

Control Rule 1					Reference Operator	Value	
FBC	Lathe.1	Attribute	Status	=	Free	AND	Condition.1
FBC	Lathe.1	Attribute	Part_In	=	Not	AND	Condition.2
FBC	Robot.1	Attribute	Status	=	Free	AND	Condition.3
FBC	Table2P.3	Attribute	Posi	=	Part-Up	AND	Condition.4
...							
Instigate	FBC	Robot.1	Transport.Part	Table2P.3	Posi	Lathe.1	Condition.1
Instigate	FBC	Lathe.1	Prepare.to.Part	Type.A			Condition.2

Fig 1

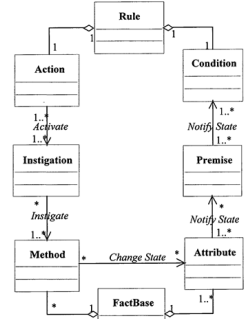


Fig 2

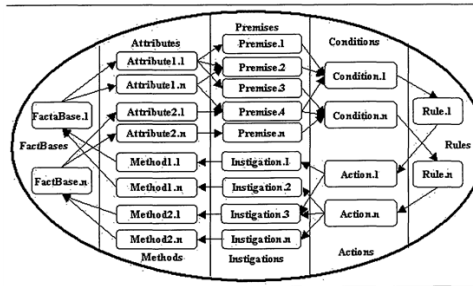


Fig 3

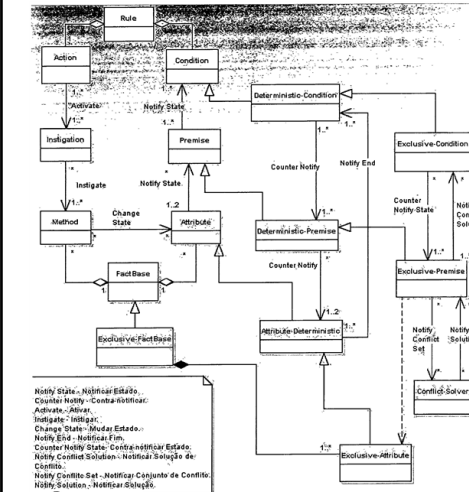


Fig 4

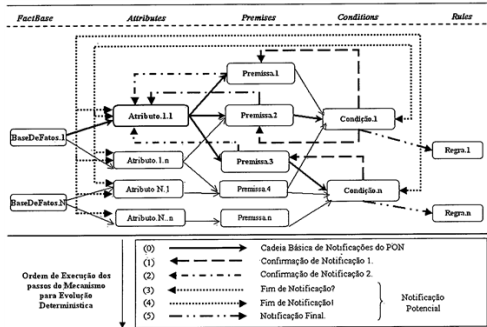


Fig 5.

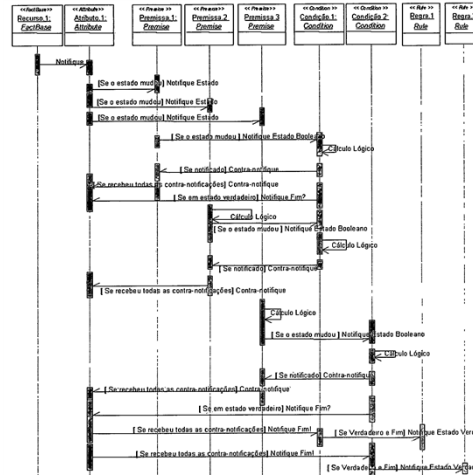


Fig. 6.

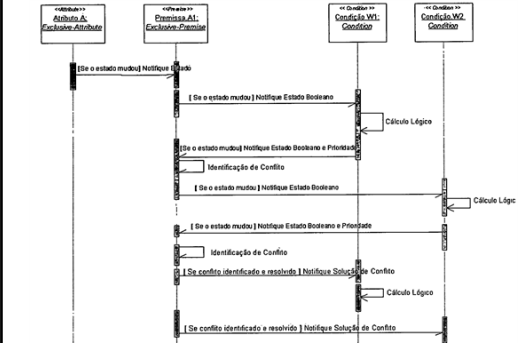


Fig. 7.