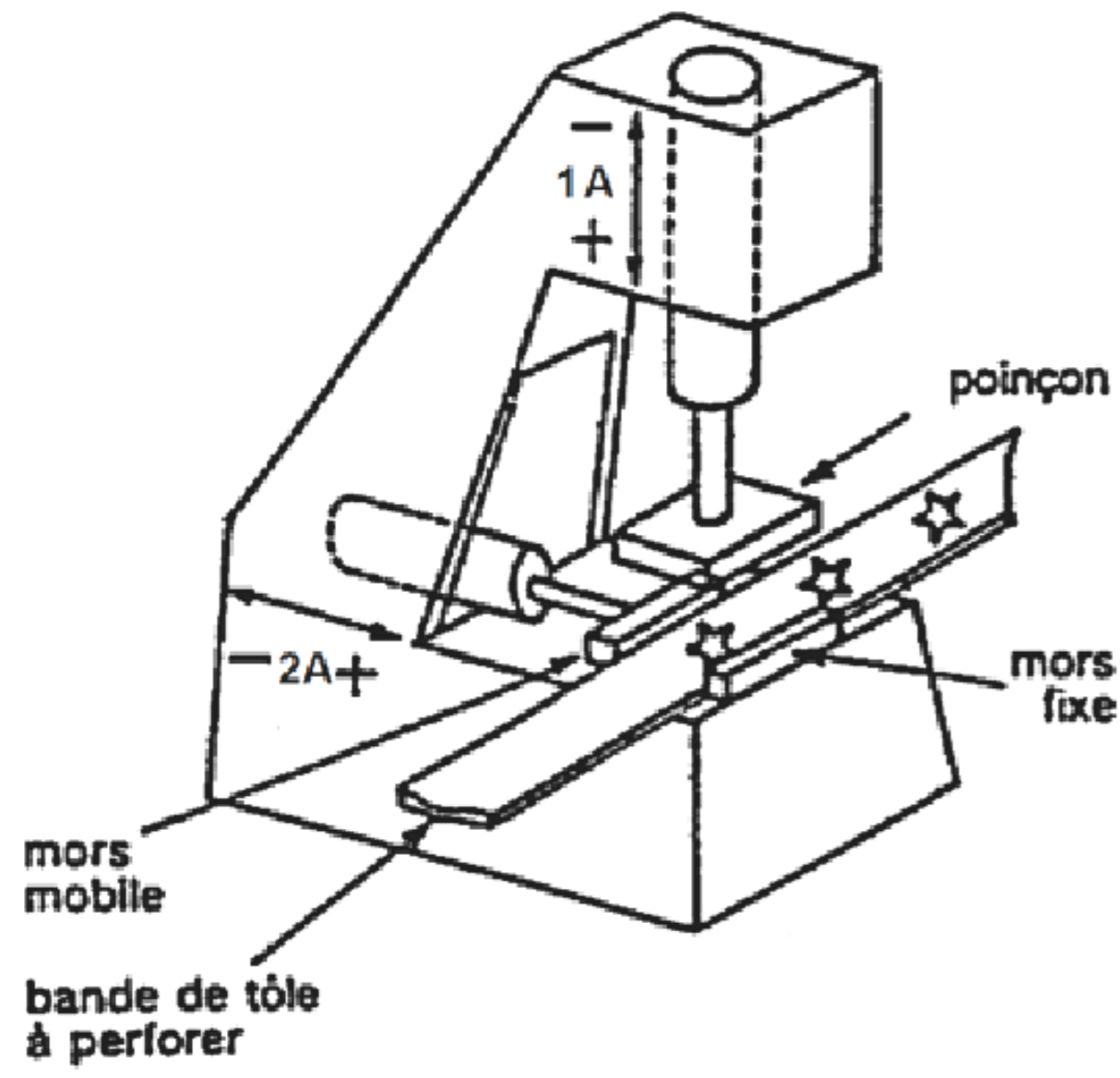
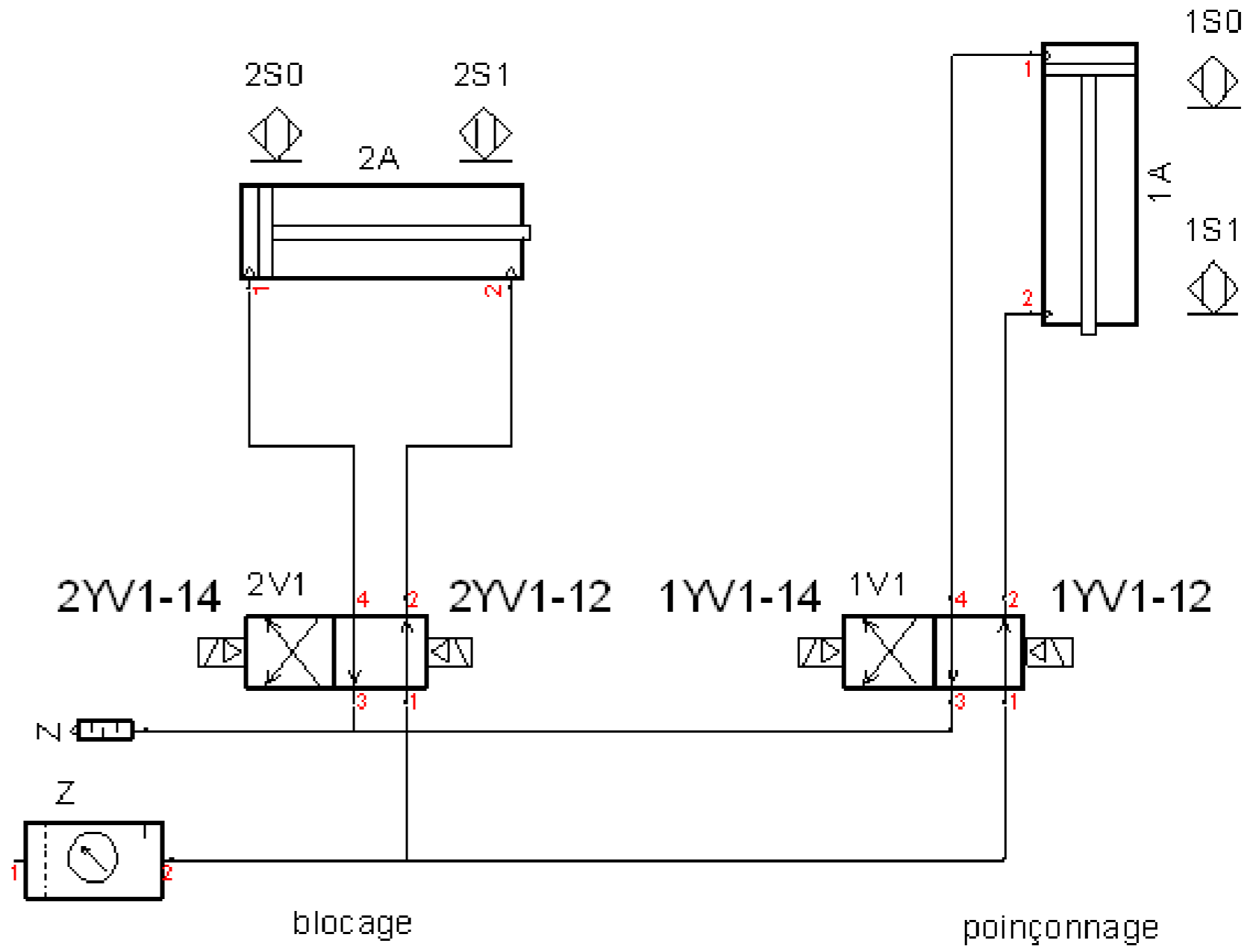


