Industrial Automation

(Automação de Processos Industriais)

GRAFCET

(Sequential Function Chart) 2/2

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

2011-2013 Prof. José Gaspar

Syllabus:

Chap. 3 – PLC Programming languages [2 weeks]

...

Chap. 4 - GRAFCET *(Sequential Function Chart)* [1 week]

The GRAFCET norm.

Elements of the language.

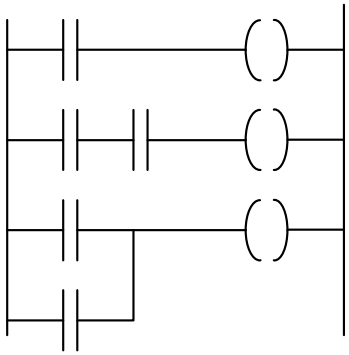
Modelling techniques using GRAFCET.

...

Chap. 5 – CAD/CAM and CNC Machines [1 week]

PLC Programming languages (IEC 1131-3)

Ladder Diagram



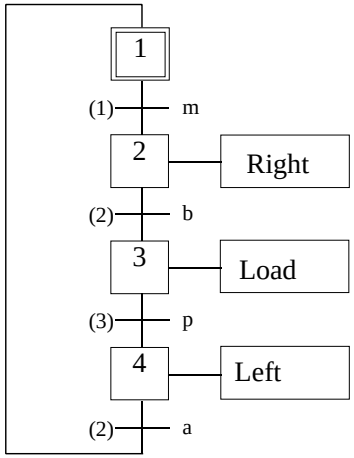
Structured Text

```
If  %I1.0  THEN
  %Q2.1 := TRUE
ELSE
  %Q2.2 := FALSE
END_IF
```

Instruction List

```
LD      %M12
AND     %I1.0
ANDN    %I1.1
OR      %M10
ST      %Q2.0
```

Sequential Function Chart (GRAFCET)



