Industrial Automation
(Automação de Processos Industriais)

http://users.isr.ist.utl.pt/~jag/courses/api1213/api1213.html

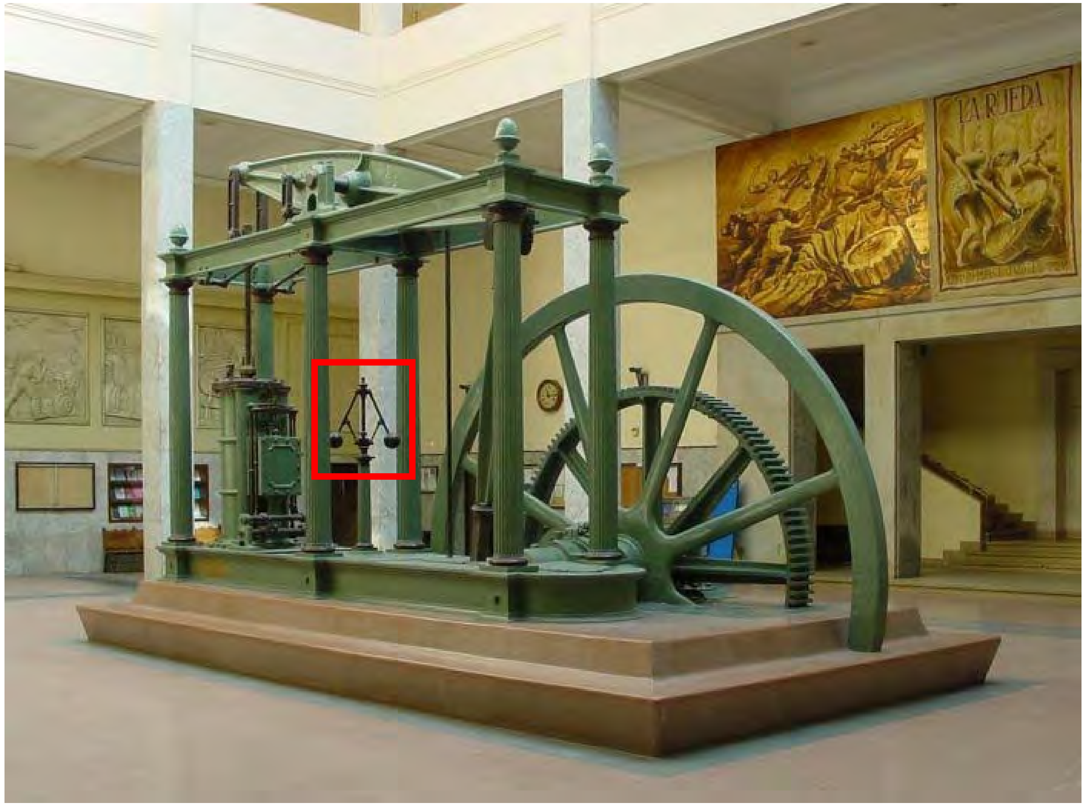
Slides 2010/2011 Prof. Paulo Jorge Oliveira

Rev. 2011-2014 Prof. José Gaspar

Industrial Revolution 1760/80 – 1820/40 (historians E. Hobsbawm, T. S. Ashton)

A steam engine built according to James Watt's patent in 1848 at Freiberg in Germany [wikipedia]

Industrial Revolution 1760/80 – 1820/40 (historians E. Hobsbawm, T. S. Ashton)



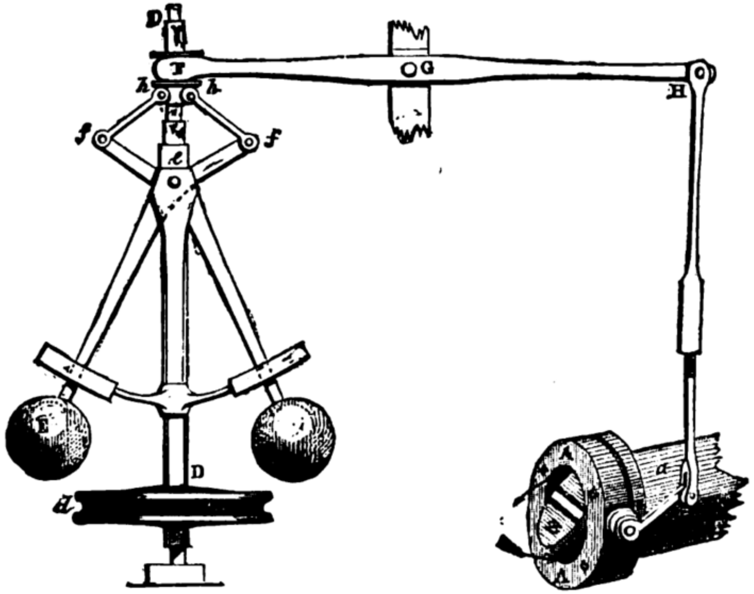
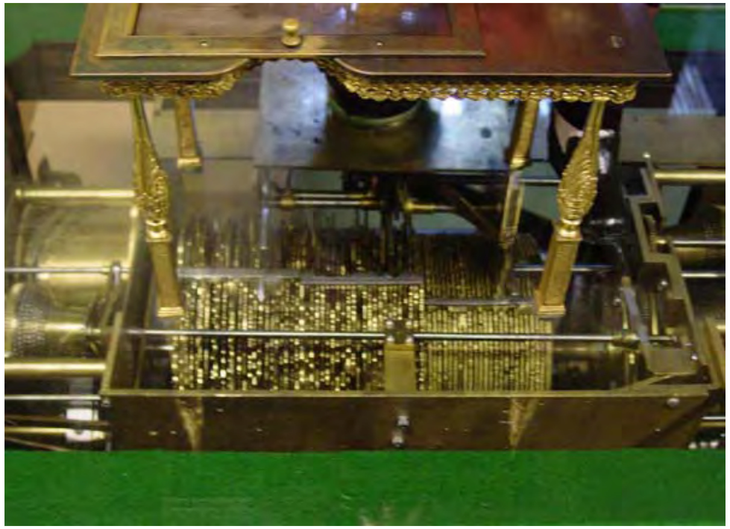
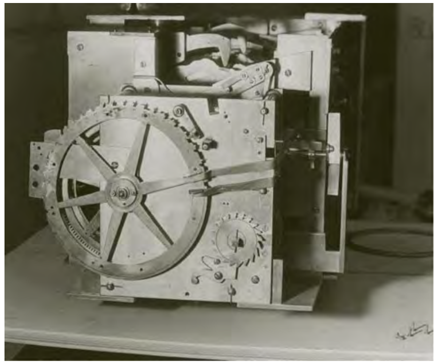


FIG. 4.—*Governor and Throttle-Valve.*

Steam engine and detail of the governor, James Watt's [wikipedia].

A jewel: Maillardet's Automaton, 18th century, the largest known mechanical memory

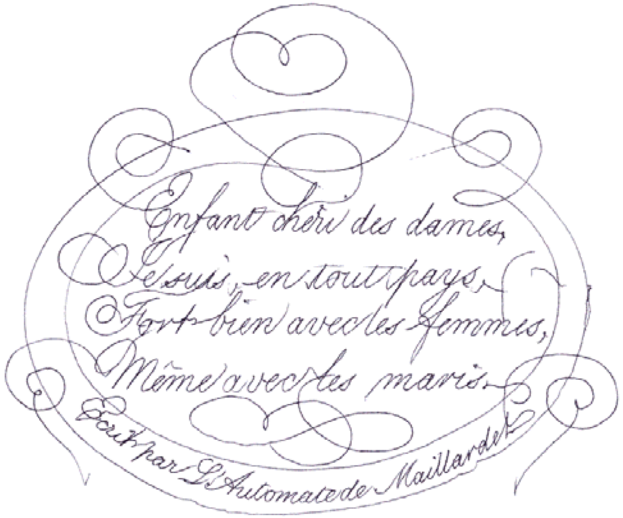


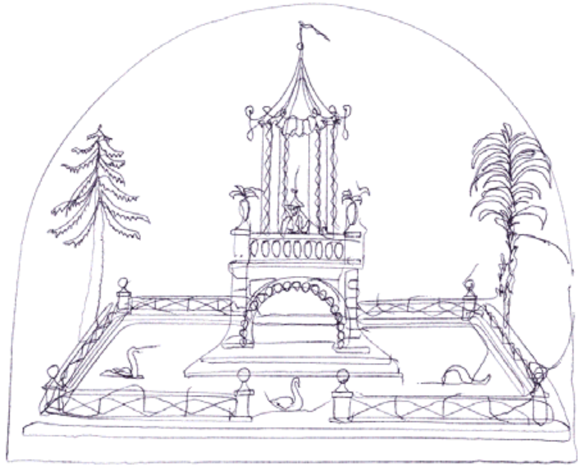


http://www.fi.edu/learn/sci-tech/automaton

Maillardet's Automaton, 18th century: the largest known mechanical memory

Four drawings and three poems



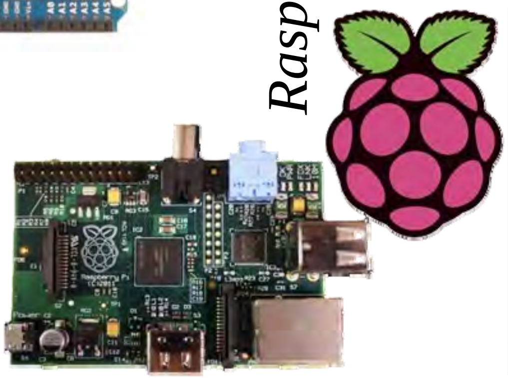


http://www.fi.edu/learn/sci-tech/automaton

Microcontrollers

Arduino

Raspberry-pi



Computer + IO

National Instruments AD/DA

PLC

Premium P57

Many options for controlling real world devices! Why PLCs?

Robustness is not an Option

a brand of Schneider Electric

Telemecanique

Objectives of the course:

- ***Analysis*** *of systems for industrial automation.*

- *Methodologies for the* ***implementation*** *of solutions in industrial automation.*

- *Programming* ***languages*** *of PLCs (Programmable Logic Controllers).*

- *CAD/CAM and Computerized Numerical Controlled machines.*

- ***Discrete Event Systems*** *Modeling.*

- ***Supervision*** *of Processes in Industrial Automation.*

Program at a glance:

1. Introduction to Automation [1 week]
Introduction to components and methodologies.

2. Introduction to PLCs [2 weeks]
Components of Programmable Logic Controllers (PLCs). Architecture, functional structure, IO.

3. PLCs Programming Languages [2w]
Standard languages (IEC-1131-3): *Ladder Diagram; Instruction List* and *Structured Text.*

4. GRAFCET *(Sequential Function Chart)* [1 week]
Norm, elements of the language, modelling.

5. CAD/CAM and CNC Machines [1 week]
Types of Computerized Numerical Controlled machines. Interpolation of trajectories. Flexible fabrication cells.

6. Discrete Event Systems [1 week]
Modeling of discrete event systems (DESs). Automata. Petri networks. State and dynamics of PNs.

7. Analysis of DESs [2 weeks]
Properties of DESs. Methodologies for the analysis: reachability graph and matricial equation.

8. DESs and Industrial Automation [1week]
Relations GRAFCET / Petri networks. Analysis of industrial automation solutions as DESs.

9. Supervision of Industrial Processes [2w]
Methodologies for supervision. SCADA. Synthesis based on invariants. Examples of application.

Assessment and grading:

- *2 Preliminary laboratory assignments - training purposes (0% of the final grade).*
- *2 Laboratory assignments (20%+20% of the final grade). Groups of 3 or 4 students.*
- *1 Seminar (20% of the final grade). Topics to be selected with each group.*
- *1 Exam (40% of the final grade).*

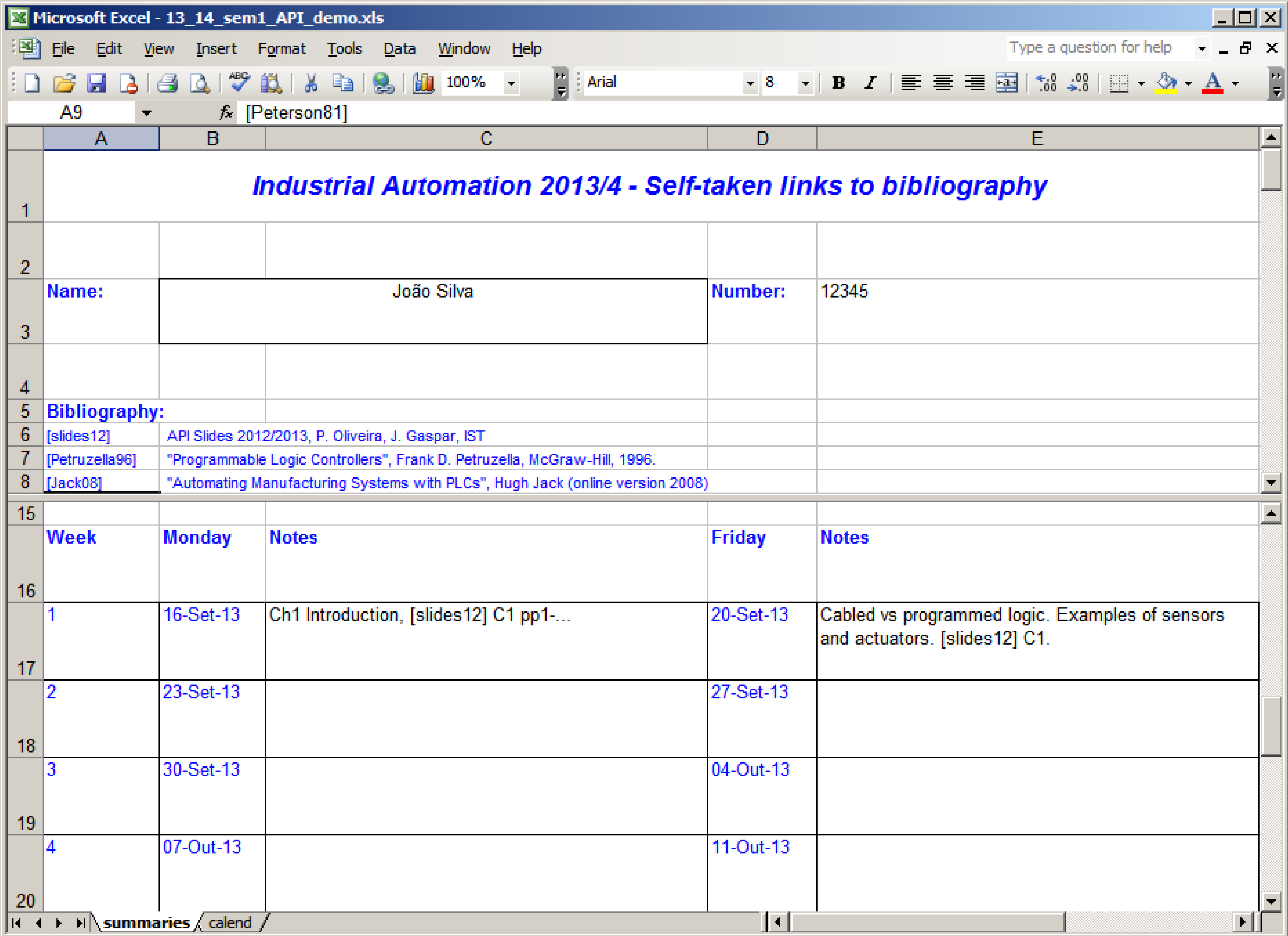
Upon student choice, the second exam can be oral.

