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(54) **CONTROL SYSTEM FOR A ROTATING MACHINE**

(71) Applicant: **Caterpillar Inc.**, Peoria, IL (US)

(72) Inventors: **Paul Friend**, Morton, IL (US); **Michael Brandt**, Racine, WI (US); **Robert Hamann**, Kenosha, WI (US); **Paul E. Rybski**, Pittsburgh, PA (US); **Mark M. Smith**, Burlington, WI (US)

(73) Assignee: **Caterpillar Inc.**, Peoria, IL (US)

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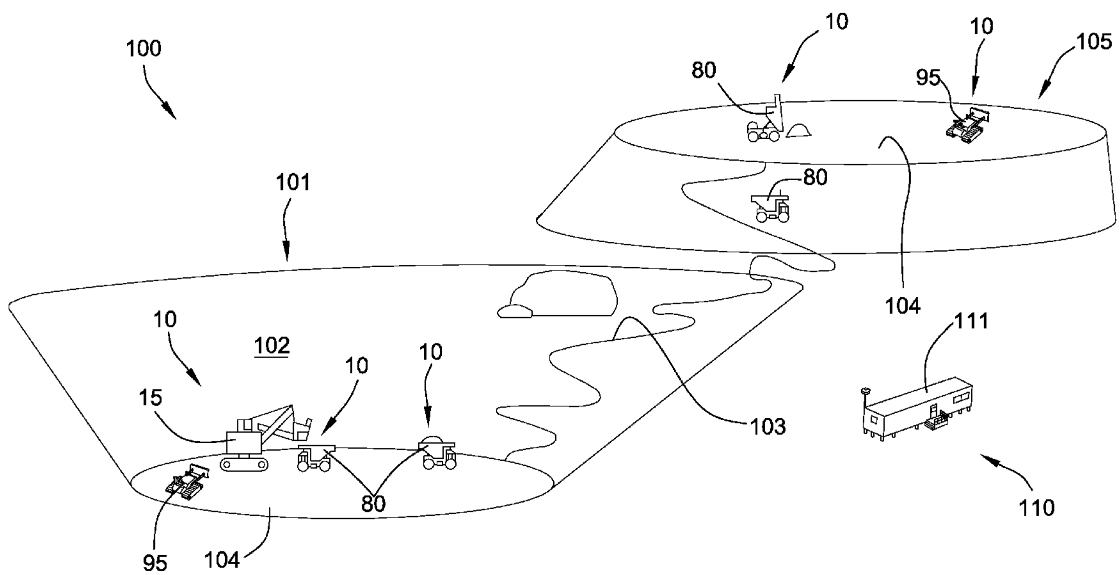
(57) **ABSTRACT**

A system for controlling movement of a work implement of a machine between a dump location and a plurality of dig locations includes a rotatable implement system, and an implement system pose sensor. A controller is configured to store first dig signals from the implement system pose sensor indicative of a first dig location, store second dig signals from the implement system pose sensor indicative of a second dig location spaced from the first dig location and store a dump location. The controller is further configured to generate command signals to move the work implement from the first dig location to the dump location, generate command signals to dump a load of material carried by the work implement at the dump location, and generate command signals to move the work implement from the dump location to the second dig location.



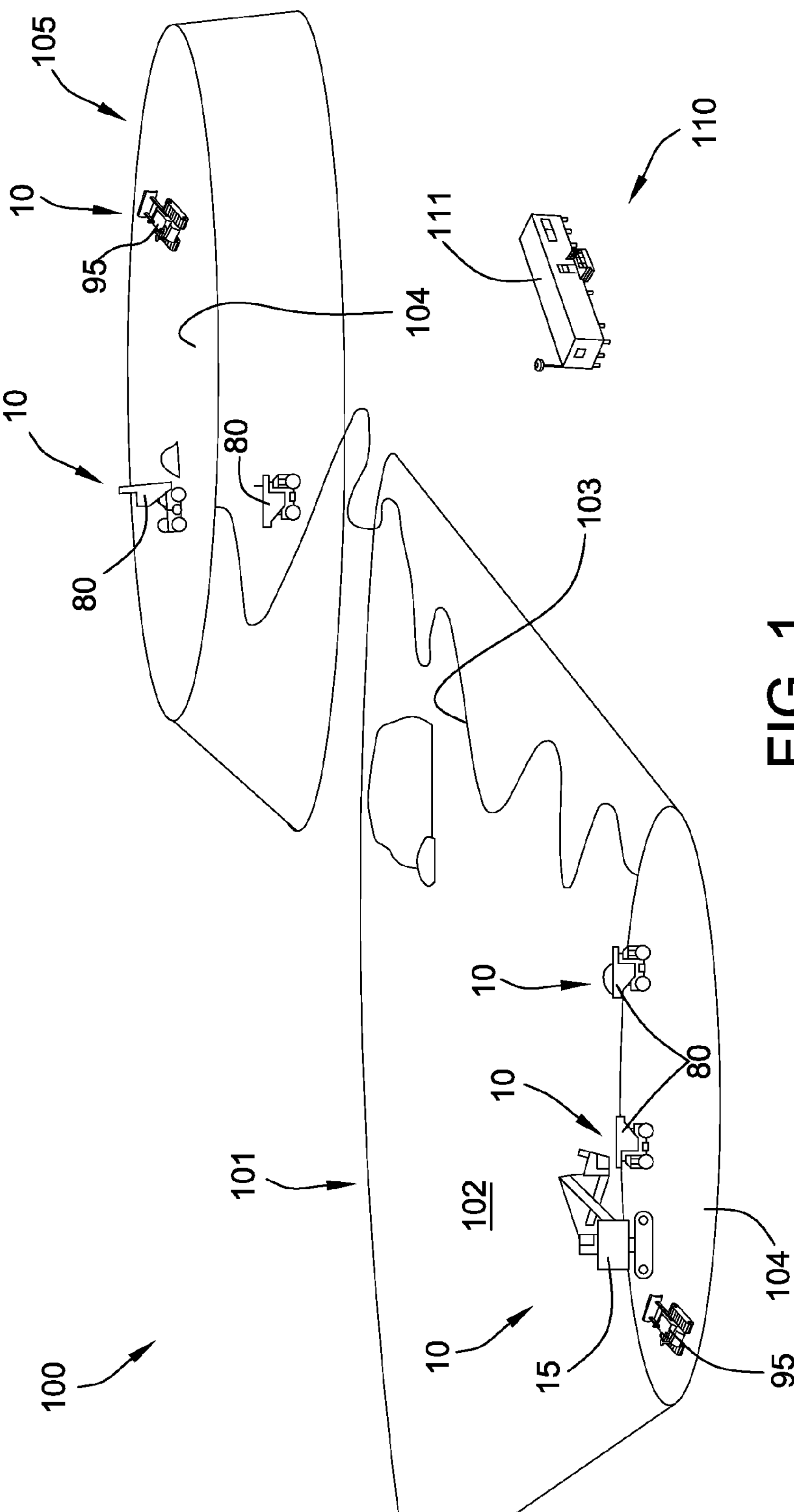
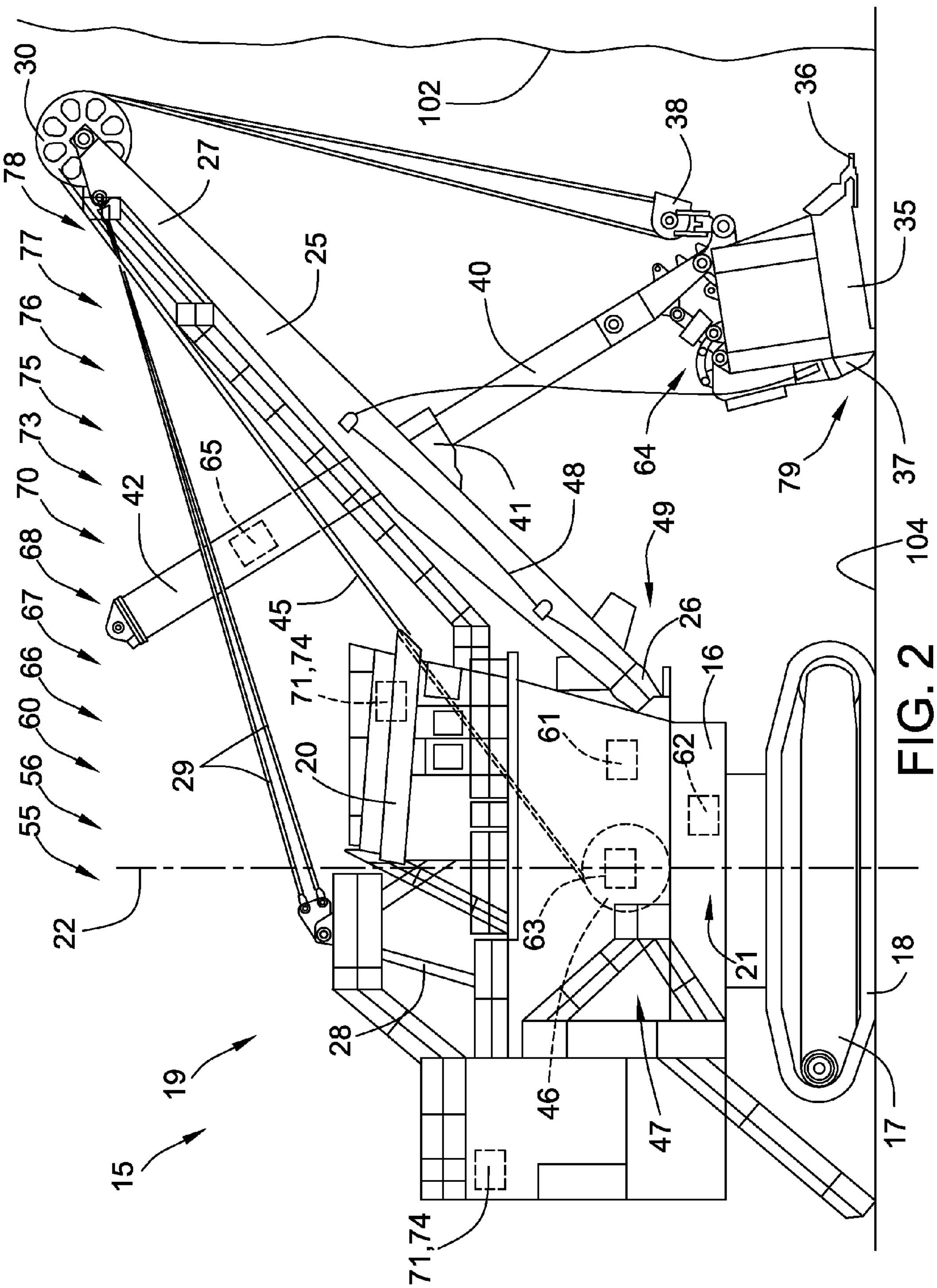


FIG. 1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102
36
38
78
27
77
25
35
76
40
75
73
65
41
48
64
79
37
70
42
49
68
104
67
45
71,74
26
66
16
60
61
29
20
62
56
55
22
63
21
18
28
19
46
47
17
15
71,74

