



## ANALYSIS OF AUTOMATED PLANNING APPLIED TO AN ASSEMBLY AND DISASSEMBLY ROBOT SYSTEM

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**Abstract.** *Despite the fact of high costs of operations and the lack of skilled labor, production processes require robots to improve efficiency in assembly and disassembly lines. Historically the robot programming is based on a set of predefined sequential actions. In this case, devices and sensors are connected to the robot controller and the programming of the robot activities is held directly by its internal software. This type of programming is usually fixed and has a little or no flexibility in handling concern, requiring reprogramming of equipment for programming new trajectories. On the other hand, several studies have been showing artificial intelligence techniques like neural nets, genetic algorithms, automated planning as enhancement proposals for practical systems. Specifically automated planners emerged in 1971 with the STRIPS or “Stanford Research Institute Problem Solver”, the first automatic solver problems. The development of the automated planners created a standard formal language called PDDL or “Planning Domain Definition Language”. In 2008, itSIMPLE was developed as a knowledge engineering tool used for modeling planning domains to several automatic planners, in order to develop a plan that meets the requirements of the project. This paper proposes the integration of automated planners with robots control systems through itSIMPLE for assembly and disassembly processes. Such integration is done using a device made especially for this project, which is responsible for translating the information received from sensors into states, which will be used by automatic planners. The plan generated is converted into a list of instructions (jobs) that is sent to the robot. Finally, a comparison will be made with the traditional method of programming and robot's training.*

**Keywords:** *Assembly and Disassembly System of Products, Automation Applied, Automated Planning, itSIMPLE, Industrial Robot.*

### 1. INTRODUCTION

In the sixteenth century, manufacturing systems were handmade, made in small shops, and the products were relatively simple compared to today's standard. Over time, emergence mass production and factories were created, with many workers in one place. With that the craft work techniques gave space to the production lines. The products become more complex, as well as production. Workers needed to specialize in tasks instead of overseeing the entire process. More accurate planning and better coordination was needed so that it could monitor the working processes. The production process, which needs to improve constantly its efficiency, required the use of automation such as robotics.

A robot is a device or group of devices, electromechanical or biomechanical able to perform work autonomously or pre-programmed. Robots are commonly used in performing tasks in poorly lit places or performing tasks in dirty or dangerous environment. Industrial robots used in the production lines are the most common form of robots, other applications are: treatment of toxic waste, underwater and space exploration, surgery, mining, search and rescue, and locating landmines. Robots also appear in the areas of entertainment and chores. Currently the robot programming is based on a set of pre-defined sequential actions. This type of programming is usually fixed and has little or no concern that flexibility, and different or new movements requires reprogramming. This method generates high costs with hand labor, loss in production fault of stops for reprogramming and training of the robot and therefore more complex changes in programming and software maintenance. On the other hand, several studies have demonstrated artificial intelligence techniques such as neural networks, genetic algorithms, and automatic planning and improvement proposals for practical systems (Fonseca *et al.*, 2012).

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Almost 40 years ago began the developing of automated planning systems, but their implementation is still restricted and often is a challenge this is due to the fact that real applications languages differs significantly from automatic planning ones (Vaquero, 2007). Since 1971, with the emergence of the STRIPS (Stanford Research Institute Problem Solver) (Fikes and Nilsson, 1971), based on logical systems are created to solve problems automatically. The concept of these systems is the existence of a real system model describing the actions and rules for each object that composes a set of inputs (baseline) and a desired state (final state). This model makes use of search algorithms applied with the model rules to find a path that starts from the set of inputs and achieve the desired state.

While the automatic planning presents a plan for a specific case in a restrict language called PDDL (Planning Domain Definition Language) (Fox and Long, 2003), the real systems uses equipments like PLC or Programmable Logic Controller with Ladder language, usually and centralize operations sensing and drives. In 2008, itSIMPLE software was developed as a knowledge engineering tool used for modeling planning domains for several automatic planners, in order to assist automated planner usage.

The current status of the industry makes attractive the possibility of using artificial intelligence methods to solve their problems. On the other hand, it is fact that the solutions approach to automatic planning is rarely used in real systems, specially with robots. The reason of this gap is the existence of a wide abyss between these developments, making it difficult for new technologies and approaches as automatic planners to be conveniently integrated in real systems. This paper presents the integration of automated planners in assembly and disassembly robot system through itSIMPLE. Firstly, it will be presented a brief literature overview followed by the programming robot state of the art and the definition of planning field. After that, it will be shown the traditional programming method for this system and its modeling in itSIMPLE. Finally, the evaluation of traditional and automated planning programming, the scenarios and the generated plans will be presented.

## **2. LITERATURE OVERVIEW**

### **2.1- Industrial Robots**

It is known that the production systems use both mechanized and automated devices to perform several tasks in a manufacturing cell. Furthermore the advancement of production automation in the last years is directly linked with the advances in robotics (Groover, 2011 ).