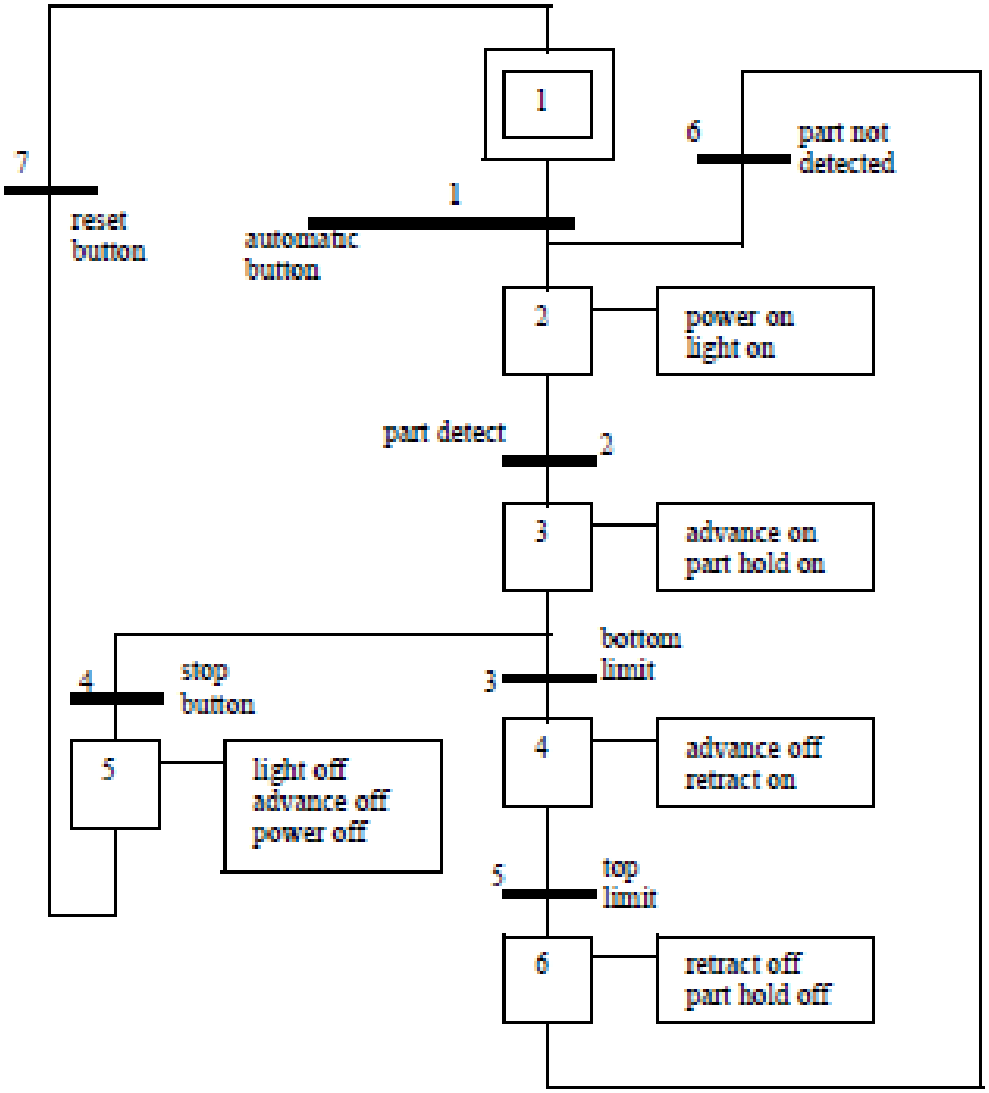
GRAFCET vs Ladder

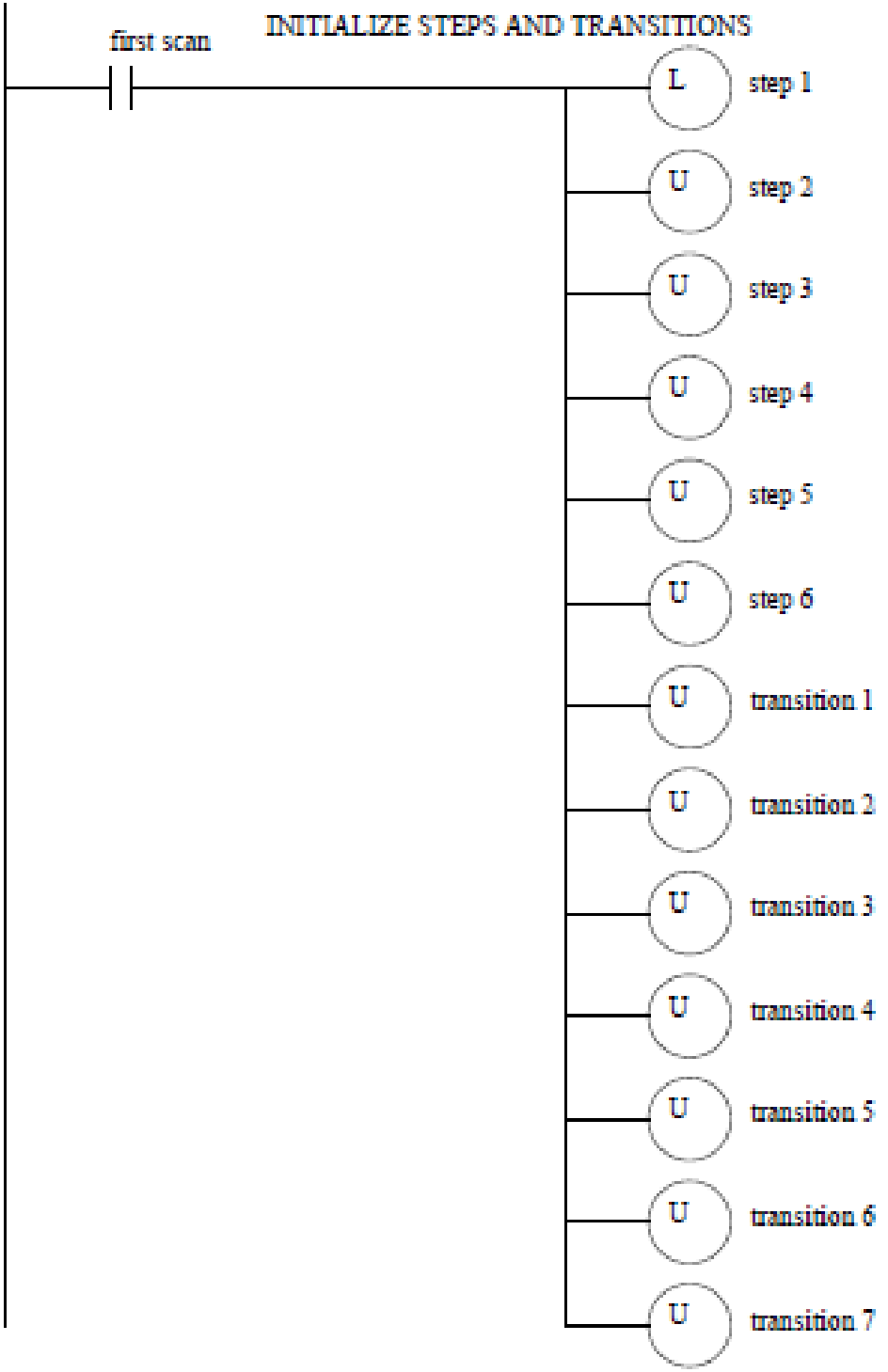
Grafcet/SFC can be converted directly to ladder logic:

0. Assign one Boolean variable to each step (si) and transition (tj)
1. Initialize steps and transitions
2. Check transitions
3. Perform activities for steps
4. Enable transitions