FIG. 2

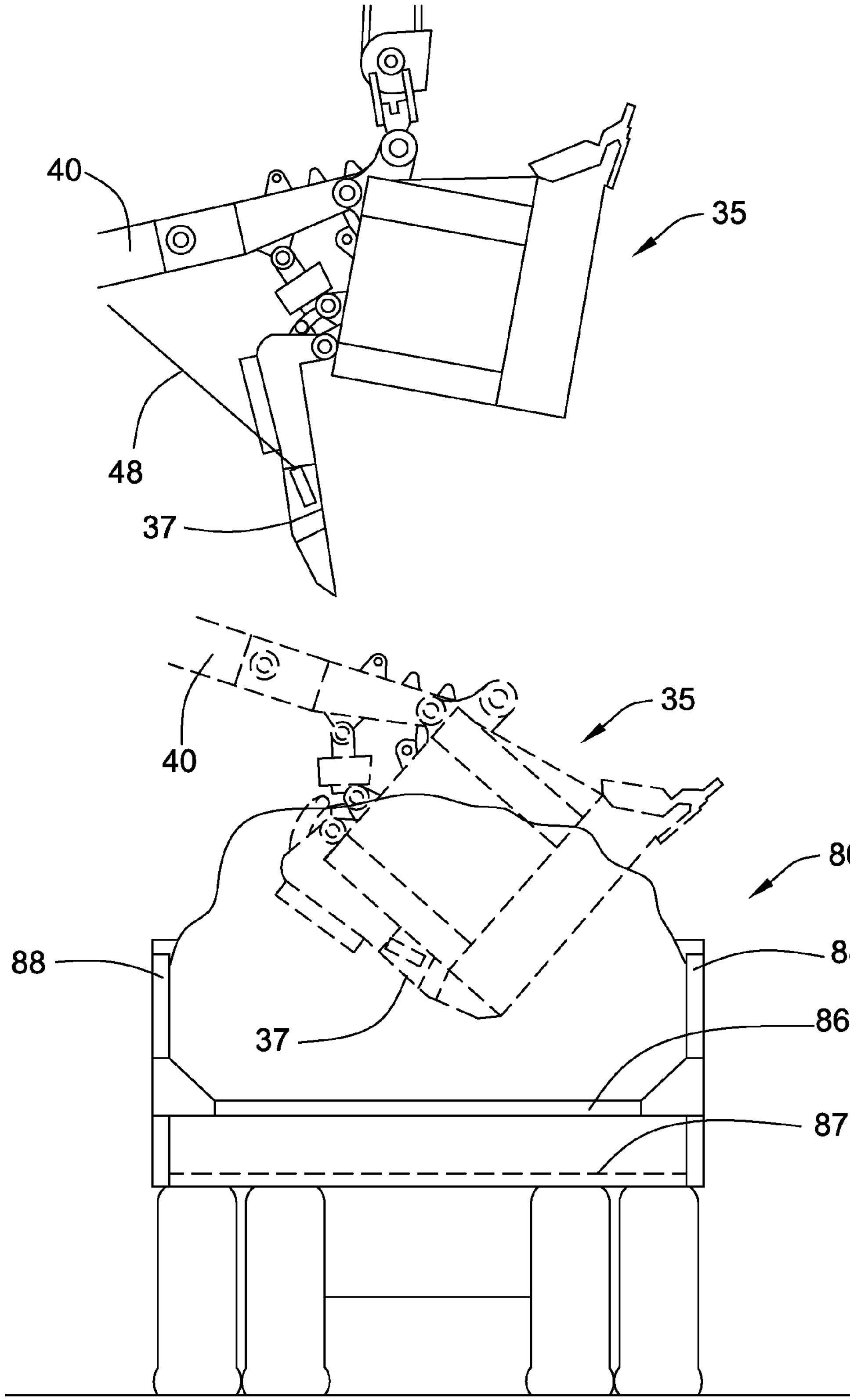

FIG. 3

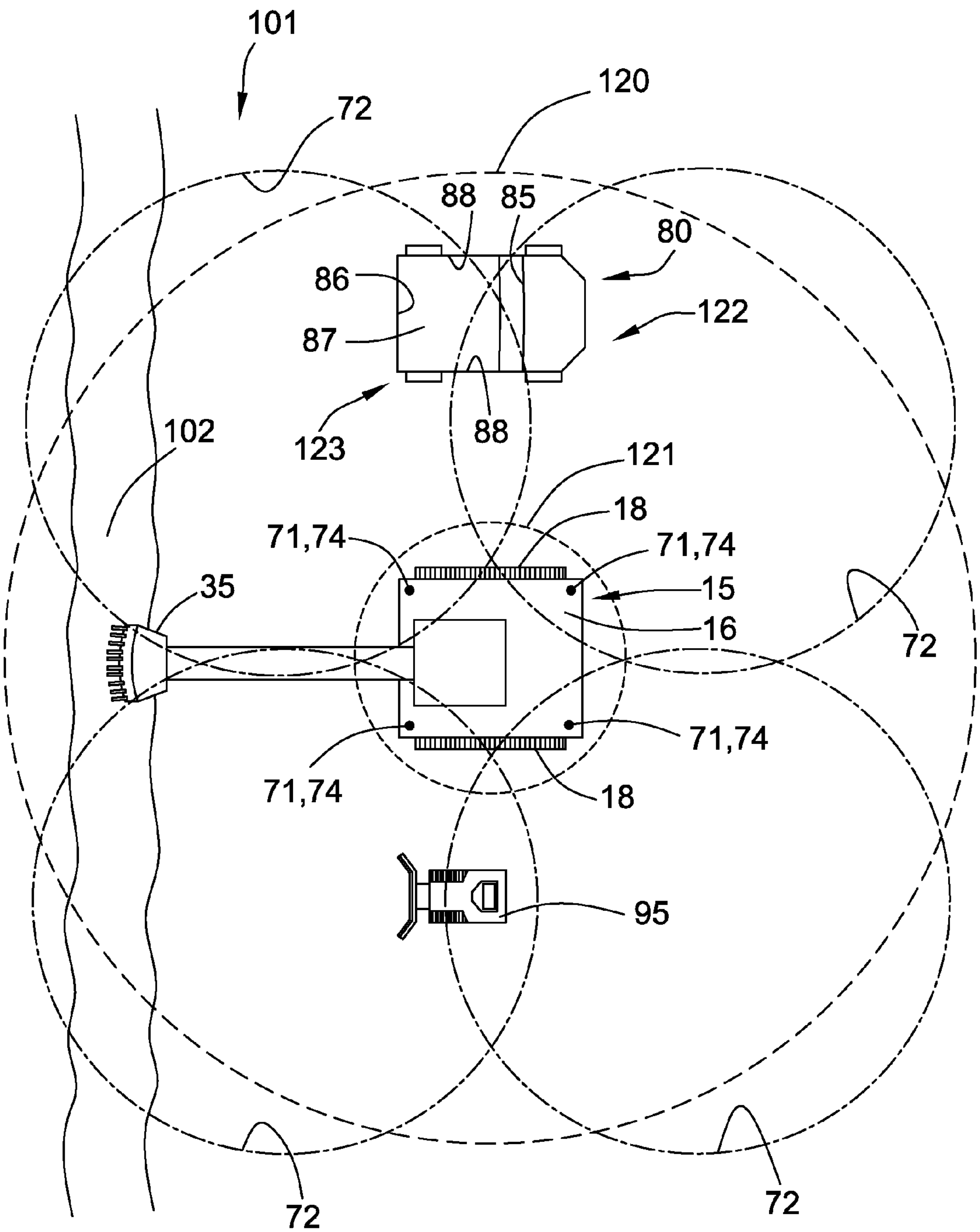
101
72
120
88
85
80
86
122
87
123
88
102
121
18
71,74
71,74
15
35
16
72
71,74
71,74
18
95
72
72

FIG. 4

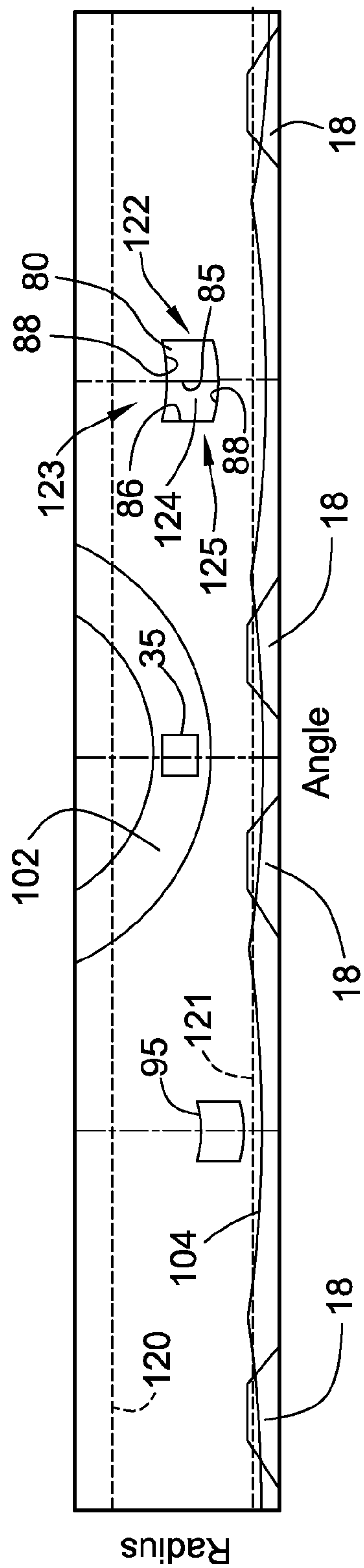
18
122
80
88
85
123
86
124
125
88
18
35
Angle
102
18
121
95
104
18
120
Radius

FIG. 5

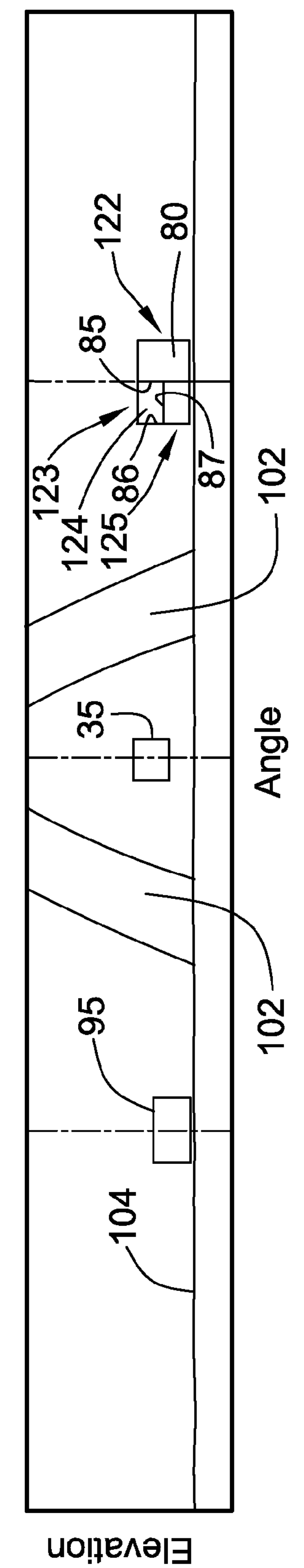
122
80
85
123
124
125
86
87
102
35
Angle
102
95
104
Elevation

FIG. 6

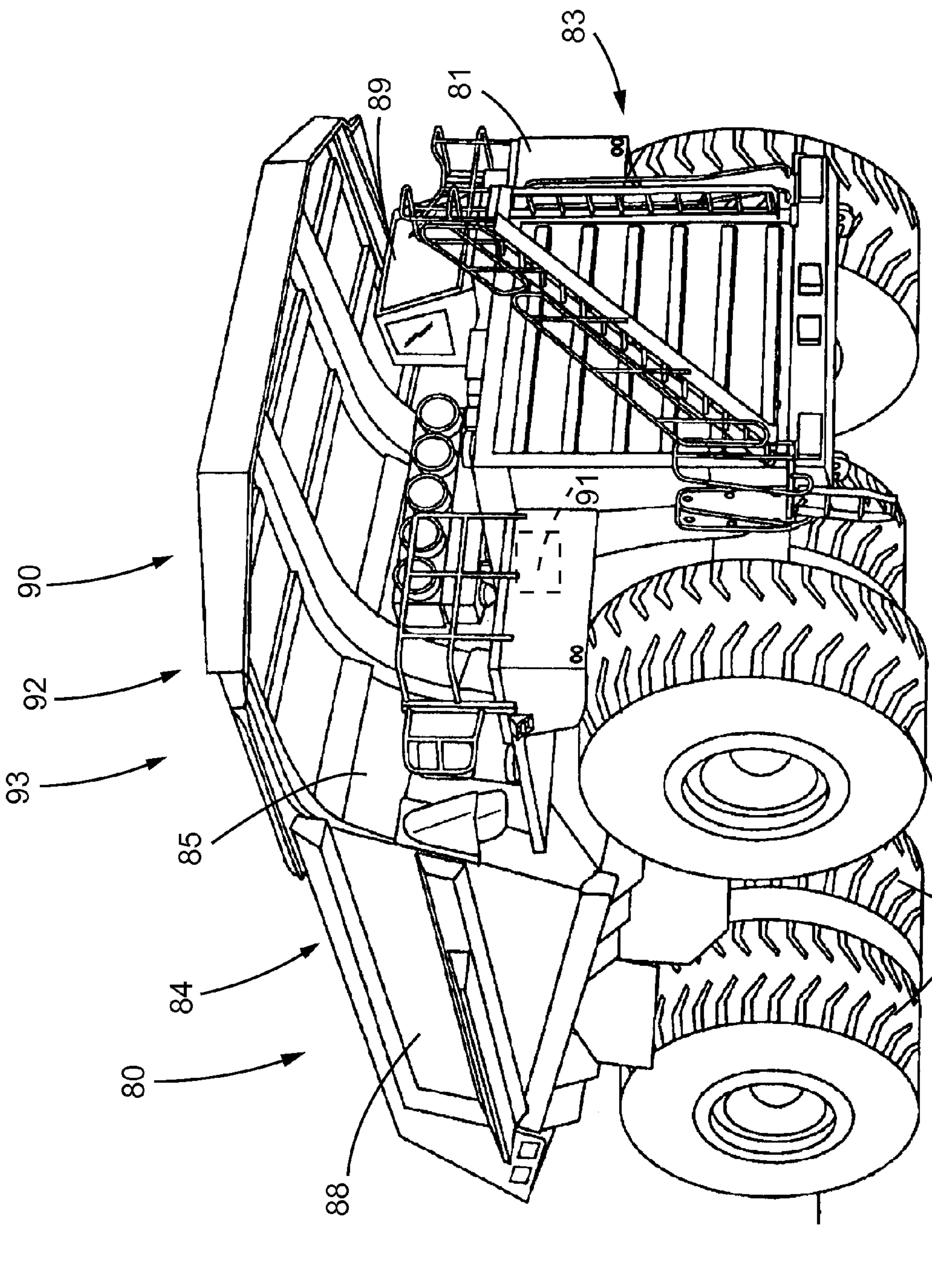

FIG. 7

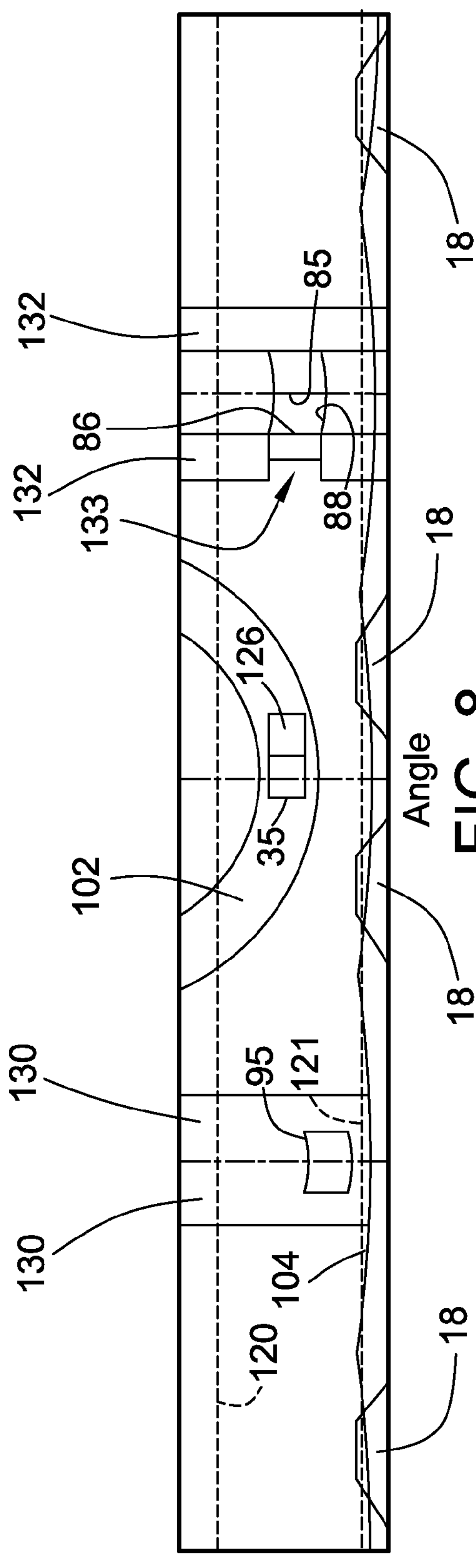
132
85
18
86
132
133
88
18
126
35
Angle
102
18
130
95
121
130
104
120
18
Radius

