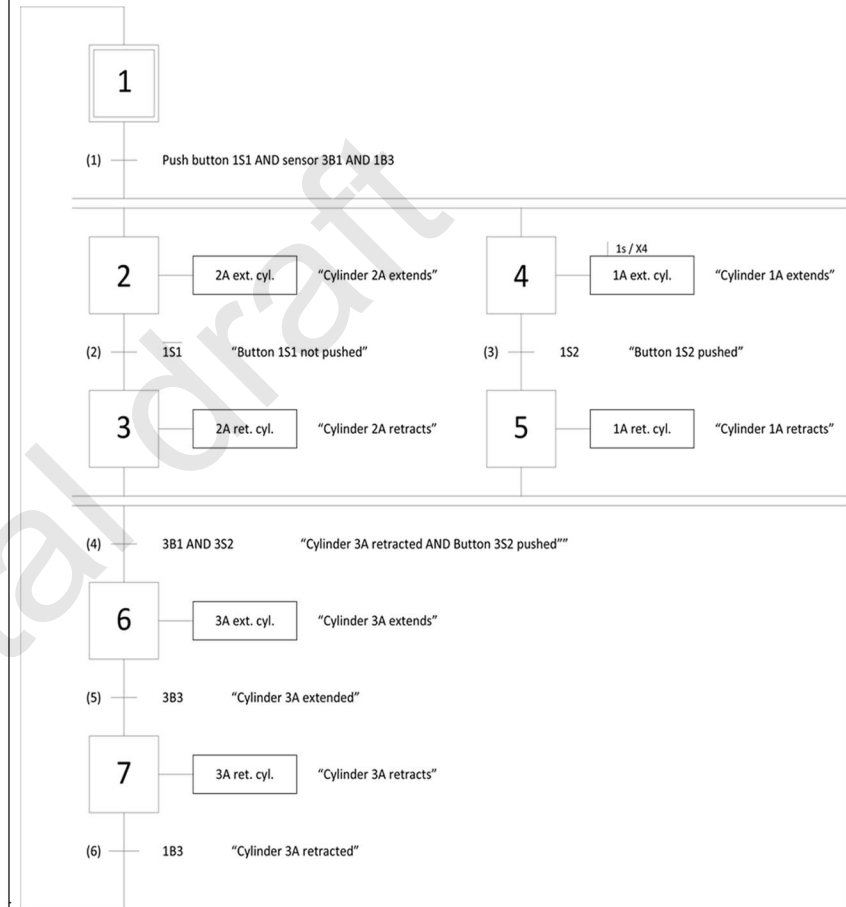


Functional plan (sequence chart) DIN EN 60848 Grafcet



Customer Description, Requirements:

The drilling device is used to manufacture a work piece according to customer requirements. The lever is actuated by pressurizing the piston rod of the single-acting cylinder 2A. A workpiece is released from the magazine and rolls into the guiding prism. Subsequently, the workpiece is clamped in the drilling device via the cylinder 1A. The drilling plate is rotatable and must be secured in its position through the clamping screw using clamps. After the drilling process, the workpiece is pushed into the collecting tray via the cylinder 3A and through the slide as well as via the ejector from the guide prism.