



**UNIVERSITI PUTRA MALAYSIA**

**DEVELOPMENT OF A COMPUTER-CONTROLLED  
AUTOMATED STORAGE AND RETRIEVAL SYSTEM**

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**DEVELOPMENT OF A COMPUTER-CONTROLLED  
AUTOMATED STORAGE AND RETRIEVAL SYSTEM**

**By**

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**Chairman: Professor Ir. Norman Mariun, PhD**

**Faculty: Engineering**

Industrial demands for higher productivity require the replacement of the traditional control equipment with newer solutions that take advantage of the latest technologies. Programmable Logic Controllers (PLCs) based system has been the main choice for control equipments for the last decades. With the rapid advancement of computing technologies, the importance of PC-based system increased remarkably in the last few years. Retrofitting the PLC based system with the PC-based system offers many advantages. Among these advantages are PC-based systems are more flexible, easy integration, lower costs, better human machine interface (HMI) facilities. The implementation of a PC based motion control on a three-axis ASRS system is the main focus of this work. The scope of the work covers the implementation of two hardware platforms for the proposed system and to implement PID system on the two platforms. The development of

GUI for the ASRS system provides the users with a comprehensive and user friendly interface to control the system. The performances of two types of hardware platforms; PCI 7344 motion controller card and (FP) 2000 Field point is compared based on trapezoidal motion profile. Both platforms are controlled by a proportional-integral-derivative (PID) controller. The parameters for the controller are determined experimentally. The experimental results show that both platforms successfully tracked the motion profile, and the tracking performance improves as the velocity of the system increase. Overall this work shows that PC-based system offers many advantageous to control and ASRS system.



Abstrak tesis yang dikemukakan kepada Senat Universiti Putra Malaysia sebagai memenuhi keperluan ijazah Sarjana Sains

**PEMBANGUNAN KAWALAN GERAKAN SISTEM ASRS  
BERASASKAN KAWALAN KOMPUTER**

Oleh

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Keperluan untuk meningkatkan produktiviti disektor industri memerlukan suatu sistem kawalan berdasarkan teknologi terkini bagi menggantikan sistem kawalan tradisional. Sistem kawalan berasaskan PLC merupakan pilihan utama industri sejak beberapa dekad lalu. Kepentingan sistem kawalan berasaskan komputer peribadi meningkat dengan mendadak kebelakangan ini sejajar dengan perkembangan teknologi komputer berbanding dengan PLC, sistem kawalan berasaskan komputer mempunyai beberapa kelebihan seperti sistem yang lebih fleksibel, kos yang lebih rendah, tiada kekangan hakmilik dan penghubungan sistem antaramuka manusia dan mesin yang lebih baik. Implementasi kawalan berasaskan komputer peribadi terhadap sistem berautomasi tiga-axis ASRS menjadi fokus kajian ini. Pembangunan GUI di dalam kajian ini memberikan kemudahan komprehensif kepada pengguna untuk mengawal sistem tersebut.



Prestasi bagi sistem kawalan berasaskan komputer berdasarkan PCI 7344 dan dasar FP 2000 telah diimplementasikan dalam kajian ini dengan kawalan PID. Parameter PID telah dikenalpasti melalui kajian. Kajian menunjukkan kedua-dua dasar tersebut telah memberikan respon yang baik terhadap profil trepezoid. Secara keseluruhan, sistem berasaskan komputer menawarkan banyak kebaikan terhadap kawalan pergerakan sistem ASRS.

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## LIST OF ABBREVIATIONS

AC	Alternating Current
ADRC	Active Disturbance Rejection Controller
ASRS	Automated Storage and Retrieval System
DC	Direct Current
DSP	Digital Signal Processing
ELCB	Earth Leakage Circuit
FMS	Flexible Manufacturing System
FP	Fieldpoint
GPOS	General Purpose Operating System
GUI	Graphical User Interface
I/O	Input Output
MAX	Measurement and Automation Explorer
MCB	Miniature Circuit Breaker
Mm	Millimeter
NI	National Instrument
OS	Operating System
PC	Personal Computer
PCI	Peripheral Connections Interface
PI	Proportional-Integral
PID	Proportional-Integral-Derivative
PLC	Programmable Logic Controller
PRBS	Pseudo-Random Binary Sequence
QUAD	Quadrature
RAM	Random Access Memory
RPM	Revolution per minute
Rps	Revolution per second
RTOS	Real-time operating systems
SID	System Identification
SR	Storage Retrieval



UMI

Universal Machine Interface



## LIST OF SYMBOLS

$Acc$	Acceleration
$A$	Acceleration
$Dec$	Deceleration
$D$	Deceleration
$e_m$	Position error
$E$	Profile
$F_A$	Axial Load
$F_R$	Radial load in Newton
$H(s)$	Transfer function of a system
$I$	Rated current
$I_0$	Continuous output current
$I_{max}$	Maximum output current
$J_1$	Inertia of pulley 1
$J_2$	Inertia of pulley 2
$J_m$	Rotor inertia
$k_c$	Proportional gain
$k_u$	Critical gain with P controller only
$K_a$	Amplifier gain
$K_d$	Derivative gain of the PID controller
$K_f$	Feedback gain
$K_i$	Integration gain of the PID controller
$K_p$	Proportional gain of the PID controller
$K_s$	Laplace transform of a transfer function
$M$	Weight
$M_c$	Mass of the box
$n$	Rated speed
$P$	Power capacity





