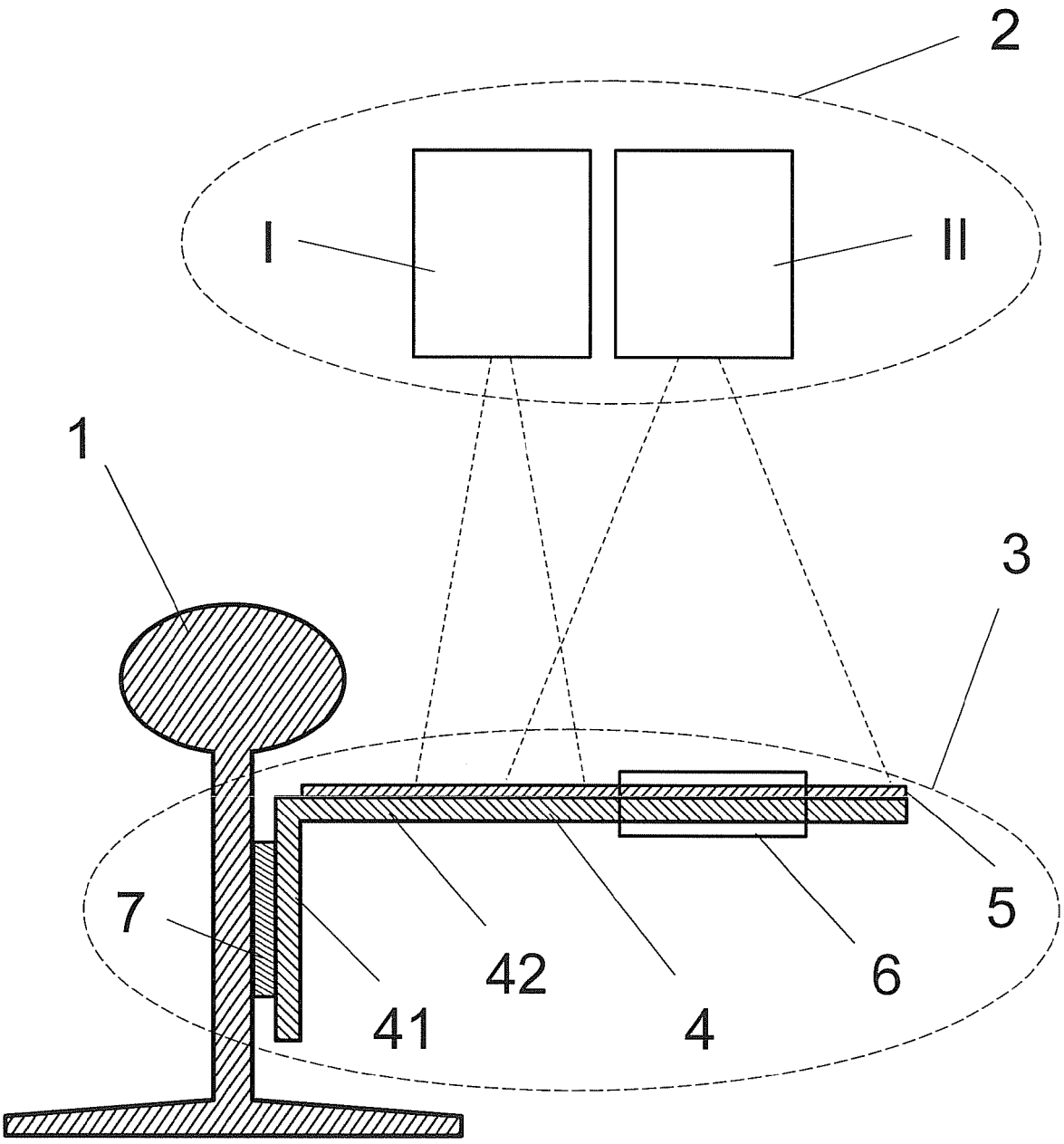


Fig. 1

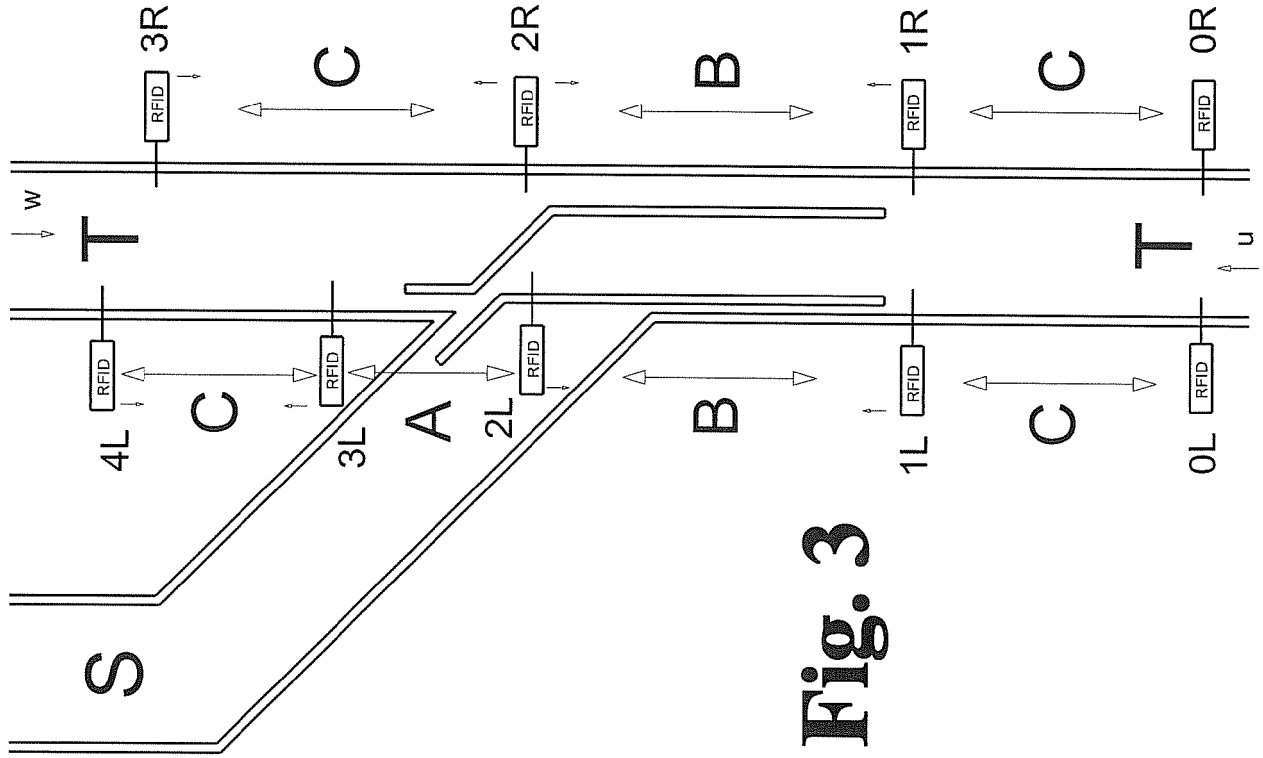

3R
2R
1R
0R
RFID
C
