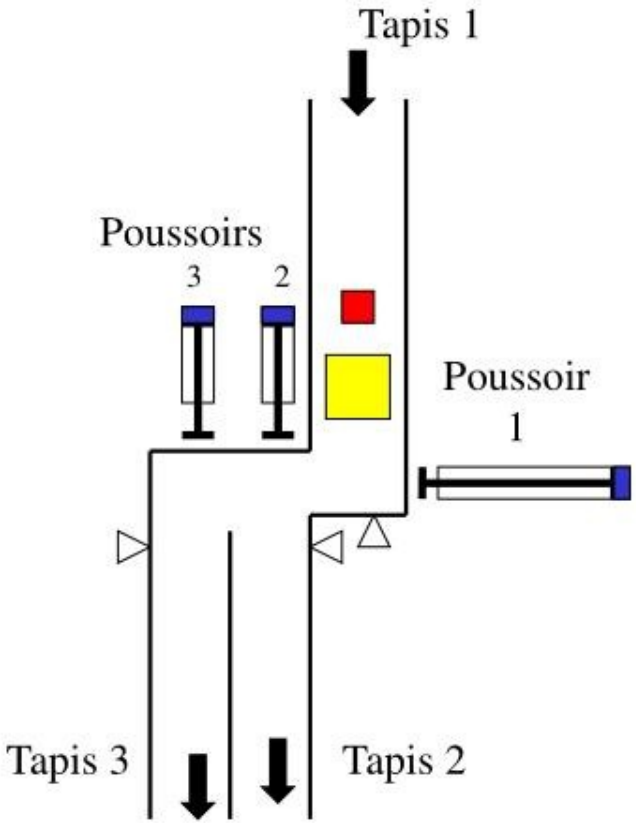
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Un dispositif automatique destiné à trier des caisses de deux tailles différentes se compose d'un tapis amenant les caisses, de trois poussoirs et de deux tapis d'évacuation suivant la figure ci-contre

Cycle de fonctionnement :

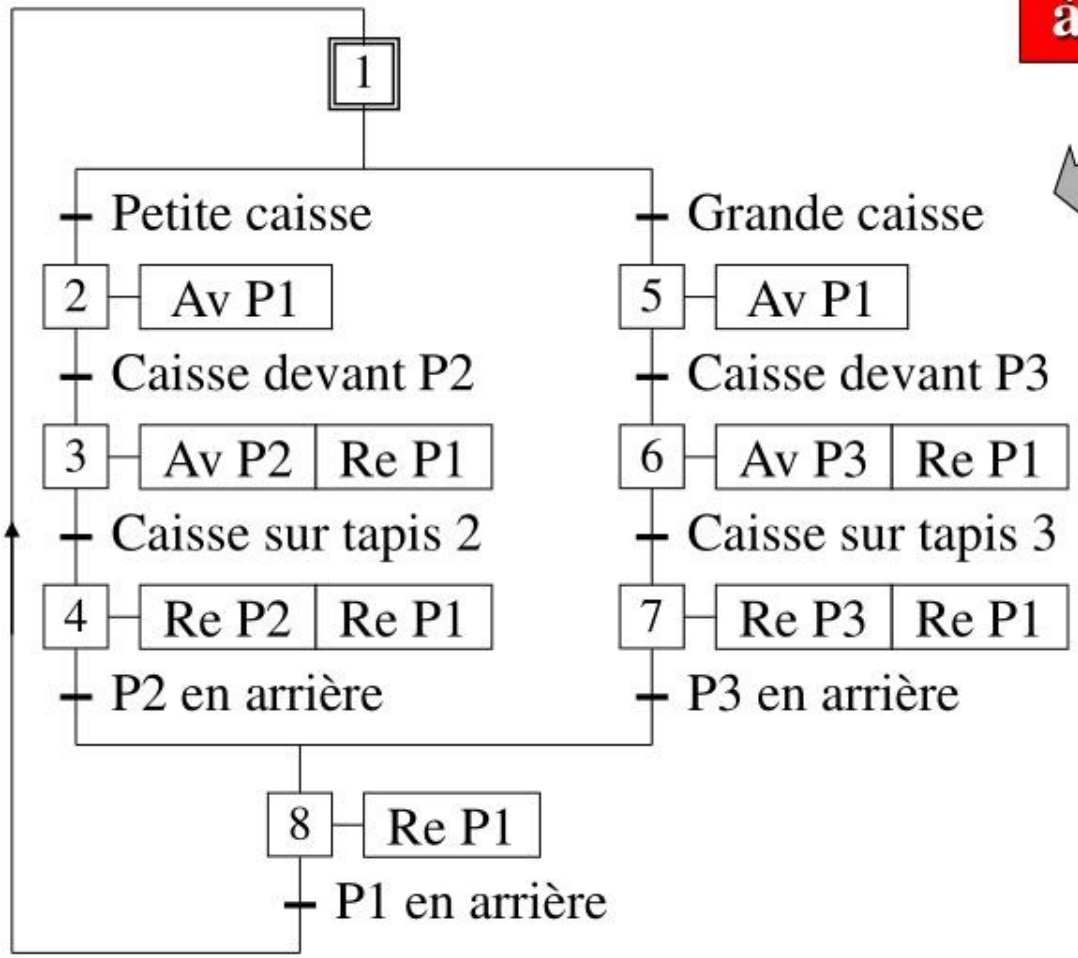
Le poussoir 1 pousse les petites caisses devant le poussoir 2 qui, à son tour, les transfère sur le tapis d'évacuation 2, alors que les grandes caisses sont poussées devant le poussoir 3, ce dernier les évacuant sur le tapis 3.

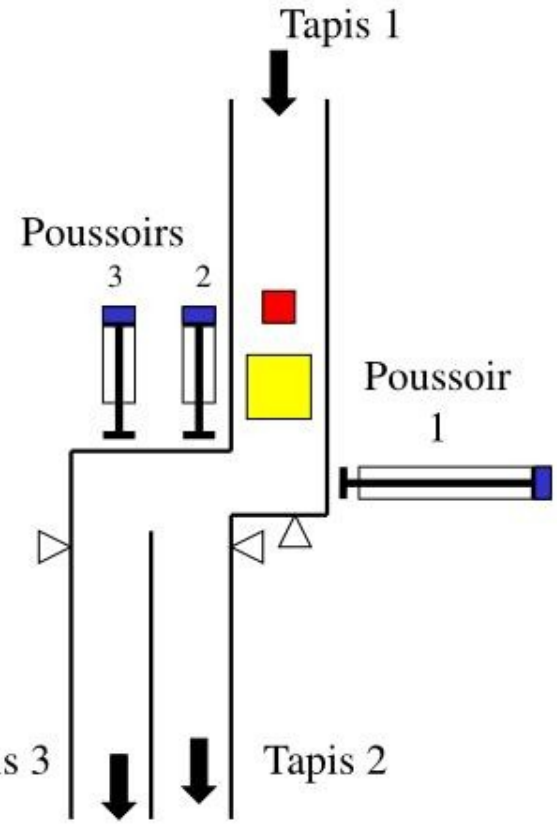
Pour effectuer la sélection des caisses, un dispositif de détection placé devant le poussoir 1 permet de reconnaître sans ambiguïté le type de caisse qui se présente.

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Une solution possible pour le Grafcet



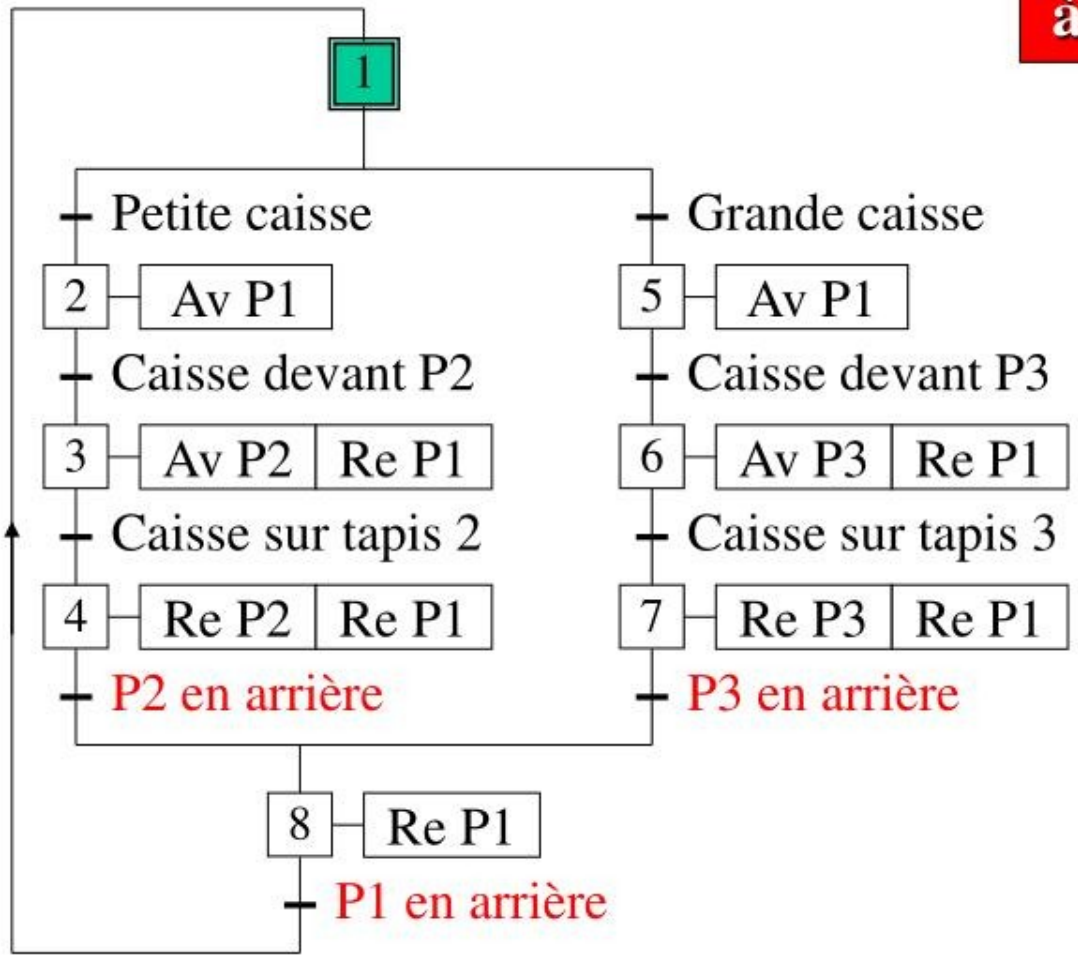


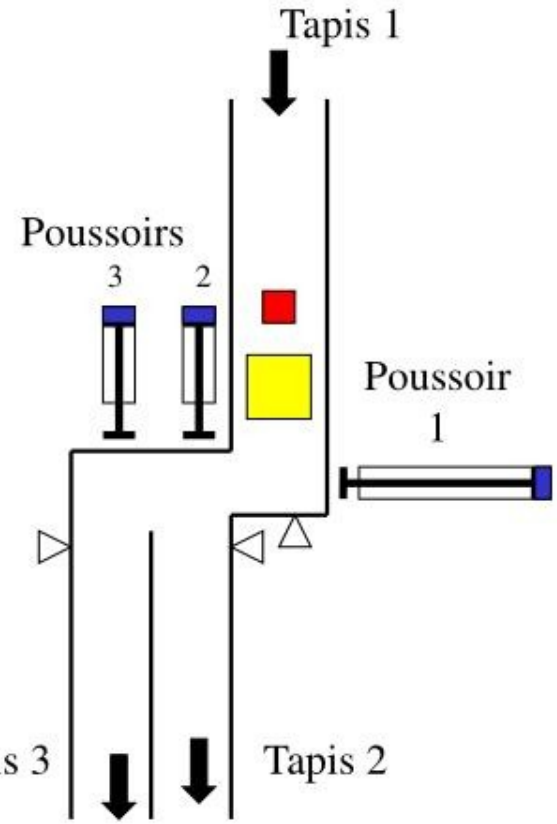
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1,2,3*

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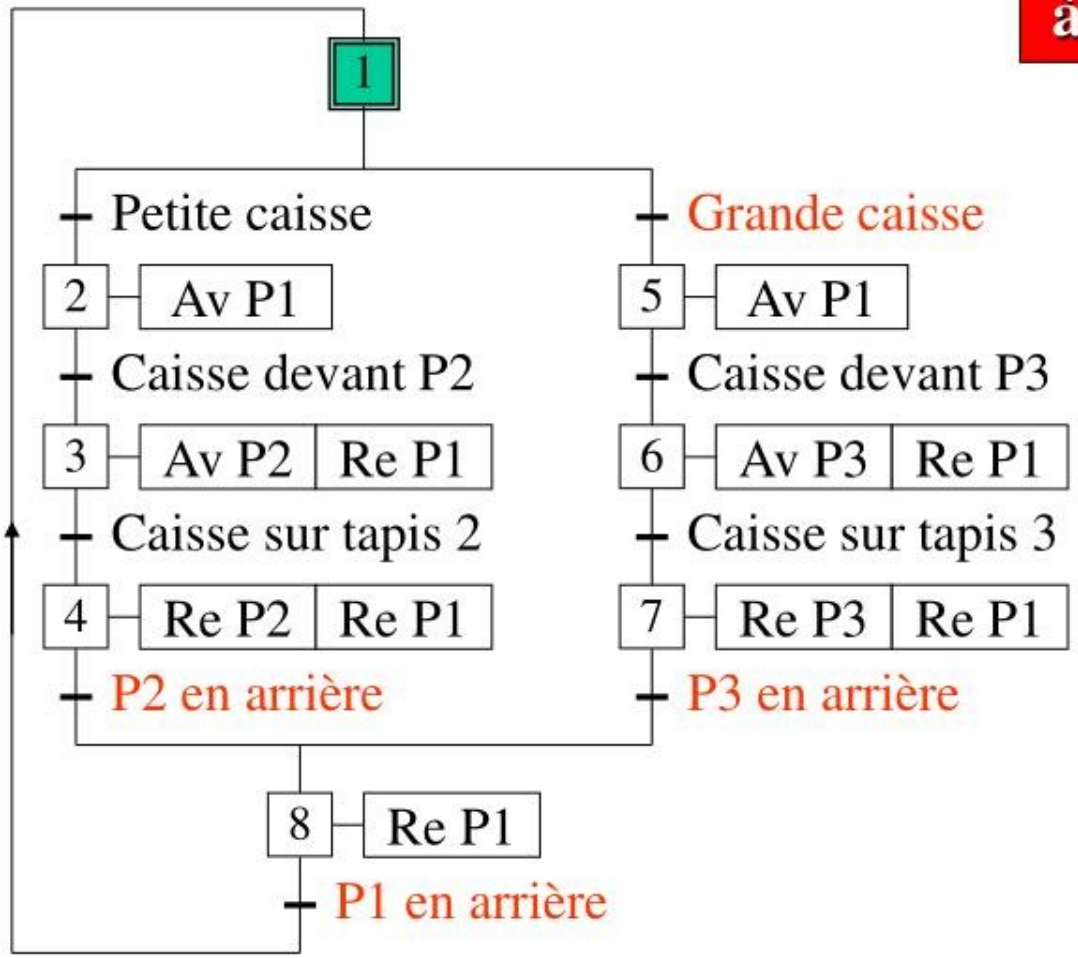