- *Minimum grade: 9.0/20.0 val. in each component.*

One extra value for students attending more than 70% of recitations and do short summaries of the classes.

Assessment and grading:

Short summaries of the classes



Microsoft Excel - 13_14_sem1_API_demo.xls

A9 [Peterson81]

Industrial Automation 2013/4 - Self-taken links to bibliography

Name:	João Silva		**Number:**	12345
Bibliography:				
[slides12]	API Slides 2012/2013, P. Oliveira, J. Gaspar, IST			
[Petruzella96]	"Programmable Logic Controllers", Frank D. Petruzella, McGraw-Hill, 1996.			
[Jack08]	"Automating Manufacturing Systems with PLCs", Hugh Jack (online version 2008)			

Week	Monday	Notes	Friday	Notes
1	16-Set-13	Ch1 Introduction, [slides12] C1 pp1-...	20-Set-13	Cabled vs programmed logic. Examples of sensors and actuators. [slides12] C1.
2	23-Set-13		27-Set-13	
3	30-Set-13		04-Out-13	
4	07-Out-13		11-Out-13	

summaries / calend

Download this XLS file from the webpage of the course.

Schedule (laboratories & exam):

Lab. registration[1]	First week	16-20/09/2013
1st preliminary lab.	1 week	30/9-4/10/2013
2nd preliminary lab.	1 week	7/10-11/10/2013
1st lab. assignment	3 weeks	14/10-01/11/2013
2nd lab. assignment	3 weeks	11/11-29/11/2013
3rd lab. assignment	0.5h seminar	One date >= week 8
Exams	3h	16Jan, 1Fev 2013

[1] *Important: define the students' representative*

Schedule (laboratories & exam):

Lab. registration[1]	First week
1st preliminary lab.	1 week
2nd preliminary lab.	1 week
1st lab. assignment	3 weeks
2nd lab. assignment	3 weeks
3rd lab. assignment	0.5h seminar (one date >= week 8)
Exams	3h, 16Jan or 1Fev 2013

[1] *Important: define the students' representative*

Schedule (according to IST-GOP):

- Recitation classes

Monday	11.00 h – 12.30h	Ea5
Friday	11.00 h – 12.30h	Ea4

- Lab. Classes (once per week)

Monday	09.30h – 11.00h L1	LSDC4 (room 5.21)
Friday	09.30h – 11.00h L2	LSDC4 (room 5.21)

- Groups registration for the Laboratory

Bibliography:

• Automating Manufacturing Systems with PLCs, Hugh Jack (online version available).

• Peterson, James L., "Petri Net Theory and the Modeling of Systems", Prentice-Hall,1981.

• Modeling and Control of Discrete-event Dynamic Systems with Petri Nets and other Tools, Branislav Hruz and MengChu Zhou, 2007. New reference…

--- secondary---

• Programmable Logic Controllers, Frank D. Petruzella, McGraw-Hill, 1996.

• Petri Nets and GRAFCET: Tools for Modeling Discrete Event Systems, R. DAVID, H. ALLA, New York : PRENTICE HALL Editions, 1992.

• Computer Control of Manufacturing Systems, Yoram Koren, McGraw Hill, 1986.

• Christos Cassandras, "Discrete Event Systems - Modeling and Performance Analysis", Aksen Associates, 1993.

• Moody and Antsaklis, Supervisory Control of Discrete Event Systems, Kluwer Academic Publishers, 1998.

Industrial Automation

(Automação de Processos Industriais)

Introduction to Automation

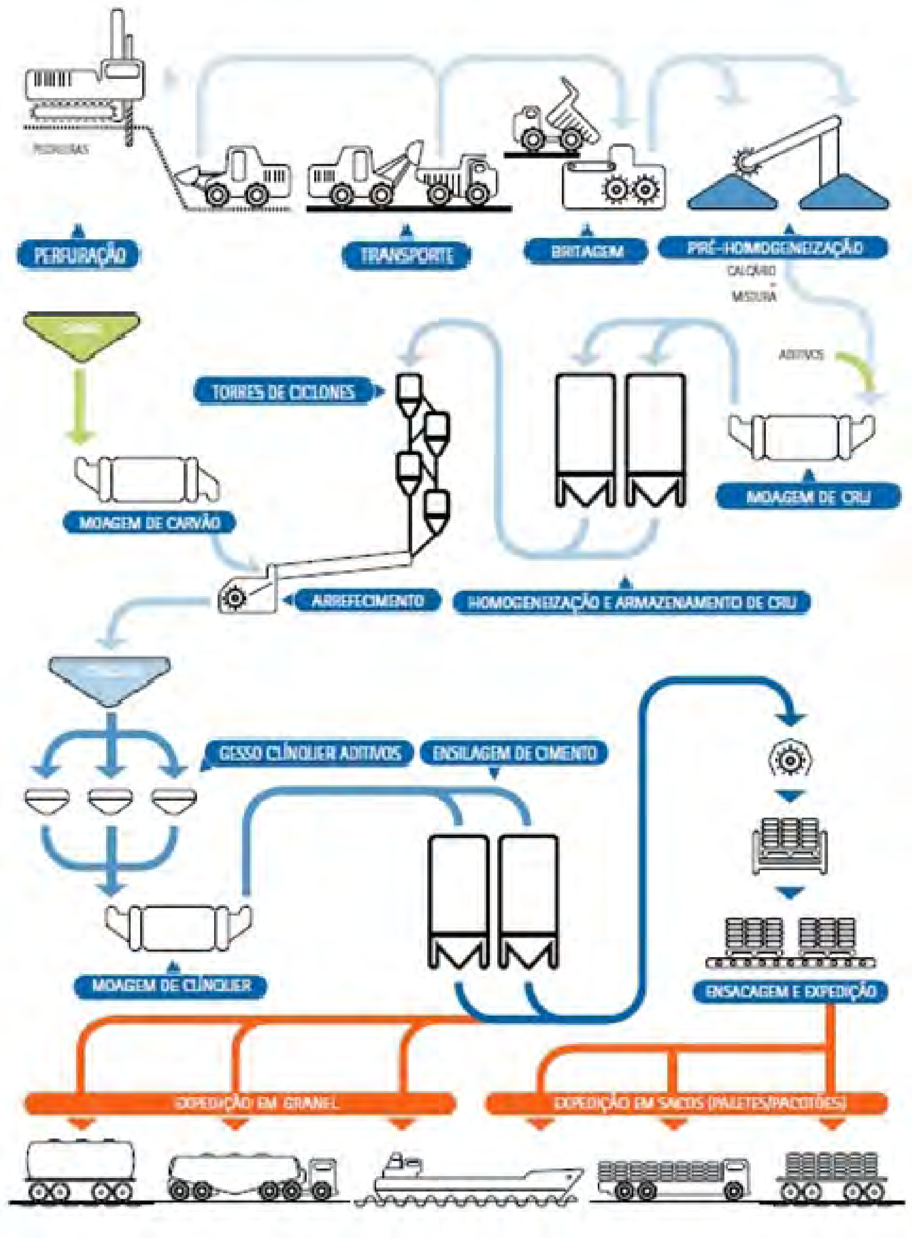
http://www.isr.ist.utl.pt/~jag/aulas/api1314/api1314.html

Slides 2010/2011, Prof. Paulo Jorge Oliveira
Rev. 2011-2014, Prof. José Gaspar

Industrial Process:

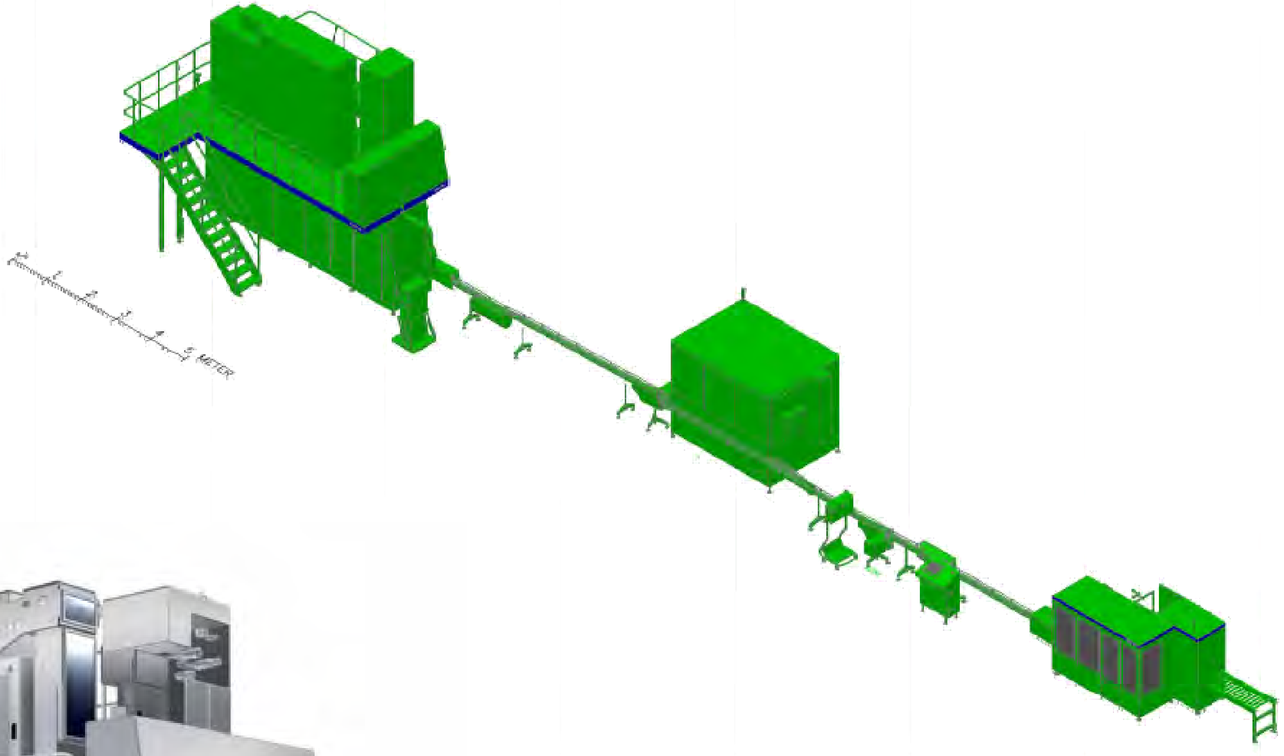
Making Cement

[Outão / Setúbal / Portugal]



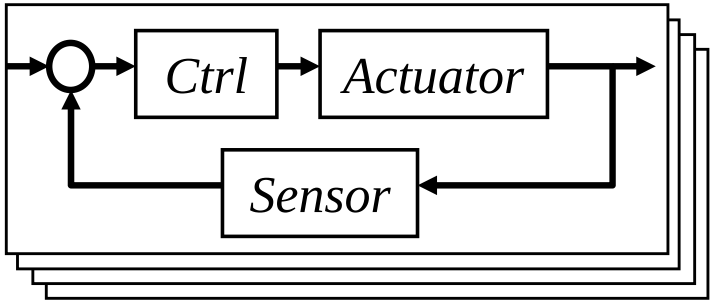
Industrial Process:

Tetra Pak / Parmalat



Complexity handled with modularity

Robot* +*Robot* +*Robot* + ... + *Global Controller* = *Automated Industrial Process



Other courses as e.g. Control

The subject of this course

Ch. 1 – Introduction to Automation [1 week]

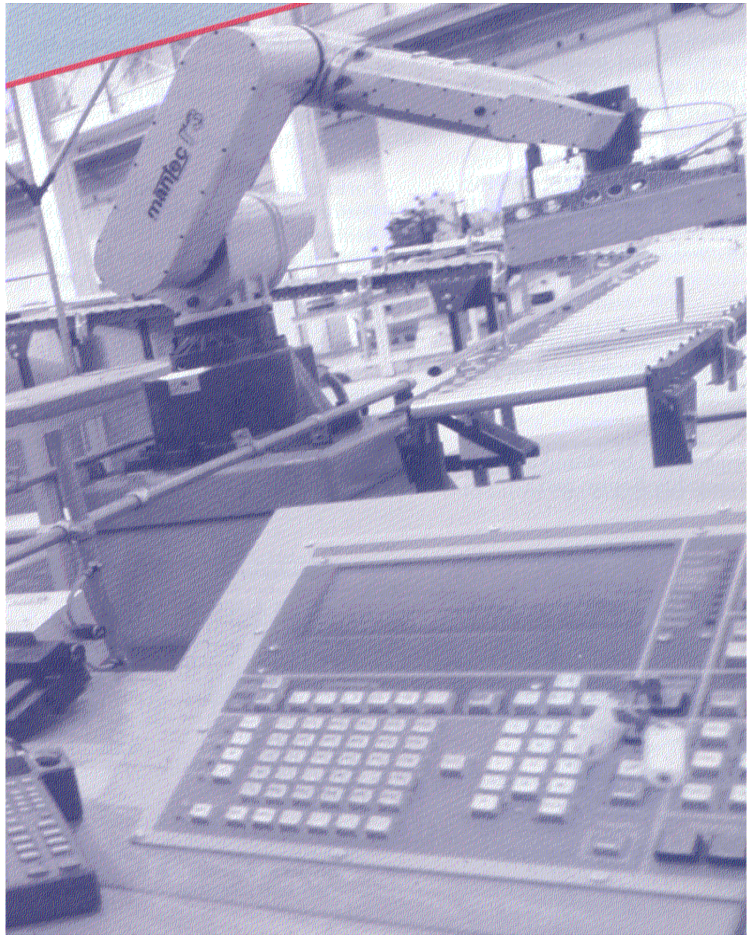
Introduction to **components** in industrial automation.

Cabled logic versus **programmed logic** versus networked logic.

Introduction to **methodologies** for problem modeling.
Methodologies of work.

Components used in industrial automation

The production of increasing amounts of goods requires the storage and handling of large quantities of resources.