B
C
w
T
u
T
4L
3L
2L
1L
0L
C
A
B
C
S

Fig. 3

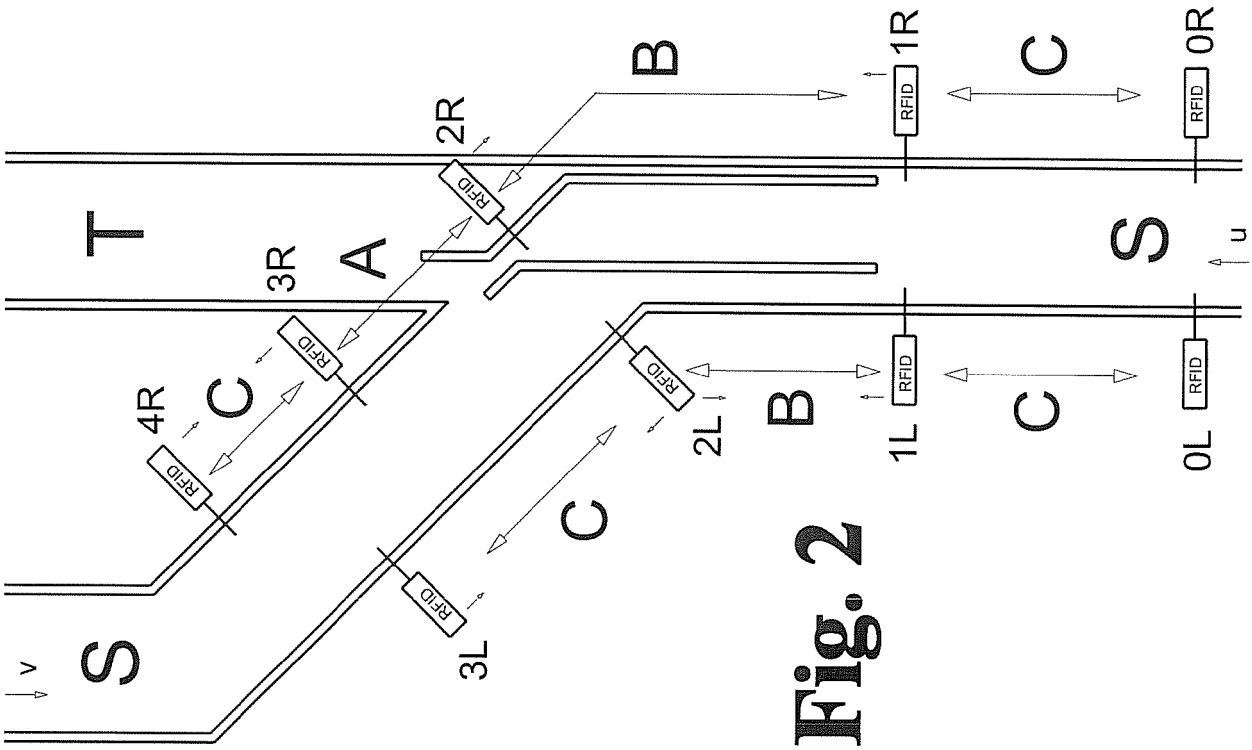

B
1R
0R
RFID
C
2R
T
A
S
u
