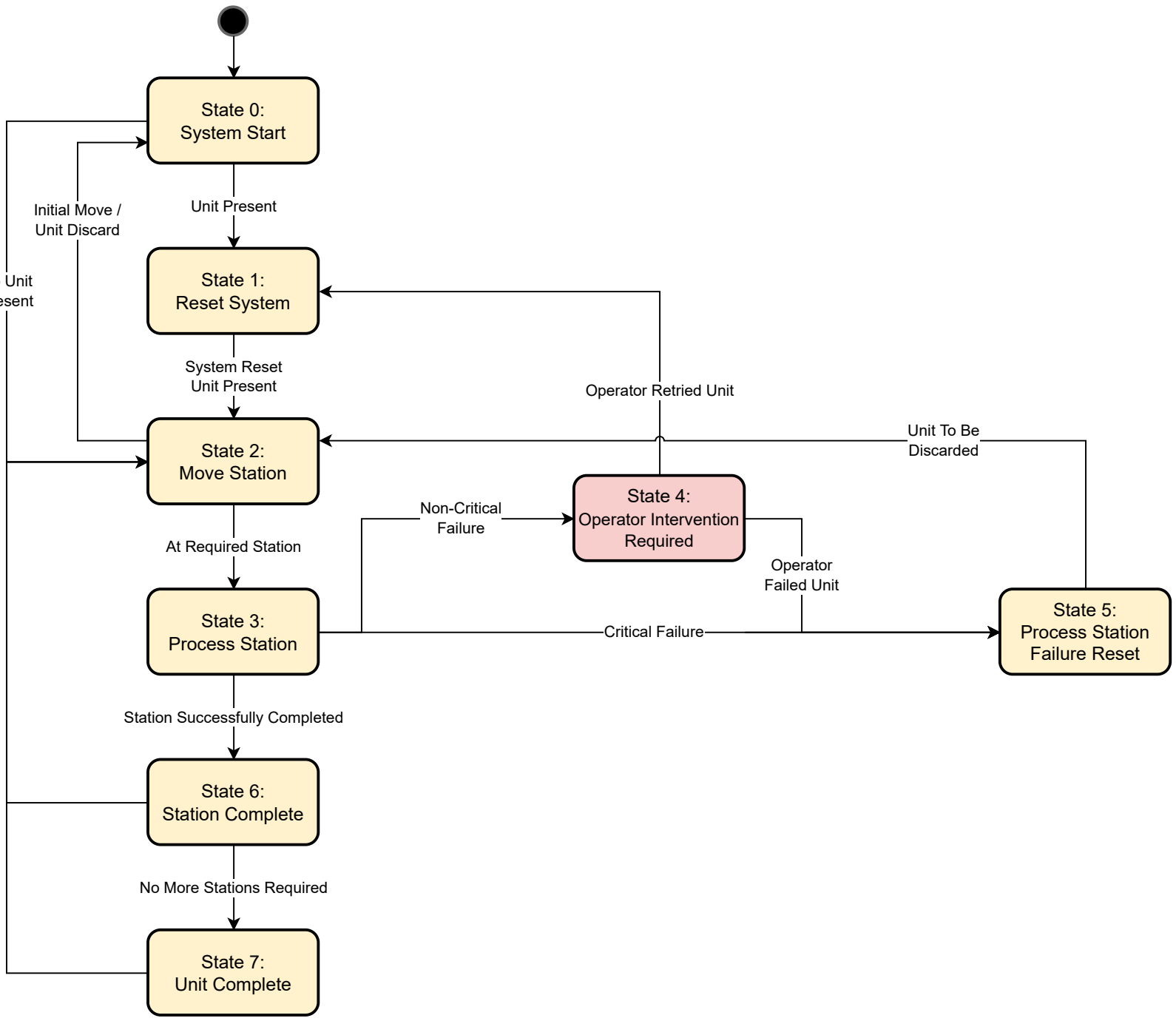
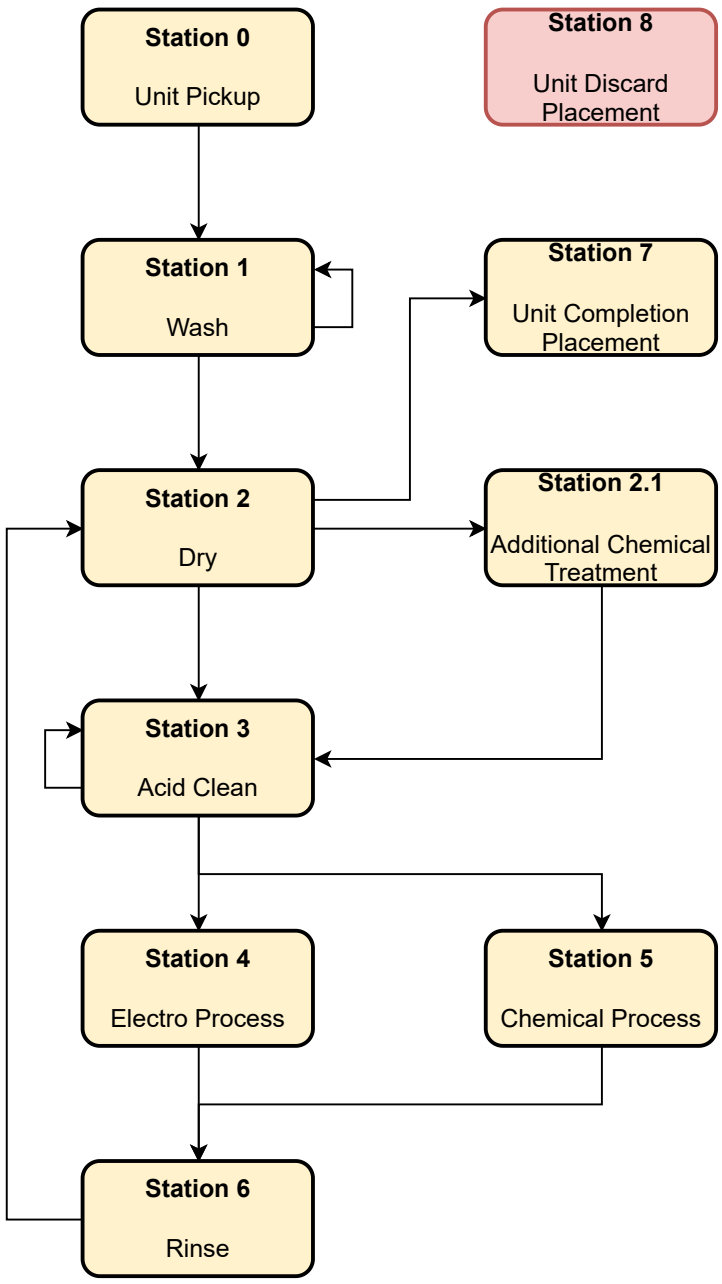
State Overview



