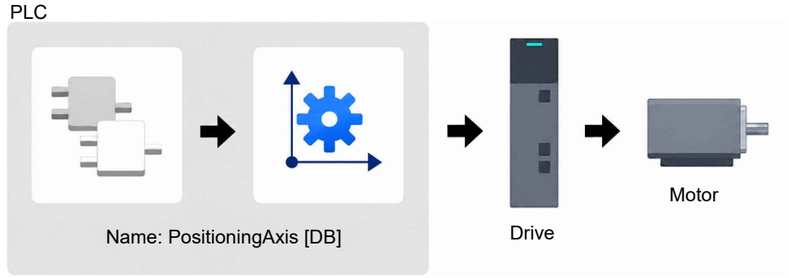
Test Project for the 48th WorldSkills Competition in Shanghai, China 2026
Copyright ©2026 WorldSkills International
All Rights Reserved

Skill: Skill 19 Industrial Control				
Design by: Rodolfo Neves, SCM				
Last Update: 21.08.2026	Scale: N/A	Paper: A4	Page: 01 of 03	
File Name: WSC2026_TP19_MB_flowchart_01_en				Rev: V1
Description: Module B – Operating flowchart				Projection:
Extra Info 1		Extra Info 2		

Power

P1

PLC

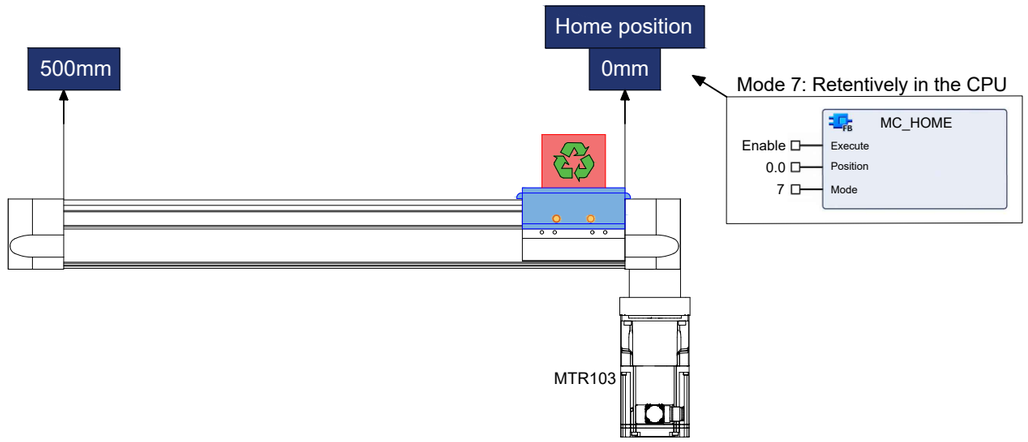


MTR103_real_position := "PositionAxis".ActualPosition
MTR103_real_velocity := "PositionAxis".ActualVelocity
MTR103_real_acceleration := "PositionAxis".ActualAcceleration
MTR103_real_torque := "PositionAxis".StatusTorqueData.ActualTorque

MC_TORQUELIMITING
True — Enable
50.0 — Limit

MC_POWER
Enable_MTR103 — Enable

MC_MOVEJOG
MTR103_forward — JogForward
MTR103_reverse — JogBackward
25.0 — Velocity



Mode 7: Retentively in the CPU

MC_HOME
Enable — Execute
0.0 — Position
7 — Mode

P1

P2

LSitop_PseDiag
Status_out — impulse

worldskills Shanghai2026

Test Project for the 48th WorldSkills Competition in Shanghai, China 2026
Copyright ©2026 WorldSkills International
All Rights Reserved

Skill: Skill 19 Industrial Control				
Design by: Rodolfo Neves, SCM				
Last Update: 21.08.2026	Scale: N/A	Paper: A4	Page: 02 of 03	
File Name: WSC2026_TP19_MB_flowchart_01_en				Rev: V1
Description: Servo Drive and SITOP				Projection:
Extra Info 1		Extra Info 2		