3R
4R
C
2L
B
1L
C
0L
C
3L
S
v

Fig. 2

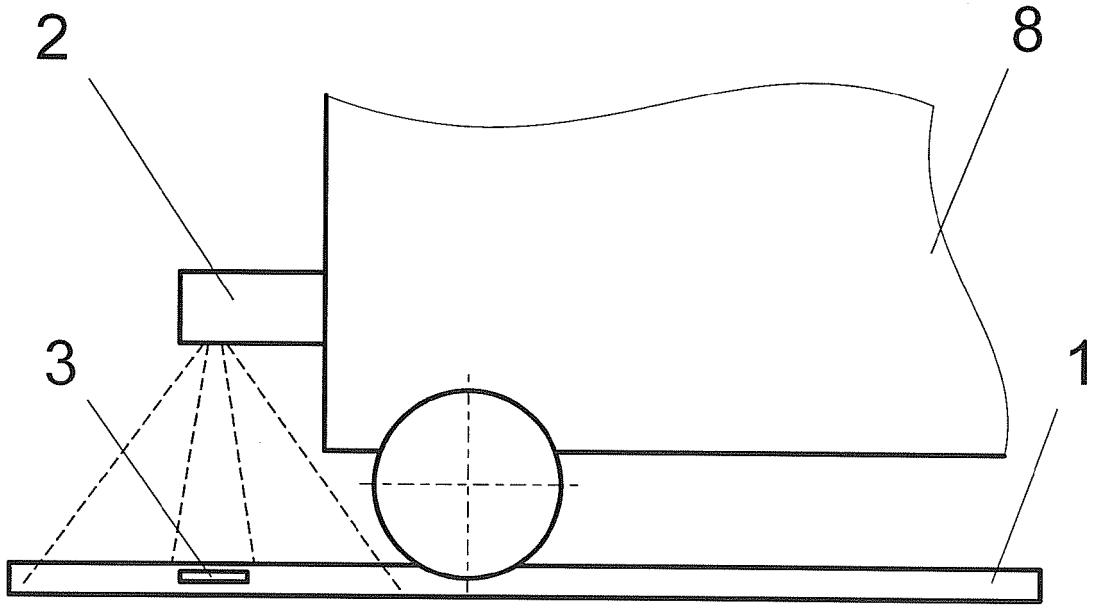


Fig. 4

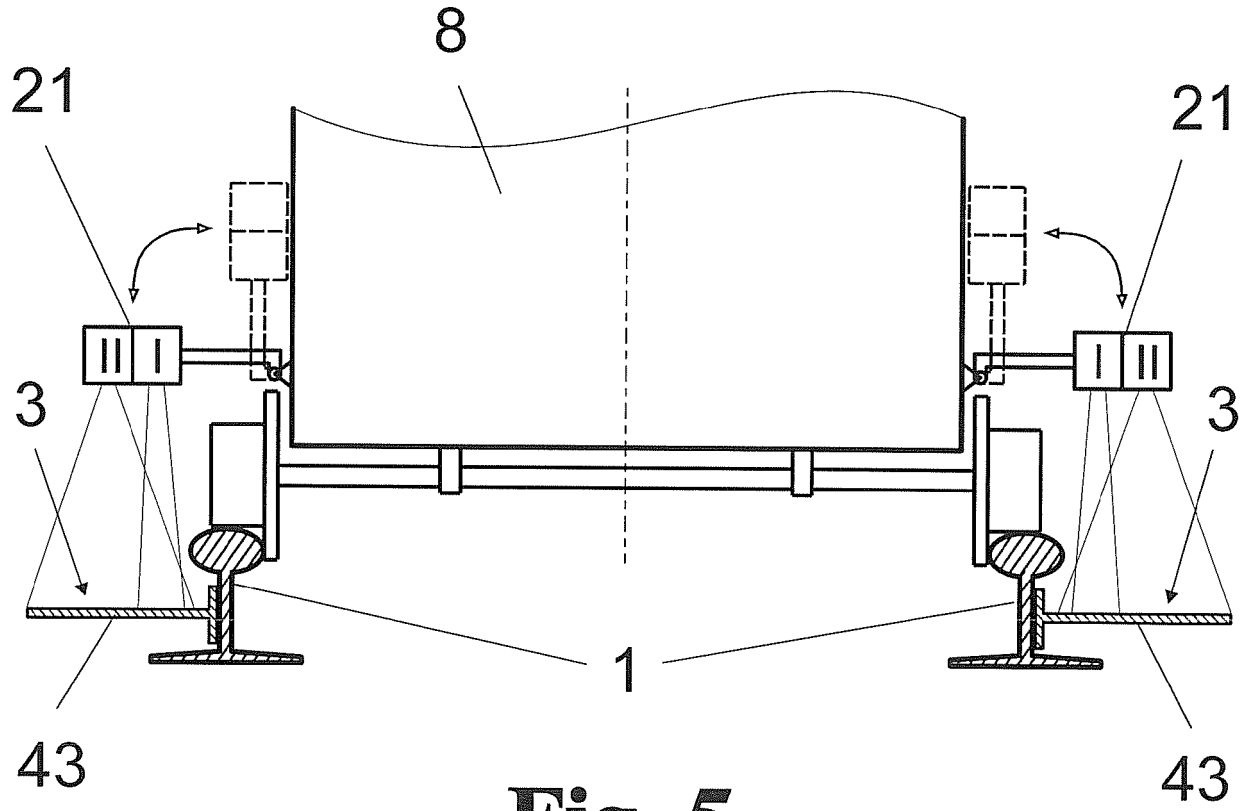


