



How to solve the problem:

The SFC implements time-out control for all movements. In order to correctly continue after a time-out stop, each time-out transition leads to its own error step, except for the slow and fast movements. After a stop in a vertical movements, the movement continues in slow mode, after the error is reset.

The interaction with another control module or with the user interface is done with the 'send'-Transition at the top. 'send' is set with the 'send' control on the simulation user interface. At the bottom of the elevator, the 'belt-ok'-Transition start the belt to move the carrier out.

In order to simulate the complete SFC, press 'new' on the simulation control panel to create a carrier. Afterwards press the 'send'-button to indicate that a carrier is ready. If the elevator is at the bottom press the 'send2'-button to tell the SFC, that it can send the carrier.