

Technical Handbook

Automation – 2024 Cycle



About WorldSkills UK

WorldSkills UK is a set of dynamic skills competitions for young people and adults, designed and delivered by industry experts annually in over 50 skills.

Many WorldSkills UK competitions lead into WorldSkills International competitions which are biennial global events.



For further details, please visit:
www.worldskillsuk.org/worldskills-uk-competitions

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ENGINEERING SKILLS FOR THE FUTURE



Automation

Introduction

The aim of this manual is to help competitor teams prepare for the Automation competition at regional and national level. We hope this will help competitors to perform to the best of their ability during the competition cycle. The guide contains general advice, technical tips and a more in-depth overview of the competition structure and its content. The teams are made up of **two competitors**.

Using the tips and advice throughout the guide will help you focus on the competition areas with a higher level of accuracy to read, look at and review tasks thoroughly before beginning each task and teach you to step back occasionally to see if you are achieving your goal.

Remember it's not a race, you are competing against a standard, a very high standard, but one that is achievable.

Competition Overview

This is a practical competition that will test your logic, design and fault-finding skills in a challenging environment.

To complete the tasks competitors are expected to apply their theoretical knowledge of fundamental principles, automation, pneumatic, electrical/electronic and PLC technologies.

The skills that are tested in the practical competition include:

- Designing, building and testing pneumatic, electro-pneumatic circuits and PLC programs for sequential and non-sequential tasks
- Using appropriate sensors and actuators to build simple automated systems
- Adding new functionality and operations to a given application
- Process monitoring and visualisation.



Stage 1 Registration and preparation

To compete in the competition, you must register using the WorldSkills UK website. You will then receive a confirmation of whether you have successfully registered. Automation competition involves a team of two competitors. Whilst you wait to get to the next stage of the competition, you should do your best to prepare for the competition by taking a look at the **pre-competition activity task** made freely available to you on [our website](#). While you will register your details individually, it is also very important at this stage to specify the same team name when registering so that you are allocated to the same team to avoid unnecessary delays.

Stage 2 Entry stage

Shortly after registering, the competition journey will begin with what is called an entry stage. This will be an online task in the form of a multiple-choice activity, exploring the competitor's basic knowledge and familiarity with pneumatics, electro-pneumatics and PLC programming. This activity is time limited to 1 hour and will take place soon after the registrations close. Each competitor will take part in the activity, but the individual marks will be combined to get a team mark. This is an important part of the competition journey as it gives the competitor an early taste of what knowledge is needed to be successful on the journey. Once everyone's scores have been totalled, competitor teams will be informed if they have progressed on to the next round, called the national qualifiers.

Stage 3 National Qualifiers

For competitors who have managed to progress from the entry stage, the next step is the national qualifiers. There will be a range of venues and dates that will be available to register. You are advised to register for your nearest venue. The top eight scoring teams meeting the minimum threshold from the national qualifiers will then go through to the next round, the national finals. National qualifiers are one-day activity, typically involving three main tasks.

Stage 4 WorldSkills UK National Finals

The top six (6) teams in the UK will be invited to compete in the UK National Final which is the pinnacle of the UK national competition cycle.

The finals are usually a large-scale event, and a chance to show off your skills, meet a bunch of industry professionals and other competitors taking part, as well as bring your family along to see you compete. The UK National Final is currently planned to take place, typically in mid-November, involving practical activities. This is typically a three-day event involving a day of setup and familiarisation followed by two days of competition activity.

Core Competencies

Please note the following are core competencies for the full set of Automation competitions, that competitors will be assessed on. Not all competencies are covered at all stages and levels.

