COBOT Gantry Communications Timing

Cobot loads and secures part in fixture

COBOT finishes loading and securing part on GANTRY

Sets OUTPUT LOW

COBOT waits for Gantry to finish processing part – waits for Gantry OUTPUT to go LOW

COBOT sees Gantry OUTPUT go LOW signaling part is finished

COBOT sets OUTPUT HIGH to signal finished part is being unloaded and next part is being loaded

Cobot OUTPUT

Gantry OUTPUT

Gantry receives signal from COBOT.

Sets OUTPUT HIGH to indicate process is in progress

Gantry processes part

Gantry finishes processing part and sets OUTPUT LOW

Gantry waits for Cobot OUTPUT to go HIGH signaling Cobot is unloading finished part and reloading next part for processing