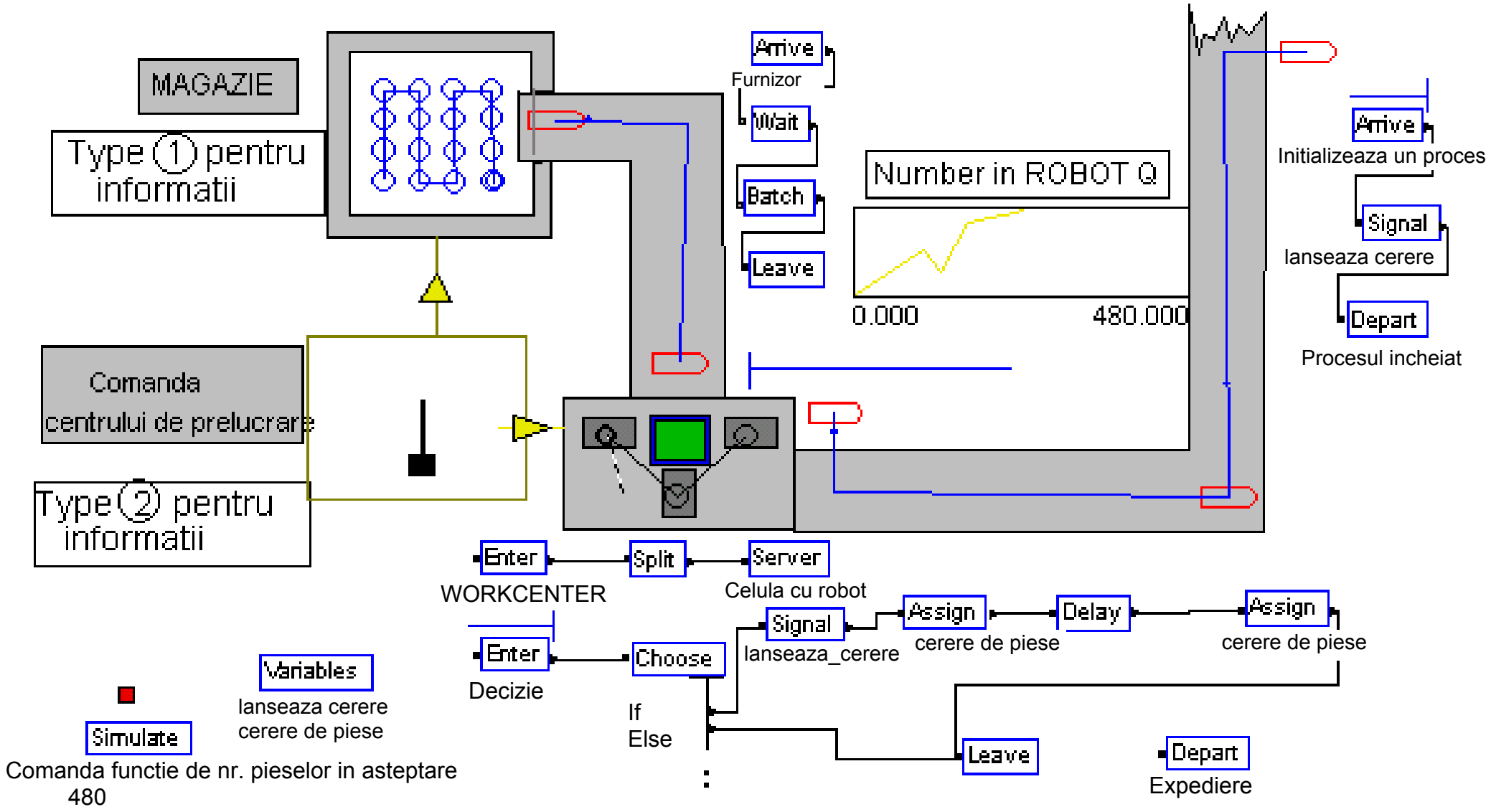
Comanda unei celule utilizand comenzile Wait si Signal



1 Sosirea pieselor

Piesele asteapta in Magazie semnalul de la Sistemul de comanda a·celulei pentru a fi directionate catre robot (care serveste celula de fabricatie -Workcenter)

Stocul din Magazie este reinnoit periodic, astfel incat mereu vor fi piese la dispozitie pentru celula.

2 Comanda centrului de prelucrare

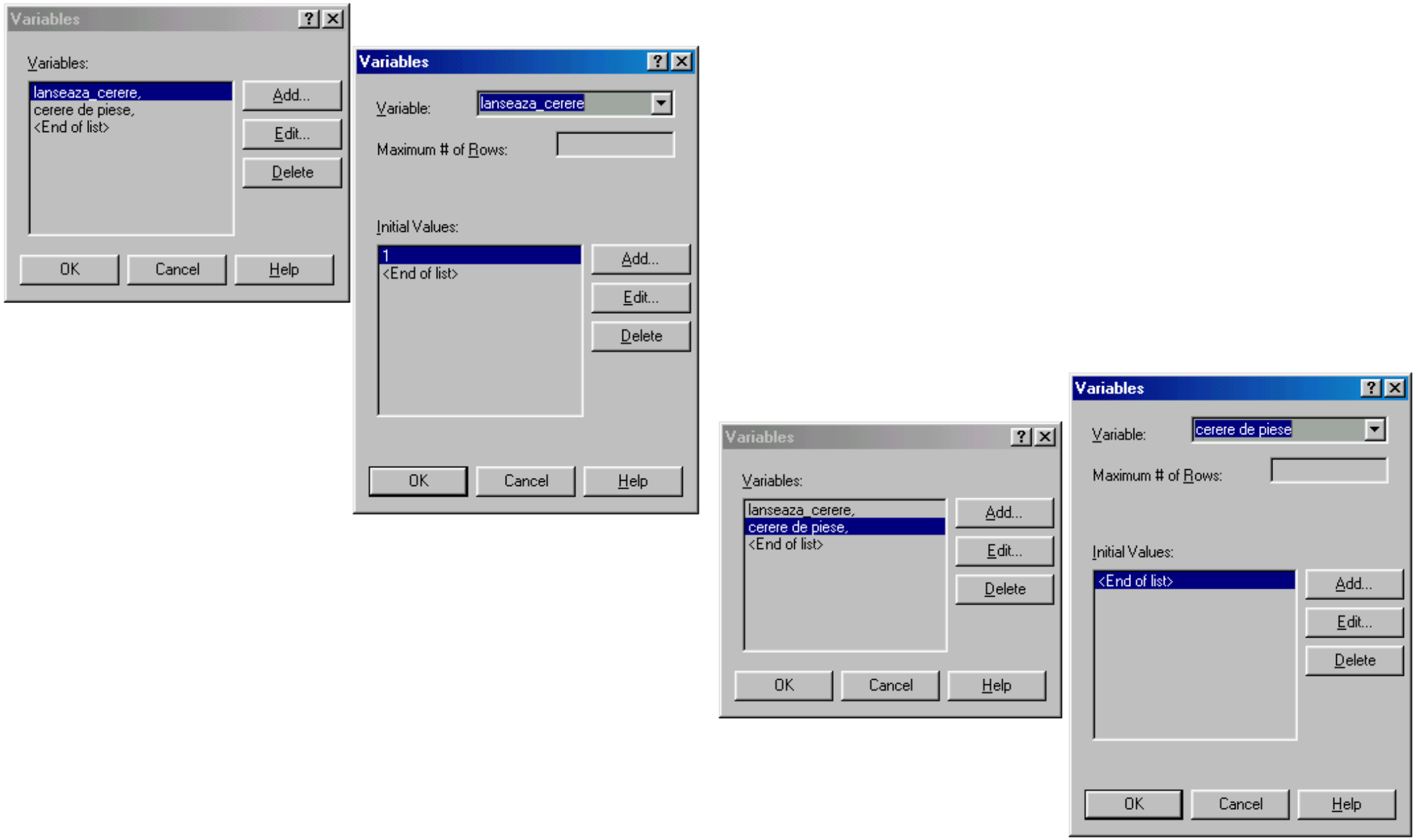
Sistemul de comanda monitorizeaza numarul de piese in asteptare la celula de fabricatie, precum si disponibili-tatea celulei;

