FIG. 1

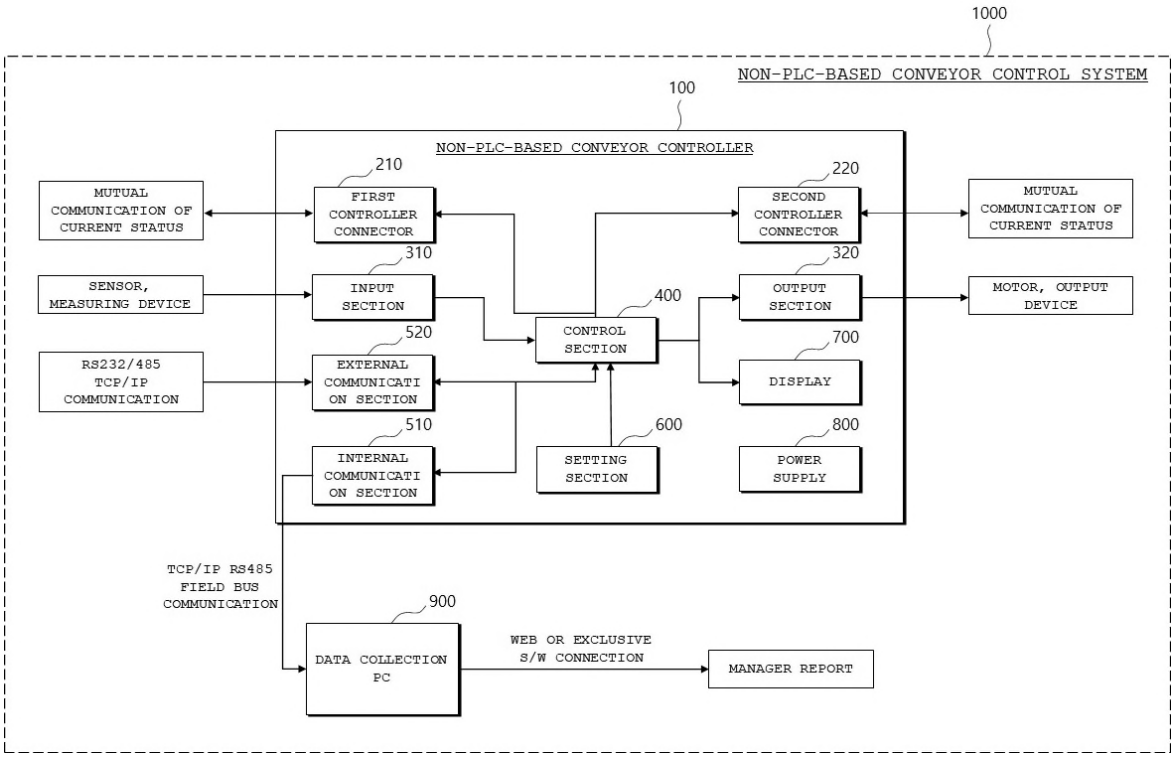

1000
NON-PLC-BASED CONVEYOR CONTROL SYSTEM
100
NON-PLC-BASED CONVEYOR CONTROLLER
210
FIRST CONTROLLER CONNECTOR
220
SECOND CONTROLLER CONNECTOR
MUTUAL COMMUNICATION OF CURRENT STATUS
MUTUAL COMMUNICATION OF CURRENT STATUS
310
INPUT SECTION
320
OUTPUT SECTION
SENSOR, MEASURING DEVICE
MOTOR, OUTPUT DEVICE
400
CONTROL SECTION
520
EXTERNAL COMMUNICATION SECTION
700
DISPLAY
RS232/485 TCP/IP COMMUNICATION
510
INTERNAL COMMUNICATION SECTION
600
SETTING SECTION
800
POWER SUPPLY
TCP/IP RS485 FIELD BUS COMMUNICATION
900
DATA COLLECTION PC
WEB OR EXCLUSIVE S/W CONNECTION
MANAGER REPORT