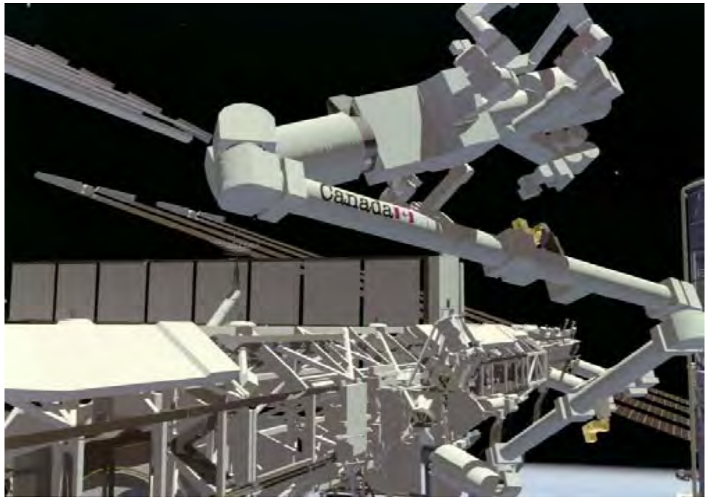


The use of **specialized, automatic tools are mandatory**.

Consistent trend in the last three centuries (since the Industrial Revolution).

Automation was also fostered by the invention of computers,

Robotic Manipulators

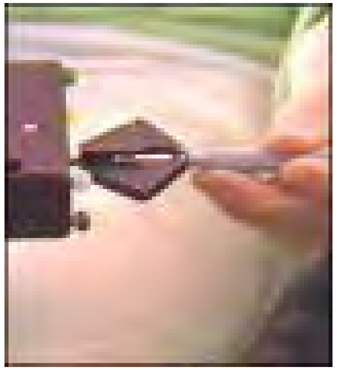


Robotic Manipulators

Riding an ABB IRB 6600 Robot 1 [Youtube]

API Note: please understand the power, and do not do this; keep always the safety!

Robotic Manipulators - End Effectors



Robotic Manipulators

Major characteristics:

- Number of degrees of freedom
- Types of joints (prismatic/revolution)
- Programming tools and environments (high level languages, teach pendent, ...)
- Workspace
- Accuracy, reliability
- Payload and robustness

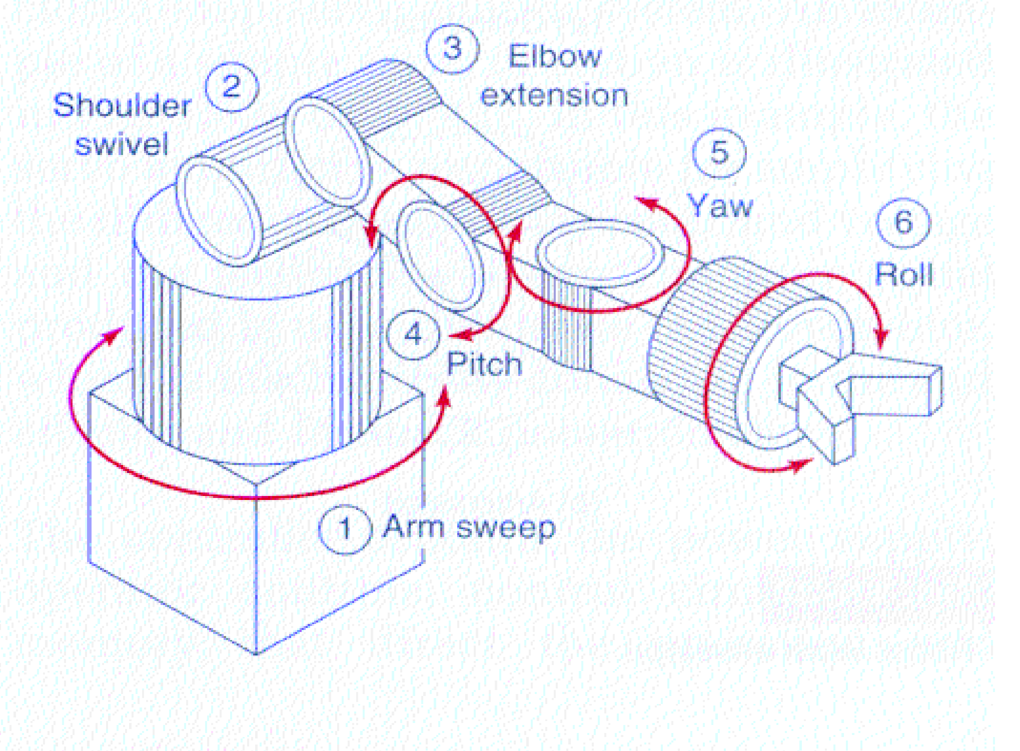


Fig. 15-22
Six-axis robot arm.

Robotic Manipulators

Workspace:

Examples

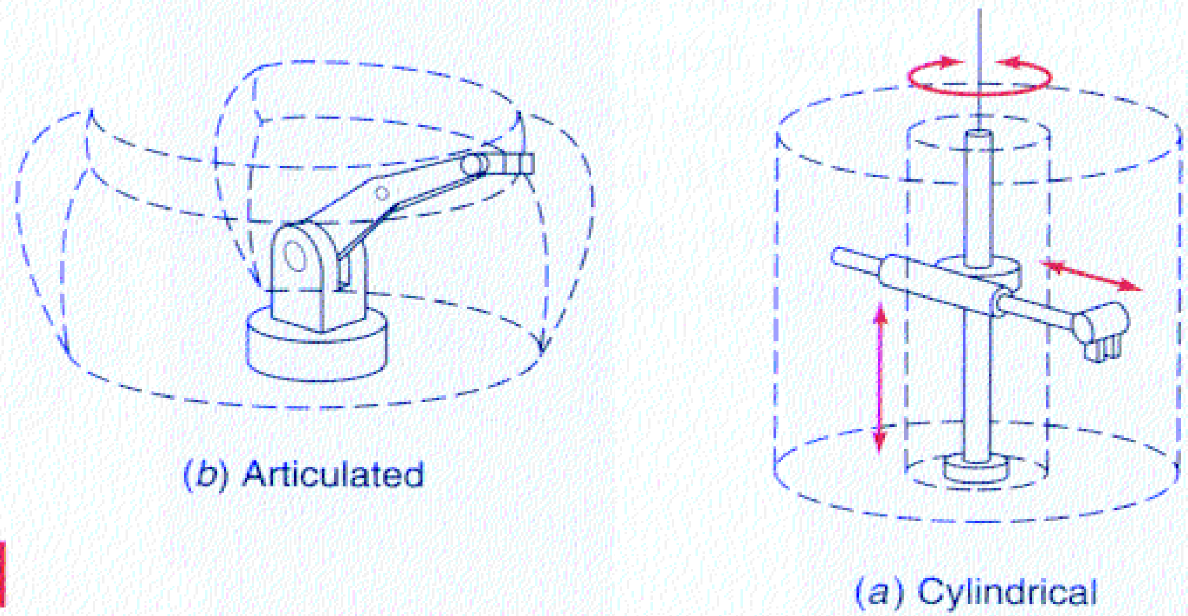
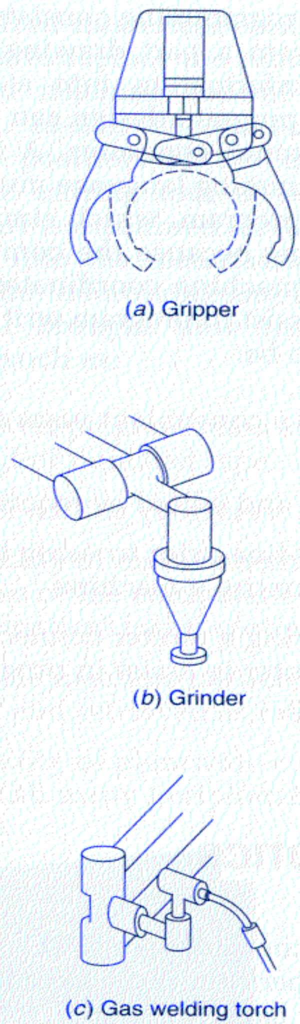


Fig. 15-23
Robot work envelope.



-24
End-of-arm tooling devices.

Robotic Manipulators

Central problems to address and solve:

- Direct / Inverse kinematics
- Trajectory generation
- Coordinate frames where tasks are specified
- Level of abstraction of the programming languages

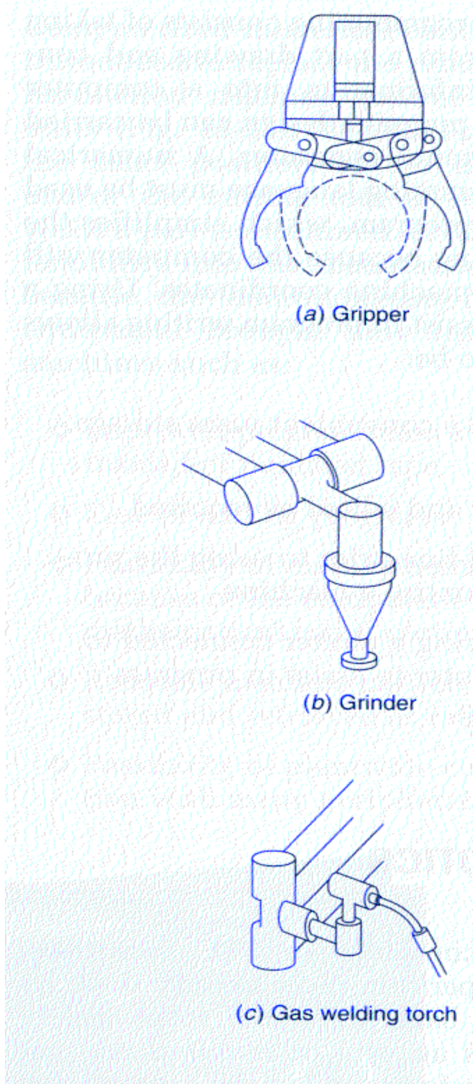


Fig. 15-24 End-of-arm tooling devices.

Robotic Manipulators

Use in Flexible

Cells of Fabrication:

it is required that the manipulators have correct interfaces for the synchronization and inputs for external commands.

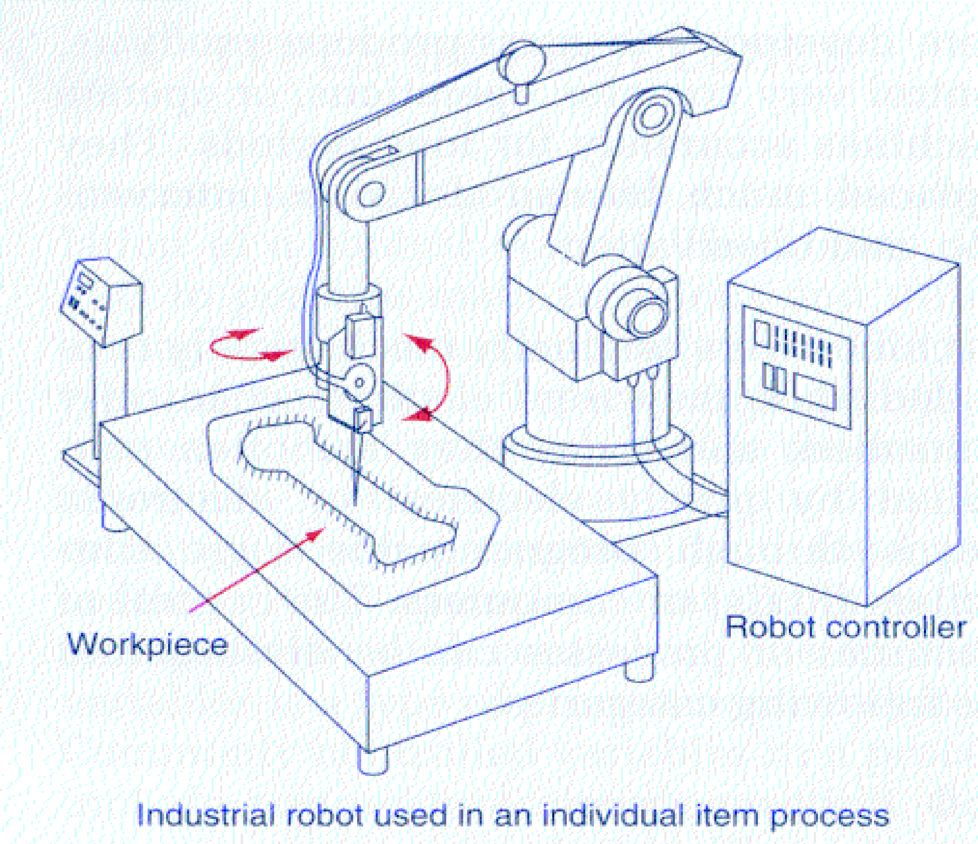


Fig. 14-3
Individual product production.

Computerized Numerical Controlled Machines

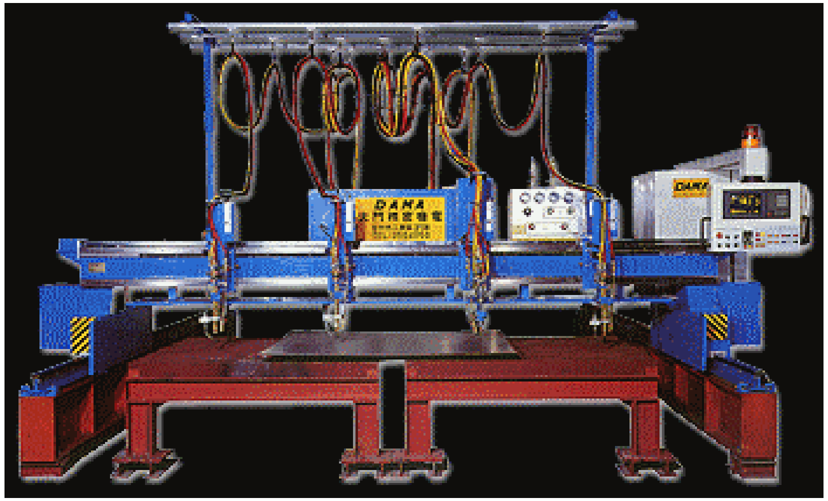
Major characteristics:

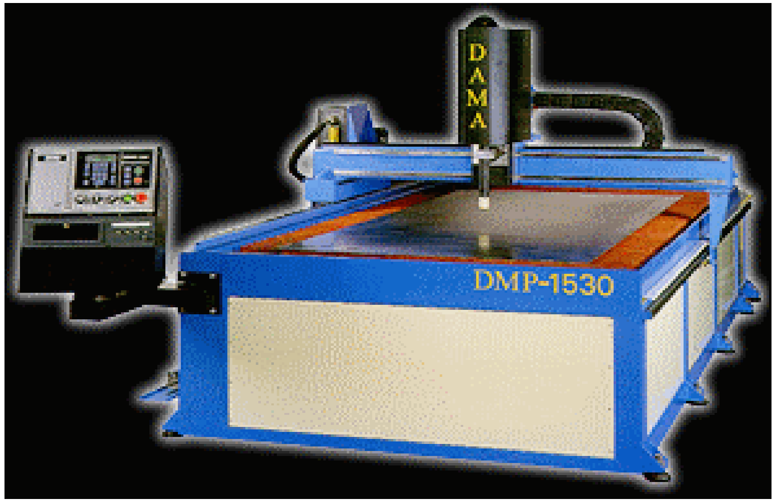
• Number of degrees of freedom
• Interpolation methods
• Load/unload automation, and also in tool change
• Programming (high level languages, teach pendent, ...)
• Workspace
• Accuracy, reliability
• Payload and robustness
• Interface
• Synchronization with exterior

Examples:
Milling, Lathes, ...