The word “robot” comes from the Czech *robot*, which means “forced labor”. The image of the robot present in our mind originates in a part of the Czech playwright Karel Capek, in which there was an automaton with human form, able to do everything that a man could do. According to the official definition of the Robotics Industries Association (RIA), an industrial robot is a reprogrammable manipulator, multifunctional, designed to move material, parts, tools or special devices in variable movements programmed to perform several tasks. Its feedback connections, between its sensors, actuators and environment eliminate the necessity of human action to perform certain tasks, although there are robots partially controlled by humans. The automation level of a robot can reach the automatic learning level, depending on the capacity of the computational algorithms to simulate the reality.

An industrial robot is a programmable machine of generic application with some anthropomorphic characteristics: the main is a mechanical arm used to perform several industrial tasks such as: pick up, put down and move parts; the other human characteristics are the ability to respond to sensory stimuli, communicate with other machines and make decisions. These abilities allow a lot of useful tasks to be performed by robots among which one can mention: spot welding, material transfer, loading machines, spray painting, assembly and disassembly of products, among other. The Figure 1 presents a production system operated by robots.



Figure 1. Production System (Reuters 2013)

## 2.2- Robots programming

In order to perform a useful activity, a robot must be programmed to execute its movement cycle. A robot program can be defined as a route to be followed by the manipulator, combined with peripheral actions that support the work cycle. Examples of peripheral action include: open and close the gripper, make logic decision, communicate with other devices.

For robots with limited sequence, the programming considers limit switches and mechanical stopping for control the end points of the movement. The sequence of movement is regulated by a sequencer device, this device determine the order in which each joint is actuated to form the complete movement cycle.

Nowadays, almost all industrial robots have digital computers as controllers. For these robots, three programming methods can be distinguished (Groover; 2011): lead-through programming, programming language for robots similar to computers and off-line programming.

**Lead-through programming** – the lead-through programming dates from early 1960s when the computer control was not prevalent. In the lead-through programming the task is taught to the robot moving the manipulator through the required movement cycle and simultaneously inserting the program in the controller memory for subsequent execution.

**Programming language for robots** – the use of textual programming language has become a suitable programming method from the point where digital computers assumed control function in robotics. Its use has been stimulated by the increasing complexity of the tasks that robots perform, with the concomitant need to embed logical decisions in the work cycle of the robot.

**Simulation and off-line programming** – the trouble with lead-through methods and textual programming techniques is to remove the robot from the production line to make the programming. The off-line programming allows to prepare the robot program on a remote computer terminal, so that the program could be downloaded without stopping the production. In real off-line programming, there is no need to physically locate the positions in the workspace for the robot as required by textual programming languages. Some graphical simulation is required to validate the programs off-line developed, similar to off-line proceedings of the Computerized Numerical Command (CNC).

## 2.3- Automated Planning

Planning is an explicitly deliberation process that chooses and organizes action by anticipating there expected outcomes. This deliberation is able at achieving as best as possible some pre-established objectives (Ghallab *et al.*, 2009). This reasoning process aims to satisfy (through the implementation of actions), some previously established objectives. The automatic planning is an artificial intelligence area that studies this deliberative process computationally (Vaquero, 2007).

The emerged of the automatic planning dates back to the 1960s from scientific studies focused on creating general problem solvers (especially with the use of first-order logic); for example, GPS (General Problem Solver) (Ernst and Newell, 1969). However, the first planner capable of using the representations of fields to obtain the solutions of the problems was created in the early 70s, when a group of researchers at the Stanford Research Institute created an automatic planning system called STRIPS (Stanford Research Institute Problem Solver) (Fikes and Nilsson, 1971). With simple formulation, this planner marked the beginning of the automatic planning classical era, which lasted until the beginning of the 90's.

In order to compare the existing planners, was created the PDDL - Planning Domain Definition Language (McDermott *et al.*, 1998). This language was used in the first competition of planners called IPC - International Planning Competition - which occurred during one of the leading conferences in the area of Automatic Planning, the AIPS (Artificial Intelligence Planning Systems – 1998). In this occasion, planners solved classical problems of planning as well as real simplified problems (Vaquero, 2007).

By 1995, there were significant progress, however, the planners could not solve many problems, even if simple, in satisfactory computational time. Avrim Blum presented a planner that used an extracting plans method differentiated by the graphs. This new scheduler was called GRAPHPLAN (Blum and Furst, 1997). Its simplicity coupled with its superior performance to the planners encouraged the development and research of new planning techniques and marked the beginning of the neoclassical era of automated planning.

This growing area of Artificial Intelligence is present in scenarios such as path planning and handling of automatic mobile; perception planning involving sensing actions to capture information from the environment, navigation planning that combines sensing and setting trajectories; planning manipulation and moving objects, e.g., parts assembly, among others (Ghallab *et al.*, 2004).