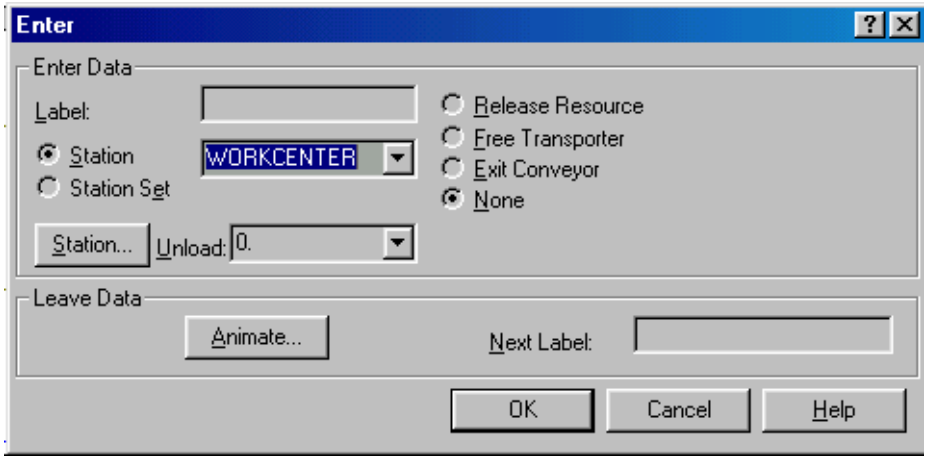
El trimite catre magazie un ordin de lansare pentru un nou lot de piese, daca:

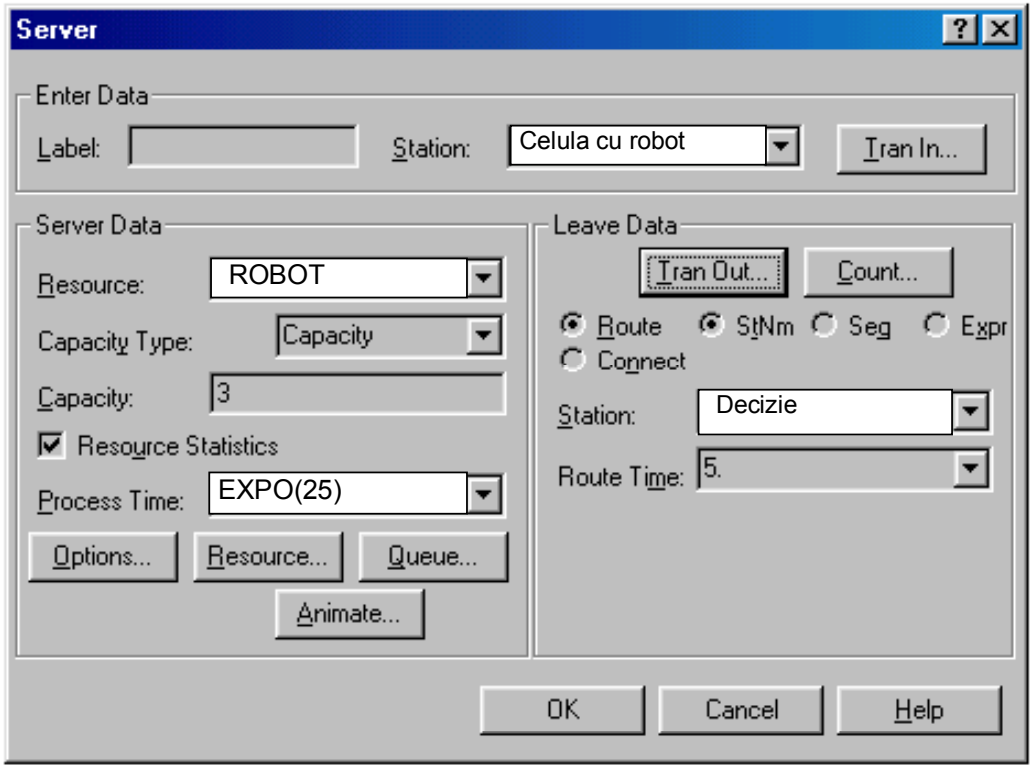
1. Celula este libera si disponibila
2. Numarul de piese in asteptare este mai mic de 5