MITSUI SEIKI Machining Center

Computerized Numerical Controlled Machines





Compact CNC plasma cutting machine
Effective cutting :1.5 m X 3 m
Plasma torch cutting capacity up to 5cm (mild steel), Gas torch option allows up to 10cm.

Solutions for Handling materials

For transport...

Major characteristics:

- Load/unload automation
- Accuracy, reliability
- Payload and robustness
- Interface
- Synchronization with exterior

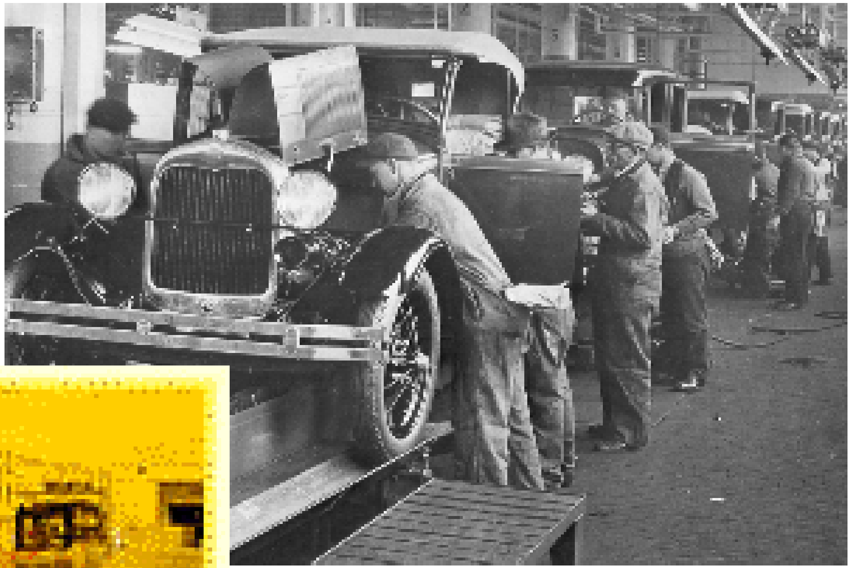
AGVs (Automatic Guided Vehicles)

Major characteristics:

- Load/unload automation
- Accuracy, reliability
- Payload and robustness
- Interface
- Synchronization with exterior

AGVs (Automatic Guided Vehicles)

Example of fleet operating in industry



AGVs (Automatic Guided Vehicles)


Kiva Systems Inc
- warehouse automation
- used by Staples, Toys R Us, ...
- 2012 bought by Amazon ($775 million)

Specific Components

Factory example: production of aluminum packs

Cabled Logic versus ...

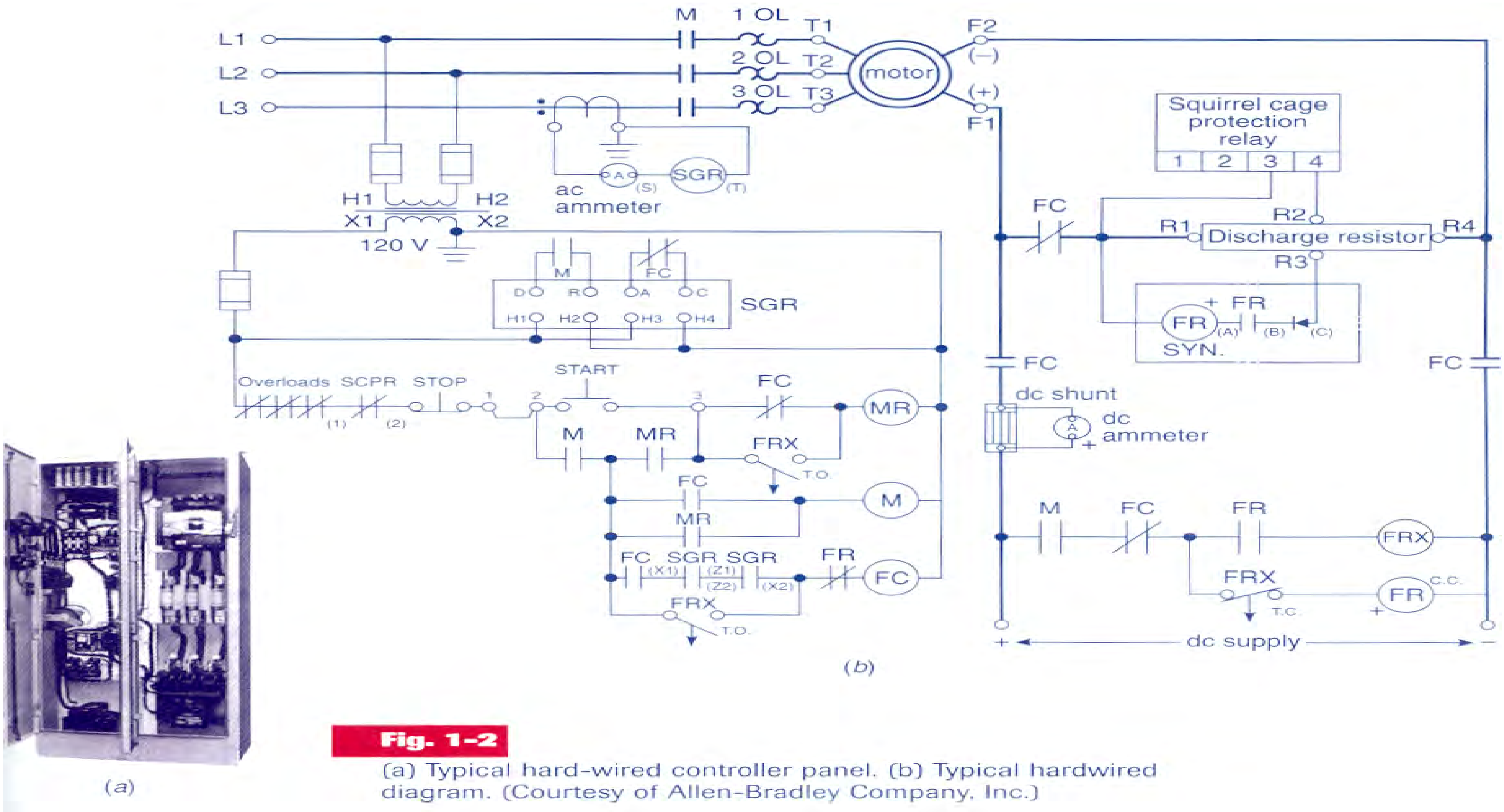
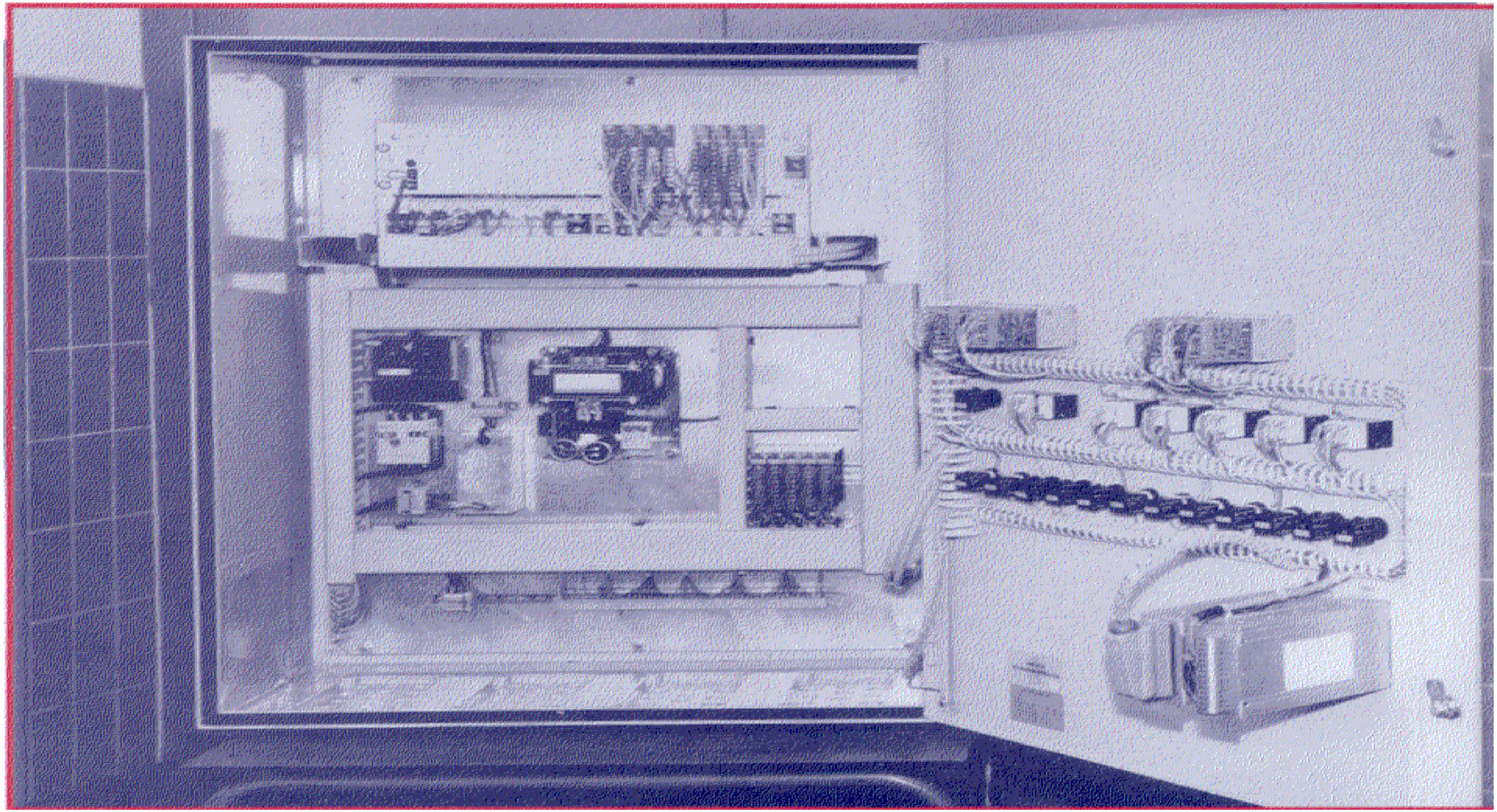


Fig. 1-2
(a) Typical hard-wired controller panel. (b) Typical hardwired diagram. (Courtesy of Allen-Bradley Company, Inc.)

... versus Programmed Logic …

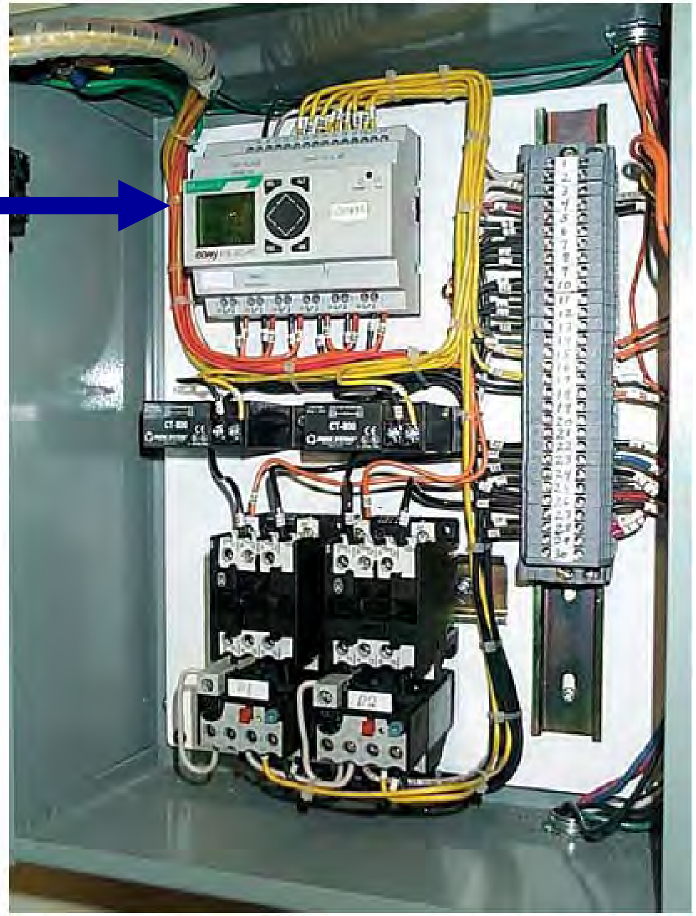


Cabled Logic versus ...

