Industrial Automation
(Automação de Processos Industriais)

GRAFCET
(Sequential Function Chart)

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

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Rev. 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 61131-3)

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)
Some pointers to GRAFCETs (SFCs)

History: http://www.lurpa.ens-cachan.fr/grafcet/groupe/gen_g7_uk/geng7.html

http://www-ipst.u-strasbg.fr/pat/autom/grafce_t.htm

Simulator: http://asi.insa-rouen.fr/~amadisa/grafcet_homepage/grafcet.html
http://www.automationstudio.com (See projects)

Bibliography:  • Petri Nets and GRAFCET: Tools for Modelling Discrete Event Systems

               • Grafcet: a powerful tool for specification of logic controllers, R. David,
                 IEEE Trans. on Control Systems Tech., 1995 v3n3 pp253-268 [online]

               • Programação de Autómatos, Método GRAFCET, José Novais,
                 Fundação Calouste Gulbenkian

               • Norme Française NF C 03-190 + R1 : Diagramme fonctionnel
                 "GRAFCET" pour la description des systèmes logiques de commande

Homepage: http://www.lurpa.ens-cachan.fr/grafcet/
GRAFCET History

• 1975 – Decision of the workgroup "Logical Systems" of AFCET (Association Française de Cybernétique Economique et Technique) on the creation of a committee to study a standard for the representation of logical systems and automation.

• 1977 – GRAFCET definition (Graphe Fonctionnel de Commande Etape-Transition).

• 1979 – Dissemination in schools and adopted as research area for the implementation of solutions of automation in the industry.

• 1988 - GRAFCET becomes an international standard denominated as "Sequential Function Chart“, by I.E.C. 60848.
GRAFCET  Basic Elements

**Steps**

<table>
<thead>
<tr>
<th>Inactive</th>
<th>1</th>
</tr>
</thead>
<tbody>
<tr>
<td>Active</td>
<td>2</td>
</tr>
<tr>
<td>Initial</td>
<td>3</td>
</tr>
</tbody>
</table>

**Connections**

Directed Arc

**Transitions**

- **Simple**
  - (1) $R_1$

- **Joint**
  - (2) $R_2$
  - (parallel junction)

- **Fork**
  - (3) $R_3$
  - (parallel branch)

- **Joint e fork**
  - (3) $R_3$

**Actions** can be associated with **Steps**.

A **logical receptivity** function can be associated with each **Transition**.
Oriented connections (arcs)

In a GRAFCET:

An Arc can connect Steps to Transitions

An Arc can connect Transitions to Steps

Arcs must be in-between: A Step can not have Transitions directly as inputs (source); A Step can not have Transitions as direct outputs (drain); Similarly for the Transitions.
GRAFCET  State of a GRAFCET

Definition of State:

The set of markings of a GRAFCET constitutes its state.

Question:

How does the state of a GRAFCET evolve?
GRAFCET  

State Evolution:

• Rule 1: Initial State
State evolution requires active Steps at the beginning of operation (at least one).

• Rule 2: Transposition of a Transition
A Transition is active or enabled only if all the Steps at its input are active (if not it is inactive).
A Transition can only be transposed if it is active and is true the associated condition (receptivity function).

• Rule 3: Evolution of active Steps
The transposition of a Transition leads to the deactivation of all the Steps on its inputs and the activation of all Steps on its outputs.

• Rule 4: Simultaneous transposition of Transitions
All active Transitions are transposed simultaneously.

• Rule 5: Simultaneous activation and deactivation of a Step
In this case the activation has priority.
GRAFCET  

**State Evolution:**

- **Rule 2a:**
  All active Transitions are transposed immediately.

- **Rule 4:**
  Simultaneously active Transitions are transposed simultaneously.
OR Divergences:

If Step 1 active and \( \text{a} \) TRUE then deactivate Step 1 and activate Step 2.

If \( \text{a} \) and \( \text{b} \) TRUE and Step 1 active (PL7) then deactivate Step 1 and activate Steps 2 & 3 (Unity) then deactivate Step 1 and activate Step 2.

AND Divergences:

If Step 1 active and \( \text{a} \) TRUE then deactivate Step 1 and activate Steps 2 and 3.