It's possible to think of a modern manufacturing process as chain of actions independently triggered and whose completion can be detected by sensors. These actions can be performed by devices, numerical controlled machines, AGV's, conveyor belts, manipulator robots, etc. Therefore these actions consist of relatively complex programs on different languages, also including PLCs' programming languages.

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So the sequencing hereby referred can be seen as a translation activity from automated planners to devices and machines. Even though the perception and actuation processes can also be performed by PLC's; it's noted that this level of language is not suitable to fit automated planners results. The designing process by itself is not feasible in a low level language as Ladder, even though in the end, it's desired to have a way to automatically actuate over the input of those actions when using PLC and detect the termination condition of these actions with sensors perceptions. (Tavares *et al.*, 2011)

Until recently to apply automated planning in real systems were very remote, since the automated planning's problems were solely treated with model problems, and extracted directly in formal specification languages such as PDDL (Fox and Long, 2003).

### 2.4- ItSIMPLE

The itSIMPLE (*Integrated Tools Software Interface for Modeling Planning Environments*) was designed to support users during the construction of real and complex planning domain applications since the initial stages of the design life cycle (Vaquero *et al.*, 2009). These initial stages encompass domain specification, modeling, analysis, planner selection, model testing and maintenance, all of them crucial for the success of the application.

The itSIMPLE Project aims to study and develop a Knowledge Engineering tool for designing Artificial Intelligence Planning and Scheduling domain models. The software provides a different approach for modeling the planning domain. Its main feature is to enable the entire modeling process to be done through UML diagrams (Unified Definition Language) (Object Management Group, 2003). As the group of the PDDL language experts, and its formalisms, is very limited, itSIMPLE opened the door for a larger group of people to be able to model the planning domain from a graphical language. Hence, the software consists of a tool capable of translating the UML model to a corresponding PDDL that can be used by automated planners.

The evolutions of the itSIMPLE present an enhanced integrated environment with well-known representation languages such as UML, XML, Petri Nets and PDDL (Planning Domain Definition Language); as shown in Figure 2, each one of them with its best contribution to the whole design process, leading designers from the informality of real world requirements to formal domain models. The tool can automatically translate UML models to a PDDL representation in order to let users test their models with several general planners (such as Metric-FF, FF, SGPlan, MIPS-xxl, LPG-td, LPG, hspsp, SATPlan, Plan-A, blackbox, LPRPG, Marvin). XML is suitably used as an intermediate language that can support the translation from UML to other representations such as PDDL.

The itSIMPLE software is an open source project implemented in Java that provides a user-friendly GUI to model and analyze many planning domains at the same time. This fact usually contributes to domain model reusability and maintenance.

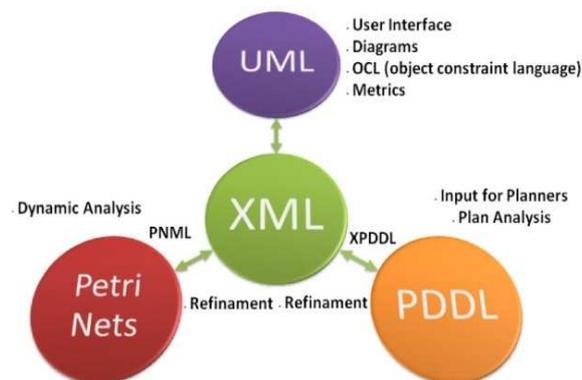


Figure 2: itSIMPLE's structure and languages (Vaquero et al. 2009)

### 2.5- Planning in robotics

Currently, there has been a discussion on the use of automated planning in robotics. For example, most of the one million robots deployed today in the manufacturing industry do not perform planning *per se*. Using a robot without planning capabilities basically requires hand-coding the environment model and the robot's skills and strategies into a *reactive controller* (Ghallab *et al.*, 2004). This type of programming is normally fixed and represents little or none flexibility with regard to other movements; requiring constantly reprogramming of the equipment. This results in high labor costs since only specialize staff can perform the programming, in addition to production losses due to setup time to robot training.

However, if a robot has to face a diversity of tasks and/or a variety of environments, then planning are going to assist robot programming, and it will increase the robot's usefulness and robustness. When planning is integrated within a robot, it usually takes several forms and it is implemented throughout different systems. Among these various forms of robot planning, there is some in particular *path and motion planning*, *perception planning*, *navigation planning*, *manipulation planning* and *domain-independent planning*.

Nowadays, the maturity of robot planning is mainly at the level of its domain-specific planners. Path and motion planning is a mature area that relies on computational geometry and efficiently it uses probabilistic algorithms, which enable manual programming of closed-loop controllers for these tasks that handle the uncertainty and the integration between acting and sensing (Ghallab *et al.*, 2004). These high-level reactive controllers permit pre-programmed goal-directed and event-reactive modalities.