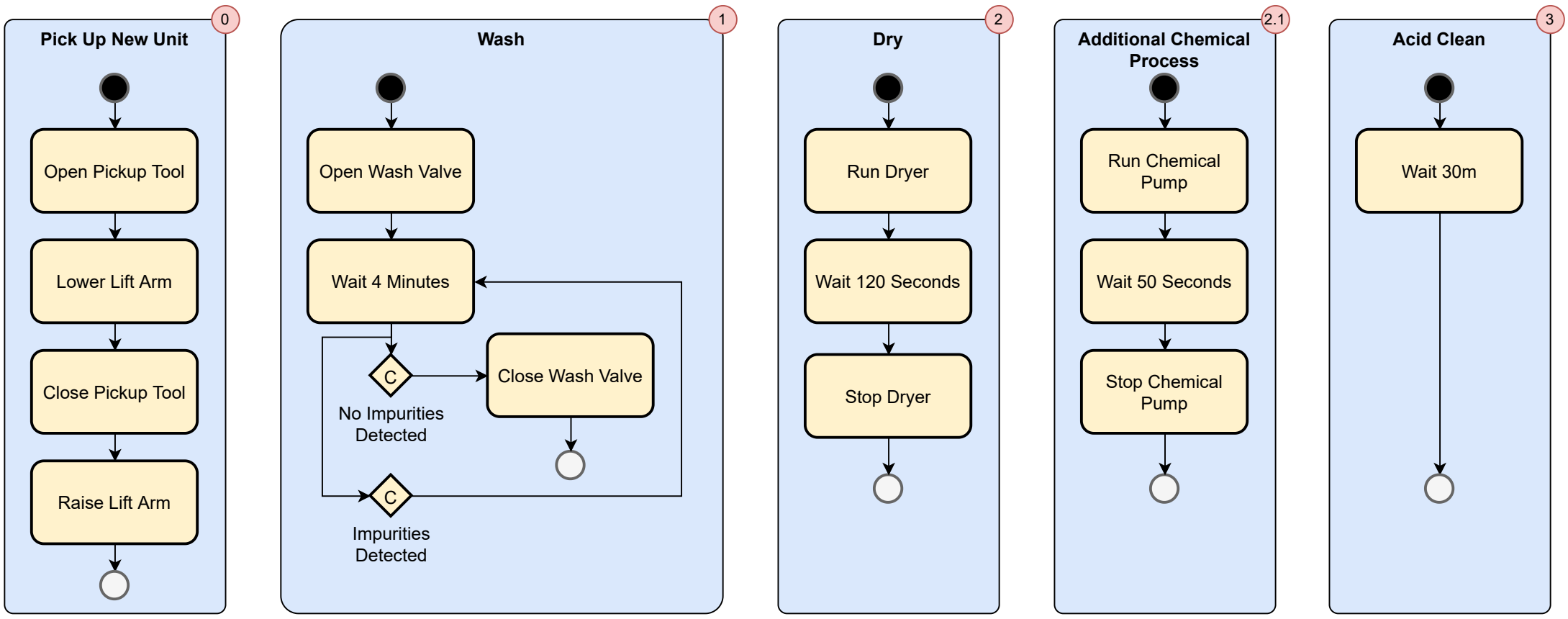
Station Overview

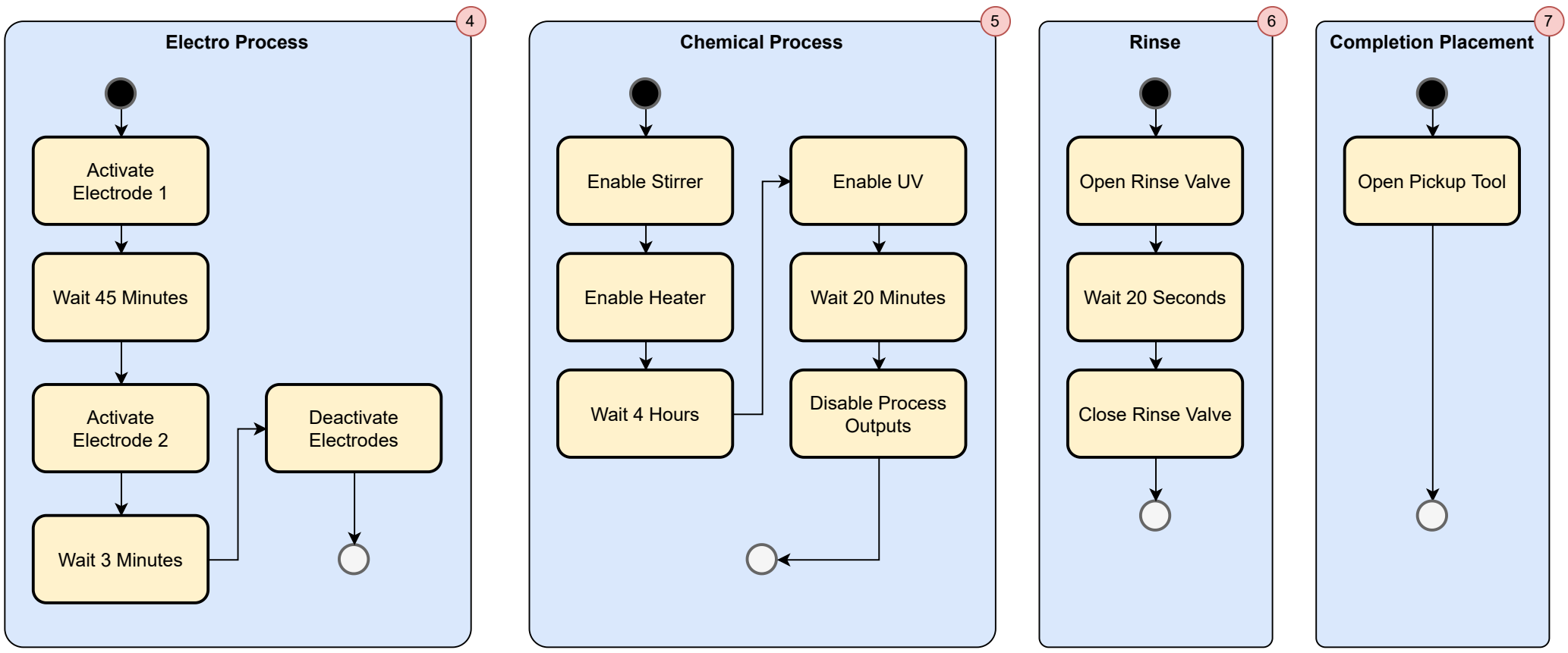


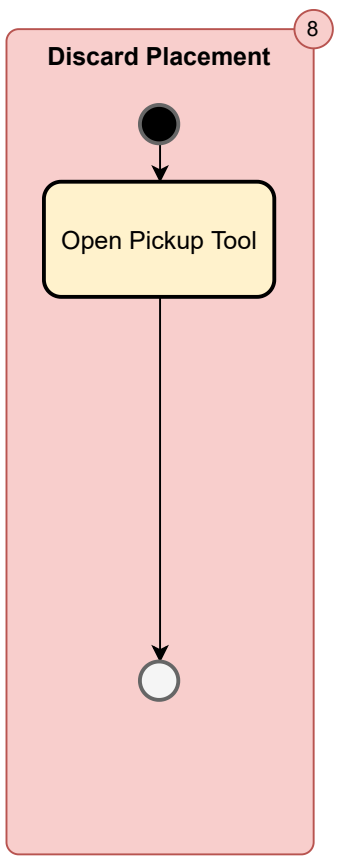
Station Control

Note

All stations require a "Lower Arm" and "Raise Arm" event.
The "Lower Arm" occurs before the station's control executes
The "Raise Arm" event occurs after the the station's control executes







Note

State 0 is **always** the first State in the sequence

This state picks up a **Unit** if one is not already present in the **Pick Tool**.