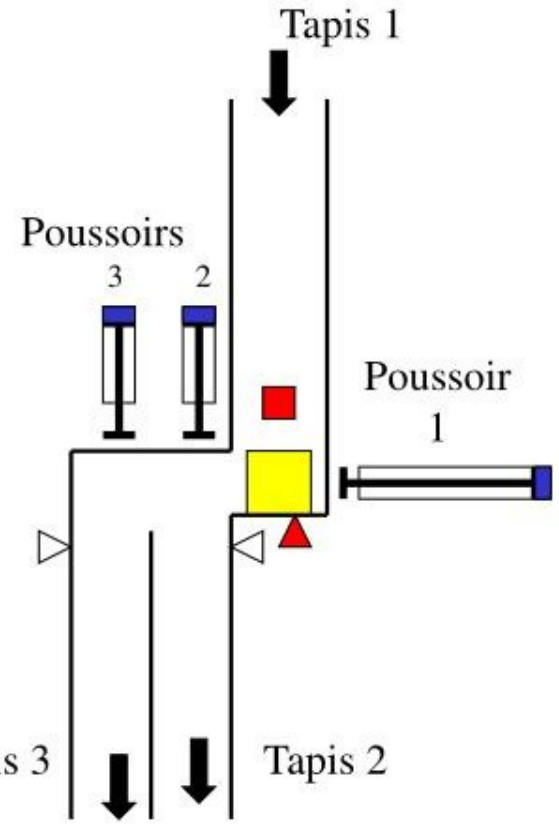
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1,2,3*

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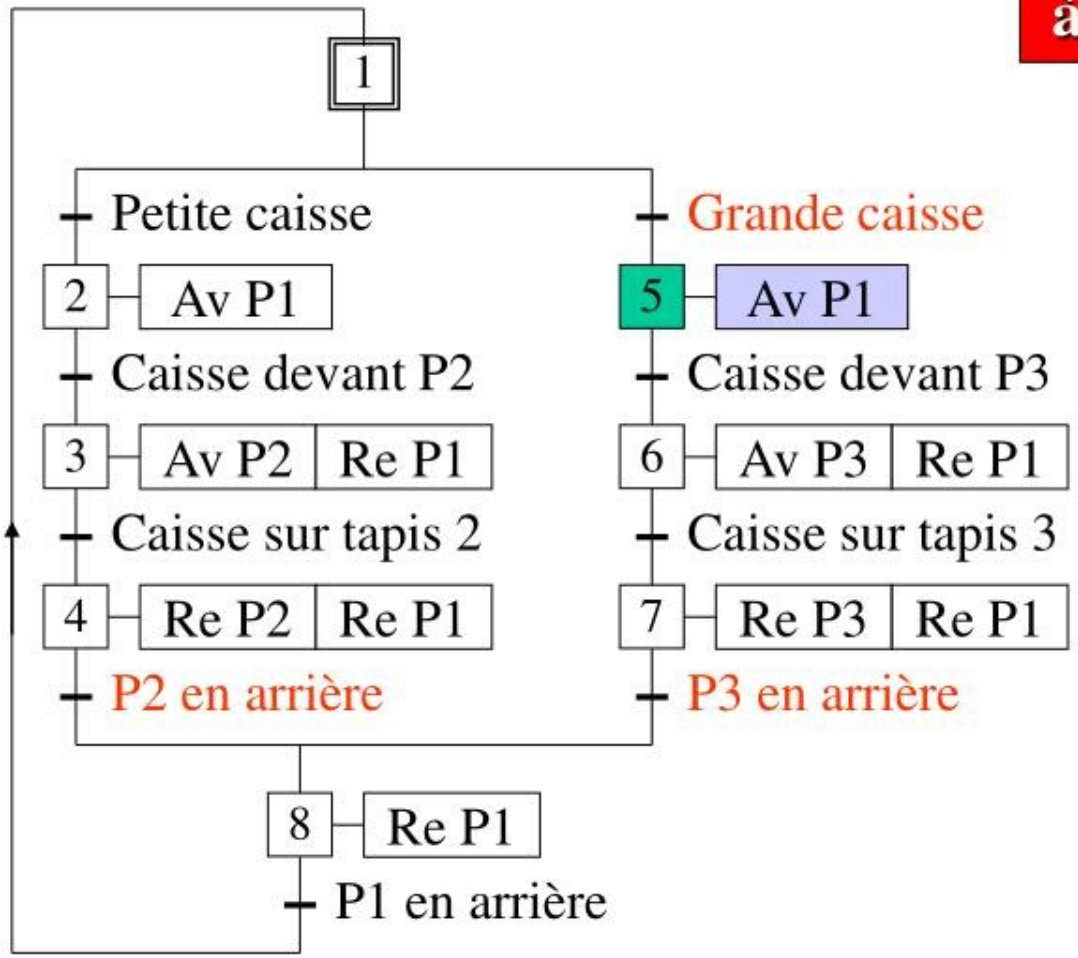


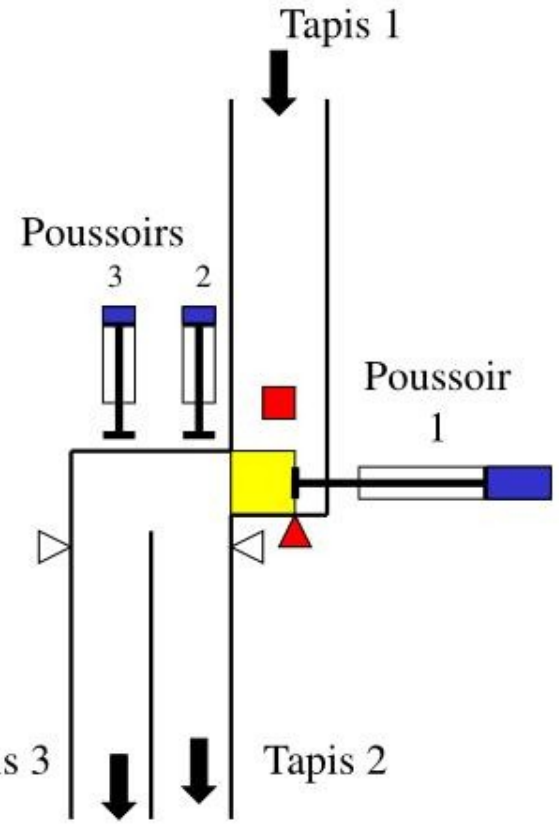
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1, 2, 3*

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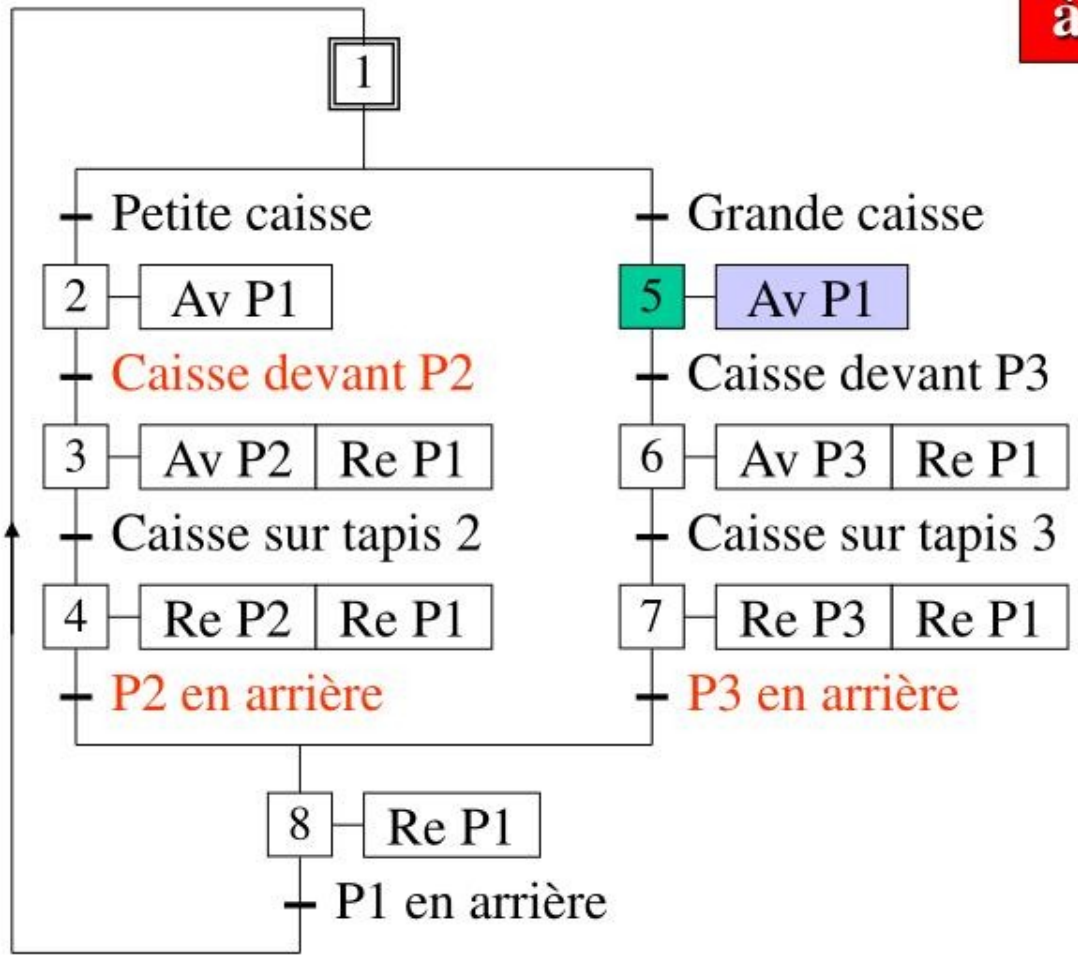


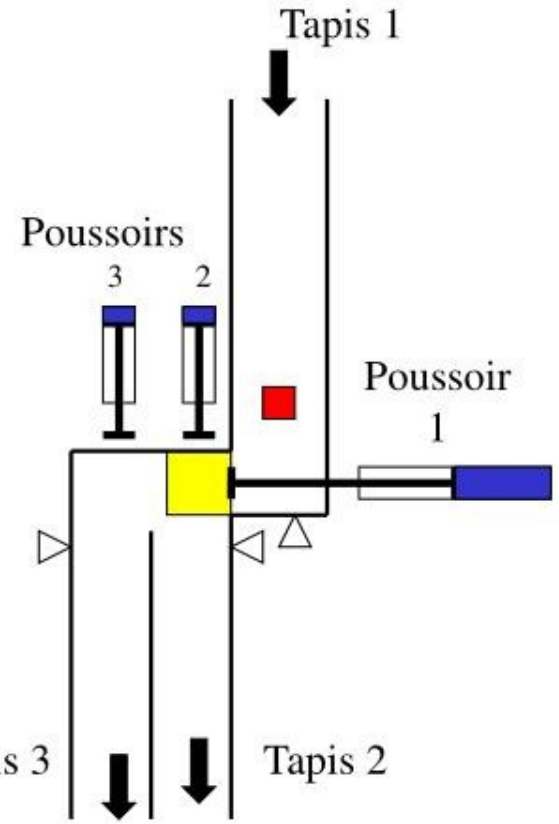
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1, 2, 3*

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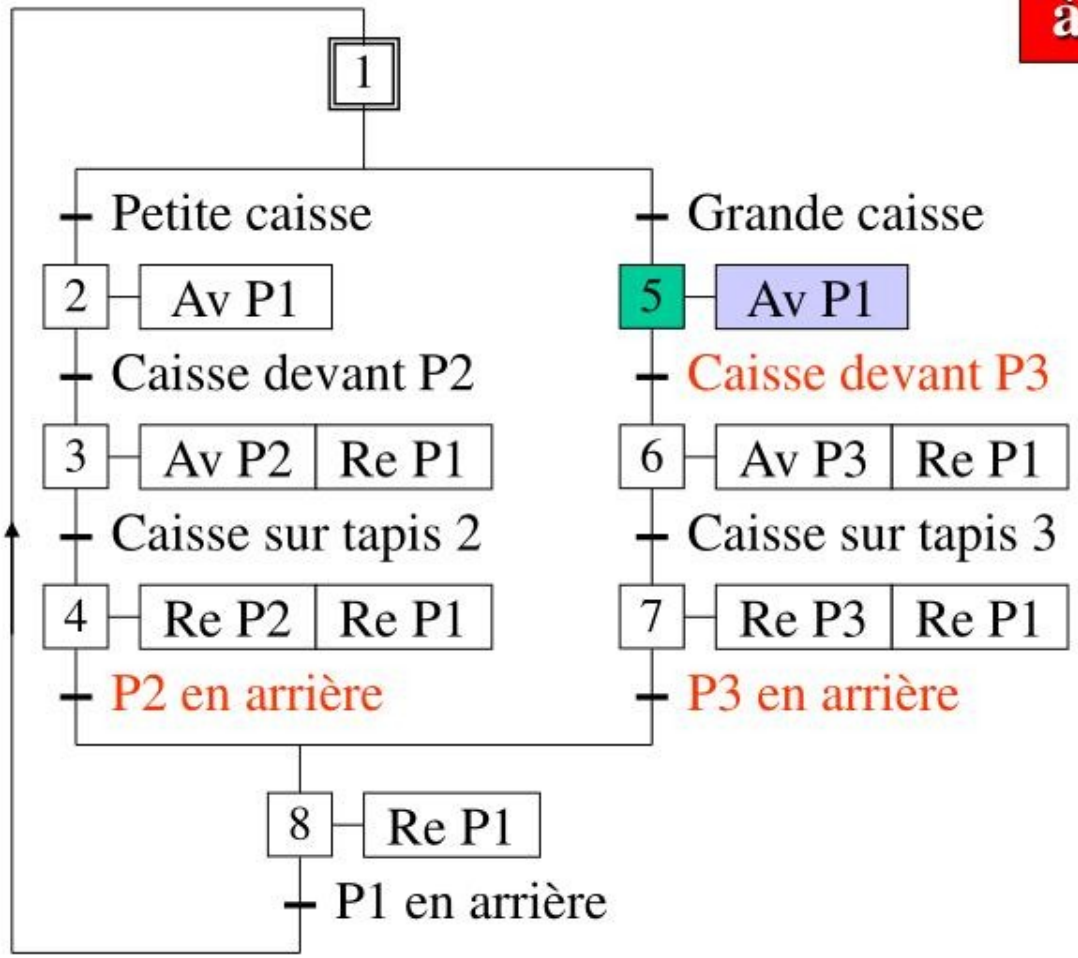


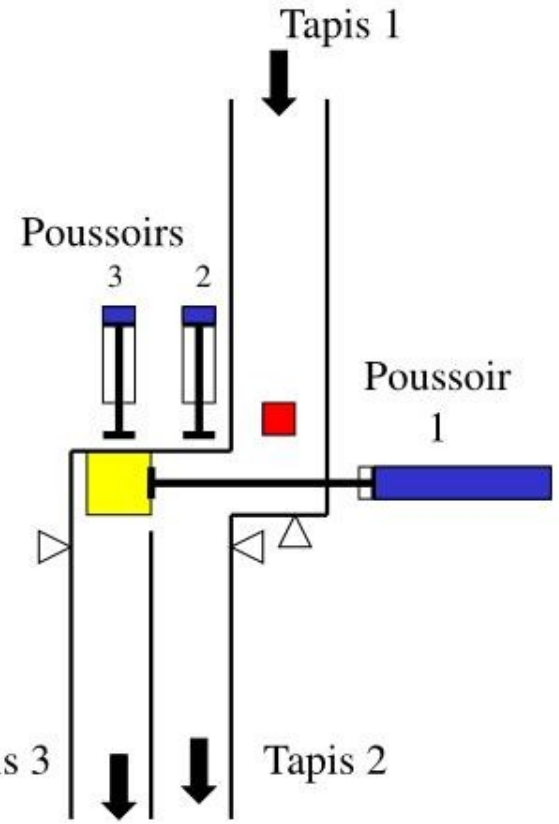
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1,2,3*