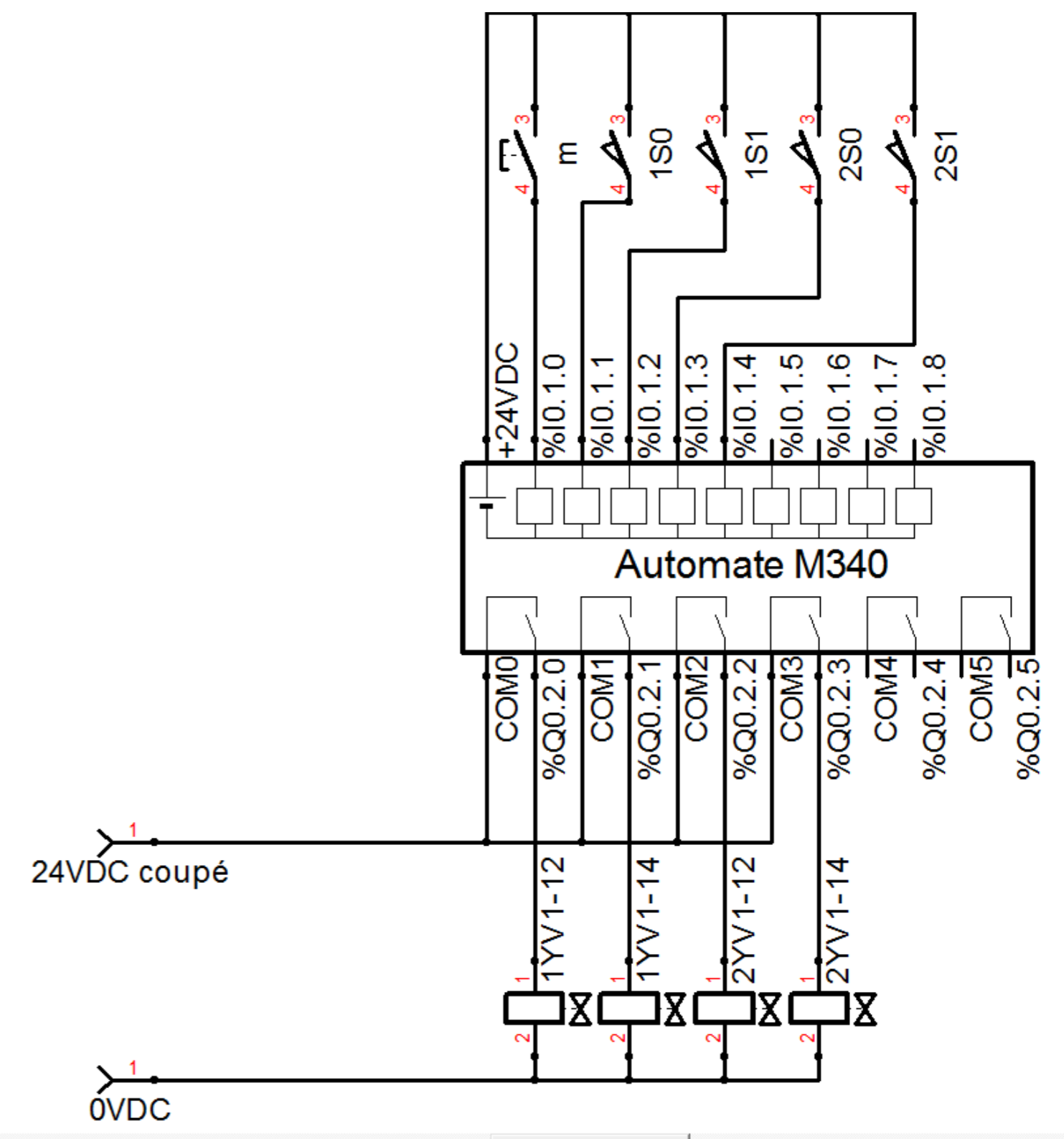
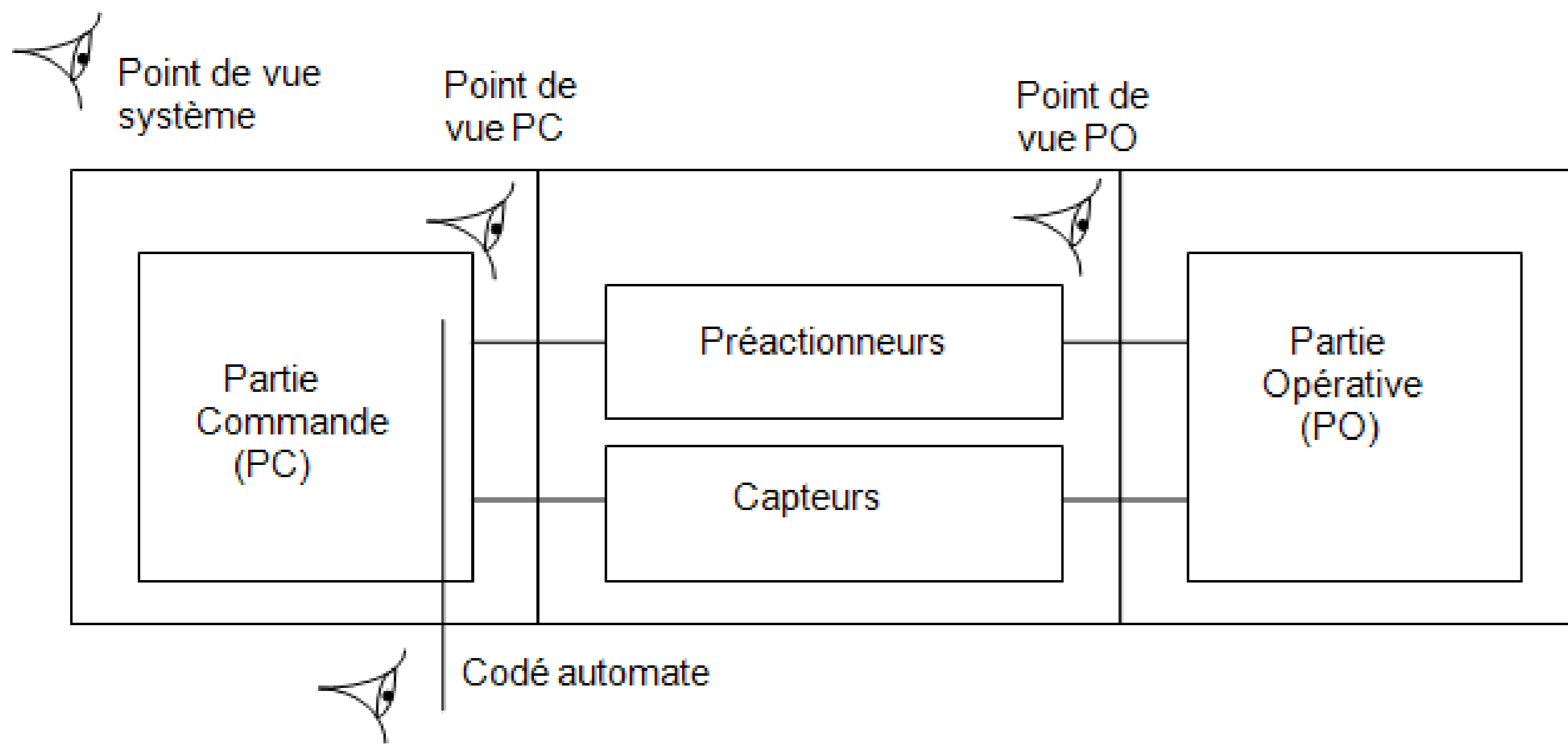
Les points de vue du grafcet