P2

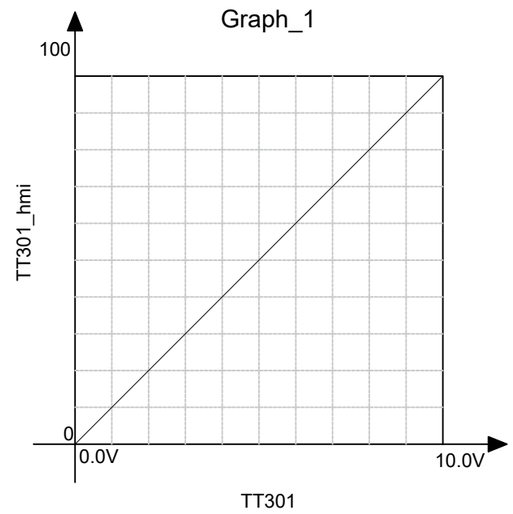
scale (Graph_1)
TT301 to TT301_hmi

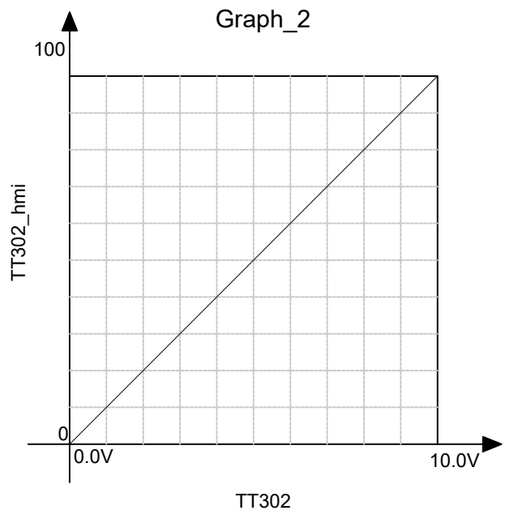
scale (Graph_2)
TT302 to TT302_hmi

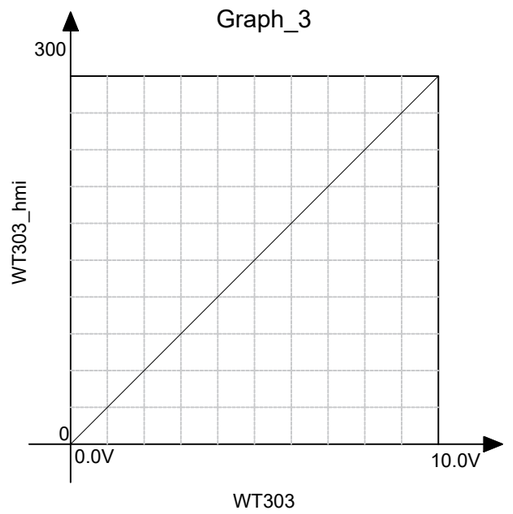
scale (Graph_3)
WT303 to WT303_hmi

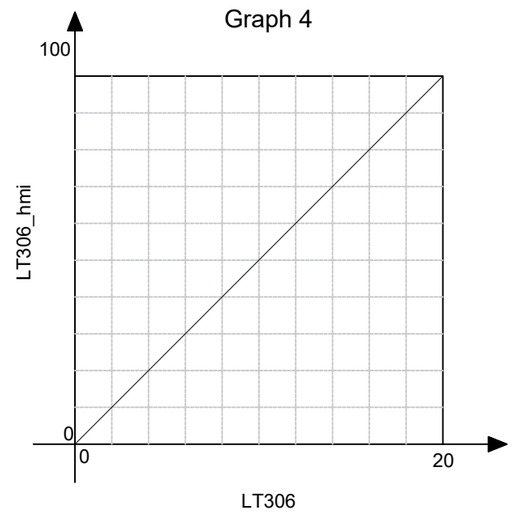
P3

scale (Graph_4)
LT306 to LT306_hmi





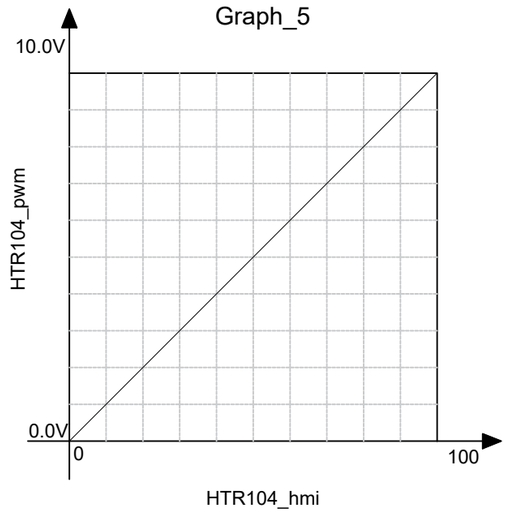




Part B

P3

scale (Graph_5)
HTR104_hmi to HTR104_pwm



worldskills Shanghai2026

Test Project for the 48th WorldSkills Competition in Shanghai, China 2026
Copyright ©2026 WorldSkills International
All Rights Reserved

Skill: Skill 19 Industrial Control			
Design by: Rodolfo Neves, SCM			
Last Update: 21.08.2026	Scale: N/A	Paper: A4	Page: 03 of 03
File Name: WSC2026_TP19_MB_flowchart_01_en			Rev: V1
Description: Scales			Projection:
Extra Info 1	Extra Info 2		