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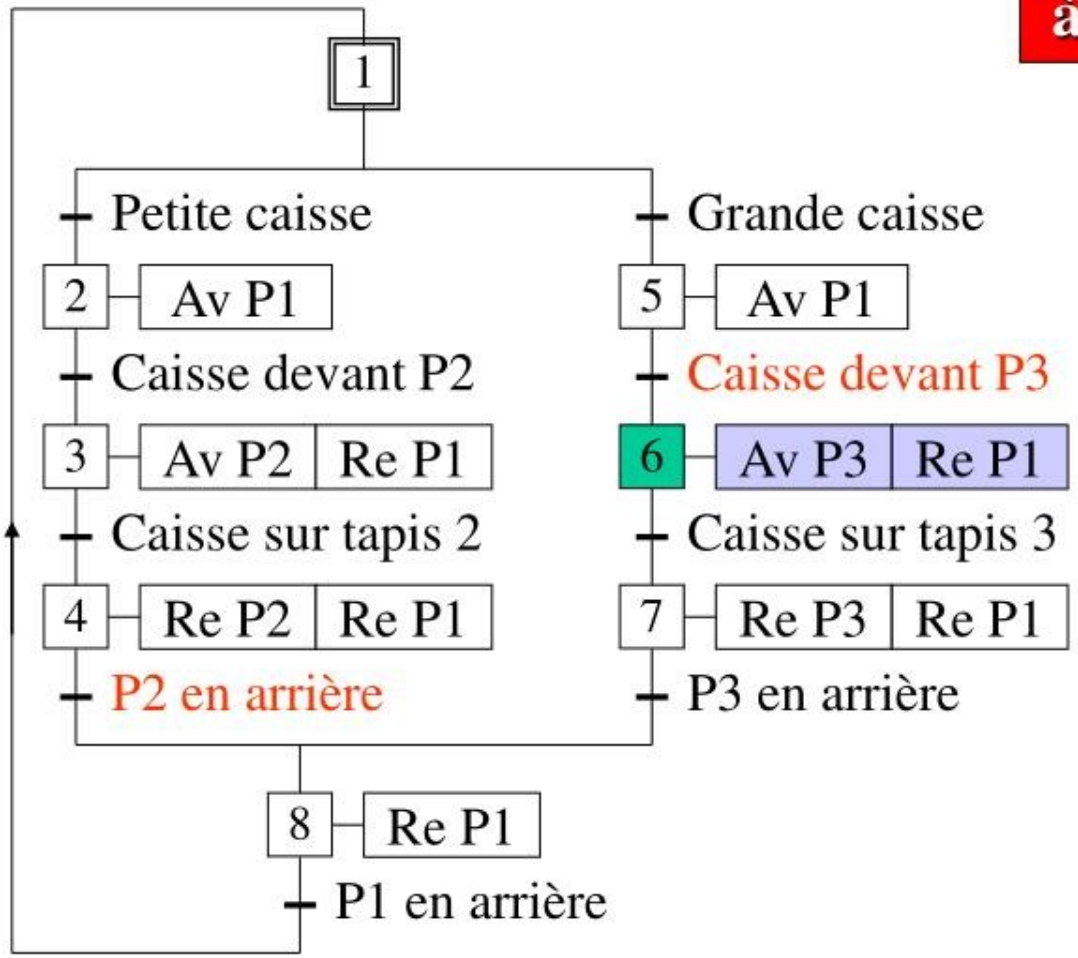


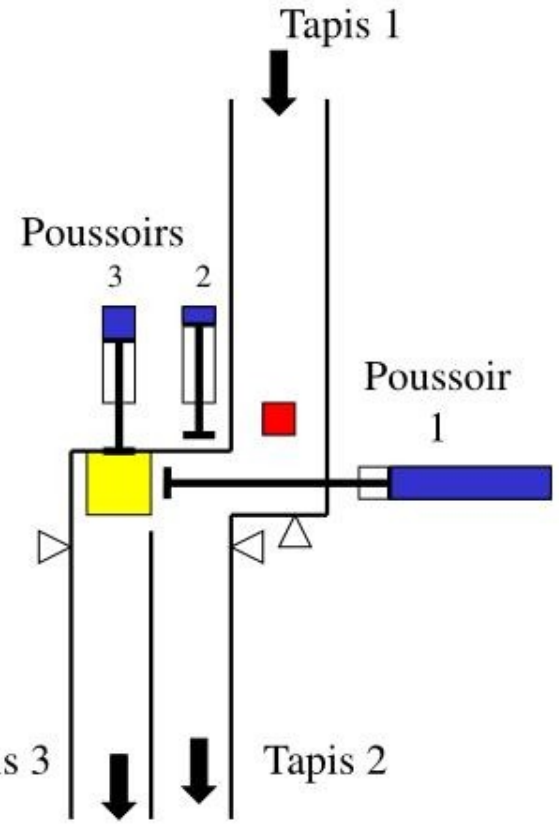
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1,2,3*

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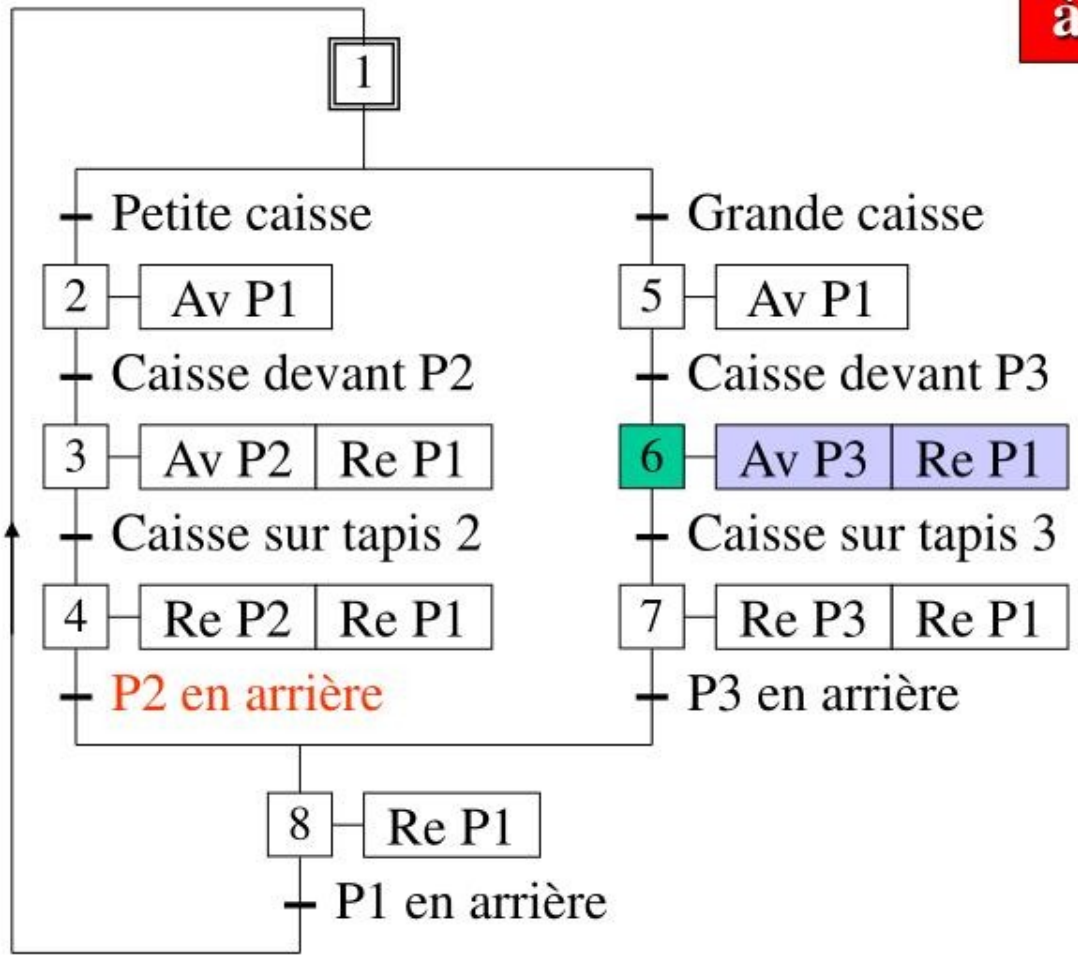


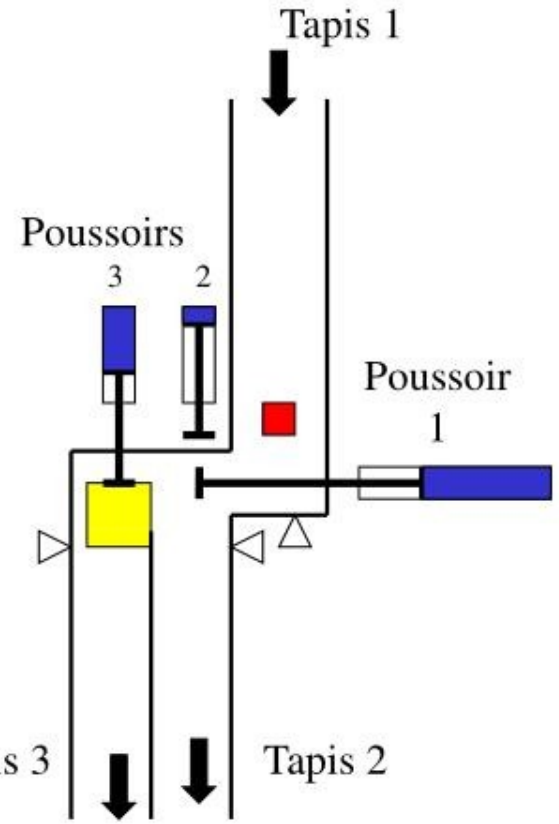
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1,2,3*

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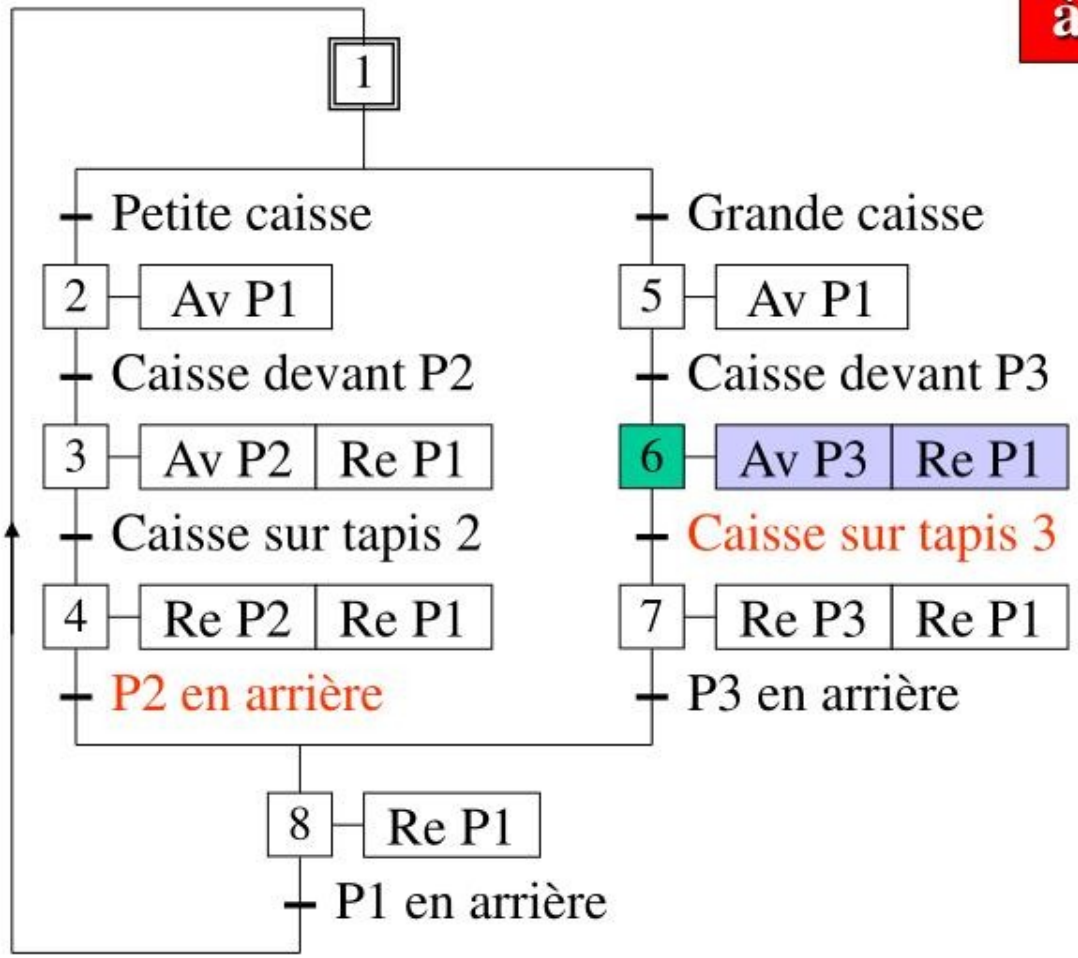


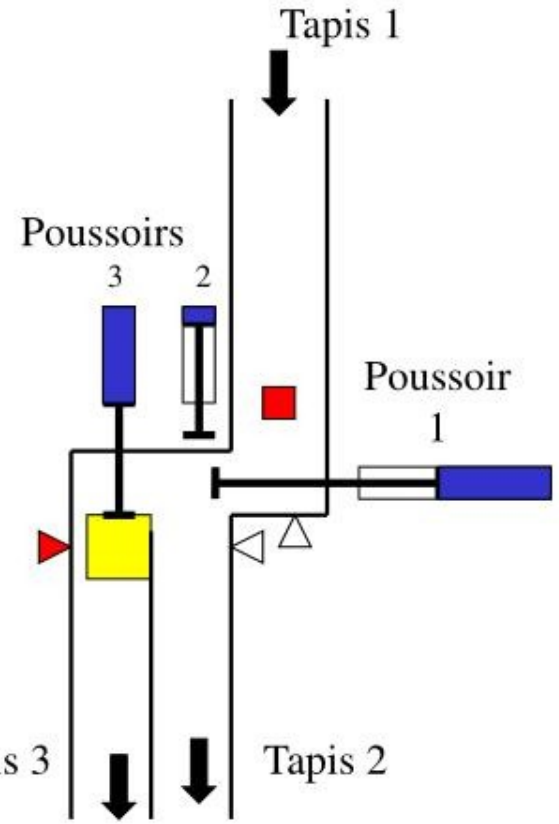
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1,2,3*

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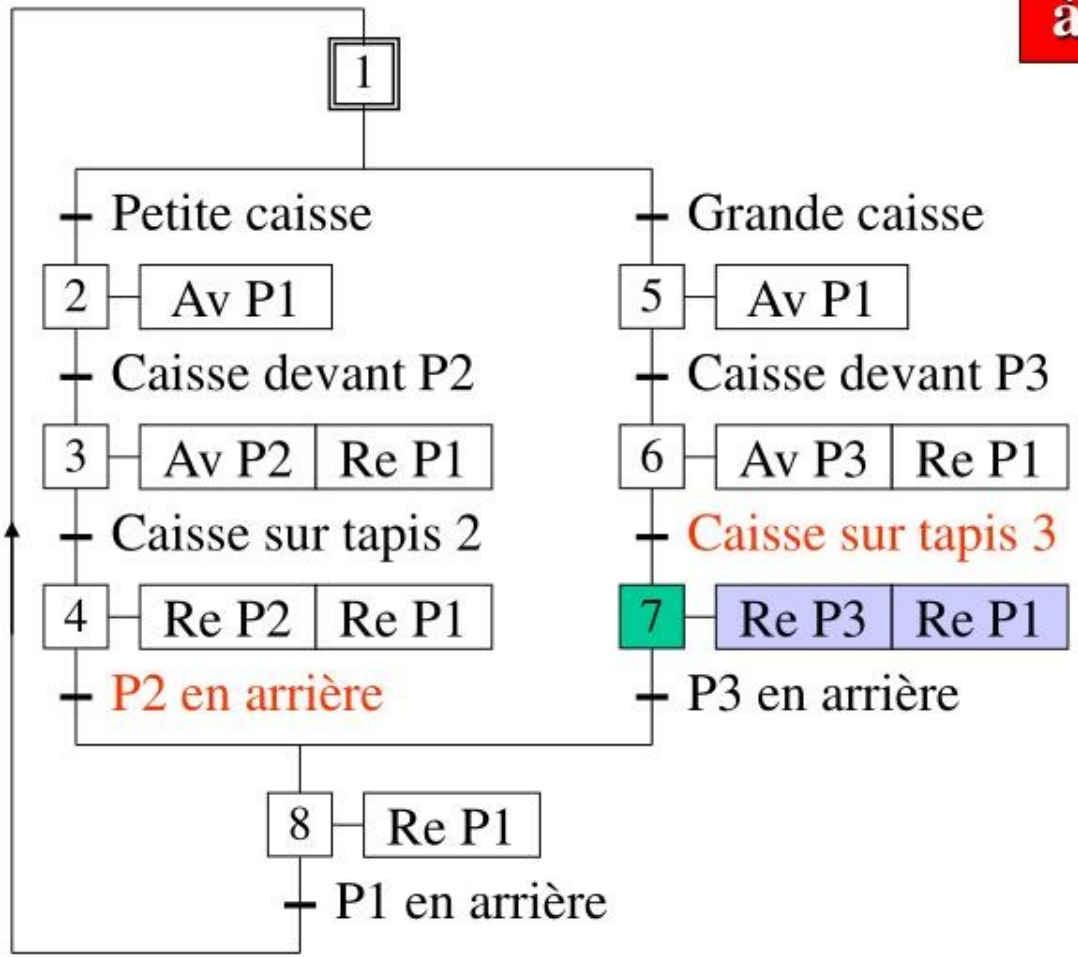