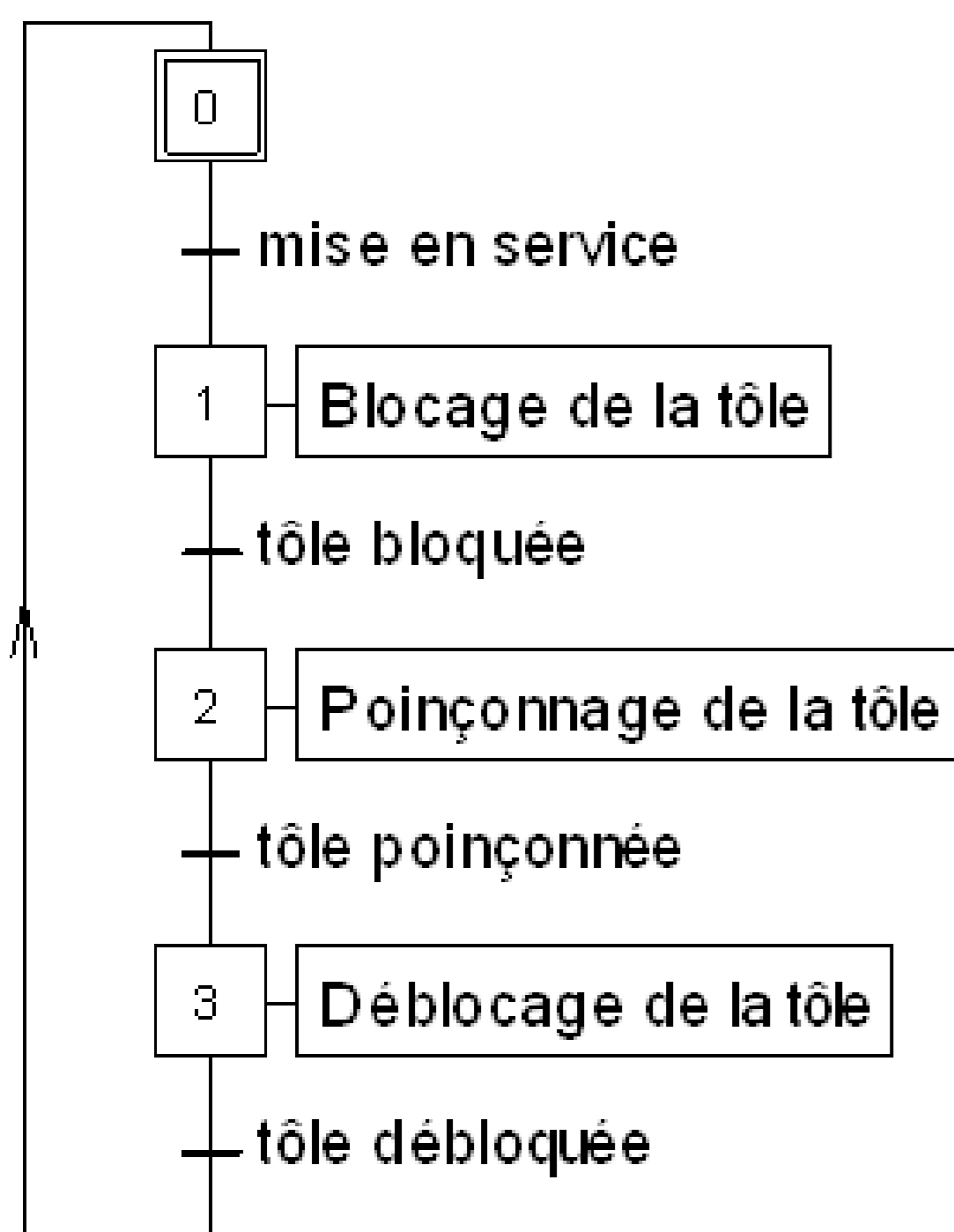
Système : poinçonneuse



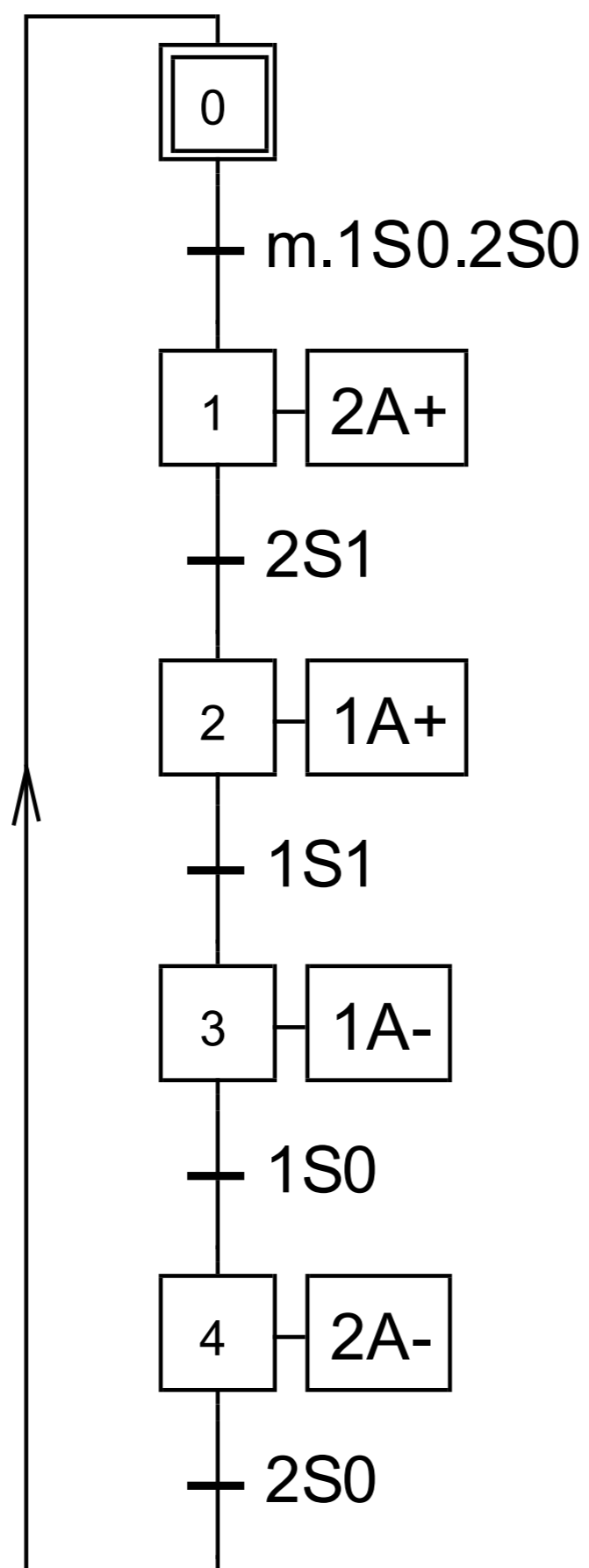