A perfect example of a robot which utilizes advanced automated planning is the *Curiosity*, shown in Figure 3. *Curiosity* is a Mars Explorer Rover (MER) - it is a car-size robot designed by NASA and developed to explore the Mar's surface. Using 17 cameras, scientists are able to choose the most suitable path to be covered. The robot also possesses an arm equipped with a drill, a brush to remove dust and a shovel to collect materials for analyses. In addition, in the *Curiosity* body are located computers that use planners to define the robot actions.



Figure 3 – Curiosity robot picture © NASA

### 3. ROBOT CASE STUDY

The problem approached in this work is a simple production system. It consists of two conveyor belts (input and output ones), a site where assembly is performed and a buffer to store parts if necessary. There are two types of parts (base and cover) and the robot must perform both the transport and the assembly of these components. (Figure 4) illustrates this system.

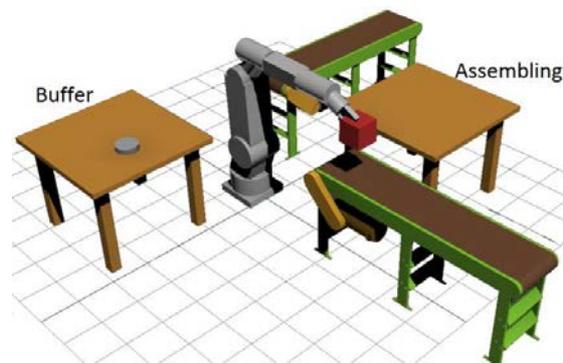


Figure 4. Robotic System

In this problem, the robot must be programmed and trained in order to perform different tasks (grab, move and drop), always analyzing the presence and the type of the part.

Follow, two different robot programming methods for this system will be presented. The first method is about the classical programming that is developed in the robot controller and the robot is trained to realize the set tasks. The second method uses automated planning, in which the system is modeled and the evaluation of the conditions generates the plans (task set) that the robot must follow.

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### 3.1- Classical robot programming method

In the classical robot programming method, firstly the trajectories and actions to be performed are defined. After that, the implementation of these in the robot controller begins with the definition of the types of movements, speed and level of precision. Later, the robot is trained to carry through these movements in definitive fixed sequence.

For the study of case, the robot will need to develop the following actions:

- FMove(Initial\_position, Conveyor Belt)
- OMove(Conveyor Belt, Buffer)
- FMove(Buffer, Conveyor Belt)
- OMove(Conveyor Belt, Assembling)
- FMove(Assembling, Conveyor Belt)
- OMove(Buffer, Assembling)
- FMove(Assembling, Buffer)
- OMove(Assembling, Output)
- FMove(Output, Initial\_position)
- FMove(Output, Conveyor Belt)
- GrabPart(Close Gripper)
- DropPart(Open Gripper)
- PartAssembly (Open Gripper)
- GrabProd(Close Gripper)
- DropProd(Open Gripper)

The command *FMove* is about a free movement (robot without any part) and *OMove* is a movement of the robot with the part. The other actions are of *Grab* or *Drop* the part (or product) and *PartAssembly* carry through the assembling.

The main characteristics of the movements are:

- *OMove* - low speed, because is a movement with the part
- *FMove* - high speed, because is a free movement of the robot
- In approach points the speed must be low
- Position Level (movement precision level) will be higher when the actions will be executed to catch and to drop

The conditions (part presence and type) are given through the read values in the sensors and will be parameters to determine a certain command execution.

The previously modeled system was mounted using a robot MOTOMAN-HP6 for accomplishment of the programming, training and tests. Figure 5 presents MOTOMAN-HP6 picture.



Figure 5. Picture of Assembly System

The tasks are divided into Jobs, which are programs with the movements and actions necessary to carry through the transport and the assembly of the product.

The Jobs required for this case study are:

**Job1:** MOVL, Initial\_position, Conveyor Belt  
Close Gripper  
**Job2:** MOVL, Conveyor Belt, Buffer  
Open Gripper  
**Job3:** MOVL, Conveyor Belt, Assembling  
Open Gripper  
**Job4:** MOVL, Buffer, Conveyor Belt  
Close Gripper  
**Job5:** MOVL, Assembling, Conveyor Belt  
Close Gripper  
**Job6:** MOVL, Assembling, Buffer  
Close Gripper

**Job7:** MOVL, Buffer, Assembling  
Open Gripper  
**Job8:** Close Gripper (GrabProd)  
MOVL, Assembling, Output  
Open Gripper (DropProd)  
**Job9:** MOVL, Output, Initial\_position  
**Job10:** MOVL, Output, Conveyor Belt  
Close Gripper  
**Job11:** MOVL, Conveyor Belt, Assembling  
Open Gripper (PartAssembly)  
**Job12:** MOVL, Buffer, Assembling  
Open Gripper (PartAssembly)