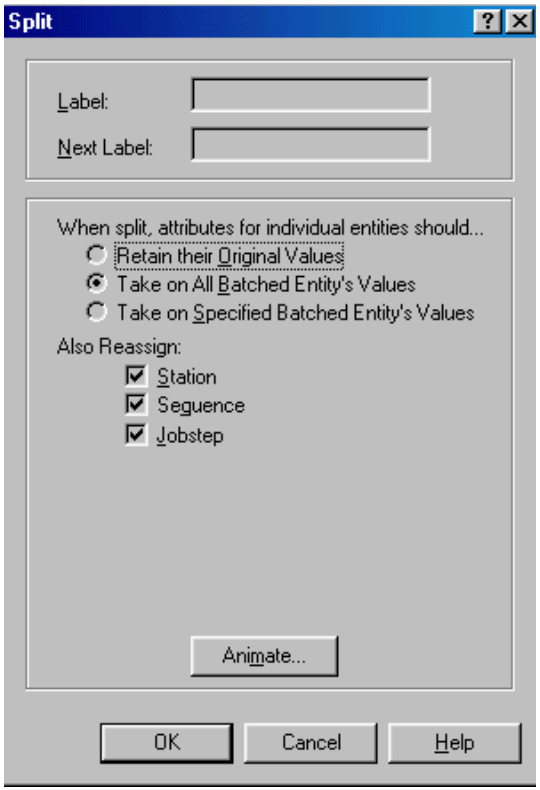
In felul acesta se asigura de lucru in permanenta celulei iar sirul de piese in asteptare nu depasete limita impusa

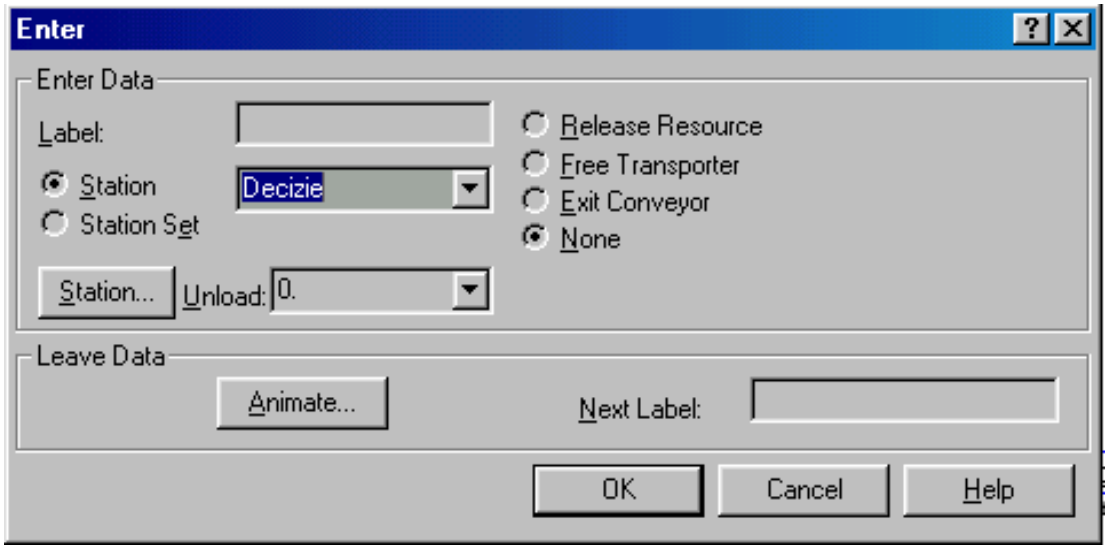
Procesul din amonte este comandat de procesul din aval, o logica similara fiind caracteristica si modelarii sistemelor JIT.

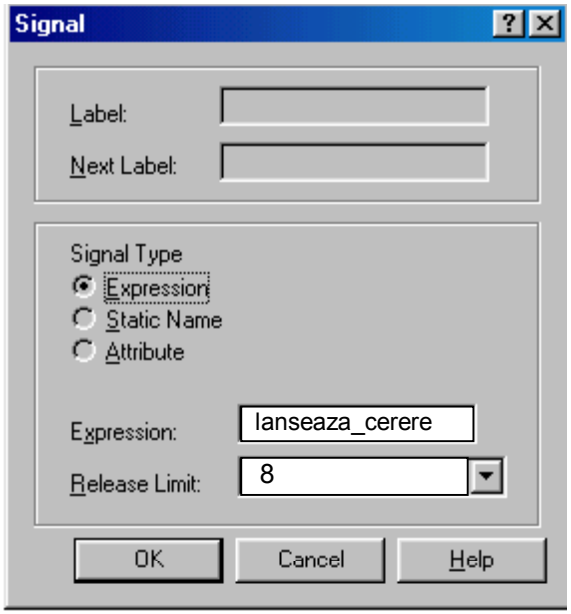

Variables
Variables:
lanseaza_cerere,
cerere de piese,
<End of list>
Add...
Edit...
Delete
OK
Cancel
Help
Variables
Variable:
lanseaza_cerere
Maximum # of Rows:
Initial Values:
1
<End of list>
Add...
Edit...
Delete
OK
Cancel
Help
Variables
Variables:
lanseaza_cerere,
cerere de piese,
<End of list>
Add...
Edit...
Delete
OK
Cancel
Help
Variables
Variable:
cerere de piese
Maximum # of Rows:
Initial Values:
<End of list>
Add...
Edit...
Delete
OK
Cancel
Help

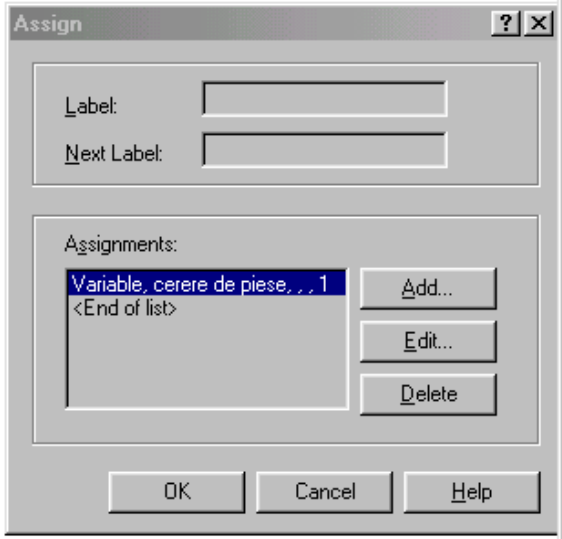

Enter
Enter Data
Label:
Station
Station Set
WORKCENTER
Release Resource
Free Transporter
Exit Conveyor
None
Station...
Unload:
0.
Leave Data
Animate...
Next Label:
OK
Cancel
Help