Note: to make Unity Pro similar to PL7 the option “allow multiple tokens” has to be enabled.
Example:

GRAFCET state evolution

Level activated Action. Actions can also be activated during transitions - see next.
Given 4 Steps (1 to 4) and 2 Transitions (t1 and t2) write a segment of GRAFCET to solve the following problem:

In the case that the Steps 1 and 2 are active:

- if t1 is TRUE, activate Step 3 (and deactivate Steps 1 and 2);
- if t2 is TRUE, activate Step 4 (and deactivate Steps 1 and 2);
- otherwise, the state is maintained.
Given 4 Steps (1 to 4) and 2 Transitions (t1 and t2) write a segment of GRAFCET to solve the following problem:

If Step 1 is active and t1 is TRUE

OR

If Step 2 is active and t2 is TRUE

THEN

Activate Steps 3 and 4.
GRAFCET

GRAFCET state evolution, **Conflicts:**

There exist **Conflicts** when the validation of a Transition depends on the same Step or when more than one receptivity functions can become true simultaneously.

Solutions:

Transition 1 priority

Three mutually exclusive hypotheses
Example 1: modeling a control/automation system
Example 2: modeling a automated transport workcell

* Conveyor A brings parts (sensor a detects part ready to lift)

* Conveyor B brings parts (sensor b detects part ready to lift)

• Hanging crane, commanded with D (droit) e G (gauche), uses sensors x, y e z to detect crane over the base, over A, or over B, respectively.

• Clamp of the crane grabs and releases parts with commands PP and DP. Limit switches fpp and fdp indicate grabbed and released part. A holding platform has two extreme positions, top and bottom, detected by switches fv+ and fv-. Part release can only be done having the holding platform up.

* Effector pushes parts with commands P+ e P-. Limit switches fp+ and fp- indicate max and min pushing positions.

* The output conveyor is always ON.

* Conveyors A e B are commanded by other automata, independent of this workcell.
To guarantee alternating A and B, modify the program, adding the following GRAFCET:

```
(a+b).(x.fpv-fv-)
```

and changing the receptivity function * to:

```
y.a.((b+X10)+z)
```

Explanation: grab part in y, if there exists part in a and if b has not the priority; if b is true and has priority, then grab part in z.

Note: terminology X10 of PL7 changes to S_1_10 in Unity Pro
GRAFCET  Example 2 (cont)

**Improved solution:**

a) After processing one part \((P+)\) prepare immediately to receive the next one: \(f v^+\).

b) Move crane \((D)\) to an optimal waiting location (i.e. location that reduces delays): \(y\).
Example 3: modeling and automation of a distribution system

Objective:
fill 1&2, empty 1&2
refill only after both empty

Sensors:
m = ON/OFF
b₁, h₁, b₂ h₂ = level

Actuators:
V₁, V₂, W₁ W₂ = admit/exhaust
Example 3: modeling and automation of a distribution system
Example 3: modeling and automation of a distribution system
Transitions can be conditions, events and conditions mixed with events

(a) Events $\uparrow f$ and $\downarrow f$ obtained from a condition $f$

(b) Event $\uparrow a \cdot b$ obtained from event $\uparrow a$ and condition $b$

(c) Event $\uparrow a \cdot \uparrow b$ obtained from events $\uparrow a$ and $\uparrow b$

(d) Event $\uparrow a + \uparrow b$ obtained from events $\uparrow a$ and $\uparrow b$

GRAFCET Transitions can be conditions, events and conditions mixed with events

Properties of events (edge triggers) mixed with conditions (Boolean variables):

$\uparrow a = \downarrow a'$

$\uparrow a . a = \uparrow a, \quad \uparrow a . a' = 0, \quad \downarrow a . a' = \downarrow a, \quad \downarrow a . a = 0$

$\uparrow a . \uparrow a = \uparrow a, \quad \uparrow a . \uparrow a' = 0$

$\uparrow (a . b) = \uparrow a . b + \uparrow b . a, \quad \uparrow (a + b) = \uparrow a . b' + \uparrow b . a'$

$\uparrow (a . b) . \uparrow (a . c) = \uparrow (a . b . c)$

In general, if events $a$ and $b$ are independent

$\uparrow a . \uparrow b = 0$
GRAFCET Other auxiliary mechanisms

Macro-steps
GRAFCET  Other auxiliary mechanisms

Pseudo Macro-steps

Macro Actions

• Force actions

• Enable actions

• Mask actions
The activity of each Step is stored in an auxiliary memory.

At startup do:

AM128

SLMx

...