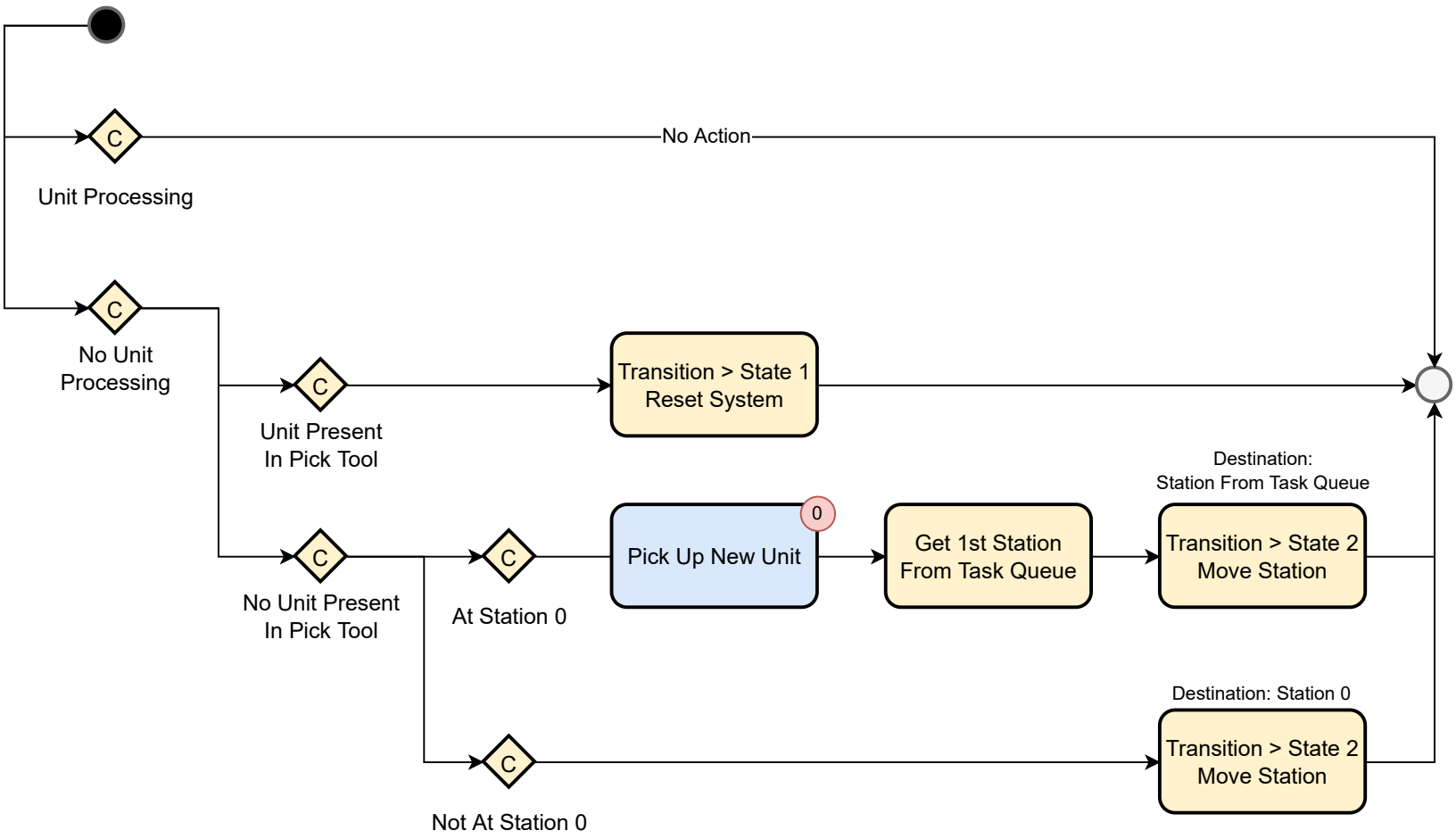
If a unit is already present, then additional checks are required before processing - This is done in the **Reset** state