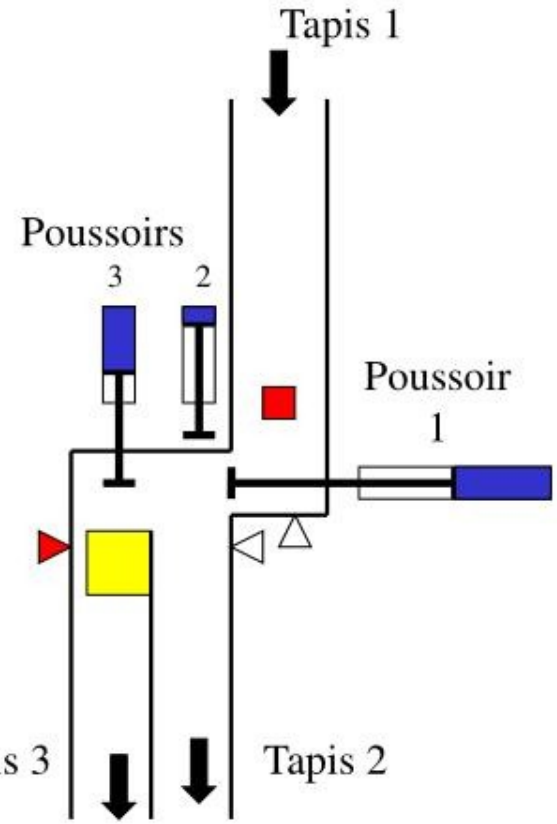
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P1, P2, P3 *: poussoirs N°1,2,3*

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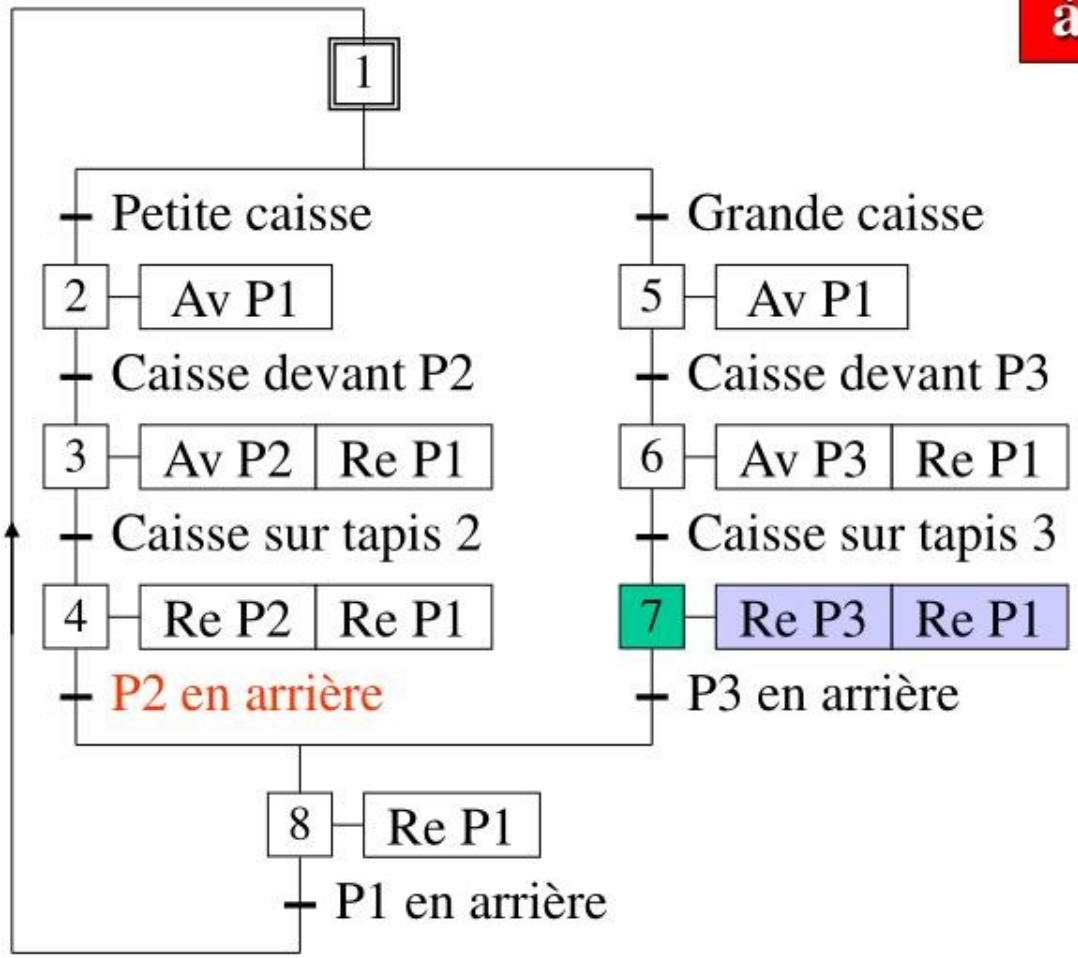


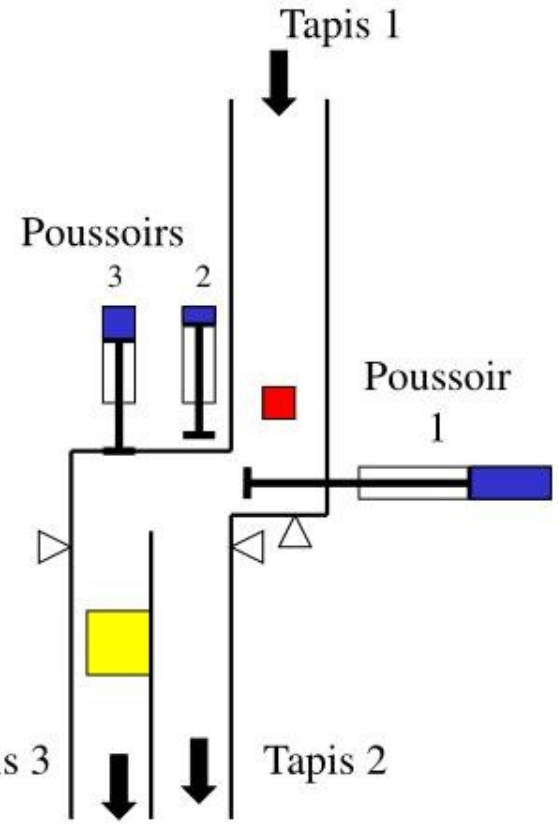
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P1, P2, P3 *: poussoirs N°1, N°2, N°3*

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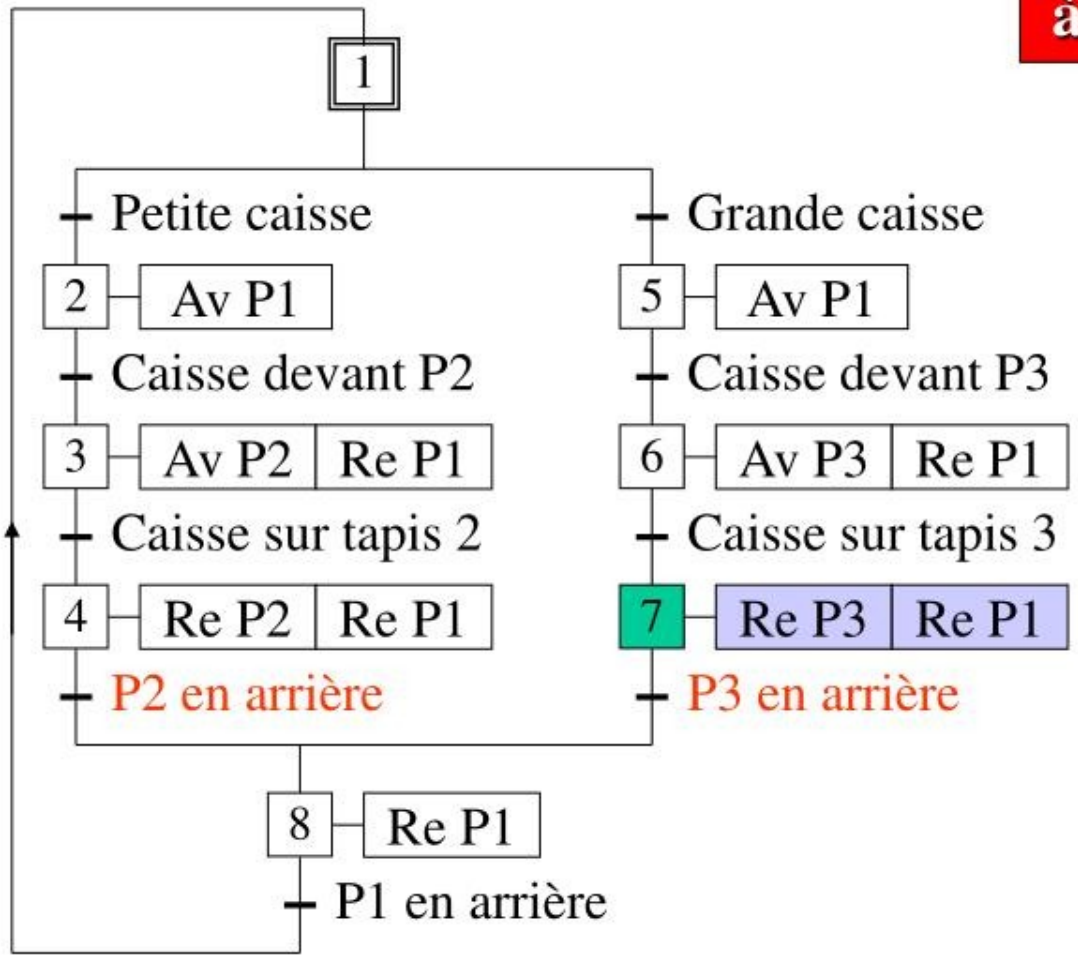


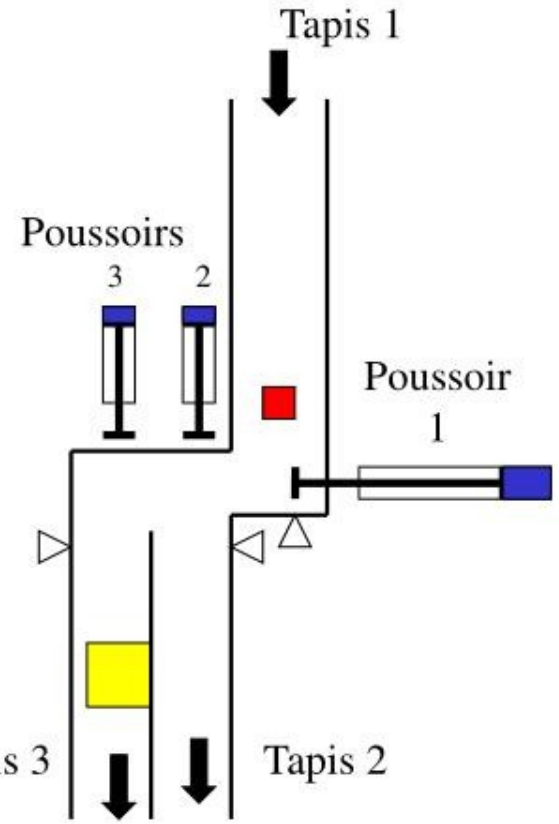
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P1, P2, P3 *: poussoirs N°1, N°2, N°3*

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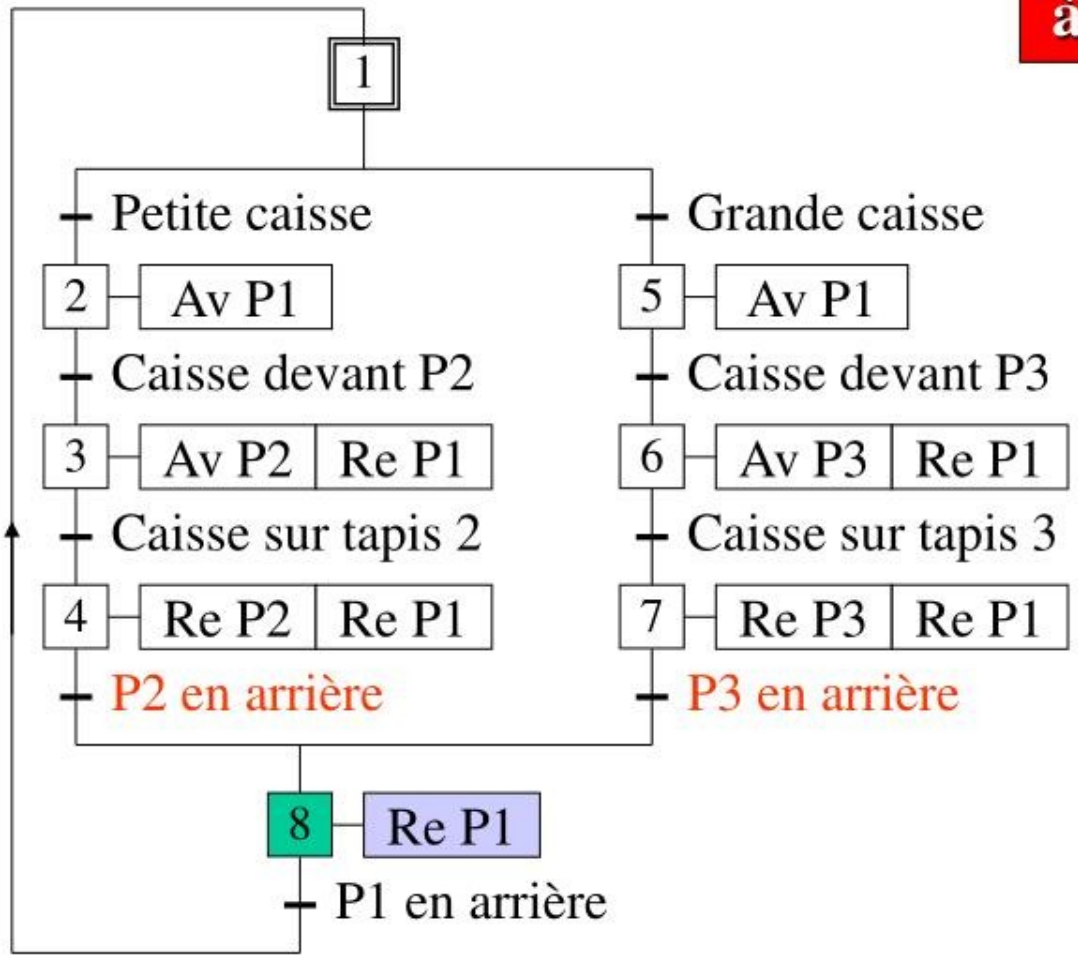