FIG. 8

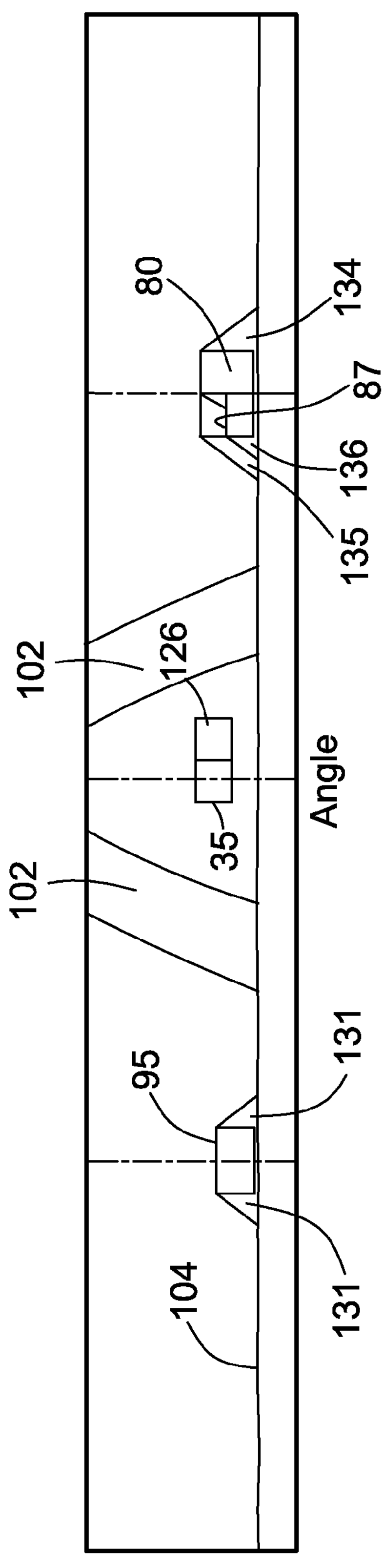
80
134
87
136
135
102
126
35
Angle
102
95
131
131
104
Elevation

FIG. 9

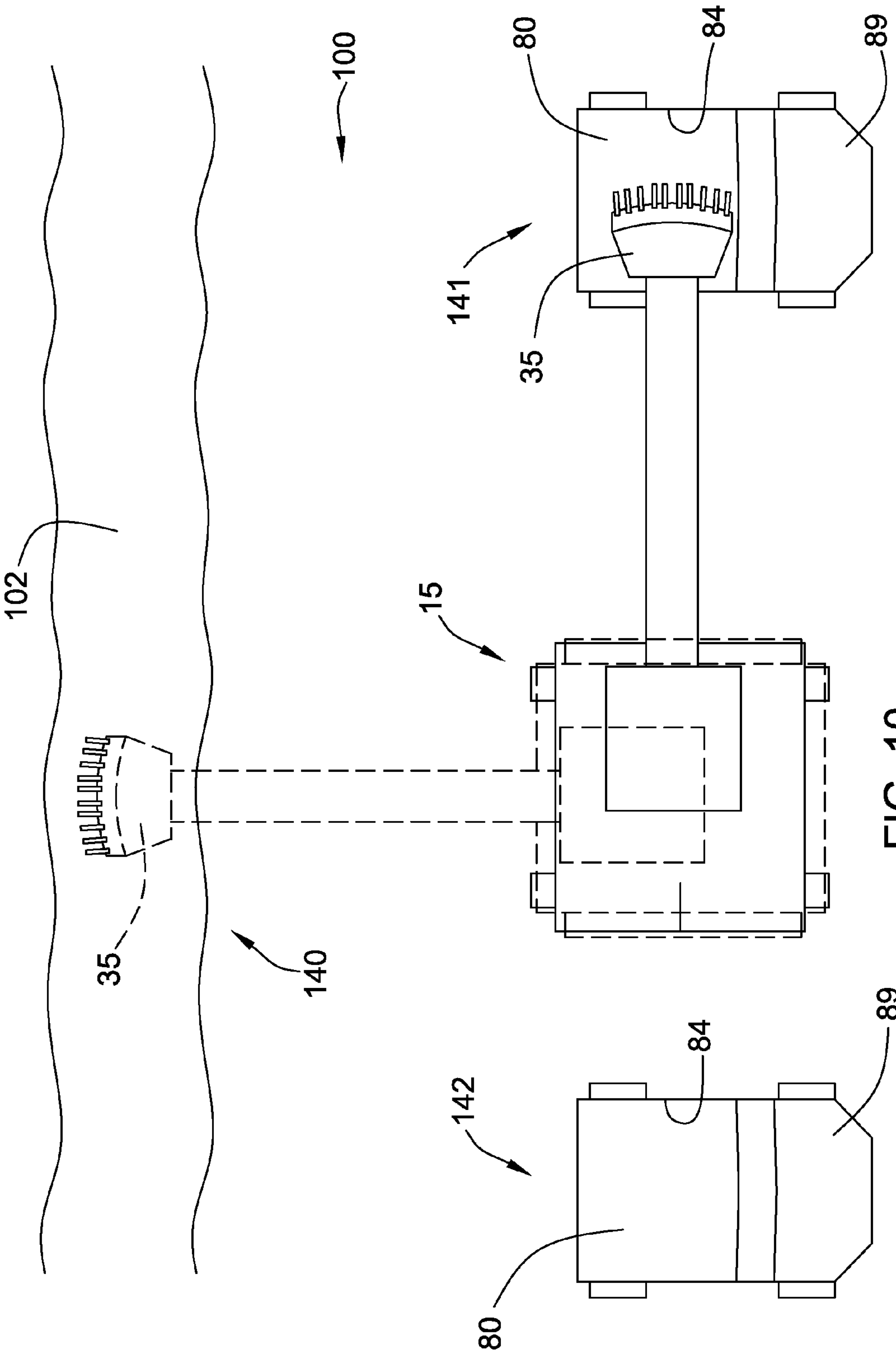

FIG. 10

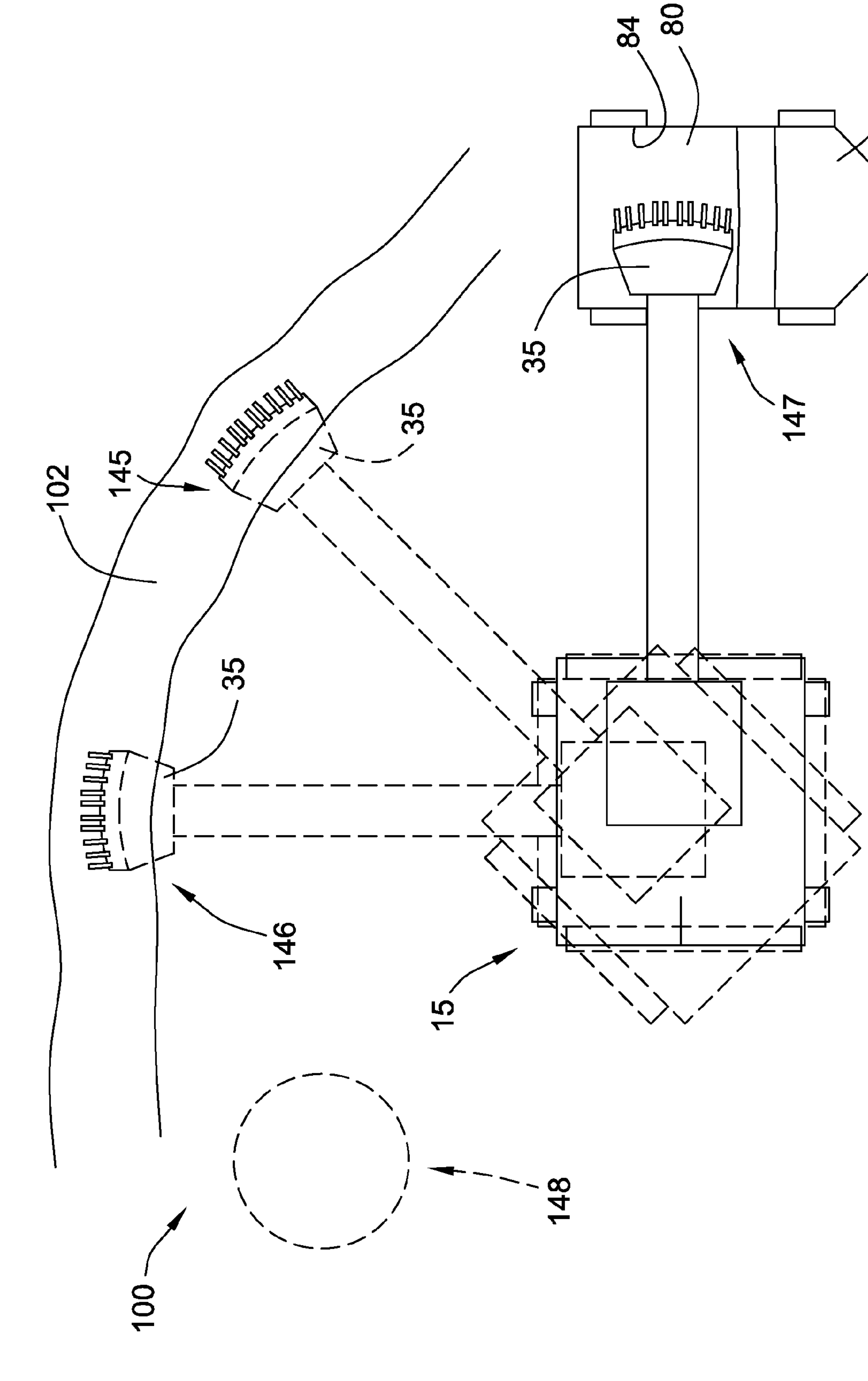

FIG. 11

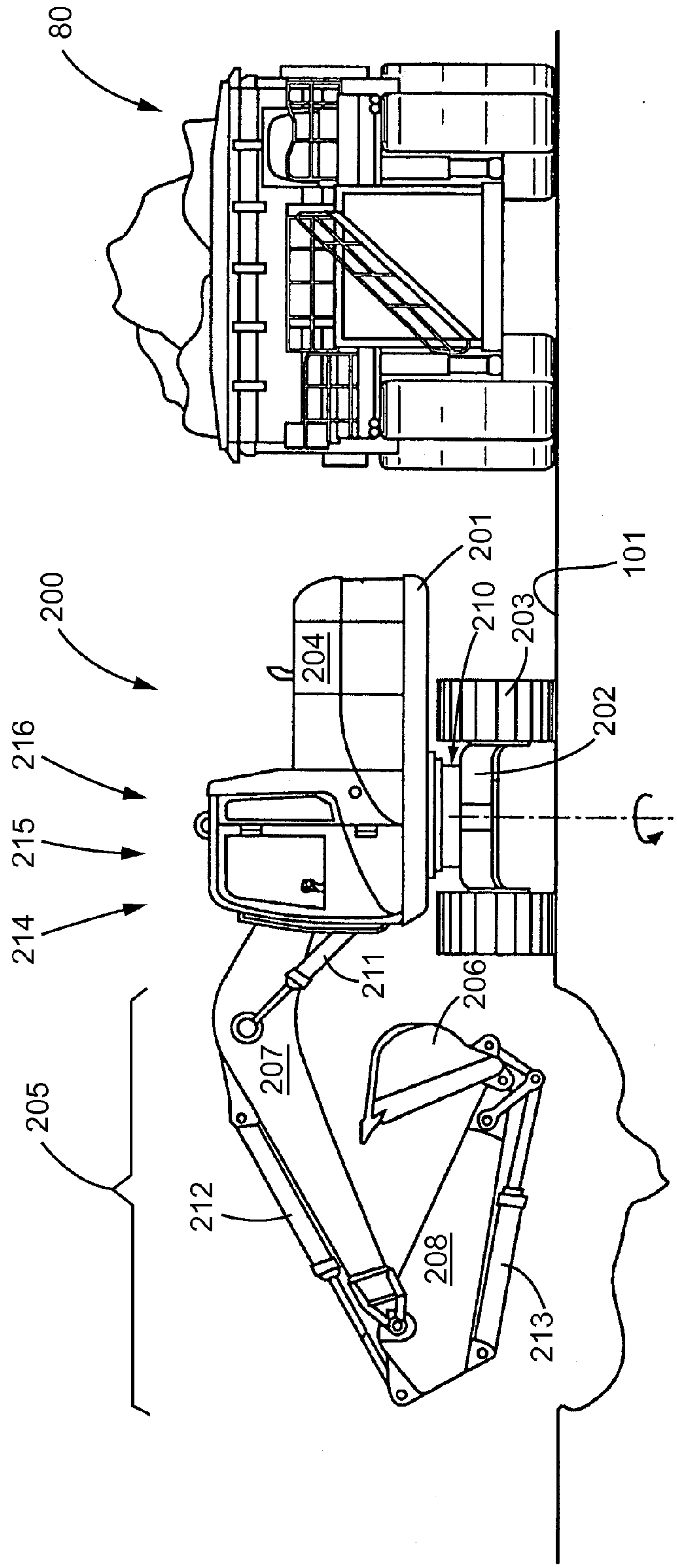
80
200
201
101
210
203
204
202
216
215
214
211
206
205
207
212
208
213