Fig. 5

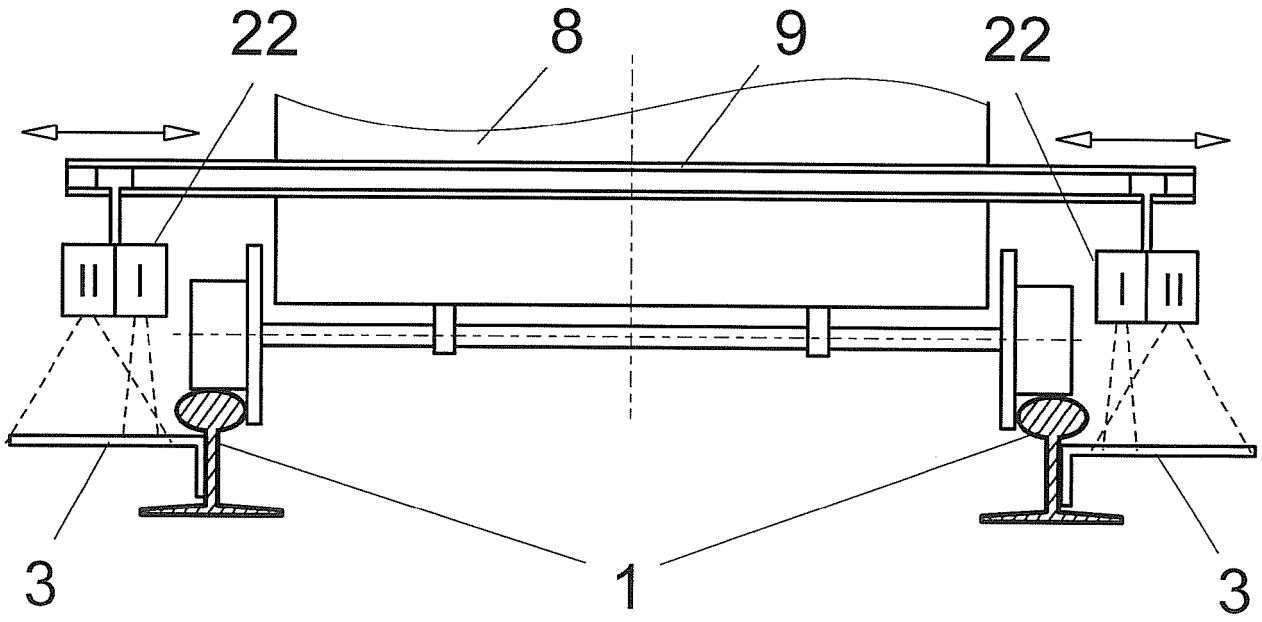


Fig. 6

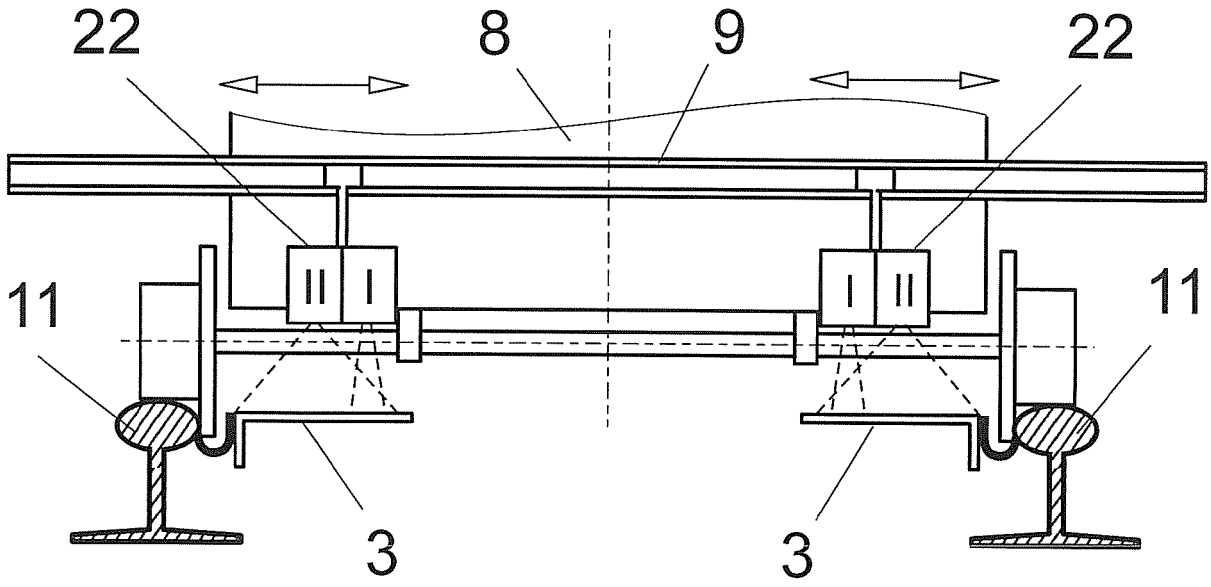