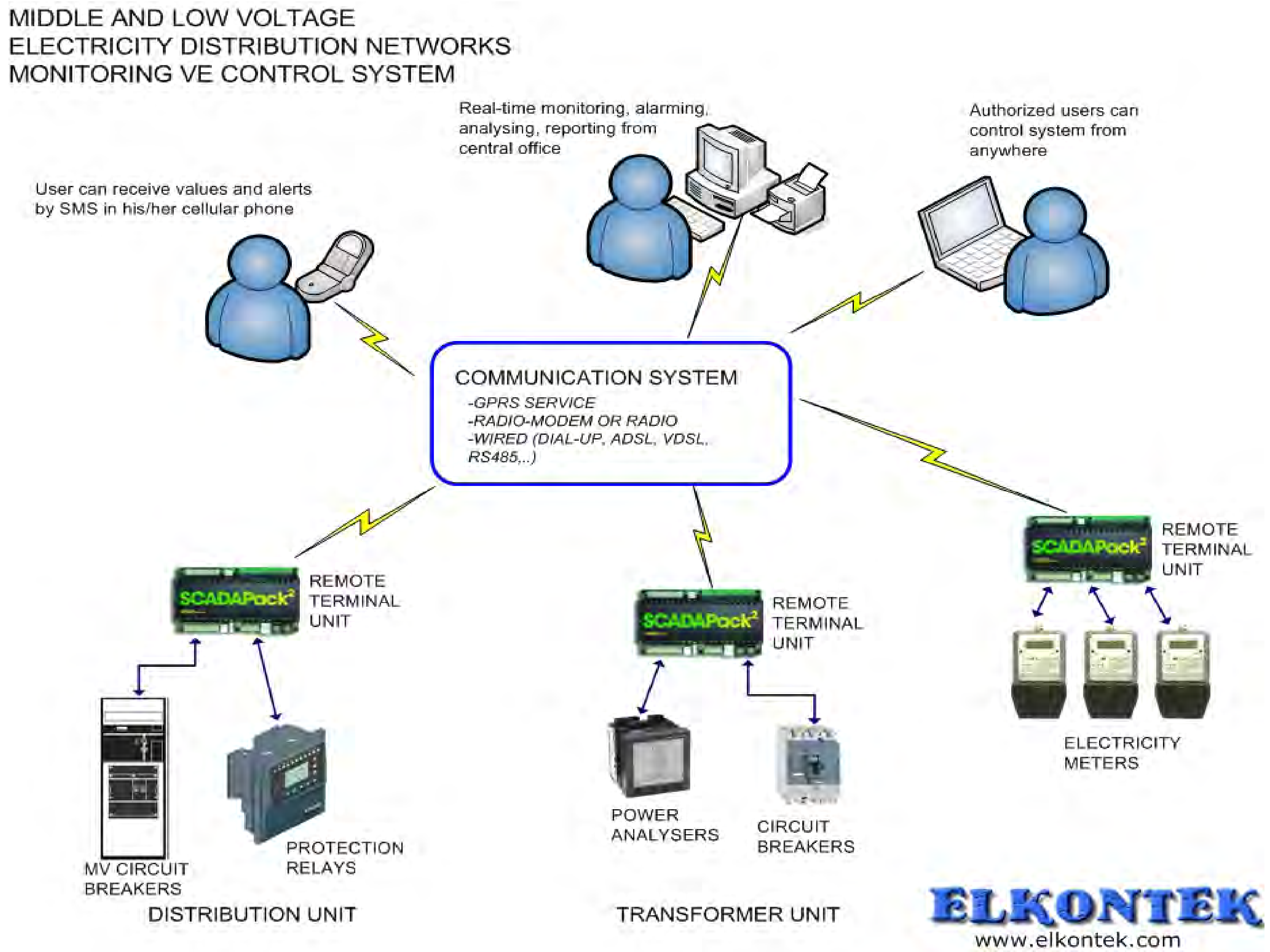
... versus Programmed Logic …

Relay control panel

PLC control panel



... versus Networked Logic



Introduction to methodologies for problem modeling in Industrial Automation

Actuators

- Motors
- Solenoide valve
- Command relay
- Pneumatic cylinder
- Electro pneumatic

Sensors

- Pressure switch
- Temperature sensors
- Proximity sensors

Relay diagram / Ladder diagram

Refs: Programmable Logic Controllers, Frank D. Petruzella, McGraw-Hill, 1996.

Actuation

Motors

Major characteristics:

• Type of start

• Type of control

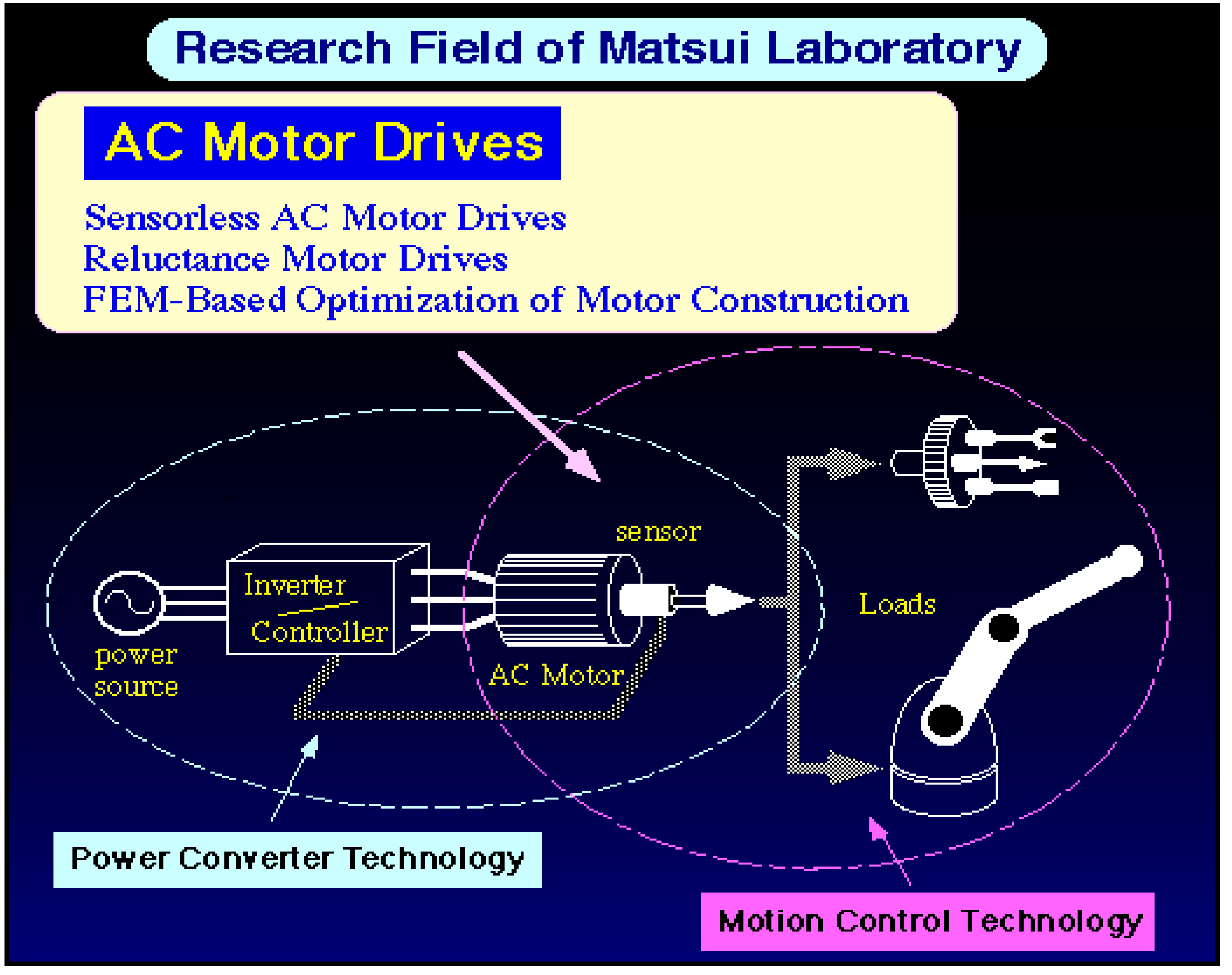
• Accuracy, reliability

• Payload and robustness

• Interface with exterior

• Synchronization

Exemple of AC motor, with driver



Solenoide Valve

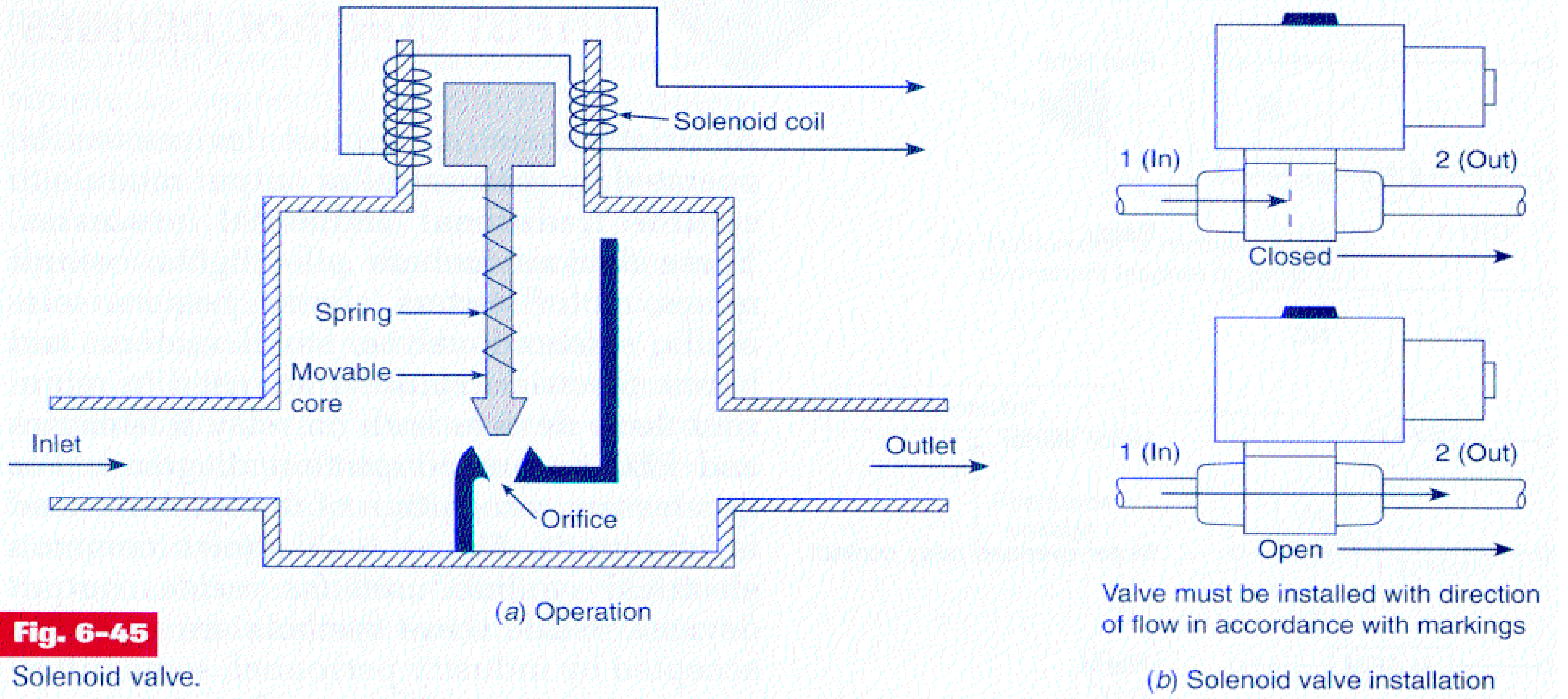


Fig. 6-45
Solenoid valve.

Command Relay

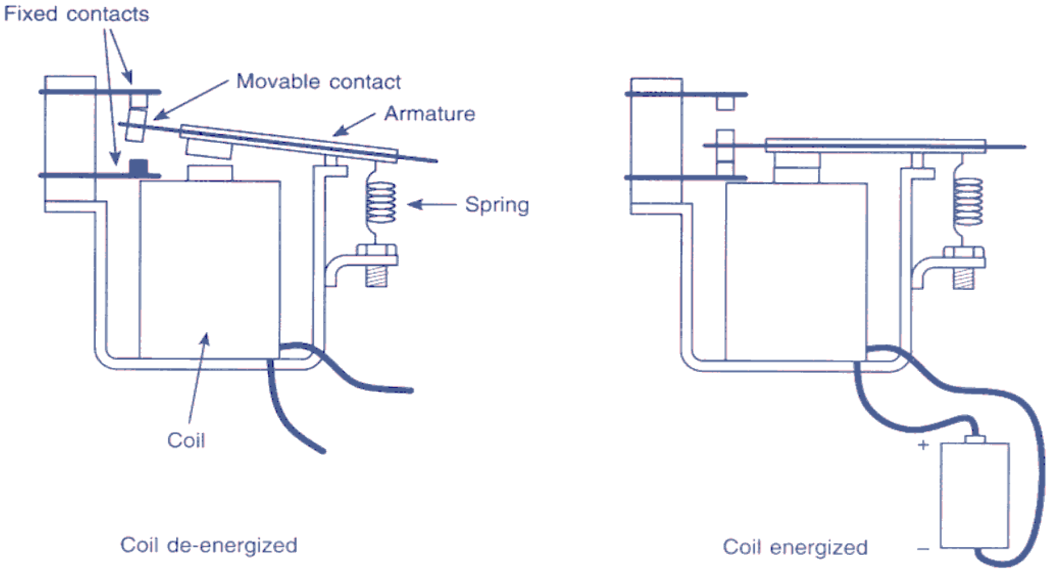
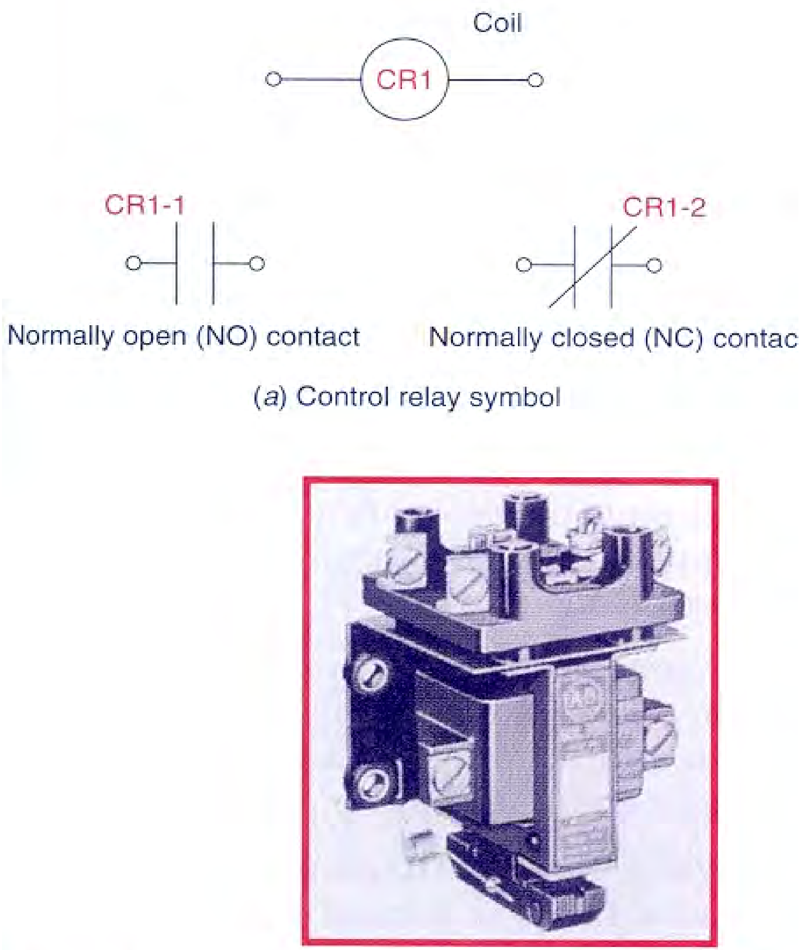


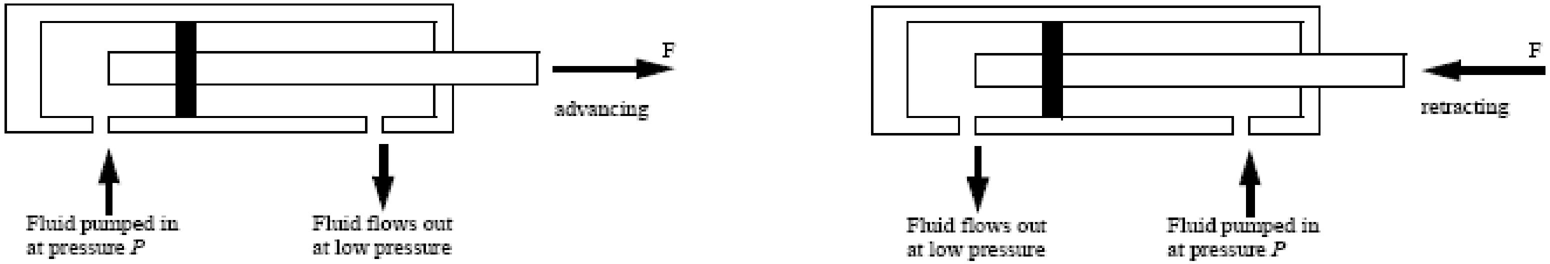
Fig. 6-1
Electromagnetic control relay operation.