FIG. 12

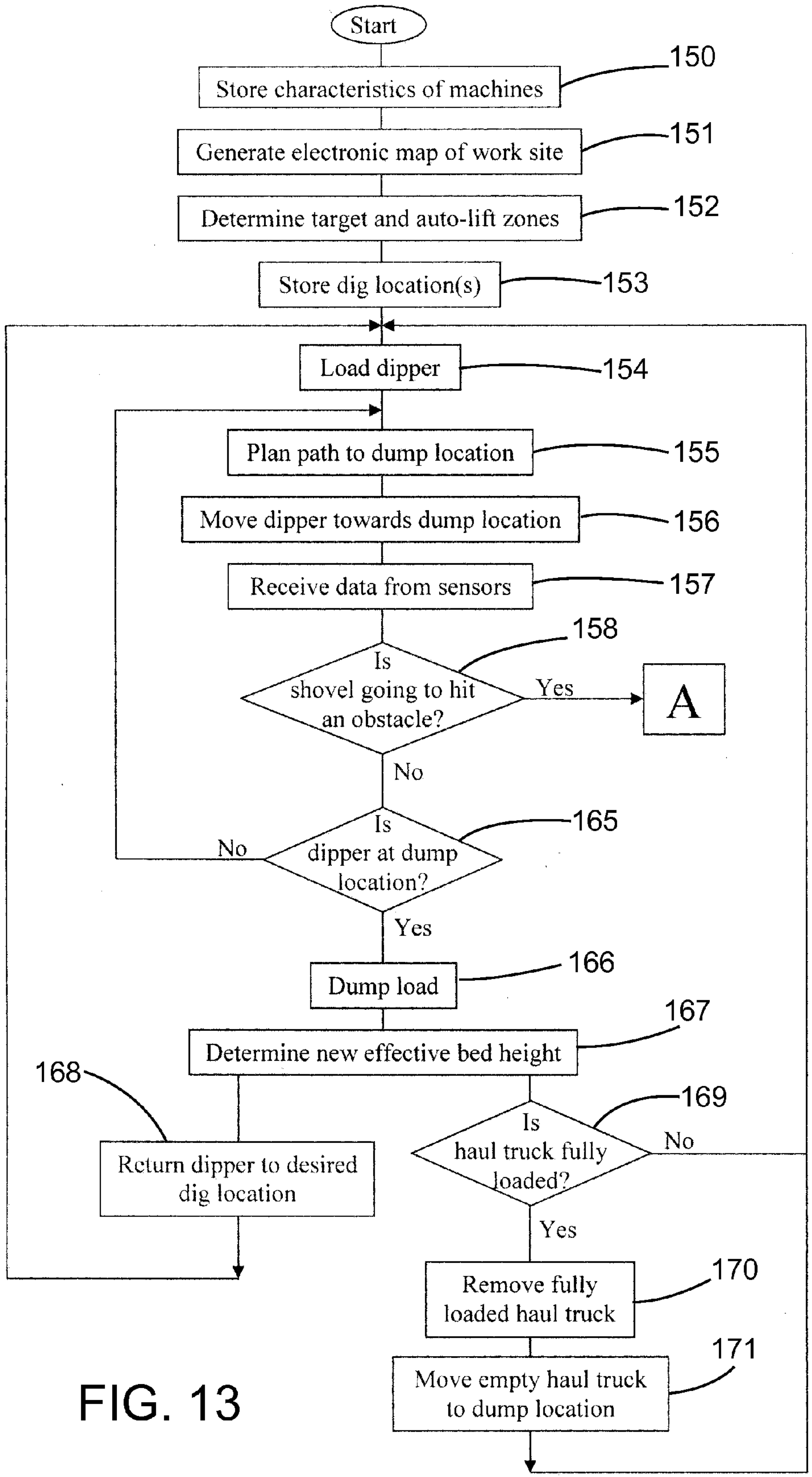
Start
Store characteristics of machines
150
Generate electronic map of work site
151
Determine target and auto-lift zones
152
Store dig location(s)
153
Load dipper
154
Plan path to dump location
155
Move dipper towards dump location
156
Receive data from sensors
157
Is shovel going to hit an obstacle?
158
Yes
A
No
Is dipper at dump location?
165
No
Yes
Dump load
166
Determine new effective bed height
167
168
Return dipper to desired dig location
Is haul truck fully loaded?
169
No
Yes
Remove fully loaded haul truck
170
Move empty haul truck to dump location
171

FIG. 13

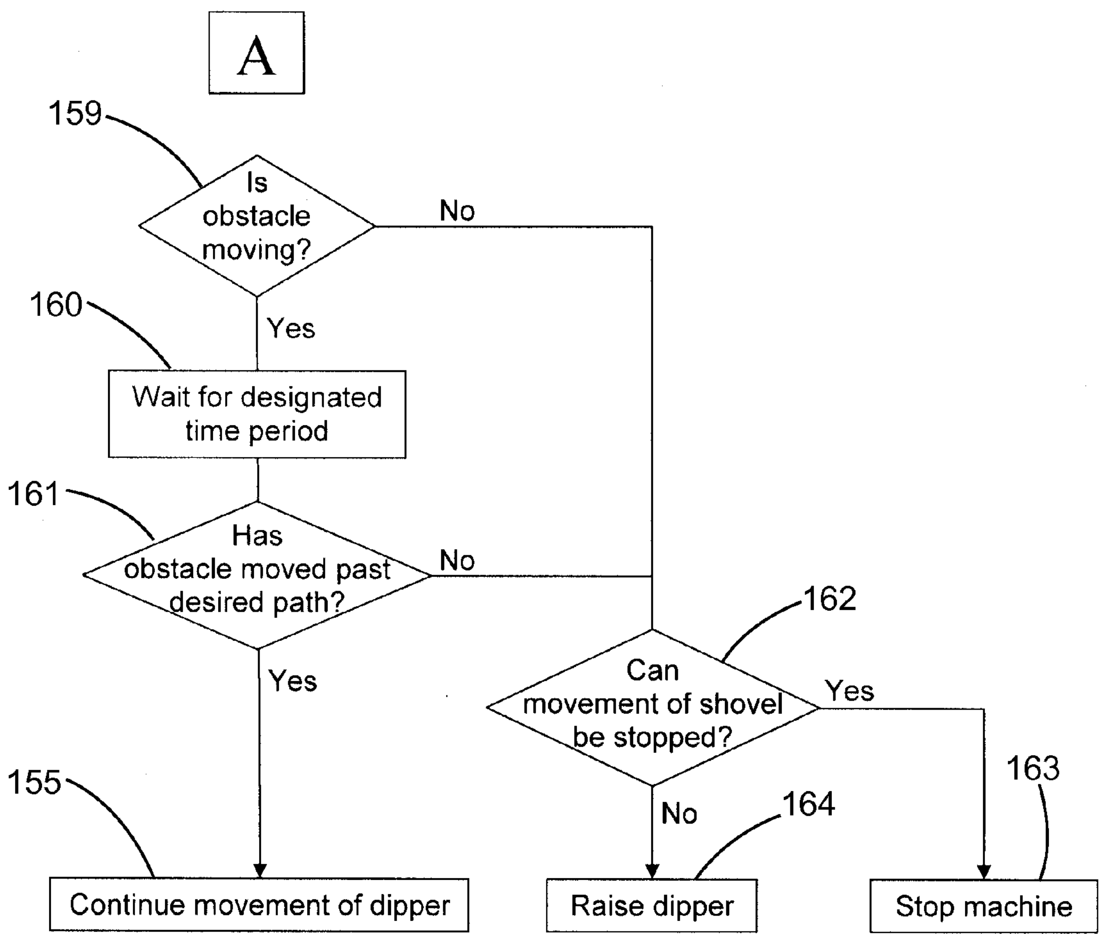
A
159
Is obstacle moving?
No
Yes
160
Wait for designated time period
161
Has obstacle moved past desired path?
No
Yes
162
Can movement of shovel be stopped?
Yes
No
155
Continue movement of dipper
164
Raise dipper
163
Stop machine

FIG. 14

CONTROL SYSTEM FOR A ROTATING MACHINE

TECHNICAL FIELD

[0001] This disclosure relates generally to controlling a machine and, more particularly, to a control system for controlling movement of a work implement while performing rotational material moving operations.

BACKGROUND

[0002] Machines for moving material such as a rope shovels, mining shovels, excavators, and backhoes may be configured for rotational movement to move material between locations at a work site. For example, machines with such rotational capabilities may dig material at a first location such as a dig site with a material engaging work implement and rotate the work implement to a second location such as a dump site at which the work implement is dumped or unloaded.

[0003] The machines may operate in an autonomous or semi-autonomous manner to perform these tasks in response to commands generated as part of a work plan for the machines. The machines may receive instructions in accordance with the work plan to perform operations at the work site, such as those related to mining, earthmoving, construction, and other industrial activities.

[0004] The process of digging material at the first location and dumping material at the second location may be repeated numerous times over the course of a desired time period. Control of such machines may be a complex task requiring a significant amount of skill on the part of an operator and may require the manipulation of multiple input devices. As an example, it is typically desirable to move the work implement in a consistent and controlled manner along the desired path between the first location and the second location.

[0005] U.S. Pat. No. 5,968,104 discloses a hydraulic excavator having an area limiting excavation control system. The area limiting excavation control system has a setting device permitting an operator to set an excavation area at which an end of a bucket is allowed to move. The area limiting excavation control system also includes angle sensors disposed at pivot points of a boom, an arm, and a bucket for detecting respective rotational angles and velocities thereof, a tilt angle sensor for detecting a tilt angle of the excavator's body in a fore/aft direction, and a pressure sensor for detecting a load pressure of the boom as it is moved upward in response to signals generated by a control lever.

[0006] The foregoing background discussion is intended solely to aid the reader. It is not intended to limit the innovations described herein, nor to limit or expand the prior art discussed. Thus, the foregoing discussion should not be taken to indicate that any particular element of a prior system is unsuitable for use with the innovations described herein, nor is it intended to indicate that any element is essential in implementing the innovations described herein. The implementations and application of the innovations described herein are defined by the appended claims.

SUMMARY

[0007] In one aspect, a system for controlling movement of a work implement of a machine between a dump location and a plurality of dig locations includes a rotatable implement system at a work site having a linkage assembly and the work implement, and an implement system pose sensor for generating implement system pose signals indicative of a pose of the implement system including a pose of the work implement. A controller is configured to store first dig signals from the implement system pose sensor indicative of a first dig location, store second dig signals from the implement system pose sensor indicative of a second dig location spaced from the first dig location and store a dump location. The controller is further configured to generate command signals to move the work implement from the first dig location to the dump location, generate command signals to dump a load of material carried by the work implement at the dump location, and generate command signals to move the work implement from the dump location to the second dig location.

[0008] In another aspect, a controller implemented method for controlling movement of a work implement of a machine between a dump location and a plurality of dig locations includes storing first dig signals from an implement system pose sensor associated with implement system the indicative of a first dig location, storing second dig signals from the implement system pose sensor indicative of a second dig location spaced from the first dig location, and storing a dump location. The method further includes generating command signals to move the work implement from the first dig location to the dump location, generating command signals to dump a load of material carried by the work implement at the dump location, and generating command signals to move the work implement from the dump location to the second dig location.

[0009] In still another aspect, a machine includes a rotatable base, a linkage assembly including a boom operatively connected to the rotatable base, a connecting member operatively connected to the boom, and a material moving work implement operatively connected to the connecting member, and an implement system pose sensor for generating implement system pose signals indicative of a pose of the implement system including a pose of the work implement. A dump body has a lower surface defining an initial bed height onto which material is dumped from the work implement and a bed height sensor generates bed height signals indicative of a bed height of the dump body. A controller is configured to store first dig signals from the implement system pose sensor indicative of a first dig location, store second dig signals from the implement system pose sensor indicative of a second dig location spaced from the first dig location and store a dump location. The controller is further configured to generate command signals to move the work implement from the first dig location to the dump location, generate command signals to dump a load of material carried by the work implement at the dump location, and generate command signals to move the work implement from the dump location to the second dig location.

BRIEF DESCRIPTION OF THE DRAWINGS

[0010] FIG. **1** depicts a schematic view of a work site at which a machine incorporating the principles disclosed herein may be used;

[0011] FIG. **2** depicts a diagrammatic illustration of a machine in accordance with the disclosure;

[0012] FIG. **3** depicts a diagrammatic illustration of a portion of the machine of FIG. **2** dumping a load of material into a haul truck;

[0013] FIG. **4** depicts a schematic view of a portion of the work site of FIG. **1**;

[0014] FIG. **5** depicts an exemplary graph of the portion of the work site of FIG. **4** plotting the radius as a function of angle in cylindrical coordinates;

[0015] FIG. **6** depicts an exemplary graph similar to FIG. **5** but plotting the elevation as a function of angle in cylindrical coordinates;

[0016] FIG. **7** depicts a diagrammatic illustration of a haul truck;

[0017] FIG. **8** depicts an exemplary graph similar to FIG. **5** but further depicting a stopping zone for the work implement and auto-lift zones for certain obstacles;

[0018] FIG. **9** depicts an exemplary graph similar to FIG. **8** but plotting the elevation is a function of angle in cylindrical coordinates;

[0019] FIG. **10** depicts a schematic view similar to FIG. **4** but utilizing a 2nd haul truck;

[0020] FIG. **11** depicts a schematic view similar to FIG. **4** but utilizing a 2nd dig location;

[0021] FIG. **12** depicts a diagrammatic illustration of an excavator and a haul truck in accordance with the disclosure;

[0022] FIG. **13** depicts a flowchart illustrating a material moving process in accordance with the disclosure; and

[0023] FIG. **14** depicts a flowchart illustrating a further aspect of the material moving process of FIG. **13**.