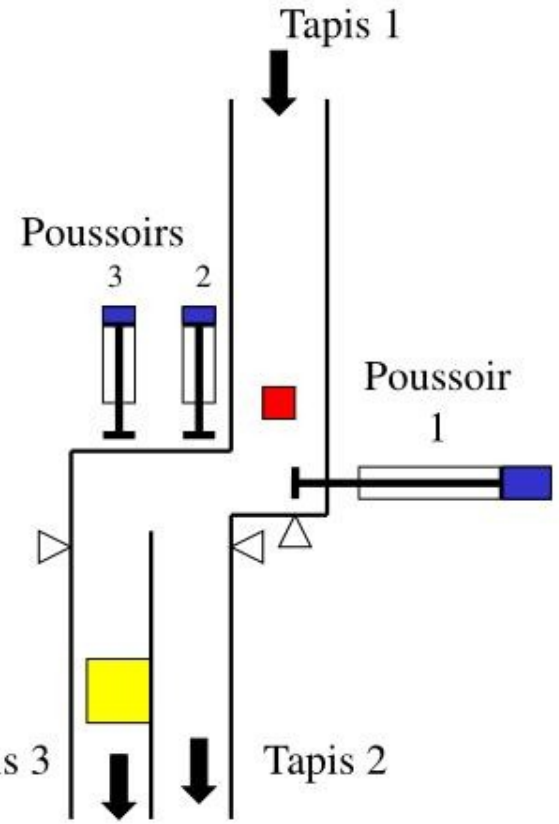
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P1, P2, P3 *: poussoirs N°1, N°2, N°3*

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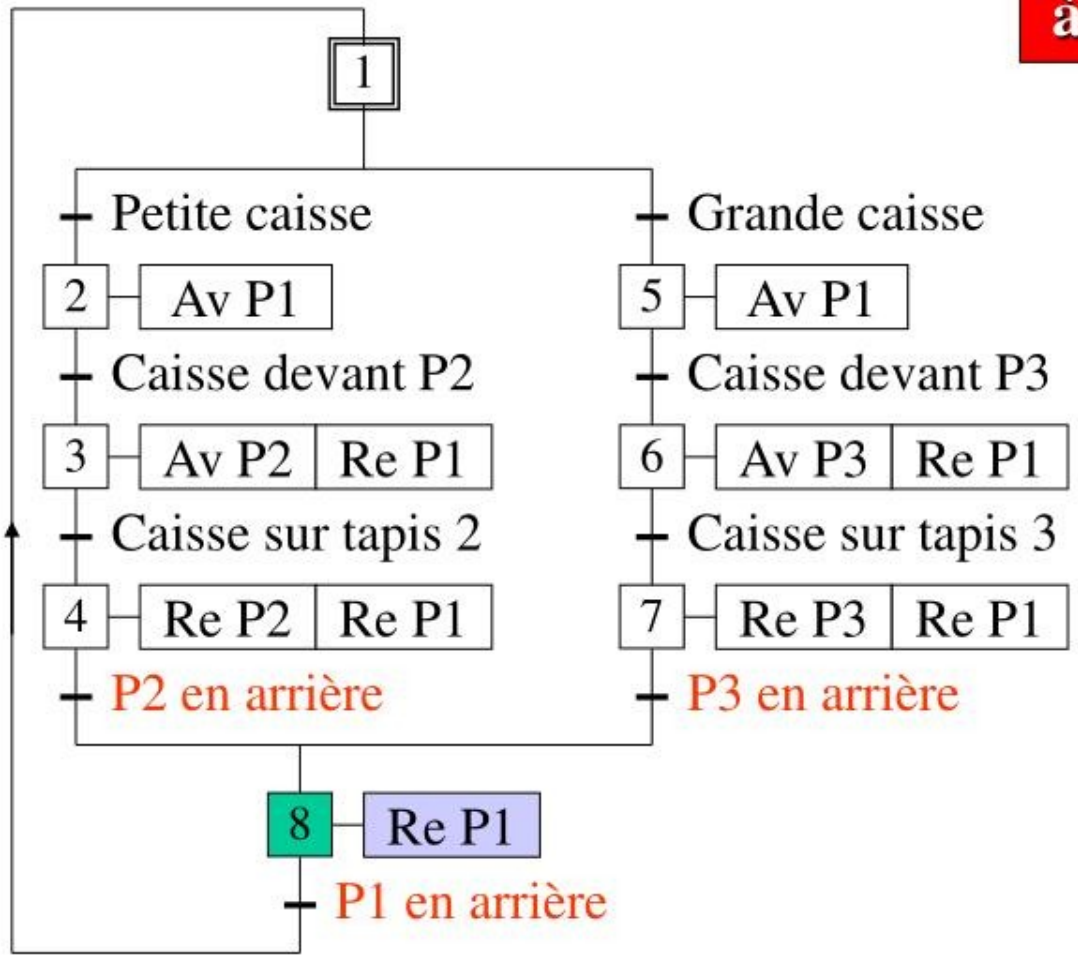


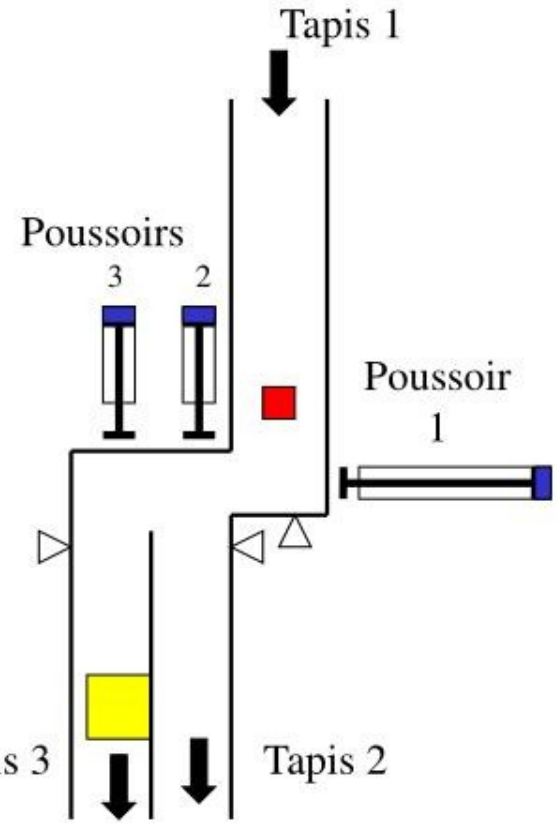
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P1, P2, P3 *: poussoirs N°1,2,3*

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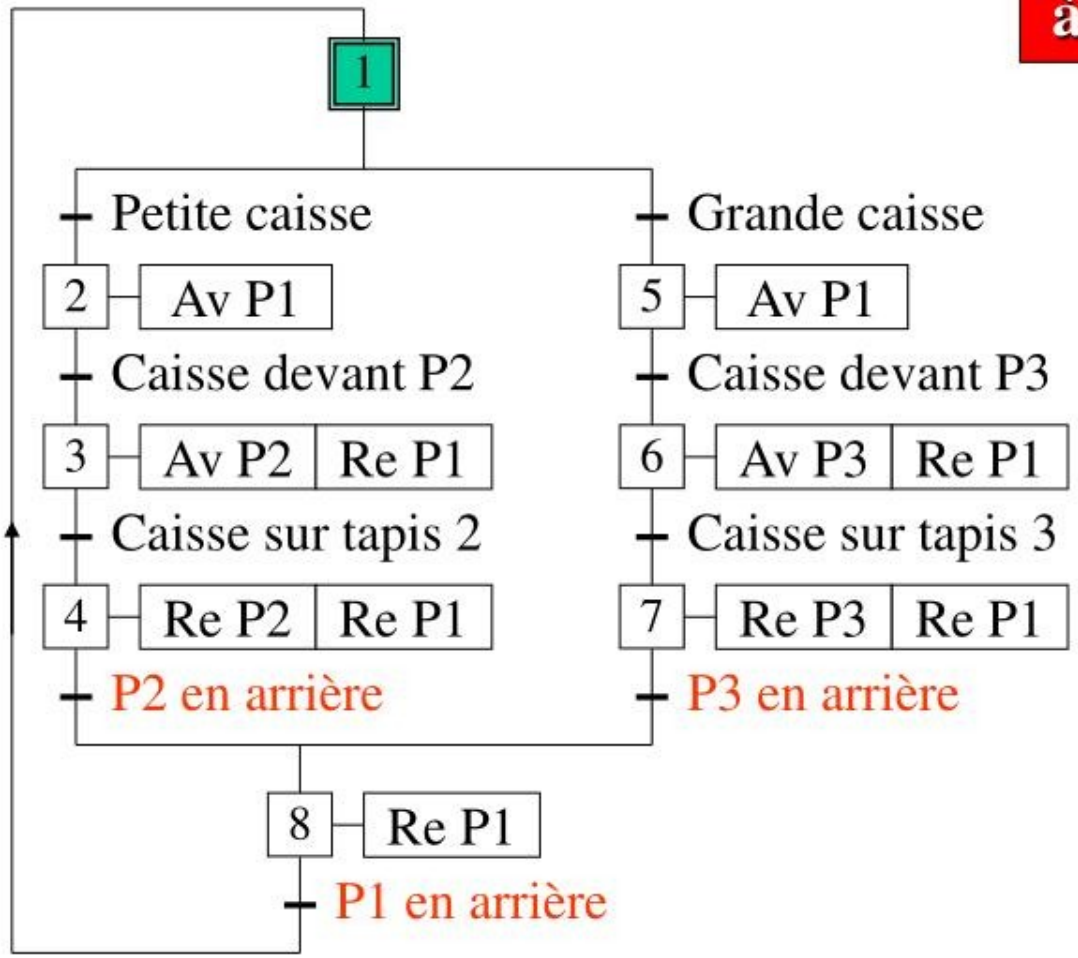


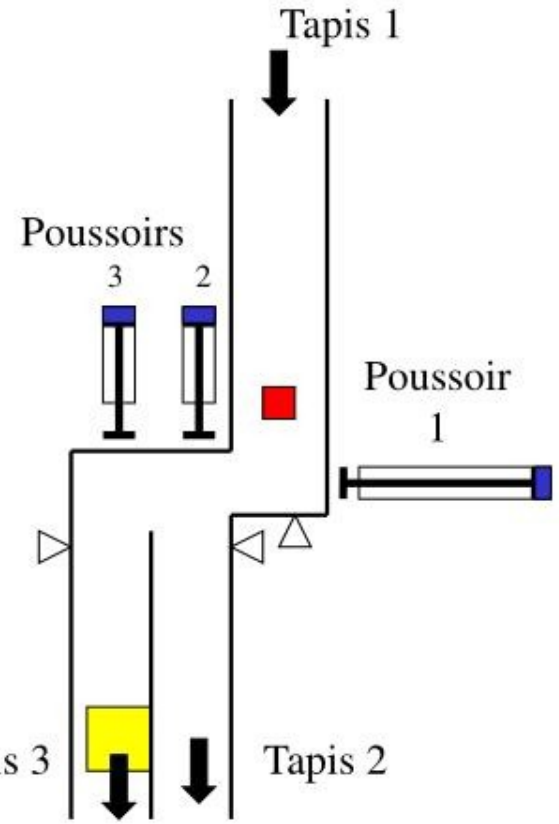
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P1, P2, P3 *: poussoirs N°1, N°2, N°3*

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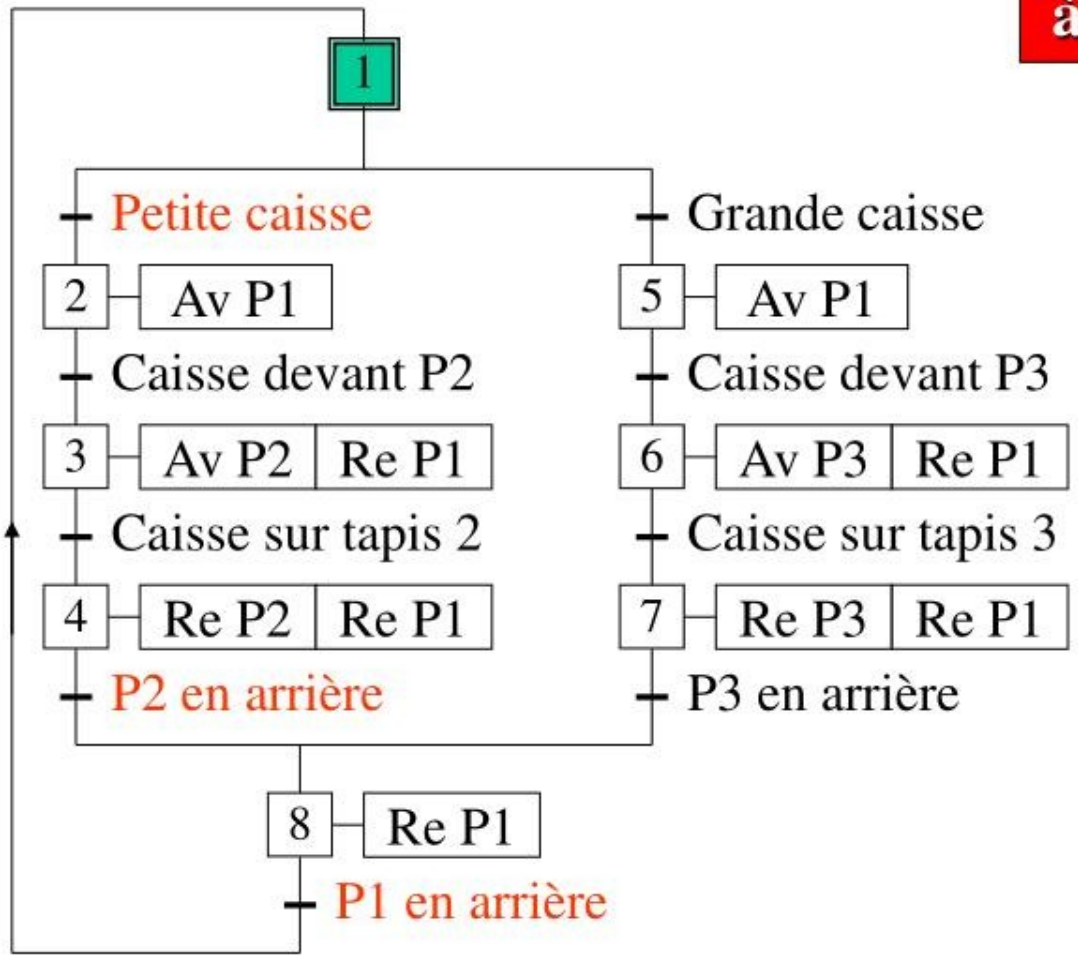


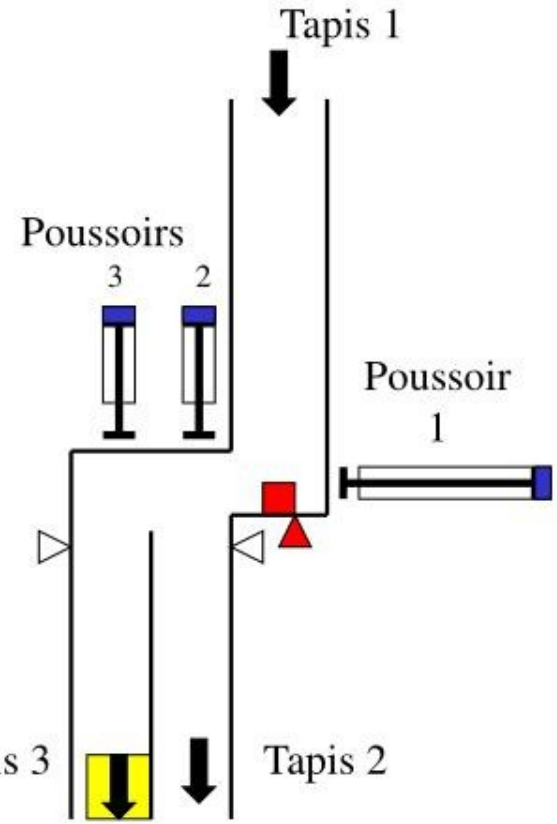
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1, 2, 3*