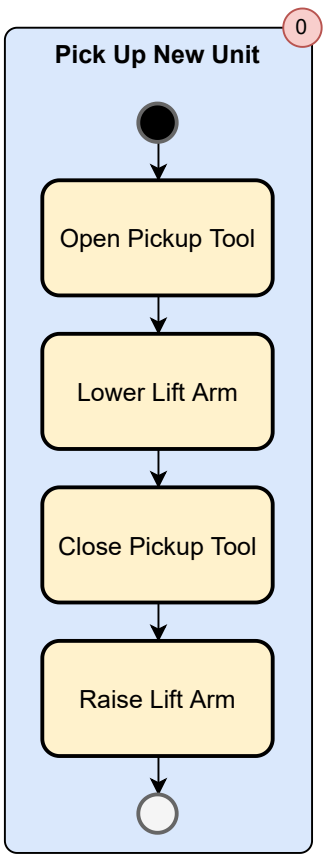
State 0
System Start

Transitions

In
-

Out
Reset System
Move Station



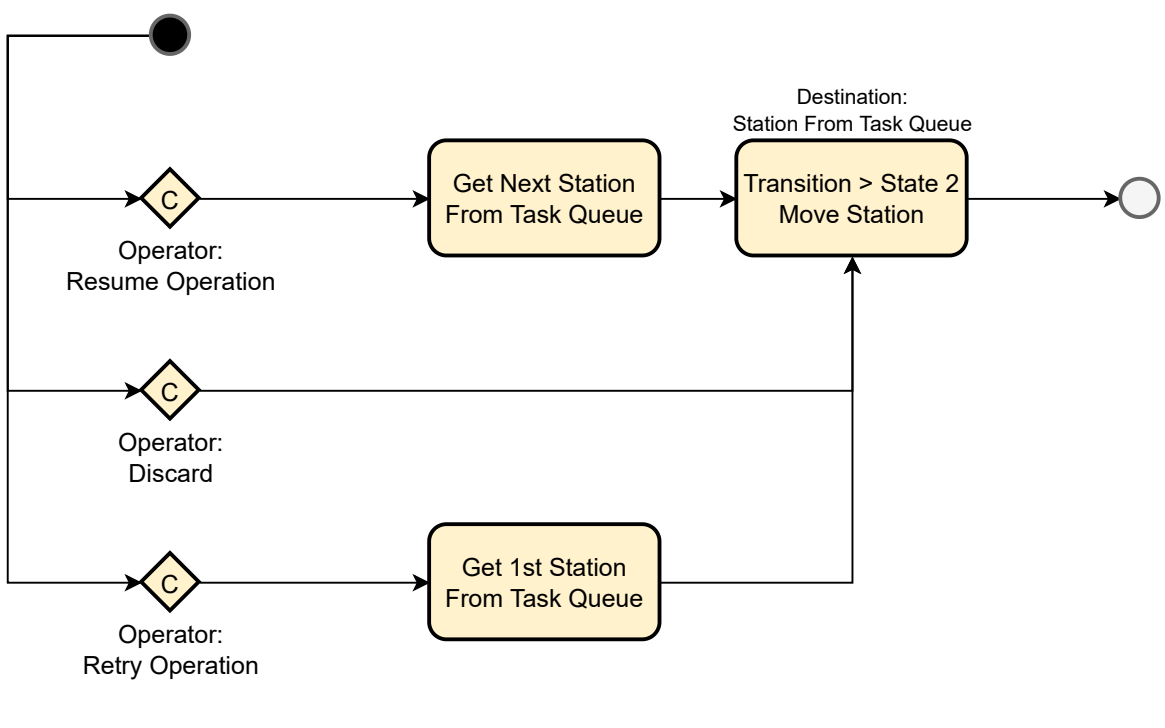


State 1
Reset System

Transitions

In
System Start