Server
Enter Data
Label:
Station:
Celula cu robot
Tran In...
Server Data
Resource:
ROBOT
Capacity Type:
Capacity
Capacity:
3
Resource Statistics
Process Time:
EXPO(25)
Options...
Resource...
Queue...
Animate...
Leave Data
Tran Out...
Count...
Route
StNm
Seq
Expr
Connect
Station:
Decizie
Route Time:
5.
OK
Cancel
Help

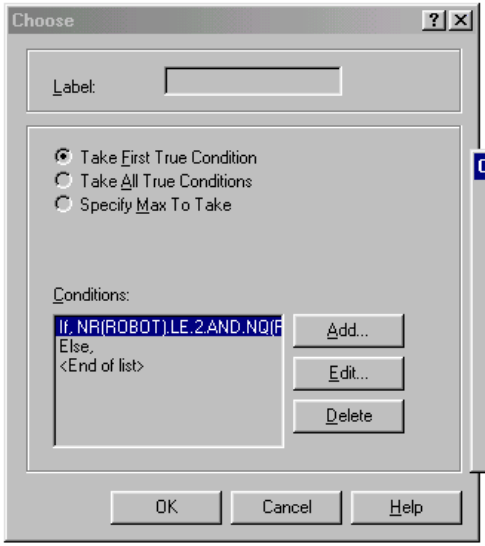

Split
Label:
Next Label:
When split, attributes for individual entities should...
Retain their Original Values
Take on All Batched Entity's Values
Take on Specified Batched Entity's Values
Also Reassign:
Station
Seguence
Jobstep
Animate...
OK
Cancel
Help

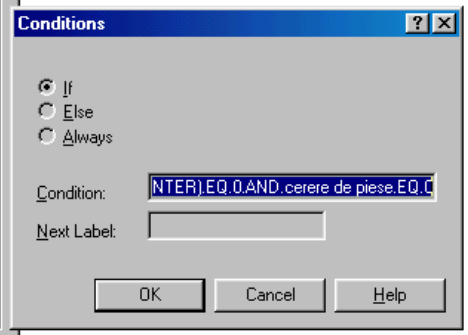

Enter
Enter Data
Label:
Station
Station Set
Decizie
Release Resource
Free Transporter
Exit Conveyor
None
Station...
Unload:
0.
Leave Data
Animate...
Next Label:
OK
Cancel
Help

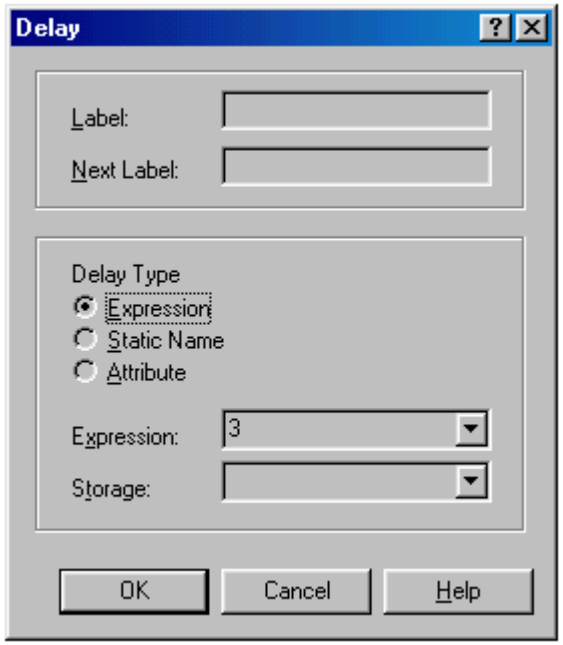

Signal
Label:
Next Label:
Signal Type
Expression
Static Name
Attribute
Expression:
lanseaza_cerere
Release Limit:
8
OK
Cancel
Help

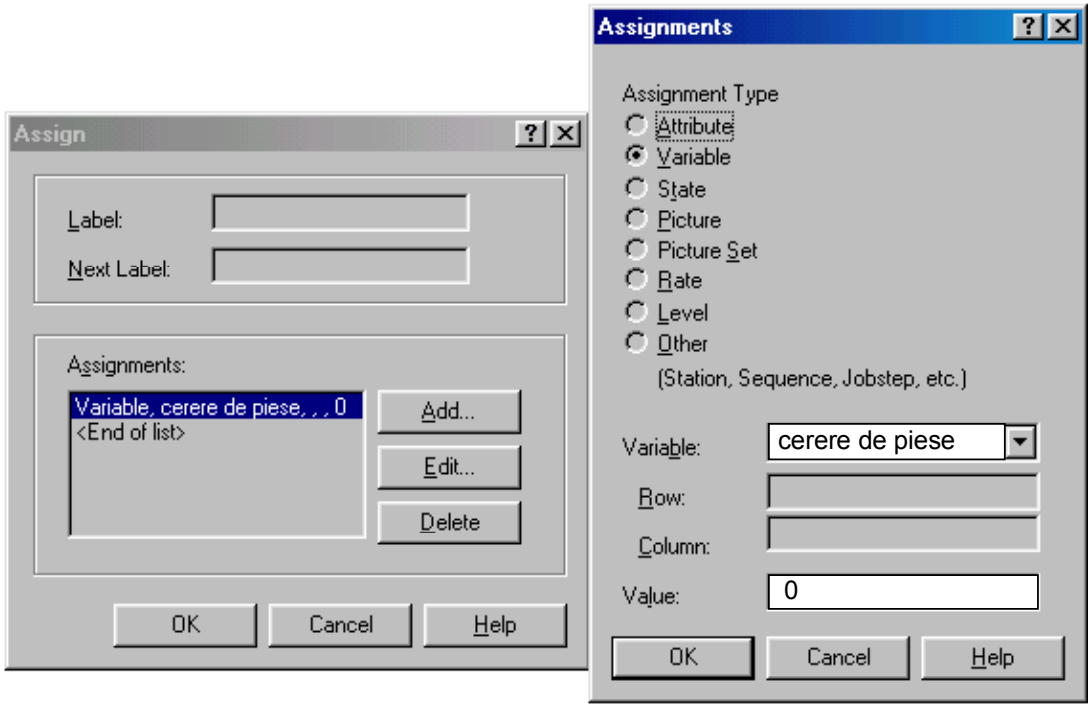

Assign
Label:
Next Label:
Assignments:
Variable, cerere de piese, , , 1
<End of list>
Add...
Edit...
Delete
OK
Cancel
Help