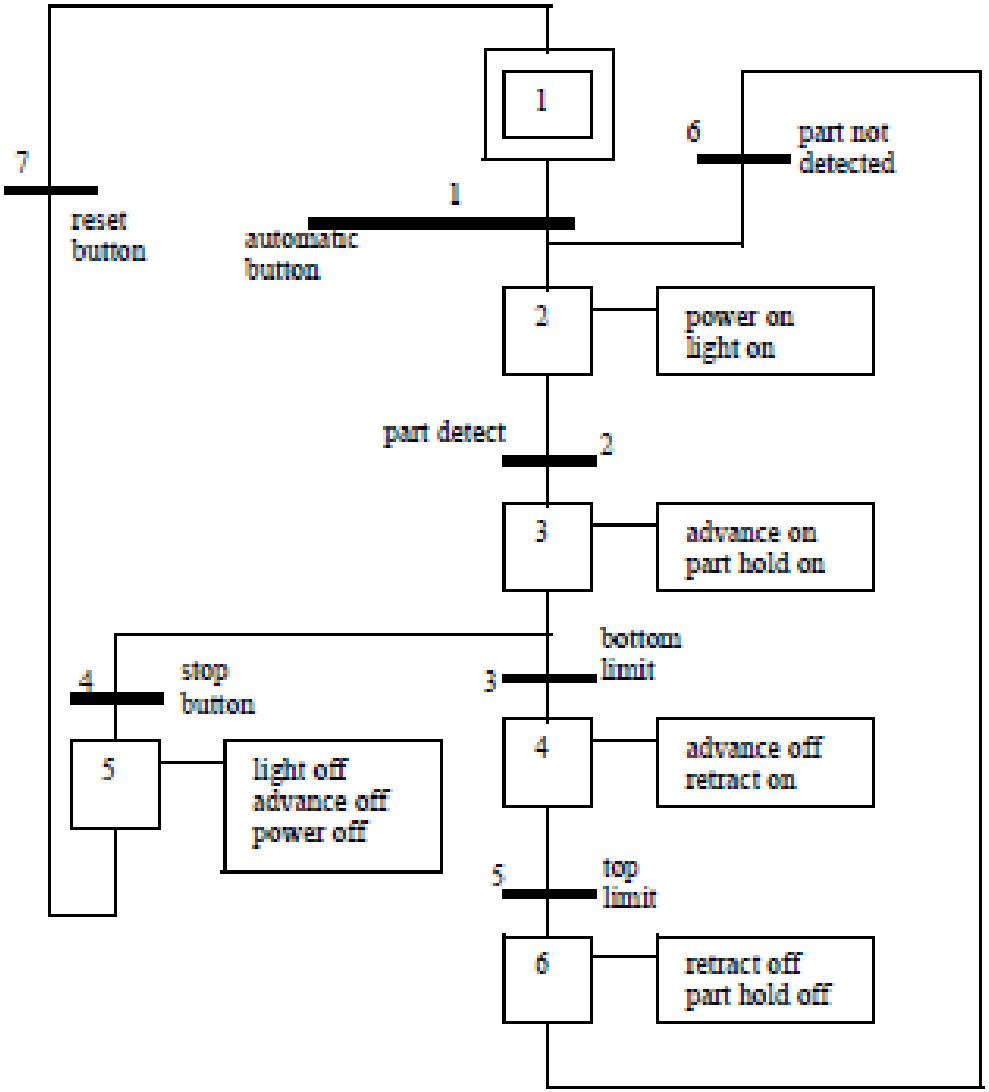
Ref: [Hugh Jack 2008]