DETAILED DESCRIPTION

[0024] FIG. **1** depicts a diagrammatic illustration of a work site **100** at which one or more machines **10** may operate. Work site **100** may be a portion of a mining site, a landfill, a quarry, a construction site, a roadwork site, a forest, a farm, or any other area in which movement of machines is desired. As depicted, work site **100** includes an open-cast or open pit mine **101** having a face **102** from which material may be excavated or removed by a machine **10** such as a rope shovel **15** and loaded into a machine such as a haul truck **80**. The haul trucks **80** are depicted as traveling along a road **103** to dump location at which the material is dumped. Machines **10** such as dozers **95** may move material along a ground surface **104** near the rope shovel **15** as well as near or towards a crest such as an edge of a ridge **105**, embankment, high wall or other change in elevation. Face **102** and ground surface **104** may be collectively referred to herein as a work surface.

[0025] Referring to FIG. **2**, an exemplary rope shovel **15** is depicted. Rope shovel **15** includes a platform or base **16** rotatably mounted on an undercarriage or crawler **17**. The crawler **17** may include a ground engaging propulsion device such as a pair of tracks **18** that operate to propel and turn the rope shovel **15**. Base **16** may include a power unit, indicated generally at **19** and an operator station **20**. The power unit **19** provides or distributes electric and/or hydraulic power to various components of the rope shovel **15**. A swing motor, indicated generally at **21**, is operative to control the rotation of the base **16** relative to the crawler **17** about axis **22**.

[0026] A linkage assembly or implement system may be mounted on the base **16** and includes a boom **25** having a lower or first end **26** operative connected, such as by being fixedly mounted, to the base **16**. An A-frame **28** may be mounted on the based **16** and one or more support cables **29** may extend between the A-frame and an upper or second end **27** of the boom **25** to support the second end of the boom. A pair of spaced apart sheaves **30** may be mounted on the second end **27** of the boom **25**.

[0027] The linkage assembly may further include a material engaging work implement such as a bucket or dipper **35** fixedly mounted to a connecting member or dipper handle **40**. Dipper **35** may include a plurality of material engaging teeth **36** and a pivotable door **37** opposite the teeth to permit dumping or emptying of the dipper **35**. At a first closed position, the door **37** retains material in the dipper **35** and at a second open position (FIG. **3**), material may exit the dipper through the door.

[0028] A hoist cable **45** extends from a hoist drum **46** on base **16**, is supported by sheaves **30** on the second end **27** of boom **25**, and engages a bail or padlock **38** associated with the dipper **35**. Extension or retraction of the hoist cable **45** through rotation of a hoist motor, indicated generally at **47**, lowers or raises the height (i.e., the hoist) of the dipper **35** relative to a ground reference. Material within the dipper **35** may be released by opening the door **37** of the dipper through the use of an actuator cable **48** that extends between the door and an door actuator motor **49** on the base **16**.

[0029] Dipper handle **40** is generally elongated and is operatively connected to the boom **25**. More specifically, the dipper handle **40** is slidably supported within saddle block **41** and the saddle block is pivotably mounted on the boom **25**. Extension or retraction (also referred to as "crowd") of the dipper handle **40** may be controlled by a crowd control mechanism operatively connected to the dipper handle and the saddle block **41**. In one embodiment, the crowd control mechanism may include a double acting hydraulic cylinder **42** with one side of the hydraulic cylinder operatively connected to the dipper handle **40** and the other side operatively connected to the saddle block **41**. The crowd of the dipper handle **40** may thus be controlled by the operation of the hydraulic cylinder **42**. In a second embodiment (not shown), a crowd rope and a retract rope may be operatively connected to the dipper handle and routed around a crowd drum. Rotation of the crowd drum controls the crowd of the dipper handle **40**. In a third embodiment (not shown), a rack may be mounted on dipper handle and a drive pinion mounted on the saddle block. In the second embodiment, the crowd of the dipper handle **40** may be controlled by operation of the pinion.

[0030] Rope shovel **15** may include an operator station **20** that an operator may physically occupy and provide input to control the machine. The operator station **20** may include one or more input devices (not shown) that an operator may utilize to provide input to a control system, indicated generally at **55**, to control aspects of the operation of the rope shovel **15**. The operator station **20** may also include a plurality of display devices (not shown) to provide information to an operator regarding the status of the rope shovel **15** and material moving operations.

[0031] Control system **55** may include an electronic control module or controller **56** and a plurality of sensors. The controller **56** may receive input signals from an operator operating the rope shovel **15** from within operator station **20** or off-board the machine through a wireless communications system **110** (FIG. **1**). The controller **56** may control the operation of various aspects of the rope shovel **15** including positioning the dipper **35** and opening the door **37** of the dipper to dump a load of material.

[0032] The controller **56** may be an electronic controller that operates in a logical fashion to perform operations, execute control algorithms, store and retrieve data and other desired operations. The controller **56** may include or access memory, secondary storage devices, processors, and any other components for running an application. The memory and secondary storage devices may be in the form of read-only memory (ROM) or random access memory (RAM) or integrated circuitry that is accessible by the controller. Various other circuits may be associated with the controller **56** such as power supply circuitry, signal conditioning circuitry, driver circuitry, and other types of circuitry.

[0033] The controller **56** may be a single controller or may include more than one controller disposed to control various functions and/or features of the rope shovel **15**. The term “controller” is meant to be used in its broadest sense to include one or more controllers and/or microprocessors that may be associated with the rope shovel **15** and that may cooperate in controlling various functions and operations of the machine. The functionality of the controller **56** may be implemented in hardware and/or software without regard to the functionality. The controller **56** may rely on one or more data maps relating to the operating conditions and the operating environment of the rope shovel **15** and the work site **100** that may be stored in the memory of controller. Each of these data maps may include a collection of data in the form of tables, graphs, and/or equations.

[0034] The control system **55** and the controller **56** may be located on the rope shovel **15** and may also include components located remotely from the machine such as at a command center **111** (FIG. **1**). The functionality of control system **55** may be distributed so that certain functions are performed at rope shovel **15** and other functions are performed remotely. In such case, the control system **55** may utilize a communications system such as wireless communications system **110** for transmitting signals between the rope shovel **15** and a system located remote from the machine.

[0035] Rope shovel **15** may be equipped or associated with a plurality of sensors that provide data indicative (directly or indirectly) of various operating parameters of the machine. The term “sensor” is meant to be used in its broadest sense to include one or more sensors and related components that may be associated with the rope shovel **15** and that may cooperate to sense various functions, operations, and operating characteristics of the machine.

[0036] A pose sensing system **60**, as shown generally by an arrow in FIG. **2**, may include a pose sensor **61** to sense the position and orientation (i.e., the heading, pitch, roll or tilt, and yaw) of the rope shovel **15** relative to the work site **100**. The position and orientation of the rope shovel **15** are sometimes collectively referred to as the pose of the machine.

[0037] The pose sensor **61** may include a plurality of individual sensors that cooperate to generate and provide pose signals to controller **56** indicative of the position and orientation of the rope shovel **15**. In one example, the pose sensor **61** may include one or more sensors that interact with a positioning system such as a global navigation satellite system or a global positioning system to operate as a pose sensor. In another example, the pose sensor **61** may further include a slope or inclination sensor such as pitch angle sensor for measuring the slope or inclination of the rope shovel **15** relative to a ground or earth reference. The controller **56** may use pose signals from the pose sensors **61** to determine the pose of the rope shovel **15** within work site **100**. In other examples, the pose sensor **61** may include a perception based system, or may use other systems such as lasers, sonar, or radar to determine all or some aspects of the pose of rope shovel **15**.

[0038] If desired, the pose sensing system **60** may include distinct position and orientation sensing systems. In other words, a position sensing system (not shown) may be provided for determining the position of the rope shovel **15** and a separate orientation sensing system (not shown) may be provided for determining the orientation of the machine.

[0039] One or more implement sensors may be provided to monitor the position and status of the dipper **35**. More specifically, sensors may be provided to provide signals indicative of the position and other characteristics of the dipper **35**. A swing sensor **62** may be provided that generates swing signals indicative of the angle of the base **16** relative to the crawler **17**. In one example, the pose sensing system **60** may determine the pose of the base **16** and the swing sensor **62** may determine the angle of the crawler **17** relative to the base.

[0040] A hoist sensor **63** may be provided that generates hoist signals indicative of the height of the dipper **35** relative to the base **16**. The hoist signals may be based upon the position of the hoist cable **45**, the hoist drum **46**, and/or the hoist motor **47**. A door sensor **64** may be provided that generates door signals indicative of the status (i.e., open or closed) of the door **37** of the dipper **35**. A crowd sensor **65** may be associated with the boom **25**, dipper handle **40**, and/or saddle block **41**. The crowd sensor **65** may be configured to generate crowd signals indicative of the crowd or position (i.e., the extension or retraction) of the dipper handle **40** relative to the boom **25**.

[0041] Each of the sensors may embody any desired structure or mechanism. While described in the context of position sensors that may be used to determine the relative positions of the base **16**, crawler **17**, dipper **35**, and dipper handle **40**, some or all of the sensors may use another frame of reference such as a global navigation satellite system or a global positioning system. For example, one or more sensors may be similar to the pose sensor **61** and determine positions relative to an earth or another non-machine based reference.

[0042] Additional sensors may be provided on the rope shovel **15** including a weight or load sensor indicated generally at **66** for determining the weight or load of material within the dipper **35**, one or more inertial measurement units or acceleration sensors indicated generally at **67** for determining a rate of acceleration of various components of the rope shovel, and one or more inclination or pitch sensors **68** for determining the pitch of various components of the machine. In addition to determining information regarding the rope shovel **15** directly (e.g., by using acceleration sensor **67** to determine acceleration or using a pitch sensor **68** to determine pitch), the sensors may be used to determine additional information regarding the performance of the machine indirectly (e.g., by using the acceleration sensor to determine velocity or the pitch sensor to determine pitch rate).

[0043] The positions of the components of the rope shovel **15** including base **16**, boom **25**, dipper **35** and dipper handle **40** may be determined based upon the kinematic model of the rope shovel together with the dimensions of the base **16**, crawler **17**, dipper **35**, and dipper handle **40**, as well as the relative positions between the various components. More specifically, the controller **56** may include a data map that identifies the position of each component of the rope shovel **15** based upon the relative positions between the various components. The controller **56** may use the dimensions and the positions of the various components to generate and store therein a three-dimensional electronic map of the rope shovel **15** at the work site **100**. In addition, by knowing the speed or acceleration of certain components, the speed or acceleration of other components of the rope shovel **15** may be determined.

[0044] The control system **55** may also include a terrain mapping system **70** positioned on or associated with rope shovel **15** to scan work site **100** and map the work surface surrounding the rope shovel as well as any obstacles at the work site. The terrain mapping system **70** may include one or more perception or perception sensors **71** (FIG. **4**) that may scan work site **100** to gather information defining the work surface thereof. More specifically, perception sensors **71** may determine the distance and direction from the perception sensors **71** to points that define a mapped surface such as the work surface as well as obstacles at the work site **100**. The field of view of each perception sensor **71** is depicted schematically at **72**.

[0045] The obstacles may embody any type of object including those that are fixed or stationary as well as those that are movable or that are moving. Examples of fixed obstacles may include infrastructure, storage, and processing facilities, buildings, trees, and other structures and fixtures found at a work site **100**. Examples of movable obstacles may include machines such as haul trucks **80**, light duty vehicles (such as pick-up trucks and cars), personnel, and other items that may move about work site **100**.

[0046] Mapping or perception sensors **71** may be mounted on rope shovel **15** such as at four corners of the machine as depicted in FIG. **4**. In other examples, perception sensors **71** may be mounted at other locations on the rope shovel **15**, on other machines, or mounted in fixed locations at the work site **100**. Perception sensors **71** may embody LIDAR (light detection and ranging) devices (e.g., a laser scanner), RADAR (radio detection and ranging) devices, SONAR (sound navigation and ranging) devices, cameras, and/or other types of devices that may determine the range and direction to objects and/or attributes thereof. Perception sensors **71** may be used to sense the range, the direction, the color, and/or other information or attributes about detected objects and the work surface and generate mapping signals indicative of such sensed information and attributes.

[0047] An object identification system, shown generally at **73**, may be mounted on or associated with the rope shovel **15** in addition to the terrain mapping system **70**. In some instances, the terrain mapping system **70** and the object identification system **73** may be integrated together. Object identification sensors **74** may generate data that is received by the controller **56** and used by the controller to determine the type of obstacles detected by the object identification system **73**. The object identification sensors **74** may be part of the perception sensors **71** and thus are depicted schematically as the same components in FIG. **4**. In an alternate embodiment, the object identification sensors may be separate components from the perception sensors **71**.

[0048] The sensed data generated by the perception sensors **71** may be used by the terrain mapping system **70** to generate an electronic three-dimensional terrain map of the work site **100**. The terrain map may be overlaid or stored as a three-dimensional electronic map of the work site **100** and include the three-dimensional map of the rope shovel **15**. In one example, the electronic map may be stored within controller **56** and/or an offboard controller.

[0049] The data or data points defining the electronic map of the work site **100** may be generated by the terrain mapping system **70** of rope shovel **15**, by one or more machines having a terrain mapping system, or by a combination of the rope shovel and other machines. Regardless of the manner in which the electronic map is initially generated, data collected by the terrain mapping system **70** of the rope shovel **15** and/or other machines having terrain mapping systems may be subsequently used to update the electronic map.

[0050] Other or additional systems may be used to identify the position or location of obstacles at the work site **100** and generate data to be stored within the electronic map of the work site **100**. In one example, machines at the work site **100** may each include a pose sensing system similar or identical to the pose sensing system **60** of rope shovel **15**. For example, a plurality of haul trucks **80** may be operating at work site **100**.

[0051] An example of a haul truck **80** is depicted in FIG. **7**. Haul truck **80** may include a frame **81** supported by one or more traction devices **82** and a propulsion system for propelling the traction devices. The propulsion system may include a prime mover, as shown generally at **83**, and a transmission (not shown) operatively connected to the prime mover. Haul truck **80** may include a pivotable dump body **84** into which material may be loaded and from which material may be subsequently dumped. Referring to FIG. **4**, dump body includes a front wall **85**, a rear wall **86**, a lower surface **87**, and a pair of opposite sidewalls **88** that extend between and connect the front and rear walls. A cab or operator station **89** may be included that an operator may physically occupy and provide input to operate the haul truck **80**.