(*b*) Typical industrial control relay. *(Courtesy of Allen-Bradley Company, Inc.)*

Fig. 6-2
Control relay.

Cylinders (Pneumatics)



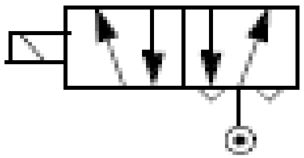
For Force:

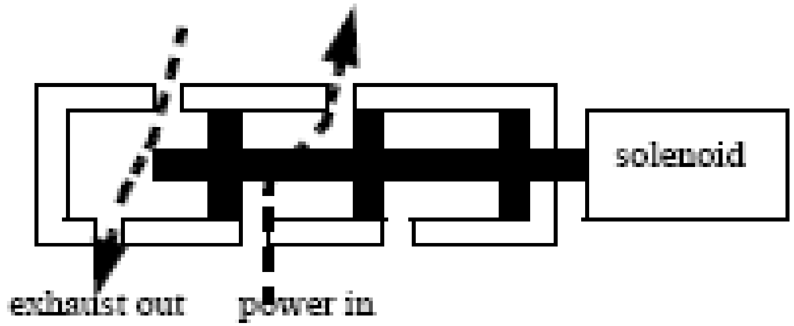
$$P = \frac{F}{A} \qquad F = PA$$

where,

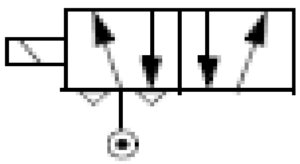
P = the pressure of the hydraulic fluid
A = the area of the piston
F = the force available from the piston rod

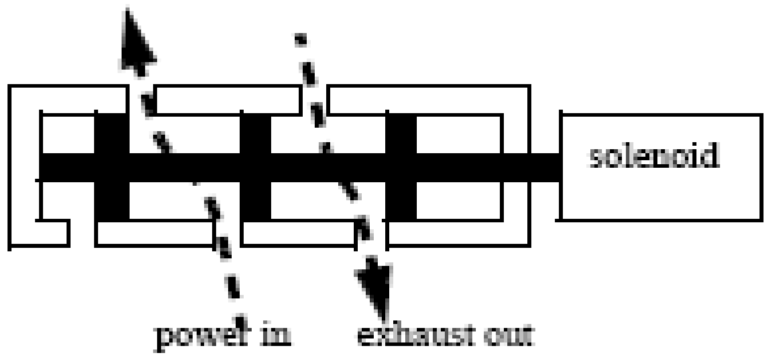
Valves (Electro-pneumatics)

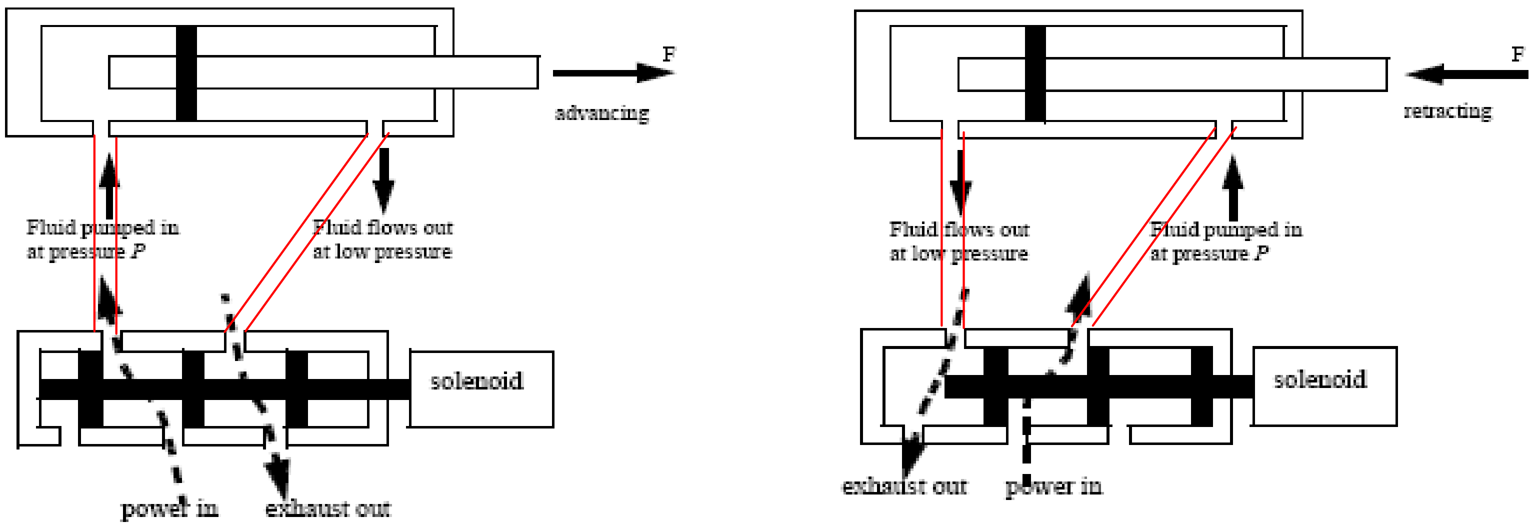




The solenoid has two positions and when actuated will change the direction that fluid flows to the device. The symbols shown here are commonly used to represent this type of valve.

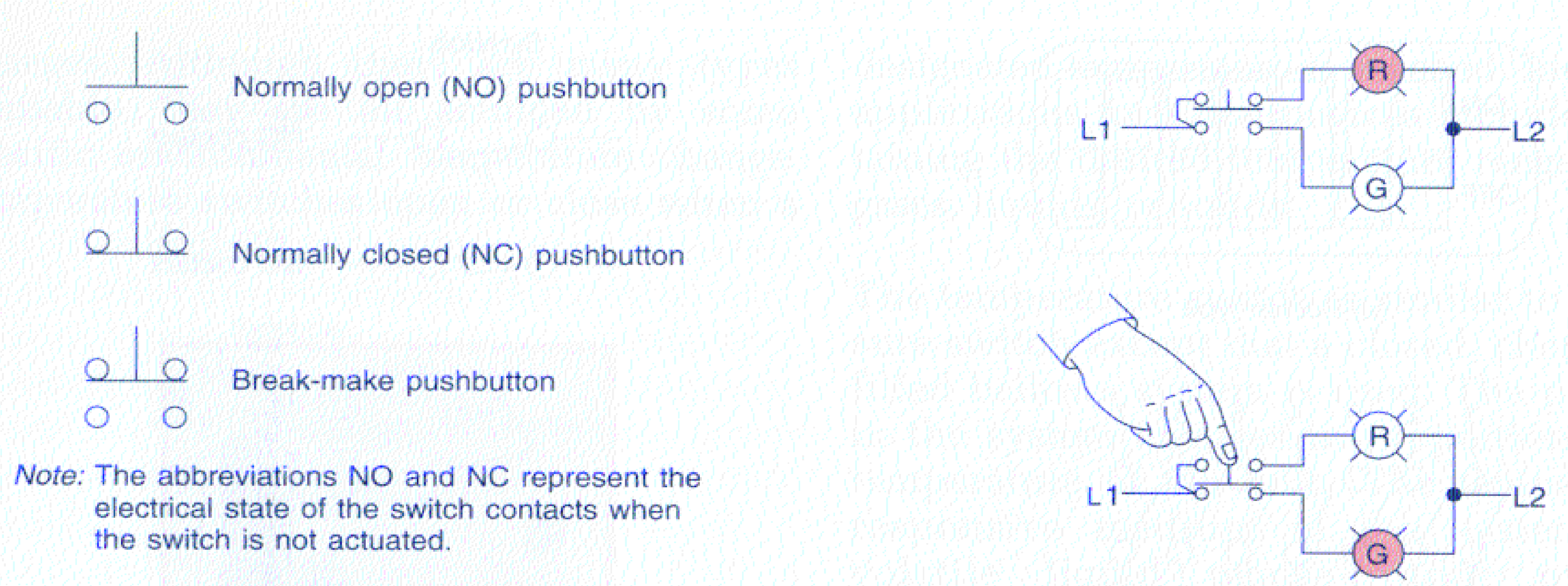





F
advancing
Fluid pumped in
at pressure P
Fluid flows out
at low pressure
solenoid
power in
exhaust out
F
retracting
Fluid flows out
at low pressure
Fluid pumped in
at pressure P
solenoid
exhaust out
power in

Sensors

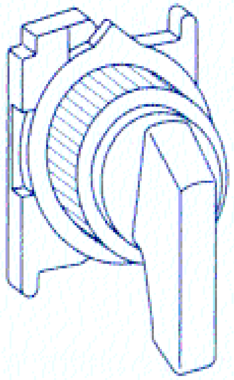
Push buttons



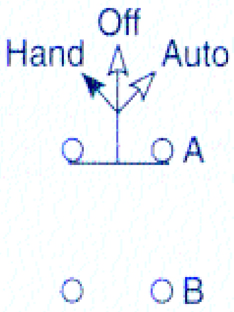
(a) Pushbutton switches

(b) Control circuit using a combination break-make pushbutton

Selector with three positions

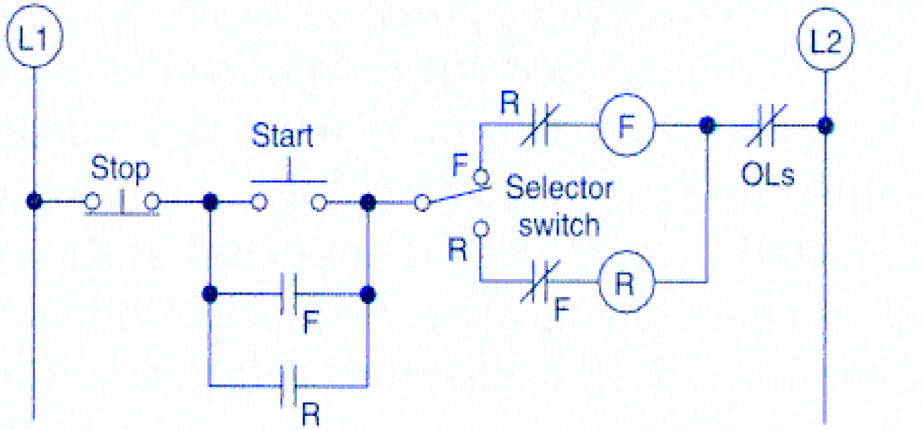


(a) Selector switch operator



	Contacts	
Position	A	B
Hand	X	
Off		
Auto		X

(b) Three-position selector switch and truth table



(c) Selector switch used in conjunction with a reversing motor starter to select forward or reverse operation of the motor

Fig. 6-11

Selector switch.

Sensors

Pressure Switch

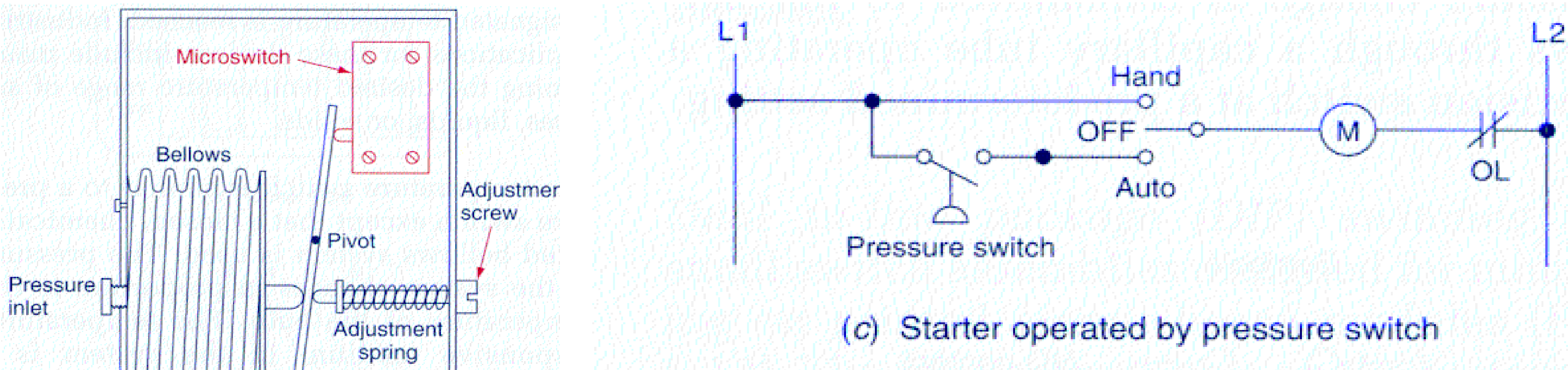
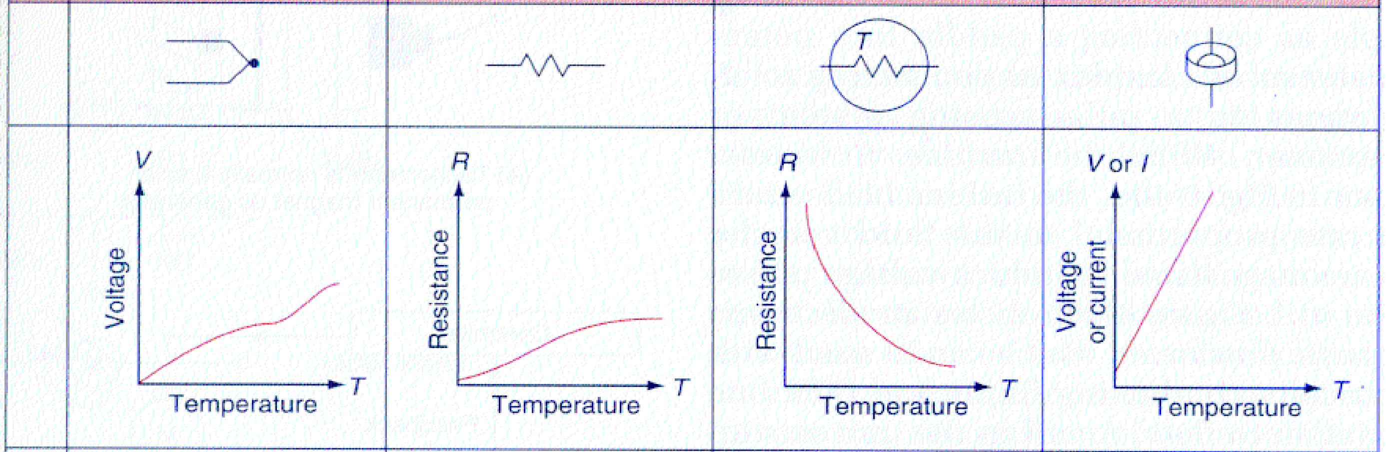


Fig. 6-15 (continued)
Pressure switch.