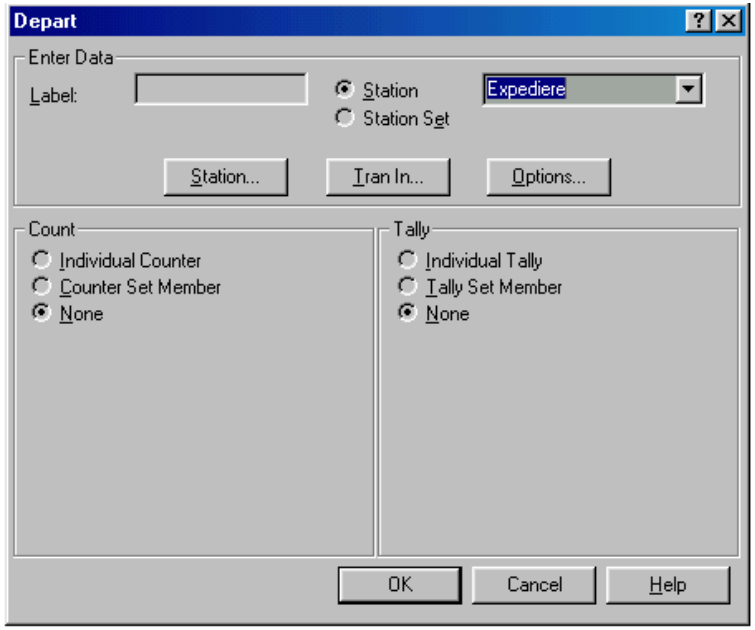
Assignments
Assignment Type
Attribute
Variable
State
Picture
Picture Set
Rate
Level
Other
(Station, Sequence, Jobstep, etc.)
Variable:
cerere de piese
Row:
Column:
Value:
1
OK
Cancel
Help

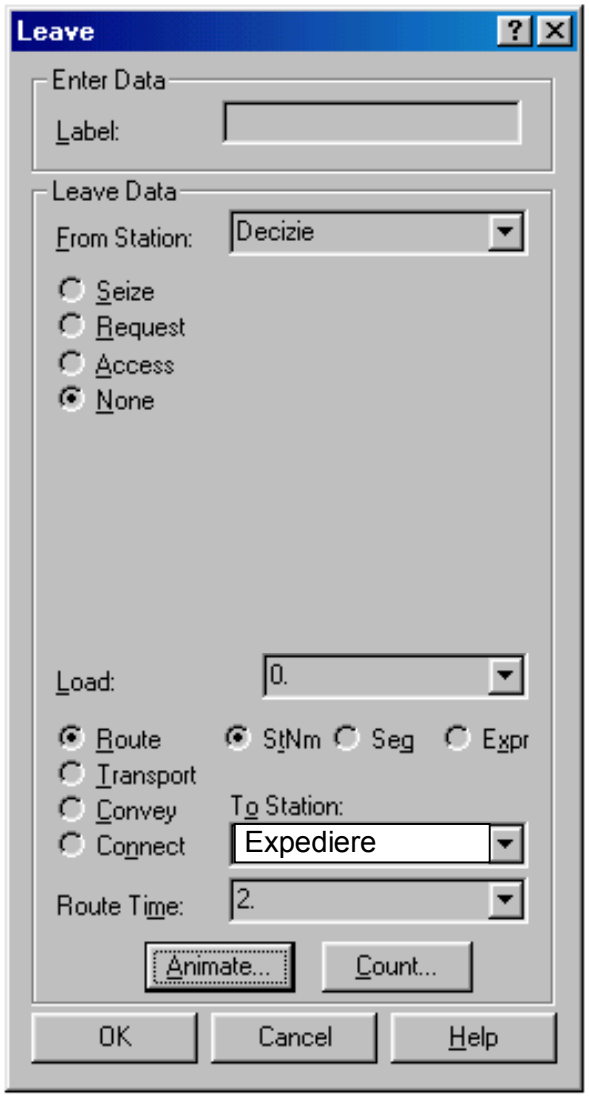

Choose
Label:
Take First True Condition
Take All True Conditions
Specify Max To Take
Conditions:
If, NR(ROBOT).LE.2.AND.NQ(F
Else,
<End of list>
Add...
Edit...
Delete
OK
Cancel
Help

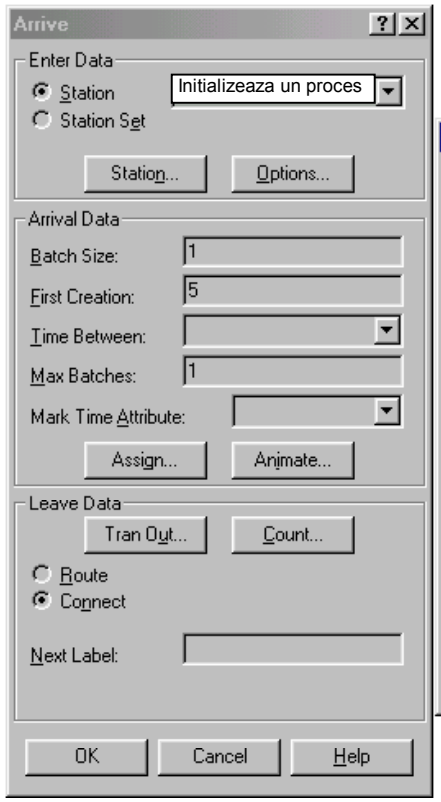

Conditions
If
Else
Always
Condition:
NTER).EQ.0.AND.cerere de piese.EQ.0
Next Label:
OK
Cancel
Help


Delay
Label:
Next Label:
Delay Type
Expression
Static Name
Attribute
Expression:
3
Storage:
OK
Cancel
Help