$P_0$	Rated output
$P_S$	Rated power rate
$R$	Radius
$R$	Reference
$S$	Position
$S_{acc}$	Distance of acceleration
$S_{dec}$	Distance of deceleration
$S_{\max speed}$	Position at maximum speed
$t_1$	Acceleration time
$t_2$	deceleration time
$t_u$	Oscillation period with P controller only
$T$	Rated torque
$T_d$	Derivative time
$T_i$	Integral time
$T_g$	Motor torque
$T_r$	Rise time
$T_s$	Settling time
$u_c$	Control loop input
$V$	Voltage
$y$	Process output
$y_f$	Final output
$y_r$	Process command signal
$\alpha$	Motor acceleration rate
$\Theta$	Motor position
$\tau_m$	Motor torque

# CHAPTER 1

## INTRODUCTION

### 1.1 Introduction

Personal computers (PCs) are widely used nowadays in automation systems. The achievement of such an interesting feature has been made possible due to the rapid growth of the computing technology, the availability of real-time operating systems and the development of programming languages suitable for control tasks [1]. PC-based system has been put forward in the automation in 1990's when programmable logic controller (PLC) based control which was an excellent tool in 1970's and 1980's was not designed for the commercial requirements [2] nor could it take the full advantage of the substantial electronics and software changes.

PC-based system offers several advantages over PLC-based system. They are easier to program and offer more flexibility and better performance [2-4]. With PC-based system, applications can be customized to meet current and future requirements, eliminating the needs to reinvest in a new system.

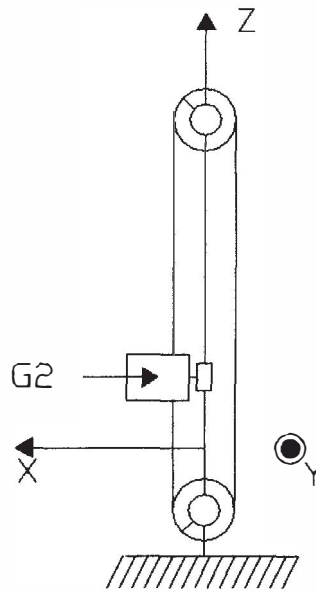
Motion control is defined as the precise control of anything that moves, and it is very essential in many industrial applications for its position and speed accuracy. It is usually designed to track trajectories and/or regulate about a desired point. Automation systems [5] include those that must integrate motion control to

manipulate or move parts in production such as bar code reader for tracking and identifying components, visual inspection for quality assurance, etc [2]. Servomotor is the essential component of the motion control system, converting the electrical power from the servo drive into the mechanical power that moves the machine [6]. AC servomotor is most preferred in motion control over DC servomotor due to its brushless structure and no maintenance capability [1].

## 1.2 Background

Automated storage and retrieval system (ASRS), a three-axis system, is a major material handling support systems which has been an integral part of flexible manufacturing system (FMS) that have been widely used in automated factories and distribution centers. ASRS offers effective utilization of factory space, increase in productivity and reduce labor costs. It is based on a servo motion system. The performance of an ASRS can be measured by its positioning precision to track the motion profile and its throughput capacity which includes both SR machine travel time the time required to pickup or deposit a load and other times associated with SR machine operation.

Figure 1.1 shows all three-axes of the ASRS system used in this work. The traveling distance of *x-axis* is 1900 mm, *y-axis* is 560 mm, and *z-axis* is 1250 mm.



**Figure 1.1: Three-Axis ASRS**

### 1.3 Problem Statement

ASRS main purpose is to automatically depositing and retrieving loads from defined storage locations. Repeatable and accurate position of the loading box is critical as it affects the manufacturing process. The system should achieve high performance in terms of forcing the motion variable (position) to track the desired trajectory quickly and accurately. A system that could be maintained and easily updated based on modern control PC technology need to be developed.

## **1.4 Objectives of the Work**

The main objective of this work is to implement a PC-based motion control on ASRS system. In order to achieve the objective, the following works were carried out.

1. Implement two types of hardware platform of the proposed system;
  - a. PC-based system with National Instrument Motion card (PCI 7344)
  - b. PC-based system with National Instrument Field point (FP 2000)
2. Implement a proportional-integral-derivative (PID) controller on both types of hardware platform onto the proposed system.

The second objective of the work is to evaluate the performance of the PC-based motion system based on trajectory motion profile.

## **1.5 Scope and Limitation**

The development of the controller used in this work is applicable for a single stacker system with five rows and seven columns storage unit ASRS; the controller hardware and software used were National Instrument products since the product are robust and industrial standard.

## 1.6 Thesis Layout

This thesis consists of five chapters. The description of each chapter of this thesis is as follows.

- Chapter 1 presents the background of the work. It explains the introduction and the objectives of the work.
- Chapter 2 introduces the various basic concepts and reviews related to PC-based system, motion control, and the latest trends in motion control.
- Chapter 3 explains the construction and implementation of the proposed hardware. It starts with the implementation of two types of hardware platform follow by performance comparisons of the proposed system based on trajectory motion profiles.
- Chapter 4 discusses the results obtained from the work.
- Chapter 5 presents the conclusions and suggestions for further improvement of the proposed system.