Temperature Sensors

	Thermocouple	RTD	Thermistor	IC Sensor



	Thermocouple	RTD	Thermistor	IC Sensor
Advantages	• Self-powered • Simple • Rugged • Inexpensive • Wide variety • Wide temperature range	• Most stable • Most accurate • More linear than thermocouple	• High output • Fast • Two-wire ohms measurement	• Most linear • Highest output • Inexpensive
Disadvantages	• Nonlinear • Low voltage • Reference required • Least stable • Least sensitive	• Expensive • Power supply required • Small ΔR • Low absolute resistance • Self-heating	• Nonlinear • Limited temperature range • Fragile • Power supply required • Self-heating	• $T < 200°C$ • Power supply required • Slow • Self-heating • Limited configurations

Fig. 6-38
Common temperature sensors.

Thermocouple

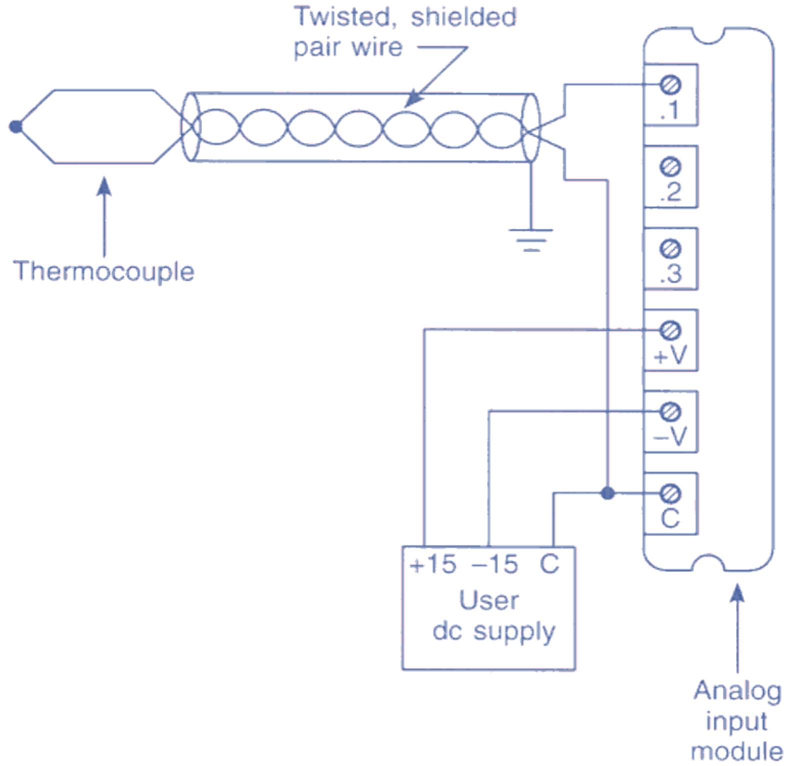


Fig. 2-12
Typical thermocouple connection to an analog input module.

Proximity detector

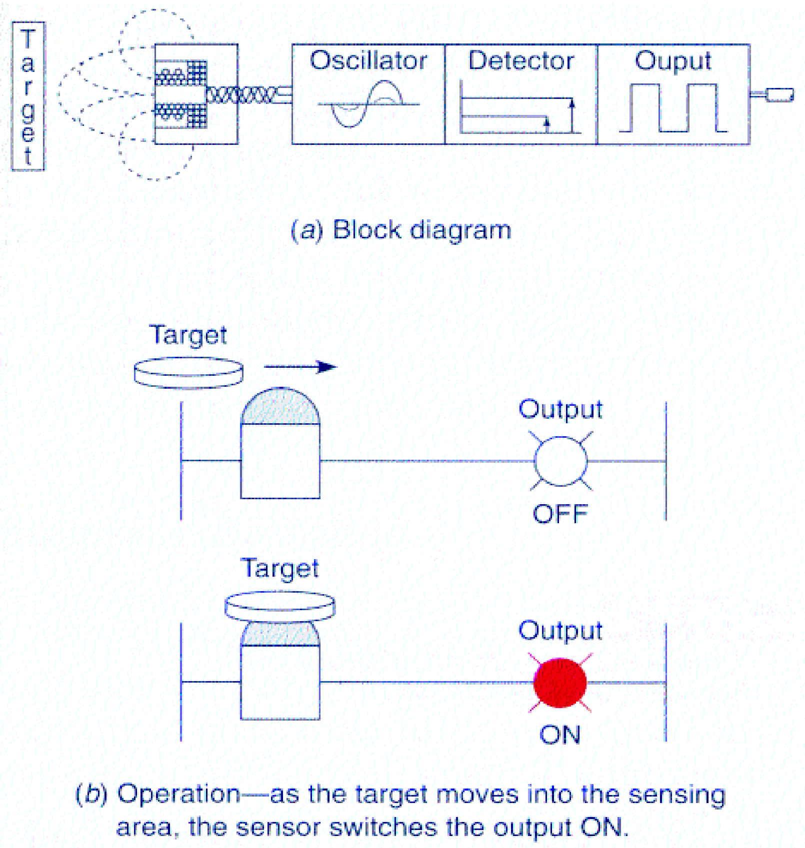


Fig. 6-20
Inductive proximity sensor.

Magnetic detector

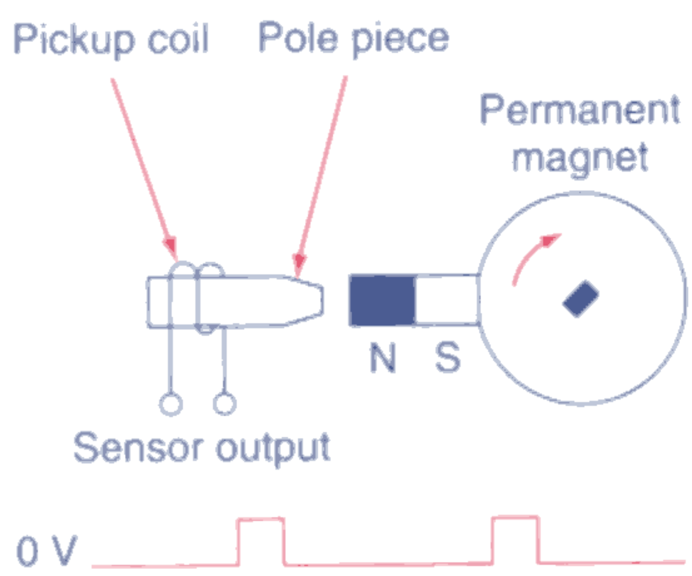


Fig. 6-42
Magnetic pickup sensor.

Magnetic switch

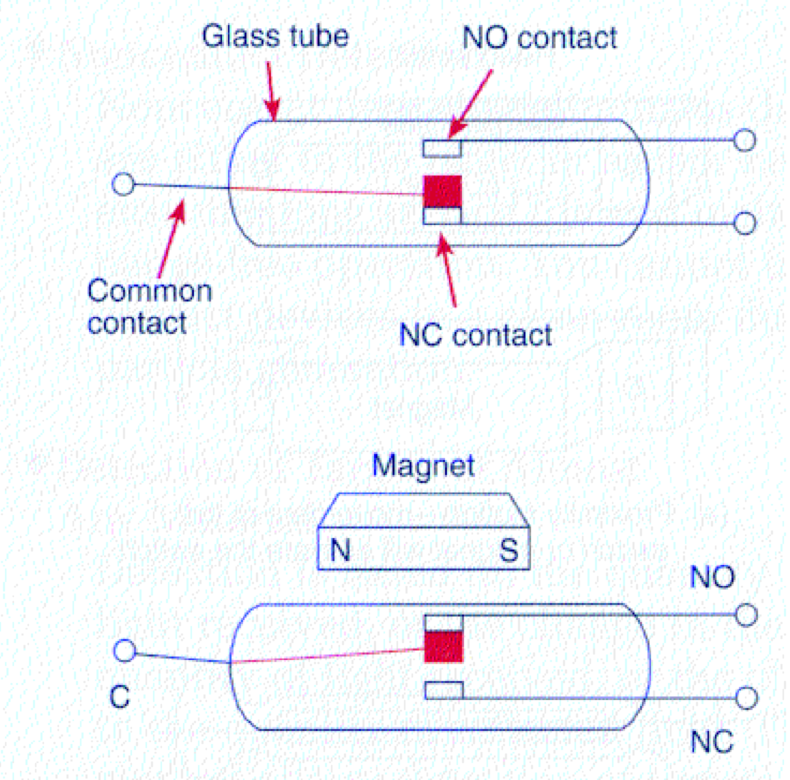


Fig. 6-25
Magnetic switch (reed switch).

Symbols associated to all components

Standards

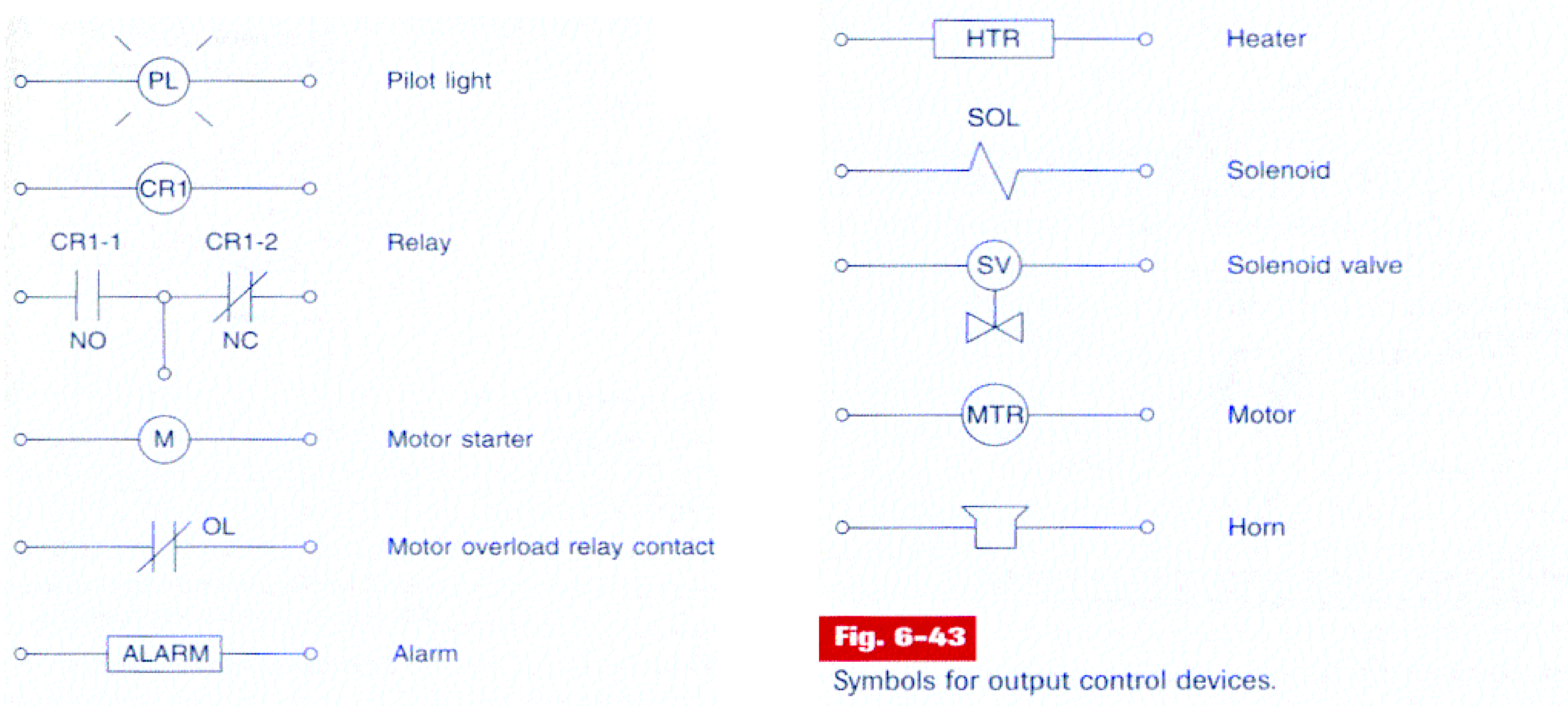
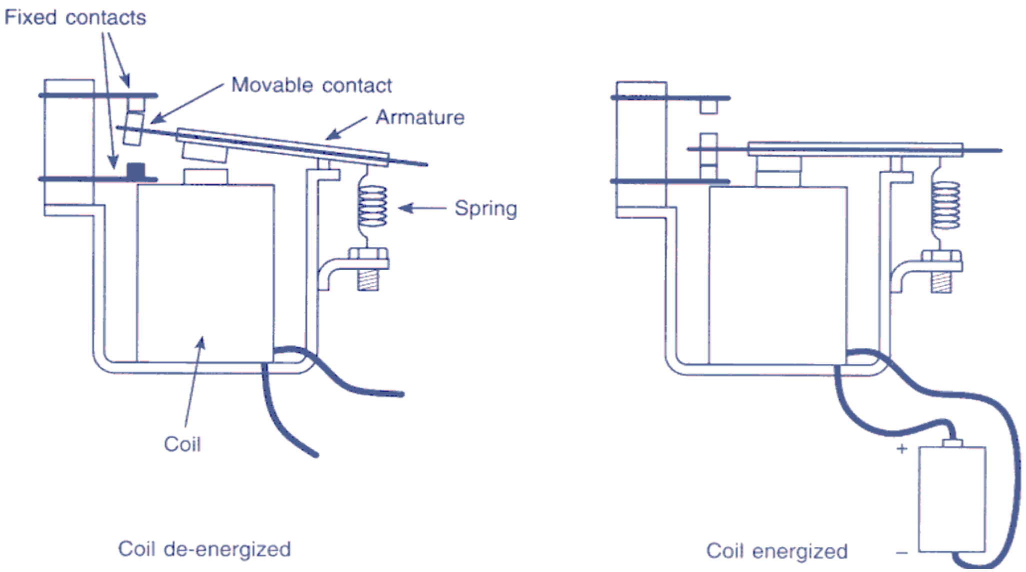


Fig. 6-43
Symbols for output control devices.