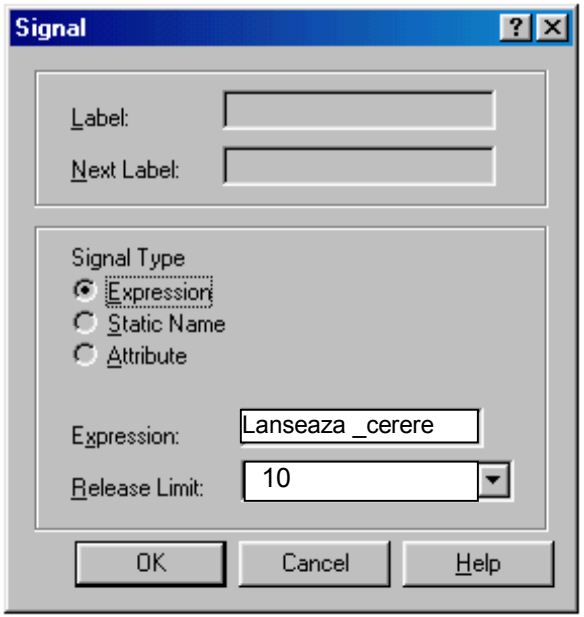

Assign
Label:
Next Label:
Assignments:
Variable, cerere de piese, , , 0
<End of list>
Add...
Edit...
Delete
OK
Cancel
Help
Assignments
Assignment Type
Attribute
Variable
State
Picture
Picture Set
Rate
Level
Other
(Station, Sequence, Jobstep, etc.)
Variable:
cerere de piese
Row:
Column:
Value:
0
OK
Cancel
Help

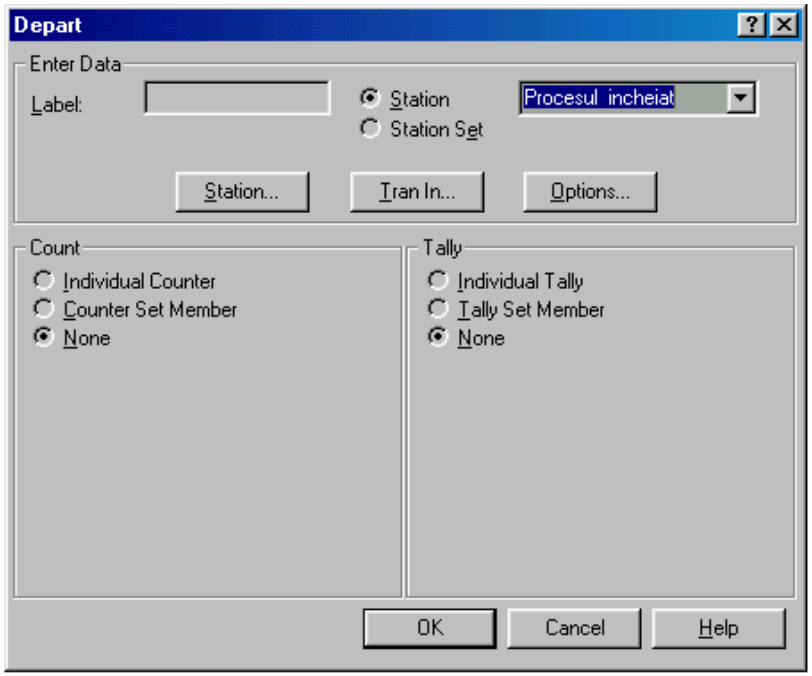

Depart
Enter Data
Label:
Station
Station Set
Expediere
Station...
Tran In...
Options...
Count
Individual Counter
Counter Set Member
None
Tally
Individual Tally
Tally Set Member
None
OK
Cancel
Help

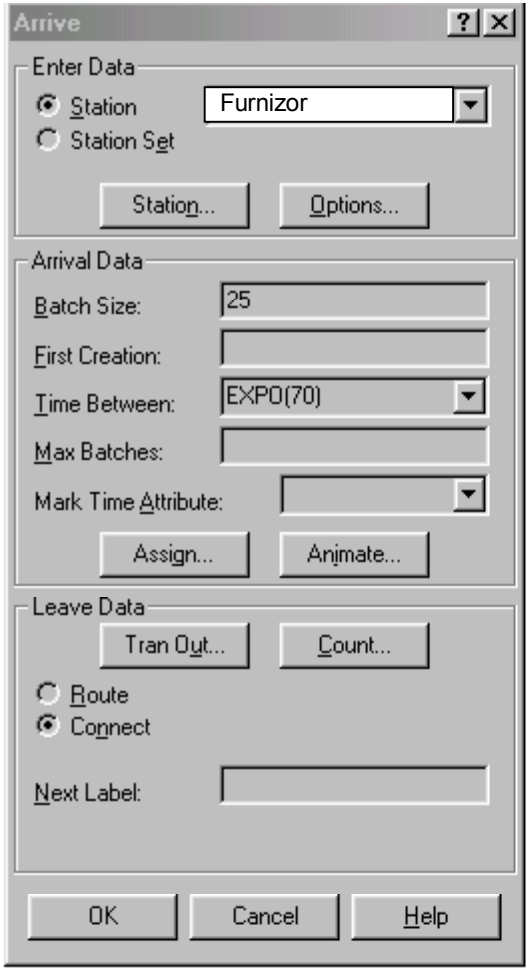

Leave
Enter Data
Label:
Leave Data
From Station:
Decizie
Seize
Request
Access
None
Load:
0.
Route
StNm
Seq
Expr
Transport
Convey
Connect
To Station:
Expediere
Route Time:
2.
Animate...
Count...
OK
Cancel
Help

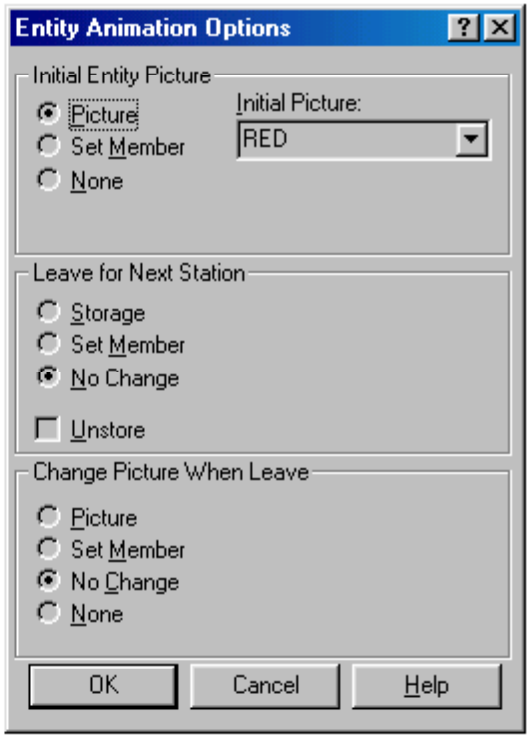

Arrive
Enter Data
Station
Station Set
Initializeaza un proces
Station...
Options...
Arrival Data
Batch Size:
1
First Creation:
5
Time Between:
Max Batches:
1
Mark Time Attribute:
Assign...
Animate...
Leave Data
Tran Out...
Count...
Route
Connect
Next Label:
OK
Cancel
Help