Core competencies and standards for WorldSkills UK Skills Competitions activities		Qualifier Stage	National Final
Standards	Development of Automation systems Knowledge and understanding: <ul style="list-style-type: none"> • Designing, assembly and commissioning of an automated system • Understand the function, the application and the components of pneumatic systems • Understand the function, the application and the components of electric and electronic systems • Understand the function, the application and the components of PLC systems 	Y	Y
Competency	Competitors shall be able to: <ul style="list-style-type: none"> • Carry out system design for a given industrial application • Assemble an automated process according to documentation • Connect wires and tubes in a correct industrial way • Install, setup and make necessary adjustments to mechanical, electrical, pneumatic & sensor systems • Commission a machine or a process by auxiliary equipment and together with a PLC using their standards and their documentation 		
Standards	Industrial Controllers Knowledge and understanding: <ul style="list-style-type: none"> • Understand the function, the structure and the operating principles of PLCs • Understand the structure and function of industrial controllers (PLCs) • Understanding of the configuration of the industrial controller and how a software program relates to a machine action. 	Y	Y
Competency	Competitors shall be able to: <ul style="list-style-type: none"> • Connect their own PLC with the supplied system or setup • Make the necessary configuration of the industrial controller • Configure all aspects of their PLC as required and the associated control circuitry for correct operation 		
Standards	Software Programming Knowledge and understanding: <ul style="list-style-type: none"> • Understanding of programming an industrial software program • Understand how a software program relates to a machine action 	Y	Y
Competency	Competitors shall be able to: <ul style="list-style-type: none"> • Write programs to control a process, and visualise the process and operation using appropriate software systems. • PLC programming. 		
Standards	Design Circuits Knowledge and understanding: <ul style="list-style-type: none"> • Knowledge required to design different circuits • Understanding of designing and assembling electrical circuits in machine/controller systems. 	Y	Y

Competency	Competitors shall be able to: <ul style="list-style-type: none"> Design pneumatic and electric circuits Design the circuits with modern software tools 		
Standards	Analytical Techniques Knowledge and understanding: <ul style="list-style-type: none"> Knowledge of analytical fault finding and repairing. 	N	Y
Competency	Competitors shall be able to: <ul style="list-style-type: none"> Find different faults in an analytic way in an automated system Repair components in short time. Demonstrate mastery of problem-solving techniques to ensure correct and safe machine operation. 		
Standards	Mechanical and Electrical Design Knowledge and understanding: <ul style="list-style-type: none"> Knowledge of designing and assembling mechanical systems including pneumatic systems, their standards and their documentation 	N	Y
Competency	Competitors shall be able to: <ul style="list-style-type: none"> Design and assemble mechanical and electrical systems. 		

Schedule

Registration:	26 February 2024 – 28 March 2024
Entry Stage:	24 – 26 April 2024
Results of Entry Stage:	10 May 2024
National Qualifiers*:	Venue 1: 30 May 2024 – Northampton Venue 2: 5 June 2024 – London Venue 3: 6 June 2024 – Northern Ireland
National Finalists Announced:	11 July 2024
National Finals:	19-22 November 2024, Manchester.

*** - These are provisional qualifier dates and other venues and dates may be added following the Entry Stage.**

General Instructions

1. Entry stage will involve 1 hour multiple choice test, aimed at testing general knowledge in pneumatic and electro-pneumatic components and associated circuits and PLC programming. Competitor teams will be informed for their specific allocated time soon after the closing of the registration period.
2. Maximum working time is 3 x 1-hour tasks at National Qualifiers and typically 5 tasks of differing lengths over 9 hours (2 days) at the National Final.
3. At the start of the competitions an allotted time will be allocated for work planning. This time is not part of the working time.
4. The National Final will typically consist of 5 modules/tasks exploring different competencies tested over two days.
5. All supplied equipment and materials must be accurately checked by the competitor teams prior to commencing the competition.
6. All materials and equipment must be marked out/used in the most economical method.
7. Competitor teams will lose marks for any misplaced, lost or spoiled materials and/or equipment, where this is the result of competitor error.

8. Minimum marks will not be awarded for dimensional accuracy or technical perfection where instructions have been disobeyed.
9. Competitor teams will lose marks for each minor breach of the Health & Safety rules. Where a competitor puts themselves or any other person at risk as a result of a Health & Safety breach, the task will be stopped. Where a task is stopped due to a Health & Safety risk, the judge will decide if the task can be continued safely.