AM128

SLMy

(initial steps)

RLM128

Store $R_k$ evaluation in M100

$R_k$
## Steps

<table>
<thead>
<tr>
<th>Name</th>
<th>Symbol</th>
<th>Functions</th>
</tr>
</thead>
<tbody>
<tr>
<td>Initial steps (i)</td>
<td><img src="image" alt="Symbol" /></td>
<td>symbolize the initial active steps at the beginning of the cycle after initialization or re-start from cold.</td>
</tr>
</tbody>
</table>
| Simple steps (i)     | ![Symbol](image) | show that the automatic system is in a stable condition. The maximum number of steps (including the initial steps) can be configured from:  
  • 1 - 96 for a TSX 37-10,  
  • 1 - 128 for a TSX 37-20,  
  • 1 - 250 for a TSX 57.  
  The maximum number of active steps at the same time can be configured. |
GRAFCET Implementation in the TSX3722/TSX57

Macro-steps

<table>
<thead>
<tr>
<th>Name</th>
<th>Symbol</th>
<th>Functions</th>
</tr>
</thead>
<tbody>
<tr>
<td>Macro steps</td>
<td>![Macro Step Symbol]</td>
<td>Symbolize a macro step: a single group of steps and transitions. The maximum number of macro steps can only be configured from 0 - 63 for the TSX 57.</td>
</tr>
<tr>
<td>Stage of Macro steps</td>
<td>![Stage Symbol]</td>
<td>Symbolizes the stages of a macro step. The maximum number of stages for each macro step can be configured from 0 - 250 for the TSX 57. Each macro step includes an IN and OUT step.</td>
</tr>
</tbody>
</table>
## GRAFCET Implementation in the TSX3722/TSX57

<table>
<thead>
<tr>
<th>Name</th>
<th>Symbol</th>
<th>Functions</th>
</tr>
</thead>
<tbody>
<tr>
<td>Transitions</td>
<td><img src="image" alt="Symbol" /></td>
<td>allow the transfer from one step to another. A transition condition associated with this condition is used to define the logic conditions necessary to cross this transition. The maximum number of transitions is 1024. It cannot be configured. The maximum number of valid transitions at the same time can be configured.</td>
</tr>
<tr>
<td>AND divergences</td>
<td><img src="image" alt="Symbol" /></td>
<td>Transition from one step to several steps: is used to activate a maximum of 11 steps at the same time.</td>
</tr>
<tr>
<td>AND convergences</td>
<td><img src="image" alt="Symbol" /></td>
<td>Transition of several steps to one: is used to deactivate a maximum of 11 steps at the same time.</td>
</tr>
<tr>
<td>OR divergences</td>
<td><img src="image" alt="Symbol" /></td>
<td>Transition from one step to several steps: is used to carry out a switch to a maximum of 11 steps.</td>
</tr>
<tr>
<td>OR convergences</td>
<td><img src="image" alt="Symbol" /></td>
<td>Transition of several steps to one: is used to end switching from a maximum of 11 steps.</td>
</tr>
</tbody>
</table>
## Arcs/Connectors

<table>
<thead>
<tr>
<th>Name</th>
<th>Symbol</th>
<th>Functions</th>
</tr>
</thead>
<tbody>
<tr>
<td>Source connectors</td>
<td>![n]</td>
<td>&quot;n&quot; is the number of the step &quot;it comes from&quot; (source step).</td>
</tr>
<tr>
<td>Destination connector</td>
<td>![n]</td>
<td>&quot;n&quot; is the number of the step &quot;it's going to&quot; (target step).</td>
</tr>
<tr>
<td>Links directed towards:</td>
<td>![top]</td>
<td>These links are used for switching, jumping a step, restarting steps (sequence).</td>
</tr>
<tr>
<td></td>
<td>![bottom]</td>
<td></td>
</tr>
<tr>
<td></td>
<td>![right or left]</td>
<td></td>
</tr>
</tbody>
</table>
Information associated with Steps in the GRAFCET:

<table>
<thead>
<tr>
<th>Name</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bits associated with the steps (1 = active step)</td>
<td>%Xi  Status of the i step of the main Grafcet (i from 0 - n) (n depends on the processor)</td>
</tr>
<tr>
<td></td>
<td>%XMj  Status of the j macro step (j from 0 - 63 for TSX/PMX/PCX 57)</td>
</tr>
<tr>
<td></td>
<td>%Xj.i Status of the i step of the j macro step</td>
</tr>
<tr>
<td></td>
<td>%Xj.IN Status of the input step of the j macro step</td>
</tr>
<tr>
<td></td>
<td>%Xj.OUT Status of the output step of the j macro step</td>
</tr>
<tr>
<td>System bits associated with Grafcet</td>
<td>%S21  Initializes Grafcet</td>
</tr>
<tr>
<td></td>
<td>%S22  Grafcet resets everything to zero</td>
</tr>
<tr>
<td></td>
<td>%S23  Freezes Grafcet</td>
</tr>
<tr>
<td></td>
<td>%S24  Resets macro steps to 0 according to the system words %SW22 - %SW25</td>
</tr>
<tr>
<td></td>
<td>%S25  Set to 1 when:</td>
</tr>
<tr>
<td></td>
<td>• tables overflow (steps/transition),</td>
</tr>
<tr>
<td></td>
<td>• an incorrect graph is run (destination connector on a step which does not belong to the graph).</td>
</tr>
</tbody>
</table>