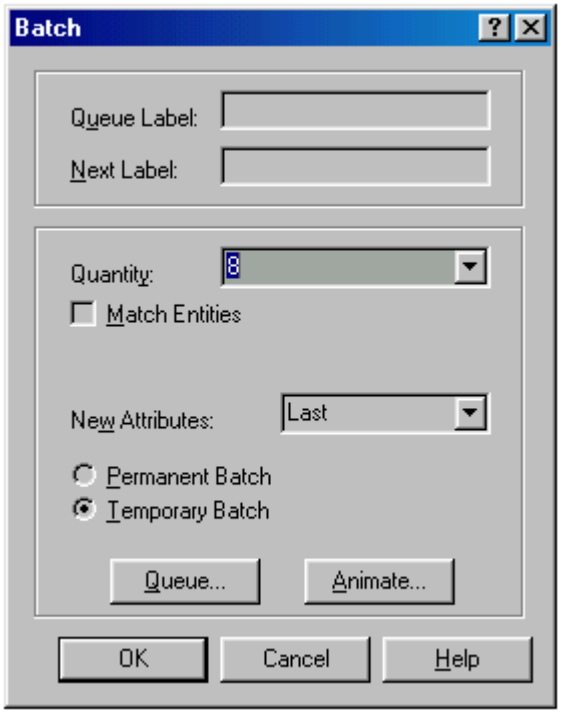
Entity Animation Options
Initial Entity Picture
Picture
Set Member
None
Initial Picture:
Default
Leave for Next Station
Storage
Set Member
No Change
Storage:
Initializeza un proc
Unstore
Change Picture When Leave
Picture
Set Member
No Change
None
OK
Cancel
Help

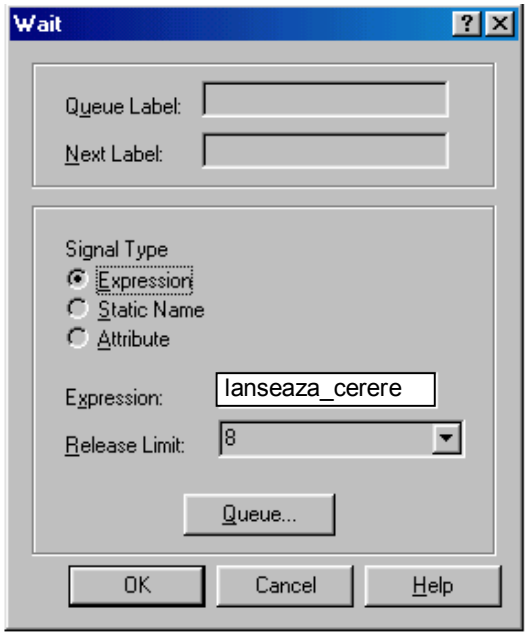

Signal
Label:
Next Label:
Signal Type
Expression
Static Name
Attribute
Expression:
Lanseaza _cerere
Release Limit:
10
OK
Cancel
Help