Competition equipment needed at National Qualifiers

1. Competition equipment is typically based on the Festo Technology Packages TP101, TP201 and TP202. This equipment is provided by the competition organisers.
2. All competitor teams will need to bring their own PLC and associated programming equipment and software.
3. While it is not necessary, competitors may bring their own tools, writing pads or boards.
4. Competitor PLCs will need to have minimum of:
 - 16 x Digital inputs – 24V DC
 - 16 x Digital outputs – 24V DC
5. Integration of the competitor's PLC is typically achieved by the use Syslink cables or directly with 4mm shrouded leads. If competitor's PLC only has hardwired connections, then it would be helpful to inform the organisers so adequate provision to connect their PLC to the rest of the equipment can be made.
6. If your PLC will be using Syslink cables to connect to the rest of the equipment, it would be helpful to bring your own Universal Connection units. Otherwise, it would be helpful to inform the organisers to ensure this is provided.

Competition equipment needed at National Finals

1. Once progressed to the National Finals, competitor teams will need to bring along their preferred PLC with the relevant programming software.
2. PLC specification will need to have:
 - 16 x Digital inputs – 24V DC
 - 16 x Digital outputs – 24V DC
 - 1 x OPC-UA Server installed
(OPC UA - Open Platform Communications Uniform Architecture)
3. Most modern PLCs will support OPC UA communication protocol but competitors need to ensure they have the correct firmware installed to enable this feature for their PLCs.
4. In addition, competitors will need to ensure **node-red** software is also installed on their laptops. This is a freely available software and can be downloaded from <https://nodered.org/>
5. Competitors will be asked to use **node-red** to build a dashboard to represent the process that is being controlled by their PLC as part of a task.
6. Full set of tools needed will be made available for all competitor teams but they are also entitled to bring their own equipment and tools.

Practice

There are a number of past competition test pieces available to [download from the WorldSkills UK website](#). This is labelled the **pre-competition activity**.

Please ensure you make full use of these in preparing to attend the qualifiers and national finals. Past competition tasks can also be obtained from the competition organisers.



A wise man can learn more from
a foolish question than a fool can
learn from a wise answer.

Bruce Lee

Judges Top Tips

The following eight aspects are neither exhaustive nor prescriptive and not a 'magic' formula to success. However, these are tips based on being involved with competitions for many years and we hope these will help you in future competition participation.

1. **Pressure.** You will be nervous, but you will need to keep nerves under control and not let the pressure overtake you. But managed pressure can be good, increasing energy and performance potential.
How to handle nerves;
 - a. Listen to the Judge's brief and ask questions – what sort of questions depends on you, i.e. repeating an aspect of their brief; gives you a chance to understand more.
 - b. Importantly, understand at what point your allotted time actually starts, i.e. normally after the Judge's brief.
 - c. Read your competitors' brief; everything you need to know for the task is in that brief. Allow yourself 2 to 3 minutes to read it. Read it at least twice as your first reading will be too fast.
 - d. Take a deep breath and start the task. You are against the clock and so you will need to work with focus.
 - e. Task going wrong? Take a moment, think. If necessary, quickly re-read that part of the instructions and then refocus. You may need to move on from that particular aspect of the task.
2. **Time Management.** The tasks are all against the clock. So once you have had your task brief and know how long you have, then quickly plan your workload. Section the aspects of the task into time blocks.
3. **Remember,** it is a competition and so practically everything you do within the task is marked and worth points; so focus on gathering points. Leave some time to put tools away at the end (that is worth points), clean up the working area (again, worth points). If you are stuck on a particular aspect then accept you may or may not get points for that particular part and in order to move onto the next part of the task, ask the Judge for assistance. Remember, there are other points to be earned.

4. **Think outside of the task.** Where are the Risk Assessments? If using any POL, where is the COSHH? If in doubt, then ask the Judge where these items are. Remember, you have a limited time to display your technical skill to the Judge and so you must be smart with your actions and work levels.
5. **Practice before the competition** at working under pressure and with someone watching you; perhaps your works' supervisor or college lecturer. Get them to be super critical on your work quality, methods of work and approach.
6. **Understand the advantage of selecting the right tool for the job.**
7. **Sleep.** Get plenty of sleep the night before. If offered, take advantage of accommodation for the night before the competition. Resist the temptation to consume alcohol the night before and have a good breakfast on the day of the competition; these actions will assist in preparing your mind and body.
8. **Arithmetic.** Practice mental arithmetic. It will sharpen your mind. Perhaps try Sudoku; aim to achieve at least medium level (start at mild or easy). Do mental arithmetic whenever the opportunity arises, e.g. just filled your car or motorbike, how many litres did you put in the tank. Mentally (without the aid of calculator convert Litres to Imperial Gallons - divide Litres by 4.5 to give Imperial Gallons or multiply Litres by 0.22). Understand the relationship between imperial and metric. Remember some datums.
e.g. 25.4mm to 1 inch and so, 12.7mm is ½ inch and 6.35mm is ¼ inch. 1 Imperial Gallon is 4.5 Litres (to 1 decimal place - it is actually 1 Imperial Gallon = 4.5461 Litres).

