

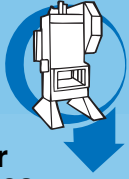
# Control system feeders



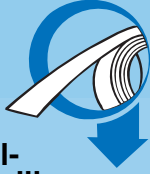
Press lines



Power Presses



Coil-handling



Nibbler



Ancillary



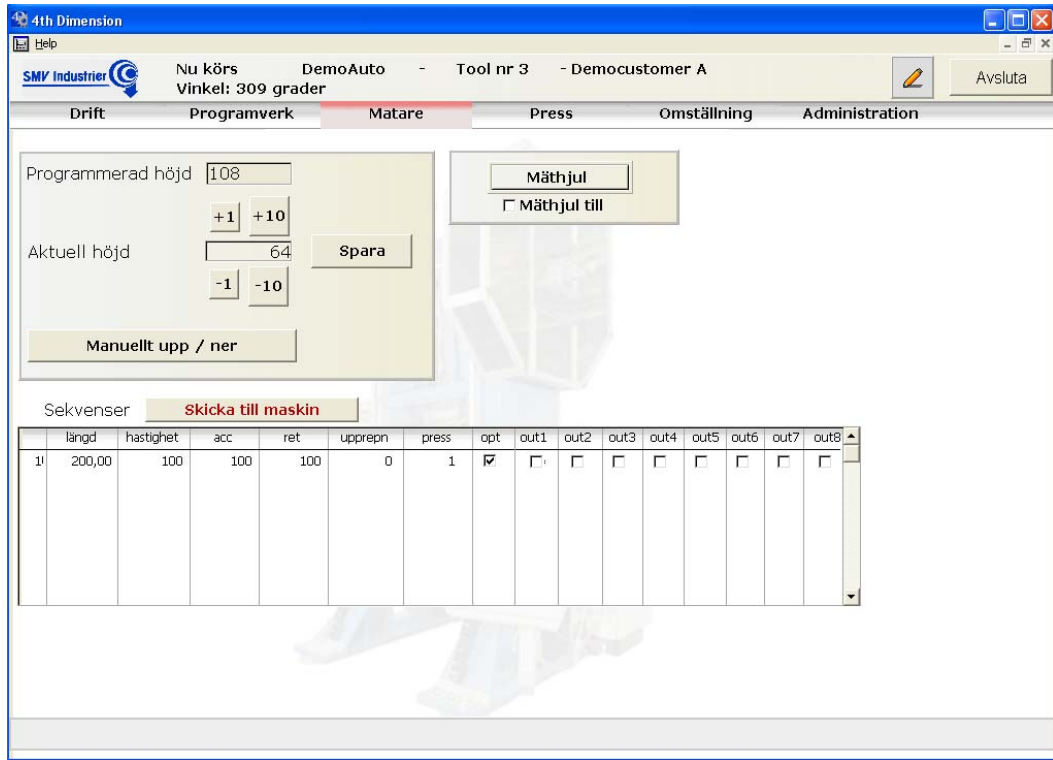
Service



Automation



Education



## SMV Control system for feeders

The control system is a modern, easy programmed system with memory function which gives increased profitability and productivity. All set data is stored per tool, which reduces the set up time considerable.

Besides roll lift, feed line height adjustment, feed length, acceleration and retardation, also sequence feeding is included as standard in the system. Sequence feeding means that an optional number of feeding sequences can be set and stored. Also optimized speed is included which means that the speed of the servo roll feed can be synchronized with the speed of the press.

Bar code reading and shuttle control is available as extra options. An optional number of shuttles can be controlled. The settings are stored in the system.

The control system for feeders is a part of the control system Multi. The system can for instance be completed with cam control and energy- and press force monitor. See separate product-sheets.

With these functions the technical level will be increased essentially on an existing pressline.

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# Program sequence feeding with shuttle control

4th Dimension

Program - DemoAuto

Programdata | Sekvenser | **Sekv. utgångar** | Utgångar | Ingångar

Ny Sekvens | Radera Sekvens

	längd	hastighet	acc	ret	upprepn	press	opt	out1	out2	out3	out4	out5	out6	out7	out8
1	200	100	78	78	1	1	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				
2	48	30	30	30	1	1	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				
3	24	30	30	30	5	1	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>				
4	24	30	30	30	1	1	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>				

Avbryt | Spara

4th Dimension

Program - DemoAuto

Programdata | Sekvenser | **Sekv. utgångar** | Utgångar | Ingångar

Ny Utgång | Radera utgång

4 | Skyttel 4 | 0 | 200

utgång nr	utgång namn	typ	fördröj ms
1	Skyttel 1	2	0
2	Skyttel 2	1	0
3	Skyttel 3	3	0
4	Skyttel 4	0	200

Utgångar kan väljas i sekvenstabellen om de definieras här.  
Utgångs typer:

- 0 = Ingen övervakning, ange fördröjning.
- 1 = Givare i "hemma"-läge (utgång från).
- 2 = Givare i båda lägen.
- 3 = Givare i "ute"-läge (utgång till).

Upp till 8 utgångar kan

Avbryt | Spara