PL7 (changed in Unity)
Information associated with Steps in the GRAFCET (bis):

<table>
<thead>
<tr>
<th>Name</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Words associated with steps</td>
<td></td>
</tr>
<tr>
<td>%Xi.T</td>
<td>Activity time for main Gracchet step i.</td>
</tr>
<tr>
<td>%Xj.i.T</td>
<td>Activity time for the i step of the j macro step</td>
</tr>
<tr>
<td>%Xj.IN.T</td>
<td>Activity time for the input step of the j macro step</td>
</tr>
<tr>
<td>%Xj.OUT.T</td>
<td>Activity time for the output step of the j macro step</td>
</tr>
<tr>
<td>System words associated with</td>
<td></td>
</tr>
<tr>
<td>Grafct</td>
<td></td>
</tr>
<tr>
<td>%SW20</td>
<td>Word which is used to inform the current cycle of the number of active steps,</td>
</tr>
<tr>
<td></td>
<td>to be activated and deactivated.</td>
</tr>
<tr>
<td>%SW21</td>
<td>Word which is used to inform the current cycle of the number of valid</td>
</tr>
<tr>
<td></td>
<td>transitions to be validated or invalidated.</td>
</tr>
<tr>
<td>%SW22 à %SW25</td>
<td>Group of 4 words which are used to indicate the macro steps to be reset to 0</td>
</tr>
<tr>
<td></td>
<td>when bit %S24 is set to 1.</td>
</tr>
</tbody>
</table>

And where to find information related with Transitions?

Does not make sense state or activity nor timings
(only number of occurrences).  

PL7 (changed in Unity)
GRAFCET

General structure:

Characteristics:

<table>
<thead>
<tr>
<th>Number</th>
<th>TSX 37 -10</th>
<th>TSX 37 -20</th>
<th>TSX 57</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Default</td>
<td>Maximum</td>
<td>Default</td>
</tr>
<tr>
<td>Main graph steps</td>
<td>96</td>
<td>128</td>
<td>128</td>
</tr>
<tr>
<td>Macro steps</td>
<td>0</td>
<td>0</td>
<td>8</td>
</tr>
<tr>
<td>Macro step steps</td>
<td>0</td>
<td>0</td>
<td>64</td>
</tr>
<tr>
<td>Step total</td>
<td>96</td>
<td>128</td>
<td>640</td>
</tr>
<tr>
<td>Steps active at the same time</td>
<td>16</td>
<td>20</td>
<td>40</td>
</tr>
<tr>
<td>Transitions valid at the same time</td>
<td>20</td>
<td>24</td>
<td>48</td>
</tr>
</tbody>
</table>
GRAFCET

Editor: 8 pages

• Pages 0 to 7

• 154 cells (14*11)

Characteristics:

• The first line is used to enter the source connectors.
• The last line is used to enter the destination connectors.
• The even lines (from 2 - 12) are step lines (for destination connector steps),
• The odd lines (from 3 - 13) are transition lines (for transitions and source connectors).
• Each step is located by a different number (0 - 127) in any order.
• Different graphs can be displayed on one page.
GRAFCET

OR divergences

(OR convergences)

Characteristics:

- The number of transitions upstream of a switching end (OR convergence) or downstream of a switching (OR divergence) must not exceed 11.
- Switching can be to the left or to the right.
- Switching must general finish with switching end.
- To avoid crossing several transitions at the same time, the associated transition conditions must be exclusive.
GRAFCET

AND divergences

(AND Convergences)

Characteristics:

- The number of steps downstream from a simultaneous activation (AND divergence) or upstream from a simultaneous deactivation (AND convergence) must not exceed 11.
- Simultaneous activation of steps must usually end with a simultaneous deactivation of steps.
- Simultaneous activation is always shown from left to right.
- Simultaneous deactivation is always shown from right to left.
GRAFCET

Arcs/Connectors

Diagram showing the connections in a GRAFCET diagram.
## Rules for divergences and convergences:

### OR

<table>
<thead>
<tr>
<th>Rule</th>
<th>Illustration</th>
</tr>
</thead>
<tbody>
<tr>
<td>For switching, transitions and destination connectors must be entered on the same page.</td>
<td><img src="image1.png" alt="Illustration" /></td>
</tr>
<tr>
<td>To end switching, the source connectors must be entered on the same page as the destination step.</td>
<td><img src="image2.png" alt="Illustration" /></td>
</tr>
<tr>
<td>For an end to switching followed by a return to destination, there must be as many source connectors as steps before the end of switching.</td>
<td><img src="image3.png" alt="Illustration" /></td>
</tr>
</tbody>
</table>

### AND

<table>
<thead>
<tr>
<th>Rule</th>
<th>Illustration</th>
</tr>
</thead>
<tbody>
<tr>
<td>To activate steps simultaneously, the destination connectors must be on the same page as the divergence step and transition.</td>
<td><img src="image4.png" alt="Illustration" /></td>
</tr>
<tr>
<td>To deactivate simultaneously, the convergence steps and transition must be on the same page as the destination connector. When several steps converge onto one transition, the source connector has the number of the furthest upstream step on the left.</td>
<td><img src="image5.png" alt="Illustration" /></td>
</tr>
</tbody>
</table>
GRAFCET

Programming Actions

The PL7 software allows three types of action:

- **actions for activation**: actions carried out once when the step with which they are associated passes from the inactive to the active state.
- **actions for deactivation**: actions carried out once when the step with which they are associated passes from the active to the inactive state.
- **continuous actions**: these actions are carried out for as long as the step with which they are associated is active.

**Note**: One action can include several programming elements (sequences or contact networks).

These actions are located in the following manner:

```
MAST - <Graf cet section name> - CHART (or MACROk)- PAGE n %Xi x
with
x = P1 for Activation, x = N1 Continuous, x = P0 Deactivation
n = Page number
i = Step number
```

**Example**: MAST - Paint - CHART - PAGE 0 %X1 P1 Action for activating step 1 of page 0 of the Paint section
GRAFCET

Programming Actions

Example of execution of Actions

Example of Activation/deactivation

Example of continuous Action
GRAFCET

GRAFCET Section Structure

1. Preliminary processing
   - LD, IL, ST
2. Sequential processing
3. Subsequent processing
   - LD, IL, ST
GRAFCET

GRAFCET Section Initialization

Initializing the Grafcet is done by the system bit %S21. Normally set at state 0, setting %S21 to 1 causes:

- active steps to deactivate,
- initial steps to activate.

The following table gives the different possibilities for setting to the system bit %S21 to 1 and 0.

<table>
<thead>
<tr>
<th>Set to 1</th>
<th>Reset to 0</th>
</tr>
</thead>
<tbody>
<tr>
<td>• By setting %S0 to 1</td>
<td>• By the system at the beginning of the process</td>
</tr>
<tr>
<td>• By the user program</td>
<td>• By the user program</td>
</tr>
<tr>
<td>• By the terminal (in debugging or animation table)</td>
<td>• By the terminal (in debugging or animation table)</td>
</tr>
</tbody>
</table>
GRAFCET

GRAFCET Section Reset

The system bit %S22 resets Grafcet to 0.

Normally set at 0, setting %S22 to 1 causes active steps in the whole of the sequential process to deactivate.

**Note:** The RESET_XIT function used to reinitialize via the program the step activity time of all the steps of the sequential processing. (See (See Reference Manual, Volume 2)).

The following table gives the different possibilities for setting to the system bit %S22 to 1 and 0.

<table>
<thead>
<tr>
<th>Set to 1</th>
<th>Reset to 0</th>
</tr>
</thead>
<tbody>
<tr>
<td>● By the user program</td>
<td>● By the system at the end of the sequential</td>
</tr>
<tr>
<td>● By the terminal (in debugging or animation</td>
<td>process</td>
</tr>
<tr>
<td>table)</td>
<td></td>
</tr>
</tbody>
</table>
Properties of **Transition Sections** (Unity Pro)

Transition sections have the following properties:

- Transition sections only have **one single output** (transition variable), whose data type is BOOL. The name of these variables are identical to the names of the transition sections.
- The transition variable can only be used once in written form.
- The transition variable can be read in any position within the project.
- Only functions can be used, function blocks or procedures cannot.
- **Only one coil** may be used in LD.
- There is only one network, i.e. all functions used are linked with each other either directly or indirectly.
- Transition sections can only be used once.
- Transition sections belong to the SFC section in which they were defined. If the respective SFC section is deleted then all transition sections of this SFC section are also deleted automatically.
- Transition sections can be called exclusively from transitions.