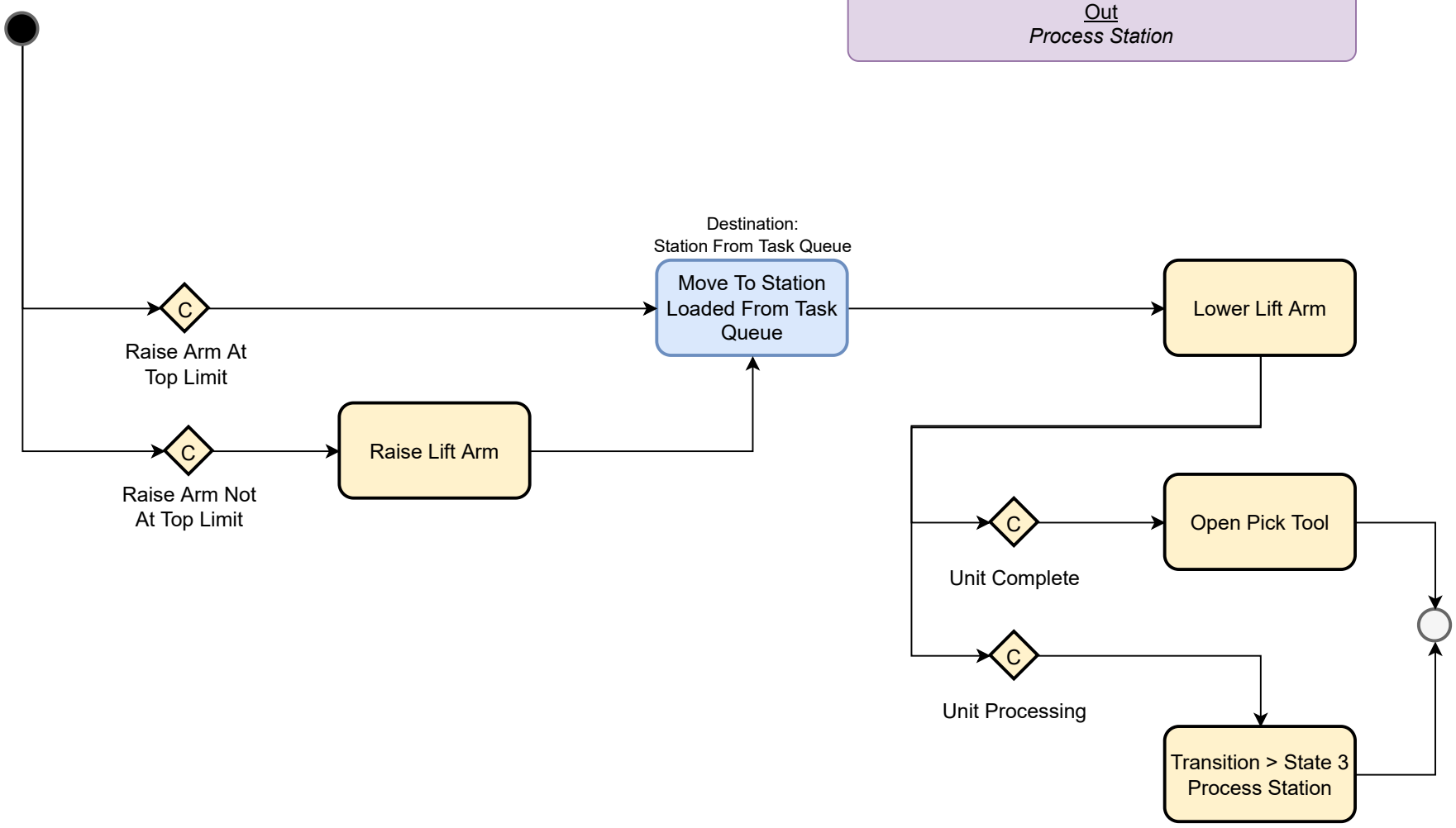
Out
Move Station

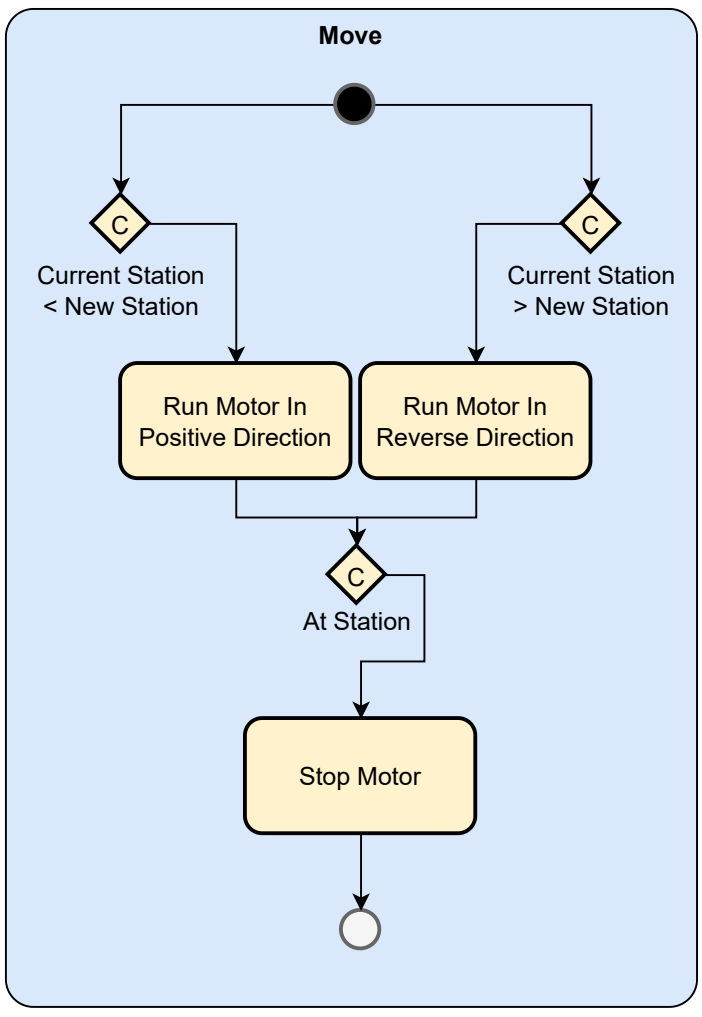


State 2
Move Station

Transitions

In
System Start
Station Complete
Reset System
Process Station Failure Reset
Unit Complete
Out
Process Station



