

Comprehensive robotics palletizing software suite



PalletSolver[®]

Revolutionary robotics palletizing software suite for Motoman[®] robots.

This feature-rich software is designed for homogeneous palletizing with two primary objectives:

• Enable fast development and integration of robotic palletizing system through easy-to-use configuration, setup and customization routines

• Facilitate system uptime without compromising production throughput through intuitive operator-friendly interface

TWO **COMPONENTS**

PalletSolver-PC

An offline pattern generation tool that resides on a PC or laptop.

PalletSolver-Engine

Resides on the robot controller (DX-series) or Rockwell PLC (MLX200 unified controls). Consists of robot libraries and I/O map to enable optimized pattern execution.

QUICK CHANGEOVERS

PalletSolver facilitates quick changeover of patterns or products without halting production for validation.

Offline pattern generation tool designs the build sequence taking physical constraints into account for a specific cell.

Pattern files are stored in XML format and execution of build occurs on demand through operator interface.

PALLETSOLVER-PC

- Allows offline generation of pallet patterns.
- Build sequence for each pattern is optimized based on established constraints to ensure maximum production rate for each workcell.
- Patterns stored on a network can be accessed directly by the robot controller. Patterns stored on a local PC can be transferred to the robot controller with a compact flash card or USB storage device.



- Intuitive graphical interface for configuring cell parameters; step-by-step process to generate pallet patterns.
- Directly imports pallet patterns generated by widely used TOPS® or CAPE Software.
- Accommodates virtually unlimited SKUs (Stock Keeping Units).
- Scalable architecture easily handles single and complex multi-line palletizing, as well as single and multiple workcells.
- Dynamic gripper zone management allows handling of various case sizes.

PC Screens

3D Pallet Pattern View



Constraints Handling for Gripper



Setup Screens MLX200 PalletSol uild # Enal Buik oduct ame IletSolver Control

er Setup		Abort	Abort		
	Disable Build #2	Disab Build	le #3	Enable Build #4	
	Enabled	Enabl		Disabled	
im	Box Sim	Box	Sim	Box - Sim	
	1111	111	1	1111	
B1	5 Box -82	5 Box	-83	5 Box -B4	
	222	333			
	Build Stations	Infeed Stations	Dispenser Stations	Reject Drop Station	
ownload	User Frames	Gripper	System Settings	Speed Adjustments	

PALLETSOLVER-ENGINE

- Modular, flexible design allows customization of each palletizing system.
- Runs directly on a DX-series controller or when used with the MLX200 as part of the customizable PLC ladder.
- Build sequence from pattern files generated offline is synthesized and coordinated with online robot motion and I/O.
- Communicates with PLC or other supervisory control for operational execution, including:
- Prioritizing infeed devices
- Changing pattern files
- Handling end of production on partially built pallets
- Continuing build on partial pallets
- Optimizes build process, robot path, production speed and motion parameters specific to physical characteristics of each SKU.

DURING OPERATION

- To switch the pattern file during production, an operator simply selects a new file (using product and line information) to command the robot to execute the selected pattern.
- During execution, data (including errors) related to build station status, is relayed to the pendant or to a customized operator interface.

PALLETSOLVER	DX-SERIES	MLX200
Maximum System Configuration		
Infeed	8	4*
Build stations	8	4*
Pallet dispensing stations	2	2
Slip sheet/tier sheet dispensing stations	2	2
Dynamic robot path adjustment (ensures optimum production rate)	\checkmark	\checkmark
Pre-mapped I/O to communicate with PLC/supervisory control (status and monitoring)	\checkmark	\checkmark
PLC - Robot Messaging interface (operations control)	\checkmark	N/A
Intuitive guided setup and configuration using robot pendant HMI	\checkmark	\checkmark
PLC-less operation (robot controller is only controller in system)	\checkmark	N/A
Network-enabled (import pattern files generated by PalletSolver-PC)	\checkmark	\checkmark
Granular control of palletizing operations	\checkmark	\checkmark
Controlling infeed pick sequence (round robin, priority, relative ration, PLC-controlled)	\checkmark	\checkmark
Automatic part rejection	\checkmark	\checkmark
Conveyor/pallet lock-out (for maintenance or failures)	\checkmark	\checkmark
End of production handling	\checkmark	\checkmark
Adjust pick/place depth (package changes due to environmental conditions)	\checkmark	\checkmark
Integrated Customization Library (unique gripper handling, error handling, pick/place handling)	\checkmark	\checkmark

*Configuration expandable to 8 in x 8 out. Default configuration shown to support 3 MB PLC memory.

			monit
DX-Se	ries		MLX20
hzard User Fr	ame - Page 2 of 4		At Home
BuildPallet_6 Station ID = 6	5		Palletizing
Station Up	er Frame #	and the second sec	Reset Build
			Lock Build
X (mm) 665			Force Comple
Y(mm) Z(mm)	665.66		Purge Infeed
	Undate		Adjustments
	- Abrana		Dispenser #1
		<back next=""> Cancel</back>	Menu

Monitoring and Control Screens



MINIMUM REQUIREMENTS

OFFLINE

Microsoft[®] Windows[®] XP Service Pack 2.0 or Windows 7

Microsoft .NET Framework 3.5

400 MHz processor, recommended 1 GHz

128 MB RAM, recommended 1 GB

30 MB hard disk space

1280 x 1024 screen resolution

DX-SERIES

Controller software with MotoPlus[™] support

64 MB programming pendant

256 MB industrial grade compact flash card or USB flash drive

MLX200

1769 CompactLogix[™] controller with built-in ethernet - OR -1756 ControlLogix®/GuardLogix® safety controller, 1756-ENBT ethernet module

3 MB memory on PLC

RSLogix[™]/Studio 5000[™] Designer

FactoryTalk® View ME Station version 6.1: 75 display activation

COMPATIBLE WITH





DX-Series

olver . D	Build Pati	tern		Associated		
Product ID:	555	Assigned		Stations		
Pattern ID:	5		Unassign	Infeed 1		
	Current E	luild				
Layer:	2/6 0	omplete E	kuild Clear	Pallet 1		
Package:	3 / 10	Fo	rce Complete			
	Station Lock		Clear Layer			
Locked	Lock Loc	k After Done	Requested	Sheet 1		
These Description	Place Error					
Place Error	Ignore	Abort	Layer Ch'd			
	Product ID: Pattern ID: Layer: Package: Lacked Place Error	Date Pattern ID: Product ID: Pattern ID: Layer: 2 / 6 Package: 3 Lock Lock Lock Lock Place Error Ignore	Bald Pattern Product ID: Station Pattern ID: Complete Patkage: 2 / 6 Package: 3 / 10 Fackage: 10 Fackage: 10 Package: A 10 Package: A 10 Package: A 10	Build Nattern Product ID: 0055 Assigned Pattern ID: 5 Current Build Current Build Layer: 2 / 6 Package: 3 / 10 Station Lock Lock Lock After Done Place Error Place Error Ignore Abort		



Yaskawa America, Inc. Motoman Robotics Division 100 Automation Way Miamisburg, OH 45342 Tel: 937.847.6200

motoman.com



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