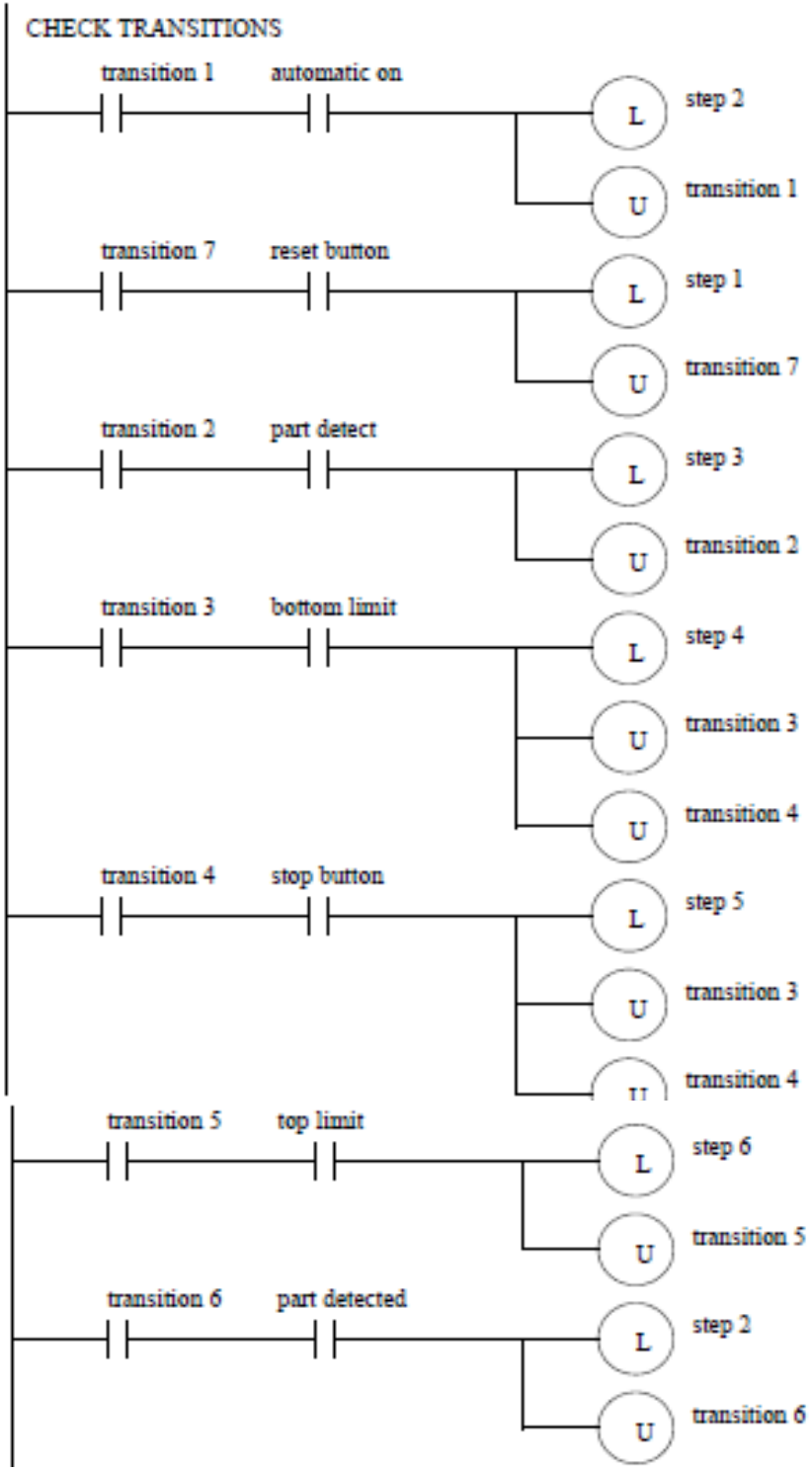
1. Initialize steps and transitions



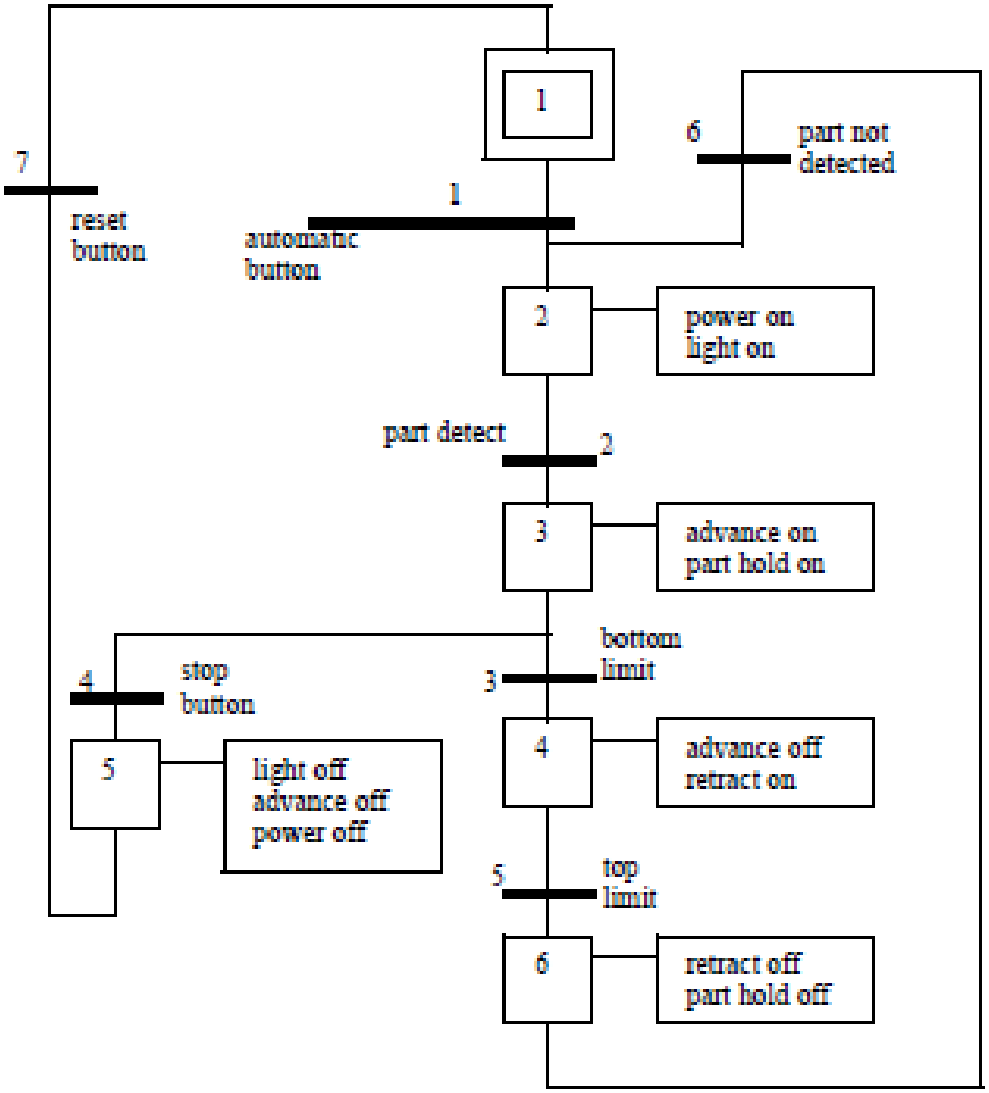


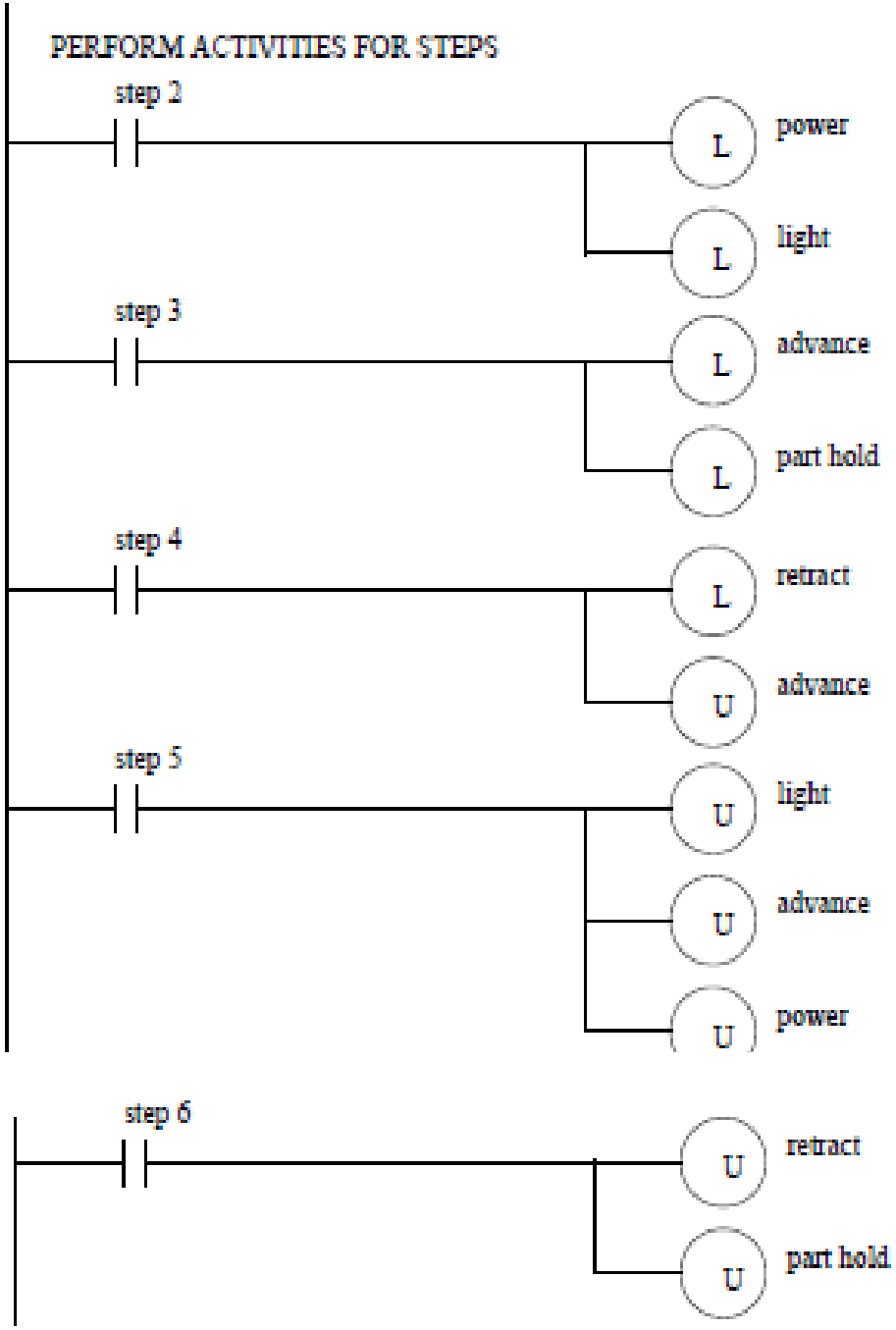