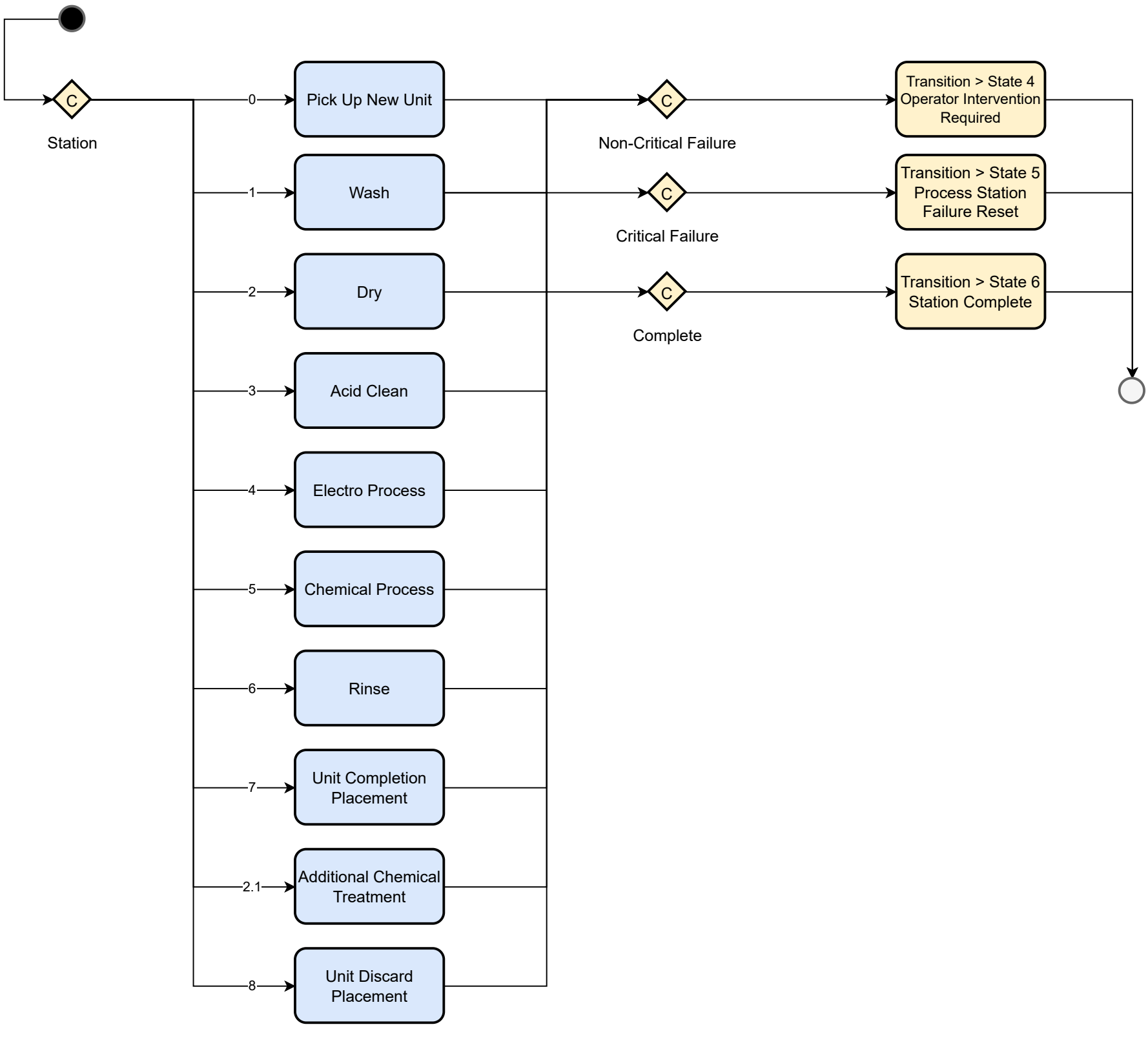


State 3
Process Station

Transitions

In
Move Station

Out
Operator Intervention Required
Process Failure
Station Complete

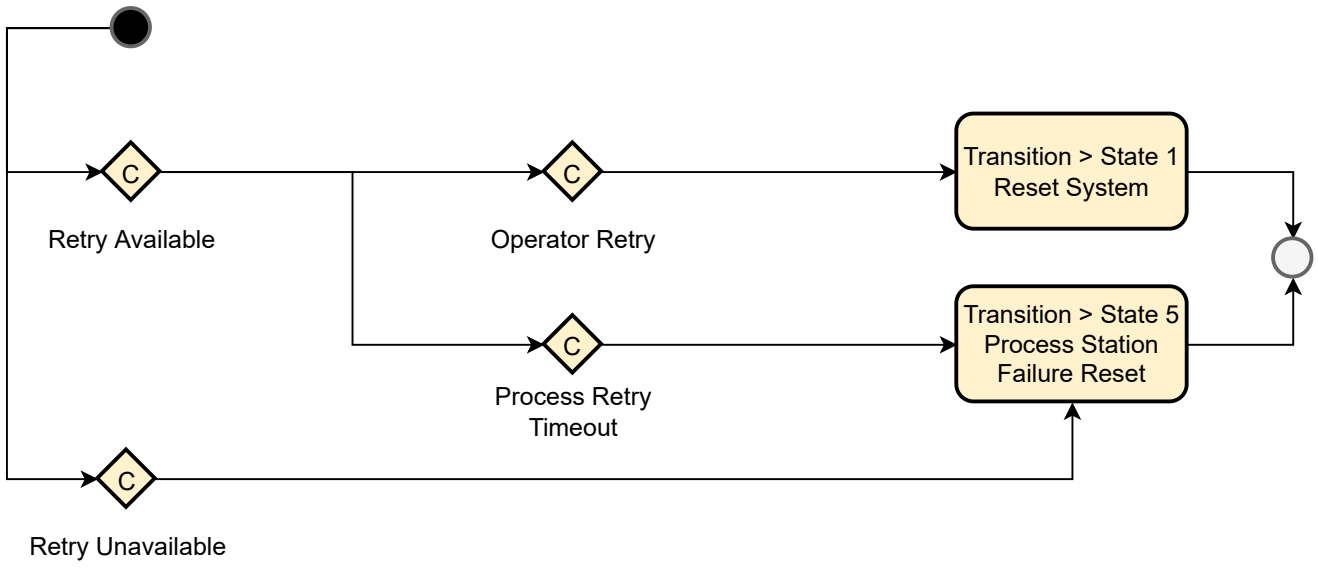


State 4
Operator