Methodologies for the implementation of solutions in industrial automation

Device: Relay



Contact Diagram or ***Ladder Diagram***

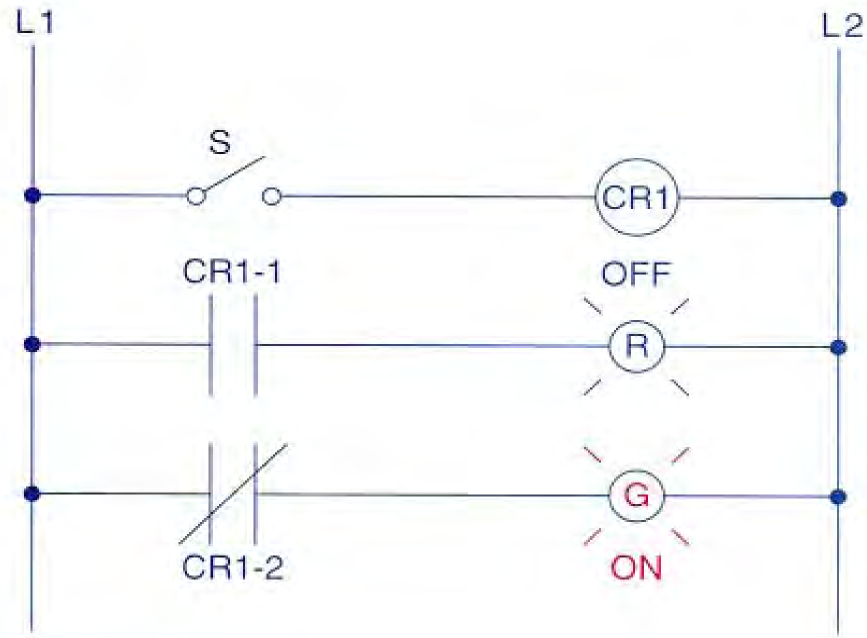


Fig. 6-3
Relay circuit—switch open.

Ladder Diagram

Or

Contact Diagram

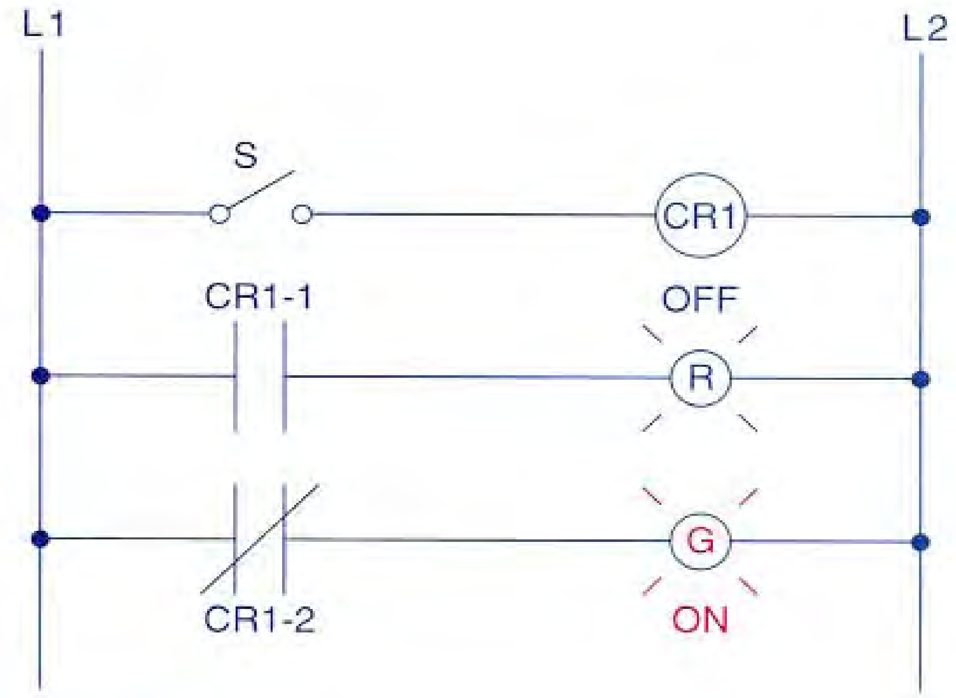


Fig. 6-3

Relay circuit—switch open.

Methodologies for the implementation of solutions in industrial automation

Contacts diagram

Example

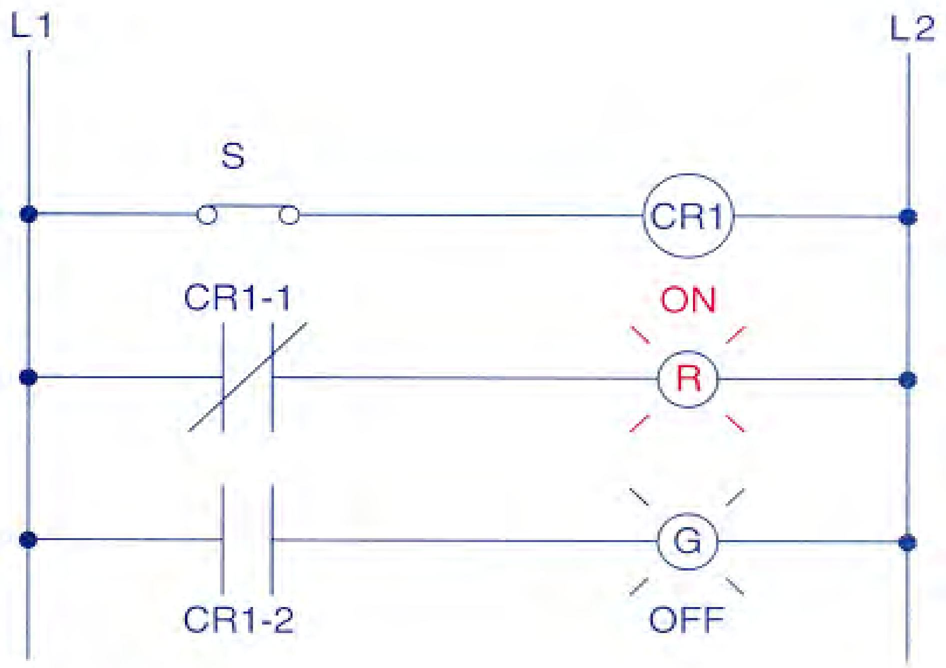


Fig. 6-4
Relay circuit–switch closed.

Example:

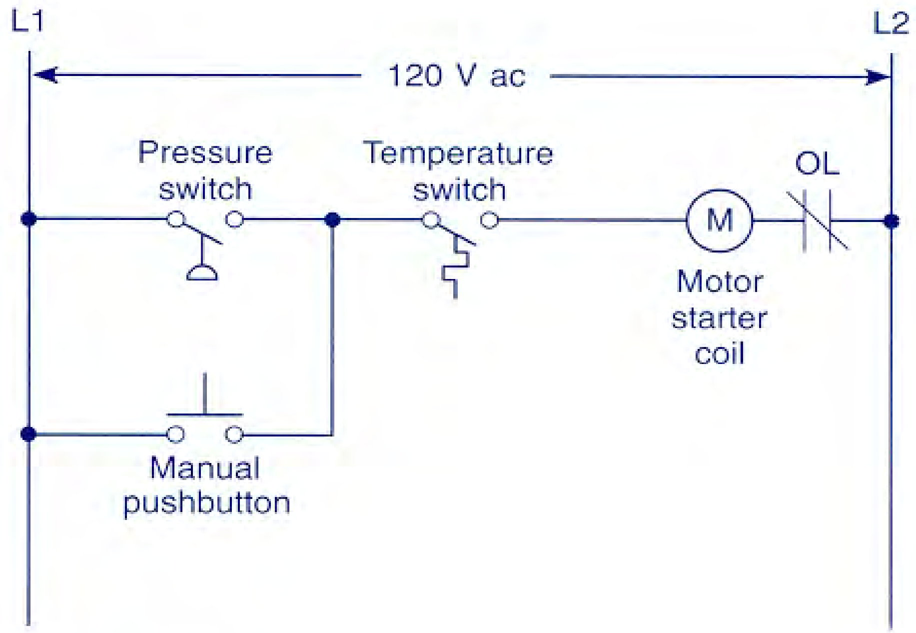


Fig. 1-13
Relay ladder diagram for modified process.

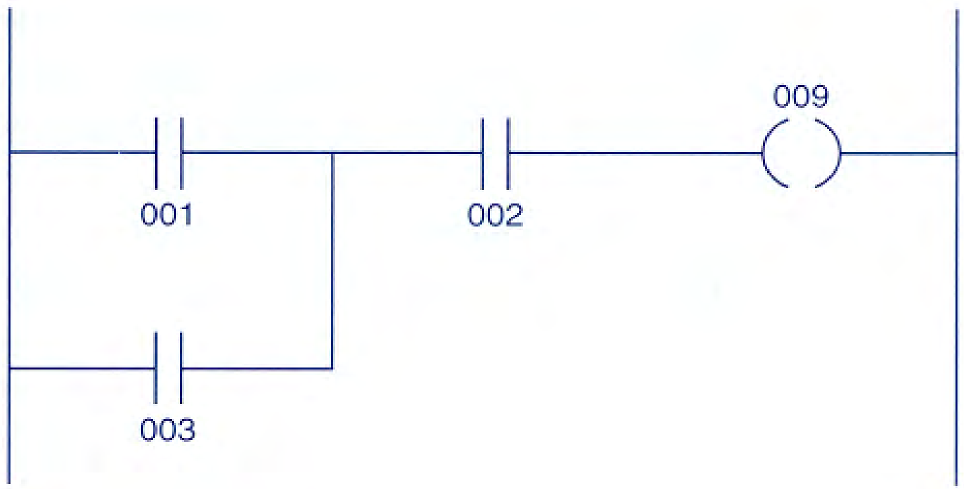
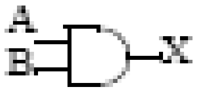


Fig. 1-14
PLC ladder logic diagram for modified process.

Logic Functions

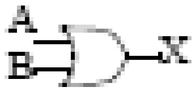
AND



$X = A \cdot B$

A	B	X
0	0	0
0	1	0
1	0	0
1	1	1

OR



$X = A + B$

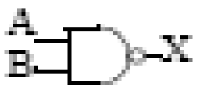
A	B	X
0	0	0
0	1	1
1	0	1
1	1	1

NOT

$X = \bar{A}$

A	X
0	1
1	0

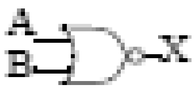
NAND



$X = \overline{A \cdot B}$

A	B	X
0	0	1
0	1	1
1	0	1
1	1	0

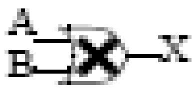
NOR



$X = \overline{A + B}$

A	B	X
0	0	1
0	1	0
1	0	0
1	1	0

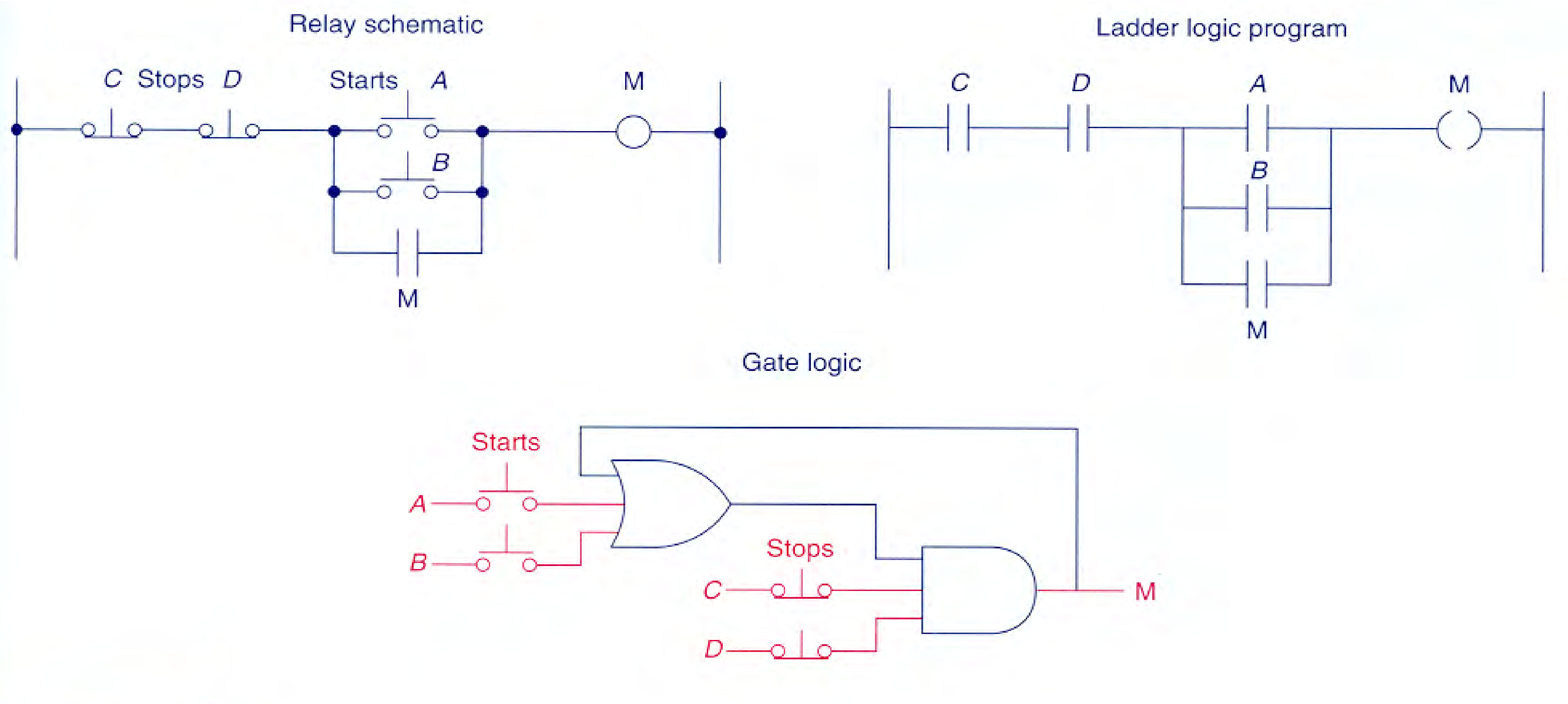
EOR



$X = A \oplus B$

A	B	X
0	0	0
0	1	1
1	0	1
1	1	0

Example:



Example 4-9

A motor control circuit with two stop buttons. When the start button is depressed, the motor runs. By sealing, it continues to run when the start button is released. The stop buttons stop the motor when they are depressed.

To exploit the advantages of Programmed Logic