Description des préactionneurs et des capteurs



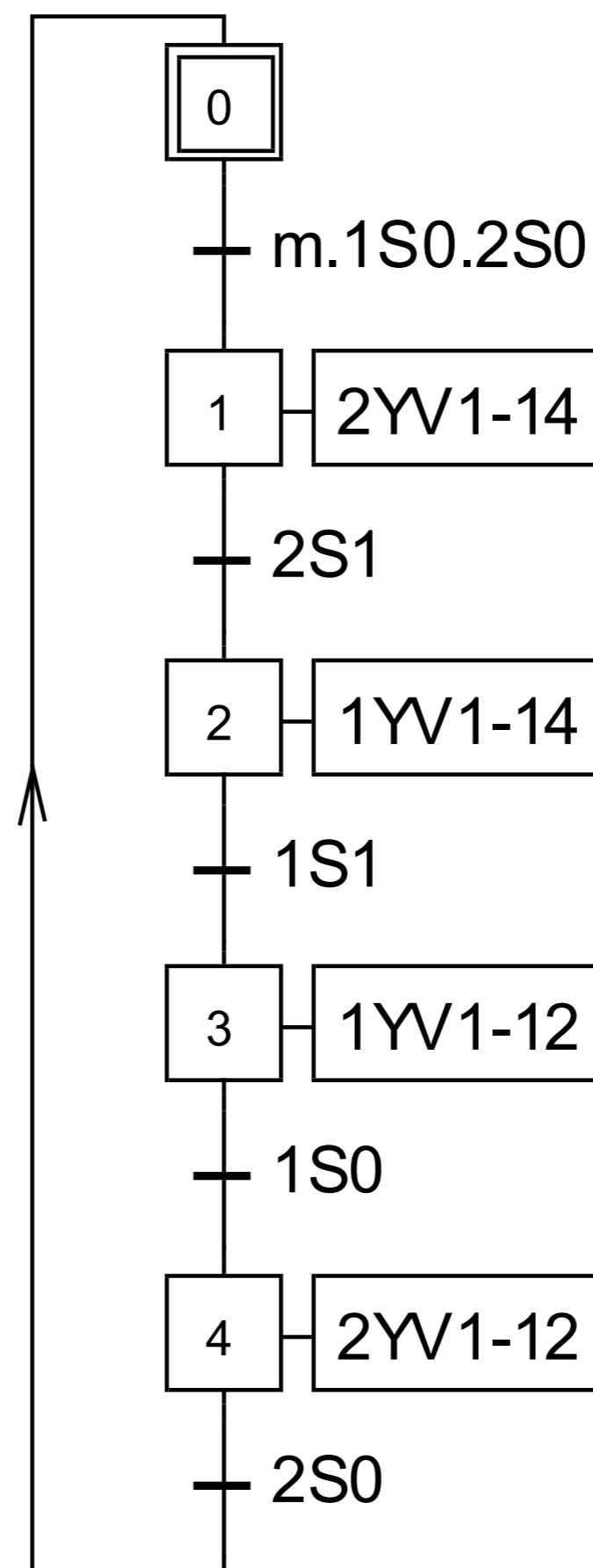