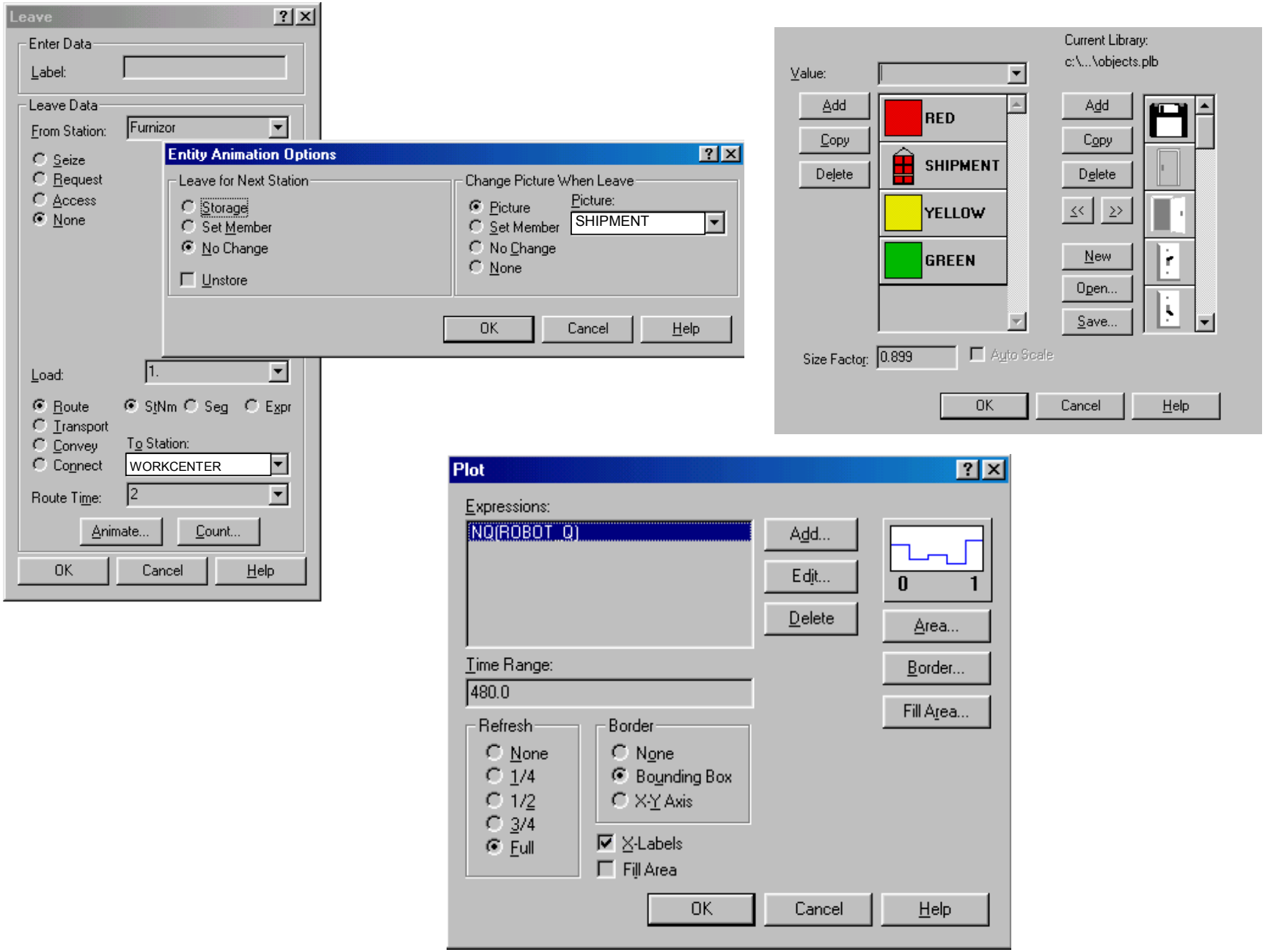

Depart
Enter Data
Label:
Station
Station Set
Procesul incheiat
Station...
Tran In...
Options...
Count
Individual Counter
Counter Set Member
None
Tally
Individual Tally
Tally Set Member
None
OK
Cancel
Help

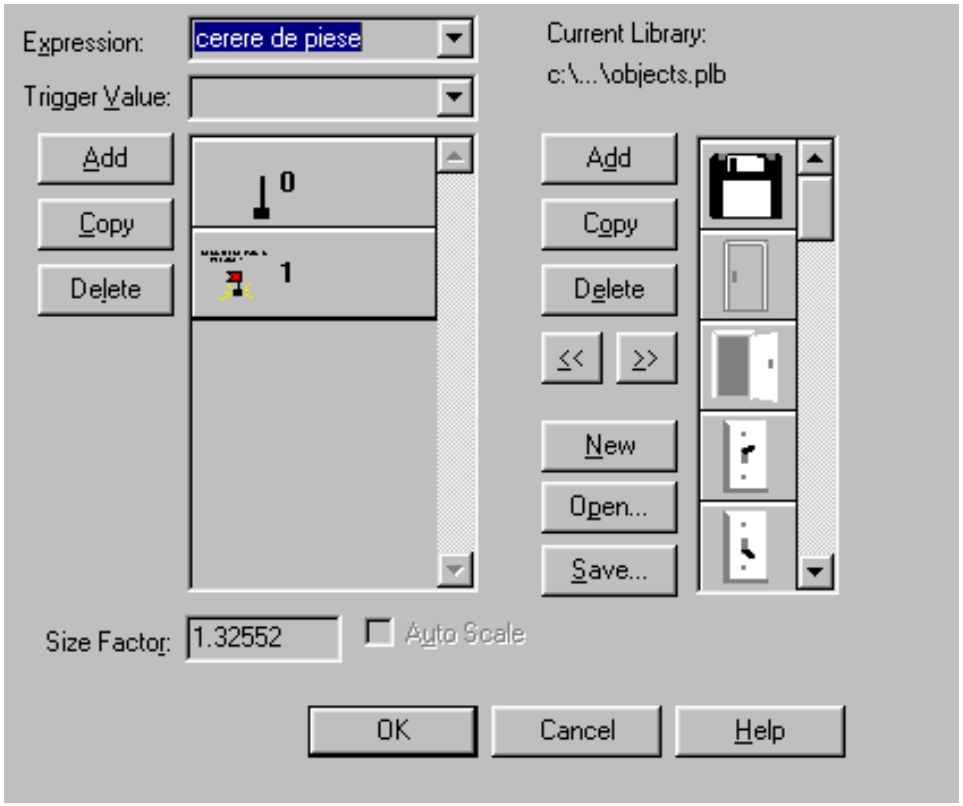

Arrive
Enter Data
Station
Station Set
Furnizor
Station...
Options...
Arrival Data
Batch Size:
25
First Creation:
Time Between:
EXPO(70)
Max Batches:
Mark Time Attribute:
Assign...
Animate...
Leave Data
Tran Out...
Count...
Route
Connect
Next Label:
OK
Cancel
Help


Entity Animation Options
Initial Entity Picture
Picture
Set Member
None
Initial Picture:
RED
Leave for Next Station
Storage
Set Member
No Change
Unstore
Change Picture When Leave
Picture
Set Member
No Change
None
OK
Cancel
Help


Batch
Queue Label:
Next Label:
Quantity:
8
Match Entities
New Attributes:
Last
Permanent Batch
Temporary Batch
Queue...
Animate...
OK
Cancel
Help


Wait
Queue Label:
Next Label:
Signal Type
Expression
Static Name
Attribute
Expression:
lanseaza_cerere
Release Limit:
8
Queue...
OK
Cancel
Help


Leave
Enter Data
Label:
Leave Data
From Station:
Furnizor
Seize
Request
Access
None
Load:
1.
Route
StNm
Seg
Expr
Transport
Convey
Connect
To Station:
WORKCENTER
Route Time:
2
Animate...
Count...
OK
Cancel
Help
Entity Animation Options
Leave for Next Station
Storage
Set Member
No Change
Unstore
Change Picture When Leave
Picture
Set Member
No Change
None
Picture:
SHIPMENT
OK
Cancel
Help
Current Library:
c:\...\objects.plb
Value:
Add
Copy
Delete
RED
SHIPMENT
YELLOW
GREEN
<<
>>
New
Open...
Save...
Size Factor:
0.899
Auto Scale
OK
Cancel
Help
Plot
Expressions:
NQ(ROBOT_Q)
Add...
Edit...
Delete
0
1
Area...
Border...
Fill Area...
Time Range:
480.0
Refresh
None
1/4
1/2
3/4
Full
Border
None
Bounding Box
X-Y Axis
X-Labels
Fill Area
OK
Cancel
Help



If ,NR(ROBOT).LE.2.AND.NQ(ROBOT_q).LT.5.AND.NE(WORCENTER).EQ.0.AND.cerere de piese.EQ.0