Fig. 7

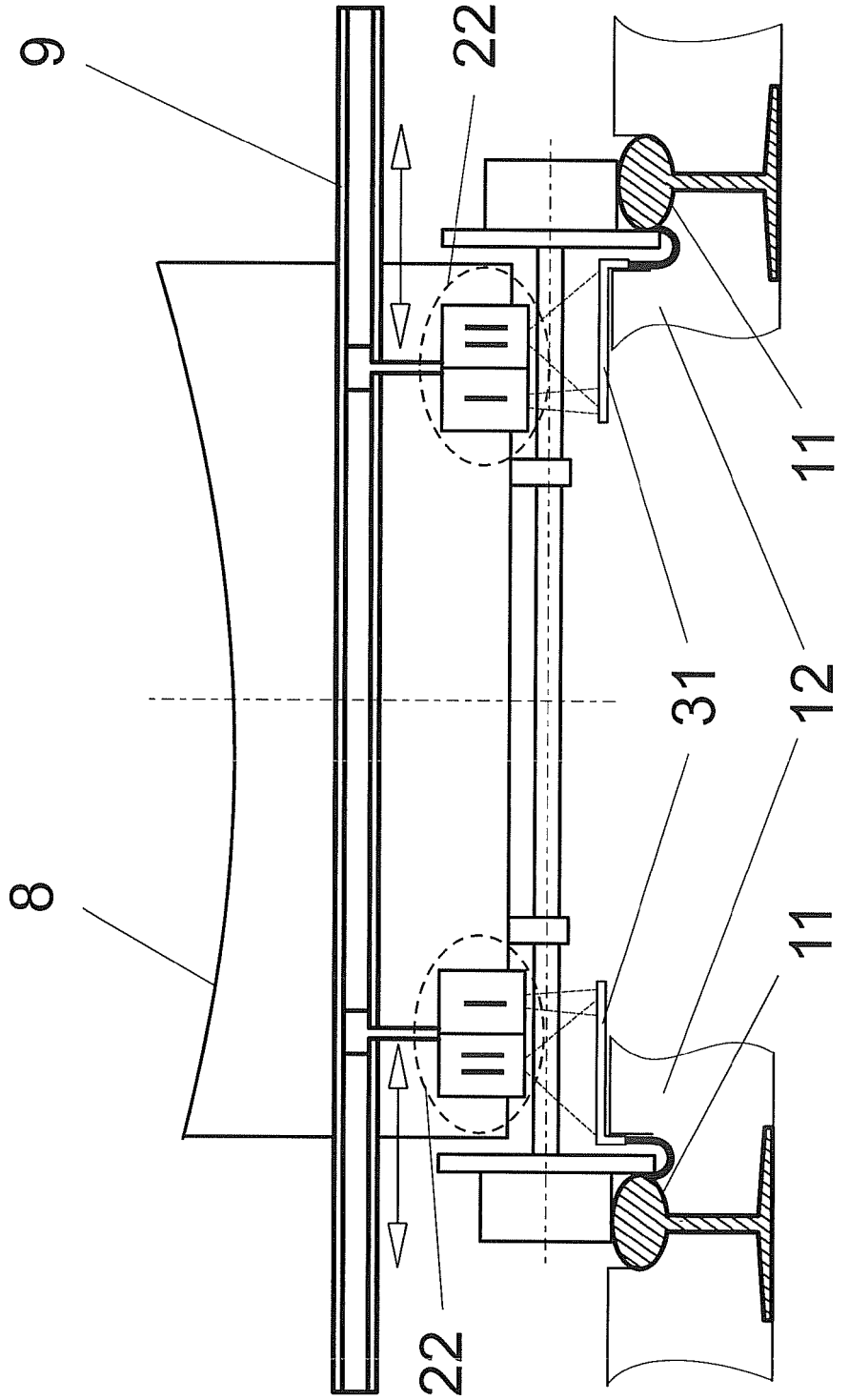


Fig. 8

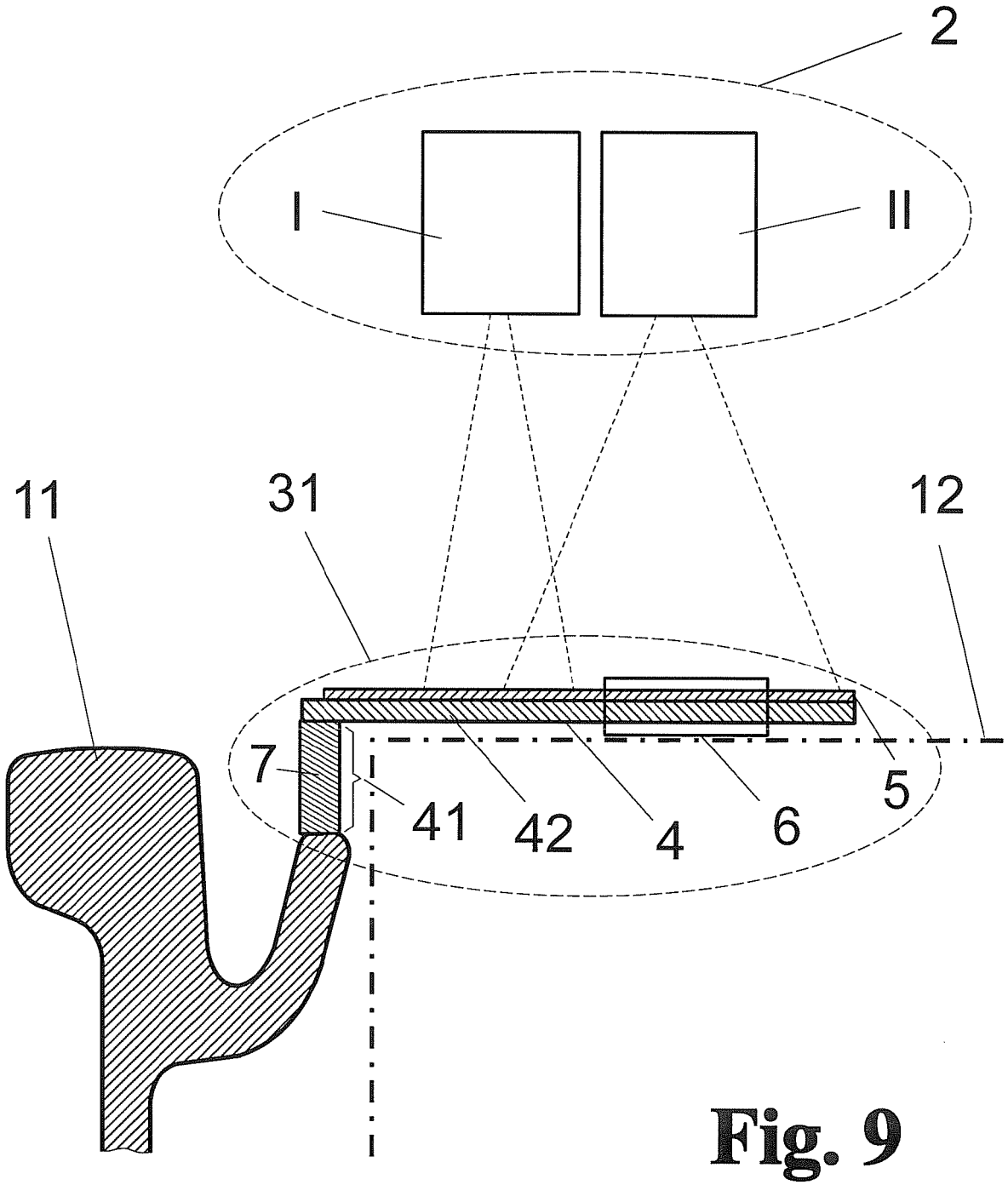