2. Check transitions



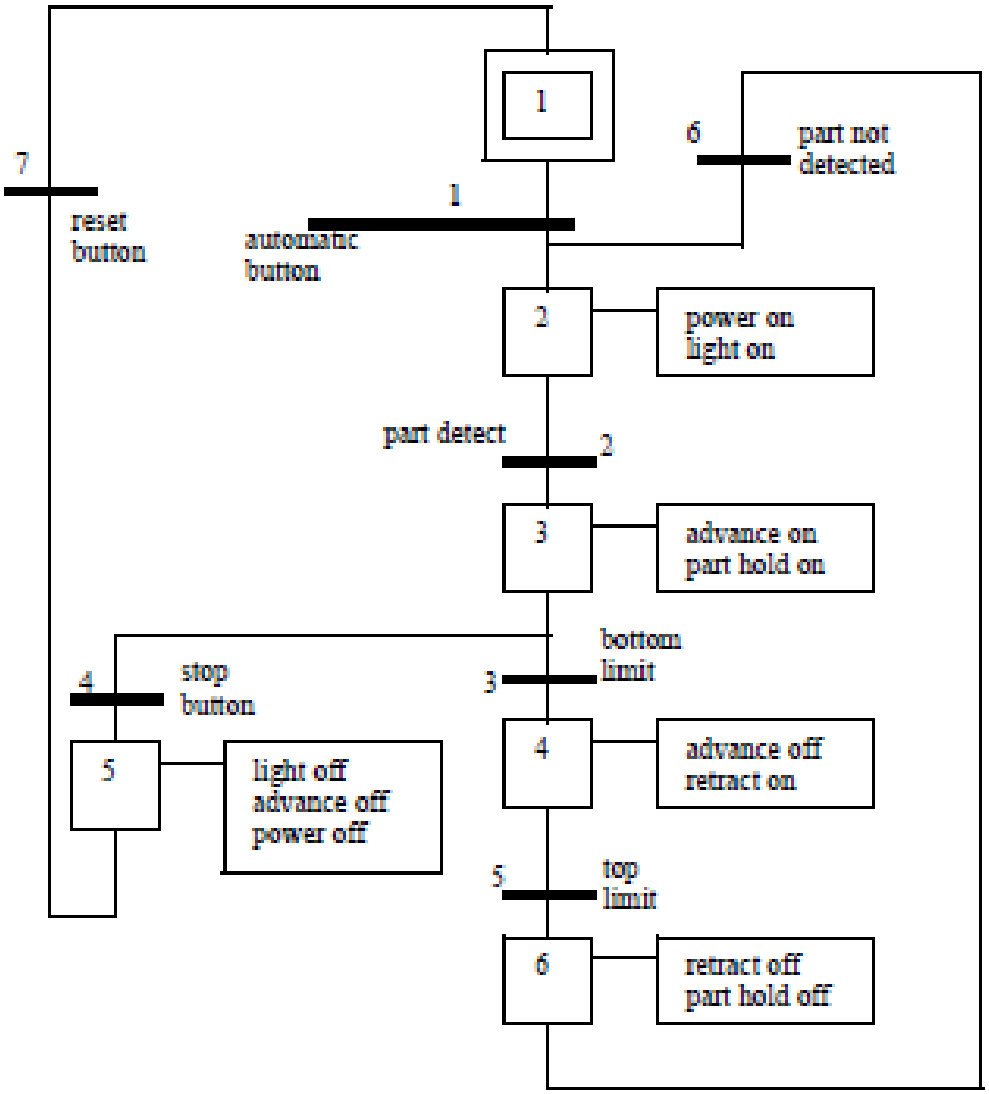


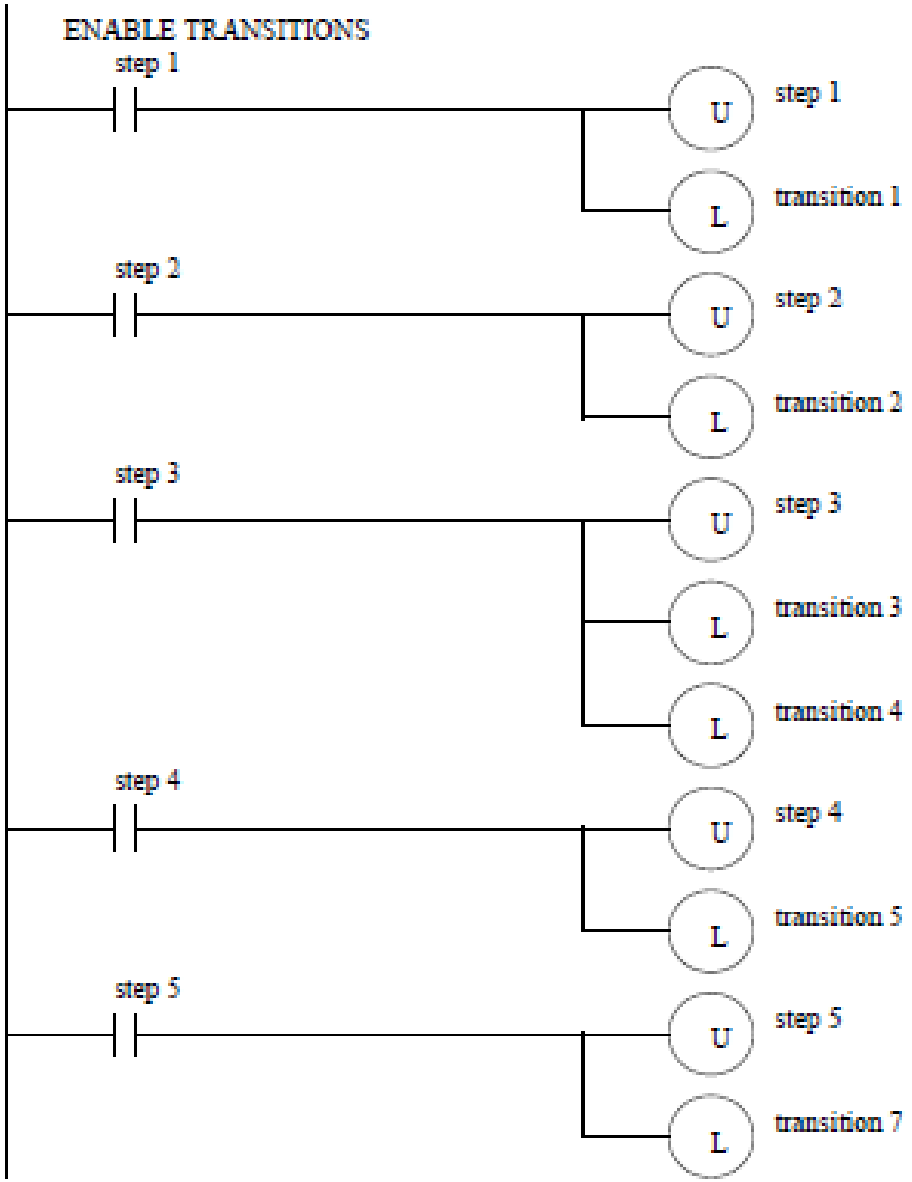
3. Perform activities for steps