Intervention Required

Transitions

In
Process Station

Out
Reset System
Process Station Failure Reset

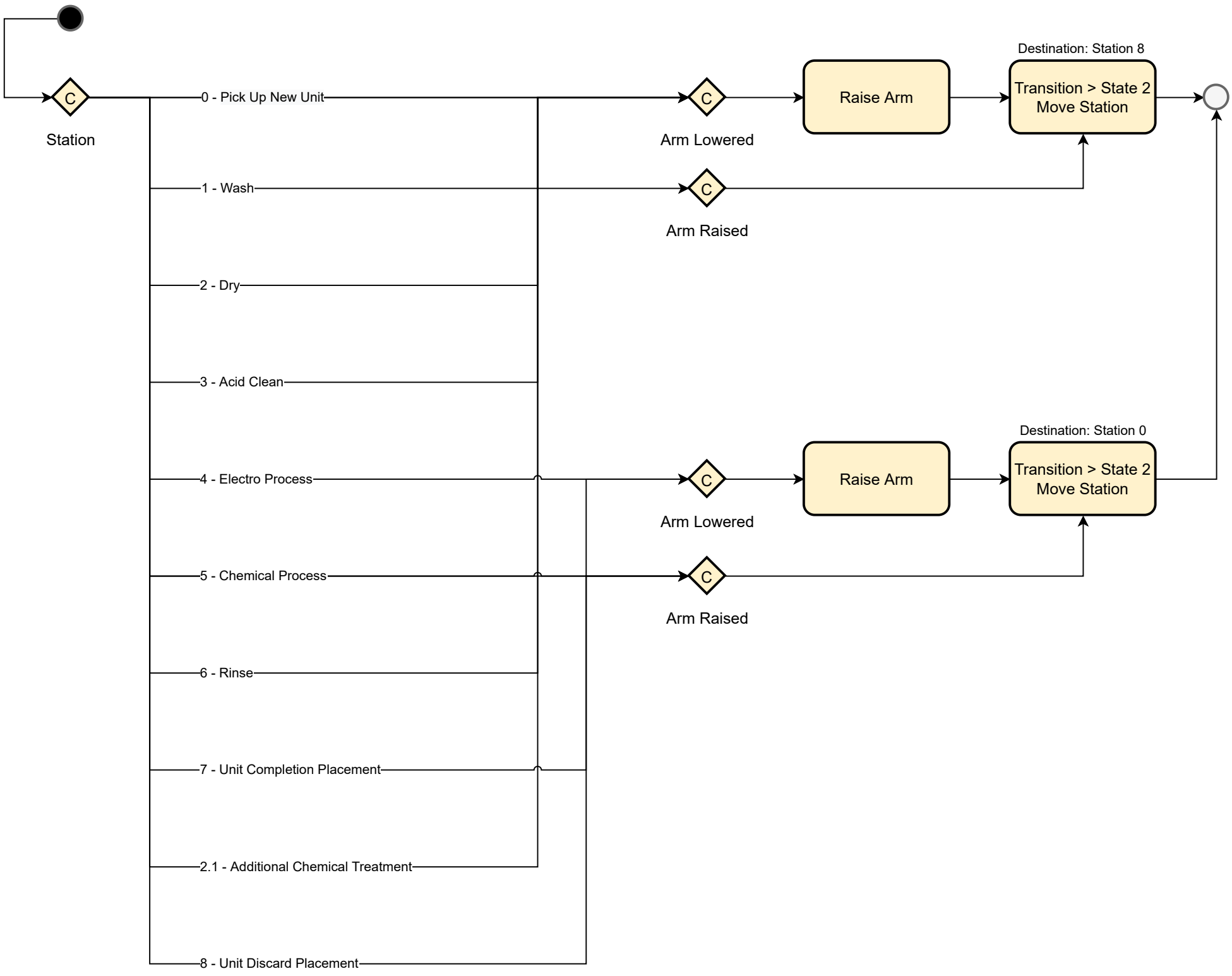


State 5
Process Station
Failure Reset

Transitions

In
Process Station

Out
Move Station