FIG. 2

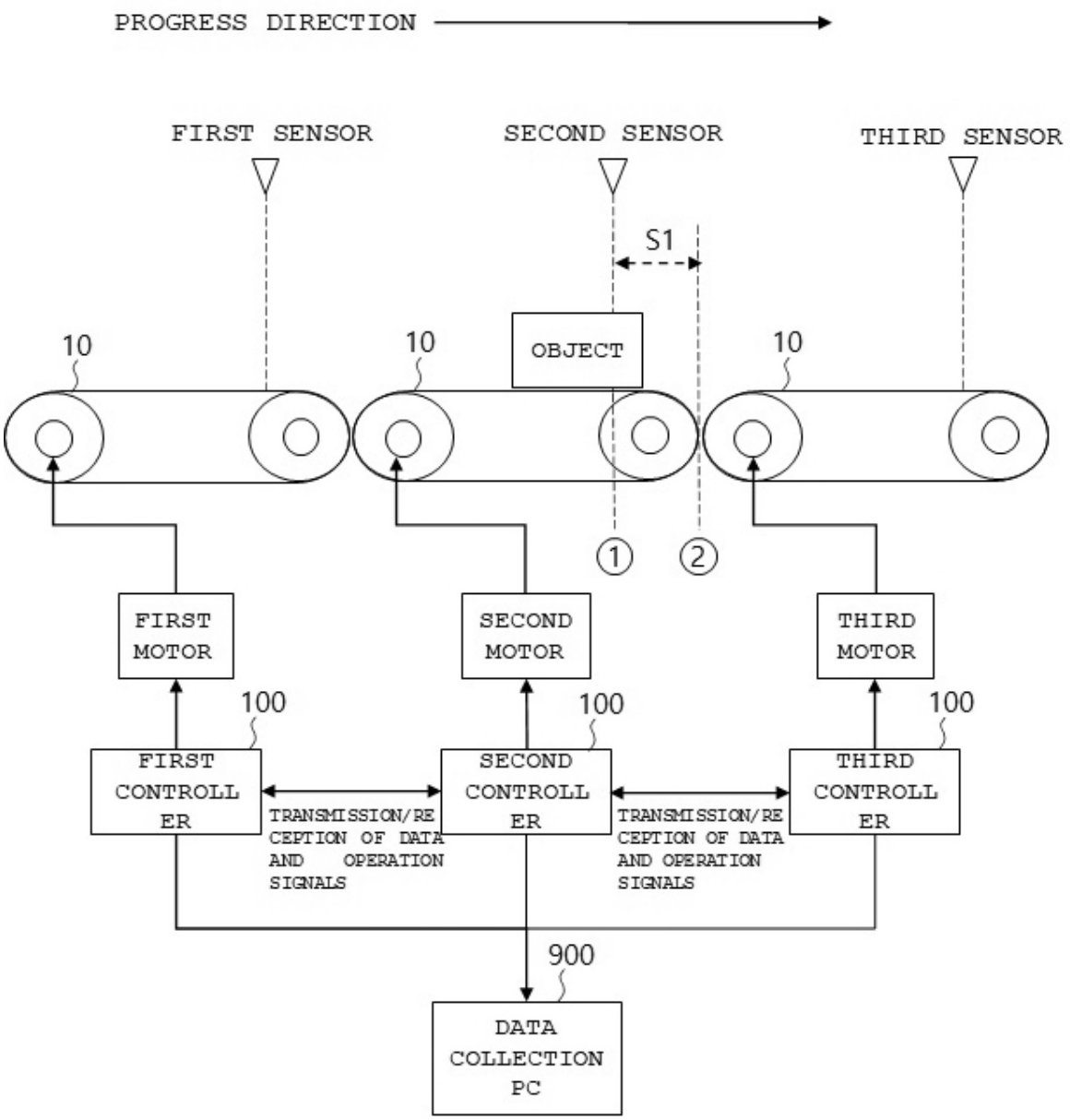

PROGRESS DIRECTION
FIRST SENSOR
SECOND SENSOR
THIRD SENSOR
S1
10
10
OBJECT
10
①
②
FIRST MOTOR
SECOND MOTOR
THIRD MOTOR
100
100
100
FIRST CONTROLLER
SECOND CONTROLLER
THIRD CONTROLLER
TRANSMISSION/RECEPTION OF DATA AND OPERATION SIGNALS
TRANSMISSION/RECEPTION OF DATA AND OPERATION SIGNALS
900
DATA COLLECTION PC