The follow figure (Figure 6), illustrates the Job test developed in robot NX100 controller.

```

JOB CONTENT
JOB NAME: W2                      STEP NO: 000
CONTROL GROUP: R1                 TOOL: **
0000  NOP
0001 001 MOVL V=60.0 PL=0
0002 002 MOVL V=60.0 PL=0
0003 003 MOVL V=80.0 PL=0
0004 004 MOVL V=60.0 PL=0
0005  END

```

Figure 6. Example of Program

In the showing program, each number on the left represents a line of address where an action is scheduled. The robot moves using the command MOVL (linear motion), speed of 60 cm / min (low speed to load one part) or 80 cm / min (free movement) and PL (precision level) equal to zero (error less than 12.5  $\mu$ m).

*MOVL* is a linear type movement, which the robot movement itself in rectilinear trajectories in the axes (x, y, z). In long movements it is necessary to establish intermediate points to prevent that the robot exceeds the work space.

After the robot training, it was created the main program that is a set of Jobs or sequence of action for a simple assembly system with two types of part. Two systems are evaluated: with buffer and without buffer. Figure 7 shows the Grafcet diagram from this case study without buffer, and Figure 8 presents the Grafcet diagram for this system with a buffer.

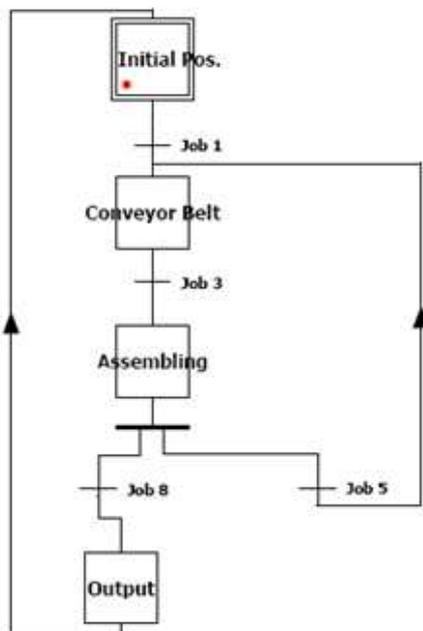


Figure 7. Grafcet of system without buffer

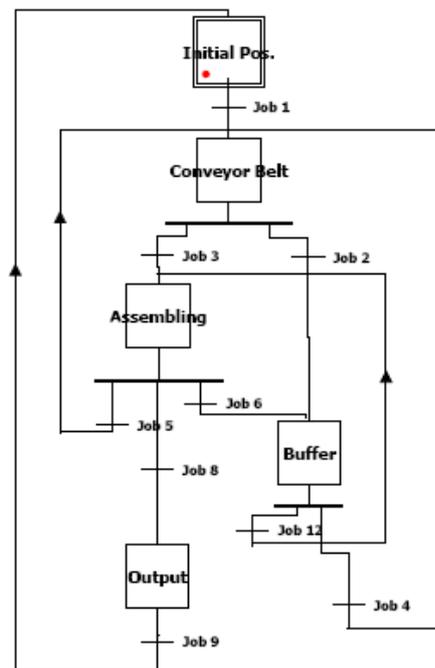


Figure 8. Grafcet of system with buffer

It is observed that in the simplest system (without buffer) only four actions are carried through. The robot moves itself of the initial position for the mat, catches the part, takes the part for the assembly and later returns for the mat and it repeats the process with other part. When it arrives again in the assembly, it mounts the product. For the product assembly the type of part condition must be respected. After the assembly, the product is carried to the exit. In this case, part sequence must be pre determined and after a base part a cover one have to be griped and assembled.

The system with buffer will be performed more analyses and actions. Depending on the part type, the robot now must store in the buffer and take for the assembly only when its corresponding type arrives. For this reason, parts can arrived in any sequence and the buffer are going to be used to reach a suitable assembly sequence.

3.2- Robot Programming method with Automated Planning

Another system programming method is the use of automatic planning. The system must be modeled and well specified (with the conditions definitions) for the development of plans, aiming at the goal state that, in this in case is the mounted product in the output conveyor belt.

The modeling process begins with the construction of the Use Cases Diagram, as showed at Figure 9. An analysis of the characteristics of the proposed problem allows the identification of three agents, the *Robot*, the *Part* and the *Product*. The agent *Robot* will be responsible for carrying out the Use Case *Grab* and *Drop*, the agent *Part* will be transported by the *Robot* while the agent *Product* will be compose for two parts ensemble on assembling place.

The Use Case *FreeMove*, *OccupiedMove*, *Grab* and *Drop* requires the activities of both *Robot* and *Part* agents simultaneously while the Use Case *PartAssembly*, *ProdGrab* and *ProdDrop* requires the activities of both *Robot* and *Product* agents. Figure 9 shows the Use Case diagram of the system.