Fig. 9

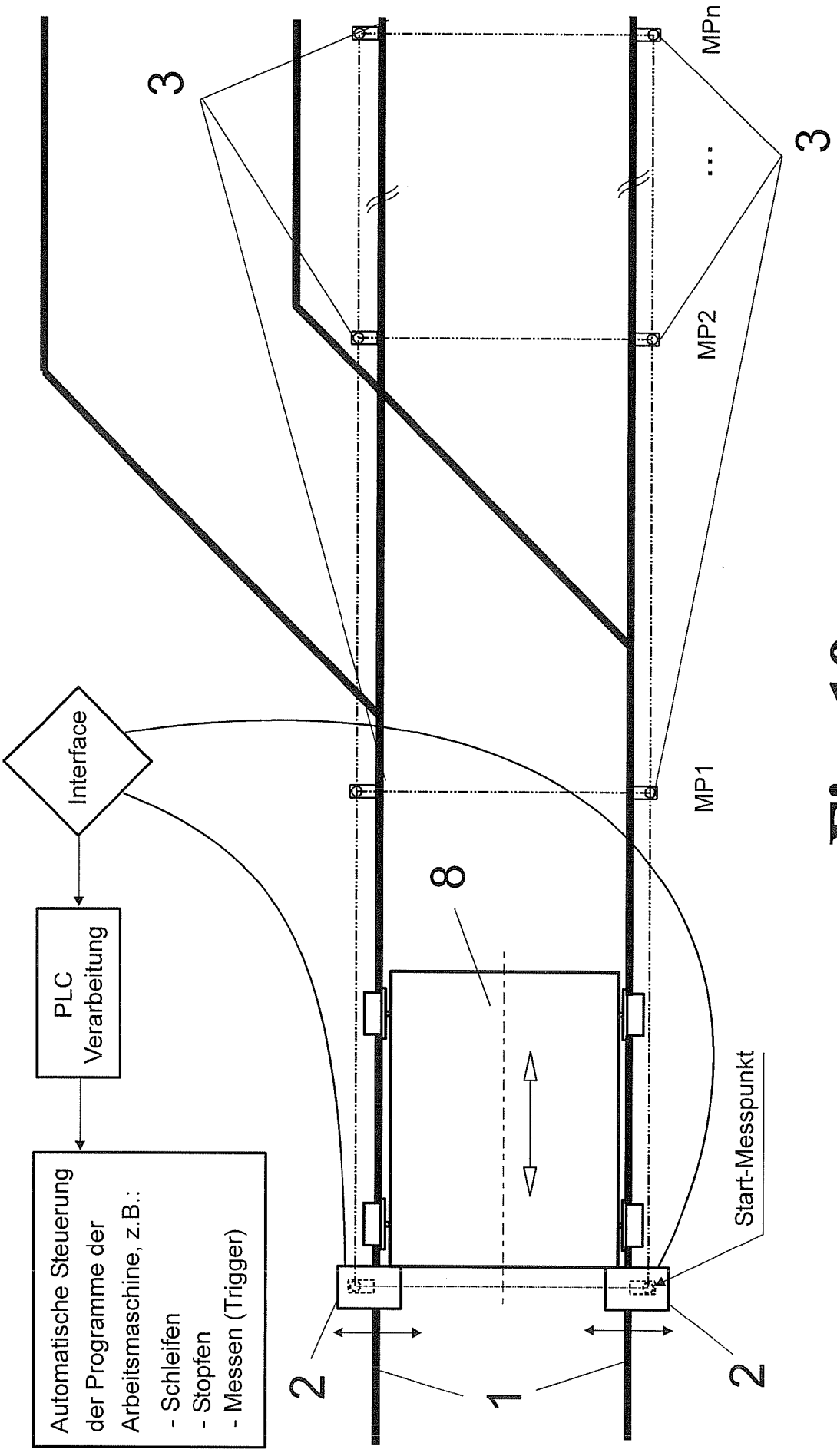

Automatische Steuerung der Programme der Arbeitsmaschine, z.B.:
- Schleifen
- Stopfen
- Messen (Trigger)
PLC Verarbeitung
Interface
3
3
MPn
...
MP2
MP1
8
Start-Messpunkt
2
1
2