FIG. 3

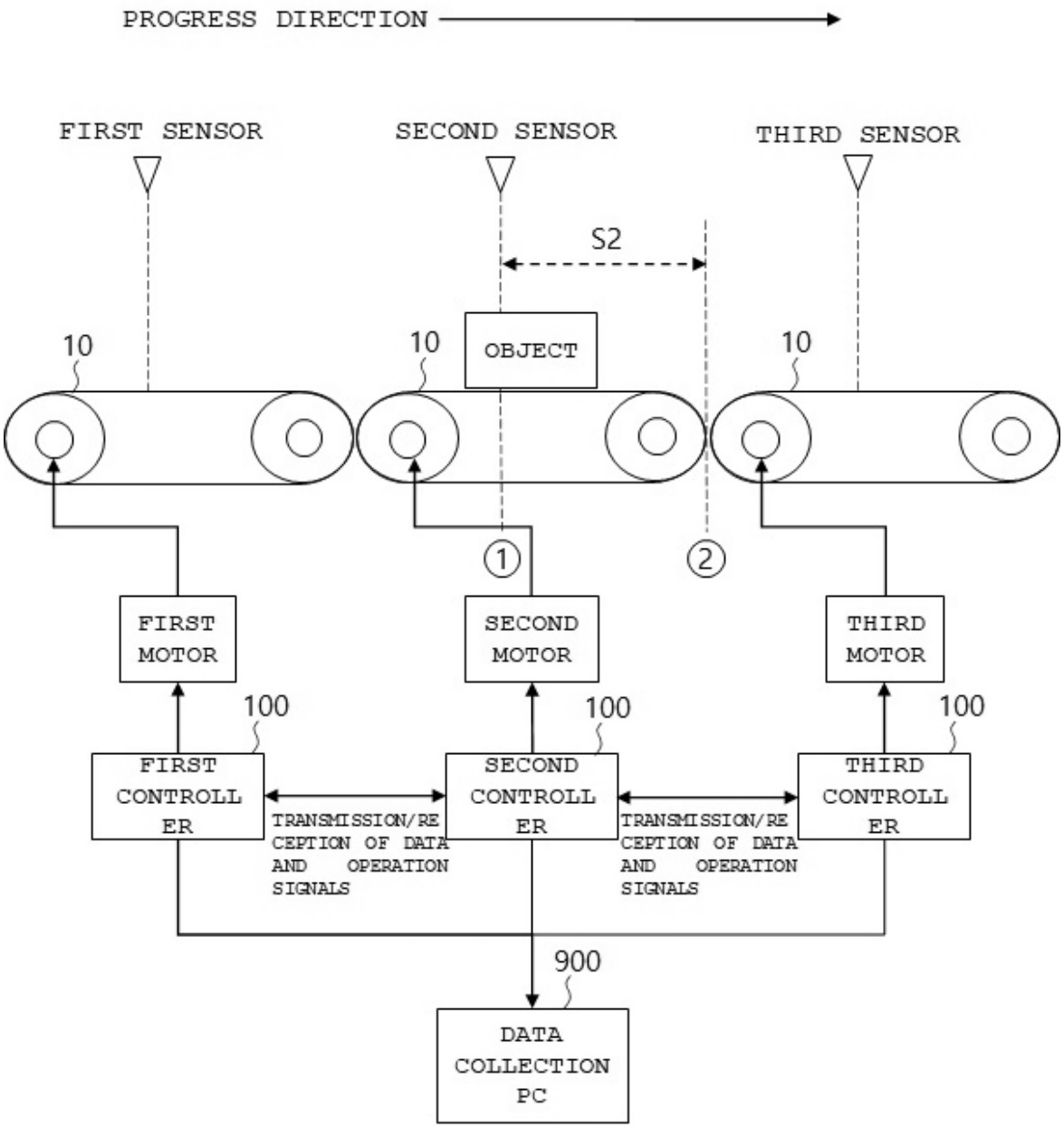

PROGRESS DIRECTION
FIRST SENSOR
SECOND SENSOR
THIRD SENSOR
S2
10
10
OBJECT
10
①
②
FIRST MOTOR
SECOND MOTOR
THIRD MOTOR
100
100
100
FIRST CONTROLLER
SECOND CONTROLLER
THIRD CONTROLLER
TRANSMISSION/RECEPTION OF DATA AND OPERATION SIGNALS
TRANSMISSION/RECEPTION OF DATA AND OPERATION SIGNALS
900
DATA COLLECTION PC