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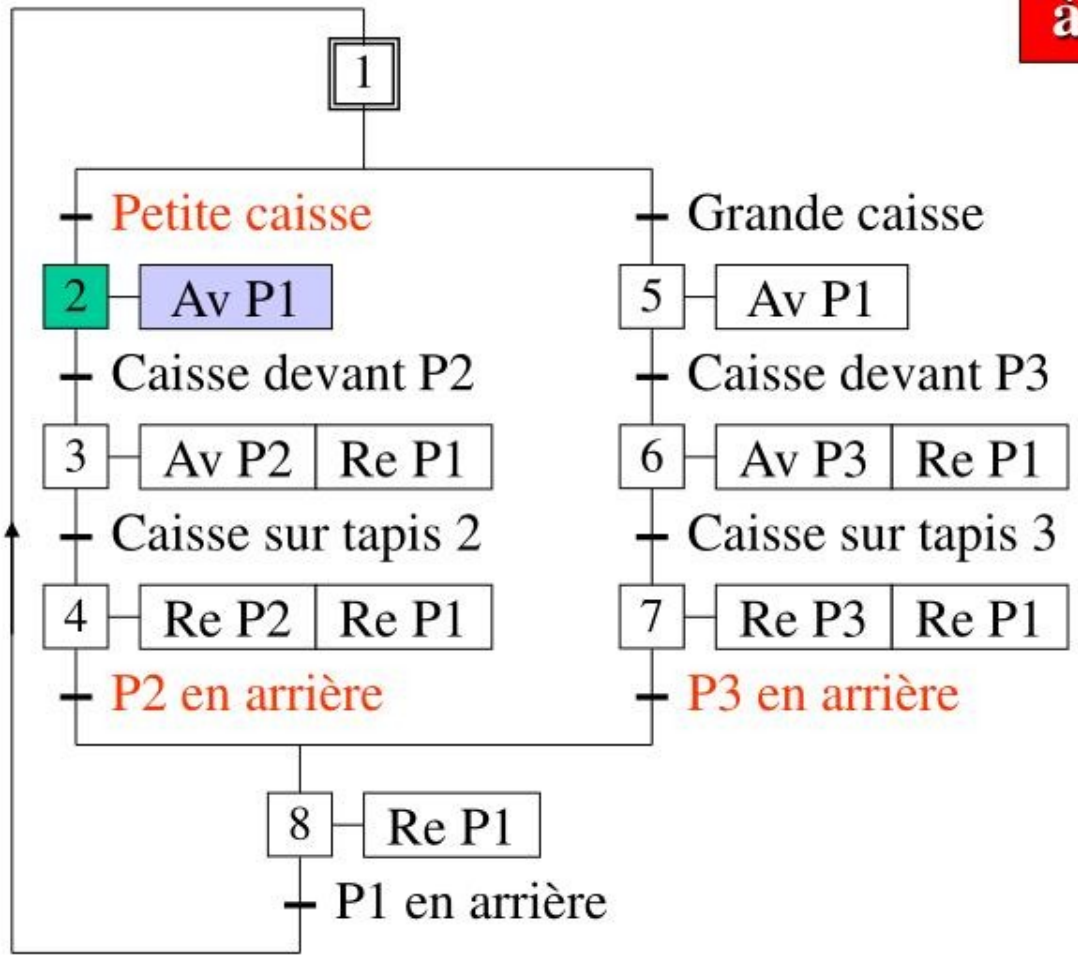


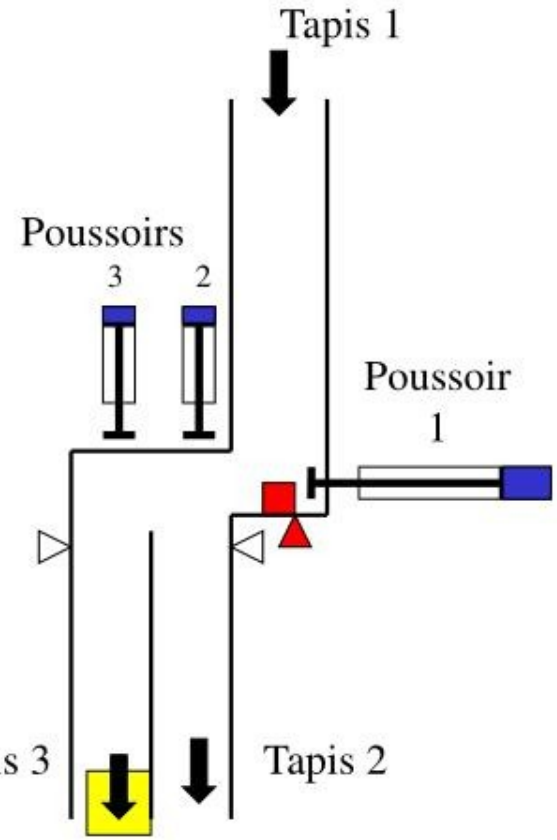
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1, 2, 3*

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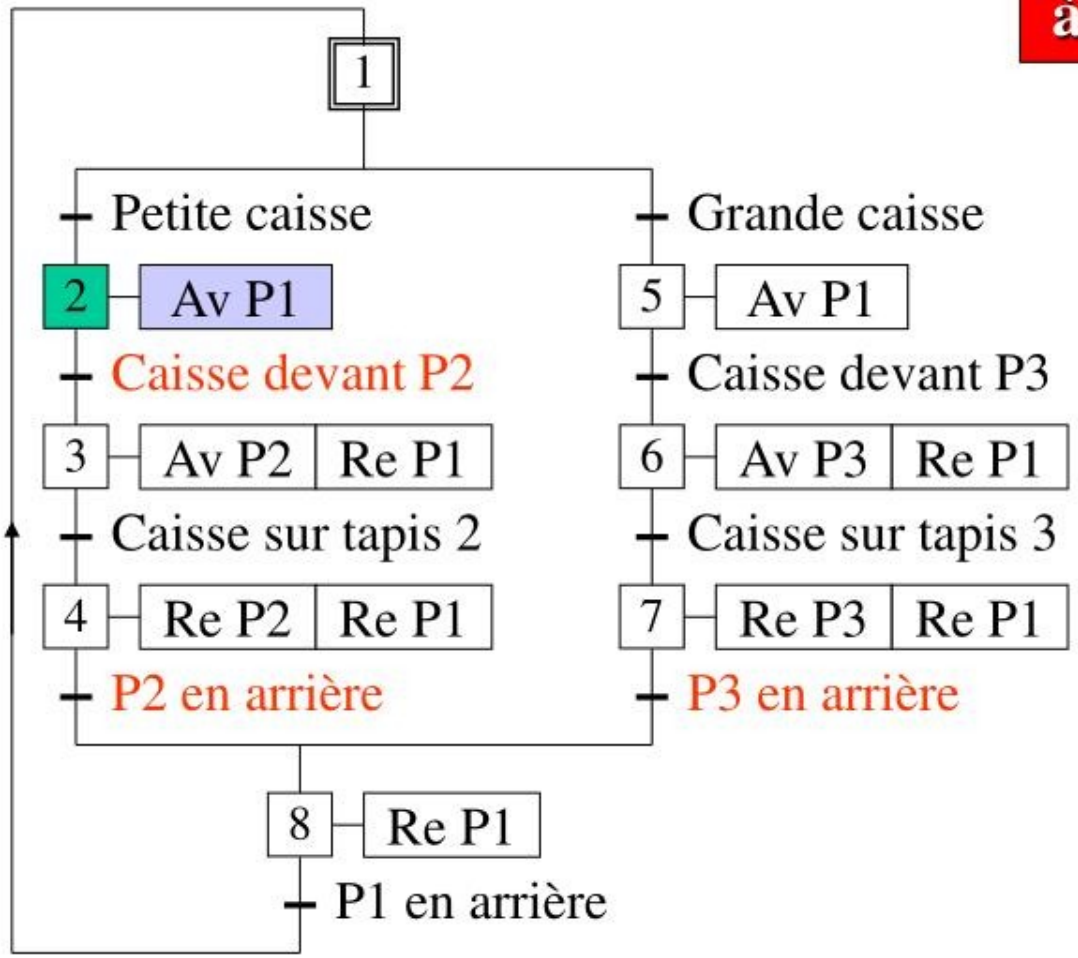


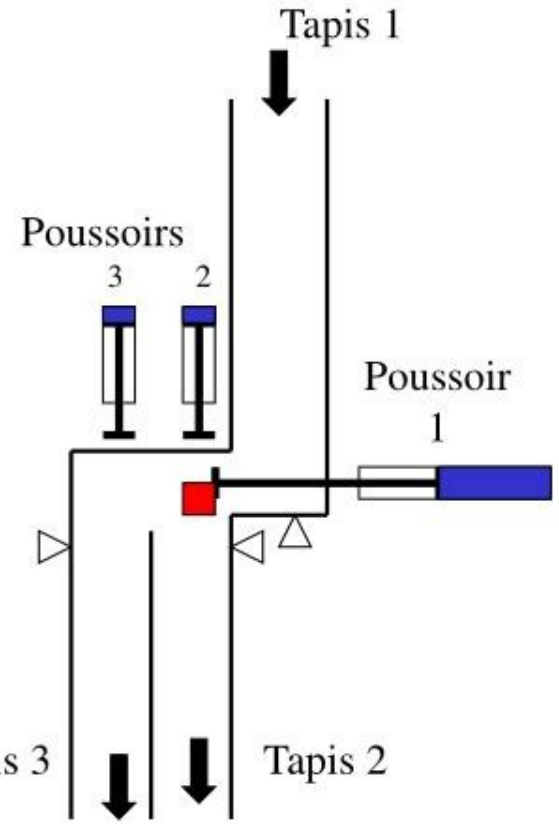
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1, 2, 3*

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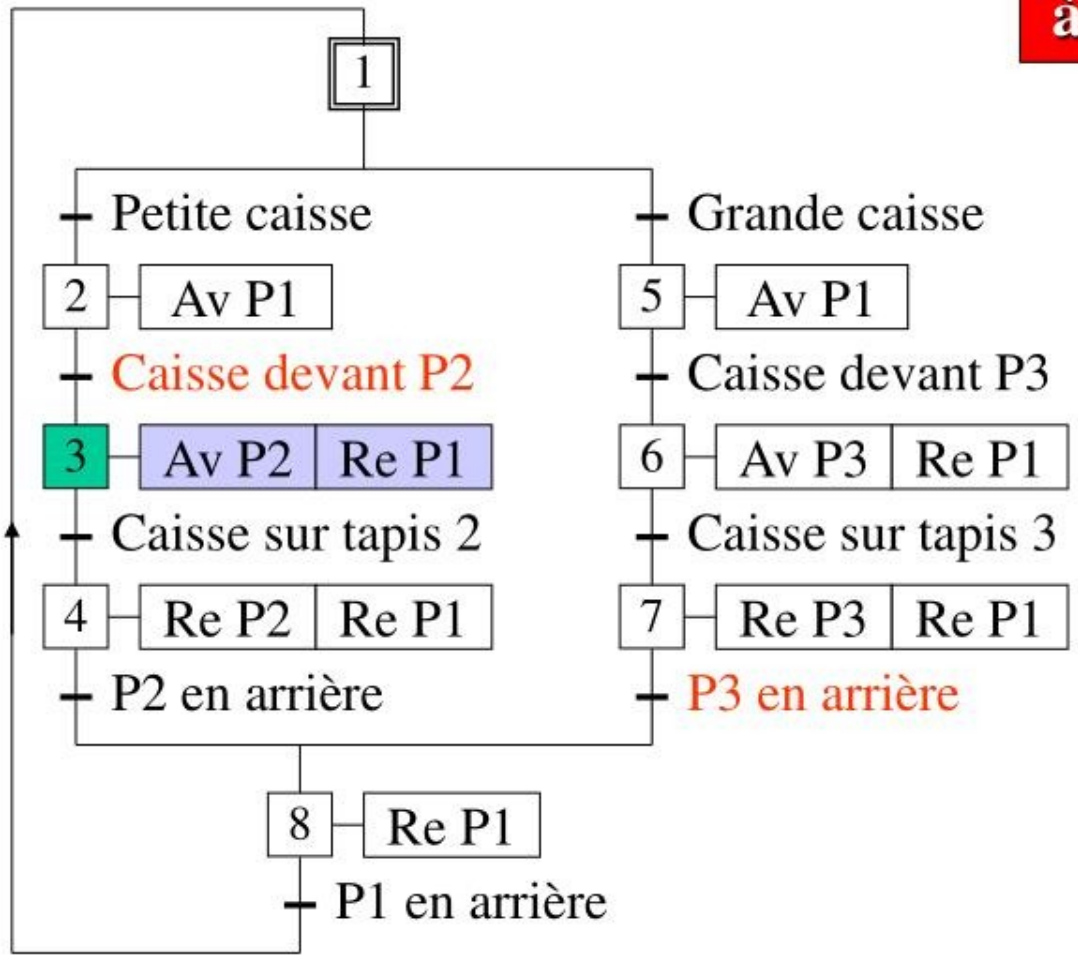


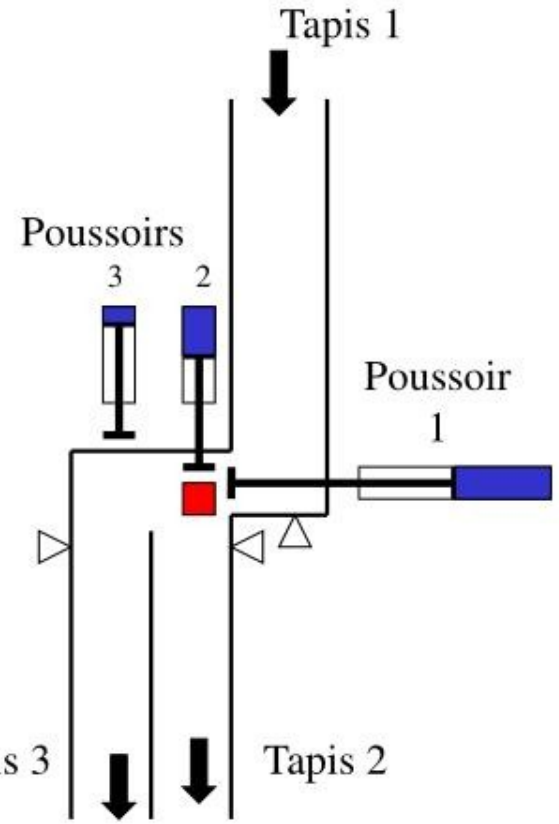
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1,2,3*

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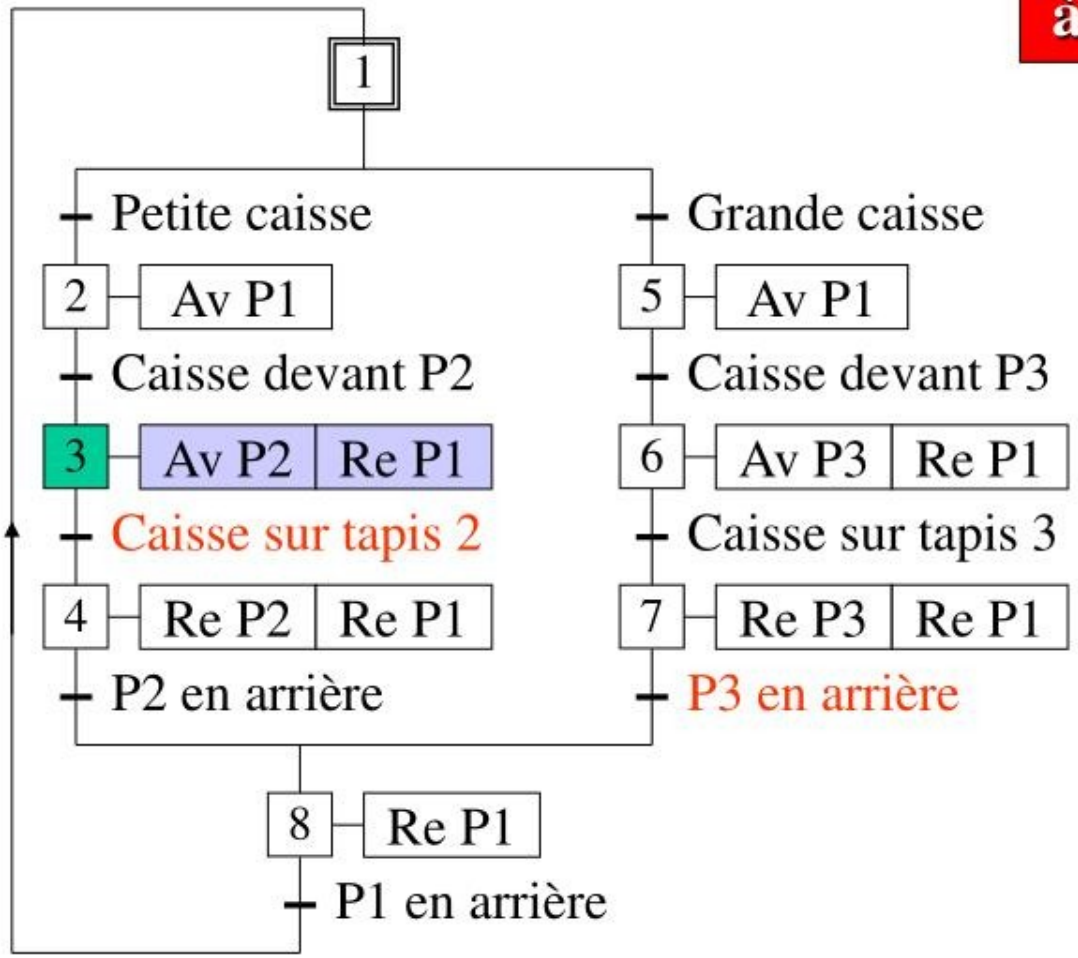