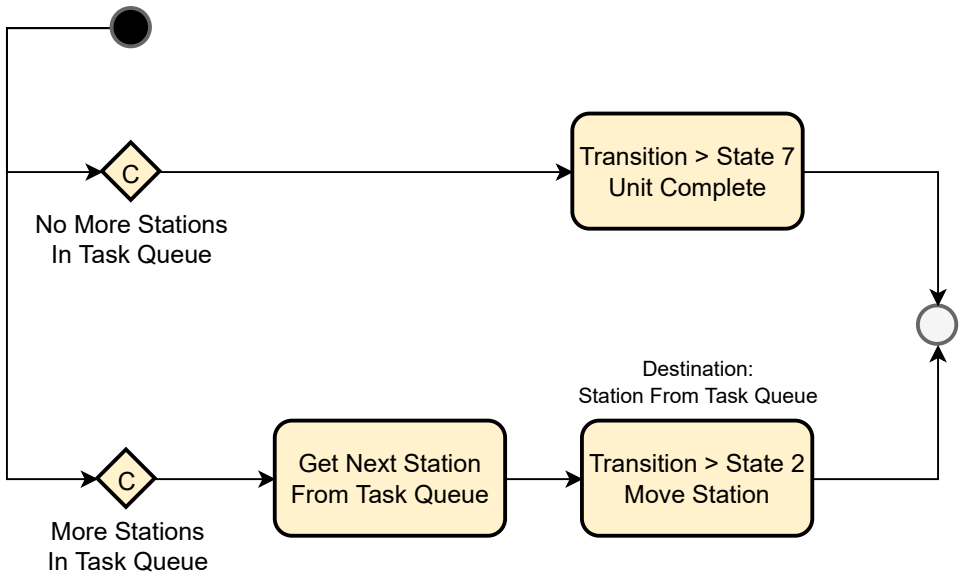


State 6
Station Complete

Transitions

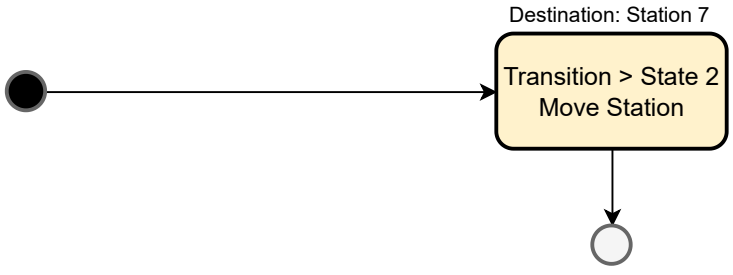
In
Process Station

Out
Move Station
Unit Complete



State 7
Unit Complete

Transitions

In
Station Complete

Out
Move Station