[0052] As with rope shovel **15**, haul truck **80** may include a control system **90** and a controller **91** similar to those of rope shovel **15** and the descriptions thereof are not repeated. Haul truck **80** may include various systems and sensors for efficient operation of the machine such as a pose sensing system **92** generally similar to that of rope shovel **15** and a load sensing system generally indicated at **93** to sense the load or amount of material within the dump body **84**.

[0053] The pose sensing system **92** of haul truck **80** may operate in a manner similar to pose sensing system **60** of rope shovel **15**. The pose of the haul truck **80** may be communicated directly to the rope shovel **15** or to a remote system and the information entered or stored within the electronic map of the work site **100**. Dimensions of the haul truck **80** may be determined or communicated and an electronic model of the truck may be added to the electronic map. In one embodiment, identifying information such as a code may also be transmitted from the haul truck **80** with the pose information.

[0054] A data map within controller **56**, either at rope shovel **15** or at a remote location, may utilize the identifying code to determine the dimensions of the haul truck **80** and generate an electronic model of the haul truck based upon the pose of the truck and its dimensions. In another embodiment, the identifying information that accompanies the pose information may also include the dimensions of the truck. In still another embodiment, the dimensions of each type of machine that may be operating at the work site **100** may be stored within controller **56**. For example, a list of potential haul trucks **80** that may be operating at the work site **100** together with their dimensions may be stored within controller **56**. Upon determining that an obstacle is within a predetermined distance or proximity of the rope shovel **15**, the object identification system **73** may identify the type of haul truck and utilize its stored dimensions to generate an electronic model that is stored within the electronic map.

[0055] The electronic map may be configured in any desired manner. In one example, the electronic map may be configured to store the data in a cylindrical coordinate system with the central axis of the cylindrical coordinate system corresponding to the axis **22** of the rope shovel **15**. For example, referring to FIG. **4**, a portion of work site **100** is depicted with rope shovel **15**, haul truck **80**, and dozer **95** adjacent a face **102** of the open pit mine **101**. In FIGS. **5-6**, the rope shovel **15**, haul truck **80**, dozer **95**, and face **102** of FIG. **4** are depicted in a cylindrical coordinate system about axis **22** with the y-axis of FIG. **5** depicting the radius from the axis **22** and the y-axis of FIG. **6** depicting the elevation relative to a ground surface **104**. In both instances, the x-axis depicts the position or angle about axis **22** and a horizontal position opposite the dipper **35** corresponding to both zero and 360 degrees.

[0056] Comparing FIG. **4** to FIGS. **5-6**, one-to-one correspondence between many of the components, elements, or features of FIG. **4** may be found. For example, face **102** of the mine **101** is depicted in both FIGS. **5-6** and ground surface **104** is depicted as being slightly above the x-axis in both FIGS. **5-6** for clarity. The outer limit **120** of the reach of dipper **35** is depicted in FIGS. **4-5** but not in FIG. **6**.

[0057] Dipper **35** is spaced from the axis **22** and thus is depicted above the x-axis in FIG. **5**. Although not visible in FIG. **4**, the dipper **35** is elevated above the ground surface **104** and thus is depicted in FIG. **6** above the ground surface.

[0058] Various obstacles adjacent the rope shovel **15** are also depicted in FIGS. **5-6**. Portions of the base **16** may contact obstacles adjacent the rope shovel **15** while the rope shovel is rotating about axis **22**. In addition, in some instances, it may be possible for the dipper **35** to contact the base **16**. Accordingly, a keep-out zone **121** corresponding to an outer path of travel of the base **16** relative to axis **22** is depicted in FIGS. **4-5**. The keep-out zone **121** is not depicted in FIG. **6**. The tracks **18** may also be obstacles since it is possible for the dipper **35** to contact them under certain circumstances. The tracks **18** are depicted in FIGS. **4-5** but not in FIG. **6**.

[0059] Haul truck **80** includes portions that are obstacles and also a portion that is a target zone for the dipper **35**. More specifically, the forward portion of the haul truck **80**, including the operator station **89**, is depicted at **122**. The rearward portion **123** of the haul truck may be divided into two sections with the dump body **84** depicted as the target zone **124** and the remainder as an obstacle **125**. More specifically, the dump body **84** may be seen in FIGS. **4-6** as being defined by front wall **85**, rear wall **86**, lower surface **87**, and sidewalls **88**. As best seen in FIG. **5**, the cylindrical coordinate boundaries of the target zone **124** are defined in one direction by sidewalls **88** that define the radial boundary, and in a perpendicular direction by the front wall **85** and rear wall **86** that define the circumferential boundary. The elevation component of the target zone **124** is defined by the lower surface **87** of the dump body **84** as well as the upper surfaces of the each of the front wall, **85**, rear wall **86**, and sidewalls **88**.

[0060] Dozer **95** is depicted in FIG. **5** as an obstacle spaced from the axis **22** and has a height beginning at ground surface **104**.

[0061] Rope shovel **15** may be configured to be operated autonomously, semi-autonomously, or manually. When operating semi-autonomously or manually, rope shovel **15** may be operated by remote control and/or by an operator physically located within the operator station **20**. As used herein, a machine operating in an autonomous manner operates automatically based upon information received from various sensors without the need for human operator input. As an example, a haul truck that automatically follows a path from one location to another and dumps a load at an end point may be operating autonomously. A machine operating semi-autonomously includes an operator, either within the machine or remotely, who performs some tasks or provides some input and other tasks are performed automatically and may be based upon information received from various sensors. As an example, a haul truck that automatically follows a path from one location to another but relies upon an operator command to dump a load may be operating semi-autonomously. In another example of a semi-autonomous operation, an operator may dump a dipper or bucket of a rope shovel **15** or an excavator **200** (FIG. **12**) into a haul truck **80** and a controller **56** may automatically return the dipper or bucket to a position to perform another digging operation. A machine being operated manually is one in which an operator is controlling all or essentially all of the functions of the machine. A machine may be operated remotely by an operator (i.e., remote control) in either a manual or semi-autonomous manner.

[0062] Control system **55** may include a module or planning system, indicated generally at **75** in FIG. **2**, for determining or planning various aspects of a material moving operation. The planning system **75** may utilize various types of inputs from the sensors associated with the rope shovel **15** as well as the electronic map of the work site **100** including the configuration of the work surface, the position of the rope shovel, the position and movement of any obstacles adjacent the rope shovel, desired or proposed dig location(s), desired or proposed dump locations(s), and the characteristics of the material to be moved. Capabilities and desired operating characteristics and capabilities of the rope shovel **15** as well as its kinematic model may also be stored within controller **56** and used by the planning system **75**. The planning system **75** may simulate and evaluate any aspect of a material moving operation, such as by evaluating a plurality of potential paths between the current location of the dipper **35** and a target zone, and then select (or provide feedback regarding) a proposed dig location, dump location, and/or the path between the dig location and the dump location that creates the most desirable results based upon one or more criteria.

[0063] One example of a desired operating characteristic, the controller **56** may be configured to minimize changes in direction such as only moving each of the swing, crowd, and hoist of the linkage assembly in a single direction during a material moving cycle or operation. In another example of a desired operating characteristic, the planning system **75** may be configured to avoid passing over any obstacles at the work site, if possible. In other words, while swinging the base **16** and the linkage assembly, the planning system **75** may move the dipper **35** and dipper handle **40** to a desired hoist and crowd, respectively, and continued to swing the dipper over the dump body **84** while generally maintaining the hoist until opening the door **37** of the dipper during the dumping process.

[0064] The planning system **75** may be utilized regardless of whether the rope shovel **15** is being operated autonomously, semi-autonomously, or manually. When operating the rope shovel **15** manually, the planning system **75** may provide suggestions for dig locations, dump locations, and paths therebetween. When operating autonomously or semi-autonomously, the planning system **75** may determine, and the controller **56** may generate, commands to direct the dipper **35** to the desired location or in a desired manner such as by controlling the rotation of the base **16** relative to the crawler **17**, the movement of the dipper handle **40** relative to the boom **25**, and the height of the dipper **35**. Such commands may control both the speed and acceleration (and deceleration) of each type of movement of the rope shovel **15** (i.e., rotation, crowd, and hoist).

[0065] In view of the size of the rope shovel **15** and the large payloads that may be carried within the dipper **35**, it may be difficult or even impossible to stop the rope shovel quickly. For example, rope shovel **15** may be a massive machine with a dipper **35** capable of carrying a payload of greater than 100 tons of material. Accordingly, the planning system **75** may generate a stopping zone **126** (FIGS. **5-6**) within the electronic map through which components of the rope shovel **15** may travel by predicting the path or motion of the rope shovel based upon its speed, acceleration, and mass (including a payload) in the absence of additional inputs. In other words, the stopping zone **126** may identify an anticipated path of the machine based upon the machine's momentum.

[0066] The planning system **75** may also generate auto-lift zones within the electronic map adjacent obstacles to provide an additional safety factor. More specifically, an auto-lift zone may be defined adjacent each obstacle so that if the dipper **35** or dipper handle **40** enters the zone, the controller **56** may automatically lift or raise the dipper in an attempt to raise the dipper over the obstacle rather than it continuing into contact with the obstacle. The size of each auto-lift zone may be a function of the obstacle, the payload within the dipper **35**, and the velocity of the dipper. Referring to FIGS. **8-9**, a first radial auto-lift zone **130** is positioned on opposite sides of the dozer **95** and a first elevation auto-lift zone **131** is positioned on opposite sides of the dozer.

[0067] If the dipper **35** approaches the dozer **95** from either direction as the dipper is being swung, it will approach the first radial auto-lift zone **130** (FIG. **8**) and the controller **56** may generate commands to cause the dipper to be raised. If the dipper **35** is higher than the first elevation auto-lift zone **131** (FIG. **9**), the dipper may pass over the dozer **95** without any action by the controller **56** or an operator. It should be noted that the elevation auto-lift zones are angled upward from the ground surface **104** since the urgency of raising the dipper **35** may be a function of the distance from the obstacle and the increase in elevation necessary to avoid the obstacle.

[0068] A second radial auto-lift zone **132** is positioned on opposite sides of the haul truck **80**. An opening **133** extends partially through the second radial auto lift zone **132** in alignment with the dump body **84**. A second elevation auto-lift zone **134** is positioned on opposite sides of the haul truck **80** and is associated with one of the second radial auto-lift zones **132** except along the opening **133**. At the opening **133**, a third elevation auto-lift zone **135** is positioned on the left side of the haul truck as viewed in FIGS. **8-9**.

[0069] If the dipper **35** approaches the haul truck **80** from the right as viewed in FIGS. **8-9** as the dipper is being swung, it will approach the second radial auto-lift zone **132** (FIG. **8**) to the right of the haul truck and the controller **56** may generate commands to cause the dipper to be raised. If the dipper **35** is higher than the second elevation auto-lift zone **134** (FIG. **9**), the dipper may pass over the haul truck **80** without any action by the controller **56** or an operator.

[0070] If the dipper **35** approaches the haul truck **80** from the left as viewed in FIGS. **8-9** as the dipper is being swung and it is above the third elevation auto-lift zone **135** (FIG. **9**) regardless of its radial position, the dipper may pass over the haul truck **80** without any action by the controller **56** or an operator. If the dipper **35** approaches the haul truck **80** from the left and is aligned with either of the second radial auto-lift zones **132**, the controller **56** may determine whether the dipper is above the third elevation auto-lift zone **135**. If the dipper is not above the third elevation auto-lift zone **135**, the controller **56** may generate commands to cause the dipper to be raised.

[0071] If the dipper **35** approaches the haul truck **80** from the left and is aligned with the opening **133**, the controller **56** may determine whether the dipper is above the fourth elevation auto-lift zone **136**. If the dipper is not above the fourth elevation auto-lift zone **136**, the controller **56** may generate commands to cause the dipper to be raised.

[0072] In order to improve the material moving process (regardless of whether it is being performed autonomously, semi-autonomously, or manually), a re-spotting or re-positioning system, indicated generally at **76** in FIG. **2**, may be provided to identify instances in which it is desirable to re-position a haul truck **80** prior to dumping a load of material. For example, it may be desirable for the dipper **35** to enter the space or target zone at the dump body **84** by moving over the rear wall **86** with the dipper at an angle and between the sidewalls **88** as depicted in phantom in FIG. **3**. Still further, it may be desirable for a lower portion of the dipper **35** to travel or pass over the rear wall **86** but be positioned lower than an upper surface of the sidewalls **88** as depicted in FIG. **3**. As such, the window or target into which it is desired to move the dipper **35** may be relatively small.

[0073] In some instances it may be desirable to generally center the dipper **35** between the front wall **85** and rear wall **86** of the dump body but position the dipper closer to the sidewall closest to the rope shovel **15** as depicted in FIGS. **10-11**. Upon beginning the dumping process, the controller **56** may generate commands to pull the actuator cable **48** and also extend or crowd out the dipper handle **40** to further increase the force applied to the actuator cable. By positioning the dipper **35** closer to the sidewall **88** nearest the rope shovel **15**, the dipper may be crowded out without engaging the sidewall farthest from the rope shovel.

[0074] The re-positioning system **76** may be configured to analyze the pose of a haul truck **80** and the pose and kinematic model or capabilities of the rope shovel **15**, as well as the location of any additional obstacles at the work site **100**, to determine whether the dipper **35** may be efficiently and/or safely moved to the target zone at the dump body **84** and dumped or whether it is desirable to re-position of the haul truck prior to dumping. For example, the controller **56** may determine a plurality of paths that the dipper **35** may travel from its current location (as determined by the pose of the rope shovel **15**) to the target zone at the dump body **84** based upon the kinematic model of the implement system and the desired operating characteristics of the implement system.

[0075] In one example, the haul truck **80** may be too close to the base **16** of rope shovel **15** (i.e., within keep-out zone **121**) so that rotation of the base during the loading process would cause a collision or the dipper **35** cannot be maneuvered into the desired loading position generally centered between the front wall **85** and rear wall **86** in a first direction and between the sidewalls **88** in a second direction, with the second direction being generally perpendicular to the first direction.