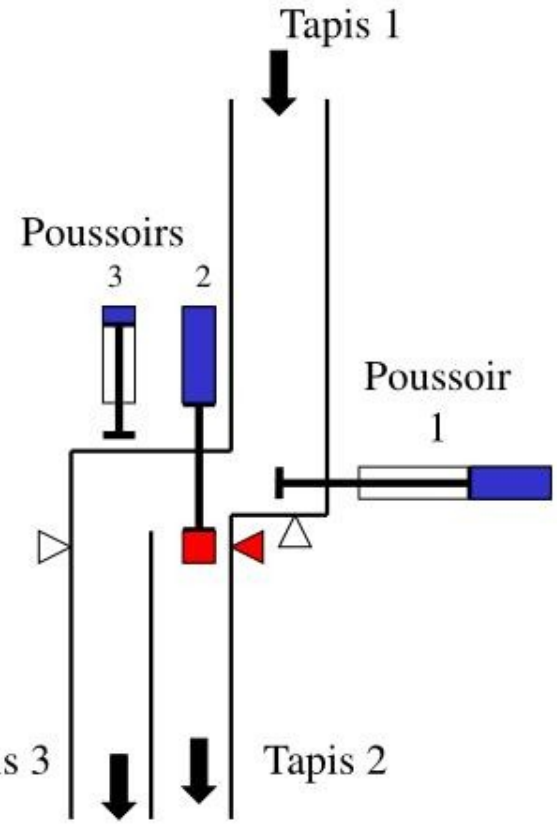
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1,2,3*

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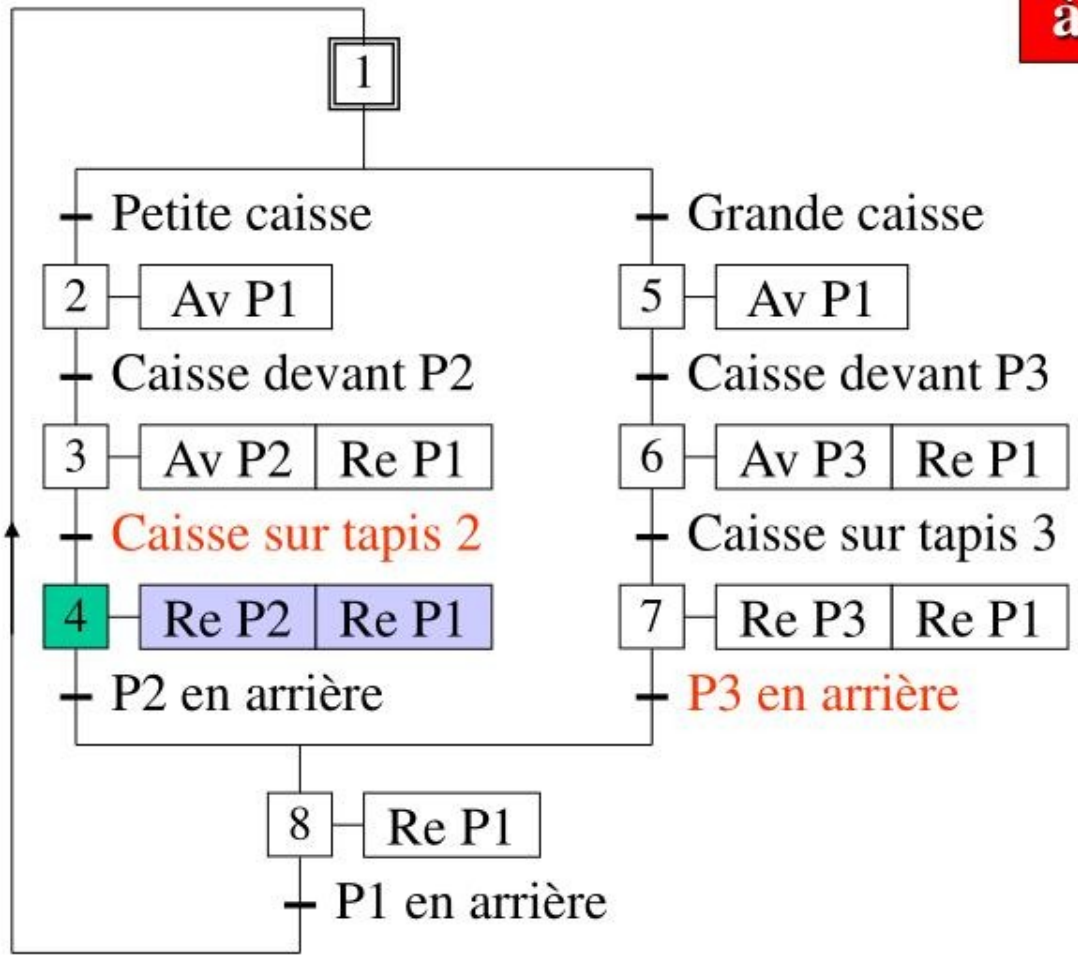


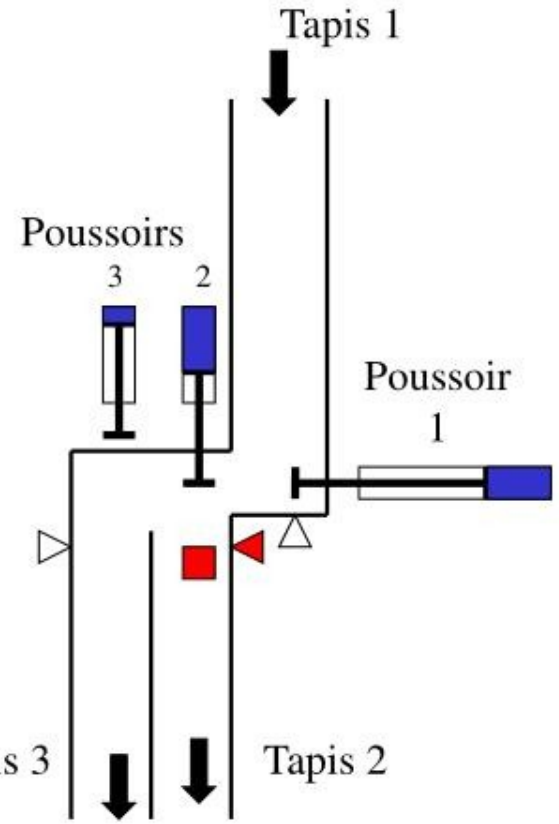
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1,2,3*

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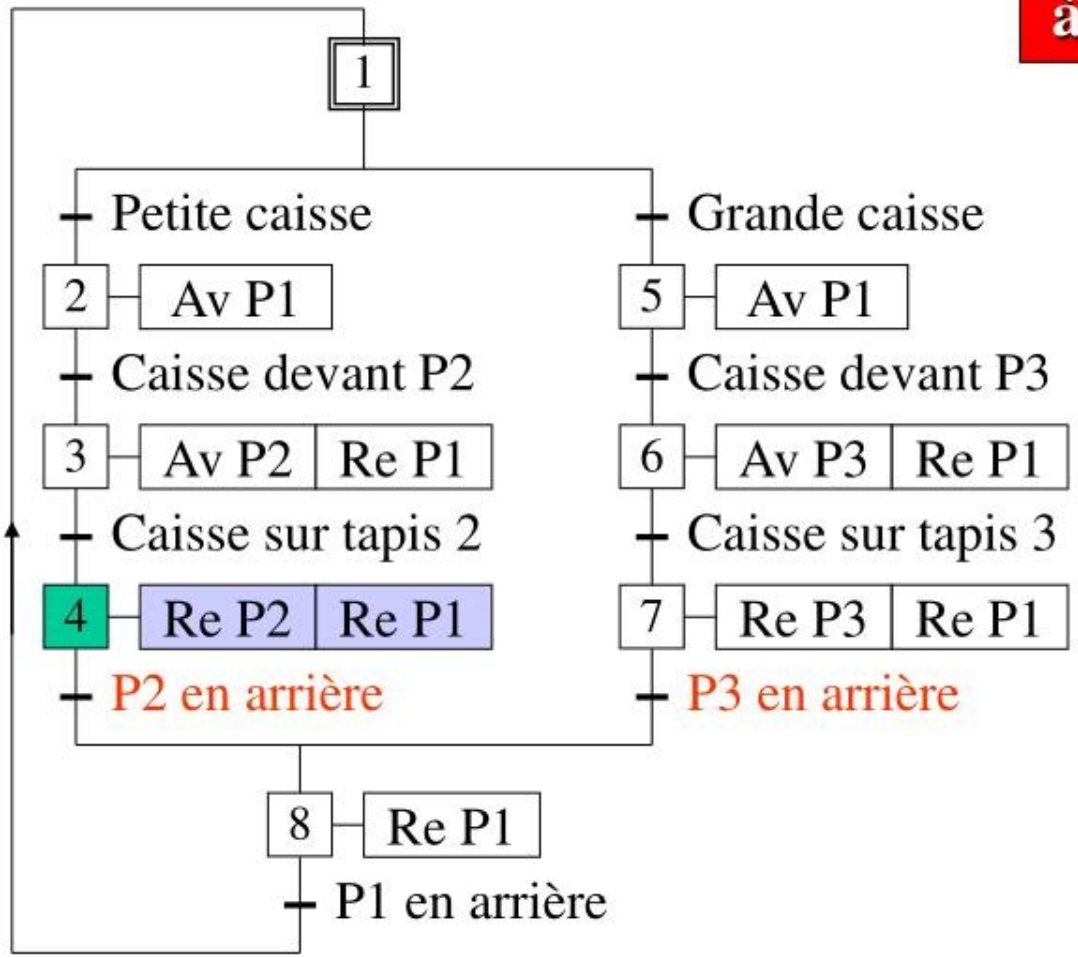


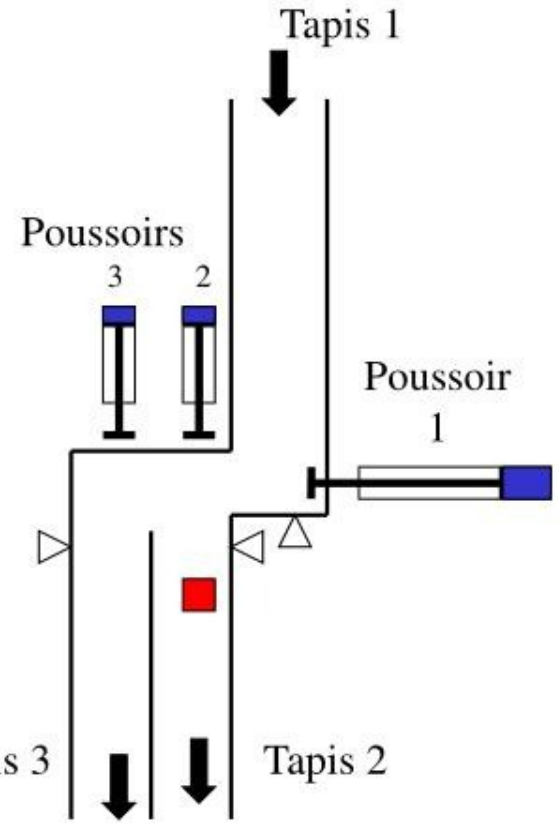
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1, 2, 3*

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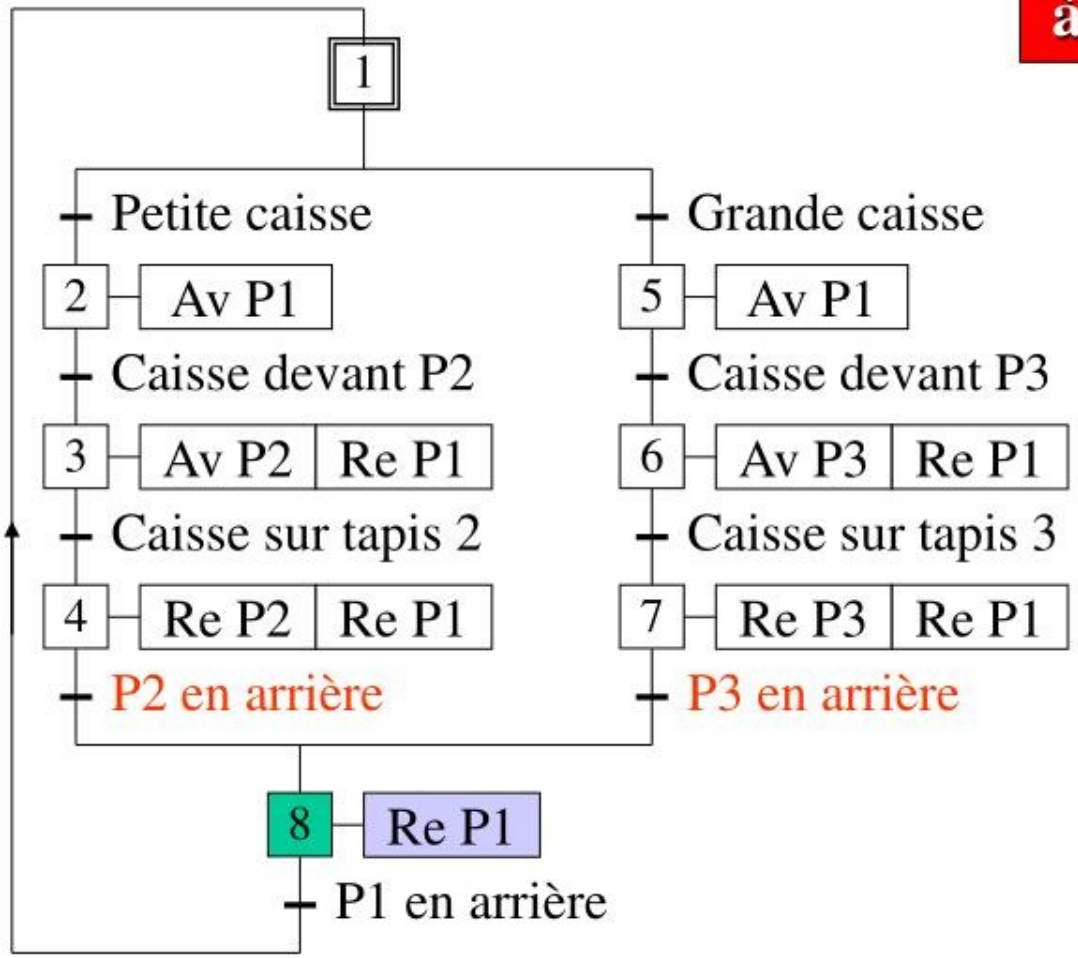