FIG. 4

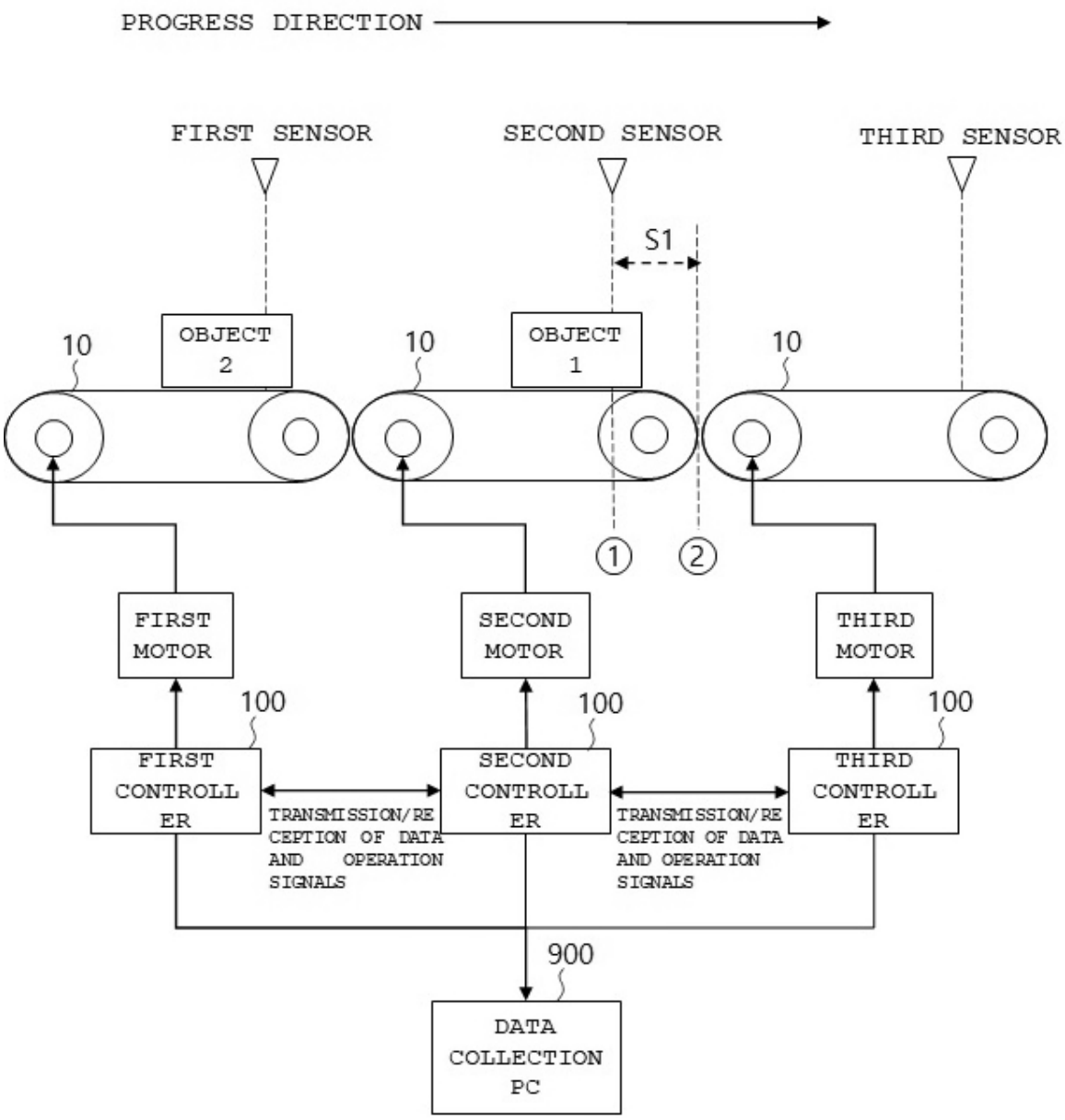
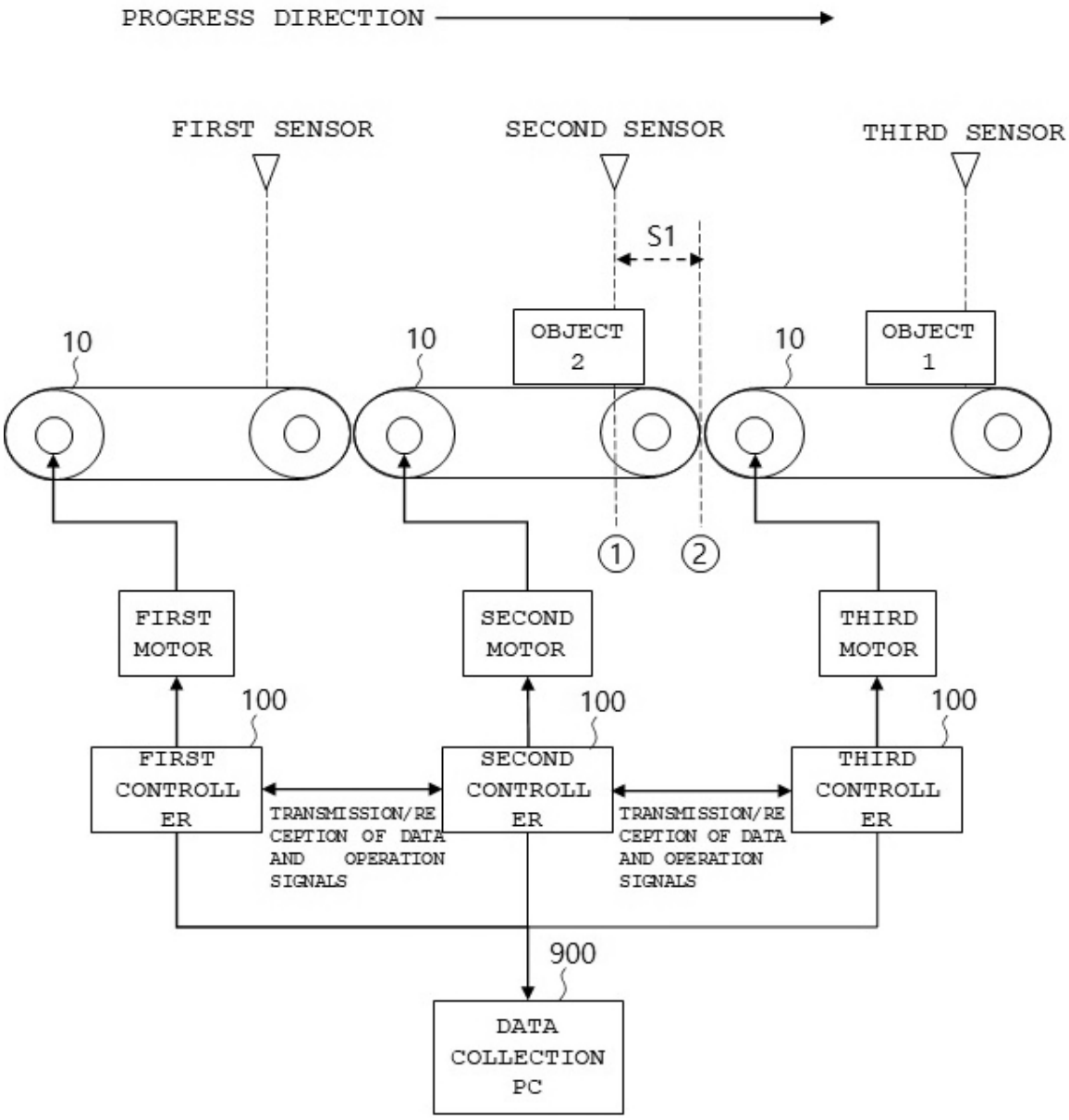

PROGRESS DIRECTION
FIRST SENSOR
SECOND SENSOR
THIRD SENSOR
S1
10
OBJECT 2
10
OBJECT 1
10
①
②
FIRST MOTOR
SECOND MOTOR
THIRD MOTOR
100
100
100
FIRST CONTROLLER
SECOND CONTROLLER
THIRD CONTROLLER
TRANSMISSION/RECEPTION OF DATA AND OPERATION SIGNALS
TRANSMISSION/RECEPTION OF DATA AND OPERATION SIGNALS
900
DATA COLLECTION PC

FIG. 5


PROGRESS DIRECTION
FIRST SENSOR
SECOND SENSOR
THIRD SENSOR
S1
10
10
10
OBJECT 2
OBJECT 1
①
②
FIRST MOTOR
SECOND MOTOR
THIRD MOTOR
100
100
100
FIRST CONTROLLER
SECOND CONTROLLER
THIRD CONTROLLER
TRANSMISSION/RECEPTION OF DATA AND OPERATION SIGNALS
TRANSMISSION/RECEPTION OF DATA AND OPERATION SIGNALS
900
DATA COLLECTION PC