



Integrated Manufacturing Systems Troubleshooting

Sequence Diagram Lab – Student Instructions

Sequence Diagram Lab - Part 1

Attached is a blank sequence diagram.

Through observations of the AMTEC/SMC/FESTO/Amatrol System operations, please complete the Sequence diagram for the system on AMTEC or for an assigned station on another integrated systems...

- 1) Identify the outputs associated with each step - this includes Output Actuators - solenoids and associated - PLC I/O addresses (this identifies the I/O lights on the module) (e.g. Output light 4 or input light 2 on the module). The student will need the print package to complete.
- 2) Identify the triggers that caused the action - this is from observation and may not be 100% accurate.

Sequence Diagram Lab - Part 2

Using the PLC Logic, verify the triggers for each step in the Sequence Diagram and record your findings on the Sequence Diagram. This includes Input device (e.g. Photo Eye for puck present on Transfer station), PLC I/O addresses, and I/O lights on the module (e.g. Input light 4 or input light 0, on the module). The student will need the print package, the PLC Junction Box Addressing handout, the PLC logic, and the Tag listing.

Note the corrected Sequence Diagram will have to be handed in to validate completion





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