Technical Guidance

Technical guidance for each specific task and / or tooling will be given at the competition.

Additional Resources

Referring to the following resources will be helpful:

- PLC open for efficiency in automation: <https://plcopen.org/>
- Omron – safety products: <https://industrial.omron.co.uk/en/products/safety>
- Didactic Services Info Portal : <https://www.didacticservices.co.uk/>
- Node-Red: <https://nodered.org/>

Task Breakdown

The following is an example of the marking criteria for the National Qualifier.

Criteria	Task	Mark
A	TASK 1: Pneumatic sequence	30
B	TASK 2: Electro-pneumatic (Hard-wired system)	30
C	TASK 3: PLC programming	40
Total Marks		100%

Health & Safety

During the competition as in any work or educational facility you have a duty to protect yourself and those around you.

As an Organising Partner, our delivery partners have a responsibility to protect you and keep you informed about health & safety procedures and practices including;

- making the competition area safe and without risks to health
- ensure plant and machinery are safe and that safe systems of work are set and followed
- ensure hazardous articles and substances are moved, stored and used safely
- provide adequate welfare facilities
- give instruction, information, supervision and where applicable training necessary to maintain health and safety.

As a competitor you have a legal duty to:

- take reasonable care for your own health & safety and that of others who may be affected by what you do or do not do
- cooperate with the Organising Partner and/or their appointed delivery team on health and safety matters
- correctly use work/competition items provided, including personal protective equipment, in accordance with instructions and/or training given
- not interfere with or misuse anything provided for your health, safety or welfare

In particular:

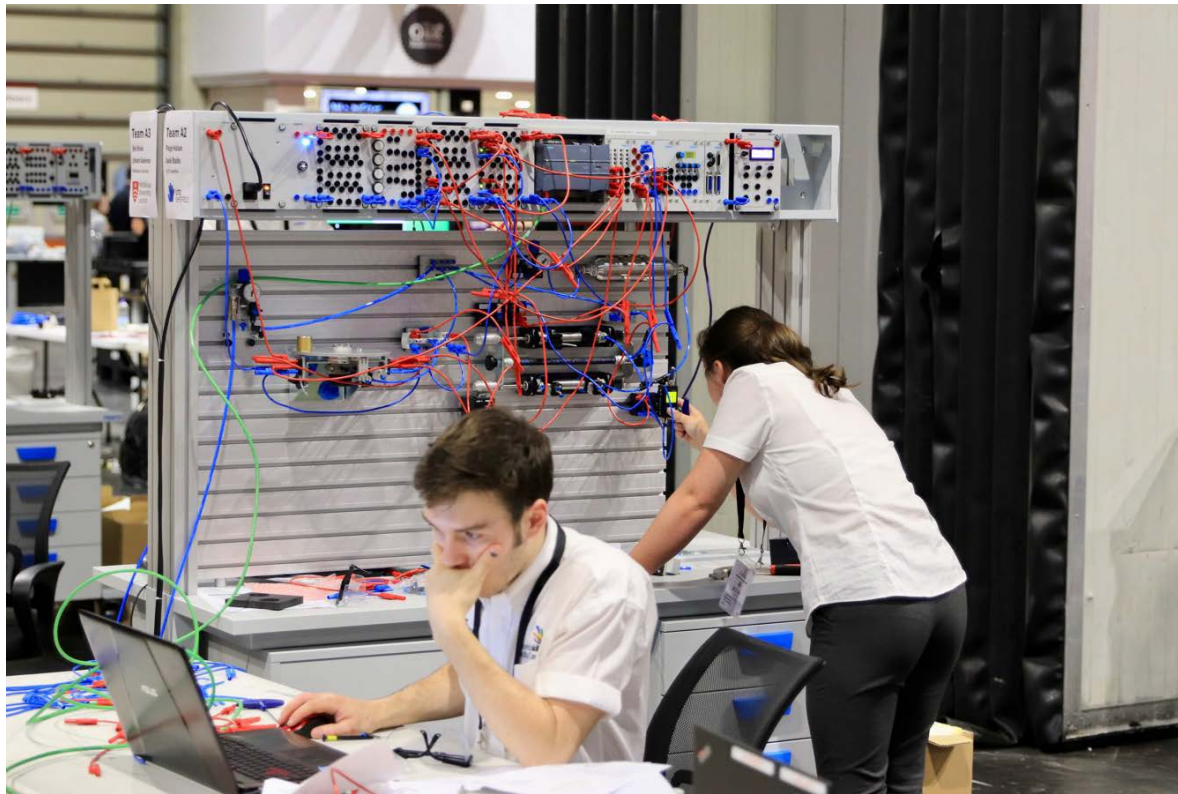
- all health and safety regulations, including protection standards, specified by the competition hosts and delivery team, must be followed exactly. Any defect in machines or equipment must be reported immediately.
- safety goggles must be used in all material-removing operations.
- shoes and clothing must comply with health and safety regulations.