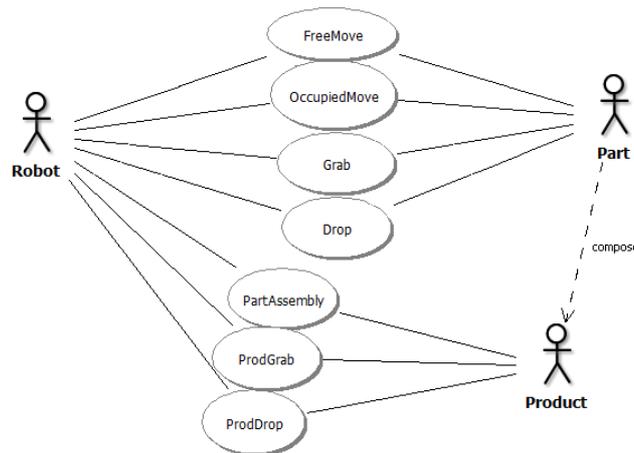


Figure 9. Assembly Line Use Case Diagram

Through this diagram, it can be visualized the robot actions: move (free and occupied ones), assembly a part, grab or drop (part or product). Finally, it can also be observed the part that will compose the product.

After the definition of Agents and Actions, the class diagram (Figure 10) can be constructed showing the functions performed by the robot class, the part class, the product class, the local class, the assembly class, the buffer class, and the relations between them.

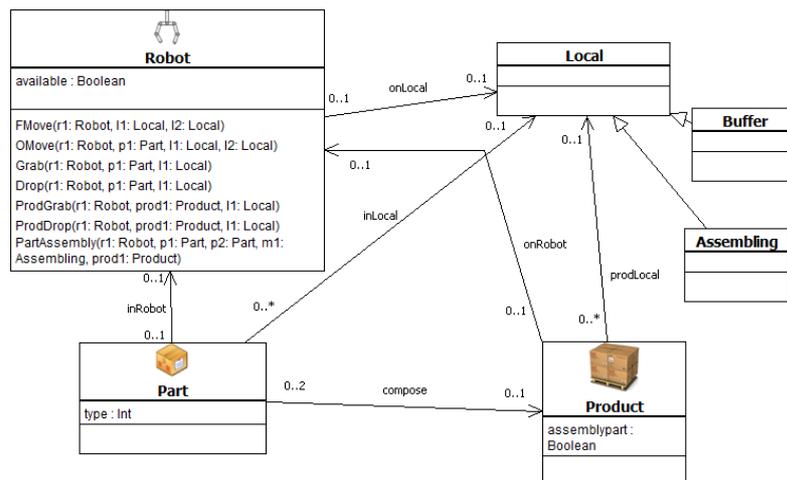


Figure 10. Robotic System Class Diagram

It can be observed from the diagram above that the robot class performs seven actions in total: *FMove* (free movement, carrying no parts, a higher speed can be used), *OMove* (occupied movement, a lower speed must be used), *Grab*, *Drop*, *ProdGrab*, *ProdDrop* (the position will be different for the product) and *PartAssembly*.

State diagrams of the parts and the robot class are built in order to relate the agents and identify their different states. (Figure 11) shows Parts state diagrams, and (Figure 12) Robot state diagram. In Figure 11, the part can be in two different states, *Still* or *Moving*. The robot actions *Grab* or *Drop* the part and the conditions evaluation ( $p1.inLocal$  or  $p1.inRobot$ ) can determinate the change of states. In Figure 12 are shown the actions (*Drop*, *prodDrop*, *Grab*, *prodGrab*, *Fmove*, *OMove* and *PartAssembly*) and conditions ( $r1.available = true$  or  $false$ ) for the change of robot states (*Free* or *Occupied*).

The product's state diagram is similar to the part's state diagram.