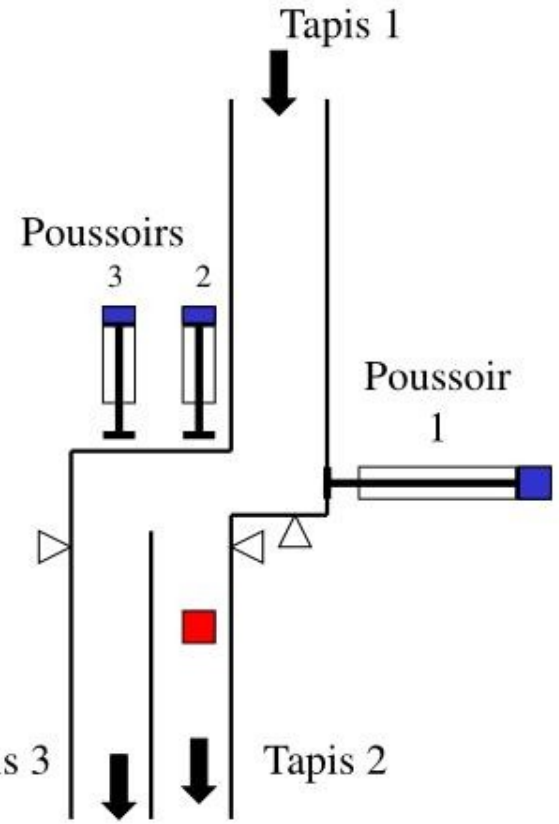
Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1, 2, 3*

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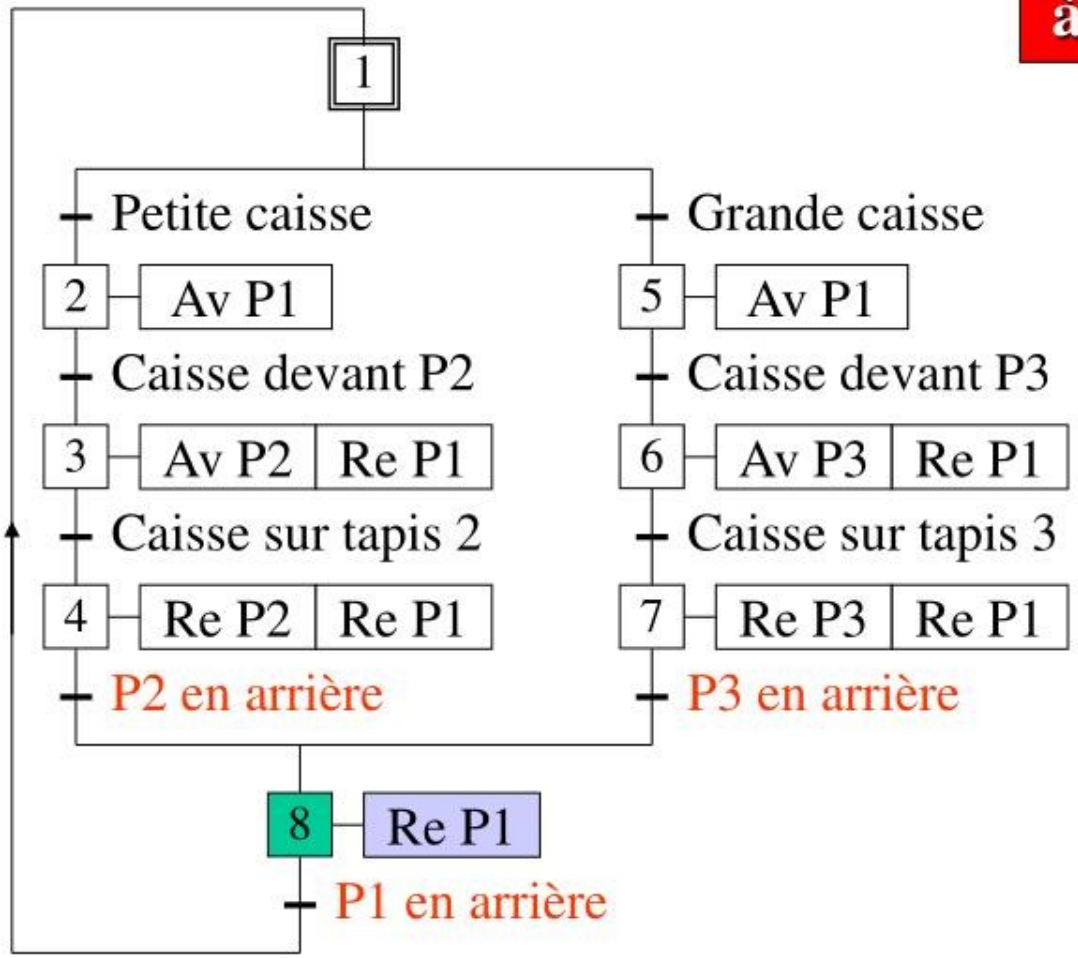


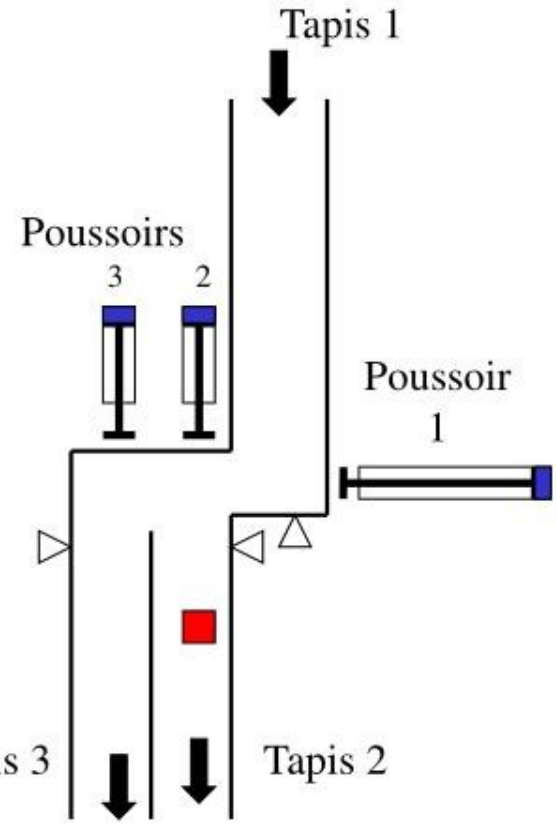
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P1, P2, P3 *: poussoirs N°1, 2, 3*

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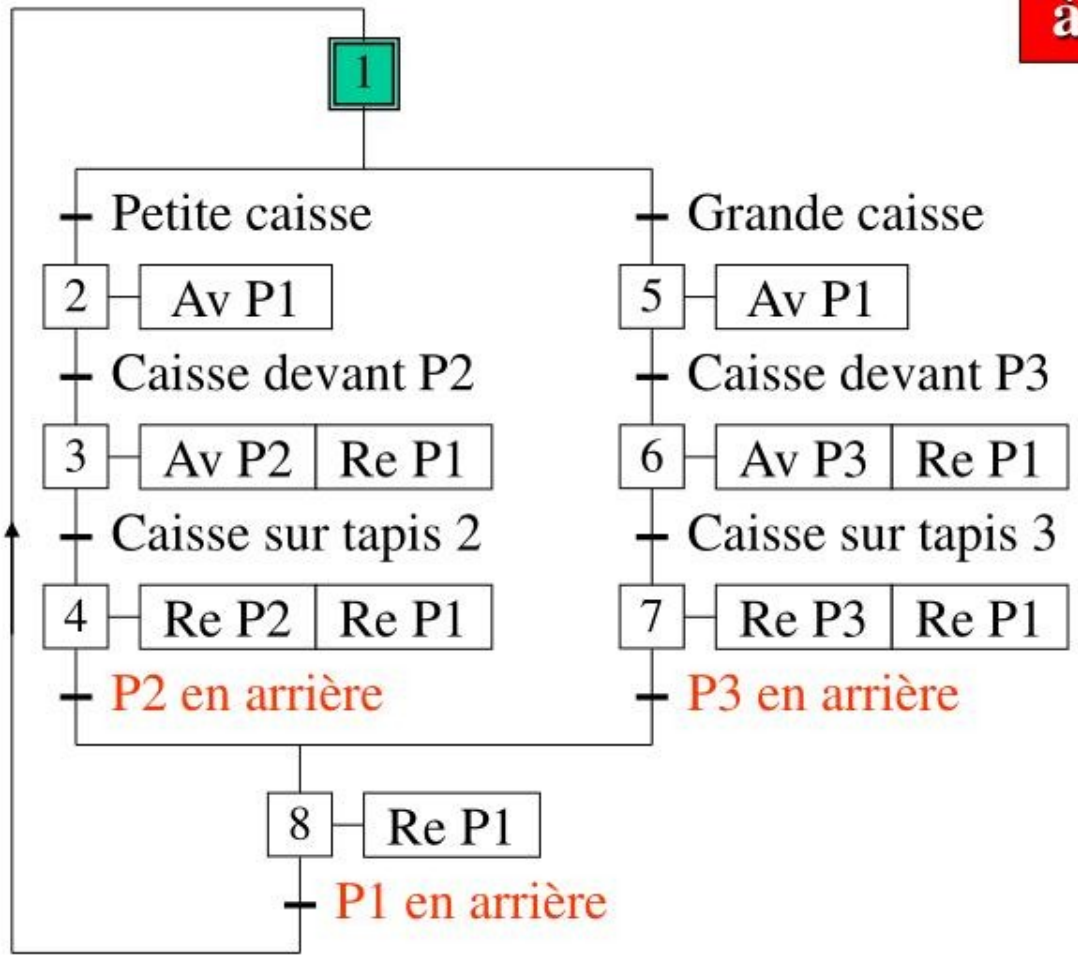


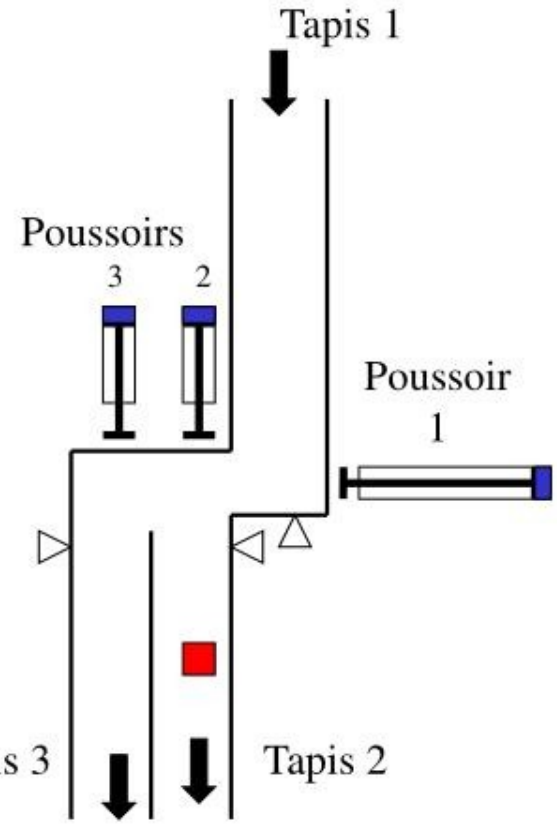
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P1, P2, P3 *: poussoirs N°1, 2, 3*

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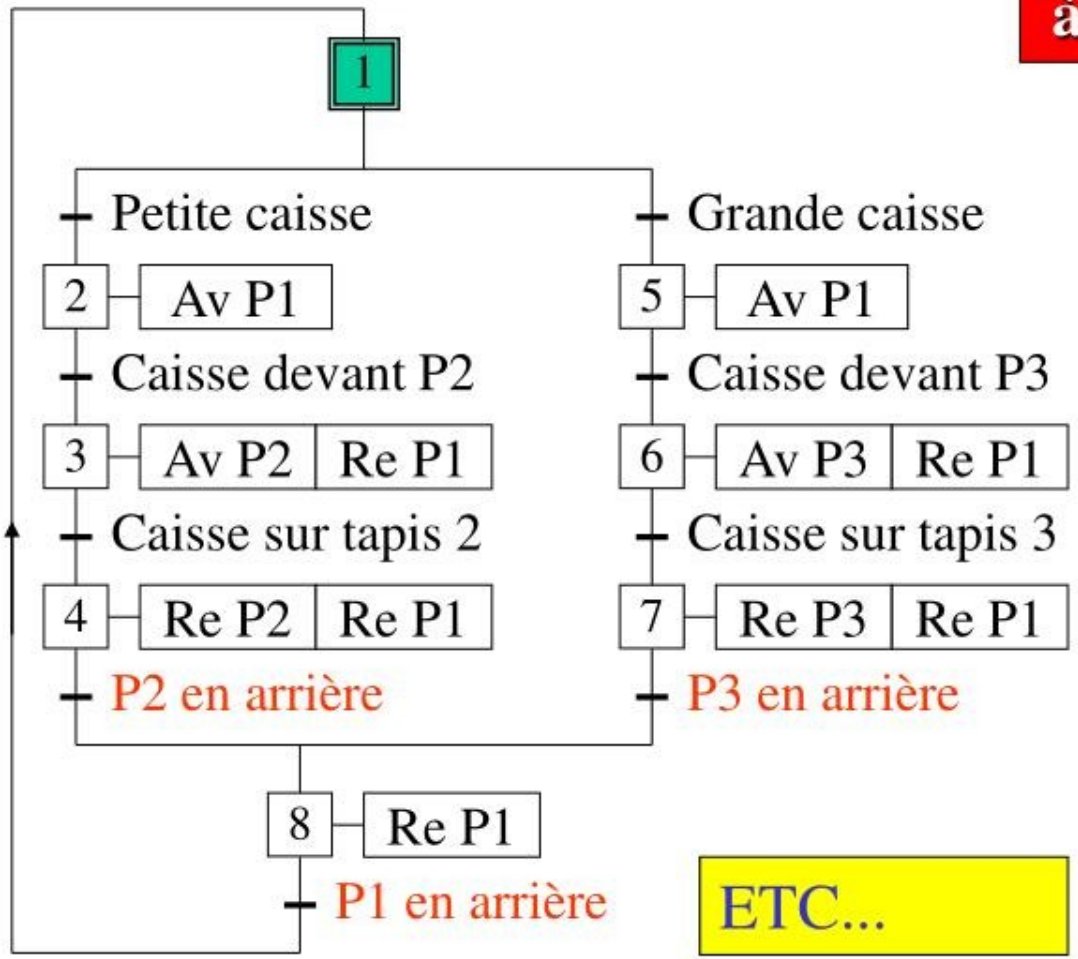


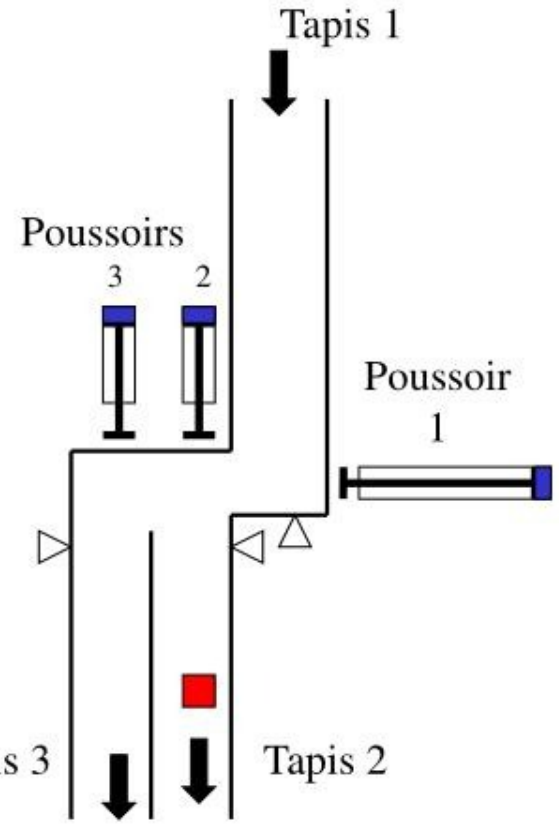
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P1, P2, P3 *: poussoirs N°1, 2, 3*

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Av *: Avance* ***Re*** *: Recule*

P1, P2, P3 *: poussoirs N°1, 2, 3*

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