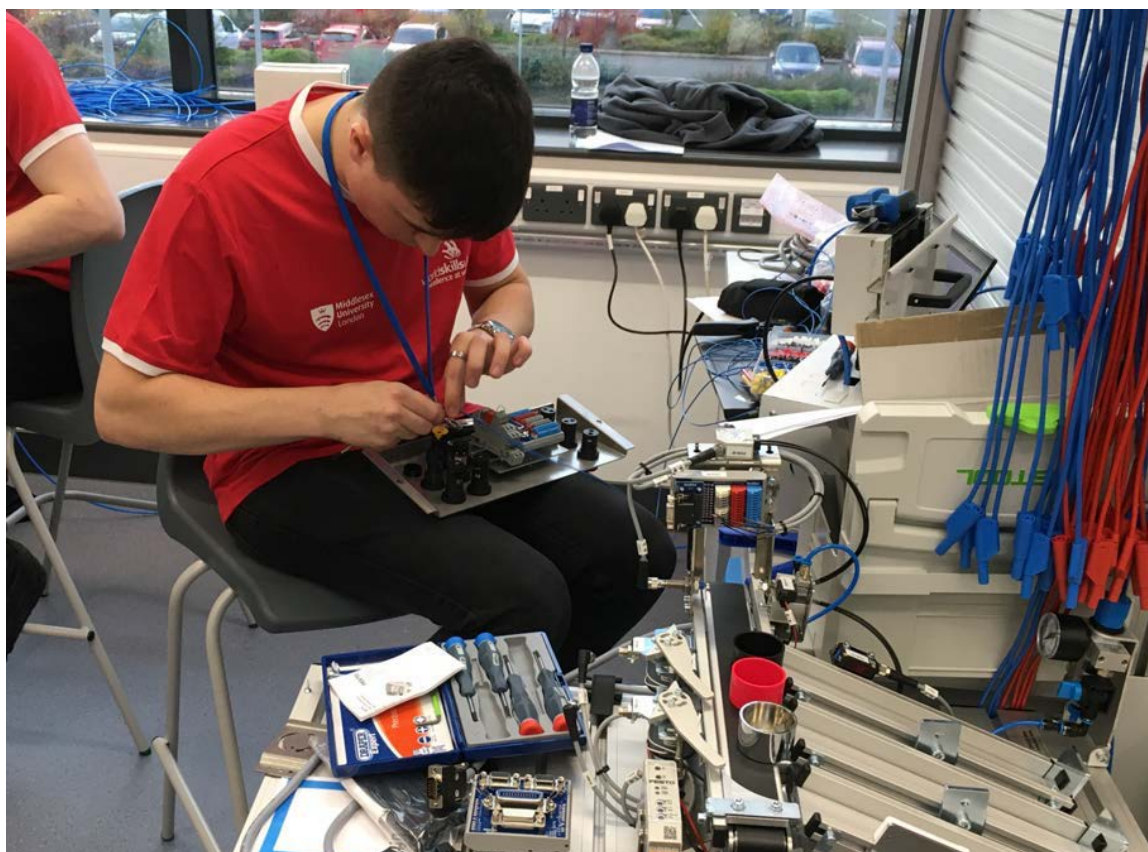
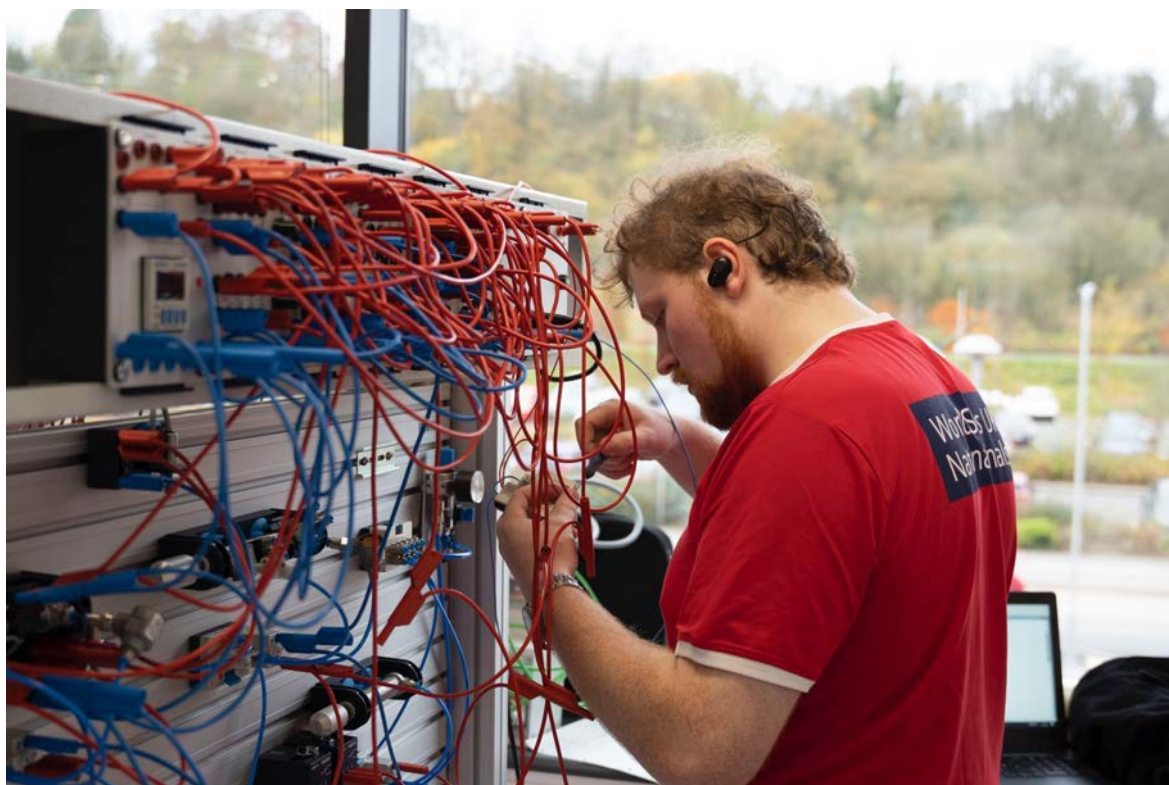
Conclusion

Remember, the competition will be designed to take you out of your comfort zone but the tasks will be achievable. There will be a lot of 'self-pressure'. You need to learn how to control this and focus on the task in hand.

Once a task is complete, you cannot change the outcome good or bad, start the next task afresh and with positivity.

Drink plenty of water throughout the competition, staying hydrated will help with your concentration, focus and will reduce stress and headaches.





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We wish you the best of luck in your competition journey,
and would like to leave you with the following quote:

“ Life is a series of experiences, each one of which makes us bigger, even though sometimes it is hard to realise this. For the world was built to develop character, and we must learn that the setbacks and grieves which we endure help us in our marching onward.

Henry Ford ”



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Further sources of information and websites

WorldSkills UK

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