Fig. 10

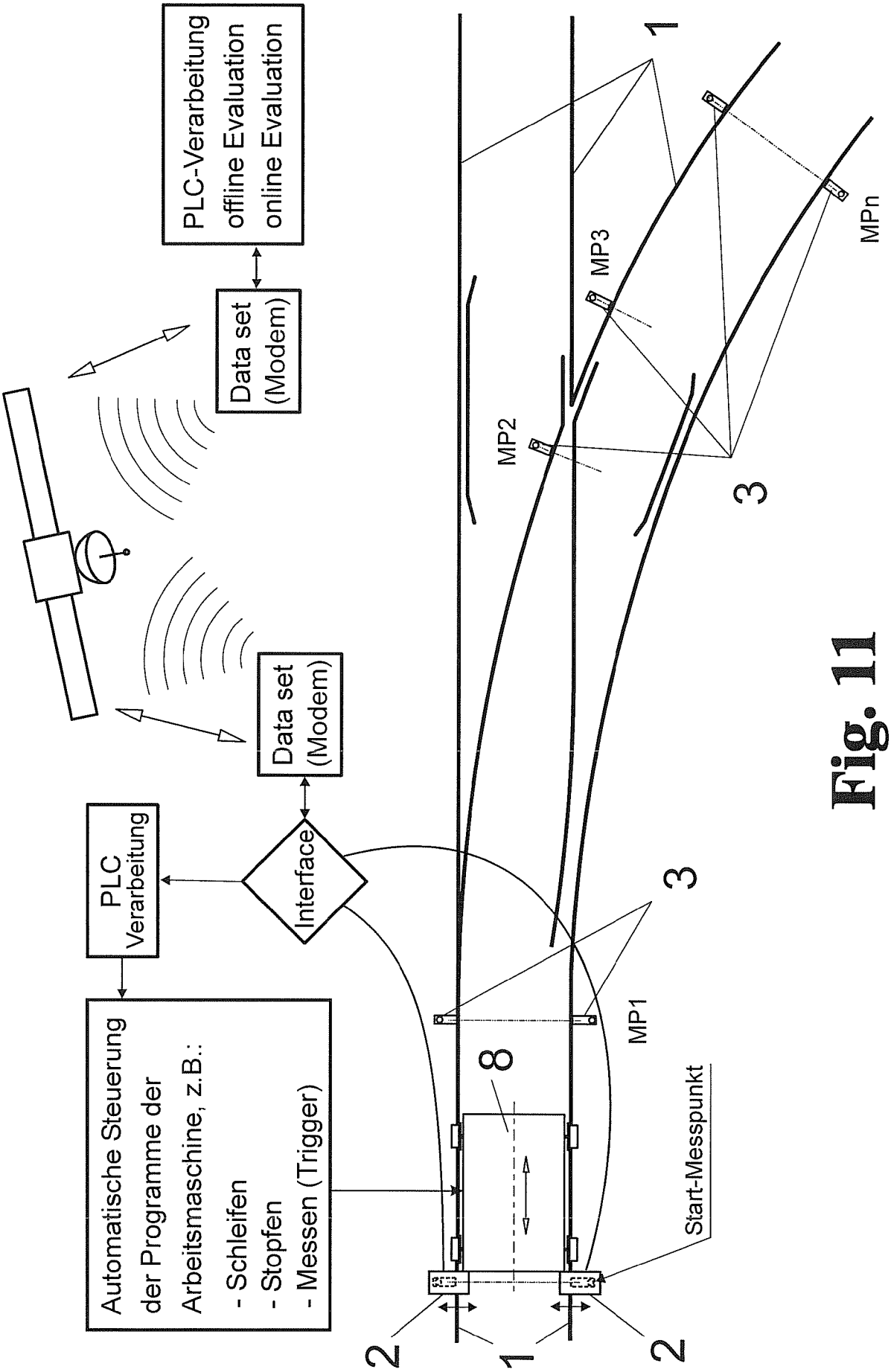

PLC-Verarbeitung
offline Evaluation
online Evaluation
Data set
(Modem)
Data set
(Modem)
PLC
Verarbeitung
Interface
Automatische Steuerung
der Programme der
Arbeitsmaschine, z.B.:
- Schleifen
- Stopfen
- Messen (Trigger)
MP1
MP2
MP3
MPn
Start-Messpunkt
1
2
3
8

Fig. 11