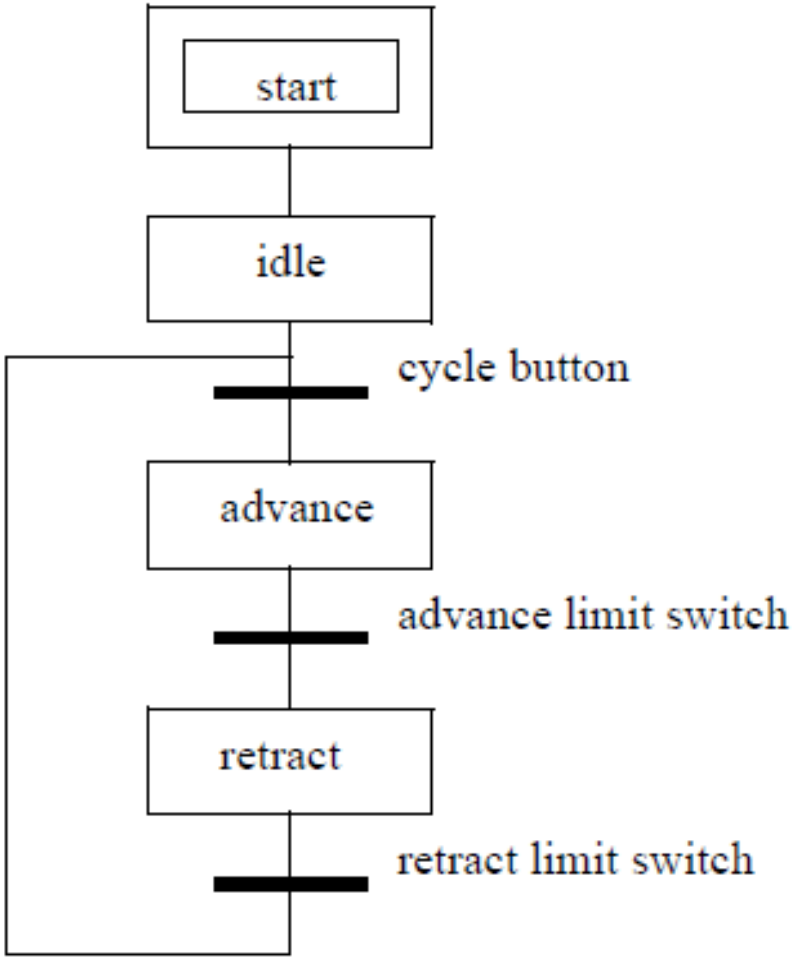
4. Enable transitions





GRAFCET **Practice Problem 1**

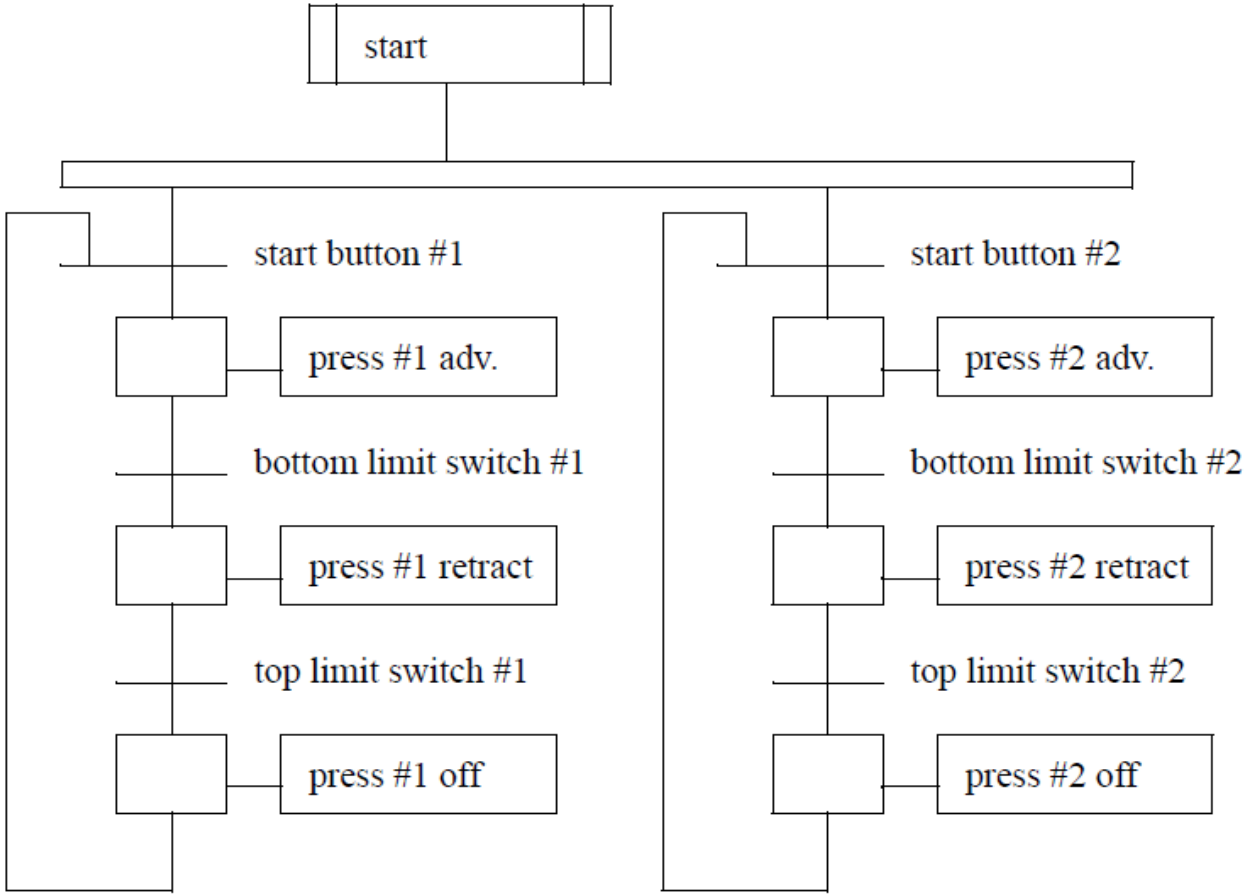
Draw an SFC for a stamping press that can advance and retract when a cycle button is pushed, and then stop until the button is pushed again.