[0076] In another example, the haul truck **80** may be too far away from the rope shovel **15** so that the dipper **35** may not be centered relative to the dump body **84** even if the dipper handle **40** is fully extended or crowded out (i.e., outside the outer limit **120** of the reach of the dipper). In still another example, the haul truck **80** may be positioned too far forward or too far rearward and at an angle such that the dipper **35** cannot enter the target zone or space above the dump body **84** along the center of the rear wall **86** (FIG. **3**).

[0077] In a further example, the haul truck **80** may be positioned at a location in which the dipper **35** may be positioned as desired above the dump body **84** but the haul truck is positioned at a location relatively far from the dig location. In such case, it may be desirable to re-position the haul truck **80** so that the time spent by the rope shovel **15** swinging between the dig and dump positions is reduced, thus increasing the efficiency of the material loading process.

[0078] If the re-positioning system **76** analyzes the pose of the haul truck **80** and the pose and kinematic model of the rope shovel **15** (or the pose of the boom **25**) and determines that it is desirable to re-position the haul truck **80**, the operator of the haul truck may be instructed to re-position the haul truck at a new location or a new orientation.

[0079] In some instances, the re-positioning system **76** may be configured to operate based upon the position or pose of any portion of the implement system together with the kinematic model of the implement system without the pose of the entire rope shovel **15** or even the pose of the dipper **35**. In doing so, the controller **56** may determine the position or pose of a portion of the implement system and determine all possible locations for the dipper **35** based upon the position of the portion of the implement system. The controller **56** may then analyze potential paths of the dipper **35** to the target zone based for each of the possible locations of the dipper **35** together with the kinematic model of the implement system and the desired operating characteristics of the implement system. For example, if the position of the boom **25** is known, the controller **56** may determine all possible positions for the dipper **35** and the dipper handle **40**. The controller may then determine potential paths of the dipper **35** to the target zone based upon each possible position of the dipper.

[0080] The instructions to re-position the haul truck **80** may take any desired form. In one example, the instructions may be provided as an alert command between the controller **56** of rope shovel **15** and controller **91** of haul truck **80**. The instructions may result in a written communication on a display within the haul truck **80**, another type of visual indication such as flashing certain lights of the haul truck, or an audible communication or indication such as by generating a verbal request or sounding a horn or an alarm of the haul truck. In another example, the rope shovel **15** may generate an alert commands as visual or audible indications such as flashing lights or sounding an alarm on the rope shovel.

[0081] When dumping or unloading a load of material from dipper **35**, in some instances, it may be desirable to position the dipper at a specified or predetermined distance above the dump body **84** to reduce or minimize the distance that material falls as it fills the dump body. By reducing or minimizing distance that the material falls, the impact of the material on the haul truck **80** is reduced, which reduces wear on the haul truck **80** and fatigue on the truck operator.

[0082] If the dipper **35** is positioned the predetermined distance above the lower surface **87** of the dump body **84** when the dump body is empty, as the dump body is filled with material, the dump height of the dipper must be increased if it is desired to maintain the relative dump height (i.e., the distance the material falls) to compensate for the additional material. In other words, if it is desirable to maintain a specified distance that the material falls into the dump body **84**, the height of the dipper **35** during the dumping process must be sequentially increased after each dumping cycle due to the addition of material into the dump body.

[0083] Referring to the height of the surface upon which the material is being dumped as the bed height, the lower surface **87** may define the initial bed height. As each load of material is added to the dump body **84**, the additional material changes the effective bed height (i.e., the height of the upper surface upon which the next load may be dumped). Accordingly, to maintain the desired relative dump height, it may be desirable to increase the absolute position of the dipper **35** relative to the ground surface **104**.

[0084] Control system **55** may include a dump height positioning system, indicated generally at **77** in FIG. **2**, that operates to determine a desired height of the dipper **35** at which each dumping or unloading operation should occur. The dump height positioning system **77** may control the dump height when performing material moving operations autonomously or semi-autonomously and may be used to suggest a dump height when operating the rope shovel **15** manually.

[0085] In operation, the dump height positioning system **77** may first determine the height of the lower surface **87** of the dump body **84** relative to ground surface **104**. In one example, the perception sensors **71** of the terrain mapping system **70** may be high enough to determine the height of the lower surface **87** relative to the ground surface **104** (i.e., the bed height). In another example, the position of the lower surface **87** may be determined from the pose of the haul truck **80** together with known machine dimensions such as those associated with an identifying code for the haul truck as discussed above.

[0086] After determining the height of the lower surface **87**, the dipper **35** may be moved to the desired position (i.e., at the desired height above the lower surface and generally centered relative to the dump body **84**) and the door **37** of the dipper opened to dump the material. The addition of material on top of the lower surface **87** of dump body **84** will likely increase the effective bed height. The dump height positioning system **77** may determine or estimate a new effective bed height in any desired manner. In one example using a closed loop system, the perception sensors **71** may be utilized to determine the new effective bed height. In another example using a closed loop system, additional mapping or perception sensors, indicated generally at **79**, may be provided at the dipper **35** or dipper handle **40** and operate in a manner similar to the perception sensors **71** to determine the effective bed height.

[0087] In an example using an open loop system, the dump height positioning system **77** may estimate the new effective bed height based upon the dimensions or capacity of the dipper **35** and the dimensions or capacity of the dump body **84** of haul truck **80**. In a further example using an open loop system, the dump height positioning system **77** may estimate the new effective bed height by raising the previous effective bed height by a predetermined increment or distance.

[0088] Upon determining or estimating a new effective bed height, a new dump height may be determined based upon the new effective bed height and the relative dump height. The dipper **35** may be moved to its desired position above the dump body **84** and the material dumped into the haul truck **80**. The process of determining or estimating a new or subsequent effective bed height, a new or subsequent dump height, and performing a material moving operation may be repeated until the haul truck **80** is filled to the desired level.

[0089] It should be noted that in some instances, the dump height positioning system **77** may determine a new dump height by raising the previous dump height based upon the dimension of the dipper and the dimensions of the dump body **84** rather than estimating a new effective bed height by raising the previous effective bed height by a predetermined increment and then calculating a new dump height.

[0090] In another example, the dump height positioning system **77** may operate by determining a first or initial dump height based upon the initial bed height and increasing the dump height by a predetermined amount after each dump process until the dump body **84** is full. In one example, the predetermined amount that the dump height is increased for each subsequent cycle may be generally identical. In another example, the predetermined amount that the dump height is increased for each subsequent cycle may be different. In instances in which more than three dump cycles are used for a haul truck **80**, the predetermined distances may be generally identical, different, or a combination.

[0091] Upon dumping each load of material, the rope shovel **15** may be operated to return the dipper **35** to a desired dig location. This process may be referred to as a return-to-dig process and may be performed autonomously, semi-autonomously, or manually. When operating autonomously or semi-autonomously, a return-to-dig system, indicated generally at **78** in FIG. **2**, may be configured to move the dipper **35** sequentially between one or more dig locations and one or more dump locations. The dig locations may be set automatically, by an operator, or other personnel. In addition, the desired sequence may be set automatically, by an operator, or other personnel.

[0092] In one example depicted in FIG. **10**, a material moving operation may be configured with a single rope shovel **15** operating at a single dig location **140** together with a first loading or dump location **141** and a second loading or dump location **142** at which haul trucks **80** may be loaded. The first dump location **141** and the second dump location **142** may be positioned at any location but are depicted in FIG. **10** on opposite sides of the rope shovel **15**.

[0093] During a material loading operation, material may be loaded into the dipper **35** at the dig location **140** and the dipper moved into alignment with a first haul truck **80** located at the first dump location **141** and unloaded. Upon emptying the dipper **35**, the controller **56** may generate command signals to move the dipper back to the dig location **140** and the process of loading the first haul truck **80** may be repeated until the first haul truck is fully loaded.

[0094] Either before or while the rope shovel **15** is loading the first haul truck **80**, a second haul truck may be positioned at the second dump location **142**. Once the first haul truck **80** is fully loaded, the first haul truck may depart the first dump location **141** and the dipper **35** returned to the dig location **140** to begin another dipper loading and unloading cycle. After loading the dipper **35**, the dipper may be moved into alignment with the second haul truck **80** located at the second dump location **142** and unloaded. Upon emptying the dipper **35**, the dipper may be moved back to the dig location **140** and the process of loading the second haul truck **80** is repeated until the second haul truck is fully loaded. Either before or while the rope shovel **15** is loading the second haul truck **80**, an empty haul truck may be positioned at the first dump location **141** and the loading process may be repeated at the first dump location once the second haul truck is fully loaded. With the configuration depicted in FIG. **10**, the rope shovel **15** may be continuously operated by positioning an empty haul truck **80** at either the first dump location **141** or the second dump location **142** while the rope shovel is loading a haul truck at the other dump location.

[0095] In a second example depicted in FIG. **11**, a material moving operation may be configured with a rope shovel **15** digging at both a first dig location **145** and a second dig location **146** and dumping at a single dump location **147**. The first dig location **145** may be located generally near or adjacent the dump location **147** and the second dig location **146** located farther from the dump location.

[0096] During a material loading operation, material may be loaded into the dipper **35** at the first dig location **145** and the dipper moved into alignment with a haul truck **80** located at the dump location **147** and unloaded. Upon emptying the dipper **35**, the controller **56** may generate command signals to move the dipper back to the first dig location **145** and the process of loading the haul truck **80** may be repeated until the haul truck is fully loaded. Once the haul truck **80** is fully loaded, the haul truck may depart the dump location **147** and an empty haul truck positioned at the dump location.

[0097] While the loaded haul truck **80** is leaving the dump location **147** and the empty haul truck is being positioned at the dump location, the dipper **35** may be moved to the second dig location **146** and material loaded into the dipper. The dipper **35** may be moved back to the dump location **142** to fill the newly positioned empty haul truck **80**. Upon emptying the dipper **35**, the dipper may be moved to the first dig location **140** and the process of digging at the first dig location and loading the haul truck **80** at the dump location **147** may be repeated until the haul truck is fully loaded. With the configuration depicted in FIG. **11**, the time required to move the fully loaded haul truck **80** from the dump location **147** and position an empty haul truck thereat may be utilized more efficiently by directing the rope shovel **15** to load the dipper **35** at the second dig location **146**, which is located farther from the dump location as compared to the first dig location **145**.

[0098] In a further example, a configuration may be utilized that is similar to that of FIG. **11** but includes a second dump location, indicated generally at **148**, near the second dig location **146**. By adding the second dump location **148**, the rope shovel **15** may load a haul truck at each dump location and then dig material at a dig location near each dump location.

[0099] The positions of the dig locations may be set in any desired manner. In one example, the dig locations may be set by an operator manually moving the dipper to a desired location and actuating an input device such as a switch (not shown) within the operator station **20**. The signals from the sensors (e.g., swing sensor **62** and crowd sensor **65**) indicative of the general position of the desired dig location may be stored within controller **56** to subsequently identify the desired dig location. The process may be repeated for each dig location.

[0100] In another example, the desired dig locations may be set or stored by entering the control system **55** into a learning mode and an operator operating the rope shovel **15** to perform a digging operation. Upon performing the digging operation, the controller **56** may determine the swing position from swing sensor **62** and the crowd from crowd sensor **65** and store the positions to subsequently identify the desired dig location.

[0101] In still another example, the desired dig locations may be set or stored by identifying the locations on the electronic map stored within controller **56**. More specifically, an operator may identify or input desired dig locations on a display device within the operator station **20**.

[0102] Referring to FIGS. **13-14**, flowcharts of a semi-autonomous material moving operation using rope shovel **15** is depicted. The flowcharts depict a process in which an operator may manually perform a digging operation and the controller **56** of rope shovel **15** semi-autonomously moves the dipper **35** into alignment with a haul truck **80**, dumps the load within the dipper, and returns the dipper to a dig location at which the operator may perform a new digging operation. At stage **150**, characteristics of the machines operating at the work site **100** may be entered into controller **56**. The characteristics may include operating capacities, dimensions, desired operating characteristics, and other desired or necessary information. Examples may include the kinematic model of the rope shovel **15** and the dimensions of the haul trucks **80**.

[0103] An electronic map of the work site **100** may be generated at stage **151**. In one example, the electronic map may be created by the terrain mapping system **70**. The perception sensors **71** may generate mapping signals that are received by controller **56** and the controller may convert the mapping signals into an electronic map of the work site **100**. The electronic map may include representations that depict the positions of face **102**, ground surface **104**, and the rope shovel **15**. In addition, each of the obstacles located by the terrain mapping system **70** and/or identified by the object identification system **73** may be included in the electronic map.

[0104] While the electronic map may be generated and stored in a rectangular or Cartesian coordinate system, it may be desirable to convert and/or store the electronic map in a cylindrical coordinate system. Storing the electronic map in a cylindrical coordinate system with the map centered about axis **22** may simplify the generation of command signals by the controller **56**, the operation of the planning system **75**, and the determination of whether a portion of the rope shovel **15** is likely to come into contact with an obstacle.

[0105] At stage **152**, the controller **56** may determine the position or pose of the target zone **124** including the height of the lower surface **87** of the dump body **84** relative to ground surface **104** and store the information within the electronic map of the controller **56**. The position or pose of the target zone may be determined based upon information from the terrain mapping system **70**, the pose sensing system **92**, other mapping or perception systems, information from a data map stored within any controller, and/or any other desired systems.

[0106] Auto-lift zones around each obstacle may also be determined and stored within the electronic map at stage **152**.

[0107] One or more dig locations may be set or stored at stage **153** within controller **56**. The dig locations may be identified and stored within controller **56** in any desired manner. In one example, an operator may move the dipper **35** to a desired dig location and actuate an input device such as a switch (not shown) within the operator station **20**. Signals from the sensors (e.g., swing sensor **62**, hoist sensor **63**, and crowd sensor **65**) indicative of the position of the desired dig location may be stored within controller **56**.