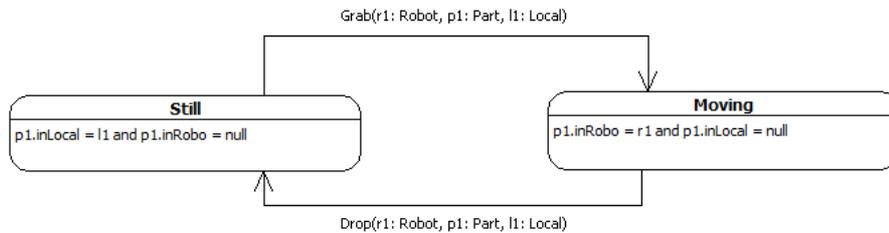


Figure 11: Part's State Diagram

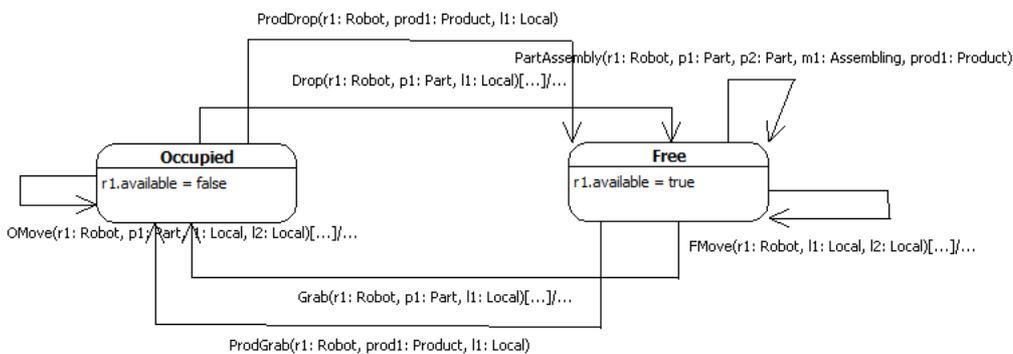


Figure 12. Robot's State Diagram

The pre and post-conditions of actions that the objects of *Robot Class* performs are extracted from descriptions of *Use Cases* and these are represented in OCL – *Object Constraint Language* (OMG – Object Management Group, 2003). The example below shows a condition in the robot's state diagram.

$$p1.inLocal = l1 \text{ and } p1.inRobo = null$$

Its means that *Part* is in one *Local* and not in the *Robot*.

### 3.3- Problem Definition

After this system model representation, the planning problem can be modeled by two distinct Snapshots (Objects Diagram) representing the initial state and goal state of the problem. For didactic reasons, this paper is presenting only two Parts ( $p1$  and  $p2$ ) to be assembled as product and does not requires the buffer. Initially, the Robot is set in Initial Position; two parts is on conveyor belt (input). The final state, defined as a goal snapshot is: two parts compose a Product and this in the output; The figure 13 and figure 14 show the initial snapshot and the goal snapshot corresponding to this problem.

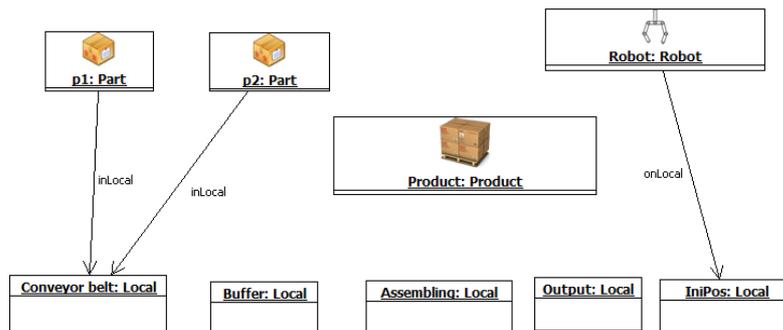


Figure 13: Initial Snapshot

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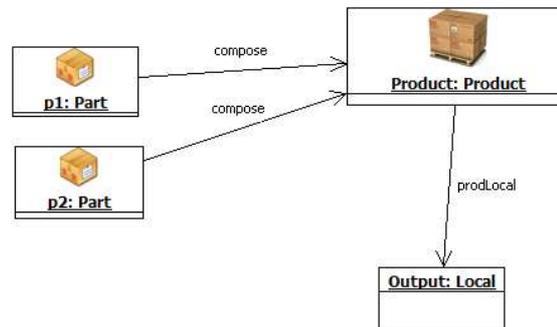


Figure 14: Final Snapshot

The itSIMPLE has a significant number of automated planners, such as SGPlan6 (Hsu and Wah 2008) and Metric-FF (Hoffmann 2003). This work presents the result obtained with the Metric-FF planner, which generated the plan-solutions described below.

- 1- (FMove, Robot, IniPos, Conveyor Belt)
- 2- (Grab, Robot P1, Conveyor Belt)
- 3- (OMove, Robot P1, Conveyor Belt, Assembling)
- 4- (Drop, Robot P1, Assembling)
- 5- (FMove, Robot, Assembling, Conveyor Belt)
- 6- (Grab, Robot P2, Conveyor Belt)
- 7- (OMove, Robot P2, Conveyor Belt, Assembling)
- 8- (Drop, Robot P2, Assembling)
- 9- (PartAssembly P2 P1, Assembling, Product)
- 10- (ProdGrab, Robot, Prod, Assembling)
- 11- (OMove, Robot P2, Assembling, Output)
- 12- (ProdDrop, Robot, Product, Output)

It can be seen that twelve steps are necessary to solve the problem. The robot moves from its initial position, grabs one part from the conveyor and transports it to the assembling area. After that, it collects another part on the conveyor and moves it to assembly. Finally, the robot assembles the two parts, grabs the product and carries it to the output conveyor belt.