From [Hugh Jack 2008]

GRAFCET **Practice Problem 2**

Develop an SFC for a two person assembly station. The station has two presses that may be used at the same time. Each press has a cycle button that will start the advance of the press. A bottom limit switch will stop the advance, and the cylinder must then be retracted until a top limit switch is hit.

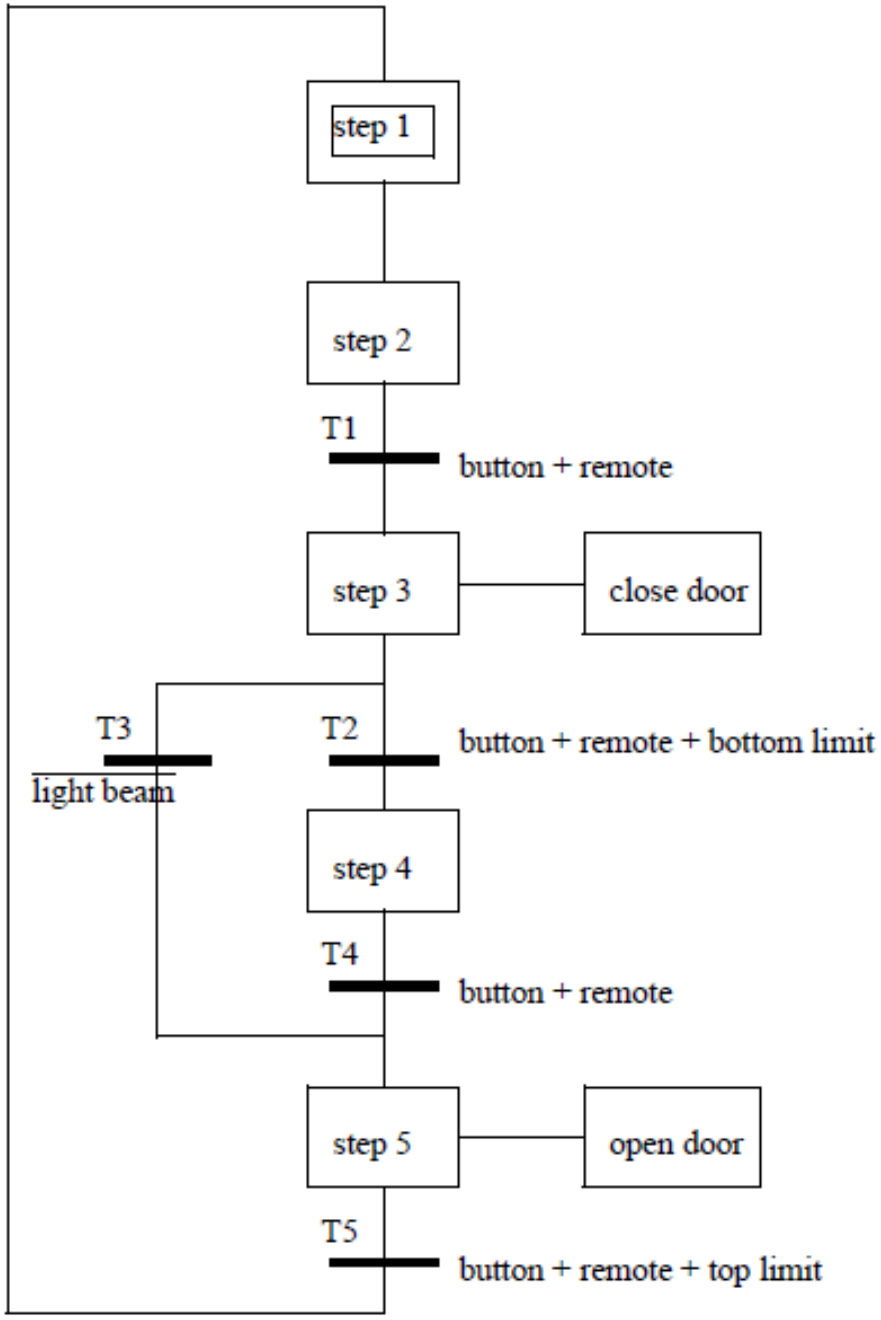


From [Hugh Jack 2008]

GRAFCET **Practice Problem 3**

Design a garage door controller using an SFC. The behavior of the garage door controller is as follows:

- there is a single button in the garage, and a single button remote control.
- when the button is pushed the door will move up or down.
- if the button is pushed once while moving, the door will stop, a second push will start motion again in the opposite direction.
- there are top/bottom limit switches to stop the motion of the door.
- there is a light beam across the bottom of the door. If the beam is cut while the door is closing the door will stop and reverse.
- there is a garage light that will be on for 5 minutes after the door opens or closes.



From [Hugh Jack 2008]