[0108] At stage **154**, the dipper **35** may be loaded with material such as from the face **102** of the mine **101** (FIG. **1**). It should be noted that the operation of stages **153** and **154** may be reversed or may occur simultaneously depending upon the manner in which the dig location(s) are stored. The planning system **75** may plan at stage **155** a desired path to the dump location. More specifically, the planning system **75** may determine the desired path for the dipper to travel from to the target zone **124** at the dump body **84** of the haul truck **80**. Upon initially loading the dipper **35**, the planning system **75** may determine the desired path from the dig location to the dump location. As the dipper **35** moves towards the dump location, the controller **56** may concurrently determine and update the desired path of the dipper from its current location to the target zone **124**.

[0109] While determining the path of the dipper **35**, the controller **56** may also determine the stopping zone **126** of the dipper **35**. Since the stopping zone **126** is generally a function of the momentum of the rope shovel **15**, the length of the stopping zone will typically increase as the rope shovel moves more rapidly. It should be noted that by avoiding obstacles that are radially between the dipper **35** and the base **16**, the likelihood of contact between an obstacle and any portion of the rope shovel **15** is reduced.

[0110] The controller **56** may generate at stage **156** command signals to move the dipper **35** along the identified or predetermined path towards the target zone **124**. While moving the dipper **35**, the controller **56** may receive at stage **157** data from the sensors associated with the rope shovel **15** together with any sensors associated with the obstacles and the work site **100** to update the electronic map of the work site. Based upon the position, speed, and acceleration of the rope shovel **15** as well as the obstacles adjacent the rope shovel, the controller **56** may determine at decision stage **158** whether the rope shovel is likely to make contact with an obstacle as the dipper moved towards the target zone **124**.

[0111] If the rope shovel **15** is likely to contact an obstacle, the controller **56** may determine at decision stage **159** (FIG. **14**) whether the obstacle is moving. If the obstacle is moving, the controller **56** may pause or wait at stage **160** for a predetermined period of time in case the obstacle moves sufficiently out of the path of the rope shovel **15**. If the obstacle has moved sufficiently so that contact or a collision between the rope shovel **15** and the obstacle may be avoided, movement of the dipper **35** may be continued by referring back to FIG. **13** at stage **155**.

[0112] If the obstacle is not moving at decision stage **159** or has not moved out of the path within the predetermined time period at decision stage **161**, controller **56** may determine at decision stage **162** whether movement of the rope shovel **15** may be stopped within a sufficient distance or time period to avoid a collision with the obstacle. If the rope shovel **15** may be stopped without a collision, the controller **56** may generate commands to stop the machine at stage **163**. If the rope shovel **15** may not be stopped without a collision, the controller **56** may generate commands at stage **164** to raise the dipper **35** in an attempt to pass over the obstacle.

[0113] If the rope shovel **15** is not going to contact an obstacle, the controller **56** may determine at decision stage **165** whether the dipper **35** is sufficiently aligned with the target zone **124** including being positioned as desired at the dump body **84** and positioned at the desired dump height above the lower surface **87** of the dump body. If the dipper **35** is not sufficiently aligned with the target zone **124** and at the desired dump height, the dipper may continue to be moved towards the desired position and stages **155-8**, **165** repeated.

[0114] If the dipper **35** is aligned with the target zone **124** and at the desired dump height, the controller **56** may dump at stage **166** the load of material into the dump body **84**. To do so, the controller **56** may generate a command to actuate the door actuator motor **49** which engages actuator cable **48** to open the door **37**.

[0115] At stage **167**, the controller **56** may determine the new effective bed height of the dump body **84**. To do so, the controller **56** may utilize perception sensors **71**, additional sensors **79**, an estimate of the change in bed height due to the addition of material into the dump body **84**, or any other desired system or process. At stage **168**, the controller **56** may generate commands to return the dipper **35** to a desired dig location and stages **154-168** repeated.

[0116] While the dipper **35** is being returned to the desired dig location, the controller **56** may determine at decision stage **169** whether the haul truck **80** is fully loaded. In one embodiment, the controller **56** may make such a determination based upon the analysis of the new effective bed height of the dump body **84**. In another embodiment, a load sensing system **93** of haul truck **80** may be used to determine when the haul truck is fully loaded. If the haul truck **80** is not fully loaded, the haul truck may remain in place and the material moving process may be continued and stages **154-169** repeated.

[0117] If the haul truck **80** is fully loaded, the haul truck may be moved at stage **170** from the dump location and transported to a desired location spaced from the dump location. Once the fully loaded haul truck **80** has been moved from the dump location, an empty haul truck may be moved at stage **171** to the dump location and the material moving process may be continued and stages **154-169** repeated.

[0118] Although described in the context of rope shovel **15**, many of the concepts disclosed herein are applicable to other similar machines and systems. For example, FIG. **12** depicts an excavator **200** having multiple systems and components that may cooperate to move material from a dig location to a dump location. Excavator **200** may include a platform **201** rotatably disposed on undercarriage **202**. Undercarriage **202** may include one or more ground engaging drive mechanism such as tracks **203**.

[0119] Platform **201** may include a prime mover **204** operative to power an implement system **205** including a work implement or tool such as bucket **206**. Prime mover **204** may provide a rotational output to drive tracks **203**, thereby propelling the excavator **200**. Prime mover **204** may also provide power to other systems and components of the excavator **200**.

[0120] The implement system **205** may include a boom **207**, a connecting member or stick **208**, and a work implement or tool. A first end of boom **207** may be pivotally connected to platform **201**, and a second end of the boom may be pivotally connected to a first end of stick **208**. The work implement or tool such as bucket **206** may be pivotally connected to a second end of stick **208**.

[0121] Rotation of platform **201** relative to undercarriage **202** may be effected by a swing motor **210**. Each linkage member may include and be operatively connected to one or more actuators such as hydraulic cylinders. More specifically, boom **207** may be propelled by one or more boom hydraulic cylinders **211** (only one being shown in FIG. **12**). Stick **208** may be propelled by a stick hydraulic cylinder **212**. Rotation of the bucket **206** relative to the stick **208** may be effected by a work implement hydraulic cylinder **213**.

[0122] Each of the swing motor **210**, boom hydraulic cylinders **211**, stick hydraulic cylinder **212**, and work implement hydraulic cylinder **213** may be driven by a hydraulic system, generally indicated at **214**, that may be powered by the prime mover **204**. Excavator **200** may include a control system **215** and a controller **216** similar to those of rope shovel **15**.

[0123] Excavator **200** may also include systems and sensors for efficient operation of the machine. Such systems and sensors may be similar to or result in similar measurements and functionality to the systems and sensors of rope shovel **15**. As non-limiting examples, the mapping system **70** of rope shovel **15** may be used with excavator **200** to generate an electronic map of the work site **100** and store the electronic map within controller **216** in either rectangular or cylindrical coordinates. Re-positioning system **76** may also be used with excavator **200** to identify instances in which the excavator may not efficiently or safely load a haul truck **80** that is positioned near the excavator. In addition, dump height positioning system **77** may be used with excavator **200** in instances in which it is desired to control the height at which the bucket **206** is dumped. Finally, return-to-dig system **78** may be used with excavator **200** in instances in which it is desired to utilize a return-to-dig process that includes automated movement between a plurality of either dig locations or dump locations.

[0124] From the forgoing, it may be understood that each of the rope shovel **15** and the excavator **200** includes a base rotatably mounted on an undercarriage having a ground engaging drive mechanism. Each of the rope shovel **15** and the excavator **200** also includes an implement system or linkage assembly mounted on the base. Each implement system includes a boom secured to the base although the boom **25** of the rope shovel is fixed while the boom **207** of the excavator is pivotably mounted to the base or platform **201**. Each of the rope shovel **15** and the excavator **200** further includes a ground engaging work implement in the form of a dipper **35** or bucket **206**, respectively. The dipper **35** is fixed to dipper handle **40** which is operatively connected to the boom **25** while the bucket **206** is pivotably mounted on the stick **208**.

INDUSTRIAL APPLICABILITY

[0125] The industrial applicability of the systems described herein will be readily appreciated from the foregoing discussion. The present disclosure is applicable to many machines and tasks performed by machines. Exemplary machines include rope shovels, hydraulic mining shovels, excavators, and backhoes.

[0126] A re-positioning system **76** may be used to identify instances in which the excavator may not efficiently or safely load a haul truck **80** that is positioned near a machine such as rope shovel **15**. A dump height positioning system **77** may be used when it is desired to control the height at which the bucket **206** is dumped. A return-to-dig system **78** may be used when it is desired to move a work implement such as dipper **35** from a dump location to one or more dig locations in an automated manner.

[0127] It will be appreciated that the foregoing description provides examples of the disclosed system and technique. However, it is contemplated that other implementations of the disclosure may differ in detail from the foregoing examples. All references to the disclosure or examples thereof are intended to reference the particular example being discussed at that point and are not intended to imply any limitation as to the scope of the disclosure more generally. All language of distinction and disparagement with respect to certain features is intended to indicate a lack of preference for those features, but not to exclude such from the scope of the disclosure entirely unless otherwise indicated.

[0128] Recitation of ranges of values herein are merely intended to serve as a shorthand method of referring individually to each separate value falling within the range, unless otherwise indicated herein, and each separate value is incorporated into the specification as if it were individually recited herein. All methods described herein can be performed in any suitable order unless otherwise indicated herein or otherwise clearly contradicted by context.

[0129] Accordingly, this disclosure includes all modifications and equivalents of the subject matter recited in the claims appended hereto as permitted by applicable law. Moreover, any combination of the above-described elements in all possible variations thereof is encompassed by the disclosure unless otherwise indicated herein or otherwise clearly contradicted by context.

1. A system for controlling movement of a work implement of a machine between a dump location and a plurality of dig locations, comprising:

a rotatable implement system at a work site having a linkage assembly including the work implement;

an implement system pose sensor for generating implement system pose signals indicative of a pose of the implement system including a pose of the work implement; and

a controller configured to:

store first dig signals from the implement system pose sensor indicative of a first dig location;

store second dig signals from the implement system pose sensor indicative of a second dig location, the second dig location being spaced from the first dig location;

store a dump location;

generate command signals to move the work implement from the first dig location to the dump location;

generate command signals to dump a load of material carried by the work implement at the dump location; and

generate command signals to move the work implement from the dump location to the second dig location.

2. The system of claim **1**, wherein the controller is further configured to store the first dig signals based upon positioning of the work implement at the first dig location and actuation of an input device.

3. The system of claim **2**, wherein the controller is further configured to store the second dig signals based upon positioning of the work implement at the second dig location and actuation of the input device.

4. The system of claim **1**, wherein the controller is further configured to store automatically the first dig signals upon entering a learning mode and the work implement performing a predetermined digging operation.

5. The system of claim **4**, wherein the controller is further configured to store automatically the second dig signals upon entering the learning mode and the work implement performing a second predetermined digging operation.

6. The system of claim **1**, further including a rotatable base having the linkage assembly mounted thereon, the linkage assembly including a boom operatively connected to the base, a connecting member operatively connected to the boom and the work implement.

7. The system of claim **6**, wherein the implement system pose sensor includes sensors for determining a position of the linkage assembly.

8. The system of claim **6**, wherein the boom is fixedly mounted to the base, and the work implement is fixedly mounted on the connecting member.

9. The system of claim **8**, wherein the connecting member is slidably mounted on a saddle block and the saddle block is pivotably mounted on the boom.

10. The system of claim **6**, wherein the boom is pivotably mounted to the base, and the work implement is pivotably mounted on the connecting member.

11. The system of claim **10**, wherein the connecting member is pivotably mounted on the boom.

12. The system of claim **1**, wherein the controller is further configured to store an electronic map including the implement system, the first dig location, the second dig location, and the dump location in cylindrical coordinates.

13. The system of claim **1**, further including a haul truck including a haul truck pose sensor for generating truck pose signals indicative of a pose of the haul truck, and the controller is further configured to determine the dump location based upon the pose of the haul truck.

14. The system of claim **1**, wherein the controller is further configured to store a second dump location, generate command signals to move the work implement from the second dig location to the second dump location, and generate command signals to dump a load of material carried by the work implement at the second dump location.

15. The system of claim **14**, further including a second haul truck including a second haul truck pose sensor for generating second truck pose signals indicative of a pose of the second haul truck, and the controller is further configured to determine the second dump position based upon the pose of the second haul truck.

16. A controller implemented method for controlling movement of a work implement of a machine between a dump location and a plurality of dig locations, the work implement being operatively connected to a rotatable implement system having a linkage assembly, the method comprising:

storing first dig signals from an implement system pose sensor associated with implement system the indicative of a first dig location;

storing second dig signals from the implement system pose sensor indicative of a second dig location, the second dig location being spaced from the first dig location;

storing a dump location;

generating command signals to move the work implement from the first dig location to the dump location;

generating command signals to dump a load of material carried by the work implement at the dump location; and

generating command signals to move the work implement from the dump location to the second dig location.

17. The method of claim **16**, further including storing the first dig signals based upon positioning of the work implement at the first dig location and actuating an input device.

18. The method of claim **16**, further including storing automatically the first dig signals upon entering a learning mode and the work implement performing a predetermined digging operation.

19. The method of claim **16**, further including storing a second dump location, generating command signals to move the work implement from the second dig location to the second dump location, and generating command signals to dump a load of material carried by the work implement at the second dump location.

20. A machine comprising:

a rotatable base;

a linkage assembly, the linkage assembly including a boom operatively connected to the base, a connecting member operatively connected to the boom, and a material moving work implement operatively connected to the connecting member;

an implement system pose sensor for generating implement system pose signals indicative of a pose of the implement system including a pose of the work implement; and

a controller configured to:

store first dig signals from the implement system pose sensor indicative of a first dig location;

store second dig signals from the implement system pose sensor indicative of a second dig location, the second dig location being spaced from the first dig location;

store a dump location;

generate command signals to move the work implement from the first dig location to the dump location;

generate command signals to dump a load of material carried by the work implement at the dump location; and

generate command signals to move the work implement from the dump location to the second dig location.

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