The generated plan steps present one direct relationship with the previously defined Jobs on classical robot programming method. This relationship is shown hereafter:

- **Job1:** steps 1 and 2
- **Job3:** steps 3 and 4
- **Job5:** steps 5 and 6
- **Job11:** steps 7,8 and 9
- **Job8:** steps 10 e 11 and 12

Therefore, to execute this plan on classical method would be necessary only a sequence of five jobs.

#### 4. CONCLUSION

This paper described how to realize classical programming and apply automated planning tools in Assembly and Disassembly Robot System. With itSIMPLE it is possible to generate several initial and goal Snapshots related to real cases; that is, solving several different problems without re-programming. Each generated solution-plan action must be mapped as Robot Language. On the other hand, it is not possible to generate a cyclic and recursive solution; each problem requires another initial snapshot and a new solution-plan must be created, which requires time processing.

The best scenario for the automated planning application in manufacturing automation would be the integration of disparate languages, in this case, PDDL and Robot Language.

The integration of these two boarding, would promote the insertion of an intelligent behavior on the diverse types of industrial systems with robot use, such as the automotive industry, oil industry, mining and others, beyond advantages as adaptability, reduction of uncertainties and forecast of behavior.

This integration would be possible by developing an application capable of performing an interface between Robot and itSIMPLE. The development of an application for the automatic integration between the planner allocated in itSIMPLE and the process controller from PDDL to Jobs (actions of robot) is a main further work. This interface will communicate them through DLL, OPC server or a built *driver*. The idea of this interface is better described in Fonseca *et al* (2013).

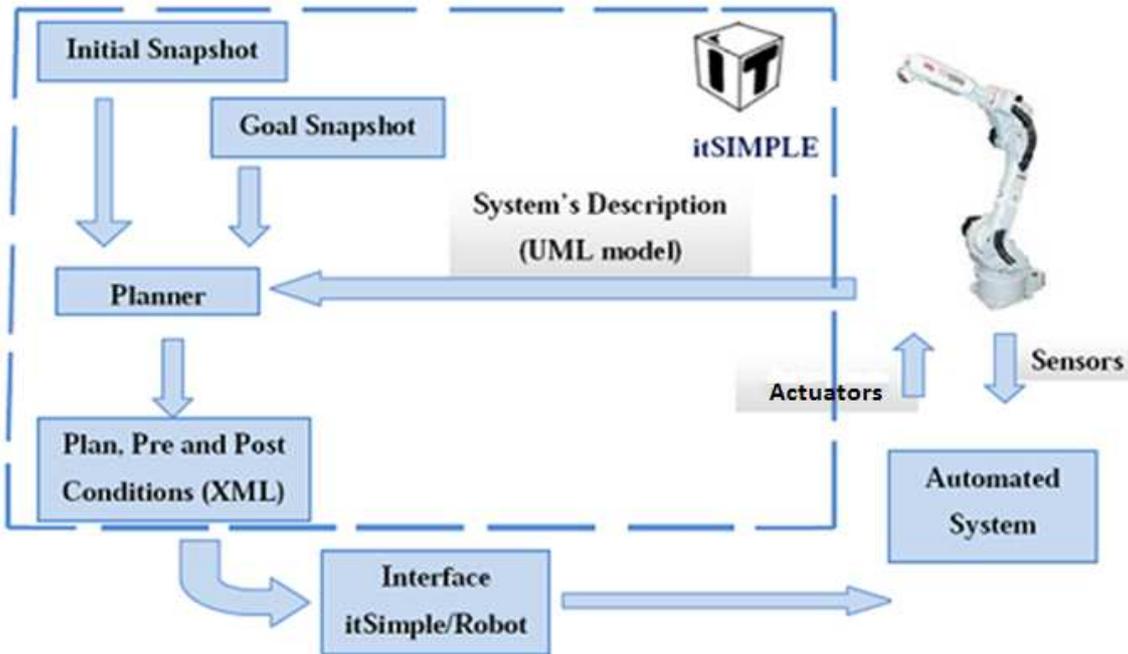


Fig 15: ItSimple and Robot Interface

In Figure 15, it can be observed the ItSimple and robot interface. Having defined the list of actions, the system begins to operate until the goal snapshot or an unexpected state is reached. The interface will convert a PDDL plan into a set of actions using the robot language (Jobs). In the case of an unexpected state, the system will request a re-planning for an automatic planner.

The automatic planning presents more flexibility and simple efficiency for solutions in a specific domain and modifications can be made offline not causing robot stop. In classic modeling system a small modification of parameters such as addition of part types becomes the program more complex and dependent on the programmer.

This is an only initial study which intends to stimulate automated planning deployment. There is a need to compare planner solutions in more complex examples and to compare it with the results obtained by using traditional programming.

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