Câblage de l'automate



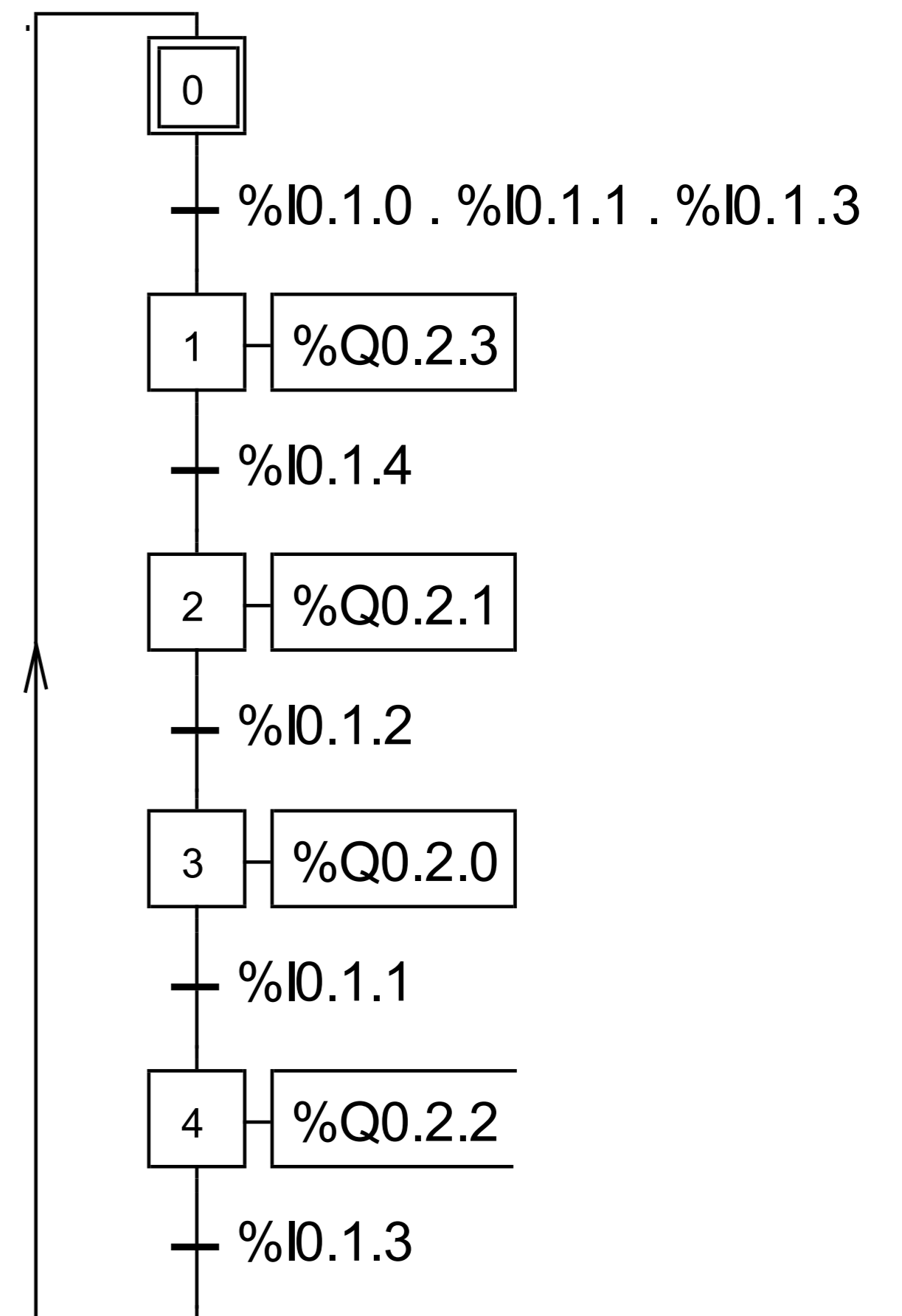
Grafcet point de vue système



Grafcet point de vue Partie Opérative (PO)



Grafcet point de vue Partie Commande (PC)



Grafcet codé automate

Equations booléennes des sorties :
 $2YV1-14 := X1$
 $1YV1-14 := X2$
 $1YV1-12 := X3$
 $2YV1-12 := X4$